

UPC



0 47700 25716 7

INCLUDES 1 IN CHAMBER

C6702931

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6702931

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/92	RW
600	Proof		5/1/92	RW
607	Check Headspace		5/1/92	RW
610	Dis-assemble Gun		5/1/92	RW
612	Magnaflux Barrel Action	MAY	5 1992	Kcl
	Magnaflux Bolt	MAY	5 1992	Kcl
615	Rollmark Caliber	MAY	5 1992	CS
617	Drill and Tap Sight Holes	MAY	5	LB
618	Polish Barrel	MAY	5	WB
620	Apply Coatings (Barrel Action)		6-10-92	JA
	Apply Coating (Bolt)			P
625	Final Assembly A) Clean inside of Bolt Assembly		6/13/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/13/92	RW
	C) Inspect Ejector Hole for Chamfer		6/13/92	RW
	D) Oil Firing Pin Ass'y		6/13/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/16/92	RW

op. #	BARBER - M24 0105410		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5	5	5			6/16/92	RW
	G) Safety Off Force		3	3	3			6/16/92	RW
	H) Trigger Pull Test & Retainability							6/16/92	RW
	I) Firing Pin Indent		.0205	.021	.021			6/16/92	RW
	J) Assemble Stock							6/16/92	RW
	K) Assemble Swivel Studs								
	L) Attach Front and Rear Sight Assemblies								
	M) Iron Sight Alignment								
	N) Detach Front & Rear Sights & place in numbered container								
	O) Attach Scope to Rifle							6/16/92	RW
	P) Detach & Attach Scope 20 Times							6/16/92	RW
640	Gallery Target & Test							6-24-92	DH
	A) Time							6-24-92	DH
	B) Malfunctions							6-24-92	DH
	C) Pierced Primers							6-24-92	DH
	D) Optical Clarity of Scope							6-24-92	DH
645	Inspect for Live Ammo							6-24-92	DH
655	Final Inspection								
	A) Headspace							6/24/92	RW
	B) Trigger Pull		2.54	2.64	2.72	2.84	2.27	6/24/92	RW
	C) Function							6/24/92	RW
660	Pack								

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

SERIAL NO. CG702931DATE 6/16/92TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.28	2.35	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.33	2.39	2.64	
PULL #3	2.41	2.29	2.50	2.72	
PULL #4	2.39	2.26	2.47	2.84	
PULL #5	2.38	2.35	2.28	2.27	
TOTAL	12.18	11.51	11.99	13.01	
AVG.	2.44	2.30	2.40	2.60	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.22		
PULL #2	3.12	3.23		
PULL #3	3.19	3.07		
PULL #4	3.18	3.27		
PULL #5	3.24	3.08		
TOTAL	15.87	15.87		
AVG.	3.17	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.19		4.39
PULL #2	4.09	4.24		4.39
PULL #3	4.13	4.30		4.42
PULL #4	4.20	4.14		4.19
PULL #5	4.17	4.35		4.45
TOTAL	20.62	21.22		21.84
AVG.	4.12	4.24		4.37

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702931
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.238619
1 TO	2	.347455
1 TO	3	.0380586
1 TO	4	.503391
1 TO	5	.12

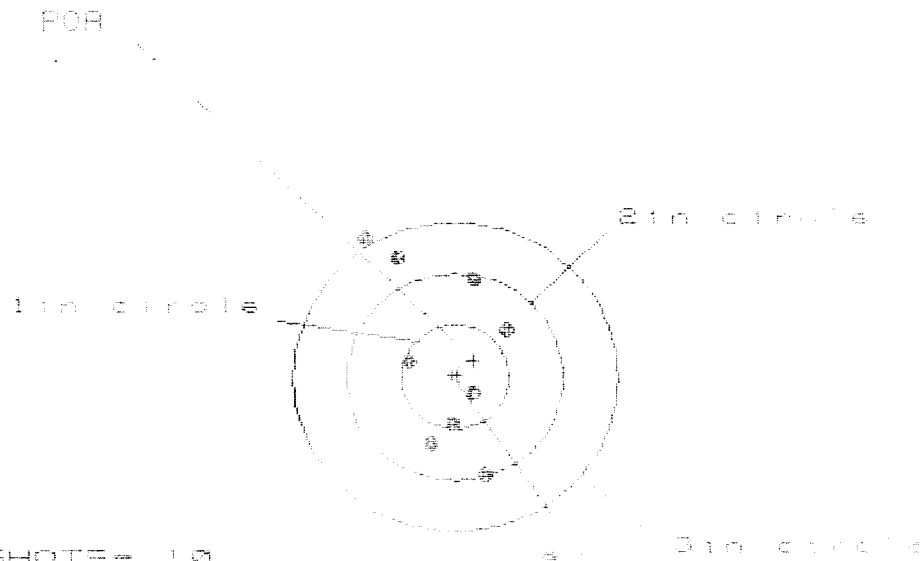
3E -1000000 FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: 8.00
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 8.00
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.00
THE AMR FOR THIS RIFLE IS: 1.003

24 Jun 1992

FILE: \PATTERNING\CENTERFIRE_PATT\08702931

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HE = 1.728

VE = 3.101

GE = 3.550

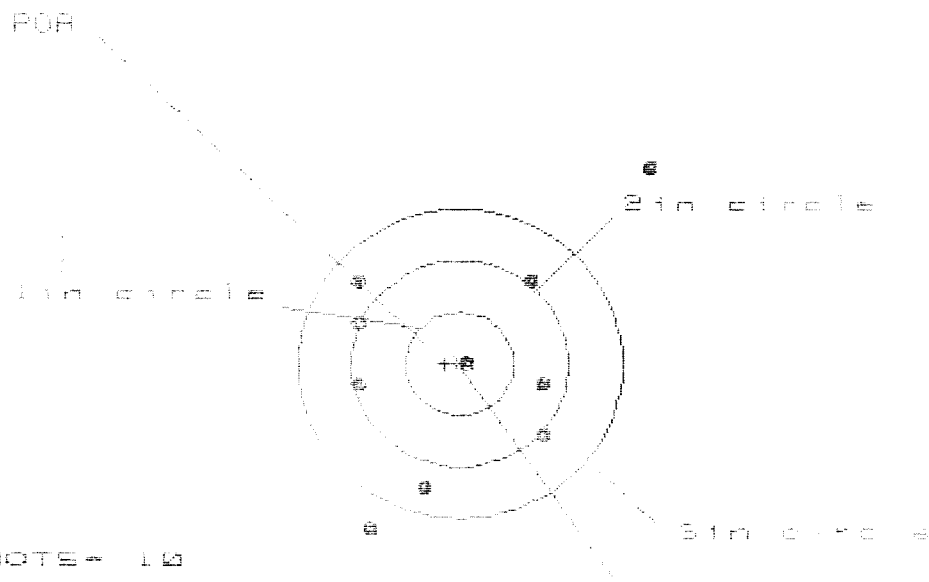
CENTROID =

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	9
MAXIMUM X	1.975	1.600	1.509
MINIMUM X	-1.853	-1.756	-1.475
MAXIMUM Y	1.339	1.143	1.113
MINIMUM Y	-1.762	-1.182	-1.035
CENTROID X	-1.173	-1.270	-1.175
CENTROID Y	-1.157	1.039	-1.104
POB TO CENTROID in.	1.234	1.273	1.205
MIN RADIUS	1.274	1.314	1.312
MEAN RADIUS	1.938	1.827	1.733
MAX RADIUS	1.967	1.370	1.210
HORIZONTAL SPREAD	1.728	1.359	1.984
VERTICAL SPREAD	3.101	2.325	2.152
EXTREME SPREAD	3.550	2.576	2.274
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

24 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8702931

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.716

VS = 3.474

GS = 4.389

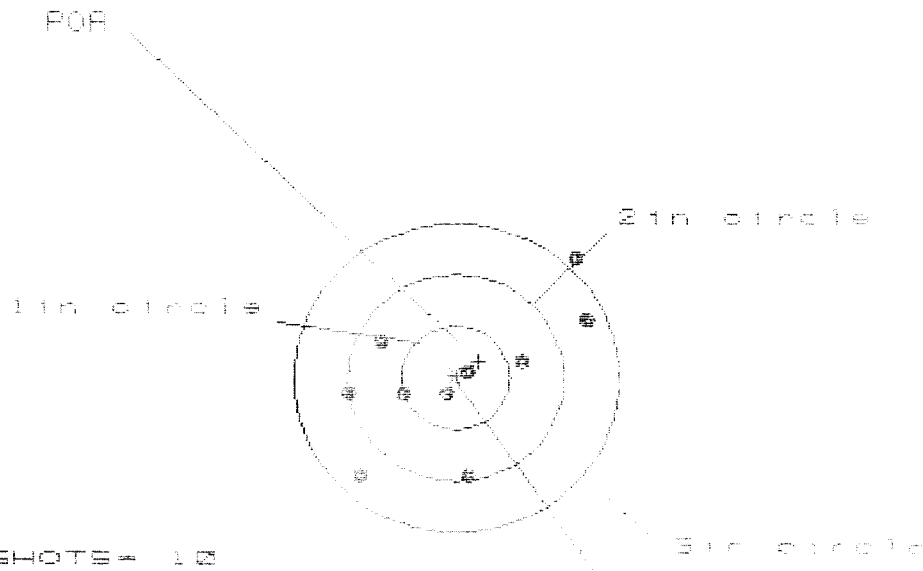
CENTROID *

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.740
MINIMUM X	:	-1.978
MAXIMUM Y	:	1.902
MINIMUM Y	:	-1.572
CENTROID X	:	.139
CENTROID Y	:	-.004
POA TO CENTROID IN.	:	.139
MIN RADIUS	:	.077
MEAN RADIUS	:	1.177
MAX RADIUS	:	2.578
HORIZONTAL SPREAD	:	2.716
VERTICAL SPREAD	:	3.474
EXTREME SPREAD	:	4.389
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

1 in = 2

2 in = 7

3 in = 9

HSE = 2.165

VSE = 2.156

ESE = 2.944

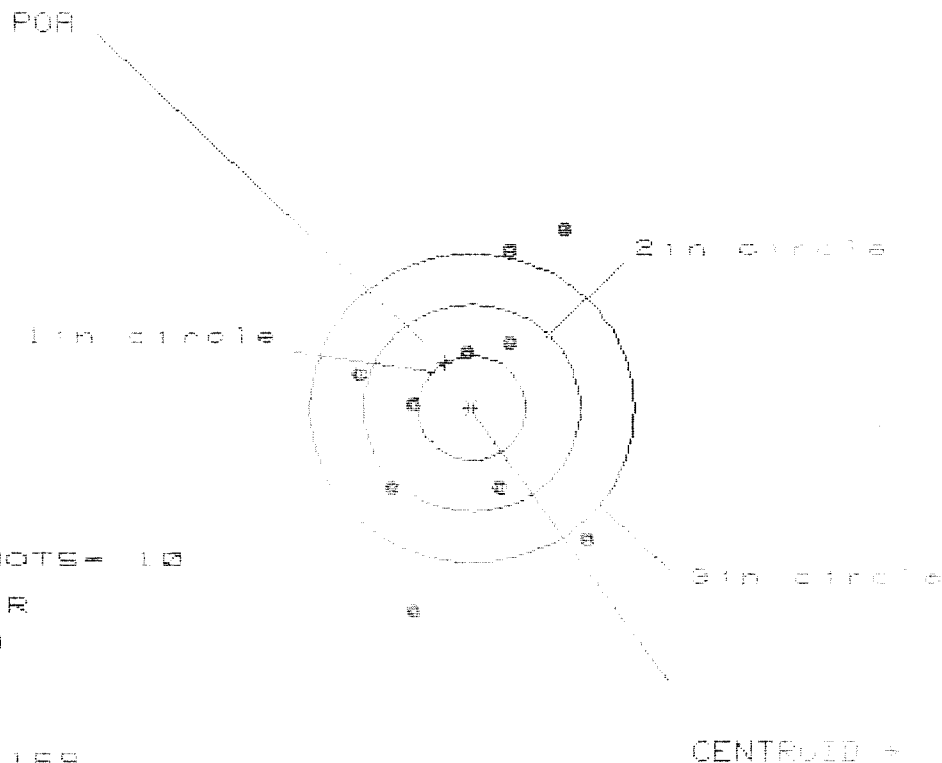
CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.323	1.658
MINIMUM X	:	-1.968	-1.842	-1.677
MAXIMUM Y	:	1.177	1.707	1.584
MINIMUM Y	:	-1.979	-1.849	-1.760
CENTROID X	:	-1.211	-1.337	-1.502
CENTROID Y	:	-1.159	-1.289	-1.378
POA TO CENTROID in.	:	.264	.444	.620
MIN RADIUS	:	.126	.082	.225
MEAN RADIUS	:	.839	.728	.628
MAX RADIUS	:	1.635	1.500	1.955
HORIZONTAL SPREAD	:	2.165	2.165	1.535
VERTICAL SPREAD	:	2.156	1.556	1.344
EXTREME SPREAD	:	2.944	2.587	1.838
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 6

HS= 2.169

VS= 3.654

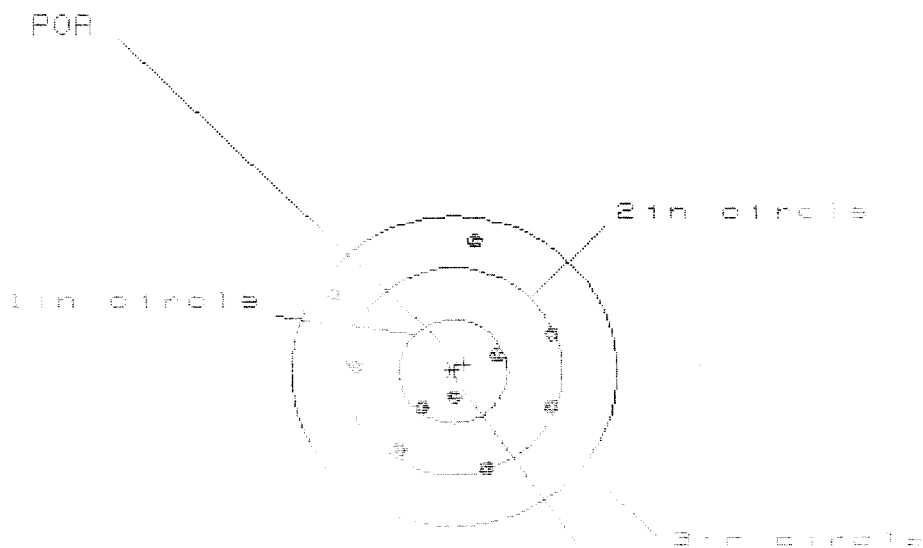
GS= 3.934

PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.062
MINIMUM X	:	-1.087
MAXIMUM Y	:	1.718
MINIMUM Y	:	-1.936
CENTROID X	:	.246
CENTROID Y	:	-.436
POA TO CENTROID in.	:	.500
MIN RADIUS	:	.535
MEAN RADIUS	:	1.208
MAX RADIUS	:	2.017
HORIZONTAL SPREAD	:	2.169
VERTICAL SPREAD	:	3.654
EXTREME SPREAD	:	3.934
NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	6

24 Jun 1962

FILE:/PATTERNING/CENTERFIRE_PATT/06702931

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 2.014

VS = 2.196

GS = 2.237

CENTROID *

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.940	.823	.832
MINIMUM X	-1.072	-1.971	-1.962
MAXIMUM Y	1.261	1.350	.632
MINIMUM Y	-.935	-.346	-.677
CENTROID X	-.181	.013	.009
CENTROID Y	-.061	-.150	-.319
POB TO CENTROID in.	.118	.151	.319
MIN RADIUS	.277	.219	.104
MEAN RADIUS	.852	.774	.671
MAX RADIUS	1.338	1.352	1.046
HORIZONTAL SPREAD	2.014	1.794	1.794
VERTICAL SPREAD	2.196	2.196	1.311
EXTREME SPREAD	2.237	2.198	1.825
NUMBER IN ONE 1 in CIRCLE =		3	
NUMBER IN TWO 2 in CIRCLE =		7	
NUMBER IN THREE 3 in CIRCLE =		10	