

C6611433

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





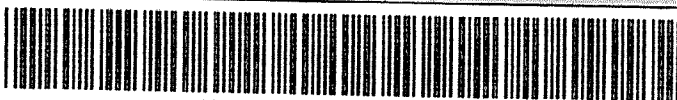
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

SERIAL NO.
C6611433

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

ORDER NO.
5716



5716 C6611433

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611433

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	81	RW
600	Proof	1 25	81	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action	1 2		KR
	Magnaflux Bolt	1 25	81	KR
615	Rollmark Caliber	1 25	91	GL
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel RBB	1 30	91	FB
620	Apply Coatings (Barrel Action)		2-10-91	TJA
	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		2/11/91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/16/91	WB
	I) Firing Pin Indent	.0225	.023	.023			2/16/91	WB
	J) Assemble Stock						2/18/91	WB
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	WB
	M) Iron Sight Alignment						2/18/91	WB
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	WB
	O) Attach Scope to Rifle						2/18/91	WB
	P) Detach & Attach Scope 20 Times						2/18/91	WB
640	Gallery Target & Test						2/19/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						2/19/91	KJ
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.40	2.36	2.24	2.35	2.20	2/21/91	WB
	C) Function						2-22-91	A
660	Pack						3-19-91	WB

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611433

DATE 2/14/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.18	2.48	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.52	2.50	2.36	
PULL #3	2.47	2.23	2.33	2.24	
PULL #4	2.36	2.22	2.41	2.35	
PULL #5	2.35	2.47	2.20	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.27		
PULL #2	3.42	3.29		
PULL #3	3.41	3.25		
PULL #4	3.33	3.27		
PULL #5	3.28	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.45		4.37
PULL #2	4.25	4.34		4.23
PULL #3	4.32	4.34		4.29
PULL #4	4.21	4.31		4.19
PULL #5	4.31	4.27		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611433
28 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0437379
1 TO	2	.0373363
1 TO	3	.10224
1 TO	4	.151093
1 TO	5	.0512445

4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0166
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0180942

THE AMP FOR THIS RIFLE IS: .0084

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611433

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 10

HS = 1.466

VS = 2.124

GS = 2.140

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.635

.673

.574

MINIMUM X

-.831

-.793

-.792

MAXIMUM Y

1.351

1.015

.614

MINIMUM Y

-.773

-.623

-.496

CENTROID X

.043

.005

.104

CENTROID Y

.008

-.142

-.269

POA TO CENTROID in.

.044

.142

.288

MIN RADIUS

.338

.288

.165

MEAN RADIUS

.745

.641

.530

MAX RADIUS

1.393

1.288

.949

HORIZONTAL SPREAD

1.466

1.466

1.366

VERTICAL SPREAD

2.124

1.638

1.110

EXTREME SPREAD

2.140

2.140

1.633

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611433

CENTERFIRE PATTERNS # 2

POA

1 in circle =

2 in circle =

3 in circle =

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 8

3 in = 8

HS = 2.873

VS = 1.591

GS = 3.237

CENTROID *

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.494

1.341

.471

MINIMUM X

-1.379

-.557

-.389

MAXIMUM Y

.691

.590

.652

MINIMUM Y

-.901

-.480

-.418

CENTROID X

.048

.201

.033

CENTROID Y

-.029

.072

.010

POA TO CENTROID in.

.056

.213

.035

MIN RADIUS

.131

.278

.107

MEAN RADIUS

.665

.591

.425

MAX RADIUS

1.647

1.428

.749

HORIZONTAL SPREAD

2.873

1.898

.960

VERTICAL SPREAD

1.591

1.070

1.070

EXTREME SPREAD

3.237

2.109

1.281

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

8

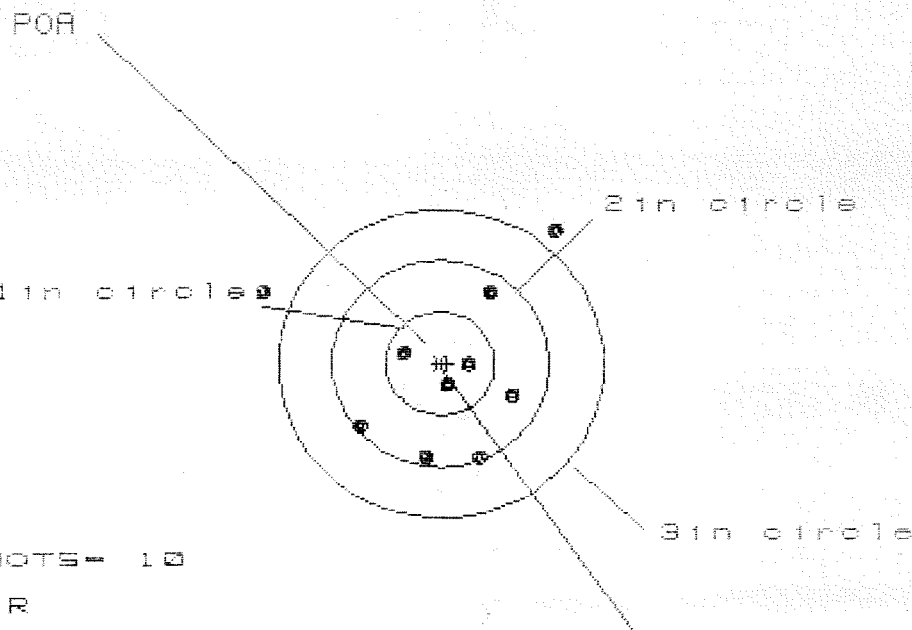
NUMBER IN THREE INCH CIRCLE =

8

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11433

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.649

VS= 2.284

GS= 2.720

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.047	.869	.616
MINIMUM X	:	-1.602	-.946	-.837
MAXIMUM Y	:	1.346	1.427	.913
MINIMUM Y	:	-.938	-.857	-.679
CENTROID X	:	-.059	.119	.010
CENTROID Y	:	.001	-.080	-.258
POA TO CENTROID in.	:	.059	.143	.258
MIN RADIUS	:	.186	.147	.086
MEAN RADIUS	:	.870	.746	.613
MAX RADIUS	:	1.760	1.671	1.003
HORIZONTAL SPREAD	:	2.649	1.815	1.453
VERTICAL SPREAD	:	2.284	2.284	1.592
EXTREME SPREAD	:	2.720	2.637	1.749
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611433

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.600

VS= 2.044

GS= 2.600

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	1.140	.614
MINIMUM X	-1.314	-1.040	-.897
MAXIMUM Y	1.146	1.133	1.114
MINIMUM Y	-.898	-.911	-.930
CENTROID X	-.034	.112	-.031
CENTROID Y	-.122	-.109	-.090
POA TO CENTROID in.	.127	.157	.095
MIN RADIUS	.276	.267	.304
MEAN RADIUS	.896	.838	.792
MAX RADIUS	1.319	1.226	1.119
HORIZONTAL SPREAD	2.600	2.180	1.511
VERTICAL SPREAD	2.044	2.044	2.044
EXTREME SPREAD	2.600	2.235	2.142
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611433

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 8

HS= 1.419

VS= 3.788

GS= 3.853

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.589	.575	.470
MINIMUM X	-.830	-.844	-.499
MAXIMUM Y	1.657	1.420	.939
MINIMUM Y	-2.131	-1.160	-.982
CENTROID X	.038	.052	.157
CENTROID Y	.059	.296	.118
POA TO CENTROID in.	.070	.300	.197
MIN RADIUS	.137	.113	.160
MEAN RADIUS	.866	.696	.571
MAX RADIUS	2.135	1.652	1.102
HORIZONTAL SPREAD	1.419	1.419	.969
VERTICAL SPREAD	3.788	2.580	1.921
EXTREME SPREAD	3.853	2.736	2.023
NUMBER IN ONE INCH CIRCLE	= 4		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		