

C6225558

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M2400051471

88299

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225558*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2/1</i>	<i>FB</i>
600	PROOF	<i>2/8/88</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>P/C</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>P/C</i>
620	COATING	<i>3/21/88</i>	<i>ISA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CG225558

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 & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/9/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/9/88	RW
	C) Inspect Ejector Hole for Chamfer		9/9/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/9/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9 Sept 88	J.H. + W.S.
	F) Safety on Force	4 4.25 4.25	9 Sept 88	J.H. + W.S.
	G) Safety off Force	2.25 3 3	9 Sept 88	J.H. + W.S.
	H) Trigger Pull Test & Retainability		9 Sept 88	J.H. + W.S.
	I) Firing Pin Indent	.022 .022 .022	9 Sept 88	J.H. + W.S.
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12-88	W.S.
	L) Attach Front & Rear Sight Assemblies		9/15/88	RW
	M) Iron Sight Alignment		9/15/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/15/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	W.S.
640	Gallery Target & Test	55 R 100L	10/10/88	A.C.
	A) Optical Clarity of Scope		10/10/88	A.C.
645	Inspect for Live Ammo		10/10/88	W.B.
655	Final Inspection			
	A) Headspace		10-12-88	W.S.
	B) Trigger Pull		10-14-88	W.S.
	C) Function		10-12-88	W.S.
660	Pack		10-21-88	W.S.

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225558
DATE 9 Sept. 88
TESTER J. H. + G. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.20	2.30	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.52	2.18	2.29	2.48	
PULL #3	2.28	2.20	2.27	2.49	
PULL #4	2.44	2.17	2.24	2.44	
PULL #5	2.48	2.21	2.21	2.56	
TOTAL	12.26	10.96	11.31	12.50	
AVG.	2.452	2.192	2.262	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.04		
PULL #2	3.03	3.06		
PULL #3	3.09	3.07		
PULL #4	3.03	3.05		
PULL #5	3.05	3.12		
TOTAL	15.25	15.34		
AVG.	3.05	3.068		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.05		4.20
PULL #2	4.13	4.21		4.19
PULL #3	4.16	4.15		4.16
PULL #4	4.13	4.14		4.21
PULL #5	4.14	4.20		4.13
TOTAL	20.72	20.75		20.89
AVG.	4.144	4.15		4.178

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225558

CENTROIDAL DISTANCES

Ø TO	1	1.05142
1 TO	2	.299541
1 TO	3	.678189
1 TO	4	.409236
1 TO	5	.728271

+ <-----POA
5
3 2
4 1

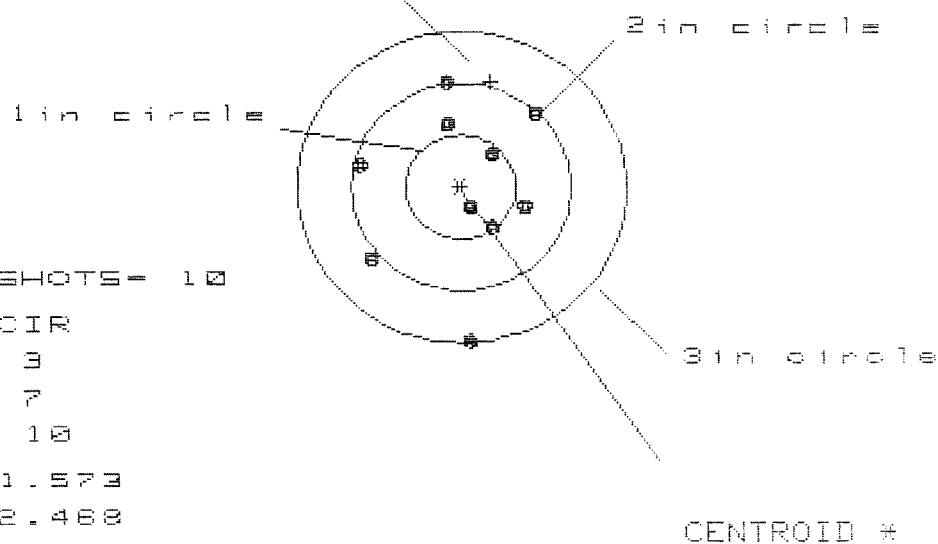
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.571
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.7792
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .966019
THE AMR FOR THIS RIFLE IS: .7682

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/622555B

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.573

VS = 2.468

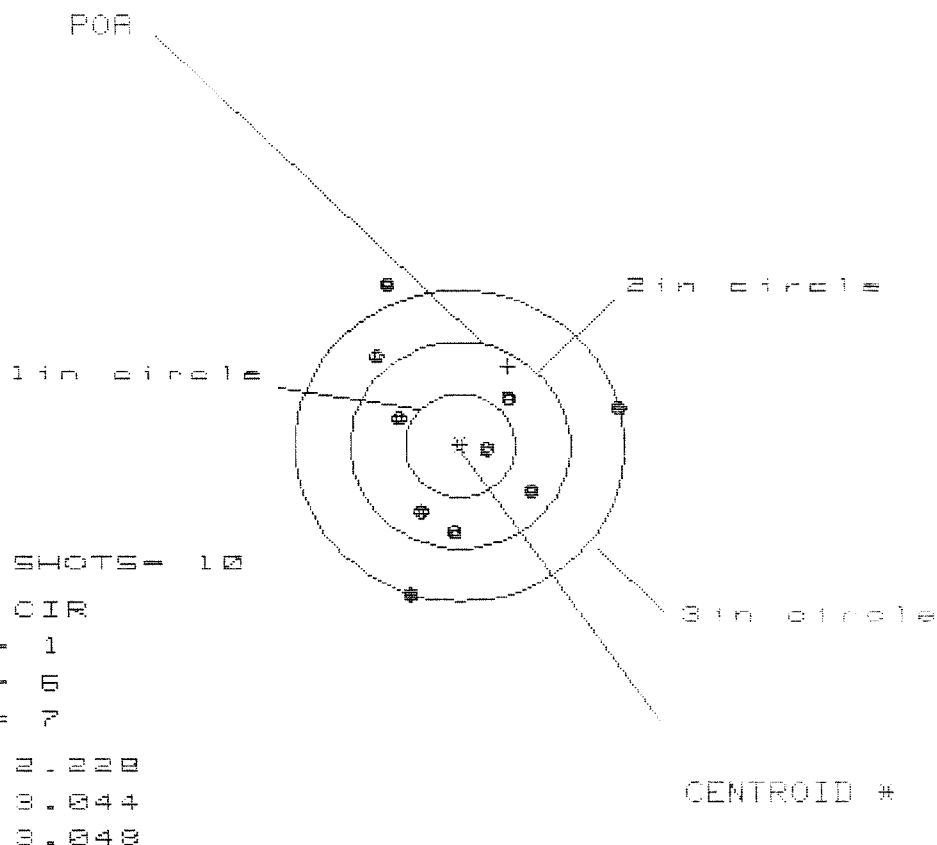
GS = 2.473

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.664	.672	.570
MINIMUM X	:	-.909	-.901	-1.003
MAXIMUM Y	:	1.032	.872	.764
MINIMUM Y	:	-1.436	-.866	-.625
CENTROID X	:	-.278	-.286	-.184
CENTROID Y	:	-1.014	-.854	-.746
POA TO CENTROID in.	:	1.051	.900	.768
MIN RADIUS	:	.236	.364	.225
MEAN RADIUS	:	.794	.714	.633
MAX RADIUS	:	1.438	1.189	1.006
HORIZONTAL SPREAD	:	1.573	1.573	1.573
VERTICAL SPREAD	:	2.468	1.738	1.389
EXTREME SPREAD	:	2.473	2.058	1.660
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/622555B

CENTERFIRE PATTERNS # 2

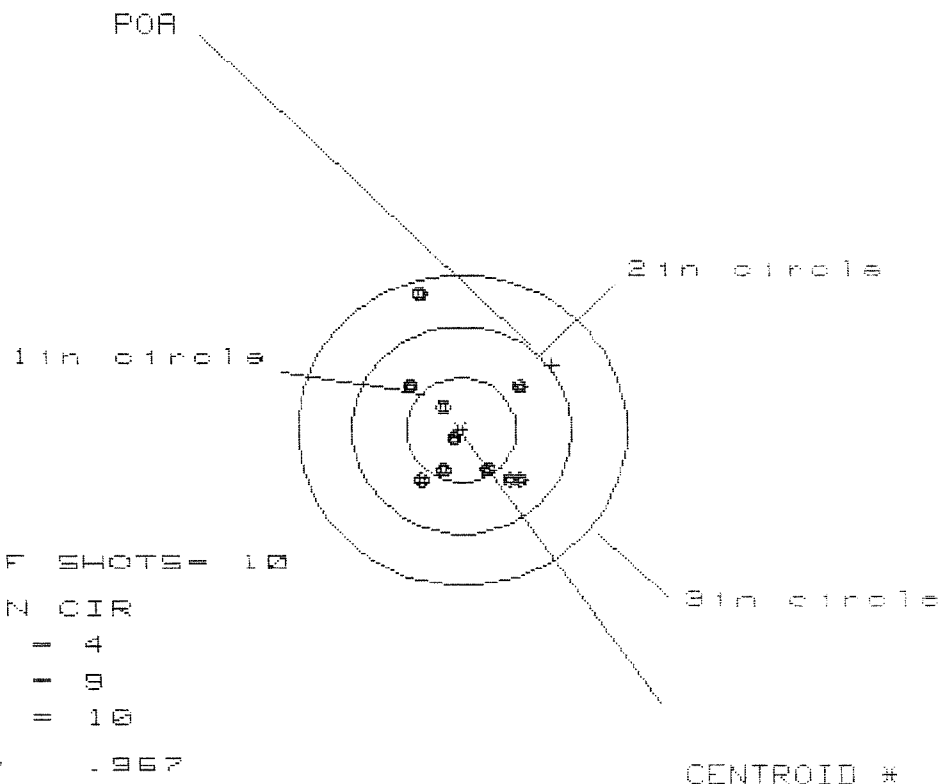


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.480	1.409	1.338
MINIMUM X	:	-.748	-.819	-.890
MAXIMUM Y	:	1.563	1.067	.903
MINIMUM Y	:	-1.481	-1.307	-.871
CENTROID X	:	-.443	-.372	-.301
CENTROID Y	:	-.764	-.938	-.774
POA TO CENTROID in.:	:	.883	1.008	.831
MIN RADIUS	:	.297	.252	.155
MEAN RADIUS	:	.993	.892	.814
MAX RADIUS	:	1.691	1.524	1.402
HORIZONTAL SPREAD	:	2.228	2.228	2.228
VERTICAL SPREAD	:	3.044	2.374	1.774
EXTREME SPREAD	:	3.048	2.732	2.280
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	7		

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225556

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 4

2in = 9

3in = 10

HS= .967

VS= 1.819

GS= 2.009

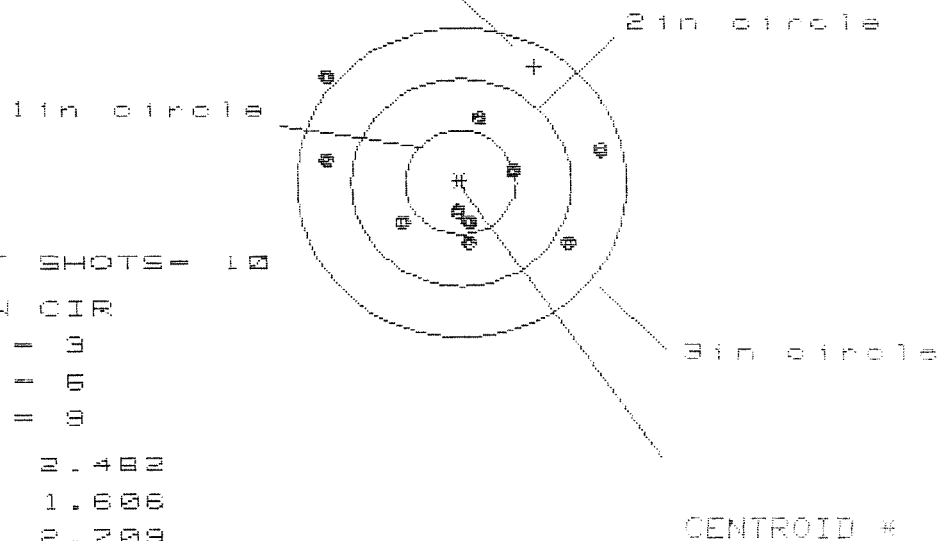
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.512	.474	.534
MINIMUM X	:	-.455	-.493	-.433
MAXIMUM Y	:	1.302	.523	.477
MINIMUM Y	:	-.517	-.373	-.345
CENTROID X	:	-.830	-.792	-.852
CENTROID Y	:	-.620	-.764	-.718
POA TO CENTROID in.	:	1.036	1.101	1.114
MIN RADIUS	:	.131	.177	.103
MEAN RADIUS	:	.525	.471	.444
MAX RADIUS	:	1.346	.716	.716
HORIZONTAL SPREAD	:	.967	.967	.967
VERTICAL SPREAD	:	1.819	.896	.822
EXTREME SPREAD	:	2.009	1.315	1.229
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/B825558

CENTERFIRE PATTERNS # 4

POA

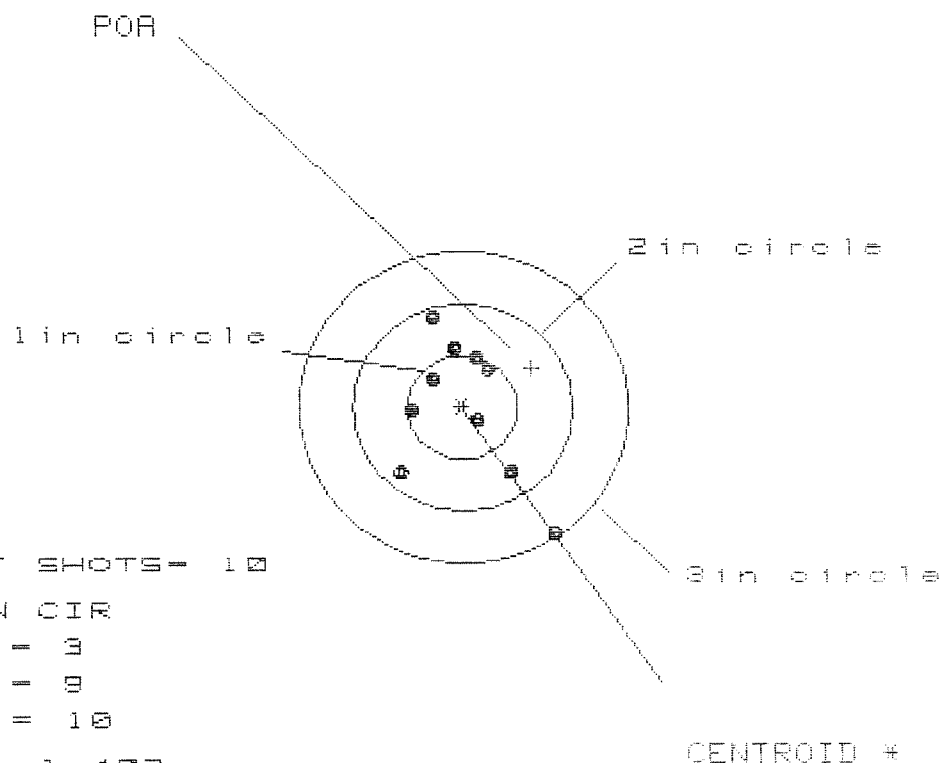


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.233	1.097	.924
MINIMUM X	:	-1.249	-1.385	-.833
MAXIMUM Y	:	.997	.710	.750
MINIMUM Y	:	-.609	-.498	-.458
CENTROID X	:	-.673	-.537	-.364
CENTROID Y	:	-1.121	-1.232	-1.272
POA TO CENTROID in.	:	1.308	1.344	1.323
MIN RADIUS	:	.238	.223	.311
MEAN RADIUS	:	.822	.703	.611
MAX RADIUS	:	1.577	1.421	1.019
HORIZONTAL SPREAD	:	2.482	2.482	1.757
VERTICAL SPREAD	:	1.606	1.208	1.208
EXTREME SPREAD	:	2.709	2.483	1.892
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/622555B

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.403

VS= 2.013

GS= 2.277

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.809	.509	.488
MINIMUM X	:	-.594	-.504	-.525
MAXIMUM Y	:	.838	.708	.582
MINIMUM Y	:	-1.175	-.760	-.672
CENTROID X	:	-.631	-.721	-.700
CENTROID Y	:	-.377	-.247	-.335
POR TO CENTROID in.	:	.735	.762	.776
MIN RADIUS	:	.182	.247	.263
MEAN RADIUS	:	.657	.544	.527
MAX RADIUS	:	1.426	.912	.853
HORIZONTAL SPREAD	:	1.403	1.013	1.013
VERTICAL SPREAD	:	2.013	1.468	1.254
EXTREME SPREAD	:	2.277	1.598	1.364
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	