

C6611387

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.
C6611387

ORDER NO.
5716



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611387

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	3 1	RW
600	Proof	1 25	9 1	RW
607	Check Headspace	25	9 1	RW
610	Dis-assemble Gun	35	9 1	RW
612	Magnaflux Barrel Action	1 25	9 1	KR
	Magnaflux Bolt	1 25	3 1	KR
615	Rollmark Caliber	1 25	3 1	JS
617	Drill and Tap Sight Holes	1 30	9 1	LB
618	Polish Barrel RBB	1 30	9 1	LB
620	Apply Coatings (Barrel Action)		2-10-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/13/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/13/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/13/91	WB
	H) Trigger Pull Test & Retainability						2/13/91	FL
	I) Firing Pin Indent	.021	.0225	.022			2/13/91	WB
	J) Assemble Stock						2/14/91	RW
	K) Assemble Swivel Studs						2-25-91	AC
	L) Attach Front and Rear Sight Assemblies						2/14/91	RW
	M) Iron Sight Alignment						2/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/14/91	RW
	O) Attach Scope to Rifle						2/14/91	RW
	P) Detach & Attach Scope 20 Times						2/14/91	RW
640	Gallery Target & Test						2-14-91	DH
	A) Time						2-14-91	DH
	B) Malfunctions						2-14-91	DH
	C) Pierced Primers						2-14-91	DH
	D) Optical Clarity of Scope						2-14-91	DH
645	Inspect for Live Ammo						2-14-91	DH
655	Final Inspection							
	A) Headspace						2-25-91	AC
	B) Trigger Pull	2.18	2.42	2.38	2.33	2.37	2-21-91	FL
	C) Function						2-25-91	AC
660	Pack						3-18-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611387DATE 2/13/91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.27	2.23	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.22	2.19	2.42	
PULL #3	2.27	2.31	2.30	2.38	
PULL #4	2.30	2.23	2.25	2.33	
PULL #5	2.30	2.36	2.33	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.30		
PULL #2	3.45	3.35		
PULL #3	3.41	3.31		
PULL #4	3.38	3.35		
PULL #5	3.18	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.31		4.28
PULL #2	4.33	4.35		4.23
PULL #3	4.30	4.23		4.30
PULL #4	4.28	4.28		4.24
PULL #5	4.28	4.16		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611387
14 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.327519
1 TO	2	.0890225
1 TO	3	.346539
1 TO	4	.485103
1 TO	5	.284935

$\bar{x}$ <----POX

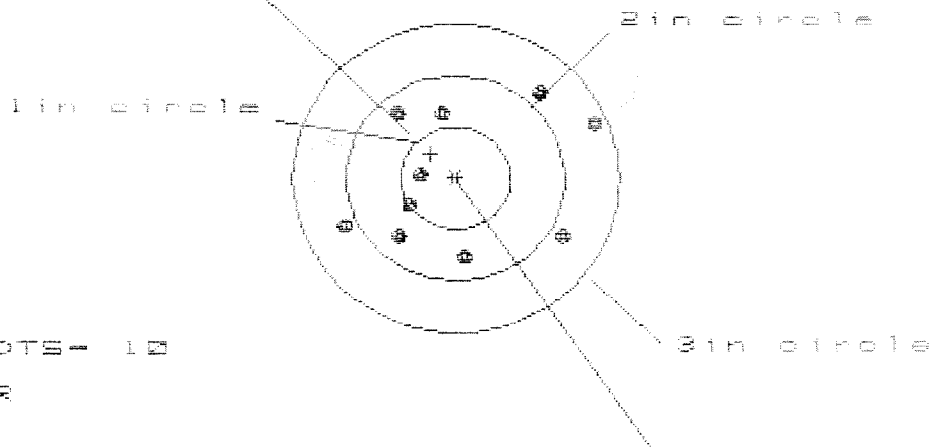
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0774
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0654
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .101331
THE AMR FOR THIS RIFLE IS: .9812

14 Feb 1931

FILE:/PATTERNING/CENTERFIRE_PATT/08611387

CENTERFIRE PATTERNS # 1

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 10

HS = 2.365

VS = 1.618

GS = 2.595

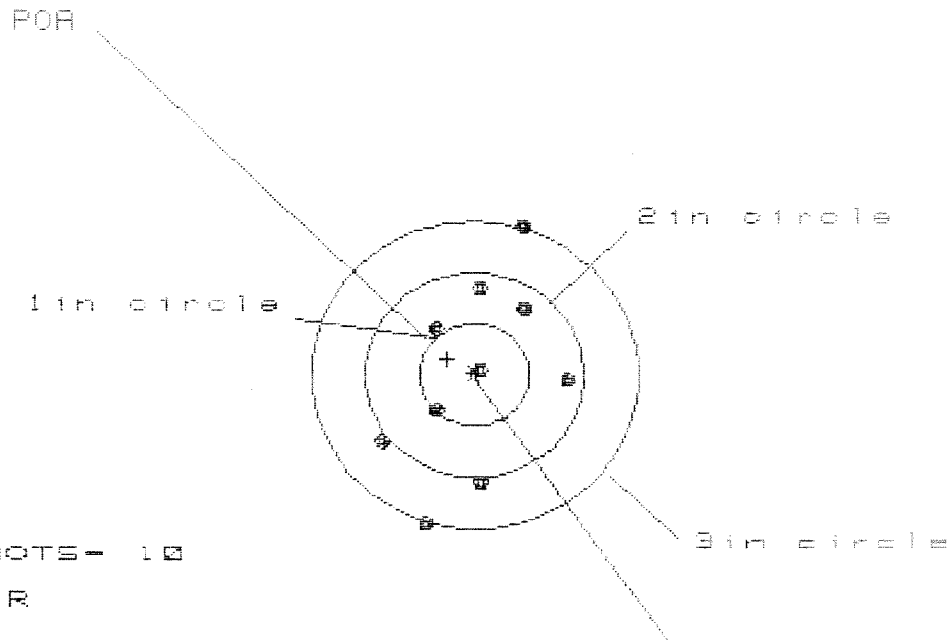
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	1.090	.975
MINIMUM X	:	-1.069	-.925	-.523
MAXIMUM Y	:	.812	.877	.825
MINIMUM Y	:	-.806	-.741	-.794
CENTROID X	:	.225	.081	.196
CENTROID Y	:	-.238	-.303	-.251
POA TO CENTROID in.	:	.327	.313	.318
MIN RADIUS	:	.373	.250	.346
MEAN RADIUS	:	.879	.779	.768
MAX RADIUS	:	1.423	1.298	1.178
HORIZONTAL SPREAD	:	2.365	2.015	1.498
VERTICAL SPREAD	:	1.618	1.618	1.618
EXTREME SPREAD	:	2.595	2.284	1.942
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.763

VS= 2.823

GS= 2.944

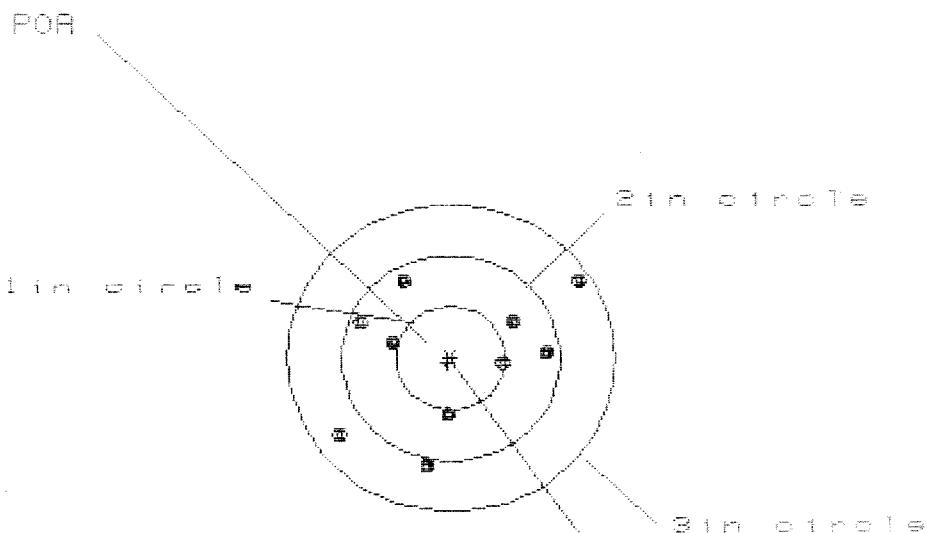
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.878	.925	.880
MINIMUM X	:	-.885	-.838	-.883
MAXIMUM Y	:	1.412	1.014	.857
MINIMUM Y	:	-1.411	-1.254	-1.026
CENTROID X	:	.248	.201	.246
CENTROID Y	:	-.152	-.309	-.152
POR TO CENTROID in.	:	.291	.368	.289
MIN RADIUS	:	.082	.244	.083
MEAN RADIUS	:	.872	.814	.722
MAX RADIUS	:	1.474	1.306	1.094
HORIZONTAL SPREAD	:	1.763	1.763	1.763
VERTICAL SPREAD	:	2.823	2.268	1.883
EXTREME SPREAD	:	2.944	2.316	1.883
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.156

VS= 1.800

GS= 2.632

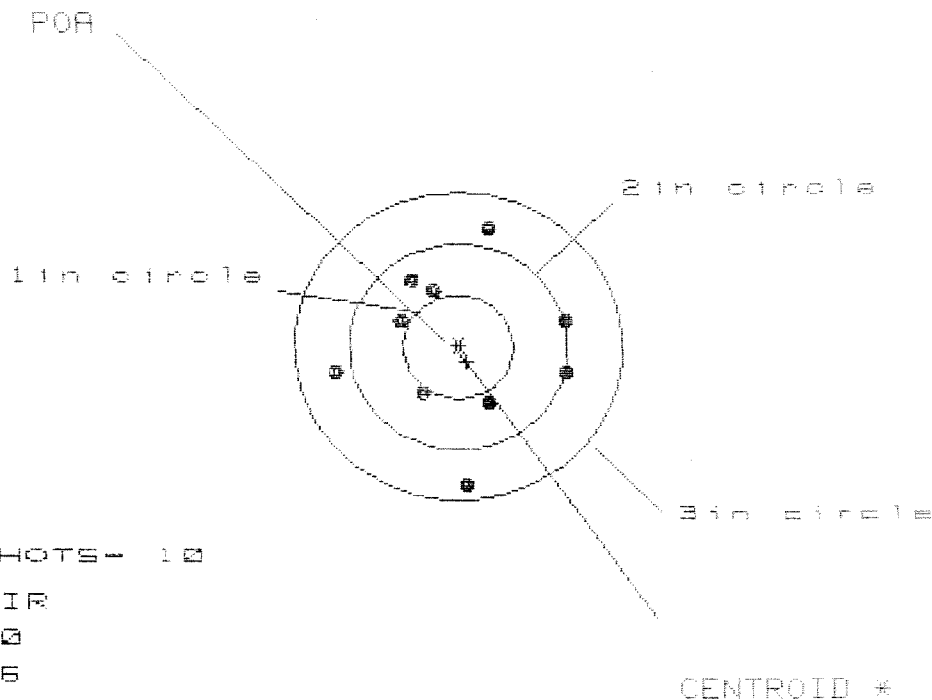
CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.127	1.012	.899
MINIMUM X	-1.029	-.904	-.848
MAXIMUM Y	.754	.813	.729
MINIMUM Y	-1.046	-.962	-1.046
CENTROID X	.025	-.100	.013
CENTROID Y	.045	-.039	.045
POA TO CENTROID in.	.052	.107	.047
MIN RADIUS	.431	.441	.443
MEAN RADIUS	.856	.794	.741
MAX RADIUS	1.356	1.126	1.061
HORIZONTAL SPREAD	2.156	1.916	1.747
VERTICAL SPREAD	1.800	1.775	1.775
EXTREME SPREAD	2.632	2.077	1.793
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 2.115

VS= 2.494

GS= 2.502

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.983	.997	1.038
MINIMUM X	-1.132	-1.118	-1.077
MAXIMUM Y	1.132	.981	.582
MINIMUM Y	-1.362	-.674	-.551
CENTROID X	-.074	-.088	-.129
CENTROID Y	.144	.295	.172
POA TO CENTROID in.	.162	.308	.216
MIN RADIUS	.528	.472	.516
MEAN RADIUS	.877	.868	.771
MAX RADIUS	1.367	1.171	1.100
HORIZONTAL SPREAD	2.115	2.115	2.115
VERTICAL SPREAD	2.494	1.655	1.133
EXTREME SPREAD	2.502	2.116	2.116
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 2.162

VS= 2.408

GS= 2.804

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.520	.982	.946
MINIMUM X	:	-.643	-.474	-.510
MAXIMUM Y	:	1.145	1.226	1.078
MINIMUM Y	:	-1.263	-1.182	-1.100
CENTROID X	:	-.037	-.206	-.170
CENTROID Y	:	-.126	-.207	-.059
POA TO CENTROID in.	:	.132	.292	.180
MIN RADIUS	:	.528	.509	.413
MEAN RADIUS	:	1.022	.928	.892
MAX RADIUS	:	1.682	1.337	1.213
HORIZONTAL SPREAD	:	2.162	1.456	1.456
VERTICAL SPREAD	:	2.408	2.408	2.178
EXTREME SPREAD	:	2.804	2.447	2.361
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	