

06225408

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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

MODEL 700™ M24

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

SERIAL NO.

0505195

ORDER NO.



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5716 C695498

The diagrams illustrate the construction of a square frame from a single wire. The first diagram shows a single wire bent into a U-shape. The second diagram shows the wire bent into a square frame with one corner open. The third diagram shows the wire bent into a complete square frame.



47700 25716

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CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225408

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12 9 88		RW
600	Proof	12 9 88		RW
607	Check Headspace	12 9 88		RW
610	Dis-assemble Gun	12 9 88		RW
612	Magnaflux Barrel Action		12-22-88	R/C.
	Magnaflux Bolt		1-3-89	R/C.
615	Rollmark Caliber		12/22/88	WDC
617	Drill and Tap Sight Holes	1 3 89		FB
618	Polish Barrel	12 2 88		WJT
620	Apply Coatings (Barrel Action)		1-16-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/23/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/23/89	RW
	C) Inspect Ejector Hole for Chamfer		1/23/89	RW
	D) Oil Firing Pin Ass'y		1/23/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		24 Jan 89	JSB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			30 Jan 89	JSJ
	G) Safety Off Force	3	3	3			30 Jan 89	JSJ
	H) Trigger Pull Test & Retainability						24 Jan 89	JSJ
	I) Firing Pin Indent	.021	.0205	.021			30 Jan 89	JSJ
	J) Assemble Stock						1/30/89	RW
	K) Assemble Swivel Studs						30 Jan 89	JSJ
	L) Attach Front and Rear Sight Assemblies						1/30/89	RW
	M) Iron Sight Alignment						1/30/89	RW
	N) Detach Front & Rear Sights & place in numbered container						1/30/89	RW
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times						31 Jan 89	JSJ
640	Gallery Target & Test	68 R	85 L				1/31/89	DAH
	A) Time						1/31/89	DAH
	B) Malfunctions						1/31/89	DAH
	C) Pierced Primers						1/31/89	DAH
	D) Optical Clarity of Scope						1/31/89	DAH
645	Inspect for Live Ammo						1/31/89	DAH
655	Final Inspection							
	A) Headspace						3 Feb 89	JSJ
	B) Trigger Pull	2.51	2.47	2.50	2.52	2.52	3 Feb 89	JSJ
	C) Function						3 Feb 89	JSJ
660	Pack						23 Mar 89	JSJ

INTEGRITY TEST
AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6225408

DATE 4/3/90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.40	2.42		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.35	2.39		
PULL #3	2.51	2.20	2.37		
PULL #4	2.48	2.27	2.30		
PULL #5	2.43	2.29	2.31		
TOTAL	12.36	11.51	11.79		
AVG.	2.47	2.31	2.35		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.13		
PULL #2	3.13	3.11		
PULL #3	3.20	3.12		
PULL #4	3.22	3.15		
PULL #5	3.19	3.16		
TOTAL	15.93	15.67		
AVG.	3.18	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.24		
PULL #2	4.17	4.18		
PULL #3	4.24	4.18		
PULL #4	4.12	4.18		
PULL #5	4.26	4.20		
TOTAL	21.02	20.98		
AVG.	4.21	4.19		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225408
2 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.410581
1 TO	2	.504933
1 TO	3	.191802
1 TO	4	.112071
1 TO	5	.694575

5
3+
4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0688
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.182
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .19457
THE AMR FOR THIS RIFLE IS: .829

31 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/062254B8

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.837

VS= 2.460

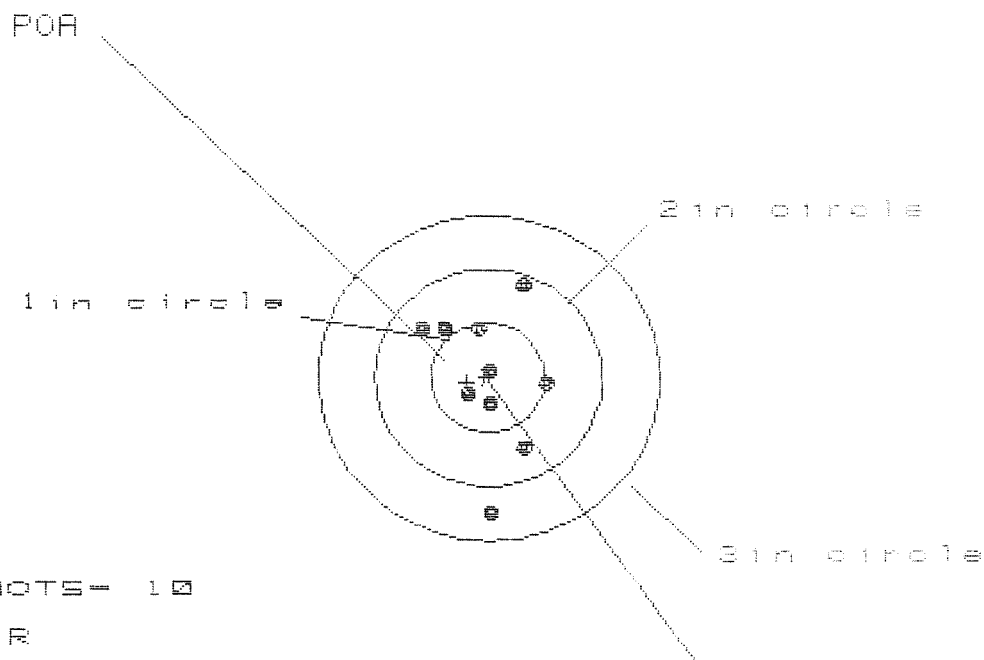
GS= 2.626

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.811	.682
MINIMUM X	:	-1.031	-1.026	-.999
MAXIMUM Y	:	.696	.499	.365
MINIMUM Y	:	-1.764	-1.075	-.440
CENTROID X	:	-.036	-.041	.087
CENTROID Y	:	-.489	-.213	-.079
POA TO CENTROID in.	:	.411	.217	.118
MIN RADIUS	:	.291	.154	.129
MEAN RADIUS	:	.813	.644	.504
MAX RADIUS	:	1.765	1.486	1.063
HORIZONTAL SPREAD	:	1.837	1.837	1.681
VERTICAL SPREAD	:	2.460	1.574	.865
EXTREME SPREAD	:	2.626	2.259	1.701
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06225400

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.141

VS= 2.123

GS= 2.139

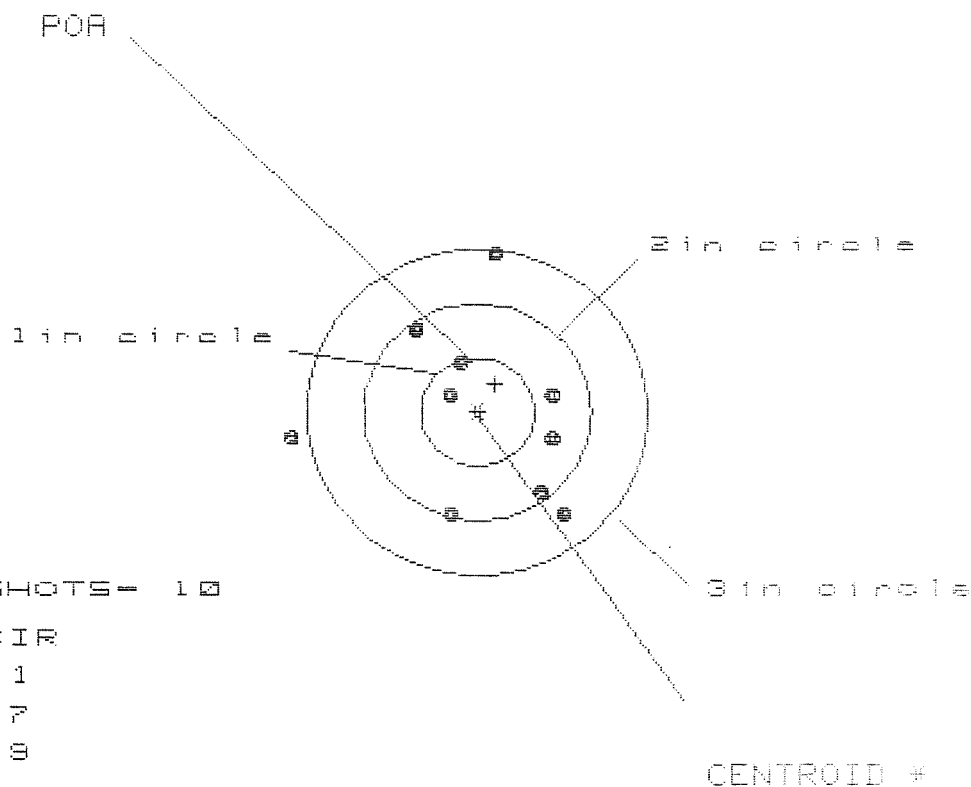
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.535	.537	.571
MINIMUM X	:	-.606	-.604	-.570
MAXIMUM Y	:	.838	.696	.481
MINIMUM Y	:	-1.285	-.746	-.659
CENTROID X	:	.185	.183	.149
CENTROID Y	:	.045	.187	.100
POA TO CENTROID in.	:	.190	.262	.179
MIN RADIUS	:	.059	.098	.067
MEAN RADIUS	:	.568	.485	.438
MAX RADIUS	:	1.285	.824	.763
HORIZONTAL SPREAD	:	1.141	1.141	1.141
VERTICAL SPREAD	:	2.123	1.442	1.068
EXTREME SPREAD	:	2.139	1.444	1.425
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.438

VS = 2.449

GS = 2.544

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.789	.606	.605
MINIMUM X	:	-1.649	-.679	-.688
MAXIMUM Y	:	1.467	1.438	.933
MINIMUM Y	:	-.982	-1.011	-.831
CENTROID X	:	-.158	.025	.026
CENTROID Y	:	-.261	-.232	-.412
POA TO CENTROID in.	:	.305	.234	.413
MIN RADIUS	:	.285	.424	.428
MEAN RADIUS	:	.939	.841	.760
MAX RADIUS	:	1.668	1.438	1.155
HORIZONTAL SPREAD	:	2.438	1.285	1.285
VERTICAL SPREAD	:	2.449	2.449	1.764
EXTREME SPREAD	:	2.544	2.525	2.182
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

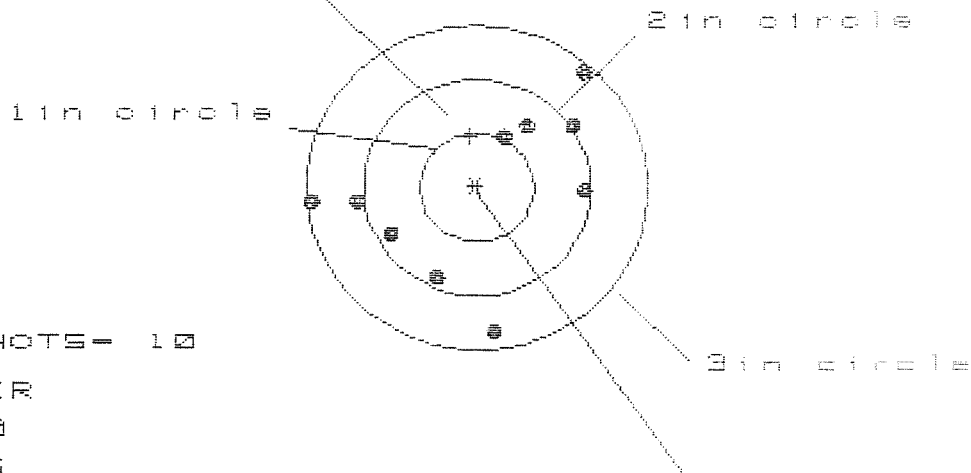
31 Jan 1989

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 10

HS= 2.353

VS= 2.408

GS= 2.635

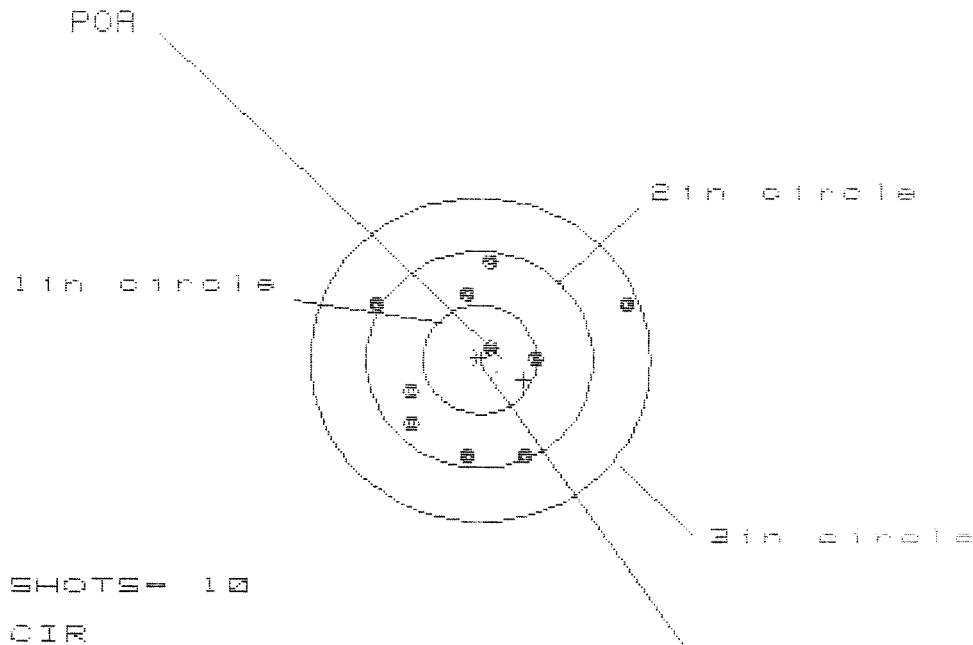
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.947	1.052	.889
MINIMUM X	:	-1.406	-1.301	-1.135
MAXIMUM Y	:	1.061	.733	.730
MINIMUM Y	:	-1.347	-1.229	-1.232
CENTROID X	:	.056	-.049	.114
CENTROID Y	:	-.473	-.591	-.588
POA TO CENTROID in.	:	.476	.593	.599
MIN RADIUS	:	.549	.686	.642
MEAN RADIUS	:	1.029	.981	.932
MAX RADIUS	:	1.417	1.302	1.237
HORIZONTAL SPREAD	:	2.353	2.353	2.024
VERTICAL SPREAD	:	2.408	1.962	1.962
EXTREME SPREAD	:	2.635	2.421	2.092
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS= 2.128

VS= 1.819

GS= 2.165

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.262	.642	.551
MINIMUM X	:	-.866	-.726	-.600
MAXIMUM Y	:	.921	.980	1.053
MINIMUM Y	:	-.898	-.839	-.766
CENTROID X	:	-.391	-.531	-.440
CENTROID Y	:	.188	.129	.056
POA TO CENTROID in.	:	.434	.547	.444
MIN RADIUS	:	.129	.277	.263
MEAN RADIUS	:	.796	.733	.699
MAX RADIUS	:	1.369	1.005	1.061
HORIZONTAL SPREAD	:	2.128	1.368	1.151
VERTICAL SPREAD	:	1.819	1.819	1.819
EXTREME SPREAD	:	2.165	1.875	1.839
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	