

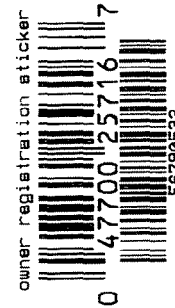
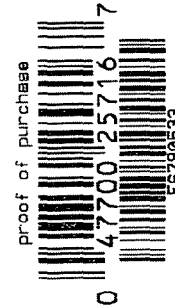
E679053

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

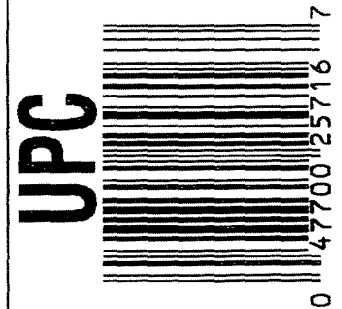


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790533



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.
E6790533

ORDER NO. **25716**

17B

Made in Union, NY
Reg. U.S. Pat. & tm. Off. Marca Registrada Marque Deposee.



5716 E6790533

ORDER

25716

MODEL 700TH M24

UPC



ORDER

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MODEL 700™ M24

UPC



SERIAL NO.



E6790533

CONTRACT #

GUN SERIAL # E6790533

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-8-01	REP
600	PROOF		11-8-01	REP
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	11-8-01	REP
610	DIS-ASSEMBLE GUN	NOV 9 2001	11-8-01	REP
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>AB</u>		
615	ROLLMARK CALIBER		11/9	AB
617	DRILL AND TAP SIGHT HOLES		11-12	BUT
620	APPLY COATINGS (BARREL ACTION)		11-27	TA
	(BOLT)		11-27	TA
625	FINAL ASSEMBLY		12/13/01	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/13/01	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/13/01	DA
	D) OIL FIRING PIN ASSEMBLY		12/13/01	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	1-16-02	DA

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.05</u> <u>5.50</u> <u>5.25</u>	1/3/02	D.M.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.25</u> <u>2.25</u>	1/3/02	D.M.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	1/3/02	D.M.
	J) ASSEMBLE STOCK		12/18	BWT
	K) ASSEMBLE SWIVEL STUDS		1/10/02	PW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1/10/02	PW
	M) IRON SIGHT ALIGNMENT		1/10/02	PW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1/10/02	PW
640	GALLERY TEST AND TARGET	PASS FAIL	12-20-01	A
	A) MALFUNCTIONS	PASS FAIL	12-20-01	A
	B) PIERCED PRIMERS	PASS FAIL	12-20-01	A
645	INSPECT FOR LIVE AMMO		12-20-01	A
655	FINAL INSPECTION A) HEADSPACE		1/10/02	PW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.68</u> <u>2.52</u> <u>2.72</u> <u>2.59</u>	1/8/02	D.M.
	C) FUNCTION		1/10/02	PW
660	PACK		1-16-02	GA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. E6790533

DATE 1/7/61

TESTER DN

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.33		2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.50		2.26	
PULL #3	2.50	2.56		2.28	
PULL #4	2.57	2.57		2.29	
PULL #5	2.48	2.50		2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.09		
PULL #2	3.23	3.05		
PULL #3	3.13	2.96		
PULL #4	3.15	2.93		
PULL #5	3.05	2.98		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.16	4.12		4.04
PULL #2	4.11	3.99		4.06
PULL #3	3.95	3.95		4.06
PULL #4	4.04	3.91		4.16
PULL #5	4.01	4.05		4.04
TOTAL				
AVG.				

SERIAL NUMBER: E6790533. __0

TARGET NUMBER: 1

FILE DATE: 12/20/2001

FILE TIME: 04:06

POINT#	X	Y
1:	0.736	-0.875
2:	0.075	0.206
3:	0.310	0.716
4:	-0.608	-0.115
5:	-0.484	0.141

X CENTROID: 0.006

Y CENTROID: 0.015

POA TO CENTROID: 0.016

HORZ SPREAD: 1.344

VERT SPREAD: 1.591

GROUP SPREAD: 1.647

MIN RADIUS: 0.204

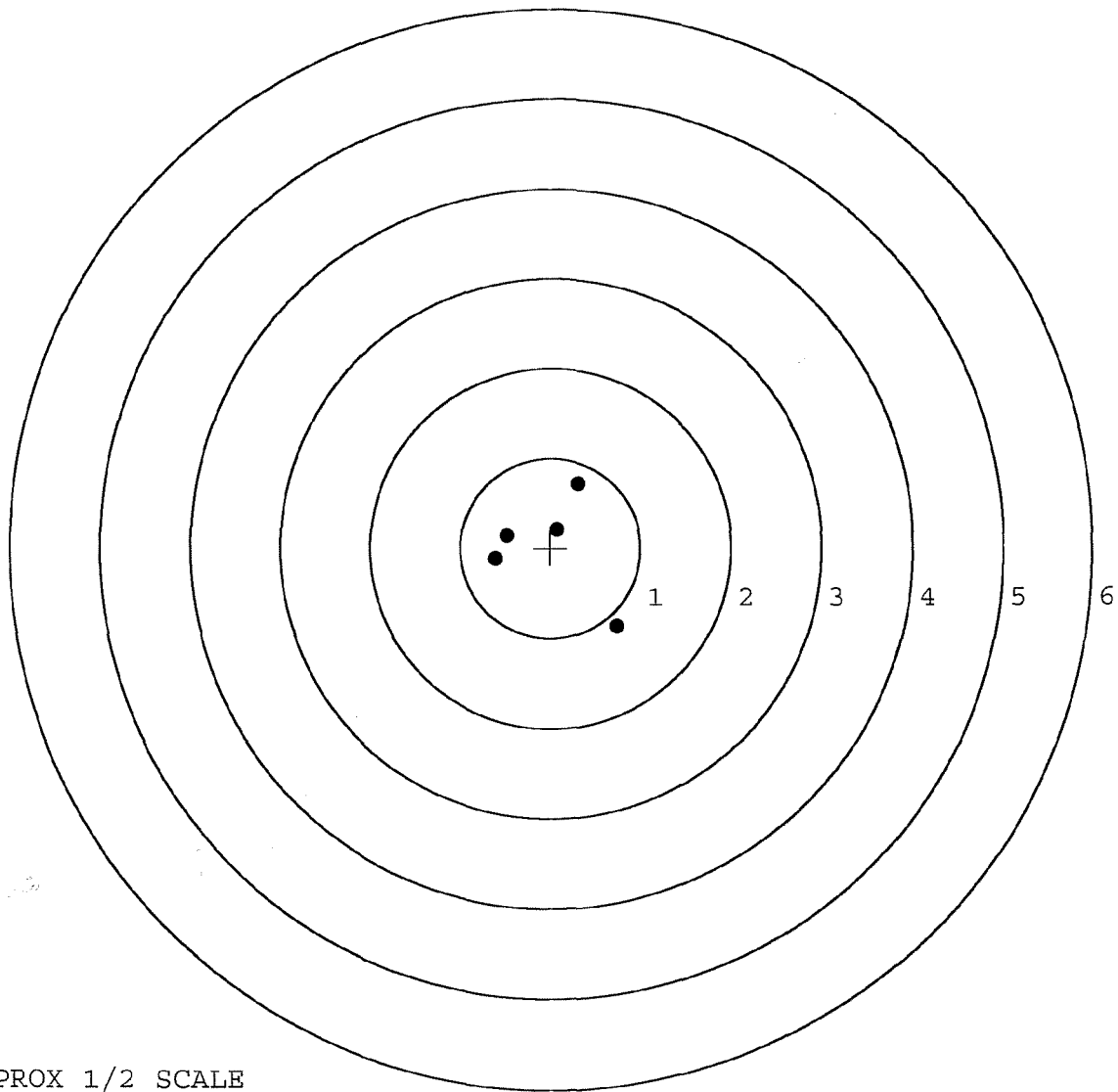
MAX RADIUS: 1.151

MEAN RADIUS: 0.650

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 5

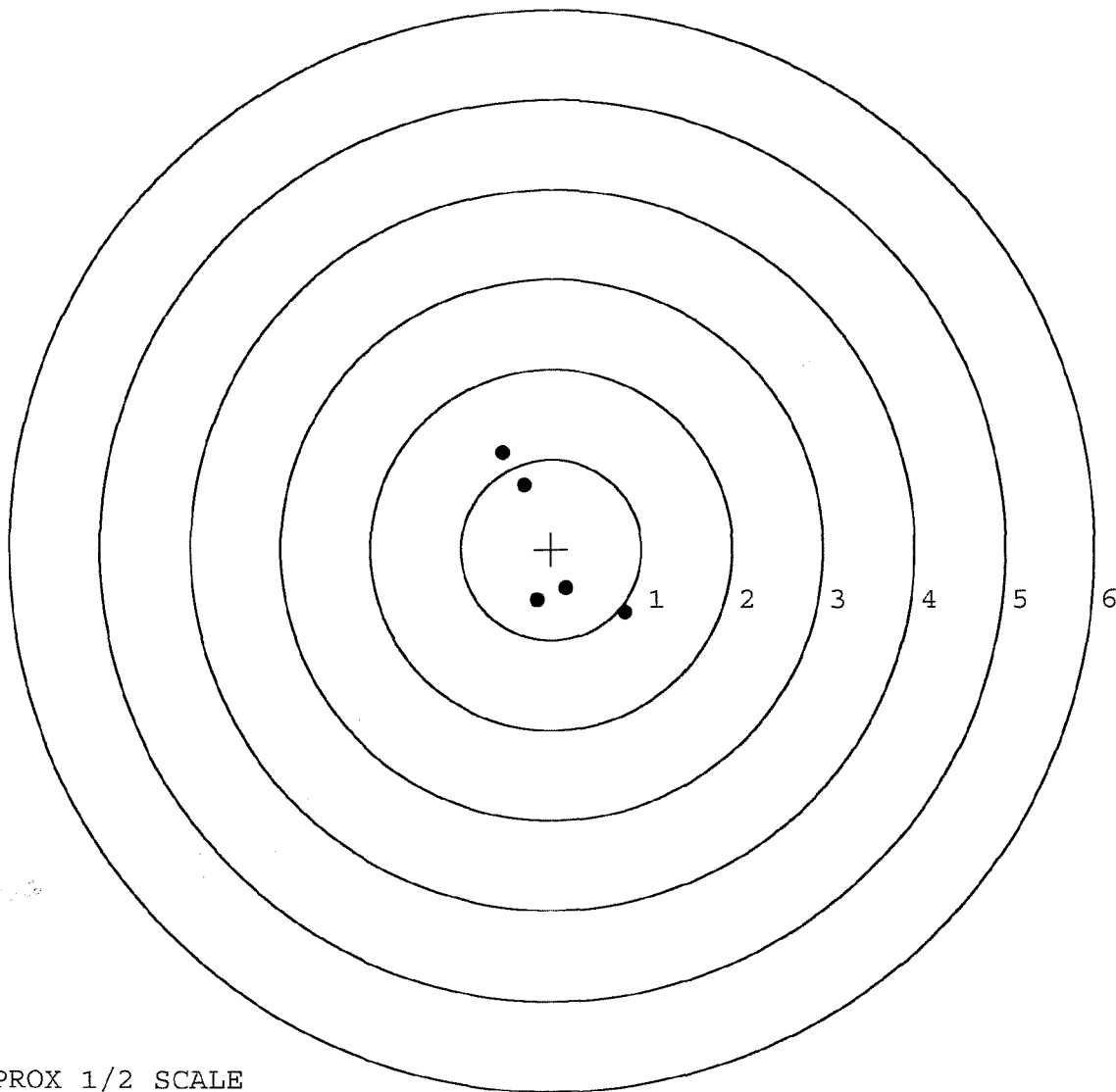


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790533. __ 0
TARGET NUMBER: .2
FILE DATE: 12/20/2001
FILE TIME: 04:06

POINT#	X	Y
1:	0.817	-0.699
2:	0.160	-0.440
3:	-0.166	-0.564
4:	-0.303	0.714
5:	-0.535	1.077

X CENTROID: -0.005
Y CENTROID: 0.018
POA TO CENTROID: 0.018
HORZ SPREAD: 1.352
VERT SPREAD: 1.776
GROUP SPREAD: 2.232
MIN RADIUS: 0.487
MAX RADIUS: 1.184
MEAN RADIUS: 0.824
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE