

EC790501

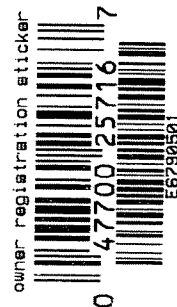
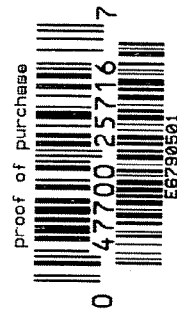
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MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6790501



CONTRACT #

GUN SERIAL # E6790501

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/27/01	RTH
600	PROOF		11/27/01	RTH
607	CHECK HEADSPACE	MAGNA - FLUX	11/27/01	RTH
610	DIS-ASSEMBLE GUN	INSPECTED	11/27/01	RTH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	1.0V 2.7 2001 OPERATOR <u>DRB</u>		
615	ROLLMARK CALIBER		11/28/01	SB
617	DRILL AND TAP SIGHT HOLES		11/29/01	BWT
620	APPLY COATINGS (BARREL ACTION)		11/30/01	HP
	(BOLT)		11/30/01	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12/12/01	D.M.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/12/01	D.M.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/12/01	D.M.
	D) OIL FIRING PIN ASSEMBLY		12/12/01	D.M.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	12/14/01	SA

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.25</u> <u>5.25</u> <u>5.25</u>		DM
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>		DM
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>		DM
	J) ASSEMBLE STOCK		12-14-01	DL
	K) ASSEMBLE SWIVEL STUDS		12/16/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/16/01	REP
	M) IRON SIGHT ALIGNMENT		12/16/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/16/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	12/14/01	G
	A) MALFUNCTIONS	PASS FAIL	12/14/01	R
	B) PIERCED PRIMERS	PASS FAIL	12/14/01	DL
645	INSPECT FOR LIVE AMMO		12/14/01	DL
655	FINAL INSPECTION A) HEADSPACE		12/16/00	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.23</u> <u>2.29</u> <u>2.20</u> <u>2.25</u>	12/15/01	DM
	C) FUNCTION		12/16/01	REP
660	PACK		12/14/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790501DATE 11/12/01TESTER D.M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.30	2.62	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.26	2.72	2.29	
PULL #3	2.33	2.80	2.46	
PULL #4	2.19	2.73	2.49	
PULL #5	2.34	2.95	2.25	
TOTAL	11.42	13.82	11.96	
AVG.	2.28	2.76	2.39	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.22	3.42	
PULL #2	3.34	3.38	
PULL #3	3.03	3.36	
PULL #4	3.33	3.34	
PULL #5	3.30	3.34	
TOTAL	16.22	16.84	
AVG.	3.24	3.37	

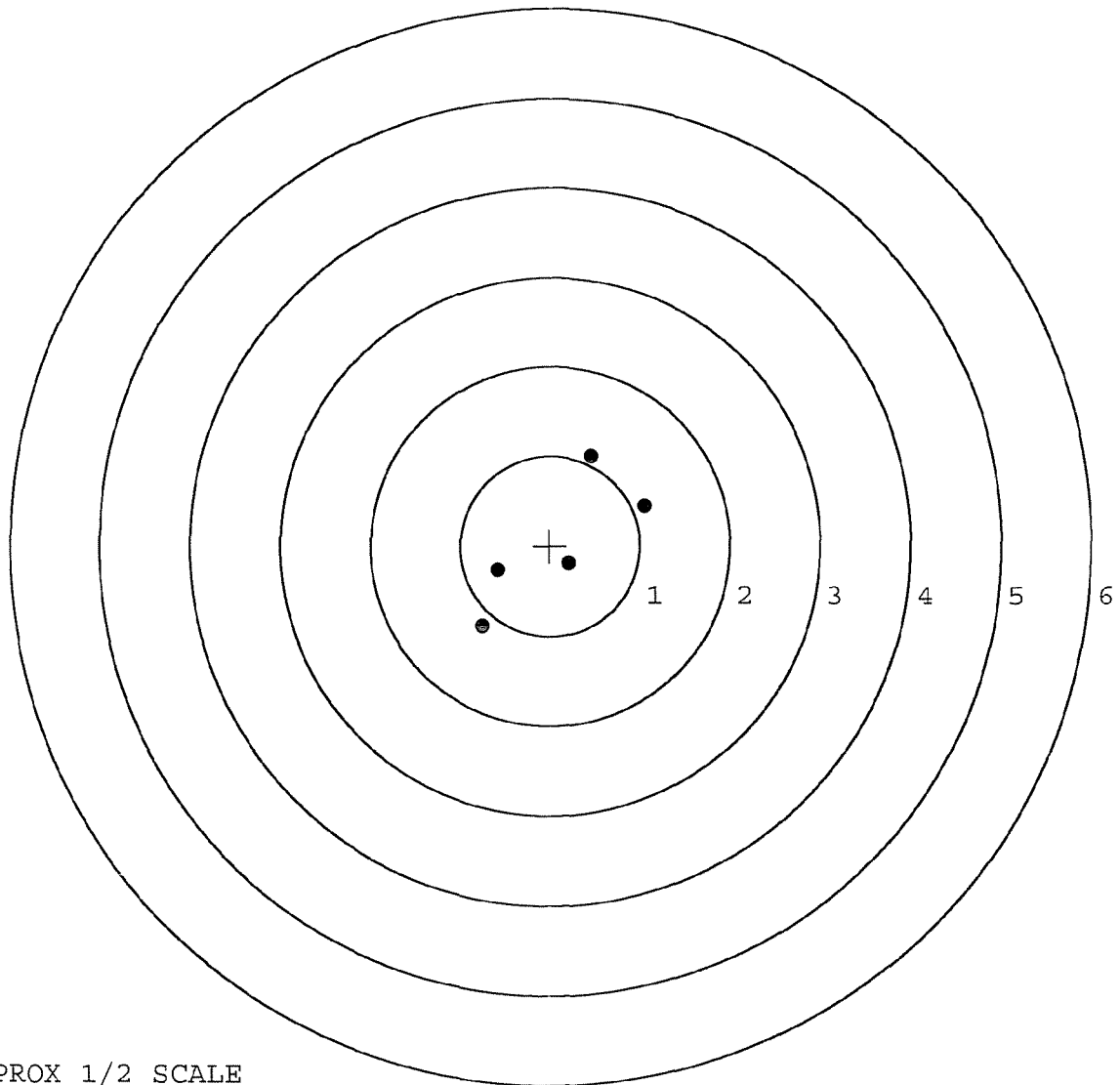
	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.06		4.33
PULL #2	4.24	4.14		4.27
PULL #3	4.14	4.05		4.24
PULL #4	4.18	3.99		4.17
PULL #5	4.21	4.04		4.21
TOTAL	21.08	20.28		21.22
AVG.	4.22	4.06		4.24

BARBER - M24 0110562

SERIAL NUMBER: E6790501. __0
 TARGET NUMBER: 1
 FILE DATE: 12/14/2001
 FILE TIME: 10:53

POINT#	X	Y
1:	1.051	0.446
2:	0.458	0.996
3:	-0.586	-0.267
4:	0.211	-0.191
5:	-0.760	-0.893

X CENTROID: 0.075
 Y CENTROID: 0.018
 POA TO CENTROID: 0.077
 HORZ SPREAD: 1.811
 VERT SPREAD: 1.889
 GROUP SPREAD: 2.252
 MIN RADIUS: 0.250
 MAX RADIUS: 1.236
 MEAN RADIUS: 0.864
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 2
 # in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

BARBER - M24 0110563

SERIAL NUMBER: E6790501. 0

TARGET NUMBER: 2

FILE DATE: 12/14/2001

FILE TIME: 10:53

POINT#	X	Y
1:	0.422	0.070
2:	-0.203	-0.291
3:	-0.150	0.324
4:	-0.334	0.204
5:	-0.214	0.270

X CENTROID: -0.096

Y CENTROID: 0.115

POA TO CENTROID: 0.150

HORZ SPREAD: 0.756

VERT SPREAD: 0.615

GROUP SPREAD: 0.768

MIN RADIUS: 0.195

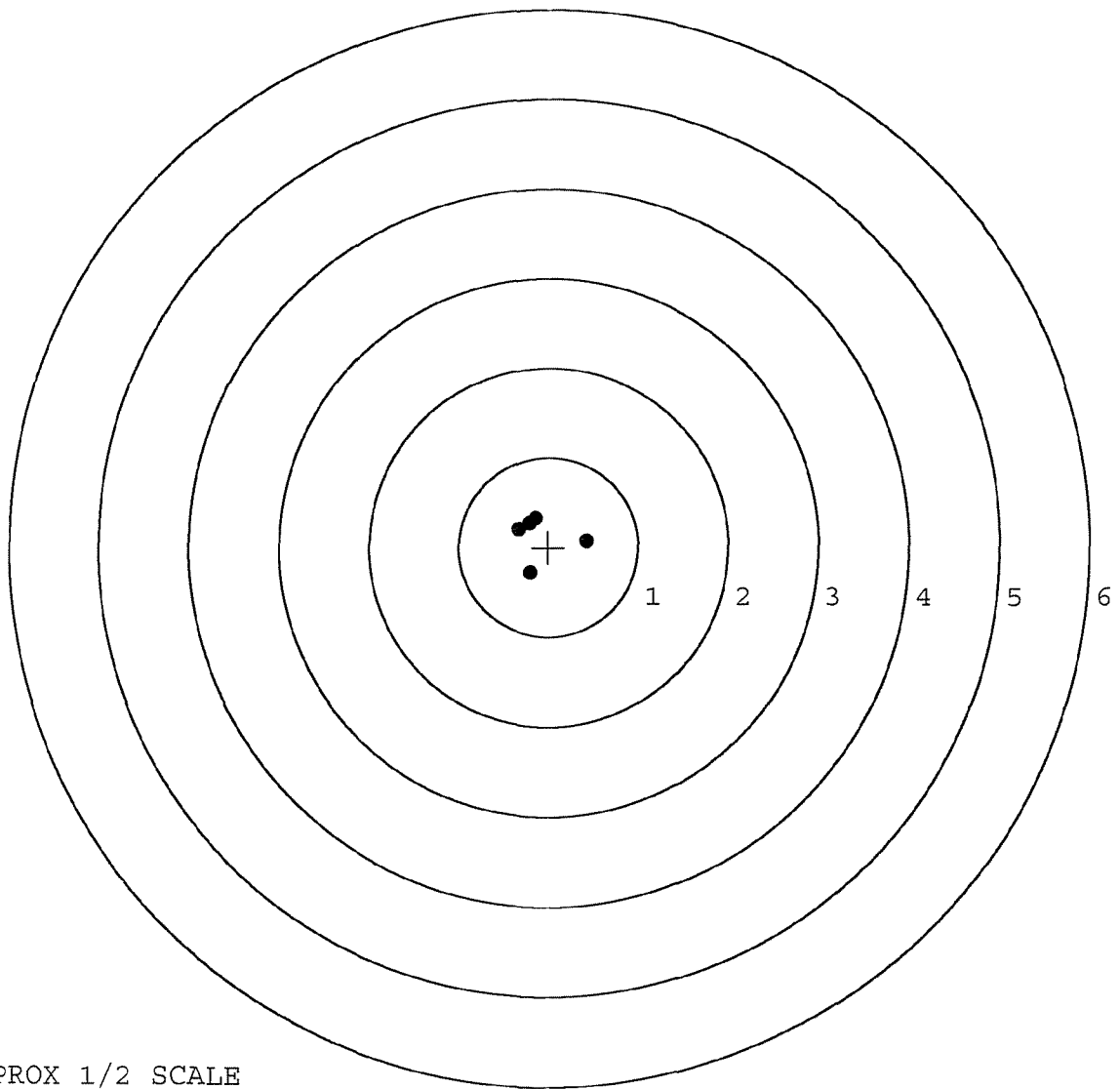
MAX RADIUS: 0.520

MEAN RADIUS: 0.321

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE