

C6225083

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225083

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	p/c.
	Magnaflux Bolt		9-14-88	p/c.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		2 NOV 88	JS
	F) Safety on Force	5 5 5	2 NOV 88	JS
	G) Safety off Force	4 4 4	2 NOV 88	JS
	H) Trigger Pull Test & Retainability		2 NOV 88	JS
	I) Firing Pin Indent	.020 .020 .020	2 NOV 88	JS
	J) Assemble Stock		11/9/88	RW
	K) Assemble Swivel Studs		30 NOV 88	JS
	L) Attach Front & Rear Sight Assemblies		11/9/88	RW
	M) Iron Sight Alignment		11/9/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/9/88	RW
	O) Attach Scope to Rifle		11 NOV 88	JS
	P) Detach & Attach Scope 20 times			
640	Gallery Target & Test	614 89L	11/14/88	D.H
	A) Optical Clarity of Scope		11/14/88	D.H
645	Inspect for Live Ammo		11/14/88	17.H
655	Final Inspection			
	A) Headspace		30 NOV 88	JS
	B) Trigger Pull		30 NOV 88	JS
	C) Function		30 NOV 88	JS
660	Pack		14 Dec 88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225083

DATE 3/10/88

TESTER JU. + 408

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.56	2.69	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.53	2.68	2.70	
PULL #3	2.53	2.50	2.67	2.71	
PULL #4	2.56	2.56	2.68	2.74	
PULL #5	2.59	2.46	2.66	2.75	
TOTAL	2.78	2.51	13.38	13.56	
AVG.	2.556	2.502	2.676	2.712	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.21		
PULL #2	3.31	3.25		
PULL #3	3.27	3.27		
PULL #4	3.25	3.28		
PULL #5	3.24	3.31		
TOTAL	16.37	16.32		
AVG.	3.274	3.264		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.13		4.35
PULL #2	4.24	4.20		4.33
PULL #3	4.25	4.22		4.35
PULL #4	4.24	4.21		4.36
PULL #5	4.22	4.23		4.39
TOTAL	21.18	20.99		21.78
AVG.	4.236	4.198		4.356

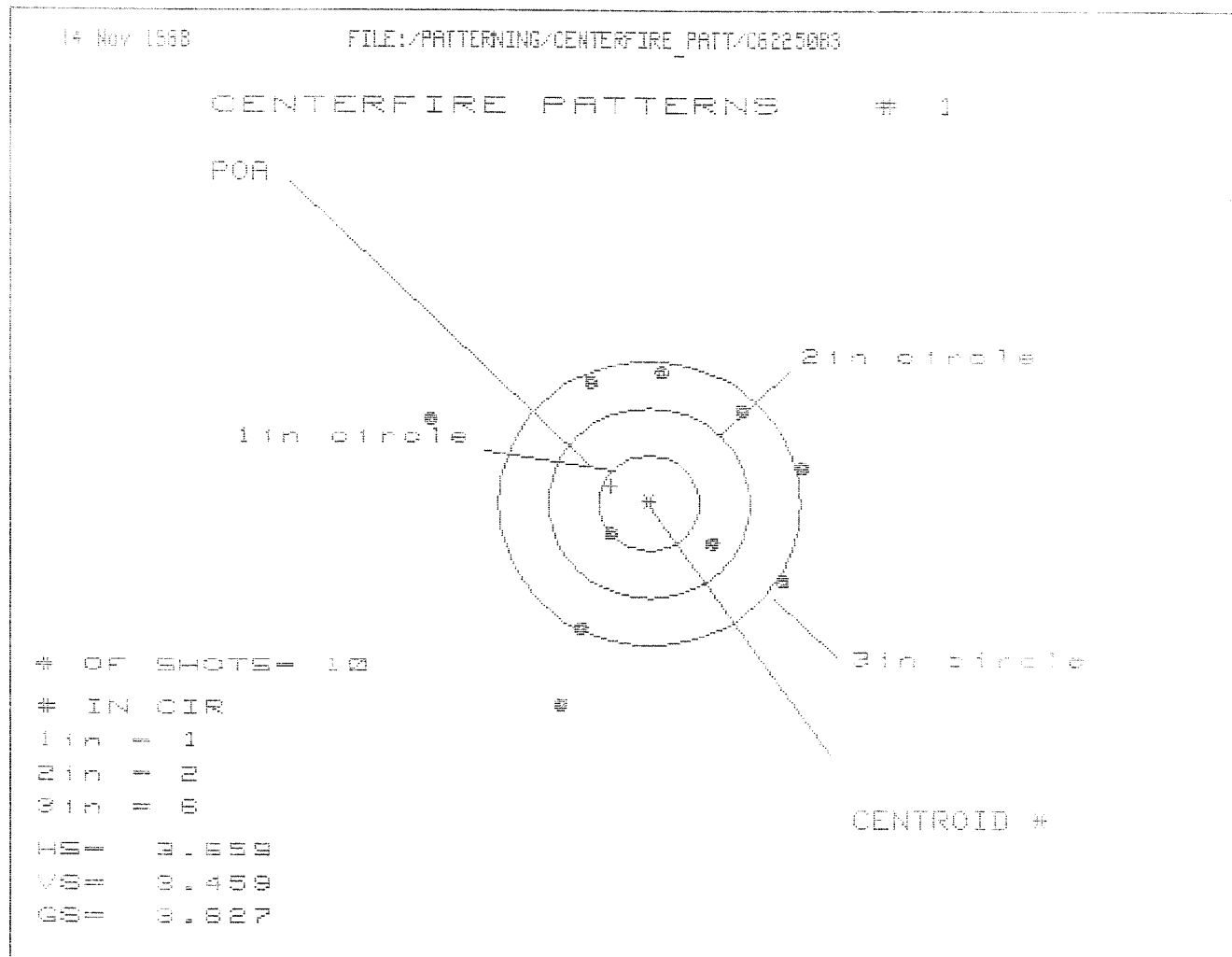
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225083

CENTROIDAL DISTANCES

0 TO	1	.418199
1 TO	2	.345861
1 TO	3	.289171
1 TO	4	.622371
1 TO	5	.911285

5
4.2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .136
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .128
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .186762
THE AMR FOR THIS RIFLE IS: 1.182

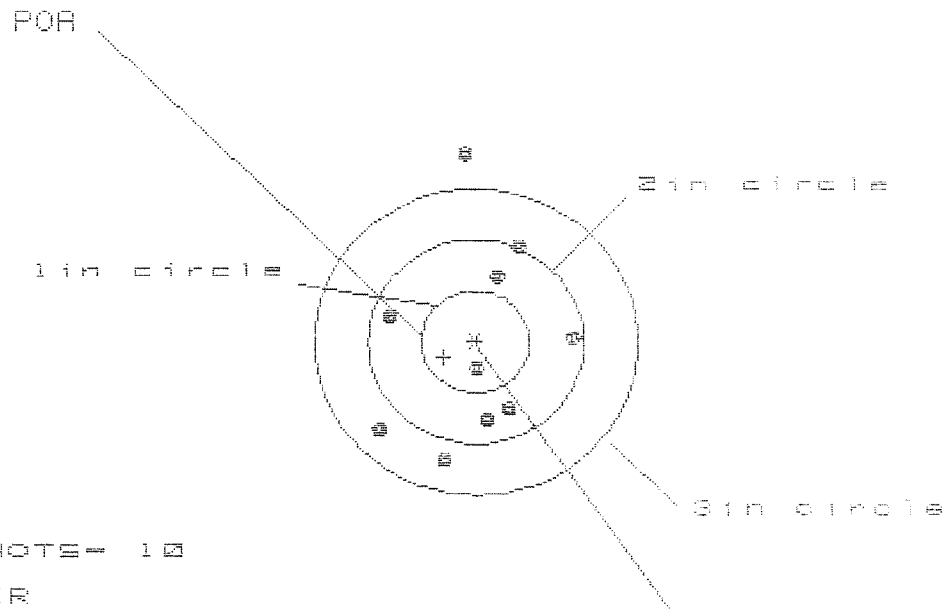


PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.519	1.281	1.145
MINIMUM X	-2.140	-1.084	-1.093
MAXIMUM Y	1.376	1.473	1.225
MINIMUM Y	-2.083	-1.986	-1.503
CENTROID X	.377	.615	.751
CENTROID Y	-.181	-.278	-.030
POA TO CENTROID in.	.419	.675	.751
MIN RADIUS	.473	.514	.611
MEAN RADIUS	1.451	1.325	1.186
MAX RADIUS	2.312	2.263	1.807
HORIZONTAL SPREAD	3.659	2.365	2.148
VERTICAL SPREAD	3.459	3.459	2.728
EXTREME SPREAD	3.827	3.591	2.818
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225083

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 1.768

VS = 2.938

GS = 2.945

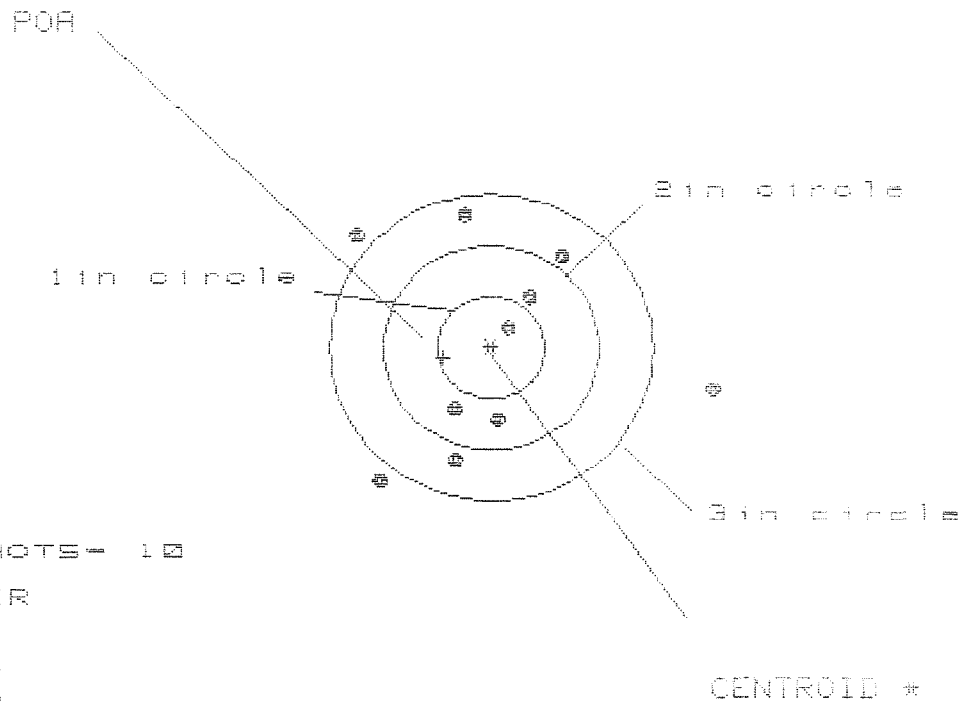
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.912	.907	.799
MINIMUM X	:	-.856	-.861	-.861
MAXIMUM Y	:	1.822	1.109	1.030
MINIMUM Y	:	-1.116	-.913	-.992
CENTROID X	:	.295	.300	.408
CENTROID Y	:	.155	-.048	.031
POA TO CENTROID in.	:	.333	.304	.409
MIN RADIUS	:	.215	.024	.125
MEAN RADIUS	:	.930	.786	.757
MAX RADIUS	:	1.823	1.163	1.058
HORIZONTAL SPREAD	:	1.768	1.768	1.660
VERTICAL SPREAD	:	2.938	2.022	2.022
EXTREME SPREAD	:	2.945	2.118	2.111
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG225083

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.266

VS = 2.547

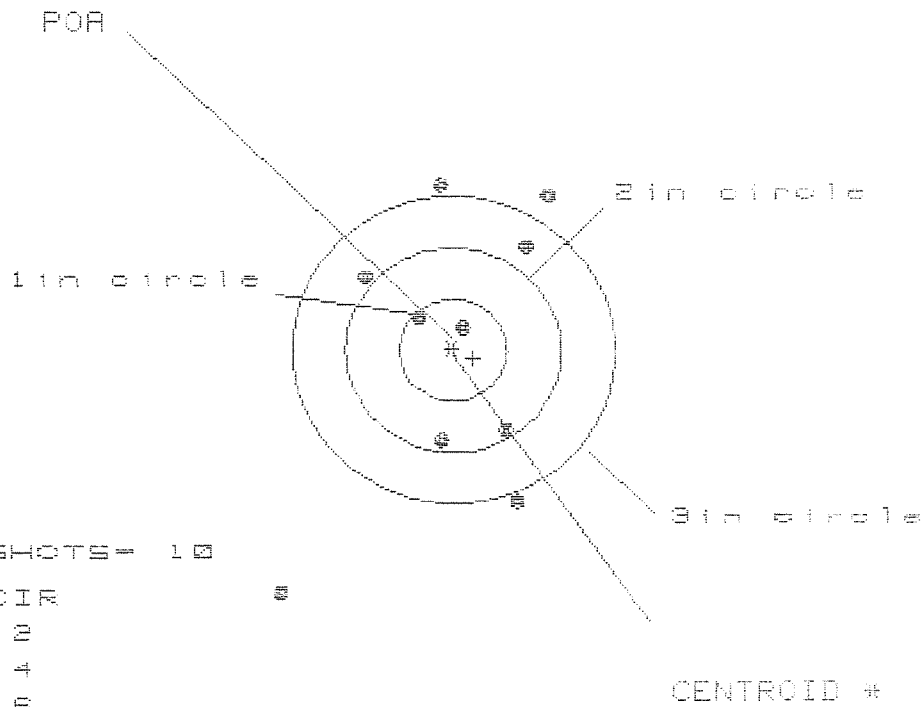
GS = 3.586

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.052	.877	.777
MINIMUM X	-1.214	-.986	-1.086
MAXIMUM Y	1.272	1.229	1.064
MINIMUM Y	-1.275	-1.318	-1.335
CENTROID X	.441	.213	.313
CENTROID Y	.101	.144	.309
POA TO CENTROID in.	.453	.257	.439
MIN RADIUS	.273	.439	.308
MEAN RADIUS	1.118	1.018	.928
MAX RADIUS	2.088	1.539	1.401
HORIZONTAL SPREAD	3.266	1.863	1.863
VERTICAL SPREAD	2.547	2.547	2.399
EXTREME SPREAD	3.586	2.759	2.401
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	7	

14 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225083

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS= 2.512

VS= 4.030

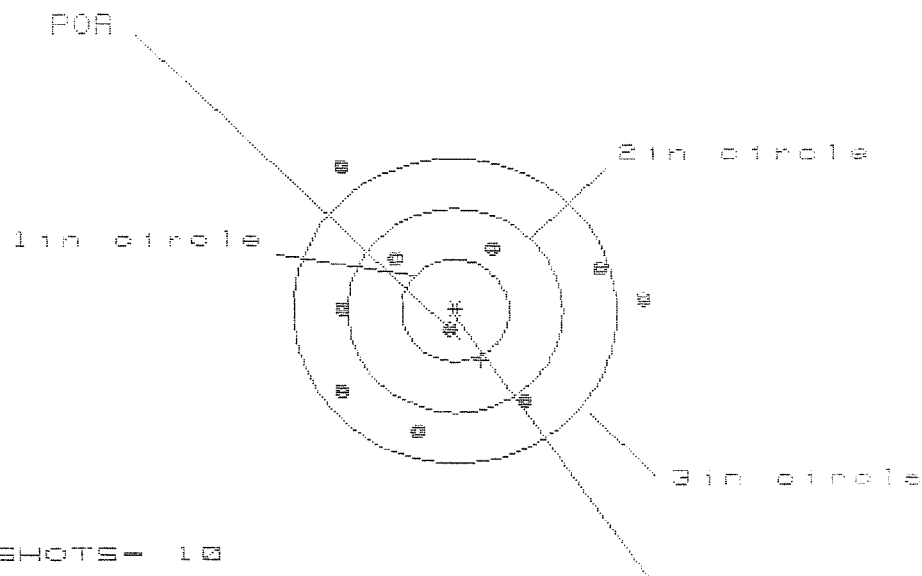
GS= 4.663

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.905	.726	.622
MINIMUM X	-1.607	-.950	-.859
MAXIMUM Y	1.632	1.366	1.524
MINIMUM Y	-2.398	-1.738	-1.580
CENTROID X	-.188	-.009	-.100
CENTROID Y	.080	.346	.188
POA TO CENTROID in.	.204	.346	.213
MIN RADIUS	.282	.050	.148
MEAN RADIUS	1.271	1.047	.990
MAX RADIUS	2.887	1.787	1.659
HORIZONTAL SPREAD	2.512	1.676	1.481
VERTICAL SPREAD	4.030	3.104	3.104
EXTREME SPREAD	4.663	3.180	3.180
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	6	

14 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225003

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 2.847

VS= 2.651

GS= 3.143

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.748	1.627	1.469
MINIMUM X	-1.099	-1.220	-1.017
MAXIMUM Y	1.450	.758	.791
MINIMUM Y	-1.201	-1.040	-1.007
CENTROID X	-.245	-.124	-.327
CENTROID Y	.485	.324	.291
POB TO CENTROID in.	.544	.347	.438
MIN RADIUS	.235	.157	.075
MEAN RADIUS	1.138	1.053	.946
MAX RADIUS	1.816	1.649	1.595
HORIZONTAL SPREAD	2.847	2.847	2.477
VERTICAL SPREAD	2.651	1.798	1.798
EXTREME SPREAD	3.143	2.978	2.758
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		