

C6349000

MODEL 700TM M24

Model **SMS**TM

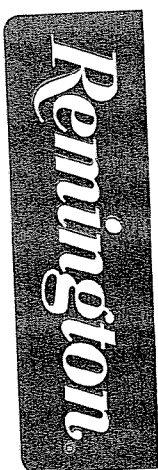
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



RC -15
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349000

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	Rw
600	Proof	1 12	90	A
607	Check Headspace	1 12	90	A
610	Dis-assemble Gun	1 12	90	Rw
612	Magnaflux Barrel Action	1-16-90		KCR
	Magnaflux Bolt	1-17-90		KCR
615	Rollmark Caliber		1/17/90	JS
617	Drill and Tap Sight Holes		1/19/90	FB
618	Polish Barrel RB		1/22/90	WB
620	Apply Coatings (Barrel Action)		1/23/90	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		2/1/90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/1/90	Rw
	C) Inspect Ejector Hole for Chamfer		2/1/90	Rw
	D) Oil Firing Pin Ass'y		2/1/90	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		12 Feb 90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2-1-90	JK
	G) Safety Off Force	3	3	3			2-1-90	JK
	H) Trigger Pull Test & Retainability						1/26/90	JS
	I) Firing Pin Indent	.021	.0215	.022			2-1-90	JK
	J) Assemble Stock						3/1/90	RW
	K) Assemble Swivel Studs						3/15/90	WB
	L) Attach Front and Rear Sight Assemblies						3/1/90	RW
	M) Iron Sight Alignment						3/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container						3/1/90	RW
	O) Attach Scope to Rifle						3/7/90	WB
	P) Detach & Attach Scope 20 Times						3/7/90	WB
640	Gallery Target & Test						3-5-90	AC
	A) Time						3-5-90	AC
	B) Malfunctions						3-5-90	AC
	C) Pierced Primers						3-5-90	AC
	D) Optical Clarity of Scope						3-5-90	AC
645	Inspect for Live Ammo						3-5-90	AC
655	Final Inspection							
	A) Headspace						15 Mar 90	JS
	B) Trigger Pull	237	238	235	233	237	15 Mar 90	JS
	C) Function						15 Mar 90	JS
660	Pack						20 Mar 90	JS




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

MODEL 700™ H24

SERIAL NO.
C6349000

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6349000

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349000
DATE 1 Feb 90
TESTER JD

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.21	2.45	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.21	2.34	2.38	
PULL #3	2.28	2.32	2.24	2.35	
PULL #4	2.33	2.23	2.27	2.33	
PULL #5	2.42	2.28	2.38	2.37	
TOTAL	11.73	11.31	11.68	11.80	
AVG.	2.346	2.262	2.336	2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.03		
PULL #2	2.95	3.03		
PULL #3	2.99	2.99		
PULL #4	3.02	3.10		
PULL #5	3.07	3.07		
TOTAL	15.07	15.22		
AVG.	3.014	3.044		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	3.84		3.94
PULL #2	4.07	3.92		3.96
PULL #3	4.07	3.94		4.05
PULL #4	4.07	3.96		3.97
PULL #5	4.04	3.95		4.05
TOTAL	20.42	19.61		19.97
AVG.	4.084	3.922		3.994

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349000
5 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.508693
1 TO	2	.439145
1 TO	3	.723243
1 TO	4	.70791
1 TO	5	.0687677

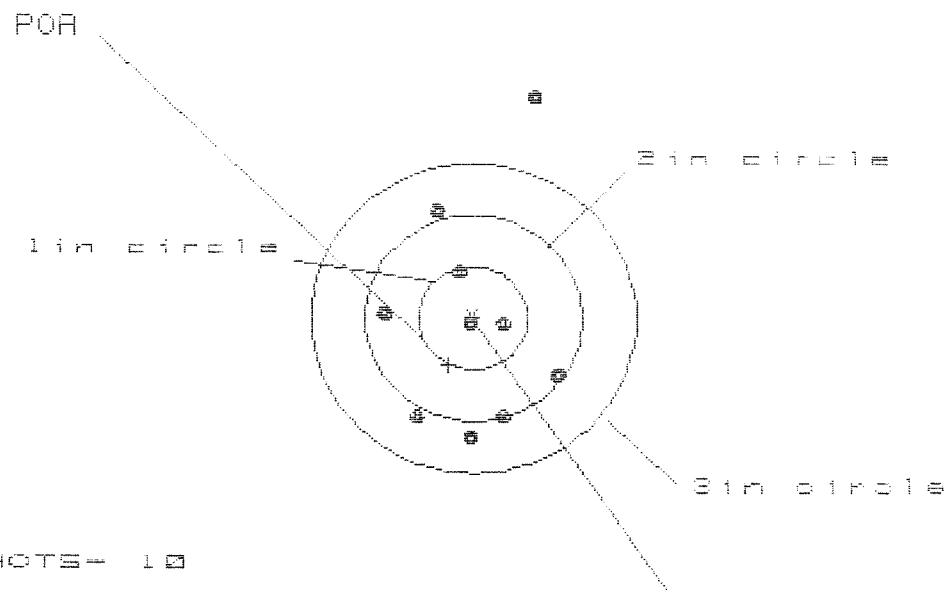
$\frac{1}{2}$ ⁵ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 0
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2084
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .2084
THE AMR FOR THIS RIFLE IS: .8902

5 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349000

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 0

HS= 1.585

VS= 3.347

QS= 3.389

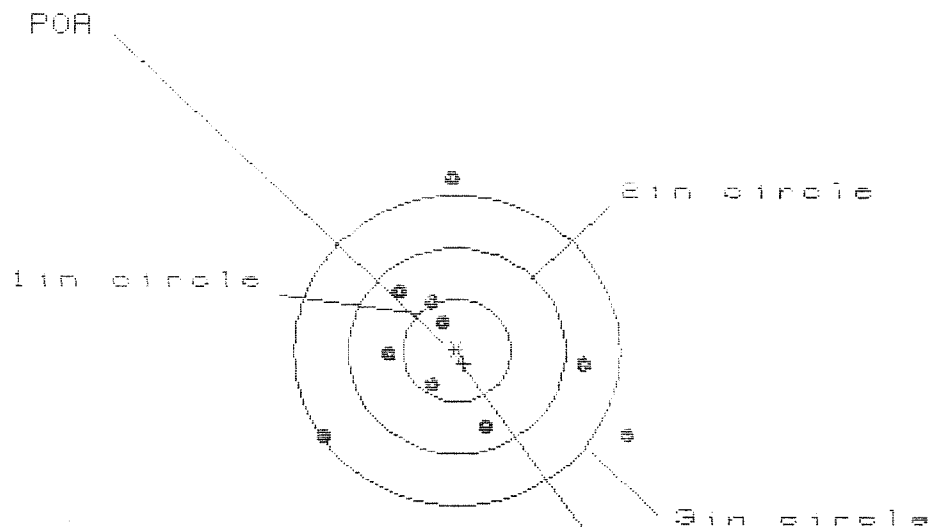
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.880	.880
MINIMUM X	:	-.866	-.806	-.798
MAXIMUM Y	:	2.153	1.253	1.134
MINIMUM Y	:	-1.194	-.955	-.826
CENTROID X	:	.227	.167	.159
CENTROID Y	:	.453	.214	.333
POA TO CENTROID in.	:	.507	.271	.369
MIN RADIUS	:	.084	.163	.061
MEAN RADIUS	:	.928	.773	.730
MAX RADIUS	:	2.219	1.280	1.162
HORIZONTAL SPREAD	:	1.686	1.686	1.686
VERTICAL SPREAD	:	3.347	2.208	1.960
EXTREME SPREAD	:	3.389	2.232	2.025
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Mar 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 2.821

VS= 2.542

GS= 3.013

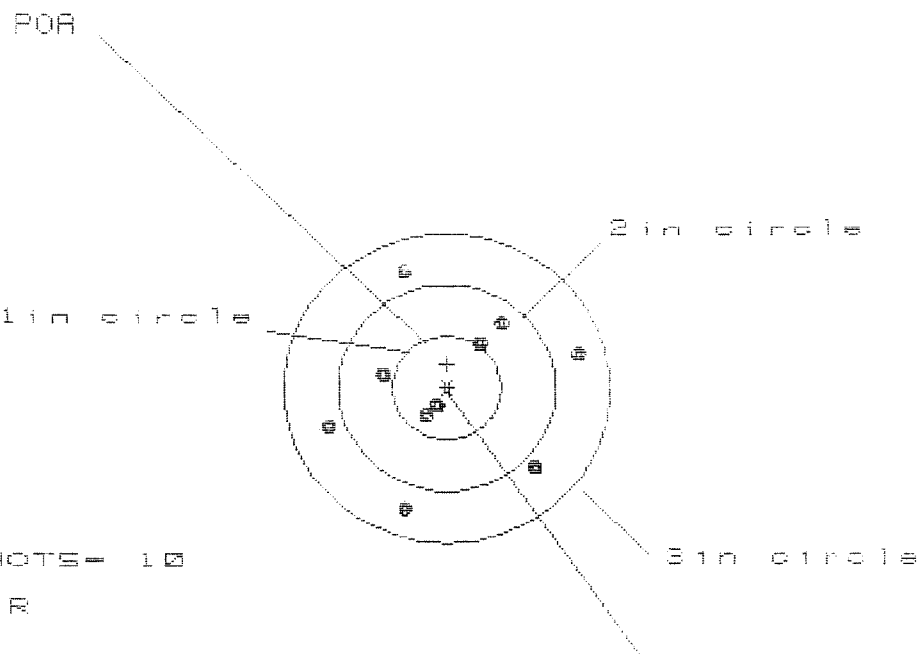
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.581	1.359	1.376
MINIMUM X	:	-1.240	-1.064	-1.047
MAXIMUM Y	:	1.668	1.570	.676
MINIMUM Y	:	-.874	-.971	-.774
CENTROID X	:	-.065	-.241	-.259
CENTROID Y	:	.125	.223	.026
POA TO CENTROID in.	:	.141	.328	.259
MIN RADIUS	:	.297	.176	.208
MEAN RADIUS	:	.960	.822	.730
MAX RADIUS	:	1.807	1.577	1.376
HORIZONTAL SPREAD	:	2.821	2.423	2.423
VERTICAL SPREAD	:	2.542	2.541	1.450
EXTREME SPREAD	:	3.013	2.811	2.535
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.274

VS = 2.295

GS = 2.377

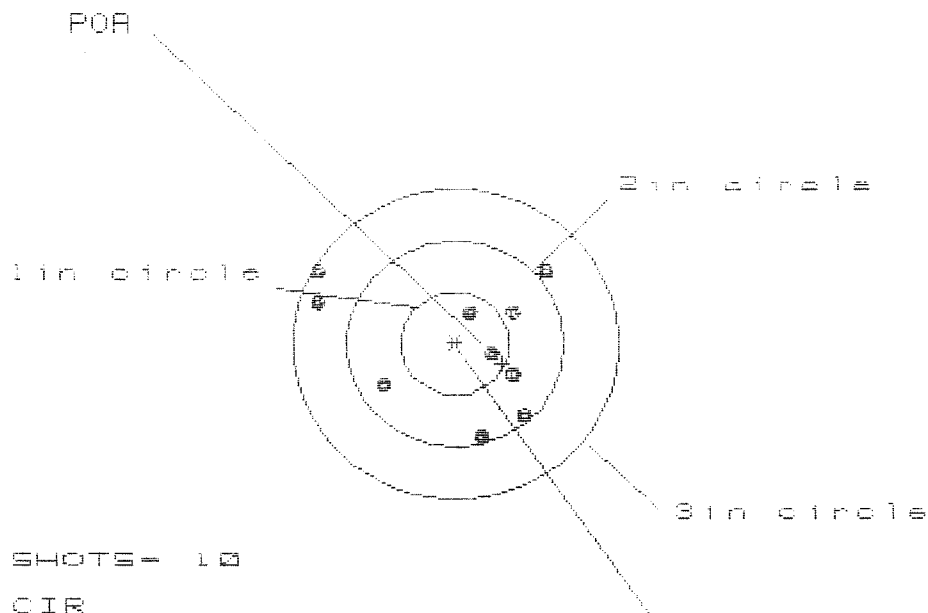
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.193	1.145	.896
MINIMUM X	:	-1.081	-1.129	-.986
MAXIMUM Y	:	1.131	1.002	1.021
MINIMUM Y	:	-1.164	-.848	-.829
CENTROID X	:	-.008	.040	-.103
CENTROID Y	:	-.231	-.102	-.121
POA TO CENTROID in.	:	.231	.109	.159
MIN RADIUS	:	.160	.298	.260
MEAN RADIUS	:	.838	.793	.733
MAX RADIUS	:	1.240	1.250	1.221
HORIZONTAL SPREAD	:	2.274	2.274	1.892
VERTICAL SPREAD	:	2.295	1.850	1.850
EXTREME SPREAD	:	2.377	2.377	2.203
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.102

VS= 1.617

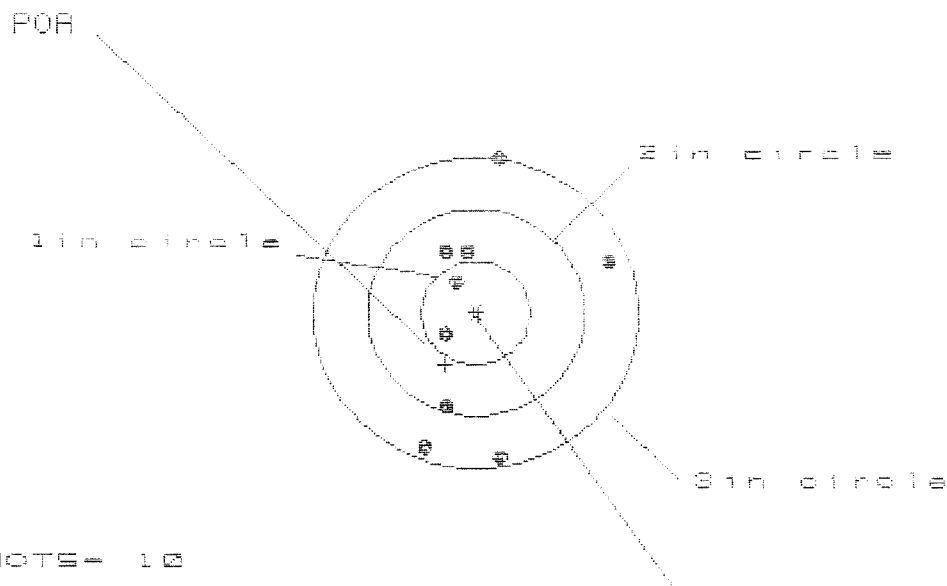
GS= 2.337

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.826	.688	.511
MINIMUM X	:	-1.276	-1.414	-1.030
MAXIMUM Y	:	.719	.796	.855
MINIMUM Y	:	-.898	-.821	-.762
CENTROID X	:	-.433	-.295	-.118
CENTROID Y	:	.197	.120	.061
POA TO CENTROID in.	:	.476	.318	.133
MIN RADIUS	:	.339	.192	.061
MEAN RADIUS	:	.850	.745	.603
MAX RADIUS	:	1.425	1.492	1.075
HORIZONTAL SPREAD	:	2.102	2.102	1.541
VERTICAL SPREAD	:	1.617	1.617	1.617
EXTREME SPREAD	:	2.337	2.205	1.931
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.738

VS= 2.881

GS= 2.921

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.243
MINIMUM X	-.495
MAXIMUM Y	1.513
MINIMUM Y	-1.368
CENTROID X	.279
CENTROID Y	.498
POB TO CENTROID in.	.571
MIN RADIUS	.291
MEAN RADIUS	.875
MAX RADIUS	1.535
HORIZONTAL SPREAD	1.738
VERTICAL SPREAD	2.881
EXTREME SPREAD	2.921
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9