

C6587509

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 700™

H24

SERIAL NO.

C6587509

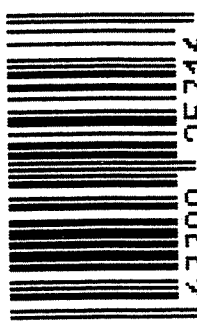
ORDER NO.

5716

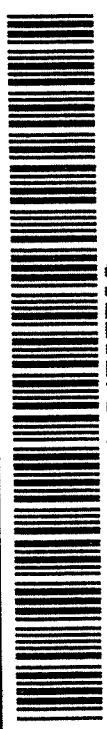
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

UPC



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5716 C6587509

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587509

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		1-7-91	KR
	Magnaflux Bolt		1-7-91	KR
615	Rollmark Caliber		1-7-91	GB
617	Drill and Tap Sight Holes	1 10	91	LB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-26-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/28/91	RW
	C) Inspect Ejector Hole for Chamfer		1/28/91	RW
	D) Oil Firing Pin Ass'y		1/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/6/91	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			2/6/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			2/6/91	WB
	H) Trigger Pull Test & Retainability						2-6-91	XL
	I) Firing Pin Indent	.021	.021	.021			2/6/91	WB
	J) Assemble Stock						2/6/91	RW
	K) Assemble Swivel Studs						2-26-91	A
	L) Attach Front and Rear Sight Assemblies						2/6/91	RW
	M) Iron Sight Alignment						2/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/6/91	RW
	O) Attach Scope to Rifle						2/6/91	RW
	P) Detach & Attach Scope 20 Times						2/6/91	RW
640	Gallery Target & Test						2-7-91	AC
	A) Time						2-7-91	AC
	B) Malfunctions						2-7-91	AC
	C) Pierced Primers						2-7-91	AC
	D) Optical Clarity of Scope						2-7-91	AC
645	Inspect for Live Ammo						2-7-91	AC
655	Final Inspection							
	A) Headspace						2-26-91	A
	B) Trigger Pull	2.50	2.49	2.47	2.53	2.50	2/25/91	XL
	C) Function						2-26-91	AC
660	Pack						3-18-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587509DATE 2-6-91TESTER JL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.26	2.25	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.25	2.23	2.49	
PULL #3	2.31	2.24	2.20	2.47	
PULL #4	2.49	2.27	2.29	2.53	
PULL #5	2.19	2.28	2.30	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.10		
PULL #2	3.50	3.41		
PULL #3	3.50	3.38		
PULL #4	3.51	3.44		
PULL #5	3.39	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.15		4.27
PULL #2	4.32	4.35		4.19
PULL #3	4.23	4.33		4.36
PULL #4	4.28	4.20		4.35
PULL #5	4.22	4.25		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587509
8 Feb 1991

CENTROIDAL DISTANCES

0 TO 1	.204783
1 TO 2	.191377
1 TO 3	.375918
1 TO 4	.40283
1 TO 5	.358001

3.54 ←----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1154
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3008
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .322177

THE AMR FOR THIS RIFLE IS: .9872

8 Feb 1991

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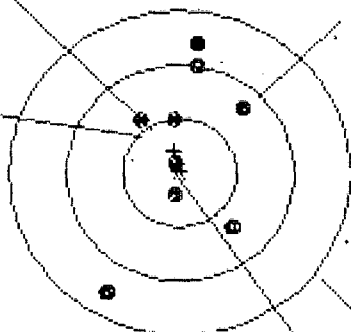
CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.163

VS= 3.141

GS= 3.162

CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.556	.531	.452
MINIMUM X	:	-.607	-.632	-.403
MAXIMUM Y	:	1.164	.945	.775
MINIMUM Y	:	-1.977	-1.360	-.855
CENTROID X	:	.044	.070	.149
CENTROID Y	:	-.200	.019	.189
FOR TO CENTROID in.	:	.205	.072	.241
MIN RADIUS	:	.089	.141	.223
MEAN RADIUS	:	.833	.668	.548
MAX RADIUS	:	1.990	1.500	.923
HORIZONTAL SPREAD	:	1.163	1.163	.855
VERTICAL SPREAD	:	3.141	2.305	1.630
EXTREME SPREAD	:	3.162	2.421	1.661
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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FILE:/PATTERNING/CENTERFIRE_PATT/06587503

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 1.972

VS= 2.657

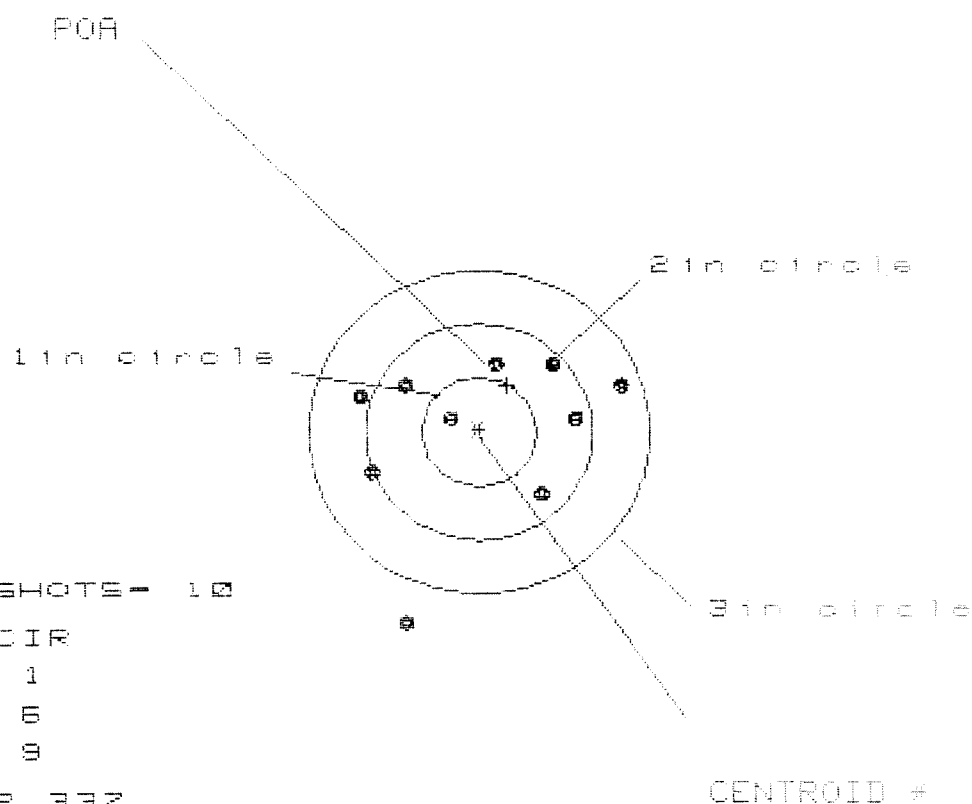
GS= 2.785

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.364	.745	.796
MINIMUM X	:	-.608	-.456	-.405
MAXIMUM Y	:	1.138	1.249	1.073
MINIMUM Y	:	-1.519	-1.408	-.916
CENTROID X	:	.032	-.120	-.171
CENTROID Y	:	-.009	-.120	.056
POA TO CENTROID in.	:	.033	.170	.180
MIN RADIUS	:	.484	.458	.336
MEAN RADIUS	:	.963	.860	.752
MAX RADIUS	:	1.690	1.467	1.136
HORIZONTAL SPREAD	:	1.972	1.201	1.201
VERTICAL SPREAD	:	2.657	2.657	1.989
EXTREME SPREAD	:	2.785	2.785	2.191
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.337

VS= 2.423

GS= 2.888

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.254	1.187	.958
MINIMUM X	:	-1.083	-1.150	-1.002
MAXIMUM Y	:	.675	.481	.514
MINIMUM Y	:	-1.748	-.795	-.762
CENTROID X	:	-.251	-.184	-.332
CENTROID Y	:	-.433	-.239	-.272
POA TO CENTROID in.	:	.501	.301	.429
MIN RADIUS	:	.243	.280	.128
MEAN RADIUS	:	.955	.825	.758
MAX RADIUS	:	1.851	1.216	1.015
HORIZONTAL SPREAD	:	2.337	2.337	1.960
VERTICAL SPREAD	:	2.423	1.276	1.276
EXTREME SPREAD	:	2.888	2.349	1.968
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 1.691

VS= 3.607

GS= 3.607

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.750	.814	.891
MINIMUM X	-.942	-.877	-.800
MAXIMUM Y	1.756	1.551	1.173
MINIMUM Y	-1.851	-1.716	-1.523
CENTROID X	.494	.429	.352
CENTROID Y	-.375	-.170	-.363
POA TO CENTROID in.	.620	.461	.506
MIN RADIUS	.227	.061	.179
MEAN RADIUS	1.149	1.016	.941
MAX RADIUS	1.941	1.725	1.526
HORIZONTAL SPREAD	1.691	1.691	1.691
VERTICAL SPREAD	3.607	3.267	2.696
EXTREME SPREAD	3.607	3.361	2.810
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

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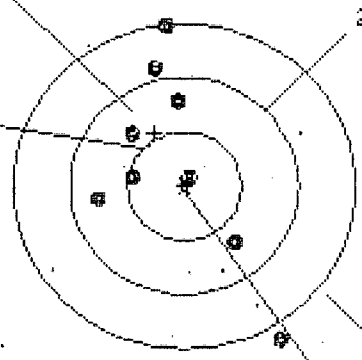
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 1.633

VS= 3.371

GS= 3.502

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.874	.961	.674
MINIMUM X	:	-.759	-.672	-.552
MAXIMUM Y	:	1.509	1.302	1.097
MINIMUM Y	:	-1.862	-1.642	-.974
CENTROID X	:	.258	.171	.051
CENTROID Y	:	-.487	-.280	-.075
POA TO CENTROID in.	:	.551	.328	.091
MIN RADIUS	:	.124	.124	.277
MEAN RADIUS	:	.986	.819	.651
MAX RADIUS	:	2.019	1.902	1.184
HORIZONTAL SPREAD	:	1.633	1.633	1.226
VERTICAL SPREAD	:	3.371	2.944	2.071
EXTREME SPREAD	:	3.502	3.123	2.166
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		