

C6611646

MODEL 700™ M24

Model **SMS**™

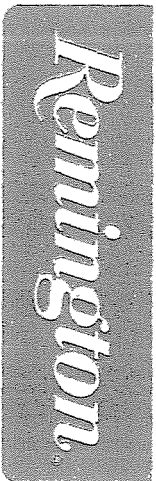
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



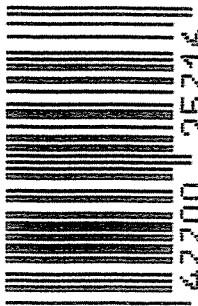
Smith
Snead




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

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

MODEL 700™ H24

	SERIAL NO. C6611646
 0 47700 25716 7	ORDER NO. 5716

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



5716 C6611646

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611646

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	9 1	RW
600	Proof	3 25	9 1	RW
607	Check Headspace	3 25	9 1	RW
610	Dis-assemble Gun	3 25	9 1	RW
612	Magnaflux Barrel Action	3 28	9 1	KR
	Magnaflux Bolt	3 28	9 1	cc
615	Rollmark Caliber	3 28	9 1	LS
617	Drill and Tap Sight Holes	APR	3 1991	RB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/11/91	JA
	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		5/14/91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-15-91	DH
	G) Safety Off Force	3	3	3			5-15-91	DH
	H) Trigger Pull Test & Retainability						5/14/91	JLP
	I) Firing Pin Indent	.021	.022	.022			5-15-91	DH
	J) Assemble Stock						5/15/91	RW
	K) Assemble Swivel Studs						5-21-91	DH
	L) Attach Front and Rear Sight Assemblies						5/15/91	RW
	M) Iron Sight Alignment						5/15/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/15/91	RW
	O) Attach Scope to Rifle						5/15/91	RW
	P) Detach & Attach Scope 20 Times						5/15/91	RW
640	Gallery Target & Test						5-15-91	DH
	A) Time						5-15-91	DH
	B) Malfunctions						5-15-91	DH
	C) Pierced Primers						5-15-91	DH
	D) Optical Clarity of Scope						5-15-91	DH
645	Inspect for Live Ammo						5-15-91	DH
655	Final Inspection							
	A) Headspace						5-21-91	DH
	B) Trigger Pull	2.15	2.20	2.18	2.23	2.15	5-20-91	JLP
	C) Function						5-21-91	DH
660	Pack						6-17-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO C-6611646

DATE 5-14-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.54	2.50	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.57	2.58	2.20	
PULL #3	2.51	2.60	2.48	2.18	
PULL #4	2.49	2.53	2.46	2.23	
PULL #5	2.47	2.49	2.50	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.35		
PULL #2	3.33	3.48		
PULL #3	3.27	3.39		
PULL #4	3.30	3.34		
PULL #5	3.33	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.47		4.47
PULL #2	4.53	4.40		4.46
PULL #3	4.47	4.41		4.48
PULL #4	4.51	4.43		4.36
PULL #5	4.50	4.43		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611646
15 May 1991

CENTROIDAL DISTANCES

0 TO	1	.167287
1 TO	2	.528977
1 TO	3	.19801
1 TO	4	.351693
1 TO	5	.566083

34⁴⁵ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .136471

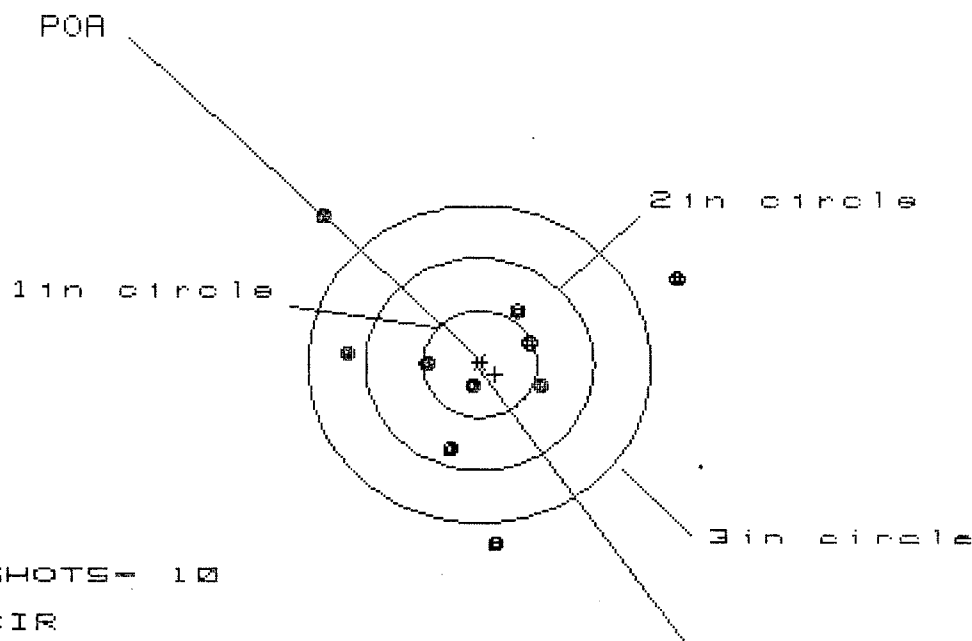
THE AMR FOR THIS RIFLE IS: 1.062

15 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611646

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in - 2

2in - 6

3in = 7

HS- 3.088

VS= 3.147

GS= 3.480

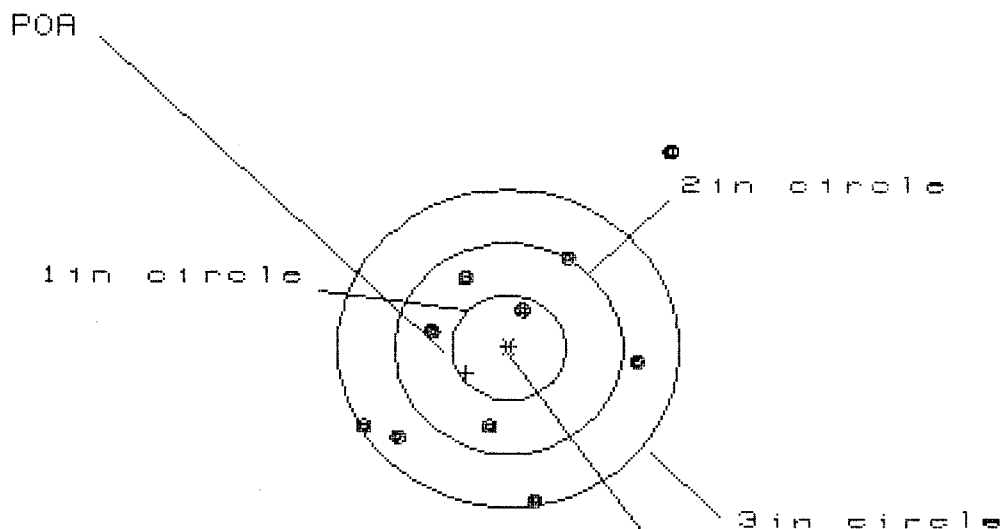
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.751	1.602	.598
MINIMUM X	:	-1.337	-1.332	-1.131
MAXIMUM Y	:	1.426	.970	.785
MINIMUM Y	:	-1.721	-1.563	-1.442
CENTROID X	:	-.137	.012	-.189
CENTROID Y	:	.096	-.062	-.183
POA TO CENTROID in.	:	.167	.063	.263
MIN RADIUS	:	.237	.183	.056
MEAN RADIUS	:	1.012	.889	.750
MAX RADIUS	:	1.955	1.873	1.459
HORIZONTAL SPREAD	:	3.088	2.934	1.729
VERTICAL SPREAD	:	3.147	2.533	2.227
EXTREME SPREAD	:	3.490	3.019	2.271
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

15 May 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.689

VS= 3.229

GS= 3.722

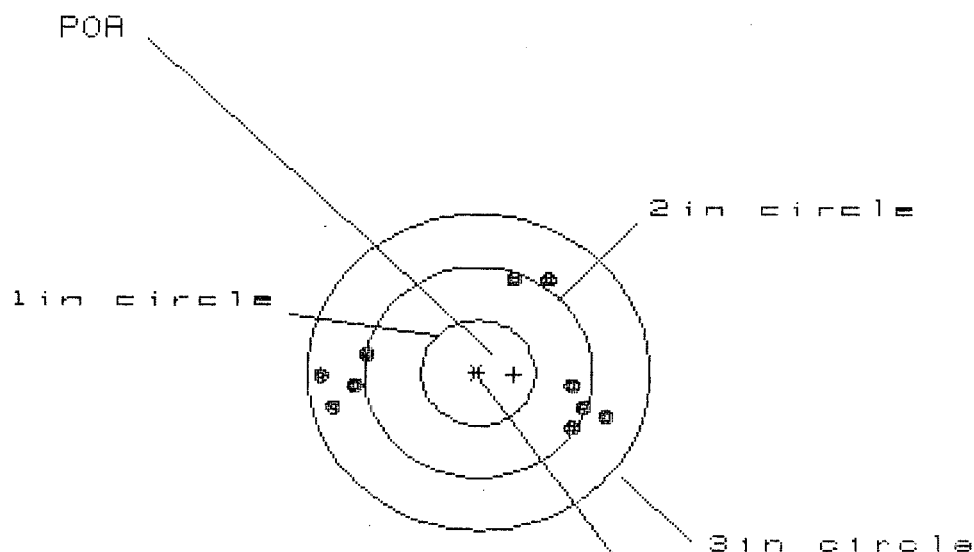
CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.419	1.277	1.138
MINIMUM X	:	-1.270	-1.112	-.955
MAXIMUM Y	:	1.834	1.045	.978
MINIMUM Y	:	-1.395	-1.191	-1.258
CENTROID X	:	.372	.214	.353
CENTROID Y	:	.240	.036	.103
POA TO CENTROID in.	:	.443	.217	.368
MIN RADIUS	:	.360	.514	.491
MEAN RADIUS	:	1.113	.963	.922
MAX RADIUS	:	2.319	1.277	1.283
HORIZONTAL SPREAD	:	2.689	2.389	2.093
VERTICAL SPREAD	:	3.229	2.236	2.236
EXTREME SPREAD	:	3.722	2.458	2.254
NUMBER IN ONE INCH CIRCLE	=	1		
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 = 0

2 in = 3

3 in = 10

HS= 2.537

VS= 1.398

GS= 2.582

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.161	1.008	.828
MINIMUM X	:	-1.376	-1.442	-1.383
MAXIMUM Y	:	.872	.874	.835
MINIMUM Y	:	-.526	-.524	-.563
CENTROID X	:	-.319	-.166	.014
CENTROID Y	:	.018	.016	.055
POA TO CENTROID in.	:	.320	.167	.057
MIN RADIUS	:	.824	.673	.505
MEAN RADIUS	:	1.082	1.023	.921
MAX RADIUS	:	1.376	1.475	1.398
HORIZONTAL SPREAD	:	2.537	2.450	2.211
VERTICAL SPREAD	:	1.398	1.398	1.398
EXTREME SPREAD	:	2.582	2.454	2.244
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	

15 May 1991

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS- 3.072

VS= 1.612

GS= 3.094

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.762	1.812	.973
MINIMUM X	:	-1.310	-1.114	-.887
MAXIMUM Y	:	.893	.889	.947
MINIMUM Y	:	-.719	-.723	-.665
CENTROID X	:	.205	.009	-.218
CENTROID Y	:	.178	.182	.124
POA TO CENTROID in.	:	.271	.182	.250
MIN RADIUS	:	.099	.209	.369
MEAN RADIUS	:	1.016	.904	.756
MAX RADIUS	:	1.763	1.872	1.358
HORIZONTAL SPREAD	:	3.072	2.926	1.860
VERTICAL SPREAD	:	1.612	1.612	1.612
EXTREME SPREAD	:	3.094	3.057	2.272
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

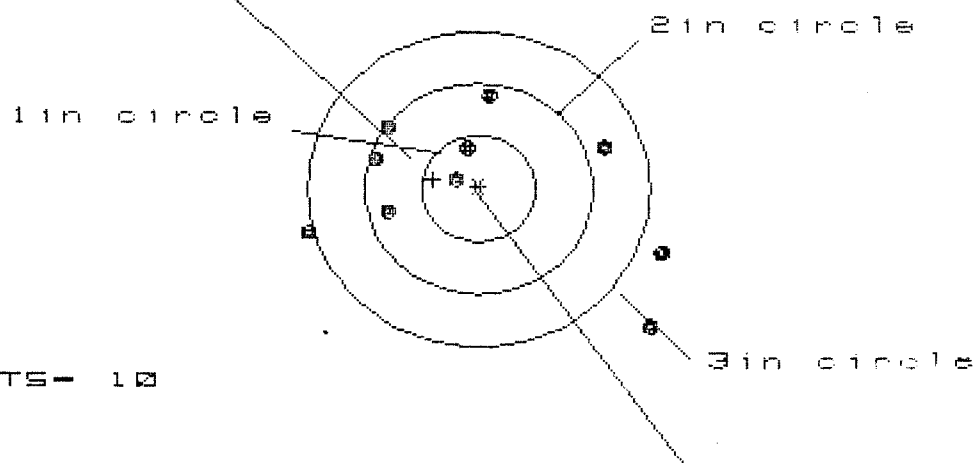
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CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 3.186

VS= 2.163

GS= 3.221

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.647	1.819	1.506
MINIMUM X	:	-1.539	-1.367	-1.139
MAXIMUM Y	:	.855	.709	.618
MINIMUM Y	:	-1.308	-.730	-.634
CENTROID X	:	.398	.226	-.002
CENTROID Y	:	-.089	.057	.148
POA TO CENTROID in.	:	.408	.233	.148
MIN RADIUS	:	.205	.105	.278
MEAN RADIUS	:	1.085	.909	.748
MAX RADIUS	:	2.028	1.960	1.510
HORIZONTAL SPREAD	:	3.186	3.186	2.645
VERTICAL SPREAD	:	2.163	1.439	1.252
EXTREME SPREAD	:	3.221	3.191	2.747
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	