

C661510

MODEL 700TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

* Includes 1 in chamber.



M2400078031



MODEL 700TM M24



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

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

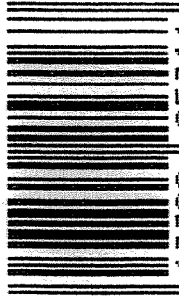
SERIAL NO. C6611510	ORDER NO. 5716
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611510

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611510**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/12/91	K.S.
600	Proof		3/12/91	K.S.
607	Check Headspace		3/12/91	K.S.
610	Dis-assemble Gun		3/12/91	K.S.
612	Magnaflux Barrel Action		3/27/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		3/27/91	SL
617	Drill and Tap Sight Holes	APR 3 1991		LB
618	Polish Barrel	APR 3 1991		WB
620	Apply Coatings (Barrel Action)		3-12-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/2/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/2/91	KS
	C) Inspect Ejector Hole for Chamfer		5/2/91	KS
	D) Oil Firing Pin Ass'y		5/2/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		5-9-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	17	17	6			5-9-91	AC
	G) Safety Off Force	4	4	4			5-9-91	AC
	H) Trigger Pull Test & Retainability						5-9-91	DH
	I) Firing Pin Indent	.021	.021	.021			5-9-91	AC
	J) Assemble Stock						5/9/91	KS
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/9/91	KS
	M) Iron Sight Alignment						5/9/91	KS
	N) Detach Front & Rear Sights & place in numbered container						5/9/91	KS
	O) Attach Scope to Rifle						5/9/91	KS
	P) Detach & Attach Scope 20 Times						5/9/91	KS
640	Gallery Target & Test						5/13/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						5/13/91	KT
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.30	2.28	2.41	2.38	2.35	5/20/91	DH
	C) Function						5-21-91	DH
660	Pack						6-18-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6091510
DATE 5-9-97
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.46	2.78	2.30	MIN. SETTING,
PULL #2	2.52	2.57	2.82	2.28	NO AVG. OF 5
PULL #3	2.47	2.47	2.74	2.41	READINGS ACCEPT-
PULL #4	2.48	2.54	2.78	2.38	ABLE LESS THAN 2#
PULL #5	2.48	2.54	2.75	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS	
PULL #1	3.12	2.97		
PULL #2	3.09	2.96		
PULL #3	3.10	2.97		
PULL #4	3.05	2.97		
PULL #5	3.05	2.97		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	4.08		4.07
PULL #2	4.03	4.07		4.09
PULL #3	3.99	4.05		4.06
PULL #4	3.97	4.09		3.90
PULL #5	4.00	4.05		4.10
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611510
13 May 1991

CENTROIDAL DISTANCES

0 TO 1	.332704
1 TO 2	.915419
1 TO 3	.631542
1 TO 4	.628784
1 TO 5	.740532

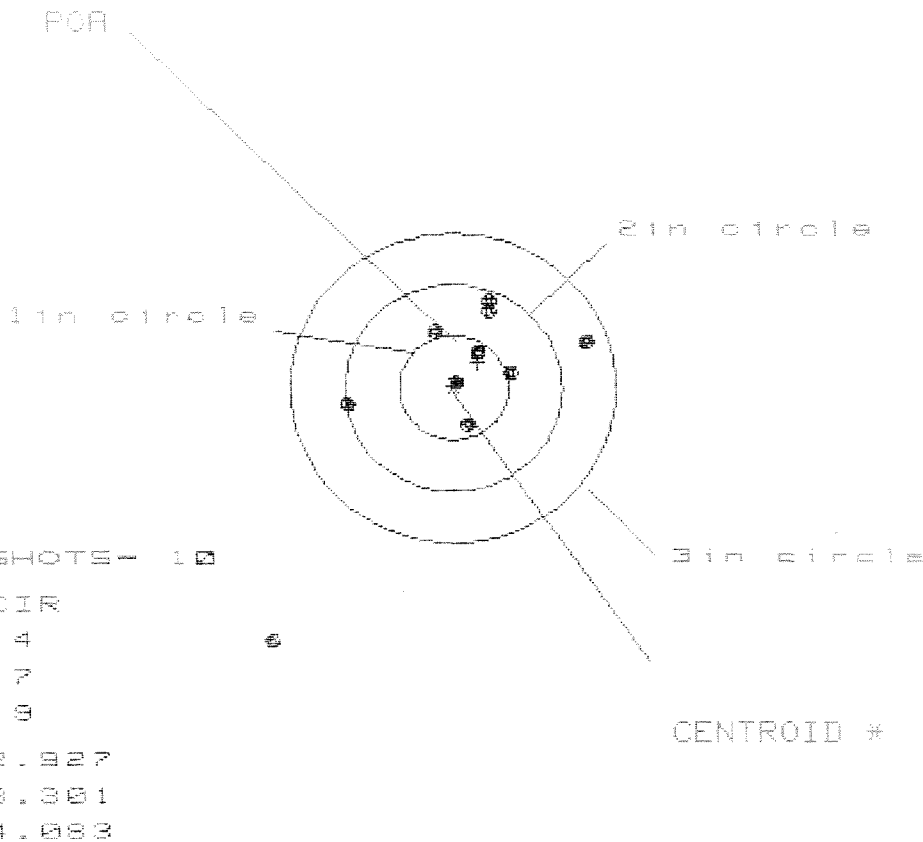
$\frac{5}{1} + 2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1456
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1816
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .232761
THE AMR FOR THIS RIFLE IS: 1.082

15 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6611510

CENTERFIRE PATTERNS # 1

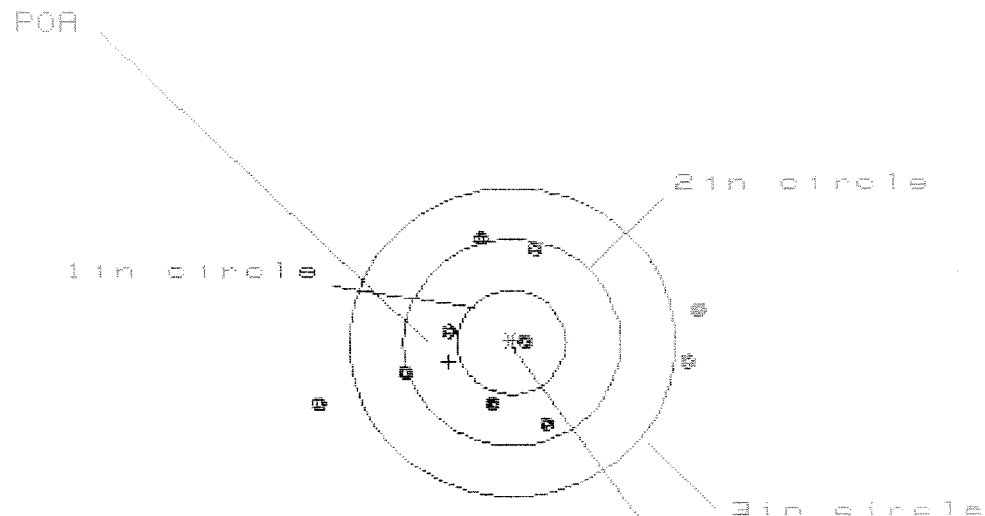


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.268	1.084	.429
MINIMUM X	-1.659	-1.173	-1.038
MAXIMUM Y	.855	.593	.599
MINIMUM Y	-2.446	-.661	-.645
CENTROID X	-.224	-.040	-.175
CENTROID Y	-.246	.026	.010
POA TO CENTROID in.	.333	.047	.176
MIN RADIUS	.089	.071	.171
MEAN RADIUS	.892	.570	.514
MAX RADIUS	2.956	1.258	1.125
HORIZONTAL SPREAD	2.927	2.257	1.457
VERTICAL SPREAD	3.381	1.244	1.244
EXTREME SPREAD	4.083	2.331	1.650
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

13 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.492

VS= 1.837

GS= 3.595

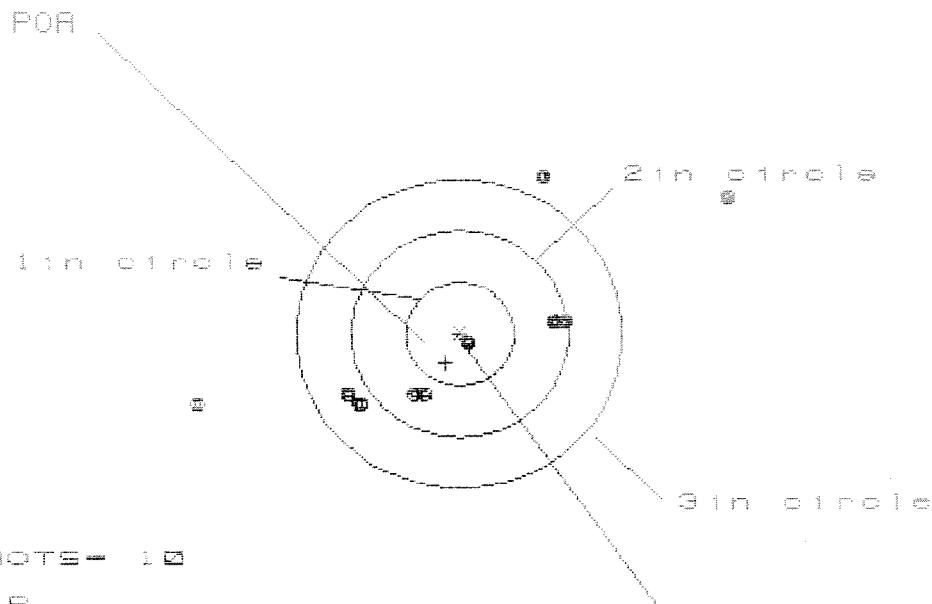
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.674	1.472	1.552
MINIMUM X	:	-1.818	-1.182	-1.998
MAXIMUM Y	:	1.034	.973	1.005
MINIMUM Y	:	-.803	-.864	-.832
CENTROID X	:	.582	.784	.600
CENTROID Y	:	.188	.249	.217
POA TO CENTROID in.	:	.612	.823	.638
MIN RADIUS	:	.119	.097	.091
MEAN RADIUS	:	1.047	.960	.859
MAX RADIUS	:	1.898	1.493	1.566
HORIZONTAL SPREAD	:	3.492	2.654	2.550
VERTICAL SPREAD	:	1.837	1.837	1.837
EXTREME SPREAD	:	3.595	2.732	2.555
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

13 May 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 4.9003

VS = 2.212

GS = 5.275

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.452	1.213	.941
MINIMUM X	-2.451	-2.178	-.979
MAXIMUM Y	1.564	1.708	1.645
MINIMUM Y	-.648	-.504	-.556
CENTROID X	.130	-.143	.129
CENTROID Y	.277	.133	.196
POA TO CENTROID in.	.306	.195	.235
MIN RADIUS	.075	.359	.086
MEAN RADIUS	1.262	1.066	.901
MAX RADIUS	2.774	2.236	1.803
HORIZONTAL SPREAD	4.903	3.391	1.920
VERTICAL SPREAD	2.212	2.212	2.201
EXTREME SPREAD	5.275	3.880	2.770
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

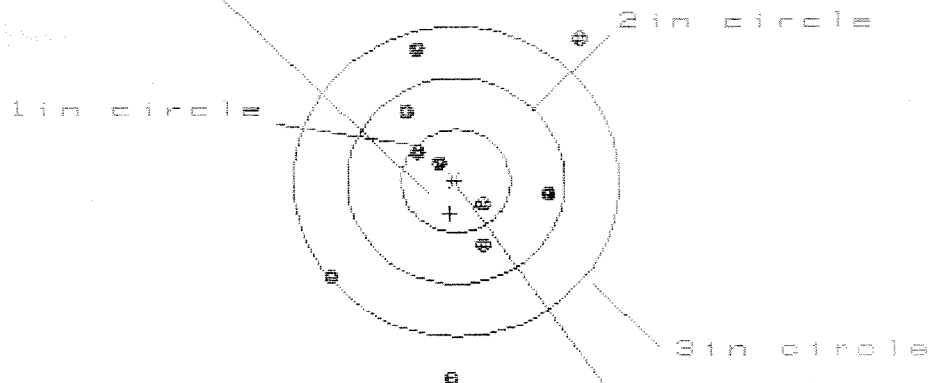
13 May 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 8

HS = 2.338

VS = 3.234

GS = 3.445

CENTROID *

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.170

1.168

.951

MINIMUM X

:

-1.168

-1.170

-1.024

MAXIMUM Y

:

1.334

1.123

1.243

MINIMUM Y

:

-1.900

-1.097

-.957

CENTROID X

:

.056

.058

-.089

CENTROID Y

:

.317

.528

.388

POA TO CENTROID in.

:

.322

.531

.398

MIN RADIUS

:

.221

.151

.098

MEAN RADIUS

:

.981

.865

.750

MAX RADIUS

:

1.900

1.621

1.401

HORIZONTAL SPREAD

:

2.338

2.338

1.974

VERTICAL SPREAD

:

3.234

2.220

2.200

EXTREME SPREAD

:

3.445

3.224

2.360

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

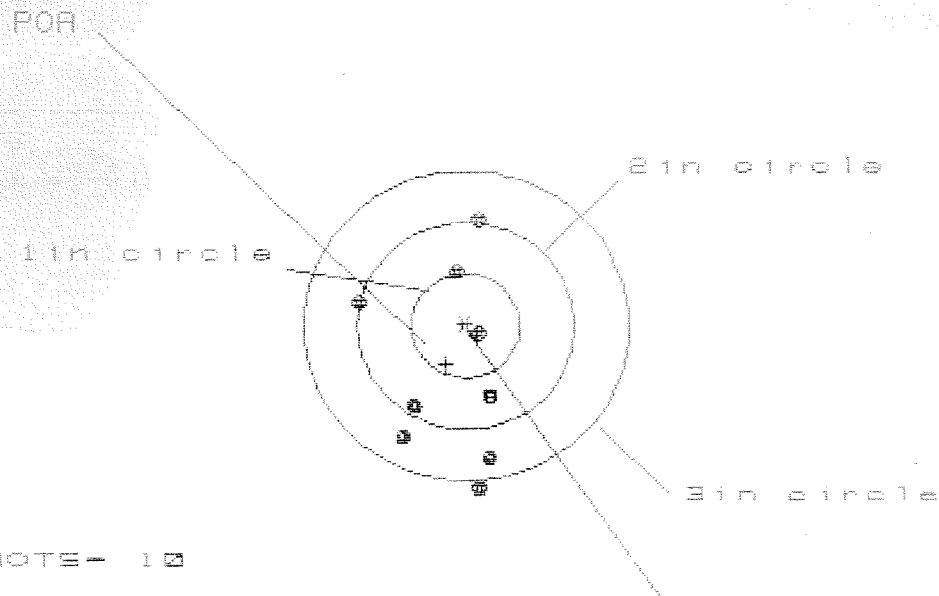
NUMBER IN THREE INCH CIRCLE =

8

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CENTERFIRE PATTERN# # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.303

VS= 5.255

GS= 5.399

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.351	.378	.410
MINIMUM X	:	-.952	-.801	-.768
MAXIMUM Y	:	3.655	1.460	1.310
MINIMUM Y	:	-1.600	-1.193	-.989
CENTROID X	:	.184	.033	.000
CENTROID Y	:	.372	-.035	.115
POR TO CENTROID in.	:	.414	.048	.115
MIN RADIUS	:	.122	.418	.345
MEAN RADIUS	:	1.228	.858	.814
MAX RADIUS	:	3.897	1.492	1.355
HORIZONTAL SPREAD	:	2.303	1.179	1.179
VERTICAL SPREAD	:	5.255	2.653	2.299
EXTREME SPREAD	:	5.399	2.653	2.300
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	