

C6636121

MODEL 700TM N24

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.

MODEL 700TM M24

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

SERIAL NO.
C6636121

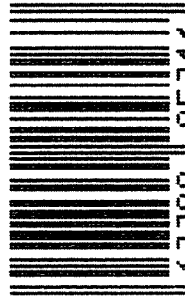
ORDER NO.
5716

20



5716 C6636121

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636121

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	9 1	RW
600	Proof	5 2	9 1	RW
607	Check Headspace	5 2	9 1	RW
610	Dis-assemble Gun	5 2	9 1	RW
612	Magnaflux Barrel Action	5 2	9 1	Ked
	Magnaflux Bolt	5 2	9 1	Ked
615	Rollmark Caliber	5 2	9 1	GB
617	Drill and Tap Sight Holes	5 15	9 1	WB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-29-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/1/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6/1/91	WB
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			6/1/91	WB
	H) Trigger Pull Test & Retainability						6/1/91	WB
	I) Firing Pin Indent	.072	.072	.072			6/1/91	WB
	J) Assemble Stock						6/3/91	Rev
	K) Assemble Swivel Studs						6-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						6/3/91	Rev
	M) Iron Sight Alignment						6/3/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						6/3/91	Rev
	O) Attach Scope to Rifle						6/3/91	Rev
	P) Detach & Attach Scope 20 Times						6/3/91	Rev
640	Gallery Target & Test						6/3/91	KJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						6/3/91	KJ
655	Final Inspection							
	A) Headspace						6-8-91	D/H
	B) Trigger Pull	2.47	2.52	2.51	2.44	2.23	6-8-91	RU
	C) Function						6-8-91	D/H
660	Pack						6-30-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6636121

DATE 6/1/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	¹ 2.29	² 2.41	² 2.39	2.47	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.46	2.56	2.52	
PULL #3	2.31	2.56	2.52	2.51	
PULL #4	2.39	2.59	2.32	2.44	
PULL #5	2.26	2.56	2.54	2.23	
TOTAL	11.71	12.58	12.33		
AVG.	2.34	2.51	2.47		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	³ 3.24	³ 3.35		
PULL #2	3.31	3.38		
PULL #3	3.39	3.26		
PULL #4	3.16	3.40		
PULL #5	3.44	3.35		
TOTAL	16.54	16.74		
AVG.	3.31	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.02	4.00		³ 3.95
PULL #2	4.05	3.90		3.95
PULL #3	4.00	3.95		3.95
PULL #4	4.10	4.00		4.00
PULL #5	4.04	4.00		3.90
TOTAL	20.21	19.85		19.75
AVG.	4.04	3.97		3.95

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636121
3 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.335887
1 TO	2	.399362
1 TO	3	.475825
1 TO	4	.293002
1 TO	5	.596041

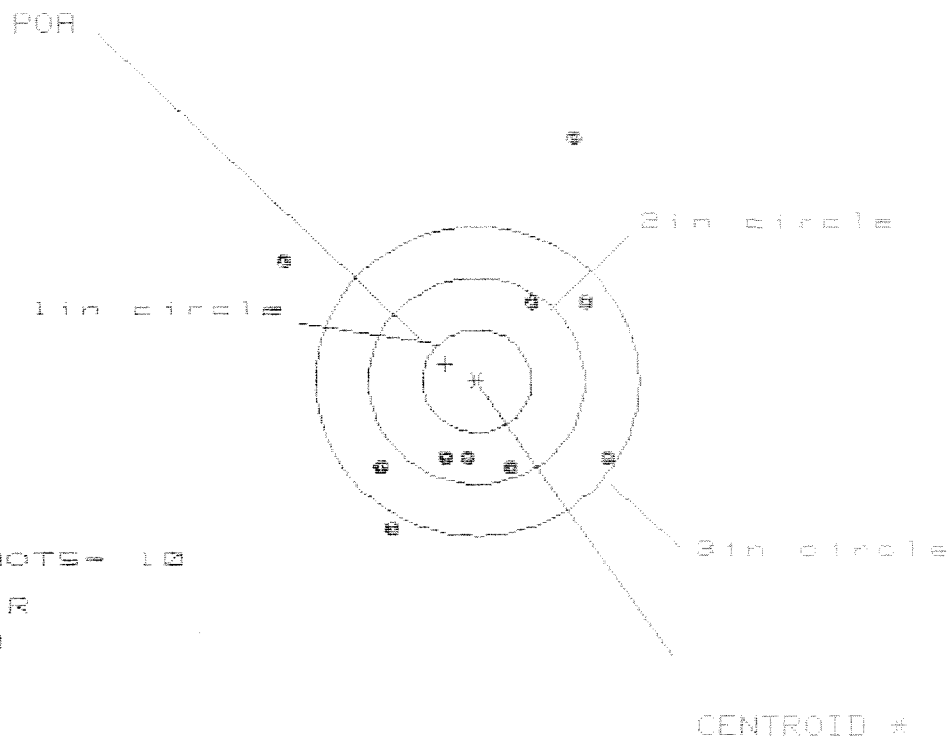
541 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0556
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .14470
THE AMR FOR THIS RIFLE IS: 1.086

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636121

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 3.033

VS= 3.784

GS= 4.138

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.202	1.305	1.089
MINIMUM X	-1.832	-1.728	-1.025
MAXIMUM Y	2.391	1.469	1.235
MINIMUM Y	-1.393	-1.127	-.944
CENTROID X	.292	.188	.404
CENTROID Y	-.166	-.432	-.615
POA TO CENTROID in.	.335	.471	.736
MIN RADIUS	.780	.425	.333
MEAN RADIUS	1.343	1.133	.935
MAX RADIUS	2.565	2.268	1.448
HORIZONTAL SPREAD	3.033	3.033	2.114
VERTICAL SPREAD	3.784	2.596	2.179
EXTREME SPREAD	4.138	3.573	2.721
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

3 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06638121

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.212

VS = 2.533

GS = 2.615

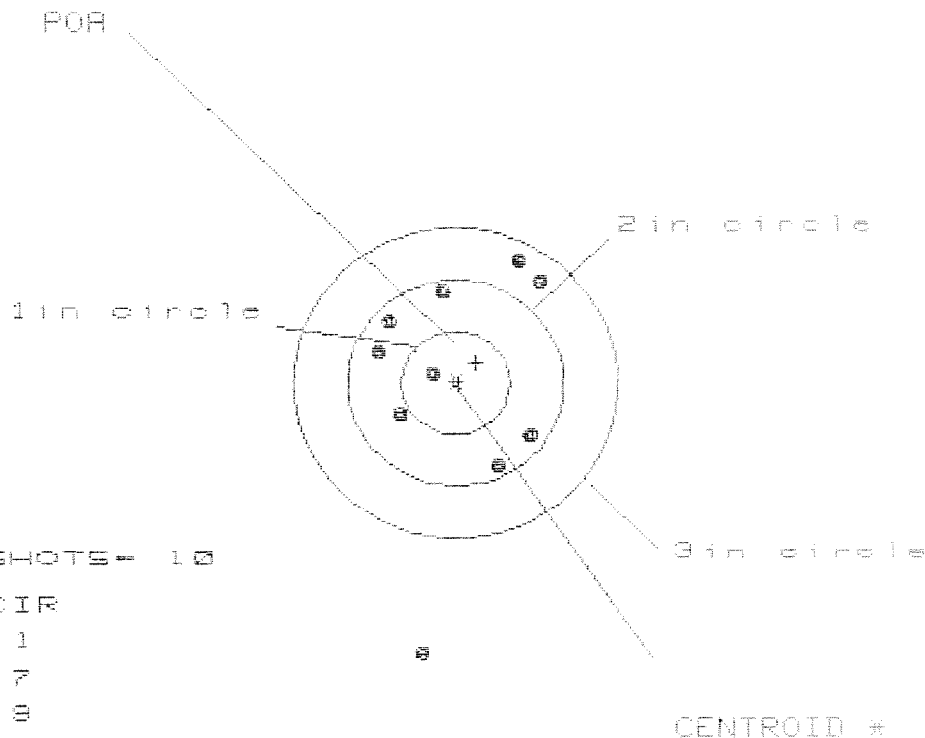
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.967	.830	.688
MINIMUM X	-1.246	-1.138	-1.095
MAXIMUM Y	1.245	1.343	1.419
MINIMUM Y	-1.288	-1.149	-1.073
CENTROID X	-.107	-.215	-.072
CENTROID Y	-.183	-.322	-.398
POA TO CENTROID in.	.212	.387	.404
MIN RADIUS	.548	.431	.332
MEAN RADIUS	1.064	.973	.910
MAX RADIUS	1.577	1.438	1.467
HORIZONTAL SPREAD	2.213	1.968	1.782
VERTICAL SPREAD	2.533	2.492	2.492
EXTREME SPREAD	2.615	2.494	2.494
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

3 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 8

HS = 1.553

VS = 3.789

GS = 3.798

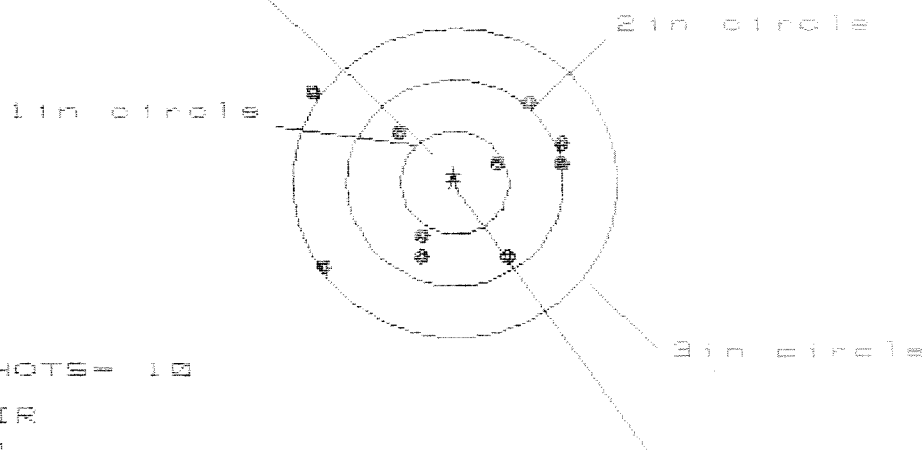
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.822	.791	.855
MINIMUM X	:	-.731	-.762	-.698
MAXIMUM Y	:	1.152	.868	.794
MINIMUM Y	:	-2.557	-1.052	-.943
CENTROID X	:	-.183	-.152	-.216
CENTROID Y	:	-.194	.090	-.019
POB TO CENTROID in.	:	.267	.177	.217
MIN RADIUS	:	.250	.280	.179
MEAN RADIUS	:	1.030	.828	.786
MAX RADIUS	:	2.572	1.122	1.167
HORIZONTAL SPREAD	:	1.553	1.553	1.553
VERTICAL SPREAD	:	3.789	1.920	1.737
EXTREME SPREAD	:	3.798	1.924	1.867
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

3 Jun 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 2.332

VS= 1.743

QS= 2.547

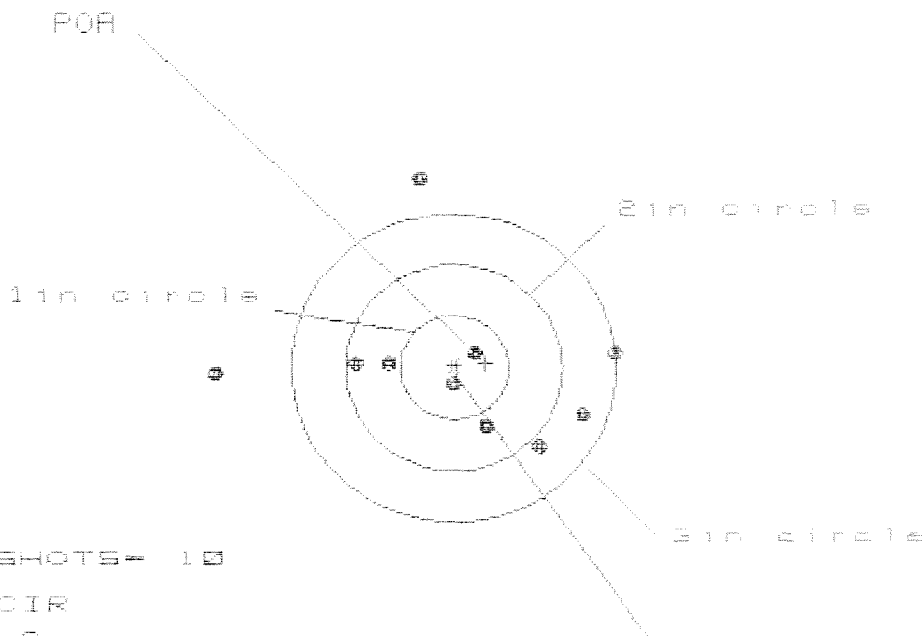
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	6
MAXIMUM X	1.033	.889	.725
MINIMUM X	-1.299	-1.315	-.823
MAXIMUM Y	.887	.874	.779
MINIMUM Y	-.856	-.757	-.736
CENTROID X	.011	.155	.319
CENTROID Y	-.083	-.182	-.087
POA TO CENTROID in.	.084	.239	.331
MIN RADIUS	.454	.371	.186
MEAN RADIUS	.960	.868	.755
MAX RADIUS	1.573	1.518	.954
HORIZONTAL SPREAD	2.332	2.204	1.548
VERTICAL SPREAD	1.743	1.631	1.515
EXTREME SPREAD	2.547	2.547	1.746
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

3 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.663

VSE= 2.628

GS= 3.669

PATTERN #

5

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.474	1.230	1.162
MINIMUM X	-2.189	-1.139	-1.207
MAXIMUM Y	1.855	1.844	.378
MINIMUM Y	-.773	-.784	-.554
CENTROID X	-.291	-.847	.021
CENTROID Y	-.042	-.031	-.261
POA TO CENTROID in.	.294	.057	.262
MIN RADIUS	.182	.157	.297
MEAN RADIUS	1.052	.912	.758
MAX RADIUS	2.192	1.924	1.226
HORIZONTAL SPREAD	3.663	2.369	2.369
VERTICAL SPREAD	2.628	2.628	.932
EXTREME SPREAD	3.669	2.859	2.372
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	