

C6636025

MODEL 700™ M24

Model SMS™

Action

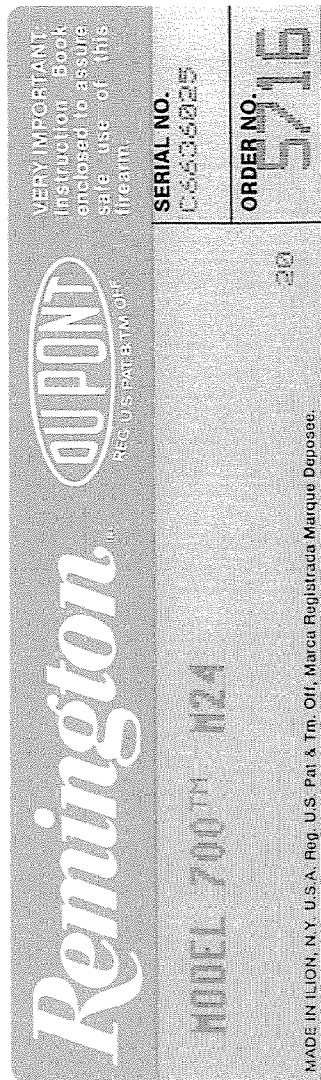
Barrel Length

Capacity

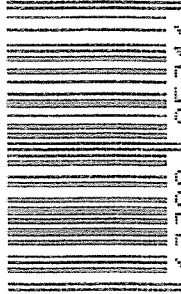
Order No. 5715

*Includes 1 in chamber.





LPC



0 4700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636025

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		Kcd
	Magnaflux Bolt	5 8 9 1		Kcd
615	Rollmark Caliber			68.
617	Drill and Tap Sight Holes	5 15 9 1		MB
618	Polish Barrel	5 15 9 1		MB
620	Apply Coatings (Barrel Action)		5-31-91	JS
	Apply Coating (Bolt)		5-31-91	JS
625	Final Assembly A) Clean inside of Bolt Assembly		7/5/91	JS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/5/91	JS
	C) Inspect Ejector Hole for Chamfer		7/5/91	JS
	D) Oil Firing Pin Ass'y		7/5/91	JS
	E) Adjust Trigger Pull to Min Setting and Stake		7/16/91	JS

op. #	BARBER - M24 0036814	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 3/4	5 3/4	5 3/4			7/16/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			7/16/91	WB
	H) Trigger Pull Test & Retainability						7-16-91	SH
	I) Firing Pin Indent	.0715	.071	.071			7/16/91	WB
	J) Assemble Stock						7/16/91	KS
	K) Assemble Swivel Studs						7-23-91	D/H
	L) Attach Front and Rear Sight Assemblies						7/16/91	KS
	M) Iron Sight Alignment						7/16/91	KS
	N) Detach Front & Rear Sights & place in numbered container						7/16/91	KS
	O) Attach Scope to Rifle						7/16/91	KS
	P) Detach & Attach Scope 20 Times						7/16/91	KS
640	Gallery Target & Test						7-18-91	AC
	A) Time						7-18-91	AC
	B) Malfunctions						7-18-91	AC
	C) Pierced Primers						7-18-91	AC
	D) Optical Clarity of Scope						7-18-91	AC
645	Inspect for Live Ammo						7-18-91	AC
655	Final Inspection							
	A) Headspace						7-23-91	D/H
	B) Trigger Pull	2.46	2.54	2.54	2.53	2.50	7-22-91	SH
	C) Function						7-23-91	D/H
660	Pack						4-18-91	AC

SWS TRIGGER PULL TEST

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

SERIAL NO C-6636025
DATE 7-16-91
TESTER Jdl.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.49	2.38	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.45	2.48	2.54	
PULL #3	2.46	2.49	2.43	2.54	
PULL #4	2.43	2.44	2.48	2.53	
PULL #5	2.43	2.47	2.48	2.50	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.41		
PULL #2	3.37	3.46		
PULL #3	3.49	3.39		
PULL #4	3.45	3.41		
PULL #5	3.39	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.22		4.24
PULL #2	4.41	4.23		4.22
PULL #3	4.38	4.25		4.25
PULL #4	4.39	4.10		4.28
PULL #5	4.38	4.33		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636025
18 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.615781
1 TO	2	.561493
1 TO	3	.823022
1 TO	4	.76958
1 TO	5	.666444

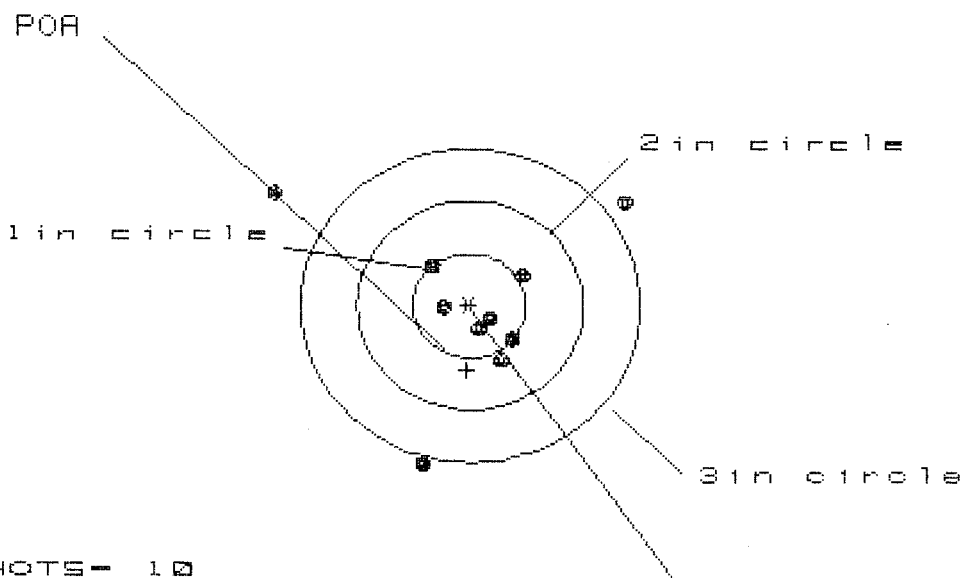
1
34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1818
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0878
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .201891
THE AMR FOR THIS RIFLE IS: 1.054

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636025

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 7

3 in = 7

HS= 3.111

VS= 2.610

GS= 3.113

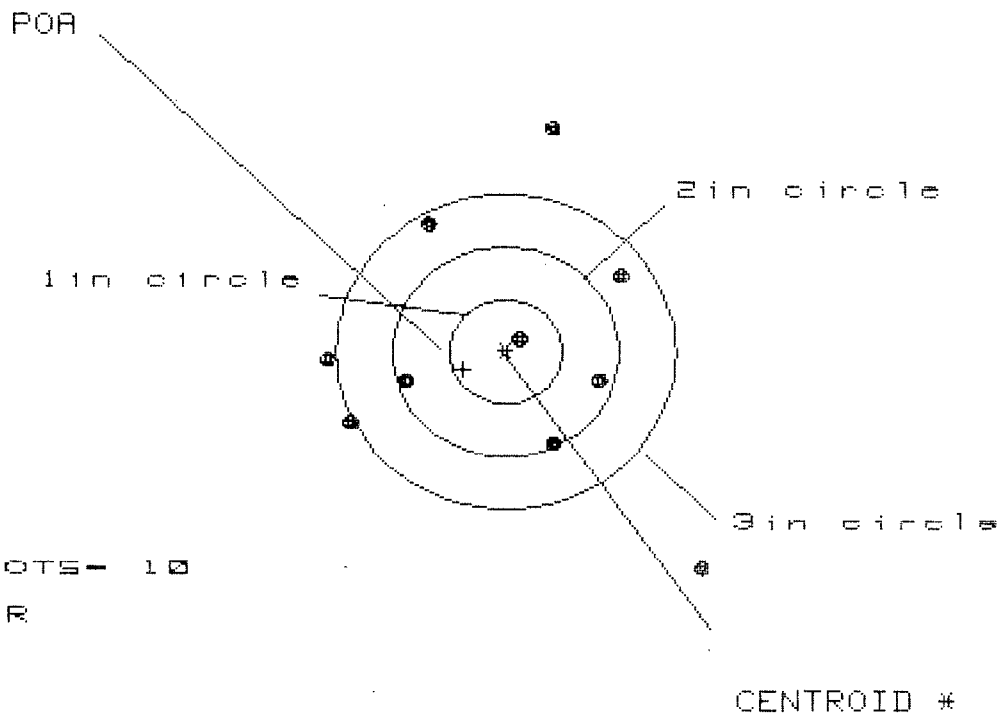
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.338	1.141	.455
MINIMUM X	:	-1.773	-.651	-.508
MAXIMUM Y	:	1.083	1.095	.609
MINIMUM Y	:	-1.527	-1.406	-1.269
CENTROID X	:	.031	.228	.085
CENTROID Y	:	.615	.494	.357
POA TO CENTROID in.	:	.615	.544	.367
MIN RADIUS	:	.191	.015	.068
MEAN RADIUS	:	.810	.620	.507
MAX RADIUS	:	2.077	1.582	1.367
HORIZONTAL SPREAD	:	3.111	1.792	.963
VERTICAL SPREAD	:	2.610	2.501	1.878
EXTREME SPREAD	:	3.113	3.077	2.079
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	7		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS= 3.315

VS= 4.221

GS= 4.404

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.701	1.252	1.331
MINIMUM X	:	-1.614	-1.425	-1.346
MAXIMUM Y	:	2.159	1.930	1.215
MINIMUM Y	:	-2.062	-1.090	-.849
CENTROID X	:	.376	.187	.108
CENTROID Y	:	.172	.401	.160
POA TO CENTROID in.	:	.414	.443	.193
MIN RADIUS	:	.173	.294	.394
MEAN RADIUS	:	1.357	1.213	1.085
MAX RADIUS	:	2.673	2.032	1.519
HORIZONTAL SPREAD	:	3.315	2.677	2.677
VERTICAL SPREAD	:	4.221	3.020	2.064
EXTREME SPREAD	:	4.404	3.374	2.804
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.060

VS= 3.275

GS= 3.570

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.905	.970	.873
MINIMUM X	:	-1.155	-1.090	-1.187
MAXIMUM Y	:	1.748	1.382	1.215
MINIMUM Y	:	-1.527	-1.333	-1.467
CENTROID X	:	.025	-.040	.057
CENTROID Y	:	-.208	-.402	-.235
POA TO CENTROID in.	:	.209	.404	.242
MIN RADIUS	:	.093	.208	.052
MEAN RADIUS	:	1.065	.991	.877
MAX RADIUS	:	1.842	1.542	1.488
HORIZONTAL SPREAD	:	2.060	2.060	2.060
VERTICAL SPREAD	:	3.275	2.715	2.682
EXTREME SPREAD	:	3.570	2.927	2.723
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.921

VS= 3.354

GS= 4.213

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.559	1.273	1.171
MINIMUM X	:	-1.362	-1.189	-1.291
MAXIMUM Y	:	1.472	1.179	.964
MINIMUM Y	:	-1.882	-1.719	-1.432
CENTROID X	:	.308	.135	.237
CENTROID Y	:	-.103	-.266	-.051
POA TO CENTROID in.	:	.325	.298	.242
MIN RADIUS	:	.076	.240	.013
MEAN RADIUS	:	1.044	.946	.759
MAX RADIUS	:	2.144	1.903	1.517
HORIZONTAL SPREAD	:	2.921	2.462	2.462
VERTICAL SPREAD	:	3.354	2.898	2.396
EXTREME SPREAD	:	4.213	3.573	2.668
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 9

HS= 2.660

VS= 2.891

GS= 2.968

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.445
MINIMUM X	-1.215
MAXIMUM Y	1.526
MINIMUM Y	-1.365
CENTROID X	.169
CENTROID Y	-.037
POA TO CENTROID in.	.173
MIN RADIUS	.361
MEAN RADIUS	.992
MAX RADIUS	1.658
HORIZONTAL SPREAD	2.660
VERTICAL SPREAD	2.891
EXTREME SPREAD	2.968
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9