

C6636033

MODEL 700™ M24

Model **S&S**™

Action

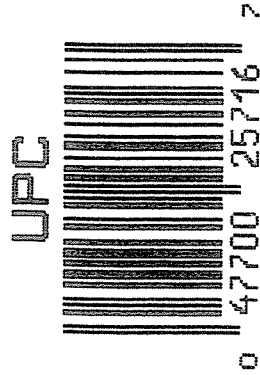
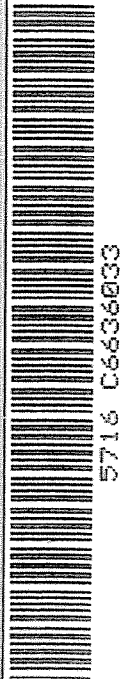
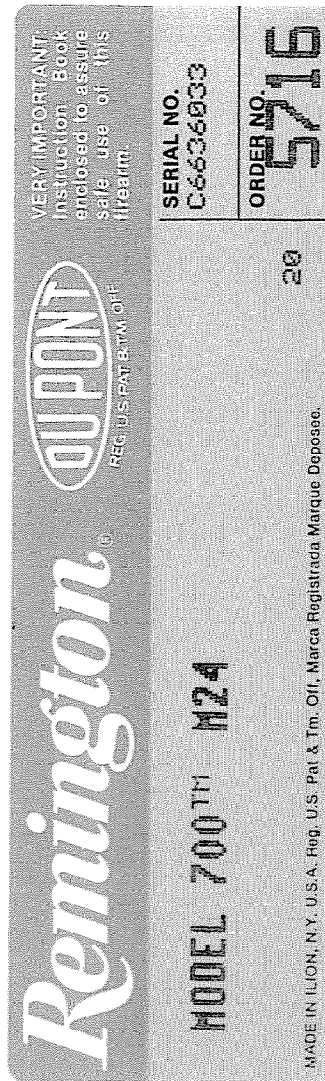
Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636033

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 8 91		RW
600	Proof	1 8 91		RW
607	Check Headspace			RW
610	Dis-assemble Gun			RW
612	Magnaflux Barrel Action		APR 9 1991	K.R
	Magnaflux Bolt		APR 9 1991	CC
615	Rollmark Caliber		APR 9 1991	GL
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	CCB
620	Apply Coatings (Barrel Action)		5-10-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/14/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/14/91	RW
	C) Inspect Ejector Hole for Chamfer		5/14/91	RW
	D) Oil Firing Pin Ass'y		5/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/25/91	GL

Op. #	BARBER - M24 0036910 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			5-28-91	DH
	G) Safety Off Force	3	3	3			5-28-91	DH
	H) Trigger Pull Test & Retainability						5/25/91	JP
	I) Firing Pin Indent	.020	.020	.020			5-28-91	DH
	J) Assemble Stock						5/29/91	Ru
	K) Assemble Swivel Studs						6-1-91	DH
	L) Attach Front and Rear Sight Assemblies						5/29/91	Ru
	M) Iron Sight Alignment						5/29/91	Ru
	N) Detach Front & Rear Sights & place in numbered container						5/29/91	Ru
	O) Attach Scope to Rifle						5/29/91	Ru
	P) Detach & Attach Scope 20 Times						5/29/91	Ru
640	Gallery Target & Test						5-31-91	DH
	A) Time						5-31-91	DH
	B) Malfunctions						5-31-91	DH
	C) Pierced Primers						5-31-91	DH
	D) Optical Clarity of Scope						5-31-91	DH
645	Inspect for Live Ammo						5-31-91	DH
655	Final Inspection							
	A) Headspace						6-1-91	DH
	B) Trigger Pull	2.57	2.36	2.47	2.38	2.26	6/1/91	JP
	C) Function						6-1-91	DH
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. C6636033

DATE 5/25/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.18	2.47	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.46	2.45	2.36	
PULL #3	2.51	2.39	2.59	2.42	
PULL #4	2.53	2.39	2.48	2.38	
PULL #5	2.51	2.23	2.50	2.26	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.44		
PULL #2	3.35	3.32		
PULL #3	3.43	3.26		
PULL #4	3.43	3.32		
PULL #5	3.36	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	4.25	4.27		4.33
PULL #2	4.18	4.34		4.19
PULL #3	4.23	4.40		4.30
PULL #4	4.29	4.40		4.31
PULL #5	4.18	4.32		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636033
31 May 1991

CENTROIDAL DISTANCES

0 TO 1	.147635
1 TO 2	.251734
1 TO 3	.0820366
1 TO 4	.0516236
1 TO 5	.154117

24 <----POA

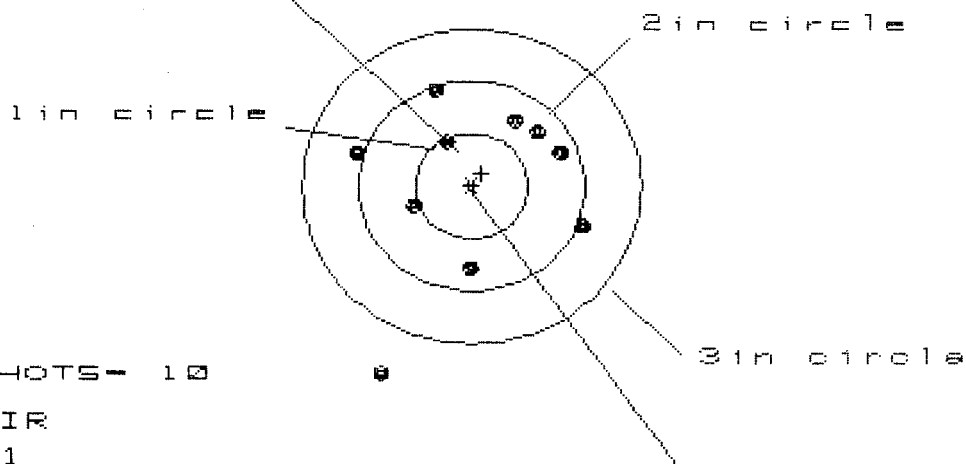
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1286
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1192
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .175347
THE AMR FOR THIS RIFLE IS: .9662

31 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636033

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in - 9

HS- 2.031

VS- 2.736

GS- 2.782

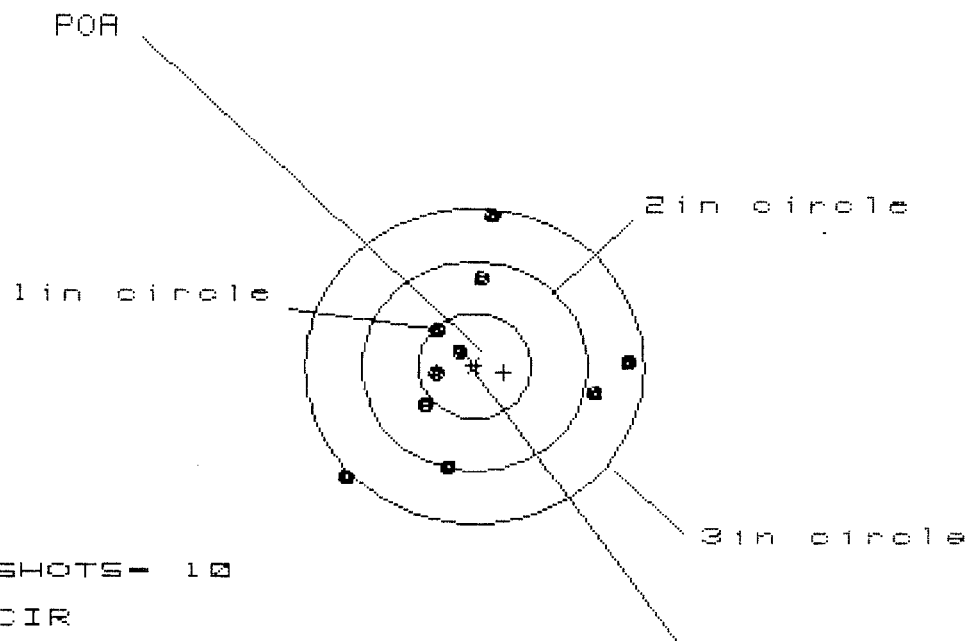
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.989	.903	.762
MINIMUM X	-1.042	-1.128	-.707
MAXIMUM Y	.940	.740	.750
MINIMUM Y	-1.796	-.981	-.971
CENTROID X	-.086	-.000	.141
CENTROID Y	-.120	.080	.070
POA TO CENTROID in.	.148	.080	.157
MIN RADIUS	.497	.394	.500
MEAN RADIUS	.930	.776	.720
MAX RADIUS	1.956	1.130	.997
HORIZONTAL SPREAD	2.031	2.031	1.469
VERTICAL SPREAD	2.736	1.721	1.721
EXTREME SPREAD	2.782	2.148	1.856
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.532

VS= 2.436

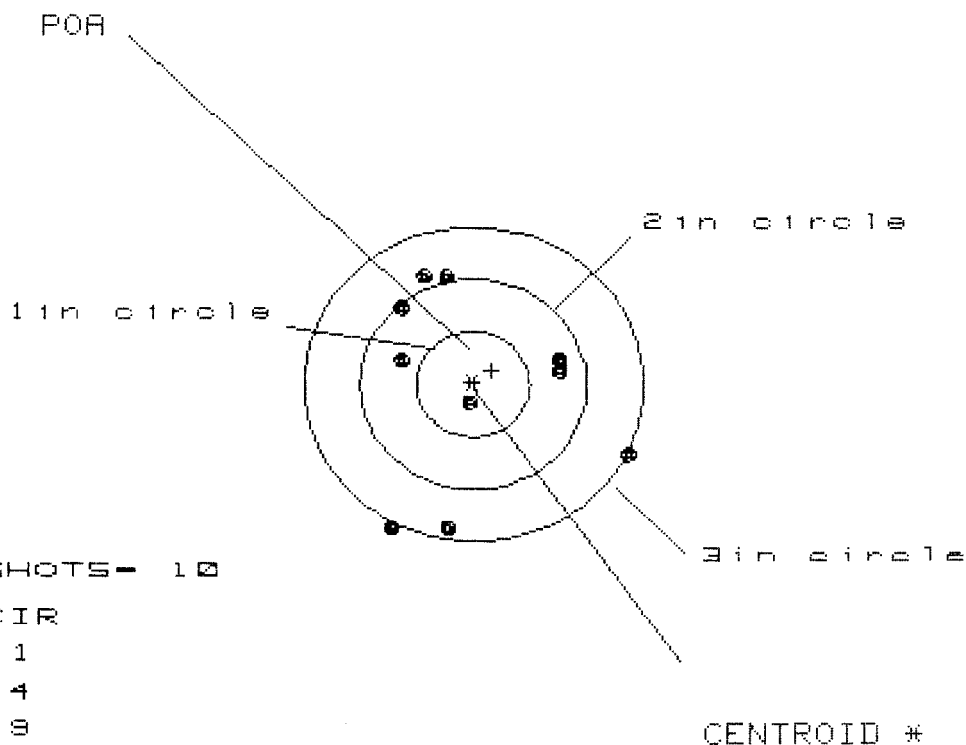
GS= 2.779

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.346	1.214	1.216
MINIMUM X	:	-1.186	-.589	-.587
MAXIMUM Y	:	1.409	1.294	.841
MINIMUM Y	:	-1.028	-1.122	-.960
CENTROID X	:	-.263	-.131	-.133
CENTROID Y	:	.059	.173	.011
POA TO CENTROID in.	:	.269	.217	.134
MIN RADIUS	:	.197	.261	.324
MEAN RADIUS	:	.890	.828	.768
MAX RADIUS	:	1.569	1.294	1.218
HORIZONTAL SPREAD	:	2.532	1.803	1.803
VERTICAL SPREAD	:	2.436	2.416	1.801
EXTREME SPREAD	:	2.779	2.452	1.911
NUMBER IN ONE INCH CIRCLE	=		2	
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 = 1

2 in = 4

3 in = 9

HS = 2.065

VS = 2.471

GS = 2.531

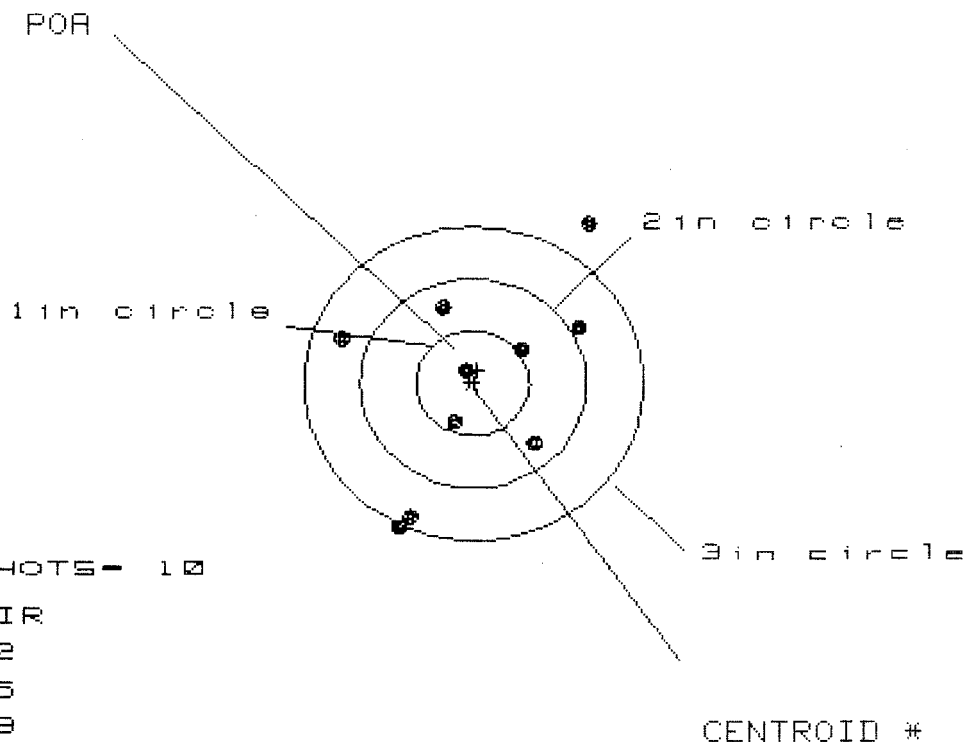
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.319	1.236	.857
MINIMUM X	:	-.746	-.722	-.567
MAXIMUM Y	:	1.073	.918	.818
MINIMUM Y	:	-1.398	-1.505	-1.605
CENTROID X	:	-.167	-.084	-.239
CENTROID Y	:	-.133	.022	.122
POA TO CENTROID in.	:	.214	.087	.268
MIN RADIUS	:	.147	.323	.390
MEAN RADIUS	:	1.002	.925	.833
MAX RADIUS	:	1.584	1.539	1.613
HORIZONTAL SPREAD	:	2.065	1.958	1.424
VERTICAL SPREAD	:	2.471	2.423	2.423
EXTREME SPREAD	:	2.531	2.423	2.423
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.201

VS = 2.863

GS = 3.327

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.031	1.050	.981
MINIMUM X	:	-1.170	-1.055	-1.124
MAXIMUM Y	:	1.519	.851	.704
MINIMUM Y	:	-1.344	-1.175	-1.222
CENTROID X	:	-.035	-.150	-.081
CENTROID Y	:	-.128	-.297	-.150
POA TO CENTROID in.	:	.133	.333	.171
MIN RADIUS	:	.176	.252	.184
MEAN RADIUS	:	.961	.865	.787
MAX RADIUS	:	1.836	1.297	1.328
HORIZONTAL SPREAD	:	2.201	2.105	2.105
VERTICAL SPREAD	:	2.863	2.026	1.926
EXTREME SPREAD	:	3.327	2.451	2.311
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.093

VS= 1.918

GS= 3.094

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.171	.957	1.034
MINIMUM X	:	-1.922	-1.598	-1.521
MAXIMUM Y	:	.700	.661	.504
MINIMUM Y	:	-1.218	-1.257	-.581
CENTROID X	:	-.092	.122	.045
CENTROID Y	:	-.274	-.235	-.078
POA TO CENTROID in.	:	.289	.265	.090
MIN RADIUS	:	.472	.428	.507
MEAN RADIUS	:	1.048	.923	.853
MAX RADIUS	:	1.953	1.627	1.528
HORIZONTAL SPREAD	:	3.093	2.555	2.555
VERTICAL SPREAD	:	1.918	1.918	1.085
EXTREME SPREAD	:	3.094	2.707	2.626
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	