

C5611644

MODEL 700™ M24

Model S&S™

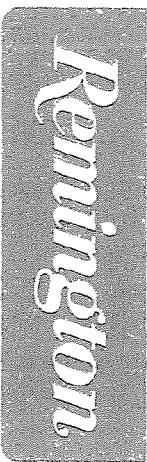
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



Smead®




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

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

MODEL 700™ H24

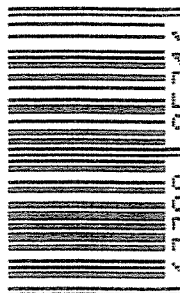
SERIAL NO.
C6611644

ORDER NO.
5716

46

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

UPC



0 47700 25716 7



5716 C6611644

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611644

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25 91		Rw
600	Proof	25 91		Rw
607	Check Headspace	25 91		Rw
610	Dis-assemble Gun	25 91		Rw
612	Magnaflux Barrel Action	2 28 91		KR
	Magnaflux Bolt	2 28 91		"
615	Rollmark Caliber	2 28 91		LS.
617	Drill and Tap Sight Holes	APR 3 1991		LS
618	Polish Barrel	APR 3 1991		LS
620	Apply Coatings (Barrel Action)		4-11-91	TJ
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/16/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/16/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/16/91	Rw
	D) Oil Firing Pin Ass'y		4/16/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/3/91	FM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5/3/91	SM
	G) Safety Off Force	4	4	4			5/3/91	SM
	H) Trigger Pull Test & Retainability						5/3/91	SM
	I) Firing Pin Indent	.0205	.020	.020			5/3/91	SM
	J) Assemble Stock						5/4/91	RW
	K) Assemble Swivel Studs						5-10-91	AE
	L) Attach Front and Rear Sight Assemblies						5/4/91	RW
	M) Iron Sight Alignment						5/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/4/91	RW
	O) Attach Scope to Rifle						5/4/91	RW
	P) Detach & Attach Scope 20 Times						5/4/91	RW
640	Gallery Target & Test						5-4-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						5-4-91	NF
655	Final Inspection							
	A) Headspace						5-10-91	AE
	B) Trigger Pull	2.22	2.21	2.28	2.28	2.32	5/9/91	SM
	C) Function						5-10-91	AC
660	Pack						6-15-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611644
DATE 5/3/91
TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.33	2.36	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.41	2.38	2.21	
PULL #3	2.32	2.36	2.40	2.28	
PULL #4	2.18	2.32	2.25	2.28	
PULL #5	2.38	2.38	2.35	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.18		
PULL #2	3.23	3.23		
PULL #3	3.44	3.34		
PULL #4	3.27	3.19		
PULL #5	3.18	3.24		
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	4.58		4.60
PULL #2	4.58	4.55		4.27
PULL #3	4.59	4.59		4.61
PULL #4	4.54	4.47		4.46
PULL #5	4.30	4.59		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611644
4 May 1991

CENTROIDAL DISTANCES

0 TO 1	.29272
1 TO 2	.311333
1 TO 3	.583648
1 TO 4	.204841
1 TO 5	.507025

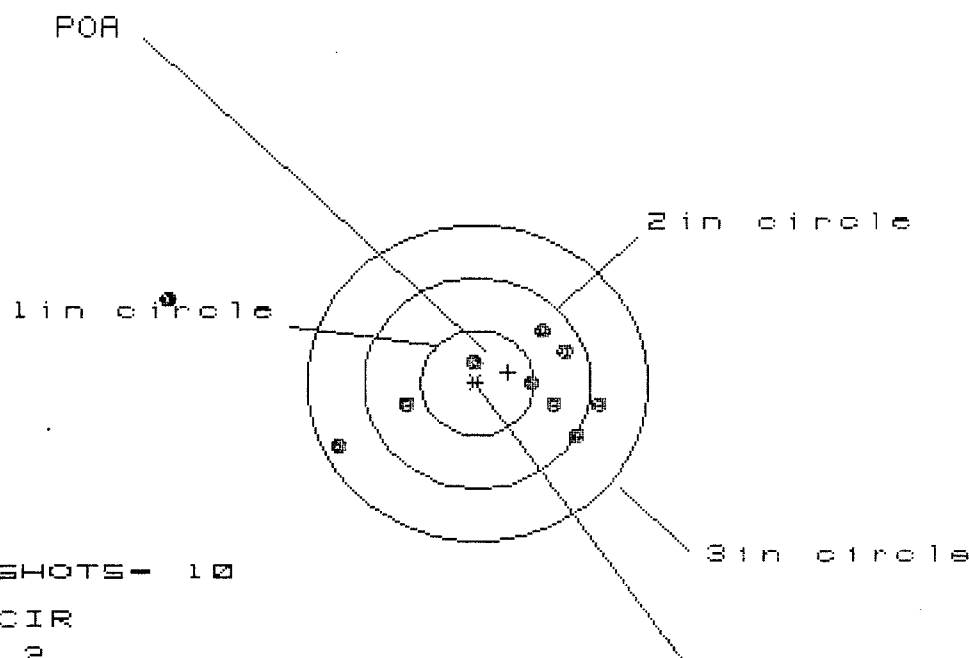
0.03 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0056
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0236
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .024253
THE AMR FOR THIS RIFLE IS: .9274

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611644

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in = 9

HS- 3.797

VS= 1.458

GS= 3.941

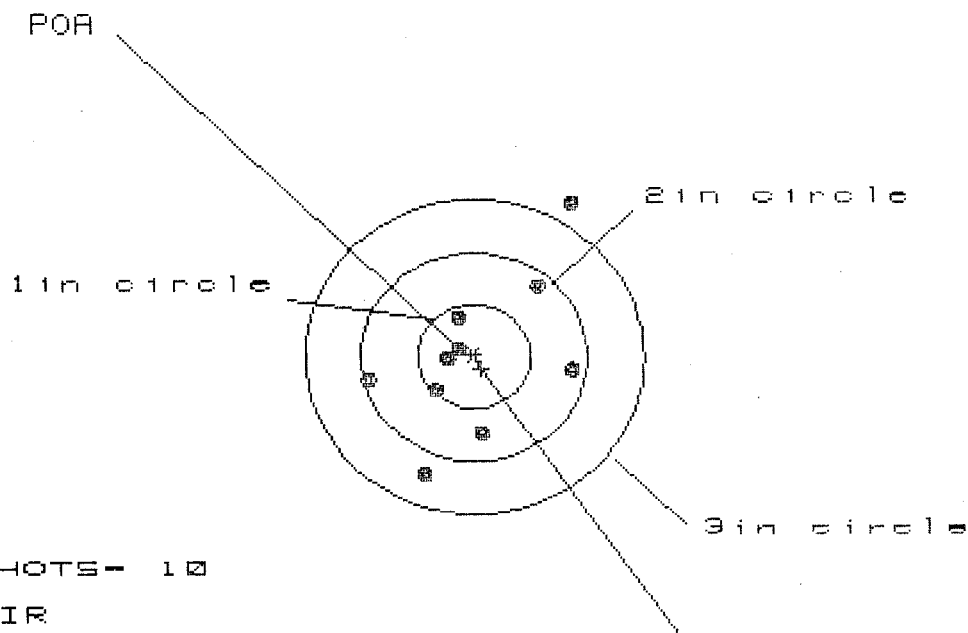
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.111	.813	.622
MINIMUM X	:	-2.686	-1.529	-1.081
MAXIMUM Y	:	.822	.576	.508
MINIMUM Y	:	-.636	-.545	-.442
CENTROID X	:	-.274	.024	.215
CENTROID Y	:	-.103	-.194	-.126
POA TO CENTROID in.	:	.293	.195	.249
MIN RADIUS	:	.173	.181	.067
MEAN RADIUS	:	.994	.706	.531
MAX RADIUS	:	2.808	1.623	1.101
HORIZONTAL SPREAD	:	3.797	2.342	1.703
VERTICAL SPREAD	:	1.458	1.121	.950
EXTREME SPREAD	:	3.941	2.376	1.703
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

4 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.813

VS= 2.555

GS= 2.895

CENTROID #

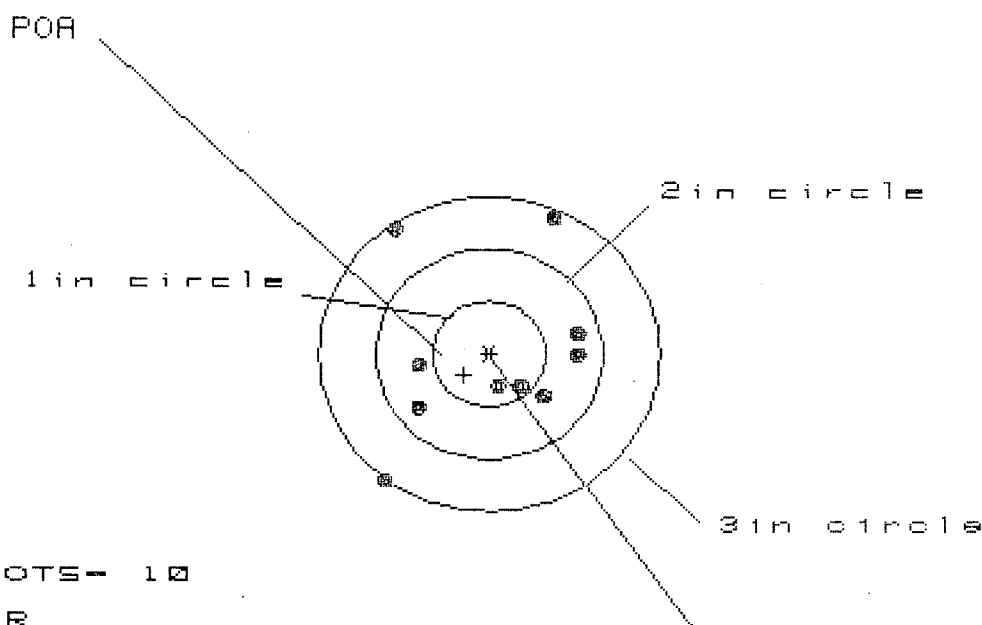
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.887	.924	.877
MINIMUM X	:	-.926	-.828	-.875
MAXIMUM Y	:	1.468	.883	.767
MINIMUM Y	:	-1.087	-.924	-.726
CENTROID X	:	-.062	-.160	-.113
CENTROID Y	:	.125	-.038	.078
POA TO CENTROID in.	:	.140	.164	.137
MIN RADIUS	:	.154	.177	.138
MEAN RADIUS	:	.762	.630	.576
MAX RADIUS	:	1.715	1.094	.974
HORIZONTAL SPREAD	:	1.813	1.752	1.752
VERTICAL SPREAD	:	2.555	1.807	1.493
EXTREME SPREAD	:	2.895	2.077	1.756
NUMBER IN ONE INCH CIRCLE =	:	4		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	9		

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CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.722

VS= 2.483

GS= 2.904

CENTROID *

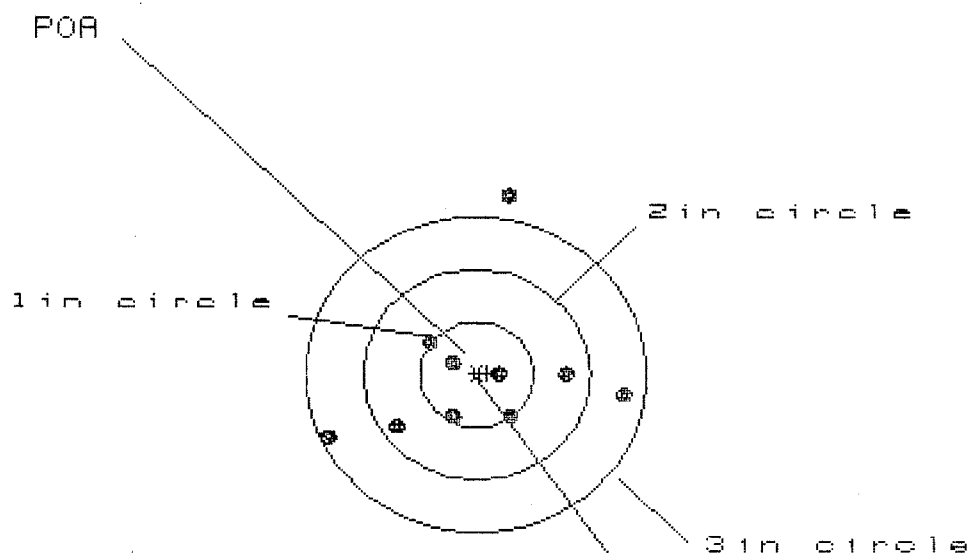
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.824	.725	.615
MINIMUM X	-.898	-.877	-.878
MAXIMUM Y	1.300	1.169	1.308
MINIMUM Y	-1.183	-.612	-.473
CENTROID X	.223	.322	.432
CENTROID Y	.203	.334	.195
POA TO CENTROID in.	.301	.464	.474
MIN RADIUS	.291	.423	.325
MEAN RADIUS	.874	.817	.687
MAX RADIUS	1.485	1.415	1.367
HORIZONTAL SPREAD	1.722	1.602	1.493
VERTICAL SPREAD	2.483	1.781	1.781
EXTREME SPREAD	2.904	2.191	2.191
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 May 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.651

VS= 2.258

GS= 2.785

CENTROID #

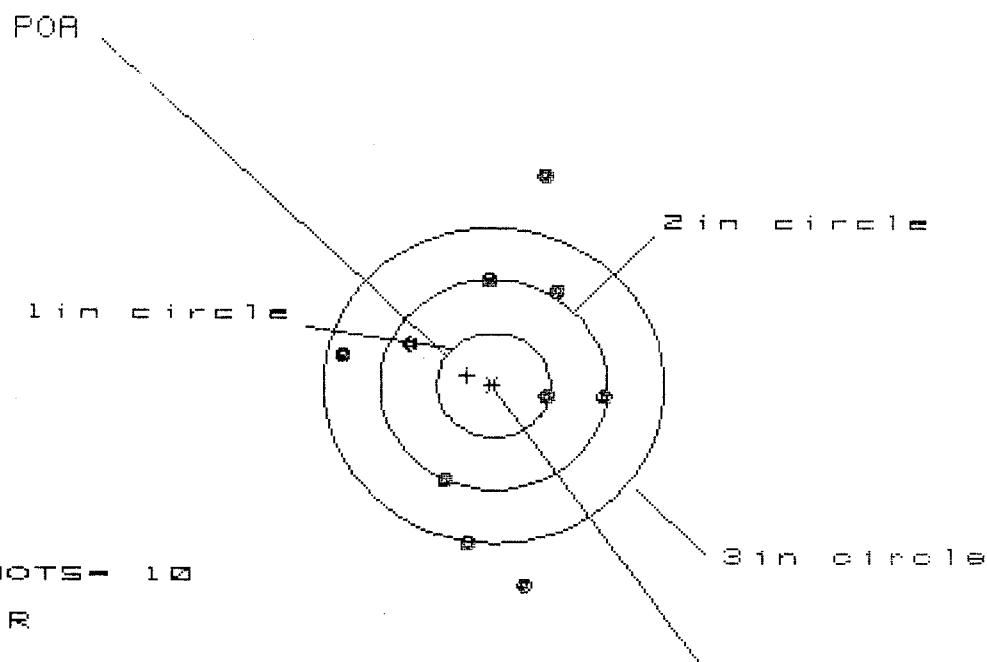
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.332	1.367	1.206
MINIMUM X	-1.319	-1.284	-.792
MAXIMUM Y	1.659	.451	.399
MINIMUM Y	-.599	-.415	-.352
CENTROID X	-.092	-.127	.034
CENTROID Y	-.009	-.193	-.141
POA TO CENTROID in.	.093	.231	.145
MIN RADIUS	.203	.292	.198
MEAN RADIUS	.797	.687	.599
MAX RADIUS	1.688	1.367	1.208
HORIZONTAL SPREAD	2.651	2.651	1.998
VERTICAL SPREAD	2.258	.866	.751
EXTREME SPREAD	2.785	2.683	2.020
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.219

VS= 3.906

GS= 3.910

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.927	.975	1.014
MINIMUM X	:	-1.292	-1.244	-1.205
MAXIMUM Y	:	1.977	1.210	.997
MINIMUM Y	:	-1.929	-1.710	-1.510
CENTROID X	:	.233	.185	.146
CENTROID Y	:	-.098	-.317	-.104
POA TO CENTROID in.	:	.253	.367	.179
MIN RADIUS	:	.436	.495	.521
MEAN RADIUS	:	1.210	1.120	1.020
MAX RADIUS	:	2.023	1.737	1.514
HORIZONTAL SPREAD	:	2.219	2.219	2.219
VERTICAL SPREAD	:	3.906	2.920	2.507
EXTREME SPREAD	:	3.910	2.935	2.534
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	