

C6587639

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smith




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

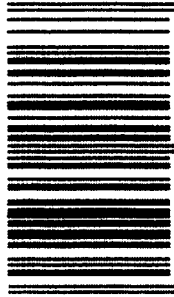
MODEL 700™ M24	SERIAL NO. C6587639
46	ORDER NO. 5716

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



5716 C6587639

UPC



0 47700 25716 7

M-24
CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587639

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	U
615	Rollmark Caliber	3 28	91	YB
617	Drill and Tap Sight Holes	APR	3 1991	LB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	RW
	C) Inspect Ejector Hole for Chamfer		4/16/91	RW
	D) Oil Firing Pin Ass'y		4/16/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/6/91	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5/6/91	JK
	G) Safety Off Force	4	4	4			5/6/91	JK
	H) Trigger Pull Test & Retainability						5/6/91	JK
	I) Firing Pin Indent	.022	.022	.022			5/6/91	JK
	J) Assemble Stock						5/6/91	RW
	K) Assemble Swivel Studs						5-9-91	AC
	L) Attach Front and Rear Sight Assemblies						5/6/91	RW
	M) Iron Sight Alignment						5/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/6/91	RW
	O) Attach Scope to Rifle						5/6/91	RW
	P) Detach & Attach Scope 20 Times						5/6/91	RW
640	Gallery Target & Test						5/6/91	K-T
	A) Time						"	K-T
	B) Malfunctions						"	K-T
	C) Pierced Primers						"	K-T
	D) Optical Clarity of Scope						"	K-T
645	Inspect for Live Ammo						5/6/91	K-T
655	Final Inspection							
	A) Headspace						5-9-91	AC
	B) Trigger Pull	2.42	2.46	2.46	2.46	2.47	5/9/91	JK
	C) Function						5-9-91	AC
660	Pack						6-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6587639

DATE 5/6/91

TESTER JLP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.47	2.42	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.42	2.43	2.46	
PULL #3	2.30	2.46	2.36	2.46	
PULL #4	2.50	2.37	2.40	2.46	
PULL #5	2.57	2.39	2.40	2.47	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.18		
PULL #2	3.36	3.18		
PULL #3	3.25	3.19		
PULL #4	3.22	3.17		
PULL #5	3.20	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.46		4.50
PULL #2	4.62	4.53		4.39
PULL #3	4.64	4.63		4.62
PULL #4	4.58	4.50		4.54
PULL #5	4.46	4.59		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587639
6 May 1991

CENTROIDAL DISTANCES

0 TO	1	.319495
1 TO	2	.282144
1 TO	3	.491709
1 TO	4	.340037
1 TO	5	.236476

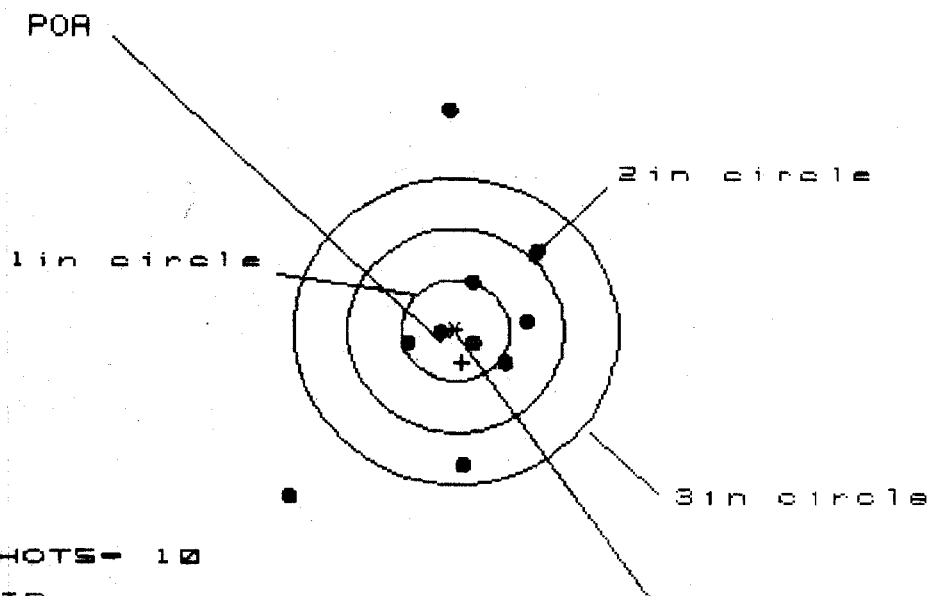
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13 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1226
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1382
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .184743
THE AMR FOR THIS RIFLE IS: .904

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587633

CENTERFIRE PATTERNS # 1



* OF SHOTS = 10

* IN CIR

1 in = 4

2 in = 6

3 in = 8

HS = 2.311

VS = 3.737

GS = 4.047

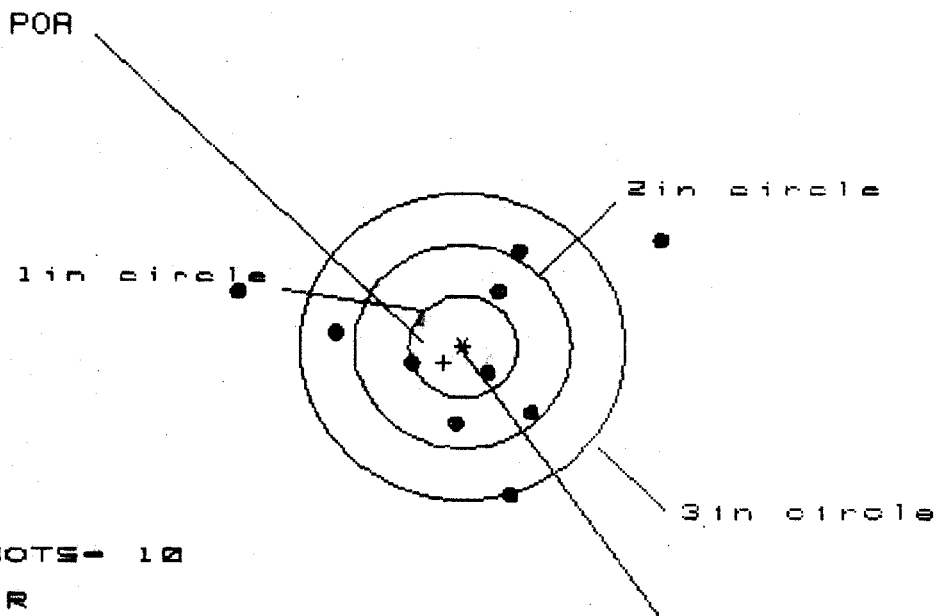
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.739	.564	.540
MINIMUM X	:	-1.572	-.630	-.654
MAXIMUM Y	:	2.151	1.974	.886
MINIMUM Y	:	-1.587	-1.506	-1.259
CENTROID X	:	-.059	.116	.140
CENTROID Y	:	.314	.490	.243
POR TO CENTROID in.	:	.319	.503	.280
MIN RADIUS	:	.185	.272	.101
MEAN RADIUS	:	.941	.792	.607
MAX RADIUS	:	2.233	1.984	1.268
HORIZONTAL SPREAD	:	2.311	1.194	1.194
VERTICAL SPREAD	:	3.737	3.480	2.145
EXTREME SPREAD	:	4.047	3.481	2.254
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587639

CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

* IN CIR

1 in 2

2 in 5

3 in 7

MEAN 2.986

VS 2.531

CS 3.936

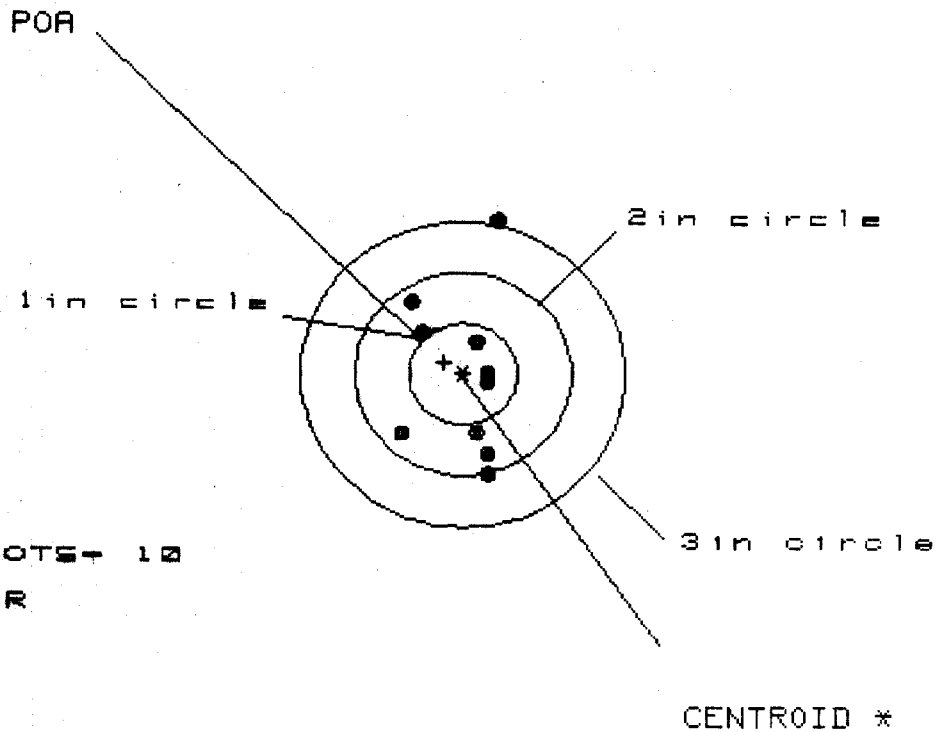
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.810	1.577	.588
MINIMUM X	:	-2.097	-1.441	-1.244
MAXIMUM Y	:	1.067	1.131	1.170
MINIMUM Y	:	-1.464	-1.400	-1.258
CENTROID X	:	.172	.404	.207
CENTROID Y	:	.152	.088	-.054
POA TO CENTROID in.	:	.229	.414	.214
MIN RADIUS	:	.382	.228	.227
MEAN RADIUS	:	1.133	.997	.847
MAX RADIUS	:	2.175	1.941	1.307
HORIZONTAL SPREAD	:	3.906	3.018	1.832
VERTICAL SPREAD	:	2.531	2.531	2.428
EXTREME SPREAD	:	3.936	3.142	2.431
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587639

CENTERFIRE PATTERNS # 3



* OF SHOTS = 10

* IN CIR

1 in = 3

2 in = 9

3 in = 9

HM = .871

VS = 2.479

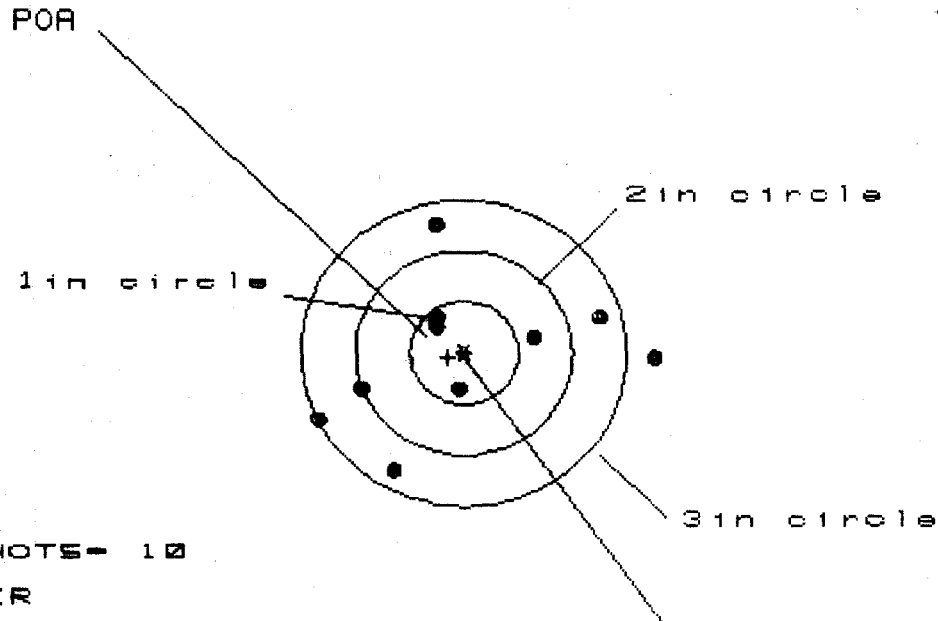
GS = 2.483

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.318	.245	.272
MINIMUM X	-.553	-.518	-.491
MAXIMUM Y	1.509	.868	.767
MINIMUM Y	-.970	-.802	-.683
CENTROID X	.174	.139	.112
CENTROID Y	-.119	-.287	-.186
POR TO CENTROID in.	.211	.318	.217
MIN RADIUS	.207	.223	.244
MEAN RADIUS	.687	.587	.552
MAX RADIUS	1.542	.982	.881
HORIZONTAL SPREAD	.871	.763	.763
VERTICAL SPREAD	2.479	1.670	1.450
EXTREME SPREAD	2.483	1.802	1.610
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		9	

6 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587639

CENTERFIRE PATTERNS # 4



* OF SHOTS - 10
 * IN CIR
 1 in = 3
 2 in = 5
 3 in = 8
 H = 3.064
 VS = 2.463
 GS = 3.132

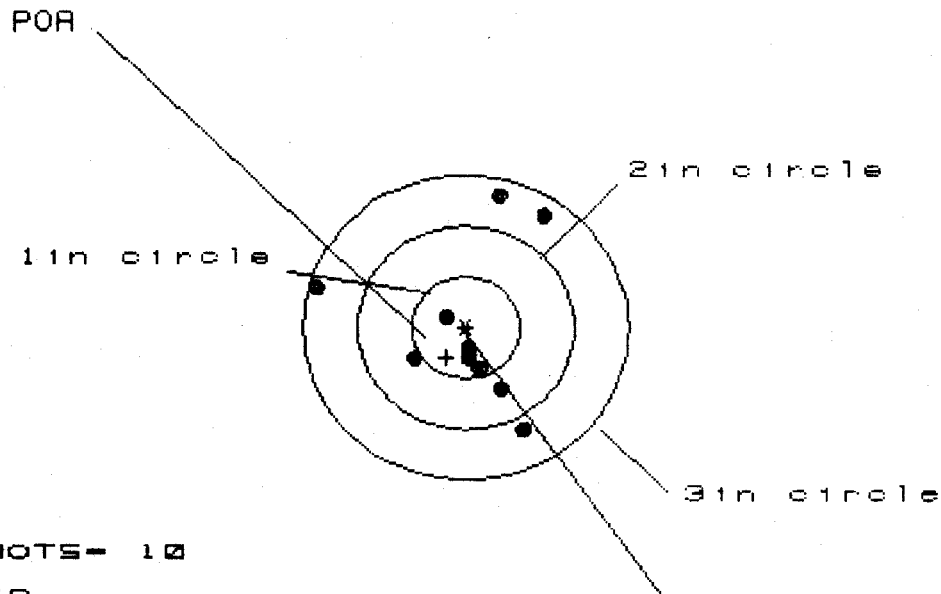
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.703	1.456	1.310
MINIMUM X	-1.361	-1.172	-.895
MAXIMUM Y	1.299	1.296	1.212
MINIMUM Y	-1.164	-1.167	-1.251
CENTROID X	.149	-.040	.106
CENTROID Y	.045	.048	.132
POA TO CENTROID in.	.156	.062	.170
MIN RADIUS	.322	.280	.269
MEAN RADIUS	.997	.897	.831
MAX RADIUS	1.703	1.505	1.375
HORIZONTAL SPREAD	3.064	2.628	2.205
VERTICAL SPREAD	2.463	2.463	2.463
EXTREME SPREAD	3.132	2.833	2.498
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

6 May 1991

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CENTERFIRE PATTERNS # 5



* OF SHOTS- 10
 * IN CIR
 1in = 4
 2in = 6
 3in = 10
 HS= 2.116
 VS= 2.329
 GS= 2.349

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.749	.597	.622
MINIMUM X	:	-1.367	-.655	-.630
MAXIMUM Y	:	1.295	1.335	1.282
MINIMUM Y	:	-1.034	-.994	-.828
CENTROID X	:	.177	.329	.304
CENTROID Y	:	.299	.259	.093
POA TO CENTROID in.	:	.348	.419	.318
MIN RADIUS	:	.203	.228	.134
MEAN RADIUS	:	.762	.691	.544
MAX RADIUS	:	1.414	1.350	1.425
HORIZONTAL SPREAD	:	2.116	1.252	1.252
VERTICAL SPREAD	:	2.329	2.329	2.109
EXTREME SPREAD	:	2.349	2.335	2.121
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	