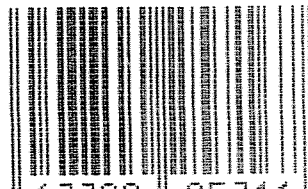


CAPACIT

*INCLUDES 1 IN CHAMBER

06648971

UPC



0 47700 25716 2

FORM

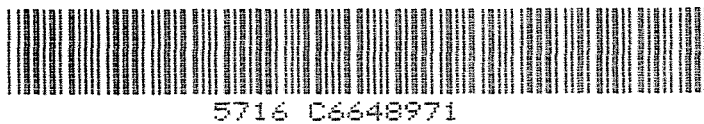
Snead®

ORDER NO. 5716

BARREL LENGTH

MODEL 700 TM M24

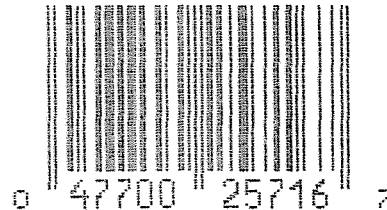
 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6648971
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



ORDER 5716
MODEL 700 TM M24
UPC



ORDER 5716
MODEL 700 TM M24
UPC



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648971

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	7 2 9 1		RW
610	Dis-assemble Gun	7 2		RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-28-91	TS
	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		7-7-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9-7-91	DH
	G) Safety Off Force	2	2	2			9-7-91	DH
	H) Trigger Pull Test & Retainability						9-7-91	DH
	I) Firing Pin Indent	.022	.022	.022			9-7-91	DH
	J) Assemble Stock						10/8/91	RW
	K) Assemble Swivel Studs						10-17-91	R
	L) Attach Front and Rear Sight Assemblies						10/8/91	RW
	M) Iron Sight Alignment						10/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/8/91	RW
	O) Attach Scope to Rifle						10/8/91	RW
	P) Detach & Attach Scope 20 Times						10/8/91	RW
640	Gallery Target & Test						10/8/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/8/91	KT
655	Final Inspection							
	A) Headspace						10-17-91	R
	B) Trigger Pull	2.31	2.33	2.31	2.34	2.33	10-9-91	DH
	C) Function						10-17-91	R
660	Pack						12-17-91	R

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6648971

DATE 7-7-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.48	2.66	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.59	2.73	2.33	
PULL #3	2.61	2.74	2.77	2.31	
PULL #4	2.69	2.55	2.72	2.34	
PULL #5	2.79	2.72	2.75	2.33	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.20		
PULL #2	3.36	3.29		
PULL #3	3.48	3.22		
PULL #4	3.39	3.19		
PULL #5	3.44	3.29		
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	4.13		4.03
PULL #2	4.33	4.13		4.10
PULL #3	4.34	3.98		4.17
PULL #4	4.39	3.98		4.09
PULL #5	4.00	4.13		4.13
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648971
8 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.505969
1 TO 2	.254922
1 TO 3	.240853
1 TO 4	.470032
1 TO 5	.700795

5421 <---POB

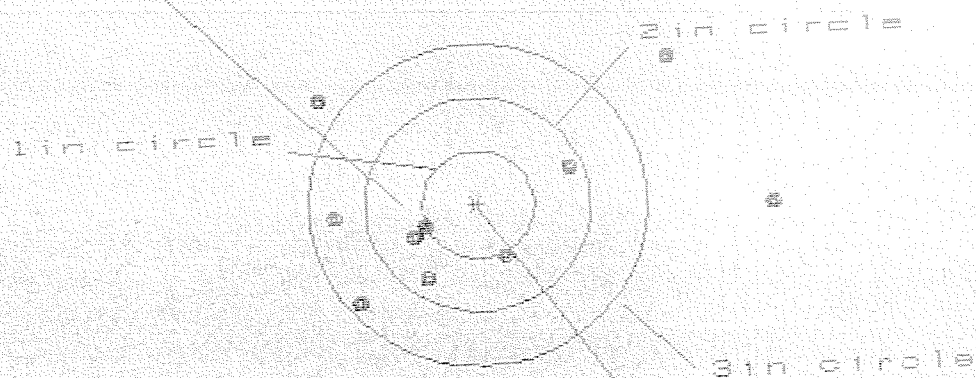
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1602
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0978
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .187694
THE AMR FOR THIS RIFLE IS: .9434

8 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8648971

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 7

HS = 3.959

VS = 2.183

GS = 4.107

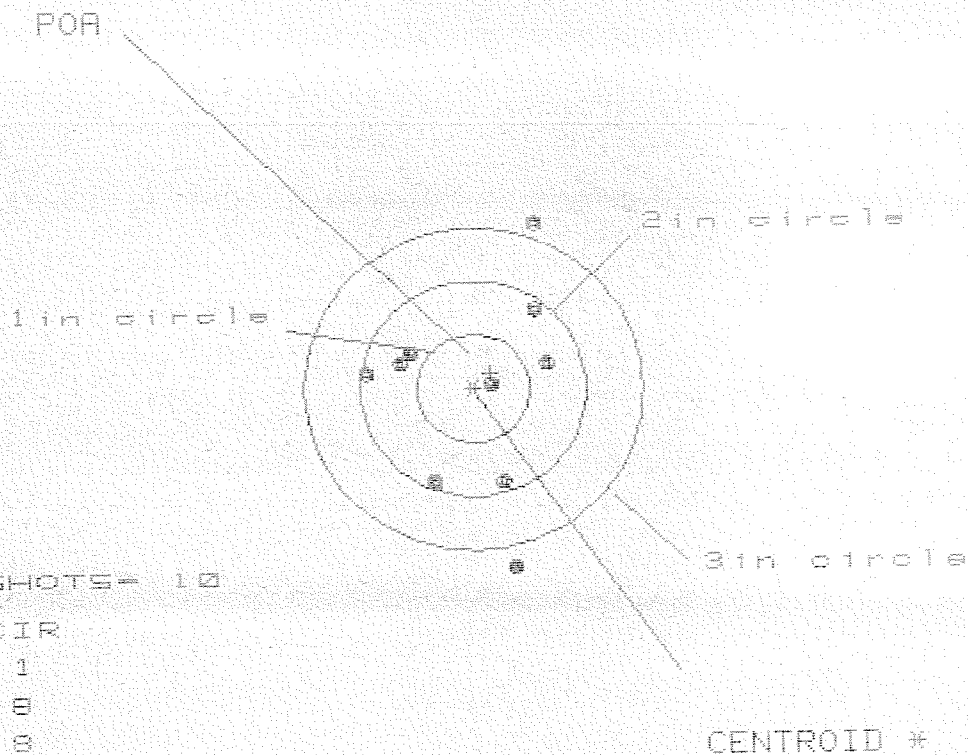
CENTROID *

PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.576	2.043	1.336
MINIMUM X	:	-1.383	-1.097	-.841
MAXIMUM Y	:	1.292	1.284	1.172
MINIMUM Y	:	-.891	-.899	-.739
CENTROID X	:	.474	.188	-.068
CENTROID Y	:	.177	.185	.025
POA TO CENTROID in.	:	.506	.264	.072
MIN RADIUS	:	.503	.252	.064
MEAN RADIUS	:	1.251	1.033	.760
MAX RADIUS	:	2.577	2.413	1.443
HORIZONTAL SPREAD	:	3.959	3.140	2.177
VERTICAL SPREAD	:	2.183	2.183	1.911
EXTREME SPREAD	:	4.107	3.602	2.294
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

B Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C864B971

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 8

3 in = 8

HS= 1.569

VS= 3.180

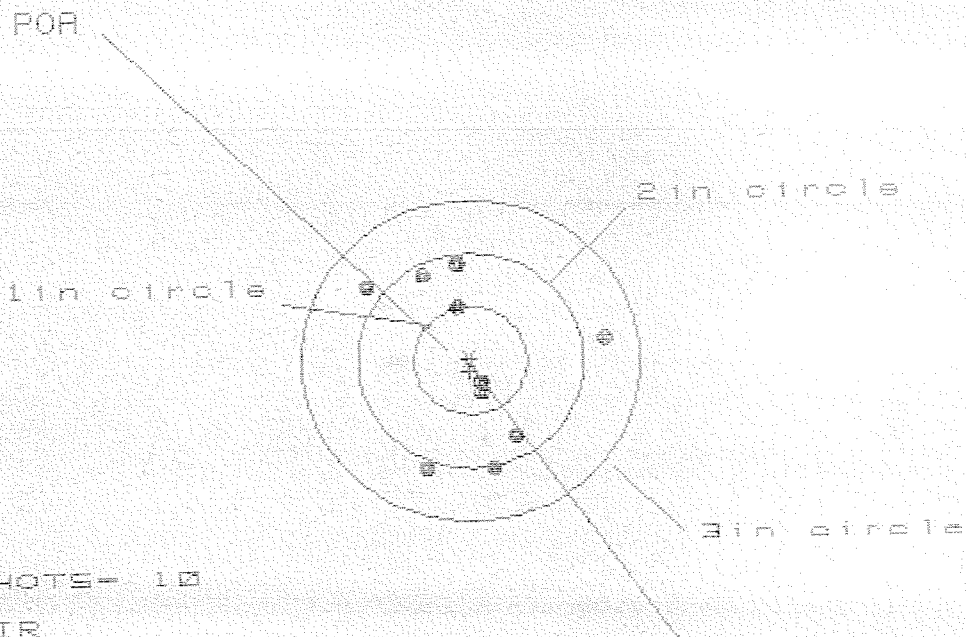
GS= 3.189

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.635	.699	.748
MINIMUM X	-.933	-.870	-.821
MAXIMUM Y	1.560	.955	.774
MINIMUM Y	-1.620	-1.447	-.887
CENTROID X	-.151	-.214	-.263
CENTROID Y	-.140	-.313	-.132
POA TO CENTROID in.	.205	.379	.294
MIN RADIUS	.163	.323	.266
MEAN RADIUS	.917	.839	.727
MAX RADIUS	1.668	1.500	1.035
HORIZONTAL SPREAD	1.569	1.569	1.569
VERTICAL SPREAD	3.180	2.402	1.661
EXTREME SPREAD	3.189	2.414	1.848
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		8	

B Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648971

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.056

VS= 1.868

GS= 2.134

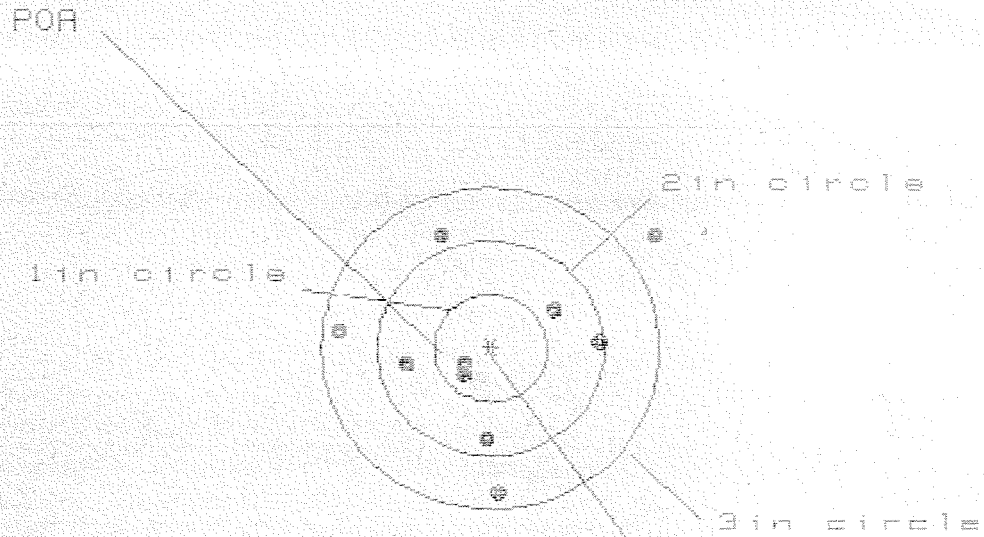
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.144	1.042	.436
MINIMUM X	-.912	-.483	-.352
MAXIMUM Y	.888	.970	1.000
MINIMUM Y	-.980	-.898	-.868
CENTROID X	.011	.113	-.018
CENTROID Y	.096	.014	-.016
POA TO CENTROID in.	.096	.114	.024
MIN RADIUS	.220	.131	.138
MEAN RADIUS	.793	.729	.681
MAX RADIUS	1.169	1.070	1.002
HORIZONTAL SPREAD	2.056	1.525	.788
VERTICAL SPREAD	1.868	1.868	1.868
EXTREME SPREAD	2.134	1.897	1.887
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

8 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C664B971

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.848

VS= 2.378

GS= 3.018

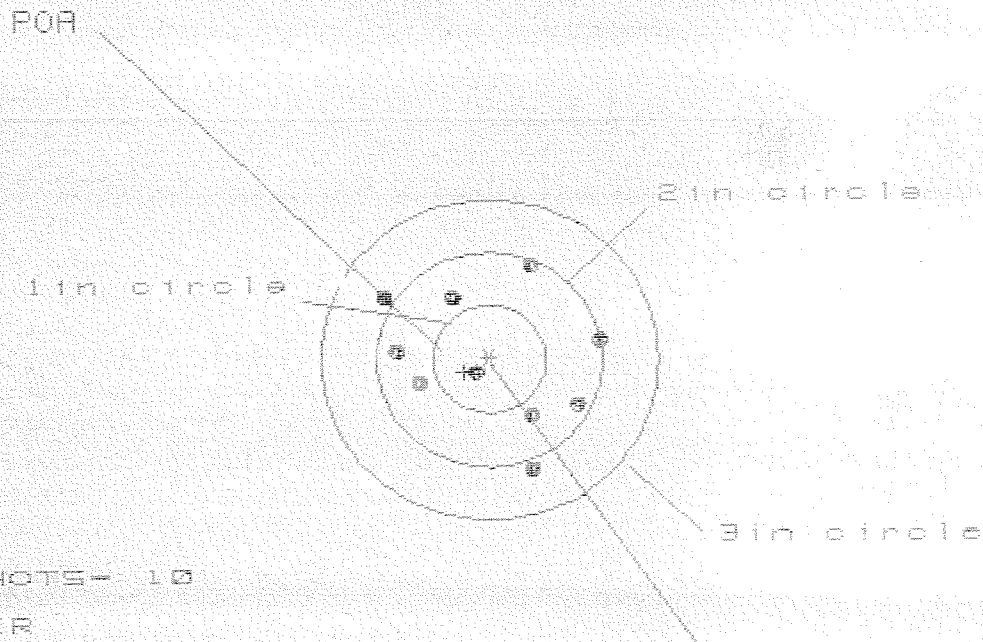
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.485	1.108	.958
MINIMUM X	:	-1.363	-1.198	-.749
MAXIMUM Y	:	1.087	1.163	1.193
MINIMUM Y	:	-1.291	-1.170	-1.140
CENTROID X	:	.241	.076	.226
CENTROID Y	:	.238	.117	.087
POA TO CENTROID in.	:	.339	.139	.242
MIN RADIUS	:	.314	.109	.243
MEAN RADIUS	:	.951	.799	.762
MAX RADIUS	:	1.840	1.221	1.253
HORIZONTAL SPREAD	:	2.848	2.306	1.707
VERTICAL SPREAD	:	2.378	2.333	2.333
EXTREME SPREAD	:	3.018	2.381	2.381
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.918

VS= 1.971

GS= 2.121

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.954	.997	.882
MINIMUM X	:	-.964	-.921	-.869
MAXIMUM Y	:	.908	.789	.846
MINIMUM Y	:	-1.063	-.627	-.578
CENTROID X	:	.226	.183	.298
CENTROID Y	:	.118	.237	.180
POA TO CENTROID in.	:	.255	.299	.348
MIN RADIUS	:	.212	.270	.306
MEAN RADIUS	:	.805	.765	.732
MAX RADIUS	:	1.132	1.026	.914
HORIZONTAL SPREAD	:	1.918	1.918	1.751
VERTICAL SPREAD	:	1.971	1.416	1.416
EXTREME SPREAD	:	2.121	1.959	1.752
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	