

C6348982

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smith
Smith
®

Remington[®] **DUPONT**[®]
REG. U.S. PAT. & TM. OFF.

MODEL 700TM H24

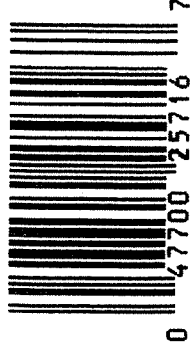
VERY IMPORTANT:
 Instruction Book
 enclosed to assure
 safe use of this
 firearm.

SERIAL NO. C6348982	Ø1
ORDER NO. 5716	

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



UPC



RC-20
Replaced

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348982

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	12-20	89	RW
600	Proof	12-20	89	F
607	Check Headspace	12-20	89	F
610	Dis-assemble Gun	12-20	89	RW
612	Magnaflux Barrel Action	1-5-90		KCR
	Magnaflux Bolt	1-5-90		
615	Rollmark Caliber		1/8/90	GS
617	Drill and Tap Sight Holes		1/10/90	FB
618	Polish Barrel <i>RB</i>		1/10/90	WB
620	Apply Coatings (Barrel Action)		1-5-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/25/90	RW
	C) Inspect Ejector Hole for Chamfer		1/25/90	RW
	D) Oil Firing Pin Ass'y		1/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/5/90	JS

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	5	5	5		1-25-90	JK
	G) Safety Off Force	3	3	3		1-25-90	JK
	H) Trigger Pull Test & Retainability					25 Jan 90	JD
	I) Firing Pin Indent	.023	.023	.023		1-25-90	JK
	J) Assemble Stock					2-26-90	K
	K) Assemble Swivel Studs					3/15/90	WB
	L) Attach Front and Rear Sight Assemblies					2-26-90	K
	M) Iron Sight Alignment					2-26-90	K
	N) Detach Front & Rear Sights & place in numbered container					2-26-90	AC
	O) Attach Scope to Rifle					4/27/90	WB
	P) Detach & Attach Scope 20 Times					4/27/90	WB
640	Gallery Target & Test					2-27-90	K
	A) Time					11	A
	B) Malfunctions					11	A
	C) Pierced Primers					11	A
	D) Optical Clarity of Scope					11	A
645	Inspect for Live Ammo					2-27-90	K
655	Final Inspection						
	A) Headspace					15 Mar 90	JD
	B) Trigger Pull	236	253	244	227	236	15 Mar 90
	C) Function					15 Mar 90	JD
660	Pack					16 Mar 90	JD

SWS TRIGGER PULL TEST

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

SERIAL NO. C6348982
DATE 25 Jan 90
TESTER JED

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.15	2.21	2.67	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.14	2.49	2.53	
PULL #3	2.21	2.18	2.26	2.44	
PULL #4	2.06	2.11	2.29	2.27	
PULL #5	2.15	2.35	2.13	2.36	
TOTAL	10.80	11.26	11.84	11.96	
AVG.	2.16	2.252	2.368	2.392	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	2.88	3.10		
PULL #2	3.07	2.95		
PULL #3	3.07	2.84		
PULL #4	3.05	2.94		
PULL #5	2.95	2.95		
TOTAL	15.02	14.73		
AVG.	3.004	2.946		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.12		4.09
PULL #2	4.18	4.04		4.14
PULL #3	4.06	4.03		3.73
PULL #4	4.03	3.65		3.85
PULL #5	3.95	3.91		3.81
TOTAL	20.34	19.75		19.52
AVG.	4.068	3.95		3.904

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348982
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.287868
1 TO	2	.23579
1 TO	3	.160801
1 TO	4	.197124
1 TO	5	.30104

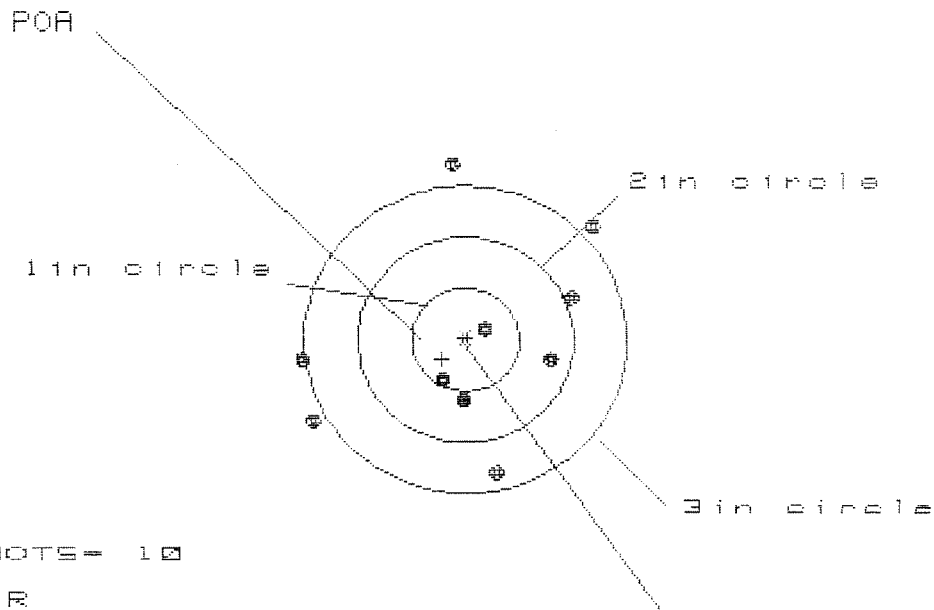
$\frac{2.3}{3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1256
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1606
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .203882
THE AMR FOR THIS RIFLE IS: 1.055

27 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63489B2

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 2.682

VS= 2.990

GS= 3.248

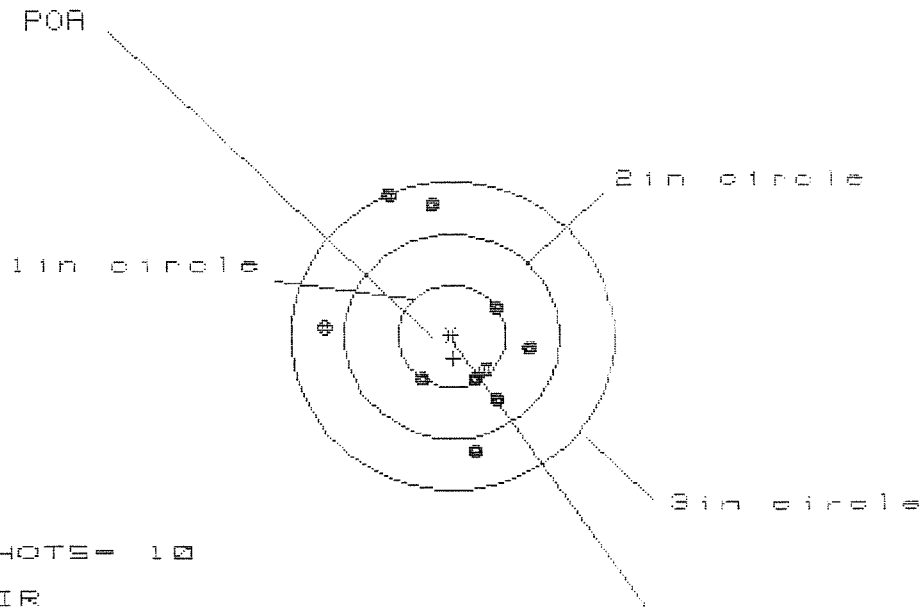
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.159	1.115
MINIMUM X	-1.510	-1.523	-1.379
MAXIMUM Y	1.748	1.341	.810
MINIMUM Y	-1.242	-1.048	-.881
CENTROID X	.218	.231	.086
CENTROID Y	.188	-.006	-.173
POA TO CENTROID in.	.288	.231	.194
MIN RADIUS	.208	.330	.130
MEAN RADIUS	1.094	.990	.867
MAX RADIUS	1.751	1.772	1.384
HORIZONTAL SPREAD	2.682	2.682	2.494
VERTICAL SPREAD	2.990	2.389	1.691
EXTREME SPREAD	3.248	3.248	2.718
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	6		

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FILE:/PATTERNING/CENTERFIRE_PATT/C634B982

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.867

VS= 2.449

GS= 2.576

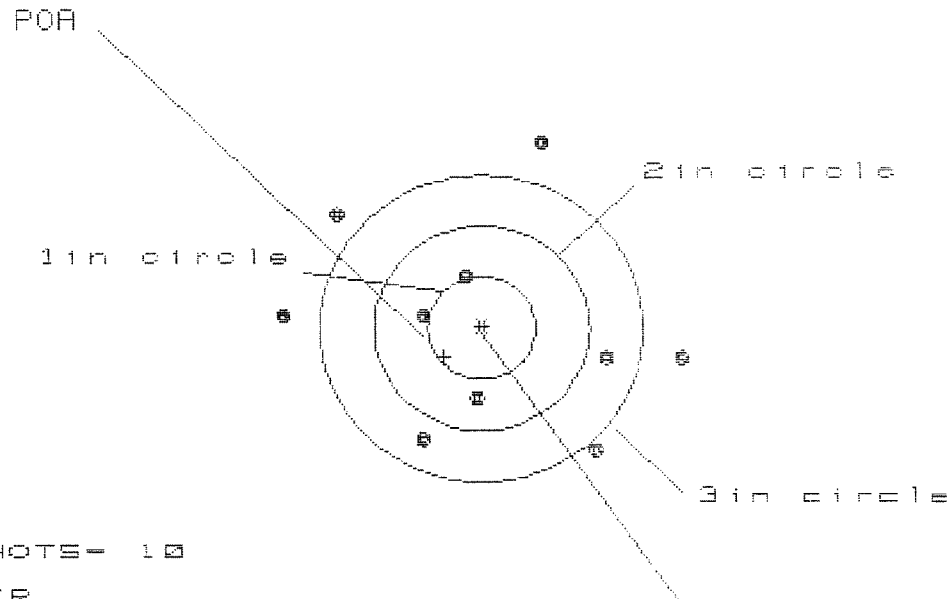
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.683	.621	.588
MINIMUM X	:	-1.184	-1.246	-1.279
MAXIMUM Y	:	1.357	1.387	.601
MINIMUM Y	:	-1.092	-.942	-.768
CENTROID X	:	-.016	.046	.079
CENTROID Y	:	.217	.067	-.107
POA TO CENTROID in.	:	.218	.081	.133
MIN RADIUS	:	.448	.293	.152
MEAN RADIUS	:	.837	.716	.581
MAX RADIUS	:	1.469	1.412	1.351
HORIZONTAL SPREAD	:	1.867	1.867	1.867
VERTICAL SPREAD	:	2.449	2.329	1.369
EXTREME SPREAD	:	2.576	2.369	1.884
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 3.696

