

FORM

UPC



0 47700 25716 7

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6666140

MODEL 700 TM M24

ORDER NO.

5716

BARBER LENGTH

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6666140
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



ORDER 5716
MODEL 700 TM M24
UPC



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MODEL 700 TM M24
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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26666140

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KA
600	Proof		10/1/91	KA
607	Check Headspace		10/1/91	KA
610	Dis-assemble Gun		10/1/91	KA
612	Magnaflux Barrel Action		10/1/91	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LS
617	Drill and Tap Sight Holes	OCT	8 1991	FB
618	Polish Barrel	OCT	8 1991	WB
620	Apply Coatings (Barrel Action)		11/1/91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		12/2/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/2/91	KA
	C) Inspect Ejector Hole for Chamfer		12/2/91	KA
	D) Oil Firing Pin Ass'y		12/2/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			12/3/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/3/91	WB
	H) Trigger Pull Test & Retainability						12/3/91	WB
	I) Firing Pin Indent	0208	0205	020			12/3/91	WB
	J) Assemble Stock						12/4/91	WB
	K) Assemble Swivel Studs						12-5-91	AC
	L) Attach Front and Rear Sight Assemblies						12/4/91	WB
	M) Iron Sight Alignment						12/4/91	WB
	N) Detach Front & Rear Sights & place in numbered container						12/4/91	WB
	O) Attach Scope to Rifle						12/4/91	WB
	P) Detach & Attach Scope 20 Times						12/4/91	WB
640	Gallery Target & Test						12-5-91	AC
	A) Time						12-5-91	AC
	B) Malfunctions						12-5-91	AC
	C) Pierced Primers						12-5-91	AC
	D) Optical Clarity of Scope						12-5-91	AC
645	Inspect for Live Ammo						12-5-91	AC
655	Final Inspection							
	A) Headspace						12-9-91	AC
	B) Trigger Pull	263	234	236	238	234	12-7-91	DH
	C) Function						12-9-91	AC
660	Pack						12/19/91	DH

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

SERIAL NO. C6666140
DATE 12/3/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.42	2.28	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.50	2.26	2.34	
PULL #3	2.47	2.37	2.36	2.36	
PULL #4	2.49	2.47	2.32	2.38	
PULL #5	2.54	2.39	2.32	2.34	
TOTAL	12.53	12.15	11.54		
AVG.	2.51	2.43	2.31		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.13		
PULL #2	3.12	3.12		
PULL #3	3.15	3.06		
PULL #4	3.18	3.06		
PULL #5	3.16	3.12		
TOTAL	15.83	15.49		
AVG.	3.17			

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.07		4.04
PULL #2	4.01	3.99		4.03
PULL #3	4.00	3.99		4.00
PULL #4	3.85	4.00		4.09
PULL #5	4.00	3.95		4.08
TOTAL	20.03	20.00		20.24
AVG.	4.01	4.00		4.05

CENTROIDAL DISTANCE CALCULATION IS
FOR RIFLE # 06666140
5 Dec 1991

CENTROIDAL DISTANCES

TO	1	.568558
TO	2	.652442
TO	3	.757956
TO	4	.785988
TO	5	.69074

TO ---POA

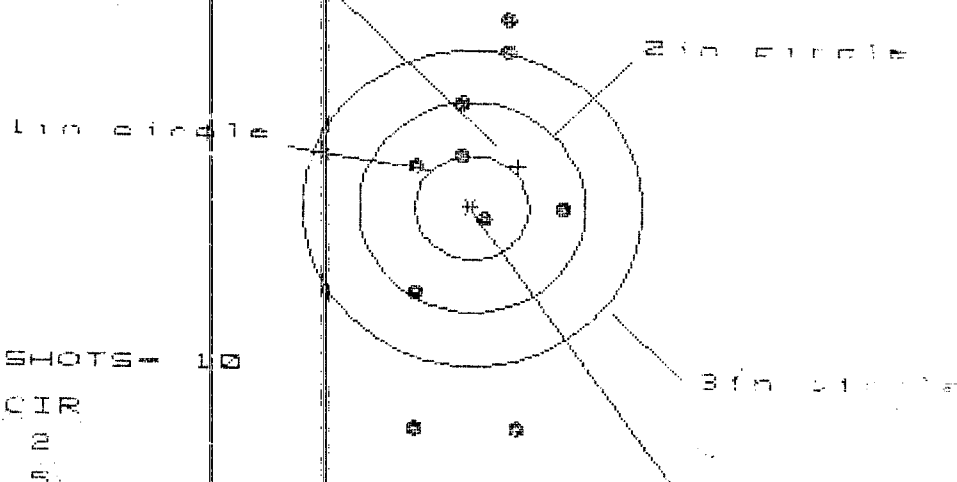
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1362
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .09452
THE AMR FOR THIS RIFLE IS: .931

5 Dec 1991

FILE: /PATTERNING/CENTERFIRE_ATT/C666B140

CENTERFIRE PATTERNS # 1

POA



+ OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 1.336

VS= 3.942

GS= 4.025

CENTROID +

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.796	.736	.777
MINIMUM X	-.540	-.584	-.543
MAXIMUM Y	1.805	1.568	1.274
MINIMUM Y	-2.137	-2.349	-1.339
CENTROID X	.407	-.347	-.388
CENTROID Y	.397	-.160	.134
POA TO CENTROID in.	.569	.382	.411
MIN RADIUS	.136	.287	.154
MEAN RADIUS	.178	1.031	.821
MAX RADIUS	2.204	2.372	1.445
HORIZONTAL SPREAD	1.336	1.320	1.320
VERTICAL SPREAD	3.942	3.917	2.613
DIAGN. SPREAD	4.025	3.919	2.732
SHOTS IN ONE INCH CIRCLE	= 2		
SHOTS IN TWO INCH CIRCLE	= 5		
SHOTS IN THREE INCH CIRCLE	= 6		

5 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666140

CENTERFIRE PATTERNS # 2

POA

11n circle

21n circle

31n circle

CENTROID *

OF SHOTS - 10

IN CIR

11n = 1

21n = 5

31n = 10

HS= 1.387

VS= 2.239

GS= 2.272

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.895	.861	.858
MINIMUM X	-.492	-.526	-.529
MAXIMUM Y	1.248	1.241	1.230
MINIMUM Y	-.991	-.852	-.697
CENTROID X	.209	.243	.246
CENTROID Y	-.182	-.321	-.476
POA TO CENTROID in.	.277	.402	.535
MIN RADIUS	.389	.327	.290
MEAN RADIUS	.885	.820	.737
MAJ. RADIUS	1.286	1.241	1.308
HORIZONTAL SPREAD	1.387	1.387	1.387
VERTICAL SPREAD	2.239	2.093	1.927
EXTREME SPREAD	2.272	2.099	2.025
COUNT IN ONE INCH CIRCLE	= 1		
COUNT IN TWO INCH CIRCLE	= 5		
COUNT IN THREE INCH CIRCLE	= 10		

5 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6695140

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.874

VS = 2.209

GS = 3.245

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.494	1.363	1.201
MINIMUM X	-1.380	-1.511	-1.341
MAXIMUM Y	1.291	.763	.713
MINIMUM Y	-.918	-.775	-.926
CENTROID X	.286	.417	.247
CENTROID Y	-.090	-.233	-.182
POA TO CENTROID in.	.300	.478	.307
MIN RADIUS	.079	.134	.055
MEAN RADIUS	1.043	.975	.884
MAX RADIUS	1.748	1.524	1.457
HORIZONTAL SPREAD	2.874	2.874	2.342
VERTICAL SPREAD	2.209	1.538	1.538
EXTREME SPREAD	3.245	2.938	2.723
CENTER IN ONE INCH CIRCLE	=	1	
CENTER IN TWO INCH CIRCLE	=	5	
CENTER IN THREE INCH CIRCLE	=	8	

DEC 1981

FILE: PATTERNING/CENTERFIRE_PATT/C6566340

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 12

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.050

VS= 2.030

GS= 2.460

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.872

.940

.801

MINIMUM X

-1.177

-1.110

-.816

MAXIMUM Y

1.137

.639

.434

MINIMUM Y

-.893

-.766

-.686

CENTROID X

.269

.202

.341

CENTROID Y

.004

-.123

-.203

POA TO CENTROID in.

.270

.237

.397

MIN RADIUS

.229

.326

.444

MEAN RADIUS

.779

.711

.664

MAX RADIUS

1.288

1.281

1.031

HORIZONTAL SPREAD

2.050

2.050

1.617

VERTICAL SPREAD

2.030

1.405

1.121

EXTREME SPREAD

2.460

2.460

1.771

SHOTS IN ONE INCH CIRCLE

4

SHOTS IN TWO INCH CIRCLE

7

SHOTS IN THREE INCH CIRCLE

10

10/2/1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8686140

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HE = 1.852

VS = 1.801

GS = 2.582

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.792	.880	.749
MINIMUM X	-1.060	-.972	-1.036
MAXIMUM Y	.736	.618	.545
MINIMUM Y	-1.065	-.564	-.487
CENTROID X	.224	.136	.250
CENTROID Y	-.116	.002	-.075
LEN TO CENTROID in.	.252	.136	.260
1 IN RADIUS	.267	.263	.214
2 IN RADIUS	.770	.697	.621
3 IN RADIUS	1.326	1.152	1.034
HORIZONTAL SPREAD	1.852	1.852	1.794
VERTICAL SPREAD	1.801	1.182	1.032
GRAND SPREAD	2.582	2.064	1.797
LEN TO ONE INCH CIRCLE		2	
LEN TO TWO INCH CIRCLE		7	
LEN TO THREE INCH CIRCLE		10	