

C6636015

MODEL 700™ M24

Model 545™

Action

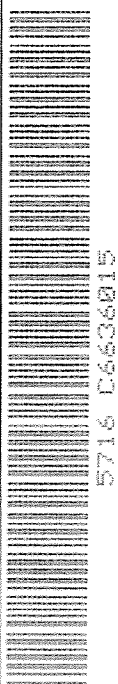
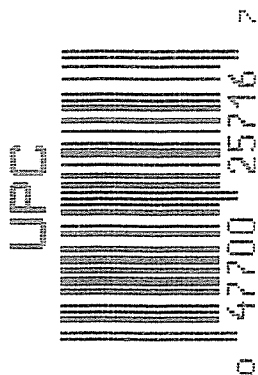
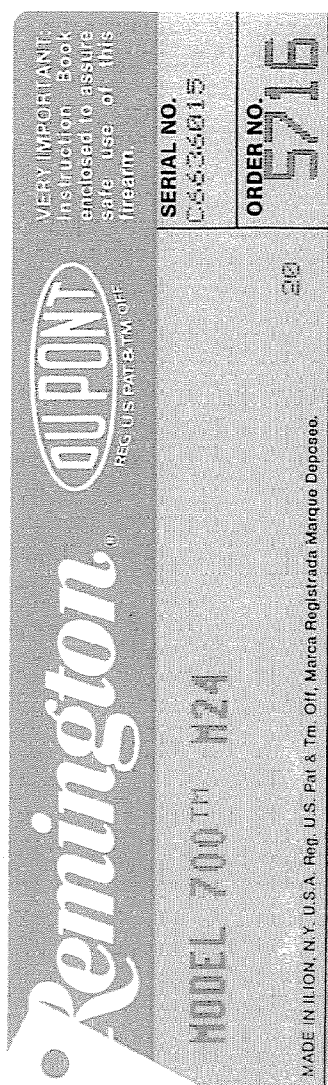
Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.





**NO
FEED
RAMP**

BARBER - M24 0036695

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636015

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber	5 8 9 1		CS
617	Drill and Tap Sight Holes	5 15 9 1		CS
618	Polish Barrel	5 15 9 1		CS
620	Apply Coatings (Barrel Action)		5-31-91	TH
	Apply Coating (Bolt)		5-31-91	TH
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/11/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/11/91	KS
	C) Inspect Ejector Hole for Chamfer		6/11/91	KS
	D) Oil Firing Pin Ass'y		6/11/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		8-26-91 6-12-91	KS

op. #	BARBER M24 0036696	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-12-91	DH
	G) Safety Off Force	3	3	3 1/2			6-12-91	D/H
	H) Trigger Pull Test & Retainability						8-26-91 6-12-91	JK
	I) Firing Pin Indent	.022	.022	.022			6-12-91	DH
	J) Assemble Stock						4/12/91	K.S
	K) Assemble Swivel Studs						8-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/12/91	KS
	M) Iron Sight Alignment						4/12/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/12/91	KS
	O) Attach Scope to Rifle						4/12/91	KS
	P) Detach & Attach Scope 20 Times						4/12/91	KS
640	Gallery Target & Test						6/24/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/21/91	KT
655	Final Inspection							
	A) Headspace						8-27-91	DH
	B) Trigger Pull	2.46	2.71	2.71	2.58	2.37	8-27-91	D/H
	C) Function						8-27-91	D/H
660	Pack						9-17-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6636015

DATE 8-26-91

TESTER JM.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.39	2.40	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.36	2.38	2.71	
PULL #3	2.43	2.39	2.44	2.71	
PULL #4	2.41	2.42	2.48	2.58	
PULL #5	2.37	2.41	2.46	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.42		
PULL #2	3.28	3.46		
PULL #3	3.47	3.40		
PULL #4	3.47	3.46		
PULL #5	3.38	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.51		4.53
PULL #2	4.49	4.41		4.51
PULL #3	4.38	4.50		4.48
PULL #4	4.46	4.48		4.55
PULL #5	4.45	4.45		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636015
26 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.193215
1 TO	2	.232545
1 TO	3	.123309
1 TO	4	.222612
1 TO	5	.182214

54 $\frac{1}{2}$ <----POR

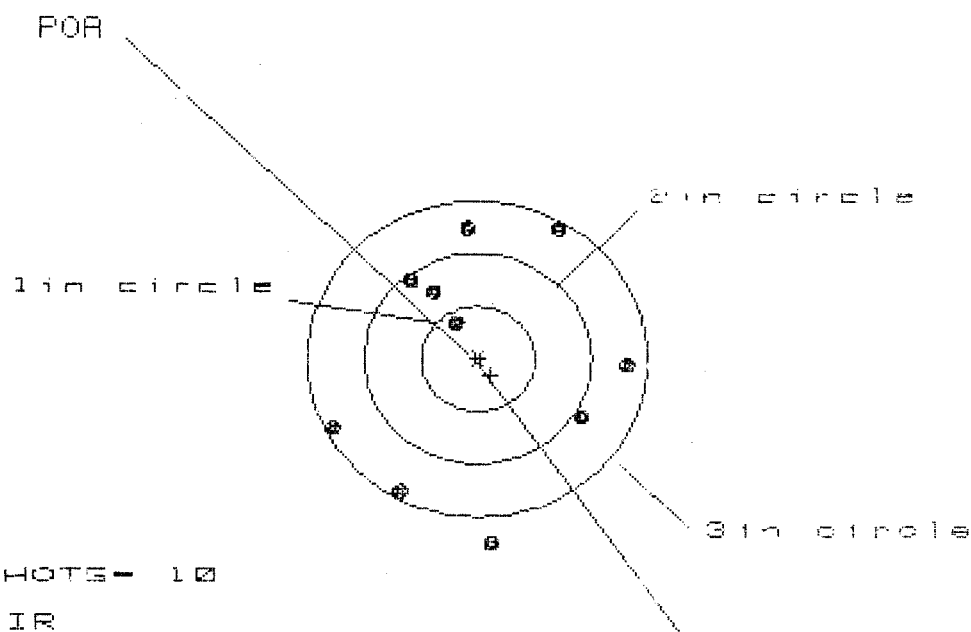
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0994
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0566
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .114015

THE AMR FOR THIS RIFLE IS: .9356

26 Aug 1991

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CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 3

3 in - 9

HS = 2.596

VS = 3.061

GS = 3.066

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.359	1.369	1.292
MINIMUM X	-1.238	-1.227	-1.314
MAXIMUM Y	1.285	1.088	.901
MINIMUM Y	-1.776	-1.493	-1.006
CENTROID X	-.114	-.124	-.037
CENTROID Y	.156	.353	.540
POA TO CENTROID in.	.193	.374	.541
MIN RADIUS	.398	.218	.218
MEAN RADIUS	1.189	1.074	.968
MAX RADIUS	1.778	1.647	1.655
HORIZONTAL SPREAD	2.596	2.596	2.596
VERTICAL SPREAD	3.061	2.581	1.907
EXTREME SPREAD	3.066	2.879	2.681
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.518

VS= 3.174

GS= 3.258

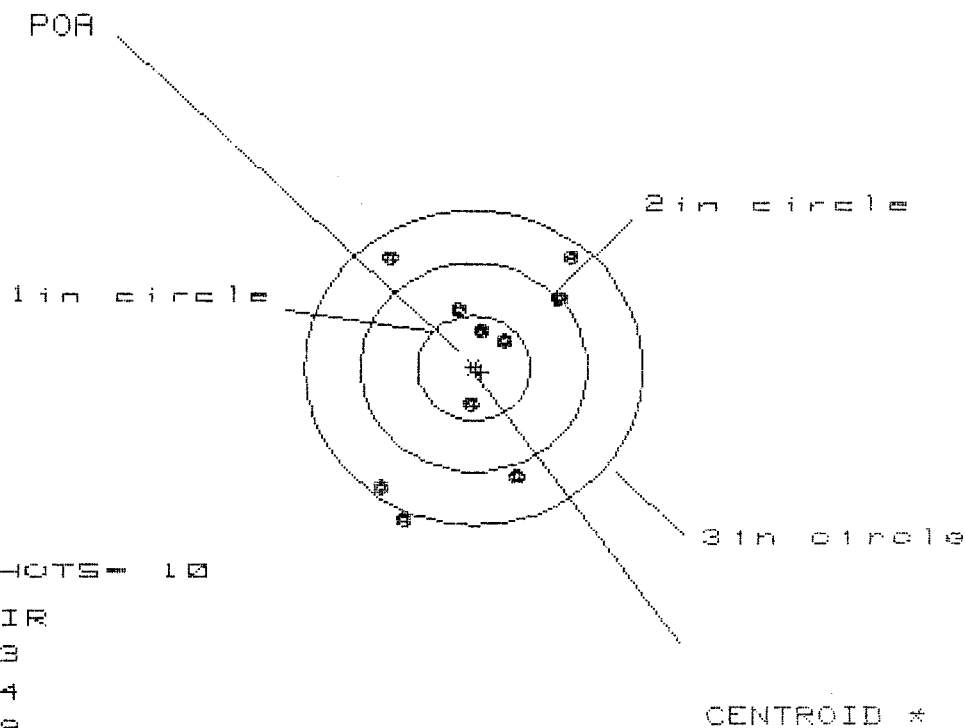
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.688	.653	.701
MINIMUM X	:	-.830	-.865	-.817
MAXIMUM Y	:	1.888	1.154	1.020
MINIMUM Y	:	-1.286	-1.076	-.889
CENTROID X	:	-.023	.012	-.036
CENTROID Y	:	-.058	-.268	-.133
POA TO CENTROID in.	:	.062	.268	.138
MIN RADIUS	:	.057	.159	.047
MEAN RADIUS	:	.878	.763	.686
MAX RADIUS	:	1.914	1.236	1.131
HORIZONTAL SPREAD	:	1.518	1.518	1.518
VERTICAL SPREAD	:	3.174	2.230	1.909
EXTREME SPREAD	:	3.258	2.231	2.003
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 1.721

VS= 2.577

GS= 2.978

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.888	.821	.836
MINIMUM X	:	-.833	-.900	-.798
MAXIMUM Y	:	1.102	.939	.963
MINIMUM Y	:	-1.475	-1.266	-1.149
CENTROID X	:	-.067	.000	-.102
CENTROID Y	:	.042	.205	.088
POA TO CENTROID in.	:	.079	.205	.135
MIN RADIUS	:	.329	.218	.350
MEAN RADIUS	:	.947	.835	.803
MAX RADIUS	:	1.594	1.554	1.399
HORIZONTAL SPREAD	:	1.721	1.721	1.634
VERTICAL SPREAD	:	2.577	2.205	2.112
EXTREME SPREAD	:	2.978	2.797	2.416
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			9	

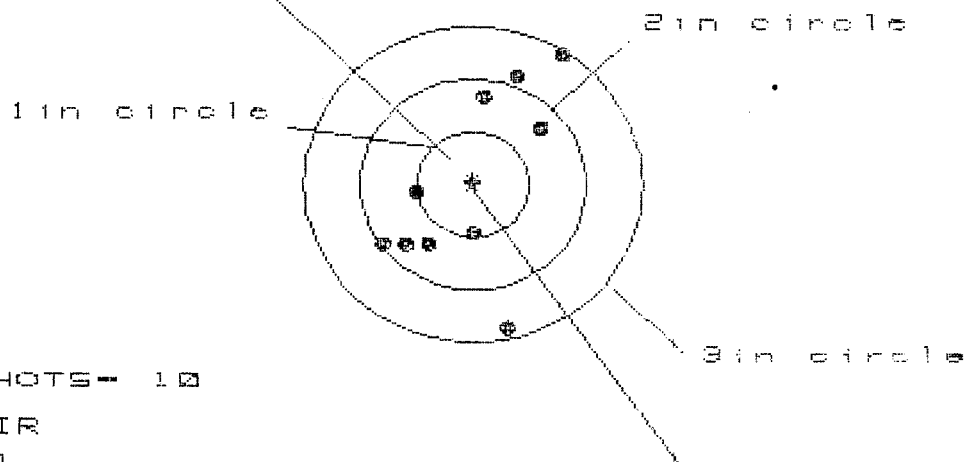
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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.574

VS= 2.639

GS= 2.689

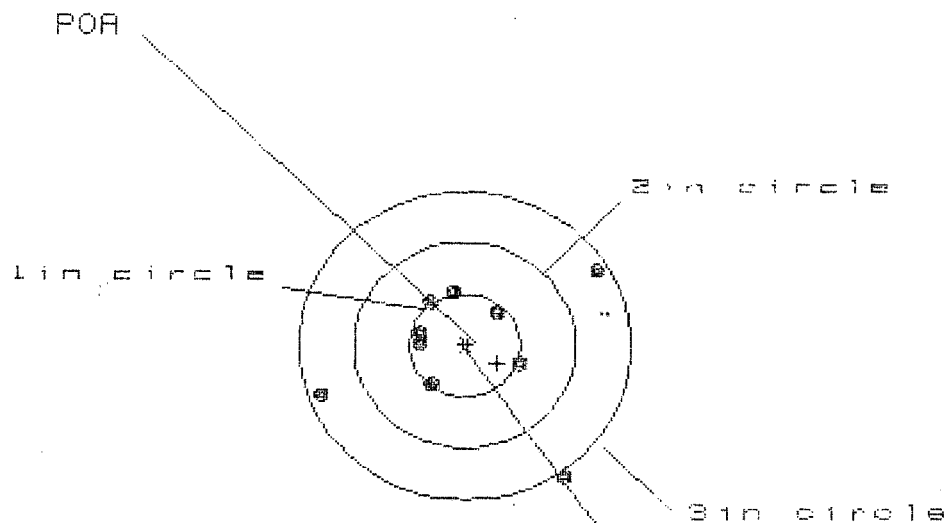
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.816	.730	.779
MINIMUM X	:	-.758	-.668	-.619
MAXIMUM Y	:	1.238	1.210	1.052
MINIMUM Y	:	-1.401	-1.263	-.616
CENTROID X	:	.002	-.088	-.137
CENTROID Y	:	-.034	-.172	-.014
POA TO CENTROID in.	:	.034	.193	.138
MIN RADIUS	:	.466	.382	.342
MEAN RADIUS	:	.912	.812	.753
MAX RADIUS	:	1.483	1.322	1.161
HORIZONTAL SPREAD	:	1.574	1.398	1.398
VERTICAL SPREAD	:	2.639	2.473	1.668
EXTREME SPREAD	:	2.689	2.474	1.952
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 5

2 in = 7

3 in = 9

HS = 2.493

VS = 1.993

GS = 2.779

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.196
MINIMUM X	-1.297
MAXIMUM Y	.764
MINIMUM Y	-1.229
CENTROID X	-.295
CENTROID Y	.177
POA TO CENTROID in.	.344
MIN RADIUS	.376
MEAN RADIUS	.752
MAX RADIUS	1.511
HORIZONTAL SPREAD	2.493
VERTICAL SPREAD	1.993
EXTREME SPREAD	2.779
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9