

06611744

MODEL 700™ M24

Model SMS™

Action

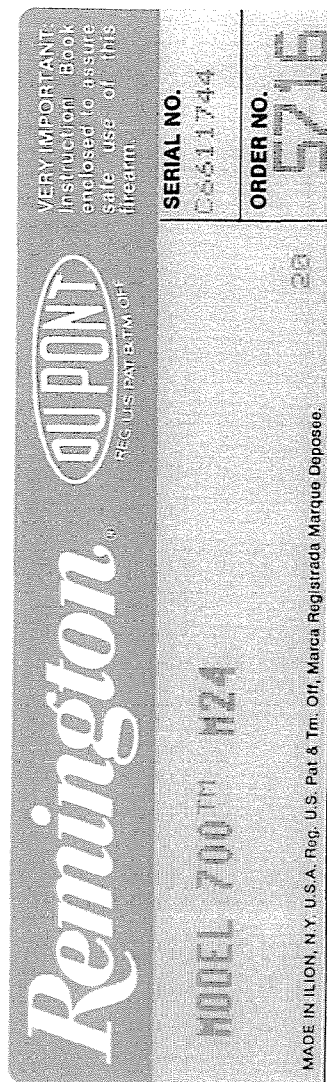
Barrel Length

Capacity

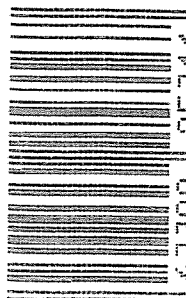
Order No. 5715

*Includes 1 in chamber.

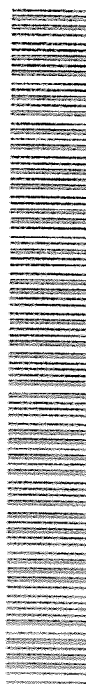




UPC



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5716 C6611744

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611744

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91	1/10/91	RW
600	Proof	1 10 91	1/10/91	RW
607	Check Headspace	1 10 91	1/10/91	RW
610	Dis-assemble Gun	1 10 91	1/10/91	RW
612	Magnaflux Barrel Action		1/16/91	KR
	Magnaflux Bolt		1/16/91	KR
615	Rollmark Caliber		1/16/91	LS.
617	Drill and Tap Sight Holes	1 17 91	1/17/91	EB
618	Polish Barrel	1 17 91	1/17/91	EB
620	Apply Coatings (Barrel Action)		2-18-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/5/91	JPL

op. #	BARBER - M24 0035190 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/6/91	SH
	G) Safety Off Force	2	2	2			3/6/91	SH
	H) Trigger Pull Test & Retainability						3/5/91	SH
	I) Firing Pin Indent	.0225	.0225	.0225			3/6/91	WB
	J) Assemble Stock						3/6/91	RW
	K) Assemble Swivel Studs						3-11-91	D/H
	L) Attach Front and Rear Sight Assemblies						3/6/91	RW
	M) Iron Sight Alignment						3/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/6/91	RW
	O) Attach Scope to Rifle						3/6/91	RW
	P) Detach & Attach Scope 20 Times						3/6/91	RW
640	Gallery Target & Test						3-17-91	A
	A) Time						11	A
	B) Malfunctions						11	A
	C) Pierced Primers						11	A
	D) Optical Clarity of Scope						11	A
645	Inspect for Live Ammo						3-17-91	A
655	Final Inspection							
	A) Headspace						3-11-91	D/H
	B) Trigger Pull	2.45	2.38	2.35	2.38	2.33	3-11/91	SH
	C) Function						3-11-91	D/H
660	Pack						3-11-91	VF

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

SERIAL NO. C661744DATE 3-5-91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.27	2.42	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.35	2.35	2.38	
PULL #3	2.26	2.36	2.38	2.35	
PULL #4	2.34	2.37	2.41	2.38	
PULL #5	2.39	2.37	2.36	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.33		
PULL #2	3.51	3.41		
PULL #3	3.45	3.41		
PULL #4	3.47	3.41		
PULL #5	3.43	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.46		4.50
PULL #2	4.44	4.40		4.38
PULL #3	4.43	4.37		4.41
PULL #4	4.33	4.28		4.42
PULL #5	4.41	4.41		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6511744
8 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.48179
1 TO	2	.692154
1 TO	3	.15807
1 TO	4	.726257
1 TO	5	.415621

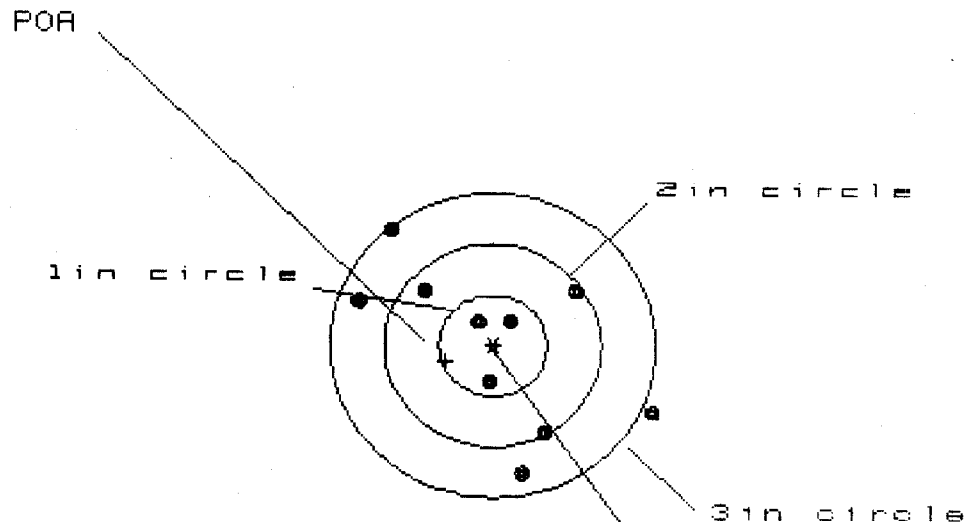
std (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1182
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0532
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129621
THE AMR FOR THIS RIFLE IS: .8882

7 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611744

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.695

VS = 2.485

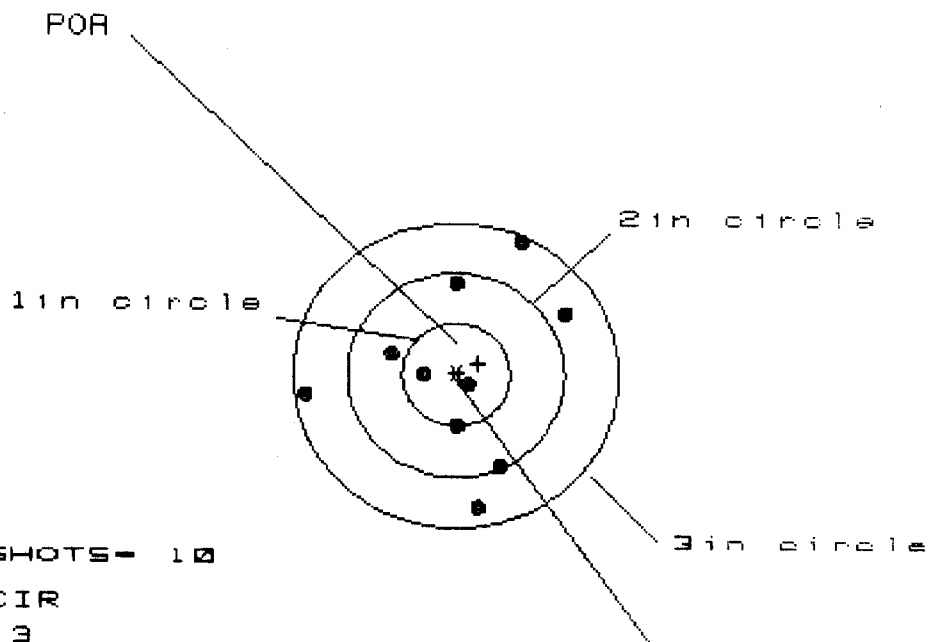
GS = 3.031

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	.965	.865
MINIMUM X	:	-1.273	-1.115	-1.215
MAXIMUM Y	:	1.190	1.114	.615
MINIMUM Y	:	-1.295	-1.371	-1.231
CENTROID X	:	.435	.277	.377
CENTROID Y	:	.155	.231	.091
POA TO CENTROID in.	:	.462	.360	.388
MIN RADIUS	:	.282	.174	.278
MEAN RADIUS	:	.953	.871	.807
MAX RADIUS	:	1.577	1.441	1.302
HORIZONTAL SPREAD	:	2.695	2.080	2.080
VERTICAL SPREAD	:	2.485	2.485	1.846
EXTREME SPREAD	:	3.031	2.781	2.306
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 10

HS= 2.251

VS= 2.639

GS= 2.669

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.959	1.025	.858
MINIMUM X	-1.402	-1.336	-.707
MAXIMUM Y	1.325	1.057	1.050
MINIMUM Y	-1.315	-1.167	-1.174
CENTROID X	-.204	-.270	-.103
CENTROID Y	-.111	-.258	-.251
POA TO CENTROID in.	.232	.373	.271
MIN RADIUS	.099	.106	.097
MEAN RADIUS	.878	.801	.734
MAX RADIUS	1.451	1.337	1.177
HORIZONTAL SPREAD	2.361	2.361	1.565
VERTICAL SPREAD	2.639	2.224	2.224
EXTREME SPREAD	2.669	2.488	2.230
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 1.999

VS = 2.356

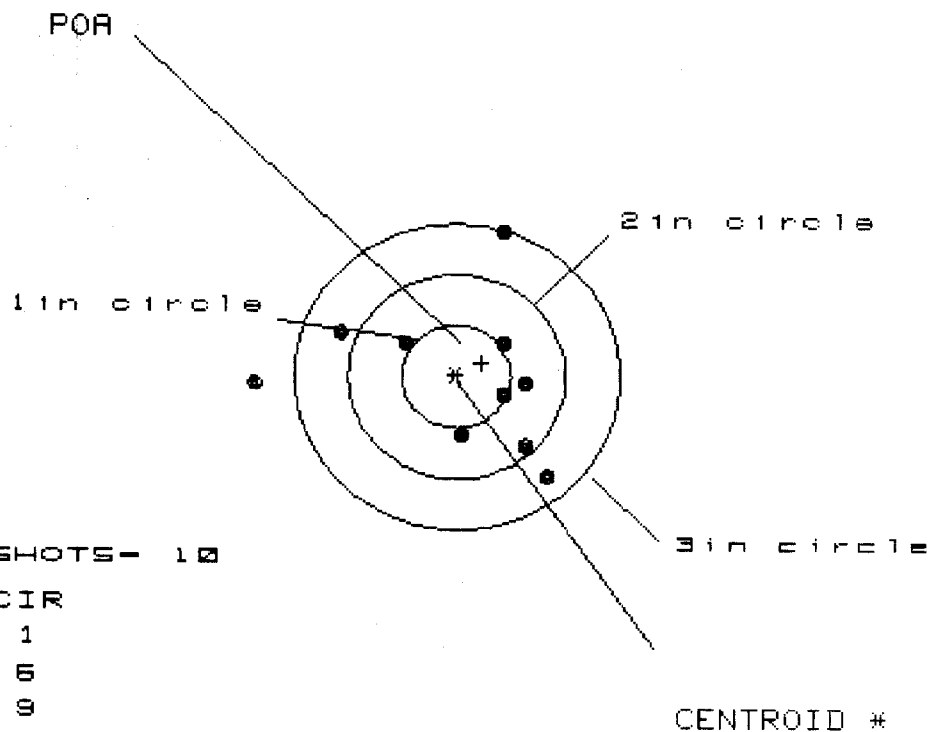
GS = 2.625

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.067	1.021	1.041
MINIMUM X	-.932	-.813	-.793
MAXIMUM Y	1.337	1.224	.723
MINIMUM Y	-1.019	-.866	-.713
CENTROID X	.404	.285	.265
CENTROID Y	-.000	.113	-.040
POA TO CENTROID in.	.404	.307	.268
MIN RADIUS	.156	.313	.286
MEAN RADIUS	.898	.829	.775
MAX RADIUS	1.475	1.339	1.262
HORIZONTAL SPREAD	1.999	1.834	1.834
VERTICAL SPREAD	2.356	2.090	1.436
EXTREME SPREAD	2.625	2.329	2.329
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HE = 2.728

VS = 2.360

GS = 2.873

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.633	.659
MINIMUM X	:	-1.886	-1.229	-1.203
MAXIMUM Y	:	1.391	1.384	.569
MINIMUM Y	:	-.969	-.976	-.803
CENTROID X	:	-.233	-.024	-.050
CENTROID Y	:	-.130	-.123	-.296
POA TO CENTROID in.	:	.267	.125	.300
MIN RADIUS	:	.410	.227	.207
MEAN RADIUS	:	.942	.788	.694
MAX RADIUS	:	1.887	1.400	1.331
HORIZONTAL SPREAD	:	2.728	1.862	1.862
VERTICAL SPREAD	:	2.360	2.360	1.372
EXTREME SPREAD	:	2.873	2.397	2.313
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.558

VS= 1.473

GS= 2.558

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.287	1.156	1.015
MINIMUM X	:	-1.271	-1.128	-.899
MAXIMUM Y	:	.640	.622	.600
MINIMUM Y	:	-.833	-.851	-.873
CENTROID X	:	.189	.046	.187
CENTROID Y	:	-.180	-.162	-.140
POA TO CENTROID in.	:	.261	.169	.233
MIN RADIUS	:	.208	.224	.246
MEAN RADIUS	:	.770	.706	.640
MAX RADIUS	:	1.297	1.156	1.016
HORIZONTAL SPREAD	:	2.558	2.284	1.914
VERTICAL SPREAD	:	1.473	1.473	1.473
EXTREME SPREAD	:	2.558	2.290	1.944
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	