

C6649287

MODEL 700™ M24

Model **SMS**™

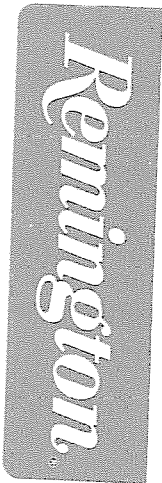
Action

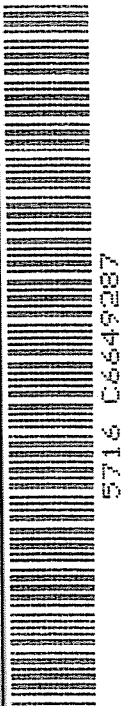
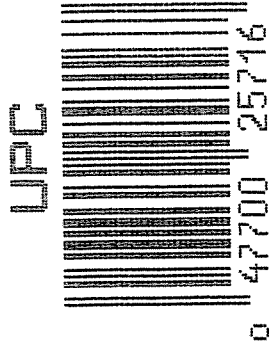
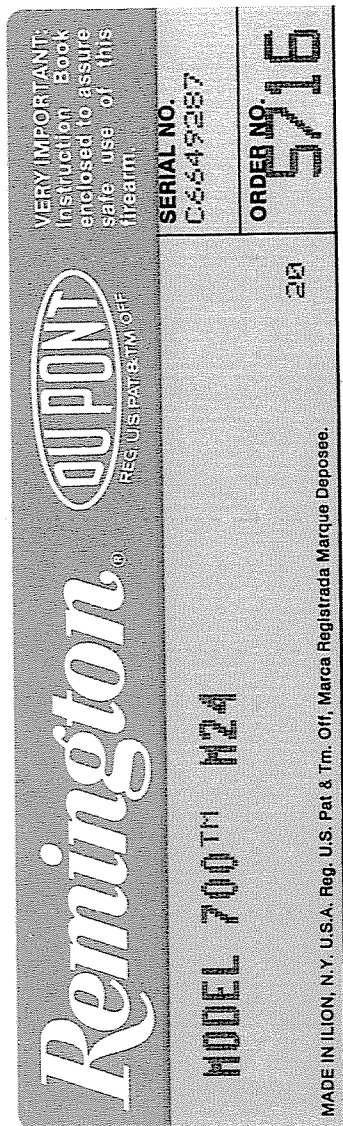
Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.





CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649287

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 9 1	6 27 9 1	dw
600	Proof	6 27 9 1	6 27 9 1	dw
607	Check Headspace	6 27 9 1	6 27 9 1	dw
610	Dis-assemble Gun	6 27 9 1	6 27 9 1	dw
612	Magnaflux Barrel Action	JUL 2 1991	JUL 2 1991	KR
	Magnaflux Bolt	JUL 2 1991	JUL 2 1991	KR
615	Rollmark Caliber	JUL 2 1991	JUL 2 1991	GS
617	Drill and Tap Sight Holes	JUL 2 1991	JUL 2 1991	LB
618	Polish Barrel	JUL 7 1991	JUL 7 1991	WB
620	Apply Coatings (Barrel Action)		7/22/91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		7/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/23/91	RW
	C) Inspect Ejector Hole for Chamfer		7/23/91	RW
	D) Oil Firing Pin Ass'y		7/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-5-91	DH

BARBER - M24 0067350

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-6-91	D/H
	G) Safety Off Force	2 1/2	2 1/4	2			8-6-91	D/H
	H) Trigger Pull Test & Retainability						8-5-91	D/H
	I) Firing Pin Indent	.020	.020	.020			8-6-91	D/H
	J) Assemble Stock						8/7/91	RW
	K) Assemble Swivel Studs						8-8-91	D/H
	L) Attach Front and Rear Sight Assemblies						8/2/91	RW
	M) Iron Sight Alignment						8/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/7/91	RW
	O) Attach Scope to Rifle						8/7/91	RW
	P) Detach & Attach Scope 20 Times						8/7/91	RW
640	Gallery Target & Test						8-7-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						8-7-91	NF
655	Final Inspection							
	A) Headspace						8-8-91	D/H
	B) Trigger Pull	265	260	263	268	269	8-8-91	RL
	C) Function						8-8-91	D/H
660	Pack						9-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649287

DATE 8-5-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.57	2.56	2.65	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.49	2.55	2.60	
PULL #3	2.58	2.62	2.70	2.63	
PULL #4	2.57	2.56	2.69	2.68	
PULL #5	2.37	2.48	2.72	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.40		
PULL #2	3.41	3.40		
PULL #3	3.46	3.06		
PULL #4	3.33	3.57		
PULL #5	3.54	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.64	4.39		4.36
PULL #2	3.94	4.55		4.22
PULL #3	4.49	4.40		4.27
PULL #4	4.00	4.48		4.25
PULL #5	3.99	4.33		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649287
7 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.174106
1 TO 2	.288669
1 TO 3	.32039
1 TO 4	.252343
1 TO 5	.287272

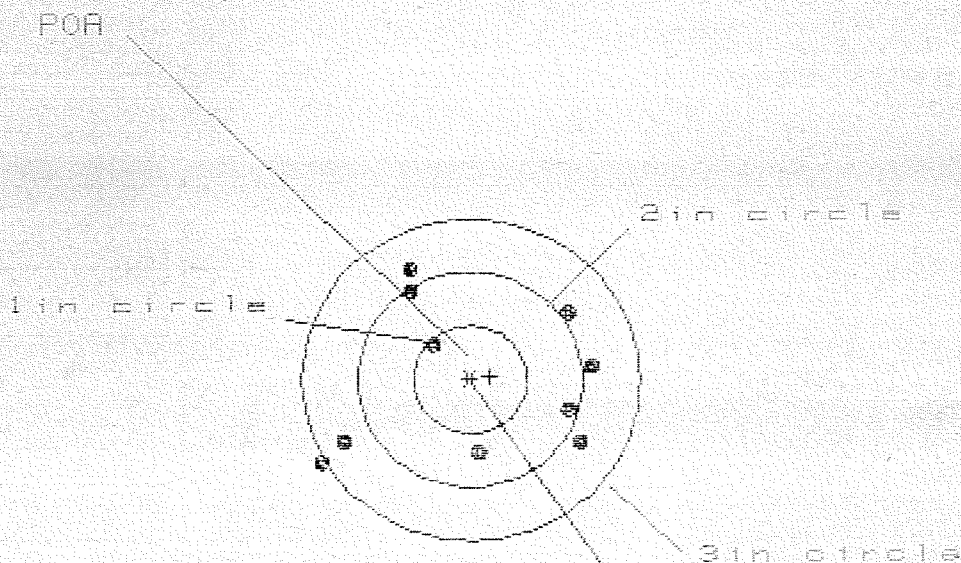
18 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0166
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0451615
THE AMR FOR THIS RIFLE IS: .9334

7 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B49287

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.380

VS = 1.816

GS = 2.588

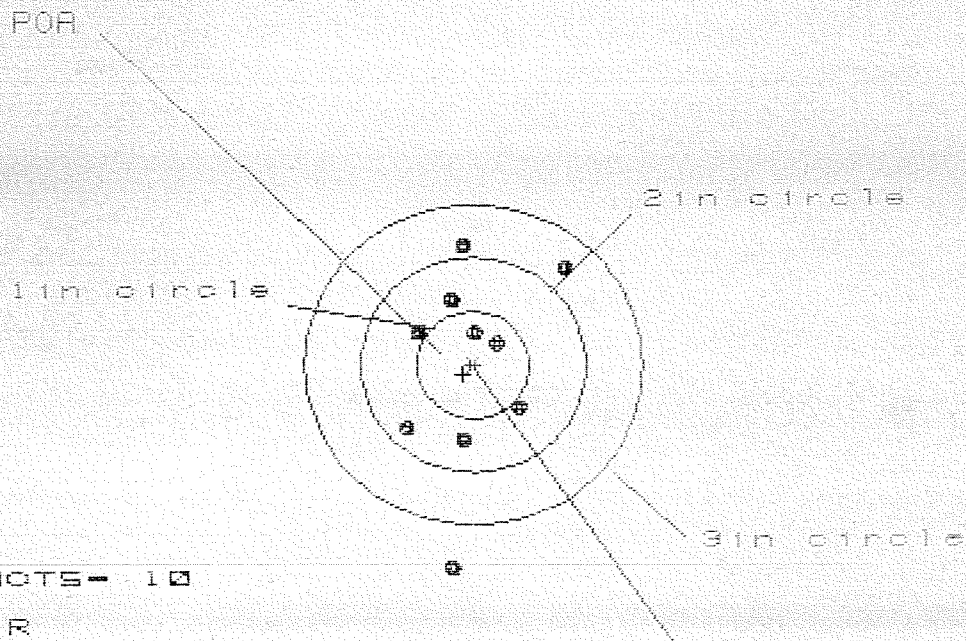
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.025	.875	.721
MINIMUM X	:	-1.355	-1.232	-.839
MAXIMUM Y	:	1.024	.937	.852
MINIMUM Y	:	-.791	-.756	-.841
CENTROID X	:	-.172	-.022	.132
CENTROID Y	:	-.027	.060	.145
POA TO CENTROID in.	:	.175	.064	.196
MIN RADIUS	:	.450	.508	.616
MEAN RADIUS	:	1.008	.927	.848
MAX RADIUS	:	1.569	1.407	1.196
HORIZONTAL SPREAD	:	2.380	2.107	1.560
VERTICAL SPREAD	:	1.816	1.693	1.693
EXTREME SPREAD	:	2.588	2.250	2.168
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Aug 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.383

VS= 2.985

GS= 2.988

CENTROID *

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.818	.512
MINIMUM X	:	-.541	-.565	-.463
MAXIMUM Y	:	1.134	.928	1.019
MINIMUM Y	:	-1.851	-.871	-.788
CENTROID X	:	.091	.115	.013
CENTROID Y	:	.092	.298	.207
POA TO CENTROID in.	:	.130	.319	.207
MIN RADIUS	:	.318	.111	.225
MEAN RADIUS	:	.822	.662	.618
MAX RADIUS	:	1.863	1.095	1.019
HORIZONTAL SPREAD	:	1.383	1.383	.975
VERTICAL SPREAD	:	2.985	1.799	1.799
EXTREME SPREAD	:	2.988	2.070	1.803
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

7 Aug 1991

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CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 4

3in = 7

HS= 2.932

VS= 2.977

GS= 3.301

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.478
MINIMUM X	-1.454
MAXIMUM Y	1.513
MINIMUM Y	-1.464
CENTROID X	.139
CENTROID Y	-.104
POA TO CENTROID in.	.174
MIN RADIUS	.241
MEAN RADIUS	1.001
MAX RADIUS	2.063
HORIZONTAL SPREAD	2.932
VERTICAL SPREAD	2.977
EXTREME SPREAD	3.301
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	7

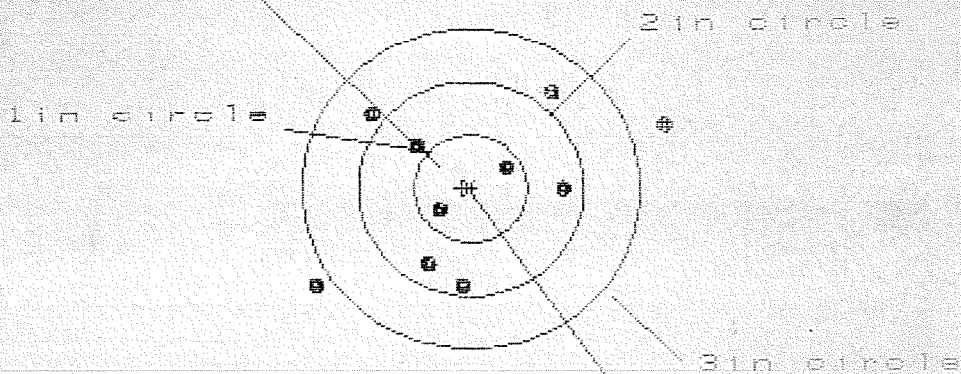
7 Aug 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.161

VS= 1.872

GS= 3.495

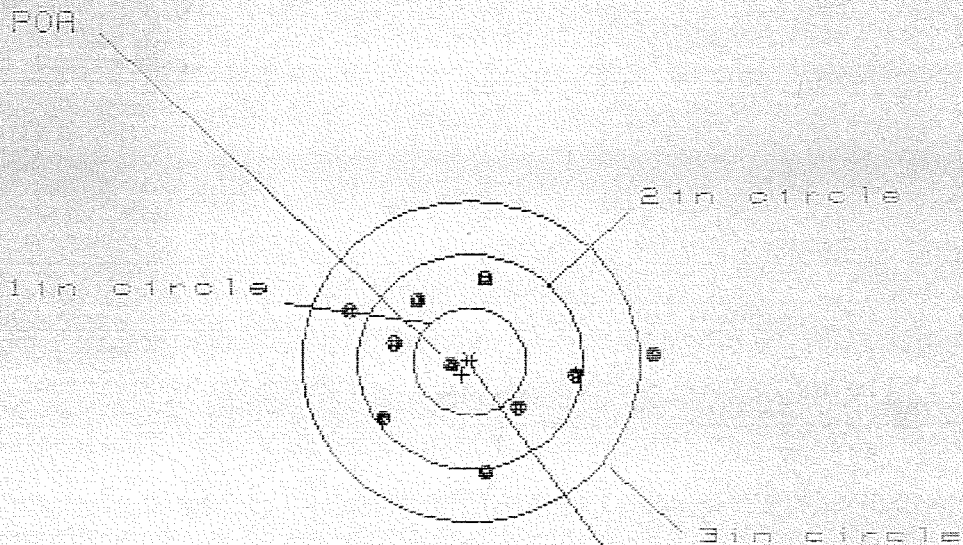
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.758	.993	.842
MINIMUM X	:	-1.403	-1.208	-.836
MAXIMUM Y	:	.935	.996	.887
MINIMUM Y	:	-.937	-.876	-.963
CENTROID X	:	.079	-.117	.034
CENTROID Y	:	-.001	-.062	.047
POA TO CENTROID in.	:	.079	.132	.050
MIN RADIUS	:	.325	.134	.317
MEAN RADIUS	:	.962	.842	.760
MAX RADIUS	:	1.843	1.492	1.163
HORIZONTAL SPREAD	:	3.161	2.201	1.678
VERTICAL SPREAD	:	1.872	1.872	1.850
EXTREME SPREAD	:	3.495	2.822	2.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Aug 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06645257

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.727

VS = 1.805

GS = 2.751

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.666	1.109	1.000
MINIMUM X	-1.061	-.876	-.710
MAXIMUM Y	.753	.762	.818
MINIMUM Y	-1.052	-1.043	-.987
CENTROID X	.073	-.112	-.003
CENTROID Y	.123	.114	.058
POA TO CENTROID in.	.143	.160	.058
MIN RADIUS	.166	.052	.083
MEAN RADIUS	.874	.753	.727
MAX RADIUS	1.668	1.112	1.001
HORIZONTAL SPREAD	2.727	1.985	1.710
VERTICAL SPREAD	1.805	1.805	1.805
EXTREME SPREAD	2.751	2.054	1.805
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		