

C6611465

MODEL 700™ M24

Model 5145™

Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Smeal®




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

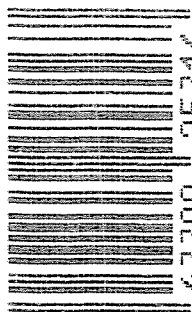
MODEL 700TM H24

SERIAL NO.
C6611465

ORDER NO.
5716

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

UPC



0 47700 25716 2



5716 C6611465

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6611465**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/18/91	K.S.
600	Proof		3/18/91	K.S.
607	Check Headspace		3/18/91	K.S.
610	Dis-assemble Gun		3/18/91	K.S.
612	Magnaflux Barrel Action		3/25/91	K.R.
	Magnaflux Bolt		"	K.R.
615	Rollmark Caliber		"	Y.S.
617	Drill and Tap Sight Holes	APR	3 1991	K.S.
618	Polish Barrel	APR	3 1991	K.S.
620	Apply Coatings (Barrel Action)		4/19/91	K.S.
	Apply Coating (Bolt)			K.S.
625	Final Assembly A) Clean inside of Bolt Assembly		4/26/91	K.S.
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/26/91	K.S.
	C) Inspect Ejector Hole for Chamfer		4/26/91	K.S.
	D) Oil Firing Pin Ass'y		4/26/91	K.S.
	E) Adjust Trigger Pull to Min Setting and Stake		4/29/91	K.S.

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/30/91	YH
	G) Safety Off Force	4	3	3			4/30/91	YH
	H) Trigger Pull Test & Retainability						4/29/91	YH
	I) Firing Pin Indent	.0225	.0225	.0225			4/30/91	YH
	J) Assemble Stock						4/30/91	K-S
	K) Assemble Swivel Studs						5-1-91	YH
	L) Attach Front and Rear Sight Assemblies						4/30/91	K-S
	M) Iron Sight Alignment						4/30/91	K-S
	N) Detach Front & Rear Sights & place in numbered container						4/30/91	K-S
	O) Attach Scope to Rifle						4/30/91	K-S
	P) Detach & Attach Scope 20 Times						4/30/91	K-S
640	Gallery Target & Test						5-1-91	AC
	A) Time						5-1-91	AC
	B) Malfunctions						5-1-91	AC
	C) Pierced Primers						5-1-91	AC
	D) Optical Clarity of Scope						5-1-91	AC
645	Inspect for Live Ammo						5-1-91	AC
655	Final Inspection							
	A) Headspace						5-13-91	YH
	B) Trigger Pull	2.22	2.25	2.24	2.23	2.32	5/10/91	YH
	C) Function						5/13-91	YH
660	Pack						6-20-91	YH

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6611485
DATE 4/29/91
TESTER [Signature] (H)
FELICITY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.44	2.41	2.22	MIN. SETTING,
PULL #2	2.38	2.48	2.44	2.25	NO AVG. OF 5
PULL #3	2.43	2.39	2.38	2.24	READINGS ACCEPT-
PULL #4	2.45	2.35	2.26	2.23	ABLE LESS THAN 2#
PULL #5	2.39	2.29	2.25	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES			COMMENTS
PULL #1	3.29	3.47			
PULL #2	3.34	3.34			
PULL #3	3.43	3.46			
PULL #4	3.56	3.45			
PULL #5	3.38	3.41			
TOTAL					
AVG.					

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.17		4.23
PULL #2	4.42	4.14		4.23
PULL #3	4.40	4.22		4.17
PULL #4	4.40	4.11		4.25
PULL #5	4.27	4.17		4.28
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611465
1 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.163884
1 TO	2	.206155
1 TO	3	.470469
1 TO	4	.172012
1 TO	5	.291153

~~4~~ 3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2536
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .049
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .25829

THE AMR FOR THIS RIFLE IS: .9392

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 8

HS = 2.186

VS = 3.345

GS = 3.495

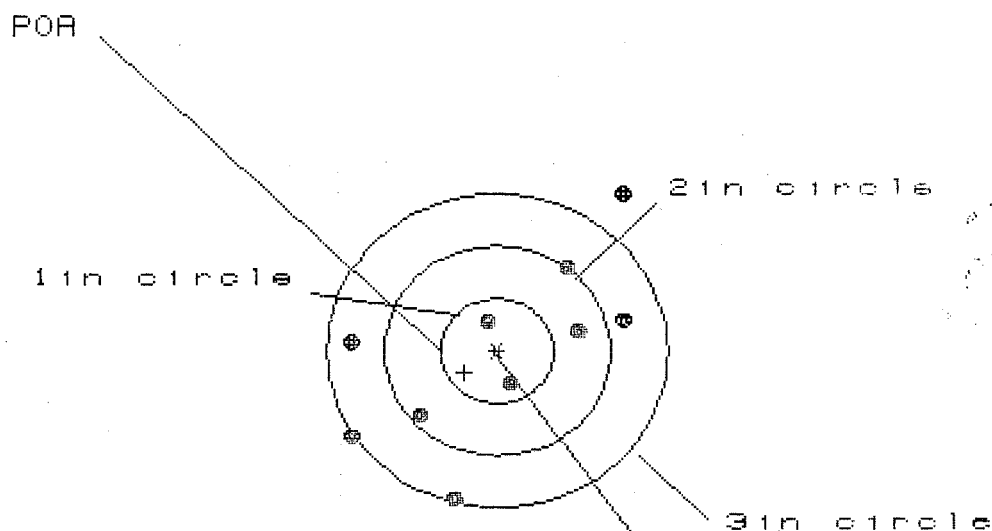
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	1.003	1.001
MINIMUM X	:	-1.182	-1.183	-1.058
MAXIMUM Y	:	1.499	1.293	.976
MINIMUM Y	:	-1.846	-1.384	-1.222
CENTROID X	:	.157	.158	.033
CENTROID Y	:	.047	.253	.091
POA TO CENTROID in.	:	.164	.298	.097
MIN RADIUS	:	.125	.205	.007
MEAN RADIUS	:	1.119	1.029	.912
MAX RADIUS	:	1.846	1.637	1.397
HORIZONTAL SPREAD	:	2.186	2.186	2.059
VERTICAL SPREAD	:	3.345	2.677	2.198
EXTREME SPREAD	:	3.495	3.000	2.535
NUMBER IN ONE INCH CIRCLE	=	2	3	8
NUMBER IN TWO INCH CIRCLE	=			
NUMBER IN THREE INCH CIRCLE	=			

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.453

VS= 2.866

GS= 3.275

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	1.272	1.133
MINIMUM X	:	-1.305	-1.181	-1.320
MAXIMUM Y	:	1.456	.958	.877
MINIMUM Y	:	-1.410	-1.248	-1.329
CENTROID X	:	.287	.163	.302
CENTROID Y	:	.207	.045	.126
POA TO CENTROID in.	:	.354	.169	.327
MIN RADIUS	:	.304	.272	.225
MEAN RADIUS	:	1.048	.957	.893
MAX RADIUS	:	1.838	1.351	1.387
HORIZONTAL SPREAD	:	2.453	2.453	2.453
VERTICAL SPREAD	:	2.866	2.206	2.206
EXTREME SPREAD	:	3.275	2.631	2.465
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 3.820

VS= 1.791

GS= 3.852

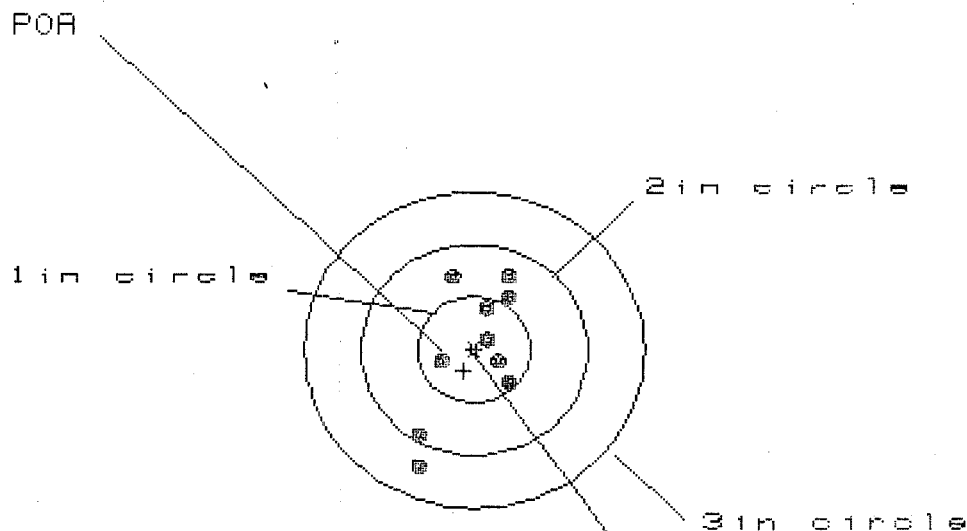
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.493	1.234	.888
MINIMUM X	:	-2.327	-1.531	-1.377
MAXIMUM Y	:	1.102	1.071	1.093
MINIMUM Y	:	-.689	-.720	-.698
CENTROID X	:	.627	.886	.731
CENTROID Y	:	.026	.057	.035
POA TO CENTROID in.	:	.628	.888	.732
MIN RADIUS	:	.193	.067	.207
MEAN RADIUS	:	1.040	.864	.811
MAX RADIUS	:	2.344	1.531	1.408
HORIZONTAL SPREAD	:	3.820	2.765	2.264
VERTICAL SPREAD	:	1.791	1.791	1.791
EXTREME SPREAD	:	3.852	2.774	2.523
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = .816

VS = 1.874

GS = 2.005

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.351	.302	.238
MINIMUM X	:	-.465	-.514	-.484
MAXIMUM Y	:	.736	.610	.497
MINIMUM Y	:	-1.138	-.900	-.567
CENTROID X	:	.089	.138	.202
CENTROID Y	:	.205	.331	.444
POA TO CENTROID in.	:	.223	.359	.488
MIN RADIUS	:	.125	.061	.111
MEAN RADIUS	:	.582	.483	.401
MAX RADIUS	:	1.220	1.037	.615
HORIZONTAL SPREAD	:	.816	.816	.642
VERTICAL SPREAD	:	1.874	1.510	1.064
EXTREME SPREAD	:	2.005	1.680	1.187
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611465

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in - 9

HS- 2.502

VS= 2.279

GS= 2.832

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.117	.963	.697
MINIMUM X	:	-1.385	-1.254	-1.133
MAXIMUM Y	:	1.238	.945	1.026
MINIMUM Y	:	-1.041	-.904	-.823
CENTROID X	:	.108	.262	.141
CENTROID Y	:	-.240	-.377	-.458
POA TO CENTROID in.	:	.263	.459	.480
MIN RADIUS	:	.309	.259	.327
MEAN RADIUS	:	.907	.761	.701
MAX RADIUS	:	1.857	1.260	1.152
HORIZONTAL SPREAD	:	2.502	2.217	1.830
VERTICAL SPREAD	:	2.279	1.849	1.849
EXTREME SPREAD	:	2.832	2.279	1.875
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	