

UPC



0 47700 25716

C6702833

INCLUDES 1 IN CHAMBER

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6702833

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/92	RW
600	Proof		5/1/92	RW
607	Check Headspace		5/1/92	RW
610	Dis-assemble Gun		5/1/92	RW
612	Magnaflux Barrel Action		MAY 5 1992	KCR
	Magnaflux Bolt		MAY 5 1992	CS
615	Rollmark Caliber		MAY 5 1992	CS
617	Drill and Tap Sight Holes		MAY 5 1992	FB
618	Polish Barrel		MAY 5 1992	WB
620	Apply Coatings (Barrel Action)		6-10-92	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6/13/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/13/92	RW
	C) Inspect Ejector Hole for Chamfer		6/13/92	RW
	D) Oil Firing Pin Ass'y		6/13/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake		6/17/92	RW

op. #	BARBER - M24 0105257 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			6/17/92	RW
	G) Safety Off Force	2.5	2.5	2.5			6/17/92	RW
	H) Trigger Pull Test & Retainability						6/17/92	RW
	I) Firing Pin Indent	.0205	.021	.0215			6/17/92	RW
	J) Assemble Stock						6/17/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle						6/17/92	RW
	P) Detach & Attach Scope 20 Times						6/17/92	RW
640	Gallery Target & Test						6-23-92	DH
	A) Time						6-23-92	DH
	B) Malfunctions						6-23-92	DH
	C) Pierced Primers						6-23-92	DH
	D) Optical Clarity of Scope						6-23-92	DH
645	Inspect for Live Ammo						6-23-92	DH
655	Final Inspection							
	A) Headspace						6/23/92	RW
	B) Trigger Pull	2.33	2.29	2.31	2.32	2.31	6/23/92	RW
	C) Function						6/23/92	RW
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6702833

DATE 6/17/92

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.53	2.57	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.56	2.56	2.29	
PULL #3	2.46	2.54	2.39	2.31	
PULL #4	2.59	2.55	2.53	2.32	
PULL #5	2.58	2.53	2.57	2.31	
TOTAL	12.75	12.71	12.62	11.56	
AVG.	2.55	2.54	2.52	2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.20		
PULL #2	3.16	3.07		
PULL #3	3.13	3.17		
PULL #4	3.16	3.19		
PULL #5	3.14	3.07		
TOTAL	15.73	15.70		
AVG.	3.15	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.09		4.06
PULL #2	4.11	4.11		4.10
PULL #3	4.09	4.12		4.09
PULL #4	4.08	4.09		4.07
PULL #5	4.10	4.12		4.11
TOTAL	20.39	20.53		20.53
AVG.	4.08	4.11		4.11

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702833
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.232545
1 TO	2	.152398
1 TO	3	.46014
1 TO	4	.207299
1 TO	5	.433129

59 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0466
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0208
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0510314

THE AMR FOR THIS RIFLE IS: .945

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG702933

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS - 10

IN CIR

1 in - 1

2 in - 5

3 in = 10

HS= 2.478

VS= 1.927

GS= 2.567

PATTERN #	1	9	8
SHOTS (BEST OF)	10		
MAXIMUM X	1.242	1.104	1.212
MINIMUM X	-1.236	-.887	-.779
MAXIMUM Y	1.101	1.046	.936
MINIMUM Y	-.826	-.881	-.720
CENTROID X	.181	.319	.211
CENTROID Y	.146	.201	.311
POA TO CENTROID in.	.233	.377	.376
MIN RADIUS	.287	.371	.236
MEAN RADIUS	.897	.847	.785
MAX RADIUS	1.330	1.234	1.212
HORIZONTAL SPREAD	2.478	1.991	1.991
VERTICAL SPREAD	1.927	1.927	1.656
EXTREME SPREAD	2.567	2.331	2.088
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 10		

23 Jun 1992

FILE:/PAT/TERNING/CENTERFIRE_PATT/06702833

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.032

VS = 1.968

GS = 2.339

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.659	.507	.569
MINIMUM X	-1.373	-1.004	.942
MAXIMUM Y	1.073	1.105	.997
MINIMUM Y	-.895	-.863	-.682
CENTROID X	.032	.184	.122
CENTROID Y	.178	.146	.254
POA TO CENTROID in.	.181	.235	.282
MIN RADIUS	.338	.222	.345
MEAN RADIUS	.820	.737	.708
MAX RADIUS	.402	1.105	.998
HORIZONTAL SPREAD	2.032	1.511	1.511
VERTICAL SPREAD	1.968	1.968	1.679
EXTREME SPREAD	2.339	2.034	1.734
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 10		

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG700833

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.408

VS = 2.898

GS = 3.277

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.317	1.247	.790
MINIMUM X	-.091	-.944	-.789
MAXIMUM Y	.552	1.403	1.233
MINIMUM Y	-.338	-1.441	-1.615
CENTROID X	.076	-.071	-.226
CENTROID Y	.302	-.153	.027
POR TO CENTROID in.	.311	.168	.228
MIN RADIUS	.239	.294	.077
MEAN RADIUS	.133	1.020	.872
MAX RADIUS	.878	1.905	1.629
HORIZONTAL SPREAD	2.408	2.191	1.579
VERTICAL SPREAD	2.898	2.844	2.838
EXTREME SPREAD	3.277	3.116	2.987
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	7	

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06702832

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 12

IN CIR

1in = 0

2in = 6

3in = 9

HS = 2.522

VS = 1.776

GS = 2.523

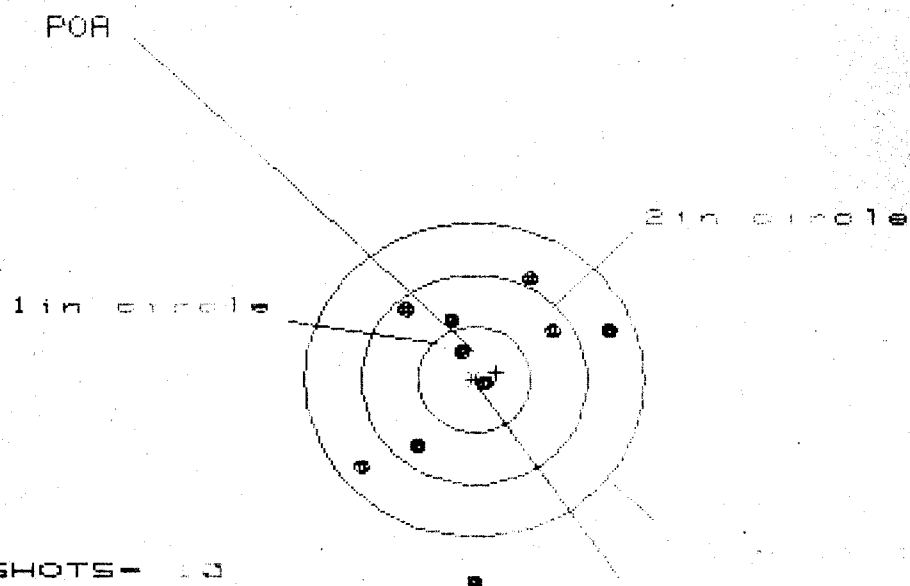
PATTERN #	1	2	3
SHOTS (BEST OF)	12	9	8
MAXIMUM X	1.484	1.161	1.079
MINIMUM X	-1.038	-.873	-.958
MAXIMUM Y	.744	.705	.572
MINIMUM Y	-1.032	-1.071	-.858
CENTROID X	.139	-.026	.056
CENTROID Y	-.057	-.018	.115
POA TO CENTROID in.	.151	.032	.128
MIN RADIUS	.568	.720	.579
MEAN RADIUS	.965	.891	.828
MAX RADIUS	1.524	1.255	1.079
HORIZONTAL SPREAD	2.522	2.034	2.034
VERTICAL SPREAD	1.776	1.776	1.438
EXTREME SPREAD	2.523	2.202	2.096
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 2

HS = 2.114

VS = 2.920

GS = 2.975

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.143	1.022
MINIMUM X	:	-.965	-.971	-.731
MAXIMUM Y	:	.981	.765	.634
MINIMUM Y	:	-1.940	-1.046	-.989
CENTROID X	:	-.195	-.189	-.068
CENTROID Y	:	-.069	.146	.277
POA TO CENTROID in.	:	.207	.239	.285
MIN RADIUS	:	.080	.134	.217
MEAN RADIUS	:	.910	.754	.664
MAX RADIUS	:	1.940	1.427	1.179
HORIZONTAL SPREAD	:	2.114	2.114	1.753
VERTICAL SPREAD	:	2.920	1.811	1.623
EXTREME SPREAD	:	2.975	2.490	2.010
NUMBER IN ONE INCH CIRCLE	=	2	6	9
NUMBER IN TWO INCH CIRCLE	=	6	9	9
NUMBER IN THREE INCH CIRCLE	=	9	9	9