

BARBER - M24 0105292

UPC



0 47700 25716 7

C6702847

*INCLUDES 1 IN CHAMBER

CONFIDENTIAL - SUBJECT TO PROTECTIVE ORDER

BARBER - M24 0105292 M2400105331

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CG702847

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	KCR
615	Rollmark Caliber	MAY	5 1992	CS
617	Drill and Tap Sight Holes	MAY	5 1992	FB
618	Polish Barrel	MAY	5	WB
620	Apply Coatings (Barrel Action)		6-10-92	RA
	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		6/15/92	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6/15/92	RW
	G) Safety Off Force	3	3	3			6/15/92	RW
	H) Trigger Pull Test & Retainability						6/15/92	RW
	I) Firing Pin Indent	.0205	.0225	.022			6/15/92	RW
	J) Assemble Stock						6/16/92	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						6/16/92	RW
	P) Detach & Attach Scope 20 Times						6/16/92	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	2.57	2.38	2.32	2.31	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. C6702847

DATE 6/15/92

TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.41	2.25	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.55	2.58	2.38	
PULL #3	2.39	2.39	2.33	2.32	
PULL #4	2.48	2.32	2.41	2.31	
PULL #5	2.32	2.44	2.28	2.31	
TOTAL	11.87	12.11	11.85	11.83	
AVG.	2.37	2.42	2.37	2.37	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.33		
PULL #2	3.31	3.24		
PULL #3	3.21	3.29		
PULL #4	3.30	3.01		
PULL #5	3.35	3.19		
TOTAL	16.45	16.06		
AVG.	3.29	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.09		4.05
PULL #2	4.02	4.20		4.00
PULL #3	4.04	4.00		4.15
PULL #4	4.12	4.00		4.10
PULL #5	4.15	4.04		4.20
TOTAL	20.59	20.33		20.50
AVG.	4.12	4.07		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702847
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.273805
1 TO	2	.468898
1 TO	3	.474473
1 TO	4	.183096
1 TO	5	.0650692

$\bar{X}_2$ <----POA

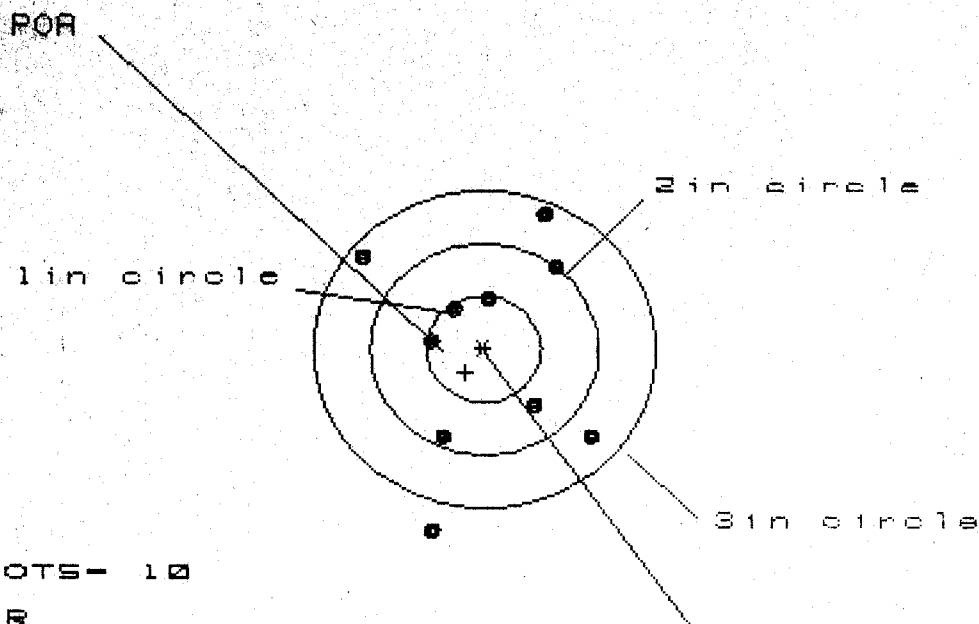
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2882
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .046
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .291848

THE AMR FOR THIS RIFLE IS: 1.036

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702847

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 1.965

VS= 3.024

GS= 3.184

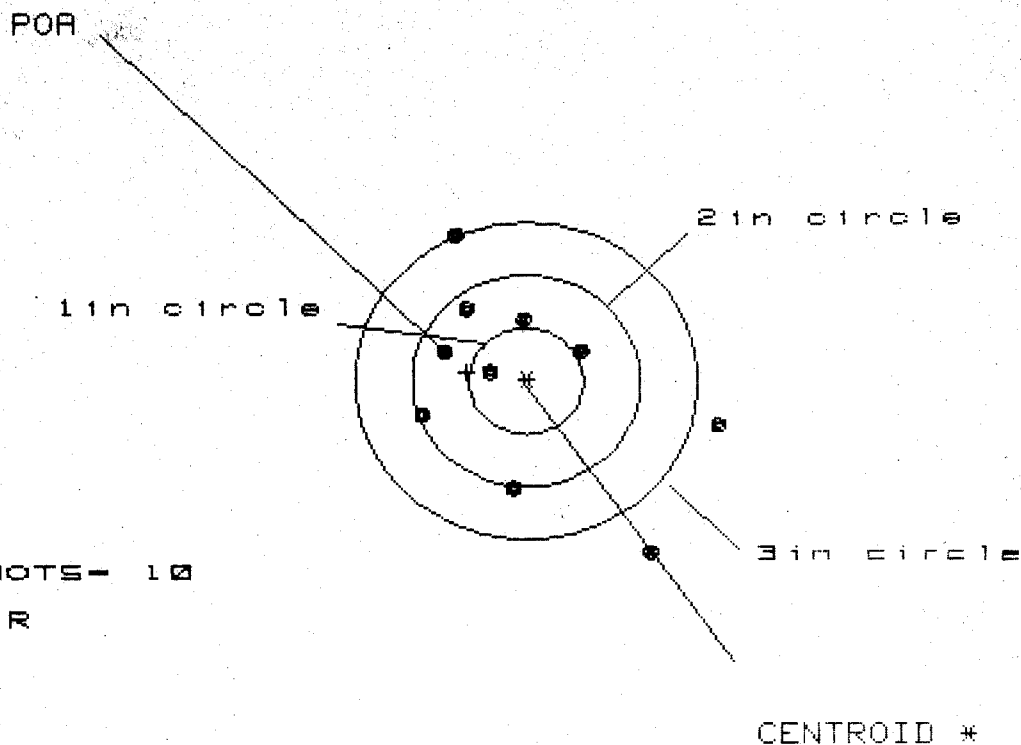
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.859	.720
MINIMUM X	:	-1.055	-1.106	-.661
MAXIMUM Y	:	1.269	1.074	1.162
MINIMUM Y	:	-1.755	-1.027	-.939
CENTROID X	:	.163	.214	.353
CENTROID Y	:	.220	.415	.327
POA TO CENTROID in.	:	.274	.467	.481
MIN RADIUS	:	.443	.262	.387
MEAN RADIUS	:	.976	.852	.810
MAX RADIUS	:	1.814	1.314	1.214
HORIZONTAL SPREAD	:	1.965	1.965	1.381
VERTICAL SPREAD	:	3.024	2.101	2.101
EXTREME SPREAD	:	3.184	2.587	2.271
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

23 Jun 1992

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 7

3 in = 7

HS = 2.577

VS = 2.976

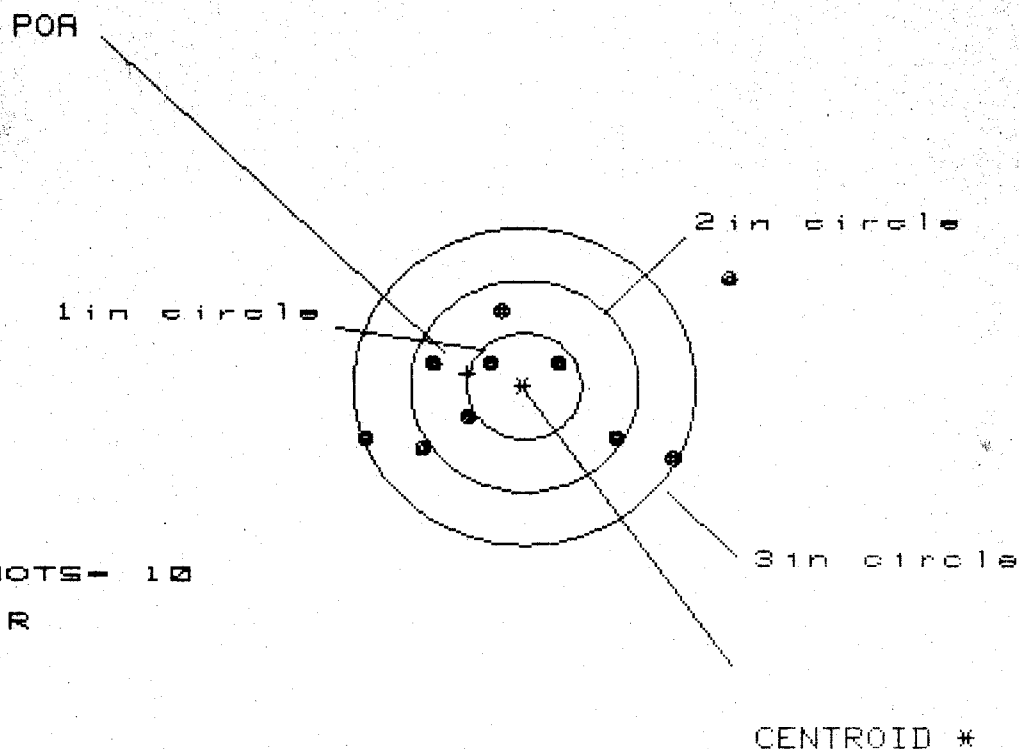
GS = 3.462

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.695	1.818	.835
MINIMUM X	:	-.882	-.759	-.531
MAXIMUM Y	:	1.368	1.189	1.114
MINIMUM Y	:	-1.608	-1.146	-1.221
CENTROID X	:	.520	.397	.169
CENTROID Y	:	-.084	.095	.170
POA TO CENTROID in.	:	.527	.408	.240
MIN RADIUS	:	.308	.217	.203
MEAN RADIUS	:	1.035	.877	.704
MAX RADIUS	:	1.955	1.915	1.247
HORIZONTAL SPREAD	:	2.577	2.577	1.366
VERTICAL SPREAD	:	2.976	2.335	2.335
EXTREME SPREAD	:	3.462	2.956	2.401
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	7		

23 Jun 1992

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 3.275

VS = 1.756

GS = 3.608

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.829	1.494	1.339
MINIMUM X	:	-1.446	-1.243	-.807
MAXIMUM Y	:	1.050	.841	.797
MINIMUM Y	:	-.706	-.589	-.633
CENTROID X	:	.497	.294	.449
CENTROID Y	:	-.117	-.234	-.190
POA TO CENTROID in.	:	.511	.376	.488
MIN RADIUS	:	.366	.370	.398
MEAN RADIUS	:	1.000	.848	.797
MAX RADIUS	:	2.109	1.606	1.481
HORIZONTAL SPREAD	:	3.275	2.737	2.146
VERTICAL SPREAD	:	1.756	1.430	1.430
EXTREME SPREAD	:	3.608	2.748	2.298
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

23 Jun 1982

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CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 1.911

VS = 3.246

GS = 3.556

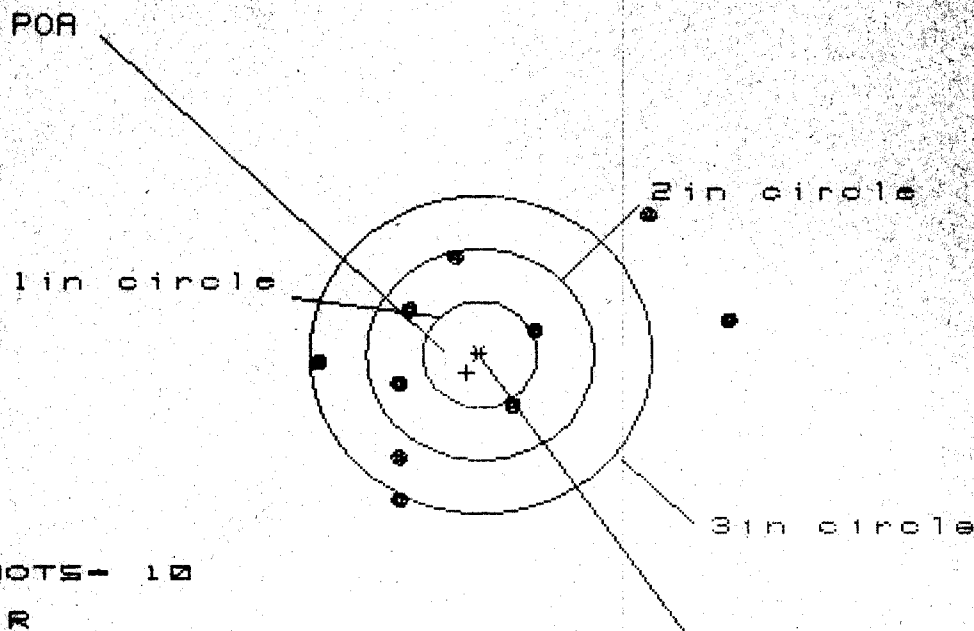
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.845	.777	.741
MINIMUM X	:	-1.066	-1.134	-1.037
MAXIMUM Y	:	1.202	.975	1.038
MINIMUM Y	:	-2.044	-1.046	-.924
CENTROID X	:	.143	.211	.114
CENTROID Y	:	.038	.265	.143
POA TO CENTROID in.	:	.148	.339	.183
MIN RADIUS	:	.169	.152	.272
MEAN RADIUS	:	.999	.845	.801
MAX RADIUS	:	2.133	1.247	1.135
HORIZONTAL SPREAD	:	1.911	1.911	1.778
VERTICAL SPREAD	:	3.246	2.021	1.962
EXTREME SPREAD	:	3.556	2.481	1.997
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Jun 1952

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HM = 3.531

VS = 2.685

GS = 3.559

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.161	1.688	.901
MINIMUM X	:	-1.370	-1.130	-.918
MAXIMUM Y	:	1.317	1.353	1.093
MINIMUM Y	:	-1.369	-1.332	-1.163
CENTROID X	:	.118	-.122	-.334
CENTROID Y	:	.173	.137	-.032
POA TO CENTROID in.	:	.210	.184	.335
MIN RADIUS	:	.492	.519	.267
MEAN RADIUS	:	1.170	1.019	.837
MAX RADIUS	:	2.186	2.163	1.192
HORIZONTAL SPREAD	:	3.531	2.818	1.820
VERTICAL SPREAD	:	2.685	2.685	2.256
EXTREME SPREAD	:	3.559	3.446	2.306
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		