

C6594578

MODEL 700TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*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

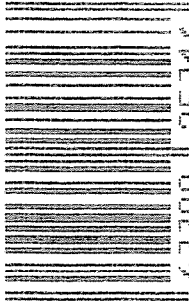
SERIAL NO.
C6594578

ORDER NO.
5716

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

20

UPC



0 47700 25716 2



5716 C6594578

SWS TRIGGER PULL TEST

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

SERIAL NO. C6594578
DATE 10-19-95
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.52	2.54	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.47	2.67	
PULL #3	2.45	2.50	2.66	
PULL #4	2.44	2.52	2.63	
PULL #5	2.40	2.46	2.60	
TOTAL	12.26	12.49	13.19	
AVG.	2.45	2.49	2.63	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.15		
PULL #2	3.14	3.16		
PULL #3	3.17	3.13		
PULL #4	3.15	3.17		
PULL #5	3.16	3.13		
TOTAL	15.78	15.74		
AVG.	3.15	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.18	4.08	
PULL #2	4.11	4.15	4.03	
PULL #3	4.19	4.12	4.06	
PULL #4	4.21	4.14	4.07	
PULL #5	4.23	4.19	4.17	
TOTAL	20.88	20.78	20.41	
AVG.	4.17	4.15	4.08	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594508

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	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	7 1/2	7 1/4	7			11/27	WB
	G) Safety Off Force	3 1/4	3 1/4	3 1/4			11/27	WB
	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	2.74	2.76	2.77	2.77	2.74	11/27	WB
	C) Function							
660	Pack							

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594578

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-4-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	YB.
617	Drill and Tap Sight Holes	1	10 91	FB
618	Polish Barrel	1	10 91	WB
620	Apply Coatings (Barrel Action)		1-18-91	JA
	Apply Coating (Bolt)			
623	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/28/91	RL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1/28/91	WB
	G) Safety Off Force	3 3/4	4	3 3/4			1/28/91	WB
	H) Trigger Pull Test & Retainability						1/28/91	RP
	I) Firing Pin Indent	.0225	.0225	.0225			1/28/91	WB
	J) Assemble Stock						1/29/91	RW
	K) Assemble Swivel Studs						2-6-91	D/H
	L) Attach Front and Rear Sight Assemblies						1/29/91	RW
	M) Iron Sight Alignment						1/29/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/29/91	RW
	O) Attach Scope to Rifle						1/29/91	RW
	P) Detach & Attach Scope 20 Times						1/29/91	RW
640	Gallery Target & Test						1/29/91	K2
	A) Time							K3
	B) Malfunctions							K3
	C) Pierced Primers							K3
	D) Optical Clarity of Scope							K2
645	Inspect for Live Ammo						1/29/91	K3
655	Final Inspection							
	A) Headspace						2-6-91	DH
	B) Trigger Pull	2.30	2.29	2.30	2.28	2.28	2-4-91	RP
	C) Function						2-6-91	D/H
660	Pack						3-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6594578

DATE 1/28/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.41	2.22	2.30	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.47	2.17	2.29	
PULL #3	2.37	2.38	2.18	2.30	
PULL #4	2.26	2.23	2.18	2.28	
PULL #5	2.48	2.38	2.20	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.17		
PULL #2	3.40	3.15		
PULL #3	3.33	3.15		
PULL #4	3.27	3.20		
PULL #5	3.23	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.47		4.43
PULL #2	4.27	4.29		4.20
PULL #3	4.29	4.35		4.47
PULL #4	4.20	4.35		4.46
PULL #5	4.21	4.37		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594578
30 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.0698928
1 TO	2	.178466
1 TO	3	.373841
1 TO	4	.469886
1 TO	5	.177553

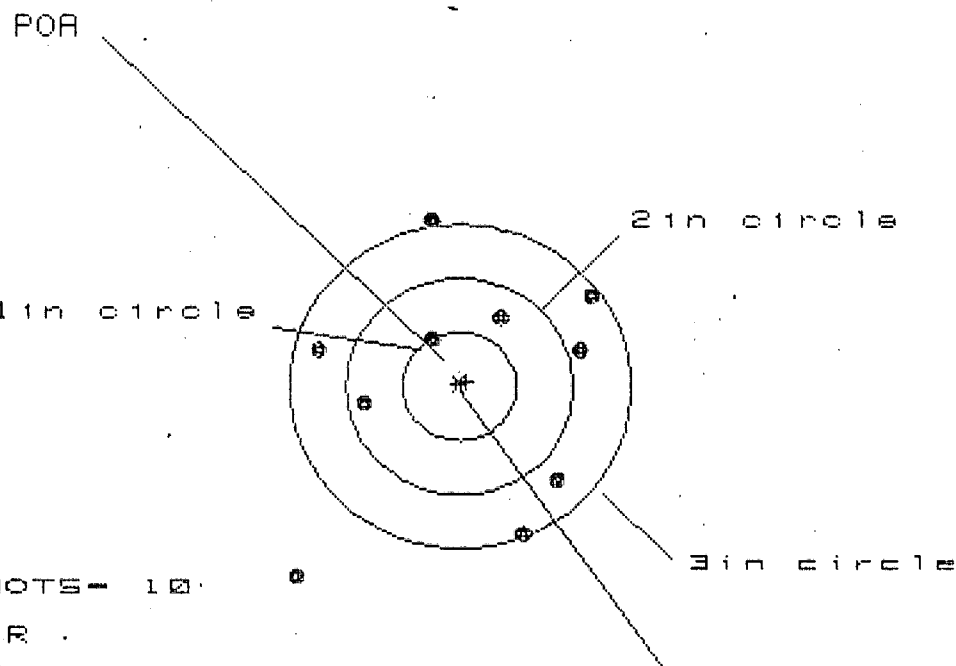
4
3m9 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0338
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .115649
THE AMR FOR THIS RIFLE IS: 1.094

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594578

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR .

1in = 0

2in = 3

3in = 8

HS= 2.513

VS= 3.213

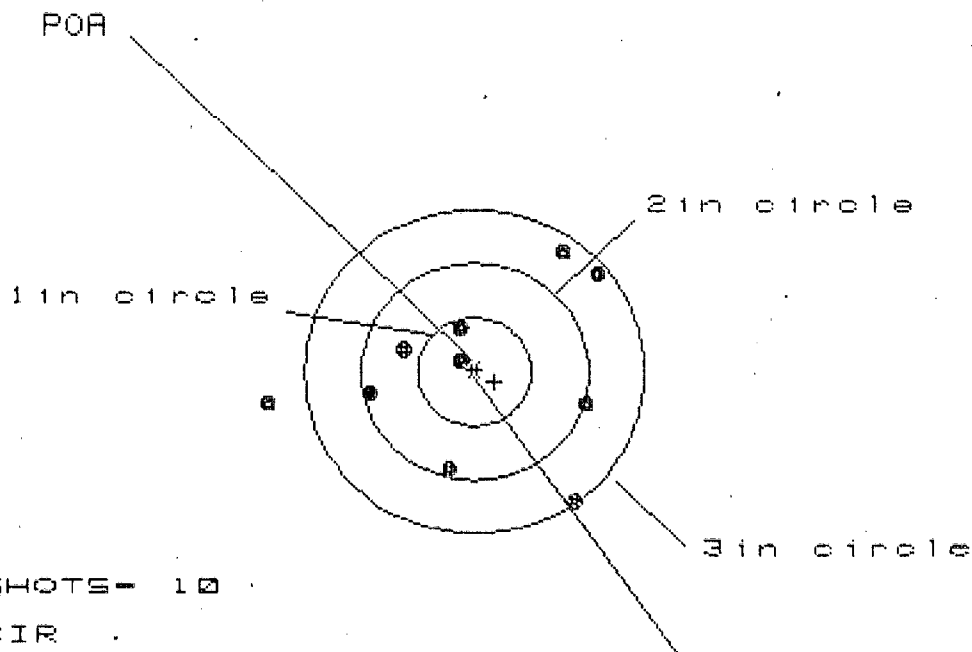
GS= 3.560

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.121	.966	.914
MINIMUM X	-1.392	-1.428	-1.480
MAXIMUM Y	1.496	1.305	.776
MINIMUM Y	-1.717	-1.520	-1.357
CENTROID X	-.058	.097	.149
CENTROID Y	-.039	.152	-.011
POA TO CENTROID in.	.069	.181	.150
MIN RADIUS	.506	.464	.608
MEAN RADIUS	1.234	1.085	1.060
MAX RADIUS	2.211	1.577	1.508
HORIZONTAL SPREAD	2.513	2.394	2.394
VERTICAL SPREAD	3.213	2.825	2.133
EXTREME SPREAD	3.560	2.946	2.474
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594578

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.892

VS = 2.301

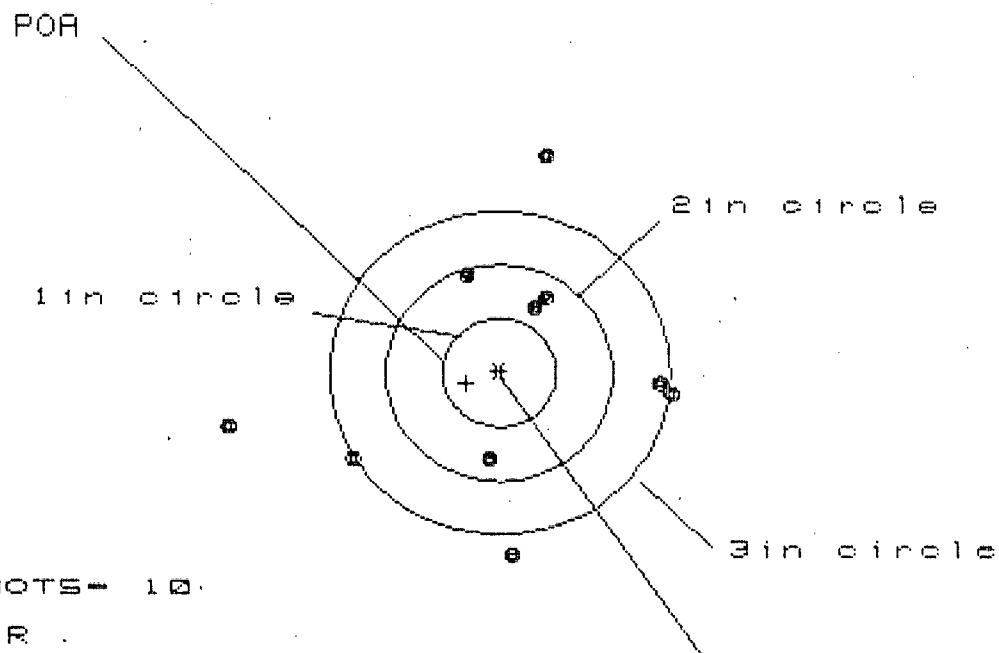
GS = 3.155

PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.119	.922	.943
MINIMUM X	-1.773	-1.117	-1.002
MAXIMUM Y	1.140	1.104	1.218
MINIMUM Y	-1.161	-1.197	-1.083
CENTROID X	-.177	.020	-.095
CENTROID Y	.094	.130	.016
POA TO CENTROID in.	.200	.131	.096
MIN RADIUS	.206	.369	.319
MEAN RADIUS	1.030	.959	.897
MAX RADIUS	1.802	1.371	1.398
HORIZONTAL SPREAD	2.892	2.039	1.945
VERTICAL SPREAD	2.301	2.301	2.301
EXTREME SPREAD	3.155	2.356	2.303
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

30 Jan 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10.

IN CIR .

1in = 0

2in = 4

3in = 5

HS= 3.829

VS= 3.669

GS= 3.842

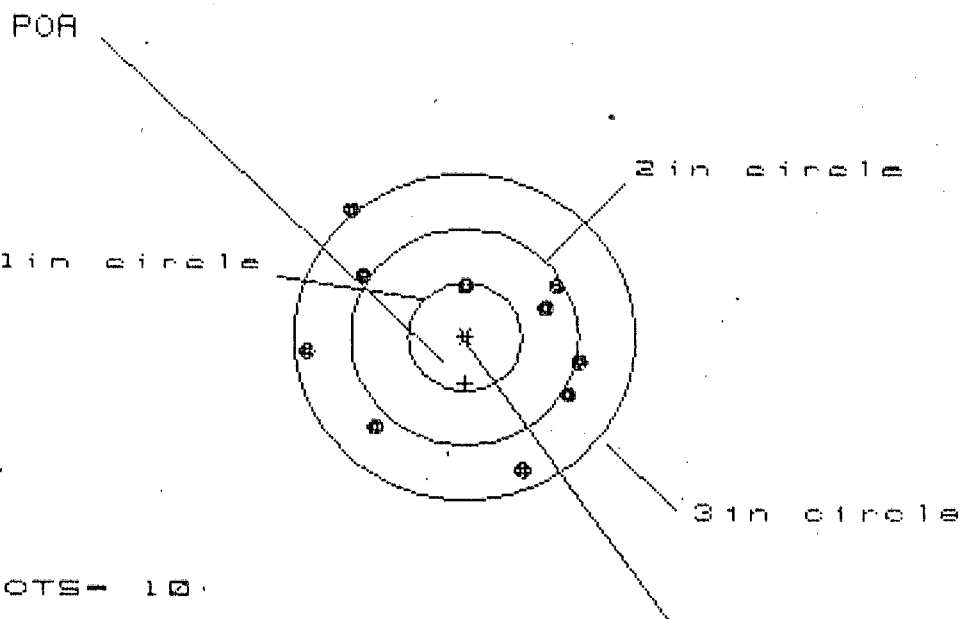
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.487	1.226	1.244
MINIMUM X	-2.342	-1.594	-1.576
MAXIMUM Y	1.958	1.899	1.108
MINIMUM Y	-1.711	-1.770	-1.533
CENTROID X	.291	.552	.534
CENTROID Y	.095	.154	-.083
POA TO CENTROID in.	.306	.573	.540
MIN RADIUS	.651	.532	.731
MEAN RADIUS	1.380	1.225	1.153
MAX RADIUS	2.402	1.904	1.699
HORIZONTAL SPREAD	3.829	2.820	2.820
VERTICAL SPREAD	3.669	3.669	2.641
EXTREME SPREAD	3.842	3.682	2.881
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

30 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594578

CENTERFIRE PATTERNS # 4



OF SHOTS- 10.

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.417

VS= 2.371

GS= 2.805

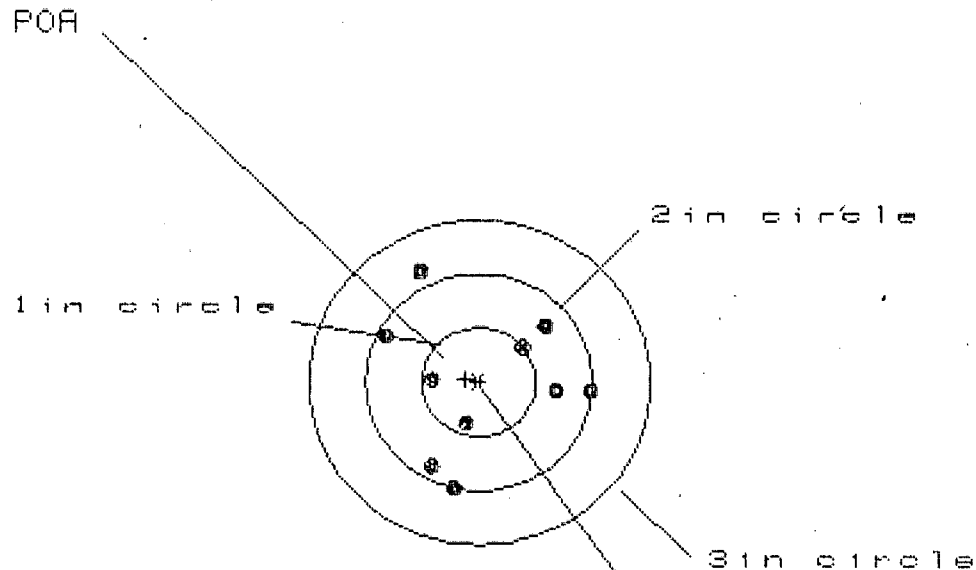
CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.054	.943	.759
MINIMUM X	-1.363	-1.474	-1.155
MAXIMUM Y	1.183	.695	.691
MINIMUM Y	-1.189	-1.057	-1.061
CENTROID X	-.006	.105	.289
CENTROID Y	.428	.296	.300
POA TO CENTROID in.	.428	.314	.417
MIN RADIUS	.432	.570	.622
MEAN RADIUS	1.081	1.019	.924
MAX RADIUS	1.548	1.474	1.360
HORIZONTAL SPREAD	2.417	2.417	1.914
VERTICAL SPREAD	2.371	1.752	1.752
EXTREME SPREAD	2.805	2.417	2.218
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

30 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10.

IN CIR .

1in = 3

2in = 9

3in = 10

HS= 1.749

VS= 1.961

GS= 1.978

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.939
MINIMUM X	-.810
MAXIMUM Y	1.000
MINIMUM Y	-.961
CENTROID X	.119
CENTROID Y	-.025
POA TO CENTROID in.	.121
MIN RADIUS	.374
MEAN RADIUS	.746
MAX RADIUS	1.112
HORIZONTAL SPREAD	1.749
VERTICAL SPREAD	1.961
EXTREME SPREAD	1.978
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10