

C6636147

MODEL 700TM M24

Model **SMS** TM

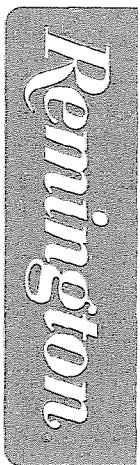
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

REG. U.S. PAT. & TM. OFF.

MODEL 700™ H24

SERIAL NO.
C6636147

ORDER NO.
5716

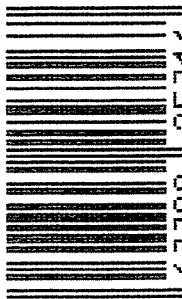
MADE IN LION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off, Marca Registrada Marque Deposee.

20



5716 C6636147

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636147

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8	9 1	KCR
	Magnaflux Bolt	5 8	9 1	KCR
615	Rollmark Caliber	5 8	9 1	GS
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-31-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JK
	G) Safety Off Force	4	4	4			6-7-91	JK
	H) Trigger Pull Test & Retainability						6-7-91	JK
	I) Firing Pin Indent	.021	.021	.021			6-7-91	JK
	J) Assemble Stock						6-7-91	KS
	K) Assemble Swivel Studs						6-13-91	AC
	L) Attach Front and Rear Sight Assemblies						6-7-91	KS
	M) Iron Sight Alignment						6-7-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-7-91	KS
	O) Attach Scope to Rifle						6-7-91	KS
	P) Detach & Attach Scope 20 Times						6-7-91	KS
640	Gallery Target & Test						6-10-91	AC
	A) Time						6-10-91	AC
	B) Malfunctions						6-10-91	AC
	C) Pierced Primers						6-10-91	AC
	D) Optical Clarity of Scope						6-10-91	AC
645	Inspect for Live Ammo						6-10-91	AC
655	Final Inspection							
	A) Headspace						6-13-91	AC
	B) Trigger Pull	2.37	2.27	2.30	2.19	2.39	6-13-91	JK
	C) Function						6-13-91	AC
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C 6636147

DATE 6-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.28	2.38	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.38	2.30	2.27	
PULL #3	2.59	2.44	2.43	2.30	
PULL #4	2.64	2.38	2.40	2.19	
PULL #5	2.40	2.36	2.40	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.44		
PULL #2	3.36	3.47		
PULL #3	3.41	3.47		
PULL #4	3.36	3.35		
PULL #5	3.40	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.29		4.16
PULL #2	4.25	4.18		4.18
PULL #3	4.30	4.60		4.30
PULL #4	4.32	4.60		4.25
PULL #5	4.33	4.58		4.16
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636147
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.223258
1 TO	2	.393459
1 TO	3	.230835
1 TO	4	.293437
1 TO	5	.595195

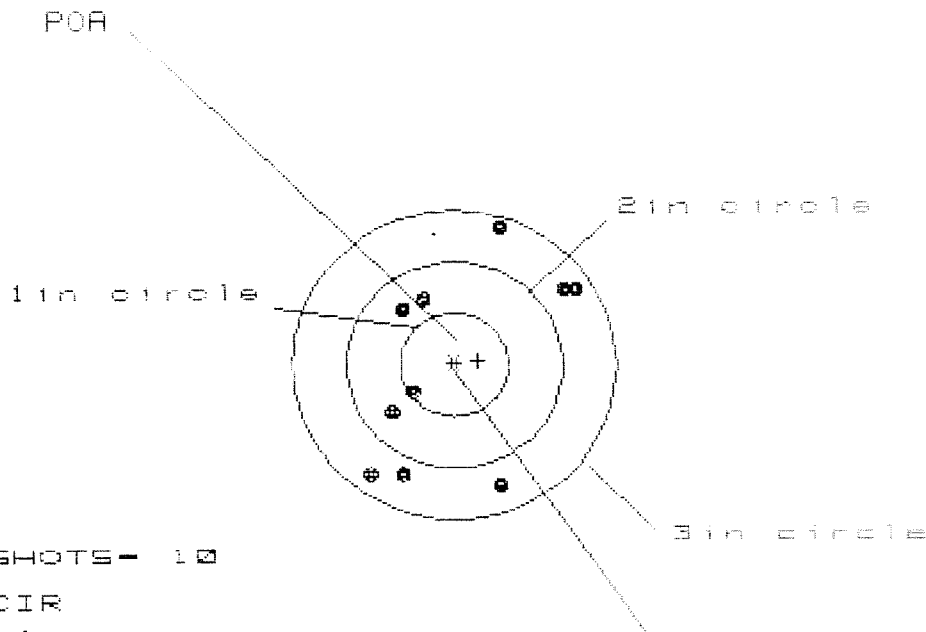
2 1₅ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.098
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142462
THE AMR FOR THIS RIFLE IS: .9146

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636147

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 1.920

VS= 2.542

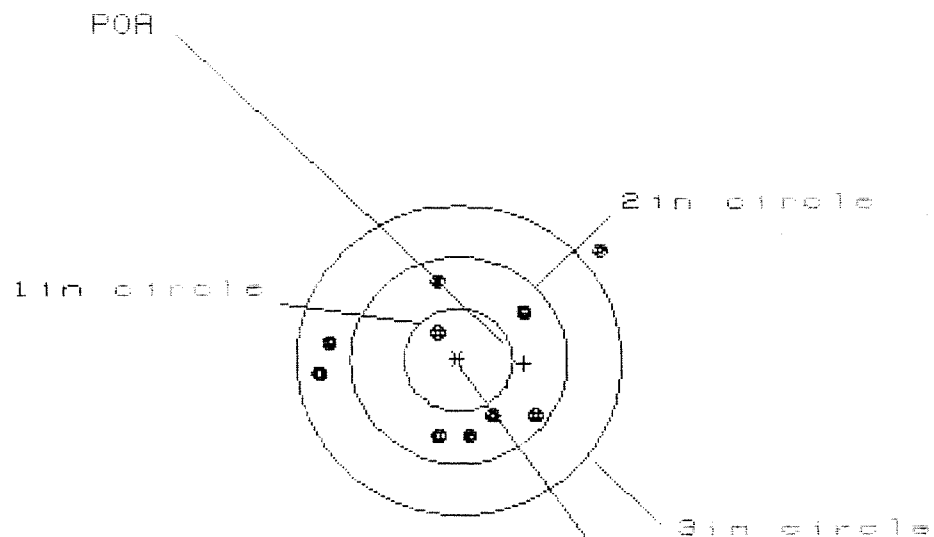
GS= 2.716

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.155	1.205	1.246
MINIMUM X	-.765	-.715	-.564
MAXIMUM Y	1.362	.937	1.047
MINIMUM Y	-1.188	-1.028	-.911
CENTROID X	-.220	-.270	-.421
CENTROID Y	-.038	-.190	-.307
POA TO CENTROID in.	.224	.330	.521
MIN RADIUS	.498	.383	.209
MEAN RADIUS	1.054	.989	.866
MAX RADIUS	1.435	1.527	1.627
HORIZONTAL SPREAD	1.920	1.920	1.810
VERTICAL SPREAD	2.542	1.965	1.958
EXTREME SPREAD	2.716	2.668	2.585
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

18 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 7

3in = 9

HS- 2.601

VS= 1.766

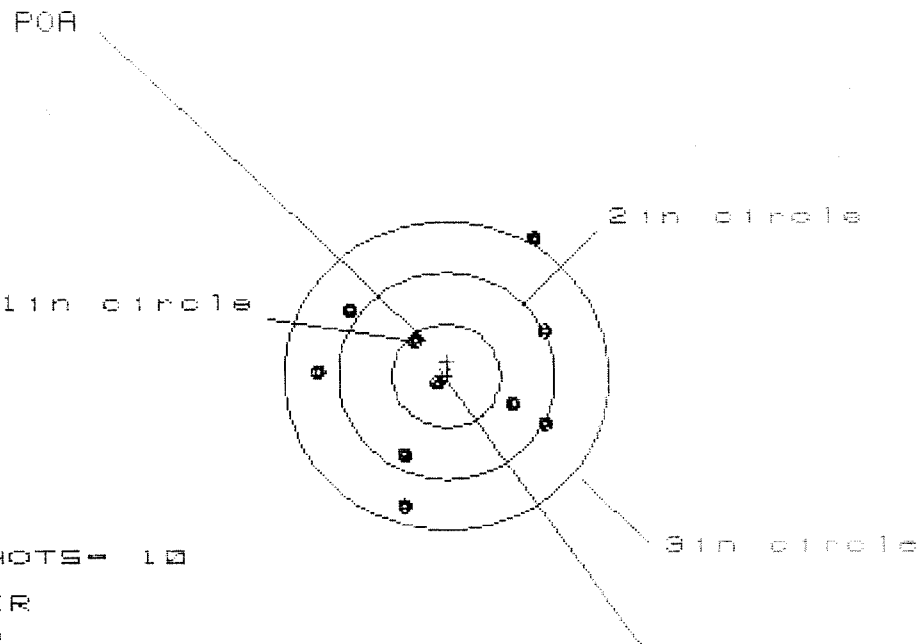
GS= 2.863

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.353	.814	.677
MINIMUM X	:	-1.248	-1.098	-1.139
MAXIMUM Y	:	1.025	.842	.835
MINIMUM Y	:	-.741	-.627	-.634
CENTROID X	:	-.607	-.757	-.620
CENTROID Y	:	.033	-.081	-.074
POA TO CENTROID in.	:	.608	.761	.624
MIN RADIUS	:	.355	.396	.437
MEAN RADIUS	:	.894	.792	.738
MAX RADIUS	:	1.697	1.099	1.169
HORIZONTAL SPREAD	:	2.601	1.912	1.816
VERTICAL SPREAD	:	1.766	1.469	1.469
EXTREME SPREAD	:	2.863	1.973	1.954
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

10 Jun 1981

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.131

VS= 2.636

GS= 2.912

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.926	1.020	.983
MINIMUM X	:	-1.205	-1.111	-1.148
MAXIMUM Y	:	1.383	.792	.654
MINIMUM Y	:	-1.253	-1.099	-.764
CENTROID X	:	-.011	-.105	-.068
CENTROID Y	:	-.136	-.290	-.152
POA TO CENTROID in.	:	.136	.300	.167
MIN RADIUS	:	.113	.098	.057
MEAN RADIUS	:	.927	.838	.785
MAX RADIUS	:	1.622	1.169	1.148
HORIZONTAL SPREAD	:	2.131	2.131	2.131
VERTICAL SPREAD	:	2.636	1.891	1.418
EXTREME SPREAD	:	2.912	2.171	2.171
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

CENTROID *

HS = 1.946

VS = 2.111

GS = 2.214

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.131	1.196	.566
MINIMUM X	:	-.816	-.750	-.601
MAXIMUM Y	:	1.070	.954	.987
MINIMUM Y	:	-1.041	-.761	-.728
CENTROID X	:	.072	.006	-.143
CENTROID Y	:	-.009	.107	.074
POA TO CENTROID in.	:	.072	.107	.161
MIN RADIUS	:	.438	.501	.425
MEAN RADIUS	:	.799	.755	.674
MAX RADIUS	:	1.196	1.225	.996
HORIZONTAL SPREAD	:	1.946	1.946	1.167
VERTICAL SPREAD	:	2.111	1.715	1.715
EXTREME SPREAD	:	2.214	1.966	1.722
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Jun 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

HS= 1.796

VS= 3.510

GS= 3.555

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.893
MINIMUM X	-.903
MAXIMUM Y	1.338
MINIMUM Y	-2.172
CENTROID X	.276
CENTROID Y	-.367
POA TO CENTROID in.	.459
MIN RADIUS	.396
MEAN RADIUS	.899
MAX RADIUS	2.179
HORIZONTAL SPREAD	1.796
VERTICAL SPREAD	3.510
EXTREME SPREAD	3.555
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9