

C6649040

MODEL 700™ M24

Model **SMS**™

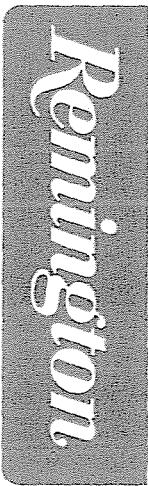
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



Smith

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.



5716 C6649040

SERIAL NO.
C6649040

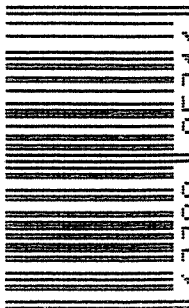
ORDER NO.
5716



5716 C6649040

20

UPC



0 47700 25716 2

GUN SERIAL # C6649040

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		RW
600	Proof	7 2 9 1		RW
607	Check Headspace	7 2 9 1		RW
610	Dis-assemble Gun	7 2 9 1		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-2-91	LS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-20-91	JU

Op. #	Op. NAME	READINGS						
625 cont.	F) Safety On Force	5	5	5			8/20/91	RM
	G) Safety Off Force	4	4	4			8/20/91	RM
	H) Trigger Pull Test & Retainability						8/20/91	RM
	I) Firing Pin Indent	.022	.0215	.0215			8/20/91	RM
	J) Assemble Stock						8/20/91	RW
	K) Assemble Swivel Studs						8-22-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/20/91	RW
	M) Iron Sight Alignment						8/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/20/91	RW
	O) Attach Scope to Rifle						8/20/91	RW
	P) Detach & Attach Scope 20 Times						8/20/91	RW
640	Gallery Target & Test						8-21-91	AC
	A) Time						8-21-91	AC
	B) Malfunctions						8-21-91	AC
	C) Pierced Primers						8-21-91	AC
	D) Optical Clarity of Scope						8-21-91	AC
645	Inspect. for Live Ammo						8-21-91	AC
655	Final Inspection							
	A) Headspace						8-22-91	D/H
	B) Trigger Pull	260	257	236	257	240	8-21-91	D/H
	C) Function						8-22-91	D/H
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6649040

DATE 8-20-91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.14	2.30	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.32	2.40	2.57	
PULL #3	2.17	2.26	2.22	2.36	
PULL #4	2.19	2.27	2.30	2.57	
PULL #5	2.19	2.25	2.28	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.40		
PULL #2	3.36	3.35		
PULL #3	3.35	3.38		
PULL #4	3.38	3.37		
PULL #5	3.37	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.33	4.40		4.33
PULL #2	4.26	4.34		4.31
PULL #3	4.30	4.30		4.35
PULL #4	4.33	4.30		4.34
PULL #5	4.38	4.34		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649040
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.325712
1 TO	2	.171047
1 TO	3	.184329
1 TO	4	.446643
1 TO	5	.251321

453 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0506
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .211541
THE AMR FOR THIS RIFLE IS: .9458

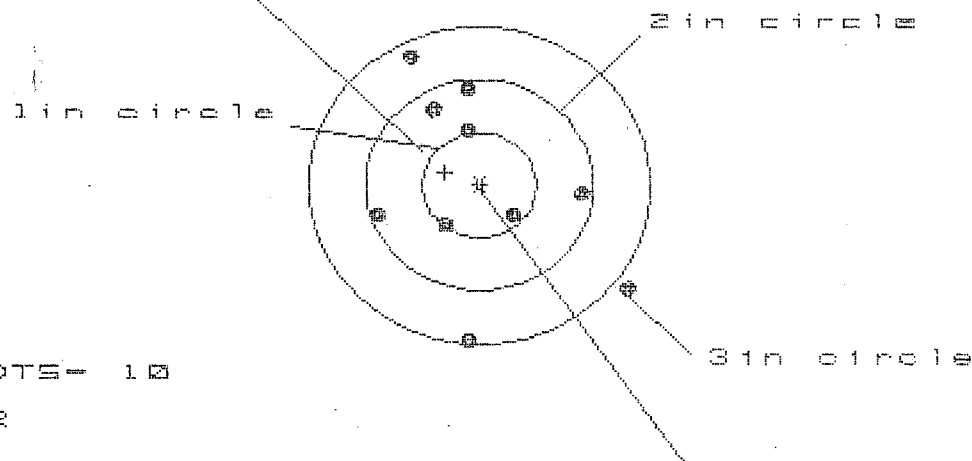
22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649040

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.239

VS= 2.672

GS= 2.962

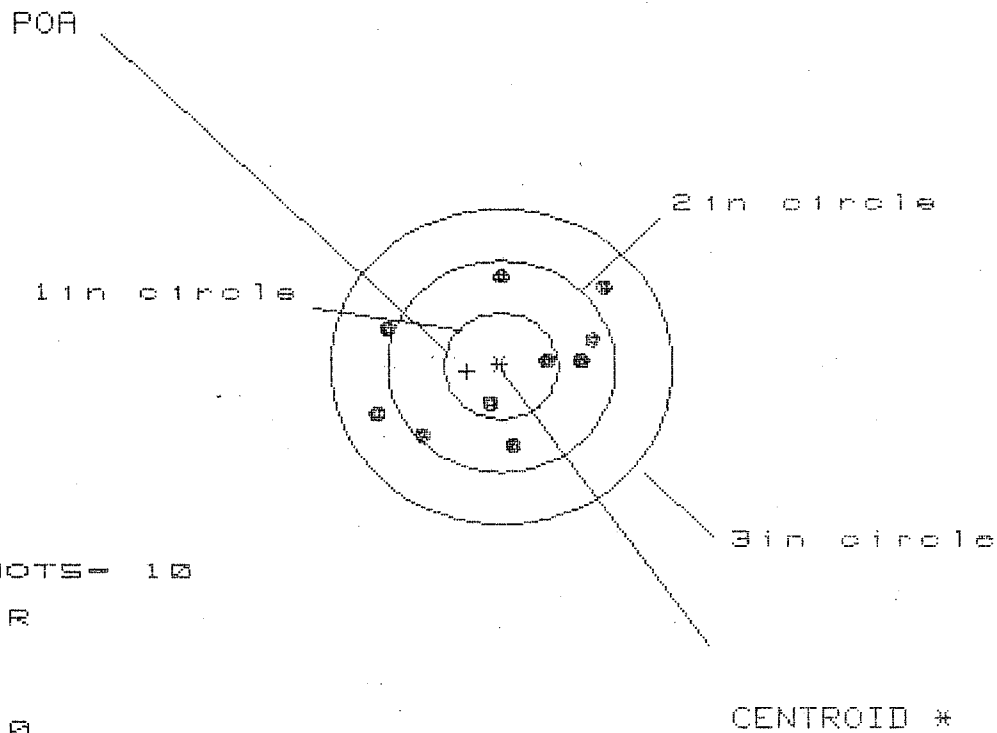
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.031	1.040
MINIMUM X	:	-.898	-.749	-.740
MAXIMUM Y	:	1.214	1.105	.909
MINIMUM Y	:	-1.458	-1.567	-.649
CENTROID X	:	.302	.153	.144
CENTROID Y	:	-.122	-.013	.183
POA TO CENTROID in.	:	.325	.153	.233
MIN RADIUS	:	.407	.398	.207
MEAN RADIUS	:	.951	.852	.729
MAX RADIUS	:	1.663	1.569	1.126
HORIZONTAL SPREAD	:	2.239	1.780	1.780
VERTICAL SPREAD	:	2.672	2.672	1.558
EXTREME SPREAD	:	2.962	2.732	2.032
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.043

VS= 1.616

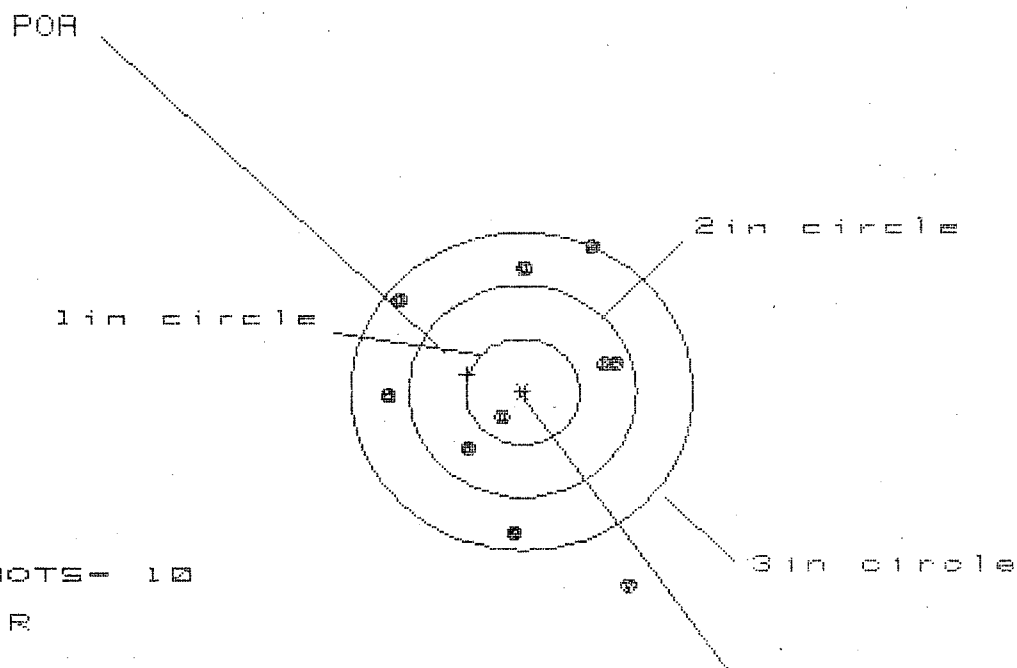
GS= 2.363

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.898	.771	.816
MINIMUM X	-1.145	-1.115	-1.019
MAXIMUM Y	.831	.782	.870
MINIMUM Y	-.785	-.834	-.746
CENTROID X	.298	.425	.329
CENTROID Y	.049	.097	.009
POA TO CENTROID in.	.302	.436	.329
MIN RADIUS	.378	.254	.350
MEAN RADIUS	.841	.778	.745
MAX RADIUS	1.225	1.162	1.100
HORIZONTAL SPREAD	2.043	1.886	1.835
VERTICAL SPREAD	1.616	1.616	1.616
EXTREME SPREAD	2.363	2.138	1.837
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

22 Aug 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.147

VS= 3.239

GS= 3.342

CENTROID *

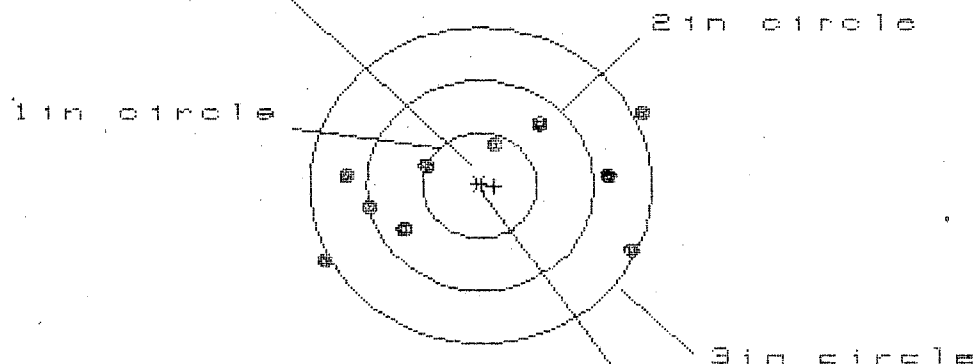
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.926	.890	.977
MINIMUM X	-1.221	-1.118	-1.031
MAXIMUM Y	1.383	1.177	1.147
MINIMUM Y	-1.856	-1.530	-1.383
CENTROID X	.481	.378	.291
CENTROID Y	-.166	.040	-.107
POR TO CENTROID in.	.508	.380	.310
MIN RADIUS	.319	.470	.315
MEAN RADIUS	1.132	1.023	.957
MAX RADIUS	2.075	1.531	1.389
HORIZONTAL SPREAD	2.147	2.008	2.008
VERTICAL SPREAD	3.239	2.707	2.530
EXTREME SPREAD	3.342	2.785	2.530
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

22 Aug 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.771

VS= 1.418

GS= 3.113

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.522	1.375
MINIMUM X	:	-1.334	-1.174	-1.168
MAXIMUM Y	:	.698	.675	.595
MINIMUM Y	:	-.720	-.643	-.628
CENTROID X	:	-.125	-.285	-.138
CENTROID Y	:	.009	-.068	.012
POA TO CENTROID in.	:	.125	.293	.138
MIN RADIUS	:	.409	.374	.409
MEAN RADIUS	:	1.033	.948	.900
MAX RADIUS	:	1.597	1.617	1.511
HORIZONTAL SPREAD	:	2.771	2.696	2.543
VERTICAL SPREAD	:	1.418	1.318	1.223
EXTREME SPREAD	:	3.113	2.698	2.631
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

22 Aug 1991

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.423

VS= 2.178

GS= 2.184

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.652	.655	.687
MINIMUM X	-.771	-.768	-.686
MAXIMUM Y	1.006	.876	.962
MINIMUM Y	-1.172	-.744	-.658
CENTROID X	.071	.068	-.014
CENTROID Y	-.023	.107	.021
POA TO CENTROID in.	.075	.127	.025
MIN RADIUS	.234	.110	.226
MEAN RADIUS	.772	.711	.686
MAX RADIUS	1.173	.949	.999
HORIZONTAL SPREAD	1.423	1.423	1.373
VERTICAL SPREAD	2.178	1.620	1.620
EXTREME SPREAD	2.184	1.800	1.678
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	