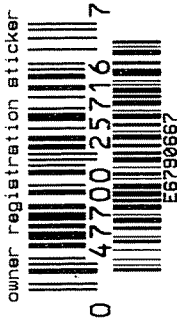


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MODEL 700[™] M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

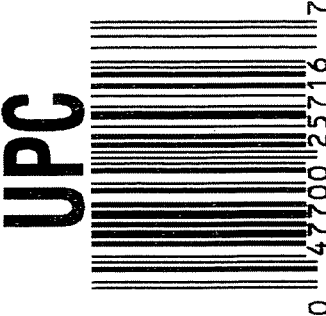
- DOCUMENT ENVELOPE ASSEMBLY:
- INSTRUCTION BOOK
 - PRODUCT OWNER'S CARD
 - SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

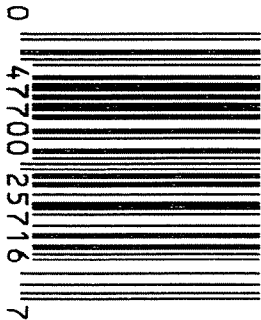
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SERIAL NO.

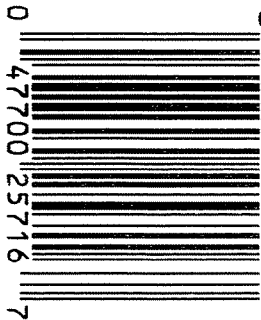


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0 47700 25716 7

ORDER 25716
MODEL 700™ M24
UPC



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MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.

5716 E6790667

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO. J E6790667
ORDER NO. 25716
46
22BW

CONTRACT #

GUN SERIAL # E6790677

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/9/01	WTH
600	PROOF		11/9/01	RTH
607	CHECK HEADSPACE		11/9/01	WTH
610	DIS-ASSEMBLE GUN		11/9/01	RTH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			AL
615	ROLLMARK CALIBER		11/15-01	WTH
617	DRILL AND TAP SIGHT HOLES		11/15	SWT
620	APPLY COATINGS (BARREL ACTION)		11-27	TA
	(BOLT)		11-27	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		12-14	Doog
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-14	Doog
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-14	Doog
	D) OIL FIRING PIN ASSEMBLY		12-14	Doog
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1-16-02	DA

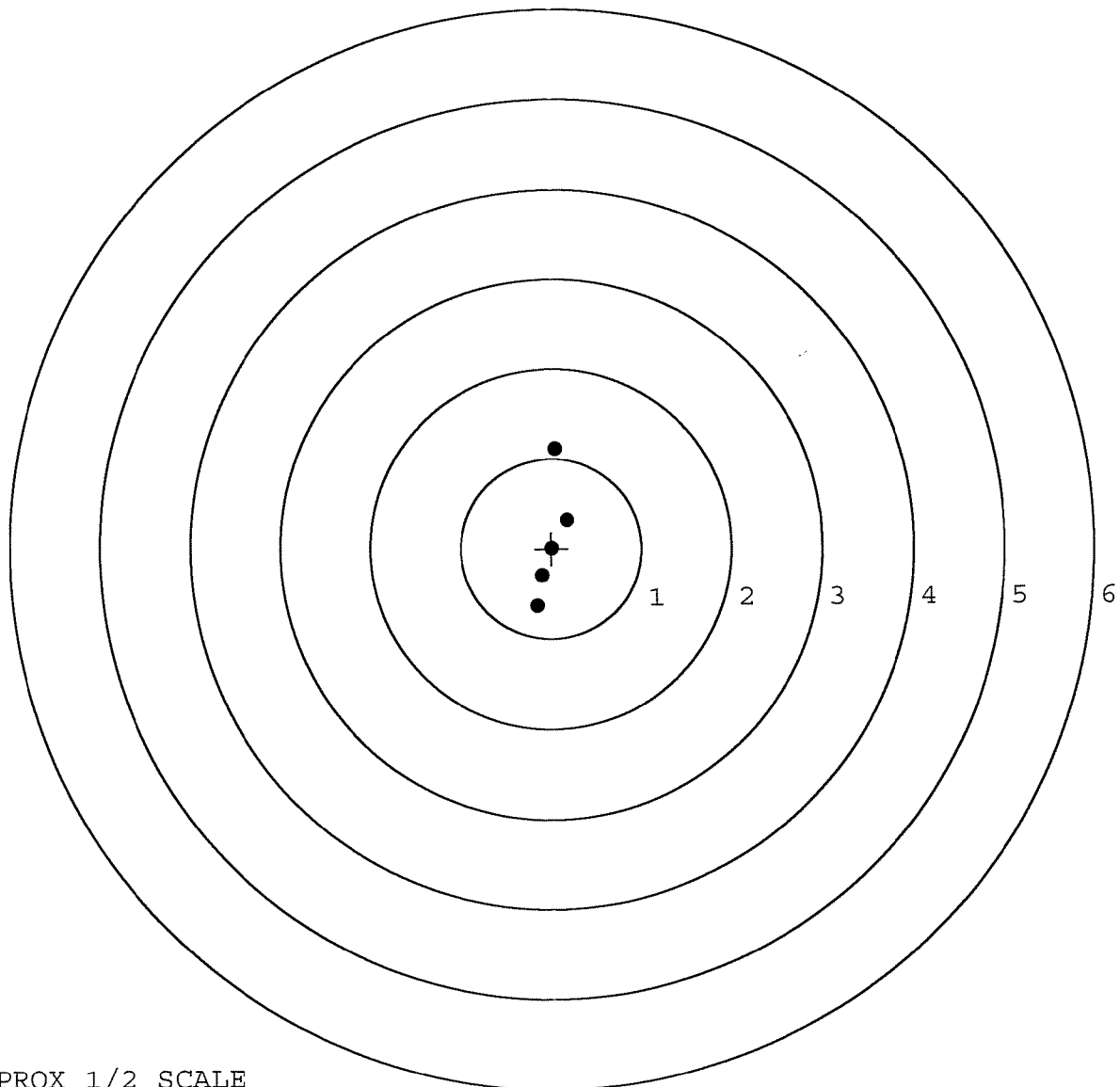
OP # OPERATION NAME		READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.50</u>	<u>4.50</u>	<u>4.25</u>	1/3/02	D.M.
CONT.						
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.75</u>	<u>2.75</u>	<u>2.75</u>	1/3/02	D.M.
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>.023</u>	<u>.024</u>	<u>.028</u>	1/3/02	D.M.
	J) ASSEMBLE STOCK				12/17	BWT
	K) ASSEMBLE SWIVEL STUDS				1/15/02	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				1/15/02	RW
	M) IRON SIGHT ALIGNMENT				1/15/02	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				1/15/02	RW
640	GALLERY TEST AND TARGET	PASS	FAIL		12-18-01	A
	A) MALFUNCTIONS	<u>PASS</u>	FAIL	Soft birds	12-18-01	A
	B) PIERCED PRIMERS	PASS	FAIL		12-18-01	A
645	INSPECT FOR LIVE AMMO				12-18-01	A
655	FINAL INSPECTION A) HEADSPACE				1/15/02	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u>	<u>2.69</u>	<u>2.30</u> <u>2.54</u> <u>2.33</u>	1/4/01	D.M.
	C) FUNCTION				1/15/02	RW
660	PACK				1-16-02	DA

BARBER - M24 0112204

SERIAL NUMBER ~~E6~~6790667. __0
TARGET NUMBER: 1
FILE DATE: 01/02/2002
FILE TIME: 01:15

POINT#	X	Y
1:	-0.003	0.000
2:	0.040	1.110
3:	0.178	0.318
4:	-0.163	-0.643
5:	-0.113	-0.304

X CENTROID: -0.012
Y CENTROID: 0.096
POA TO CENTROID: 0.097
HORZ SPREAD: 0.341
VERT SPREAD: 1.753
GROUP SPREAD: 1.765
MIN RADIUS: 0.097
MAX RADIUS: 1.015
MEAN RADIUS: 0.514
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



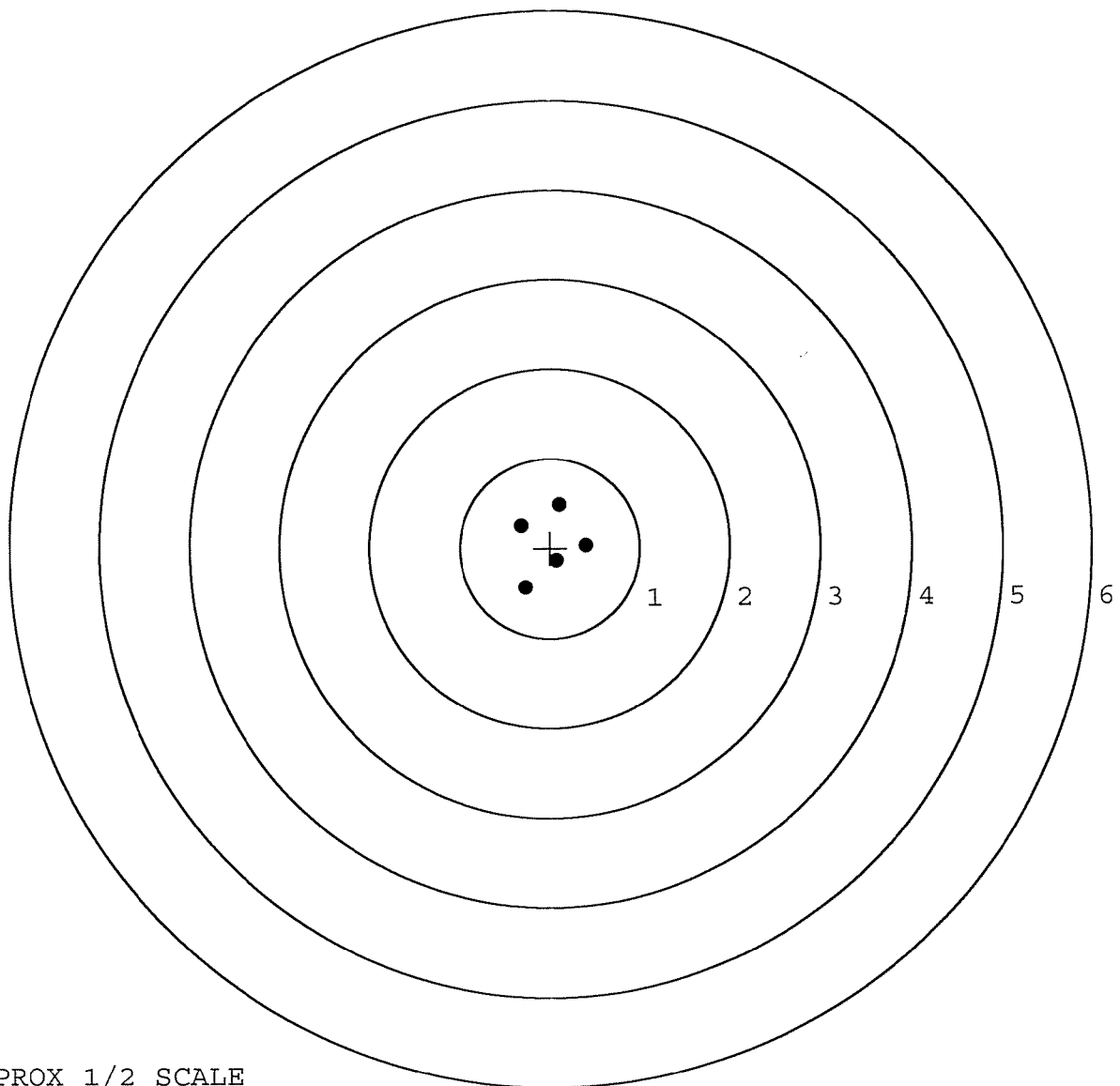
TARGET APPROX 1/2 SCALE

BARBER - M24 0112205

SERIAL NUMBER ~~E6~~790667. __0
TARGET NUMBER: 2
FILE DATE: 01/02/2002
FILE TIME: 01:15

POINT#	X	Y
1:	0.102	0.481
2:	-0.324	0.251
3:	0.404	0.028
4:	0.067	-0.145
5:	-0.275	-0.443

X CENTROID: -0.005
Y CENTROID: 0.034
POA TO CENTROID: 0.035
HORZ SPREAD: 0.728
VERT SPREAD: 0.924
GROUP SPREAD: 0.998
MIN RADIUS: 0.193
MAX RADIUS: 0.548
MEAN RADIUS: 0.399
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

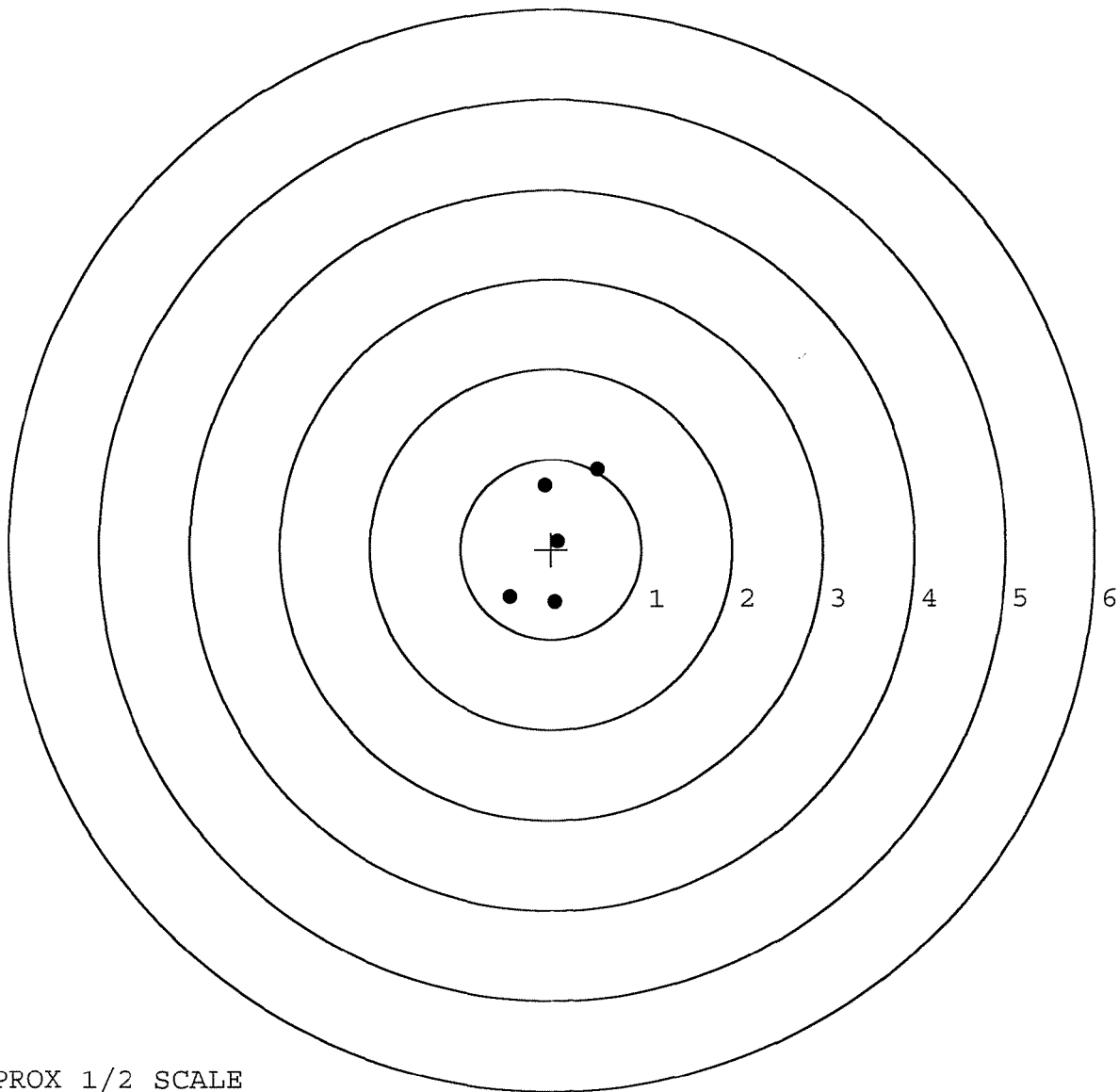
BARBER - M24 0112206

SERIAL NUMBER: 6790667. __0
TARGET NUMBER: 1
FILE DATE: 12/18/2001
FILE TIME: 04:56

POINT#	X	Y
1:	0.514	0.887
2:	-0.074	0.709
3:	0.070	0.090
4:	-0.463	-0.533
5:	0.036	-0.589

X CENTROID: 0.017
Y CENTROID: 0.113
POA TO CENTROID: 0.114
HORZ SPREAD: 0.977
VERT SPREAD: 1.476
GROUP SPREAD: 1.724
MIN RADIUS: 0.058
MAX RADIUS: 0.920
MEAN RADIUS: 0.618
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 5

Failed Target



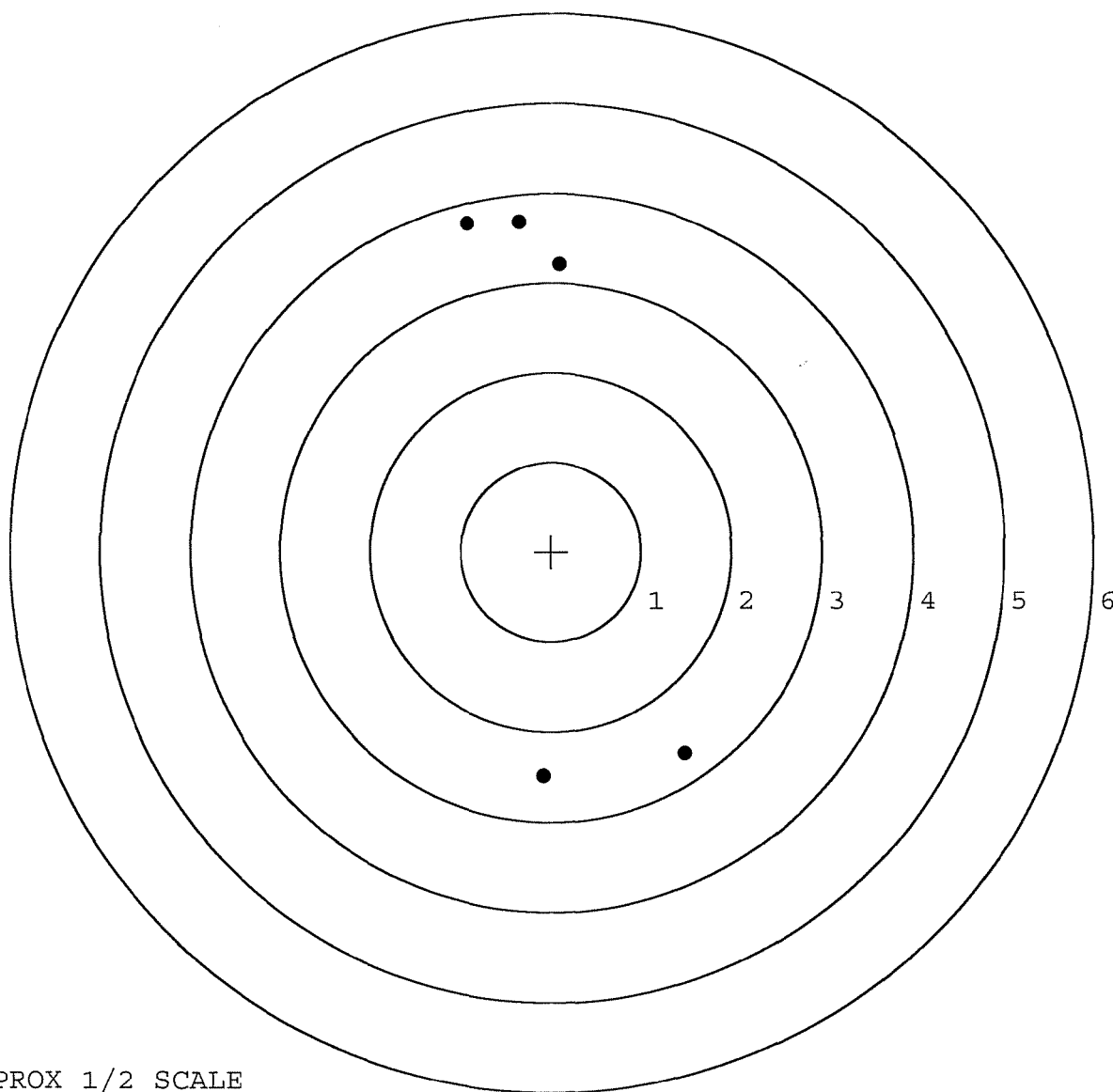
TARGET APPROX 1/2 SCALE

BARBER - M24 0112207

SERIAL NUMBER: 6790667. __0
TARGET NUMBER: 2
FILE DATE: 12/18/2001
FILE TIME: 04:56

POINT#	X	Y
1:	0.093	3.205
2:	-0.364	3.675
3:	-0.937	3.655
4:	1.487	-2.241
5:	-0.091	-2.499

X CENTROID: 0.038
Y CENTROID: 1.159
POA TO CENTROID: 1.160
HORZ SPREAD: 2.424
VERT SPREAD: 6.174
GROUP SPREAD: 6.375
MIN RADIUS: 2.047
MAX RADIUS: 3.696
MEAN RADIUS: 2.926
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 0
in 3 IN DIAMETER: 0



TARGET APPROX 1/2 SCALE

BARBER - M24 0112208

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6790677

DATE 10/31/01

TESTER R.N.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.91		2.70 2.84	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.80		2.71	
PULL #3	2.18	2.77		2.71	
PULL #4	2.57	2.58		2.63	
PULL #5	2.29	2.84		3.09	
TOTAL	11.65	13.90		13.87	
AVG.	2.37	2.78		2.77	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.65	3.80		
PULL #2	3.67	3.71		
PULL #3	3.40	3.70		
PULL #4	3.47	3.48		
PULL #5	3.50	3.23		
TOTAL	17.69	17.92		
AVG.	3.54	3.58		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.70		4.64
PULL #2	4.70	4.79		4.63
PULL #3	4.58	4.68		4.65
PULL #4	4.57	4.81		4.13
PULL #5	4.67	4.60		4.66
TOTAL	23.07	23.58		22.71
AVG.	4.61	4.72		4.54