

C6225558

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



BARBER - M24 **M2400951472**

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225558*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2/1</i>	<i>FB</i>
600	PROOF	<i>2/2/88</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>P/C</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>P/C</i>
620	COATING	<i>3/21/88</i>	<i>ISA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

Scope & 1074

CONTRACT # DAAG21-87-C-0086

GUN SERIAL # C6225558

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

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9 Sept 88	JU + J.S.
	F) Safety on Force	4 4.25 4.25	9 Sept 88	JU + J.S.
	G) Safety off Force	2.25 3 3	9 Sept 88	JU + J.S.
	H) Trigger Pull Test & Retainability		9 Sept 88	JU + J.S.
	I) Firing Pin Indent	.022 .022 .022	9 Sept 88	JU + J.S.
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/15/88	RW
	M) Iron Sight Alignment		9/15/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/15/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	J.S.
640	Gallery Target & Test	55 R 100L	10/10/88	A.C.
	A) Optical Clarity of Scope		10/10/88	A.C.
645	Inspect for Live Ammo		10/10/88	V.B.
655	Final Inspection		10-12-88	J.S.
	A) Headspace		10-14-88	J.S.
	B) Trigger Pull		10-12-88	J.S.
	C) Function		10-12-88	J.S.
660	Pack		10-21-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225558DATE 9 Sept. 88TESTER J. U. + 92

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.20	2.30	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.18	2.29	2.48	
PULL #3	2.28	2.20	2.27	2.49	
PULL #4	2.44	2.17	2.24	2.44	
PULL #5	2.48	2.21	2.21	2.56	
TOTAL	12.26	10.96	11.31	12.50	
AVG.	2.452	2.192	2.262	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.04		
PULL #2	3.03	3.06		
PULL #3	3.09	3.07		
PULL #4	3.03	3.05		
PULL #5	3.05	3.12		
TOTAL	15.25	15.34		
AVG.	3.05	3.068		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.05		4.20
PULL #2	4.13	4.21		4.19
PULL #3	4.16	4.15		4.16
PULL #4	4.13	4.14		4.21
PULL #5	4.14	4.20		4.13
TOTAL	20.72	20.75		20.89
AVG.	4.144	4.15		4.178

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225558

CENTROIDAL DISTANCES

0	TO	1	1.05142
1	TO	2	.299541
1	TO	3	.678189
1	TO	4	.409236
1	TO	5	.728271

+ <----FOR
5
3 2
4 1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.571
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.7792
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .966019
THE AMR FOR THIS RIFLE IS: .7682

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CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.573

VS= 2.468

GS= 2.473

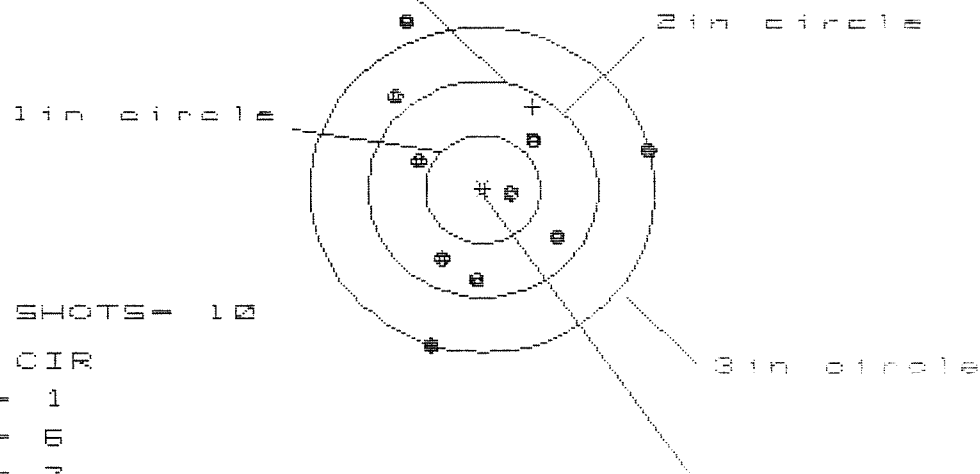
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.664	.672	.570
MINIMUM X	-.909	-.901	-1.003
MAXIMUM Y	1.032	.872	.764
MINIMUM Y	-1.436	-.866	-.625
CENTROID X	-.278	-.286	-.184
CENTROID Y	-1.014	-.854	-.746
POA TO CENTROID in.	1.051	.900	.768
MIN RADIUS	.236	.364	.225
MEAN RADIUS	.794	.714	.633
MAX RADIUS	1.438	1.189	1.006
HORIZONTAL SPREAD	1.573	1.573	1.573
VERTICAL SPREAD	2.468	1.738	1.389
EXTREME SPREAD	2.473	2.058	1.660
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 7

HS= 2.228

VS= 3.044

GS= 3.048

CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.480	1.409	1.338
MINIMUM X	:	-.748	-.819	-.890
MAXIMUM Y	:	1.563	1.067	.903
MINIMUM Y	:	-1.481	-1.307	-.871
CENTROID X	:	-.443	-.372	-.301
CENTROID Y	:	-.764	-.938	-.774
POA TO CENTROID in.:	:	.883	1.008	.831
MIN RADIUS	:	.297	.252	.155
MEAN RADIUS	:	.993	.892	.814
MAX RADIUS	:	1.691	1.524	1.402
HORIZONTAL SPREAD	:	2.228	2.228	2.228
VERTICAL SPREAD	:	3.044	2.374	1.774
EXTREME SPREAD	:	3.048	2.732	2.280
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= .967

VS= 1.819

GS= 2.009

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.512	.474	.534
MINIMUM X	-.455	-.493	-.433
MAXIMUM Y	1.302	.523	.477
MINIMUM Y	-.517	-.373	-.345
CENTROID X	-.830	-.792	-.852
CENTROID Y	-.620	-.764	-.718
POA TO CENTROID in.	1.036	1.101	1.114
MIN RADIUS	.131	.177	.103
MEAN RADIUS	.575	.471	.444
MAX RADIUS	1.346	.716	.716
HORIZONTAL SPREAD	.967	.967	.967
VERTICAL SPREAD	1.819	.896	.822
EXTREME SPREAD	2.009	1.315	1.229
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

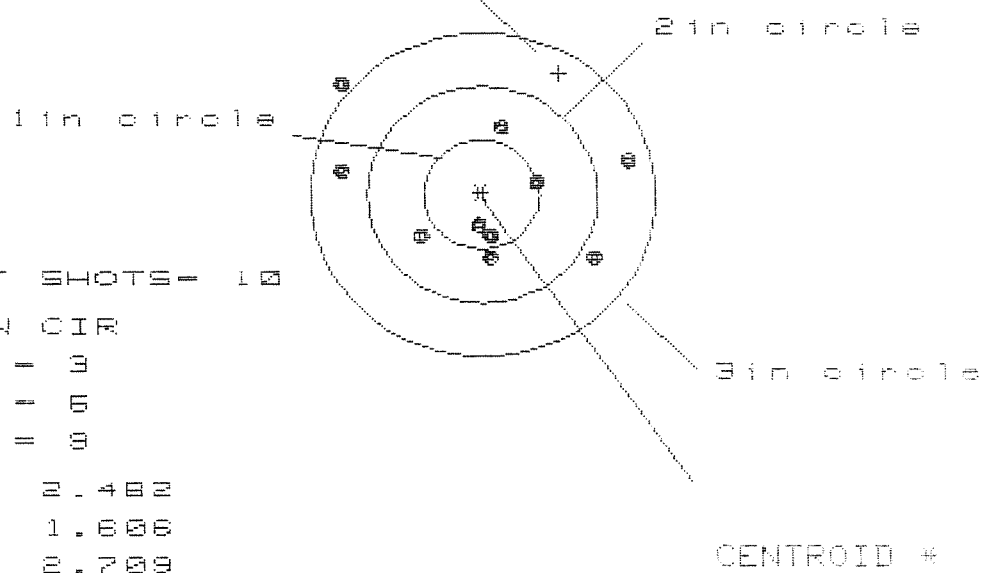
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CENTERFIRE PATTERNS

4

POR

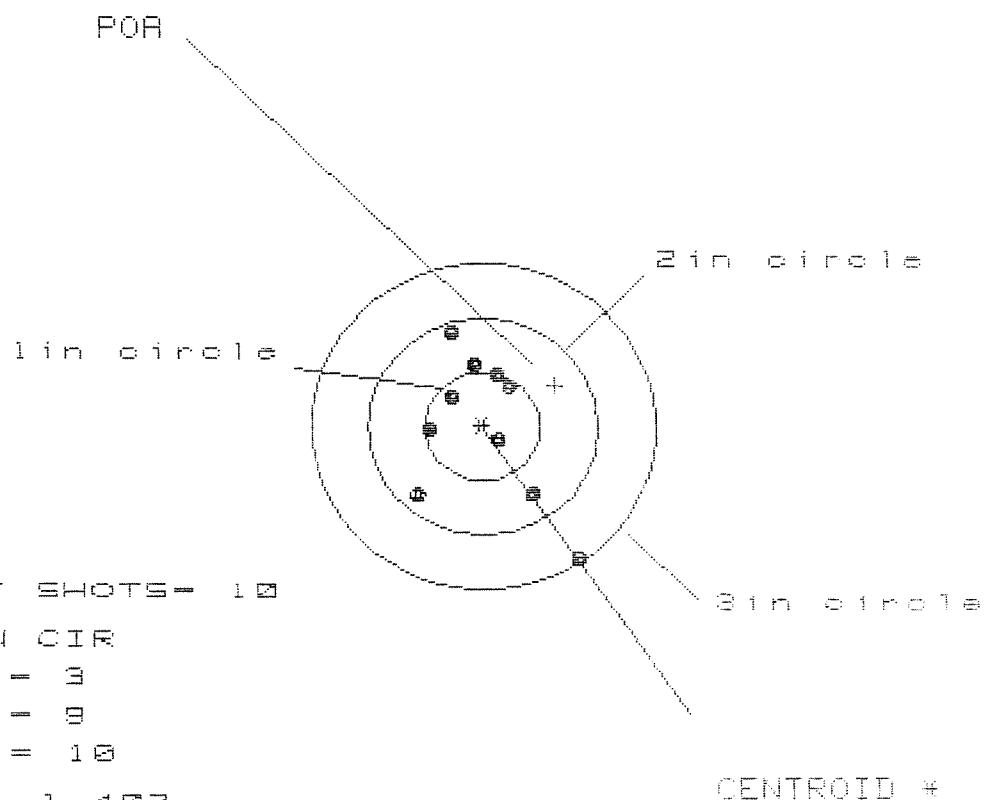


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	1.097	.924
MINIMUM X	:	-1.249	-1.385	-.833
MAXIMUM Y	:	.997	.710	.750
MINIMUM Y	:	-.609	-.498	-.458
CENTROID X	:	-.673	-.537	-.364
CENTROID Y	:	-1.121	-1.232	-1.272
POR TO CENTROID in.	:	1.308	1.344	1.323
MIN RADIUS	:	.238	.223	.311
MEAN RADIUS	:	.822	.703	.611
MAX RADIUS	:	1.577	1.421	1.019
HORIZONTAL SPREAD	:	2.482	2.482	1.757
VERTICAL SPREAD	:	1.606	1.208	1.208
EXTREME SPREAD	:	2.709	2.483	1.892
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.809	.509	.488
MINIMUM X	-.594	-.504	-.525
MAXIMUM Y	.838	.708	.582
MINIMUM Y	-1.175	-.760	-.672
CENTROID X	-.631	-.721	-.700
CENTROID Y	-.377	-.247	-.335
POA TO CENTROID in.	.735	.762	.776
MIN RADIUS	.182	.247	.263
MEAN RADIUS	.657	.544	.527
MAX RADIUS	1.426	.912	.853
HORIZONTAL SPREAD	1.403	1.013	1.013
VERTICAL SPREAD	2.013	1.468	1.254
EXTREME SPREAD	2.277	1.598	1.364
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		