

C6611714

MODEL 700TM M24

Model S&STM

Action _____

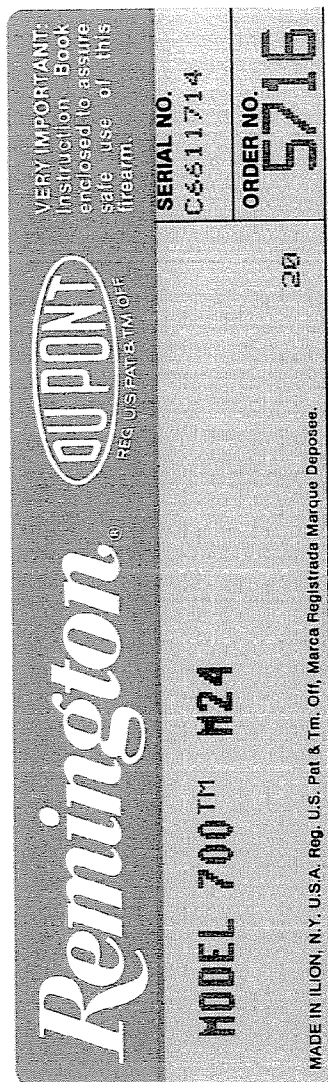
Barrel Length _____

Capacity _____

Order No. 5715

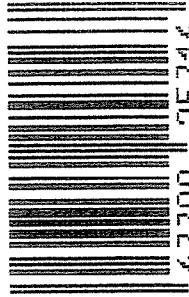
*Includes 1 in chamber.





5716 C6611714

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611714

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	RW
600	Proof	3 28	9 1	RW
607	Check Headspace	2 3	9 1	RW
610	Dis-assemble Gun	3 28	9 1	RW
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	"
615	Rollmark Caliber	APR	2 1991	JS
617	Drill and Tap Sight Holes	APR	5 1991	FB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			P
625	Final Assembly			
	A) Clean inside of Bolt Assembly		4/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	RW
	C) Inspect Ejector Hole for Chamfer		4/10/91	RW
	D) Oil Firing Pin Ass'y		4/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/23/91	JH

op. #	OP NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/23/91	RL
	G) Safety Off Force	3	3	3			4/23/91	RL
	H) Trigger Pull Test & Retainability						4/23/91	RL
	I) Firing Pin Indent	1.021	1.0225	1.0225			4/23/91	RL
	J) Assemble Stock						5/1/91	RL
	K) Assemble Swivel Studs						5-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/1/91	RL
	M) Iron Sight Alignment						5/1/91	RL
	N) Detach Front & Rear Sights & place in numbered container						5/1/91	RL
	O) Attach Scope to Rifle						5/1/91	RL
	P) Detach & Attach Scope 20 Times						5/1/91	RL
640	Gallery Target & Test						5/1/91	RL
	A) Time						5/1/91	RL
	B) Malfunctions						5/1/91	RL
	C) Pierced Primers						5/1/91	RL
	D) Optical Clarity of Scope						5/1/91	RL
645	Inspect for Live Ammo						5/1/91	RL
655	Final Inspection						5/1/91	RL
	A) Headspace						5-1-91	D/H
	B) Trigger Pull	2.34	2.31	2.34	2.40	2.37	5/1/91	RL
	C) Function						5-1-91	D/H
660	Pack						6-1-91	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6611714

DATE 4/23/91

TESTER J. J. J.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.60	2.43	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.37	2.40	2.31	
PULL #3	2.51	2.29	2.44	2.34	
PULL #4	2.51	2.34	2.38	2.40	
PULL #5	2.59	2.39	2.42	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.24		
PULL #2	3.34	3.34		
PULL #3	3.37	3.35		
PULL #4	3.29	3.27		
PULL #5	3.32	3.27		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.22		4.54
PULL #2	4.45	4.50		4.59
PULL #3	4.24	4.53		4.36
PULL #4	4.42	4.23		4.44
PULL #5	4.43	4.38		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611714
1 May 1991

CENTROIDAL DISTANCES

0 TO 1	.241249
1 TO 2	.429057
1 TO 3	.174428
1 TO 4	.281187
1 TO 5	.204453

← ---- POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0662
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .112694

THE AMR FOR THIS RIFLE IS: .8184

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611714

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.497

VS = 2.470

GS = 2.475

CENTROID *

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.725

.745

.489

MINIMUM X

-.772

-.752

-.659

MAXIMUM Y

1.277

1.139

.641

MINIMUM Y

-1.193

-1.051

-.989

CENTROID X

.220

.200

.107

CENTROID Y

-.099

-.241

-.383

POA TO CENTROID in.

.241

.313

.398

MIN RADIUS

.375

.425

.541

MEAN RADIUS

.823

.763

.679

MAX RADIUS

1.289

1.361

.920

HORIZONTAL SPREAD

1.497

1.497

1.148

VERTICAL SPREAD

2.470

2.190

1.550

EXTREME SPREAD

2.475

2.298

1.612

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611714

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 2.082

VS= 2.019

GS= 2.290

CENTROID #

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.145	1.144	.849
MINIMUM X	-.937	-.938	-.795
MAXIMUM Y	.555	.392	.436
MINIMUM Y	-1.464	-1.838	-1.794
CENTROID X	-.043	-.042	-.185
CENTROID Y	.240	.403	.359
POA TO CENTROID in.	.244	.405	.404
MIN RADIUS	.223	.308	.190
MEAN RADIUS	.834	.753	.663
MAX RADIUS	1.464	1.197	.974
HORIZONTAL SPREAD	2.082	2.082	1.644
VERTICAL SPREAD	2.019	1.230	1.230
EXTREME SPREAD	2.290	2.085	1.812
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611714

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 10

HS = 2.002

VS = 1.662

GS = 2.213

CENTROID *

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.945	.525	.406
MINIMUM X	-1.057	-.952	-.529
MAXIMUM Y	.795	.542	.563
MINIMUM Y	-.867	-.778	-.757
CENTROID X	.063	-.042	.076
CENTROID Y	-.023	-.112	-.133
POA TO CENTROID in.	.067	.119	.153
MIN RADIUS	.252	.185	.146
MEAN RADIUS	.636	.574	.504
MAX RADIUS	1.235	.967	.924
HORIZONTAL SPREAD	2.002	1.477	.936
VERTICAL SPREAD	1.662	1.320	1.320
EXTREME SPREAD	2.213	1.520	1.497
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611714

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.444

VS= 3.479

GS= 3.486

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.218

1.165

1.072

MINIMUM X

-1.226

-1.279

-1.372

MAXIMUM Y

2.100

.591

.448

MINIMUM Y

-1.379

-1.146

-.309

CENTROID X

.145

.198

.291

CENTROID Y

.172

-.061

.082

POA TO CENTROID in.

.225

.207

.302

MIN RADIUS

.430

.198

.309

MEAN RADIUS

1.045

.880

.807

MAX RADIUS

2.152

1.366

1.397

HORIZONTAL SPREAD

2.444

2.444

2.444

VERTICAL SPREAD

3.479

1.737

.757

EXTREME SPREAD

3.486

2.458

2.458

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611714

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 10

HS = 1.895

VS = 2.135

GS = 2.548

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.784

.672

.617

MINIMUM X

-1.111

-1.223

-1.139

MAXIMUM Y

1.092

.998

.856

MINIMUM Y

-1.043

-1.137

-.831

CENTROID X

.071

.183

.098

CENTROID Y

.041

.135

.277

POA TO CENTROID in.

.082

.227

.294

MIN RADIUS

.041

.145

.149

MEAN RADIUS

.754

.659

.565

MAX RADIUS

1.316

1.403

1.410

HORIZONTAL SPREAD

1.895

1.895

1.756

VERTICAL SPREAD

2.135

2.135

1.687

EXTREME SPREAD

2.548

2.435

2.435

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10