

E6790236

MODEL 700™ M24

UPC



0 47700 25716 7

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SERIAL NO.



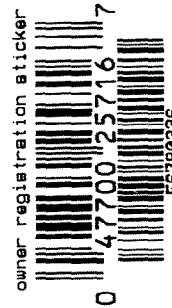
E6790236

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

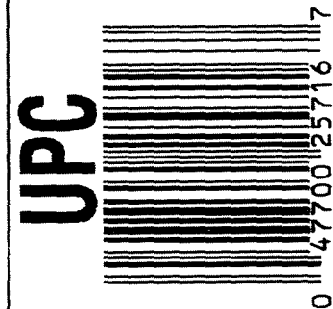


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790236



GUN SERIAL # E6790236

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-3	DK
600	PROOF		11-3	DK
607	CHECK HEADSPACE		11-3	DK
610	DIS-ASSEMBLE GUN		11-3	DK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		11-3	al
615	ROLLMARK CALIBER		11/6	Ⓟ
617	DRILL AND TAP SIGHT HOLES		11/7	BWT
620	APPLY COATINGS (BARREL ACTION)		11/9	HP
	(BOLT)		11/9	HP
625	FINAL ASSEMBLY		12-2	DK
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-2	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-2	DK
	D) OIL FIRING PIN ASSEMBLY		12-2	PK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12/9/01	DA

BARBER - M24 0117155			READINGS			DATE	INITIAL		
OP #	OPERATION NAME								
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3.5</u>	<u>3.5</u>	<u>3.5</u>	12/9/01	DA		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.2</u>	<u>2.2</u>	<u>2.2</u>	12/9/01	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.021</u>	<u>.021</u>	<u>.022</u>	12/9/01	DA		
	J) ASSEMBLE STOCK					12-5-01	RW		
	K) ASSEMBLE SWIVEL STUDS					12/11/01	Rep		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					12/11/01	Rep		
	M) IRON SIGHT ALIGNMENT					12/11/01	Rep		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					12/11/01	Rep		
640	GALLERY TEST AND TARGET		PASS FAIL			12501	KT		
	A) MALFUNCTIONS		PASS FAIL			12501	KT		
	B) PIERCED PRIMERS		PASS FAIL			12501	KT		
645	INSPECT FOR LIVE AMMO					12501	KT		
655	FINAL INSPECTION A) HEADSPACE					12/11/01	Rep		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u>	<u>2.16</u>	<u>2.29</u>	<u>2.13</u>	<u>2.26</u>	12/10/01	AM
	C) FUNCTION					12/11/01	Rep		
660	PACK					12/11/01	DA		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. FL790236

DATE 12/3/01

TESTER J. M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.67	2.25		2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.69	2.26		2.49	
PULL #3	2.72	2.27		2.46	
PULL #4	2.71	2.20		2.50	
PULL #5	2.68	2.15		2.53	
TOTAL	13.47	11.13		12.42	
AVG.	2.69	2.23		2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.29		
PULL #2	3.36	3.24		
PULL #3	3.34	3.31		
PULL #4	3.35	3.31		
PULL #5	3.26	3.35		
TOTAL	16.64	16.50		
AVG.	3.33	3.30		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.19		4.26
PULL #2	4.30	4.47		4.17
PULL #3	4.29	4.31		4.33
PULL #4	4.33	4.26		4.27
PULL #5	4.32	4.40		4.25
TOTAL	21.43	21.63		21.28
AVG.	4.29	4.33		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790236.___0

FILE DATE AND TIME: 12/05/2001 11:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

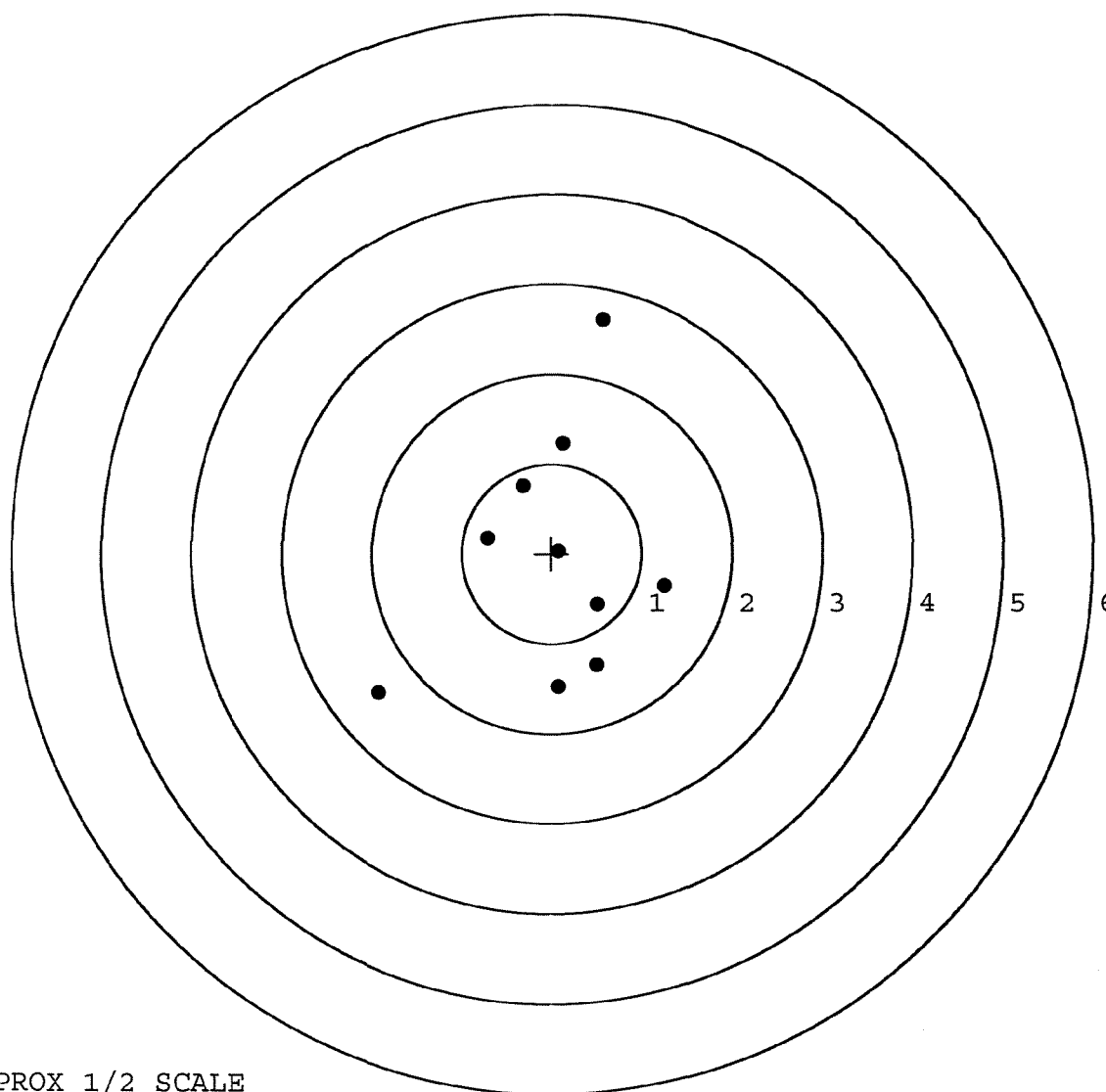
The Average X Centroid of the Five Target Set:	-0.037
The Average Y Centroid of the Five Target Set:	-0.124
The Average Point of Impact of the Five Target Set:	0.129
The Average Mean Radius of the Five Target Set:	0.955
The Distance from POA to Centroid Target #1:	0.044
The Distance from Centroid Target #2 to Centroid Target #1:	0.210
The Distance from Centroid Target #3 to Centroid Target #1:	0.127
The Distance from Centroid Target #4 to Centroid Target #1:	0.066
The Distance from Centroid Target #5 to Centroid Target #1:	0.266

BARBER - M24 0117158

SERIAL NUMBER: E6790236. __0
 TARGET NUMBER: 1
 FILE DATE: 12/05/2001
 FILE TIME: 11:10

POINT#	X	Y
1:	1.253	-0.367
2:	0.513	-0.567
3:	0.506	-1.245
4:	0.076	-1.480
5:	-1.921	-1.542
6:	-0.714	0.178
7:	-0.325	0.754
8:	0.120	1.227
9:	0.567	2.598
10:	0.075	0.028

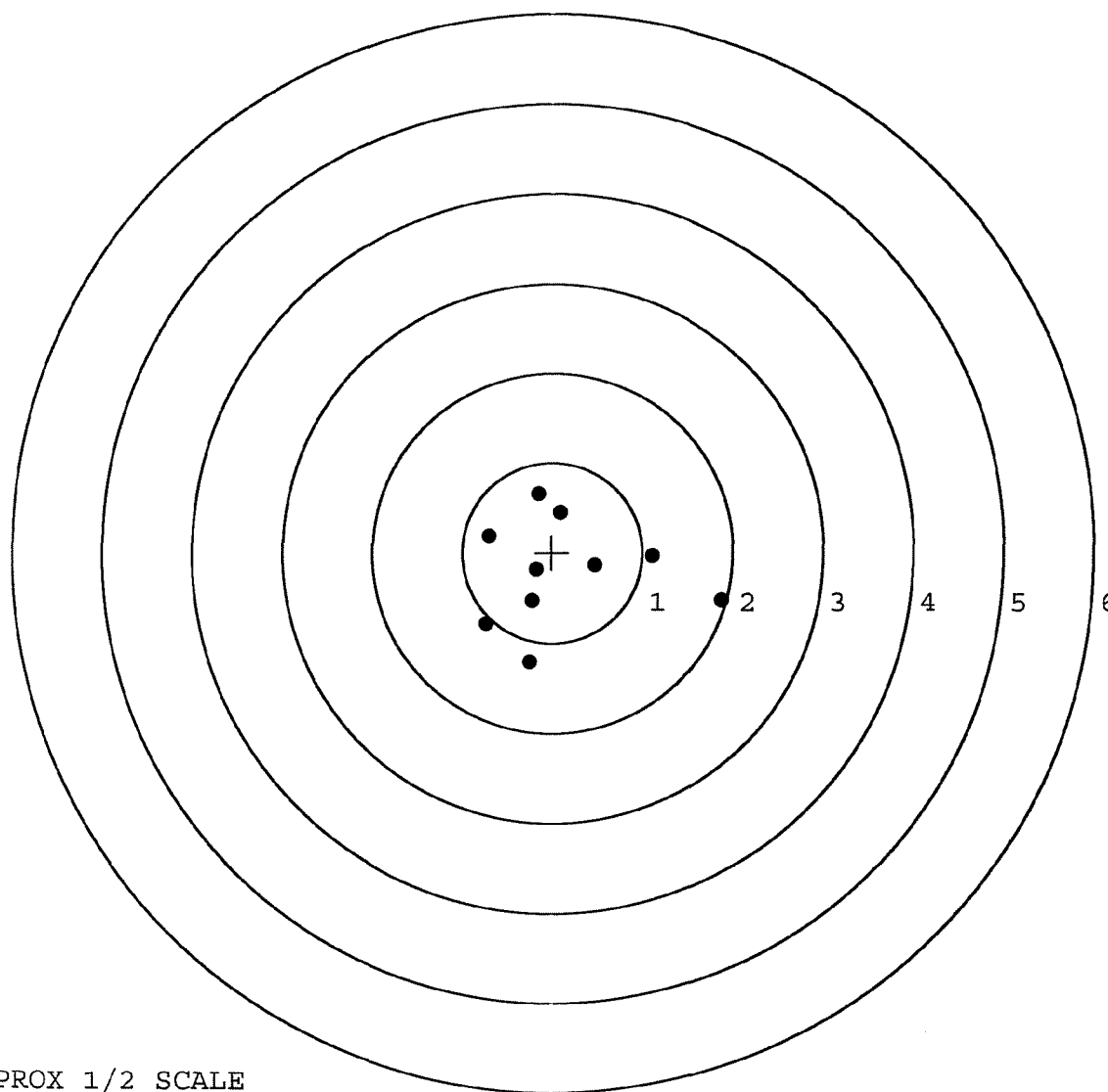
X CENTROID: 0.015
 Y CENTROID: -0.042
 POA TO CENTROID: 0.044
 HORZ SPREAD: 3.174
 VERT SPREAD: 4.140
 GROUP SPREAD: 4.830
 MIN RADIUS: 0.092
 MAX RADIUS: 2.697
 MEAN RADIUS: 1.288
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0117159

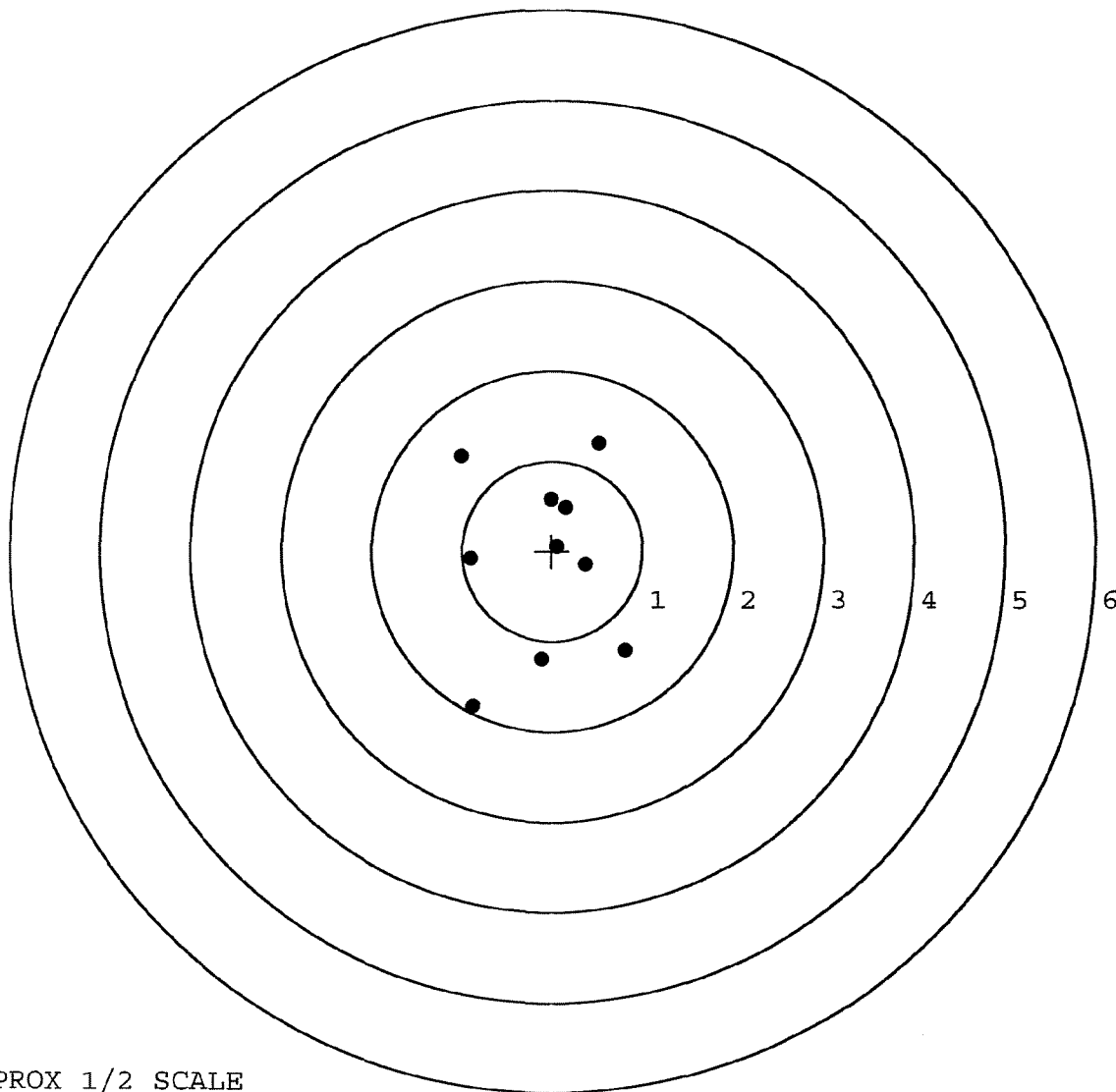
SERIAL NUMBER: E6790236. __0	POINT#	X	Y
TARGET NUMBER: 2	1:	1.880	-0.532
FILE DATE: 12/05/2001	2:	1.110	-0.040
FILE TIME: 11:10	3:	0.478	-0.140
	4:	0.092	0.441
X CENTROID: 0.130	5:	-0.160	0.650
Y CENTROID: -0.218	6:	-0.713	0.182
POA TO CENTROID: 0.253	7:	-0.174	-0.191
HORZ SPREAD: 2.618	8:	-0.226	-0.538
VERT SPREAD: 1.868	9:	-0.738	-0.790
GROUP SPREAD: 2.690	10:	-0.252	-1.218
MIN RADIUS: 0.305			
MAX RADIUS: 1.778			
MEAN RADIUS: 0.853			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

BARBER - M24 0117160

SERIAL NUMBER: E6790236.____0	POINT#	X	Y
TARGET NUMBER: 3	1:	0.369	-0.157
FILE DATE: 12/05/2001	2:	0.055	0.051
FILE TIME: 11:10	3:	0.153	0.481
	4:	-0.018	0.578
X CENTROID: -0.102	5:	0.518	1.200
Y CENTROID: -0.091	6:	-1.012	1.054
POA TO CENTROID: 0.137	7:	-0.906	-0.087
HORZ SPREAD: 1.823	8:	0.811	-1.107
VERT SPREAD: 2.924	9:	-0.115	-1.201
GROUP SPREAD: 3.239	10:	-0.876	-1.724
MIN RADIUS: 0.212			
MAX RADIUS: 1.807			
MEAN RADIUS: 0.997			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

BARBER - M24 0117161

SERIAL NUMBER: E6790236. __0

TARGET NUMBER: 4

FILE DATE: 12/05/2001

FILE TIME: 11:10

POINT#	X	Y
1:	0.216	0.197
2:	0.363	-0.176
3:	-0.617	0.497
4:	-0.396	0.118
5:	-0.554	-0.294
6:	0.335	-0.629
7:	0.275	-1.217
8:	-0.374	0.093
9:	0.279	0.180
10:	0.382	0.200

X CENTROID: -0.009

Y CENTROID: -0.103

POA TO CENTROID: 0.104

HORZ SPREAD: 0.999

VERT SPREAD: 1.714

GROUP SPREAD: 1.932

MIN RADIUS: 0.375

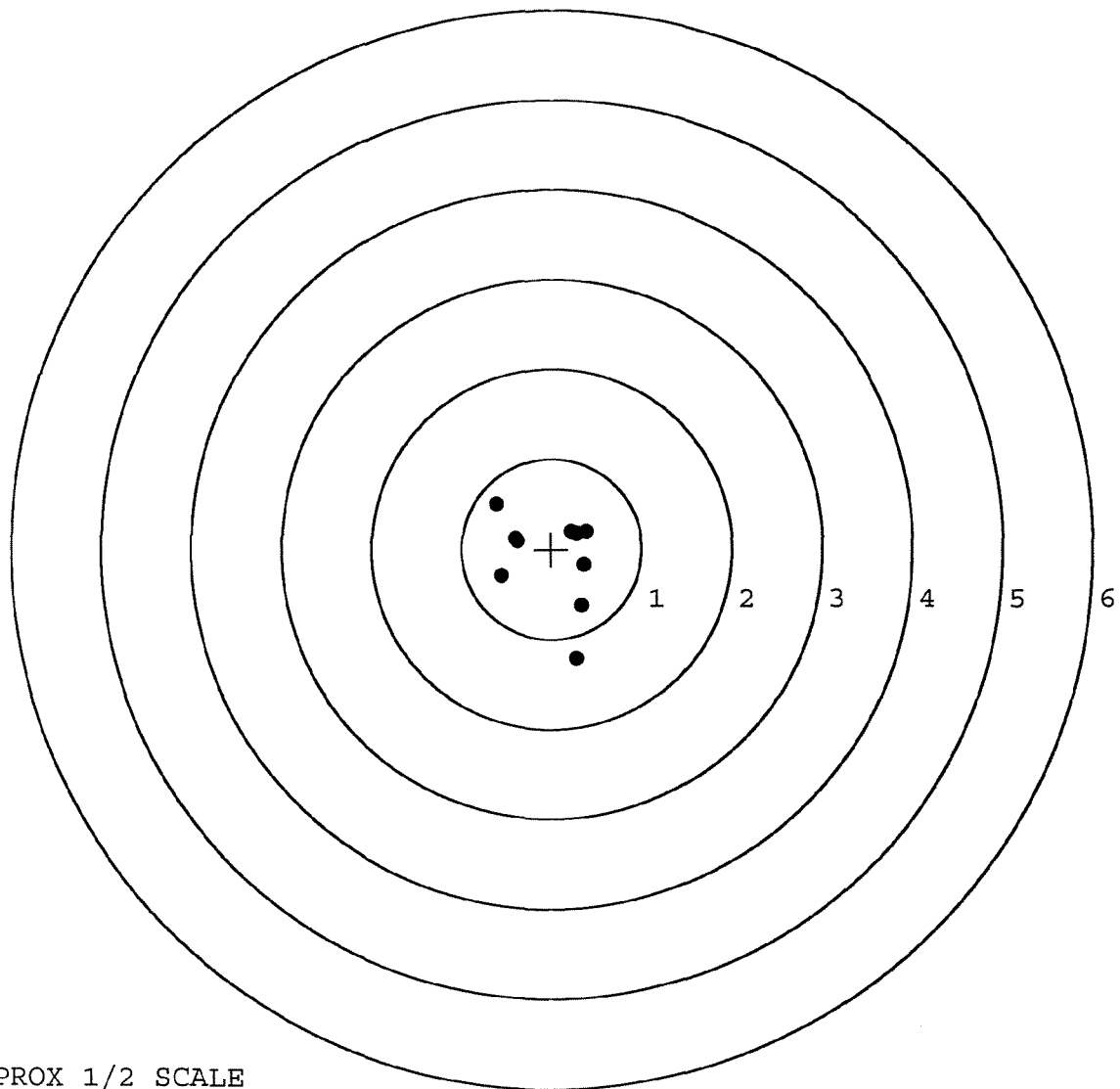
MAX RADIUS: 1.150

MEAN RADIUS: 0.572

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0117162

SERIAL NUMBER: E6790236. __0

TARGET NUMBER: 5

FILE DATE: 12/05/2001

FILE TIME: 11:10

POINT#	X	Y
1:	1.055	0.498
2:	0.595	0.857
3:	-0.415	0.478
4:	-0.026	-0.297
5:	-0.166	-0.559
6:	-1.132	-0.405
7:	0.086	-1.305
8:	-0.357	-1.181
9:	-2.352	-0.625
10:	0.508	0.884

X CENTROID: -0.220

Y CENTROID: -0.165

POA TO CENTROID: 0.276

HORZ SPREAD: 3.407

VERT SPREAD: 2.189

GROUP SPREAD: 3.587

MIN RADIUS: 0.235

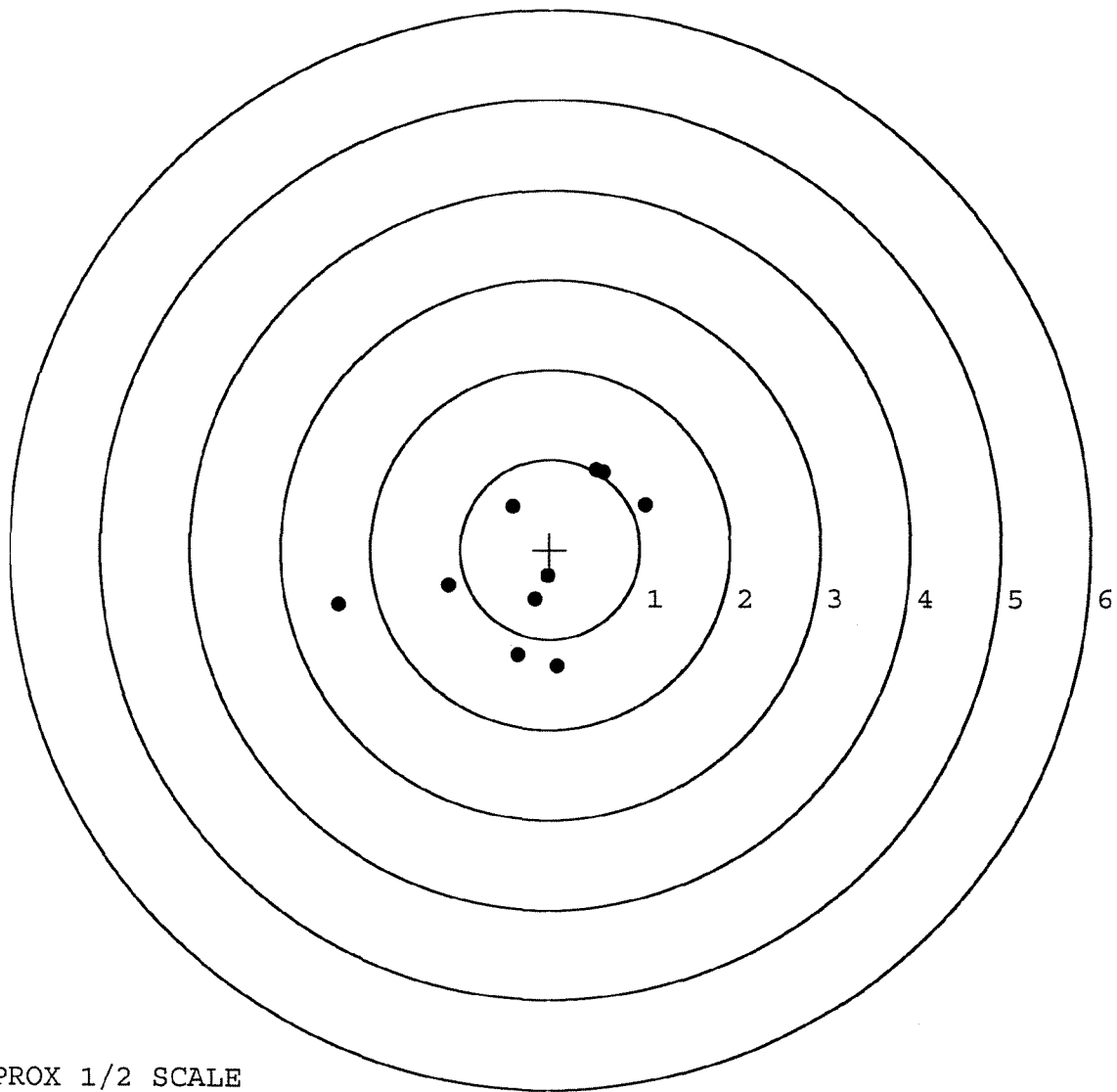
MAX RADIUS: 2.181

MEAN RADIUS: 1.065

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE