

C6636318

MODEL 700™ M24

Model **SMS**™

Action

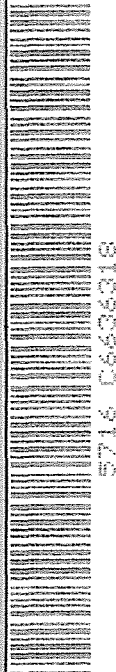
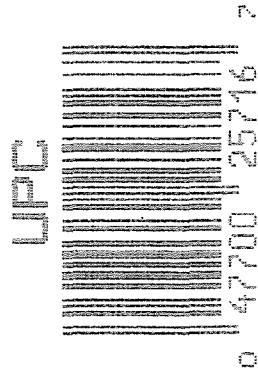
Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.





CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636318

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		JUL 2 1991	KR
	Magnaflux Bolt		JUL 2 1991	KR
615	Rollmark Caliber		JUL 2 1991	KR
617	Drill and Tap Sight Holes		JUL 2 1991	FB
618	Polish Barrel		JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		5-6-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/15/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/15/91	KH
	C) Inspect Ejector Hole for Chamfer		8/15/91	KH
	D) Oil Firing Pin Ass'y		8/15/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		8/16/91	WB

op. #	BARBER M24 0032981	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/16/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			8/16/91	WB
	H) Trigger Pull Test & Retainability						8/16/91	WB
	I) Firing Pin Indent	.0225	.0215	.022			8/16/91	WB
	J) Assemble Stock						8/19/91	K
	K) Assemble Swivel Studs						8/22/91	JH
	L) Attach Front and Rear Sight Assemblies						8/19/91	K
	M) Iron Sight Alignment						8/19/91	K
	N) Detach Front & Rear Sights & place in numbered container						8/19/91	K
	O) Attach Scope to Rifle						8/19/91	K
	P) Detach & Attach Scope 20 Times						8/19/91	K
640	Gallery Target & Test						8/20/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8/20/91	KT
655	Final Inspection							
	A) Headspace						8/22/91	JH
	B) Trigger Pull	260	265	265	264	264	8-21-91	DU
	C) Function						8/22/91	JH
660	Pack						9-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636318

DATE 8/16/91

TESTER WAB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.44	2.48	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.54	2.43	2.65	
PULL #3	2.36	2.37	2.47	2.65	
PULL #4	2.35	2.36	2.21	2.64	
PULL #5	2.30	2.33	2.45	2.64	
TOTAL	11.86	12.04	12.04		
AVG.	2.31	2.41	2.41		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.15		
PULL #2	3.16	2.95		
PULL #3	2.90	3.07		
PULL #4	3.16	3.00		
PULL #5	3.07	3.15		
TOTAL	15.39	15.32		
AVG.	3.08	3.06		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.26		4.29
PULL #2	4.30	4.00		4.20
PULL #3	4.02	4.19		4.37
PULL #4	4.25	4.00		4.11
PULL #5	4.12	3.90		4.39
TOTAL	20.77	20.35		21.36
AVG.	4.15	4.07		4.27

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06696318
23 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.234269
1 TO 2	.271737
1 TO 3	.24226
1 TO 4	.199111
1 TO 5	.462044

POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1058
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.018
THE RESULTING AVERAGE POT RADIUS FOR THIS RIFLE IS: .10732
THE AMR FOR THIS RIFLE IS: 1.051

PDF



BARBER - M24 ~~0032984~~ **M2400033023**

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636318

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.449

VS= 3.038

GS= 3.133

CENTROID #

PATTERN #

:

2

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.286

1.231

1.145

MINIMUM X

:

-1.244

-1.218

-1.384

MAXIMUM Y

:

1.638

1.389

1.243

MINIMUM Y

:

-1.392

-1.210

-1.358

CENTROID X

:

-1.118

-1.143

-1.057

CENTROID Y

:

.029

-1.153

-1.007

POA TO CENTROID IN.

:

.121

.218

.058

MIN RADIUS

:

.382

.520

.378

MEAN RADIUS

:

1.126

1.062

1.005

MAX RADIUS

:

1.654

1.390

1.390

HORIZONTAL SPREAD

:

2.449

2.449

2.449

VERTICAL SPREAD

:

3.038

2.599

2.599

EXTREME SPREAD

:

3.133

2.638

2.634

NUMBER IN ONE INCH CIRCLE =

:

1

NUMBER IN TWO INCH CIRCLE =

:

3

NUMBER IN THREE INCH CIRCLE =

:

8

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636318

CENTERFIRE PATTERNS # 3

FOR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 10

3 in = 10

HS = 1.460

VS = 1.561

GS = 1.775

CENTROID *

PATTERN #

:

3

SHOTS (BEST OF)

:

10

3

8

MAXIMUM X

:

.714

.665

.428

MINIMUM X

:

-.746

-.795

-.712

MAXIMUM Y

:

.873

.662

.653

MINIMUM Y

:

-.688

-.591

-.509

CENTROID X

:

.034

.083

.000

CENTROID Y

:

.000

-.097

-.179

FOR TO CENTROID in.

:

.034

.128

.179

MIN RADIUS

:

.250

.145

.190

MEAN RADIUS

:

.650

.595

.553

MAX RADIUS

:

.980

.938

.751

HORIZONTAL SPREAD

:

1.460

1.460

1.140

VERTICAL SPREAD

:

1.561

1.253

1.162

EXTREME SPREAD

:

1.775

1.775

1.434

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

10

NUMBER IN THREE INCH CIRCLE =

10

23 Aug 1981

FILE: \PATTERNING\CENTERFIRE_PATT\06636318

CENTERFIRE PATTERNS # 1

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 9

HS= 2.485

VS= 2.267

GS= 3.207

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.285	1.304	1.393
MINIMUM X	-1.200	-1.058	-0.894
MAXIMUM Y	1.143	1.249	1.143
MINIMUM Y	-1.124	-0.998	-1.099
CENTROID X	-0.141	-0.289	-0.447
CENTROID Y	-0.060	-0.186	-0.085
FOR TO CENTROID IN.	.153	.339	.455
MIN RADIUS	.919	.754	.638
MEAN RADIUS	1.233	1.162	1.092
MAX RADIUS	1.719	1.536	1.399
HORIZONTAL SPREAD	2.485	2.362	2.297
VERTICAL SPREAD	2.267	2.247	2.247
EXTREME SPREAD	3.207	2.770	2.496
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	9		

23 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8&3E318

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 4.221

VS= 1.814

GS= 4.332

CENTROID *

PATTERN #

:



SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.780

1.509

1.008

MINIMUM X

:

-2.441

-1.601

-1.418

MAXIMUM Y

:

.733

.767

.688

MINIMUM Y

:

-1.081

-1.047

-1.126

CENTROID X

:

-.265

.006

-.182

CENTROID Y

:

.172

.138

.217

POA TO CENTROID in.

:

.316

.138

.283

MIN RADIUS

:

.192

.110

.114

MEAN RADIUS

:

1.114

.919

.821

MAX RADIUS

:

2.461

1.636

1.511

HORIZONTAL SPREAD

:

4.221

3.110

2.421

VERTICAL SPREAD

:

1.814

1.814

1.814

EXTREME SPREAD

:

4.332

3.215

2.715

NUMBER IN ONE INCH CIRCLE =

:

2

4

NUMBER IN TWO INCH CIRCLE =

:

7

NUMBER IN THREE INCH CIRCLE =

:

7

7