

C6225439

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

\*Includes 1 in chamber.



88299

[illegible]

**M-24**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225439*

| OPERATION   |                      | DATE           | INT         |
|-------------|----------------------|----------------|-------------|
| #           | NAME                 |                |             |
| 575-<br>580 | ASSEMBLY             | <i>2 26</i>    | <i>FB</i>   |
| 600         | PROOF                | <i>2 29</i>    | <i>RW</i>   |
| 615         | MAGNAFLUX<br>BARREL  | <i>5/13/88</i> | <i>pfe.</i> |
|             | MAGNAFLUX<br>BOLT    | <i>5/13/88</i> | <i>pfe.</i> |
| 620         | COATING              | <i>8/1/88</i>  | <i>JA</i>   |
| 625-<br>630 | FINAL<br>ASSEMBLY    |                |             |
| 635         | TEST                 |                |             |
| 640         | TARGET               |                |             |
|             | FIRING PIN<br>INDENT |                |             |
| 660         | PACK                 |                |             |

M-24

1203

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225439

| OP.#         | OP. NAME                                                       | READINGS | DATE    | INITIAL |
|--------------|----------------------------------------------------------------|----------|---------|---------|
| 575 &<br>580 | Assemble Action<br>and stock                                   |          |         |         |
| 600          | Proof                                                          |          |         |         |
| 607          | Check Headspace                                                |          |         |         |
| 610          | Dis-assemble gun                                               |          |         |         |
| 612          | Magnaflux Barrel<br>Action                                     |          |         |         |
|              | Magnaflux Bolt                                                 |          |         |         |
| 615          | Rollmark Caliber                                               |          |         |         |
| 617          | Drill & Tap Sight Holes                                        |          |         |         |
| 618          | Polish Barrel                                                  |          |         |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |          |         |         |
|              | Apply Coatings (Bolt)                                          |          |         |         |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 8/22/88 | RW      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 8/22/88 | RW      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 8/22/88 | RW      |

OVER

| OP.#         |                                                                   | READINGS                            | DATE      | INITIAL     |
|--------------|-------------------------------------------------------------------|-------------------------------------|-----------|-------------|
| 625<br>cont. | D) Oil Firing Pin Ass'y                                           |                                     | 8/22/88   | RW          |
|              | E) Adjust Trigger Pull to<br>Min. Setting and Stake               | 2.47 2.49<br>2.48 2.43<br>2.42 2.43 | 19 aug 88 | J.U. + J.S. |
|              | F) Safety on Force                                                | 5   5   5.5                         | 19 aug 88 | J.U. + J.S. |
|              | G) Safety off Force                                               | 2.5   2.5   2.5                     | 19 aug 88 | J.U. + J.S. |
|              | H) Trigger Pull Test &<br>Retainabilty                            |                                     | 19 aug 88 | J.U. + J.S. |
|              | I) Firing Pin Indent                                              | .022   .0215   .022                 | 19 aug 88 | J.U. + J.S. |
|              | J) Assemble Stock                                                 |                                     | 8/24/88   | RW          |
|              | K) Assemble Swivel Studs                                          |                                     |           |             |
|              | L) Attach Front & Rear<br>Sight Assemblies                        |                                     | 9/6/88    | RW          |
|              | M) Iron Sight Alignment                                           |                                     | 9/6/88    | RW          |
|              | N) Detach Front & Rear<br>Sights & place in<br>numbered container |                                     | 9/6/88    | RW          |
|              | O) Attach Scope to Rifle                                          |                                     | 9/12/88   | RW          |
|              | P) Detach & Attach Scope<br>20 times                              |                                     | 9/17/88   | W.B.        |
| 640          | Gallery Target & Test                                             | 65 R 90 L                           | 9/16/88   | D. H.       |
|              | A) Optical Clarity of Scope                                       |                                     | 9/16/88   | W.B.        |
| 645          | Inspect for Live Ammo                                             |                                     | 9/16/88   | W.B.        |
| 655          | Final Inspection                                                  |                                     |           |             |
|              | A) Headspace                                                      | OK                                  | 9/30/88   | J.S.        |
|              | B) Trigger Pull                                                   | OK                                  | 9/30/88   | J.S.        |
|              | C) Function                                                       | OK                                  | 9/30/88   | J.S.        |
| 660          | Pack                                                              |                                     | 10-21-88  | J.S.        |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06225439

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | 1.08406 |
| 1 TO | 2 | .660186 |
| 1 TO | 3 | .225568 |
| 1 TO | 4 | .745349 |
| 1 TO | 5 | 1.00492 |

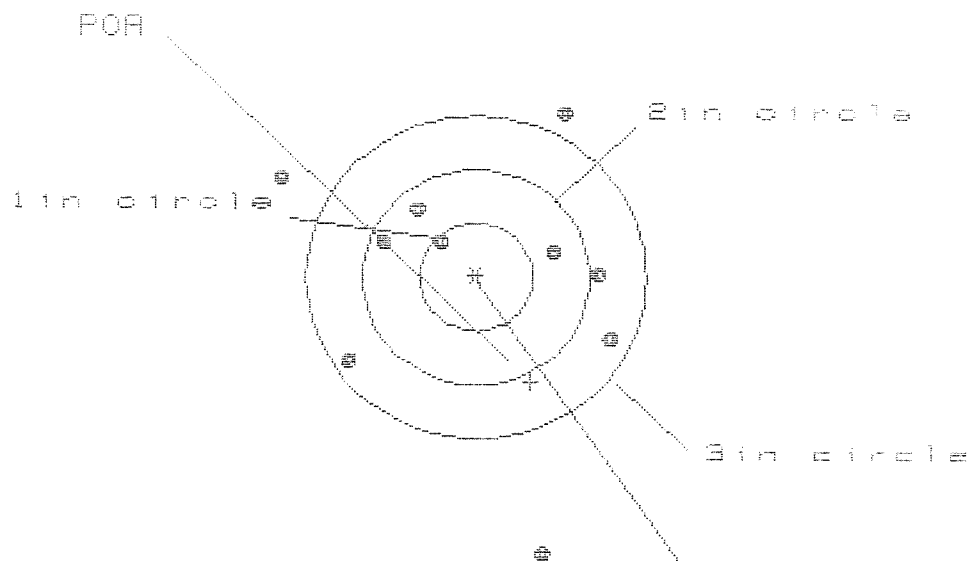
$\begin{matrix} & 4 \\ 1 & & \\ 3 & & \\ 2 & 5 \\ & + \end{matrix}$ 
(----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.115  
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7564  
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .765092  
 THE AMR FOR THIS RIFLE IS: 1.085

19 Sep 1988

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## CENTERFIRE PATTERNS # 1



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 0.000

VS = 4.163

GS = 4.182

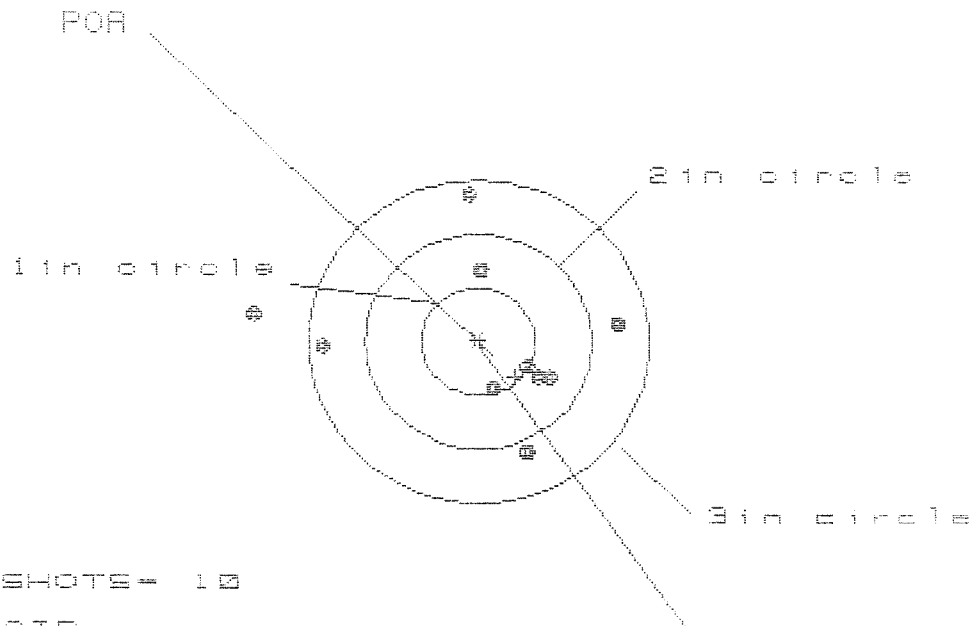
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.187  | 1.254  | 1.050  |
| MINIMUM X                     | -1.701 | -1.634 | -1.220 |
| MAXIMUM Y                     | 1.565  | 1.277  | 1.352  |
| MINIMUM Y                     | -2.598 | -1.076 | -1.001 |
| CENTROID X                    | -0.480 | -0.547 | -0.343 |
| CENTROID Y                    | 0.972  | 1.260  | 1.185  |
| POB TO CENTROID in.           | 1.084  | 1.374  | 1.234  |
| MIN RADIUS                    | 0.488  | 0.271  | 0.488  |
| MEAN RADIUS                   | 1.297  | 1.090  | 1.016  |
| MAX RADIUS                    | 2.667  | 1.742  | 1.578  |
| HORIZONTAL SPREAD             | 2.888  | 2.888  | 2.270  |
| VERTICAL SPREAD               | 4.163  | 2.353  | 2.353  |
| EXTREME SPREAD                | 4.182  | 3.232  | 2.986  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08225439

## CENTERFIRE PATTERNS # 2



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 3

HS = 3.152

VS = 2.380

GS = 3.157

CENTROID \*

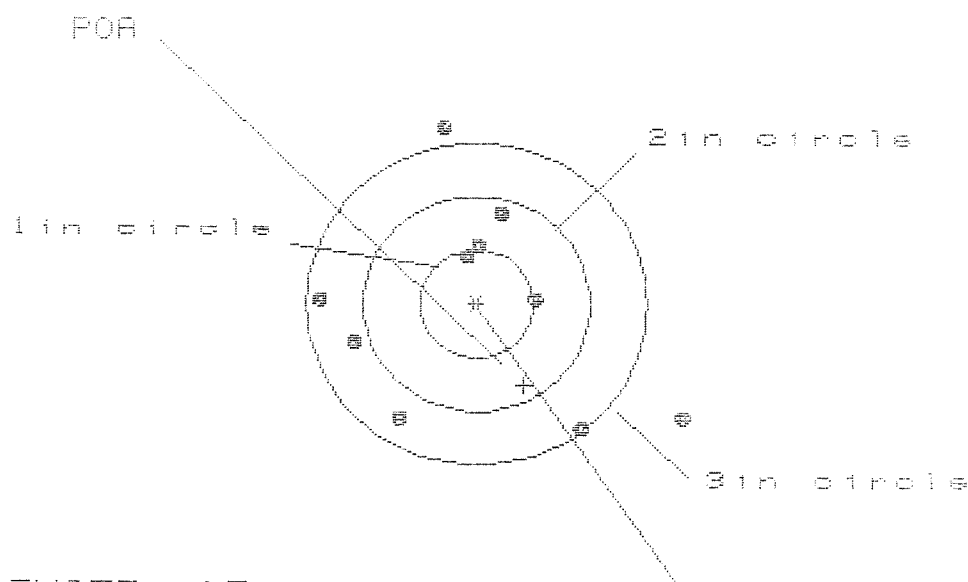
| PATTERN #                     | 2      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.217  | 1.002  | .803   |
| MINIMUM X                     | -1.935 | -1.589 | -.498  |
| MAXIMUM Y                     | 1.330  | 1.365  | 1.361  |
| MINIMUM Y                     | -1.050 | -1.015 | -1.019 |
| CENTROID X                    | -.322  | -.107  | .092   |
| CENTROID Y                    | .331   | .296   | .300   |
| POR TO CENTROID in.           | .462   | .315   | .314   |
| MIN RADIUS                    | .425   | .271   | .179   |
| MEAN RADIUS                   | .991   | .817   | .677   |
| MAX RADIUS                    | 1.960  | 1.589  | 1.448  |
| HORIZONTAL SPREAD             | 3.152  | 2.591  | 1.299  |
| VERTICAL SPREAD               | 2.380  | 2.380  | 2.380  |
| EXTREME SPREAD                | 3.157  | 2.599  | 2.439  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |



19 Sep 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C6225439

## CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 3.147

VS = 2.813

GS = 3.402

CENTROID \*

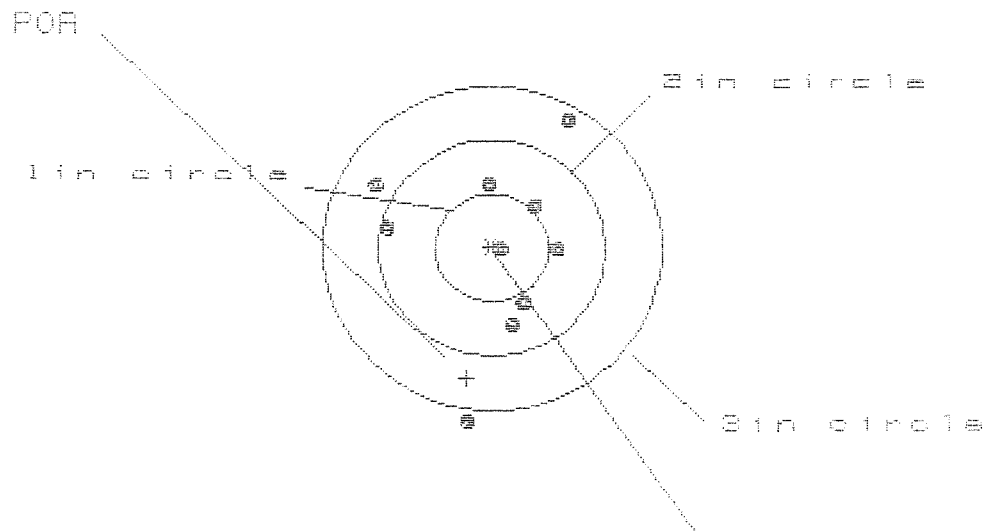
| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.792  | 1.145  | 1.132  |
| MINIMUM X                   | : | -1.355 | -1.156 | -1.169 |
| MAXIMUM Y                   | : | 1.672  | 1.560  | .893   |
| MINIMUM Y                   | : | -1.141 | -1.253 | -1.058 |
| CENTROID X                  | : | -.415  | -.614  | -.601  |
| CENTROID Y                  | : | .756   | .868   | .673   |
| POA TO CENTROID in.         | : | .863   | 1.064  | .903   |
| MIN RADIUS                  | : | .433   | .336   | .520   |
| MEAN RADIUS                 | : | 1.129  | 1.002  | .951   |
| MAX RADIUS                  | : | 2.056  | 1.698  | 1.550  |
| HORIZONTAL SPREAD           | : | 3.147  | 2.301  | 2.301  |
| VERTICAL SPREAD             | : | 2.813  | 2.813  | 1.951  |
| EXTREME SPREAD              | : | 3.402  | 3.078  | 2.580  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

19 Sep 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08225439

## CENTERFIRE PATTERNS

# 4



# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.687

VS= 2.837

GS= 2.972

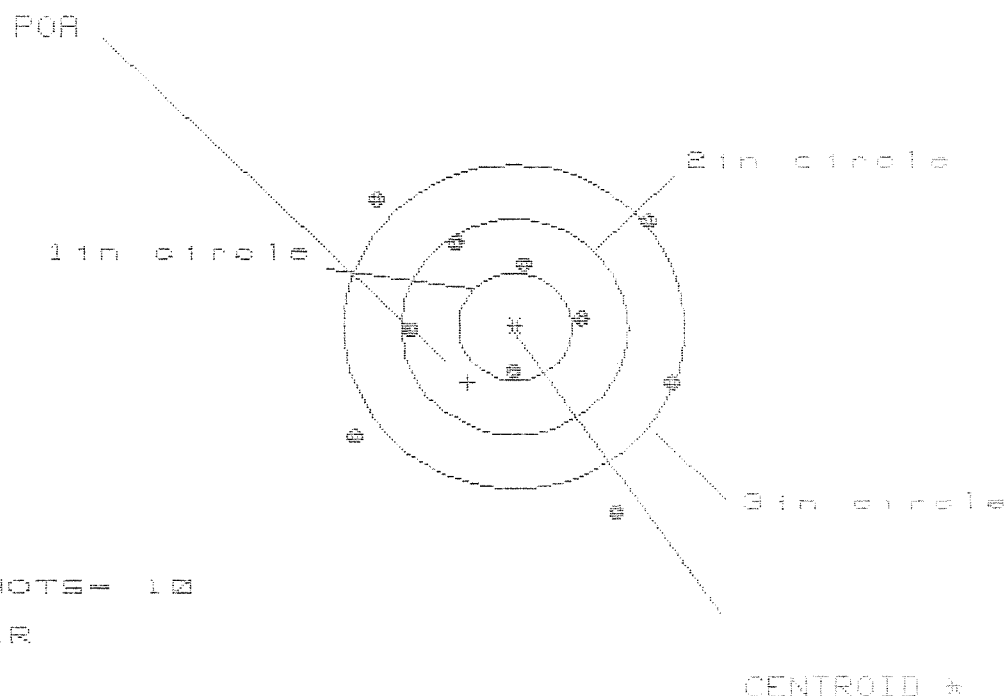
CENTROID \*

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | .681   | .658   | .666  |
| MINIMUM X                   | : | -1.006 | -1.029 | -.947 |
| MAXIMUM Y                   | : | 1.204  | 1.022  | .551  |
| MINIMUM Y                   | : | -1.633 | -.875  | -.747 |
| CENTROID X                  | : | .227   | .250   | .168  |
| CENTROID Y                  | : | 1.208  | 1.390  | 1.262 |
| POA TO CENTROID in.         | : | 1.230  | 1.412  | 1.273 |
| MIN RADIUS                  | : | .113   | .238   | .190  |
| MEAN RADIUS                 | : | .831   | .735   | .672  |
| MAX RADIUS                  | : | 1.646  | 1.216  | 1.076 |
| HORIZONTAL SPREAD           | : | 1.687  | 1.687  | 1.552 |
| VERTICAL SPREAD             | : | 2.837  | 1.897  | 1.298 |
| EXTREME SPREAD              | : | 2.972  | 1.963  | 1.728 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

18 Sep 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/08225439

## CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1 in = 1

2 in = 5

3 in = 6

HS = 2.834

VS = 2.812

GS = 3.537

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 9      |
| MAXIMUM X                   | : | 1.395  | 1.489  | 1.320  |
| MINIMUM X                   | : | -1.439 | -1.345 | -1.243 |
| MAXIMUM Y                   | : | 1.191  | 1.000  | .854   |
| MINIMUM Y                   | : | -1.721 | -1.165 | -.850  |
| CENTROID X                  | : | .415   | .321   | .490   |
| CENTROID Y                  | : | .515   | .706   | .852   |
| POA TO CENTROID in.         | : | .661   | .776   | .983   |
| MIN RADIUS                  | : | .406   | .456   | .271   |
| MEAN RADIUS                 | : | 1.178  | 1.074  | .962   |
| MAX RADIUS                  | : | 1.915  | 1.780  | 1.570  |
| HORIZONTAL SPREAD           | : | 2.834  | 2.834  | 2.563  |
| VERTICAL SPREAD             | : | 2.912  | 2.165  | 1.764  |
| EXTREME SPREAD              | : | 3.537  | 3.240  | 3.078  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225439DATE 19 Aug. 88TESTER J. H. + S. 8.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.47             | 2.41                     | 2.46                           | 2.89  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.48             | 2.38                     | 2.62                           | 2.69  |                                                                        |
| PULL #3 | 2.42             | 2.38                     | 2.45                           | 2.61  |                                                                        |
| PULL #4 | 2.49             | 2.37                     | 2.40                           | 2.60  |                                                                        |
| PULL #5 | 2.43             | 2.36                     | 2.44                           | 2.62  |                                                                        |
| TOTAL   | 12.29            | 11.90                    | 12.47                          | 13.41 |                                                                        |
| AVG.    | 2.458            | 2.38                     | 2.494                          | 2.68  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.16             | 3.20                     |  |          |
| PULL #2 | 3.10             | 3.18                     |  |          |
| PULL #3 | 3.16             | 3.15                     |  |          |
| PULL #4 | 3.08             | 3.17                     |  |          |
| PULL #5 | 3.18             | 3.17                     |  |          |
| TOTAL   | 15.68            | 15.87                    |  |          |
| AVG.    | 3.136            | 3.174                    |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.04             | 3.98                     | 4.23                           | 4.28                                 |
| PULL #2 | 4.00             | 3.99                     | 4.18                           | 4.24                                 |
| PULL #3 | 3.93             | 4.00                     | 4.18                           | 4.28                                 |
| PULL #4 | 4.01             | 3.91                     | 4.16                           | 4.27                                 |
| PULL #5 | 4.01             | 4.01                     | 4.18                           | 4.27                                 |
| TOTAL   | 19.99            | 19.89                    | 20.93                          | 21.34                                |
| AVG.    | 3.998            | 3.978                    | 4.186                          | 4.268                                |

5439

MOD. \_\_\_\_\_ GUN # \_\_\_\_\_

| #    | DATE | MALFUNCTION/DEFECT                                                    | ASSEM. # |
|------|------|-----------------------------------------------------------------------|----------|
| TEST | 1st  | WONT EXTRACT<br>ON 4 <sup>th</sup> TARGET<br>E 5 <sup>th</sup> TARGET |          |
|      | 2nd  | EXTRACTOR LOOSE<br>NEW EXTRACTOR                                      |          |
|      | 3rd  | 100 Rdk<br>shot of                                                    | 94       |
|      | 4th  |                                                                       |          |

FUNCTION \_\_\_\_\_ RD 6654 Rev 1



| TEST INT. ACTION TO CORRECT |          | ASSEM.<br># |
|-----------------------------|----------|-------------|
| PROOF                       |          |             |
| TEST                        |          |             |
| TGT                         |          |             |
| PROOF                       |          |             |
| TEST                        |          |             |
| TGT                         |          |             |
| PROOF                       | ENGINEER |             |
| TEST                        |          |             |
| TGT                         |          |             |
| PROOF                       | ENGINEER |             |
| TEST                        |          |             |
| TGT                         |          |             |