

FORM

UPC



0 47700 25716 7

06665709

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY\*

|                                                                                                                                                                      |  |                                                                                                      |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------|
|   |  | <p>VERY IMPORTANT:<br/>Instruction Book<br/>enclosed to assure<br/>safe use of this<br/>firearm.</p> |
| <p><b>MODEL 700™ M24</b></p>                                                                                                                                         |  | <p>SERIAL NO.<br/><b>C6665709</b></p>                                                                |
| <p>MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat &amp; Tm. Off, Marca Registrada Marque Deposee.</p>                                                                      |  | <p>ORDER NO.<br/><b>5716</b></p>                                                                     |



**ORDER 5716**  
MODEL 700™ M24  
**UPC**



**ORDER 5716**  
MODEL 700™ M24  
**UPC**



**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665709

| OP. #        | OP. NAME                                                       | READINGS | DATE        | INIT |
|--------------|----------------------------------------------------------------|----------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 26     | 9 1         | RW   |
| 600          | Proof                                                          | 9 26     | 9 1         | RW   |
| 607          | Check Headspace                                                | 9 26     | 9 1         | RW   |
| 610          | Dis-assemble Gun                                               | 9 26     | 9 1         | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | SEP 30 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | SEP 30 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | SEP 30 1991 | GS.  |
| 617          | Drill and Tap Sight Holes                                      |          | SEP 30 1991 | LB   |
| 618          | Polish Barrel                                                  |          | OCT 2 1991  | WT   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-13-91    | DA   |
|              | Apply Coating (Bolt)                                           |          |             |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10-14-91    | A    |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10-14-91    | A.   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10-14-91    | A    |
|              | D) Oil Firing Pin Ass'y                                        |          | 10-14-91    | A    |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/14/91    | JE   |

| op. #        | OP. NAME                                                    | READINGS |      |      |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|------|------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5        | 5    | 5    |      |      | 10-14-91 | AC   |
|              | G) Safety Off Force                                         | 3        | 3    | 3    |      |      | 10-14-91 | AC   |
|              | H) Trigger Pull Test & Retainability                        |          |      |      |      |      | 10/14/91 | AC   |
|              | I) Firing Pin Indent                                        | .021     | .022 | .022 |      |      | 10-14-91 | AC   |
|              | J) Assemble Stock                                           |          |      |      |      |      | 10/15/91 | AC   |
|              | K) Assemble Swivel Studs                                    |          |      |      |      |      | 10-18-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |      |      |      | 10/15/91 | AC   |
|              | M) Iron Sight Alignment                                     |          |      |      |      |      | 10/15/91 | AC   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |      |      |      | 10/15/91 | AC   |
|              | O) Attach Scope to Rifle                                    |          |      |      |      |      | 10/15/91 | AC   |
|              | P) Detach & Attach Scope 20 Times                           |          |      |      |      |      | 10/15/91 | AC   |
| 640          | Gallery Target & Test                                       |          |      |      |      |      | 10-16-91 | DH   |
|              | A) Time                                                     |          |      |      |      |      | 10-16-91 | DH   |
|              | B) Malfunctions                                             |          |      |      |      |      | 10-16-91 | DH   |
|              | C) Pierced Primers                                          |          |      |      |      |      | 10-16-91 | DH   |
|              | D) Optical Clarity of Scope                                 |          |      |      |      |      | 10-16-91 | DH   |
| 645          | Inspect for Live Ammo                                       |          |      |      |      |      | 10-16-91 | DH   |
| 655          | Final Inspection                                            |          |      |      |      |      |          |      |
|              | A) Headspace                                                |          |      |      |      |      | 10-18-91 | AC   |
|              | B) Trigger Pull                                             | 2.30     | 2.29 | 2.25 | 2.17 | 2.10 | 10-16-91 | DH   |
|              | C) Function                                                 |          |      |      |      |      | 10-18-91 | AC   |
| 660          | Pack                                                        |          |      |      |      |      | 12-17-91 | AC   |

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6665709

DATE 10-14-91

TESTER JH

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.53             | 2.54                     | 2.66                           | 2.30 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.66             | 2.56                     | 2.72                           | 2.29 |                                                                        |
| PULL #3 | 2.51             | 2.66                     | 2.57                           | 2.25 |                                                                        |
| PULL #4 | 2.61             | 2.67                     | 2.70                           | 2.17 |                                                                        |
| PULL #5 | 2.36             | 2.59                     | 2.69                           | 2.10 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.66             | 3.71                     |  |          |
| PULL #2 | 3.48             | 3.69                     |  |          |
| PULL #3 | 3.54             | 3.50                     |  |          |
| PULL #4 | 3.58             | 3.69                     |  |          |
| PULL #5 | 3.62             | 3.63                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.51             | 4.40                     |                                | 4.48                                 |
| PULL #2 | 4.25             | 4.43                     |                                | 4.30                                 |
| PULL #3 | 4.25             | 4.42                     |                                | 4.42                                 |
| PULL #4 | 4.50             | 4.42                     |                                | 4.17                                 |
| PULL #5 | 4.48             | 4.60                     |                                | 4.24                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6665709  
16 Oct 1991

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .45104  |
| 1 TO 2 | .434442 |
| 1 TO 3 | .699718 |
| 1 TO 4 | .62052  |
| 1 TO 5 | .561208 |

1 <sup>5</sup>/<sub>19</sub> <----POA  
2

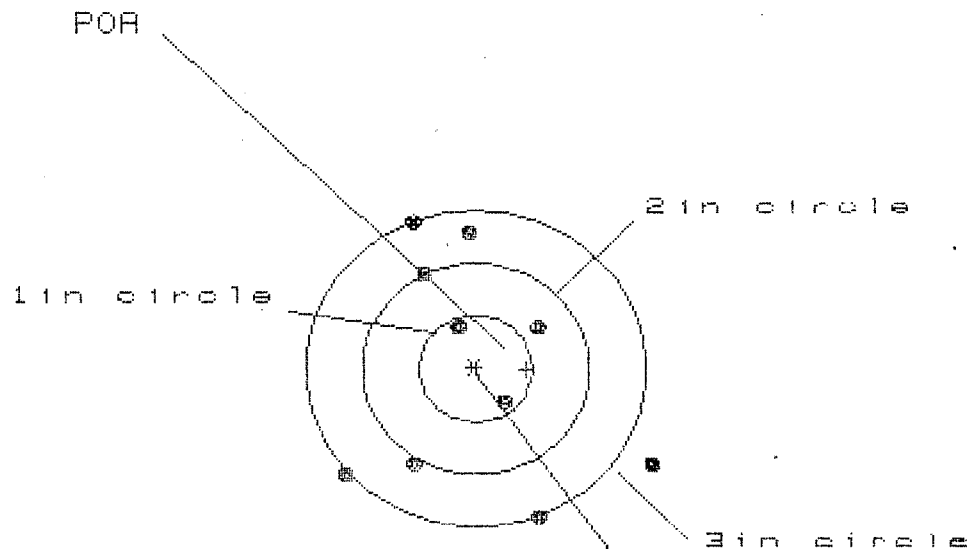
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0942  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0324  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0996163  
THE AMR FOR THIS RIFLE IS: 1.027

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6665709

# CENTERFIRE PATTERNS

# 1



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 3

3in = 7

HS= 2.752

VS= 2.822

GS= 3.134

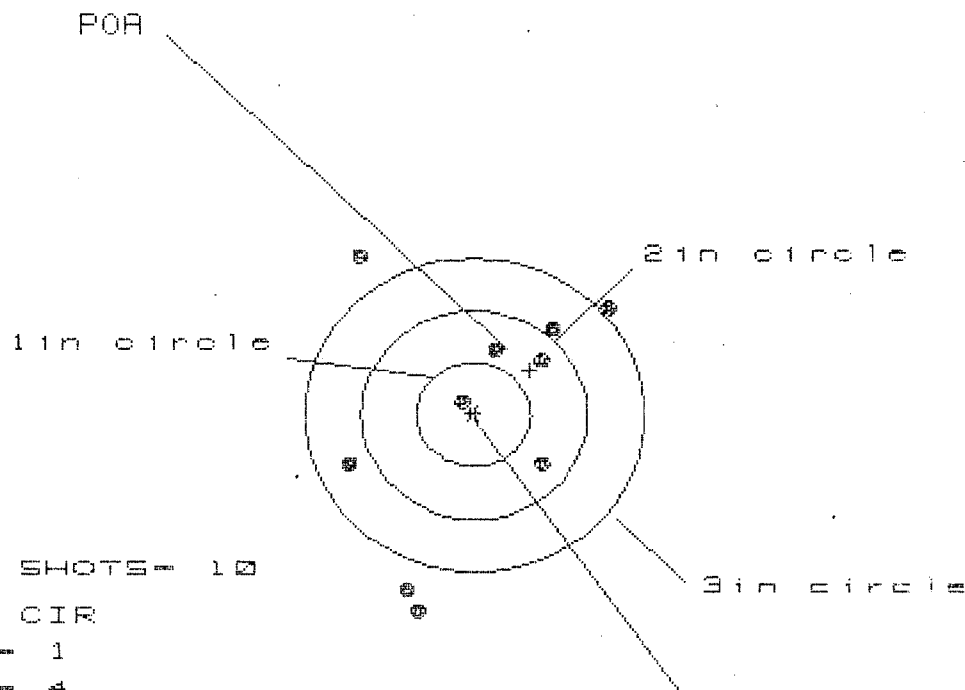
CENTROID #

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 1      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.585  | .748   | .624   |
| MINIMUM X                     | : | -1.167 | -.991  | -.494  |
| MAXIMUM Y                     | : | 1.427  | 1.330  | 1.195  |
| MINIMUM Y                     | : | -1.395 | -1.492 | -1.627 |
| CENTROID X                    | : | -.451  | -.627  | -.503  |
| CENTROID Y                    | : | .086   | .103   | .238   |
| POA TO CENTROID in.           | : | .451   | .635   | .557   |
| MIN RADIUS                    | : | .370   | .324   | .226   |
| MEAN RADIUS                   | : | 1.124  | 1.035  | .945   |
| MAX RADIUS                    | : | 1.808  | 1.646  | 1.725  |
| HORIZONTAL SPREAD             | : | 2.752  | 1.739  | 1.118  |
| VERTICAL SPREAD               | : | 2.822  | 2.822  | 2.822  |
| EXTREME SPREAD                | : | 3.134  | 3.016  | 3.016  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 7      |        |

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8685709

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.225

VS= 3.389

GS= 3.435

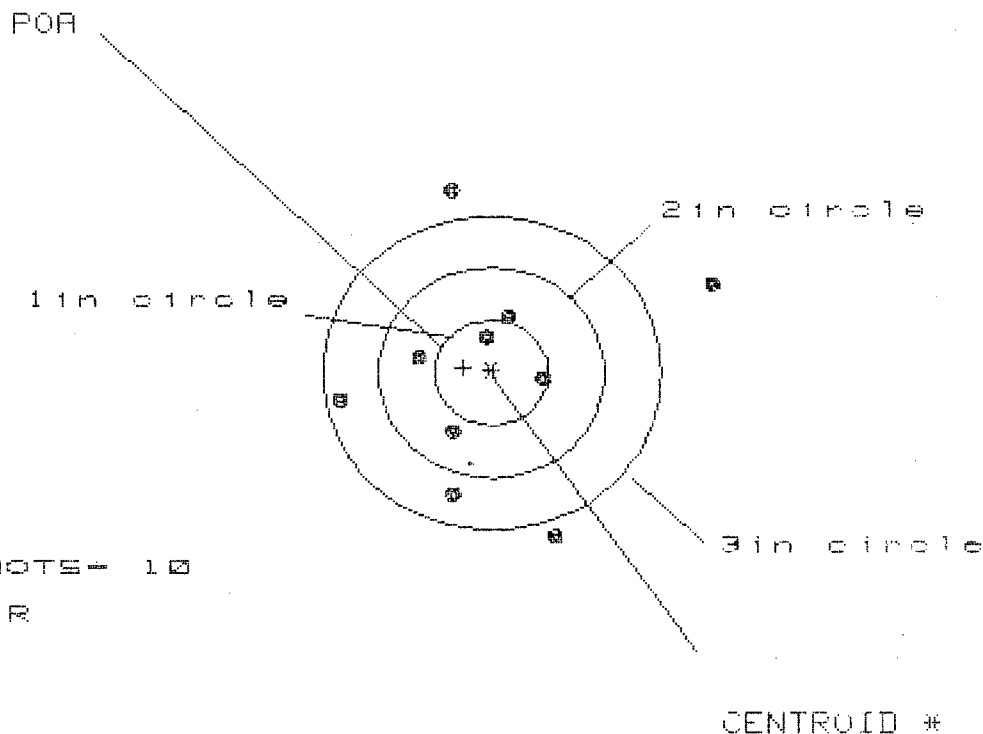
CENTROID \*

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 2      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.156  | 1.104  | .968   |
| MINIMUM X                     | : | -1.069 | -1.121 | -1.257 |
| MAXIMUM Y                     | : | 1.477  | 1.264  | .958   |
| MINIMUM Y                     | : | -1.912 | -1.894 | -1.736 |
| CENTROID X                    | : | -.497  | -.445  | -.309  |
| CENTROID Y                    | : | -.426  | -.213  | -.372  |
| POA TO CENTROID in.           | : | .655   | .493   | .483   |
| MIN RADIUS                    | : | .151   | .153   | .275   |
| MEAN RADIUS                   | : | 1.167  | 1.033  | .955   |
| MAX RADIUS                    | : | 1.969  | 2.007  | 1.911  |
| HORIZONTAL SPREAD             | : | 2.225  | 2.225  | 2.225  |
| VERTICAL SPREAD               | : | 3.389  | 3.158  | 2.693  |
| EXTREME SPREAD                | : | 3.435  | 3.222  | 3.222  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 5      |        |

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06065709

# CENTERFIRE PATTERNS # 3



# OF SHOTS = 10

# IN CIR

1in = 2

2in = 5

3in = 7

HS = 3.291

VS = 3.317

GS = 3.480

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 3      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.946  | .730   | .709   |
| MINIMUM X                     | : | -1.345 | -1.128 | -1.149 |
| MAXIMUM Y                     | : | 1.753  | 1.849  | .886   |
| MINIMUM Y                     | : | -1.564 | -1.468 | -1.237 |
| CENTROID X                    | : | .247   | .030   | .051   |
| CENTROID Y                    | : | -.043  | -.139  | -.370  |
| POA TO CENTROID in.           | : | .250   | .142   | .373   |
| MIN RADIUS                    | : | .298   | .444   | .287   |
| MEAN RADIUS                   | : | 1.078  | .947   | .828   |
| MAX RADIUS                    | : | 2.127  | 1.856  | 1.426  |
| HORIZONTAL SPREAD             | : | 3.291  | 1.858  | 1.858  |
| VERTICAL SPREAD               | : | 3.317  | 3.317  | 2.123  |
| EXTREME SPREAD                | : | 3.480  | 3.436  | 2.262  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 7      |        |

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/06665789

# CENTERFIRE PATTERNS

# 4

FOR

1in circle

2in circle

3in circle

# OF SHOTS = 10

# IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.400

VS= 2.366

GS= 2.859

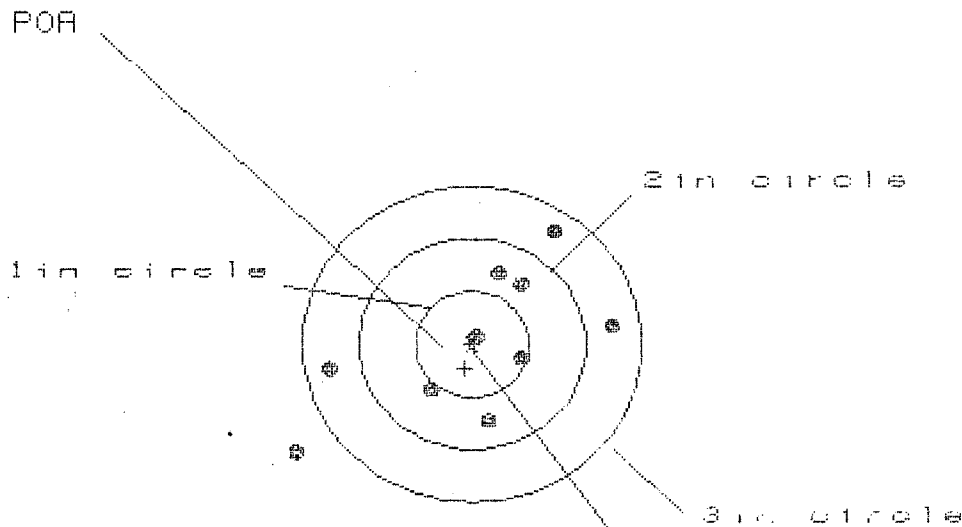
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.078  | .931   | .948   |
| MINIMUM X                   | : | -1.323 | -1.229 | -1.213 |
| MAXIMUM Y                   | : | 1.023  | .714   | .560   |
| MINIMUM Y                   | : | -1.343 | -1.229 | -1.648 |
| CENTROID X                  | : | .166   | .312   | .296   |
| CENTROID Y                  | : | .072   | -.042  | .112   |
| POA TO CENTROID in.         | : | .180   | .315   | .316   |
| MIN RADIUS                  | : | .143   | .297   | .231   |
| MEAN RADIUS                 | : | .863   | .751   | .680   |
| MAX RADIUS                  | : | 1.672  | 1.336  | 1.267  |
| HORIZONTAL SPREAD           | : | 2.400  | 2.160  | 2.160  |
| VERTICAL SPREAD             | : | 2.366  | 1.943  | 1.288  |
| EXTREME SPREAD              | : | 2.859  | 2.220  | 2.198  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

16 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/086657B3

# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.819

VS= 2.126

GS= 3.152

| PATTERN #                   | : | 5      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.226  | 1.049  | .864   |
| MINIMUM X                   | : | -1.593 | -1.477 | -1.734 |
| MAXIMUM Y                   | : | 1.052  | .933   | .887   |
| MINIMUM Y                   | : | -1.073 | -.825  | -.871  |
| CENTROID X                  | : | .064   | .241   | .426   |
| CENTROID Y                  | : | .229   | .348   | .394   |
| POA TO CENTROID in.         | : | .237   | .423   | .580   |
| MIN RADIUS                  | : | .052   | .162   | .281   |
| MEAN RADIUS                 | : | .903   | .766   | .661   |
| MAX RADIUS                  | : | 1.921  | 1.523  | .962   |
| HORIZONTAL SPREAD           | : | 2.819  | 2.526  | 1.598  |
| VERTICAL SPREAD             | : | 2.126  | 1.758  | 1.758  |
| EXTREME SPREAD              | : | 3.152  | 2.561  | 1.857  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |