

56790372

**M2400116407**

**MODEL 700<sup>TH</sup> M24**  
**BOLT ACTION CENTERFIRE RIFLE**  
**24" BARREL 7.62 NATO**

**DOCUMENT ENVELOPE ASSEMBLY:**

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

**46 FORM 1444**

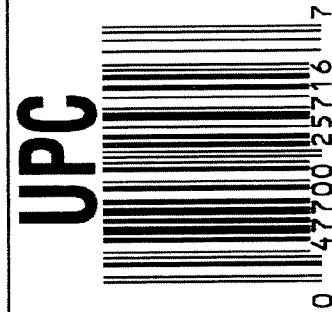


**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**E6790372**



CONTRACT #

GUN SERIAL # E6790372

| OP #      | OPERATION NAME                                                                                                                         | READINGS                           | DATE     | INITIAL |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------|------------------------------------|----------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                                                                                              |                                    | 11/6/01  | REP     |
| 600       | PROOF                                                                                                                                  |                                    | 11/6/01  | REP     |
| 607       | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                       | 11/6/01  | REP     |
| 610       | DIS-ASSEMBLE GUN                                                                                                                       | INSPECTED                          | 11/6/01  | REP     |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 | NOV 13 2001<br>OPERATOR <u>DRS</u> |          |         |
| 615       | ROLLMARK CALIBER                                                                                                                       |                                    | 11/14-01 | Wm      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                    | 11/14    | BWT     |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                    | 11/15    | HP      |
|           | (BOLT)                                                                                                                                 |                                    | 11/15    | HP      |
| 625       | FINAL ASSEMBLY<br>A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                  |                                    | 1/15/02  | D.M.    |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                    | 1/15/02  | D.M.    |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                    | 1/15/02  | D.M.    |
|           | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                    | 1/15/02  | D.M.    |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |                                    | 1-22-02  | RA      |

| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.00</u> <u>5.75</u> <u>5.25</u>                         |         |         |
| CONT. |                                                                          |                                                             |         |         |
|       | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3.60</u> <u>3.00</u> <u>3.50</u>                         |         |         |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.021</u> <u>.023</u> <u>.022</u>                         |         |         |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 1/16/02 | RW      |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 1/21/02 | RW      |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 1/16/02 | RW      |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 1/14/02 | RW      |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 1/16/02 | RW      |
| 640   | GALLERY TEST AND<br>TARGET                                               | PASS FAIL                                                   | 1-17-02 | A       |
|       | A) MALFUNCTIONS                                                          | PASS FAIL                                                   | 1-17-02 | A       |
|       | B) PIERCED PRIMERS                                                       | PASS FAIL                                                   | 1-17-02 | A       |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 1-17-02 | A       |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 1/21/02 | RW      |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.26</u> <u>2.28</u> <u>2.35</u> <u>2.42</u> <u>2.44</u> | 1/21/02 | D.N.    |
|       | C) FUNCTION                                                              |                                                             | 1/21/02 | RW      |
| 660   | PACK                                                                     |                                                             | 1-22-02 | DA      |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790372

DATE 1/10/02

TESTER D.N.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.67             | 2.25                     | 2.32                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.42             | 2.61                     | 2.47                           |                                                                        |
| PULL #3 | 2.43             | 2.40                     | 2.35                           |                                                                        |
| PULL #4 | 2.55             | 2.59                     | 2.35                           |                                                                        |
| PULL #5 | 2.37             | 2.31                     | 2.27                           |                                                                        |
| TOTAL   | 12.44            | 12.16                    | 11.76                          |                                                                        |
| AVG.    | 2.49             | 2.43                     | 2.35                           |                                                                        |

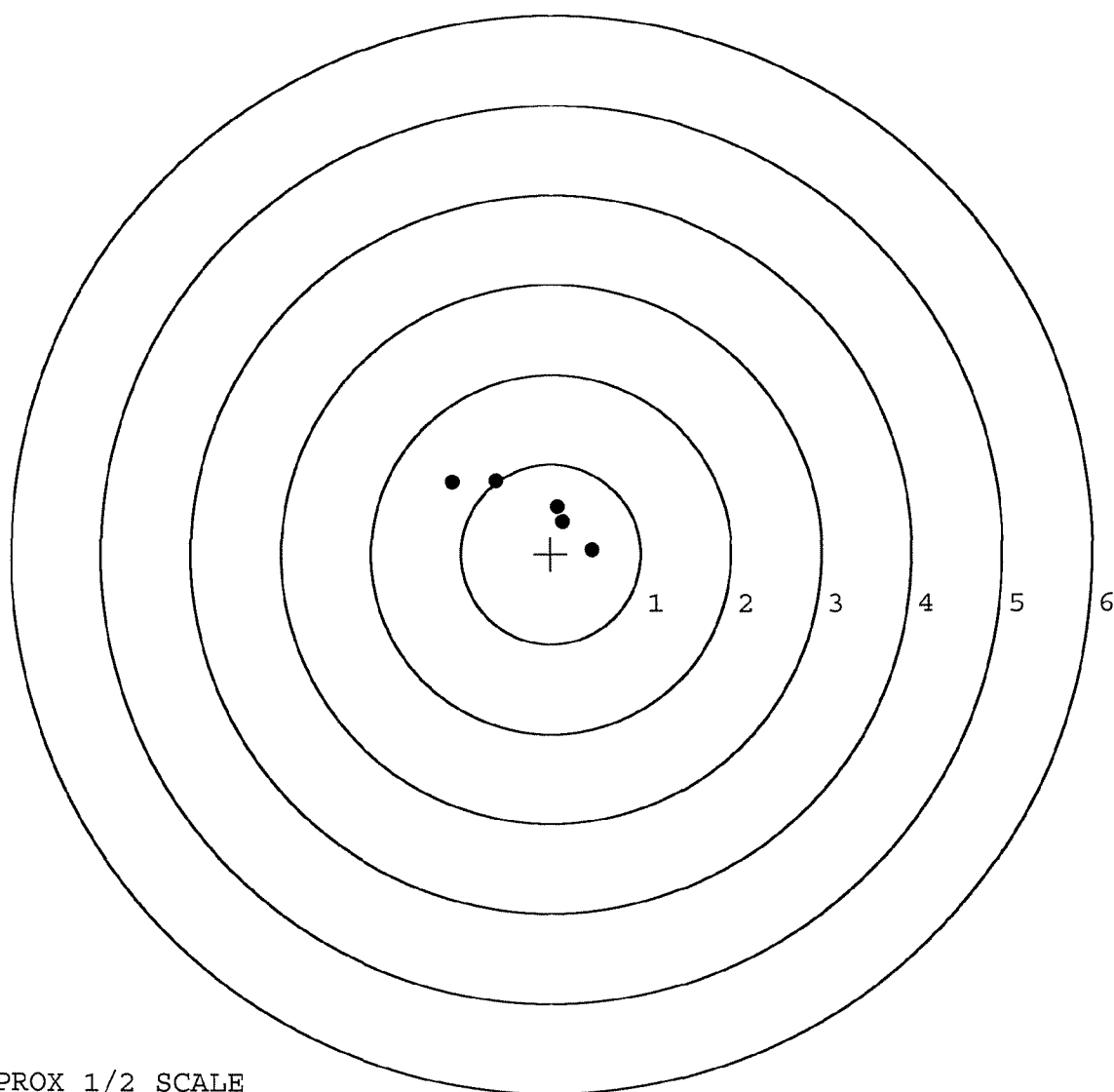
|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.09             | 3.02                     |          |
| PULL #2 | 3.02             | 3.04                     |          |
| PULL #3 | 3.08             | 2.98                     |          |
| PULL #4 | 3.04             | 2.89                     |          |
| PULL #5 | 3.21             | 2.89                     |          |
| TOTAL   | 15.44            | 14.77                    |          |
| AVG.    | 3.09             | 2.95                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.15             | 4.06                     |                                | 4.19                                 |
| PULL #2 | 4.23             | 4.11                     |                                | 4.10                                 |
| PULL #3 | 4.09             | 4.03                     |                                | 3.96                                 |
| PULL #4 | 4.36             | 4.28                     |                                | 4.09                                 |
| PULL #5 | 4.15             | 4.27                     |                                | 4.15                                 |
| TOTAL   | 20.98            | 20.75                    |                                | 20.49                                |
| AVG.    | 4.20             | 4.15                     |                                | 4.10                                 |

SERIAL NUMBER: E6790372. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 01/17/2002  
FILE TIME: 17:41

| POINT# | X      | Y     |
|--------|--------|-------|
| 1:     | 0.067  | 0.524 |
| 2:     | 0.127  | 0.356 |
| 3:     | 0.464  | 0.042 |
| 4:     | -0.608 | 0.818 |
| 5:     | -1.106 | 0.805 |

X CENTROID: -0.211  
Y CENTROID: 0.509  
POA TO CENTROID: 0.551  
HORZ SPREAD: 1.570  
VERT SPREAD: 0.776  
GROUP SPREAD: 1.746  
MIN RADIUS: 0.279  
MAX RADIUS: 0.942  
MEAN RADIUS: 0.583  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 5  
# in 3 IN DIAMETER: 5

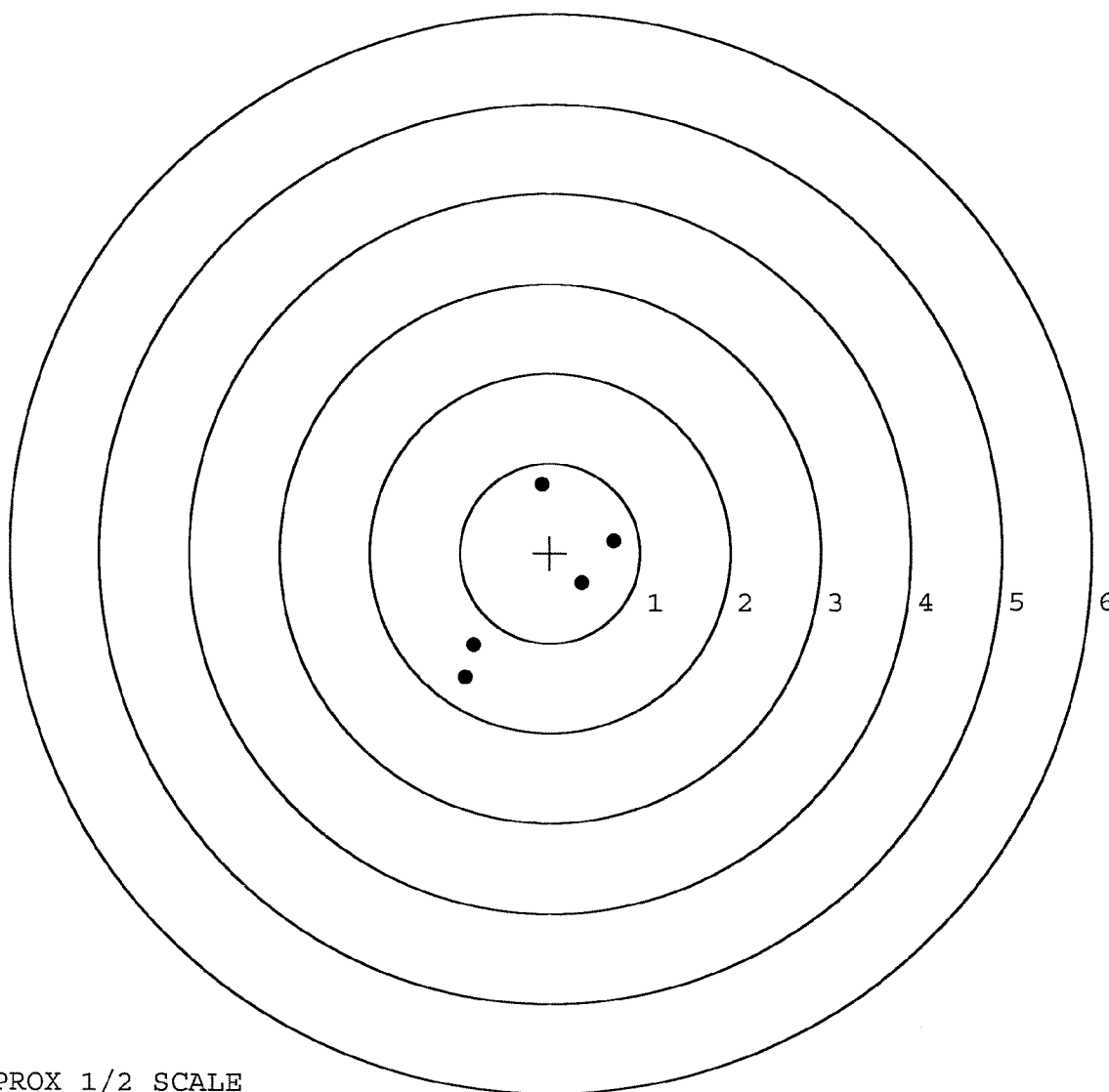


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790372. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 01/17/2002  
FILE TIME: 17:41

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.087 | 0.765  |
| 2:     | 0.713  | 0.133  |
| 3:     | 0.357  | -0.338 |
| 4:     | -0.849 | -1.025 |
| 5:     | -0.941 | -1.382 |

X CENTROID: -0.161  
Y CENTROID: -0.369  
POA TO CENTROID: 0.403  
HORZ SPREAD: 1.654  
VERT SPREAD: 2.147  
GROUP SPREAD: 2.311  
MIN RADIUS: 0.519  
MAX RADIUS: 1.278  
MEAN RADIUS: 0.979  
# IN 1 IN DIAMETER: 0  
# IN 2 IN DIAMETER: 2  
# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE