

C6349055

MODEL 700TM M24

Model **SMS**TM

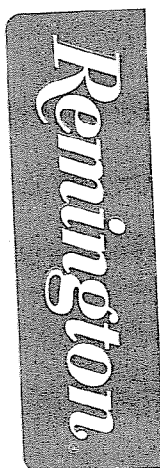
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24

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



REG. U.S. PAT. & TM. OFF.

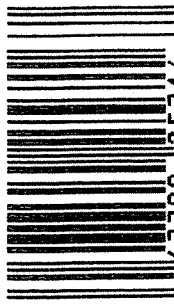
MADE IN ILION, N.Y., U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marquo Deposee.

SERIAL NO.	C6349055
ORDER NO.	5716



5716 C6349055

UPC



0 47700 25716 7

RC - 15
replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349055

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 12	90	RW
600	Proof	1 12	90	EW
607	Check Headspace	1 12	90	EW
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	GS
617	Drill and Tap Sight Holes		1-19-90	HB
618	Polish Barrel RB		1-22-90	WB
620	Apply Coatings (Barrel Action)		1-28-90	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		1/26/90	928

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			2-1-90	JS
	G) Safety Off Force	3	3	3			2-1-90	JS
	H) Trigger Pull Test & Retainability						1/26/90	JS
	I) Firing Pin Indent	.0205	.0215	.022			2-1-90	JS
	J) Assemble Stock						3/1/90	RW
	K) Assemble Swivel Studs						3/12/90	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						3/1/90	WB
	P) Detach & Attach Scope 20 Times						3/1/90	WB
640	Gallery Target & Test						3-2-90	JS (TEMP)
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection						3/12/90	WB
	A) Headspace							
	B) Trigger Pull	2.22	2.42	2.59	2.57	2.48	3/12/90	G.8
	C) Function						3/12/90	WB
660	Pack						20 MAR 90	JS

S/S TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50#+ .50#

3.00#+ .75#

4.00#+1.00#

SERIAL NO. C6 349055

DATE 1 Feb 90

TESTER JSS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	226	243	222	222	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	236	235	219	242	
PULL #3	238	226	227	259	
PULL #4	244	226	221	257	
PULL #5	247	226	221	248	
TOTAL	1191	1146	1110		
AVG.	2382	2292	222		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	292	296		
PULL #2	291	293		
PULL #3	293	290		
PULL #4	288	294		
PULL #5	292	296		
TOTAL	1456	1459		
AVG.	2912	2918		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	379		387
PULL #2	383	395		389
PULL #3	393	391		388
PULL #4	390	391		387
PULL #5	389	389		383
TOTAL	1958	1945		1934
AVG.	3916	389		3868

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349055
2 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.855277
1 TO	2	.889798
1 TO	3	1.23822
1 TO	4	1.48533
1 TO	5	1.23245

$4.5^2 + 3^2$ <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1116
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114634
THE AOR FOR THIS RIFLE IS: 1.304

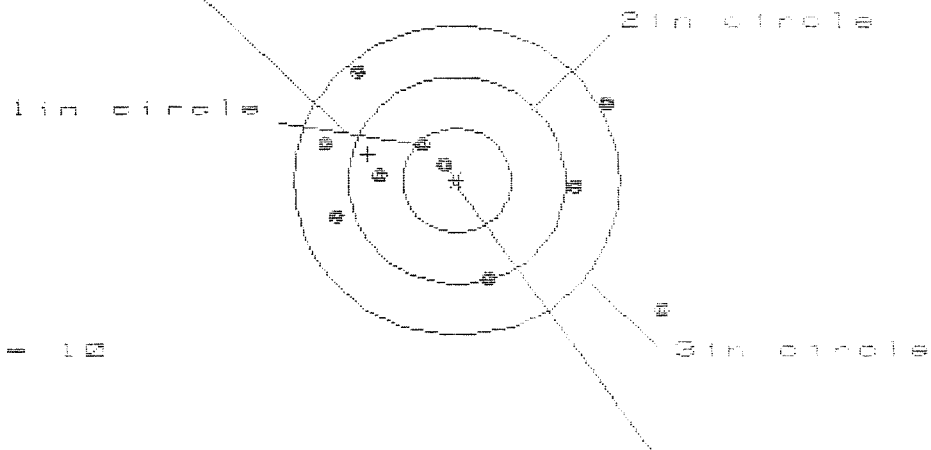
2 Mar 1990

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CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 3.127

VS= 2.266

GS= 3.617

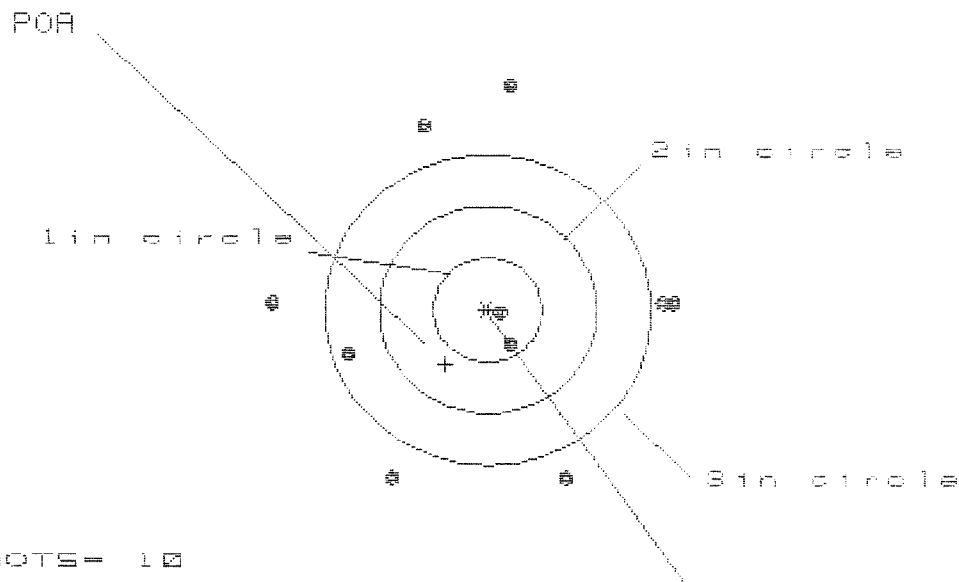
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.881	1.562	1.515
MINIMUM X	-1.246	-1.037	-0.841
MAXIMUM Y	1.008	.868	.944
MINIMUM Y	-1.258	-1.112	-1.036
CENTROID X	.817	.608	.412
CENTROID Y	-.253	-.113	-.189
POA TO CENTROID in.	.855	.618	.454
MIN RADIUS	.235	.067	.276
MEAN RADIUS	1.129	.929	.811
MAX RADIUS	2.263	1.676	1.517
HORIZONTAL SPREAD	3.127	2.599	2.356
VERTICAL SPREAD	2.266	1.980	1.980
DIAGN. SPREAD	3.617	2.742	2.378
SHOTS IN ONE INCH CIRCLE =	1		
SHOTS IN TWO INCH CIRCLE =	3		
SHOTS IN THREE INCH CIRCLE =	6		

2 Mar 1998

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 2

3 in = 3

HS= 3.681

VS= 3.801

GS= 3.948

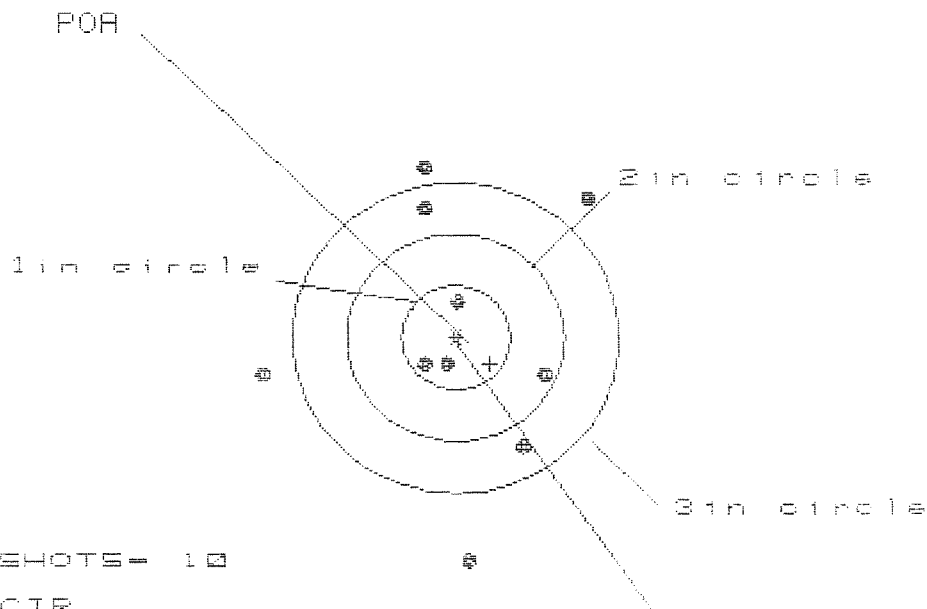
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.715	1.740	1.497
MINIMUM X	:	-1.966	-1.941	-1.487
MAXIMUM Y	:	2.131	2.016	2.057
MINIMUM Y	:	-1.670	-1.433	-1.392
CENTROID X	:	.387	.362	.685
CENTROID Y	:	.526	.289	.248
POA TO CENTROID in.	:	.653	.463	.654
MIN RADIUS	:	.155	.269	.091
MEAN RADIUS	:	1.491	1.394	1.279
MAX RADIUS	:	2.143	2.095	2.212
HORIZONTAL SPREAD	:	3.681	3.681	2.984
VERTICAL SPREAD	:	3.801	3.449	3.449
ELONGATE SPREAD	:	3.948	3.681	3.662
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		3	

2 Mar 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 4

3in = 6

HS = 2.972

VS = 3.796

GS = 3.814

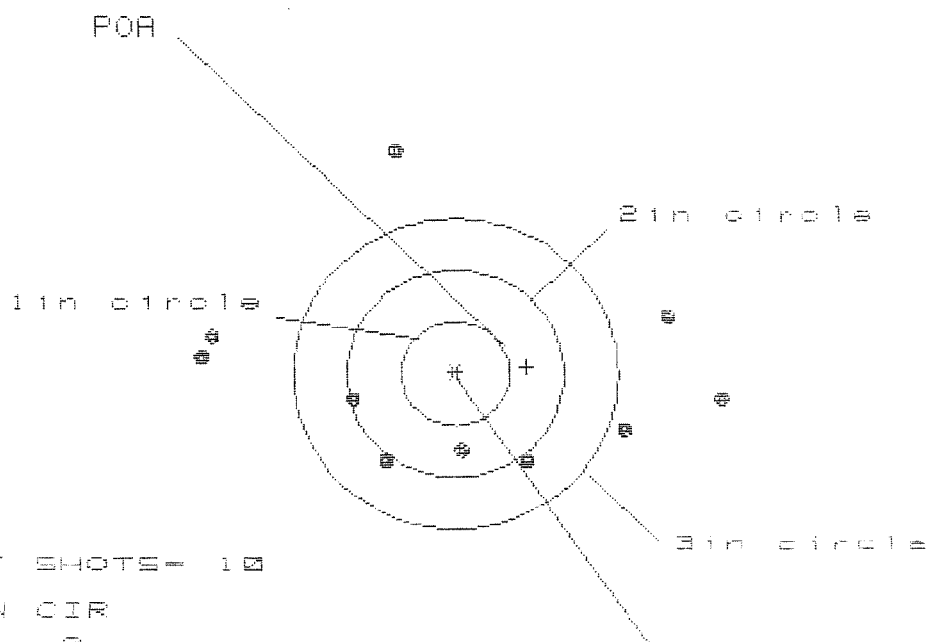
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.211	.962
MINIMUM X	:	-1.775	-1.761	-1.610
MAXIMUM Y	:	1.614	1.371	1.515
MINIMUM Y	:	-2.182	-1.274	-1.130
CENTROID X	:	-.314	-.328	-.479
CENTROID Y	:	.251	.494	.350
POA TO CENTROID in.	:	.402	.593	.594
MIN RADIUS	:	.322	.108	.308
MEAN RADIUS	:	1.186	1.069	.983
MAX RADIUS	:	2.186	1.870	1.681
HORIZONTAL SPREAD	:	2.972	2.972	2.572
VERTICAL SPREAD	:	3.796	2.645	2.645
EXTREME SPREAD	:	3.814	3.463	2.768
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Mar 1990

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 0

2in = 2

3in = 4

HS = 4.0000

VS = 2.9999

GS = 4.8229

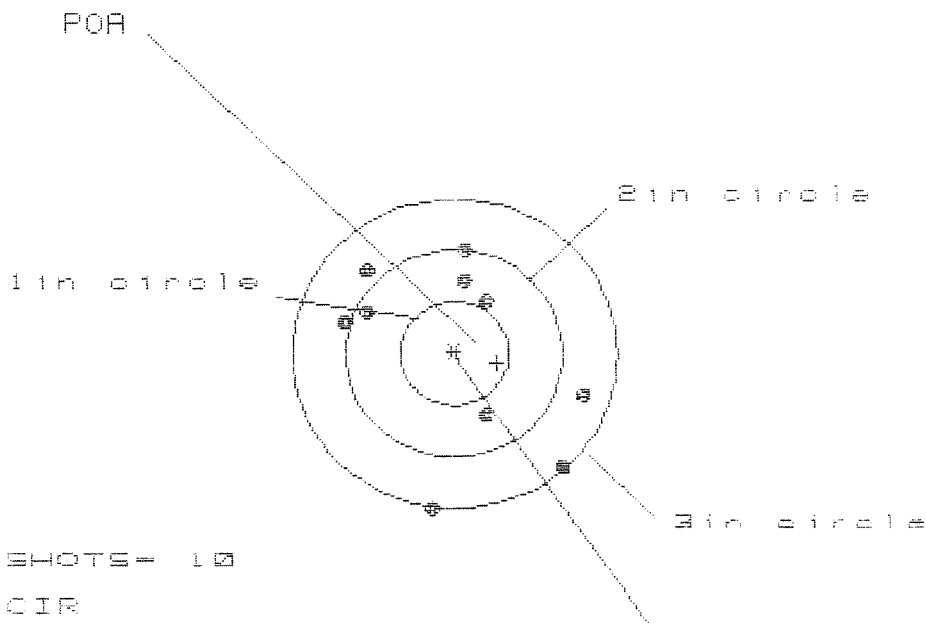
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.505	2.227	1.976
MINIMUM X	-2.304	-2.026	-2.277
MAXIMUM Y	2.206	2.184	2.229
MINIMUM Y	-0.793	-0.815	-0.770
CENTROID X	-0.656	-0.934	-0.683
CENTROID Y	-0.062	-0.040	-0.035
POA TO CENTROID in.	.659	.935	.688
MIN RADIUS	.783	.733	.764
MEAN RADIUS	1.692	1.581	1.505
MAX RADIUS	2.512	2.301	2.287
HORIZONTAL SPREAD	4.809	4.253	4.253
VERTICAL SPREAD	2.999	2.999	2.999
EXTREME SPREAD	4.829	4.273	4.273
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	4		

2 Mar 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 5

HS= 2.172

VS= 2.454

GS= 2.596

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.156	1.129	1.246
MINIMUM X	-1.016	-1.043	-1.925
MAXIMUM Y	.966	.801	.638
MINIMUM Y	-1.488	-1.303	-1.944
CENTROID X	-.392	-.365	-.482
CENTROID Y	.096	.261	.424
FOR TO CENTROID in.	.403	.449	.642
MIN RADIUS	.543	.387	.373
MEAN RADIUS	1.024	.934	.803
MAX RADIUS	1.507	1.608	1.453
HORIZONTAL SPREAD	2.172	2.172	2.172
VERTICAL SPREAD	2.454	2.104	1.582
EXTREME SPREAD	2.596	2.596	2.289
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	