

E 6790522

VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
E6790562

46

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

31XV

1. The first step in the process of creating a new product is to identify a market need. This involves conducting market research to understand what consumers want and what problems they are facing. Once a need is identified, the next step is to develop a concept that addresses this need. This is often done through brainstorming sessions and the creation of a prototype. The concept is then refined through further research and development, leading to the creation of a final product. This process is iterative, with many products going through several versions before reaching the market. The final product is then launched and marketed to the target audience. The success of a new product depends on how well it meets the market need and how effectively it is marketed.

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MODEL 700™ M24**MODEL 700™ M24**

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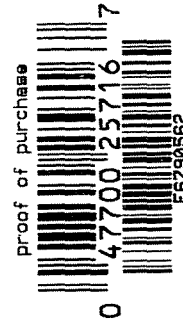
E6790562

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

DOCUMENT ENVELOPE ASSEMBLY:

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

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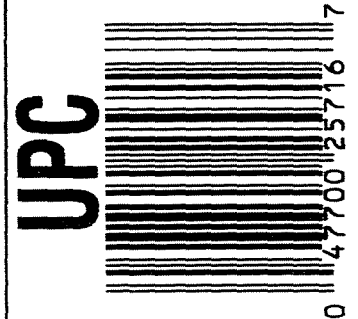


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790562



GUN SERIAL # E6790562

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	11-8-01	REP
610	DIS-ASSEMBLE GUN	INSPECTED	11-8-01	REP
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 10 2001 OPERATOR <u>ARL</u>		
615	ROLLMARK CALIBER		11/12	AB
617	DRILL AND TAP SIGHT HOLES		11/14	BWT
620	APPLY COATINGS (BARREL ACTION)		11/15	HP
	(BOLT)		11/15	HP
625	FINAL ASSEMBLY		12/9/01	DK
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/9/01	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/9/01	DK
	D) OIL FIRING PIN ASSEMBLY		12/9/01	DK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	12/9/01	DK

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.5</u> <u>5.25</u>	<u>12-17-01</u>	<u>EK</u>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	<u>12-17-01</u>	<u>EK</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.0215</u> <u>.0235</u>	<u>12-17-01</u>	<u>EK</u>
	J) ASSEMBLE STOCK		<u>12/13</u>	<u>BWT</u>
	K) ASSEMBLE SWIVEL STUDS		<u>12/19/01</u>	<u>Rep</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>12/19/01</u>	<u>Rep</u>
	M) IRON SIGHT ALIGNMENT		<u>12/19/01</u>	<u>Rep</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>12/19/01</u>	<u>Rep</u>
640	GALLERY TEST AND TARGET	PASS FAIL	<u>12-13-01</u>	<u>A</u>
	A) MALFUNCTIONS	PASS FAIL	<u>12-13-01</u>	<u>A</u>
	B) PIERCED PRIMERS	PASS FAIL	<u>12-13-01</u>	<u>A</u>
645	INSPECT FOR LIVE AMMO		<u>12/13-01</u>	<u>A</u>
655	FINAL INSPECTION A) HEADSPACE		<u>12/19/01</u>	<u>Rep</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.71</u> <u>2.75</u> <u>2.76</u> <u>2.69</u>	<u>12/18/01</u>	<u>J.M.</u>
	C) FUNCTION		<u>12/19/01</u>	<u>Rep</u>
660	PACK		<u>12/21/01</u>	<u>DR</u>

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

SERIAL NO. E6790562

DATE 10/29/01

TESTER A.M.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.39	2.01	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.40	2.55	
PULL #3	2.15	2.40	2.47	
PULL #4	2.12	2.38	2.56	
PULL #5	2.17	2.37	2.51	
TOTAL	11.16	11.57	12.54	
AVG.	2.23	2.31	2.50	

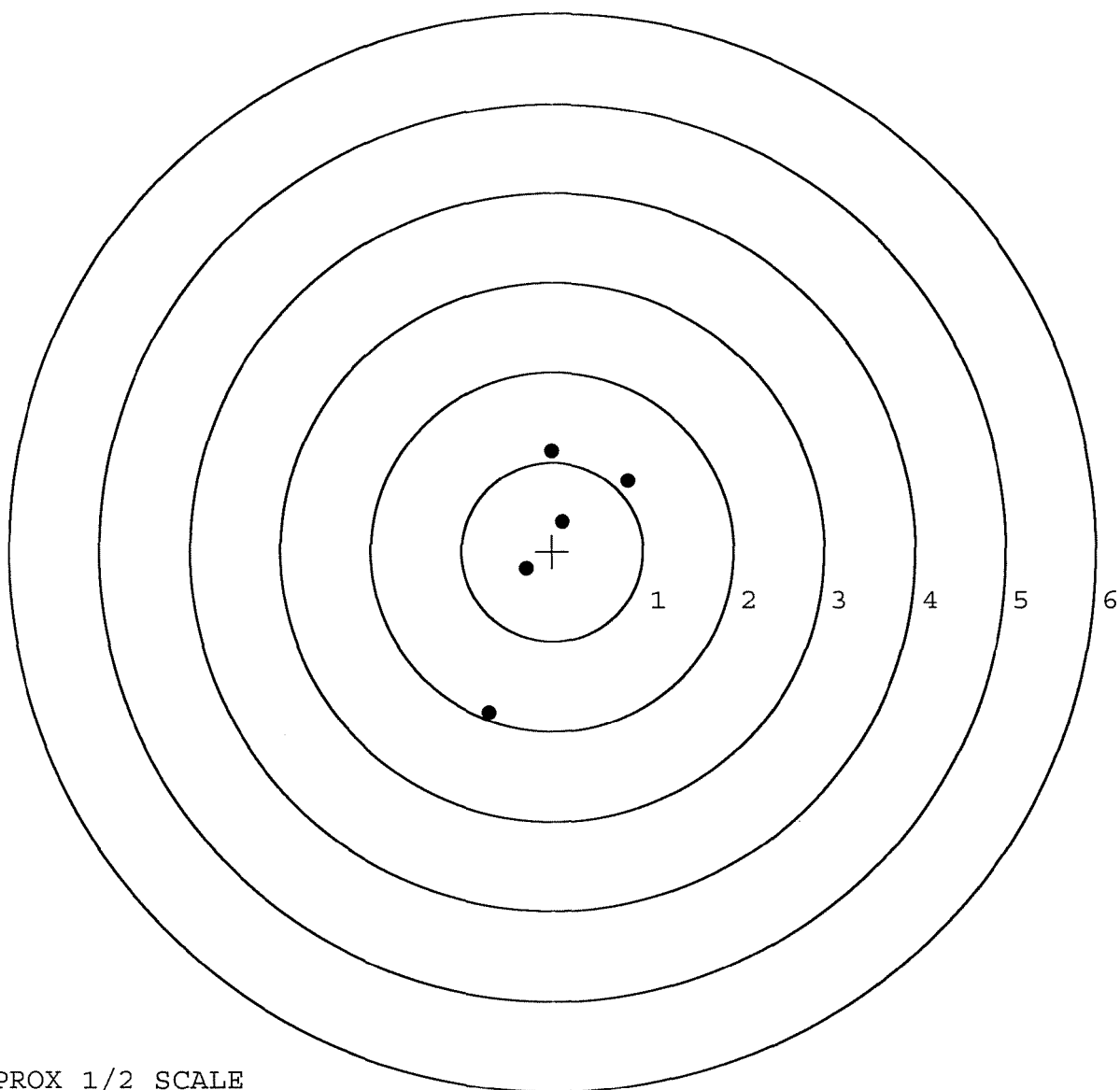
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.31		
PULL #2	3.17	3.34		
PULL #3	3.22	3.31		
PULL #4	3.34	3.46		
PULL #5	3.27	3.31		
TOTAL	16.30	16.73		
AVG.	3.26	3.35		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.01		4.25
PULL #2	4.07	4.17		4.20
PULL #3	4.02	4.21		4.06
PULL #4	4.32	4.02		3.95
PULL #5	4.25	4.08		4.26
TOTAL	21.02	20.49		20.72
AVG.	4.20	4.10		4.14

SERIAL NUMBER: E6790562. __0
TARGET NUMBER: 1
FILE DATE: 12/13/2001
FILE TIME: 03:58

POINT#	X	Y
1:	-0.701	-1.799
2:	-0.292	-0.198
3:	0.113	0.328
4:	0.840	0.789
5:	-0.008	1.121

X CENTROID: -0.010
Y CENTROID: 0.048
POA TO CENTROID: 0.049
HORZ SPREAD: 1.541
VERT SPREAD: 2.920
GROUP SPREAD: 3.012
MIN RADIUS: 0.305
MAX RADIUS: 1.972
MEAN RADIUS: 0.970
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 4

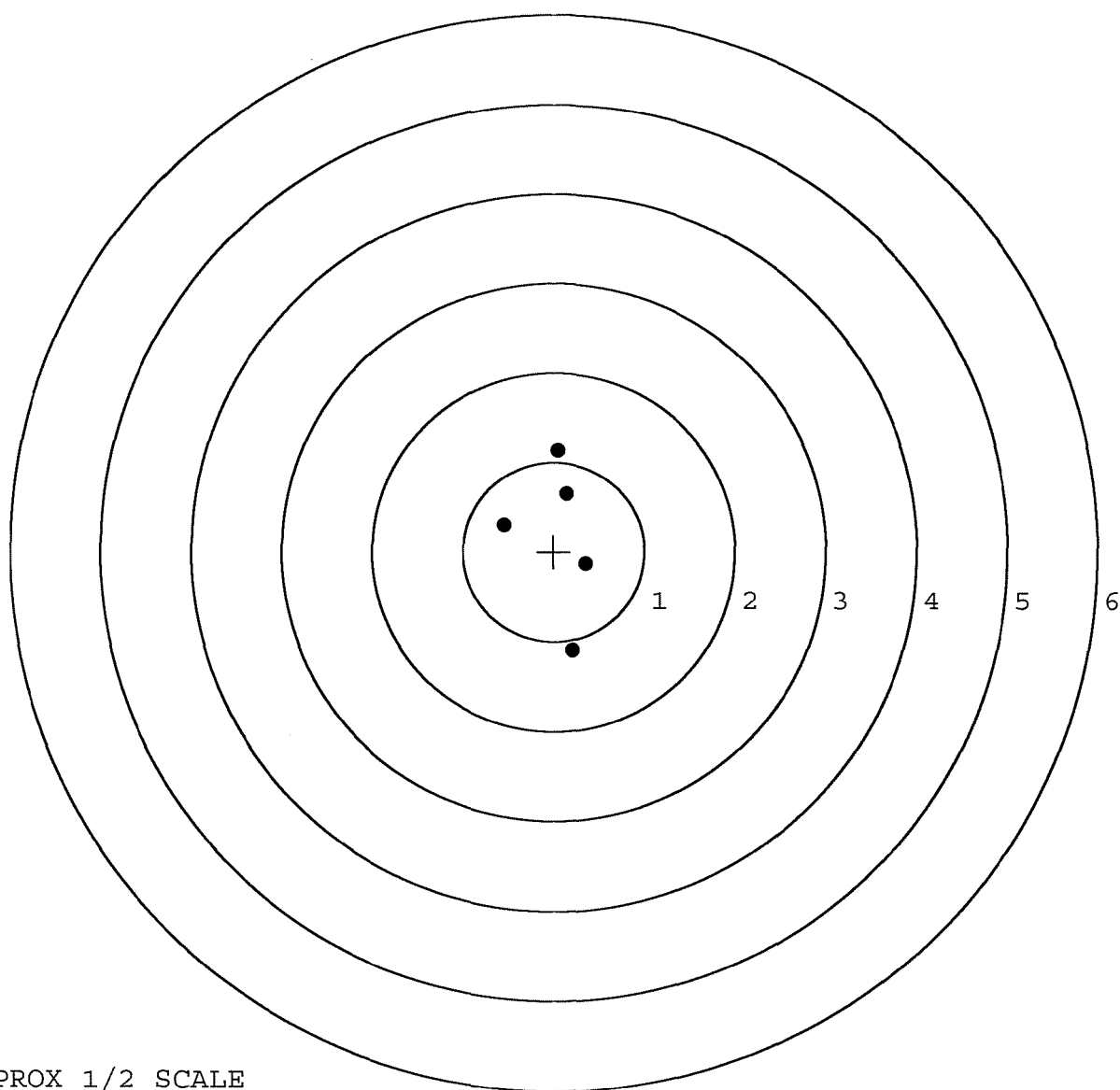


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790562. __0
TARGET NUMBER: 2
FILE DATE: 12/13/2001
FILE TIME: 03:58

POINT#	X	Y
1:	0.052	1.128
2:	0.143	0.644
3:	-0.551	0.297
4:	0.357	-0.138
5:	0.213	-1.105

X CENTROID: 0.043
Y CENTROID: 0.165
POA TO CENTROID: 0.171
HORZ SPREAD: 0.908
VERT SPREAD: 2.233
GROUP SPREAD: 2.239
MIN RADIUS: 0.437
MAX RADIUS: 1.282
MEAN RADIUS: 0.756
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE