

C6649255

MODEL 700™ M24

Model **SMS**™

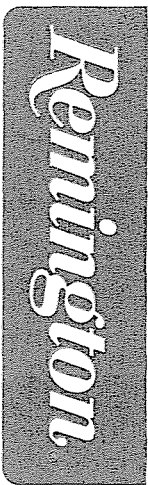
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



Smead®




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

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

MODEL 700TM H24

SERIAL NO.
C6649255

ORDER NO.
5716

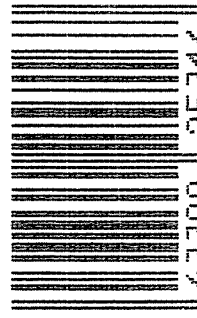
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

20



5716 C6649255

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649255

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	GL
	Magnaflux Bolt		JUL 22 1991	GL
615	Rollmark Caliber		JUL 22 1991	GL
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-2-91	LB
	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		8-12-91	GL

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649255

DATE 8-12-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.45	2.52	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.40	2.54	2.60	
PULL #3	2.46	2.42	2.50	2.70	
PULL #4	2.41	2.51	2.53	2.75	
PULL #5	2.38	2.54	2.55	2.75	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.25		
PULL #2	3.37	3.29		
PULL #3	3.20	3.37		
PULL #4	3.27	3.17		
PULL #5	3.37	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.29		4.42
PULL #2	4.34	4.22		4.51
PULL #3	4.38	4.24		4.52
PULL #4	4.33	4.28		4.51
PULL #5	4.24	4.31		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649255
23 Aug 1991

CENTROIDAL DISTANCES

0	TO	1	.341013
1	TO	2	.439264
1	TO	3	.445325
1	TO	4	.559912
1	TO	5	.301705

4.1 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0438
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113031
THE AMR FOR THIS RIFLE IS: .8554

23 R. 951

FILE:/PATTERNING/CENTERFIRE_PATT/C6649255

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.786

VS= 1.937

GS= 2.834

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.439	1.289	.950
MINIMUM X	:	-1.347	-.946	-.785
MAXIMUM Y	:	.867	.753	.676
MINIMUM Y	:	-1.070	-1.184	-1.261
CENTROID X	:	.271	.421	.260
CENTROID Y	:	.207	.321	.398
POA TO CENTROID in.	:	.341	.529	.475
MIN RADIUS	:	.105	.123	.098
MEAN RADIUS	:	.903	.782	.689
MAX RADIUS	:	1.692	1.429	1.261
HORIZONTAL SPREAD	:	2.786	2.235	1.735
VERTICAL SPREAD	:	1.937	1.937	1.937
EXTREME SPREAD	:	2.834	2.622	2.078
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649255

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.274

VS= 2.530

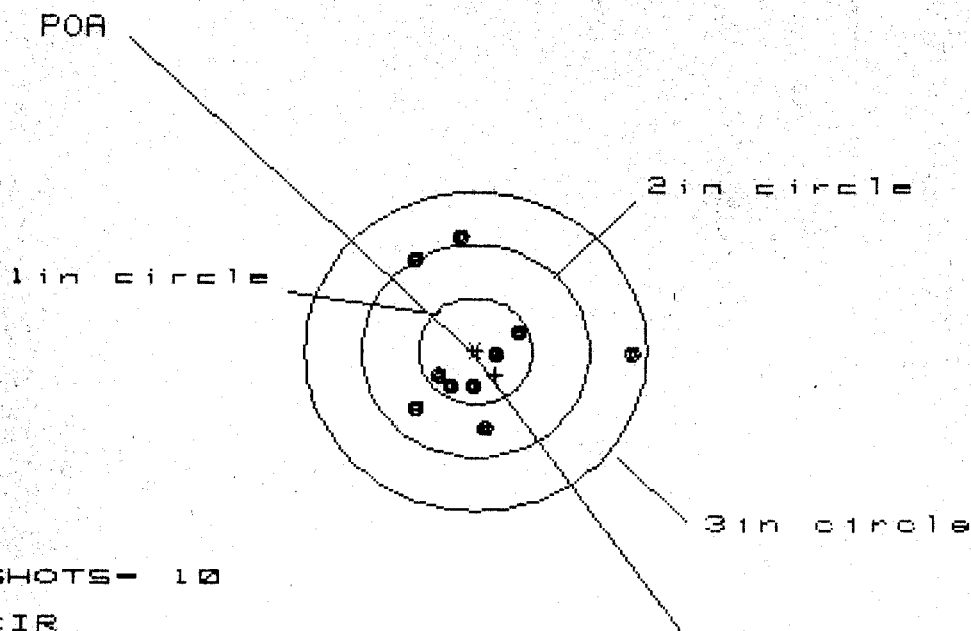
GS= 3.111

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.020	1.081	.932
MINIMUM X	:	-1.254	-1.193	-.644
MAXIMUM Y	:	1.653	.895	.808
MINIMUM Y	:	-.877	-.694	-.554
CENTROID X	:	-.102	-.164	-.015
CENTROID Y	:	-.025	-.208	-.121
POA TO CENTROID in.	:	.105	.265	.122
MIN RADIUS	:	.079	.174	.187
MEAN RADIUS	:	.855	.738	.669
MAX RADIUS	:	1.744	1.385	1.215
HORIZONTAL SPREAD	:	2.274	2.274	1.576
VERTICAL SPREAD	:	2.530	1.589	1.363
EXTREME SPREAD	:	3.111	2.754	1.973
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649255

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 10

HS= 1.896

VS= 1.808

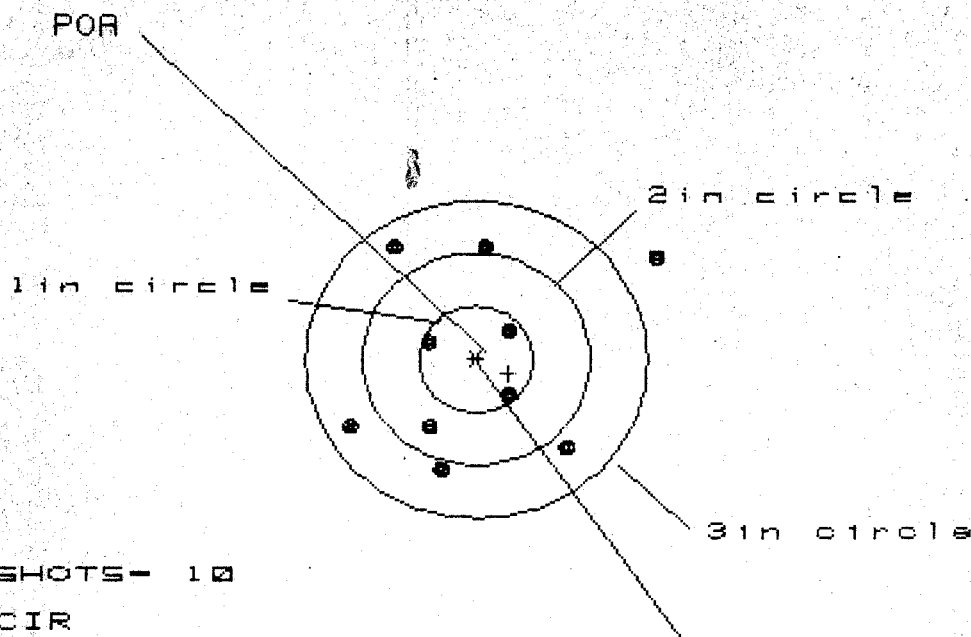
GS= 2.128

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.325	.525	.525
MINIMUM X	:	-.571	-.423	-.423
MAXIMUM Y	:	1.122	1.116	1.049
MINIMUM Y	:	-.686	-.692	-.552
CENTROID X	:	-.174	-.322	-.322
CENTROID Y	:	.224	.230	.090
POA TO CENTROID in.	:	.284	.395	.335
MIN RADIUS	:	.128	.274	.210
MEAN RADIUS	:	.669	.594	.482
MAX RADIUS	:	1.326	1.116	1.131
HORIZONTAL SPREAD	:	1.896	.948	.948
VERTICAL SPREAD	:	1.808	1.808	1.602
EXTREME SPREAD	:	2.128	1.822	1.731
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648255

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 2.734

VS= 2.076

GS= 3.171

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.574	.932	.808
MINIMUM X	:	-1.160	-.985	-.684
MAXIMUM Y	:	1.070	1.175	1.106
MINIMUM Y	:	-1.006	-.901	-.970
CENTROID X	:	-.284	-.459	-.335
CENTROID Y	:	.133	.028	.097
POA TO CENTROID in.	:	.313	.459	.349
MIN RADIUS	:	.360	.372	.421
MEAN RADIUS	:	.976	.866	.822
MAX RADIUS	:	1.836	1.286	1.285
HORIZONTAL SPREAD	:	2.734	1.917	1.492
VERTICAL SPREAD	:	2.076	2.076	2.076
EXTREME SPREAD	:	3.171	2.391	2.391
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Aug 1951

FILE: /PATTERNING/CENTERFIRE_PATT/C6649235

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS = 2.212

VS = 2.343

GS = 2.829

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	.867	.830
MINIMUM X	:	-.879	-.731	-.623
MAXIMUM Y	:	1.350	1.445	.610
MINIMUM Y	:	-.993	-.898	-.717
CENTROID X	:	.070	-.078	-.186
CENTROID Y	:	-.018	-.113	-.294
POA TO CENTROID in.	:	.072	.138	.348
MIN RADIUS	:	.315	.212	.318
MEAN RADIUS	:	.874	.762	.629
MAX RADIUS	:	1.584	1.685	1.097
HORIZONTAL SPREAD	:	2.212	1.598	1.453
VERTICAL SPREAD	:	2.343	2.343	1.327
EXTREME SPREAD	:	2.829	2.766	1.751
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	