

C6587540

MODEL 700™ M24

Model SMS™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.





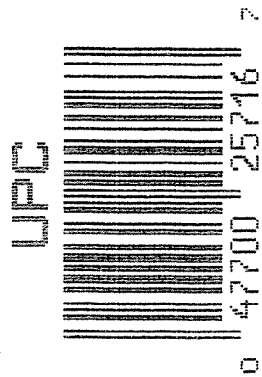
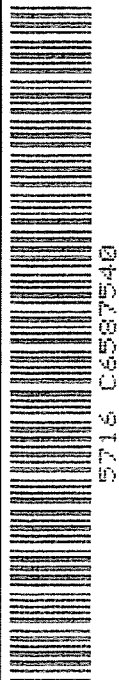

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM H24

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

SERIAL NO.
C6587540

ORDER NO.
5716



INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06587540

OP. #	OP. NAME	READINGS	DATE	INIT
575* & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel RB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-4-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3.50	3.75	3.75			1/3/91	KJ
	G) Safety Off Force	2.50	2.50	2.50			1/3/91	KJ
	H) Trigger Pull Test & Retainability						1-4-91	DH
	I) Firing Pin Indent	.020	.020	.020			1/3/91	RJ
	J) Assemble Stock						1/9/91	RW
	K) Assemble Swivel Studs						1-11-91	
	L) Attach Front and Rear Sight Assemblies						1/9/91	RW
	M) Iron Sight Alignment						1/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/9/91	RW
	O) Attach Scope to Rifle						1/9/91	RW
	P) Detach & Attach Scope 20 Times						1/9/91	RW
640	Gallery Target & Test						1-10-91	AC
	A) Time						1-10-91	AC
	B) Malfunctions						1-10-91	AC
	C) Pierced Primers						1-10-91	AC
	D) Optical Clarity of Scope						1-10-91	AC
645	Inspect for Live Ammo						1-10-91	AC
655	Final Inspection							
	A) Headspace						1-11-91	JH
	B) Trigger Pull	2.46	2.47	2.43	2.49	2.44	1-11-91	JH
	C) Function						1-11-91	JH
660	Pack						3-15-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6587540

DATE 1-4-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.27	2.51	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.25	2.31	2.47	
PULL #3	2.41	2.24	2.21	2.43	
PULL #4	2.37	2.23	2.44	2.49	
PULL #5	2.25	2.21	2.32	2.44	
TOTAL	11.82	11.20	11.79		
AVG.	2.36	2.24	2.35		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.01		
PULL #2	3.25	3.22		
PULL #3	3.27	3.14		
PULL #4	3.34	3.06		
PULL #5	3.35	3.02		
TOTAL	16.46	15.45		
AVG.	3.29	3.09		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.38		4.44
PULL #2	4.76	4.28		4.43
PULL #3	4.28	4.28		4.59
PULL #4	4.31	4.05		4.08
PULL #5	4.25	4.13		4.32
TOTAL	21.09	21.12		21.86
AVG.	4.21	4.22		4.37

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587540
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.115966
1 TO	2	.236008
1 TO	3	.781634
1 TO	4	.302167
1 TO	5	.319776

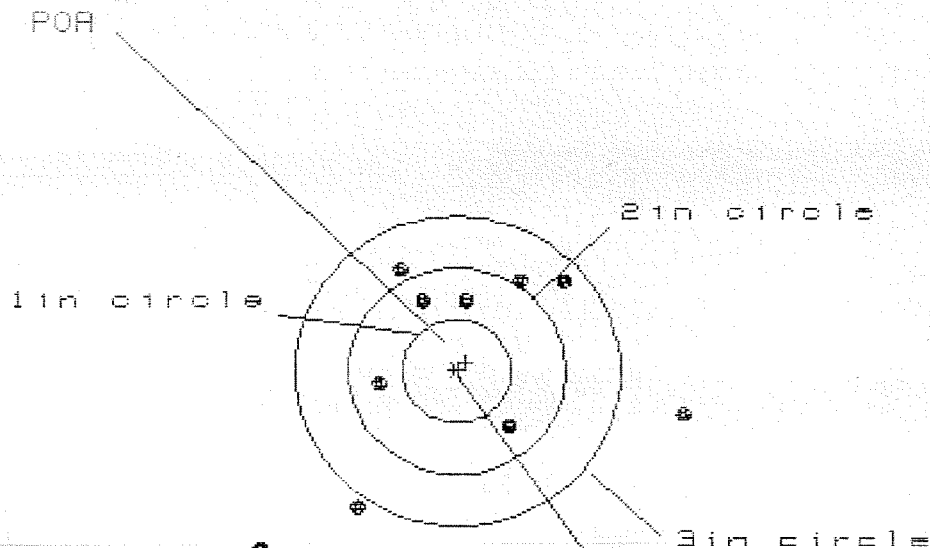
$\frac{5}{4}$ $\frac{3}{4}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0658
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .049
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0820405
THE AMR FOR THIS RIFLE IS: 1.2

10 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587540

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 4

2in = 4

3in = 7

HS= 3.838

VS= 2.737

GS= 4.153

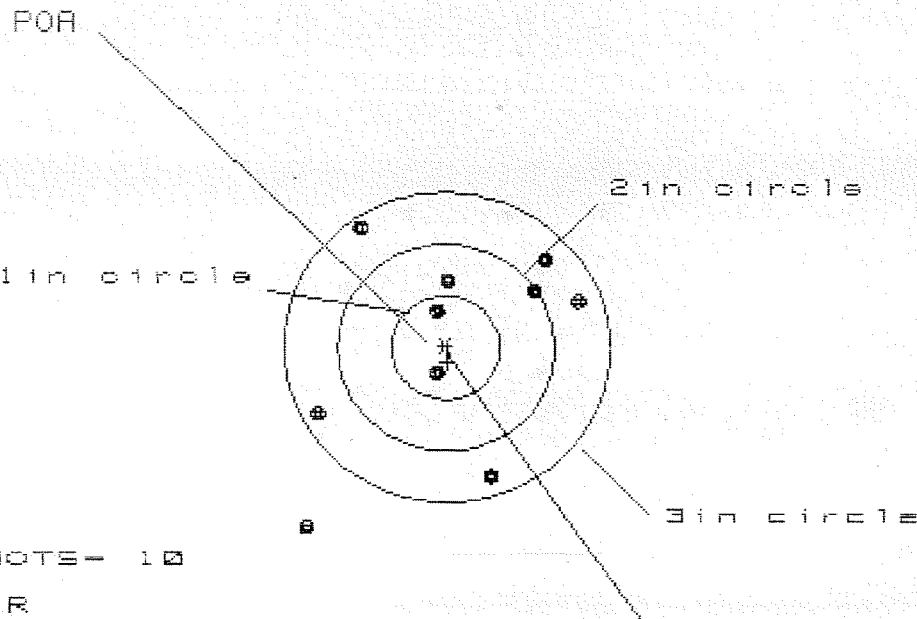
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.112	1.909	1.000
MINIMUM X	:	-1.826	-1.089	-.850
MAXIMUM Y	:	1.013	.822	.747
MINIMUM Y	:	-1.724	-1.519	-1.594
CENTROID X	:	-.082	.121	-.118
CENTROID Y	:	-.082	.109	.184
POA TO CENTROID in.	:	.116	.163	.218
MIN RADIUS	:	.644	.465	.390
MEAN RADIUS	:	1.265	1.085	.927
MAX RADIUS	:	2.511	2.000	1.807
HORIZONTAL SPREAD	:	3.938	2.998	1.850
VERTICAL SPREAD	:	2.737	2.341	2.341
EXTREME SPREAD	:	4.153	3.137	2.900
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587540

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 2.481

VS= 2.908

GS= 3.390

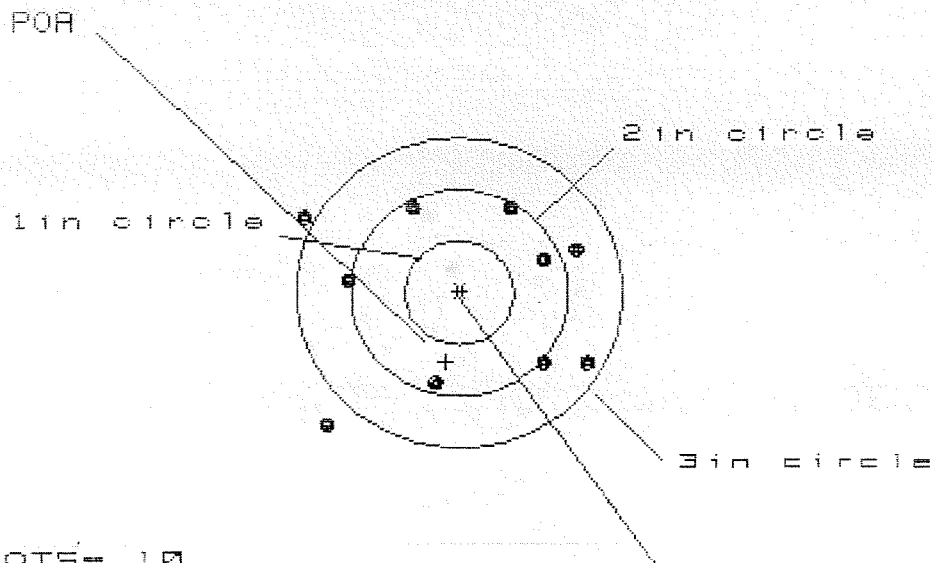
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.198	1.055	.942
MINIMUM X	:	-1.283	-1.306	-1.419
MAXIMUM Y	:	1.152	.957	.741
MINIMUM Y	:	-1.757	-1.449	-1.330
CENTROID X	:	-.014	.129	.242
CENTROID Y	:	.144	.339	.220
POA TO CENTROID in.	:	.145	.363	.327
MIN RADIUS	:	.285	.276	.437
MEAN RADIUS	:	1.097	.937	.897
MAX RADIUS	:	2.176	1.536	1.577
HORIZONTAL SPREAD	:	2.481	2.361	2.361
VERTICAL SPREAD	:	2.909	2.406	2.071
EXTREME SPREAD	:	3.390	2.658	2.572
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587540

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS= 2.552

VS= 2.107

GS= 2.910

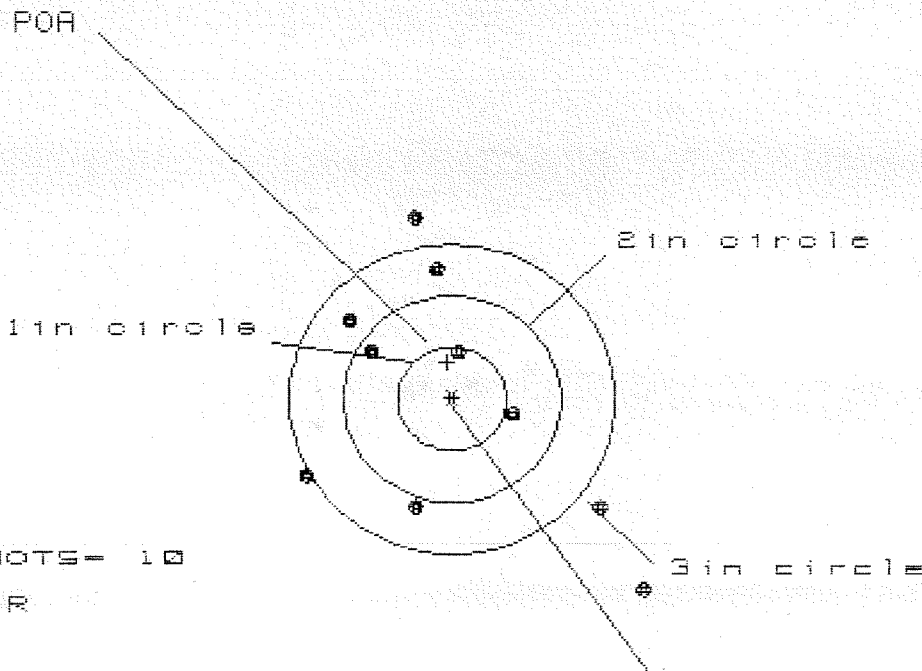
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.147	1.012	.819
MINIMUM X	:	-1.405	-1.540	-1.340
MAXIMUM Y	:	.859	.720	.797
MINIMUM Y	:	-1.248	-1.033	-.956
CENTROID X	:	.124	.259	.452
CENTROID Y	:	.672	.811	.734
POA TO CENTROID in.	:	.683	.851	.862
MIN RADIUS	:	.840	.665	.520
MEAN RADIUS	:	1.156	1.061	.955
MAX RADIUS	:	1.744	1.658	1.342
HORIZONTAL SPREAD	:	2.552	2.552	2.159
VERTICAL SPREAD	:	2.107	1.753	1.753
EXTREME SPREAD	:	2.910	2.906	2.297
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587540

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 3.047

VS= 3.646

GS= 4.222

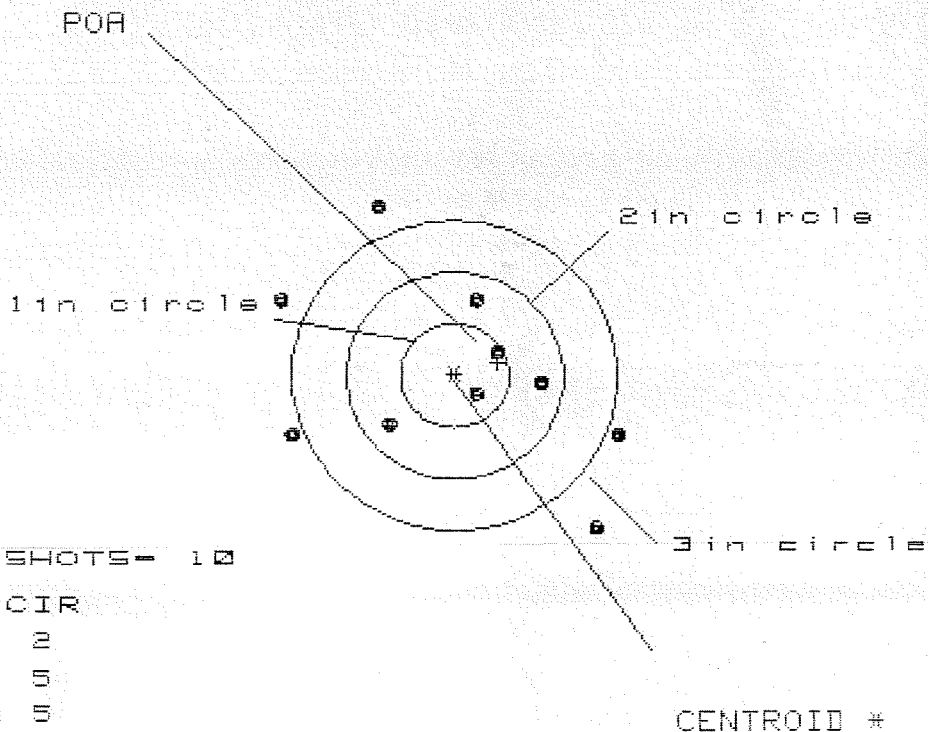
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.753	1.528	1.506
MINIMUM X	:	-1.293	-1.099	-1.121
MAXIMUM Y	:	1.792	1.587	1.226
MINIMUM Y	:	-1.853	-1.253	-1.055
CENTROID X	:	.041	-.153	-.131
CENTROID Y	:	-.358	-.152	-.350
POA TO CENTROID in.	:	.360	.216	.374
MIN RADIUS	:	.500	.393	.544
MEAN RADIUS	:	1.304	1.116	1.069
MAX RADIUS	:	2.552	1.977	1.839
HORIZONTAL SPREAD	:	3.047	2.627	2.627
VERTICAL SPREAD	:	3.646	2.840	2.281
EXTREME SPREAD	:	4.222	3.315	2.957
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

10 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587540

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 5

HS= 3.052

VS= 3.102

GS= 3.714

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	1.620	1.547
MINIMUM X	:	-1.578	-1.432	-1.505
MAXIMUM Y	:	1.586	1.417	.735
MINIMUM Y	:	-1.516	-.729	-.552
CENTROID X	:	-.398	-.544	-.471
CENTROID Y	:	-.131	.038	-.139
POA TO CENTROID in.	:	.419	.545	.491
MIN RADIUS	:	.287	.510	.337
MEAN RADIUS	:	1.176	1.095	1.012
MAX RADIUS	:	2.006	1.760	1.663
HORIZONTAL SPREAD	:	3.052	3.052	3.052
VERTICAL SPREAD	:	3.102	2.146	1.287
EXTREME SPREAD	:	3.714	3.286	3.286
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		5	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587540
12 Mar 1991

CENTROIDAL DISTANCES

0 TO	1	.255783
1 TO	2	.0594643
1 TO	3	.278002
1 TO	4	.605219
1 TO	5	.268405

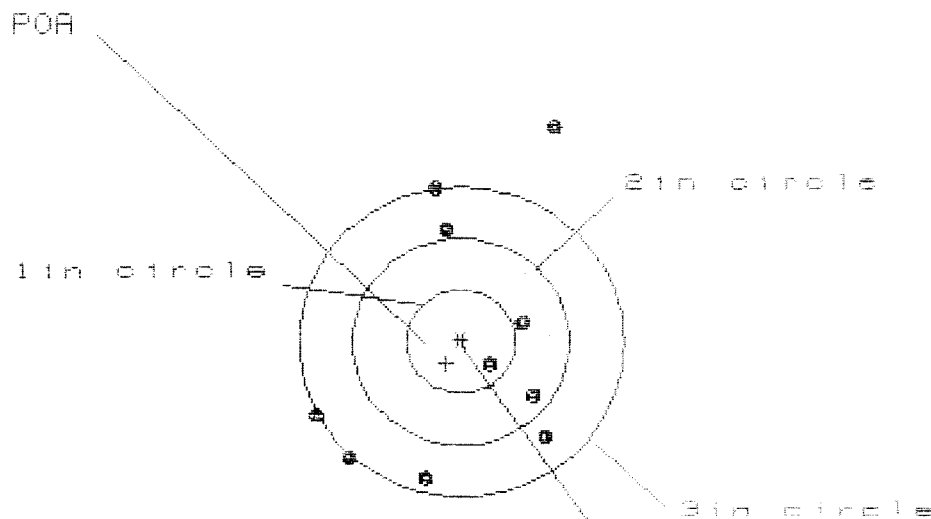
 ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1474
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0316
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .150749
THE AMR FOR THIS RIFLE IS: 1.302

12 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587540.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.182

VS= 3.438

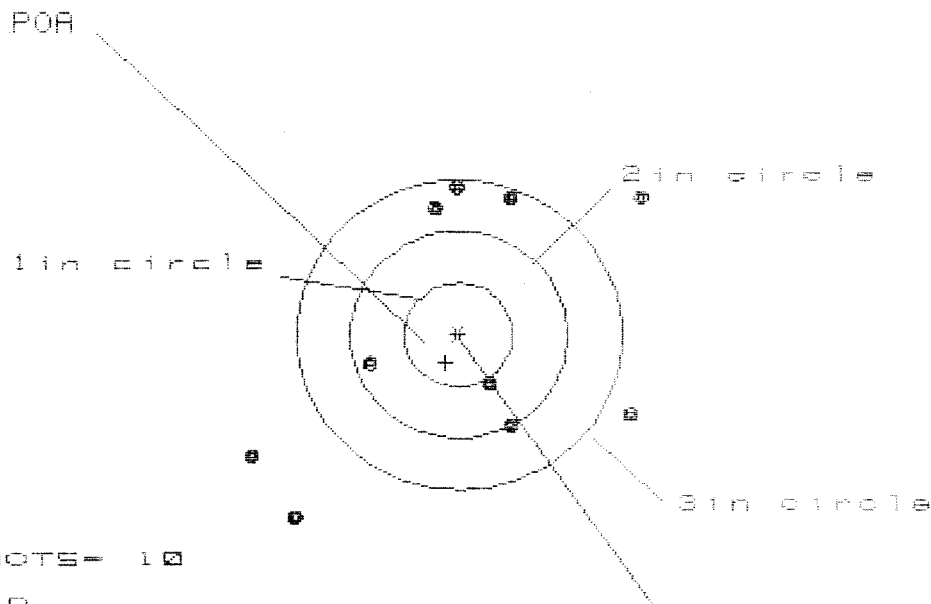
GS= 3.765

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.818	.698
MINIMUM X	:	-1.298	-1.200	-1.321
MAXIMUM Y	:	2.085	1.695	1.581
MINIMUM Y	:	-1.353	-1.121	-1.235
CENTROID X	:	.137	.039	.160
CENTROID Y	:	.216	-.016	.098
POA TO CENTROID in.	:	.256	.042	.187
MIN RADIUS	:	.301	.336	.224
MEAN RADIUS	:	1.214	1.084	1.023
MAX RADIUS	:	2.265	1.699	1.601
HORIZONTAL SPREAD	:	2.182	2.018	2.018
VERTICAL SPREAD	:	3.438	2.816	2.816
EXTREME SPREAD	:	3.765	2.817	2.817
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

12 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587540.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 6

HS= 3.549

VS= 3.215

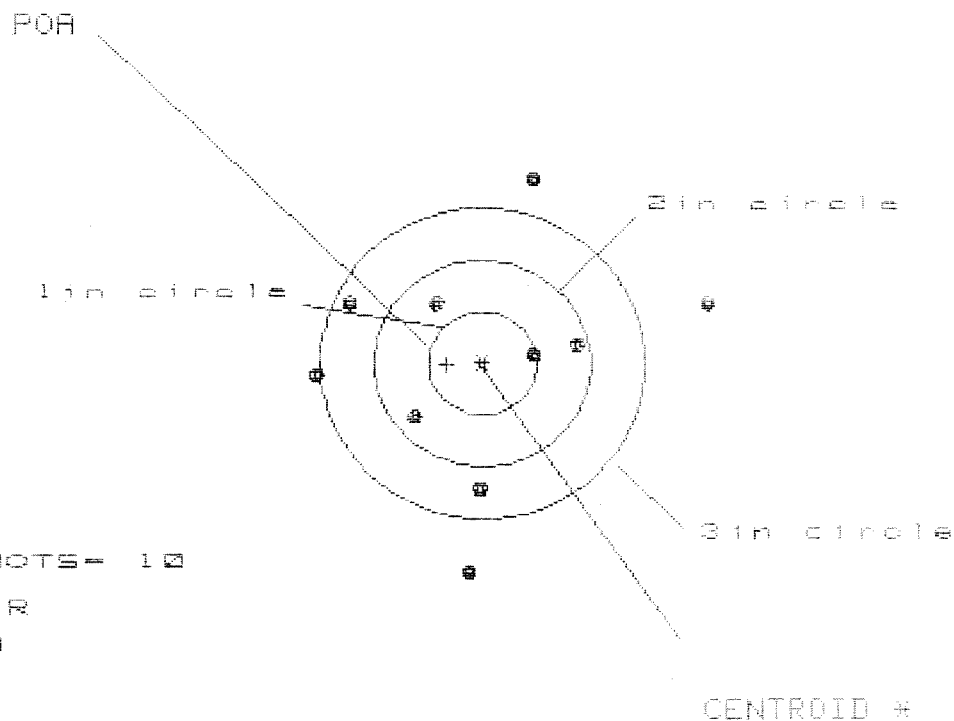
GS= 4.389

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.643	1.479	1.220
MINIMUM X	-1.906	-2.070	-1.262
MAXIMUM Y	1.477	1.284	1.109
MINIMUM Y	-1.738	-1.399	-1.230
CENTROID X	.117	.281	.540
CENTROID Y	.272	.465	.640
POA TO CENTROID in.	.296	.543	.837
MIN RADIUS	.584	.713	.887
MEAN RADIUS	1.505	1.404	1.251
MAX RADIUS	2.280	2.499	1.638
HORIZONTAL SPREAD	3.549	3.549	2.482
VERTICAL SPREAD	3.215	2.683	2.339
EXTREME SPREAD	4.389	4.374	2.988
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		6	

12 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00587540.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 0

2in = 4

3in = 6

HS = 3.654

VS = 3.781

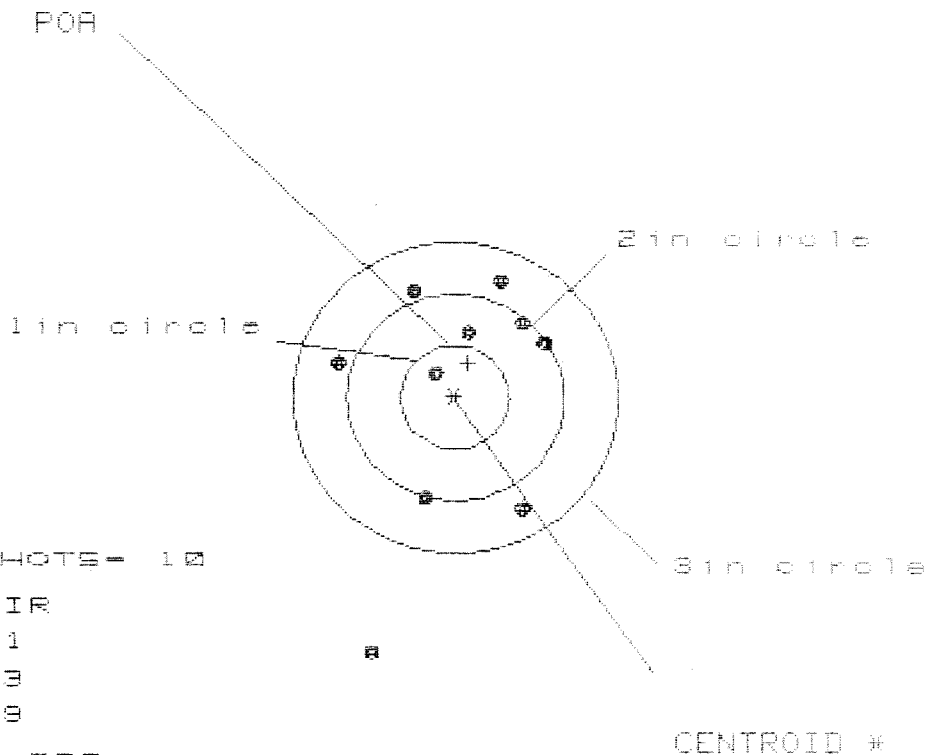
GS = 3.626

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.112	1.076	1.090
MINIMUM X	:	-1.542	-1.307	-1.293
MAXIMUM Y	:	1.814	1.877	1.639
MINIMUM Y	:	-1.967	-1.904	-1.425
CENTROID X	:	.328	.093	.079
CENTROID Y	:	.014	-.049	.139
POA TO CENTROID in.	:	.328	.105	.205
MIN RADIUS	:	.521	.578	.486
MEAN RADIUS	:	1.310	1.196	1.091
MAX RADIUS	:	2.186	2.002	1.787
HORIZONTAL SPREAD	:	3.654	2.383	2.383
VERTICAL SPREAD	:	3.781	3.781	3.064
EXTREME SPREAD	:	3.826	3.826	3.107
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

12 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587540.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 9

HS= 1.963

VS= 3.522

GS= 3.694

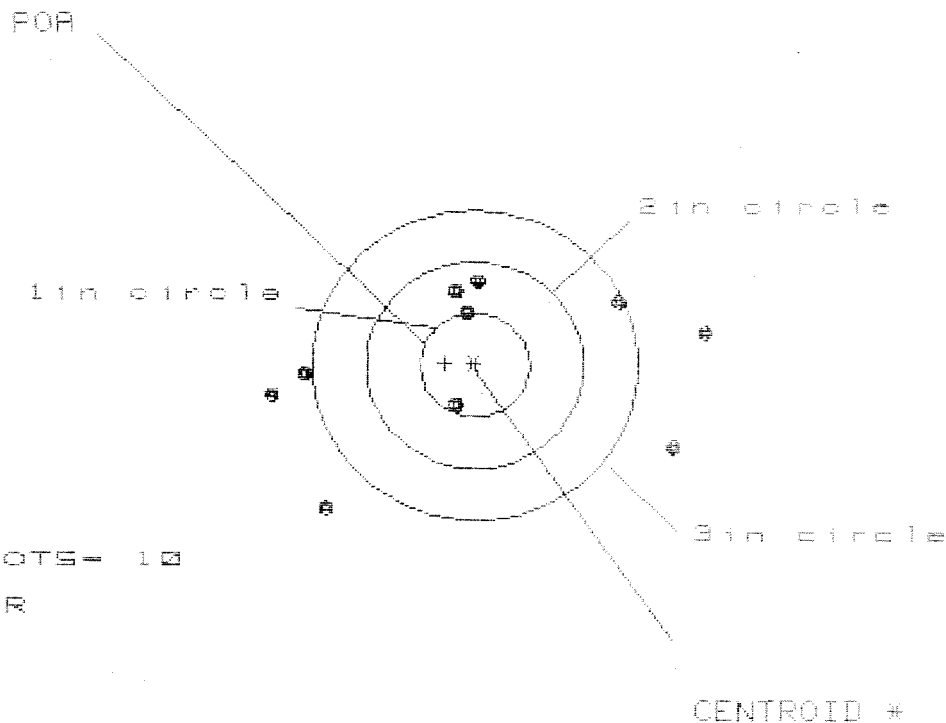
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.867	.786	.854
MINIMUM X	:	-1.096	-1.177	-1.109
MAXIMUM Y	:	1.083	.811	.641
MINIMUM Y	:	-2.439	-1.368	-1.446
CENTROID X	:	-.122	-.041	-.109
CENTROID Y	:	-.331	-.060	.110
POA TO CENTROID in.	:	.353	.073	.155
MIN RADIUS	:	.300	.279	.241
MEAN RADIUS	:	1.118	.882	.766
MAX RADIUS	:	2.548	1.472	1.469
HORIZONTAL SPREAD	:	1.963	1.963	1.963
VERTICAL SPREAD	:	3.522	2.179	2.086
EXTREME SPREAD	:	3.694	2.370	2.178
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08582540.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 4.021

VS= 2.260

GS= 4.071

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.116	2.076	1.783
MINIMUM X	-1.905	-1.670	-1.411
MAXIMUM Y	.827	.864	.769
MINIMUM Y	-1.433	-1.396	-1.491
CENTROID X	.277	.042	-.217
CENTROID Y	-.013	-.050	.045
POA TO CENTROID in.	.278	.065	.222
MIN RADIUS	.468	.390	.567
MEAN RADIUS	1.365	1.262	1.129
MAX RADIUS	2.141	2.209	1.875
HORIZONTAL SPREAD	4.021	3.746	3.194
VERTICAL SPREAD	2.260	2.260	2.260
EXTREME SPREAD	4.071	3.777	3.336
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		5	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587540
13 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.0871436
1 TO 2	.34192
1 TO 3	.169544
1 TO 4	.691279
1 TO 5	.335006

$\frac{5}{2}$ (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1652
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0906
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .188413

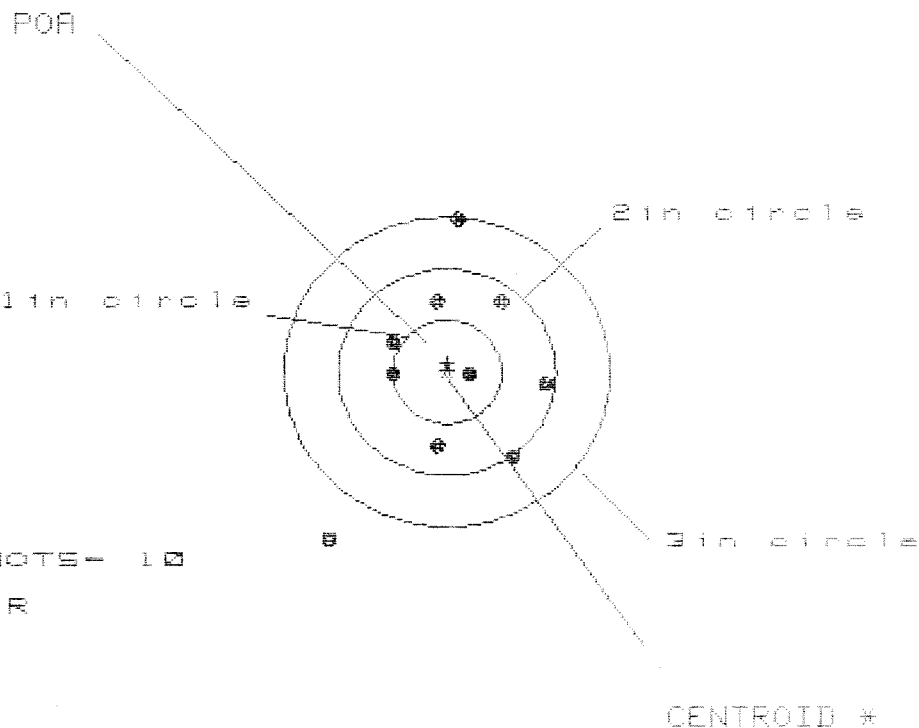
THE AMR FOR THIS RIFLE IS: 1.04

*Lead & Reshoot
9/27/91 3/14/91*

13 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587540.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 2.025

VS= 3.127

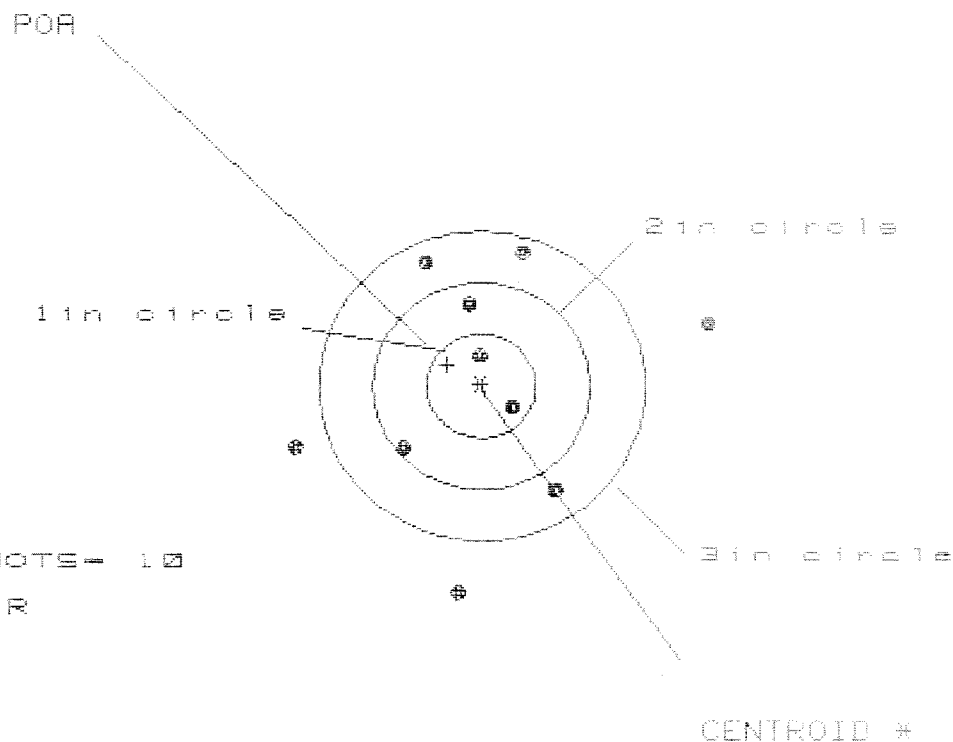
GS= 3.335

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.943	.822	.817
MINIMUM X	-1.083	-.665	-.670
MAXIMUM Y	1.489	1.307	.696
MINIMUM Y	-1.638	-.950	-.787
CENTROID X	-.005	.116	.121
CENTROID Y	-.087	.095	-.068
POA TO CENTROID in.	.087	.150	.139
MIN RADIUS	.193	.204	.072
MEAN RADIUS	.903	.772	.684
MAX RADIUS	1.964	1.307	.907
HORIZONTAL SPREAD	2.025	1.487	1.487
VERTICAL SPREAD	3.127	2.257	1.483
EXTREME SPREAD	3.335	2.312	1.627
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

13 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587540.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 7

HS = 3.845

VS = 3.364

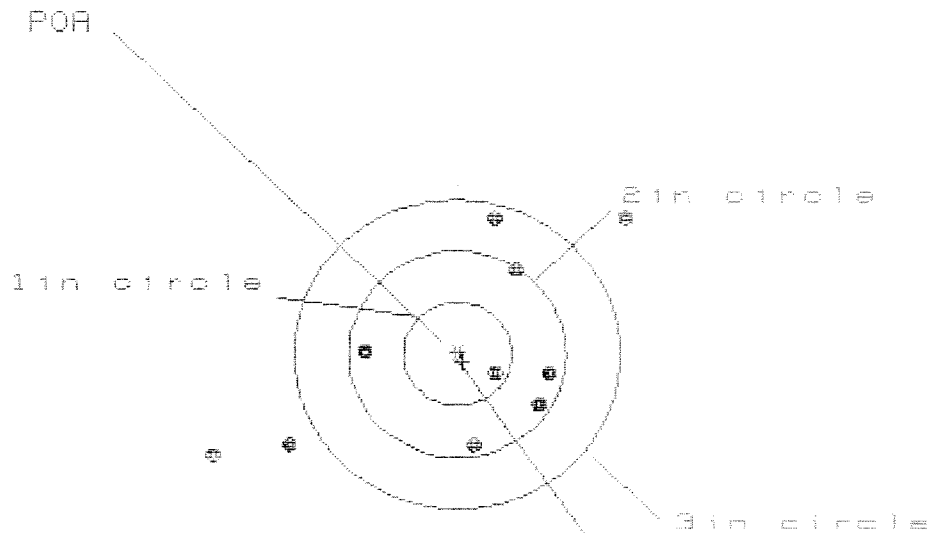
GS = 4.030

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.097	.881	.887
MINIMUM X	:	-1.748	-1.515	-1.509
MAXIMUM Y	:	1.340	1.410	1.166
MINIMUM Y	:	-2.024	-1.954	-1.144
CENTROID X	:	.317	.084	.078
CENTROID Y	:	-.202	-.272	-.028
POR TO CENTROID in.	:	.376	.285	.083
MIN RADIUS	:	.271	.373	.195
MEAN RADIUS	:	1.225	1.123	.981
MAX RADIUS	:	2.191	1.954	1.683
HORIZONTAL SPREAD	:	3.845	2.396	2.396
VERTICAL SPREAD	:	3.364	3.364	2.310
EXTREME SPREAD	:	4.030	3.417	2.882
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 7

HS = 3.788

VS = 2.315

GS = 4.439

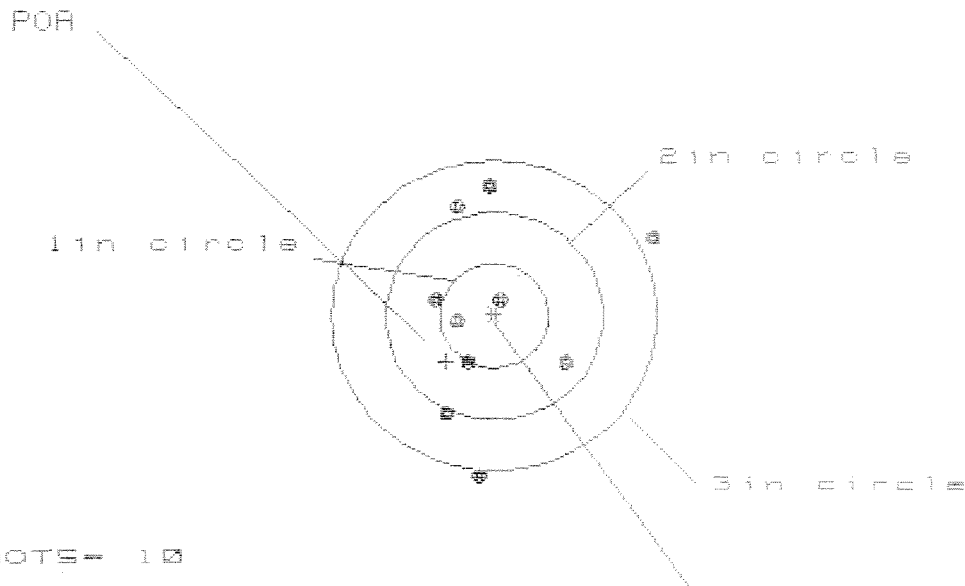
CENTROID #

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.573	1.327	.754
MINIMUM X	-2.215	-1.814	-1.648
MAXIMUM Y	1.324	1.213	1.321
MINIMUM Y	-.992	-.986	-.834
CENTROID X	-.048	.198	.032
CENTROID Y	.077	.188	.036
POR TO CENTROID in.	.091	.273	.048
MIN RADIUS	.363	.270	.273
MEAN RADIUS	1.236	1.054	.963
MAX RADIUS	2.427	2.042	1.826
HORIZONTAL SPREAD	3.788	3.141	2.402
VERTICAL SPREAD	2.315	2.199	2.155
EXTREME SPREAD	4.439	3.807	2.875
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.002

VS= 2.776

GS= 2.785

CENTROID #

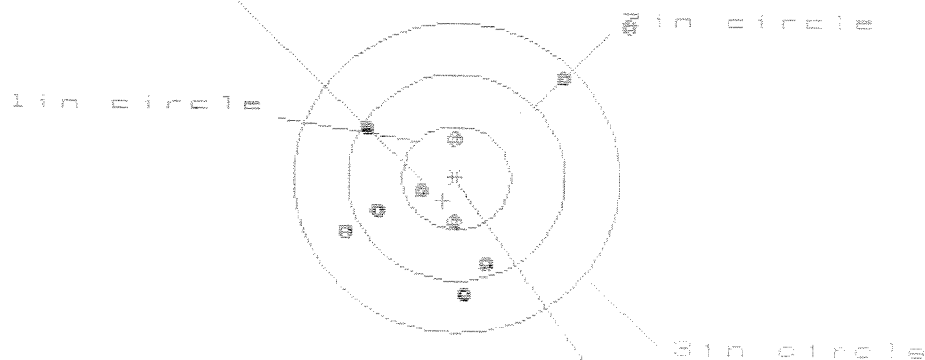
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.452	.807	.803
MINIMUM X	:	-.550	-.388	-.392
MAXIMUM Y	:	1.277	1.360	1.183
MINIMUM Y	:	-1.499	-1.416	-1.033
CENTROID X	:	.440	.278	.282
CENTROID Y	:	.442	.359	.536
POA TO CENTROID in.	:	.624	.454	.605
MIN RADIUS	:	.171	.183	.247
MEAN RADIUS	:	.892	.780	.701
MAX RADIUS	:	1.636	1.416	1.191
HORIZONTAL SPREAD	:	2.002	1.195	1.195
VERTICAL SPREAD	:	2.776	2.776	2.216
EXTREME SPREAD	:	2.785	2.781	2.261
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.539

VS= 2.529

GS= 3.206

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.550	1.166	.686
MINIMUM X	:	-.989	-.817	-.671
MAXIMUM Y	:	1.427	1.142	.779
MINIMUM Y	:	-1.102	-.944	-.801
CENTROID X	:	.122	-.050	-.196
CENTROID Y	:	.223	.065	-.078
POA TO CENTROID in.	:	.254	.082	.211
MIN RADIUS	:	.316	.128	.186
MEAN RADIUS	:	.943	.749	.617
MAX RADIUS	:	2.107	1.633	.952
HORIZONTAL SPREAD	:	2.539	1.983	1.277
VERTICAL SPREAD	:	2.529	2.086	1.580
EXTREME SPREAD	:	3.206	2.495	1.834
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50#+ .50#
3.00#+ .75#
4.00#+1.00#

SERIAL NO C6587540
DATE 2-15-96
TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.55	2.52		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.58	2.49		
PULL #3	2.58	2.37	2.50		
PULL #4	2.57	2.53	2.48		
PULL #5	2.57	2.54	2.49		
TOTAL	1276	1257	1248		
AVG.	2.55	2.51	2.49		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.18		
PULL #2	3.22	3.20		
PULL #3	3.20	3.19		
PULL #4	3.22	3.15		
PULL #5	3.00	3.20		
TOTAL	1569	1592		
AVG.	3.13	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.18		4.38
PULL #2	4.09	4.22		4.30
PULL #3	4.23	4.15		4.42
PULL #4	4.20	4.20		4.48
PULL #5	4.00	4.19		4.15
TOTAL	2070	2094		2173
AVG.	4.14	4.18		4.34

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587540

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

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 ³ / ₄	4 ³ / ₄	4 ³ / ₄			2/23/96	W3
	G) Safety Off Force	2 ³ / ₄	2 ³ / ₄	2 ³ / ₄			2/23/96	W3
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	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							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/23/96	RA
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace						2/24/96	RA
	B) Trigger Pull	2.61	2.67	2.69	2.68	2.64	2/23/96	W3
	C) Function						2/24/96	RA
660	Pack							