

C6594513

MODEL 700™ M24

Model **SMS**™

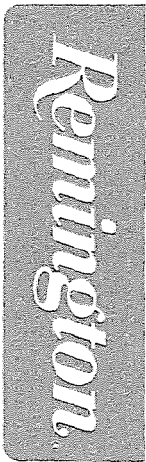
Action

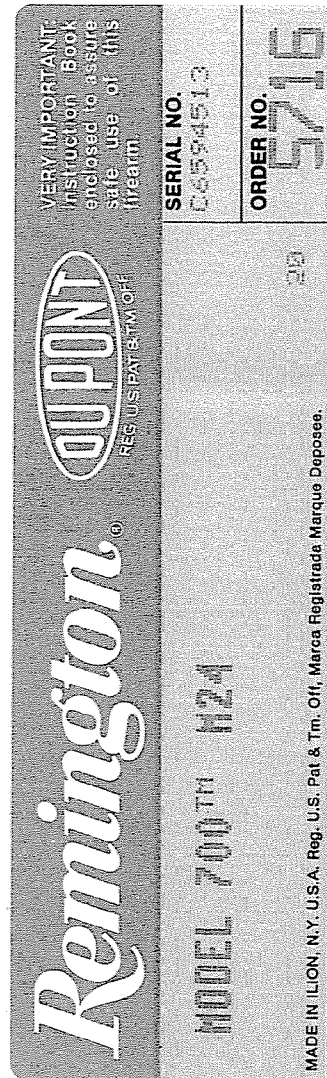
Barrel Length

Capacity

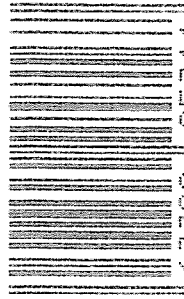
Order No. **5715**

*Includes 1 in chamber.

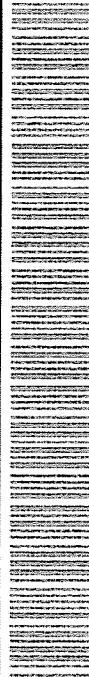




UPC



0 47700 25746 2



5716 C6594513

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6594513

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	GL
617	Drill and Tap Sight Holes	1 10	91	FB
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1/24/91	SM

op. #	BARBER - M24 0018392 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/25/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			1/25/91	WB
	H) Trigger Pull Test & Retainability						1/24/91	Yf
	I) Firing Pin Indent	.020	.020	.020			1/25/91	WB
	J) Assemble Stock						1/28/91	RW
	K) Assemble Swivel Studs						2-4-91	AC
	L) Attach Front and Rear Sight Assemblies						1/28/91	RW
	M) Iron Sight Alignment						1/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/28/91	RW
	O) Attach Scope to Rifle						1/28/91	RW
		P) Detach & Attach Scope 20 Times						1/28/91
640	Gallery Target & Test						1-28-91	DH
	A) Time						1-28-91	DH
	B) Malfunctions						1-28-91	DH
	C) Pierced Primers						1-28-91	DH
	D) Optical Clarity of Scope						1-28-91	DH
645	Inspect for Live Ammo						1-28-91	DH
655	Final Inspection							
	A) Headspace						2-4-91	AC
	B) Trigger Pull	2.32	2.36	2.28	2.38	2.50	2-1-91	Yf
	C) Function						2-21-91	AC
660	Pack						3-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 06594573DATE 1-24-91TESTER JLL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.57	2.50	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.40	2.16	2.36	
PULL #3	2.40	2.38	2.51	2.28	
PULL #4	2.46	2.43	2.42	2.38	
PULL #5	2.40	2.41	2.42	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.25		
PULL #2	3.23	3.50		
PULL #3	3.27	3.24		
PULL #4	3.44	3.54		
PULL #5	3.13	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.24		4.41
PULL #2	4.42	4.19		4.47
PULL #3	4.25	4.37		4.49
PULL #4	4.20	4.41		4.32
PULL #5	4.27	4.29		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594513
28 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.298645
1 TO 2	.288917
1 TO 3	.583216
1 TO 4	.605974
1 TO 5	.475232

\$+? <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0548
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0590512
THE AMP FOR THIS RIFLE IS: .8488

28 Jan 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06534513

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.166

VS = 2.363

GS = 2.933

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.503	1.553	.373
MINIMUM X	-.663	-.496	-.302
MAXIMUM Y	1.275	1.154	1.029
MINIMUM Y	-1.088	-1.005	-.937
CENTROID X	.242	.075	-.119
CENTROID Y	-.175	-.054	.071
POA TO CENTROID in.	.299	.093	.139
MIN RADIUS	.063	.188	.269
MEAN RADIUS	.931	.786	.625
MAX RADIUS	1.855	1.850	1.046
HORIZONTAL SPREAD	2.166	2.049	.675
VERTICAL SPREAD	2.363	2.159	1.966
EXTREME SPREAD	2.933	2.707	1.978
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594513

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.690

VS= 1.486

GS= 2.732

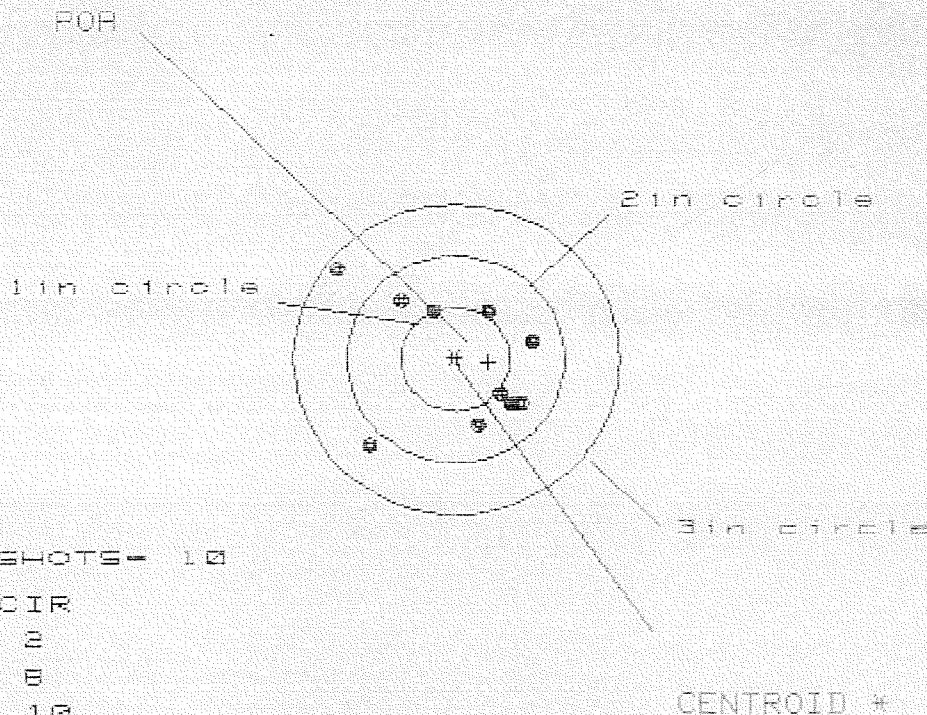
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.354	1.006	.938
MINIMUM X	-1.336	-1.185	-.793
MAXIMUM Y	.626	.585	.593
MINIMUM Y	-.860	-.901	-.893
CENTROID X	.265	.114	.262
CENTROID Y	.113	.154	.146
POA TO CENTROID in.	.288	.192	.300
MIN RADIUS	.348	.481	.377
MEAN RADIUS	.900	.836	.780
MAX RADIUS	1.404	1.187	1.049
HORIZONTAL SPREAD	2.690	2.271	1.731
VERTICAL SPREAD	1.486	1.486	1.486
EXTREME SPREAD	2.732	2.271	1.886
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

28 Jan 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06554513

CENTERFIRE PATTERNS

3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS = 1.805

VS = 1.702

GS = 2.175

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.685	.561	.445
MINIMUM X	-1.120	-.928	-.751
MAXIMUM Y	.887	.713	.624
MINIMUM Y	-.815	-.717	-.578
CENTROID X	-.304	-.180	-.064
CENTROID Y	.030	-.068	.021
POA TO CENTROID in.	.306	.192	.067
MIN RADIUS	.476	.329	.320
MEAN RADIUS	.757	.647	.559
MAX RADIUS	1.428	1.173	.976
HORIZONTAL SPREAD	1.805	1.489	1.196
VERTICAL SPREAD	1.702	1.430	1.202
EXTREME SPREAD	2.175	1.769	1.532
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

26 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594513

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 10

HS = 2.081

VS = 1.853

GS = 2.297

CENTROID #

PATTERN #

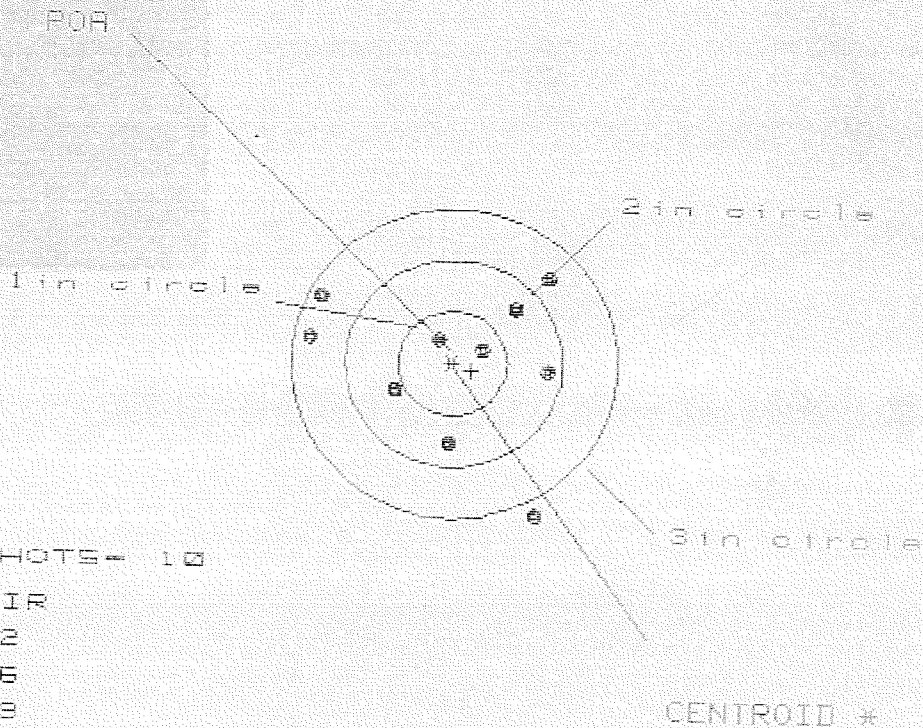
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.773	.628	.688
MINIMUM X	-1.388	-.663	-.683
MAXIMUM Y	1.049	1.033	.944
MINIMUM Y	-.804	-.820	-.691
CENTROID X	-.310	-.165	-.225
CENTROID Y	.075	.091	-.038
POA TO CENTROID in.	.319	.188	.228
MIN RADIUS	.370	.444	.328
MEAN RADIUS	.759	.707	.620
MAX RADIUS	1.315	1.140	1.168
HORIZONTAL SPREAD	2.081	1.291	1.291
VERTICAL SPREAD	1.853	1.853	1.635
EXTREME SPREAD	2.297	1.853	1.655
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

28 Jan 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06534513

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.188

VS= 2.253

GS= 2.861

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.878	.962	.623
MINIMUM X	-1.318	-1.226	-1.365
MAXIMUM Y	.824	.666	.729
MINIMUM Y	-1.429	-.986	-.843
CENTROID X	-.167	-.251	-.112
CENTROID Y	.067	.225	.162
POA TO CENTROID in.	.180	.337	.197
MIN RADIUS	.205	.029	.166
MEAN RADIUS	.897	.798	.730
MAX RADIUS	1.616	1.228	1.372
HORIZONTAL SPREAD	2.188	2.188	2.188
VERTICAL SPREAD	2.253	1.572	1.572
EXTREME SPREAD	2.861	2.219	2.219
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	9	9	9