Smead®

UPC

0 47700 25716 7

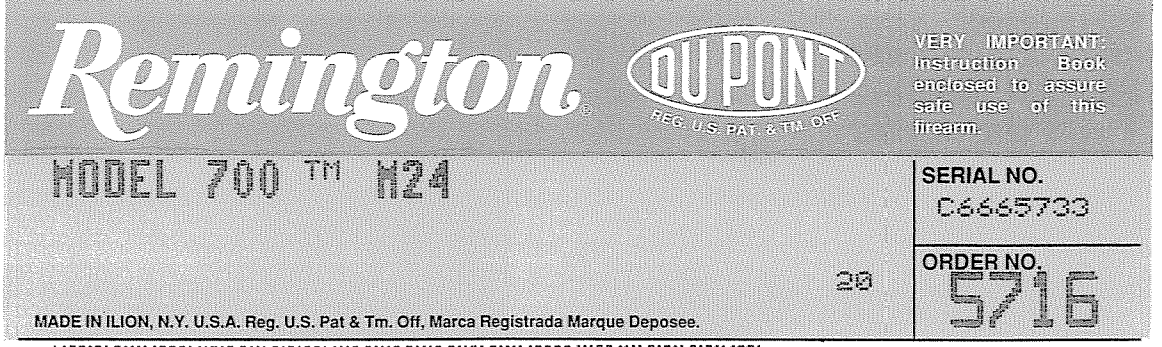
C666573

ORDER NO. 516

BARREL LENGTH

CAPACITY*

MODEL 700 TM M24



ORDER 5716
MODEL 700 TM M24
UPC

ORDER 5716
MODEL 700 TM M24
UPC

MOD. _____ GA. _____ GUN # C6665733
CAL. _____

# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
DH	1st 10-27-91	slide Broke ejector sticks	RW
	2nd 11/2/91	Polished face of Bolt & reamed Ejector hole	KS
	3rd		
	4th		

FUNCTION RD 6654 Rev 1

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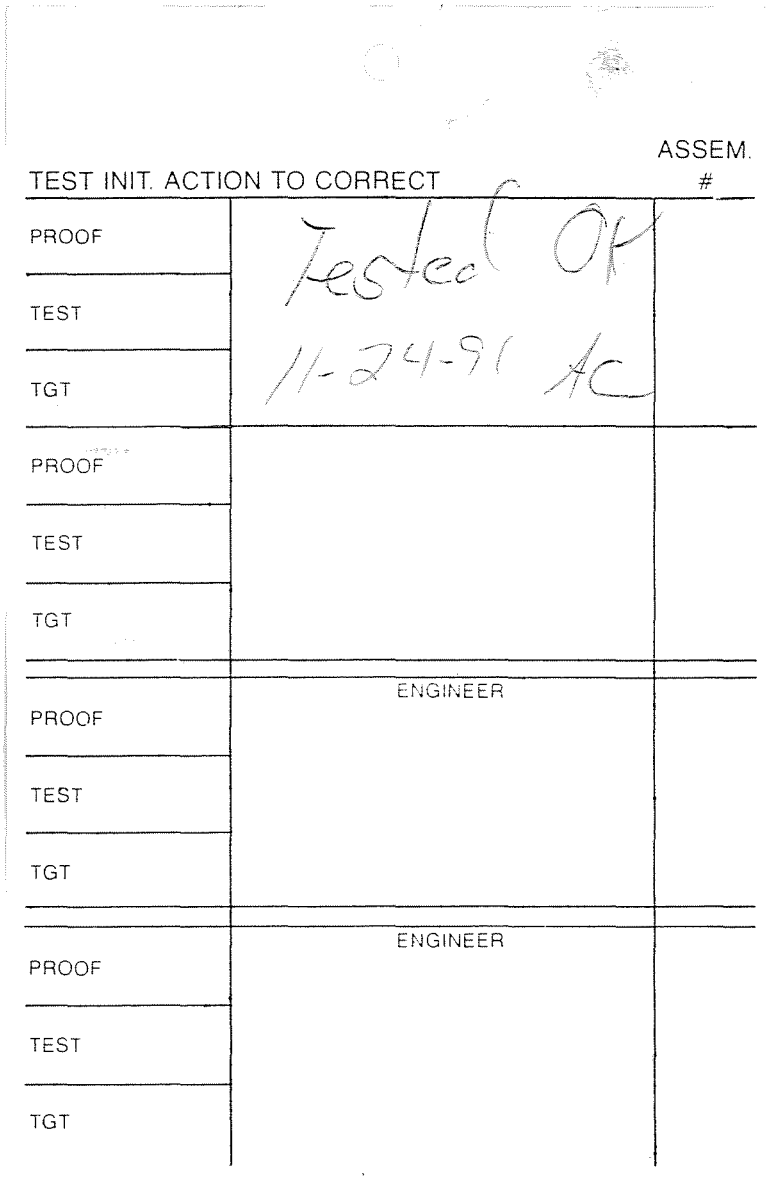
ASSEM.
TEST INIT. ACTION TO CORRECT
#
PROOF
TEST
TGT
Tested OK
11-24-91 AC
PROOF
TEST
TGT
ENGINEER
PROOF
TEST
TGT
ENGINEER
PROOF
TEST
TGT

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665733

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10 1 91	
600	Proof		10 1 91	
607	Check Headspace		1 91	
610	Dis-assemble Gun		91	
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	GS
617	Drill and Tap Sight Holes		OCT 4 1991	
618	Polish Barrel		10/8/91	
620	Apply Coatings (Barrel Action)		10-22-91	
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	
	C) Inspect Ejector Hole for Chamfer		10/22/91	
	D) Oil Firing Pin Ass'y		10/22/91	
	E) Adjust Trigger Pull to Min Setting and Stake		10/25/91	

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op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			10-25-91	AC
	G) Safety Off Force	3	3	3			10-25-91	AC
	H) Trigger Pull Test & Retainability						10/25/91	AC
	I) Firing Pin Indent	.020	.020	.020			10-25-91	AC
	J) Assemble Stock						10/28/91	RW
	K) Assemble Swivel Studs						11-27-91	DH
	L) Attach Front and Rear Sight Assemblies						10/28/91	RW
	M) Iron Sight Alignment						10/28/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/28/91	RW
	O) Attach Scope to Rifle						10/28/91	RW
	P) Detach & Attach Scope 20 Times						10/28/91	RW
640	Gallery Target & Test						10-29-91	DH
	A) Time						10-29-91	DH
	B) Malfunctions						10-29-91	DH
	C) Pierced Primers						10-29-91	DH
	D) Optical Clearity of Scope						10-29-91	DH
645	Inspect for Live Ammo						10-29-91	DH
655	Final Inspection A) Headspace						11-27-91	DH
	B) Trigger Pull	2.53	2.51	2.48	2.33	2.48	11-26-91	DH
	C) Function						11-27-91	DH
660	Pack						12-19-91	[illegible]

SWS TRIGGER PULL TEST

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

SERIAL NO. C6665733

DATE 10/25/91

TESTER

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.27	2.38	2.53	MIN. SETTING,
PULL #2	2.52	2.33	2.36	2.51	NO AVG. OF 5
PULL #3	2.33	2.47	2.28	2.48	READINGS ACCEPT-
PULL #4	2.44	2.27	2.30	2.33	ABLE LESS THAN 2#
PULL #5	2.44	2.31	2.30	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.48		
PULL #2	3.38	3.42		
PULL #3	3.44	3.53		
PULL #4	3.46	3.52		
PULL #5	3.47	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.42		4.31
PULL #2	4.31	4.49		4.36
PULL #3	4.38	4.56		4.40
PULL #4	4.50	4.51		4.32
PULL #5	4.31	4.44		4.46
TOTAL				
AVG.				

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CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # D6665733
29 Oct 1991

CENTROIDAL DISTANCES

0	TO	1	.365308
1	TO	2	.0691158
1	TO	3	.227264
1	TO	4	.10284
1	TO	5	.407443

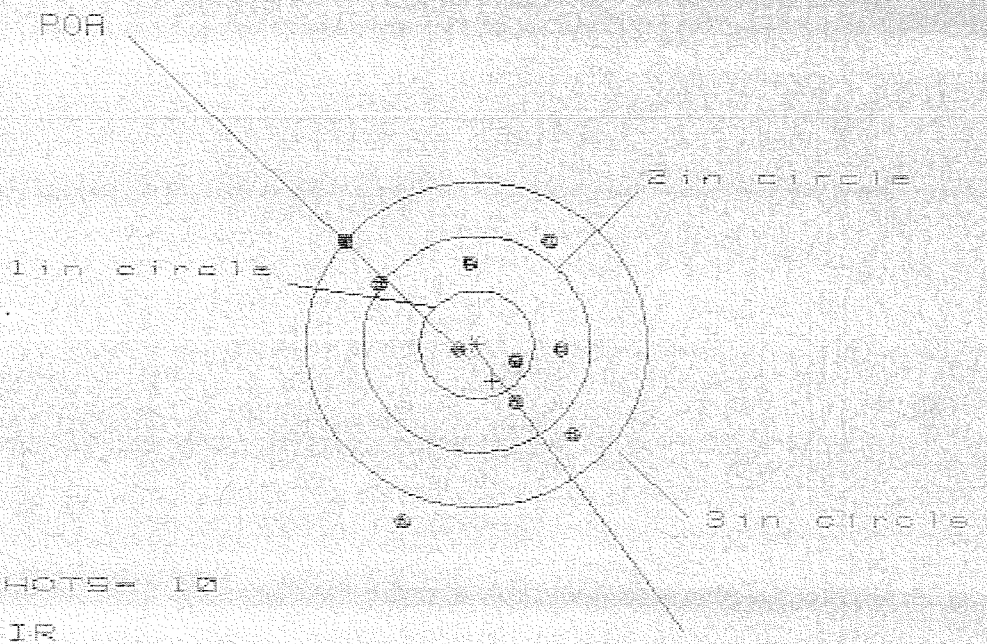
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0664
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .254418

THE AMR FOR THIS RIFLE IS: .9282

29 Oct 1931 FILE:/PATTERNING/CENTERFIRE_PATT/C6685733

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

# IN CIR	
1in =	2
2in =	5
3in =	8

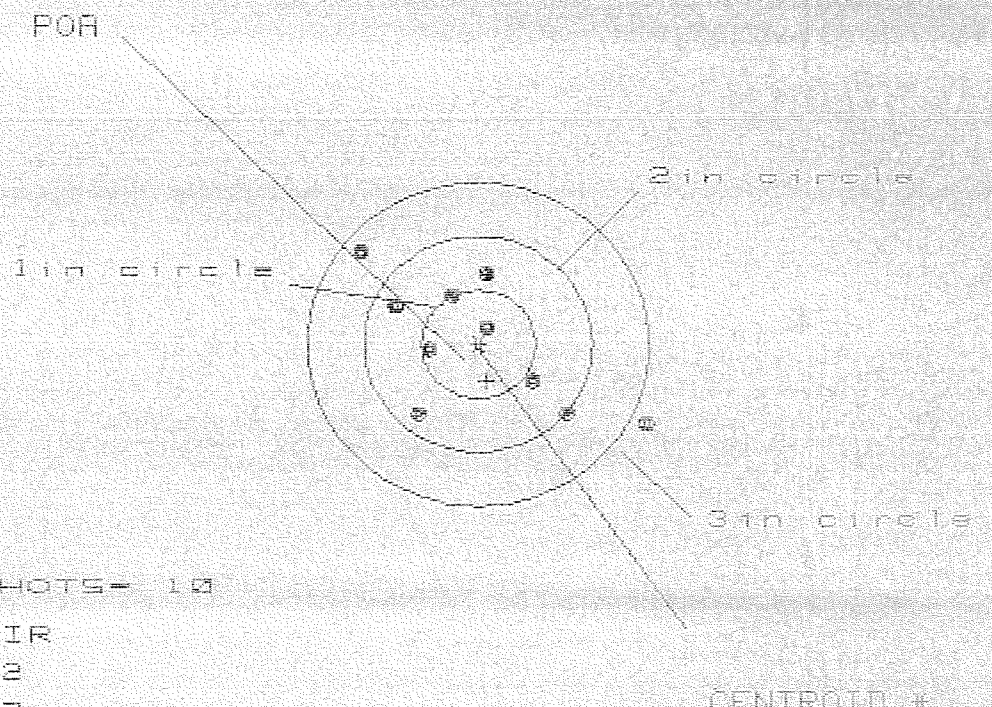
HS= 2.003
VS= 2.560
GS= 2.889

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.736	.577
MINIMUM X	:	-1.193	-1.267	-1.051
MAXIMUM Y	:	.939	.759	.853
MINIMUM Y	:	-1.621	-.994	-.899
CENTROID X	:	-.141	-.067	.092
CENTROID Y	:	.337	.517	.422
POA TO CENTROID in.	:	.365	.521	.432
MIN RADIUS	:	.171	.341	.233
MEAN RADIUS	:	.920	.824	.710
MAX RADIUS	:	1.753	1.477	1.146
HORIZONTAL SPREAD	:	2.003	2.003	1.628
VERTICAL SPREAD	:	2.560	1.753	1.752
EXTREME SPREAD	:	2.889	2.662	2.119

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8

29 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PAT/C6B65733

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

# IN CIR
1in = 2
2in = 7
3in = 8

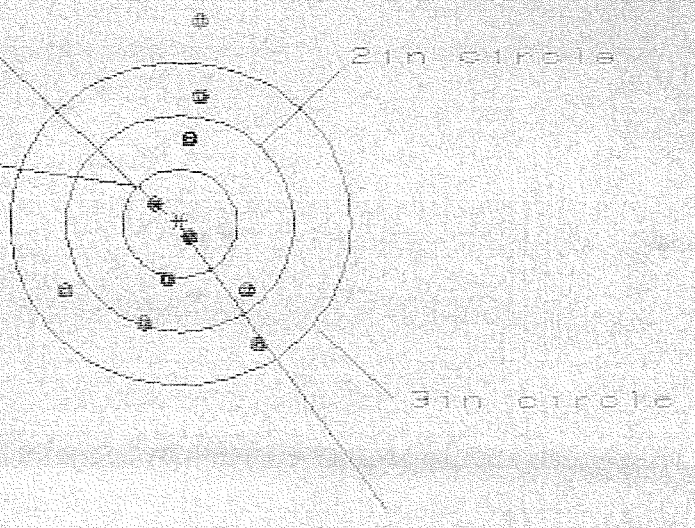
HS= 2.532
VS= 1.508
GS= 2.947

PATTERN #	:	2	
SHOTS (BEST OF)	:	10	9 8
MAXIMUM X	:	1.517	.965 .860
MINIMUM X	:	-1.015	-.847 -.623
MAXIMUM Y	:	.810	.732 .707
MINIMUM Y	:	-.698	-.759 -.667
CENTROID X	:	-.072	-.240 -.135
CENTROID Y	:	.341	.419 .327
POA TO CENTROID in.	:	.349	.483 .354
MIN RADIUS	:	.156	.229 .197
MEAN RADIUS	:	.800	.675 .625
MAX RADIUS	:	1.670	1.228 1.088
HORIZONTAL SPREAD	:	2.532	1.812 1.483
VERTICAL SPREAD	:	1.508	1.491 1.374
EXTREME SPREAD	:	2.947	2.347 1.804

NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 9

29 Oct [98] FILE:/PATTERNING/CENTERFIRE_PATT/C0665703

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

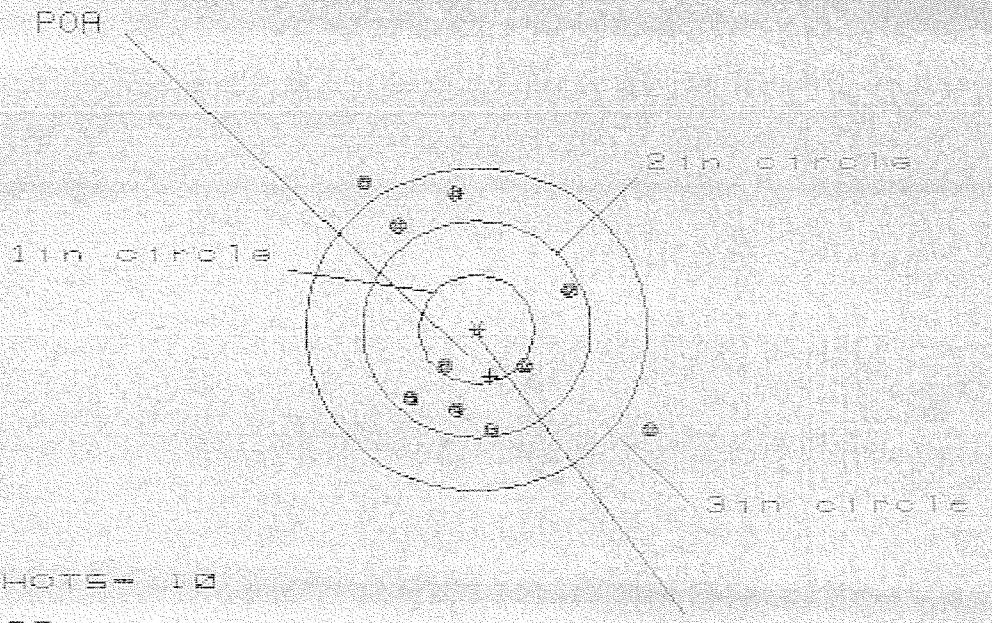
# IN CIR	
1in	= 3
2in	= 6
3in	= 9

HS=	1.758
VS=	3.022
GS=	3.071

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.699	.716	.670
MINIMUM X	:	-1.059	-1.042	-.953
MAXIMUM Y	:	1.876	1.403	1.286
MINIMUM Y	:	-1.146	-.938	-.836
CENTROID X	:	-.084	-.101	-.190
CENTROID Y	:	.117	-.091	.026
POA TO CENTROID in.	:	.144	.136	.192
MIN RADIUS	:	.188	.112	.207
MEAN RADIUS	:	.915	.772	.727
MAX RADIUS	:	1.882	1.417	1.317
HORIZONTAL SPREAD	:	1.758	1.758	1.623
VERTICAL SPREAD	:	3.022	2.341	2.122
EXTREME SPREAD	:	3.071	2.398	2.235
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C8685733

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

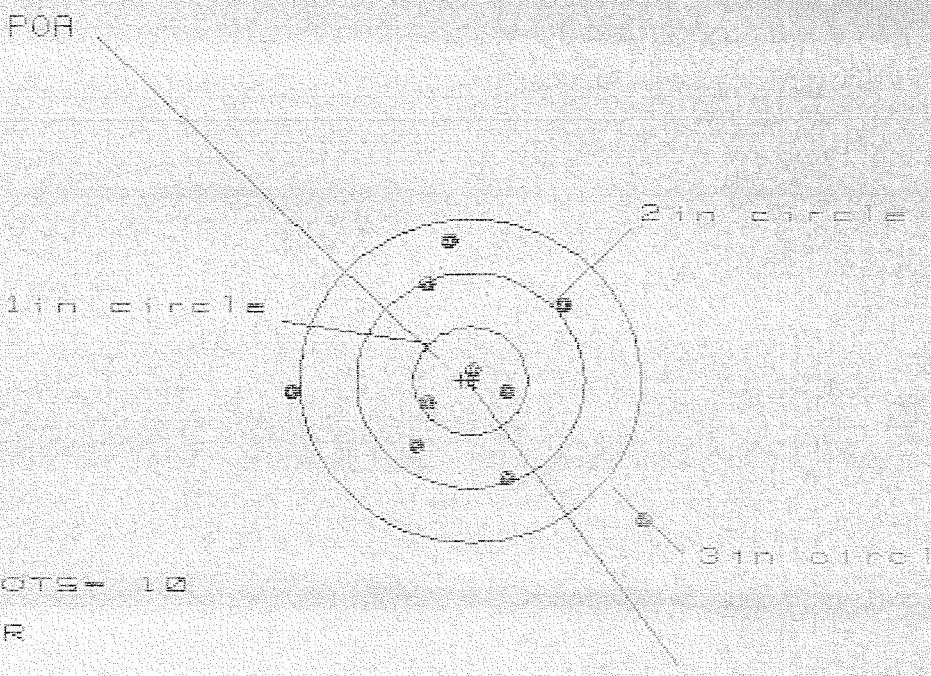
# IN CIR
1in = 1
2in = 6
3in = 8

HS= 2.561
VS= 2.278
GS= 3.414

PATTERN #	:	4	
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.547	.975	.870
MINIMUM X	:	-1.014	-.842	-.604
MAXIMUM Y	:	1.315	1.210	1.342
MINIMUM Y	:	-.963	-1.068	-.917
CENTROID X	:	-.117	-.289	-.184
CENTROID Y	:	.437	.542	.391
POA TO CENTROID in.	:	.453	.614	.432
MIN RADIUS	:	.413	.437	.336
MEAN RADIUS	:	1.051	.973	.867
MAX RADIUS	:	1.812	1.474	1.344
HORIZONTAL SPREAD	:	2.561	1.817	1.474
VERTICAL SPREAD	:	2.278	2.278	2.259
EXTREME SPREAD	:	3.414	2.538	2.272
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

29 Oct 1991 FILE:/PATTERNING/CENTERFIRE_PATT/CAB85733

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

# IN CIR	
1in =	3
2in =	6
3in =	8

HS= 3.000
VS= 2.514
GS= 3.299

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.477	1.028	.849
MINIMUM X	:	-1.603	-1.439	-.526
MAXIMUM Y	:	1.265	1.126	1.101
MINIMUM Y	:	-1.249	-1.034	-1.059
CENTROID X	:	.082	-.082	.097
CENTROID Y	:	-.004	.135	.160
POA TO CENTROID in.	:	.082	.158	.188
MIN RADIUS	:	.148	.188	.020
MEAN RADIUS	:	.955	.845	.739
MAX RADIUS	:	1.935	1.453	1.115
HORIZONTAL SPREAD	:	3.080	2.467	1.375
VERTICAL SPREAD	:	2.514	2.160	2.160
EXTREME SPREAD	:	3.299	2.595	2.210

NUMBER IN ONE INCH CIRCLE = 3
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 8