

E 6790203

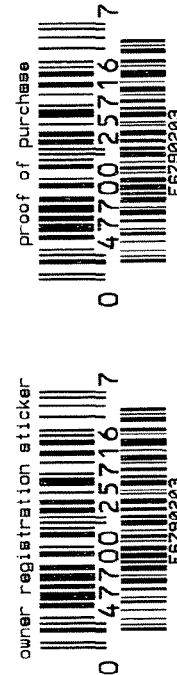
M2400115051

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

DOCUMENT ENVELOPE ASSEMBLY:

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

46 FORM 1444

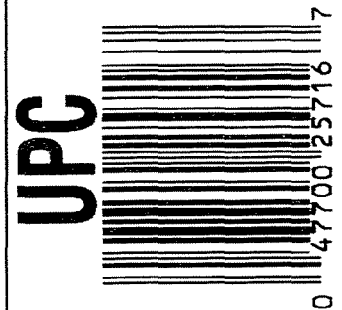


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790203



CONTRACT #

GUN SERIAL # E6790203

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/5/01	REP
600	PROOF		11/5/01	REP
607	CHECK HEADSPACE	MAGNA - FLUX	11/5/01	REP
610	DIS-ASSEMBLE GUN	INSPECTED	11/5/01	REP
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	11/7 - 2001 OPERATOR <u>DRS</u>		
615	ROLLMARK CALIBER		11/6	Ⓟ
617	DRILL AND TAP SIGHT HOLES		11/7	BWT
620	APPLY COATINGS (BARREL ACTION)		11/14	HP
	(BOLT)		11/14	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-7	K7
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-8	K7
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-7	K7
	D) OIL FIRING PIN ASSEMBLY		12/17/01	RA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12/17/01	RA

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>3.75</u> <u>3.5</u>	12-13-01	EK
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	12-13-01	EK
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.021</u> <u>.0225</u>	12-13-01	EK
	J) ASSEMBLE STOCK		12-16-01	RW
	K) ASSEMBLE SWIVEL STUDS		12/17/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/17/01	REP
	M) IRON SIGHT ALIGNMENT		12/17/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/17/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	12-11-01	K
	A) MALFUNCTIONS	PASS FAIL	12-11-01	K
	B) PIERCED PRIMERS	PASS FAIL	12-11-01	A
645	INSPECT FOR LIVE AMMO		12-11-01	A
655	FINAL INSPECTION A) HEADSPACE		12/17/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>271</u> <u>263</u> <u>283</u> <u>288</u> <u>275</u>	12/14/01	SM
	C) FUNCTION		12/17/01	REP
660	PACK		12/17/01	SM

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. FL790203

DATE 12/9/01

TESTER DM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.50	2.55	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.70	2.67	2.74	
PULL #3	2.70	2.69	2.81	
PULL #4	2.59	2.54	2.48	
PULL #5	2.52	2.64	2.58	
TOTAL	13.01	13.09	13.39	
AVG.	2.60	2.62	2.68	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.13	3.17	
PULL #2	3.52	3.63	
PULL #3	3.43	3.82	
PULL #4	3.23	3.23	
PULL #5	3.35	3.26	
TOTAL	16.66	17.11	
AVG.	3.33	3.42	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.13	4.53		4.39
PULL #2	4.04	3.92		3.95
PULL #3	4.05	4.54		3.94
PULL #4	4.10	4.45		4.05
PULL #5	3.94	4.06		4.00
TOTAL	20.26	21.50		20.33
AVG.	4.05	4.30		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790203.__0
FILE DATE AND TIME: 12/11/2001 01:21

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.183
The Average Y Centroid of the Five Target Set:	0.070
The Average Point of Impact of the Five Target Set:	0.196
The Average Mean Radius of the Five Target Set:	0.536
The Distance from POA to Centroid Target #1:	0.475
The Distance from Centroid Target #2 to Centroid Target #1:	0.260
The Distance from Centroid Target #3 to Centroid Target #1:	0.455
The Distance from Centroid Target #4 to Centroid Target #1:	0.422
The Distance from Centroid Target #5 to Centroid Target #1:	0.398

SERIAL NUMBER: E6790203. 0

TARGET NUMBER: 1

FILE DATE: 12/11/2001

FILE TIME: 01:21

X CENTROID: 0.363

Y CENTROID: 0.307

POA TO CENTROID: 0.475

HORZ SPREAD: 1.371

VERT SPREAD: 2.746

GROUP SPREAD: 2.794

MIN RADIUS: 0.155

MAX RADIUS: 1.702

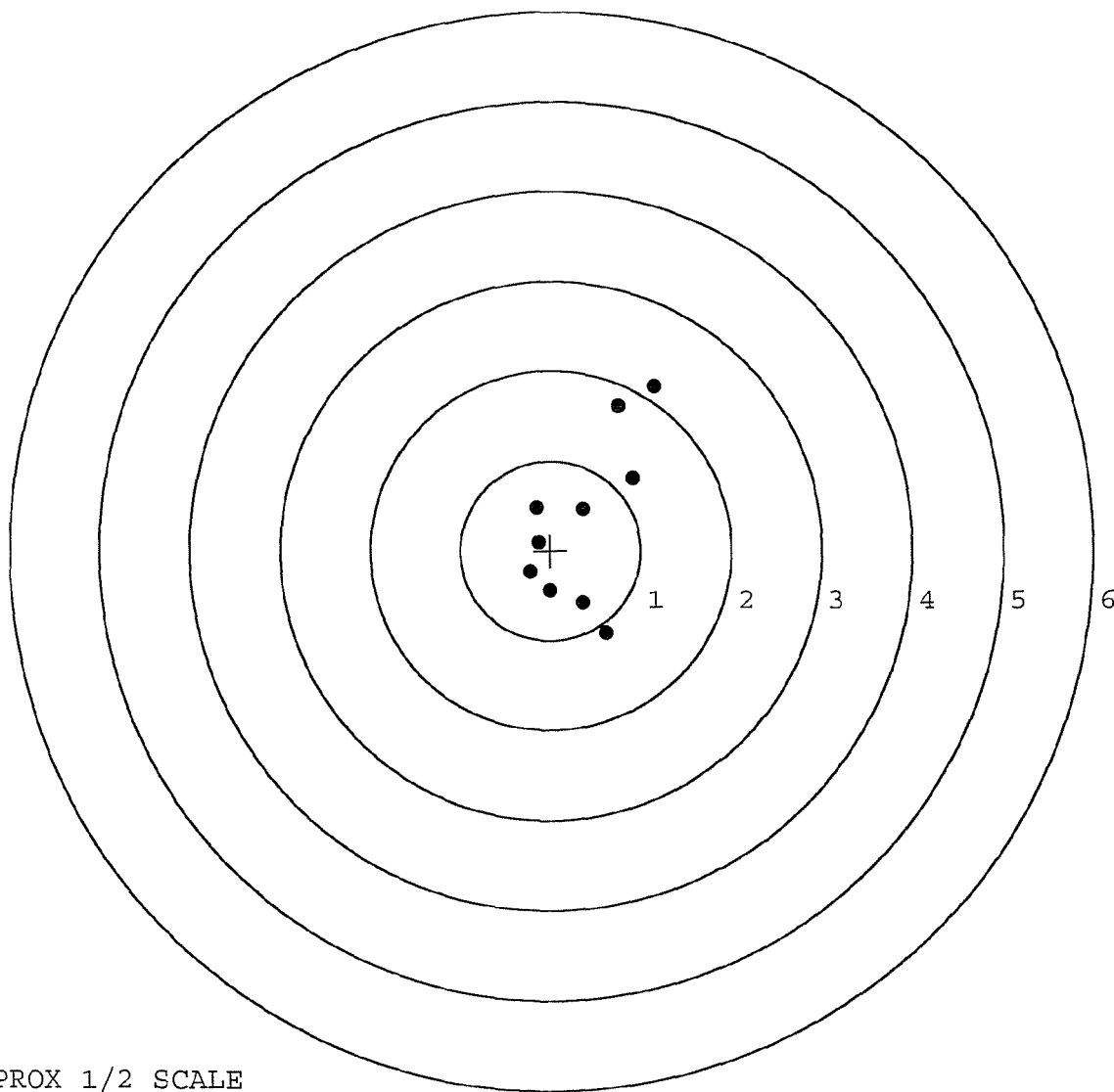
MEAN RADIUS: 0.884

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.140	1.821
2:	0.748	1.600
3:	0.912	0.811
4:	0.363	0.462
5:	-0.156	0.479
6:	-0.133	0.098
7:	-0.231	-0.241
8:	-0.004	-0.450
9:	0.360	-0.587
10:	0.626	-0.925



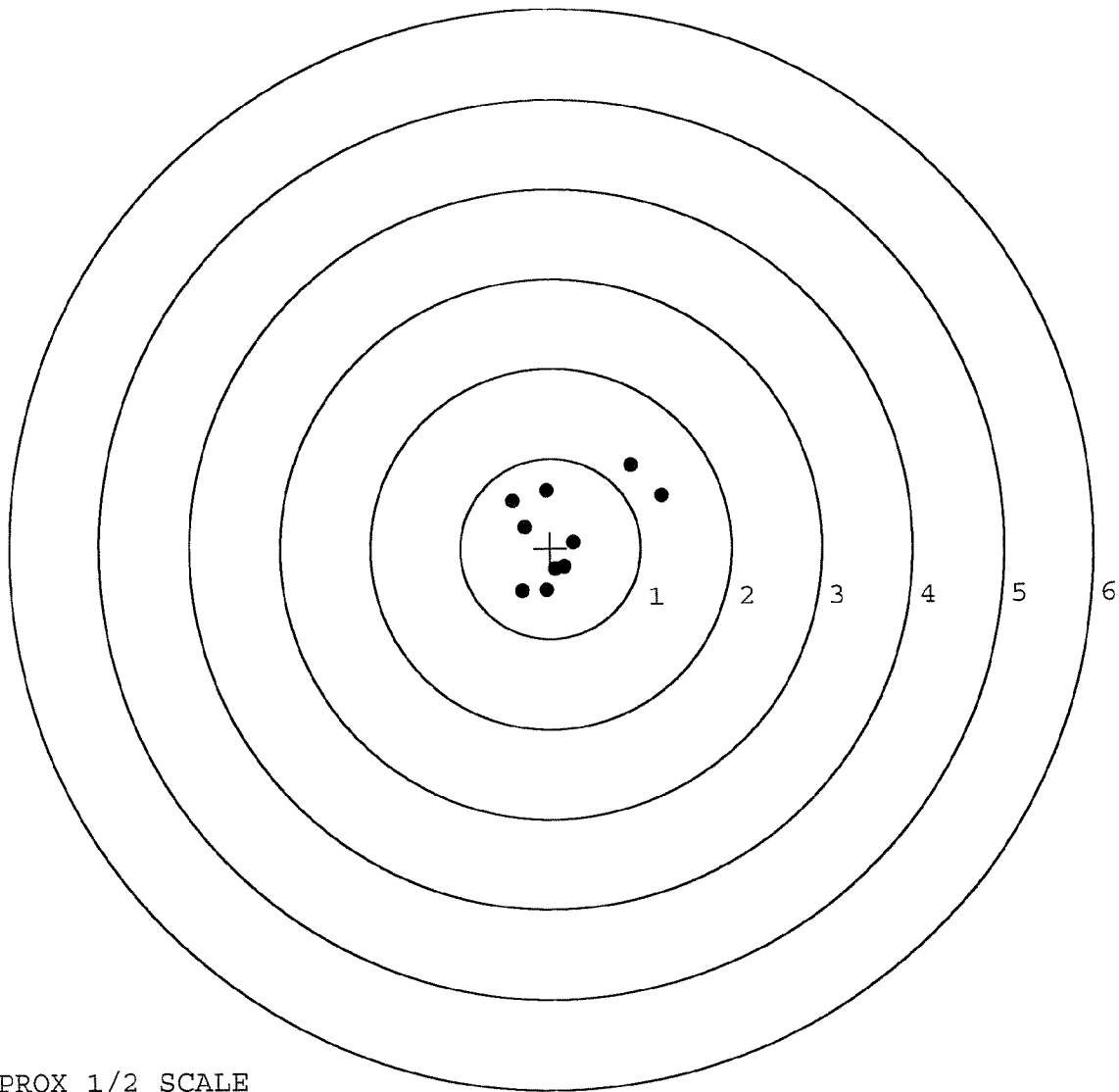
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790203. __0
TARGET NUMBER: 2
FILE DATE: 12/11/2001
FILE TIME: 01:21

X CENTROID: 0.149
Y CENTROID: 0.158
POA TO CENTROID: 0.217
HORZ SPREAD: 1.652
VERT SPREAD: 1.395
GROUP SPREAD: 1.881
MIN RADIUS: 0.141
MAX RADIUS: 1.167
MEAN RADIUS: 0.623

POINT#	X	Y
1:	-0.042	0.646
2:	-0.415	0.533
3:	-0.286	0.236
4:	0.255	0.066
5:	0.157	-0.209
6:	-0.052	-0.467
7:	-0.320	-0.478
8:	1.237	0.578
9:	0.894	0.917
10:	0.058	-0.239

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

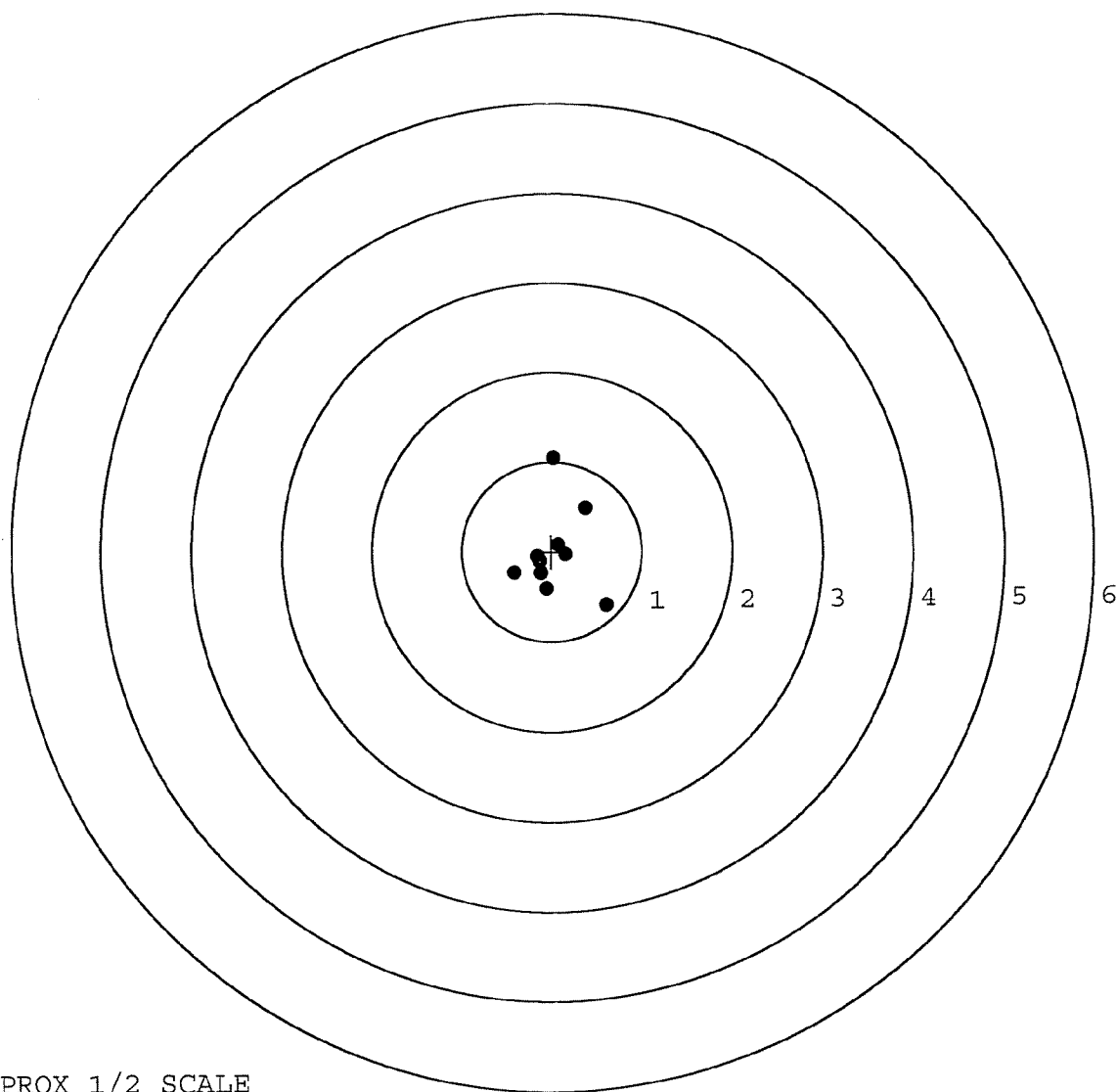


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790203. __0
TARGET NUMBER: 3
FILE DATE: 12/11/2001
FILE TIME: 01:21

POINT#	X	Y
1:	0.030	1.044
2:	0.385	0.486
3:	0.606	-0.605
4:	-0.062	-0.416
5:	-0.419	-0.234
6:	-0.164	-0.057
7:	0.080	0.079
8:	0.157	-0.037
9:	-0.135	-0.110
10:	-0.121	-0.246

X CENTROID: 0.036
Y CENTROID: -0.010
POA TO CENTROID: 0.037
HORZ SPREAD: 1.025
VERT SPREAD: 1.649
GROUP SPREAD: 1.747
MIN RADIUS: 0.099
MAX RADIUS: 1.054
MEAN RADIUS: 0.432
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

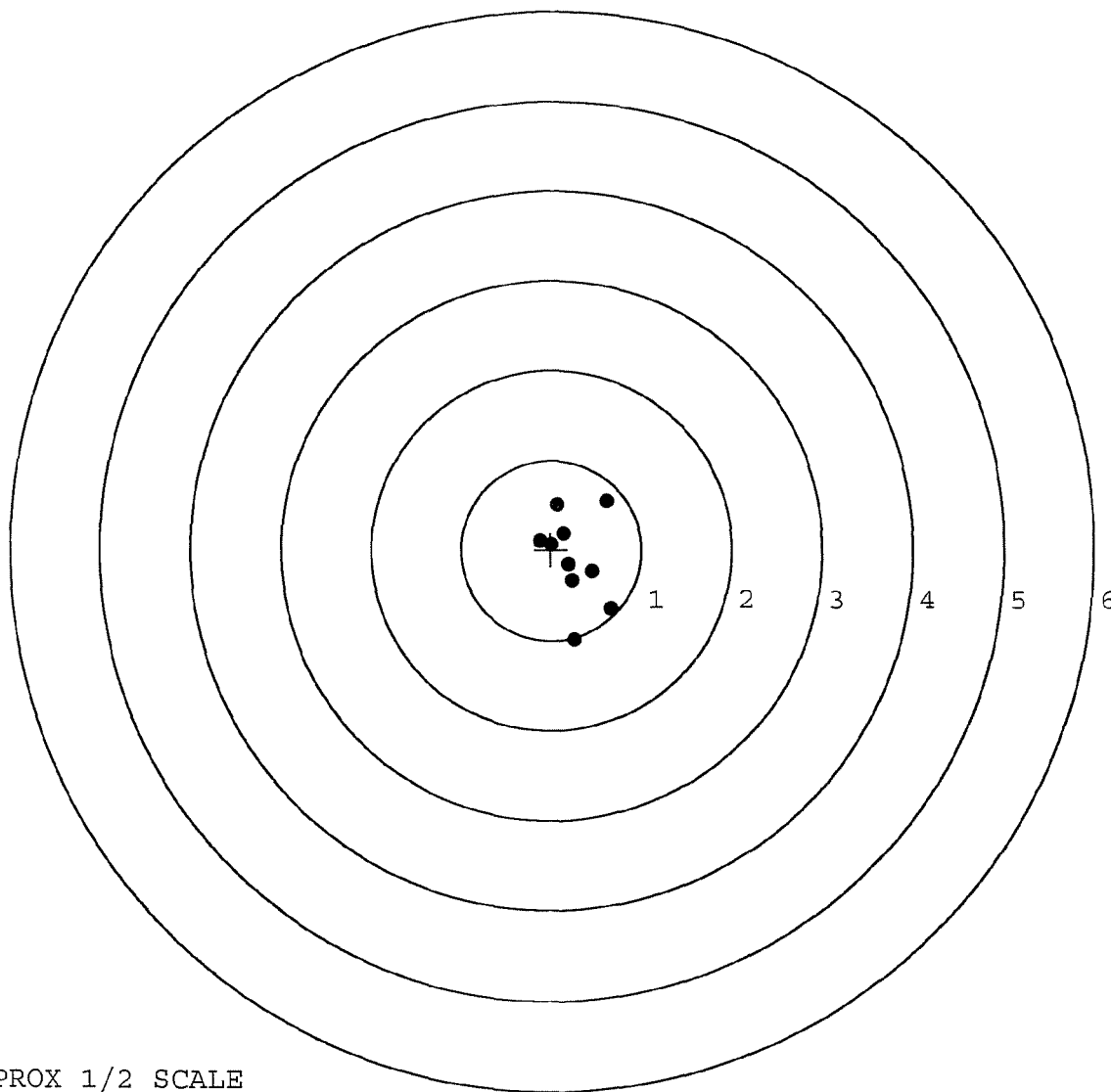


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790203. 0
TARGET NUMBER: 4
FILE DATE: 12/11/2001
FILE TIME: 01:21

POINT#	X	Y
1:	0.618	0.545
2:	0.458	-0.244
3:	0.670	-0.657
4:	0.263	-0.995
5:	0.236	-0.341
6:	-0.125	0.100
7:	0.069	0.513
8:	0.145	0.182
9:	-0.001	0.058
10:	0.194	-0.166

X CENTROID: 0.253
Y CENTROID: -0.101
POA TO CENTROID: 0.272
HORZ SPREAD: 0.795
VERT SPREAD: 1.540
GROUP SPREAD: 1.580
MIN RADIUS: 0.088
MAX RADIUS: 0.895
MEAN RADIUS: 0.458
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

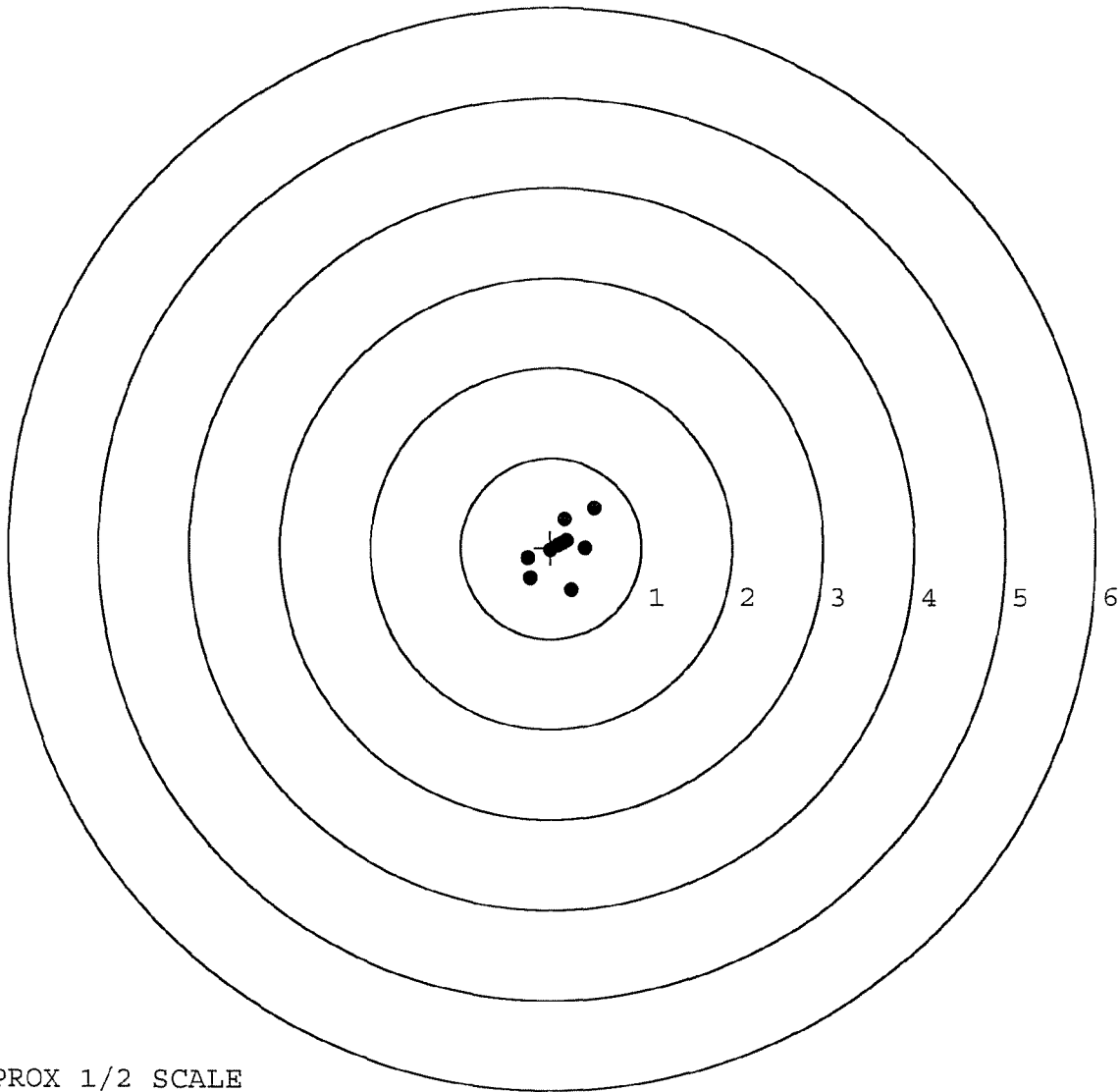


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790203. __0
TARGET NUMBER: 5
FILE DATE: 12/11/2001
FILE TIME: 01:21

POINT#	X	Y
1:	0.477	0.444
2:	0.380	0.006
3:	0.233	-0.471
4:	-0.229	-0.339
5:	-0.256	-0.117
6:	-0.013	-0.031
7:	0.176	0.078
8:	0.153	0.316
9:	0.083	0.028
10:	0.127	0.048

X CENTROID: 0.113
Y CENTROID: -0.004
POA TO CENTROID: 0.113
HORZ SPREAD: 0.733
VERT SPREAD: 0.915
GROUP SPREAD: 1.054
MIN RADIUS: 0.044
MAX RADIUS: 0.577
MEAN RADIUS: 0.284
IN 1 IN DIAMETER: 9
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE