

C6636021

MODEL 700™ M24

Model SMS™

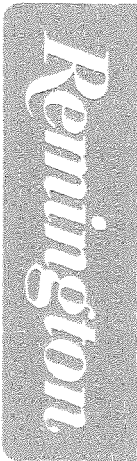
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



Stock
RepairedREPAIR
8/6
6/27/91GUN SERIAL # **C 6636021**

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		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		68
617	Drill and Tap Sight Holes	5 15 9 1		63
618	Polish Barrel	5 15 9 1		63
620	Apply Coatings (Barrel Action)		5-31-91	DH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/12/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/12/91	KS
	C) Inspect Ejector Hole for Chamfer		4/12/91	KS
	D) Oil Firing Pin Ass'y		4/12/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6/3/91	DH

op. #	BARBER M24 0036769	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-13-91	DH
	G) Safety Off Force	2	2	2			6-13-91	DH
	H) Trigger Pull Test & Retainability						6-13-91	DH
	I) Firing Pin Indent	.022	.021	.022			6-13-91	DH
	J) Assemble Stock						6-13-91	KS
	K) Assemble Swivel Studs						6-15-91	DH
	L) Attach Front and Rear Sight Assemblies						6-13-91	KS
	M) Iron Sight Alignment						6-13-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-13-91	KS
	O) Attach Scope to Rifle						6-13-91	KS
	P) Detach & Attach Scope 20 Times						6-13-91	KS
640	Gallery Target & Test						6-14-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						6-14-91	AF
655	Final Inspection							
	A) Headspace						6-15-91	DH
	B) Trigger Pull	2.58	2.58	2.48	2.35	2.45	6-15-91	DL
	C) Function						6-15-91	DH
660	Pack						6-20-91	AF

SWS TRIGGER PULL TEST

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

SERIAL NO. CC636021
DATE 6-13-91
TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.56	2.64	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.48	2.57	2.58	
PULL #3	2.34	2.45	2.69	2.48	
PULL #4	2.36	2.39	2.64	2.35	
PULL #5	2.35	2.49	2.85	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.43		
PULL #2	3.25	3.33		
PULL #3	3.23	3.37		
PULL #4	3.29	3.45		
PULL #5	3.21	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.39		4.32
PULL #2	4.39	4.35		4.37
PULL #3	4.40	4.40		4.45
PULL #4	4.35	4.44		4.43
PULL #5	4.41	4.51		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636021
14 Jun 1991

CENTROIDAL DISTANCES

0 TO 1	.188725
1 TO 2	.323012
1 TO 3	.21049
1 TO 4	.154729
1 TO 5	.0408534

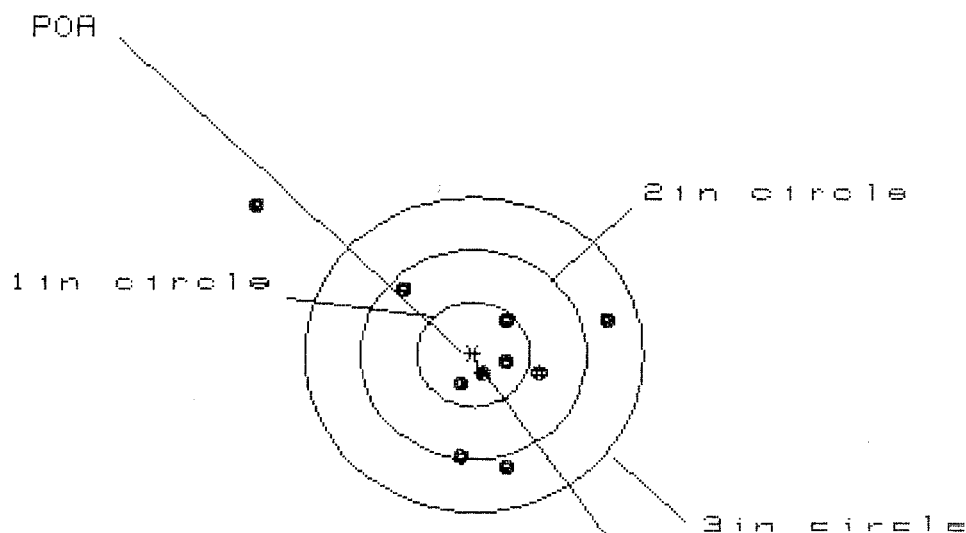
45.2
31 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.048
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .126
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134833
THE AMR FOR THIS RIFLE IS: .8836

14 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636021

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 4

2 in - 7

3 in - 9

HS= 3.085

VS= 2.541

GS= 3.363

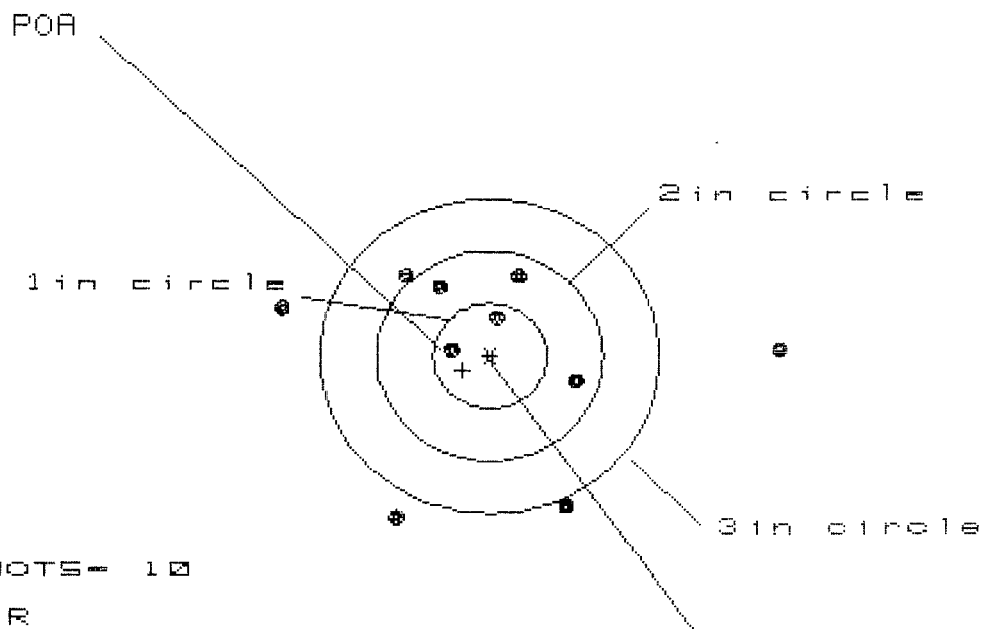
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.205	.996	.479
MINIMUM X	:	-1.880	-.804	-.680
MAXIMUM Y	:	1.423	.832	.894
MINIMUM Y	:	-1.118	-.960	-.898
CENTROID X	:	-.084	.125	.001
CENTROID Y	:	.169	.011	-.051
POA TO CENTROID in.	:	.189	.126	.051
MIN RADIUS	:	.221	.128	.036
MEAN RADIUS	:	.852	.628	.556
MAX RADIUS	:	2.358	1.157	1.123
HORIZONTAL SPREAD	:	3.085	1.800	1.159
VERTICAL SPREAD	:	2.541	1.792	1.792
EXTREME SPREAD	:	3.363	2.013	2.013
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 6

HS = 4.388

VS = 2.360

GS = 4.410

CENTROID *

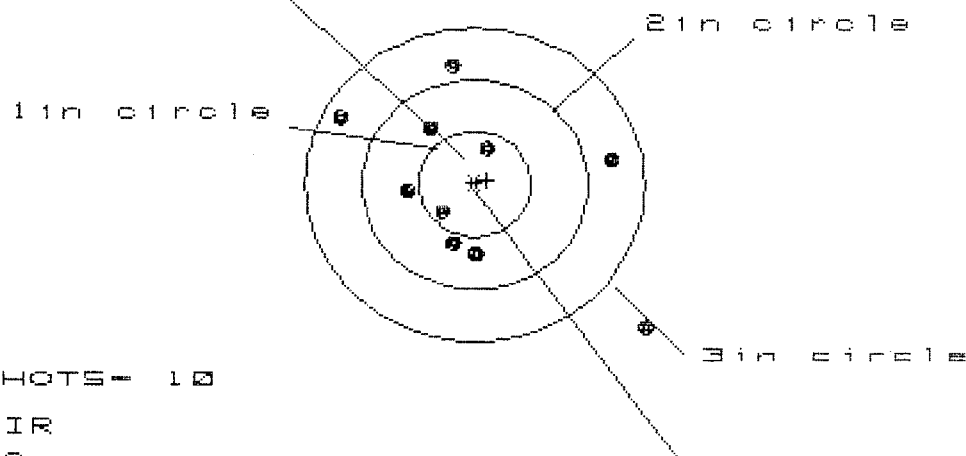
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.530	1.063	.865
MINIMUM X	:	-1.859	-1.577	-.797
MAXIMUM Y	:	.811	.818	.881
MINIMUM Y	:	-1.549	-1.542	-1.479
CENTROID X	:	.237	-.044	.154
CENTROID Y	:	.133	.126	.063
POA TO CENTROID in.	:	.272	.134	.166
MIN RADIUS	:	.313	.080	.262
MEAN RADIUS	:	1.212	1.037	.969
MAX RADIUS	:	2.530	1.768	1.680
HORIZONTAL SPREAD	:	4.388	2.640	1.662
VERTICAL SPREAD	:	2.360	2.360	2.360
EXTREME SPREAD	:	4.410	3.233	2.711
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.738

VS= 2.537

GS= 3.377

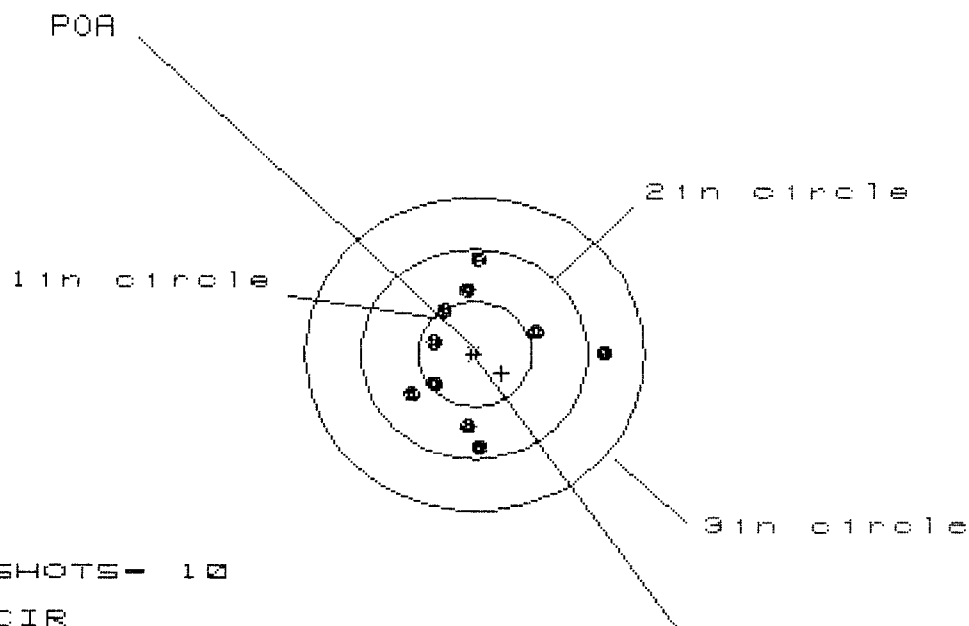
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.513	1.363	1.231
MINIMUM X	:	-1.225	-1.057	-.564
MAXIMUM Y	:	1.169	1.018	1.075
MINIMUM Y	:	-1.367	-.825	-.768
CENTROID X	:	-.109	-.277	-.145
CENTROID Y	:	-.040	.112	.055
POA TO CENTROID in.	:	.116	.299	.155
MIN RADIUS	:	.364	.365	.301
MEAN RADIUS	:	.905	.751	.701
MAX RADIUS	:	2.039	1.367	1.242
HORIZONTAL SPREAD	:	2.738	2.420	1.795
VERTICAL SPREAD	:	2.537	1.843	1.843
EXTREME SPREAD	:	3.377	2.445	1.853
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.683

VS= 1.822

GS= 1.822

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.109	.652	.676
MINIMUM X	:	-.574	-.450	-.426
MAXIMUM Y	:	.939	.935	.686
MINIMUM Y	:	-.883	-.887	-.770
CENTROID X	:	-.238	-.362	-.386
CENTROID Y	:	.184	.188	.071
POA TO CENTROID in.	:	.301	.408	.392
MIN RADIUS	:	.351	.233	.266
MEAN RADIUS	:	.680	.606	.554
MAX RADIUS	:	1.110	.954	.799
HORIZONTAL SPREAD	:	1.683	1.102	1.102
VERTICAL SPREAD	:	1.822	1.822	1.457
EXTREME SPREAD	:	1.822	1.822	1.466
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 9

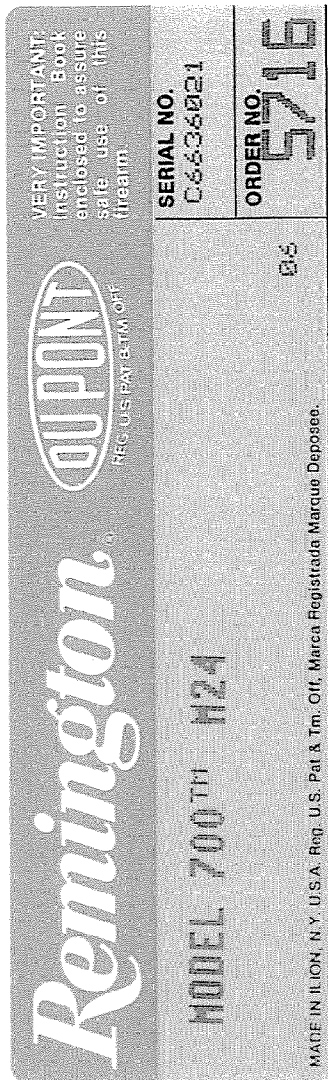
HS = 1.705

VS = 2.380

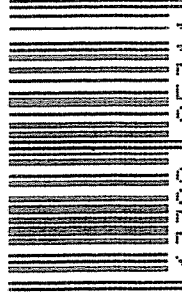
GS = 2.601

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.740	.766	.649
MINIMUM X	:	-.965	-.939	-.619
MAXIMUM Y	:	.837	.665	.739
MINIMUM Y	:	-1.543	-1.152	-1.078
CENTROID X	:	-.046	-.072	.045
CENTROID Y	:	.184	.356	.282
POA TO CENTROID in.	:	.190	.363	.285
MIN RADIUS	:	.187	.293	.242
MEAN RADIUS	:	.769	.670	.603
MAX RADIUS	:	1.562	1.179	1.086
HORIZONTAL SPREAD	:	1.705	1.705	1.268
VERTICAL SPREAD	:	2.380	1.817	1.817
EXTREME SPREAD	:	2.601	2.111	1.968
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



UPC



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