

06587708

MODEL 700TM N24

Model **SMS** TM

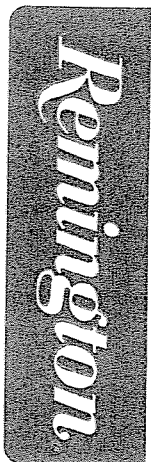
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6587708

DATE 6-3-96

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.79	2.61		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.80	2.53		
PULL #3	2.49	2.83	2.44		
PULL #4	2.49	2.68	2.45		
PULL #5	2.45	2.64	2.52		
TOTAL	12.58	13.74	12.55		
AVG.	2.51	2.74	2.51		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.17		
PULL #2	3.13	3.14		
PULL #3	3.08	3.09		
PULL #4	3.13	3.00		
PULL #5	3.13	3.00		
TOTAL	15.58	15.40		
AVG.	3.11	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.00		4.09
PULL #2	4.21	4.16		4.03
PULL #3	4.18	4.00		4.05
PULL #4	4.22	4.04		4.11
PULL #5	4.15	4.00		4.14
TOTAL	20.91	20.20		20.42
AVG.	4.18	4.04		4.08

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06587708
10 Apr 1900

CENTROIDAL DISTANCES

0 TO	1	.200122
1 TO	2	.149723
1 TO	3	.166481
1 TO	4	.228127
1 TO	5	.358276

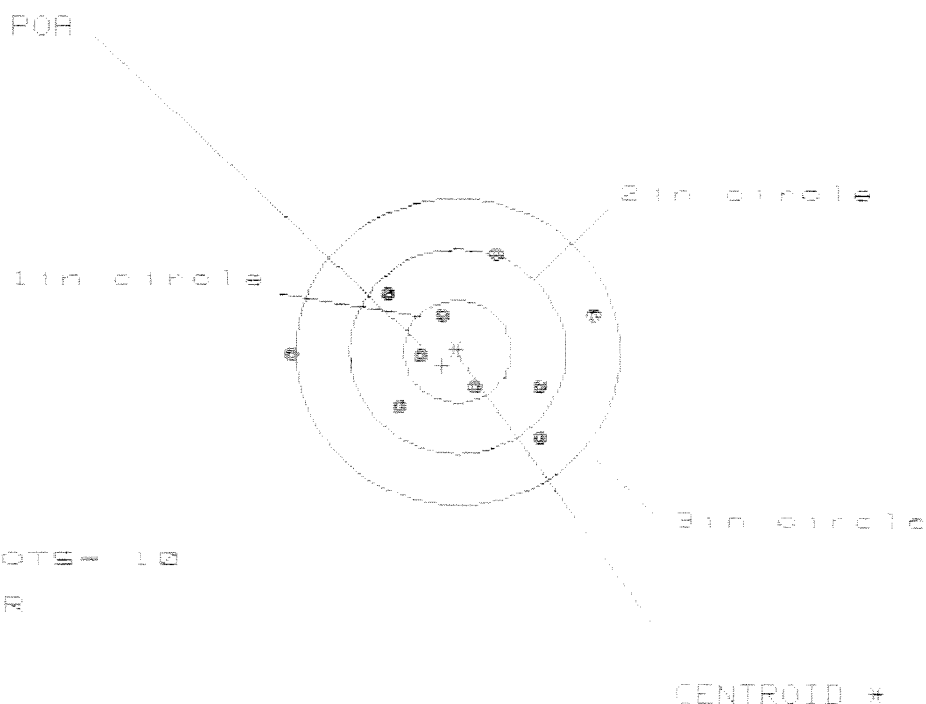
$\frac{1}{5}$ -----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2602
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0566
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .266285
THE AMR FOR THIS RIFLE IS: .9652

18 Apr 1988

FILE: \PATTERNING\CENTERFIRE_PATT\08587708

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.796

VS= 1.723

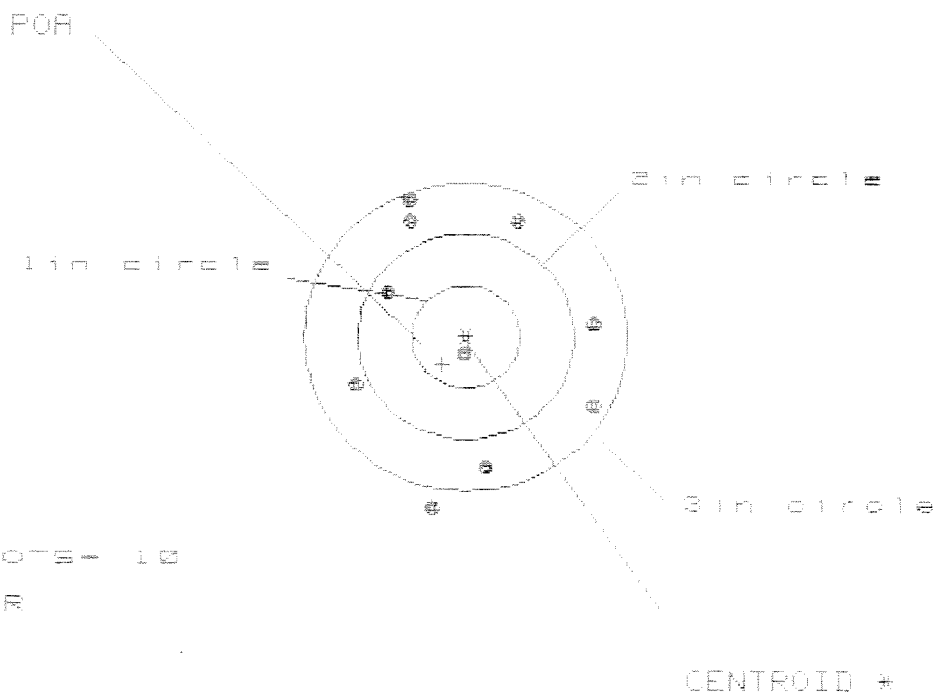
GS= 2.823

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.288	1.121	.712
MINIMUM X	-1.508	-.636	-.696
MAXIMUM Y	.916	.911	.953
MINIMUM Y	-.807	-.812	-.771
CENTROID X	.143	.310	.170
CENTROID Y	.140	.145	.104
POA TO CENTROID (in)	.200	.343	.199
MIN RADIUS	.351	.322	.306
MEAN RADIUS	.852	.780	.710
MAX RADIUS	1.509	1.169	1.035
HORIZONTAL SPREAD	2.796	1.957	1.408
VERTICAL SPREAD	1.723	1.723	1.723
EXTREME SPREAD	2.823	2.081	1.929
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587708

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 9

HS = 2.208

VS = 3.041

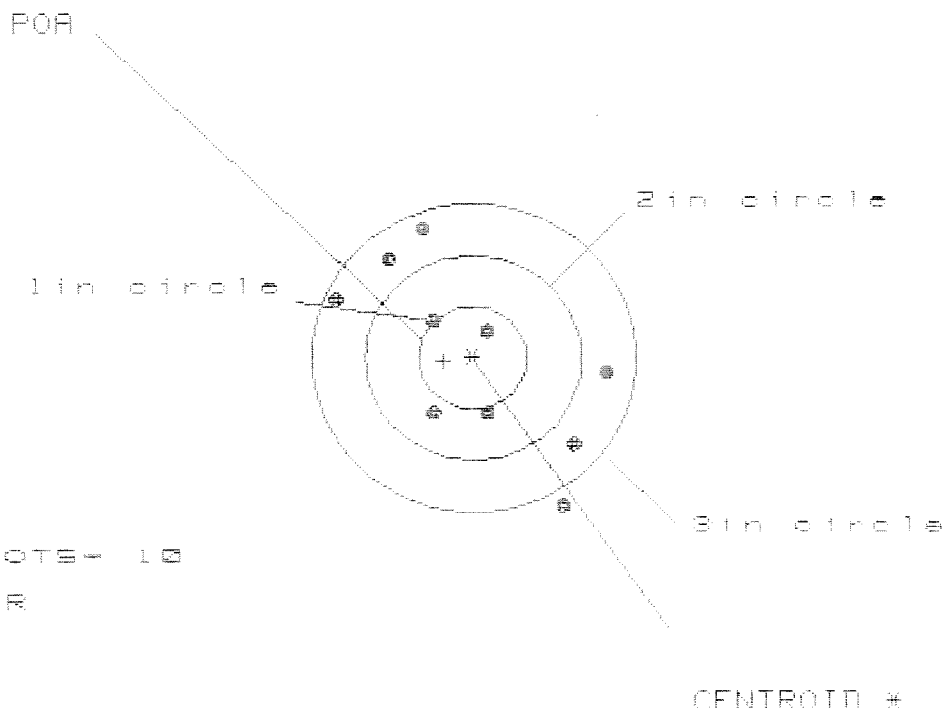
GS = 3.049

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.166	1.099
MINIMUM X	:	-1.011	-1.042	-1.109
MAXIMUM Y	:	1.339	1.150	1.134
MINIMUM Y	:	-1.702	-1.457	-1.313
CENTROID X	:	.219	.250	.317
CENTROID Y	:	.269	.458	.314
POA TO CENTROID in.	:	.347	.522	.446
MIN RADIUS	:	.157	.347	.244
MEAN RADIUS	:	1.166	1.101	1.070
MAX RADIUS	:	1.724	1.462	1.314
HORIZONTAL SPREAD	:	2.208	2.208	2.208
VERTICAL SPREAD	:	3.041	2.607	2.447
EXTREME SPREAD	:	3.049	2.689	2.499
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	9		

10 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/09587788

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

HM = 0.470

VM = 0.652

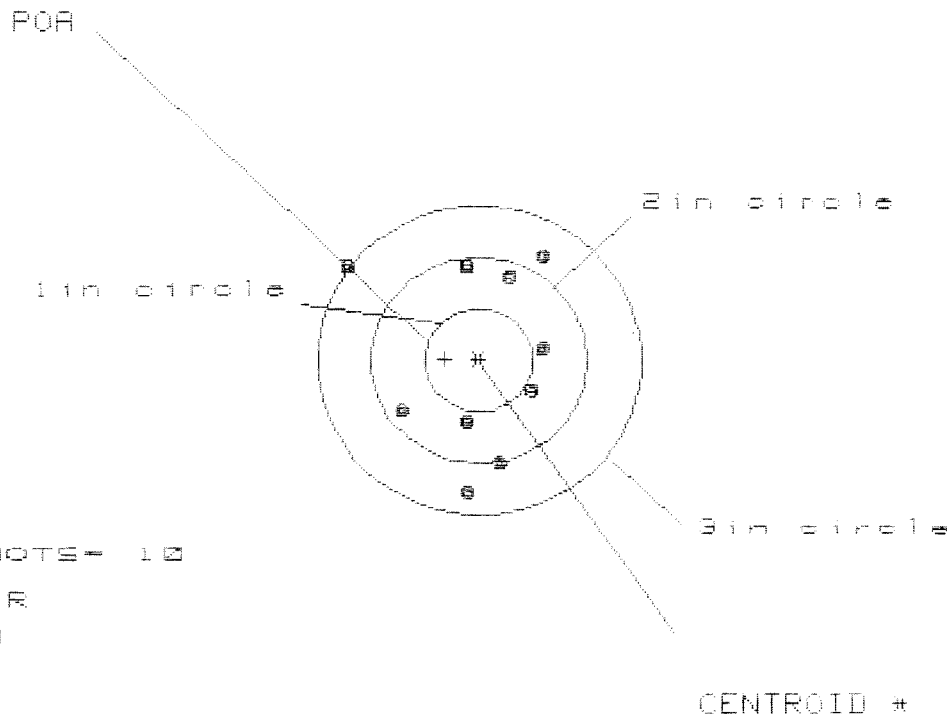
GM = 0.983

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	1.329	1.186
MINIMUM X	-1.237	-1.143	-0.869
MAXIMUM Y	1.245	1.089	1.140
MINIMUM Y	-1.407	-0.983	-0.931
CENTROID X	.273	.179	.322
CENTROID Y	.036	.192	.141
POA TO CENTROID in.	.275	.263	.351
MIN RADIUS	.252	.220	.137
MEAN RADIUS	1.008	.921	.877
MAX RADIUS	1.641	1.438	1.300
HORIZONTAL SPREAD	2.472	2.472	2.055
VERTICAL SPREAD	2.652	2.072	2.072
EXTREME SPREAD	2.983	2.600	2.545
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

18 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06587788

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 6

3in = 9

HS= 1.774

VS= 2.279

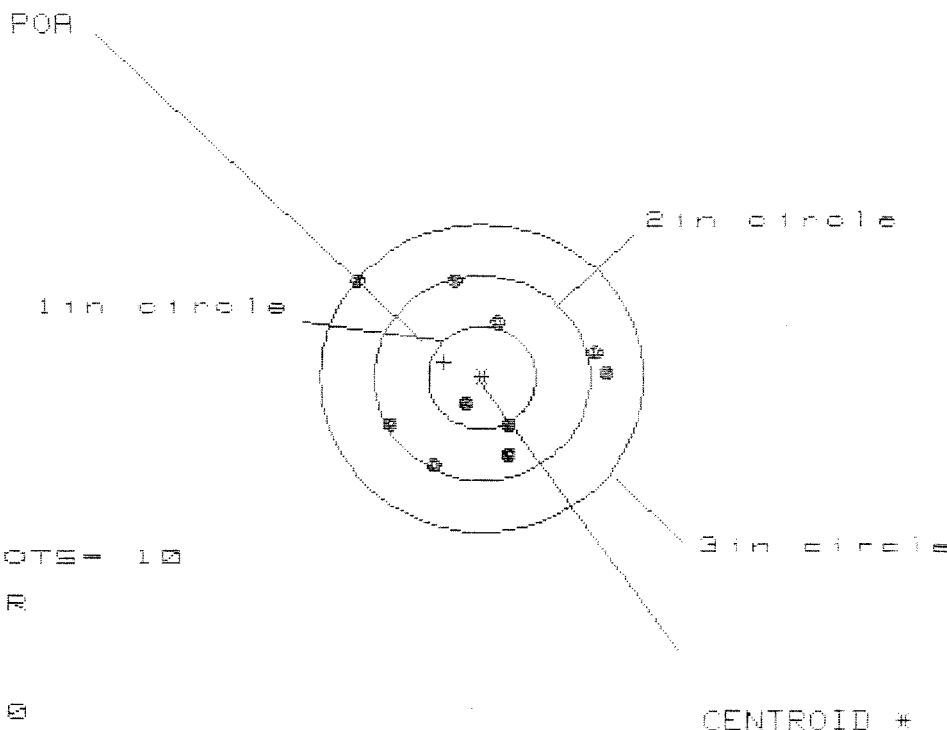
GS= 2.487

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.594	.463	.436
MINIMUM X	:	-1.180	-.797	-.824
MAXIMUM Y	:	.981	1.036	.937
MINIMUM Y	:	-1.298	-1.193	-1.053
CENTROID X	:	.314	.445	.472
CENTROID Y	:	-.011	-.116	.033
POA TO CENTROID in.	:	.314	.460	.473
MIN RADIUS	:	.553	.398	.389
MEAN RADIUS	:	.925	.832	.779
MAX RADIUS	:	1.512	1.212	1.053
HORIZONTAL SPREAD	:	1.774	1.260	1.260
VERTICAL SPREAD	:	2.279	2.279	1.990
EXTREME SPREAD	:	2.497	2.378	2.031
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Apr 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08587708

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.280

VS= 1.860

GS= 2.469

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.143	1.017	1.068
MINIMUM X	-1.137	-.932	-.805
MAXIMUM Y	.981	1.088	1.102
MINIMUM Y	-.879	-.772	-.758
CENTROID X	.352	.478	.351
CENTROID Y	-.151	-.258	-.272
POA TO CENTROID in.	.383	.543	.444
MIN RADIUS	.249	.281	.161
MEAN RADIUS	.875	.786	.741
MAX RADIUS	1.487	1.146	1.127
HORIZONTAL SPREAD	2.280	1.949	1.873
VERTICAL SPREAD	1.860	1.860	1.860
EXTREME SPREAD	2.469	2.004	1.996
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587708

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	6 1/2	6 1/2	6 1/2			6/8/96	WB
	G) Safety Off Force	2	2 1/2	2 1/4			6/8/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.024	.024	.024			6/8/96	WB
	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	2.58	2.54	2.54	2.51	2.49	6/21/96	RW
	C) Function							
660	Pack							

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




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

MODEL 700™ H24

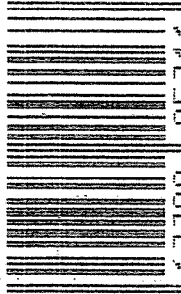
20

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

SERIAL NO.
C6587708

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6587708

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6587708

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/18/90	KJ
600	Proof		10/18/90	KJ
607	Check Headspace		10/18/90	KJ
610	Dis-assemble Gun		10/18/90	KJ
612	Magnaflux Barrel Action		10/22/90	KR
	Magnaflux Bolt		10/22/90	KR
615	Rollmark Caliber		10/22/90	SS
617	Drill and Tap Sight Holes		10/23/90	WB
618	Polish Barrel RB		10/24/90	WB
620	Apply Coatings (Barrel Action)		10/26/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/90	KS
	C) Inspect Ejector Hole for Chamfer		11/6/90	KS
	D) Oil Firing Pin Ass'y		11/6/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11/21/90 11/15/90	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.3/4	4.3/4	4.0			11/7/90	KS
	G) Safety Off Force	2.1/2	2.3/4	3.0			11/7/90	KS
	H) Trigger Pull Test & Retainability						1-21-91 1-13-90	JH
	I) Firing Pin Indent	.0205	.0205	.021			11/7/90	KS
	J) Assemble Stock						11/13/90	Kd
	K) Assemble Swivel Studs						2-6-91	DH
	L) Attach Front and Rear Sight Assemblies						11/13/90	Kd
	M) Iron Sight Alignment						11/13/90	Kd
	N) Detach Front & Rear Sights & place in numbered container						11/13/90	Kd
	O) Attach Scope to Rifle						11/13/90	Kd
P) Detach & Attach Scope 20 Times						11/13/90	Kd	
640	Gallery Target & Test						1-23-91	DH
	A) Time						1-23-91	DH
	B) Malfunctions						1-23-91	DH
	C) Pierced Primers						1-23-91	DH
	D) Optical Clarity of Scope						1-23-91	DH
645	Inspect for Live Ammo						1-23-91	DH
655	Final Inspection							
	A) Headspace						2-6-91	DH
	B) Trigger Pull	2.40	2.32	2.25	2.33	2.41	2-1-91	JH
	C) Function						2-6-91	DH
660	Pack						3/15/91	WB

SWS TRIGGER PULL TEST

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

SERIAL NO. C6587708
DATE 1-28-91
TESTER JLI.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.44	2.40	2.40	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.47	2.43	2.32	
PULL #3	2.49	2.46	2.43	2.25	
PULL #4	2.46	2.43	2.47	2.33	
PULL #5	2.41	2.47	2.40	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.28		
PULL #2	3.25	3.34		
PULL #3	3.17	3.33		
PULL #4	3.23	3.19		
PULL #5	3.22	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.34		4.15
PULL #2	4.39	4.15		4.30
PULL #3	4.23	4.27		4.24
PULL #4	4.31	4.29		4.27
PULL #5	4.34	4.25		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587708
24 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.196229
1 TO	2	.0684251
1 TO	3	.285727
1 TO	4	.192083
1 TO	5	.177882

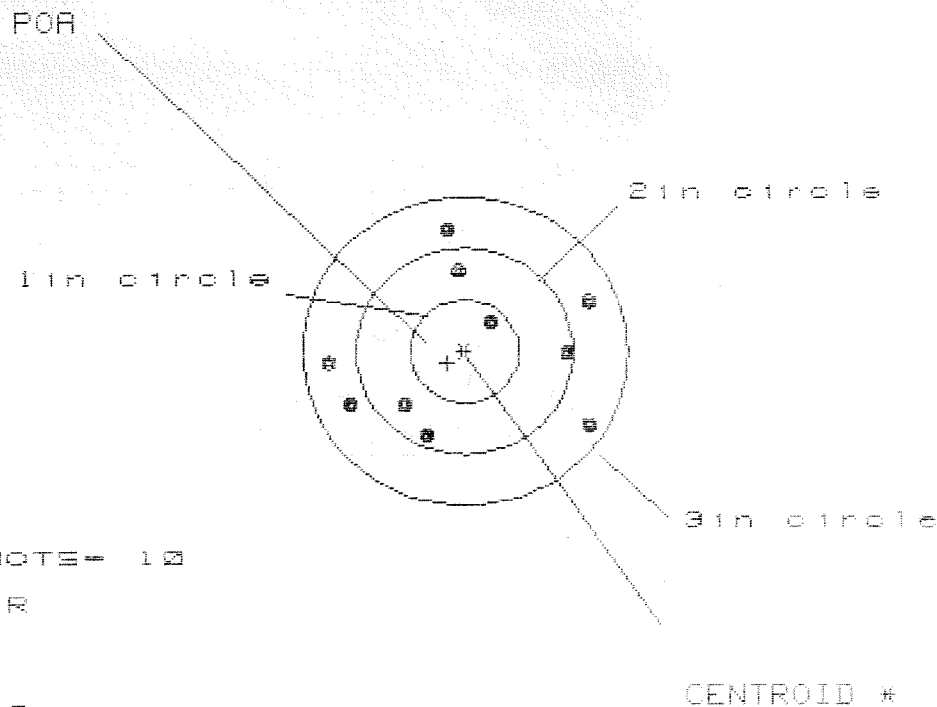
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1126
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0514
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12377
THE AMR FOR THIS RIFLE IS: .9728

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG587788

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 2.455

VS = 1.967

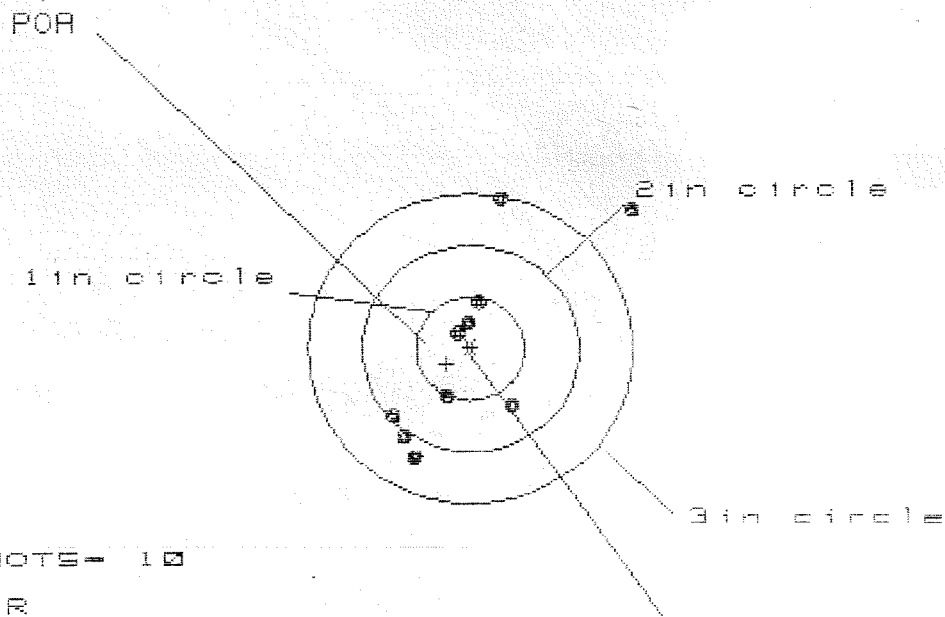
GS = 2.509

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.182	1.309	1.165
MINIMUM X	:	-1.273	-1.146	-1.041
MAXIMUM Y	:	1.140	1.058	1.039
MINIMUM Y	:	-.827	-.909	-.928
CENTROID X	:	.159	.032	.176
CENTROID Y	:	.115	.197	.216
POA TO CENTROID in.	:	.196	.199	.278
MIN RADIUS	:	.400	.437	.312
MEAN RADIUS	:	.991	.940	.898
MAX RADIUS	:	1.356	1.359	1.233
HORIZONTAL SPREAD	:	2.455	2.455	2.206
VERTICAL SPREAD	:	1.967	1.967	1.967
EXTREME SPREAD	:	2.509	2.509	2.426
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587700

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.199

VS= 2.497

GS= 3.149

CENTROID +

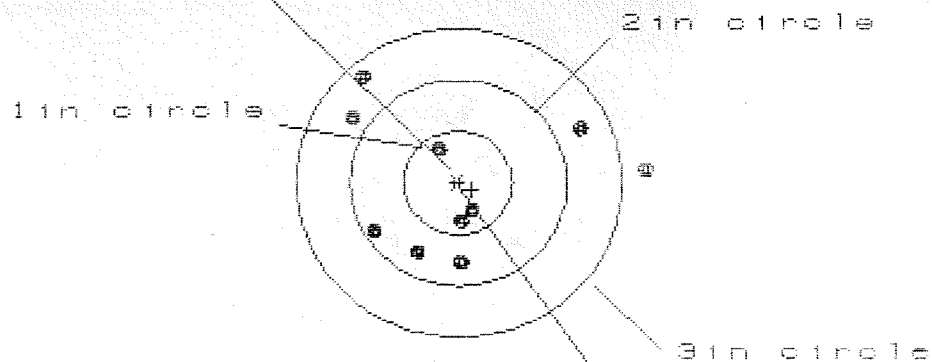
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.496	.529	.583
MINIMUM X	:	-.703	-.537	-.483
MAXIMUM Y	:	1.417	1.567	.837
MINIMUM Y	:	-1.080	-.930	-.734
CENTROID X	:	.220	.054	.000
CENTROID Y	:	.146	-.004	-.200
POA TO CENTROID in.	:	.264	.054	.200
MIN RADIUS	:	.172	.271	.070
MEAN RADIUS	:	.885	.738	.601
MAX RADIUS	:	2.018	1.625	.899
HORIZONTAL SPREAD	:	2.199	1.066	1.066
VERTICAL SPREAD	:	2.497	2.497	1.571
EXTREME SPREAD	:	3.149	2.612	1.686
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587708

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS = 2.710

VS = 1.759

GS = 2.754

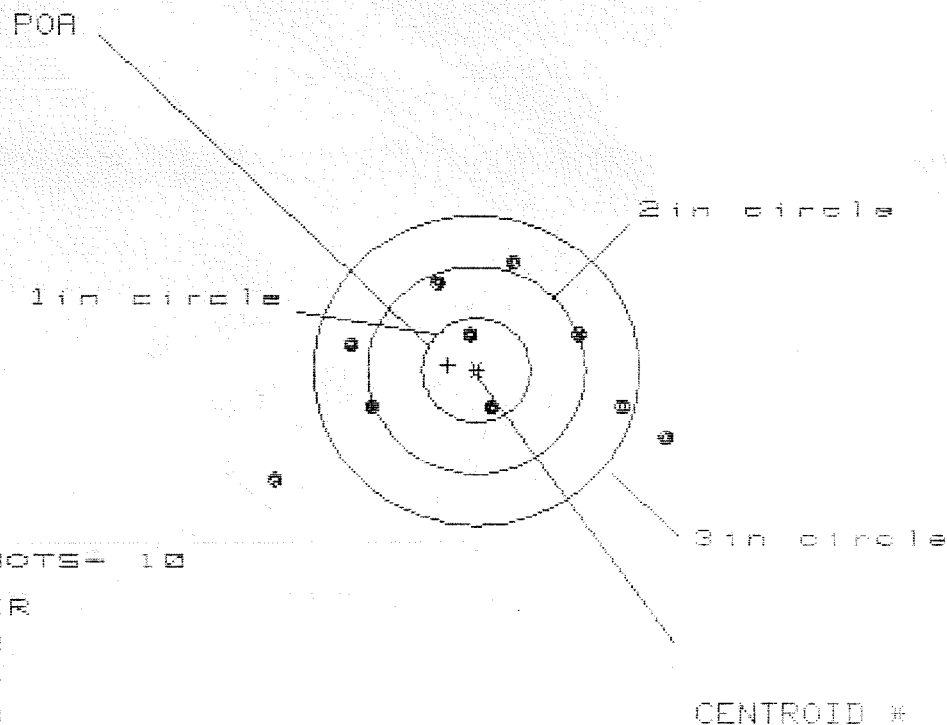
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.740	1.364	1.285
MINIMUM X	-.970	-.777	-.856
MAXIMUM Y	1.031	1.048	.790
MINIMUM Y	-.728	-.711	-.580
CENTROID X	-.123	-.316	-.237
CENTROID Y	.069	.052	-.079
POA TO CENTROID in.	.141	.321	.249
MIN RADIUS	.319	.320	.297
MEAN RADIUS	.902	.790	.700
MAX RADIUS	1.747	1.457	1.437
HORIZONTAL SPREAD	2.710	2.141	2.141
VERTICAL SPREAD	1.759	1.759	1.370
EXTREME SPREAD	2.754	2.174	2.174
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587788

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.619

VS= 2.139

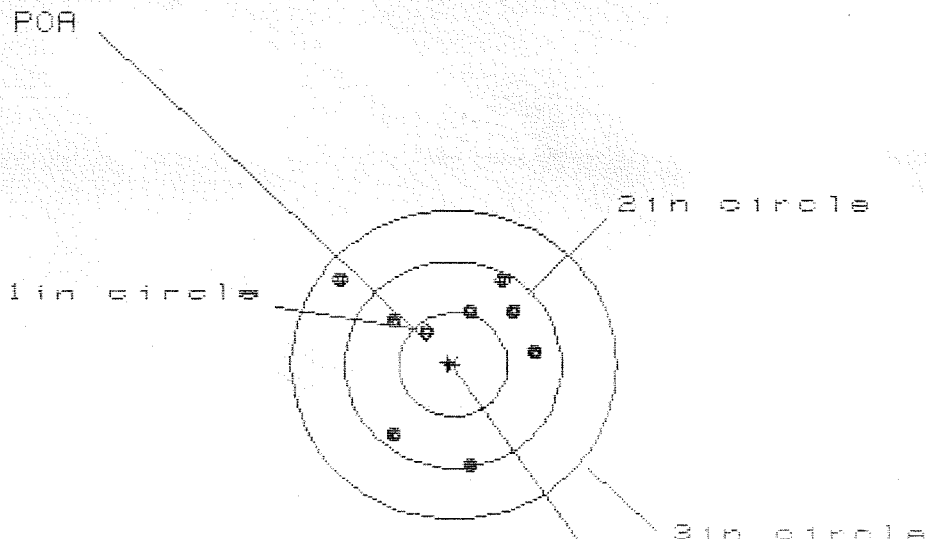
GS= 3.641

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.740	1.532	1.309
MINIMUM X	-1.879	-1.416	-1.225
MAXIMUM Y	1.075	.956	.858
MINIMUM Y	-1.064	-.787	-.616
CENTROID X	.259	.467	.276
CENTROID Y	-.049	.070	.168
POA TO CENTROID in.	.263	.472	.323
MIN RADIUS	.343	.367	.157
MEAN RADIUS	1.139	1.009	.884
MAX RADIUS	2.159	1.722	1.415
HORIZONTAL SPREAD	3.619	2.948	2.534
VERTICAL SPREAD	2.139	1.743	1.474
EXTREME SPREAD	3.641	3.077	2.596
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587788

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.798

VS= 2.906

GS= 3.186

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.742	.784	.657
MINIMUM X	:	-1.056	-1.014	-.664
MAXIMUM Y	:	.840	.610	.679
MINIMUM Y	:	-2.066	-1.204	-1.135
CENTROID X	:	.048	.006	.133
CENTROID Y	:	-.024	.206	.137
POA TO CENTROID in.	:	.054	.206	.191
MIN RADIUS	:	.431	.226	.369
MEAN RADIUS	:	.947	.757	.710
MAX RADIUS	:	2.101	1.220	1.138
HORIZONTAL SPREAD	:	1.798	1.798	1.321
VERTICAL SPREAD	:	2.906	1.814	1.814
EXTREME SPREAD	:	3.186	2.132	1.839
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	