

C6225055

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



GUN SERIAL # C6225055

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	8 8	FB
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble Gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9 22 88	Pfe.
	Magnaflux Bolt		9 22 88	Pfe
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/3/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/3/88	RW
	C) Inspect Ejector Hole for Chamfer		11/3/88	RW
	D) Oil Firing Pin Ass'y		11/3/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-3-88	JCJ & GJ

BARBER - M24 0047903

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	6	5	5.5			8/10/88	RS
	G) Safety Off Force	3	3.5	3.5			8/10/88	RS
	H) Trigger Pull Test & Retainability						3/10/88	RS
	I) Firing Pin Indent	.020	.020	.020			8/10/88	RS
	J) Assemble Stock						11/16/88	RW
	K) Assemble Swivel Studs						10 Dec 88	RS
	L) Attach Front and Rear Sight Assemblies						11/16/88	RW
	M) Iron Sight Alignment						11/16/88	RW
	N) Detach Front & Rear Sights & place in numbered container						11/16/88	RW
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test	70 R	82L				11/18/88	DH
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope						11/18/88	DH
645	Inspect for Live Ammo						11/18/88	DH
655	Final Inspection						1 Dec 88	RS
	A) Headspace						1 Dec 88	RS
	B) Trigger Pull	2.49	2.46	2.49	2.48	2.50	1 Dec 88	RS
	C) Function						1 Dec 88	RS
660	Pack						14 Dec 88	RS

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

SERIAL NO. C6225055DATE 3/11/88TESTER J. U. + M. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.35	2.38	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.26	2.42	2.46	
PULL #3	2.42	2.30	2.44	2.49	
PULL #4	2.45	2.35	2.44	2.48	
PULL #5	2.45	2.37	2.41	2.50	
TOTAL	12.27	11.63	12.09	12.42	
AVG.	2.454	2.326	2.418	2.484	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.20		
PULL #2	3.16	3.15		
PULL #3	3.18	3.21		
PULL #4	3.22	3.19		
PULL #5	3.17	3.18		
TOTAL	15.90	15.93		
AVG.	3.18	3.186		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	3.91		4.06
PULL #2	4.10	3.95		4.06
PULL #3	4.05	3.95		4.04
PULL #4	4.05	3.97		4.03
PULL #5	4.02	3.99		4.03
TOTAL	20.32	19.77		20.21
AVG.	4.064	3.954		4.042

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225055

CENTROIDAL DISTANCES

0	TO	1	.889648
1	TO	2	.431264
1	TO	3	.364001
1	TO	4	.484533
1	TO	5	.121277

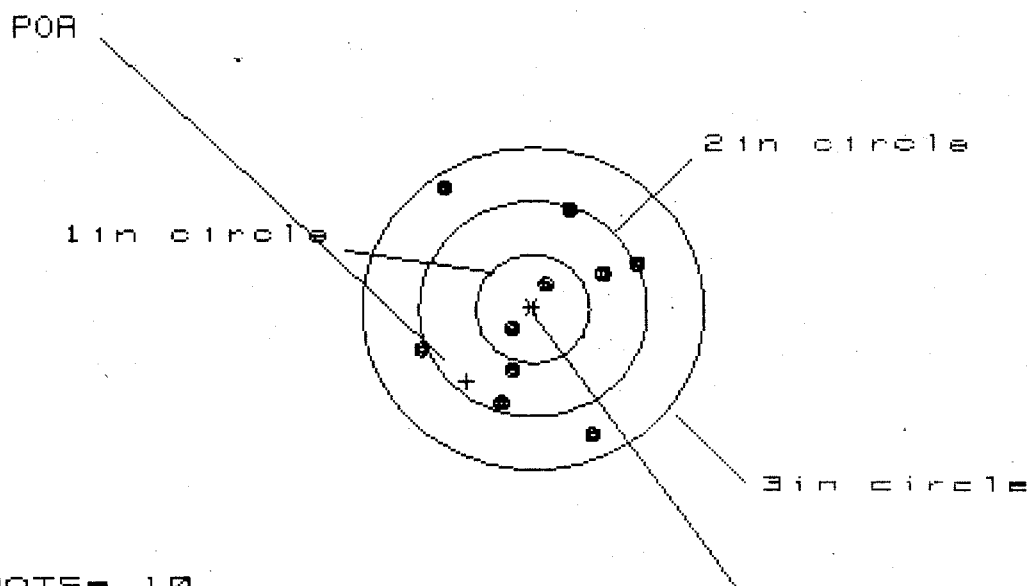
2
1
0
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4376
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7666
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .882706
THE AMR FOR THIS RIFLE IS: .9488

