

C6636029

MODEL 700TM M24

Model **SMS** TM

Action

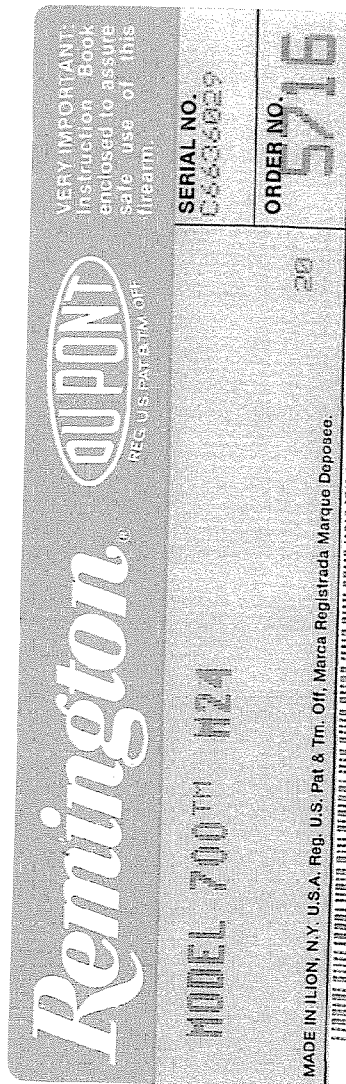
Barrel Length

Capacity

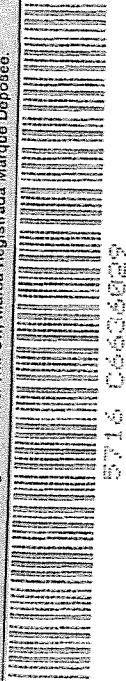
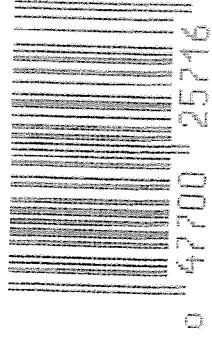
Order No. **5716**

* Includes 1 in chamber.





UPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636029

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		4/23/91	K.S.
600	Proof		4/23/91	K.S.
607	Check Headspace		4/23/91	K.S.
610	Dis-assemble Gun		4/23/91	K.S.
612	Magnaflux Barrel Action	5 8 9 1		KCR
	Magnaflux Bolt	5 8 9 1		KCR
615	Rollmark Caliber			GL
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		W.B.
620	Apply Coatings (Barrel Action)		5-31-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/15/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/15/91	KA
	C) Inspect Ejector Hole for Chamfer		7/15/91	KA
	D) Oil Firing Pin Ass'y		7/15/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		7/16/91	CB

op. #	BARBER, M24 0036866 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	7 1/2	7 1/2			7/16/91	W/B
	G) Safety Off Force	3 1/2	3 1/2	3 1/2			7/16/91	W/B
	H) Trigger Pull Test & Retainability						7-16-91	SL
	I) Firing Pin Indent	.024	.023	.023			7/16/91	W/B
	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						7-17-91	AC
	A) Time						7-17-91	AC
	B) Malfunctions						7-17-91	AC
	C) Pierced Primers						7-17-91	AC
	D) Optical Clarity of Scope						7-17-91	AC
645	Inspect for Live Ammo						7-17-91	AC
655	Final Inspection						7-23-91	D/H
	A) Headspace							
	B) Trigger Pull	2.39	2.45	2.62	2.56	2.56	7-22-91	SL
	C) Function						7-23-91	D/H
660	Pack						9-18-91	RF

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

SERIAL NO. 6636029DATE 7-16-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.49	2.51	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.49	2.50	2.45	
PULL #3	2.46	2.50	2.48	2.52	
PULL #4	2.48	2.50	2.50	2.56	
PULL #5	2.48	2.48	2.50	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.35		
PULL #2	3.29	3.33		
PULL #3	3.34	3.25		
PULL #4	3.33	3.29		
PULL #5	3.32	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.34		4.36
PULL #2	4.59	4.35		4.17
PULL #3	4.59	4.34		4.15
PULL #4	4.60	4.36		4.36
PULL #5	4.60	4.38		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636029
17 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.561263
1 TO	2	1.23679
1 TO	3	.239771
1 TO	4	.336251
1 TO	5	.59854

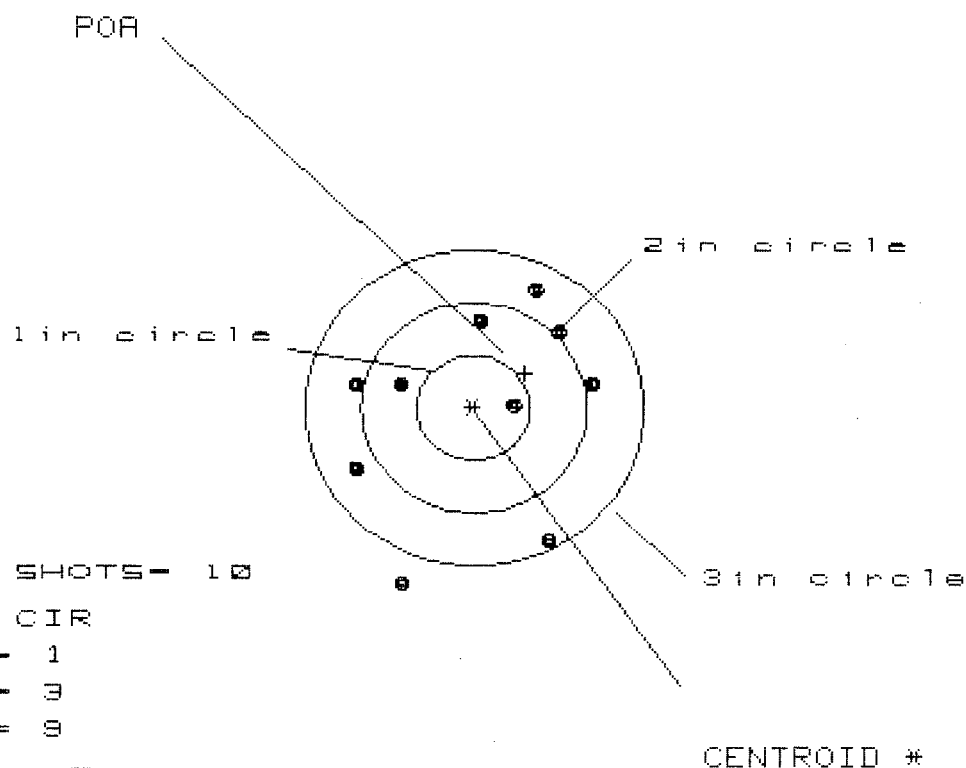
$\bar{x}^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.045
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1306
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138135
THE AMR FOR THIS RIFLE IS: 1.151

17 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636029

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 3

3 in - 9

HS- 2.052

VS- 2.793

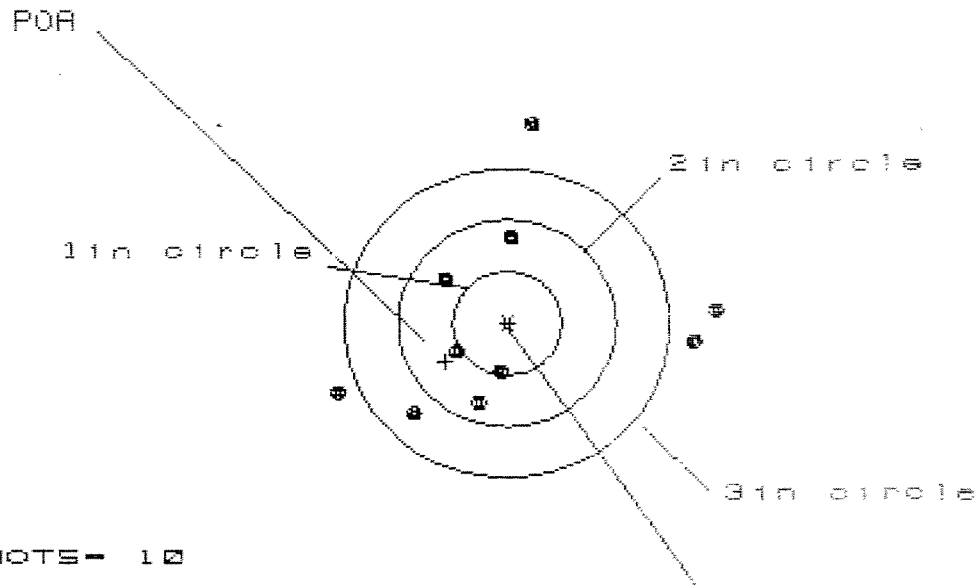
GS- 3.059

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.010	.935	1.006
MINIMUM X	:	-1.042	-1.117	-1.046
MAXIMUM Y	:	1.152	.969	.791
MINIMUM Y	:	-1.641	-1.424	-.936
CENTROID X	:	-.454	-.379	-.450
CENTROID Y	:	-.330	-.147	.031
POA TO CENTROID in.	:	.561	.407	.451
MIN RADIUS	:	.372	.335	.496
MEAN RADIUS	:	1.070	.957	.866
MAX RADIUS	:	1.773	1.533	1.403
HORIZONTAL SPREAD	:	2.052	2.052	2.052
VERTICAL SPREAD	:	2.793	2.393	1.727
EXTREME SPREAD	:	3.059	2.394	2.367
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



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 3.511

VS= 2.733

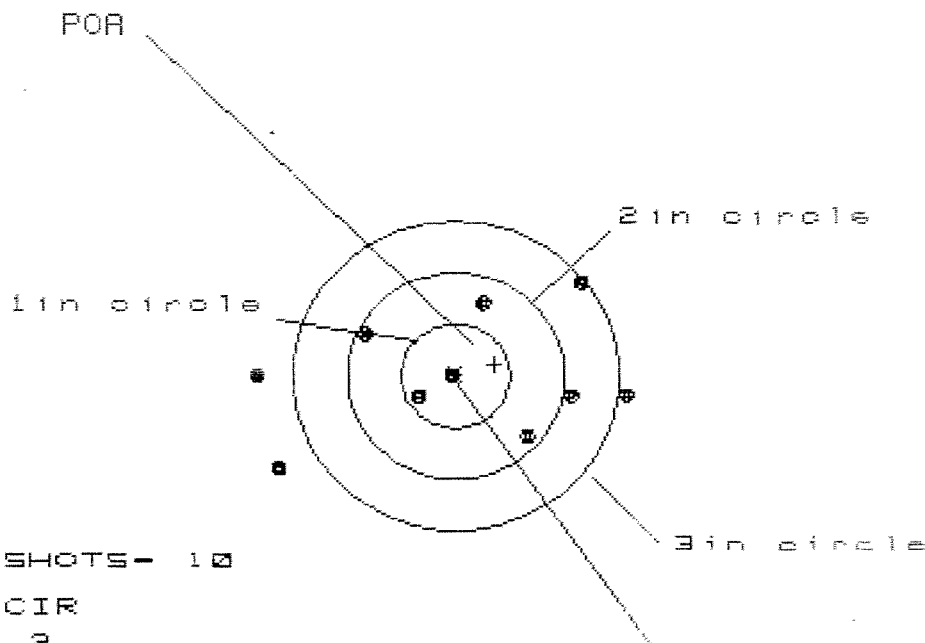
GS= 3.597

PATTERN #	10	9	2
SHOTS (BEST OF)	10	9	2
MAXIMUM X	1.920	1.901	1.954
MINIMUM X	-1.591	-1.377	-1.324
MAXIMUM Y	1.903	1.916	1.056
MINIMUM Y	-0.830	-0.817	-0.578
CENTROID X	.567	.353	.300
CENTROID Y	.368	.356	.117
POA TO CENTROID in.	.676	.502	.322
MIN RADIUS	.465	.397	.215
MEAN RADIUS	1.185	1.056	.879
MAX RADIUS	1.924	1.963	1.955
HORIZONTAL SPREAD	3.511	3.278	3.278
VERTICAL SPREAD	2.733	2.733	1.634
EXTREME SPREAD	3.597	3.311	2.311
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in = 7

HS= 3.422

VS= 1.765

GS= 3.429

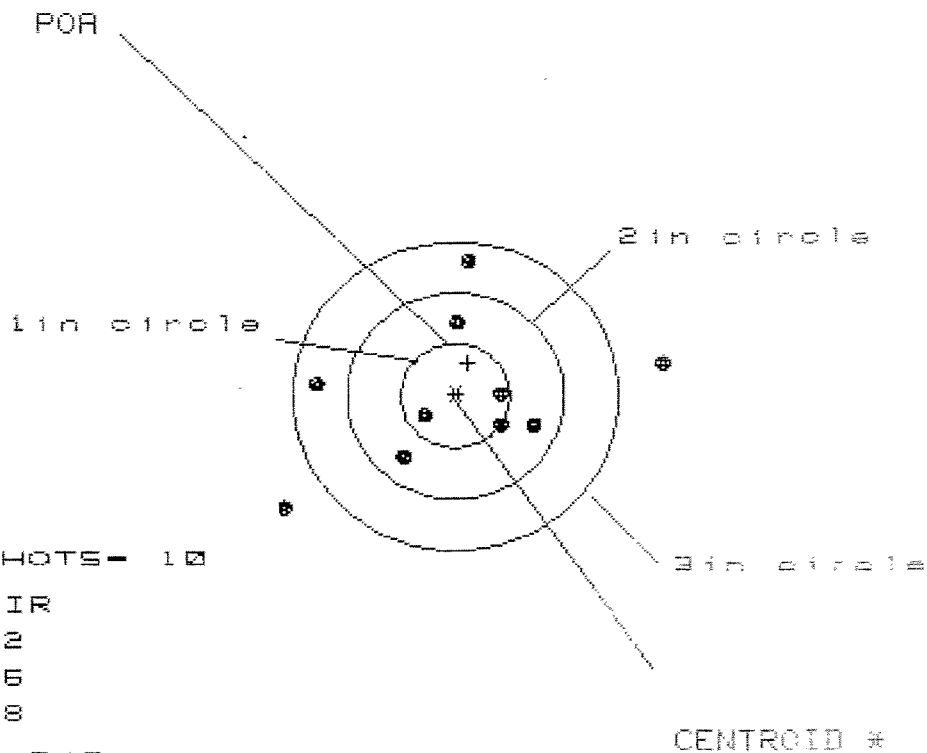
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.559	1.352	1.125
MINIMUM X	:	-1.863	-1.817	-1.321
MAXIMUM Y	:	.872	.877	.766
MINIMUM Y	:	-.893	-.888	-.712
CENTROID X	:	-.361	-.154	.073
CENTROID Y	:	-.109	-.114	-.003
POA TO CENTROID in.	:	.377	.192	.073
MIN RADIUS	:	.081	.273	.496
MEAN RADIUS	:	1.080	.994	.857
MAX RADIUS	:	1.863	2.022	1.245
HORIZONTAL SPREAD	:	3.422	3.169	2.446
VERTICAL SPREAD	:	1.765	1.765	1.478
EXTREME SPREAD	:	3.429	3.296	2.563
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in - 2

2in - 6

3in - 8

HS = 3.543

VS = 2.445

GS = 3.824

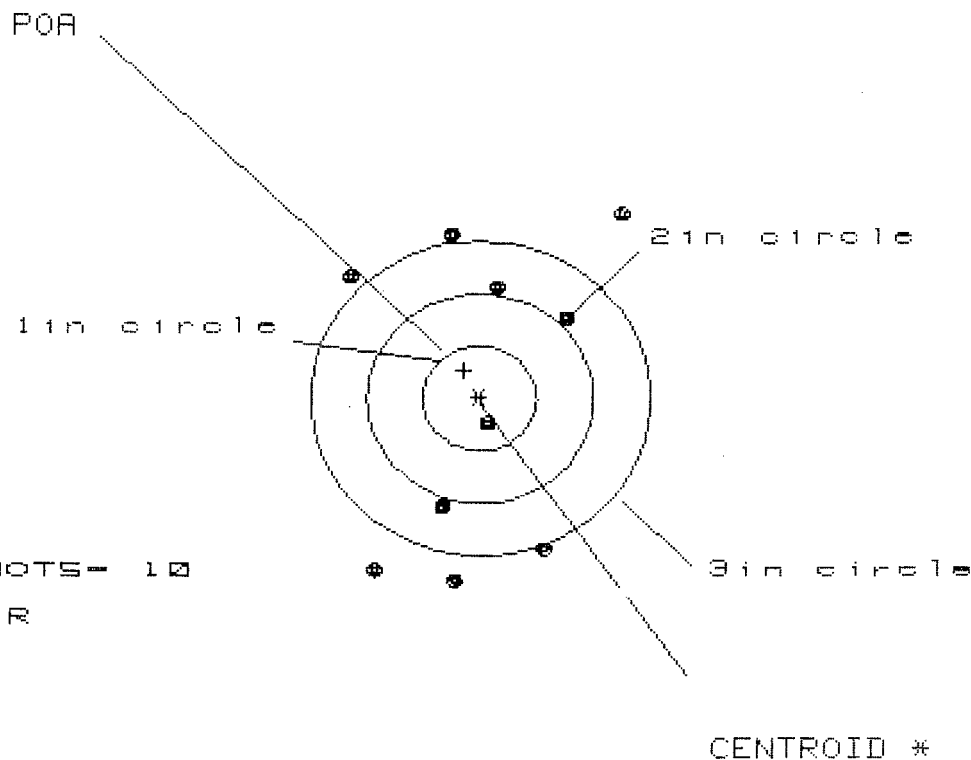
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.938	.966	.792
MINIMUM X	:	-1.605	-1.390	-1.227
MAXIMUM Y	:	1.330	1.366	1.232
MINIMUM Y	:	-1.115	-1.079	-1.702
CENTROID X	:	-.118	-.333	-.159
CENTROID Y	:	-.317	-.353	-.219
POR TO CENTROID in.	:	.338	.486	.270
MIN RADIUS	:	.355	.187	.393
MEAN RADIUS	:	1.015	.910	.769
MAX RADIUS	:	1.965	1.759	1.246
HORIZONTAL SPREAD	:	3.543	2.356	2.019
VERTICAL SPREAD	:	2.445	2.445	1.933
EXTREME SPREAD	:	3.824	3.007	2.046
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 1

3in = 4

HS = 2.417

VS = 3.546

GS = 4.117

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	.907	.810
MINIMUM X	:	-1.109	-.964	-1.061
MAXIMUM Y	:	1.784	1.732	1.547
MINIMUM Y	:	-1.762	-1.564	-1.749
CENTROID X	:	.141	-.004	.093
CENTROID Y	:	-.265	-.463	-.278
POA TO CENTROID in.	:	.300	.463	.293
MIN RADIUS	:	.244	.161	.238
MEAN RADIUS	:	1.407	1.298	1.244
MAX RADIUS	:	2.212	1.738	1.755
HORIZONTAL SPREAD	:	2.417	1.871	1.871
VERTICAL SPREAD	:	3.546	3.296	3.296
EXTREME SPREAD	:	4.117	3.297	3.297
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		4	