

C6636019

MODEL 700™ N24

Model **SMS**™

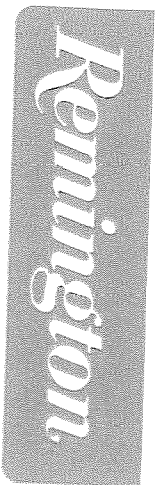
Action

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

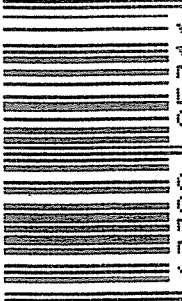
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO. C6636019

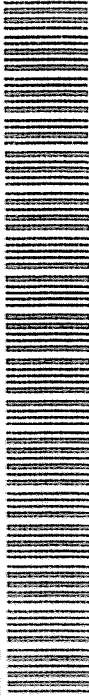
ORDER NO. 5716

20

UPC



0 47700 25716 7



5716 C6636019

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636019

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1	5/1/91	KS
	Magnaflux Bolt	5 8 9 1	5/1/91	KS
615	Rollmark Caliber		5/1/91	GS
617	Drill and Tap Sight Holes	5 15 9 1	5/1/91	KS
618	Polish Barrel	5 15 9 1	5/1/91	KS
620	Apply Coatings (Barrel Action)		5-31-91	KS
	Apply Coating (Bolt)		5-31-91	KS
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JH
	G) Safety Off Force	4	4	4			6-7-91	JH
	H) Trigger Pull Test & Retainability						6-7-91	JH
	I) Firing Pin Indent	10205	0225	0225			6-7-91	JH
	J) Assemble Stock						6-7-91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						6-7-91	KS
	M) Iron Sight Alignment						6-7-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-7-91	KS
	O) Attach Scope to Rifle						6-7-91	KS
	P) Detach & Attach Scope 20 Times						6-7-91	KS
640	Gallery Target & Test						6-10-91	DH
	A) Time						6-10-91	DH
	B) Malfunctions						6-10-91	DH
	C) Pierced Primers						6-10-91	DH
	D) Optical Clarity of Scope						6-10-91	DH
645	Inspect for Live Ammo						6-10-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.69	2.70	2.75	2.70	2.69	6-13-91	JH
	C) Function						6-13-91	AC
660	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636019

DATE 6-7-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.52	2.49	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.54	2.52	2.70	
PULL #3	2.25	2.52	2.50	2.75	
PULL #4	2.49	2.53	2.55	2.70	
PULL #5	2.59	2.56	2.58	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.40		
PULL #2	3.50	3.32		
PULL #3	3.45	3.29		
PULL #4	3.40	3.27		
PULL #5	3.36	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	4.34	4.21		4.16
PULL #2	4.31	4.20		4.50
PULL #3	4.31	4.19		4.46
PULL #4	4.25	4.18		4.47
PULL #5	4.21	4.20		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636019
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.418374
1 TO	2	.50852
1 TO	3	.0970052
1 TO	4	.434839
1 TO	5	.266242

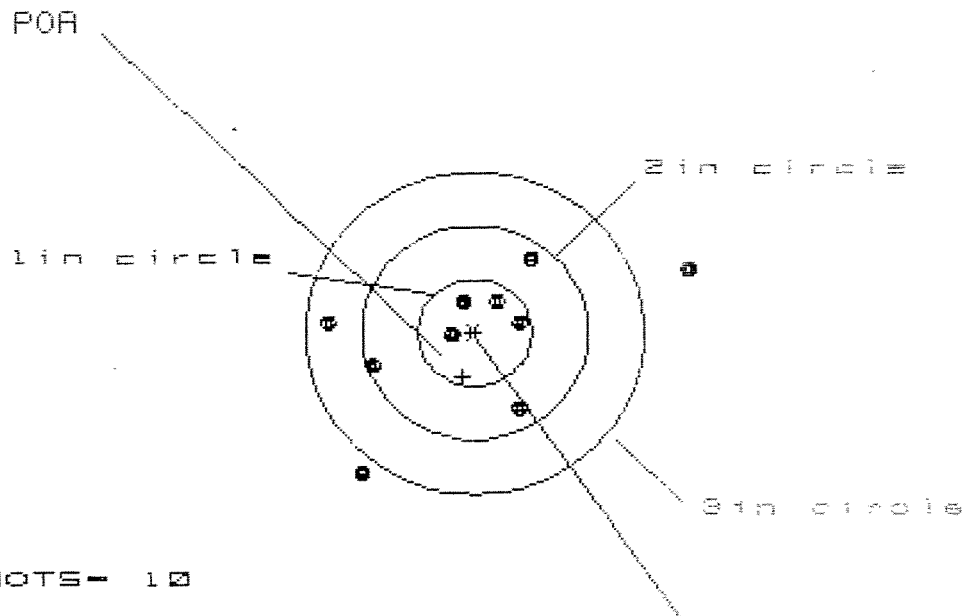
$\frac{d}{c} +$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1494
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .234078
THE AMR FOR THIS RIFLE IS: 1.023

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CSS36019

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 4

2in - 7

3in = 8

HS= 3.187

VS= 1.991

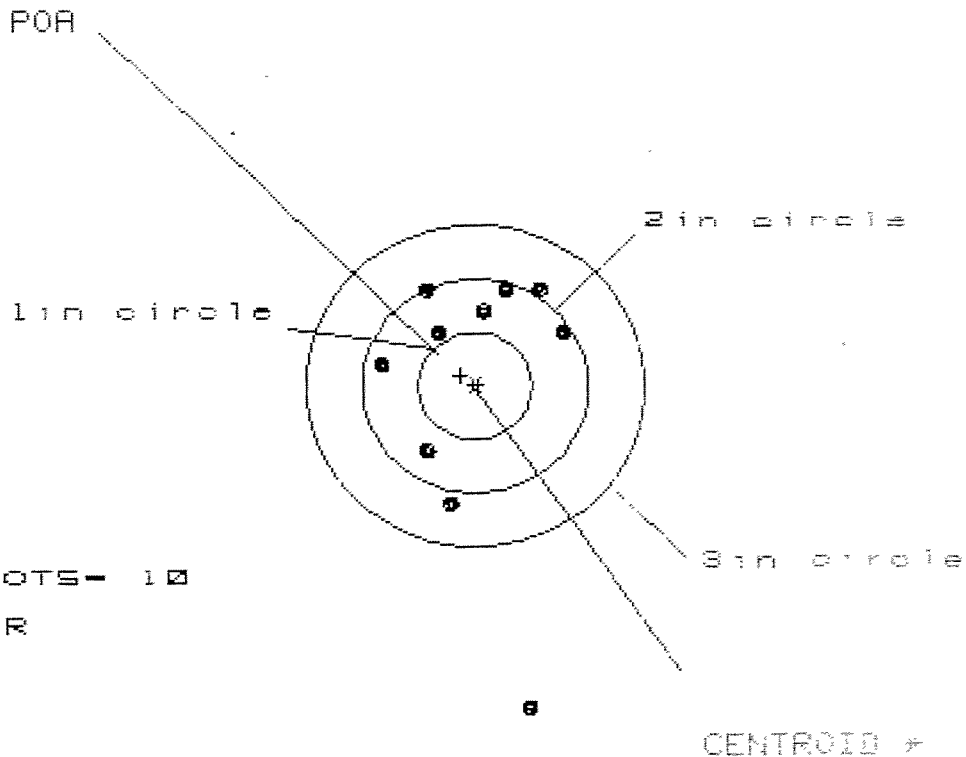
GS= 3.469

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.925	.736	.639
MINIMUM X	:	-1.262	-1.048	-1.145
MAXIMUM Y	:	.727	.794	.645
MINIMUM Y	:	-1.264	-1.197	-.887
CENTROID X	:	.101	-.113	-.016
CENTROID Y	:	.406	.339	.488
POR TO CENTROID in.	:	.419	.357	.489
MIN RADIUS	:	.289	.076	.118
MEAN RADIUS	:	.892	.765	.643
MAX RADIUS	:	2.020	1.428	1.146
HORIZONTAL SPREAD	:	3.187	1.784	1.734
VERTICAL SPREAD	:	1.991	1.991	1.452
EXTREME SPREAD	:	3.469	3.502	1.827
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636019

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 1.644

VS= 3.940

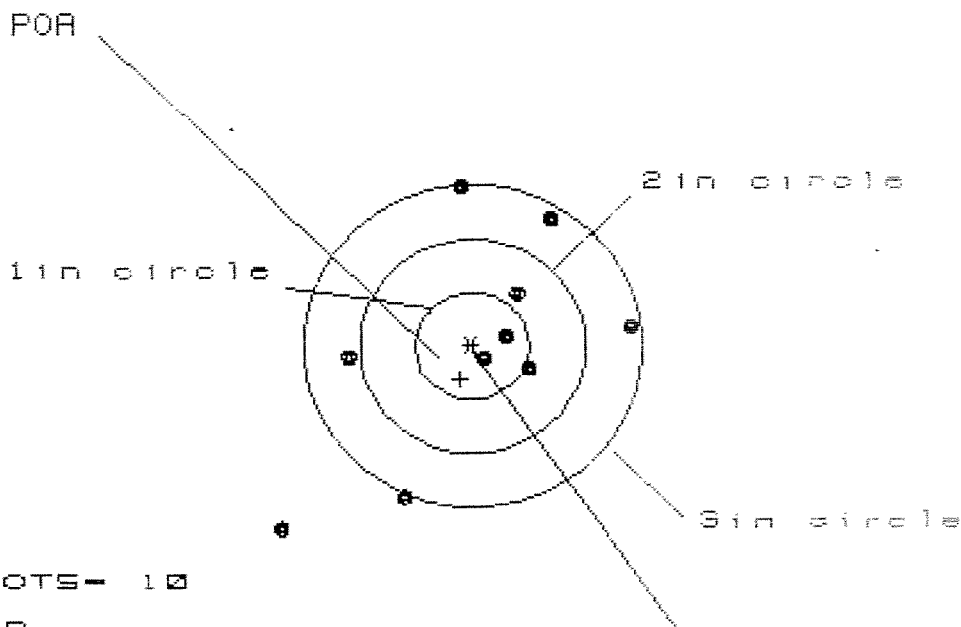
GS= 4.032

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.786	.838	.916
MINIMUM X	:	-.858	-.806	-.728
MAXIMUM Y	:	.942	.608	.683
MINIMUM Y	:	-2.998	-1.394	-1.319
CENTROID X	:	.124	.072	-.006
CENTROID Y	:	-.102	.232	.157
POA TO CENTROID in.	:	.161	.242	.157
MIN RADIUS	:	.625	.342	.338
MEAN RADIUS	:	1.103	.780	.777
MAX RADIUS	:	3.036	1.399	1.320
HORIZONTAL SPREAD	:	1.644	1.644	1.644
VERTICAL SPREAD	:	3.940	2.002	2.002
EXTREME SPREAD	:	4.032	2.125	2.012
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Jun 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 3.124

VS= 3.227

GS= 3.761

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.445	1.258	1.219
MINIMUM X	:	-1.679	-1.269	-1.388
MAXIMUM Y	:	1.522	1.333	1.149
MINIMUM Y	:	-1.705	-1.554	-1.388
CENTROID X	:	.100	.287	.326
CENTROID Y	:	.309	.498	.332
POA TO CENTROID in.	:	.325	.575	.465
MIN RADIUS	:	.132	.187	.137
MEAN RADIUS	:	1.102	.910	.927
MAX RADIUS	:	2.393	1.744	1.618
HORIZONTAL SPREAD	:	3.124	2.527	2.527
VERTICAL SPREAD	:	3.227	2.887	2.537
EXTREME SPREAD	:	3.761	2.926	2.873
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Jun 1991

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 3.094

VS= 2.289

GS= 3.555

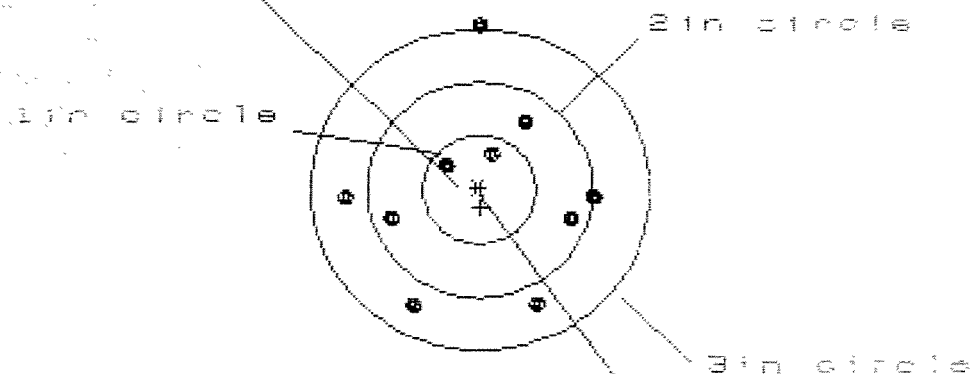
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.974	.739	.786
MINIMUM X	:	-2.120	-.797	-.750
MAXIMUM Y	:	1.090	.960	.873
MINIMUM Y	:	-1.199	-1.329	-1.209
CENTROID X	:	.432	.667	.620
CENTROID Y	:	.124	.254	.134
POA TO CENTROID in.	:	.449	.714	.634
MIN RADIUS	:	.433	.570	.596
MEAN RADIUS	:	1.091	.895	.897
MAX RADIUS	:	2.422	1.422	1.296
HORIZONTAL SPREAD	:	3.094	1.536	1.536
VERTICAL SPREAD	:	2.289	2.289	2.082
EXTREME SPREAD	:	3.555	2.438	2.236
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Jun 1991

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CENTERFIRE PATTERNS # 5

FOR



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 2.190

VS = 2.583

GS = 2.655

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.022	1.021	.544
MINIMUM X	:	-1.168	-1.169	-1.246
MAXIMUM Y	:	1.492	.831	.715
MINIMUM Y	:	-1.091	-.925	-.938
CENTROID X	:	-.010	-.009	.059
CENTROID Y	:	.164	-.002	.114
FOR TO CENTROID in.	:	.164	.009	.133
MIN RADIUS	:	.308	.470	.348
MEAN RADIUS	:	.925	.874	.817
MAX RADIUS	:	1.492	1.172	1.246
HORIZONTAL SPREAD	:	2.190	2.190	2.190
VERTICAL SPREAD	:	2.583	1.756	1.703
EXTREME SPREAD	:	2.655	2.191	2.191
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	