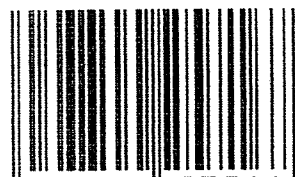


UPC



0 47700 25716 2

C6702849

*INCLUDES 1 IN CHAMBER

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6702849

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	Kcd
	Magnaflux Bolt	MAY	5 1992	Kcd
615	Rollmark Caliber	MAY	5 1992	GS
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	JA
	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. #	BARBER - M24 0105306 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			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	.0215	.0215	.022			6/15/92	RW
	J) Assemble Stock						6/15/92	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						6/15/92	RW
	P) Detach & Attach Scope 20 Times						6/15/92	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	2.69	2.66	2.59	2.60	2.57	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. C6702849

DATE 6/15/92

TESTER PW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.28	2.37	2.69	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.27	2.39	2.66	
PULL #3	2.34	2.22	2.33	2.59	
PULL #4	2.32	2.25	2.30	2.60	
PULL #5	2.32	2.25	2.35	2.57	
TOTAL	11.59	11.27	11.74	13.11	
AVG.	2.32	2.25	2.35	2.62	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.35		
PULL #2	3.33	3.36		
PULL #3	3.29	3.32		
PULL #4	3.31	3.31		
PULL #5	3.31	3.32		
TOTAL	16.50	16.66		
AVG.	3.30	3.33		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	4.18		4.11
PULL #2	4.12	4.18		4.12
PULL #3	4.15	4.13		4.17
PULL #4	4.11	4.15		4.18
PULL #5	4.17	4.16		4.10
TOTAL	20.69	20.80		20.68
AVG.	4.14	4.16		4.14

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6702849
25 Jun 1992

CENTROIDAL DISTANCES

0 TO	1	.25046
1 TO	2	.692642
1 TO	3	.392766
1 TO	4	.423605
1 TO	5	.151489

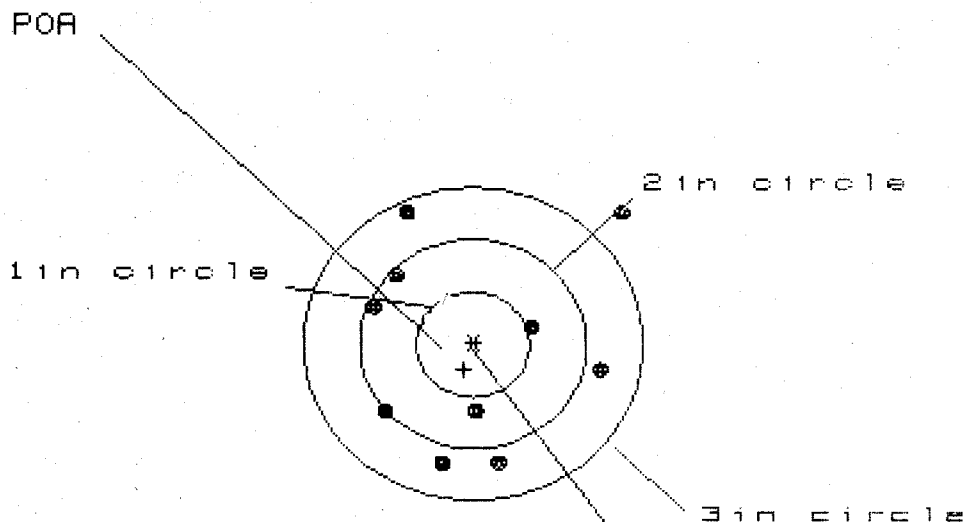
θ_2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0206
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0442
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0487647
THE AMR FOR THIS RIFLE IS: 1.094

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG702849

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 9

HS = 2.248

VS = 2.433

GS = 2.934

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.354	1.260	1.209
MINIMUM X	-.894	-.743	-.794
MAXIMUM Y	1.252	1.390	1.004
MINIMUM Y	-1.181	-1.043	-.869
CENTROID X	.081	-.070	-.019
CENTROID Y	.237	.099	-.075
POA TO CENTROID in.	.251	.121	.078
MIN RADIUS	.519	.495	.317
MEAN RADIUS	1.075	.967	.877
MAX RADIUS	1.841	1.448	1.215
HORIZONTAL SPREAD	2.248	2.003	2.003
VERTICAL SPREAD	2.433	2.433	1.873
EXTREME SPREAD	2.934	2.482	2.078
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702849

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS = 2.548

VS = 1.765

GS = 2.569

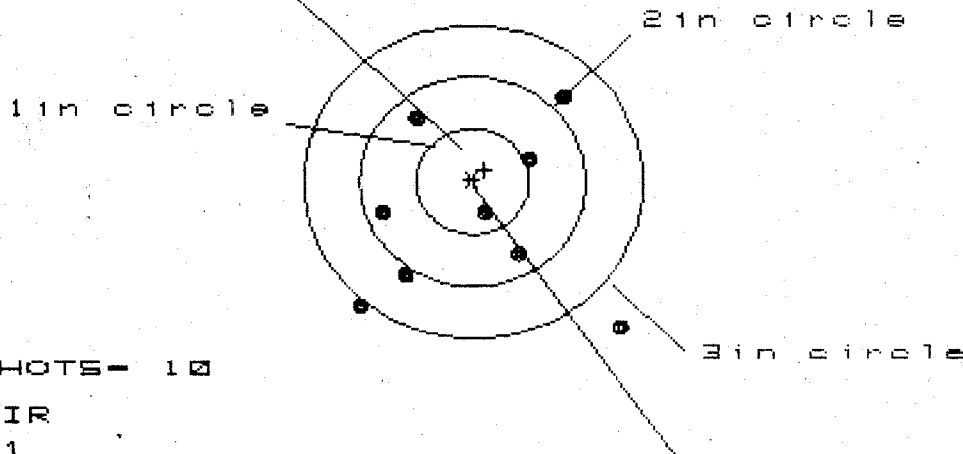
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.750	1.111	1.051
MINIMUM X	:	-.798	-.603	-.663
MAXIMUM Y	:	.794	.794	.640
MINIMUM Y	:	-.971	-.971	-.872
CENTROID X	:	.353	.158	.218
CENTROID Y	:	-.400	-.400	-.499
POA TO CENTROID in.	:	.534	.430	.544
MIN RADIUS	:	.401	.310	.364
MEAN RADIUS	:	.849	.711	.694
MAX RADIUS	:	1.750	1.137	1.061
HORIZONTAL SPREAD	:	2.548	1.714	1.714
VERTICAL SPREAD	:	1.765	1.765	1.512
EXTREME SPREAD	:	2.569	1.912	1.805
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/CG702849

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.258

VS = 4.269

GS = 4.557

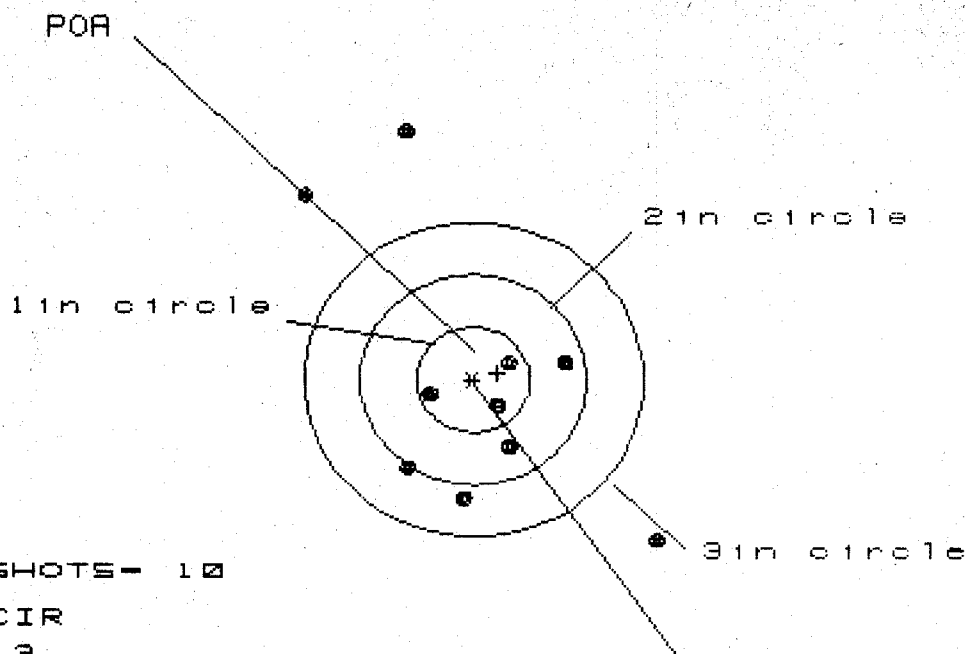
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	1.229	.883
MINIMUM X	:	-.992	-1.029	-.875
MAXIMUM Y	:	2.896	1.159	1.028
MINIMUM Y	:	-1.373	-1.052	-.970
CENTROID X	:	-.103	-.066	-.220
CENTROID Y	:	-.110	-.432	-.301
POA TO CENTROID in.	:	.151	.437	.373
MIN RADIUS	:	.291	.116	.260
MEAN RADIUS	:	1.180	.939	.855
MAX RADIUS	:	2.914	1.618	1.355
HORIZONTAL SPREAD	:	2.258	2.258	1.758
VERTICAL SPREAD	:	4.269	2.211	1.998
EXTREME SPREAD	:	4.557	2.661	2.661
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

23 Jun 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6702849

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 3.078

VS= 3.882

GS= 4.496

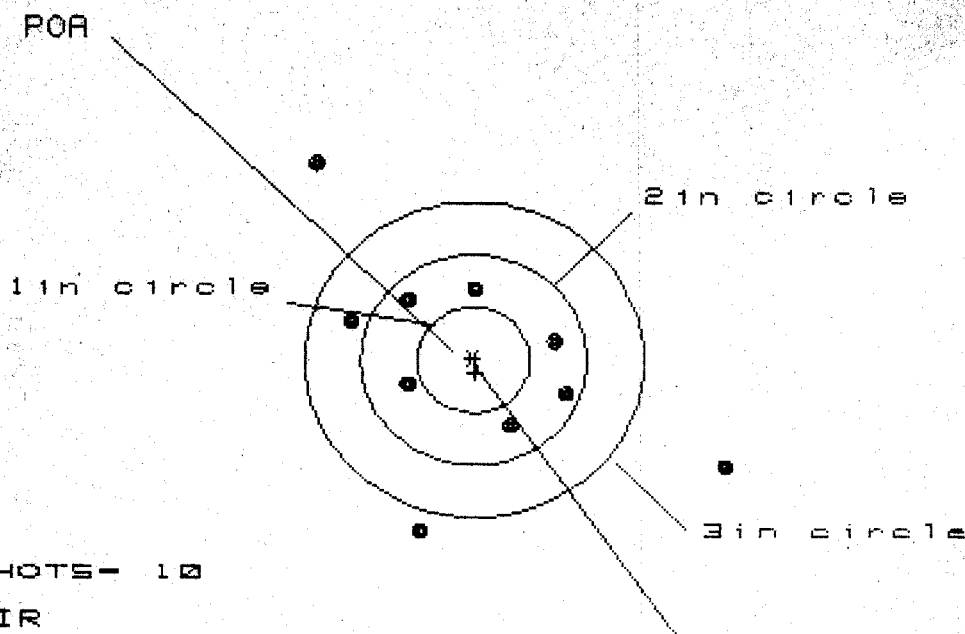
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.616	1.548	1.357
MINIMUM X	:	-1.462	-1.530	-.838
MAXIMUM Y	:	2.326	1.980	.714
MINIMUM Y	:	-1.556	-1.297	-1.050
CENTROID X	:	-.214	-.146	.045
CENTROID Y	:	-.067	-.326	-.573
POA TO CENTROID in.	:	.224	.357	.575
MIN RADIUS	:	.297	.122	.149
MEAN RADIUS	:	1.166	.968	.767
MAX RADIUS	:	2.404	2.502	1.716
HORIZONTAL SPREAD	:	3.078	3.078	2.195
VERTICAL SPREAD	:	3.882	3.277	1.764
EXTREME SPREAD	:	4.496	4.496	2.520
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

23 Jan 1982

FILE:/PATTERNING/CENTERFIRE_PATT/C6702849

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 7

HS= 3.517

VS= 3.457

GS= 4.532

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	5
MAXIMUM X	2.181	1.035	.894
MINIMUM X	-1.336	-1.093	-.956
MAXIMUM Y	1.839	1.725	.930
MINIMUM Y	-1.618	-1.732	-1.516
CENTROID X	-.014	-.257	-.120
CENTROID Y	.119	.233	.017
POA TO CENTROID in.	.120	.346	.121
MIN RADIUS	.653	.483	.520
MEAN RADIUS	1.202	1.048	.916
MAX RADIUS	2.408	2.043	1.570
HORIZONTAL SPREAD	3.517	2.128	1.854
VERTICAL SPREAD	3.457	3.457	2.346
EXTREME SPREAD	4.532	3.553	3.411
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	0	0	0
NUMBER IN THREE INCH CIRCLE =	0	0	0