

E6790277

M2400115419

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

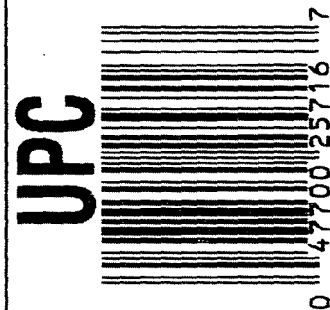


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790277



CONTRACT #

GUN SERIAL # E6790277

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11/27/01	RJR
600	PROOF		11/27/01	RJR
607	CHECK HEADSPACE	MAGNA - FLUX	11/27/01	RJR
610	DIS-ASSEMBLE GUN	INSPECTED	11/27/01	RJR
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 27 2001 OPERATOR <u>ABD</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		12/12/01	D.N.
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12/12/01	D.N.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/12/01	D.N.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/12/01	D.N.
	D) OIL FIRING PIN ASSEMBLY		12/12/01	D.N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	12/12/01	LN

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>5.5</u>	12-18-01	EK
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.75</u> <u>3.5</u> <u>3.25</u>	12-18-01	EK
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.0225</u> <u>.024</u>	12-18-01	EK
	J) ASSEMBLE STOCK		12-18-01	REP
	K) ASSEMBLE SWIVEL STUDS		12/19/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/19/01	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	12-19-01	REP
	A) MALFUNCTIONS	PASS FAIL	12/17/01	REP
	B) PIERCED PRIMERS	PASS FAIL	12-24-01	REP
645	INSPECT FOR LIVE AMMO			
655	FINAL INSPECTION A) HEADSPACE		12/19/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.19</u> <u>2.14</u> <u>2.40</u> <u>2.44</u>	12/18/01	D.H.
	C) FUNCTION		12/19/01	REP
660	PACK		12/21/01	D.H.

SERIAL NUMBER: E6790277. __0

TARGET NUMBER: 1

FILE DATE: 12/17/2001

FILE TIME: 12:05

POINT#	X	Y
1:	0.827	-0.639
2:	1.006	1.361
3:	-0.186	0.780
4:	-0.674	-0.314
5:	-0.495	-0.952

X CENTROID: 0.096

Y CENTROID: 0.047

POA TO CENTROID: 0.107

HORZ SPREAD: 1.680

VERT SPREAD: 2.313

GROUP SPREAD: 2.757

MIN RADIUS: 0.785

MAX RADIUS: 1.598

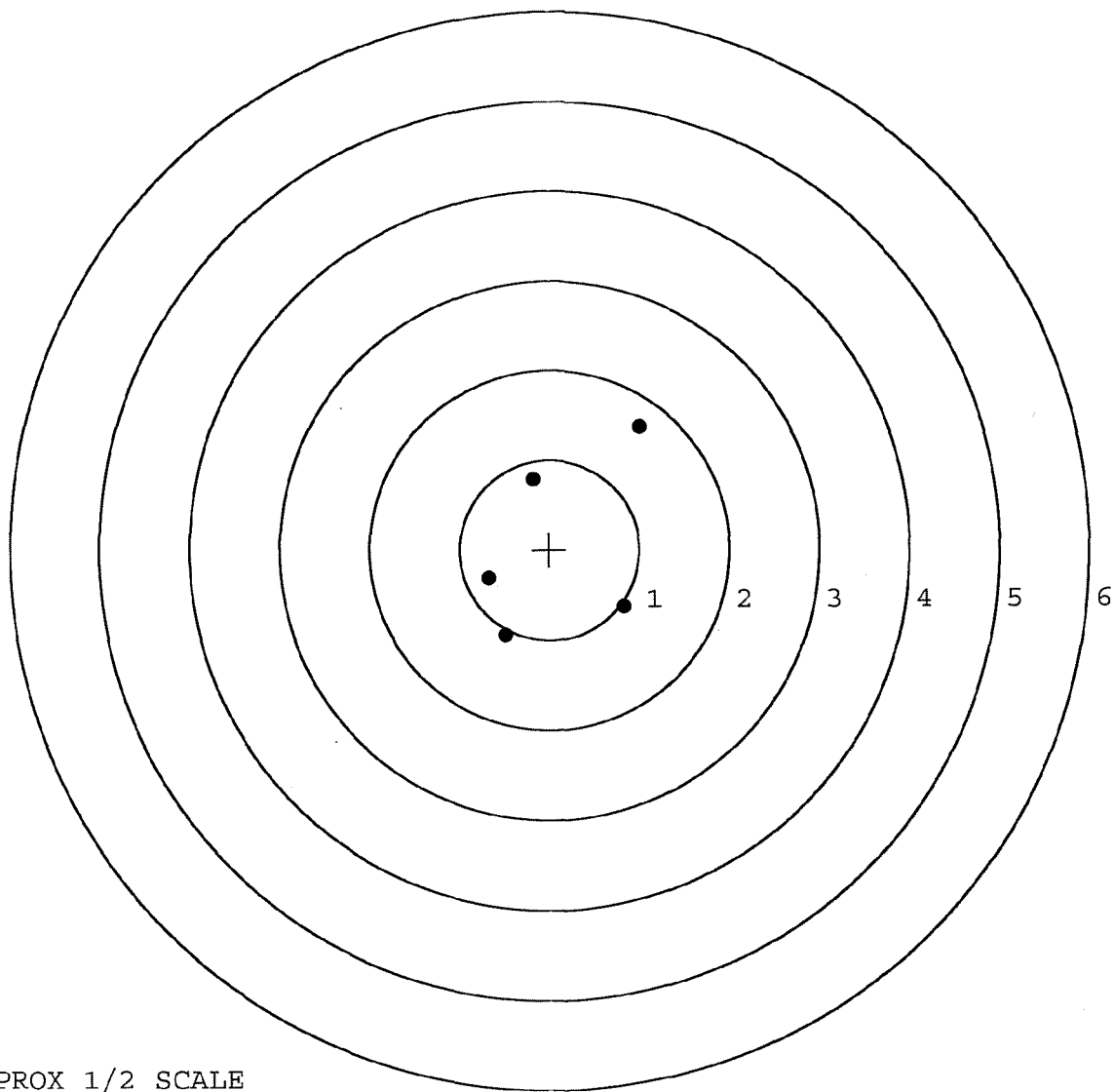
MEAN RADIUS: 1.079

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 4

Av. Mean R. .856

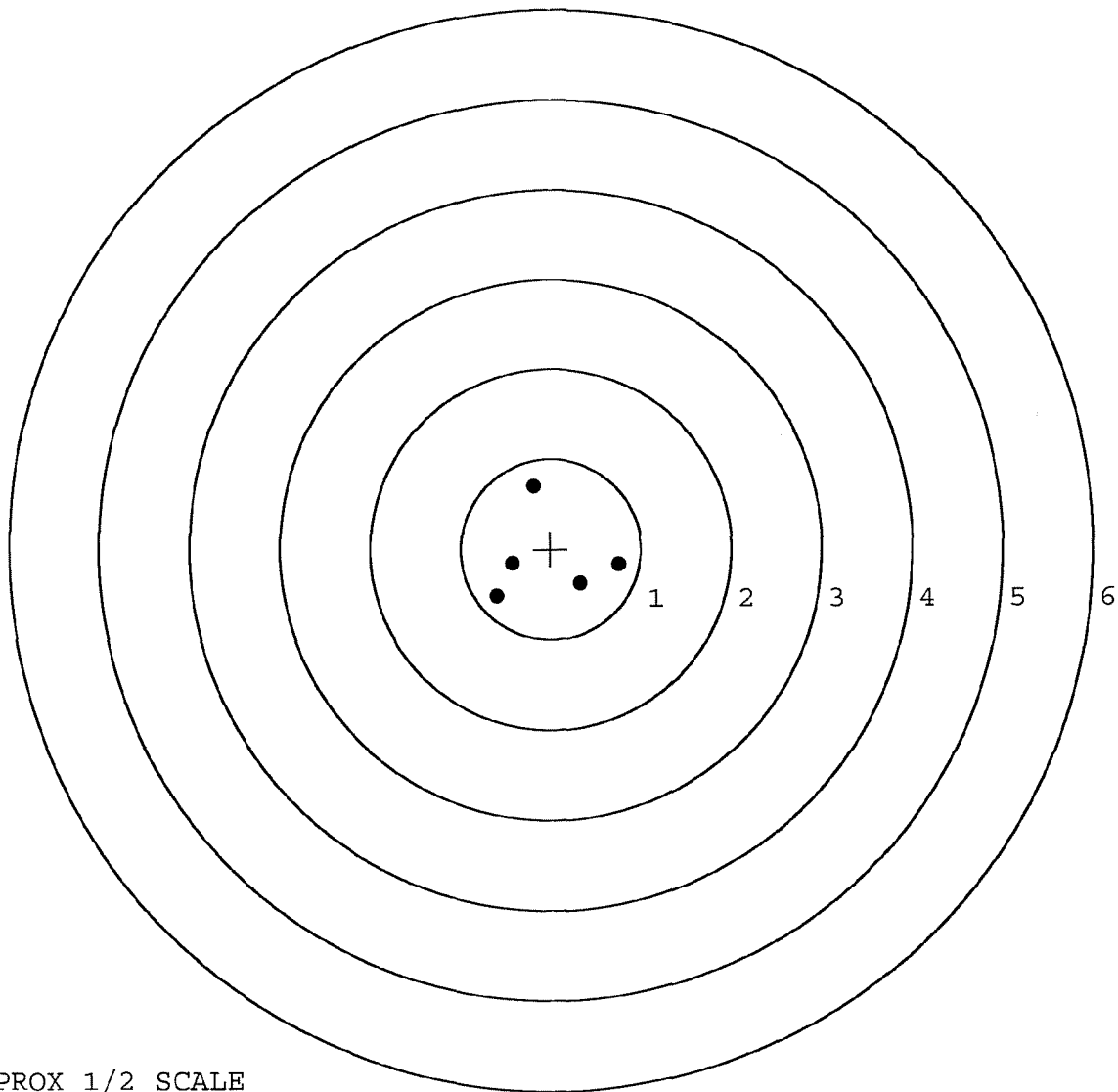


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790277. __0
TARGET NUMBER: 2
FILE DATE: 12/17/2001
FILE TIME: 12:05

POINT#	X	Y
1:	0.754	-0.180
2:	0.332	-0.385
3:	-0.424	-0.165
4:	-0.601	-0.522
5:	-0.187	0.697

X CENTROID: -0.025
Y CENTROID: -0.111
POA TO CENTROID: 0.114
HORZ SPREAD: 1.355
VERT SPREAD: 1.219
GROUP SPREAD: 1.287
MIN RADIUS: 0.402
MAX RADIUS: 0.824
MEAN RADIUS: 0.633
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790277

DATE 11/1/01

TESTER D.N.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.70	2.22		2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.32		2.32	
PULL #3	2.30	2.05		2.28	
PULL #4	2.27	2.00		2.08	
PULL #5	2.05	2.26		2.24	
TOTAL	11.71	10.85 10.85		11.20	
AVG.	2.34	2.17		2.24	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.33		
PULL #2	3.37	3.46		
PULL #3	3.44	3.11		
PULL #4	3.48	3.27		
PULL #5	3.53	3.30		
TOTAL	17.10	16.47		
AVG.	3.42	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.00		4.14
PULL #2	4.48	4.00		3.85
PULL #3	4.16	4.19		3.84
PULL #4	4.07	4.25		4.14
PULL #5	4.08	4.07		4.01
TOTAL	21.16	20.51		19.98
AVG.	4.23	4.10		4.00