

05587592

MODEL 700™ M24

Model S&S™

Action _____

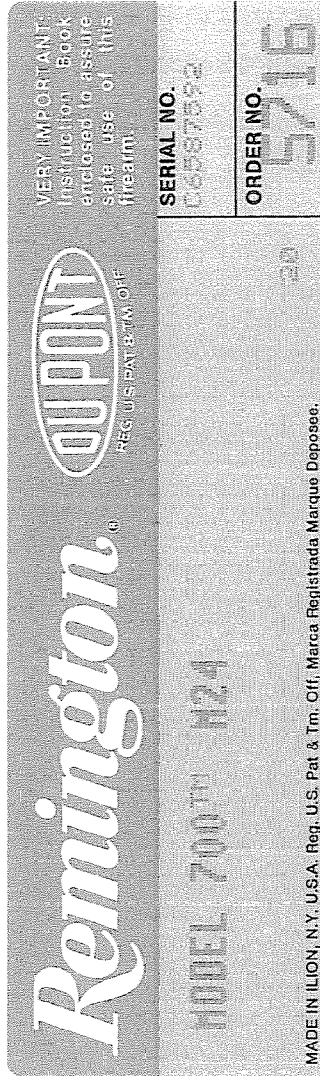
Barrel Length _____

Capacity _____

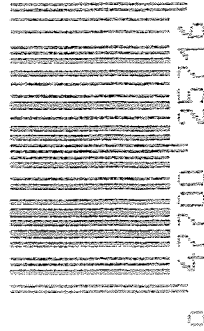
Order No. 5715

*Includes 1 in chamber.





UPC



5716 C6587592

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C 6587592

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	Kd
600	Proof		10/24/90	Kd
607	Check Headspace		10/24/90	Kd
610	Dis-assemble Gun		10/24/90	Kd
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		10/30/90	GL
617	Drill and Tap Sight Holes		11/6/90	W/B
618	Polish Barrel AB		11/7/90	W/B
620	Apply Coatings (Barrel Action)		11-20-90	W/B
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/15/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/18/91	KS
	C) Inspect Ejector Hole for Chamfer		1/18/91	KS
	D) Oil Firing Pin Ass'y		1/18/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		1-21-91	W/B

BARBER - M24 0023324

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5/4	5/4	5/4			1/21/91	WB
	G) Safety Off Force	3	3	3			1/21/91	WB
	H) Trigger Pull Test & Retainability						1-21-91	JB
	I) Firing Pin Indent	.021	.0205	.0205			1/21/91	WB
	J) Assemble Stock						1/21/91	KS
	K) Assemble Swivel Studs						2-4-91	K
	L) Attach Front and Rear Sight Assemblies						1/21/91	KS
	M) Iron Sight Alignment						1/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container						1/21/91	KS
	O) Attach Scope to Rifle						1/21/91	KS
	P) Detach & Attach Scope 20 Times						1/21/91	KS
640	Gallery Target & Test						1-22-91	DH
	A) Time						1-22-91	DH
	B) Malfunctions						1-22-91	DH
	C) Pierced Primers						1-22-91	DH
	D) Optical Clarity of Scope						1-22-91	DH
645	Inspect for Live Ammo						1-22-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.24	2.32	2.32	2.36	2.33	2-1-91	JB
	C) Function						2-4-91	AC
660	Pack						3-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587592

DATE 1-21-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.26	2.37	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.43	2.40	2.32	
PULL #3	2.46	2.49	2.44	2.32	
PULL #4	2.45	2.48	2.40	2.36	
PULL #5	2.49	2.46	2.43	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.19		
PULL #2	3.23	3.29		
PULL #3	3.22	3.37		
PULL #4	3.19	3.32		
PULL #5	3.26	3.22		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.35		4.22
PULL #2	4.20	4.31		4.25
PULL #3	4.18	4.27		4.26
PULL #4	4.20	4.26		4.23
PULL #5	4.21	4.30		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587592
23 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.395683
1 TO	2	.246223
1 TO	3	.637942
1 TO	4	.539676
1 TO	5	.549401

53 <----POA

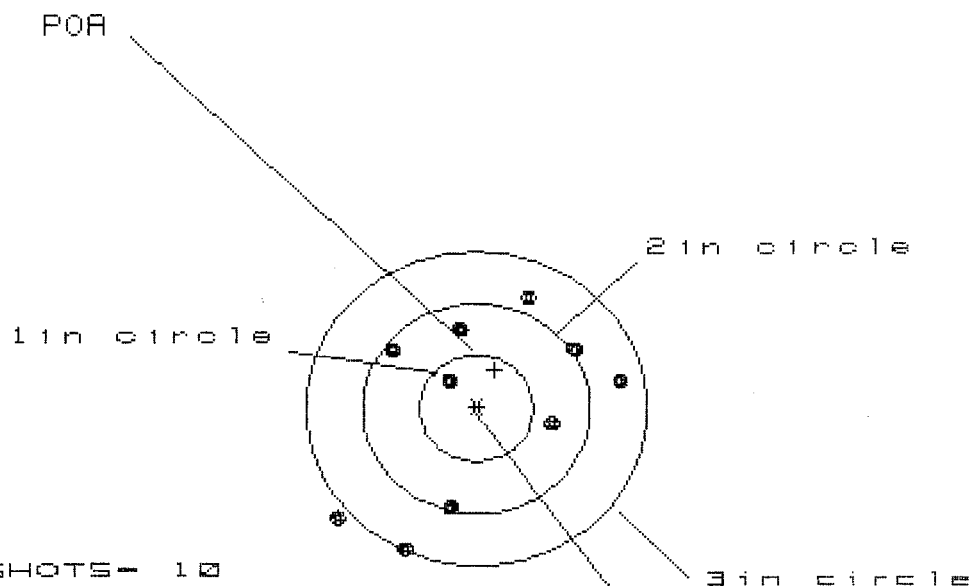
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0024
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.017
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0171686
THE AMR FOR THIS RIFLE IS: .9498

23 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587592

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.439

VS= 2.337

GS= 2.773

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.251	1.119	1.028
MINIMUM X	:	-1.188	-.918	-1.009
MAXIMUM Y	:	1.016	.902	.722
MINIMUM Y	:	-1.321	-1.435	-1.263
CENTROID X	:	-.162	-.030	.061
CENTROID Y	:	-.361	-.247	-.067
POA TO CENTROID in.	:	.396	.248	.091
MIN RADIUS	:	.379	.435	.502
MEAN RADIUS	:	1.018	.930	.811
MAX RADIUS	:	1.572	1.608	1.340
HORIZONTAL SPREAD	:	2.439	2.037	2.037
VERTICAL SPREAD	:	2.337	2.337	1.985
EXTREME SPREAD	:	2.773	2.561	2.098
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

23 Jan 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.633

VS= 2.518

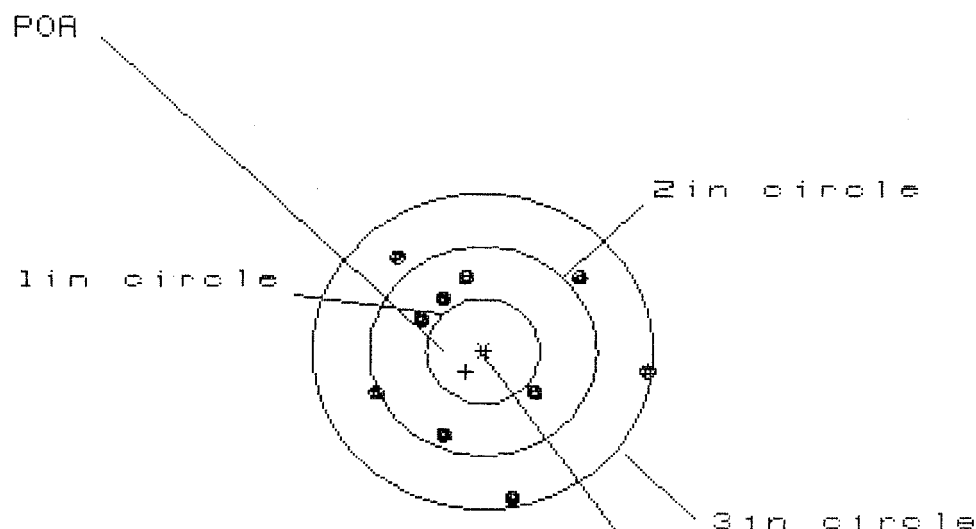
GS= 2.763

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.359	1.421	1.583
MINIMUM X	:	-1.274	-1.212	-1.050
MAXIMUM Y	:	1.099	.942	.814
MINIMUM Y	:	-1.419	-1.021	-.817
CENTROID X	:	-.017	-.079	-.241
CENTROID Y	:	-.162	-.005	.123
POA TO CENTROID in.	:	.163	.080	.270
MIN RADIUS	:	.407	.259	.061
MEAN RADIUS	:	1.112	1.034	.904
MAX RADIUS	:	1.526	1.645	1.608
HORIZONTAL SPREAD	:	2.633	2.633	2.633
VERTICAL SPREAD	:	2.518	1.963	1.631
EXTREME SPREAD	:	2.763	2.763	2.651
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 10

HS = 2.374

VS = 2.333

GS = 2.527

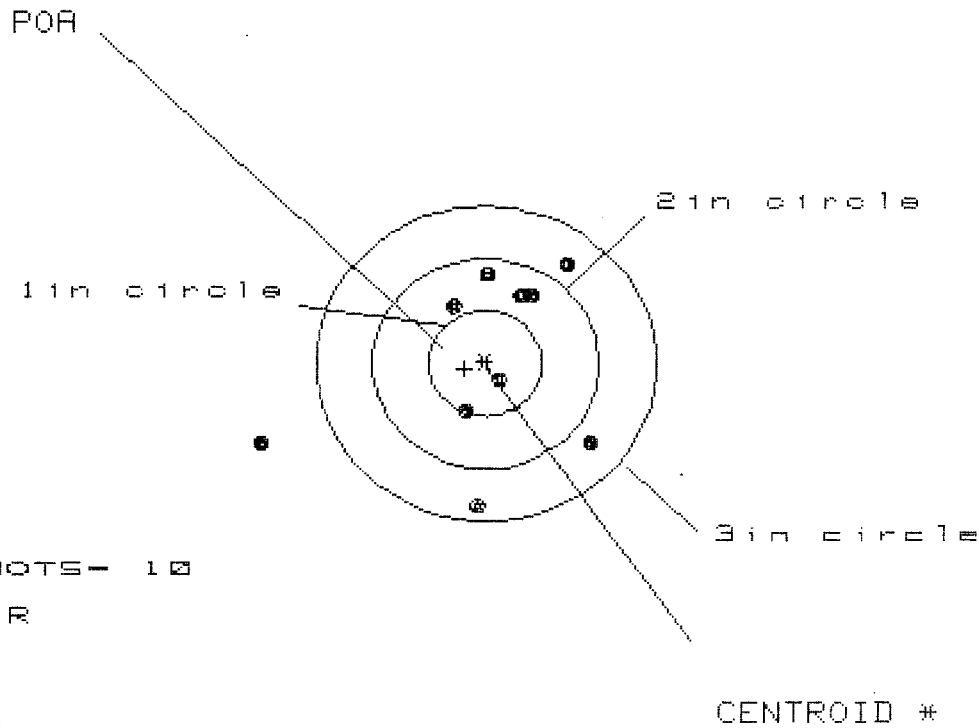
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	1.028	1.077
MINIMUM X	:	-.942	-.783	-.734
MAXIMUM Y	:	.943	.920	.744
MINIMUM Y	:	-1.390	-1.413	-.960
CENTROID X	:	.149	-.010	-.059
CENTROID Y	:	.196	.219	.395
POA TO CENTROID in.	:	.246	.219	.400
MIN RADIUS	:	.579	.444	.319
MEAN RADIUS	:	.947	.866	.751
MAX RADIUS	:	1.447	1.465	1.205
HORIZONTAL SPREAD	:	2.374	1.811	1.811
VERTICAL SPREAD	:	2.333	2.333	1.704
EXTREME SPREAD	:	2.527	2.527	2.128
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.905

VS= 2.316

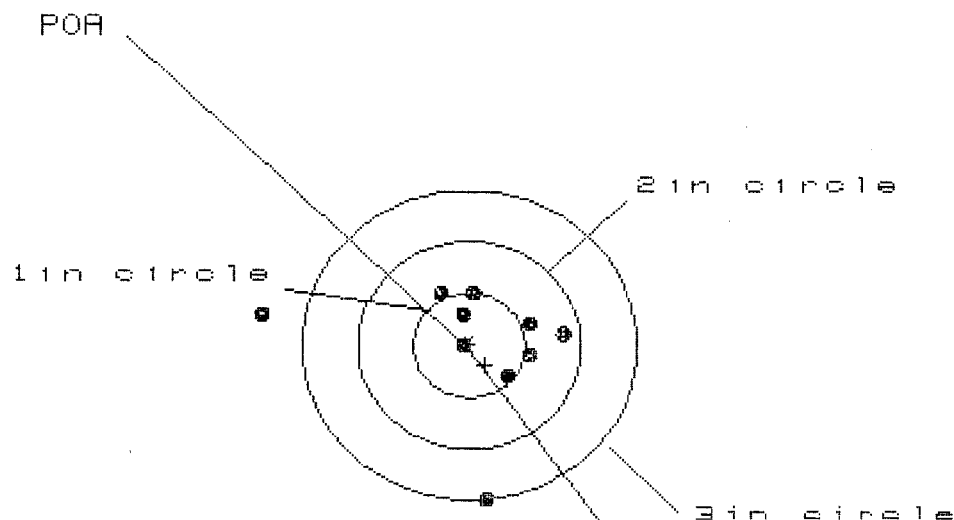
GS= 3.264

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.882	.657	.624
MINIMUM X	:	-2.023	-.555	-.588
MAXIMUM Y	:	.972	.885	.706
MINIMUM Y	:	-1.344	-1.431	-1.054
CENTROID X	:	.183	.408	.441
CENTROID Y	:	.054	.141	.320
POA TO CENTROID in.	:	.191	.432	.545
MIN RADIUS	:	.246	.284	.361
MEAN RADIUS	:	.957	.792	.675
MAX RADIUS	:	2.171	1.456	1.225
HORIZONTAL SPREAD	:	2.905	1.212	1.212
VERTICAL SPREAD	:	2.316	2.316	1.760
EXTREME SPREAD	:	3.264	2.440	1.809
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS = 2.699

VS = 1.956

GS = 2.706

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.596	.585
MINIMUM X	:	-1.893	-.493	-.504
MAXIMUM Y	:	.482	.512	.331
MINIMUM Y	:	-1.474	-1.444	-.419
CENTROID X	:	-.141	.069	.080
CENTROID Y	:	.188	.158	.339
POA TO CENTROID in.	:	.235	.173	.348
MIN RADIUS	:	.100	.268	.285
MEAN RADIUS	:	.715	.555	.416
MAX RADIUS	:	1.912	1.447	.595
HORIZONTAL SPREAD	:	2.699	1.089	1.089
VERTICAL SPREAD	:	1.956	1.956	.750
EXTREME SPREAD	:	2.706	1.983	1.160
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	