

EC790182

MODEL 700TH M24

UPC



MODEL 700_{TS} M24

UPC



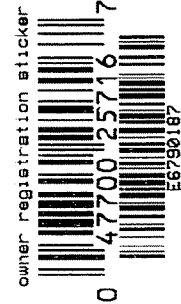
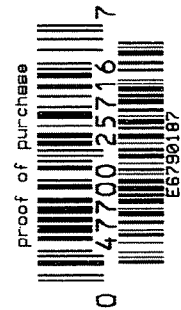
SERIAL NO.



MODEL 700TM 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

E6790187



CONTRACT #

GUN SERIAL # E6790187

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/5/01	Rep
600	PROOF		11/5/01	Rep
607	CHECK HEADSPACE		11/5/01	Rep
610	DIS-ASSEMBLE GUN	NOV 7 2001 INSPECTED	11/5/01	Rep
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 7 2001 OPERATOR <u>DRD</u>		
615	ROLLMARK CALIBER		11/6	DR
617	DRILL AND TAP SIGHT HOLES		11/7	BWT
620	APPLY COATINGS (BARREL ACTION)		11/14	HP
	(BOLT)		11/14	HP
625	FINAL ASSEMBLY		1/23/02	DM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1/23/02	DM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1/23/02	DM
	D) OIL FIRING PIN ASSEMBLY		1/23/02	DM
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		2/18/02	DA

OP # OPERATION NAME		READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.85</u>	<u>5.25</u>	<u>4.50</u>	1/28/02	D.M.
CONT.						
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.25</u>	<u>4.00</u>	<u>3.75</u>	1/28/02	D.M.
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>.024</u>	<u>.023</u>	<u>.025</u>	1/28/02	D.M.
	J) ASSEMBLE STOCK				1/23/02	RW
	K) ASSEMBLE SWIVEL STUDS				1-28-02	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				2/15/02	RW
	M) IRON SIGHT ALIGNMENT				2/15/02	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				2/15/02	RW
640	GALLERY TEST AND TARGET	PASS	FAIL		1-24-02	A
	A) MALFUNCTIONS	PASS	FAIL		1-24-02	A
	B) PIERCED PRIMERS	PASS	FAIL		1-24-02	A
645	INSPECT FOR LIVE AMMO				1-24-02	A
655	FINAL INSPECTION A) HEADSPACE				1-28-02	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u>	<u>2.39</u>	<u>2.89</u>	1/28/02	D.M.
	C) FUNCTION				1-28-02	RW
660	PACK				2/18/02	DA

SERIAL NUMBER: E6790187. __0

TARGET NUMBER: 1

FILE DATE: 01/24/2002

FILE TIME: 02:22

POINT#	X	Y
1:	0.288	0.923
2:	-1.164	0.055
3:	0.318	0.036
4:	0.308	-0.185
5:	0.258	-0.026

X CENTROID: 0.002

Y CENTROID: 0.161

POA TO CENTROID: 0.161

HORZ SPREAD: 1.482

VERT SPREAD: 1.108

GROUP SPREAD: 1.692

MIN RADIUS: 0.317

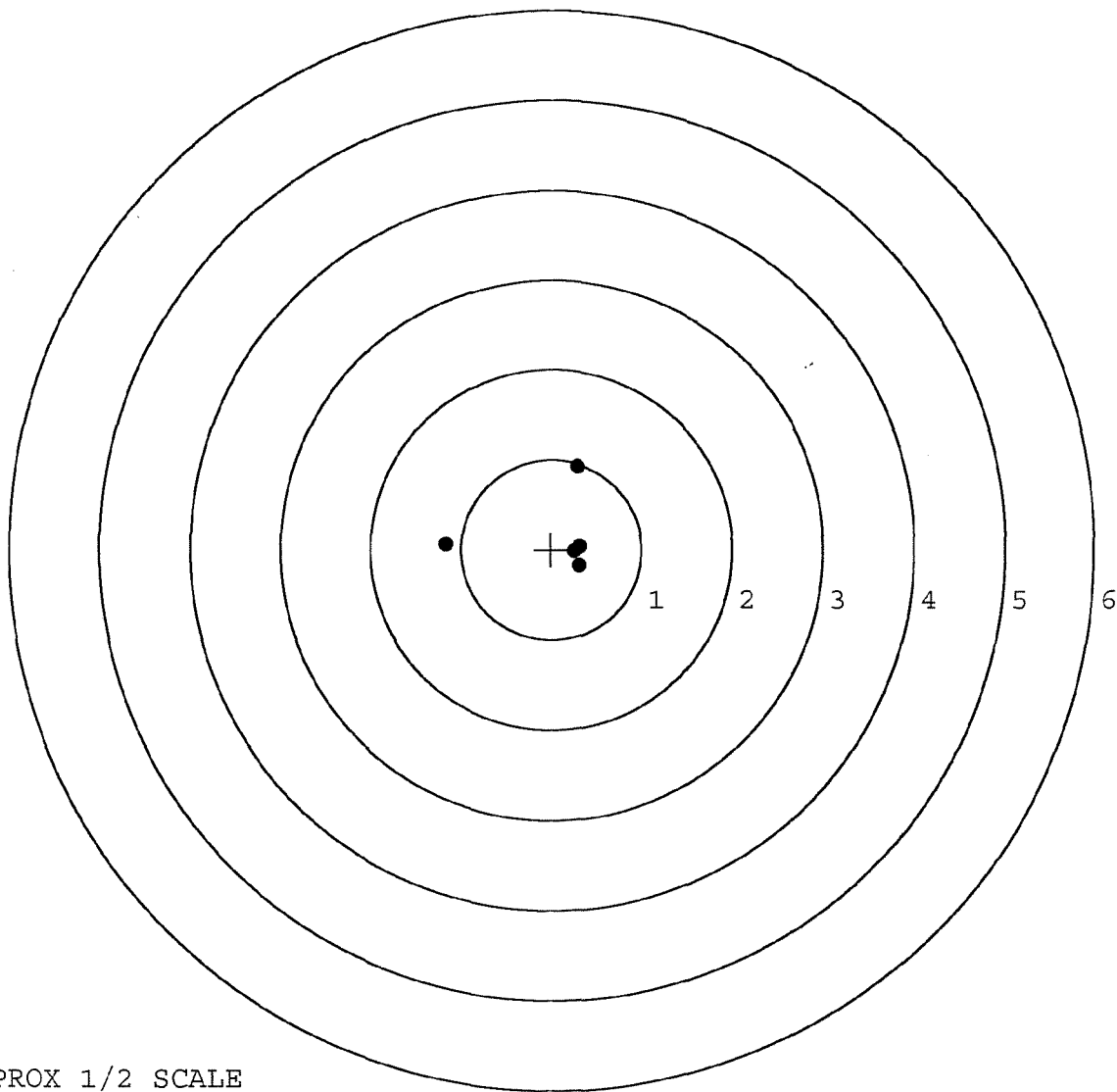
MAX RADIUS: 1.170

MEAN RADIUS: 0.621

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 5

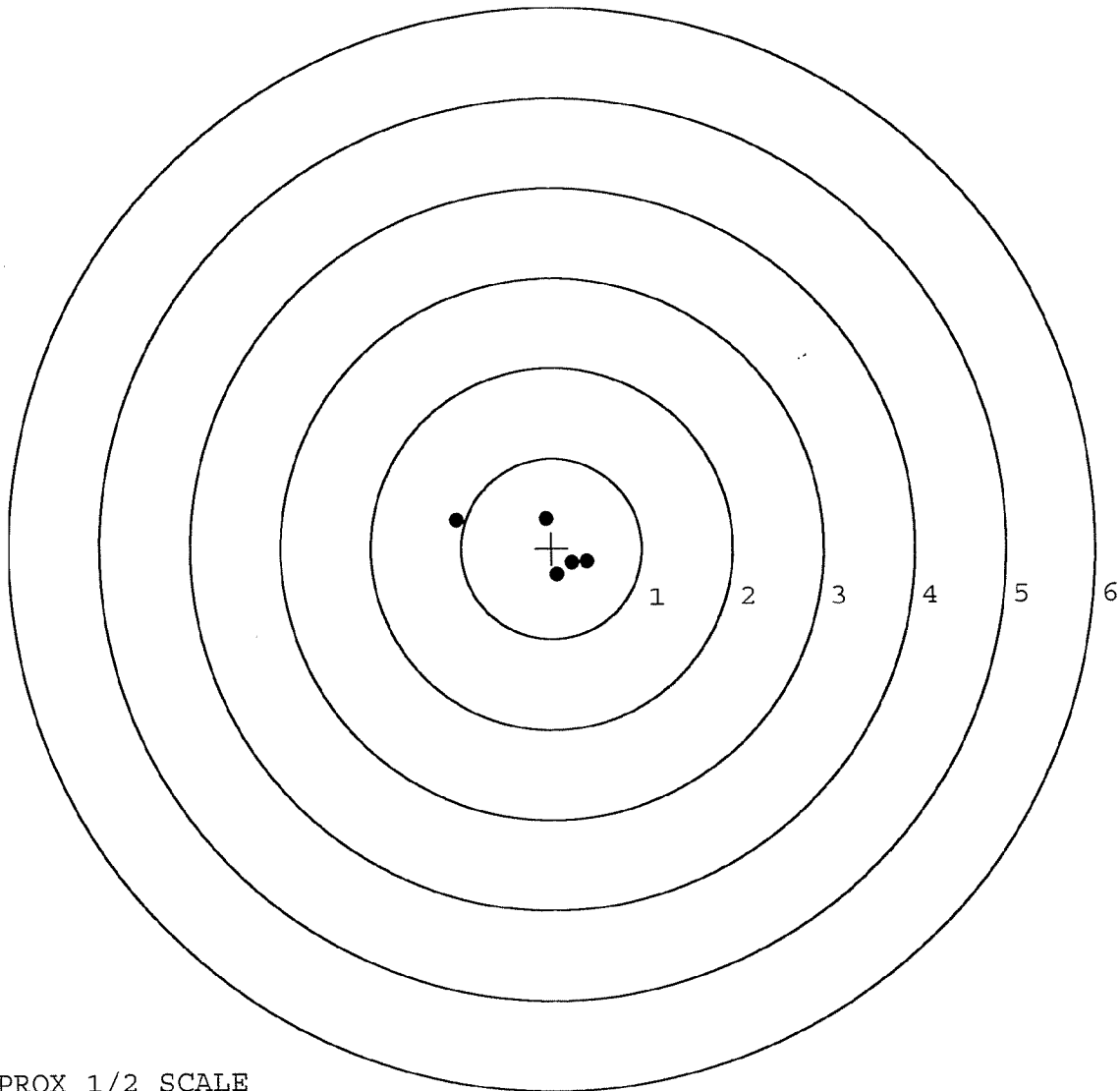


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790187. __0
 TARGET NUMBER: 2
 FILE DATE: 01/24/2002
 FILE TIME: 02:22

POINT#	X	Y
1:	-0.063	0.331
2:	-1.048	0.321
3:	0.390	-0.148
4:	0.225	-0.163
5:	0.058	-0.299

X CENTROID: -0.088
 Y CENTROID: 0.008
 POA TO CENTROID: 0.088
 HORZ SPREAD: 1.438
 VERT SPREAD: 0.630
 GROUP SPREAD: 1.513
 MIN RADIUS: 0.324
 MAX RADIUS: 1.010
 MEAN RADIUS: 0.507
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. F6790187

DATE 12/31/01

TESTER D.N.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.14		2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.28		2.48	
PULL #3	2.44	2.17		2.50	
PULL #4	2.24	2.44		2.51	
PULL #5	2.25	2.49		2.42	
TOTAL	11.72	11.52		12.34	
AVG.	2.34	2.30		2.47	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.39		
PULL #2	3.24	3.23		
PULL #3	3.46	3.18		
PULL #4	3.67	3.04		
PULL #5	3.33	3.32		
TOTAL	16.26	16.16		
AVG.	3.25	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.37		4.25
PULL #2	4.36	4.28		4.27
PULL #3	4.17	4.20		3.99
PULL #4	4.33	4.46		4.27
PULL #5	4.33	4.51		4.24
TOTAL	21.42	21.82		21.02
AVG.	4.28	4.36		4.20