

C6611712

MODEL 700TM M24

Model 5115 TM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



nagletj	4/21/2003	3:39 PM	CAPS	NUM	INS	SCPL
start	2 Micro	2 Micro	Arms Ser...	Part Ser...	Google Se	Create P...

Serial Number: C6611712

Model: 700



RE00064644

R & E NUMBER	C04644		
SERIAL NUMBER	C601712		
LOG-IN DATE	4-21-03		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	4-22-03	RTL
560 A	RE-BARREL	4-23-03	RTL
B	DRILL AND TAP	4-23-03	TRW
575	ASSEMBLE	4-23-03	RTL
600	PROOF	4-23-03	AC
605	CHECK HEADSPACE	4-23-03	AC
610	DIS-ASSEMBLE GUN	4-23-03	
612	MAGNAFLUX OPERATOR		
615	ROLLMARK CALIBER	4-23-03	RTL
618	ROTO-BLAST	4-24-03	DG
620	APPLY COATINGS	5-3-03	TA
625 A	FINAL ASSEMBLY	5-5-03	RW
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	5-6-03	AC
655	FINAL INSPECT	5-9-03	RTL
660	PACK	5-9-03	DA
		SHIP DATE	
QAR INSPECTION DATE			

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611712.___0
FILE DATE AND TIME: 05/06/2003 23:37

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.043
The Average Y Centroid of the Five Target Set:	0.007
The Average Point of Impact of the Five Target Set:	0.044
The Average Mean Radius of the Five Target Set:	0.784
The Distance from POA to Centroid Target #1:	0.050
The Distance from Centroid Target #2 to Centroid Target #1:	0.035
The Distance from Centroid Target #3 to Centroid Target #1:	0.169
The Distance from Centroid Target #4 to Centroid Target #1:	0.145
The Distance from Centroid Target #5 to Centroid Target #1:	0.153

SERIAL NUMBER: C6611712. 0

TARGET NUMBER: 1

FILE DATE: 05/06/2003

FILE TIME: 23:37

X CENTROID: -0.049

Y CENTROID: -0.010

POA TO CENTROID: 0.050

HORZ SPREAD: 2.391

VERT SPREAD: 2.601

GROUP SPREAD: 3.048

MIN RADIUS: 0.103

MAX RADIUS: 1.632

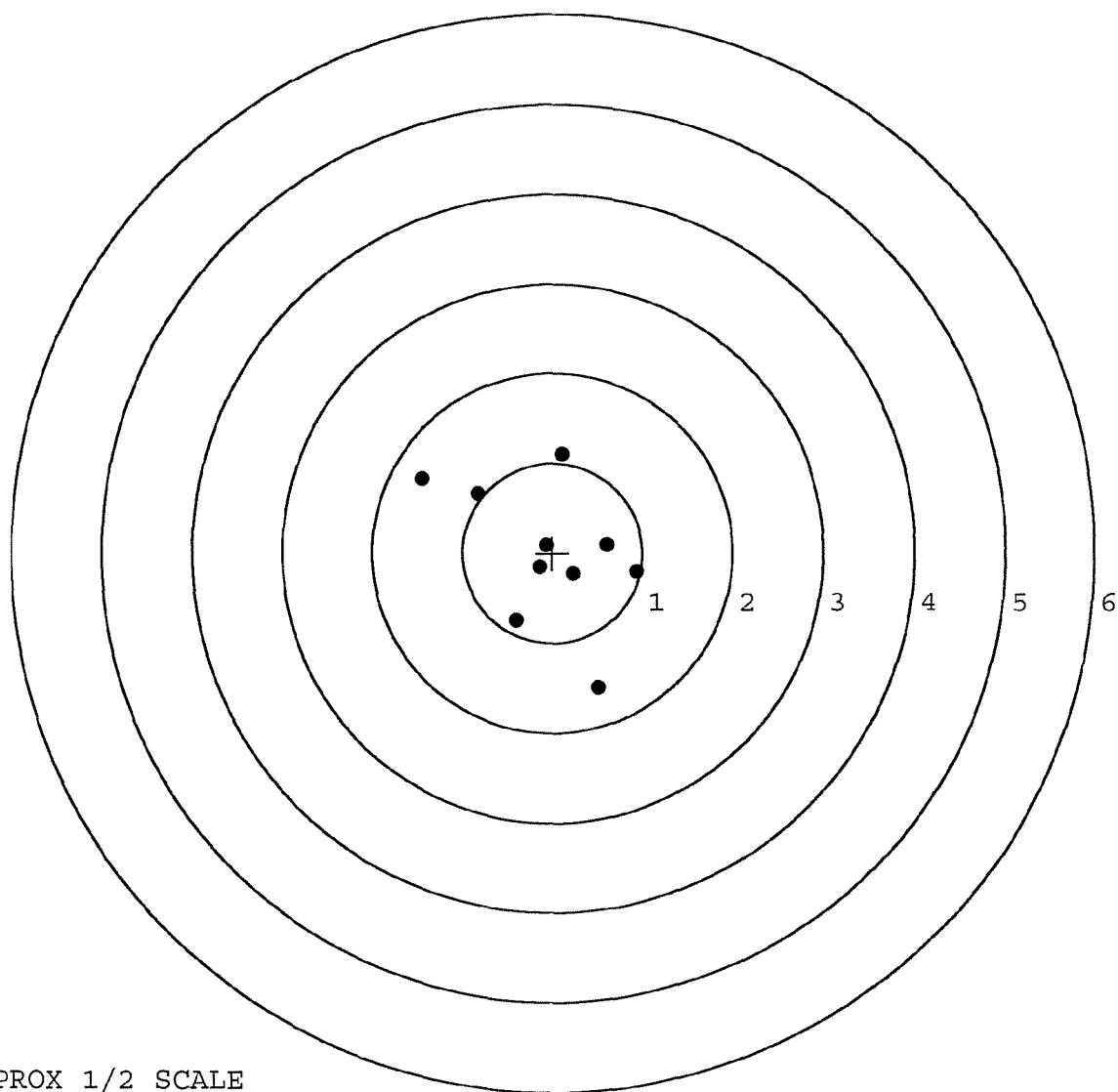
MEAN RADIUS: 0.851

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.517	-1.501
2:	-0.401	-0.755
3:	0.940	-0.211
4:	0.608	0.093
5:	0.230	-0.237
6:	-0.144	-0.160
7:	-0.068	0.091
8:	0.105	1.100
9:	-0.829	0.655
10:	-1.451	0.826



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611712. __ 0

TARGET NUMBER: 2

FILE DATE: 05/06/2003

FILE TIME: 23:37

POINT#	X	Y
1:	1.459	-0.419
2:	0.618	-0.330
3:	0.847	0.238
4:	0.264	-0.152
5:	-0.032	-0.009
6:	0.313	0.456
7:	0.113	0.745
8:	-0.722	-0.478
9:	-0.998	-0.567
10:	-2.058	0.224

X CENTROID: -0.020

Y CENTROID: -0.029

POA TO CENTROID: 0.035

HORZ SPREAD: 3.517

VERT SPREAD: 1.312

GROUP SPREAD: 3.575

MIN RADIUS: 0.024

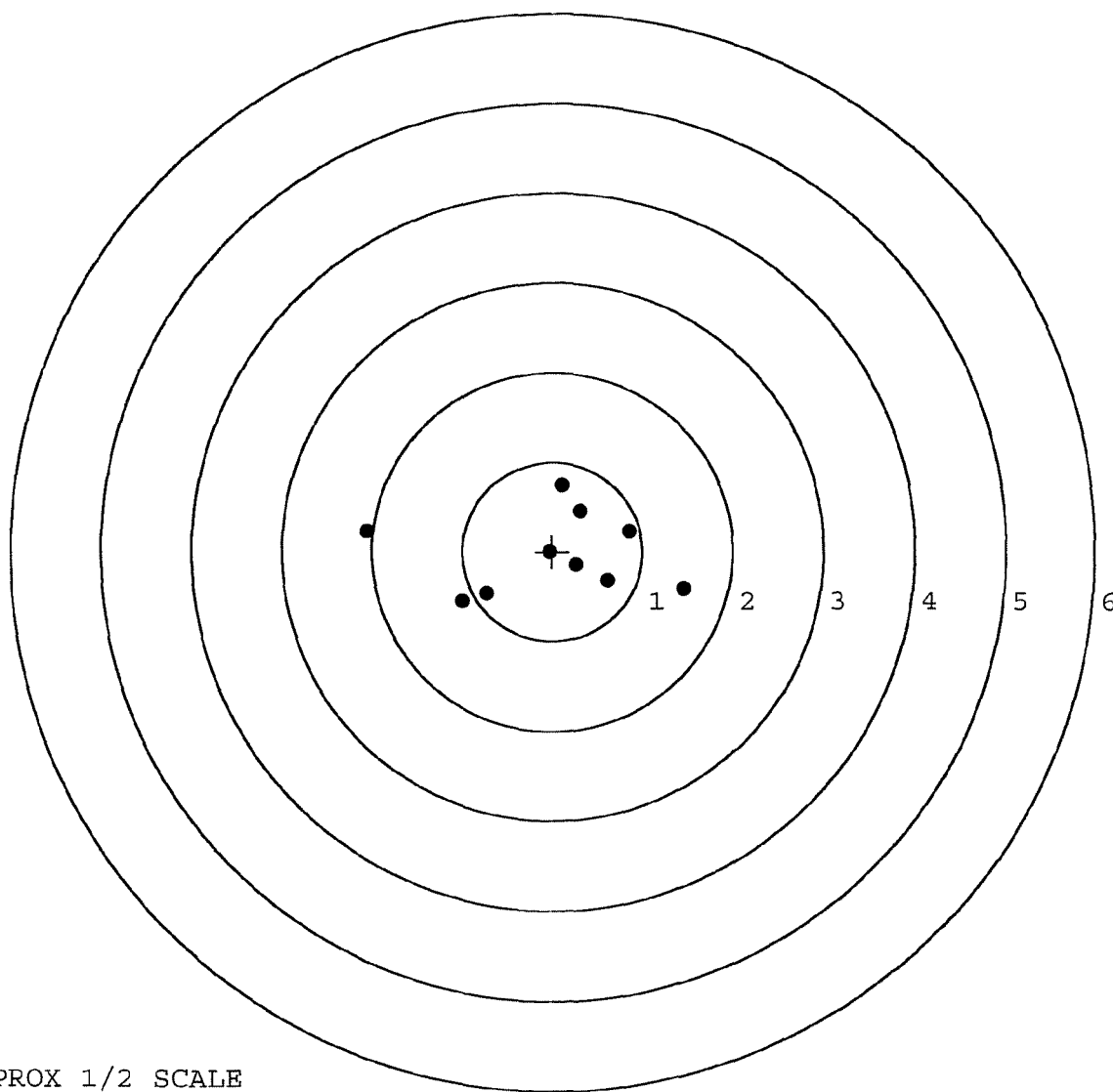
MAX RADIUS: 2.054

MEAN RADIUS: 0.885

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

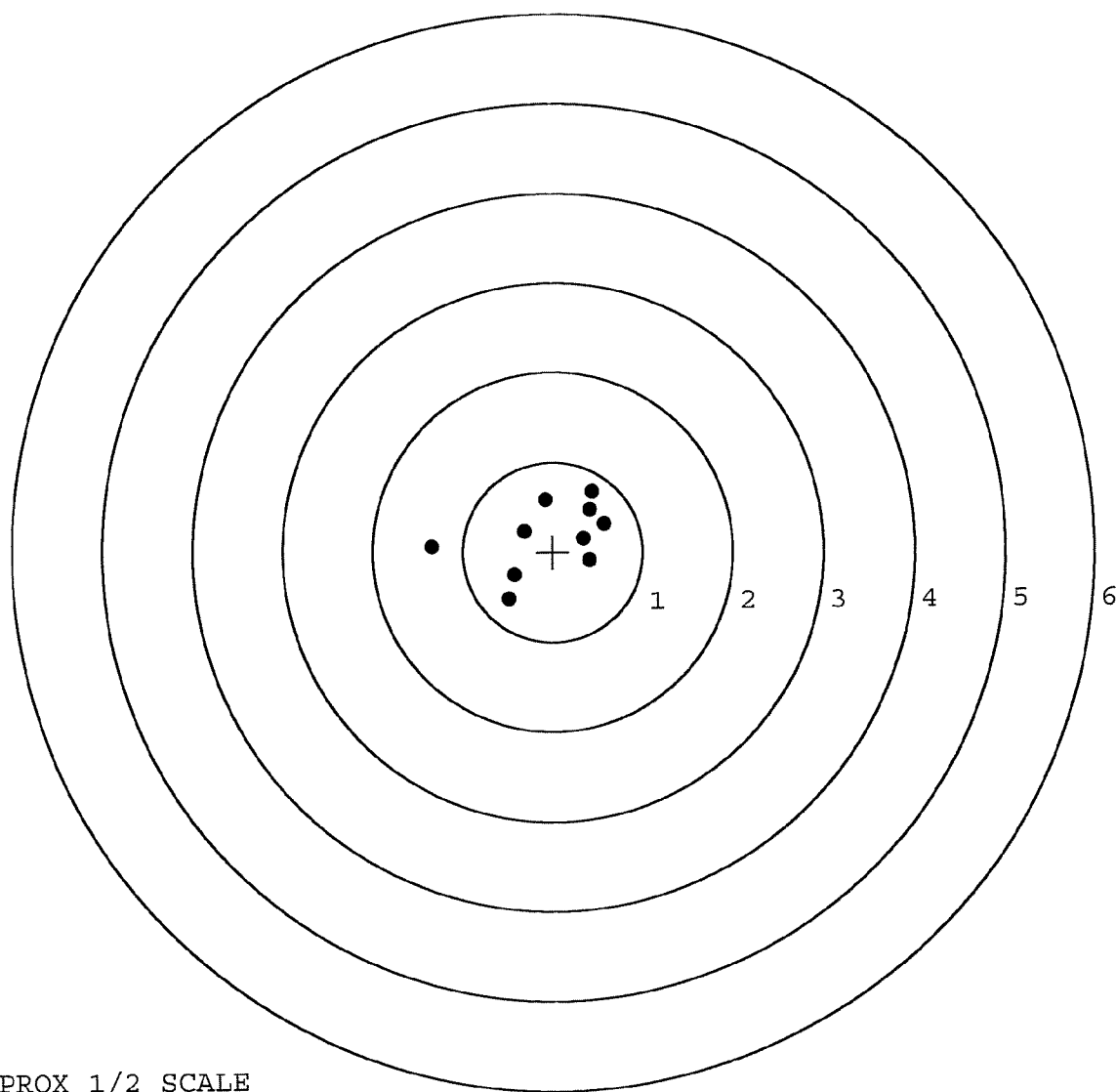


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611712. 0
 TARGET NUMBER: 3
 FILE DATE: 05/06/2003
 FILE TIME: 23:37

POINT#	X	Y
1:	-0.488	-0.524
2:	-0.432	-0.259
3:	-0.315	0.227
4:	-1.340	0.065
5:	-0.086	0.583
6:	0.441	0.668
7:	0.414	0.468
8:	0.578	0.308
9:	0.343	0.151
10:	0.408	-0.097

X CENTROID: -0.048
 Y CENTROID: 0.159
 POA TO CENTROID: 0.166
 HORZ SPREAD: 1.918
 VERT SPREAD: 1.192
 GROUP SPREAD: 1.933
 MIN RADIUS: 0.276
 MAX RADIUS: 1.296
 MEAN RADIUS: 0.620
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

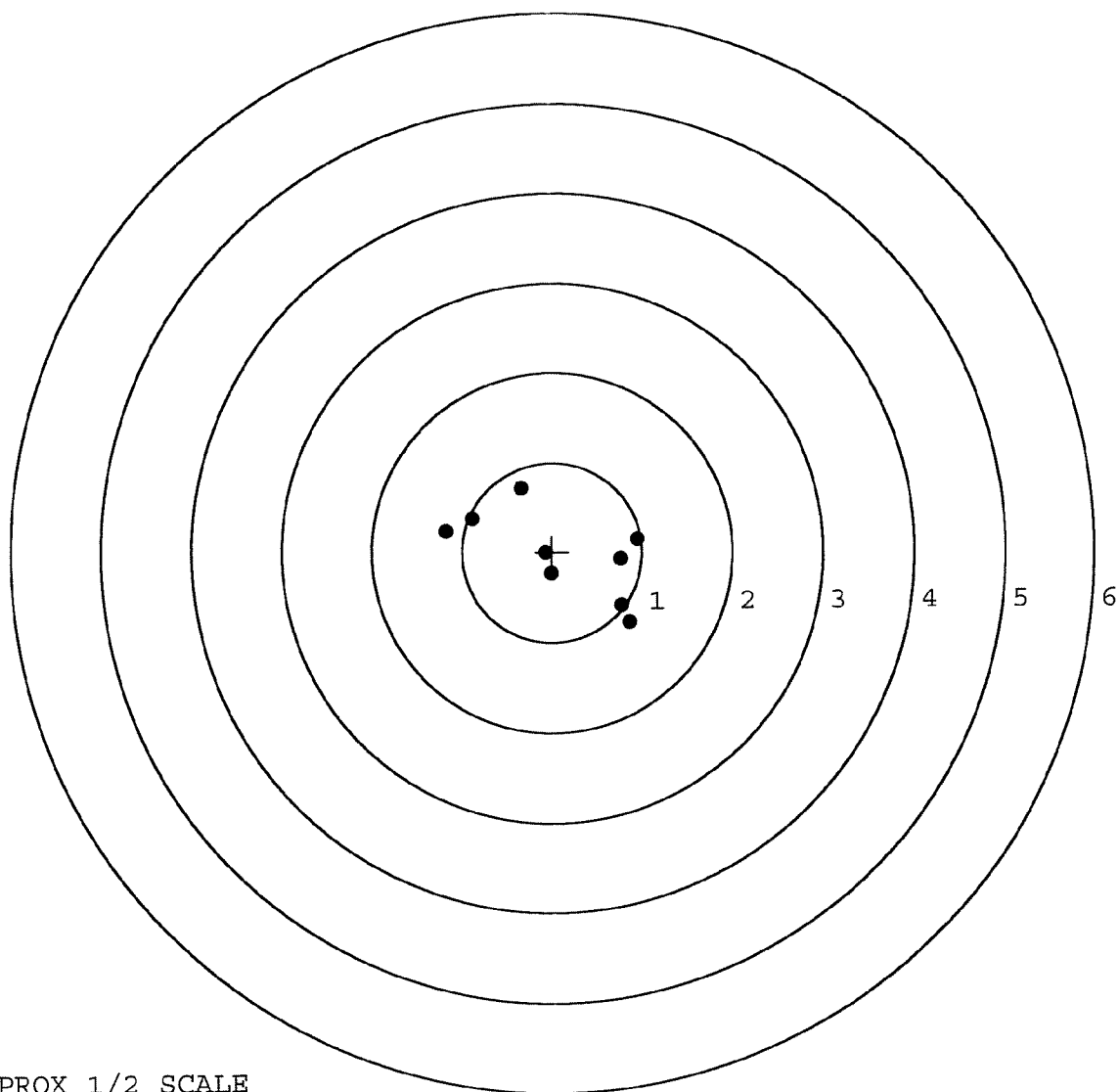


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611712. 0
 TARGET NUMBER: 4
 FILE DATE: 05/06/2003
 FILE TIME: 23:37

POINT#	X	Y
1:	-0.008	-0.240
2:	-0.076	-0.010
3:	0.951	0.144
4:	0.763	-0.081
5:	0.769	-0.598
6:	0.856	-0.782
7:	-0.340	0.716
8:	-0.882	0.377
9:	-1.177	0.236

X CENTROID: 0.095
 Y CENTROID: -0.026
 POA TO CENTROID: 0.099
 HORZ SPREAD: 2.128
 VERT SPREAD: 1.498
 GROUP SPREAD: 2.274
 MIN RADIUS: 0.172
 MAX RADIUS: 1.299
 MEAN RADIUS: 0.792
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611712. 0

TARGET NUMBER: 5

FILE DATE: 05/06/2003

FILE TIME: 23:37

X CENTROID: -0.194

Y CENTROID: -0.058

POA TO CENTROID: 0.203

HORZ SPREAD: 1.374

VERT SPREAD: 2.461

GROUP SPREAD: 2.468

MIN RADIUS: 0.379

MAX RADIUS: 1.255

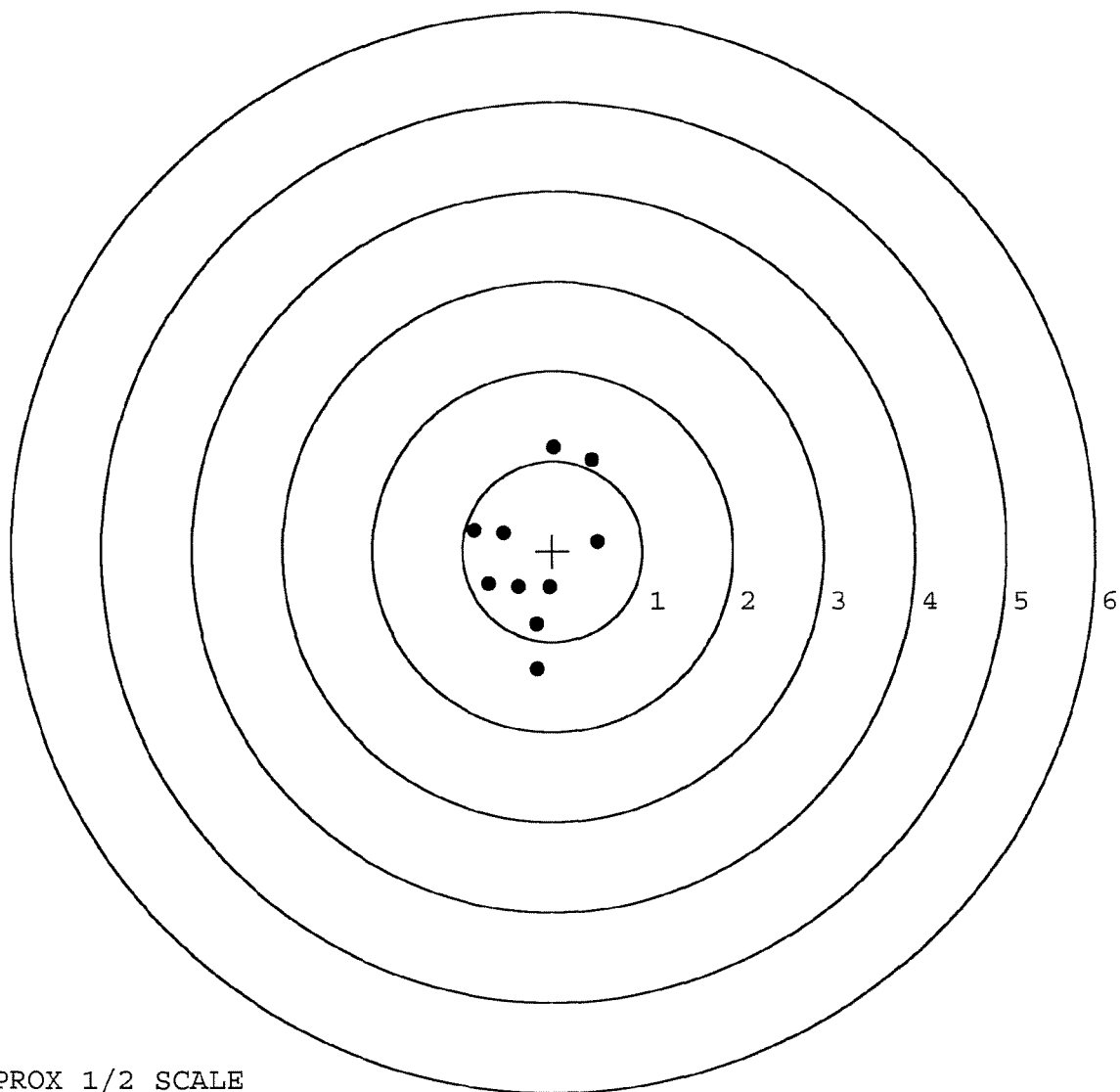
MEAN RADIUS: 0.773

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.170	-1.312
2:	-0.185	-0.810
3:	-0.037	-0.403
4:	-0.386	-0.395
5:	-0.708	-0.364
6:	-0.545	0.203
7:	-0.871	0.231
8:	0.503	0.109
9:	0.439	1.016
10:	0.018	1.149



TARGET APPROX 1/2 SCALE



MODEL 700TM M24

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

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

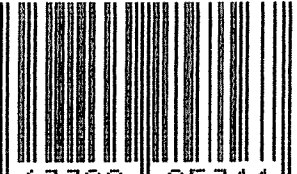
SERIAL NO.	C6611712
ORDER NO.	5716

46



5716 C6611712

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611712

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 28	9 1	Rw
600	Proof	3 28	9 1	Rw
607	Check Headspace	3 23	9 1	Rw
610	Dis-assemble Gun	3 23	9 1	Rw
612	Magnaflux Barrel Action	APR	2 1991	KR
	Magnaflux Bolt	APR	2 1991	V
615	Rollmark Caliber	APR	2 1991	SL
617	Drill and Tap Sight Holes	APR	5 1991	LB
618	Polish Barrel	APR	5 1991	WB
620	Apply Coatings (Barrel Action)		4-9-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	Rw
	C) Inspect Ejector Hole for Chamfer		4/10/91	Rw
	D) Oil Firing Pin Ass'y		4/10/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		4/22/91	JA

op. #	BARBER - M24 0034661 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			4-22-91	DH
	G) Safety Off Force	4	4	4			4-22-91	DH
	H) Trigger Pull Test & Retainability						4/22/91	JP
	I) Firing Pin Indent	.022	.022	.021			4-22-91	DH
	J) Assemble Stock						4/23/91	RW
	K) Assemble Swivel Studs						5-2-91	DH
	L) Attach Front and Rear Sight Assemblies						4/23/91	RW
	M) Iron Sight Alignment						4/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/23/91	RW
	O) Attach Scope to Rifle						4/23/91	RW
	P) Detach & Attach Scope 20 Times						4/23/91	RW
640	Gallery Target & Test						4-24-91	AC
	A) Time						4-24-91	AC
	B) Malfunctions						4-24-91	AC
	C) Pierced Primers						4-24-91	AC
	D) Optical Clarity of Scope						4-24-91	AC
645	Inspect for Live Ammo						4-24-91	AC
655	Final Inspection							
	A) Headspace						5-2-91	DH
	B) Trigger Pull	2.43	2.51	2.57	2.50	2.59	4/26/91	JP
	C) Function						5-2-91	DH
660	Pack						6-15-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611712

DATE 4/22/91

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.34	2.51	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.21	2.50	2.51	
PULL #3	2.54	2.47	2.49	2.57	
PULL #4	2.56	2.56	2.48	2.50	
PULL #5	2.57	2.58	2.50	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.56		
PULL #2	3.65	3.51		
PULL #3	3.35	3.45		
PULL #4	3.49	3.22		
PULL #5	3.19	3.54		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.57	4.50		4.42
PULL #2	4.55	4.33		4.13
PULL #3	4.55	4.58		4.27
PULL #4	4.50	4.28		4.40
PULL #5	4.42	4.24		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611712
24 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.583342
1 TO	2	.42916
1 TO	3	.578627
1 TO	4	.724278
1 TO	5	.540201

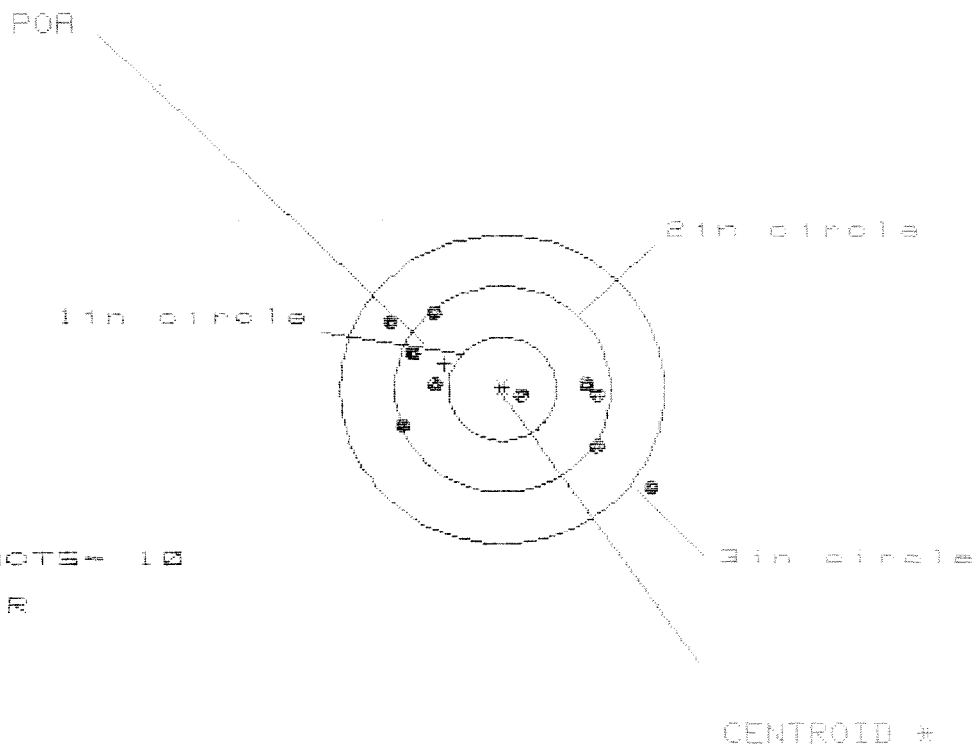
$\begin{matrix} 3 & 4 \\ 1 & 2 \end{matrix}$
 $\leftarrow$ ---- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5044
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0156
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .504641
 THE AMR FOR THIS RIFLE IS: 1.045

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611712

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 9

HS = 2.401

VS = 1.709

GS = 2.855

PATTERN #

1

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.376	.991	.882
MINIMUM X	:	-1.025	-.872	-.882
MAXIMUM Y	:	.789	.687	.752
MINIMUM Y	:	-.920	-.664	-.599
CENTROID X	:	.528	.375	.484
CENTROID Y	:	-.248	-.146	-.211
POA TO CENTROID in.	:	.584	.403	.528
MIN RADIUS	:	.203	.300	.255
MEAN RADIUS	:	.925	.892	.802
MAX RADIUS	:	1.655	1.193	1.066
HORIZONTAL SPREAD	:	2.401	1.863	1.764
VERTICAL SPREAD	:	1.709	1.351	1.351
EXTREME SPREAD	:	2.855	2.268	1.960
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	9		

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611712

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.191

VS = 3.401

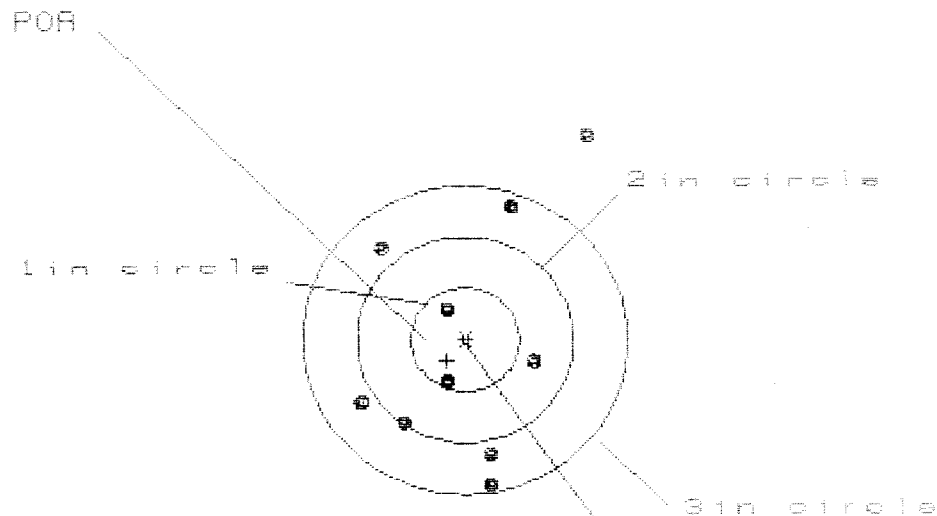
GS = 4.046

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.108	.988	1.110
MINIMUM X	-1.083	-1.185	-1.062
MAXIMUM Y	1.225	.983	1.007
MINIMUM Y	-2.176	-.839	-.716
CENTROID X	.691	.811	.688
CENTROID Y	-.645	-.403	-.526
POR TO CENTROID in.	.945	.906	.866
MIN RADIUS	.565	.569	.631
MEAN RADIUS	1.084	.922	.845
MAX RADIUS	2.431	1.394	1.196
HORIZONTAL SPREAD	2.191	2.173	2.172
VERTICAL SPREAD	3.401	1.822	1.723
EXTREME SPREAD	4.046	2.356	2.265
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611712

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.046

VS = 3.344

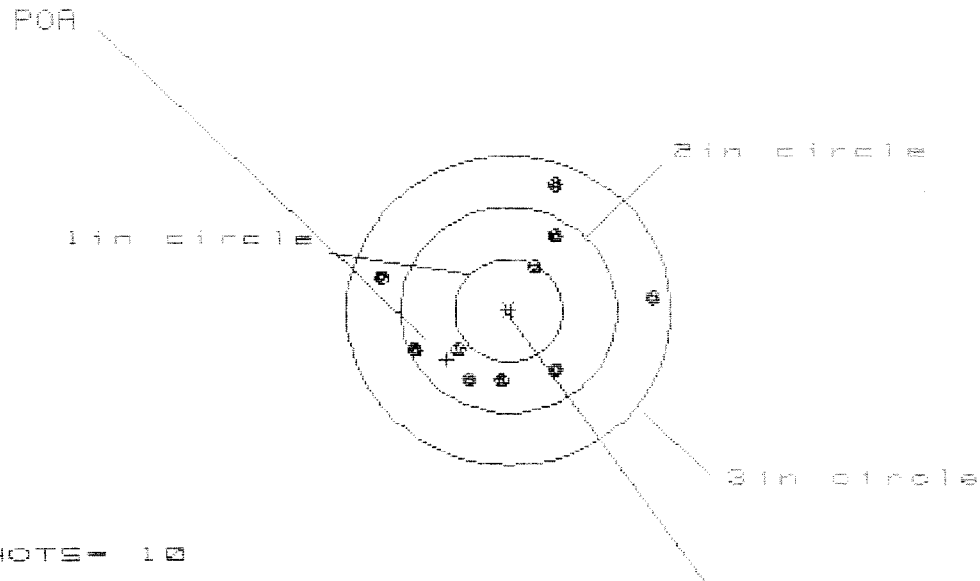
GS = 3.461

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.083
MINIMUM X	-0.963
MAXIMUM Y	1.961
MINIMUM Y	-1.383
CENTROID X	.168
CENTROID Y	.205
POA TO CENTROID in.	.265
MIN RADIUS	.319
MEAN RADIUS	1.097
MAX RADIUS	2.241
HORIZONTAL SPREAD	2.046
VERTICAL SPREAD	3.344
EXTREME SPREAD	3.461
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	4
NUMBER IN THREE INCH CIRCLE	8

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11712

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.467

VS = 1.931

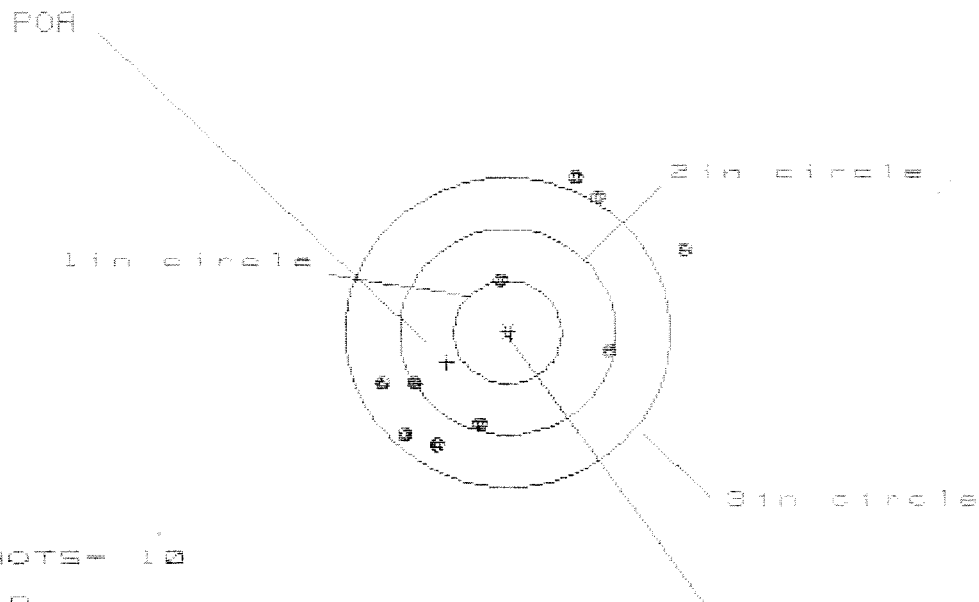
GS = 2.476

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.343	.616	.692
MINIMUM X	:	-1.124	-.975	-.899
MAXIMUM Y	:	1.216	1.230	.865
MINIMUM Y	:	-.714	-.701	-.547
CENTROID X	:	.571	.422	.346
CENTROID Y	:	.475	.462	.306
POA TO CENTROID in.	:	.743	.626	.463
MIN RADIUS	:	.515	.496	.327
MEAN RADIUS	:	.897	.834	.726
MAX RADIUS	:	1.348	1.373	1.108
HORIZONTAL SPREAD	:	2.467	1.591	1.591
VERTICAL SPREAD	:	1.931	1.931	1.413
EXTREME SPREAD	:	2.476	2.129	1.782
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB11712

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.782

VS= 2.546

GS= 3.118

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.586	1.131	1.230
MINIMUM X	-1.196	-1.020	-0.921
MAXIMUM Y	1.470	1.565	1.558
MINIMUM Y	-1.076	-0.981	-0.786
CENTROID X	.564	.388	.289
CENTROID Y	.291	.196	.001
POA TO CENTROID in.	.635	.435	.289
MIN RADIUS	.587	.594	.604
MEAN RADIUS	1.224	1.127	.996
MAX RADIUS	1.801	1.754	1.932
HORIZONTAL SPREAD	2.782	2.151	2.151
VERTICAL SPREAD	2.546	2.546	2.343
EXTREME SPREAD	3.118	2.903	2.884
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		