

E6790290



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

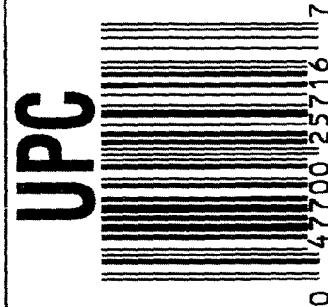


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6790290



GUN SERIAL # E6790290

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-29-01	KW
600	PROOF		11-30-01	KJ
607	CHECK HEADSPACE		11-30-01	KJ
610	DIS-ASSEMBLE GUN		MAGNA-FLUX INSPECTED	
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		NOV 2 2001	
615	ROLLMARK CALIBER		OPERATOR 11-2	
617	DRILL AND TAP SIGHT HOLES		11-6	SE
620	APPLY COATINGS (BARREL ACTION)		11-7	TH
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD			
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY			
	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>4.0</u> <u>4.0</u> <u>4.0</u>	11-10-01	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>2.5</u> <u>2.5</u>	11-10-01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-10-01	DA
	J) ASSEMBLE STOCK		11-7-01	RW
	K) ASSEMBLE SWIVEL STUDS		12/10/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/10/01	REP
	M) IRON SIGHT ALIGNMENT		12/10/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/10/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	11901	K7
	A) MALFUNCTIONS	PASS FAIL	11901	K7
	B) PIERCED PRIMERS	PASS FAIL	11901	K7
645	INSPECT FOR LIVE AMMO		11901	K7
655	FINAL INSPECTION A) HEADSPACE		12/10/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.66</u> <u>2.71</u> <u>2.67</u> <u>2.76</u>	11-27-01	DA
	C) FUNCTION		12/10/01	REP
660	PACK		12/10/01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790290

DATE 11/09/01

TESTER BK.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.46		2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.32		2.19	
PULL #3	2.35	2.24		2.18	
PULL #4	2.44	2.24		2.25	
PULL #5	2.26	2.27		2.21	
TOTAL	1173	1153		1107	
AVG.	2.34	2.30		2.21	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.39		
PULL #2	3.26	3.36		
PULL #3	3.29	3.27		
PULL #4	3.04	3.41		
PULL #5	3.02	3.28		
TOTAL	1576	1660		
AVG.	3.15	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.35		4.29
PULL #2	4.24	4.04		4.12
PULL #3	4.28	4.41		4.04
PULL #4	4.30	4.25		4.13
PULL #5	4.20	4.28		4.25
TOTAL	2131	2133		2083
AVG.	4.26	4.26		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790290.___0
FILE DATE AND TIME: 11/09/2001 10:45

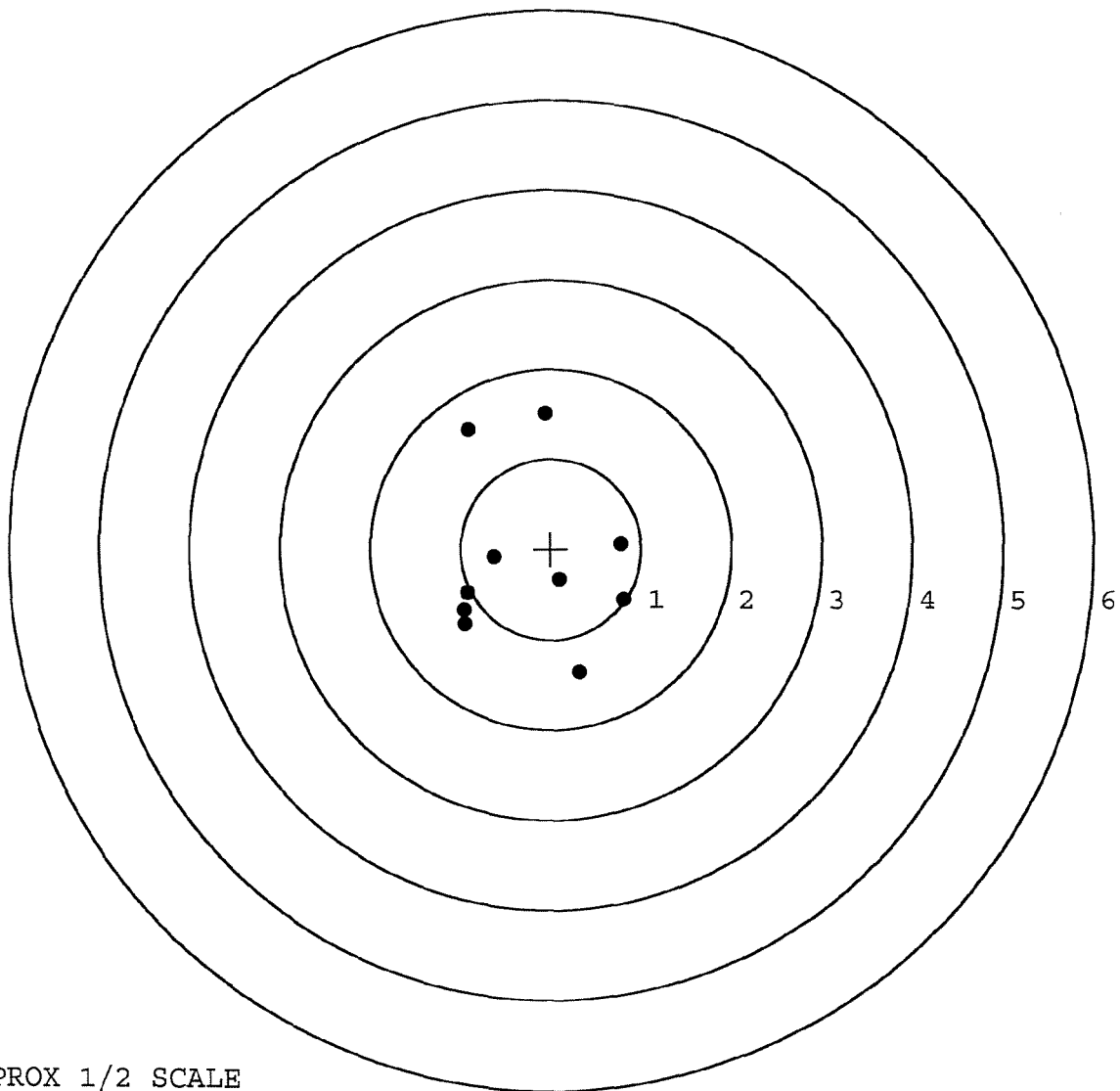
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.101
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.119
The Average Mean Radius of the Five Target Set:	0.994
The Distance from POA to Centroid Target #1:	0.285
The Distance from Centroid Target #2 to Centroid Target #1:	0.434
The Distance from Centroid Target #3 to Centroid Target #1:	0.306
The Distance from Centroid Target #4 to Centroid Target #1:	0.571
The Distance from Centroid Target #5 to Centroid Target #1:	0.589

SERIAL NUMBER: E6790290. __0
TARGET NUMBER: 1
FILE DATE: 11/09/2001
FILE TIME: 10:45

POINT#	X	Y
1:	-0.067	1.502
2:	-0.925	1.318
3:	-0.627	-0.089
4:	0.094	-0.336
5:	0.786	0.061
6:	0.807	-0.559
7:	0.329	-1.363
8:	-0.953	-0.835
9:	-0.955	-0.685
10:	-0.926	-0.488

X CENTROID: -0.244
Y CENTROID: -0.147
POA TO CENTROID: 0.285
HORZ SPREAD: 1.762
VERT SPREAD: 2.865
GROUP SPREAD: 2.892
MIN RADIUS: 0.387
MAX RADIUS: 1.659
MEAN RADIUS: 1.021
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790290. 0

TARGET NUMBER: 2

FILE DATE: 11/09/2001

FILE TIME: 10:45

POINT#	X	Y
1:	-0.187	1.743
2:	0.064	1.766
3:	0.134	1.102
4:	-0.086	0.656
5:	-0.335	0.304
6:	0.155	-0.228
7:	-0.114	-0.920
8:	-0.716	-1.372
9:	0.714	-0.999
10:	0.692	-0.175

X CENTROID: 0.032

Y CENTROID: 0.188

POA TO CENTROID: 0.190

HORZ SPREAD: 1.430

VERT SPREAD: 3.138

GROUP SPREAD: 3.233

MIN RADIUS: 0.385

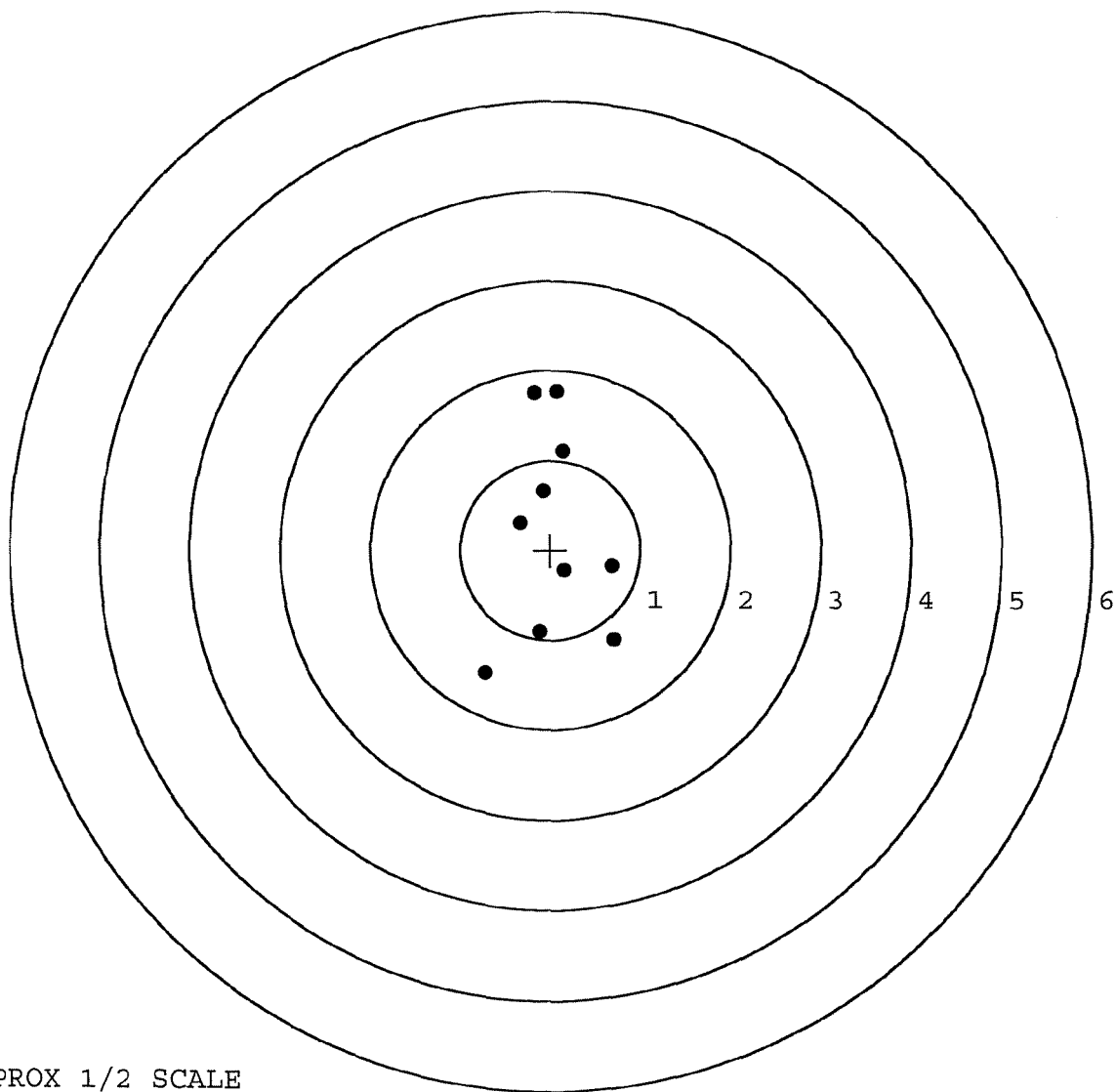
MAX RADIUS: 1.730

MEAN RADIUS: 1.034

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790290. 0

TARGET NUMBER: 3

FILE DATE: 11/09/2001

FILE TIME: 10:45

POINT#	X	Y
1:	-0.180	1.245
2:	-0.057	0.854
3:	-0.471	0.118
4:	-1.111	-0.218
5:	-0.144	-0.403
6:	-0.388	-0.603
7:	0.105	-1.097
8:	1.402	-0.813
9:	0.769	-0.288
10:	0.672	0.099

X CENTROID: 0.060

Y CENTROID: -0.111

POA TO CENTROID: 0.126

HORZ SPREAD: 2.513

VERT SPREAD: 2.342

GROUP SPREAD: 2.596

MIN RADIUS: 0.356

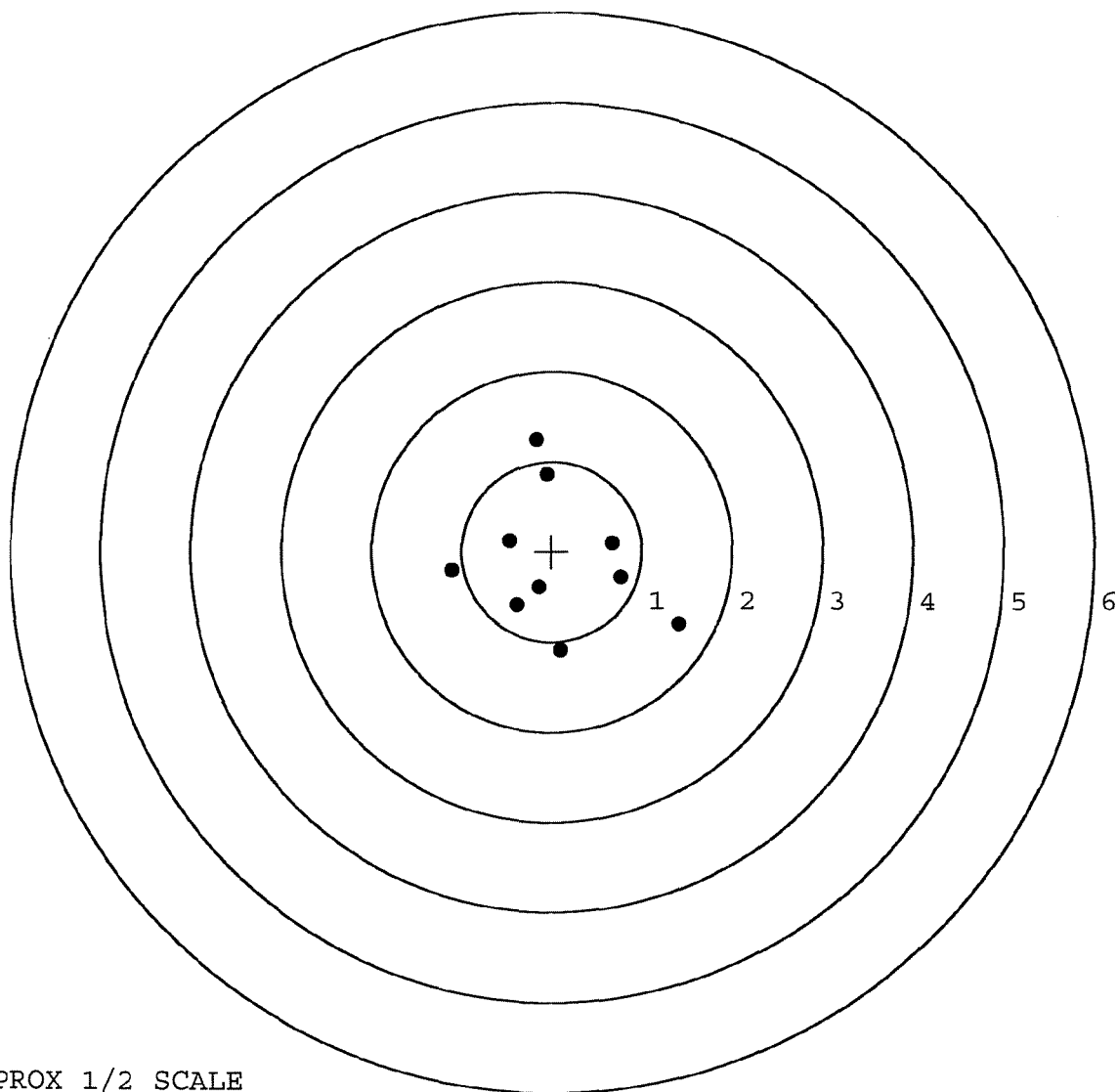
MAX RADIUS: 1.515

MEAN RADIUS: 0.900

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790290. 0

TARGET NUMBER: 4

FILE DATE: 11/09/2001

FILE TIME: 10:45

POINT#	X	Y
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1:	1.385	1.289
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2:	0.443	1.831
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3:	-0.297	0.347
----	--------	-------

4:	-0.584	0.228
----	--------	-------

5:	0.120	-0.276
----	-------	--------

6:	-0.416	-0.722
----	--------	--------

7:	0.493	-0.824
----	-------	--------

8:	0.577	-0.906
----	-------	--------

9:	1.425	-1.401
----	-------	--------

10:	0.075	-1.801
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X CENTROID: 0.322

Y CENTROID: -0.224

POA TO CENTROID: 0.392

HORZ SPREAD: 2.009

VERT SPREAD: 3.632

GROUP SPREAD: 3.651

MIN RADIUS: 0.209

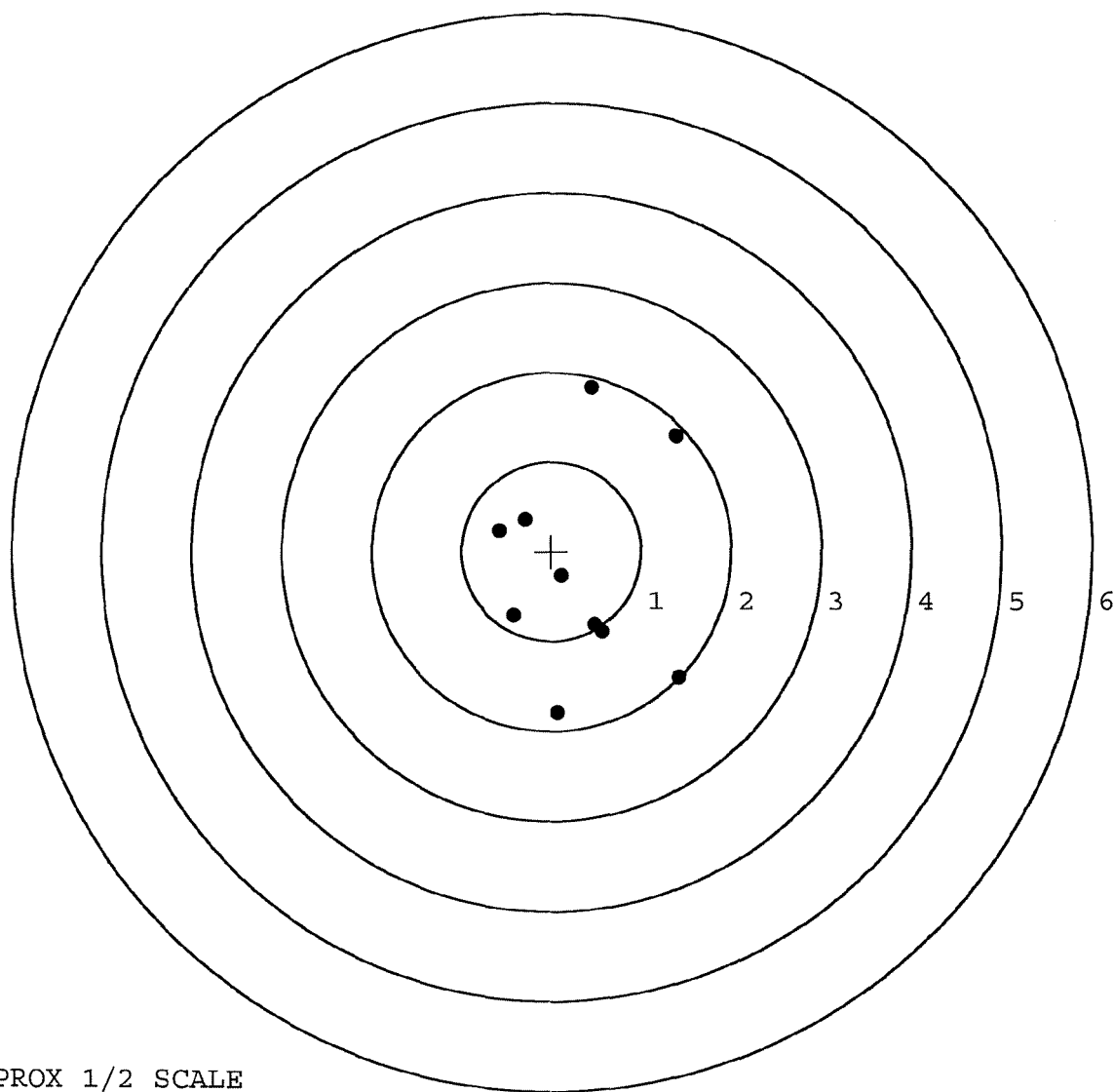
MAX RADIUS: 2.058

MEAN RADIUS: 1.142

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790290. 0

TARGET NUMBER: 5

FILE DATE: 11/09/2001

FILE TIME: 10:45

X CENTROID: 0.333

Y CENTROID: -0.025

POA TO CENTROID: 0.334

HORZ SPREAD: 3.343

VERT SPREAD: 1.723

GROUP SPREAD: 3.358

MIN RADIUS: 0.047

MAX RADIUS: 1.761

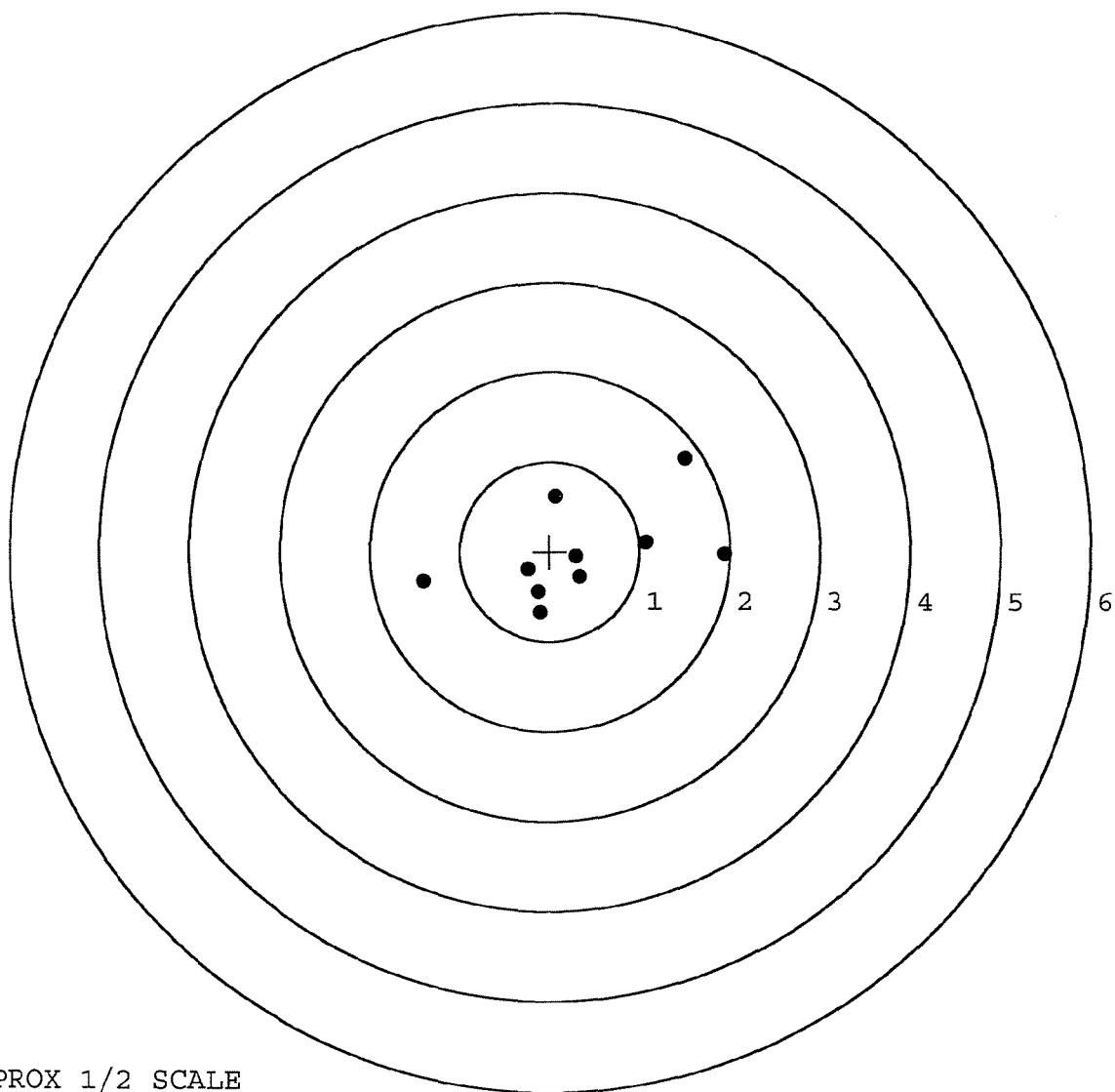
MEAN RADIUS: 0.872

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.495	1.043
2:	1.072	0.112
3:	1.942	-0.021
4:	0.064	0.616
5:	0.300	-0.058
6:	0.337	-0.285
7:	-0.107	-0.680
8:	-0.244	-0.194
9:	-1.401	-0.335
10:	-0.130	-0.447



TARGET APPROX 1/2 SCALE