

C6636291

MODEL 700™ M24

Model **SMS**™

Action

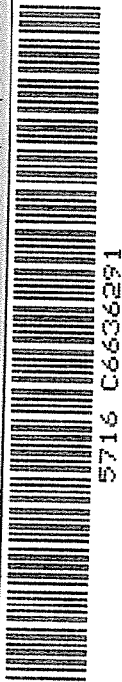
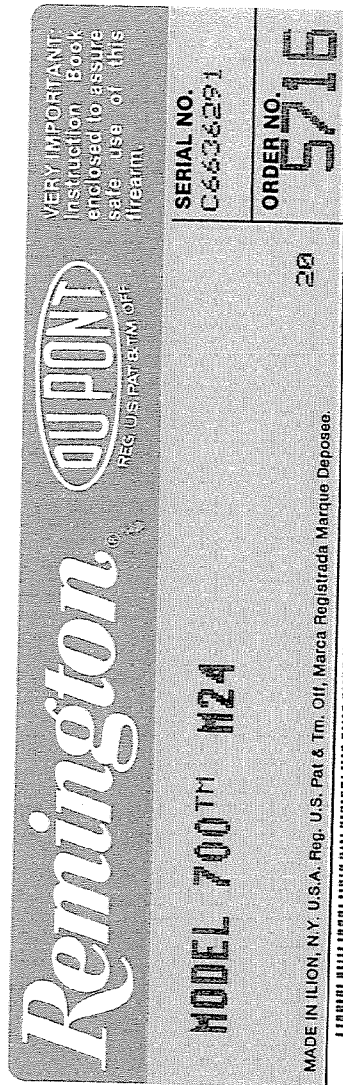
Barrel Length

Capacity

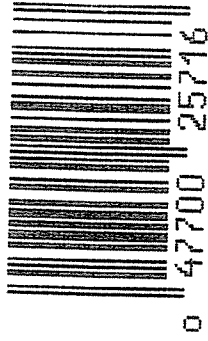
Order No. **5716**

*Includes 1 in chamber.





UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # **C6636291**

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber	0 0 0 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		FB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-8-91	JA
	Apply Coating (Bolt)		5-8-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	KS
	C) Inspect Ejector Hole for Chamfer		5/30/91	KS
	D) Oil Firing Pin Ass'y		5/30/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	JA

op. #	BARBER - M24 0032683	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	4	6			6-5-91	JH
	G) Safety Off Force	3	3	3			6-5-91	JH
	H) Trigger Pull Test & Retainability						6-5-91	JH
	I) Firing Pin Indent	.021	.0215	.0215			6-5-91	JH
	J) Assemble Stock						4/5/91	KS
	K) Assemble Swivel Studs						6-13-91	A
	L) Attach Front and Rear Sight Assemblies						4/5/91	KS
	M) Iron Sight Alignment						4/5/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/5/91	KS
	O) Attach Scope to Rifle						4/5/91	KS
	P) Detach & Attach Scope 20 Times						4/5/91	KS
640	Gallery Target & Test						6-6-91	DH
	A) Time						6-6-91	DH
	B) Malfunctions						6-6-91	DH
	C) Pierced Primers						6-6-91	DH
	D) Optical Clarity of Scope						6-6-91	DH
645	Inspect for Live Ammo						6-6-91	DH
655	Final Inspection							
	A) Headspace						6-13-91	A
	B) Trigger Pull	2.48	2.48	2.46	2.41	2.40	6-13-91	JH
	C) Function						6-13-91	A
660	Pack						6-20-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636291

DATE 6-5-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.39	2.44	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.36	2.48	2.48	
PULL #3	2.39	2.36	2.36	2.46	
PULL #4	2.35	2.34	2.39	2.41	
PULL #5	2.31	2.40	2.44	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.17		
PULL #2	3.34	3.15		
PULL #3	3.38	3.27		
PULL #4	3.30	3.21		
PULL #5	3.32	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	4.40	4.39		4.21
PULL #2	4.35	4.41		4.43
PULL #3	4.33	4.42		4.41
PULL #4	4.32	4.33		4.40
PULL #5	4.29	4.46		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636291
6 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.24891
1 TO	2	.656327
1 TO	3	.423647
1 TO	4	.345475
1 TO	5	.413417


 <----POA

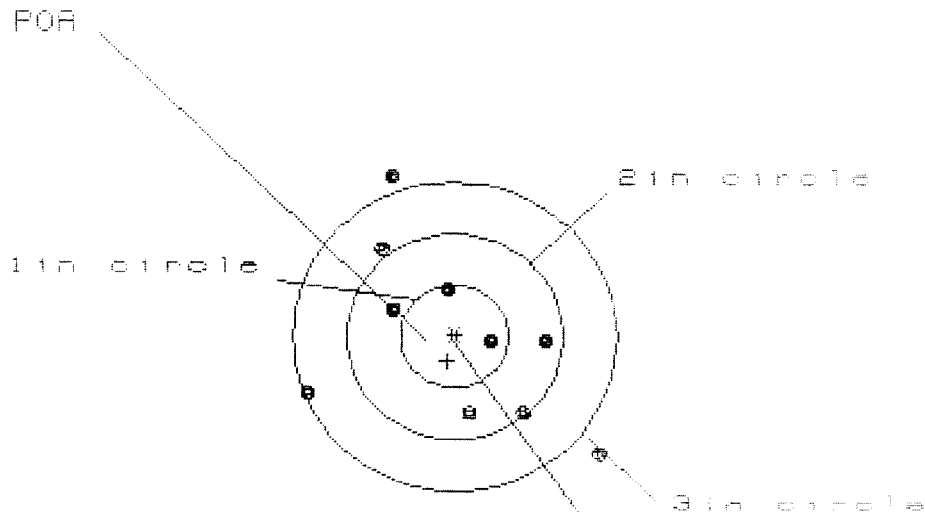
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1712
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .037
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .175153

THE AMR FOR THIS RIFLE IS: .9238

6 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08635291

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.627

VS= 2.685

GS= 3.291

CENTROID +

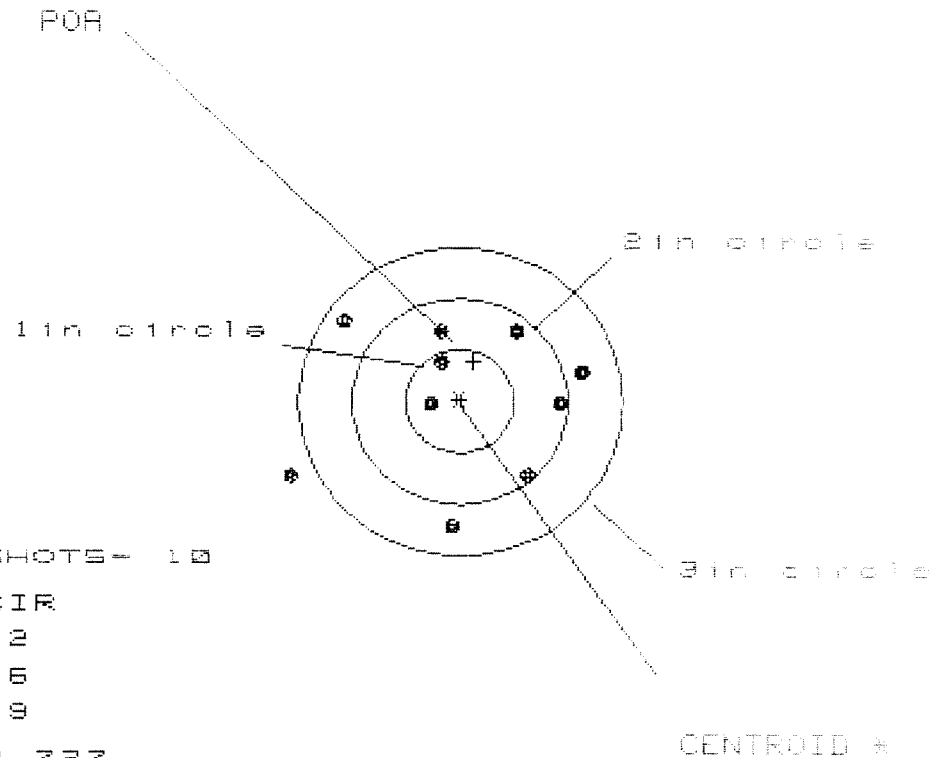
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.297	1.087	.949
MINIMUM X	:	-1.330	-1.186	-1.244
MAXIMUM Y	:	1.528	1.400	.945
MINIMUM Y	:	-1.157	-.905	-.730
CENTROID X	:	.066	-.078	-.020
CENTROID Y	:	.240	.368	.193
POA TO CENTROID in.	:	.249	.376	.194
MIN RADIUS	:	.320	.325	.408
MEAN RADIUS	:	.998	.906	.832
MAX RADIUS	:	1.738	1.474	1.323
HORIZONTAL SPREAD	:	2.627	2.193	2.193
VERTICAL SPREAD	:	2.685	2.305	1.675
EXTREME SPREAD	:	3.291	2.627	2.245
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636291

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.727

VS= 1.996

GS= 2.894

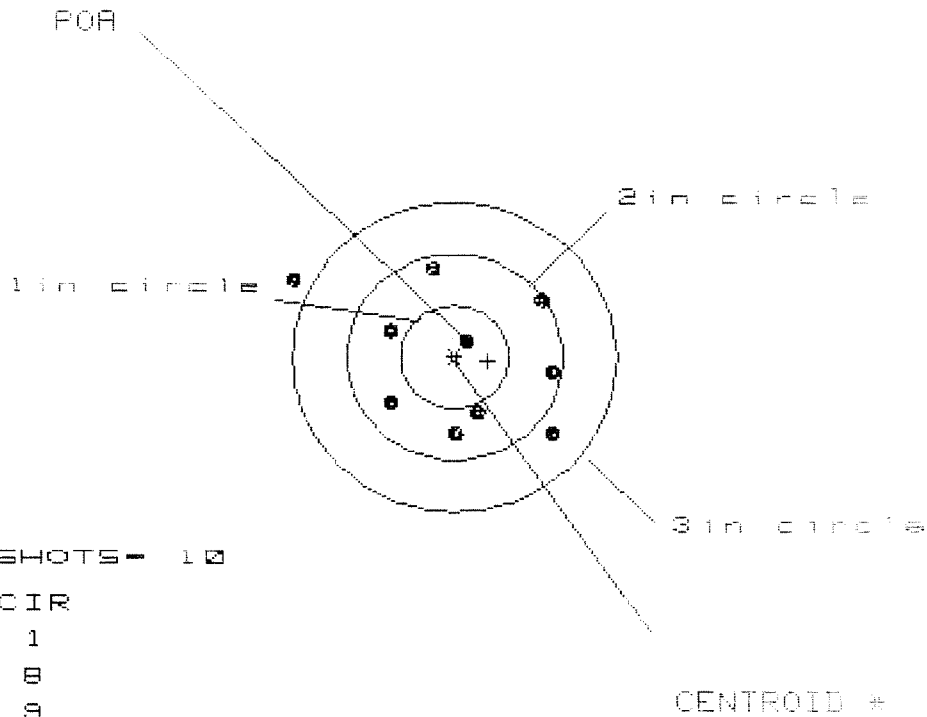
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.166	.992	.832
MINIMUM X	:	-1.561	-1.283	-.569
MAXIMUM Y	:	.762	.681	.698
MINIMUM Y	:	-1.234	-1.315	-1.229
CENTROID X	:	-.128	.046	.206
CENTROID Y	:	-.387	-.306	-.392
POA TO CENTROID in.	:	.408	.310	.442
MIN RADIUS	:	.238	.425	.570
MEAN RADIUS	:	.964	.868	.795
MAX RADIUS	:	1.722	1.452	1.282
HORIZONTAL SPREAD	:	2.727	2.275	1.401
VERTICAL SPREAD	:	1.996	1.996	1.927
EXTREME SPREAD	:	2.894	2.334	2.013
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06835291

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.415

VS= 1.659

GS= 2.867

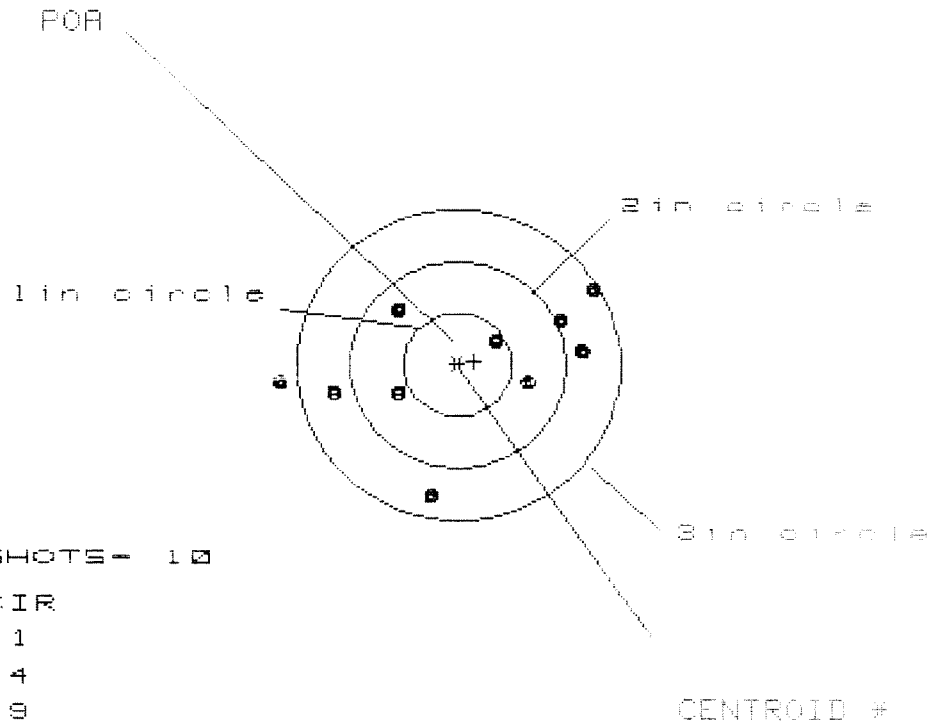
PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.937
MINIMUM X	:	-1.478
MAXIMUM Y	:	.873
MINIMUM Y	:	-.786
CENTROID X	:	-.308
CENTROID Y	:	.041
POA TO CENTROID in.	:	.311
MIN RADIUS	:	.205
MEAN RADIUS	:	.862
MAX RADIUS	:	1.678
HORIZONTAL SPREAD	:	2.415
VERTICAL SPREAD	:	1.659
EXTREME SPREAD	:	2.867
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	8
NUMBER IN THREE INCH CIRCLE	=	9

CENTROID *

8 Jun 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.900

VS= 2.065

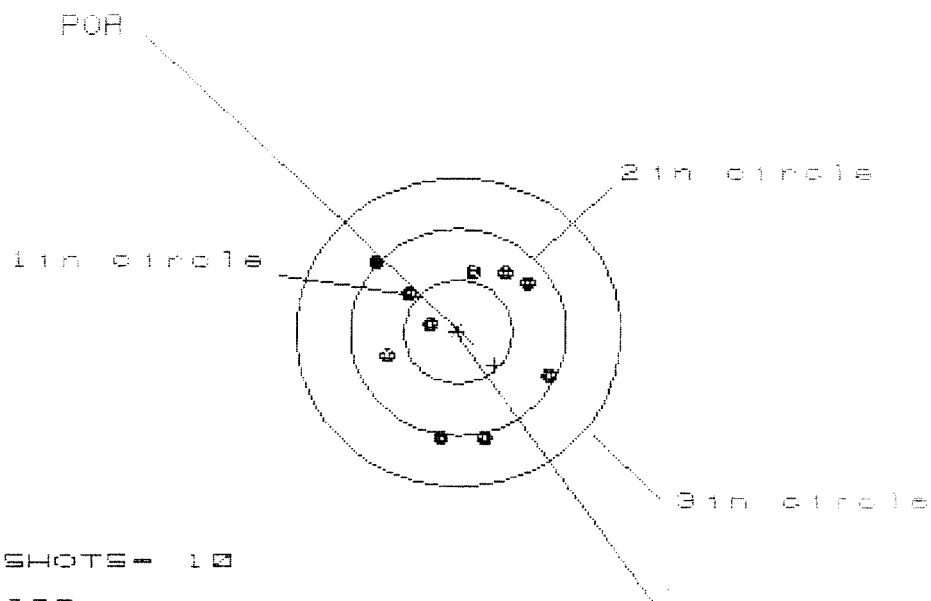
GS= 3.032

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.200	1.011	1.043
MINIMUM X	:	-1.700	-1.382	-1.255
MAXIMUM Y	:	.757	.743	.567
MINIMUM Y	:	-1.308	-1.322	-1.229
CENTROID X	:	-.147	.042	-.085
CENTROID Y	:	-.032	-.018	-.111
POA TO CENTROID in.	:	.151	.045	.140
MIN RADIUS	:	.385	.253	.399
MEAN RADIUS	:	1.020	.914	.883
MAX RADIUS	:	1.704	1.410	1.269
HORIZONTAL SPREAD	:	2.900	2.393	2.298
VERTICAL SPREAD	:	2.065	2.065	1.796
EXTREME SPREAD	:	3.032	2.602	2.339
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Jun 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS = 1.635

VS = 1.683

GS = 1.883

PATTERN #	5	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.867	.899	.896
MINIMUM X	-.768	-.736	-.671
MAXIMUM Y	.645	.538	.562
MINIMUM Y	-1.038	-1.104	-1.038
CENTROID X	-.339	-.371	-.278
CENTROID Y	.323	.438	.372
POA TO CENTROID in.	.468	.574	.465
MIN RADIUS	.289	.251	.340
MEAN RADIUS	.775	.718	.706
MAX RADIUS	1.075	1.111	1.060
HORIZONTAL SPREAD	1.635	1.635	1.478
VERTICAL SPREAD	1.683	1.634	1.608
EXTREME SPREAD	1.983	1.977	1.782
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		