

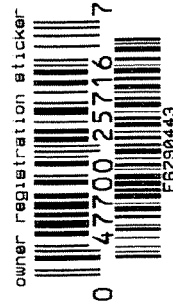
E 6790 443

**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

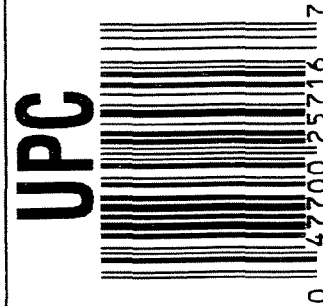


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**E6790443**





GUN SERIAL # E6790443

| OP #         | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|--------------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 575 &<br>580 | ASSEMBLE ACTION<br>AND STOCK                                                                                                           |          | 1-17-02 | reH     |
| 600          | PROOF                                                                                                                                  |          | 1-17-02 | Ac      |
| 607          | CHECK HEADSPACE                                                                                                                        |          | 1-17-02 | Ac      |
| 610          | DIS-ASSEMBLE GUN                                                                                                                       |          | 1-17-02 | reH     |
| 612          | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 |          |         | Ac      |
| 615          | ROLLMARK CALIBER                                                                                                                       |          | 1/21/02 | JB      |
| 617          | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 1/21/02 | BWT     |
| 620          | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 1-23    | TA      |
|              | (BOLT)                                                                                                                                 |          | 1-23    | TA      |
| 625          | FINAL ASSEMBLY                                                                                                                         |          | 1-25    | DK      |
|              | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          |         |         |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 1-25    | DK      |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 1-25    | DK      |
|              | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 1-25    | DK      |
|              | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |          | 2/19/02 | DA      |

| OP #  | BARBER NAME                                                           | 7475                                      | READINGS    |             |             | DATE        | INITIAL     |         |    |
|-------|-----------------------------------------------------------------------|-------------------------------------------|-------------|-------------|-------------|-------------|-------------|---------|----|
| 625   | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>6.00</u> | <u>5.25</u> | <u>5.00</u> | 1/28/02     | D.M.        |         |    |
| CONT. |                                                                       |                                           |             |             |             |             |             |         |    |
|       | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>4.00</u> | <u>3.50</u> | <u>3.50</u> | 1/28/02     | D.M.        |         |    |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |             |             |             |             |             |         |    |
|       | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> | <u>.023</u> | <u>.023</u> | 1/28/02     | D.M.        |         |    |
|       | J) ASSEMBLE STOCK                                                     |                                           |             |             |             | 1-25-02     | RW          |         |    |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |             |             |             | 1-31-02     | RW          |         |    |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                              |                                           |             |             |             | 2/18/02     | RW          |         |    |
|       | M) IRON SIGHT<br>ALIGNMENT                                            |                                           |             |             |             | 2/18/02     | RW          |         |    |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER |                                           |             |             |             | 2/18/02     | RW          |         |    |
| 640   | GALLERY TEST AND<br>TARGET                                            |                                           | PASS        | FAIL        |             | 1-28-02     | A           |         |    |
|       | A) MALFUNCTIONS                                                       |                                           | PASS        | FAIL        |             | 1-28-02     | A           |         |    |
|       | B) PIERCED PRIMERS                                                    |                                           | PASS        | FAIL        |             | 1-28-02     | A           |         |    |
| 645   | INSPECT FOR LIVE AMMO                                                 |                                           |             |             |             | 1-28-02     | A           |         |    |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |             |             |             | 1-31-02     | RW          |         |    |
|       | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.75</u> | <u>2.63</u> | <u>2.82</u> | <u>2.77</u> | <u>2.78</u> | 1-31-02 | DA |
|       | C) FUNCTION                                                           |                                           |             |             |             | 1-31-02     | RW          |         |    |
| 660   | PACK                                                                  |                                           |             |             |             | 2/19/02     | DA          |         |    |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6290443DATE 1/15/82TESTER M.N.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.51             | 2.19                     |                                | 2.10  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.56             | 2.57                     |                                | 2.11  |                                                                        |
| PULL #3 | 2.42             | 2.45                     |                                | 2.14  |                                                                        |
| PULL #4 | 2.40             | 2.49                     |                                | 2.15  |                                                                        |
| PULL #5 | 2.29             | 2.12                     |                                | 2.10  |                                                                        |
| TOTAL   | 12.18            | 11.82                    |                                | 10.60 |                                                                        |
| AVG.    | 2.44             | 2.36                     |                                | 2.12  |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.20             | 3.05                     |  |          |
| PULL #2 | 3.20             | 3.04                     |  |          |
| PULL #3 | 3.01             | 3.08                     |  |          |
| PULL #4 | 3.16             | 3.11                     |  |          |
| PULL #5 | 3.12             | 3.02                     |  |          |
| TOTAL   | 15.69            | 15.30                    |  |          |
| AVG.    | 3.14             | 3.06                     |  |          |

|         | 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 | 4.42             | 4.06                     |                                | 4.11                                 |
| PULL #2 | 4.52             | 4.22                     |                                | 4.20                                 |
| PULL #3 | 4.33             | 4.15                     |                                | 4.05                                 |
| PULL #4 | 4.15             | 4.18                     |                                | 4.11                                 |
| PULL #5 | 4.21             | 3.97                     |                                | 4.14                                 |
| TOTAL   | 21.63            | 20.58                    |                                | 20.61                                |
| AVG.    | 4.33             | 4.12                     |                                | 4.12                                 |

SERIAL NUMBER: E6790443. 0

TARGET NUMBER: 1

FILE DATE: 01/28/2002

FILE TIME: 02:20

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.114 | 0.071  |
| 2:     | -0.323 | -0.015 |
| 3:     | -1.065 | -0.542 |
| 4:     | 0.297  | -0.015 |
| 5:     | 0.892  | 0.912  |

X CENTROID: -0.063

Y CENTROID: 0.082

POA TO CENTROID: 0.103

HORZ SPREAD: 1.957

VERT SPREAD: 1.454

GROUP SPREAD: 2.438

MIN RADIUS: 0.053

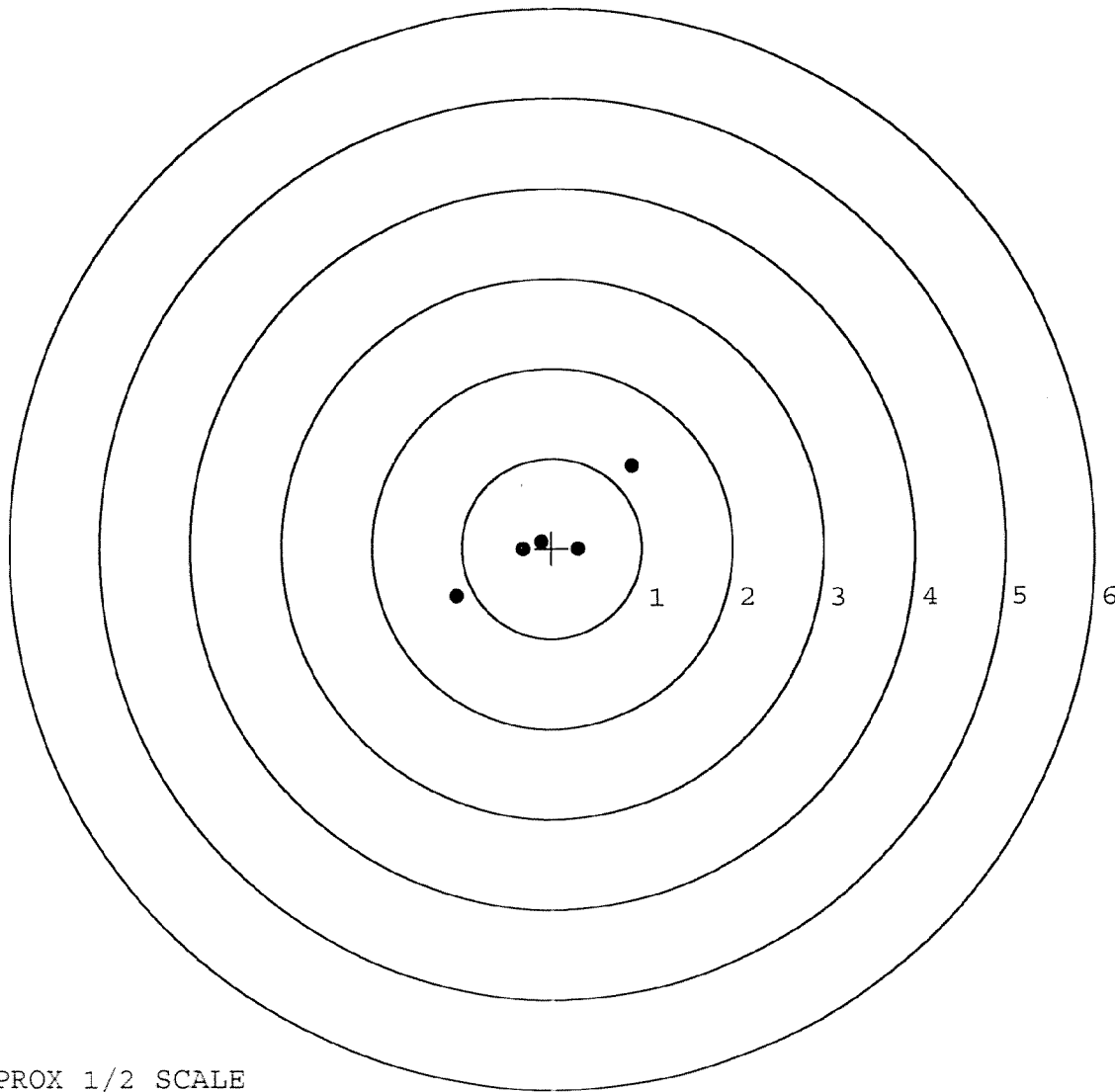
MAX RADIUS: 1.265

MEAN RADIUS: 0.630

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 3

# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

**BARBER - M24 0117478**

SERIAL NUMBER: E6790443. \_\_0

TARGET NUMBER: 2

FILE DATE: 01/28/2002

FILE TIME: 02:20

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.321 | 0.813  |
| 2:     | 0.017  | 0.305  |
| 3:     | -0.213 | -0.027 |
| 4:     | -0.289 | -0.628 |
| 5:     | 0.464  | -0.362 |

X CENTROID: -0.068

Y CENTROID: 0.020

POA TO CENTROID: 0.071

HORZ SPREAD: 0.785

VERT SPREAD: 1.441

GROUP SPREAD: 1.441

MIN RADIUS: 0.152

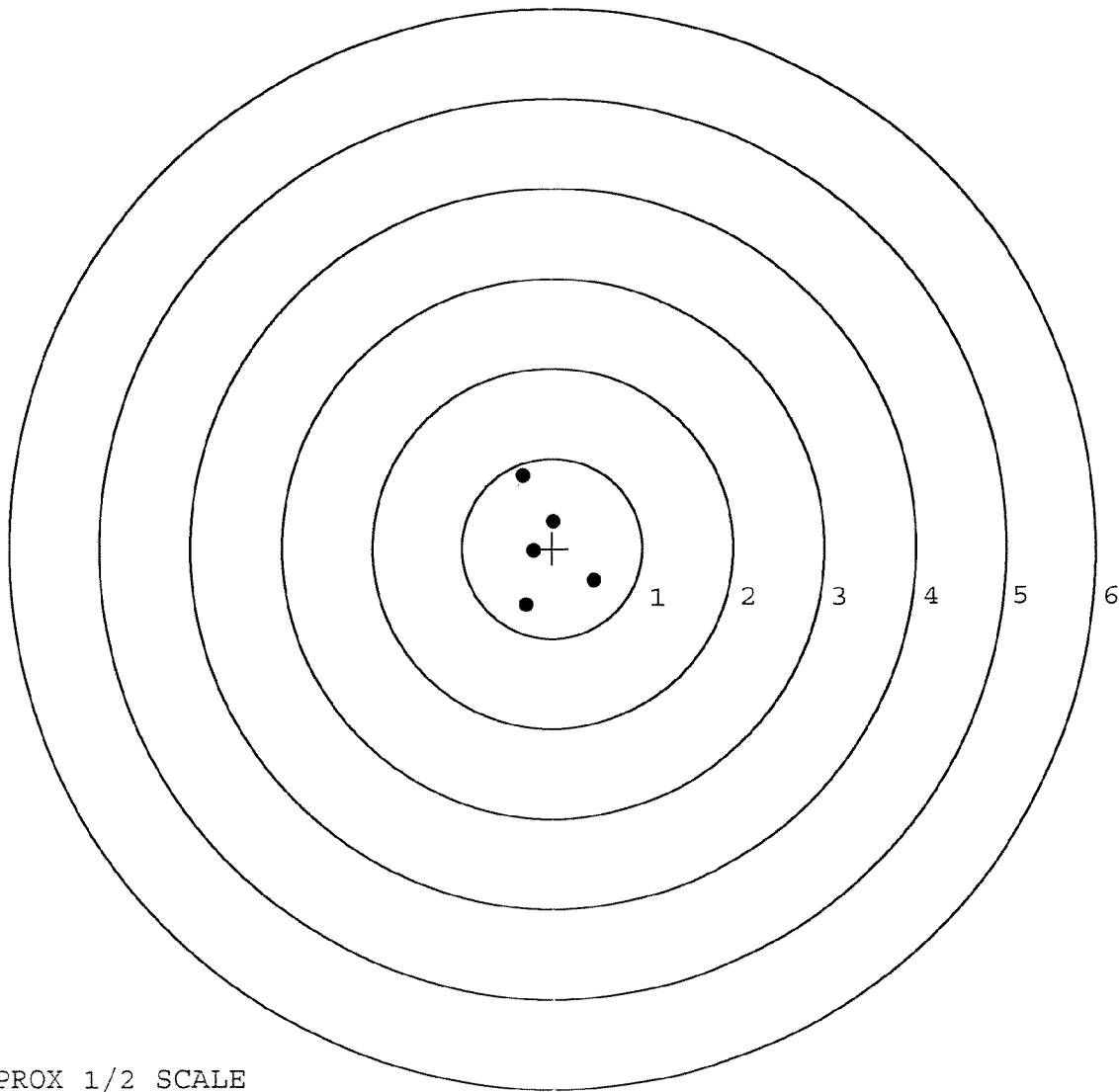
MAX RADIUS: 0.832

MEAN RADIUS: 0.524

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 5

# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE