

FORM

UPC



006665700

INCLUDES 1 IN CHAMBER

MODEL 788 TM M24

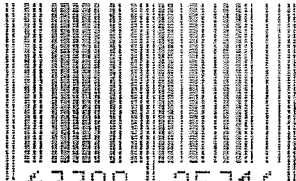
ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6665700
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



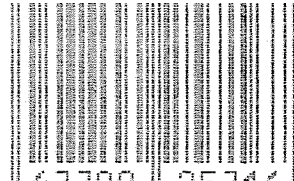
5716 C6665700

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 # *C6665700*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	<i>RW</i>
600	Proof	9 26	9 1	<i>RW</i>
607	Check Headspace	9 26	9 1	<i>RW</i>
610	Dis-assemble Gun	9 26	9 1	<i>RW</i>
612	Magnaflux Barrel Action		SEP 30 1991	<i>KR</i>
	Magnaflux Bolt		SEP 30 1991	<i>KR</i>
615	Rollmark Caliber		SEP 30 1991	<i>SL</i>
617	Drill and Tap Sight Holes		SEP 30 1991	<i>KB</i>
618	Polish Barrel		OCT 22 1991	<i>WT</i>
620	Apply Coatings (Barrel Action)		10-13-91	<i>JA</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		10/13/91	<i>RW</i>
	D) Oil Firing Pin Ass'y		10/13/91	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	<i>JM</i>

op. #	BARBER M24 0101487	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{3}{4}$	4 $\frac{3}{4}$	4 $\frac{1}{4}$			10-22-91	D/H
	G) Safety Off Force	2 $\frac{1}{4}$	2 $\frac{1}{4}$	2 $\frac{1}{2}$			10-22-91	D/H
	H) Trigger Pull Test & Retainability						10/22/91	QU
	I) Firing Pin Indent	.021	.021	.022			10-22-91	D/H
	J) Assemble Stock						10/22/91	RW
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10/22/91	RW
	M) Iron Sight Alignment						10/22/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/91	RW
	O) Attach Scope to Rifle						10/22/91	RW
	P) Detach & Attach Scope 20 Times						10/22/91	RW
640	Gallery Target & Test						10-22-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-22-91	NF
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	237	235	232	233	235	10-23-91	D/H
	C) Function						10-30-91	AC
660	Pack						12-18-91	D/H

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO 2-6665700

DATE 10/22/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.17	2.24	2.38	237	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.26	2.30	235	
PULL #3	2.24	2.24	2.28	232	
PULL #4	2.15	2.27	2.20	233	
PULL #5	2.18	2.26	2.22	235	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.30		
PULL #2	3.56	3.29		
PULL #3	3.45	3.25		
PULL #4	3.47	3.22		
PULL #5	3.54	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.24		4.32
PULL #2	4.35	4.36		4.38
PULL #3	4.38	4.30		4.36
PULL #4	4.37	4.34		4.37
PULL #5	4.33	4.30		4.35
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665700
22 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.362305
1 TO	2	.352575
1 TO	3	.259069
1 TO	4	.265047
1 TO	5	.310137

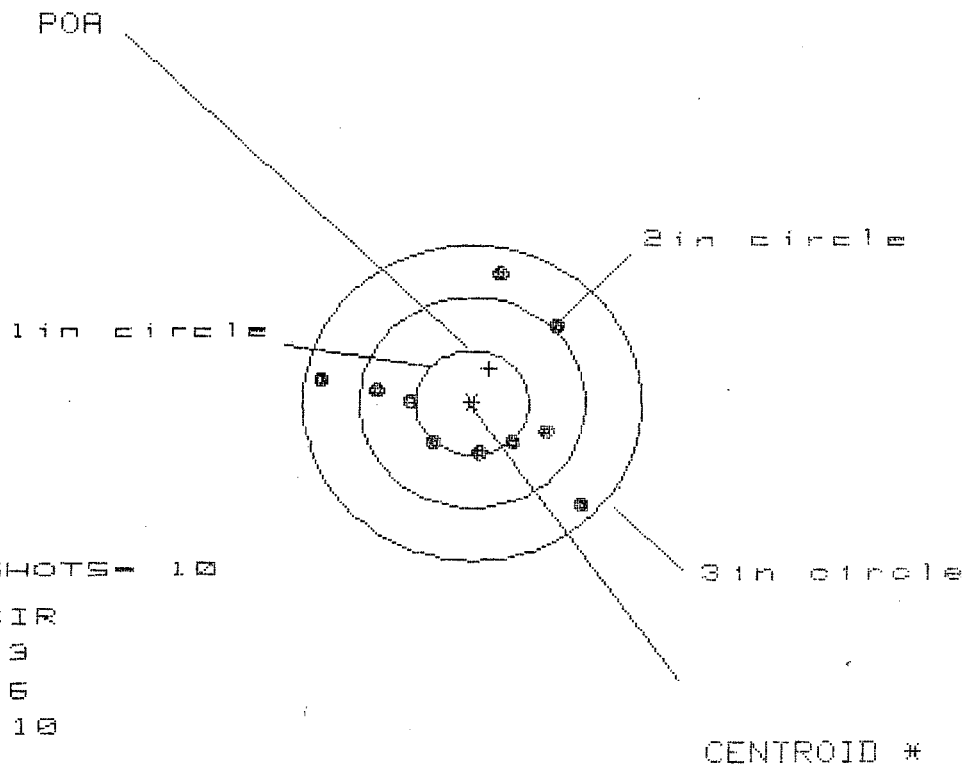
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1148
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1048
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .155442
THE AMR FOR THIS RIFLE IS: .952

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665780

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.352

VS= 2.126

GS= 2.646

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	.805	.723
MINIMUM X	-1.392	-1.015	-.914
MAXIMUM Y	1.183	1.213	1.099
MINIMUM Y	-.943	-.913	-.520
CENTROID X	-.156	-.001	-.102
CENTROID Y	-.327	-.357	-.242
POA TO CENTROID in.	.362	.357	.263
MIN RADIUS	.449	.371	.523
MEAN RADIUS	.856	.782	.737
MAX RADIUS	1.418	1.218	1.118
HORIZONTAL SPREAD	2.352	1.820	1.637
VERTICAL SPREAD	2.126	2.126	1.619
EXTREME SPREAD	2.646	2.238	1.736
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665700

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 3.300

VS= 2.001

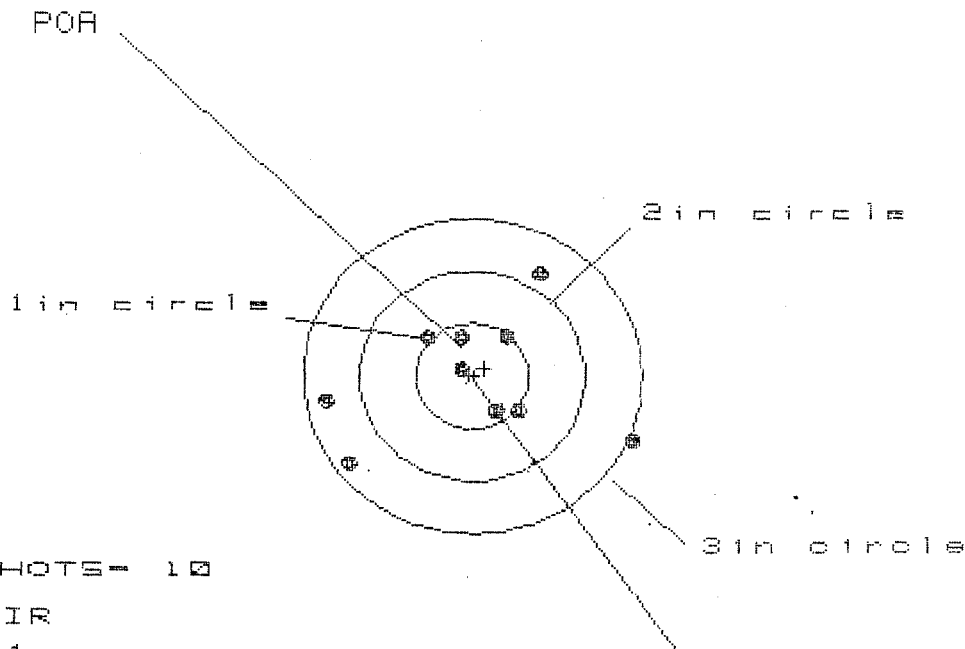
GS= 3.532

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.731	1.418	1.246
MINIMUM X	:	-1.569	-1.377	-1.103
MAXIMUM Y	:	1.063	.959	.986
MINIMUM Y	:	-.938	-.295	-.268
CENTROID X	:	.034	-.158	.014
CENTROID Y	:	-.030	.074	.047
POA TO CENTROID in.	:	.046	.174	.049
MIN RADIUS	:	.254	.084	.188
MEAN RADIUS	:	.996	.840	.795
MAX RADIUS	:	1.968	1.641	1.522
HORIZONTAL SPREAD	:	3.300	2.795	2.349
VERTICAL SPREAD	:	2.001	1.254	1.254
EXTREME SPREAD	:	3.532	2.841	2.546
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665700

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 9

CENTROID #

HS= 2.575

VS= 1.771

GS= 2.701

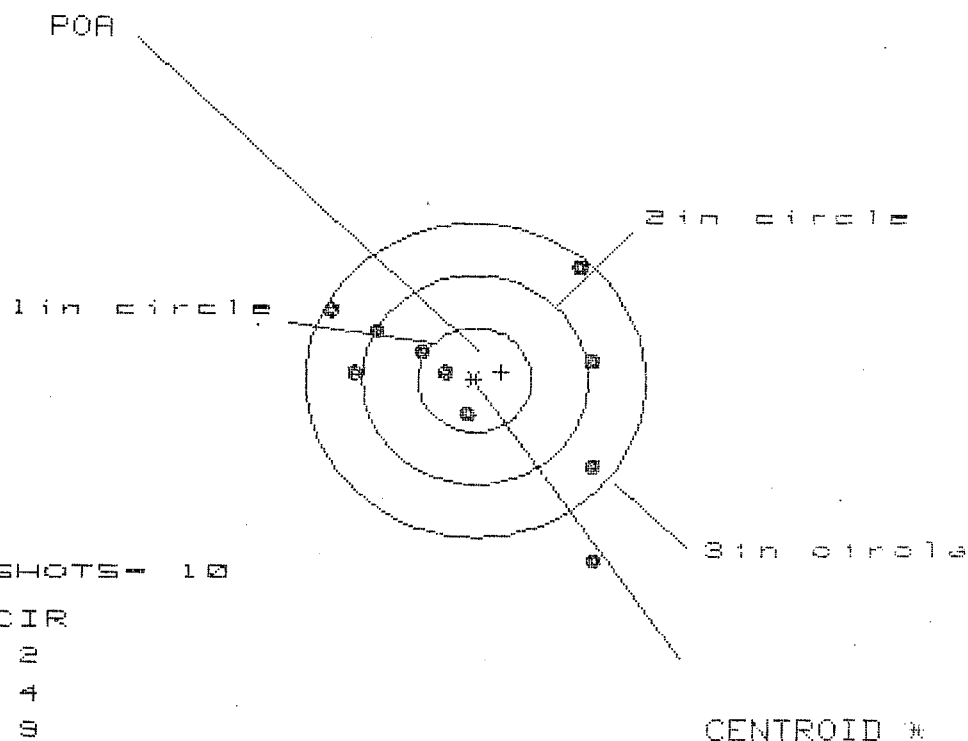
PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.424
MINIMUM X	:	-1.251
MAXIMUM Y	:	.941
MINIMUM Y	:	-.830
CENTROID X	:	-.105
CENTROID Y	:	-.073
POA TO CENTROID in.	:	.128
MIN RADIUS	:	.131
MEAN RADIUS	:	.785
MAX RADIUS	:	1.549
HORIZONTAL SPREAD	:	2.675
VERTICAL SPREAD	:	1.771
EXTREME SPREAD	:	2.701
NUMBER IN ONE INCH CIRCLE	=	4
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	9

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66657B0

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 2.302

VS = 2.783

GS = 3.335

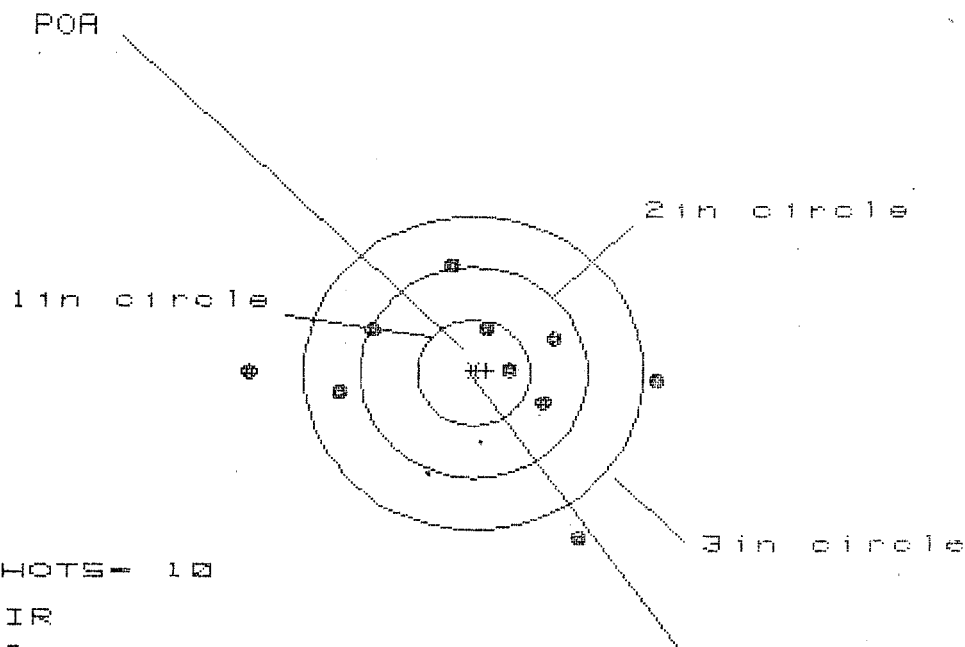
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.054	1.171	1.030
MINIMUM X	:	-1.248	-1.131	-1.078
MAXIMUM Y	:	1.069	.878	.942
MINIMUM Y	:	-1.714	-1.061	-.997
CENTROID X	:	-.235	-.352	-.211
CENTROID Y	:	-.074	.116	.052
POA TO CENTROID in.	:	.247	.371	.217
MIN RADIUS	:	.317	.215	.335
MEAN RADIUS	:	1.048	.904	.882
MAX RADIUS	:	2.012	1.580	1.433
HORIZONTAL SPREAD	:	2.302	2.302	2.107
VERTICAL SPREAD	:	2.783	1.939	1.939
EXTREME SPREAD	:	3.335	2.787	2.337
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	9		

22 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665700

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 7

HS= 3.547

VS= 2.604

GS= 3.549

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.569	1.349	1.433
MINIMUM X	-1.978	-1.400	-1.316
MAXIMUM Y	.976	.978	.775
MINIMUM Y	-1.628	-1.626	-.518
CENTROID X	-.112	.108	.024
CENTROID Y	-.020	-.022	.181
POA TO CENTROID in.	.114	.110	.182
MIN RADIUS	.272	.067	.195
MEAN RADIUS	1.075	.927	.802
MAX RADIUS	1.978	1.759	1.463
HORIZONTAL SPREAD	3.547	2.749	2.749
VERTICAL SPREAD	2.604	2.604	1.293
EXTREME SPREAD	3.549	2.803	2.750
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		