

E6761589

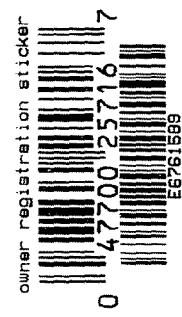
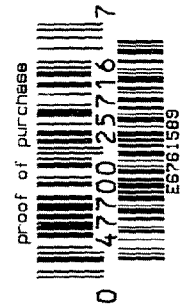
MODEL 700TM M24
ORDER
25716

		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
		SERIAL NO. J E6761589	
MODEL 700TM M24 BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO		46	ORDER NO. 25716
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		17XV	
		5716 E6761589	

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

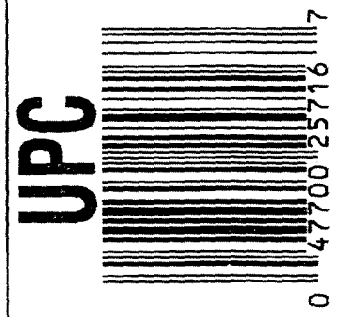
- DOCUMENT ENVELOPE ASSEMBLY:
- INSTRUCTION BOOK
 - PRODUCT OWNER'S CARD
 - SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

E6761589



ORDER

25716

MODEL 700TH M24

UPC



0 47700 25716 7

ORDER

25716

MODEL 700TH M24

UPC



0 47700 25716 7

SERIAL NO.



E6761589

CONTRACT #

GUN SERIAL #

E6761589

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		OCT 29 - 01	RW
600	PROOF		OCT 29 - 01	RW
607	CHECK HEADSPACE		OCT 29 - 01	RW
610	DIS-ASSEMBLE GUN		OCT 29 - 01	RW
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			AL
615	ROLLMARK CALIBER		11/2	B
617	DRILL AND TAP SIGHT HOLES		11/7	BWT
620	APPLY COATINGS (BARREL ACTION)		11/8	HP
	(BOLT)		11/8	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-14-01	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-14-01	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-14-01	DA
	D) OIL FIRING PIN ASSEMBLY		11-14-01	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12/10/01	DA

BARBER - M24 0113765			READINGS			DATE	INITIAL		
OP #	OPERATION NAME								
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6.0</u>	<u>6.5</u>	<u>6.0</u>	11/27	BK		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u> <u>4.0</u>	<u>4.0</u> <u>4.0</u>	<u>3.5</u> <u>3.5</u>	11/27	BK		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.022</u>	<u>.022</u>	11/27	BK		
	J) ASSEMBLE STOCK					11/14/01	KT		
	K) ASSEMBLE SWIVEL STUDS					12/10/01	Rep		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					12/10/01	Rep		
	M) IRON SIGHT ALIGNMENT					12/10/01	Rep		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					12/10/01	Rep		
640	GALLERY TEST AND TARGET		PASS FAIL			11/14/01	KT		
	A) MALFUNCTIONS		PASS FAIL			11/14/01	KT		
	B) PIERCED PRIMERS		PASS FAIL			11/14/01	KT		
645	INSPECT FOR LIVE AMMO					11/14/01	KT		
655	FINAL INSPECTION A) HEADSPACE					12/10/01	Rep		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u>	<u>2.75</u>	<u>2.77</u>	<u>2.75</u>	<u>2.64</u>	11-27-01	DA
	C) FUNCTION					12/10/01	Rep		
660	PACK					12/10/01	DA		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6761589DATE 11/13/01TESTER D.M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.65		2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.75		2.22	
PULL #3	2.41	2.79		2.44	
PULL #4	2.24	2.64		2.39	
PULL #5	2.01	2.44		2.40	
TOTAL	11.39	13.27		11.83	
AVG.	2.28	2.65		2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.33		
PULL #2	3.40	3.35		
PULL #3	3.23	3.42		
PULL #4	3.24	3.13		
PULL #5	3.16	3.37		
TOTAL	16.26	16.60		
AVG.	3.25	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.24		4.45
PULL #2	4.23	4.37		4.12
PULL #3	4.29	4.09		4.16
PULL #4	4.09	4.25		4.37
PULL #5	4.14	4.36		4.25
TOTAL	21.13	21.31		21.35
AVG.	4.23	4.26		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6761589.__0
FILE DATE AND TIME: 11/14/2001 10:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.048
The Average Y Centroid of the Five Target Set:	0.028
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	1.119
The Distance from POA to Centroid Target #1:	0.176
The Distance from Centroid Target #2 to Centroid Target #1:	0.213
The Distance from Centroid Target #3 to Centroid Target #1:	0.191
The Distance from Centroid Target #4 to Centroid Target #1:	0.177
The Distance from Centroid Target #5 to Centroid Target #1:	0.406

BARBER - M24 0113768

SERIAL NUMBER: E6761589. __0

TARGET NUMBER: 1

FILE DATE: 11/14/2001

FILE TIME: 10:43

X CENTROID: -0.124

Y CENTROID: -0.125

POA TO CENTROID: 0.176

HORZ SPREAD: 2.143

VERT SPREAD: 3.687

GROUP SPREAD: 3.769

MIN RADIUS: 0.333

MAX RADIUS: 2.067

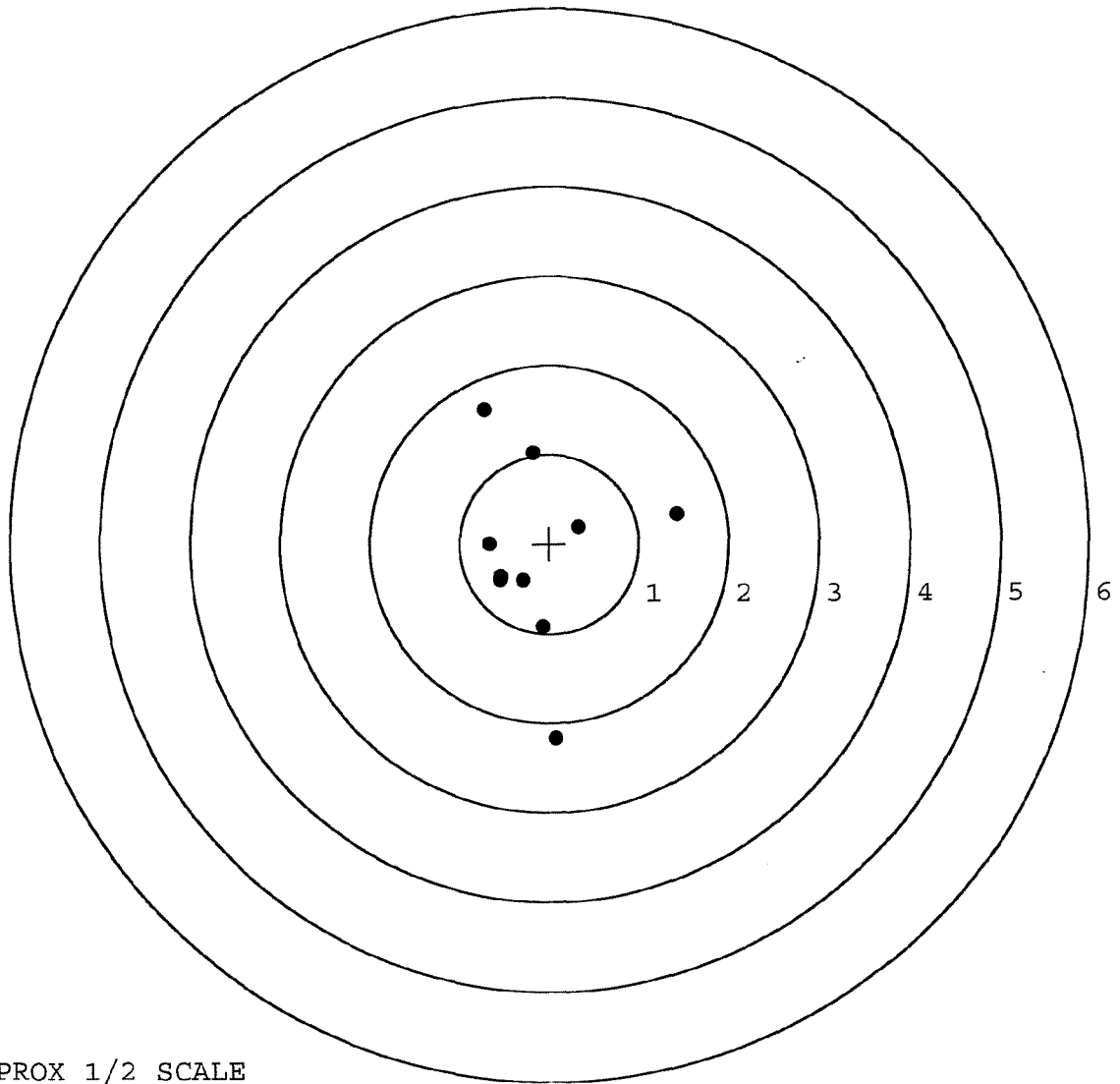
MEAN RADIUS: 0.979

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.723	1.503
2:	-0.186	1.016
3:	-0.661	0.001
4:	-0.551	-0.405
5:	-0.297	-0.409
6:	0.326	0.192
7:	-0.082	-0.931
8:	1.420	0.333
9:	0.061	-2.184
10:	-0.543	-0.364



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6761589. 0

TARGET NUMBER: 2

FILE DATE: 11/14/2001

FILE TIME: 10:43

X CENTROID: 0.057

Y CENTROID: -0.012

POA TO CENTROID: 0.059

HORZ SPREAD: 2.162

VERT SPREAD: 3.404

GROUP SPREAD: 3.460

MIN RADIUS: 0.539

MAX RADIUS: 1.838

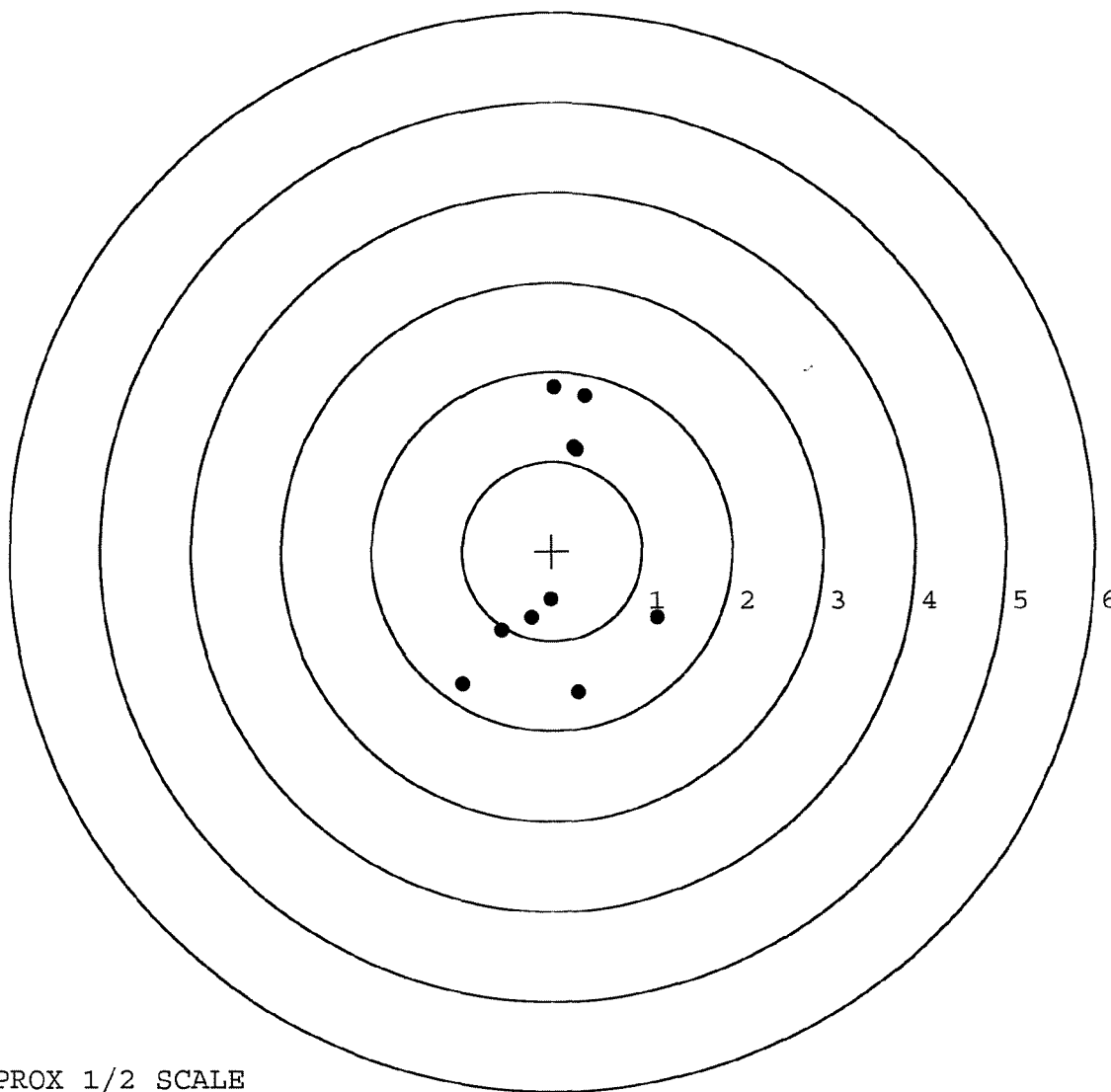
MEAN RADIUS: 1.308

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.015	-0.546
2:	-0.231	-0.742
3:	-0.565	-0.881
4:	-0.993	-1.483
5:	0.298	-1.579
6:	1.169	-0.744
7:	0.365	1.732
8:	0.022	1.825
9:	0.245	1.160
10:	0.278	1.135



TARGET APPROX 1/2 SCALE

BARBER - M24 0113770

SERIAL NUMBER: E6761589. __0

TARGET NUMBER: 3

FILE DATE: 11/14/2001

FILE TIME: 10:43

POINT#	X	Y
1:	0.906	0.709
2:	0.521	0.363
3:	-0.098	1.079
4:	-0.131	0.311
5:	-0.614	0.374
6:	-1.389	-0.045
7:	-0.749	-0.594
8:	0.223	-0.760
9:	0.566	-1.446
10:	0.562	0.370

X CENTROID: -0.020

Y CENTROID: 0.036

POA TO CENTROID: 0.041

HORZ SPREAD: 2.295

VERT SPREAD: 2.525

GROUP SPREAD: 2.611

MIN RADIUS: 0.296

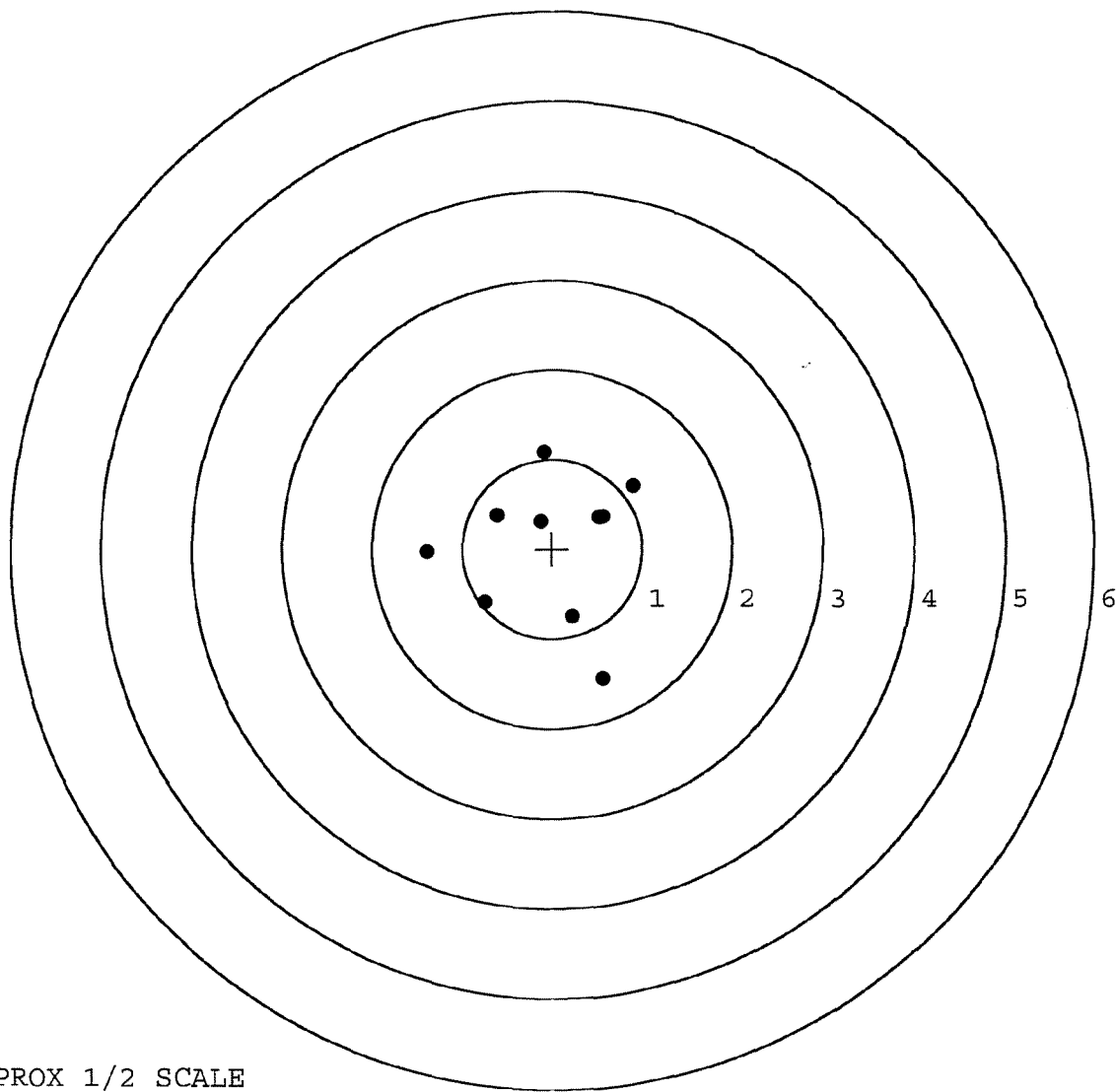
MAX RADIUS: 1.594

MEAN RADIUS: 0.923

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6761589. __0

TARGET NUMBER: 4

FILE DATE: 11/14/2001

FILE TIME: 10:43

X CENTROID: -0.233

Y CENTROID: 0.014

POA TO CENTROID: 0.233

HORZ SPREAD: 3.112

VERT SPREAD: 2.976

GROUP SPREAD: 3.654

MIN RADIUS: 0.416

MAX RADIUS: 2.267

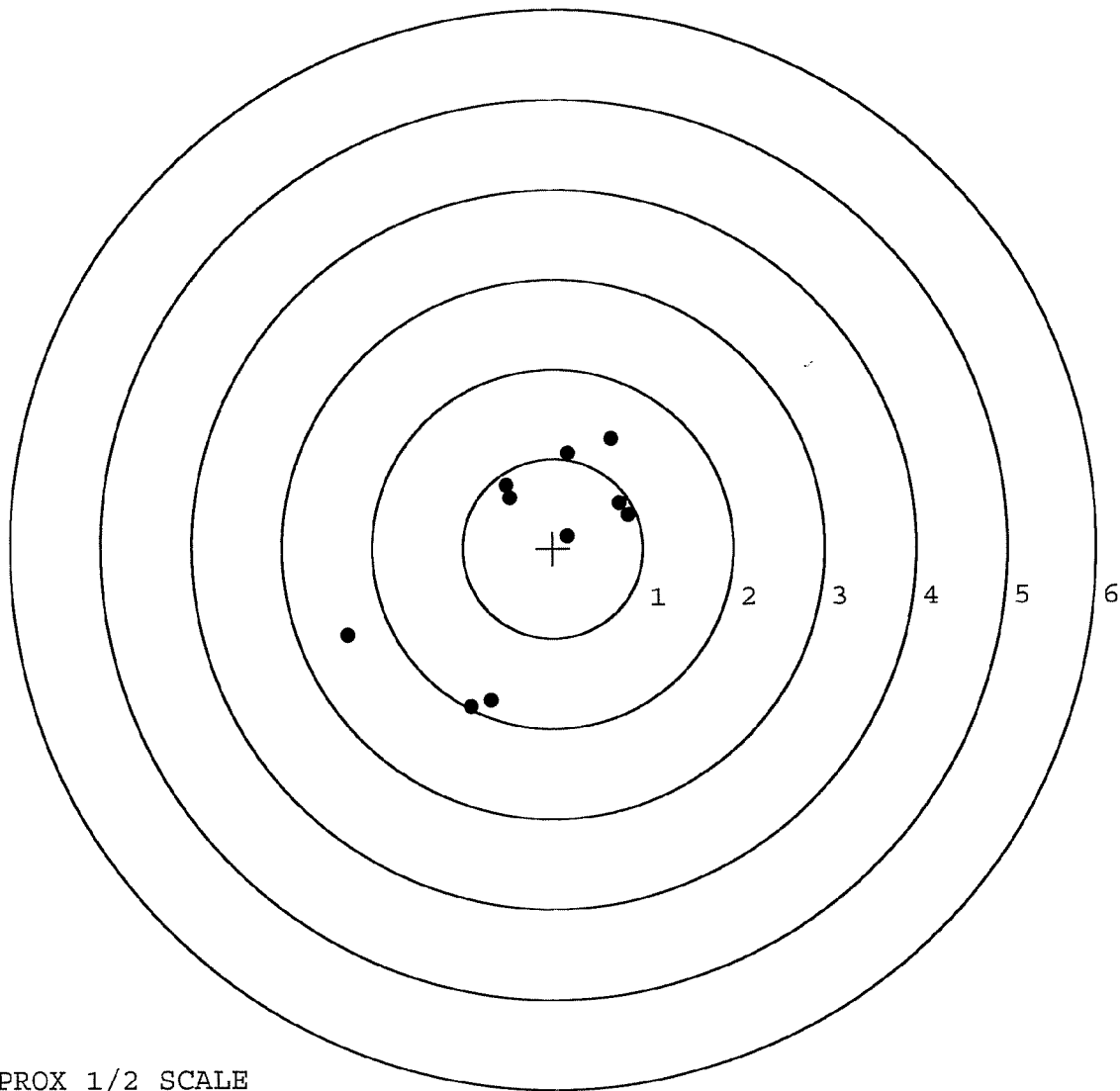
MEAN RADIUS: 1.252

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.653	1.217
2:	0.167	1.057
3:	0.834	0.373
4:	0.734	0.503
5:	-0.694	-1.691
6:	-0.916	-1.759
7:	-2.278	-0.965
8:	-0.475	0.566
9:	-0.517	0.701
10:	0.164	0.138



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6761589. 0

TARGET NUMBER: 5

FILE DATE: 11/14/2001

FILE TIME: 10:43

X CENTROID: 0.080

Y CENTROID: 0.226

POA TO CENTROID: 0.240

HORZ SPREAD: 2.467

VERT SPREAD: 3.130

GROUP SPREAD: 3.706

MIN RADIUS: 0.507

MAX RADIUS: 2.625

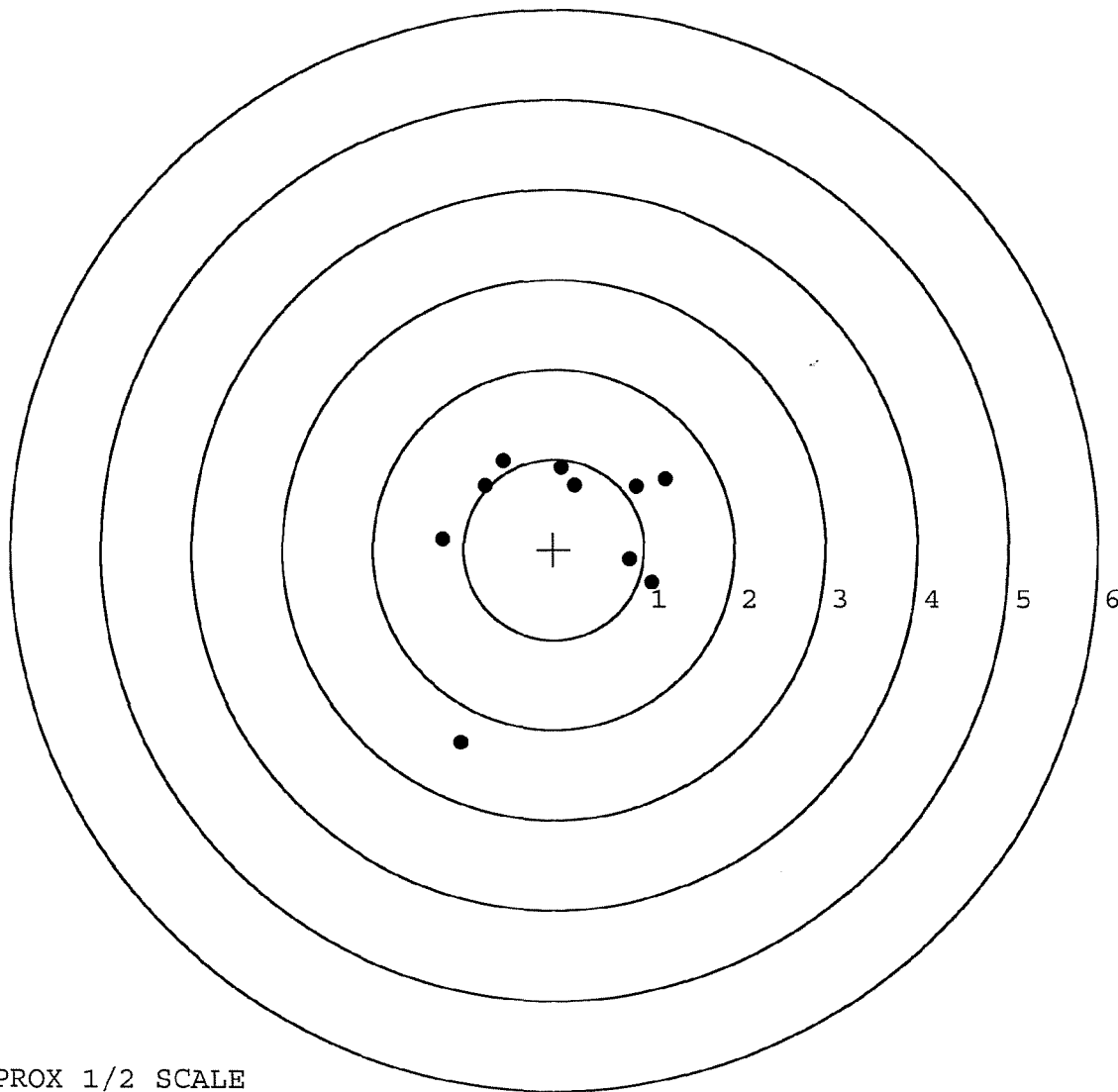
MEAN RADIUS: 1.133

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.238	0.778
2:	0.908	0.697
3:	1.092	-0.368
4:	0.844	-0.108
5:	-1.229	0.112
6:	-0.764	0.700
7:	-0.566	0.979
8:	0.084	0.910
9:	0.227	0.711
10:	-1.033	-2.151



TARGET APPROX 1/2 SCALE