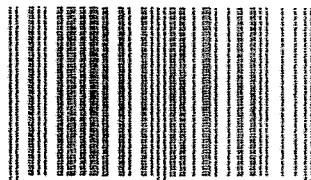


FORM

UPC



0 47700 25716 7

66648925

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

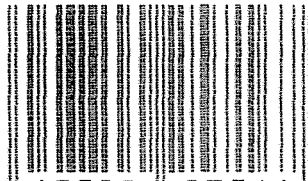
MODEL 700 TM M24

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6648925
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



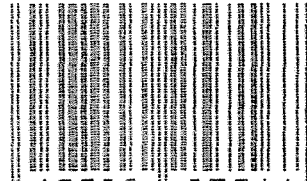
5716 C6648925

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648925

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2 9 1		Rw
600	Proof	7 2 9 1		Rw
607	Check Headspace	2 9 1		Rw
610	Dis-assemble Gun	8 2 8 1		Rw
612	Magnaflux Barrel Action		JUL 22 1991	JS
	Magnaflux Bolt		JUL 22 1991	JS
615	Rollmark Caliber		JUL 22 1991	JS
617	Drill and Tap Sight Holes		JUL 22 1991	WB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-23-91	JS
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/30/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/91	Rw
	C) Inspect Ejector Hole for Chamfer		8/30/91	Rw
	D) Oil Firing Pin Ass'y		8/30/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9-11-91	JS

op. #	BARBER - M24 0033401	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	JM
	G) Safety Off Force	3	3	3			9/11/91	JM
	H) Trigger Pull Test & Retainability						9/11/91	JM
	I) Firing Pin Indent	10225	1023	1023			9/11/91	JM
	J) Assemble Stock						10/7/91	RW
	K) Assemble Swivel Studs						10/14/91	JM
	L) Attach Front and Rear Sight Assemblies						10/7/91	RW
	M) Iron Sight Alignment						10/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/7/91	RW
	O) Attach Scope to Rifle						10/7/91	RW
	P) Detach & Attach Scope 20 Times						10/7/91	RW
640	Gallery Target & Test						10-10-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-10-91	NF
655	Final Inspection							
	A) Headspace						10/14/91	JM
	B) Trigger Pull	2.22	2.35	2.32	2.36	2.34	10/14/91	JM
	C) Function						10/14/91	JM
660	Pack						12-17-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6648925

DATE 9-11-91

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.36	2.38	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.32	2.40	2.35	
PULL #3	2.43	2.34	2.45	2.32	
PULL #4	2.25	2.33	2.49	2.36	
PULL #5	2.33	2.30	2.33	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.43		
PULL #2	3.48	3.45		
PULL #3	3.44	3.53		
PULL #4	3.55	3.50		
PULL #5	3.50	3.58		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.59		4.41
PULL #2	4.46	4.69		4.54
PULL #3	4.37	4.50		4.47
PULL #4	4.40	4.59		4.38
PULL #5	4.41	4.56		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648925
10 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.263919
1 TO 2	.119067
1 TO 3	.657036
1 TO 4	.550956
1 TO 5	.466247

25
47 (----POB

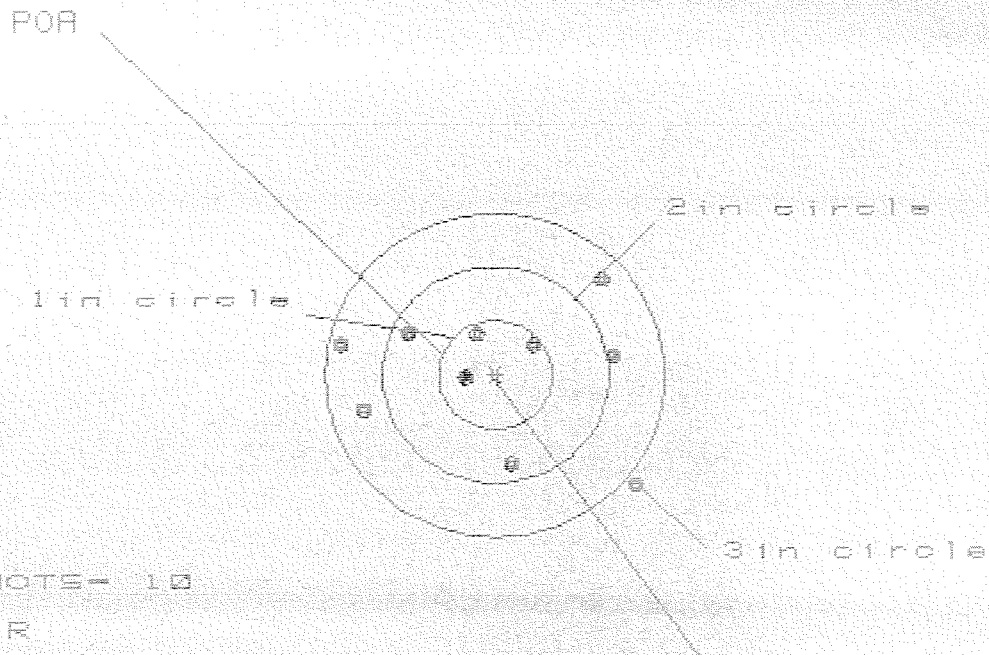
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0514
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1444
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153275
THE AMR FOR THIS RIFLE IS: 1.041

18 Oct 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8648925

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.517

VS= 1.965

GS= 2.850

CENTROID *

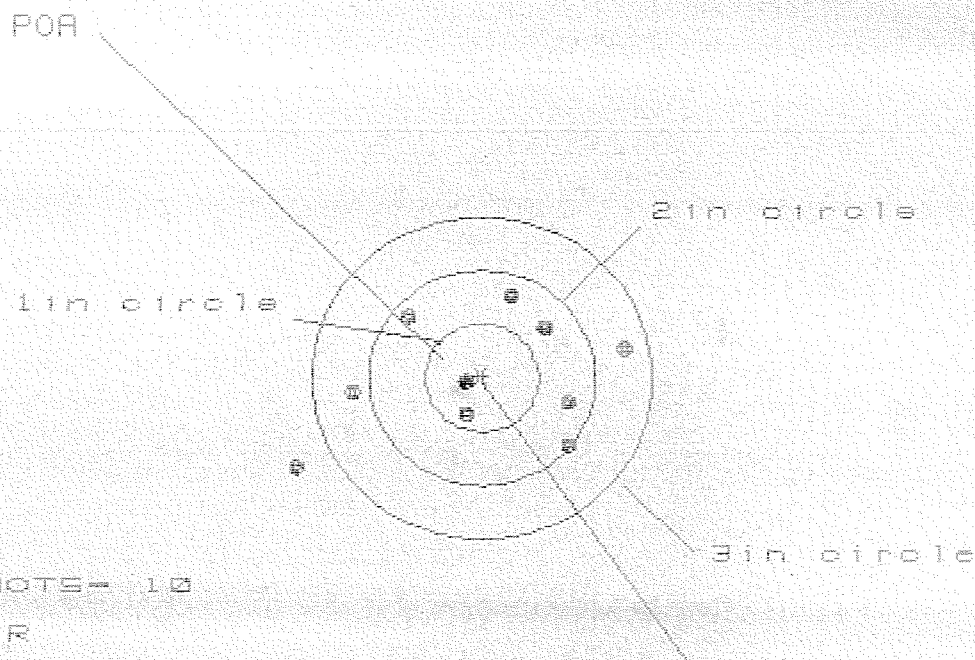
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.203	1.210	1.063
MINIMUM X	-1.314	-1.181	-1.187
MAXIMUM Y	.899	.781	.800
MINIMUM Y	-1.066	-.964	-.945
CENTROID X	.263	.130	.277
CENTROID Y	.022	.140	.121
POA TO CENTROID in.	.264	.191	.303
MIN RADIUS	.303	.245	.309
MEAN RADIUS	.944	.841	.801
MAX RADIUS	1.607	1.327	1.276
HORIZONTAL SPREAD	2.517	2.391	2.250
VERTICAL SPREAD	1.965	1.745	1.745
EXTREME SPREAD	2.850	2.464	2.464
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C684B925

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.960

VS= 1.651

GS= 3.156

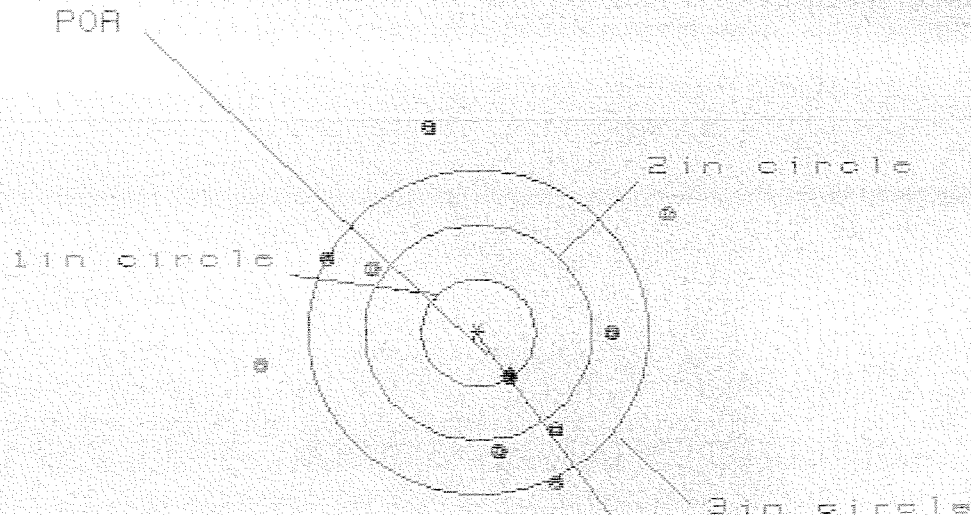
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.274	1.086	.731
MINIMUM X	-1.686	-1.337	-1.201
MAXIMUM Y	.885	.711	.731
MINIMUM Y	-.846	-.722	-.702
CENTROID X	.144	.331	.195
CENTROID Y	.026	.120	.100
POA TO CENTROID in.	.146	.352	.219
MIN RADIUS	.110	.315	.183
MEAN RADIUS	.902	.785	.733
MAX RADIUS	1.887	1.352	1.215
HORIZONTAL SPREAD	2.960	2.423	1.932
VERTICAL SPREAD	1.651	1.433	1.433
EXTREME SPREAD	3.156	2.450	1.976
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B48925

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 5

HS= 3.633

VS= 3.322

GS= 3.897

CENTROID *

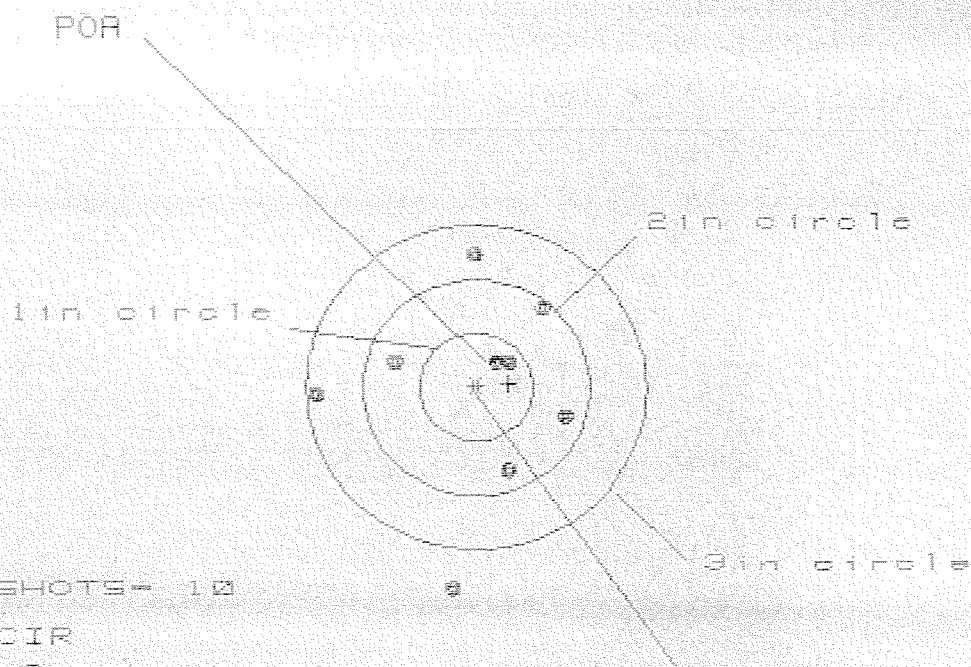
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.665	1.446	1.147
MINIMUM X	-1.968	-1.591	-1.410
MAXIMUM Y	1.871	1.834	1.964
MINIMUM Y	-1.451	-1.488	-1.358
CENTROID X	-.273	-.054	-.235
CENTROID Y	.482	.439	.309
POA TO CENTROID in.	.486	.442	.389
MIN RADIUS	.510	.448	.415
MEAN RADIUS	1.405	1.318	1.238
MAX RADIUS	1.996	1.933	2.010
HORIZONTAL SPREAD	3.633	3.037	2.557
VERTICAL SPREAD	3.322	3.322	3.322
EXTREME SPREAD	3.897	3.491	3.491
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		1	
NUMBER IN THREE INCH CIRCLE =		5	

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0864B925

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.248

VS= 3.046

GS= 3.054

CENTROID #

PATTERN #	4	5	6
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.820	.795	.613
MINIMUM X	-1.428	-1.453	-1.897
MAXIMUM Y	1.187	.981	.950
MINIMUM Y	-1.859	-.984	-1.015
CENTROID X	-.285	-.260	-.078
CENTROID Y	-.035	.171	.202
POA TO CENTROID in.	.287	.311	.217
MIN RADIUS	.285	.148	.006
MEAN RADIUS	.881	.714	.546
MAX RADIUS	1.872	1.474	1.018
HORIZONTAL SPREAD	2.248	2.248	1.500
VERTICAL SPREAD	3.046	1.965	1.965
EXTREME SPREAD	3.054	2.256	1.997
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

10 Oct 1991

FILE://PATTERNING/CENTERFIRE_PATT/C864B925

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 3.884

VS= 2.822

GS= 4.605

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.582	1.326	1.000
MINIMUM X	-2.302	-1.537	-1.371
MAXIMUM Y	1.369	1.208	1.315
MINIMUM Y	-1.453	-1.762	-1.655
CENTROID X	-1.106	.150	-.016
CENTROID Y	.307	.468	.361
POA TO CENTROID in.	.325	.492	.361
MIN RADIUS	.131	.399	.213
MEAN RADIUS	1.075	.887	.769
MAX RADIUS	2.722	1.954	1.900
HORIZONTAL SPREAD	3.884	2.863	2.371
VERTICAL SPREAD	2.822	1.970	1.970
EXTREME SPREAD	4.605	2.884	2.630
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		