

C6349170

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





MODEL 700™ H24

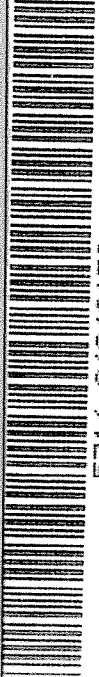
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada

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



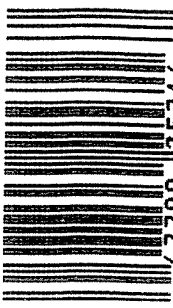
SERIAL NO.
C6349170

ORDER NO.
5716



5716 C6349170

UPC



0 47700 25716 7

RC -15

M-24

Replaced

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349170

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	AC
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	New Barrel 10/30/89 Magnaflux Barrel Action	REJECT	10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force					
	G) Safety Off Force					
	H) Trigger Pull Test & Retainability					
	I) Firing Pin Indent					
	J) Assemble Stock					
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies					
	M) Iron Sight Alignment					
	N) Detach Front & Rear Sights & place in numbered container					
	O) Attach Scope to Rifle					
	P) Detach & Attach Scope 20 Times					
640	Gallery Target & Test					
	A) Time					
	B) Malfunctions					
	C) Pierced Primers					
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo					
655	Final Inspection A) Headspace					
	B) Trigger Pull					
	C) Function					
660	Pack					

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349170

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	11-2	89	RW
600	Proof	11-2	89	A
607	Check Headspace	11-2	89	RW
610	Dis-assemble Gun	11-2	89	RW
612	Magnaflux Barrel Action	11-9-89		KCR
	Magnaflux Bolt	11-9-89		KCR
615	Rollmark Caliber			
17	Drill and Tap Sight Holes	11 9	89	YB
618	Polish Barrel RUB	11 9	89	BT
620	Apply Coatings (Barrel Action)		11-17-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/4/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/4/90	RW
	C) Inspect Ejector Hole for Chamfer		1/4/90	RW
	D) Oil Firing Pin Ass'y		1/4/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-5-90	JAL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-9-90	JH
	G) Safety Off Force	3	3	3			1-9-90	JH
	H) Trigger Pull Test & Retainability						1-9-90	JH
	I) Firing Pin Indent	.021	.0205	.0205			1-9-90	JH
	J) Assemble Stock						1/10/90	RW
	K) Assemble Swivel Studs						3/12/90	WB
	L) Attach Front and Rear Sight Assemblies						1/10/90	RW
	M) Iron Sight Alignment						1/10/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/10/90	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	JES 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	2.39	2.38	2.44	2.42	2.61	3/12/90	GL
	C) Function						3/12/90	WB
660	Pack						20 Mar 90	JES

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6349170

DATE 1-5-90

TESTER J.B.21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.50	2.42	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.58	2.31	2.38	
PULL #3	2.44	2.38	2.50	2.44	
PULL #4	2.41	2.51	2.43	2.42	
PULL #5	2.71	2.34	2.51	2.61	
TOTAL	12.57	12.31	12.17		
AVG.	2.514	2.462	2.434		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.32		
PULL #2	3.29	3.41		
PULL #3	3.27	3.47		
PULL #4	3.26	3.35		
PULL #5	3.25	3.51		
TOTAL	16.53	17.06		
AVG.	3.306	3.412		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.22		4.28
PULL #2	4.15	4.22		4.22
PULL #3	4.17	4.18		4.21
PULL #4	4.11	4.20		4.22
PULL #5	4.56	4.28		4.28
TOTAL	21.26	21.10		21.21
AVG.	4.252	4.22		4.242

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349170
2 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.166973
1 TO	2	.374833
1 TO	3	.0741687
1 TO	4	.595944
1 TO	5	.350782

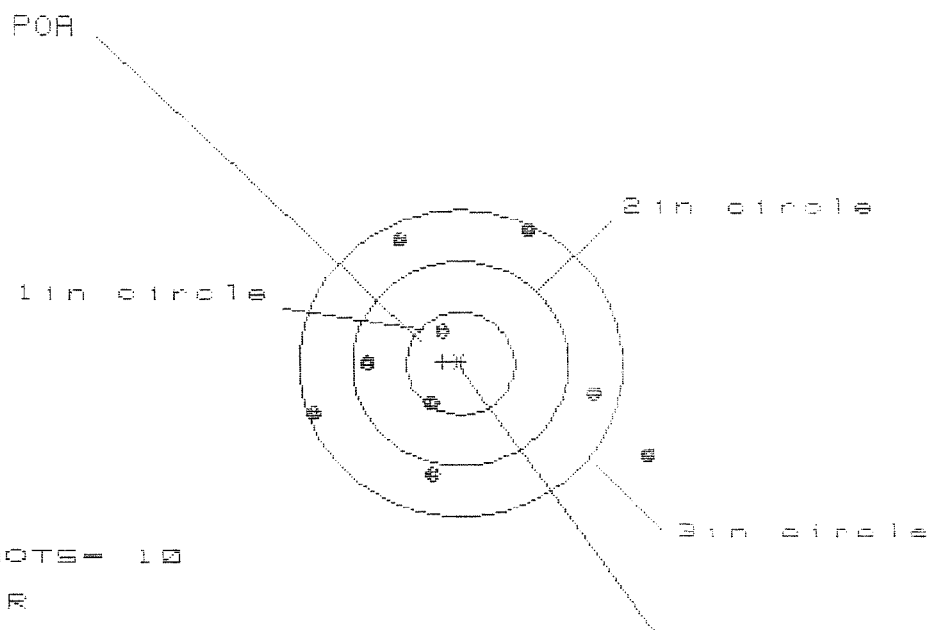
502 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0348
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0746126
THE AMR FOR THIS RIFLE IS: 1.187

2 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349170

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 9

HS= 3.183

VS= 2.429

GS= 3.202

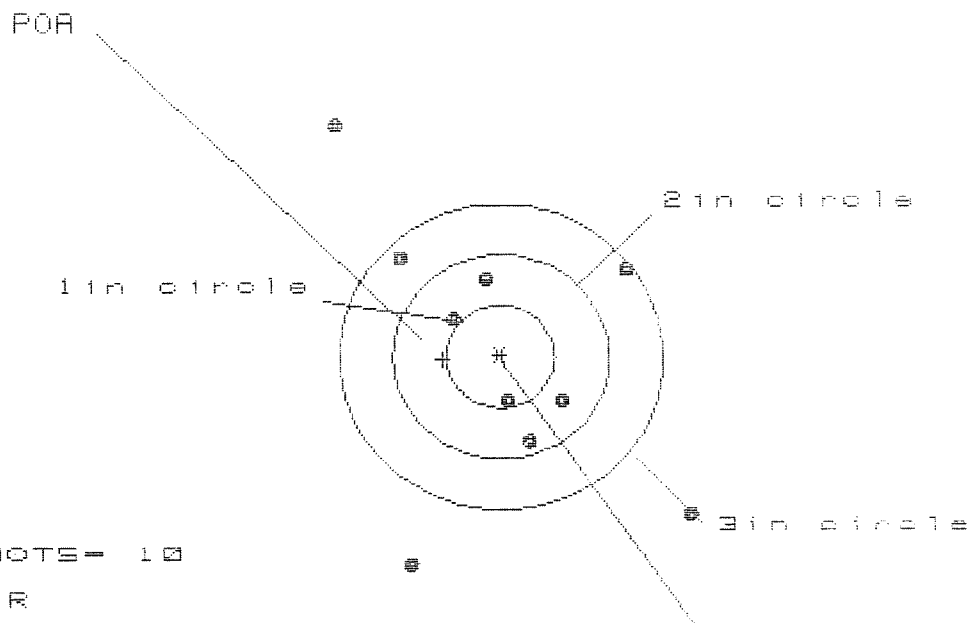
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.773	1.460	1.309
MINIMUM X	-1.410	-1.213	-0.867
MAXIMUM Y	1.307	1.214	1.142
MINIMUM Y	-1.122	-1.215	-1.287
CENTROID X	.166	-.031	.120
CENTROID Y	-.018	.075	.147
POR TO CENTROID in.	.167	.081	.190
MIN RADIUS	.353	.222	.189
MEAN RADIUS	1.089	.945	.895
MAX RADIUS	1.960	1.519	1.398
HORIZONTAL SPREAD	3.183	2.673	2.176
VERTICAL SPREAD	2.429	2.429	2.429
EXTREME SPREAD	3.202	2.752	2.599
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

2 Mar 1988

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.222

VS= 4.340

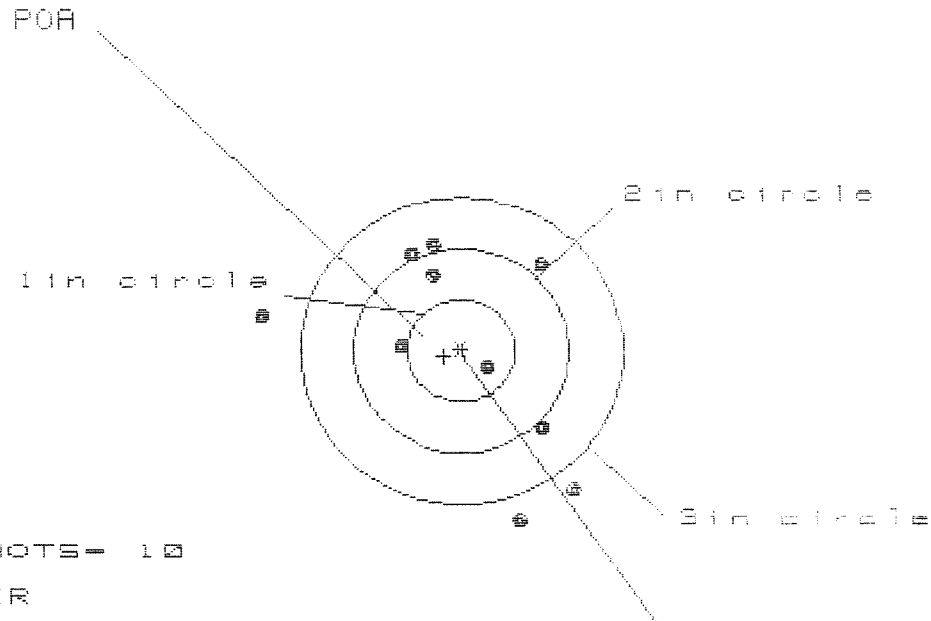
GS= 5.040

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.730	1.564	1.191
MINIMUM X	-1.492	-1.063	-0.668
MAXIMUM Y	2.307	1.261	1.097
MINIMUM Y	-2.033	-1.776	-1.940
CENTROID X	.538	.704	.509
CENTROID Y	.028	-.229	-.065
POA TO CENTROID in.	.539	.740	.513
MIN RADIUS	.409	.190	.323
MEAN RADIUS	1.340	1.152	1.037
MAX RADIUS	2.748	2.041	2.098
HORIZONTAL SPREAD	3.222	2.627	2.059
VERTICAL SPREAD	4.340	3.037	3.037
EXTREME SPREAD	5.040	3.677	3.532
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

2 Mar 1998

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.854

VS= 2.687

GS= 3.328

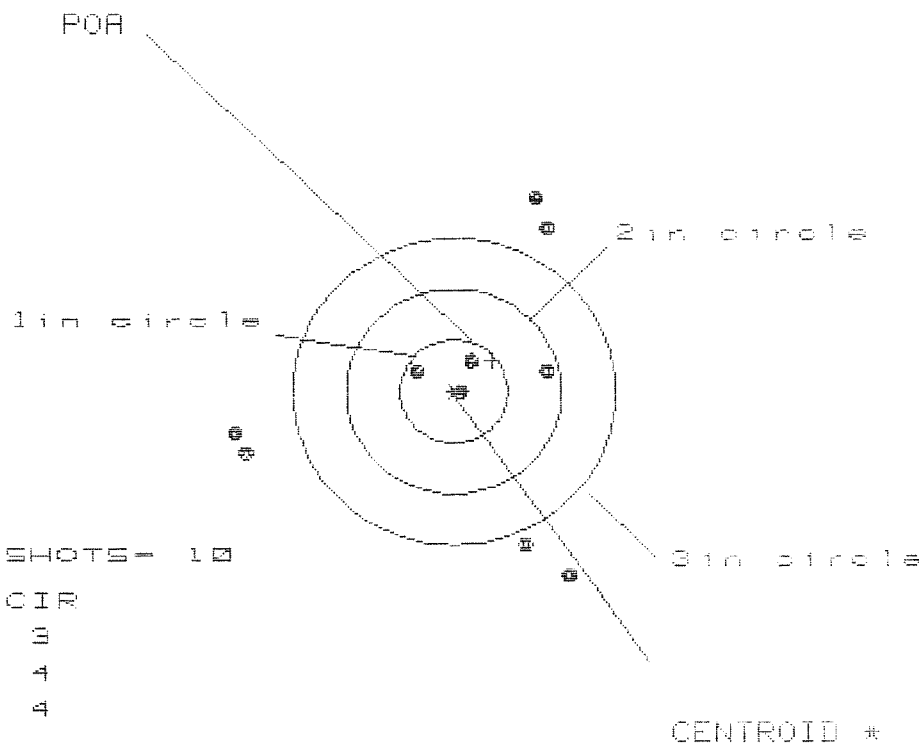
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.022	.819	.862
MINIMUM X	-1.832	-.773	-.730
MAXIMUM Y	1.007	1.050	.845
MINIMUM Y	-1.680	-1.637	-1.439
CENTROID X	.161	.364	.321
CENTROID Y	.056	.013	.218
POA TO CENTROID in.	.170	.364	.388
MIN RADIUS	.285	.099	.304
MEAN RADIUS	1.116	1.020	.915
MAX RADIUS	1.872	1.672	1.720
HORIZONTAL SPREAD	2.854	1.592	1.592
VERTICAL SPREAD	2.687	2.687	2.334
EXTREME SPREAD	3.328	2.809	2.670
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

2 Mar 1938

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 4

3 in = 4

HS = 3.112

VS = 3.702

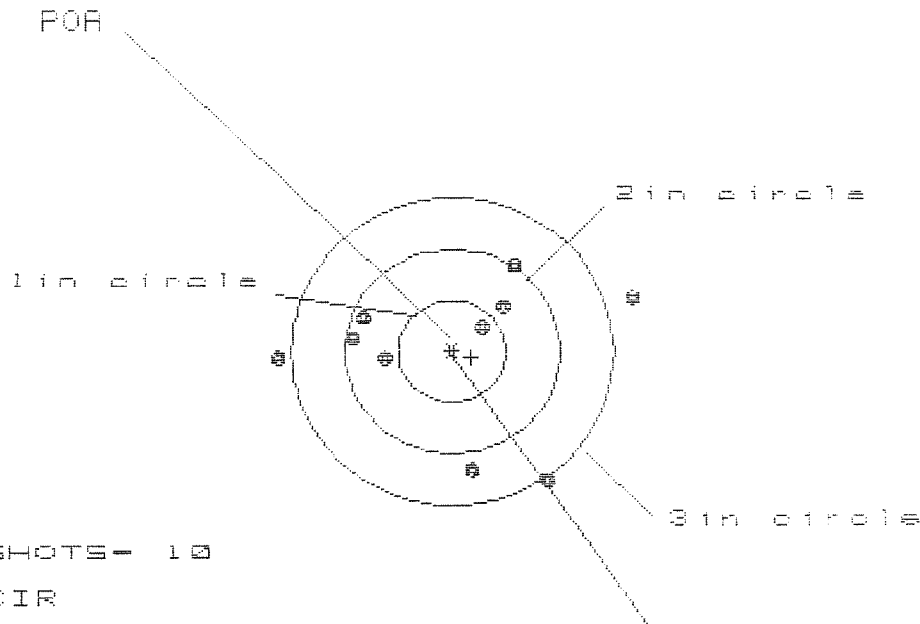
GS = 3.716

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.057	.829	.746
MINIMUM X	:	-2.055	-2.176	-2.073
MAXIMUM Y	:	1.911	1.866	1.637
MINIMUM Y	:	-1.791	-1.836	-1.808
CENTROID X	:	-.359	-.131	-.234
CENTROID Y	:	-.300	-.255	-.026
POA TO CENTROID in.	:	.468	.287	.236
MIN RADIUS	:	.042	.193	.062
MEAN RADIUS	:	1.338	1.248	1.110
MAX RADIUS	:	2.094	2.270	2.250
HORIZONTAL SPREAD	:	3.112	3.005	2.819
VERTICAL SPREAD	:	3.702	3.702	3.445
EXTREME SPREAD	:	3.716	3.716	3.674
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		4	

2 Mar 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS = 3.312

VS = 2.054

GS = 3.368

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.648	1.053	.868
MINIMUM X	-1.664	-1.481	-.922
MAXIMUM Y	.818	.873	.867
MINIMUM Y	-1.236	-1.181	-1.187
CENTROID X	-.176	-.359	-.174
CENTROID Y	.060	.005	.011
POA TO CENTROID in.	.186	.359	.174
MIN RADIUS	.394	.475	.426
MEAN RADIUS	1.052	.965	.897
MAX RADIUS	1.723	1.582	1.471
HORIZONTAL SPREAD	3.312	2.534	1.790
VERTICAL SPREAD	2.054	2.054	2.054
EXTREME SPREAD	3.368	2.774	2.278
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		