

E6790250

(W)

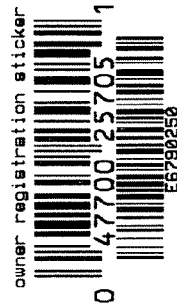
M2400117348

MODEL 700[™] M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

GREEN ENVELOPE CONTAINS:

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

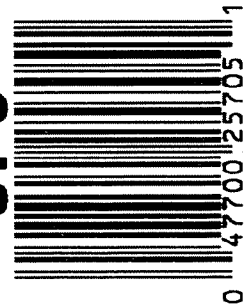
46 FORM



ORDER NO.	25705
BARREL LENGTH	24"
CAPACITY	6

E6790250

UPC



(3)

CONTRACT #
DAAE20-01-P-0489
170 RIFLES

GUN SERIAL # E6790250

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		2-1-02	AK
600	PROOF		2-1-02	AC
607	CHECK HEADSPACE		2-1-02	AC
610	DIS-ASSEMBLE GUN		2-1-02	AK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		FEB 9 2002 OPERATOR AC	AC
615	ROLLMARK CALIBER		2-9-02	WM
617-	DRILL AND TAP SIGHT HOLES		2-12-02	AC
620	APPLY COATINGS (BARREL ACTION)		2-20	TA
	(BOLT)		2-20	TA
625	FINAL ASSEMBLY		2/27/02	DK
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/27/02	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/27/02	DK
	D) OIL FIRING PIN ASSEMBLY		2/27/02	DK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/2/02	PL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.0</u>	4/2/02	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	4/2/02	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		4/2/02	RL
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	4/2/02	DA
	J) ASSEMBLE STOCK		3/18/02	RW
	K) ASSEMBLE SWIVEL STUDS		4/17/02	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/17/02	RL
	M) IRON SIGHT ALIGNMENT		4/17/02	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/17/02	RL
640	GALLERY TEST AND TARGET	PASS FAIL	3-21-02	F
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION		A
	MALFUNCTION	CORRECTION	✓	A
645	INSPECT FOR LIVE AMMO		3-21-02	A
655	FINAL INSPECTION A) HEADSPACE		4/17/02	RL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.36</u> <u>2.43</u> <u>2.35</u> <u>2.51</u>	4/2/02	DA
	C) FUNCTION		4/17/02	RL
660	PACK		4/29/02	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6790250

DATE 2/24/02

TESTER _____

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.57	2.52	2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.58	2.59	
PULL #3	2.72	2.64	2.62	
PULL #4	2.60	2.52	2.61	
PULL #5	2.62	2.54	2.67	
TOTAL	12.98	12.80	13.17	
AVG.	2.60	2.56	2.63	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.24	
PULL #2	3.26	3.26	
PULL #3	3.33	3.19	
PULL #4	3.21	3.29	
PULL #5	3.27	3.19	
TOTAL	16.31	16.17	
AVG.	3.26	3.23	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURAC
PULL #1	4.10	4.15		4.22
PULL #2	4.05	4.06		4.20
PULL #3	4.08	4.02		4.16
PULL #4	4.10	4.12		4.21
PULL #5	4.04	3.93		4.07
TOTAL	20.37	20.23		20.86
AVG.	4.07	4.05		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790250.___0

FILE DATE AND TIME: 03/21/2002 02:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.024
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.041
The Average Mean Radius of the Five Target Set:	0.746
The Distance from POA to Centroid Target #1:	0.034
The Distance from Centroid Target #2 to Centroid Target #1:	0.382
The Distance from Centroid Target #3 to Centroid Target #1:	0.182
The Distance from Centroid Target #4 to Centroid Target #1:	0.214
The Distance from Centroid Target #5 to Centroid Target #1:	0.289

SERIAL NUMBER: E6790250. 0

TARGET NUMBER: 1

FILE DATE: 03/21/2002

FILE TIME: 02:42

POINT#	X	Y
1:	0.542	-1.481
2:	-0.766	-1.108
3:	-0.642	1.615
4:	0.432	0.633
5:	0.072	0.527
6:	-0.097	0.292
7:	0.295	0.283
8:	0.501	0.110
9:	0.035	-0.318
10:	-0.497	-0.237

X CENTROID: -0.012

Y CENTROID: 0.032

POA TO CENTROID: 0.034

HORZ SPREAD: 1.308

VERT SPREAD: 3.096

GROUP SPREAD: 3.315

MIN RADIUS: 0.274

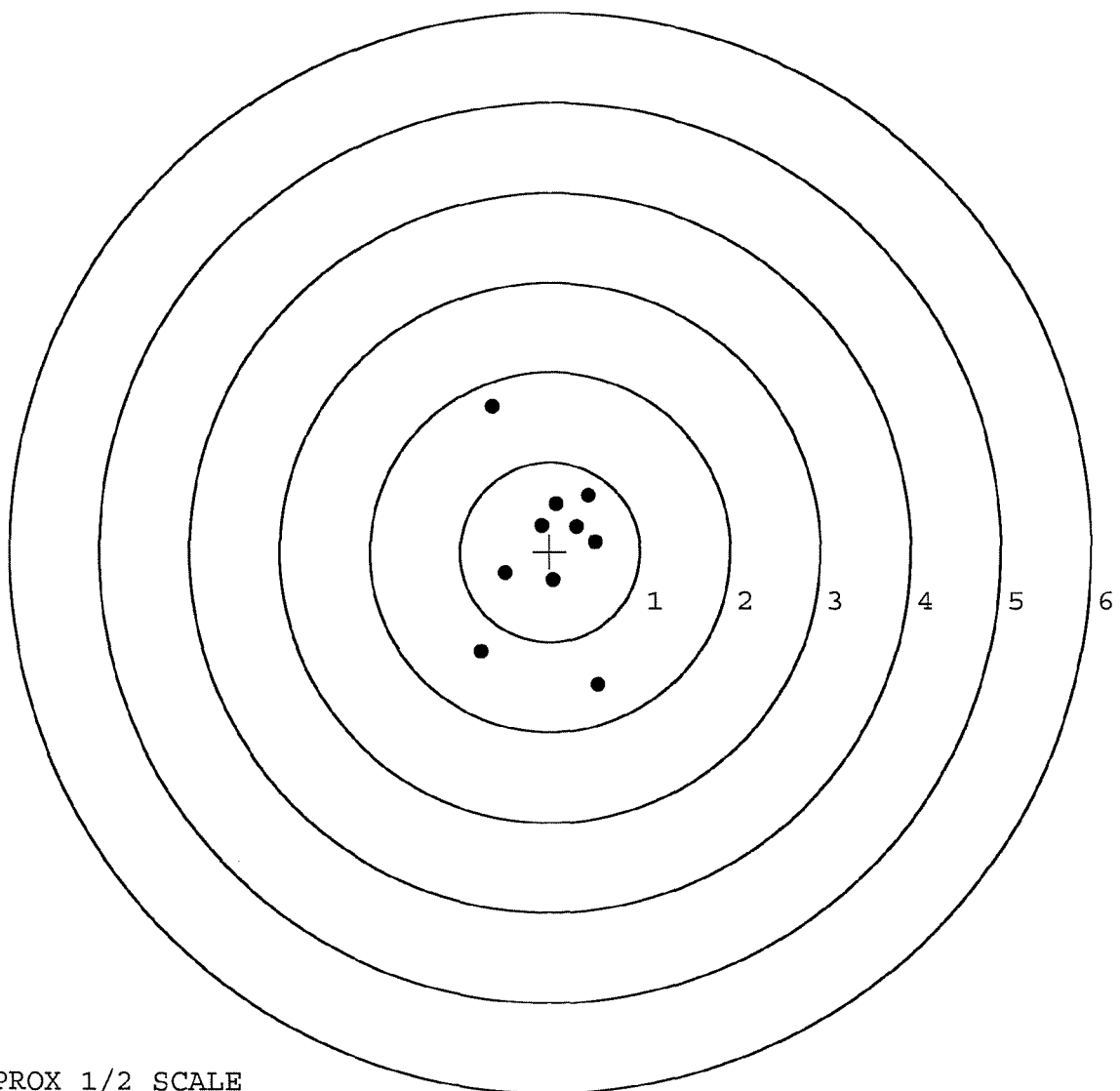
MAX RADIUS: 1.704

MEAN RADIUS: 0.803

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

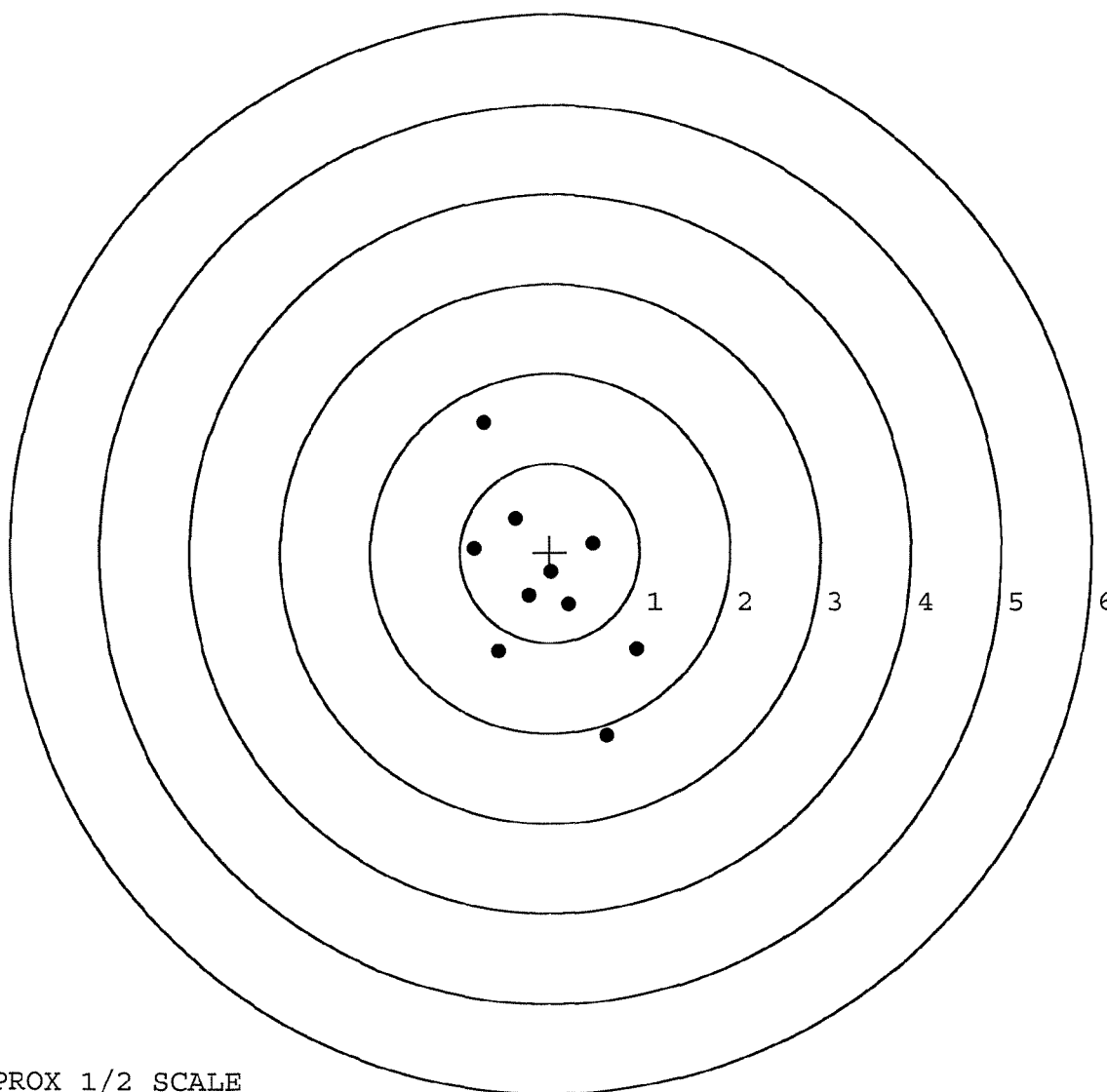


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790250. __0
TARGET NUMBER: 2
FILE DATE: 03/21/2002
FILE TIME: 02:42

POINT#	X	Y
1:	0.962	-1.079
2:	0.634	-2.029
3:	-0.567	-1.096
4:	0.212	-0.582
5:	-0.240	-0.481
6:	0.015	-0.223
7:	0.486	0.106
8:	-0.391	0.383
9:	-0.842	0.053
10:	-0.743	1.459

X CENTROID: -0.047
Y CENTROID: -0.349
POA TO CENTROID: 0.352
HORZ SPREAD: 1.804
VERT SPREAD: 3.488
GROUP SPREAD: 3.750
MIN RADIUS: 0.141
MAX RADIUS: 1.937
MEAN RADIUS: 0.903
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

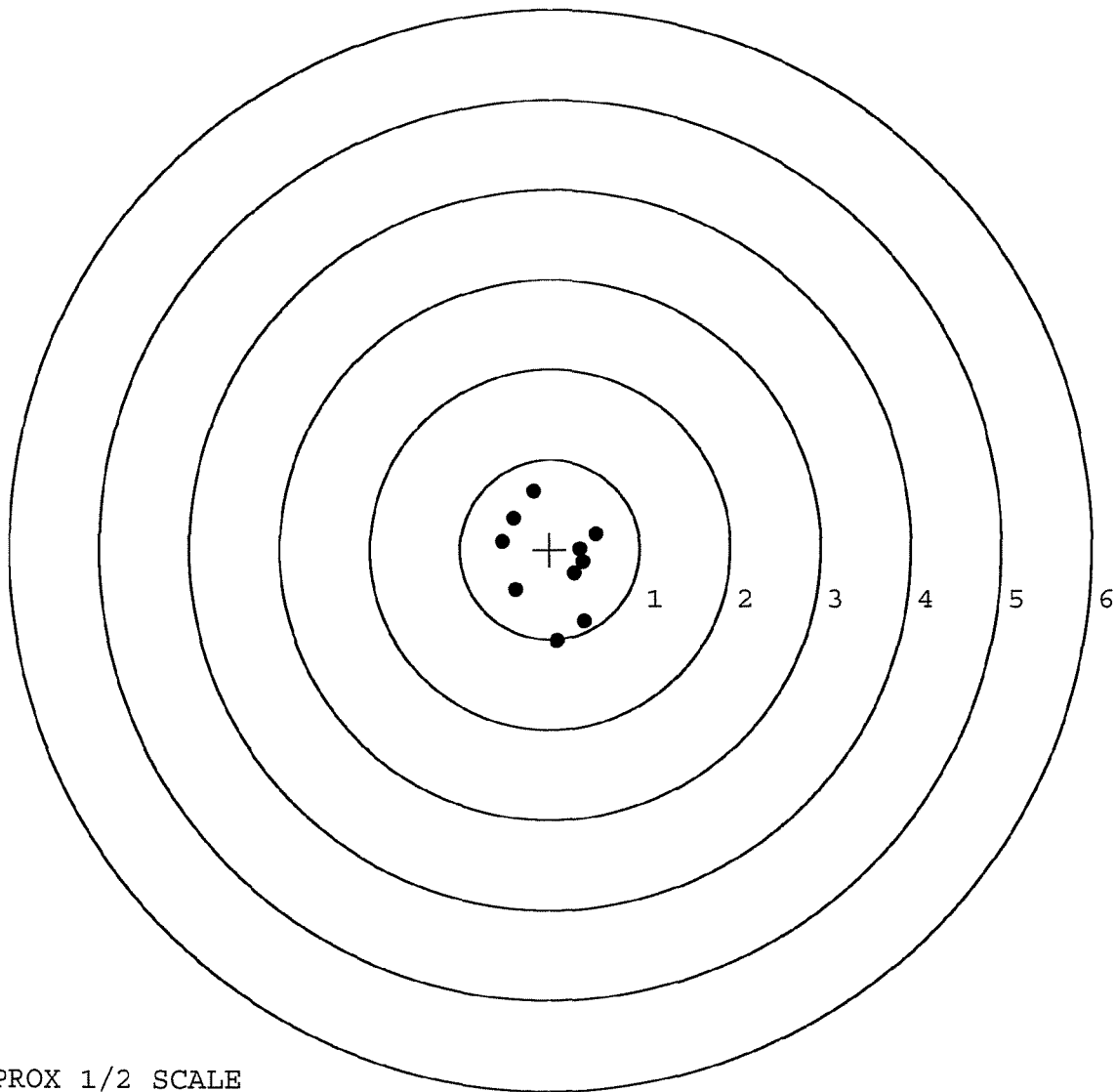


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790250. __0
TARGET NUMBER: 3
FILE DATE: 03/21/2002
FILE TIME: 02:42

POINT#	X	Y
1:	-0.182	0.651
2:	-0.413	0.347
3:	-0.529	0.091
4:	0.508	0.178
5:	0.340	0.010
6:	0.372	-0.139
7:	0.276	-0.265
8:	0.381	-0.805
9:	0.086	-1.021
10:	-0.382	-0.453

X CENTROID: 0.046
Y CENTROID: -0.141
POA TO CENTROID: 0.148
HORZ SPREAD: 1.037
VERT SPREAD: 1.672
GROUP SPREAD: 1.693
MIN RADIUS: 0.262
MAX RADIUS: 0.881
MEAN RADIUS: 0.575
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

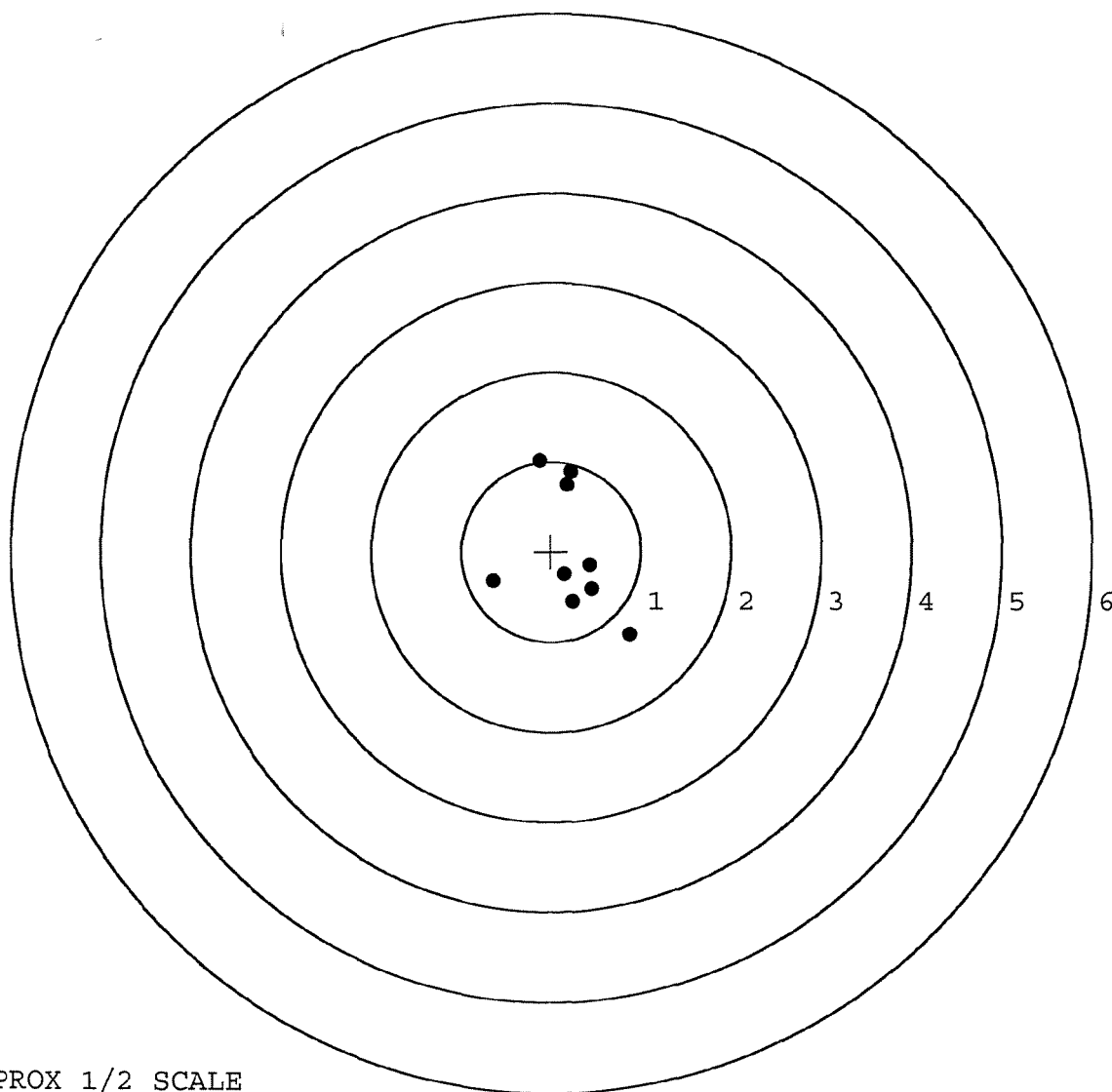


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790250. __0
TARGET NUMBER: 4
FILE DATE: 03/21/2002
FILE TIME: 02:42

X CENTROID: 0.194
Y CENTROID: -0.025
POA TO CENTROID: 0.195
HORZ SPREAD: 1.517
VERT SPREAD: 1.932
GROUP SPREAD: 2.179
MIN RADIUS: 0.237
MAX RADIUS: 1.130
MEAN RADIUS: 0.654
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.877	-0.925
2:	0.242	-0.557
3:	0.459	-0.419
4:	0.435	-0.149
5:	0.150	-0.259
6:	0.153	-0.258
7:	-0.640	-0.328
8:	0.177	0.746
9:	0.215	0.892
10:	-0.130	1.007

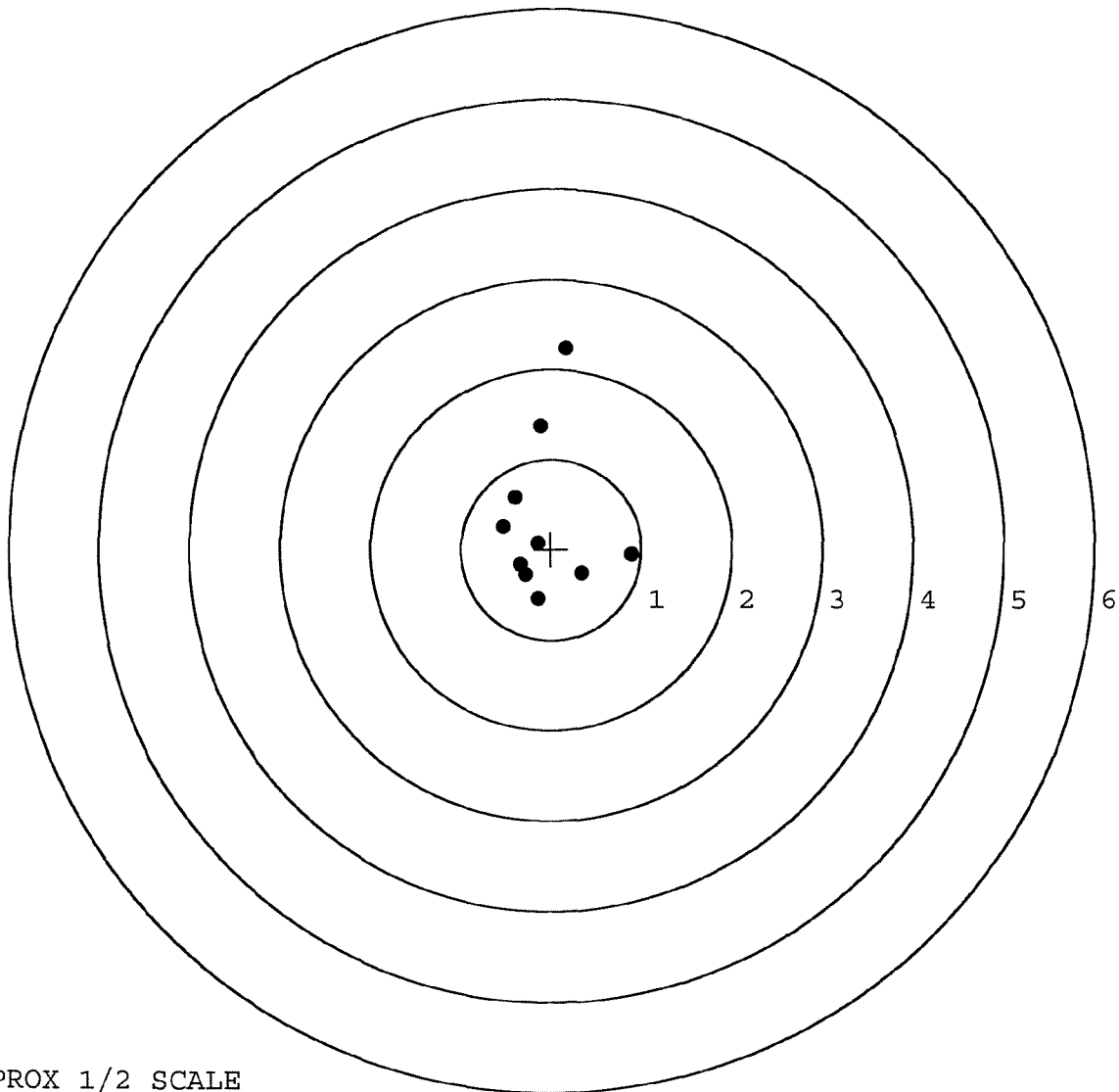


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790250. 0
TARGET NUMBER: 5
FILE DATE: 03/21/2002
FILE TIME: 02:42

POINT#	X	Y
1:	0.896	-0.062
2:	0.345	-0.262
3:	-0.146	-0.549
4:	-0.405	0.574
5:	-0.536	0.251
6:	0.161	2.233
7:	-0.126	1.371
8:	-0.145	0.064
9:	-0.345	-0.170
10:	-0.283	-0.281

X CENTROID: -0.058
Y CENTROID: 0.317
POA TO CENTROID: 0.322
HORZ SPREAD: 1.432
VERT SPREAD: 2.782
GROUP SPREAD: 2.799
MIN RADIUS: 0.267
MAX RADIUS: 1.929
MEAN RADIUS: 0.797
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE