

C6611748

MODEL 700™ M24

Model S&S™

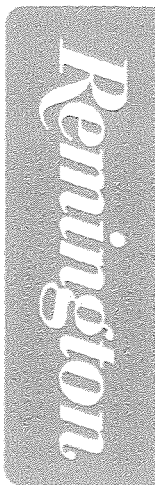
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611748

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 10 91		RW
600	Proof	1 10 91		RW
607	Check Headspace	1 10 91		RW
610	Dis-assemble Gun	1 10 91		RW
612	Magnaflux Barrel Action		1/14/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LSL
617	Drill and Tap Sight Holes	1 17 91		LB
618	Polish Barrel	1 17 91		WB
620	Apply Coatings (Barrel Action)		8-18-91	TS
	Apply Coating (Bolt)			
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		4/24/91	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4/24/91	SH
	G) Safety Off Force	4	4	4			4/24/91	SH
	H) Trigger Pull Test & Retainability						4/24/91	SH
	I) Firing Pin Indent	.022	.0225	.0225			4/24/91	SH
	J) Assemble Stock						4/25/91	RW
	K) Assemble Swivel Studs						4-30-91	DH
	L) Attach Front and Rear Sight Assemblies						4/25/91	RW
	M) Iron Sight Alignment						4/25/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/91	RW
	O) Attach Scope to Rifle						4/25/91	RW
	P) Detach & Attach Scope 20 Times						4/25/91	RW
640	Gallery Target & Test						4-25-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						4-25-91	NF
655	Final Inspection							
	A) Headspace						4-30-91	DH
	B) Trigger Pull	2.57	2.55	2.55	2.60	2.64	4/26/91	SH
	C) Function						4-30-91	DH
660	Pack						6-1F-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6611748DATE 4/24/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.30	2.48	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.36	2.35	2.55	
PULL #3	2.41	2.50	2.48	2.55	
PULL #4	2.28	2.26	2.36	2.60	
PULL #5	2.34	2.35	2.36	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.38		
PULL #2	3.56	3.45		
PULL #3	3.55	3.32		
PULL #4	3.48	3.48		
PULL #5	3.53	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.36		4.49
PULL #2	4.53	4.53		4.28
PULL #3	4.38	4.41		4.56
PULL #4	4.30	4.56		4.58
PULL #5	4.40	4.46		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611748
25 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.178466
1 TO	2	.198595
1 TO	3	.0863771
1 TO	4	.12256
1 TO	5	.0674463

←----POA

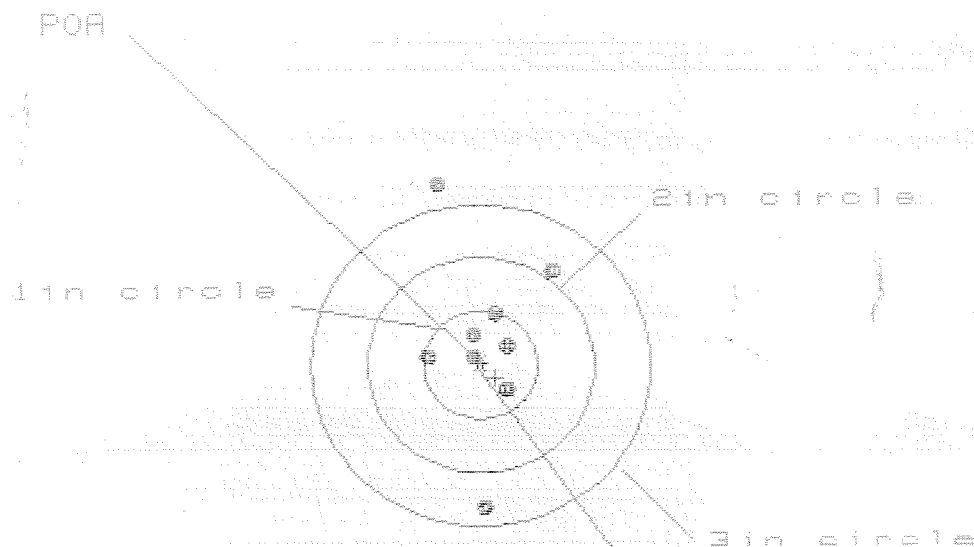
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0714
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0548
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0900056

THE AMR FOR THIS RIFLE IS: .6628

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611748

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 6

2in = 6

3in = 8

HS= 1.027

VS= 3.923

GS= 3.925

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X	.605	.574	.519
MINIMUM X	-.422	-.453	-.508
MAXIMUM Y	1.720	1.475	.835
MINIMUM Y	-2.203	-1.522	-1.337
CENTROID X	-.133	-.102	-.047
CENTROID Y	.119	.364	.179
POA TO CENTROID in.	.178	.378	.186
MIN RADIUS	.071	.127	.108
MEAN RADIUS	.820	.629	.510
MAX RADIUS	2.221	1.538	1.340
HORIZONTAL SPREAD	1.027	1.027	1.027
VERTICAL SPREAD	3.923	2.997	2.173
EXTREME SPREAD	3.925	3.024	2.255
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

25 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611748

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 1.692

VS= 1.470

GS= 1.760

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1

.807

.556

.534

MINIMUM X

2

-.885

-.795

-.817

MAXIMUM Y

3

.500

.424

.293

MINIMUM Y

4

-.970

-1.046

-.529

CENTROID X

5

.031

-.059

-.037

CENTROID Y

6

.007

.083

.213

POR TO CENTROID in.

7

.032

.102

.217

MIN RADIUS

8

.278

.319

.189

MEAN RADIUS

9

.629

.571

.475

MAX RADIUS

10

1.055

1.061

.922

HORIZONTAL SPREAD

11

1.692

1.351

1.351

VERTICAL SPREAD

12

1.470

1.470

.823

EXTREME SPREAD

13

1.760

1.643

1.531

NUMBER IN ONE INCH CIRCLE =

5

NUMBER IN TWO INCH CIRCLE =

8

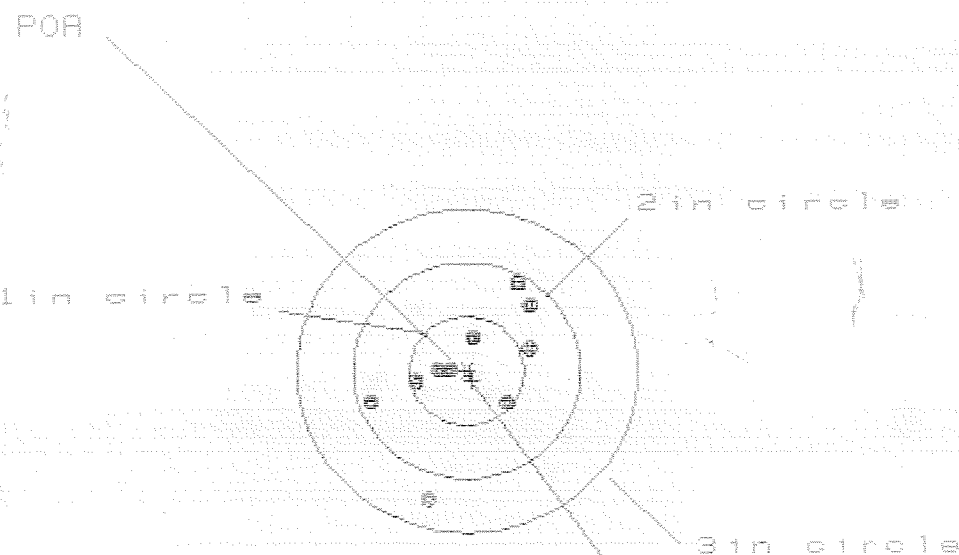
NUMBER IN THREE INCH CIRCLE =

10

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611748

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= 1.402

VS= 2.014

GS= 2.160

CENTROID *

PATTERN #		3		
SHOTS (BEST OF)		10	9	8
MAXIMUM X		.569	.527	.417
MINIMUM X		-.833	-.875	-.555
MAXIMUM Y		.793	.657	.601
MINIMUM Y		-1.221	-.450	-.471
CENTROID X		-.052	-.010	.100
CENTROID Y		.089	.225	.281
POA TO CENTROID in.		.103	.225	.299
MIN RADIUS		.104	.199	.181
MEAN RADIUS		.597	.516	.459
MAX RADIUS		1.279	.984	.651
HORIZONTAL SPREAD		1.402	1.402	.972
VERTICAL SPREAD		2.014	1.107	1.072
EXTREME SPREAD		2.160	1.665	1.162
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C8611748

CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 6

2 in = 9

3 in = 10

HS= 1.490

VS= 1.500

GS= 1.739

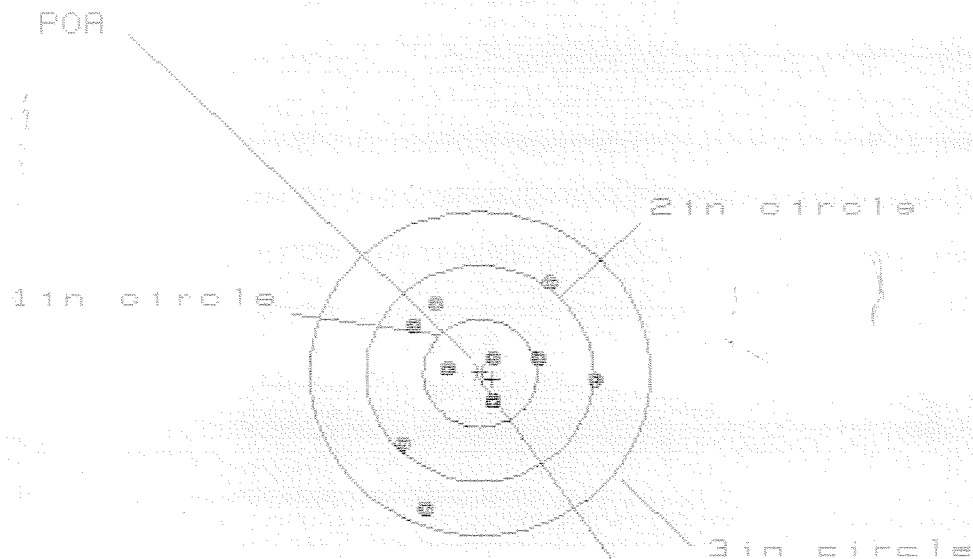
CENTROID #

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.715
MINIMUM X	-.775
MAXIMUM Y	.566
MINIMUM Y	-.934
CENTROID X	-.088
CENTROID Y	.005
POR TO CENTROID in.	.088
MIN RADIUS	.240
MEAN RADIUS	.562
MAX RADIUS	1.176
HORIZONTAL SPREAD	1.490
VERTICAL SPREAD	1.500
EXTREME SPREAD	1.739
NUMBER IN ONE INCH CIRCLE =	6
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10

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FILE:/PATTERNING/CENTERFIRE_PATT/C8511748

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.603

VS= 2.086

GS= 2.404

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.968	.909	.934
MINIMUM X	-.635	-.694	-.619
MAXIMUM Y	.835	.696	.636
MINIMUM Y	-1.251	-.827	-.740
CENTROID X	-.115	-.056	-.131
CENTROID Y	.054	.193	.106
POR TO CENTROID in.	.127	.201	.169
MIN RADIUS	.168	.077	.149
MEAN RADIUS	.706	.621	.577
MAX RADIUS	1.360	1.080	.990
HORIZONTAL SPREAD	1.603	1.603	1.603
VERTICAL SPREAD	2.086	1.523	1.376
EXTREME SPREAD	2.404	2.000	1.722
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		