

C6349215

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.

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

MODEL 700™ H24

SERIAL NO. C6349215

ORDER NO. 5716

Ø1

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



5716 C6349215

UPC



0 47700 25716 7

RC-15
replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349215

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20 89		RW
600	Proof	12-20 89		A
607	Check Headspace			A
610	Dis-assemble Gun	12-20 89		RW
612	Magnaflux Barrel Action	1-5-90		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/3/90	JS
617	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel RB		1/9/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TA
	Apply Coating (Bolt)			
625	Final Assembly		1/16/90	WB
	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		2/1/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-25-90	gcl
	G) Safety Off Force	2	2	2			1-25-90	gcl
	H) Trigger Pull Test & Retainability						2/1/90	gcl
	I) Firing Pin Indent	.023	.023	.0235			1-25-90	gcl
	J) Assemble Stock						1-29-90	K
	K) Assemble Swivel Studs						3/12/90	WB
	L) Attach Front and Rear Sight Assemblies						1-29-90	K
	M) Iron Sight Alignment						1-29-90	K
	N) Detach Front & Rear Sights & place in numbered container						1-29-90	K
	O) Attach Scope to Rifle						2/28/90	WB
	P) Detach & Attach Scope 20 Times						2/28/90	WB
640	Gallery Target & Test						3-1-90	(Temp. Help) J.B.
	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	2.75	2.86	2.85	2.73	2.72	3/12/90	GS
	C) Function						3/12/90	WB
660	Pack						20 Mar 90	gcl

SWS TRIGGER PULL TEST

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

SERIAL NO. C6349215
DATE 24 Jan 90
TESTER JRS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.17	2.07	2.18	2.75	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.01	2.17	2.86	
PULL #3	2.28	2.34	2.33	2.85	
PULL #4	2.37	2.24	2.23	2.73	
PULL #5	2.32	2.20	2.17	2.72	
TOTAL	11.52	10.91	11.05		
AVG.	2.304	2.182	2.21		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.22		
PULL #2	3.41	3.20		
PULL #3	3.38	3.19		
PULL #4	3.41	3.15		
PULL #5	3.37	3.09		
TOTAL	16.70	15.85		
AVG.	3.34	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	3.92		3.84
PULL #2	4.17	3.82		3.98
PULL #3	4.10	3.93		4.07
PULL #4	4.07	4.07		4.10
PULL #5	4.14	3.87		3.99
TOTAL	20.50	19.61		19.98
AVG.	4.10	3.922		3.996

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349215
1 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.473334
1 TO	2	.266177
1 TO	3	.639866
1 TO	4	.913081
1 TO	5	.156003

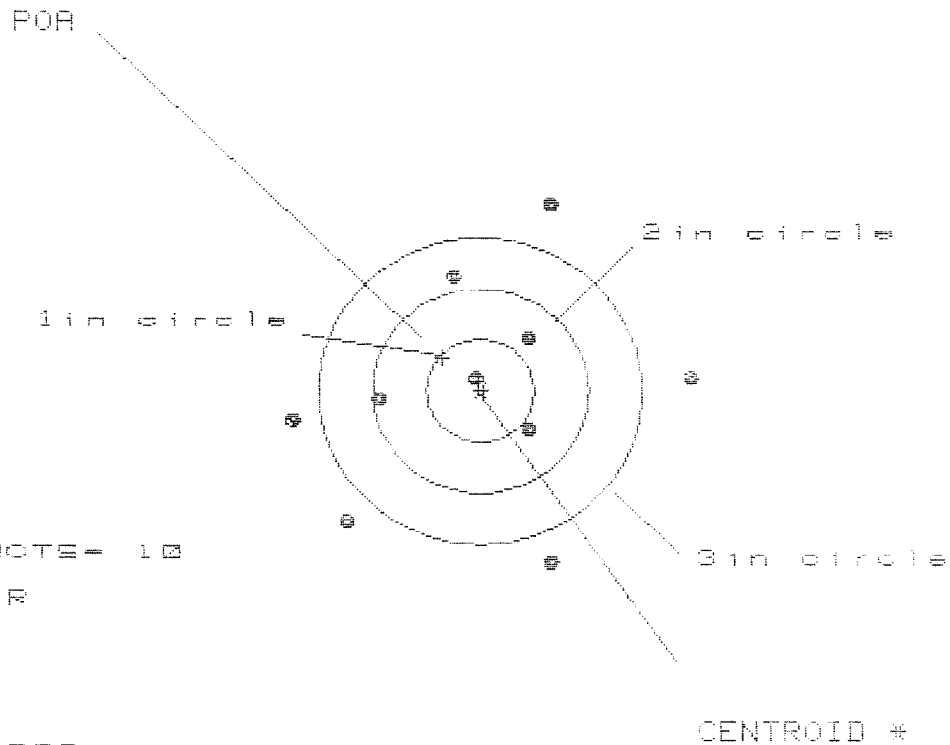
4 $\frac{3}{4}$ $\frac{2}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0744
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.191
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204979
THE AMR FOR THIS RIFLE IS: 1.103

1 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08349215

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 5

HS = 3.693

VS = 3.460

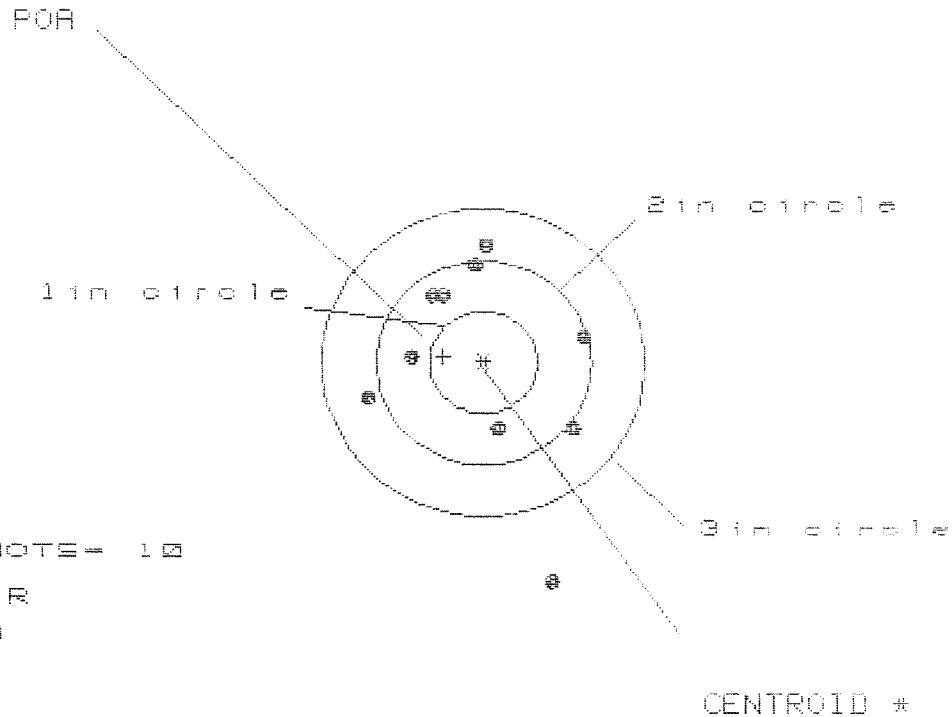
ES = 3.707

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.938	.839	.929
MINIMUM X	:	-1.755	-1.540	-1.435
MAXIMUM Y	:	1.818	1.829	1.401
MINIMUM Y	:	-1.642	-1.631	-1.403
CENTROID X	:	.346	.131	.026
CENTROID Y	:	-.323	-.334	-.563
POA TO CENTROID in.	:	.473	.359	.563
MIN RADIUS	:	.101	.231	.458
MEAN RADIUS	:	1.269	1.199	1.111
MAX RADIUS	:	1.940	2.012	1.682
HORIZONTAL SPREAD	:	3.693	2.379	2.364
VERTICAL SPREAD	:	3.460	3.460	2.903
EXTREME SPREAD	:	3.707	3.641	2.919
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 9

HB = 1.947

VB = 3.311

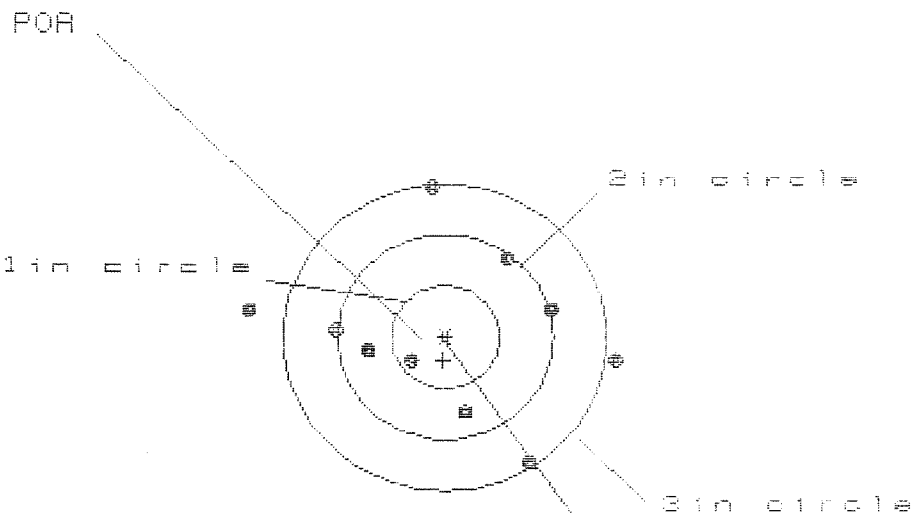
GB = 3.377

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.988	.974	.983
MINIMUM X	:	-1.047	-.973	-.964
MAXIMUM Y	:	1.188	.952	.903
MINIMUM Y	:	-2.123	-.855	-.737
CENTROID X	:	.371	.297	.288
CENTROID Y	:	-.858	.177	.059
POR TO CENTROID in.	:	.376	.346	.294
MIN RADIUS	:	.634	.516	.590
MEAN RADIUS	:	1.024	.838	.829
MAX RADIUS	:	2.225	1.257	1.189
HORIZONTAL SPREAD	:	1.947	1.947	1.947
VERTICAL SPREAD	:	3.311	1.807	1.540
EXTREME SPREAD	:	3.377	2.030	2.030
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HS= 3.450

VS= 2.627

GS= 3.485

CENTROID #

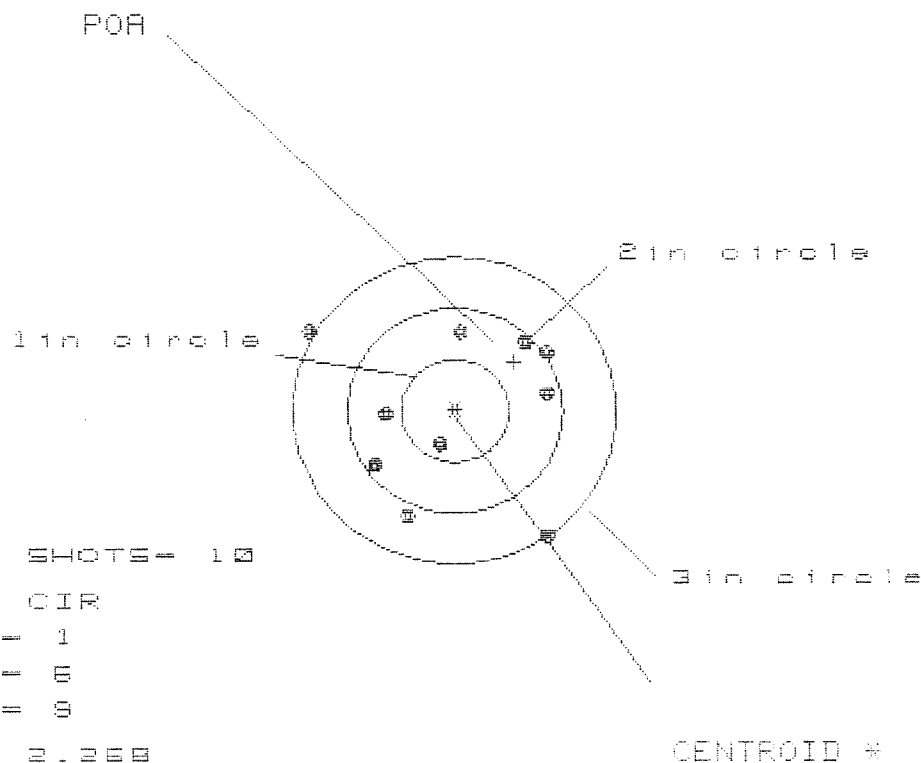
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.595	1.389	.920
MINIMUM X	:	-1.855	-1.193	-1.019
MAXIMUM Y	:	1.440	1.465	1.435
MINIMUM Y	:	-1.187	-1.162	-1.192
CENTROID X	:	.019	.225	.051
CENTROID Y	:	.227	.202	.232
POA TO CENTROID in.	:	.228	.302	.238
MIN RADIUS	:	.456	.622	.485
MEAN RADIUS	:	1.126	1.040	.974
MAX RADIUS	:	1.869	1.512	1.448
HORIZONTAL SPREAD	:	3.450	2.582	1.939
VERTICAL SPREAD	:	2.627	2.627	2.627
EXTREME SPREAD	:	3.485	2.788	2.788
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.268

VS= 1.952

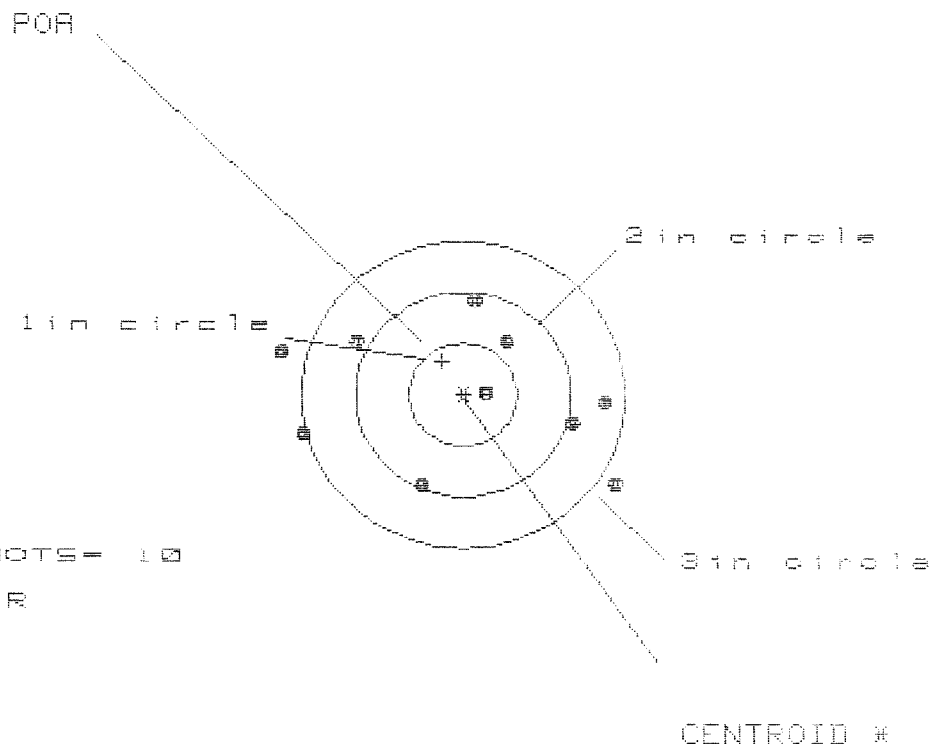
GS= 2.958

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.880	.726	.811
MINIMUM X	:	-1.388	-.894	-.809
MAXIMUM Y	:	.779	.848	.712
MINIMUM Y	:	-1.173	-1.086	-1.040
CENTROID X	:	-.554	-.400	-.485
CENTROID Y	:	-.477	-.564	-.428
POA TO CENTROID in.	:	.731	.691	.647
MIN RADIUS	:	.360	.383	.434
MEAN RADIUS	:	.967	.894	.830
MAX RADIUS	:	1.591	1.282	1.148
HORIZONTAL SPREAD	:	2.268	1.620	1.620
VERTICAL SPREAD	:	1.952	1.934	1.752
EXTREME SPREAD	:	2.958	2.071	2.007
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 8

IS= 3.128

VS= 1.809

GS= 3.387

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	1.244	1.322
MINIMUM X	:	-1.696	-1.642	-1.487
MAXIMUM Y	:	.896	.939	.831
MINIMUM Y	:	-.913	-.870	-.916
CENTROID X	:	.190	.378	.223
CENTROID Y	:	-.324	-.367	-.259
POA TO CENTROID in.	:	.376	.527	.341
MIN RADIUS	:	.241	.119	.198
MEAN RADIUS	:	1.127	1.029	.966
MAX RADIUS	:	1.739	1.673	1.547
HORIZONTAL SPREAD	:	3.128	2.886	2.809
VERTICAL SPREAD	:	1.809	1.809	1.747
EXTREME SPREAD	:	3.387	2.938	2.821
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	