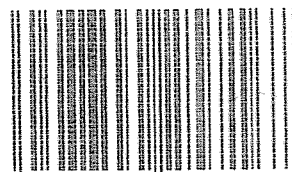


FROM

UPC



0 47700 25716 7

06649185

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

ORDER NO. 5716

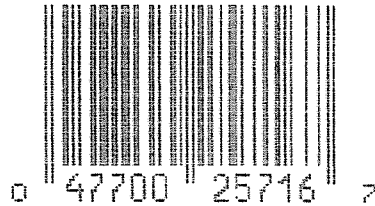
MODEL 700 TM M24

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6649186
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



5716 C6649186

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 # C6649186

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	Rev
600	Proof	10 1	91	Rev
607	Check Headspace	1	91	Rev
610	Dis-assemble Gun	10 1	91	Rev
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	GL
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-2-91	HA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	Rev
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	Rev
	C) Inspect Ejector Hole for Chamfer		11/11/91	Rev
	D) Oil Firing Pin Ass'y		11/11/91	Rev
	E) Adjust Trigger Pull to Min Setting and Stake		12-7-91	GM

op. #	BARBER M24 0065961	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	4	4			12-7-91	AC
	G) Safety Off Force	2	2	2			12-7-91	AC
	H) Trigger Pull Test & Retainability						12-7-91	JK
	I) Firing Pin Indent	.021	.021	.020			12-7-91	AC
	J) Assemble Stock						12/2/91	RW
	K) Assemble Swivel Studs						12/13/91	JK
	L) Attach Front and Rear Sight Assemblies						12/7/91	RW
	M) Iron Sight Alignment						12/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/7/91	RW
	O) Attach Scope to Rifle						12/7/91	RW
	P) Detach & Attach Scope 20 Times						12/7/91	RW
640	Gallery Target & Test						12-9-91	AC
	A) Time						12-9-91	AC
	B) Malfunctions						12-9-91	AC
	C) Pierced Primers						12-9-91	AC
	D) Optical Clarity of Scope						12-9-91	AC
645	Inspect for Live Ammo						12-9-91	AC
655	Final Inspection						12-15-91	JK
	A) Headspace						12-15-91	JK
	B) Trigger Pull	2.51	2.33	2.49	2.45	2.42	12-10-91	JK
	C) Function						12-13-91	JK
660	Pack						12-17-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6649 186DATE 12-7-91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.52	2.30	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.53	2.20	2.33	
PULL #3	2.24	2.52	2.51	2.49	
PULL #4	2.24	2.42	2.51	2.45	
PULL #5	2.51	2.49	2.48	2.42	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.25		
PULL #2	3.51	3.39		
PULL #3	3.44	3.49		
PULL #4	3.44	3.50		
PULL #5	3.63	3.51		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.39		4.19
PULL #2	4.18	4.30		4.25
PULL #3	4.48	4.26		4.22
PULL #4	4.48	4.26		4.23
PULL #5	4.43	4.26		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649186
9 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.608784
1 TO	2	.840387
1 TO	3	1.09124
1 TO	4	.397201
1 TO	5	.800743

St₁ ←---FOR
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0648
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .3135

THE AMR FOR THIS RIFLE IS: 1.168

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649106

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 5

HS= 3.775

VS= 2.736

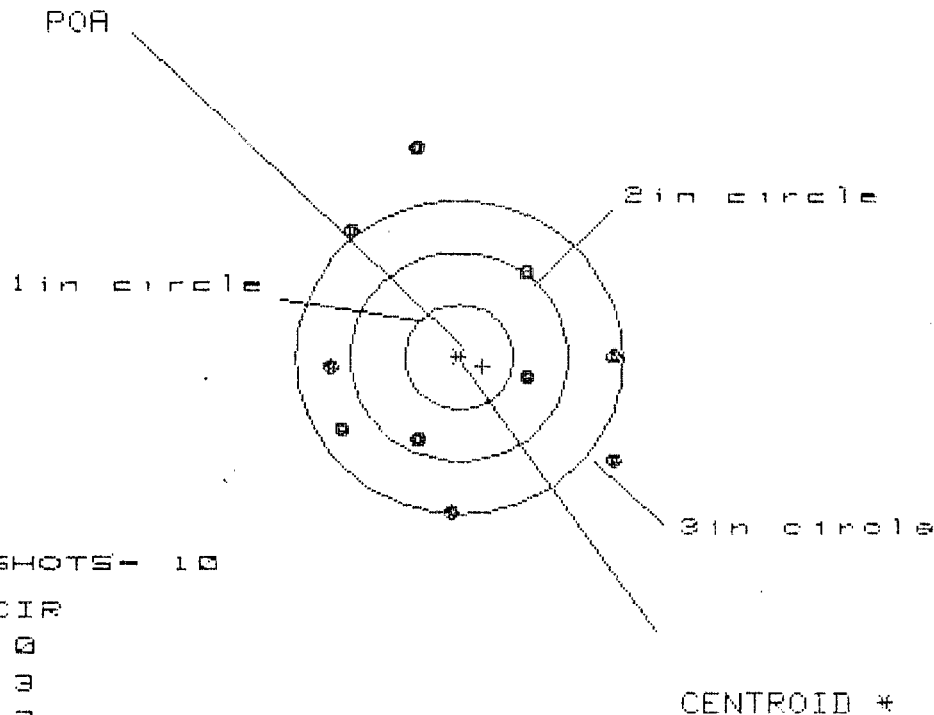
GS= 4.120

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.879	1.669	1.828
MINIMUM X	:	-1.896	-1.863	-1.655
MAXIMUM Y	:	1.235	1.122	1.186
MINIMUM Y	:	-1.501	-1.614	-1.550
CENTROID X	:	.507	.717	.509
CENTROID Y	:	-.337	-.224	-.288
POA TO CENTROID in.	:	.609	.751	.585
MIN RADIUS	:	.304	.069	.206
MEAN RADIUS	:	1.322	1.199	1.128
MAX RADIUS	:	2.153	1.941	1.866
HORIZONTAL SPREAD	:	3.775	3.532	3.483
VERTICAL SPREAD	:	2.736	2.736	2.736
EXTREME SPREAD	:	4.120	3.688	3.485
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	5		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8849188

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HSI = 2.579

VS = 3.408

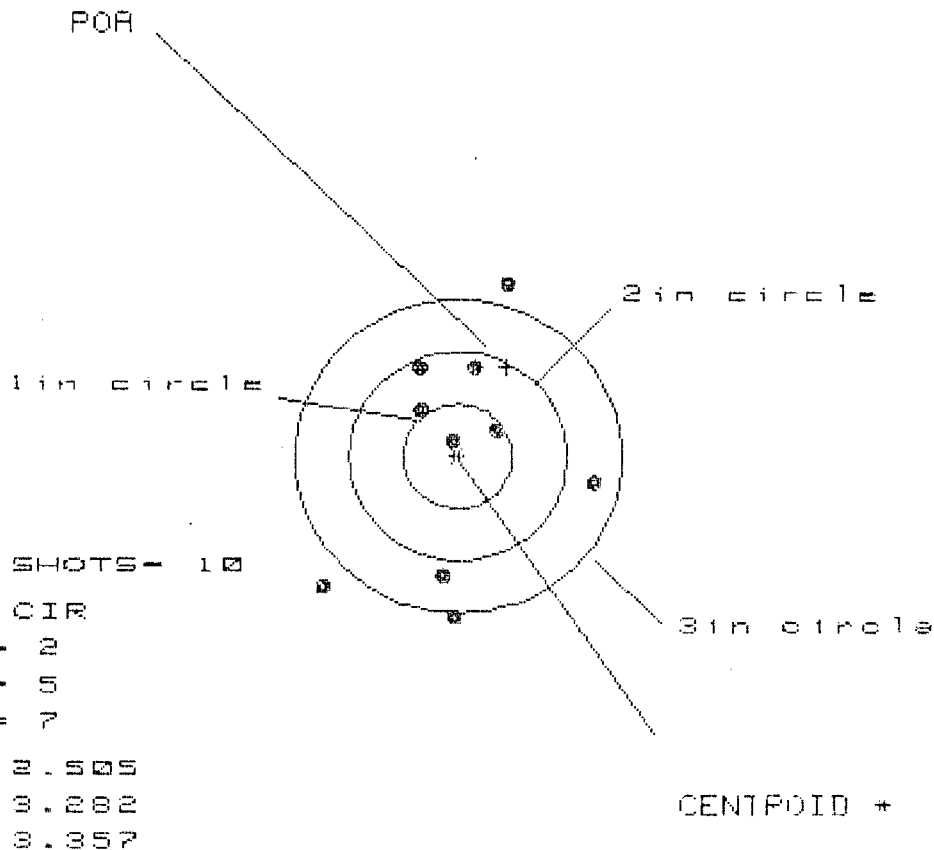
GS = 3.414

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.440	1.403	1.575
MINIMUM X	-1.139	-1.176	-1.084
MAXIMUM Y	1.968	1.419	1.329
MINIMUM Y	-1.440	-1.222	-1.312
CENTROID X	-.218	-.181	-.353
CENTROID Y	.088	-.130	-.040
POA TO CENTROID in.	.235	.223	.356
MIN RADIUS	.673	.622	.664
MEAN RADIUS	1.306	1.203	1.151
MAX RADIUS	1.996	1.759	1.587
HORIZONTAL SPREAD	2.579	2.579	2.579
VERTICAL SPREAD	3.408	2.641	2.641
EXTREME SPREAD	3.414	3.233	2.782
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649186

CENTERFIRE PATTERNS # 3



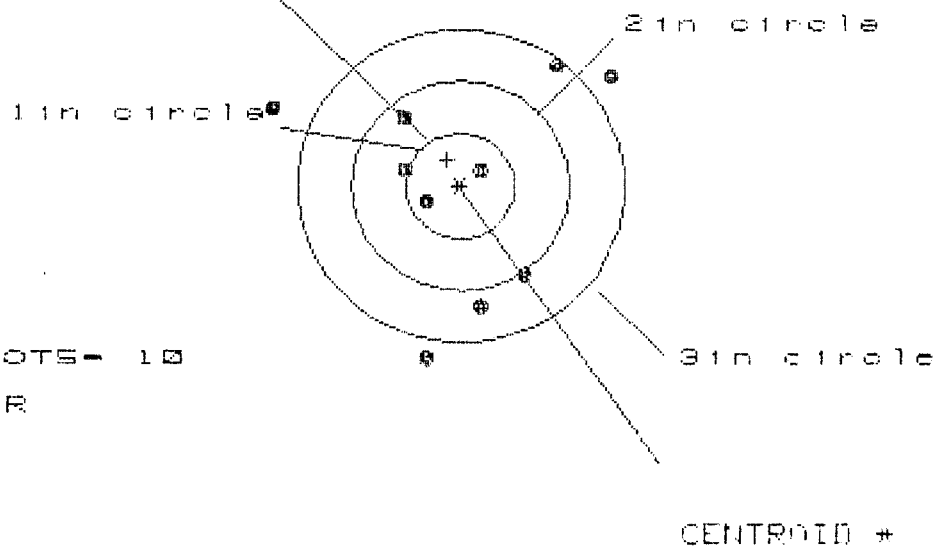
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.303	1.353	1.209
MINIMUM X	-1.202	-1.152	-.476
MAXIMUM Y	1.690	1.078	.947
MINIMUM Y	-1.592	-1.405	-1.536
CENTROID X	-.454	-.504	-.360
CENTROID Y	-.854	-1.041	-.910
POA TO CENTROID in.	.967	1.157	.979
MIN RADIUS	.164	.350	.250
MEAN RADIUS	1.046	1.002	.887
MAX RADIUS	1.747	1.558	1.546
HORIZONTAL SPREAD	2.505	2.505	1.685
VERTICAL SPREAD	3.282	2.483	2.483
EXTREME SPREAD	3.357	2.679	2.500
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849186

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 3.119

VS= 2.813

GS= 3.223

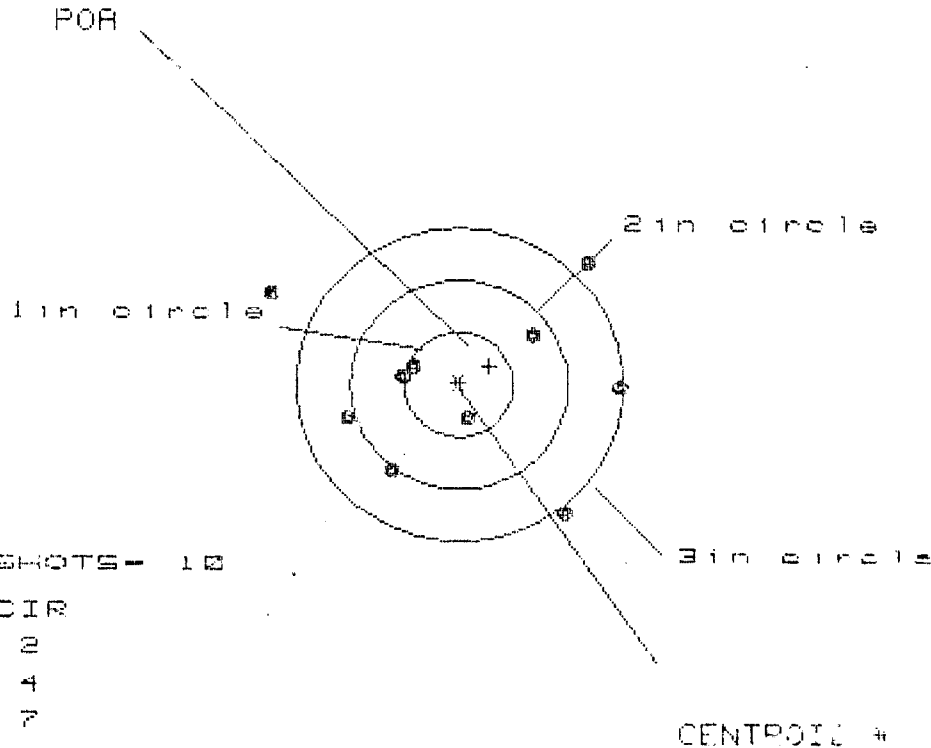
CENTROID +

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.410	1.221	.878
MINIMUM X	-1.709	-.702	-.550
MAXIMUM Y	1.130	1.211	1.353
MINIMUM Y	-1.683	-1.602	-1.460
CENTROID X	.119	.308	.156
CENTROID Y	-.252	-.333	-.475
POA TO CENTROID in.	.278	.454	.500
MIN RADIUS	.192	.214	.319
MEAN RADIUS	1.080	1.088	.902
MAX RADIUS	1.860	1.672	1.613
HORIZONTAL SPREAD	3.119	1.923	1.428
VERTICAL SPREAD	2.813	2.813	2.813
EXTREME SPREAD	3.223	3.223	3.060
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649186

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

H0 = 3.176

V0 = 2.343

G0 = 3.385

PATTERN #	15	15	15
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.441	1.248	1.377
MINIMUM X	-1.735	-1.287	-1.070
MAXIMUM Y	1.139	1.231	.689
MINIMUM Y	-1.204	-1.112	-.958
CENTROID X	-.278	-.085	-.214
CENTROID Y	-.179	-.271	-.425
POA TO CENTROID in.	.330	.284	.475
MIN RADIUS	.294	.255	.054
MEAN RADIUS	1.087	1.002	.884
MAX RADIUS	1.923	1.605	1.398
HORIZONTAL SPREAD	3.176	2.455	2.455
VERTICAL SPREAD	2.343	2.343	1.647
EXTREME SPREAD	3.385	2.713	2.475
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		