

E6790451

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

GREEN ENVELOPE CONTAINS:
- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM

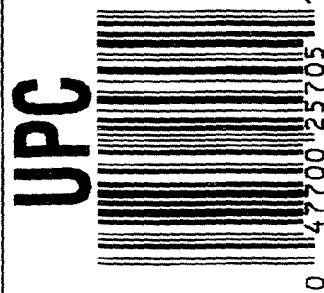


ORDER NO. **25705**

BARREL LENGTH **24"**

CAPACITY **6**

E6790451



M2400117584

CONTRACT #
DAAE20-01-P-0489
170 RIFLES

GUN SERIAL # E679 0451

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-31-02	RHL
600	PROOF		1-31-02	A
607	CHECK HEADSPACE		1-31-02	A
610	DIS-ASSEMBLE GUN		1-31-02	RHL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		2-1-02	AL
615	ROLLMARK CALIBER		2/4/02	LB
617	DRILL AND TAP SIGHT HOLES		2/4/02	BWT
620	APPLY COATINGS (BARREL ACTION)		2-16	TA
	(BOLT)		2-16	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-1-02	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-1-02	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-1-02	A
	D) OIL FIRING PIN ASSEMBLY		3-1-02	AW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-1-02	AW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>4.5</u>	5/28/02	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	5/28/02	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.022</u> <u>.022</u>	5/28/02	DA
	J) ASSEMBLE STOCK		5-25-02	RW
	K) ASSEMBLE SWIVEL STUDS		6/14/02	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6/14/02	RW
	M) IRON SIGHT ALIGNMENT		6/14/02	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6/14/02	RW
640	GALLERY TEST AND TARGET	PASS FAIL	5-10-02	TRW
	MALFUNCTION	CORRECTION	5-10-02	TRW
	MALFUNCTION	CORRECTION	5-10-02	TRW
	MALFUNCTION	CORRECTION	5-10-02	TRW
	MALFUNCTION	CORRECTION	5-10-02	TRW
645	INSPECT FOR LIVE AMMO		5-10-02	TRW
655	FINAL INSPECTION A) HEADSPACE		6/14/02	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>225</u> <u>229</u> <u>225</u> <u>255</u> <u>231</u>	5/29/02	RHL
	C) FUNCTION		6/14/02	RW
660	PACK		6/11/02	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. L6790451

DATE 1/31/02

TESTER D. A.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.50	2.32	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.67	2.22	
PULL #3	2.44	2.80	2.31	
PULL #4	2.49	2.79	2.47	
PULL #5	2.35	2.49	2.65	
TOTAL	12.21	13.07	11.99	
AVG.	2.44	2.61	2.40	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.32	3.53	
PULL #2	3.09	3.51	
PULL #3	3.26	3.00	
PULL #4	3.36	3.77	
PULL #5	3.14	3.56	
TOTAL	16.17	17.37	
AVG.	3.23	3.47	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.17		4.09
PULL #2	4.77	4.04		4.07
PULL #3	4.42	4.04		4.12
PULL #4	4.40	4.08		4.02
PULL #5	4.46	4.16		4.06
TOTAL	22.57	20.49		20.36
AVG.	4.51	4.10		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: E6790451.___0
FILE DATE AND TIME: 05/11/2002 13:19

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.083
The Average Y Centroid of the Five Target Set:	-0.147
The Average Point of Impact of the Five Target Set:	0.169
The Average Mean Radius of the Five Target Set:	0.937
The Distance from POA to Centroid Target #1:	0.298
The Distance from Centroid Target #2 to Centroid Target #1:	0.181
The Distance from Centroid Target #3 to Centroid Target #1:	0.179
The Distance from Centroid Target #4 to Centroid Target #1:	0.238
The Distance from Centroid Target #5 to Centroid Target #1:	0.272

SERIAL NUMBER: E6790451. __0

TARGET NUMBER: 1

FILE DATE: 05/11/2002

FILE TIME: 13:19

POINT#	X	Y
1:	0.725	0.848
2:	1.127	1.458
3:	0.294	0.630
4:	0.088	0.850
5:	0.139	-0.908
6:	-0.092	-1.171
7:	-0.231	-0.765
8:	-0.880	-0.932
9:	-1.217	-0.600
10:	-2.108	-1.462

X CENTROID: -0.215

Y CENTROID: -0.205

POA TO CENTROID: 0.298

HORZ SPREAD: 3.235

VERT SPREAD: 2.920

GROUP SPREAD: 4.358

MIN RADIUS: 0.560

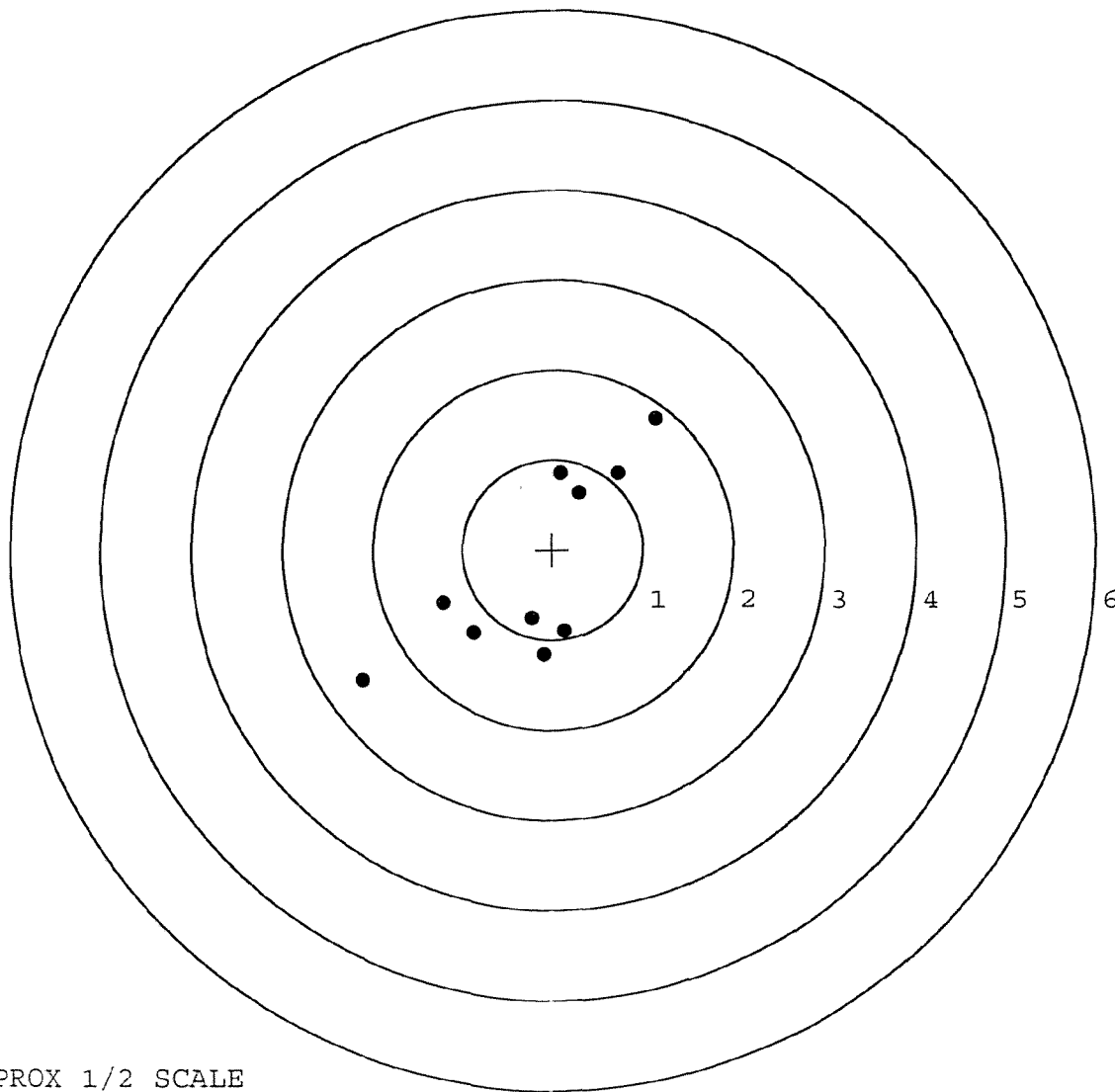
MAX RADIUS: 2.272

MEAN RADIUS: 1.228

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



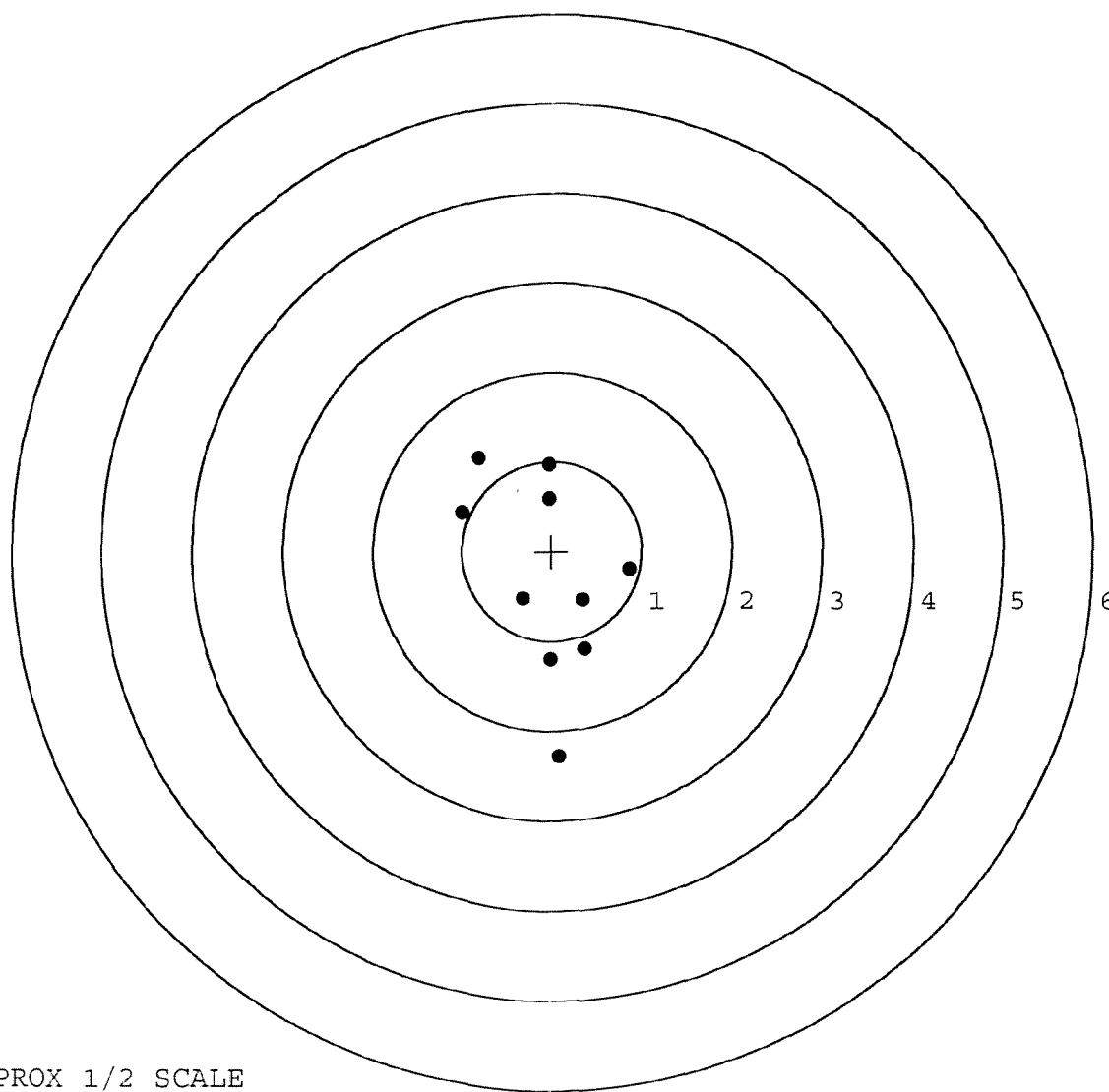
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790451. __0
TARGET NUMBER: 2
FILE DATE: 05/11/2002
FILE TIME: 13:19

X CENTROID: -0.053
Y CENTROID: -0.285
POA TO CENTROID: 0.290
HORZ SPREAD: 1.868
VERT SPREAD: 3.326
GROUP SPREAD: 3.447
MIN RADIUS: 0.364
MAX RADIUS: 2.007
MEAN RADIUS: 1.044

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.090	-2.287
2:	0.371	-1.089
3:	-0.011	-1.209
4:	-0.324	-0.528
5:	0.350	-0.542
6:	0.868	-0.202
7:	-0.030	0.586
8:	-0.027	0.961
9:	-0.814	1.039
10:	-1.000	0.424



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790451. 0

TARGET NUMBER: 3

FILE DATE: 05/11/2002

FILE TIME: 13:19

POINT#	X	Y
1:	0.749	0.238
2:	0.360	0.625
3:	-0.254	0.395
4:	-0.987	-0.623
5:	-0.040	-1.704
6:	-0.356	-0.348
7:	0.354	-0.048
8:	0.155	-0.095
9:	-0.163	-0.196
10:	-0.206	-0.028

X CENTROID: -0.039

Y CENTROID: -0.178

POA TO CENTROID: 0.183

HORZ SPREAD: 1.736

VERT SPREAD: 2.329

GROUP SPREAD: 2.363

MIN RADIUS: 0.125

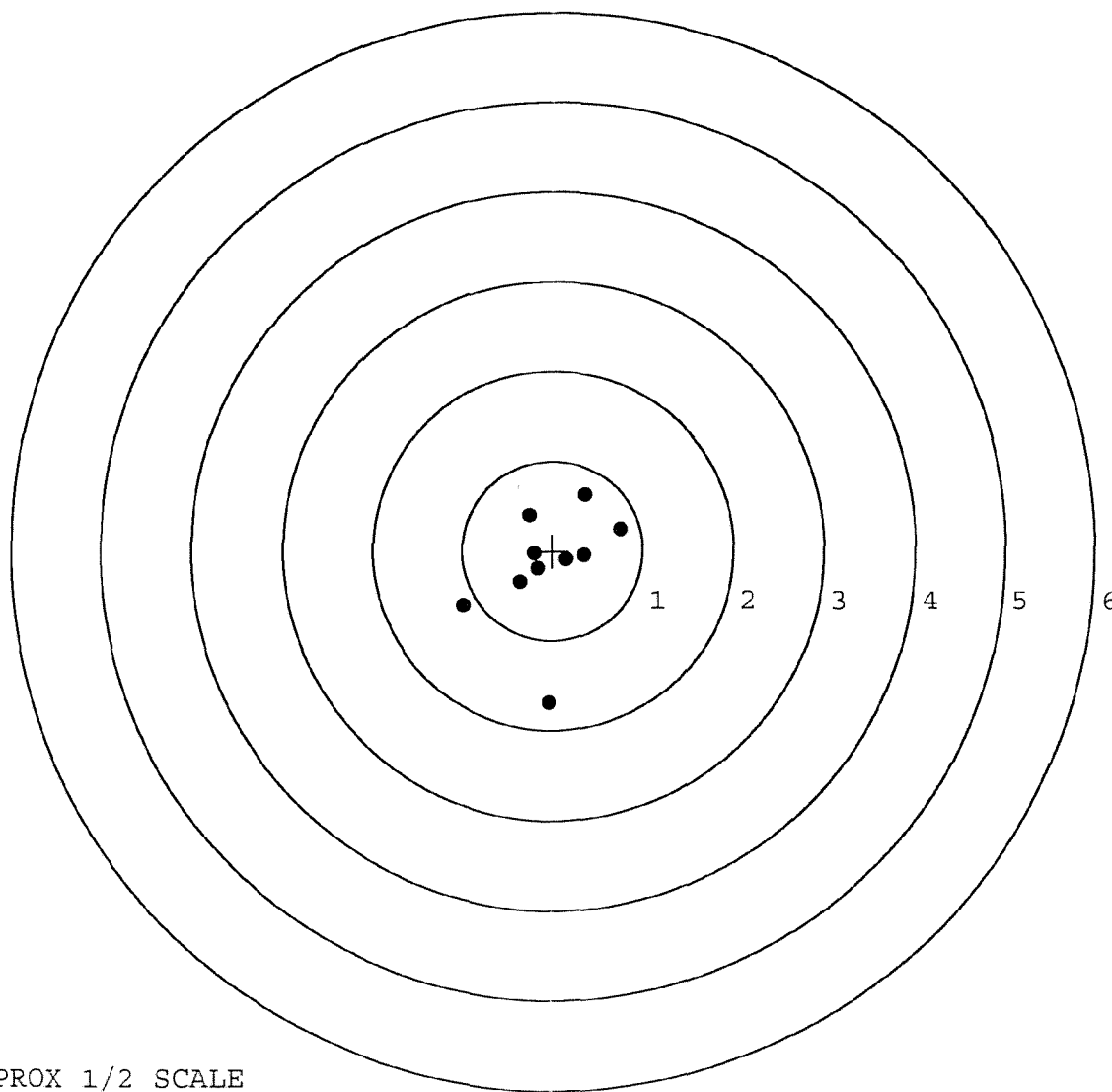
MAX RADIUS: 1.526

MEAN RADIUS: 0.631

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

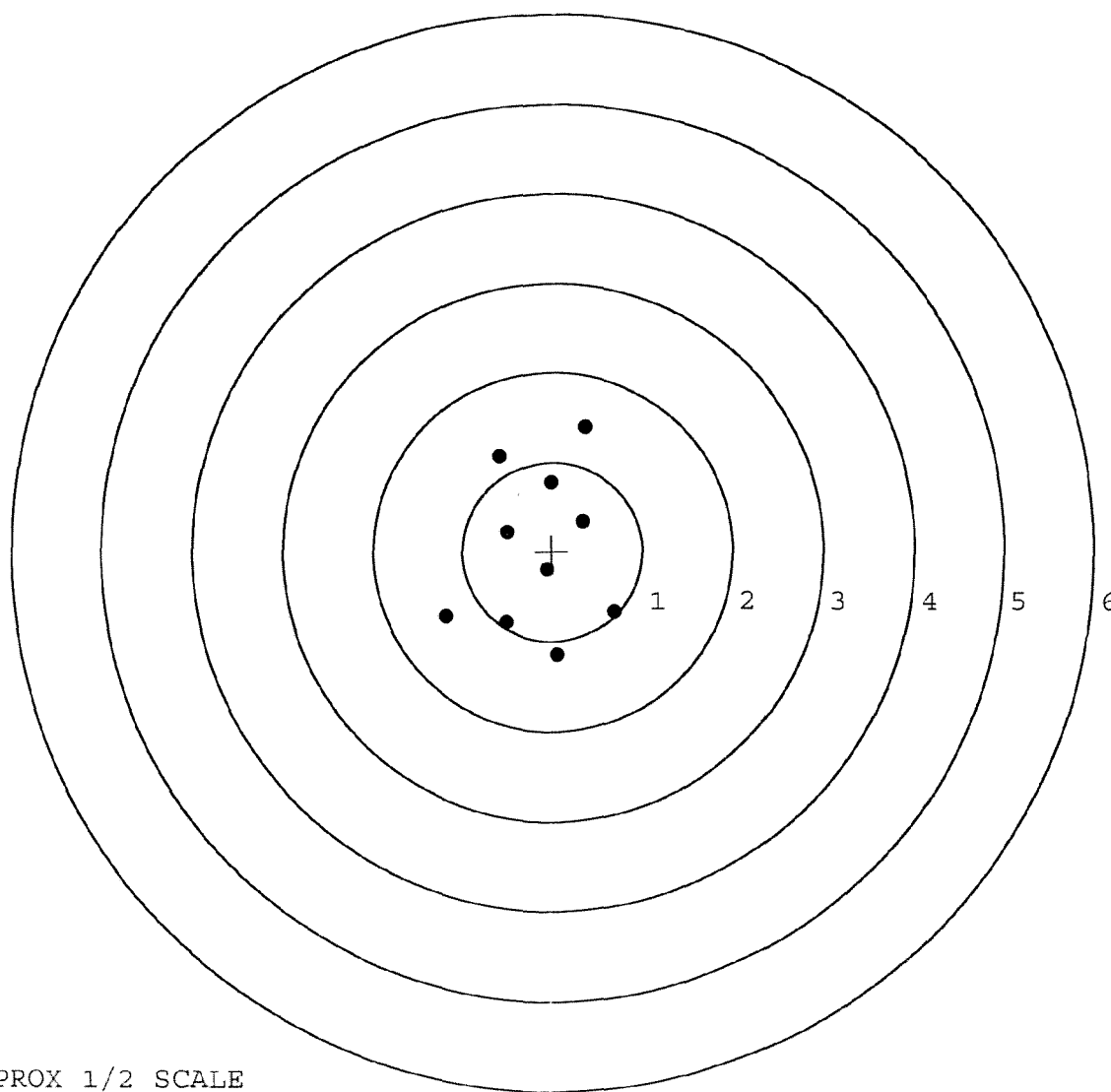


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790451. __0
TARGET NUMBER: 4
FILE DATE: 05/11/2002
FILE TIME: 13:19

X CENTROID: -0.139
Y CENTROID: 0.021
POA TO CENTROID: 0.141
HORZ SPREAD: 1.878
VERT SPREAD: 2.552
GROUP SPREAD: 2.639
MIN RADIUS: 0.247
MAX RADIUS: 1.464
MEAN RADIUS: 0.907
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.693	-0.674
2:	0.063	-1.159
3:	-0.509	-0.796
4:	-1.185	-0.739
5:	-0.500	0.218
6:	0.343	0.334
7:	-0.013	0.780
8:	0.370	1.393
9:	-0.599	1.061
10:	-0.054	-0.211



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: E6790451. 0

TARGET NUMBER: 5

FILE DATE: 05/11/2002

FILE TIME: 13:19

POINT#	X	Y
1:	0.932	-1.160
2:	-0.244	-1.729
3:	0.485	-0.437
4:	0.135	-0.527
5:	-0.113	-0.379
6:	-0.454	2.142
7:	0.207	0.278
8:	0.065	0.468
9:	-0.222	0.349
10:	-0.502	0.141

X CENTROID: 0.029

Y CENTROID: -0.085

POA TO CENTROID: 0.090

HORZ SPREAD: 1.434

VERT SPREAD: 3.871

GROUP SPREAD: 3.877

MIN RADIUS: 0.326

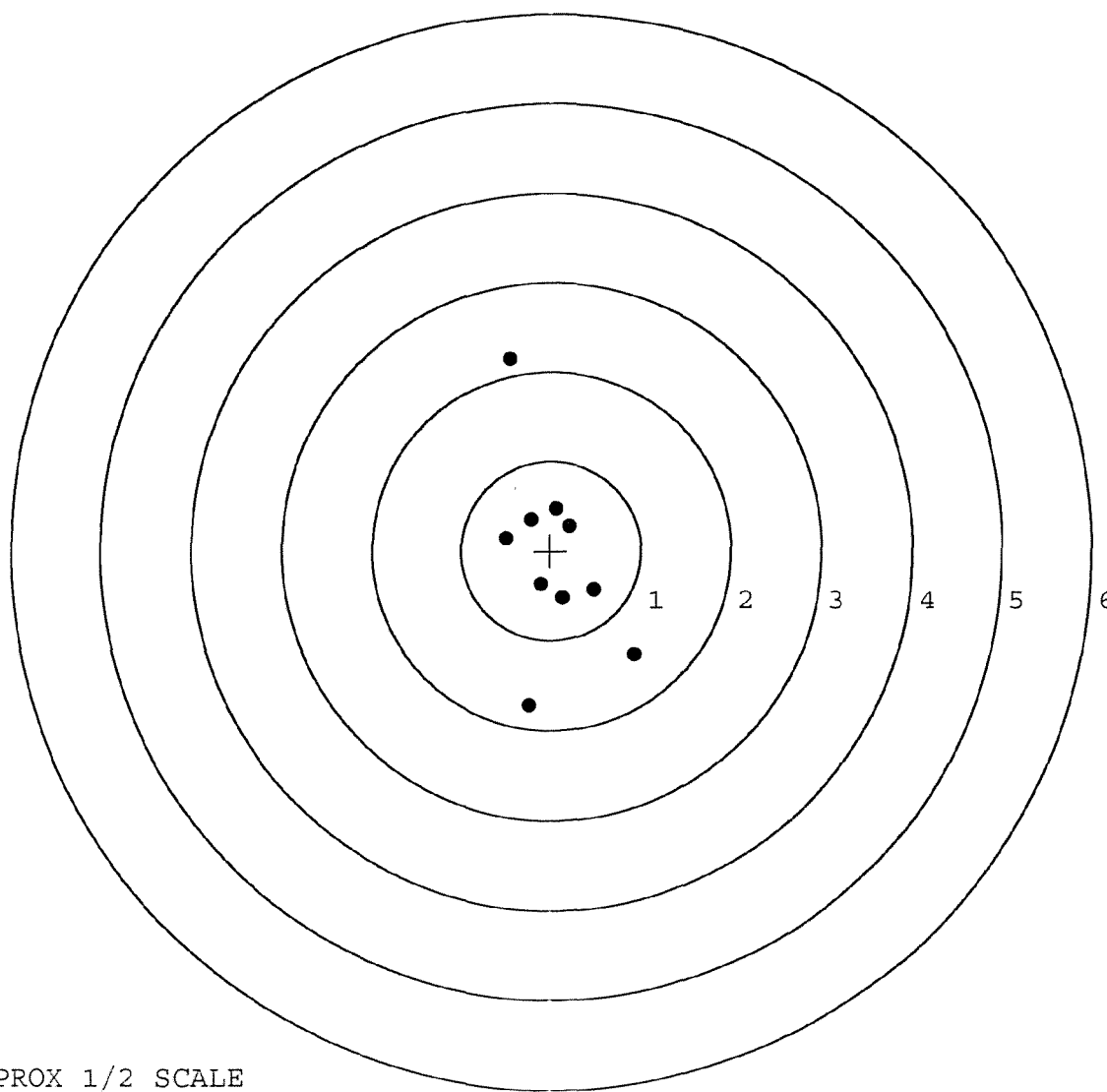
MAX RADIUS: 2.279

MEAN RADIUS: 0.874

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE