

EC790479

		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24 BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO		SERIAL NO. J E6790479	
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		46 25716	
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5716 E6790479			

25716

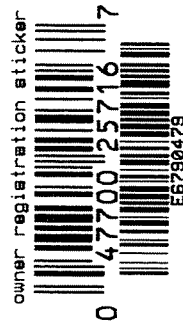
MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

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

ORDER

46 FORM 1444

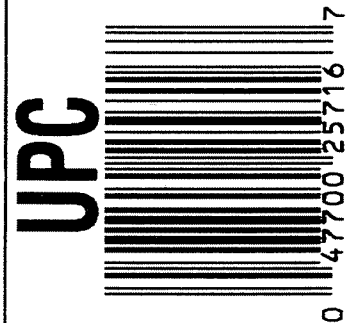


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6790479



FORM 144

ORDER 25716

MODEL 700TH M24

UPC



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MODEL 700TH M24

UPC



UPC



SERIAL NO.



E6780478

6 24 16

CONTRACT #

GUN SERIAL # E679 0479

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/27/01	RH
600	PROOF		11/27/01	RH
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	11/27/01	RH
610	DIS-ASSEMBLE GUN		11/27/01	RH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 27 2001 OPERATOR <u>JSB</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	HN

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>	12-18-01	EK
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.25</u> <u>3.5</u>	12-18-01	EK
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.0235</u> <u>.025</u>	12-18-01	EK
	J) ASSEMBLE STOCK		12-15-01	RP
	K) ASSEMBLE SWIVEL STUDS		12/20/19	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/20/19	REP
	M) IRON SIGHT ALIGNMENT		12/19/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/19/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	12/17/01	RP
	A) MALFUNCTIONS	PASS FAIL	12/18/01	RP
	B) PIERCED PRIMERS	PASS FAIL	12/20/01	RP
645	INSPECT FOR LIVE AMMO		12/12/01	RP
655	FINAL INSPECTION A) HEADSPACE		12/19/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.76</u> <u>2.82</u> <u>2.84</u> <u>2.85</u>	12/18/01	D.M.
	C) FUNCTION		12/19/01	REP
660	PACK		12/21/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6790479DATE 11/1/01TESTER D.M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.23	2.54	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.49	2.27	
PULL #3	2.36	2.63	2.15	
PULL #4	2.41	2.56	2.28	
PULL #5	2.58	2.67	2.19	
TOTAL	11.83	12.89	11.07	
AVG.	2.37	2.58	2.21	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.34		
PULL #2	3.55	3.30		
PULL #3	3.57	3.35		
PULL #4	3.56	3.48		
PULL #5	3.52	3.45		
TOTAL	17.74	16.92		
AVG.	3.55	3.38		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.11		4.23
PULL #2	4.24	3.98		3.94
PULL #3	4.16	4.08		4.20
PULL #4	4.10	4.02		4.16
PULL #5	4.14	4.08		4.19
TOTAL	20.95	20.27		20.72
AVG.	4.19	4.05		4.14

SERIAL NUMBER: E6790479. __0

TARGET NUMBER: 1

FILE DATE: 12/17/2001

FILE TIME: 11:16

POINT#	X	Y
1:	0.635	-2.386
2:	-0.519	-0.631
3:	-0.877	0.081
4:	0.650	0.658
5:	0.546	1.604

X CENTROID: 0.087

Y CENTROID: -0.135

POA TO CENTROID: 0.160

HORZ SPREAD: 1.527

VERT SPREAD: 3.990

GROUP SPREAD: 3.991

MIN RADIUS: 0.783

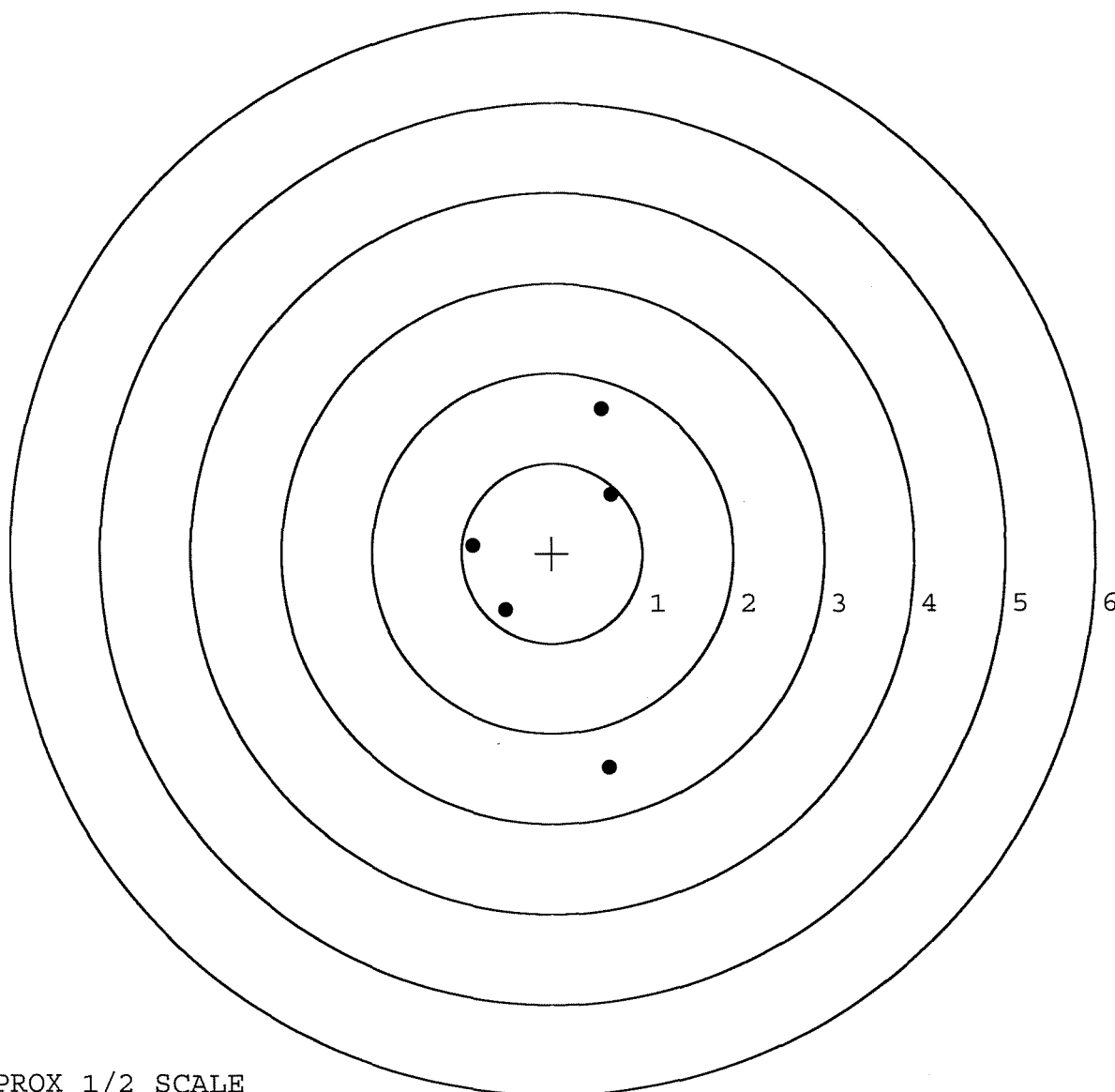
MAX RADIUS: 2.317

MEAN RADIUS: 1.372

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 3

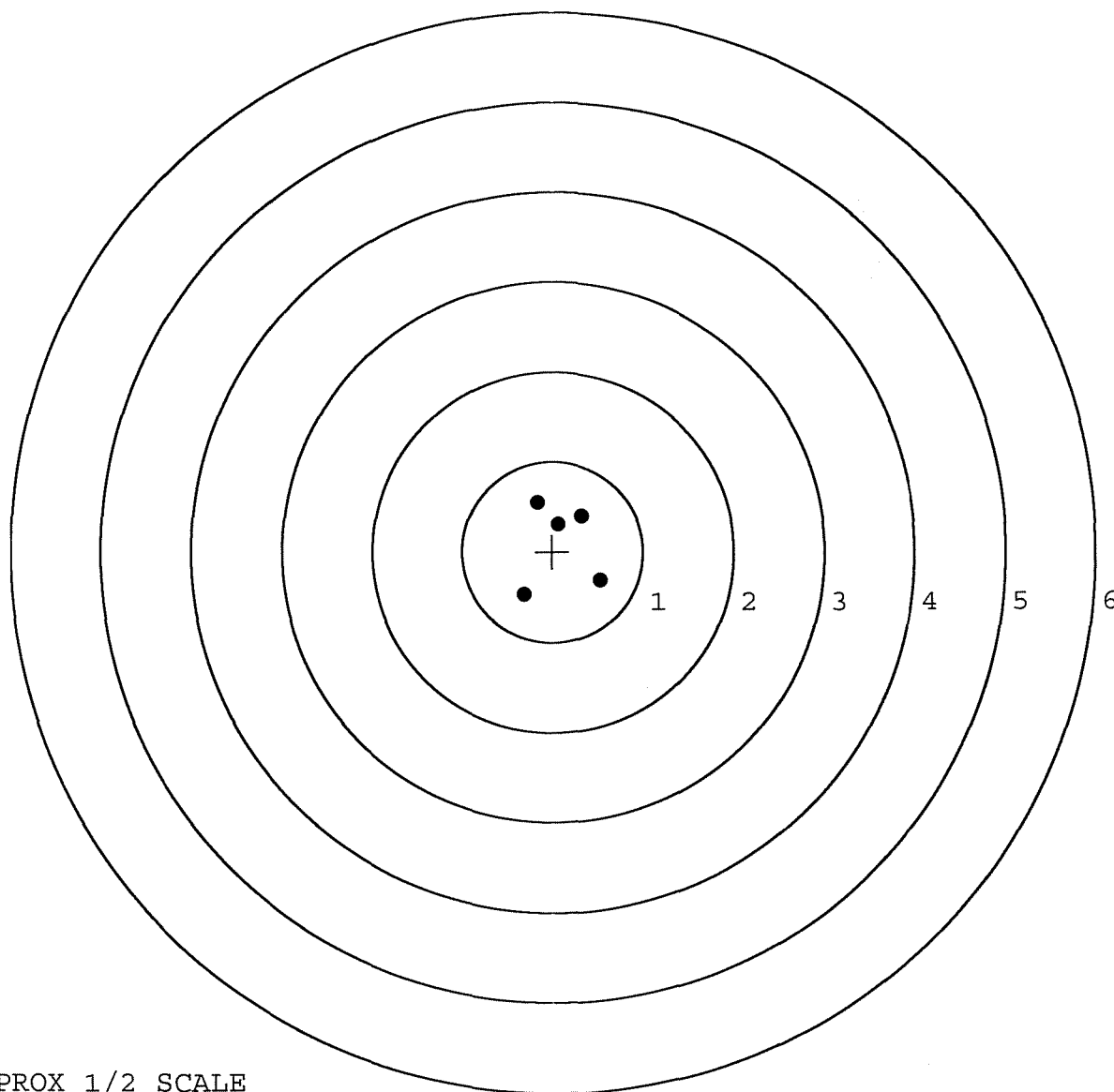
Av. Mean R. .928

TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790479. __0
 TARGET NUMBER: 2
 FILE DATE: 12/17/2001
 FILE TIME: 11:16

POINT#	X	Y
1:	0.529	-0.317
2:	-0.314	-0.475
3:	0.322	0.396
4:	0.067	0.302
5:	-0.171	0.543

X CENTROID: 0.087
 Y CENTROID: 0.090
 POA TO CENTROID: 0.125
 HORZ SPREAD: 0.843
 VERT SPREAD: 1.018
 GROUP SPREAD: 1.078
 MIN RADIUS: 0.213
 MAX RADIUS: 0.692
 MEAN RADIUS: 0.483
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE