

E6790471

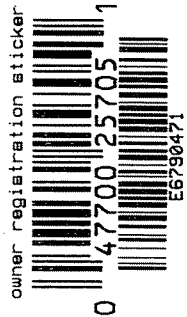
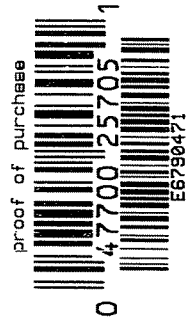
		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
		SERIAL NO. J E6790471	
MODEL 700™ M24 BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO		46	ORDER NO. 25705
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		31KW	
			
5705 E6790471			

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

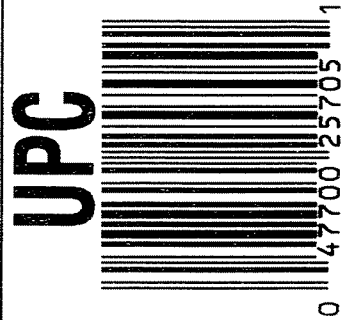
GREEN ENVELOPE CONTAINS:

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

46 FORM



ORDER NO.	25705
BARREL LENGTH	24"
CAPACITY	6
E6790471	



ORDER 25705

MODEL 700TH M24

UPC



ORDER 25705

MODEL 700TH M24

UPC



SERIAL NO.



E6790471

CONTRACT #
DAAE20-01-P-0489
170 RIFLES

GUN SERIAL # E679 0471

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-30-02	RHR
600	PROOF		1-30-02	AC
607	CHECK HEADSPACE		1-30-02	AC
610	DIS-ASSEMBLE GUN		1-30-02	RTH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		2-2-02	
615	ROLLMARK CALIBER		2/4/02	LB
617	DRILL AND TAP SIGHT HOLES		2/4/02	BWT
620	APPLY COATINGS (BARREL ACTION)		2-12	TA
	(BOLT)		2-12	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-15-02	AC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-15-02	AC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-15-02	AC
	D) OIL FIRING PIN ASSEMBLY		2-15-02	KL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/21/02	RTH

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.0</u> <u>5.5</u>	3-21-02	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4.0</u> <u>4.0</u>	3-21-02	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/21-02	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	3-21-02	DA
	J) ASSEMBLE STOCK		2-26-02	DA
	K) ASSEMBLE SWIVEL STUDS		4/16/02	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/16/02	RTL
	M) IRON SIGHT ALIGNMENT		4/16/02	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/16/02	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	3-6-02	A
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION		A
645	INSPECT FOR LIVE AMMO		3-6-02	A
655	FINAL INSPECTION A) HEADSPACE		4/16/02	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.43</u> <u>2.69</u> <u>2.70</u> <u>2.85</u>	4/1/02	DA
	C) FUNCTION		4/16/02	RTL
660	PACK		4/21/02	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO.

E6790471

DATE

2/15/02

TESTER

D.N.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.73	2.32	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.81	2.40	2.44	
PULL #3	2.71	2.20	2.42	
PULL #4	2.78	2.33	2.29	
PULL #5	2.61	2.34	2.41	
TOTAL	13.61	11.59	11.94	
AVG.	2.73	2.32	2.39	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.29	3.15	
PULL #2	3.28	3.30	
PULL #3	3.17	3.24	
PULL #4	3.30	3.31	
PULL #5	3.29	3.25	
TOTAL	16.33	16.25	
AVG.	3.27	3.25	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURAC
PULL #1	4.12	4.02		4.15
PULL #2	4.08	4.04		4.10
PULL #3	4.09	4.12		4.03
PULL #4	4.11	4.19		4.06
PULL #5	4.08	4.14		4.12
TOTAL	20.48	20.51		20.46
AVG.	4.10	4.10		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790471.__0

FILE DATE AND TIME: 03/07/2002 19:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.015
The Average Y Centroid of the Five Target Set:	-0.014
The Average Point of Impact of the Five Target Set:	0.020
The Average Mean Radius of the Five Target Set:	0.518
The Distance from POA to Centroid Target #1:	0.049
The Distance from Centroid Target #2 to Centroid Target #1:	0.165
The Distance from Centroid Target #3 to Centroid Target #1:	0.016
The Distance from Centroid Target #4 to Centroid Target #1:	0.196
The Distance from Centroid Target #5 to Centroid Target #1:	0.225

SERIAL NUMBER: E6790471. __0

TARGET NUMBER: 1

FILE DATE: 03/07/2002

FILE TIME: 19:39

X CENTROID: 0.042

Y CENTROID: -0.024

POA TO CENTROID: 0.049

HORZ SPREAD: 1.702

VERT SPREAD: 1.391

GROUP SPREAD: 1.868

MIN RADIUS: 0.344

MAX RADIUS: 1.417

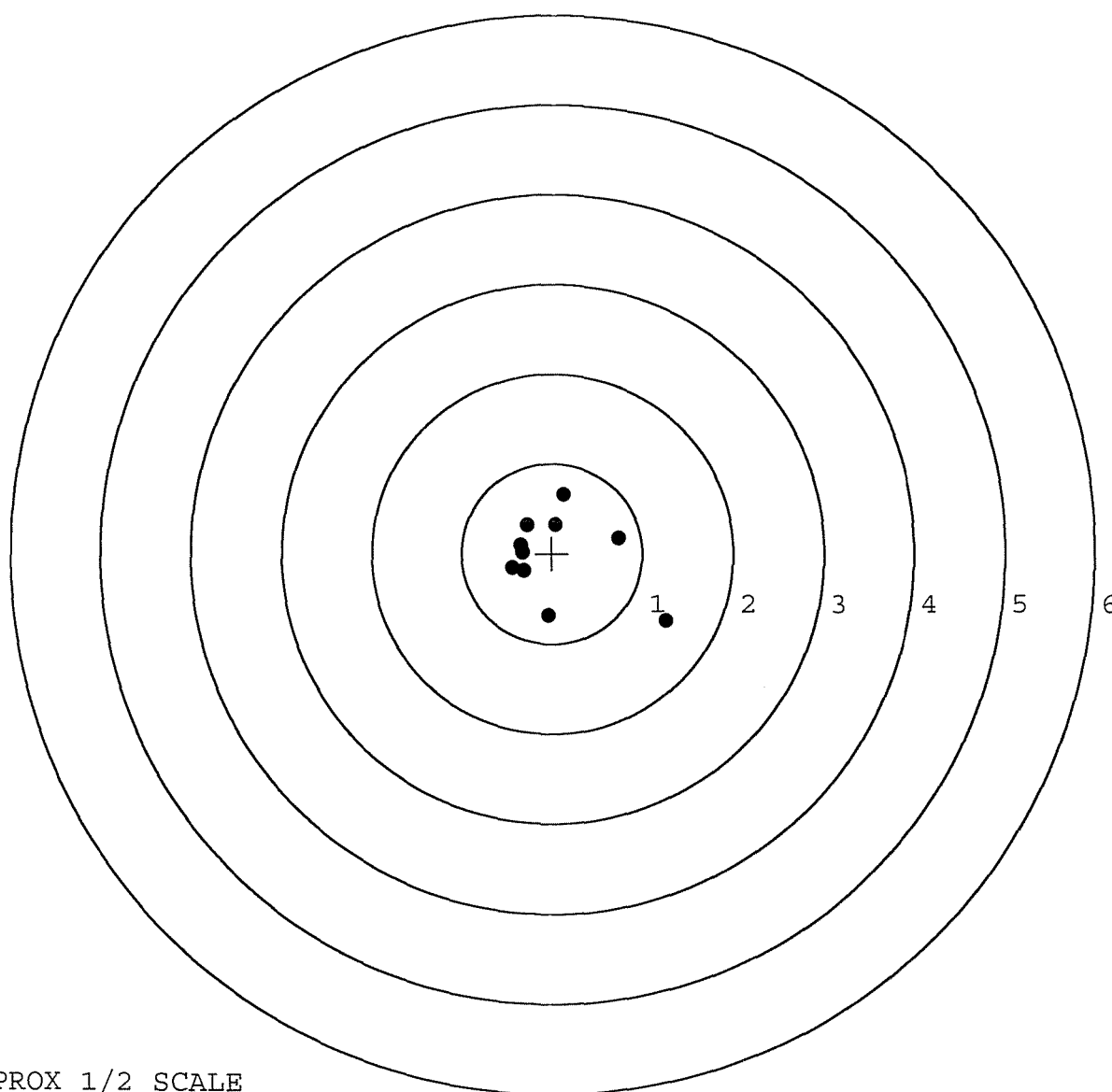
MEAN RADIUS: 0.596

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.128	0.649
2:	0.040	0.320
3:	-0.280	0.309
4:	-0.347	0.091
5:	-0.438	-0.162
6:	-0.310	-0.196
7:	-0.037	-0.688
8:	0.734	0.168
9:	1.264	-0.742
10:	-0.330	0.010

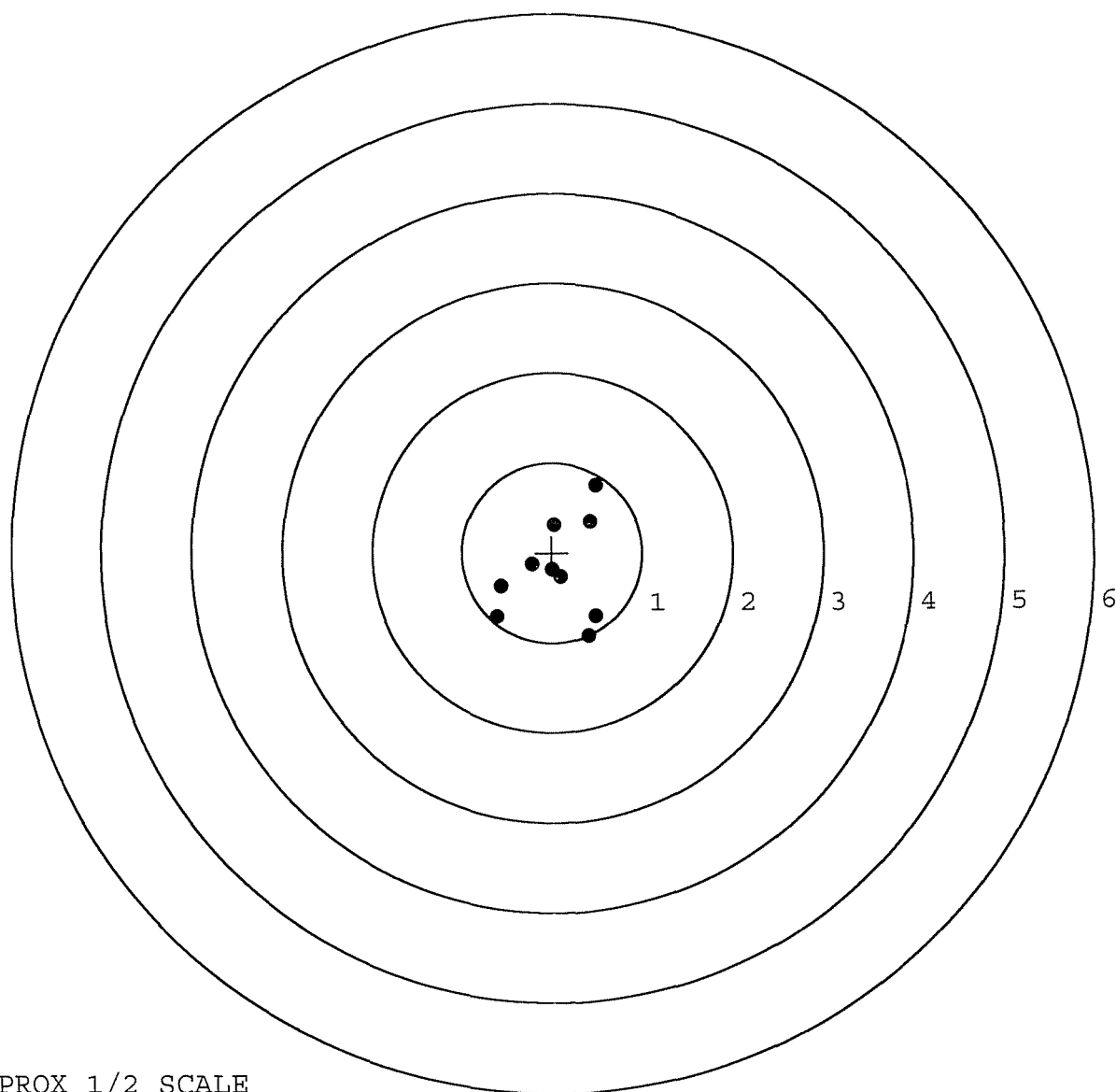


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790471. __0
 TARGET NUMBER: 2
 FILE DATE: 03/07/2002
 FILE TIME: 19:39

X CENTROID: 0.054
 Y CENTROID: -0.189
 POA TO CENTROID: 0.197
 HORZ SPREAD: 1.105
 VERT SPREAD: 1.669
 GROUP SPREAD: 1.828
 MIN RADIUS: 0.053
 MAX RADIUS: 1.034
 MEAN RADIUS: 0.560
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.490	0.748
2:	0.427	0.348
3:	0.032	0.307
4:	0.099	-0.272
5:	0.001	-0.188
6:	-0.226	-0.132
7:	-0.570	-0.370
8:	-0.615	-0.708
9:	0.412	-0.921
10:	0.486	-0.703

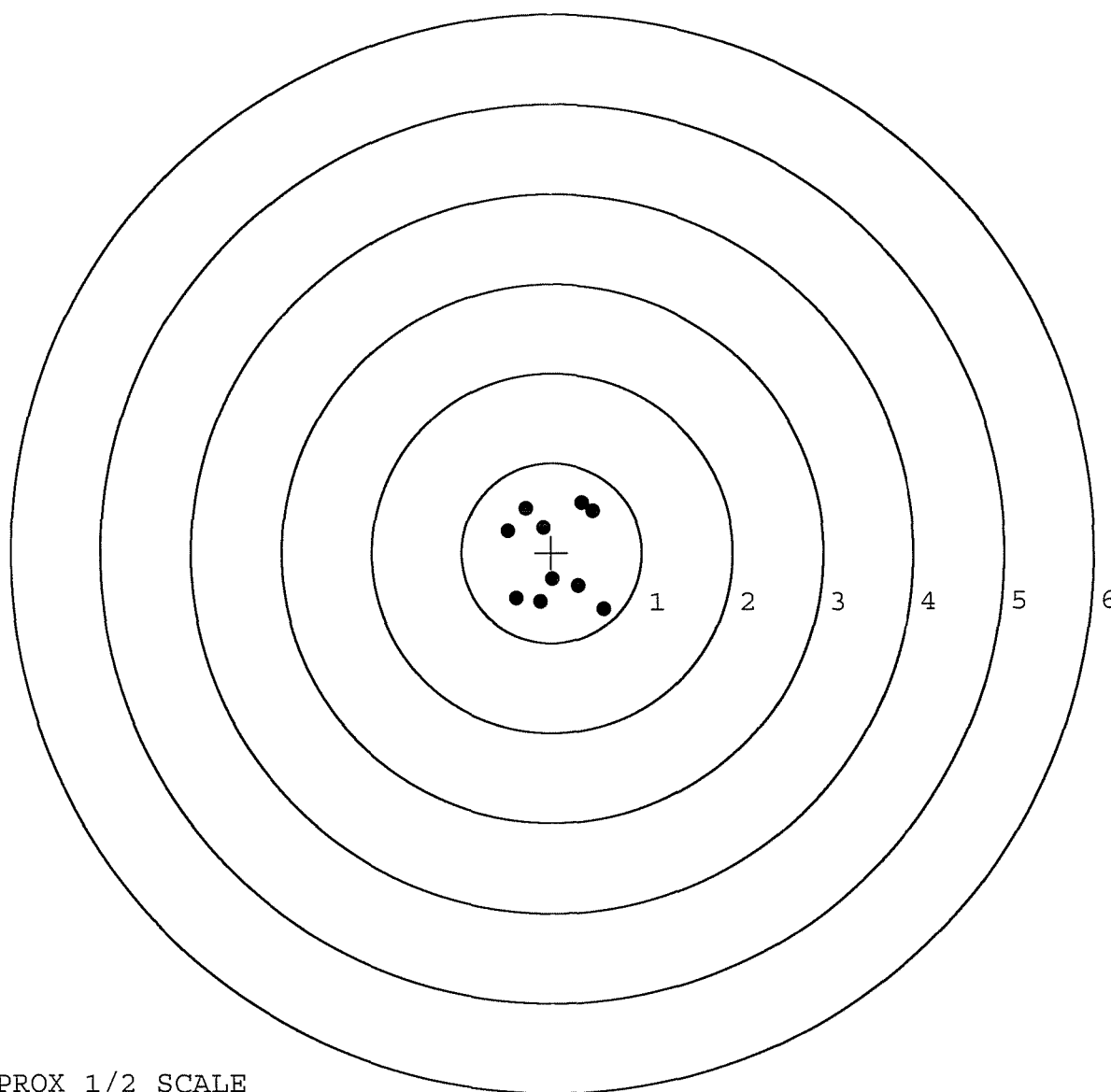


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790471. __0
 TARGET NUMBER: 3
 FILE DATE: 03/07/2002
 FILE TIME: 19:39

X CENTROID: 0.029
 Y CENTROID: -0.032
 POA TO CENTROID: 0.043
 HORZ SPREAD: 1.058
 VERT SPREAD: 1.192
 GROUP SPREAD: 1.421
 MIN RADIUS: 0.265
 MAX RADIUS: 0.814
 MEAN RADIUS: 0.553
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.336	0.559
2:	0.459	0.462
3:	-0.088	0.276
4:	-0.289	0.493
5:	-0.480	0.243
6:	-0.397	-0.507
7:	-0.133	-0.547
8:	0.007	-0.296
9:	0.297	-0.372
10:	0.578	-0.633



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790471. __0

TARGET NUMBER: 4

FILE DATE: 03/07/2002

FILE TIME: 19:39

X CENTROID: -0.152

Y CENTROID: -0.004

POA TO CENTROID: 0.152

HORZ SPREAD: 0.984

VERT SPREAD: 0.818

GROUP SPREAD: 1.039

MIN RADIUS: 0.089

MAX RADIUS: 0.678

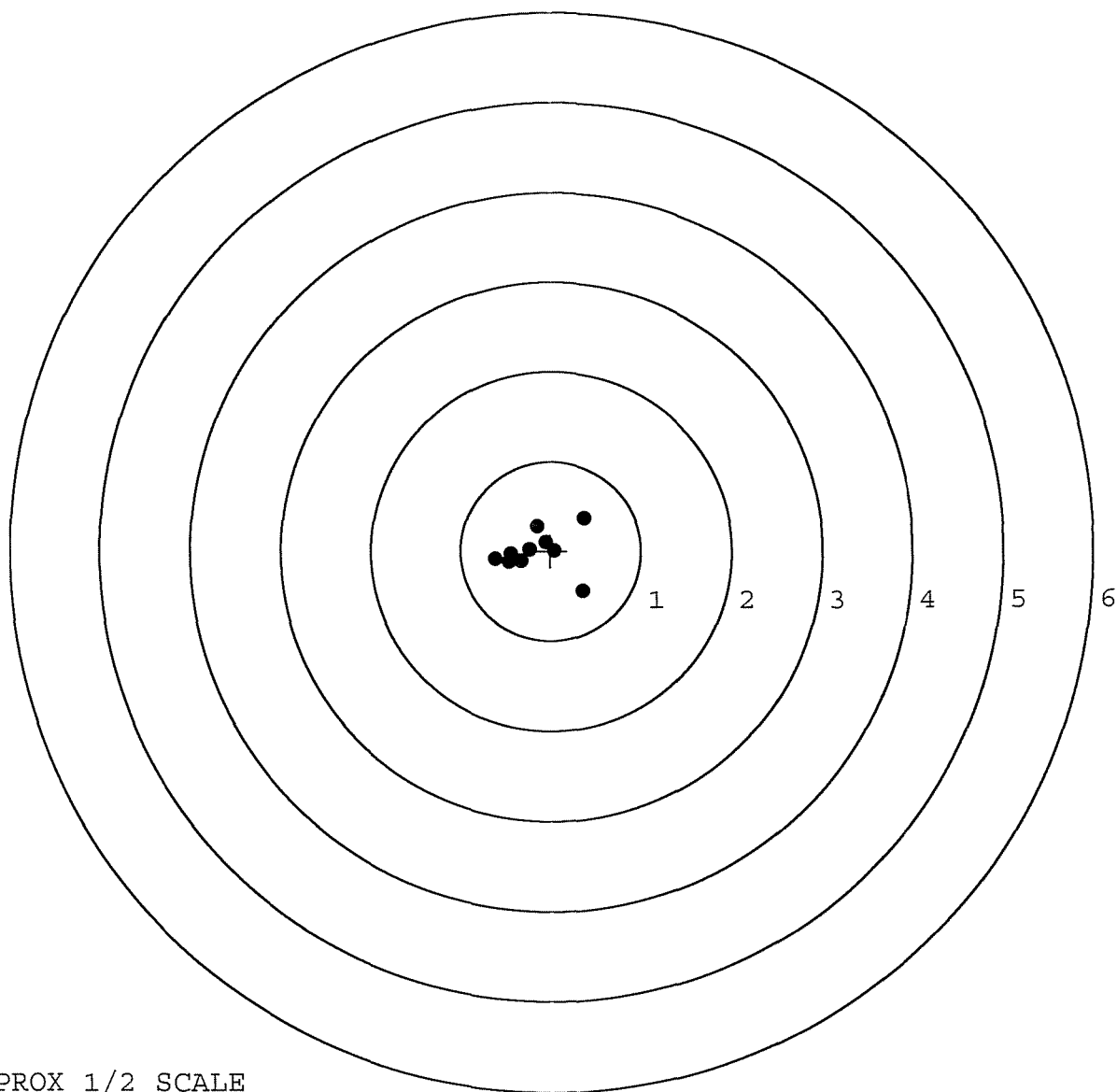
MEAN RADIUS: 0.333

IN 1 IN DIAMETER: 8

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.369	0.370
2:	0.044	0.006
3:	0.360	-0.448
4:	-0.615	-0.088
5:	-0.466	-0.123
6:	-0.440	-0.035
7:	-0.327	-0.115
8:	-0.238	0.019
9:	-0.153	0.279
10:	-0.057	0.097



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790471. __0

TARGET NUMBER: 5

FILE DATE: 03/07/2002

FILE TIME: 19:39

X CENTROID: -0.049

Y CENTROID: 0.181

POA TO CENTROID: 0.188

HORZ SPREAD: 1.373

VERT SPREAD: 1.573

GROUP SPREAD: 1.641

MIN RADIUS: 0.027

MAX RADIUS: 0.945

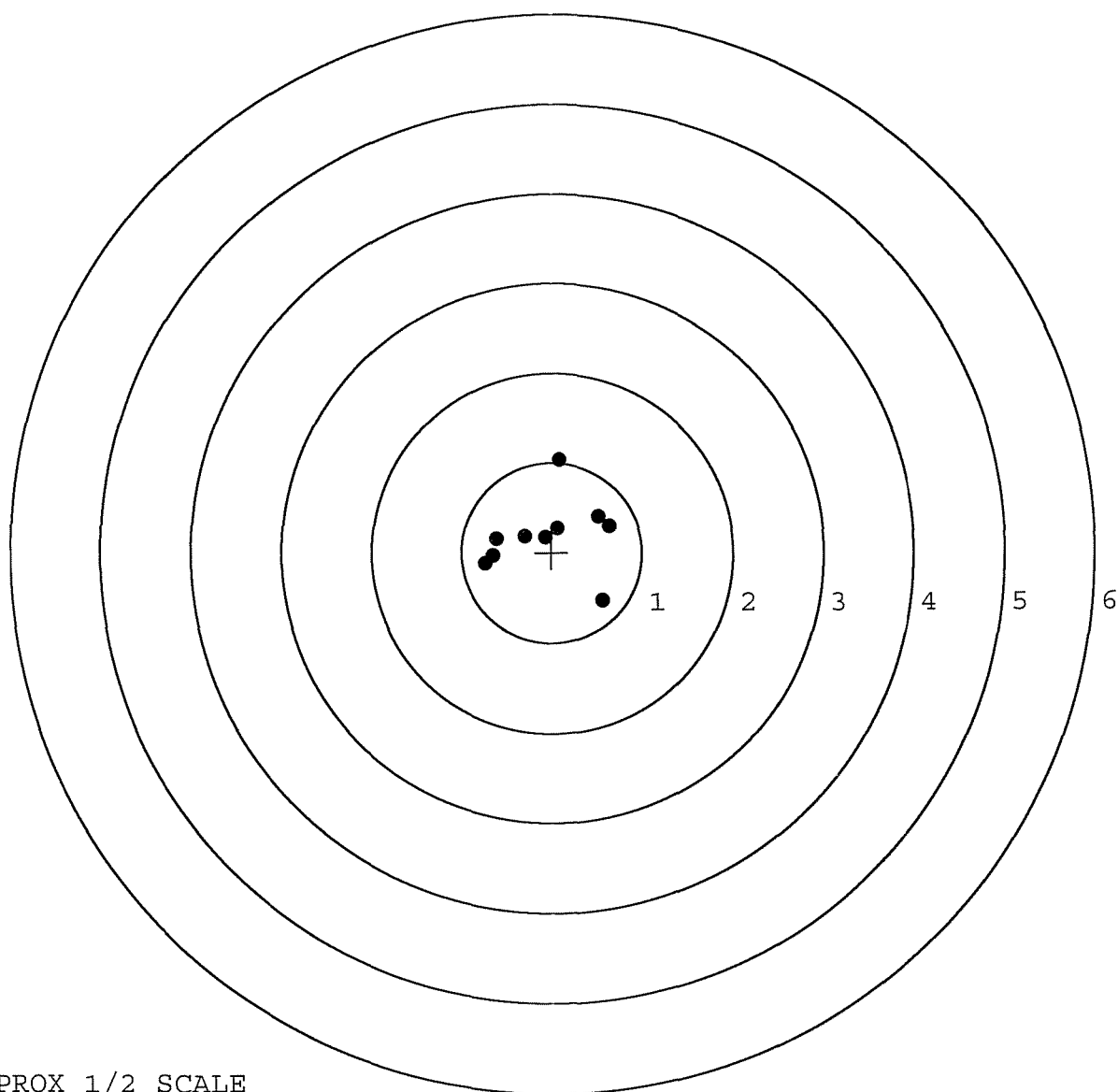
MEAN RADIUS: 0.548

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.093	1.033
2:	0.514	0.404
3:	0.636	0.297
4:	0.070	0.268
5:	-0.073	0.169
6:	-0.300	0.183
7:	-0.608	0.155
8:	-0.647	-0.036
9:	-0.737	-0.123
10:	0.562	-0.540



TARGET APPROX 1/2 SCALE