

C6522338

MODEL 700™ M24

Model **S&S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522338
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.363259
1 TO	2	.557869
1 TO	3	.607049
1 TO	4	.424156
1 TO	5	.300927

$\frac{342}{91}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0584
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0517629
THE AMR FOR THIS RIFLE IS: 1.018

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522338

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.154

VS= 2.086

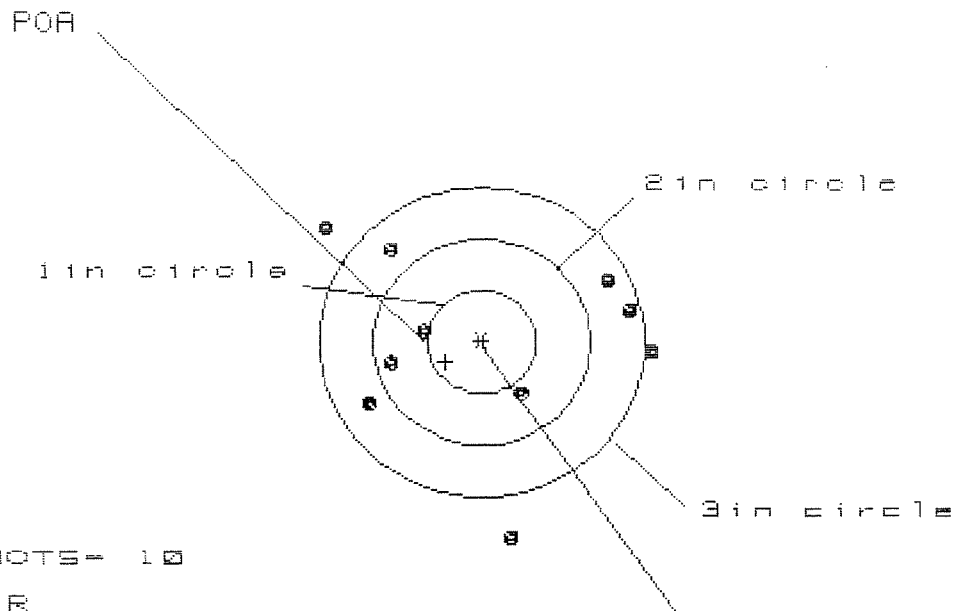
GS= 3.154

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.810	1.405	1.369
MINIMUM X	:	-1.344	-1.142	-.967
MAXIMUM Y	:	1.161	1.118	1.236
MINIMUM Y	:	-.925	-.968	-.829
CENTROID X	:	.154	-.048	-.223
CENTROID Y	:	-.329	-.286	-.425
POA TO CENTROID in.	:	.363	.289	.480
MIN RADIUS	:	.457	.395	.464
MEAN RADIUS	:	1.139	1.022	.881
MAX RADIUS	:	1.853	1.795	1.845
HORIZONTAL SPREAD	:	3.154	2.547	2.336
VERTICAL SPREAD	:	2.086	2.086	2.065
EXTREME SPREAD	:	3.154	2.959	2.769
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.033

VS= 2.931

GS= 3.391

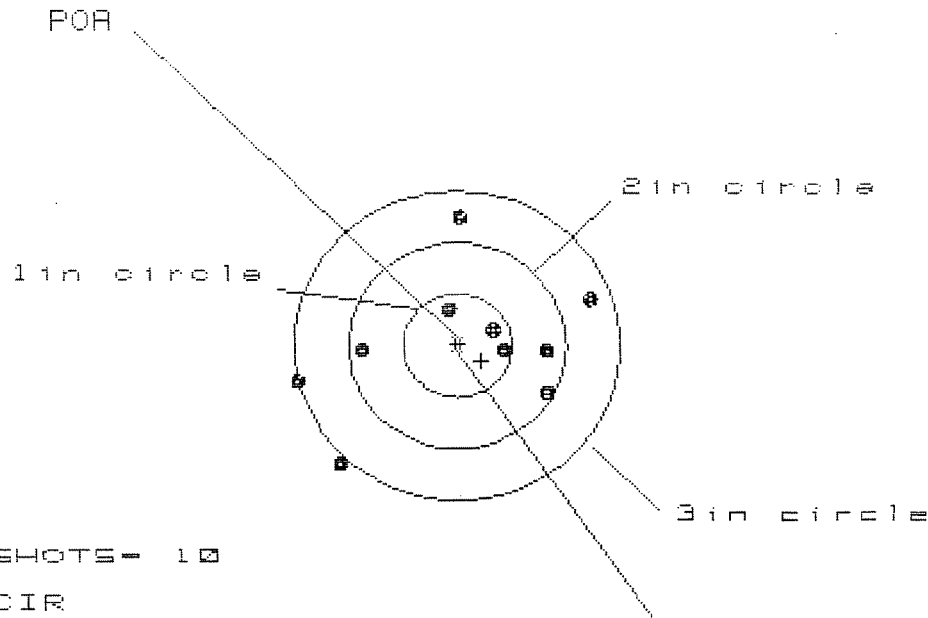
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.569	1.596	1.416
MINIMUM X	:	-1.464	-1.437	-1.232
MAXIMUM Y	:	1.082	.877	.827
MINIMUM Y	:	-1.849	-.754	-.645
CENTROID X	:	.337	.310	.490
CENTROID Y	:	.193	.398	.289
POA TO CENTROID in.	:	.388	.505	.568
MIN RADIUS	:	.528	.494	.620
MEAN RADIUS	:	1.244	1.170	1.101
MAX RADIUS	:	1.865	1.683	1.425
HORIZONTAL SPREAD	:	3.033	3.033	2.648
VERTICAL SPREAD	:	2.931	1.631	1.472
EXTREME SPREAD	:	3.391	3.242	2.692
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.708

VS= 2.403

GS= 2.822

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.223
MINIMUM X	-1.485
MAXIMUM Y	1.238
MINIMUM Y	-1.165
CENTROID X	-.224
CENTROID Y	.146
POA TO CENTROID in.	.267
MIN RADIUS	.353
MEAN RADIUS	.947
MAX RADIUS	1.609
HORIZONTAL SPREAD	2.708
VERTICAL SPREAD	2.403
EXTREME SPREAD	2.822
NUMBER IN ONE INCH CIRCLE	= 3
NUMBER IN TWO INCH CIRCLE	= 6
NUMBER IN THREE INCH CIRCLE	= 8

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

HS= 2.752

VS= 2.417

GS= 2.844

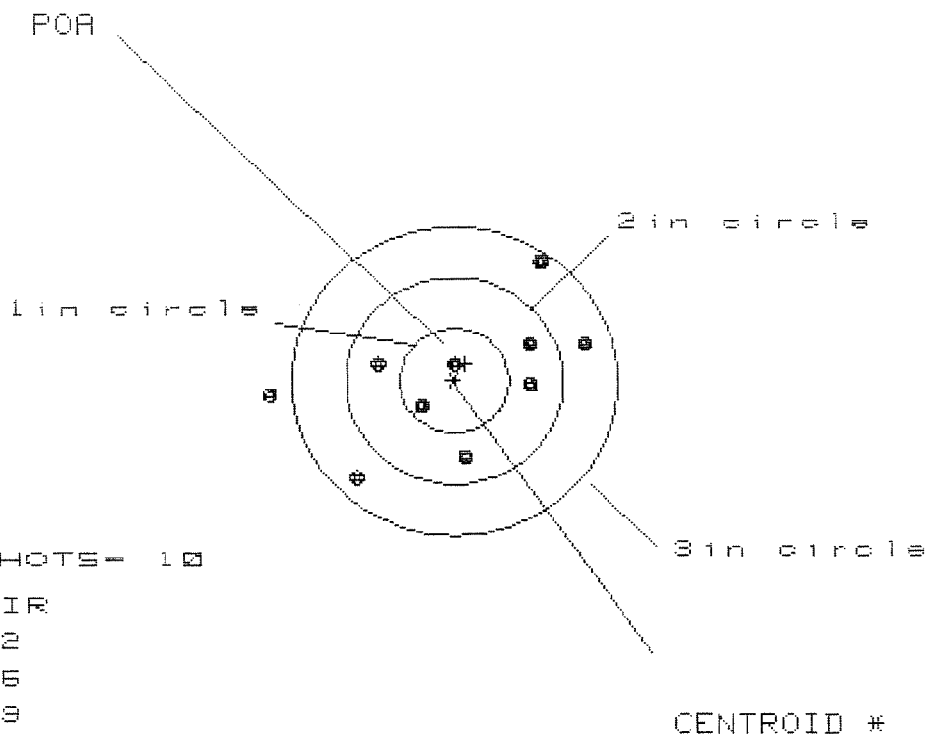
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.108	1.176
MINIMUM X	:	-1.480	-1.133	-.995
MAXIMUM Y	:	1.185	1.049	.952
MINIMUM Y	:	-1.232	-.770	-.520
CENTROID X	:	.082	.246	.108
CENTROID Y	:	.089	.225	.322
POA TO CENTROID in.	:	.121	.334	.339
MIN RADIUS	:	.063	.124	.178
MEAN RADIUS	:	.853	.722	.631
MAX RADIUS	:	1.925	1.349	1.286
HORIZONTAL SPREAD	:	2.752	2.241	2.171
VERTICAL SPREAD	:	2.417	1.819	1.472
EXTREME SPREAD	:	2.844	2.318	2.185
NUMBER IN ONE INCH CIRCLE	=		4	
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 = 2

2 in = 6

3 in = 8

HS= 2.919

VS= 2.006

GS= 2.971

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.215	1.026	1.103
MINIMUM X	:	-1.704	-1.045	-.968
MAXIMUM Y	:	1.116	1.097	.527
MINIMUM Y	:	-.890	-.909	-.772
CENTROID X	:	-.097	.092	.015
CENTROID Y	:	-.163	-.144	-.281
POA TO CENTROID in.	:	.190	.171	.281
MIN RADIUS	:	.128	.256	.285
MEAN RADIUS	:	.909	.818	.753
MAX RADIUS	:	1.713	1.385	1.238
HORIZONTAL SPREAD	:	2.919	2.071	2.071
VERTICAL SPREAD	:	2.006	2.006	1.299
EXTREME SPREAD	:	2.971	2.606	2.428
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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

SERIAL NO. C6522338
DATE 8/18/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.41	2.36	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.27	2.38	2.50	
PULL #3	2.41	2.29	2.38	2.53	
PULL #4	2.39	2.25	2.40	2.52	
PULL #5	2.41	2.30	2.40	2.55	
TOTAL	12.16	11.52	11.92	12.65	
AVG.	2.43	2.31	2.38	2.53	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.24		
PULL #2	3.07	3.06		
PULL #3	3.05	3.04		
PULL #4	3.02	3.11		
PULL #5	3.08	3.06		
TOTAL	15.33	15.51		
AVG.	3.06	3.10		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.27		4.11
PULL #2	4.05	4.13		4.13
PULL #3	4.32	4.21		4.14
PULL #4	4.31	4.19		4.20
PULL #5	4.24	4.20		4.20
TOTAL	21.09	21.00		20.88
AVG.	4.22	4.20		4.17

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6522338

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29	90	RW
600	Proof	6 29	90	RW
607	Check Headspace	6 29	90	RW
610	Dis-assemble Gun	6 29	90	RW
612	Magnaflux Barrel Action		7-12-90	KR
	Magnaflux Bolt		7-12-90	KR
615	Rollmark Caliber		7-12-90	G.S.
617	Drill and Tap Sight Holes		7/13/90	LB
618	Polish Barrel AB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-13-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/18/90	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/10/90	RL
	G) Safety Off Force	2	2	2			8/10/90	RL
	H) Trigger Pull Test & Retainability						8/18/90	WB
	I) Firing Pin Indent	.0225	.023	.023			8/10/90	RL
	J) Assemble Stock						8/24/90	RL
	K) Assemble Swivel Studs						8/31/90	RL
	L) Attach Front and Rear Sight Assemblies						8/24/90	RL
	M) Iron Sight Alignment						8/24/90	RL
	N) Detach Front & Rear Sights & place in numbered container						8/24/90	RL
	O) Attach Scope to Rifle						8/24/90	WB
	P) Detach & Attach Scope 20 Times						8/24/90	WB
640	Gallery Target & Test						8-24-90	DH
	A) Time						8-24-90	DH
	B) Malfunctions						8-24-90	DH
	C) Pierced Primers						8-24-90	DH
	D) Optical Clarity of Scope						8-24-90	DH
645	Inspect for Live Ammo						8-24-90	DH
655	Final Inspection							
	A) Headspace						8/31/90	RL
	B) Trigger Pull	2.55	2.50	2.53	2.52	2.55	8/31/90	RL
	C) Function						8/31/90	RL
660	Pack						9/20/90	RF