

C6636169

MODEL 700™ M24

Model SMS™

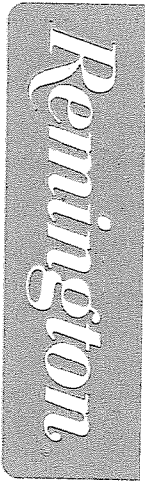
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



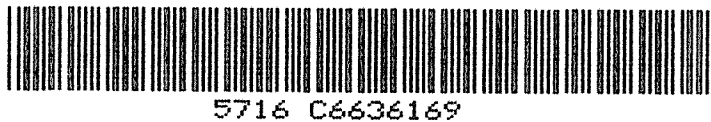


VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24	SERIAL NO. C6636169
	ORDER NO. 5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

20



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636169

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 2	9 1	RW
600	Proof	5 2	9 1	RW
607	Check Headspace	5 2	9 1	RW
610	Dis-assemble Gun	5 2	9 1	RW
612	Magnaflux Barrel Action	5 8	9 1	KCR
	Magnaflux Bolt	5 8	9 1	KCR
615	Rollmark Caliber	5 8	9 1	GL
617	Drill and Tap Sight Holes	5 15	9 1	LB
618	Polish Barrel	5 15	9 1	WB
620	Apply Coatings (Barrel Action)		5-29-91	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/30/91	RW
	C) Inspect Ejector Hole for Chamfer		5/30/91	RW
	D) Oil Firing Pin Ass'y		5/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5/30/91	RU

op. #	BARBER M24 0038509	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7 1/2	7	7			5-30-91	DH
	G) Safety Off Force	3 1/2	3 1/2	3			5-30-91	DH
	H) Trigger Pull Test & Retainability						6/30/91	RL
	I) Firing Pin Indent	.020	.021	.020			5-30-91	DH
	J) Assemble Stock						5/31/91	RW
	K) Assemble Swivel Studs						6-3-91	DH
	L) Attach Front and Rear Sight Assemblies						5/31/91	RW
	M) Iron Sight Alignment						5/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						5/31/91	RW
	O) Attach Scope to Rifle						5/31/91	RW
	P) Detach & Attach Scope 20 Times						5/31/91	RW
640	Gallery Target & Test						6-1-91	DH
	A) Time						6-1-91	DH
	B) Malfunctions						6-1-91	DH
	C) Pierced Primers						6-1-91	DH
	D) Optical Clarity of Scope						6-1-91	DH
645	Inspect for Live Ammo						6-1-91	DH
655	Final Inspection							
	A) Headspace						6-3-91	DH
	B) Trigger Pull	2.48	2.38	2.42	2.38	2.35	6/3/01	RL
	C) Function						6-3-91	DH
660	Pack						6-20-91	RL

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636169

DATE 5/30/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.47	2.54	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.44	2.50	2.38	
PULL #3	2.38	2.50	2.49	2.42	
PULL #4	2.46	2.50	2.56	2.38	
PULL #5	2.14	2.57	2.55	2.35	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.44		
PULL #2	3.37	3.25		
PULL #3	3.43	3.26		
PULL #4	3.47	3.38		
PULL #5	3.49	3.64		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.32		4.47
PULL #2	4.41	4.34		4.50
PULL #3	4.41	4.48		4.44
PULL #4	4.30	4.34		4.37
PULL #5	4.25	4.40		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636169
1 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.104307
1 TO	2	.244043
1 TO	3	.257288
1 TO	4	.369444
1 TO	5	.0842021

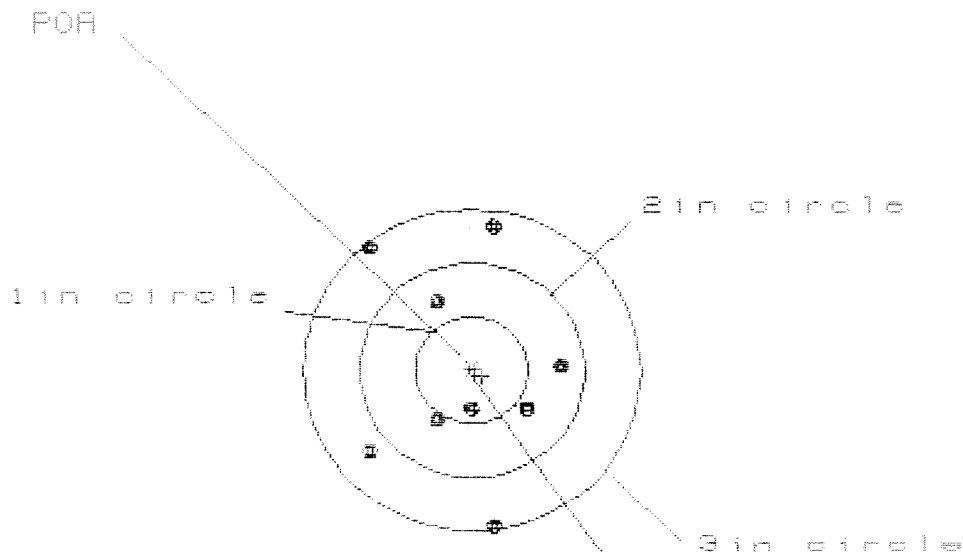
4.92 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0782
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .890524
THE AMR FOR THIS RIFLE IS: .9374

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06636169

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.700

VS = 2.788

GS = 2.788

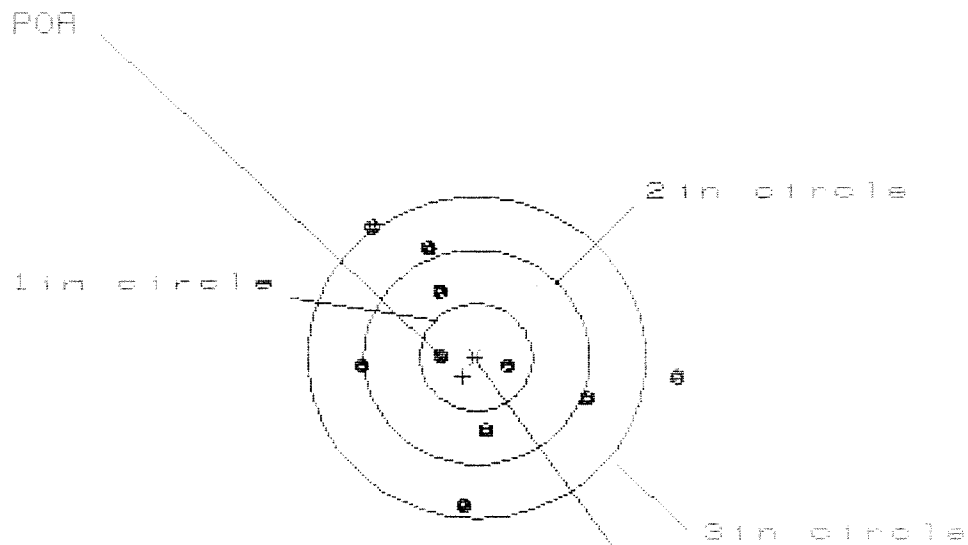
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.796	.696	.706
MINIMUM X	-.904	-1.004	-.994
MAXIMUM Y	1.377	1.501	1.340
MINIMUM Y	-1.411	-1.287	-.766
CENTROID X	-.088	.012	.002
CENTROID Y	.056	-.068	.093
POA TO CENTROID in.	.104	.069	.093
MIN RADIUS	.326	.217	.369
MEAN RADIUS	.913	.823	.780
MAX RADIUS	1.429	1.503	1.343
HORIZONTAL SPREAD	1.700	1.700	1.700
VERTICAL SPREAD	2.788	2.788	2.106
EXTREME SPREAD	2.788	2.788	2.373
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636163

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.779

VS= 2.521

GS= 3.025

CENTROID #

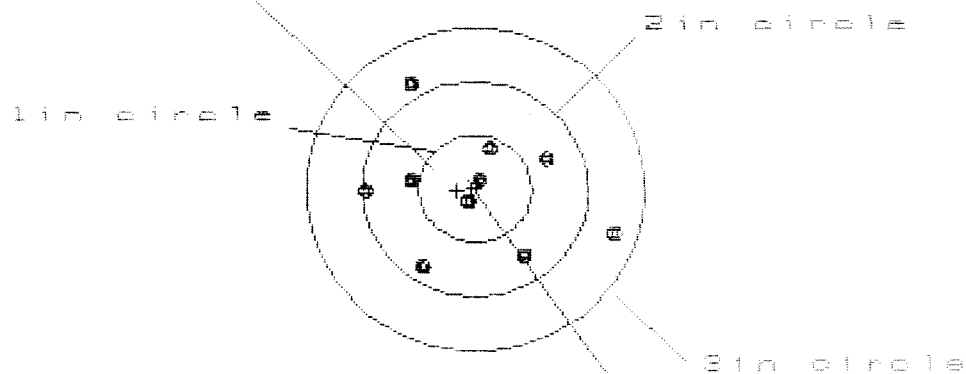
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.747	1.177	1.083
MINIMUM X	:	-1.032	-.838	-.932
MAXIMUM Y	:	1.172	1.149	1.135
MINIMUM Y	:	-1.349	-1.372	-1.228
CENTROID X	:	.121	-.073	.021
CENTROID Y	:	.182	.205	.061
POA TO CENTROID in.	:	.219	.218	.065
MIN RADIUS	:	.301	.108	.268
MEAN RADIUS	:	.976	.865	.804
MAX RADIUS	:	1.759	1.374	1.230
HORIZONTAL SPREAD	:	2.779	2.015	2.015
VERTICAL SPREAD	:	2.521	2.521	2.363
EXTREME SPREAD	:	3.025	2.639	2.372
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Jun 1991

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CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.225

VS= 1.689

GS= 2.293

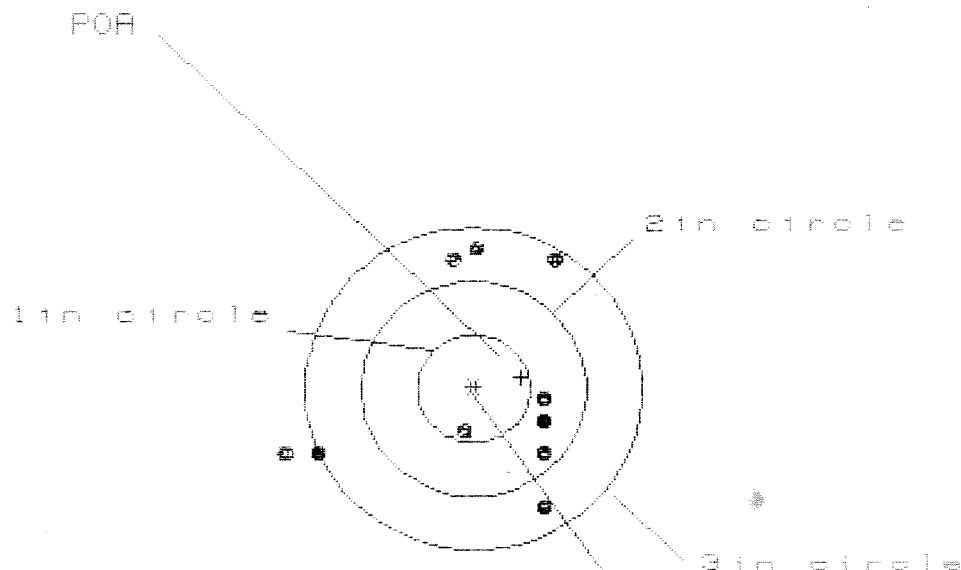
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.256	.804	.752
MINIMUM X	:	-.969	-.830	-.882
MAXIMUM Y	:	.991	.945	.443
MINIMUM Y	:	-.698	-.744	-.626
CENTROID X	:	.166	.027	.079
CENTROID Y	:	.015	.061	-.057
POA TO CENTROID in.	:	.167	.067	.097
MIN RADIUS	:	.122	.196	.073
MEAN RADIUS	:	.698	.632	.568
MAX RADIUS	:	1.322	1.032	.882
HORIZONTAL SPREAD	:	2.225	1.634	1.634
VERTICAL SPREAD	:	1.689	1.689	1.069
EXTREME SPREAD	:	2.293	1.872	1.667
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836163

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.344

VS = 2.411

GS = 2.930

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.696	.513	.315
MINIMUM X	-1.648	-1.582	-.549
MAXIMUM Y	1.270	1.207	1.122
MINIMUM Y	-1.141	-1.204	-1.289
CENTROID X	-.421	-.238	-.040
CENTROID Y	-.104	-.042	.043
POA TO CENTROID in.	.434	.242	.059
MIN RADIUS	.358	.435	.339
MEAN RADIUS	1.102	1.000	.889
MAX RADIUS	1.742	1.723	1.317
HORIZONTAL SPREAD	2.344	2.095	.864
VERTICAL SPREAD	2.411	2.411	2.411
EXTREME SPREAD	2.930	2.771	2.525
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/086361B9

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.817

VS= 3.431

GS= 4.439

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.435	1.281	.661
MINIMUM X	-1.382	-1.175	-1.015
MAXIMUM Y	1.483	1.266	.959
MINIMUM Y	-1.948	-.872	-.714
CENTROID X	-.169	-.015	-.175
CENTROID Y	.079	.296	.138
POA TO CENTROID in.	.186	.296	.223
MIN RADIUS	.264	.282	.235
MEAN RADIUS	.998	.826	.687
MAX RADIUS	2.389	1.801	1.129
HORIZONTAL SPREAD	2.817	2.456	1.676
VERTICAL SPREAD	3.431	2.138	1.673
EXTREME SPREAD	4.439	2.963	2.062
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		