

C6636052

MODEL 700TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Smith




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

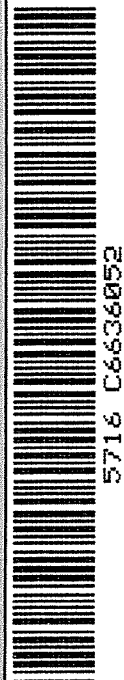
MODEL 700TM H24

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

SERIAL NO.
C6636052

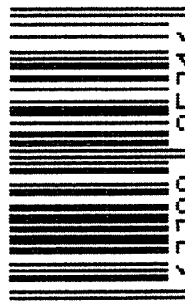
ORDER NO.
5716

20



5716 C6636052

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636052

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		WCB
615	Rollmark Caliber	5 8 9 1		GB
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5/21/91	TH
	Apply Coating (Bolt)		5/21/91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		6/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/10/91	KS
	C) Inspect Ejector Hole for Chamfer		6/10/91	KS
	D) Oil Firing Pin Ass'y		6/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-11-91	SL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7	7			6-11-91	JS
	G) Safety Off Force	4	4	4			6-11-91	JS
	H) Trigger Pull Test & Retainability						6-11-91	JS
	I) Firing Pin Indent	.022	.022	.022			6-11-91	JS
	J) Assemble Stock						6/11/91	KS
	K) Assemble Swivel Studs						6-13-91	K
	L) Attach Front and Rear Sight Assemblies						6/11/91	KS
	M) Iron Sight Alignment						6/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						6/11/91	KS
	O) Attach Scope to Rifle						6/11/91	KS
	P) Detach & Attach Scope 20 Times						6/11/91	KS
640	Gallery Target & Test						6/11/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/11/91	KT
655	Final Inspection							
	A) Headspace						6-13-91	K
	B) Trigger Pull	2.27	2.31	2.30	2.33	2.31	6-13-91	JS
	C) Function						6-13-91	K
660	Pack						6-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636052

DATE 6-11-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.29	2.44	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.28	2.35	2.31	
PULL #3	2.26	2.28	2.38	2.30	
PULL #4	2.20	2.25	2.44	2.33	
PULL #5	2.25	2.27	2.39	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.59		
PULL #2	3.41	3.59		
PULL #3	3.20	3.51		
PULL #4	3.41	3.56		
PULL #5	3.45	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	4.50	4.20		4.57
PULL #2	4.49	4.49		4.52
PULL #3	4.39	4.18		4.30
PULL #4	4.44	4.36		4.56
PULL #5	4.25	4.49		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636052
12 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.160331
1 TO	2	.384246
1 TO	3	.2249
1 TO	4	.0902109
1 TO	5	.586674

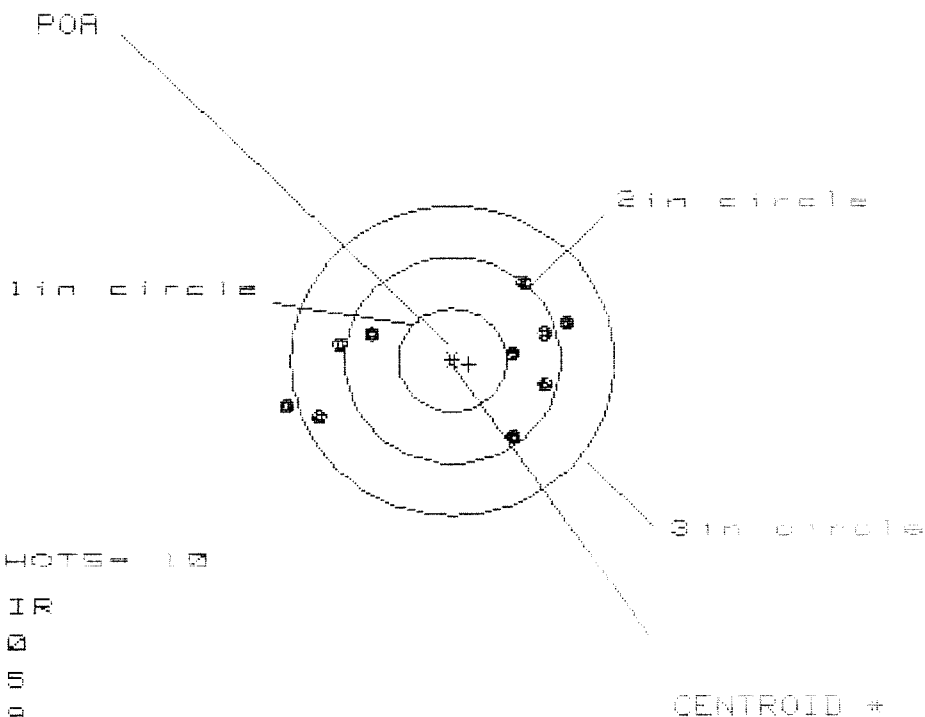
$\frac{4}{3}\pi r^3$ <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .003
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0656
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0656666
THE AMR FOR THIS RIFLE IS: .9488

11 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636052

CENTERFIRE PATTERNS # 1



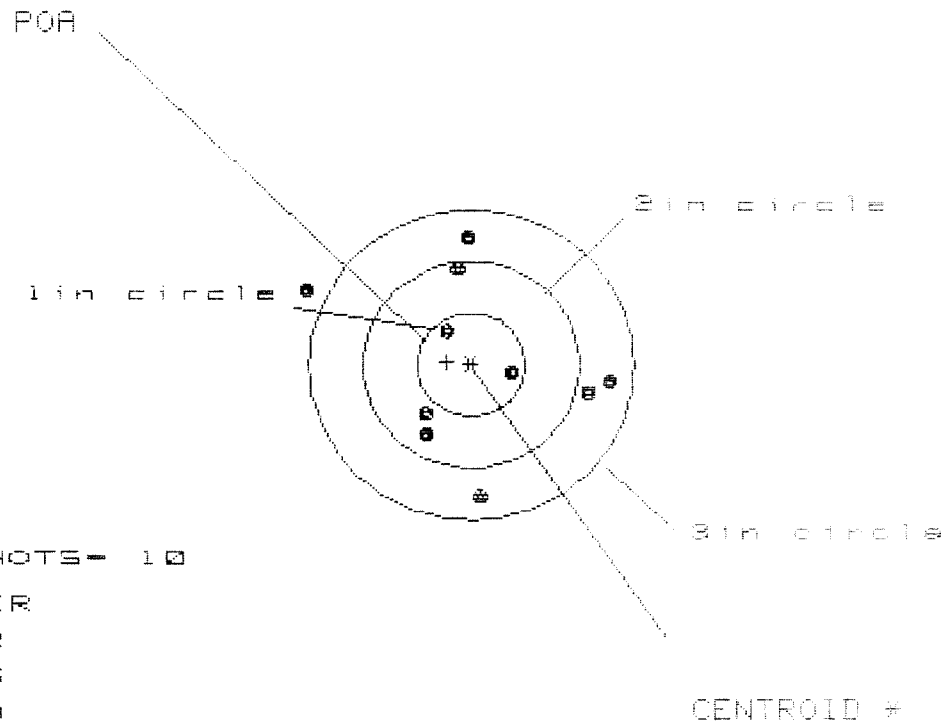
OF SHOTS = 10
 # IN CIR
 1 in = 0
 2 in = 5
 3 in = 9
 HS = 2.579
 VS = 1.502
 GS = 2.716

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.052	.882	.705
MINIMUM X	-1.527	-1.412	-1.428
MAXIMUM Y	.799	.746	.677
MINIMUM Y	-.703	-.756	-.825
CENTROID X	-.155	.015	.192
CENTROID Y	.041	.094	.163
POR TO CENTROID in.	.160	.095	.251
MIN RADIUS	.534	.365	.211
MEAN RADIUS	1.020	.914	.780
MAX RADIUS	1.600	1.515	1.429
HORIZONTAL SPREAD	2.579	2.294	2.133
VERTICAL SPREAD	1.502	1.502	1.502
EXTREME SPREAD	2.716	2.454	2.141
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

11 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.772

VS= 2.537

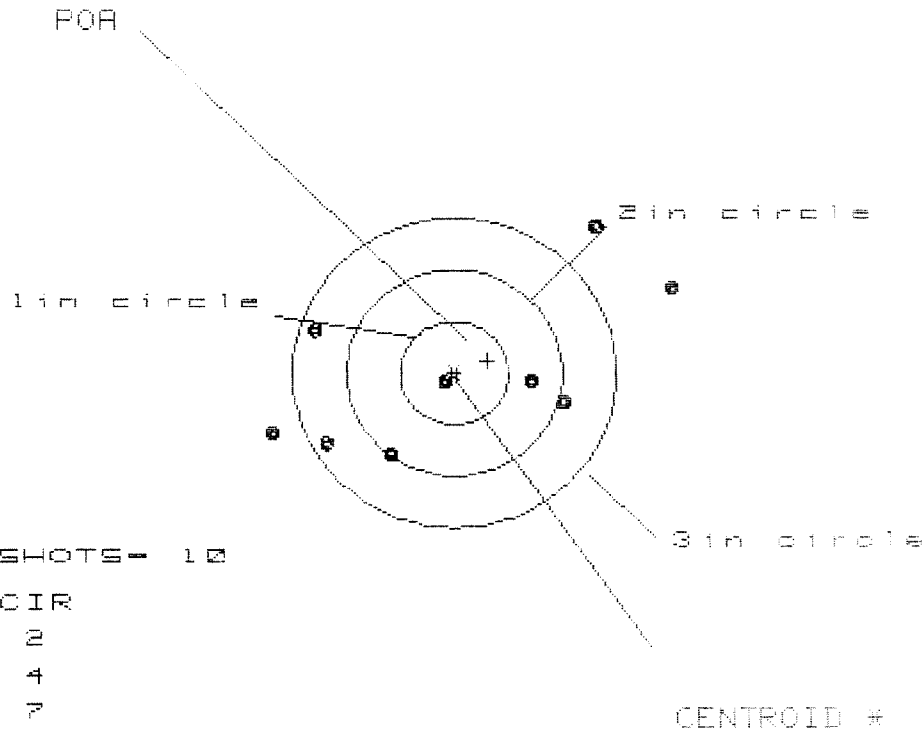
GS= 2.924

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.236	1.066	1.054
MINIMUM X	:	-1.536	-1.620	-1.632
MAXIMUM Y	:	1.220	1.300	1.146
MINIMUM Y	:	-1.317	-1.237	-1.790
CENTROID X	:	.223	.394	.406
CENTROID Y	:	-.028	-.108	.046
POA TO CENTROID in.	:	.225	.409	.489
MIN RADIUS	:	.348	.165	.227
MEAN RADIUS	:	.968	.870	.820
MAX RADIUS	:	1.696	1.314	1.163
HORIZONTAL SPREAD	:	2.772	1.686	1.686
VERTICAL SPREAD	:	2.537	2.537	1.936
EXTREME SPREAD	:	2.924	2.539	1.983
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10
 # IN CIR
 1 in = 2
 2 in = 4
 3 in = 7
 HS= 3.733
 VS= 2.281
 GS= 3.964

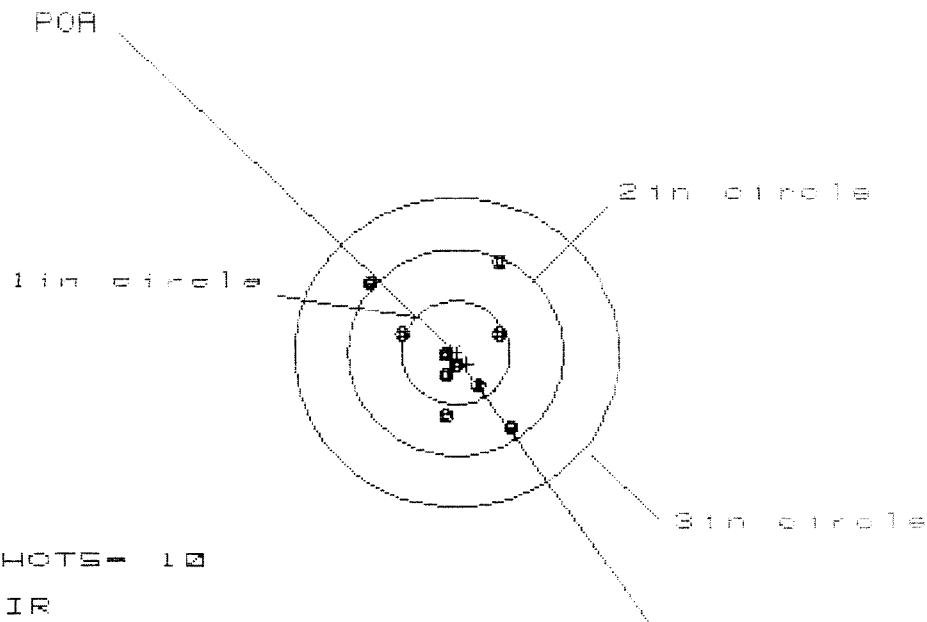
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.027	1.502	1.429
MINIMUM X	:	-1.706	-1.481	-1.293
MAXIMUM Y	:	1.455	1.541	.690
MINIMUM Y	:	-.826	-.740	-.547
CENTROID X	:	-.311	-.536	-.724
CENTROID Y	:	-.121	-.207	-.400
POA TO CENTROID in.	:	.334	.575	.827
MIN RADIUS	:	.078	.099	.358
MEAN RADIUS	:	1.170	1.040	.911
MAX RADIUS	:	2.172	2.152	1.429
HORIZONTAL SPREAD	:	3.733	2.983	2.722
VERTICAL SPREAD	:	2.281	2.281	1.237
EXTREME SPREAD	:	3.964	3.595	2.733
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Jun 1981

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CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 6

2in = 9

3in = 10

HS = 1.279

VS = 1.644

GS = 1.964

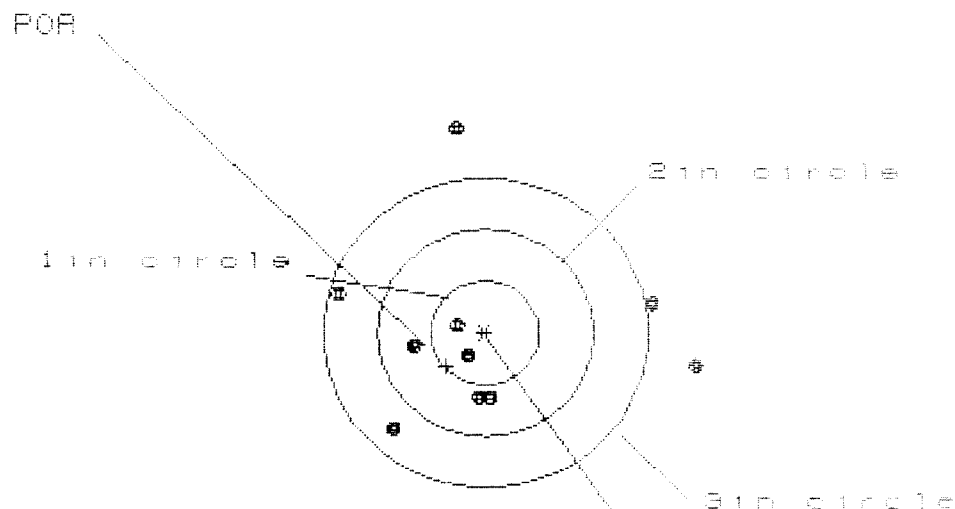
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.518	.433	.473
MINIMUM X	:	-.761	-.547	-.507
MAXIMUM Y	:	.888	.969	.7425
MINIMUM Y	:	-.756	-.675	-.553
CENTROID X	:	-.102	-.017	-.057
CENTROID Y	:	.114	.033	-.089
POA TO CENTROID in.	:	.153	.037	.105
MIN RADIUS	:	.123	.097	.093
MEAN RADIUS	:	.539	.474	.385
MAX RADIUS	:	1.057	1.019	.728
HORIZONTAL SPREAD	:	1.279	.980	.980
VERTICAL SPREAD	:	1.644	1.644	.978
EXTREME SPREAD	:	1.964	1.648	1.339
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

11 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.290

VS= 2.867

GS= 3.352

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.922	1.890	1.774
MINIMUM X	:	-1.368	-1.400	-1.163
MAXIMUM Y	:	1.969	.583	.576
MINIMUM Y	:	-1.898	-.680	-.687
CENTROID X	:	.360	.392	.155
CENTROID Y	:	.322	.103	.110
POR TO CENTROID in.	:	.483	.405	.191
MIN RADIUS	:	.234	.185	.056
MEAN RADIUS	:	1.047	.901	.715
MAX RADIUS	:	1.989	1.891	1.839
HORIZONTAL SPREAD	:	3.290	3.290	2.937
VERTICAL SPREAD	:	2.867	1.263	1.263
EXTREME SPREAD	:	3.352	3.352	2.933
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		