

F02H

UPC



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C6649006

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARNEL LEWITT

MODEL 700 TM M24

ORDER NO. 5716

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6649006
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6649006

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MODEL 700 TM M24
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MODEL 700 TM M24
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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649006

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCD
	Magnaflux Bolt	OCT	3 1991	KCD
615	Rollmark Caliber	OCT	3 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	LS
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	JA
	Apply Coating (Bolt)			JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-11-91	JA

op. #	BARBER M24 0030552	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-11-91	SL
	G) Safety Off Force	4	4	4			11-11-91	SL-
	H) Trigger Pull Test & Retainability						11-11-91	SL
	I) Firing Pin Indent	.020	.0205	.0205			11-11-91	SL
	J) Assemble Stock						11/13/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/13/91	RW
	M) Iron Sight Alignment						11/13/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/13/91	RW
	O) Attach Scope to Rifle						11/13/91	RW
	P) Detach & Attach Scope 20 Times						11/13/91	RW
640	Gallery Target & Test						11-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-22-91	NF
655	Final Inspection A) Headspace						11-27-91	D/H
	B) Trigger Pull	297	298	300	300	300	11-26-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

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

SERIAL NO. C 6649006
DATE 11-11-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.42	2.45	297	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.27	2.47	298	
PULL #3	2.42	2.34	2.40	3.00	
PULL #4	2.34	2.46	2.44	3.00	
PULL #5	2.26	2.47	2.51	3.00	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.70	3.32		
PULL #2	3.61	3.42		
PULL #3	3.52	3.27		
PULL #4	3.42	3.27		
PULL #5	3.38	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.29		4.36
PULL #2	4.33	4.36		4.40
PULL #3	4.20	4.16		4.33
PULL #4	4.32	4.32		4.28
PULL #5	4.26	4.28		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649006
22 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.188743
1 TO	2	.275588
1 TO	3	.107782
1 TO	4	.103247
1 TO	5	.12478

§ <----POA

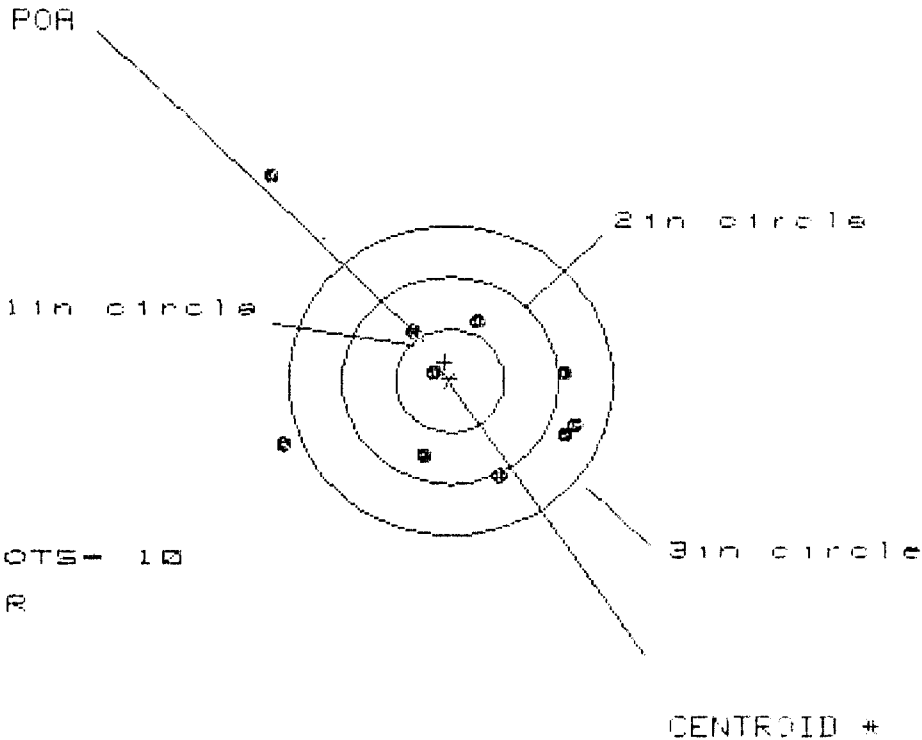
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0664
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .07611

THE AMR FOR THIS RIFLE IS: .9056

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649006

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

IS = 2.8009

VS = 2.9300

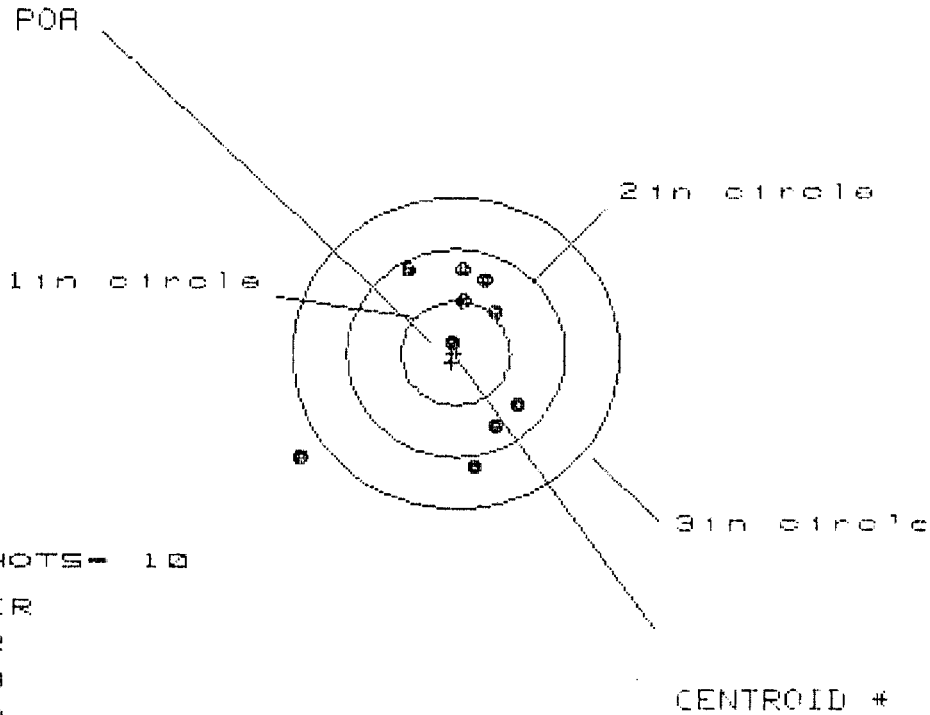
GS = 3.6802

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.183	1.002	.791
MINIMUM X	-1.626	-1.694	-1.700
MAXIMUM Y	1.975	.776	.729
MINIMUM Y	-.955	-.736	-.783
CENTROID X	.050	.231	.442
CENTROID Y	-.182	-.401	-.354
POA TO CENTROID in.	.188	.463	.566
MIN RADIUS	.159	.436	.587
MEAN RADIUS	1.078	.899	.773
MAX RADIUS	2.558	1.736	.979
HORIZONTAL SPREAD	2.809	2.696	1.491
VERTICAL SPREAD	2.930	1.512	1.512
EXTREME SPREAD	3.682	2.703	1.750
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

22 Nov 1991

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CENTERFIRE PATTERNS # 2

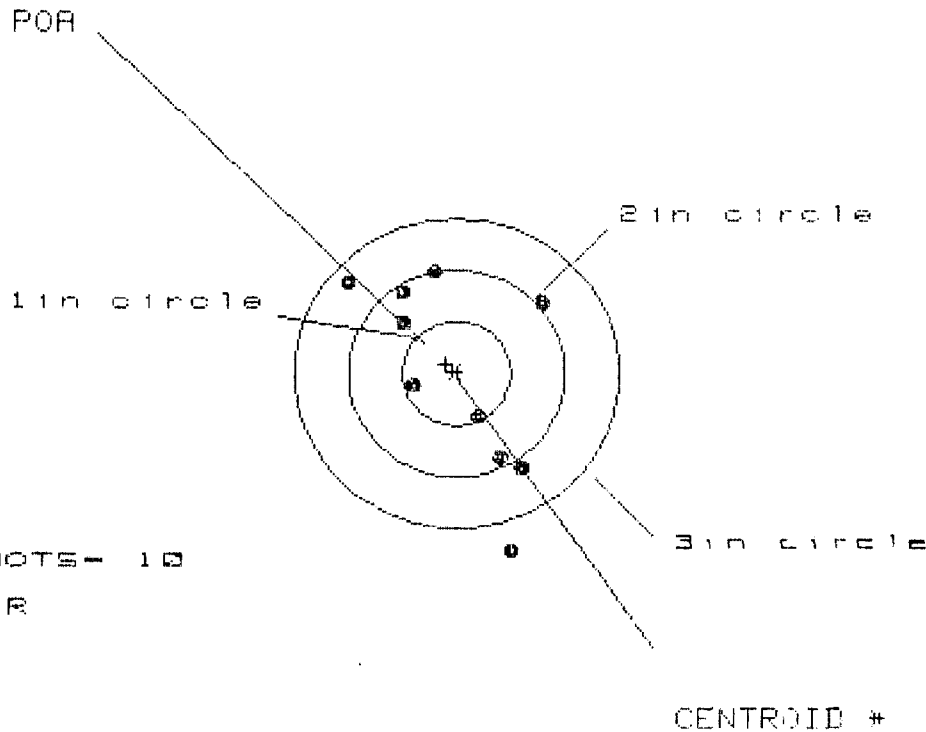


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.530	.367	.369
MINIMUM X	:	-1.470	-.580	-.578
MAXIMUM Y	:	.814	.701	.544
MINIMUM Y	:	-1.142	-1.255	-.919
CENTROID X	:	.032	.196	.194
CENTROID Y	:	.093	.206	.363
POA TO CENTROID in.	:	.098	.284	.411
MIN RADIUS	:	.076	.173	.223
MEAN RADIUS	:	.803	.654	.539
MAX RADIUS	:	1.789	1.255	.944
HORIZONTAL SPREAD	:	2.001	.947	.947
VERTICAL SPREAD	:	1.956	1.956	1.463
EXTREME SPREAD	:	2.447	2.036	1.655
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

22 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 1.844

VS = 2.703

GS = 2.887

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.845
MINIMUM X	-.999
MAXIMUM Y	1.008
MINIMUM Y	-1.695
CENTROID X	.099
CENTROID Y	-.086
POR TO CENTROID in.	.131
MIN RADIUS	.418
MEAN RADIUS	.976
MAX RADIUS	1.768
HORIZONTAL SPREAD	1.844
VERTICAL SPREAD	2.703
EXTREME SPREAD	2.997
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9

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FILE: /PATTERNING/CENTERFIRE_PATT/C6649086

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS = 2.278

VS = 3.209

GS = 3.215

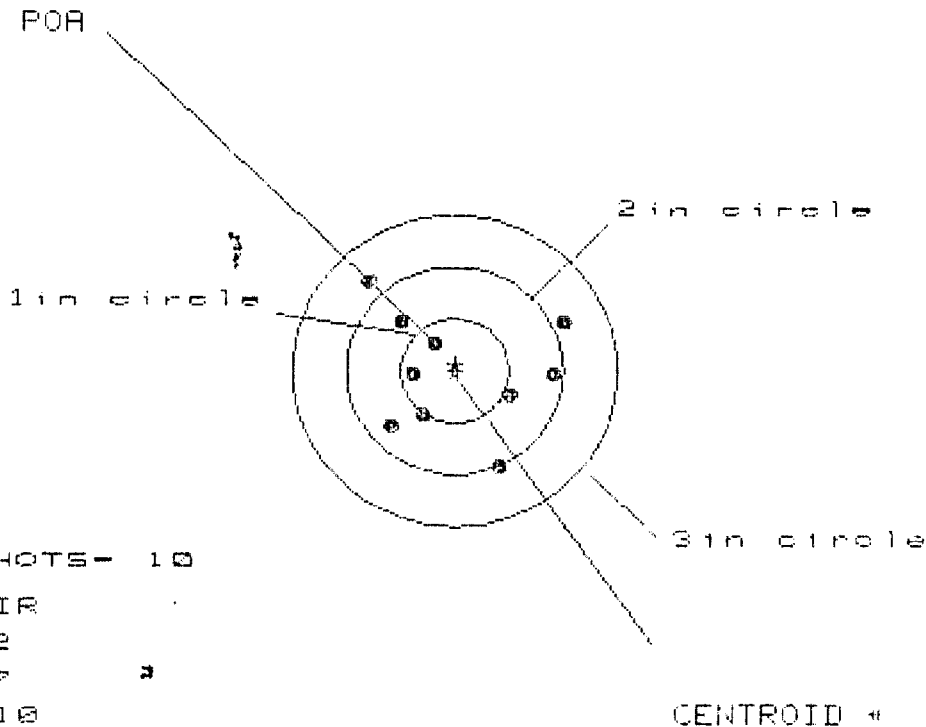
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.691	.691	.493
MINIMUM X	:	-1.587	-1.587	-.494
MAXIMUM Y	:	1.481	1.289	1.323
MINIMUM Y	:	-1.728	-1.287	-1.253
CENTROID X	:	.012	.012	.210
CENTROID Y	:	-.086	.106	.072
POA TO CENTROID in.	:	.087	.107	.222
MIN RADIUS	:	.079	.192	.132
MEAN RADIUS	:	.917	.803	.694
MAX RADIUS	:	1.728	1.610	1.323
HORIZONTAL SPREAD	:	2.278	2.278	.987
VERTICAL SPREAD	:	3.209	2.576	2.576
EXTREME SPREAD	:	3.215	2.577	2.577
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.776

VS = 1.815

GS = 2.170

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.023	.939	.931
MINIMUM X	:	-.753	-.701	-.584
MAXIMUM Y	:	.915	.571	.629
MINIMUM Y	:	-.900	-.799	-.727
CENTROID X	:	-.007	.077	-.040
CENTROID Y	:	-.071	-.172	-.244
POA TO CENTROID in.	:	.071	.189*	.247
MIN RADIUS	:	.360	.396	.400
MEAN RADIUS	:	.754	.704	.634
MAX RADIUS	:	1.185	1.099	.943
HORIZONTAL SPREAD	:	1.776	1.640	1.515
VERTICAL SPREAD	:	1.815	1.370	1.356
EXTREME SPREAD	:	2.170	1.895	1.662
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	