VS= 2.958

GS= 3.713

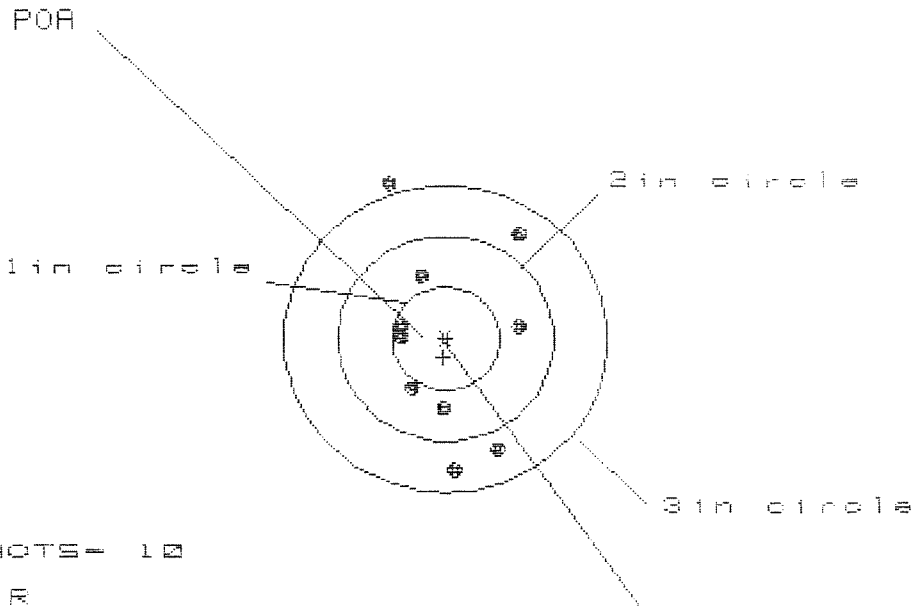
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.873	1.323	1.414
MINIMUM X	-1.823	-1.615	-1.524
MAXIMUM Y	1.809	1.778	1.274
MINIMUM Y	-1.149	-1.180	-.958
CENTROID X	.347	.139	.048
CENTROID Y	.284	.315	.093
POA TO CENTROID in.	.449	.345	.105
MIN RADIUS	.490	.391	.415
MEAN RADIUS	1.308	1.218	1.111
MAX RADIUS	1.893	1.923	1.668
HORIZONTAL SPREAD	3.696	2.938	2.938
VERTICAL SPREAD	2.958	2.958	2.232
EXTREME SPREAD	3.713	3.277	3.277
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.152

VS= 2.855

GS= 2.903

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.673	.620	.619
MINIMUM X	:	-.479	-.507	-.508
MAXIMUM Y	:	1.546	1.209	1.067
MINIMUM Y	:	-1.309	-1.138	-1.062
CENTROID X	:	.021	.074	.075
CENTROID Y	:	.181	.010	.152
POA TO CENTROID in.	:	.182	.074	.169
MIN RADIUS	:	.401	.476	.462
MEAN RADIUS	:	.878	.788	.738
MAX RADIUS	:	1.618	1.359	1.234
HORIZONTAL SPREAD	:	1.152	1.127	1.127
VERTICAL SPREAD	:	2.855	2.347	2.129
EXTREME SPREAD	:	2.903	2.430	2.136
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.780

VS = 2.657

GS = 3.128

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.097	.910	1.010
MINIMUM X	:	-1.683	-1.378	-1.278
MAXIMUM Y	:	1.295	1.267	1.093
MINIMUM Y	:	-1.362	-1.390	-0.816
CENTROID X	:	.058	.245	.145
CENTROID Y	:	-.067	-.039	.135
POA TO CENTROID in.	:	.088	.248	.198
MIN RADIUS	:	.609	.576	.687
MEAN RADIUS	:	1.157	1.078	1.012
MAX RADIUS	:	1.701	1.603	1.327
HORIZONTAL SPREAD	:	2.780	2.288	2.288
VERTICAL SPREAD	:	2.657	2.657	1.909
EXTREME SPREAD	:	3.128	3.128	2.568
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	