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FILE://PATTERNING/CENTERFIRE_PATT/C6225055

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 2

2in - 6

3in - 10

HS - 1.862

VS - 2.302

GS - 2.639

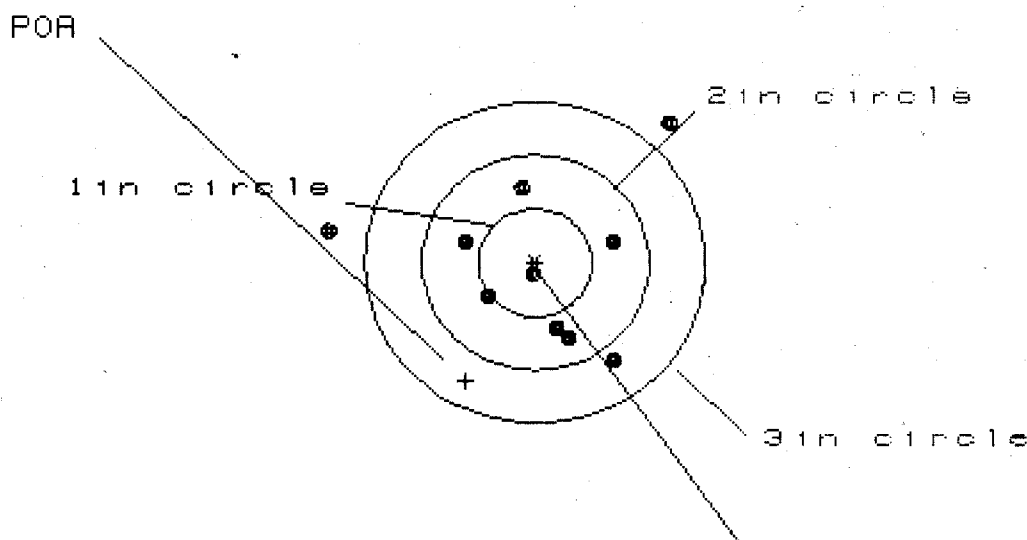
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.893	.802	.849
MINIMUM X	-.969	-1.060	-1.013
MAXIMUM Y	1.156	1.065	.938
MINIMUM Y	-1.146	-1.017	-.839
CENTROID X	.583	.674	.627
CENTROID Y	.672	.543	.670
POA TO CENTROID in.	.890	.866	.918
MIN RADIUS	.243	.255	.252
MEAN RADIUS	.840	.769	.717
MAX RADIUS	1.417	1.090	1.082
HORIZONTAL SPREAD	1.862	1.862	1.862
VERTICAL SPREAD	2.302	2.082	1.777
EXTREME SPREAD	2.639	2.091	2.046
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 2.917

VS= 2.179

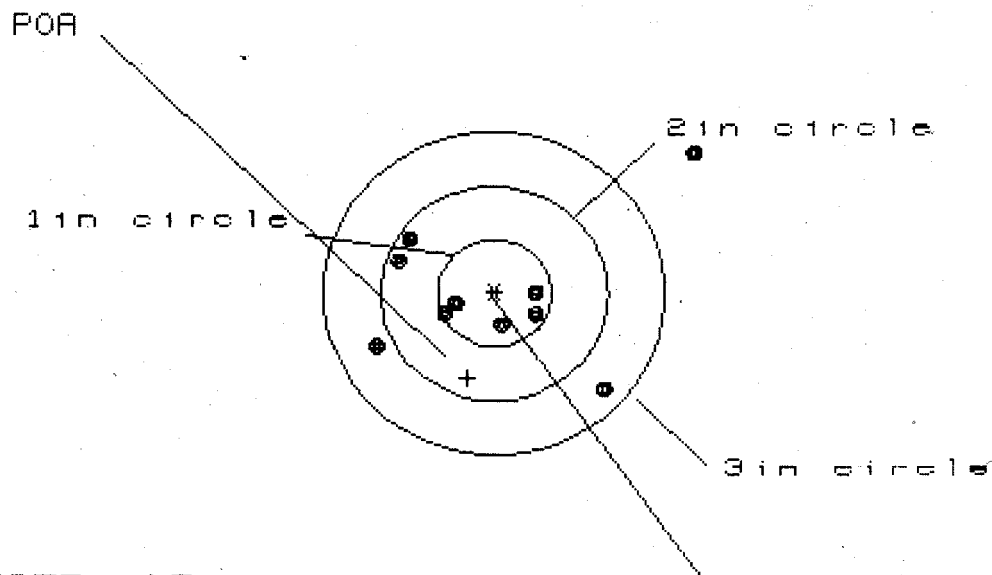
GS= 3.089

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	.953	.628
MINIMUM X	:	-1.768	-.812	-.693
MAXIMUM Y	:	1.273	1.301	.900
MINIMUM Y	:	-.906	-.878	-.715
CENTROID X	:	.616	.812	.693
CENTROID Y	:	1.102	1.074	.911
POA TO CENTROID in.	:	1.262	1.346	1.145
MIN RADIUS	:	.087	.204	.129
MEAN RADIUS	:	.865	.767	.617
MAX RADIUS	:	1.786	1.613	.952
HORIZONTAL SPREAD	:	2.917	1.765	1.321
VERTICAL SPREAD	:	2.179	2.179	1.615
EXTREME SPREAD	:	3.089	2.224	1.832
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.740

VS= 2.245

GS= 3.301

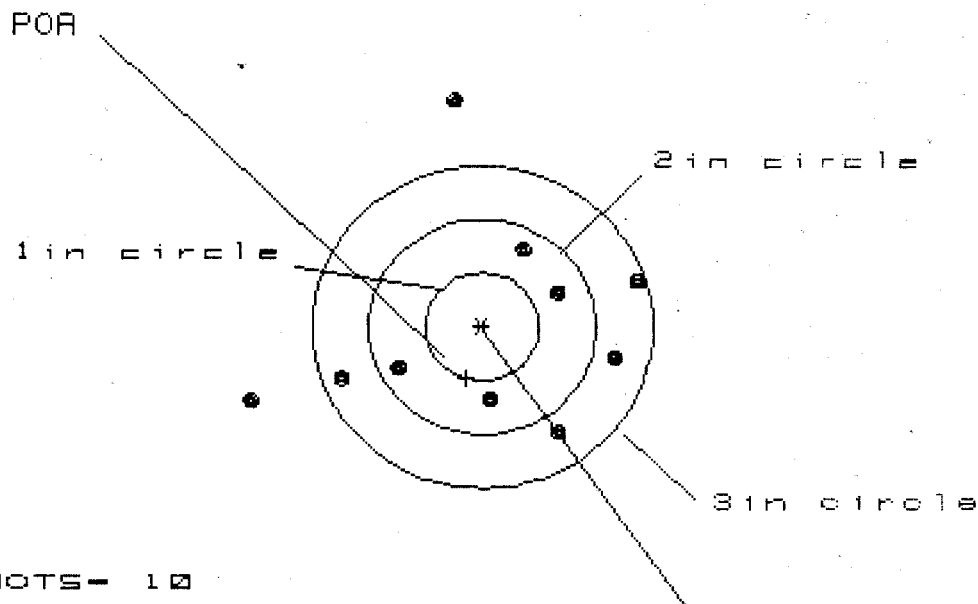
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.716	1.138	.732
MINIMUM X	:	-1.024	-.833	-.691
MAXIMUM Y	:	1.356	.657	.565
MINIMUM Y	:	-.889	-.738	-.426
CENTROID X	:	.239	.048	-.094
CENTROID Y	:	.791	.640	.732
POA TO CENTROID in.	:	.826	.642	.738
MIN RADIUS	:	.246	.203	.044
MEAN RADIUS	:	.845	.651	.538
MAX RADIUS	:	2.188	1.356	.812
HORIZONTAL SPREAD	:	2.740	1.971	1.423
VERTICAL SPREAD	:	2.245	1.395	.991
EXTREME SPREAD	:	3.301	2.215	1.491
NUMBER IN ONE INCH CIRCLE =			5	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.425

VS= 3.148

GS= 3.610

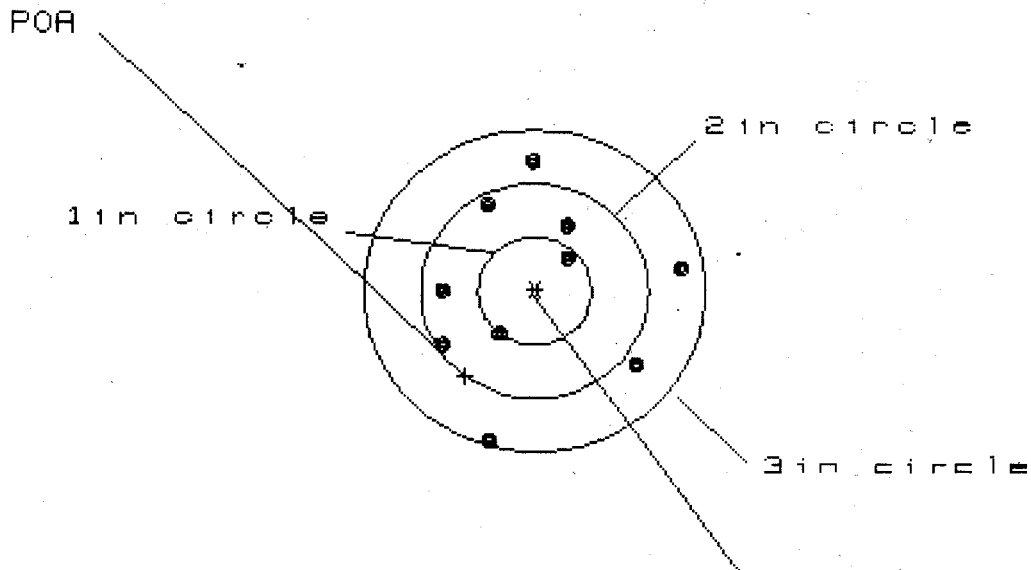
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.368	1.140	1.080
MINIMUM X	:	-2.057	-1.493	-1.553
MAXIMUM Y	:	2.127	2.048	.851
MINIMUM Y	:	-1.021	-1.100	-.844
CENTROID X	:	.139	.367	.427
CENTROID Y	:	.478	.557	.301
POA TO CENTROID in.	:	.498	.667	.523
MIN RADIUS	:	.679	.524	.537
MEAN RADIUS	:	1.258	1.119	.966
MAX RADIUS	:	2.176	2.103	1.575
HORIZONTAL SPREAD	:	3.425	2.633	2.633
VERTICAL SPREAD	:	3.148	3.148	1.695
EXTREME SPREAD	:	3.610	3.291	2.773
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			8	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.100

VS= 2.622

GS= 2.651

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.300	1.258	.982
MINIMUM X	:	-.800	-.842	-.685
MAXIMUM Y	:	1.184	1.024	1.028
MINIMUM Y	:	-1.438	-.855	-.851
CENTROID X	:	.611	.653	.496
CENTROID Y	:	.790	.950	.946
POA TO CENTROID in.	:	.999	1.153	1.068
MIN RADIUS	:	.419	.284	.428
MEAN RADIUS	:	.936	.852	.792
MAX RADIUS	:	1.488	1.258	1.300
HORIZONTAL SPREAD	:	2.100	2.100	1.667
VERTICAL SPREAD	:	2.622	1.879	1.879
EXTREME SPREAD	:	2.651	2.197	2.064
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	