

EC790592

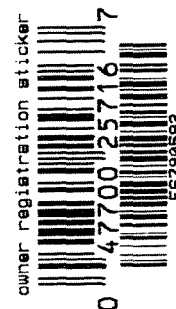
M2400111451

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

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

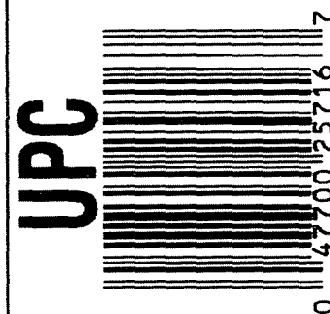


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790592



CONTRACT #

GUN SERIAL # E6790592

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/10/01	KCH
600	PROOF		11/10/01	KCH
607	CHECK HEADSPACE		11/10/01	KCH
610	DIS-ASSEMBLE GUN		11/10/01	KCH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		NOV 15 2001	AC
615	ROLLMARK CALIBER		11/15-01	Wm
617	DRILL AND TAP SIGHT HOLES		11/15	BWT
620	APPLY COATINGS (BARREL ACTION)		11-27	TA
	(BOLT)		11-27	TA
625	FINAL ASSEMBLY		12/13/01	DK
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/14/01	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/14/01	DK
	D) OIL FIRING PIN ASSEMBLY		12/14/01	DK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.2</u> <u>4.5</u> <u>4.5</u>	12/19/01	JA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>3.2</u> <u>2.5</u>	12/19/01	JA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12/19/01	JA
	J) ASSEMBLE STOCK		12-16-01	liv
	K) ASSEMBLE SWIVEL STUDS		12/20/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/20/01	REP
	M) IRON SIGHT ALIGNMENT		12/20/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/20/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	12/20/01	A
	A) MALFUNCTIONS	PASS FAIL	12/20/01	Q
	B) PIERCED PRIMERS	PASS FAIL	12/20/01	FF
645	INSPECT FOR LIVE AMMO		12/20/01	FF
655	FINAL INSPECTION A) HEADSPACE		12/20/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.73</u> <u>2.78</u> <u>2.68</u> <u>2.68</u>	12/19/01	BWT
	C) FUNCTION		12/20/01	REP
660	PACK		12/20/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. F6790592

DATE 11/01/01

TESTER B.K.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	231	2.28		2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	230	2.27		2.70	
PULL #3	2.37	2.31		2.66	
PULL #4	2.33	2.36		2.73	
PULL #5	2.21	2.27		2.67	
TOTAL	1152	1149		1343	
AVG.	2.30	2.29		2.68	

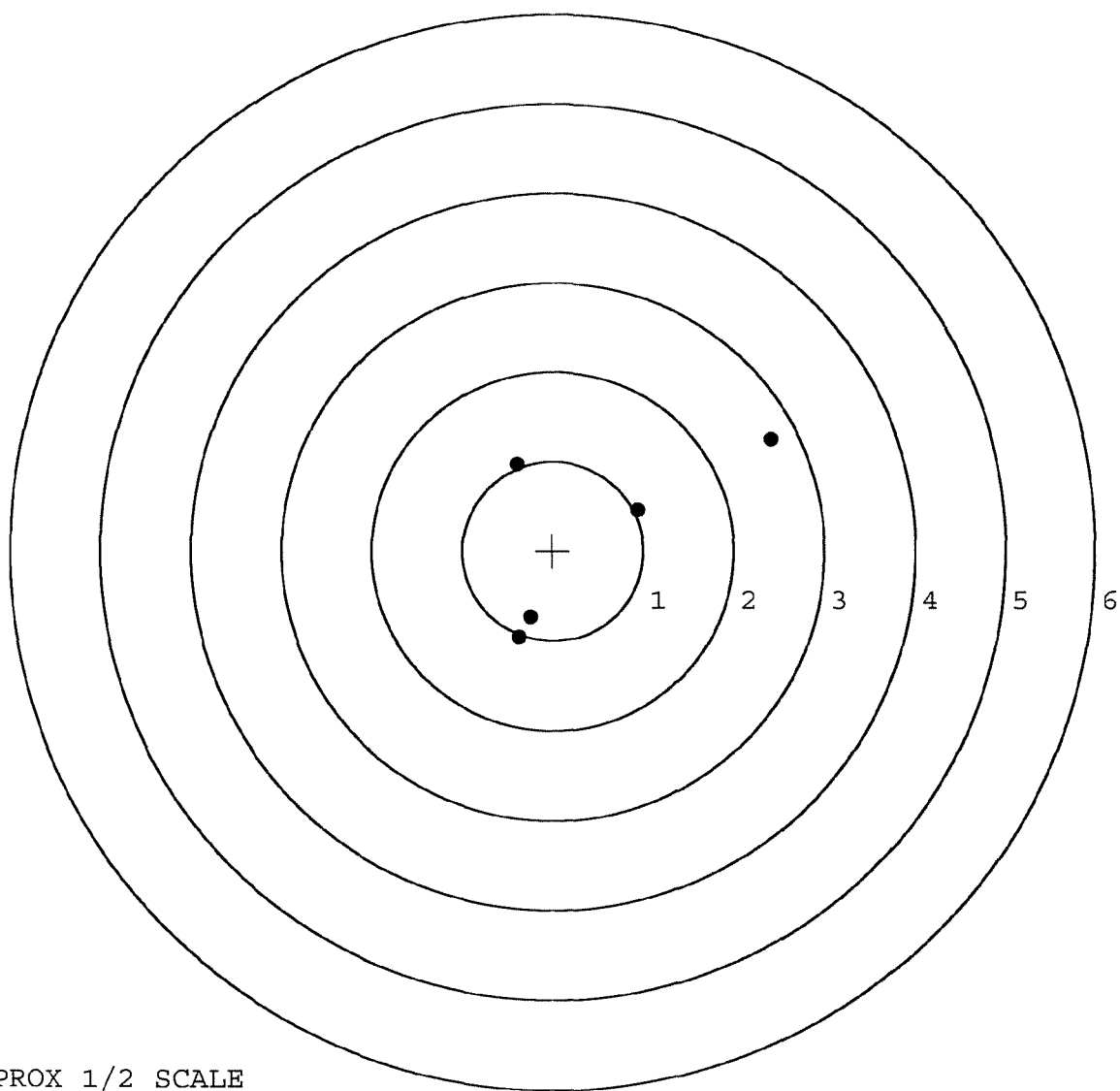
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.18		
PULL #2	3.29	3.11		
PULL #3	3.18	3.11		
PULL #4	3.15	3.13		
PULL #5	3.19	3.21		
TOTAL	1612	1574		
AVG.	3.22	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.11		4.60
PULL #2	4.06	3.97		4.61
PULL #3	4.23	4.12		4.64
PULL #4	4.53	4.20		4.61
PULL #5	4.19	4.31		4.60
TOTAL	2122	2071		2306
AVG.	4.24	4.14		4.61

SERIAL NUMBER: E6790592. __0
TARGET NUMBER: 1
FILE DATE: 12/18/2001
FILE TIME: 06:33

POINT#	X	Y
1:	-0.380	-0.971
2:	-0.251	-0.745
3:	0.934	0.454
4:	-0.400	0.972
5:	2.413	1.240

X CENTROID: 0.463
Y CENTROID: 0.190
POA TO CENTROID: 0.501
HORZ SPREAD: 2.813
VERT SPREAD: 2.211
GROUP SPREAD: 3.562
MIN RADIUS: 0.540
MAX RADIUS: 2.215
MEAN RADIUS: 1.306
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 1
in 3 IN DIAMETER: 4

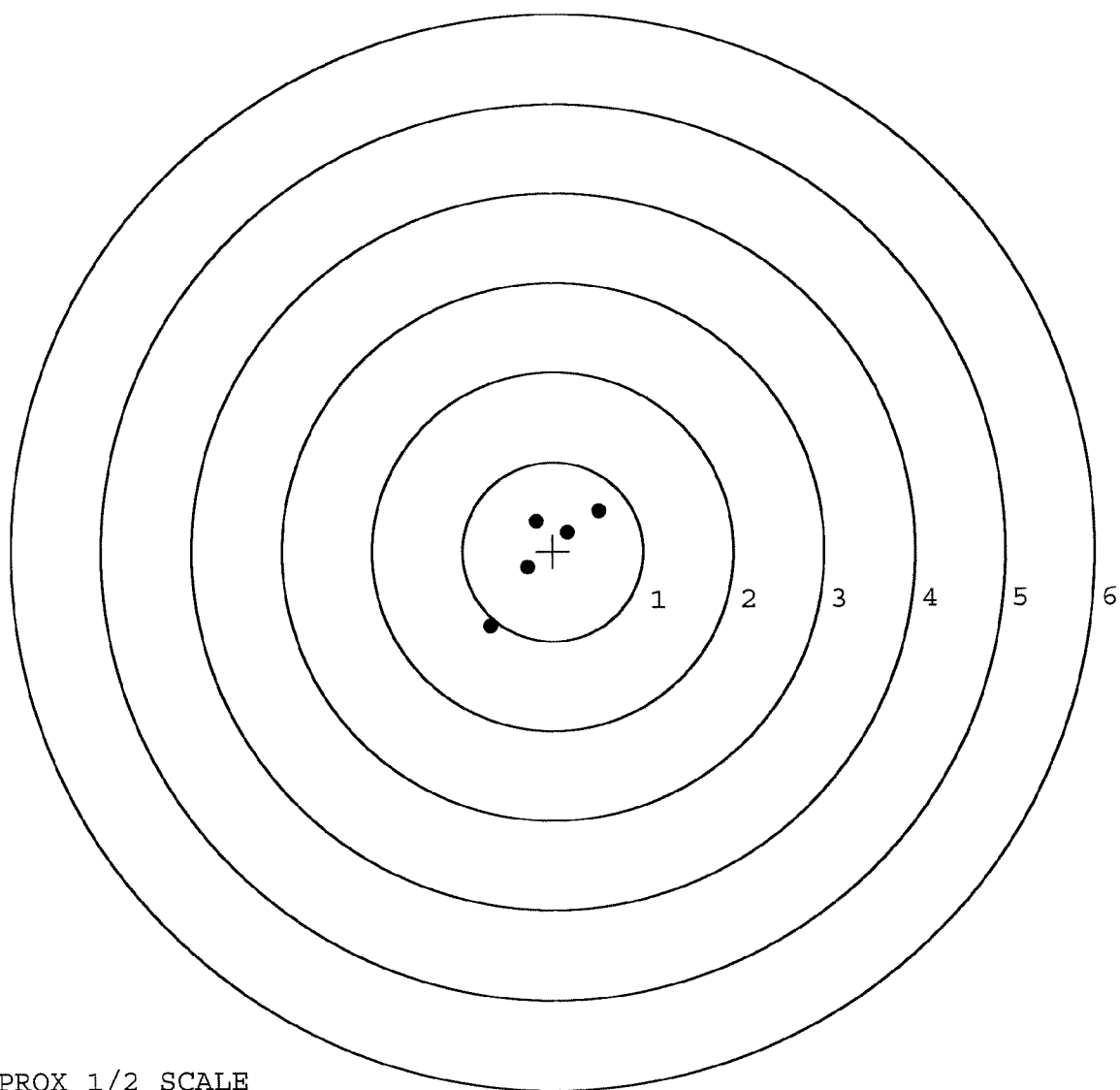


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790592. __0
TARGET NUMBER: 2
FILE DATE: 12/18/2001
FILE TIME: 06:33

POINT#	X	Y
1:	-0.694	-0.834
2:	-0.281	-0.182
3:	-0.186	0.340
4:	0.164	0.209
5:	0.509	0.447

X CENTROID: -0.098
Y CENTROID: -0.004
POA TO CENTROID: 0.098
HORZ SPREAD: 1.203
VERT SPREAD: 1.281
GROUP SPREAD: 1.757
MIN RADIUS: 0.256
MAX RADIUS: 1.022
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE