

C6649247

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





MODEL 700™ H24



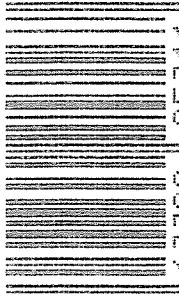
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
C6649247

ORDER NO.
5716

UPC



0 4700 25716 7



5716 C6649247

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649247

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7/22/91	LS
	Apply Coating (Bolt)		7/22/91	LS
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8-16-91	DH
	G) Safety Off Force	2	2	2			8-16-91	DH
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.021	.022	.022			8-16-91	DH
	J) Assemble Stock						8/17/91	RW
	K) Assemble Swivel Studs						8-21-91	AC
	L) Attach Front and Rear Sight Assemblies						8/17/91	RW
	M) Iron Sight Alignment						8/17/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/17/91	RW
	O) Attach Scope to Rifle						8/17/91	RW
	P) Detach & Attach Scope 20 Times						8/17/91	RW
640	Gallery Target & Test						8-19-91	AC
	A) Time						8-19-91	AC
	B) Malfunctions						8-19-91	AC
	C) Pierced Primers						8-19-91	AC
	D) Optical Clarity of Scope						8-19-91	AC
645	Inspect for Live Ammo						8-19-91	AC
655	Final Inspection							
	A) Headspace						8-21-91	AC
	B) Trigger Pull	2.70	2.72	2.71	2.72	2.56	8-21-91	DH
	C) Function						8-21-91	AC
660	Pack						9-19-91	AC

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649247
DATE 8/16/81
TESTER W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.48	2.43	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.33	2.50	2.72	
PULL #3	2.25	2.39	2.48	2.71	
PULL #4	2.37	2.36	2.53	2.72	
PULL #5	2.49	2.49	2.33	2.56	
TOTAL	11.75	12.05	12.27		
AVG.	2.35	2.41	2.45		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.17		
PULL #2	3.15	3.17		
PULL #3	3.17	3.15		
PULL #4	3.13	3.17		
PULL #5	3.22	3.15		
TOTAL	15.80	15.81		
AVG.	3.16	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.04		4.04
PULL #2	4.04	4.08		4.06
PULL #3	4.00	3.95		4.13
PULL #4	4.00	4.08		4.14
PULL #5	4.10	4.02		4.08
TOTAL	20.17	20.17		20.45
AVG.	4.03	4.03		4.09

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649247
23 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.142285
1 TO	2	.313287
1 TO	3	.0980051
1 TO	4	.142667
1 TO	5	.446161

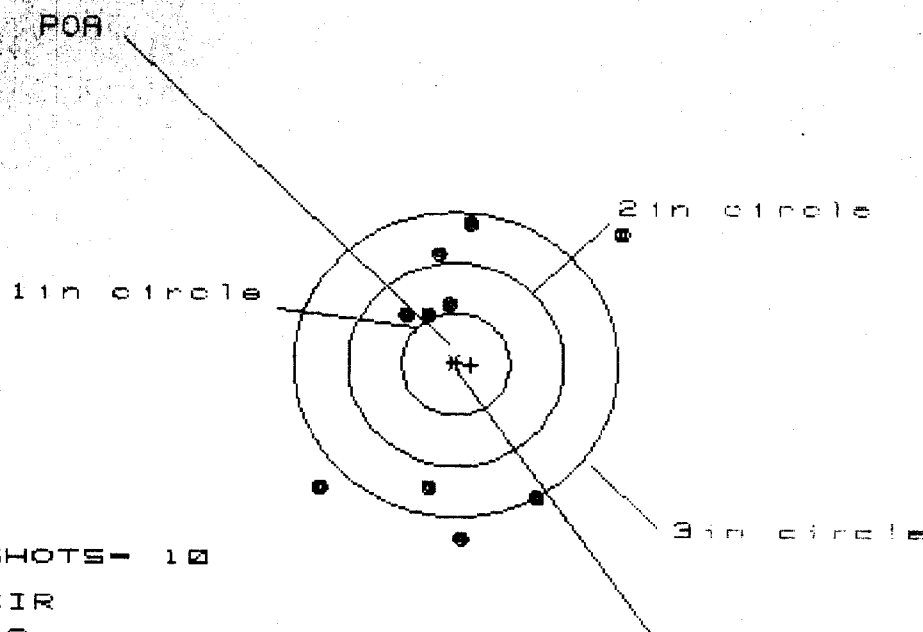
245 <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0774
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0676
RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102764
MEAN FOR THIS RIFLE IS: .9194

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649247

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 0

2in - 3

3in = 7

CENTROID #

HS= 2.789

VS= 3.149

GS= 3.746

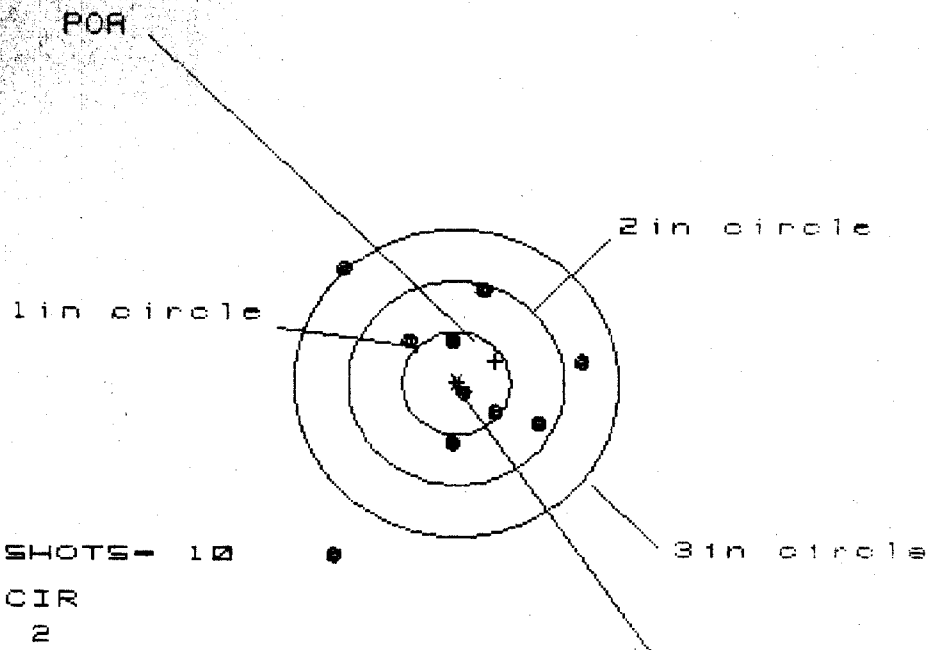
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.560	.921	.949
MINIMUM X	:	-1.229	-1.056	-1.028
MAXIMUM Y	:	1.419	1.563	1.364
MINIMUM Y	:	-1.730	-1.586	-1.341
CENTROID X	:	-.142	-.315	-.343
CENTROID Y	:	.009	-.135	.064
POA TO CENTROID in.	:	.142	.342	.349
MIN RADIUS	:	.562	.685	.485
MEAN RADIUS	:	1.265	1.183	1.073
MAX RADIUS	:	2.026	1.602	1.643
HORIZONTAL SPREAD	:	2.789	1.977	1.977
VERTICAL SPREAD	:	3.149	3.149	2.705
EXTREME SPREAD	:	3.746	3.150	2.952
NUMBER IN ONE INCH CIRCLE	=	0	3	7
NUMBER IN TWO INCH CIRCLE	=	3	7	7
NUMBER IN THREE INCH CIRCLE	=	7	7	7

23 Aug 1991

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CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.289

VS= 2.801

GS= 2.998

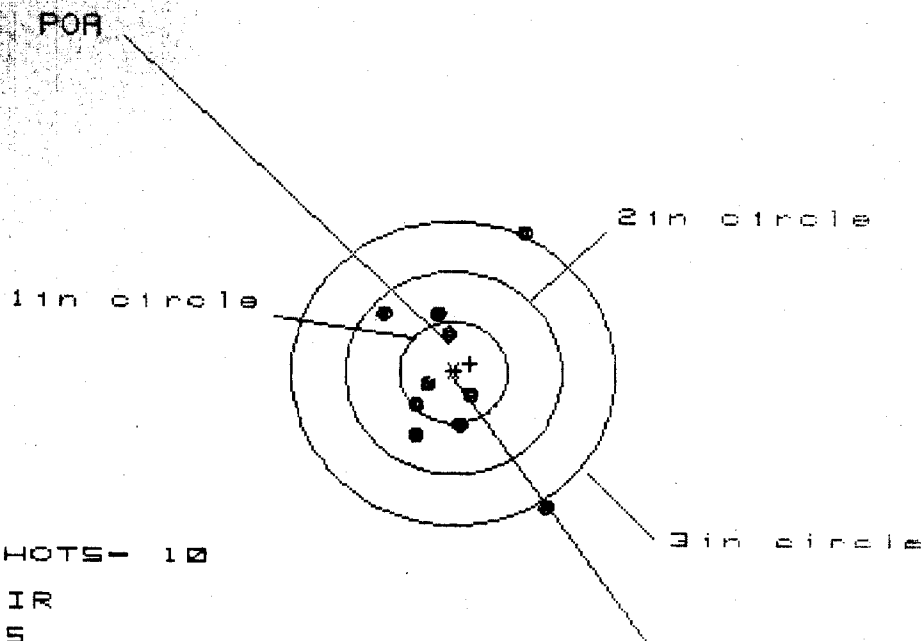
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.122	.993	.851
MINIMUM X	:	-1.167	-1.135	-.671
MAXIMUM Y	:	1.143	.958	.888
MINIMUM Y	:	-1.659	-.797	-.677
CENTROID X	:	-.360	-.231	-.089
CENTROID Y	:	-.216	-.032	-.152
POA TO CENTROID in.	:	.420	.233	.176
MIN RADIUS	:	.151	.289	.234
MEAN RADIUS	:	.881	.743	.633
MAX RADIUS	:	2.028	1.486	.889
HORIZONTAL SPREAD	:	2.289	2.128	1.522
VERTICAL SPREAD	:	2.801	1.755	1.565
EXTREME SPREAD	:	2.998	2.351	1.609
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

23 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.552

VS= 2.617

GS= 2.627

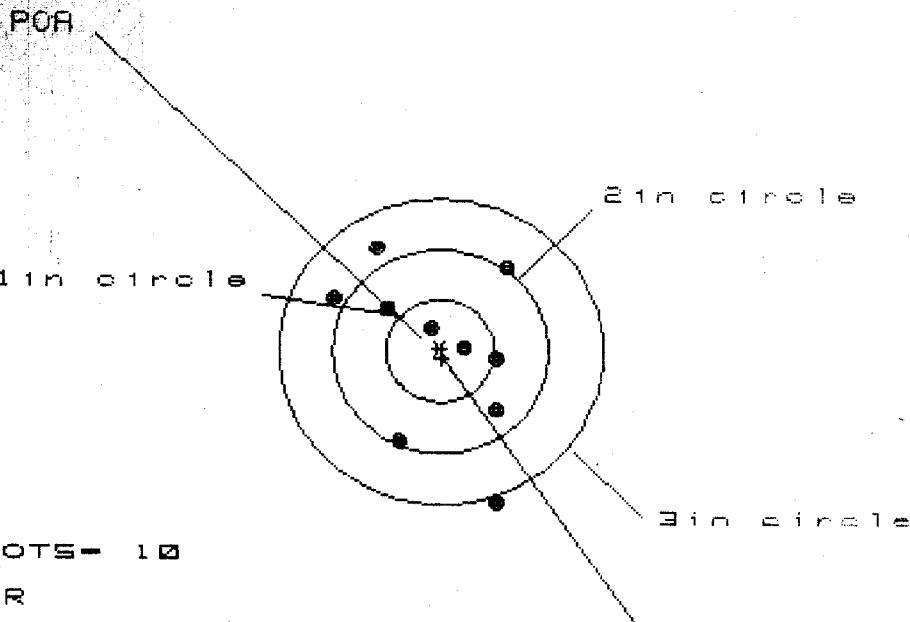
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.897	.763	.386
MINIMUM X	-.655	-.555	-.460
MAXIMUM Y	1.339	1.197	.628
MINIMUM Y	-1.278	-.722	-.573
CENTROID X	-.156	-.256	-.351
CENTROID Y	-.088	.054	-.095
POR TO CENTROID in.	.179	.261	.364
MIN RADIUS	.258	.251	.137
MEAN RADIUS	.714	.612	.476
MAX RADIUS	1.562	1.419	.744
HORIZONTAL SPREAD	1.552	1.318	.846
VERTICAL SPREAD	2.617	1.919	1.201
EXTREME SPREAD	2.627	2.152	1.279
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1981

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.583

VS= 2.490

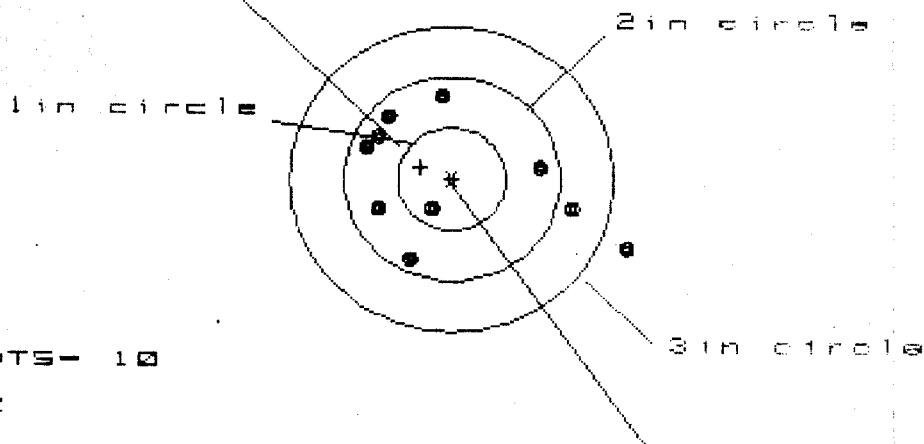
GS= 2.713

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.633	.693	.633
MINIMUM X	:	-.950	-.890	-.950
MAXIMUM Y	:	.984	.817	.763
MINIMUM Y	:	-1.506	-1.067	-.965
CENTROID X	:	-.015	-.075	-.015
CENTROID Y	:	.074	.241	.139
POA TO CENTROID in.	:	.075	.252	.140
MIN RADIUS	:	.258	.097	.213
MEAN RADIUS	:	.831	.722	.692
MAX RADIUS	:	1.601	1.119	1.059
HORIZONTAL SPREAD	:	1.583	1.583	1.583
VERTICAL SPREAD	:	2.490	1.884	1.728
EXTREME SPREAD	:	2.713	2.012	2.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 8

3 in - 9

HS- 2.396

VS- 1.594

GS- 2.604

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.573	1.275	1.157
MINIMUM X	:	-.823	-.649	-.489
MAXIMUM Y	:	.806	.731	.681
MINIMUM Y	:	-.788	-.863	-.913
CENTROID X	:	.286	.112	-.048
CENTROID Y	:	-.117	-.042	.008
POA TO CENTROID in.	:	.309	.119	.048
MIN RADIUS	:	.309	.332	.415
MEAN RADIUS	:	.906	.776	.671
MAX RADIUS	:	1.714	1.336	1.157
HORIZONTAL SPREAD	:	2.396	1.924	1.646
VERTICAL SPREAD	:	1.594	1.594	1.594
EXTREME SPREAD	:	2.604	2.034	1.658
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	