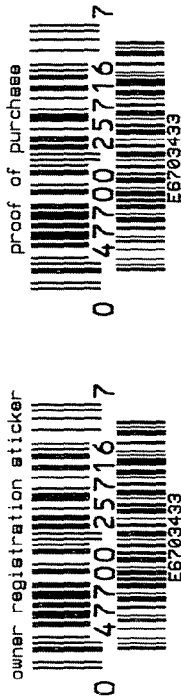


E670 3433

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

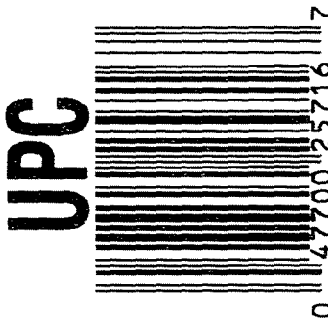
- DOCUMENT ENVELOPE ASSEMBLY:
- INSTRUCTION BOOK
 - PRODUCT OWNER'S CARD
 - SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

E6703433



GUN SERIAL # E6703433

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3/01	CK
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(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			CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		3/01	CK

OP #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>6.0</u>	<u>5.0</u>	<u>5.0</u>	3/25	Tjd
CONT.	G) SAFETY OFF FORCE	<u>3.0</u>	<u>4.0</u>	<u>4.0</u>	3/25	Tjd
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>.021</u>	<u>.023</u>	<u>.021</u>	3/25	Tjd
	J) ASSEMBLE STOCK					CK
	K) ASSEMBLE SWIVEL STUDS				3/26/01	Rep
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT					
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640	GALLERY TEST AND TARGET				3-21-01	Rw
	A) MALFUNCTIONS				3-21-01	Rw
	B) PIERCED PRIMERS				3-21-01	Rw
645	INSPECT FOR LIVE AMMO				3-21-01	Rw
655	FINAL INSPECTION A) HEADSPACE				3/26/01	
	B) TRIGGER PULL	<u>288</u>	<u>295</u>	<u>289</u> <u>285</u> <u>293</u>	3-25	Tjd
	C) FUNCTION				3/26/01	
660	PACK				3/26/01	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703433DATE 2-8-01TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.64		2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.57		2.26	
PULL #3	2.38	2.62		2.23	
PULL #4	2.30	2.62		2.26	
PULL #5	2.27	2.51		2.25	
TOTAL	1183	1296		1133	
AVG.	2.36	2.59		2.26	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.04		
PULL #2	3.06	3.02		
PULL #3	3.08	3.00		
PULL #4	2.97	3.00		
PULL #5	3.11	3.02		
TOTAL	1528	1508		
AVG.	3.05	3.01		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.01		4.25
PULL #2	4.02	3.89		4.26
PULL #3	4.15	3.88		4.06
PULL #4	4.00	3.90		4.19
PULL #5	4.15	3.85		4.17
TOTAL	2035	1953		2093
AVG.	4.07	3.90		4.18

BARBER - M24 0121445

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703433
24 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0054$

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.04$

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0403629$

THE AMR FOR THIS RIFLE IS: $.9912$

CENTROIDAL DISTANCES

Ø TO	1	.103942
1 TO	2	.0117047
1 TO	3	.31543
1 TO	4	.144586
1 TO	5	.315127

5 4² <----POA
3

BARBER - M24 0121446

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .104

MIN RADIUS : .465

MEAN RADIUS : .987

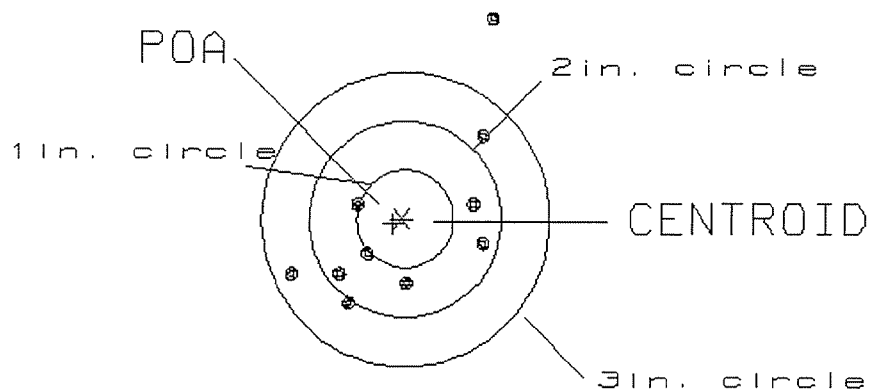
MAX RADIUS : 2.266

CENTROID X : .090

CENTROID Y : .052

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 1

OF SHOTS= 10

IN CIRCLE

HS= 2.16

1

VS= 2.90

6

GS= 3.37

9

BARBER - M24 0121447

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .092

MIN RADIUS : .206

MEAN RADIUS : 1.042

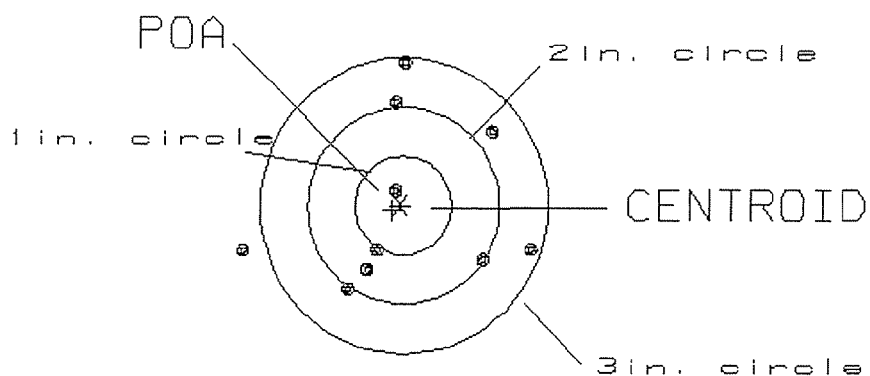
MAX RADIUS : 1.765

CENTROID X : .079

CENTROID Y : .048

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e0703433

CENTERFIRE PATTERN # 2

OF SHOTS= 10

IN CIRCLE

HS= 3.03

1

VS= 2.34

3

GS= 3.03

9

BARBER - M24 0121448

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .269

MIN RADIUS : .170

MEAN RADIUS : .985

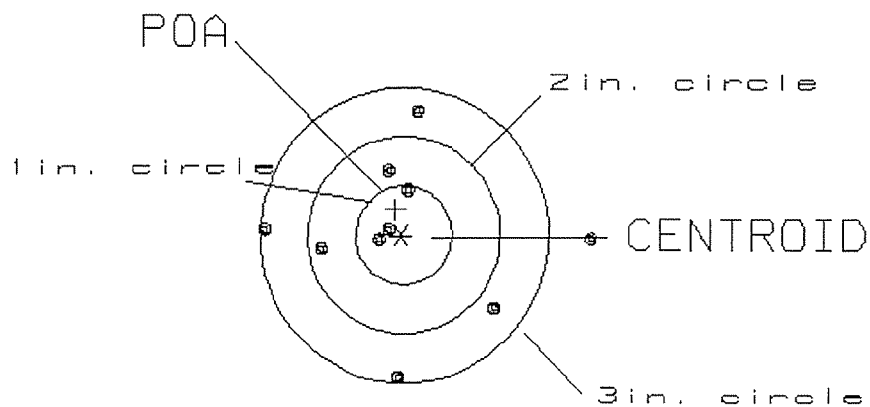
MAX RADIUS : 1.908

CENTROID X : .060

CENTROID Y : -.262

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e8703433

CENTERFIRE PATTERN # 3

OF SHOTS= 10

IN CIRCLE

HS= 3.41

3

VS= 2.74

5

GS= 3.41

8

BARBER - M24 0121449

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .043

MIN RADIUS : .534

MEAN RADIUS : 1.162

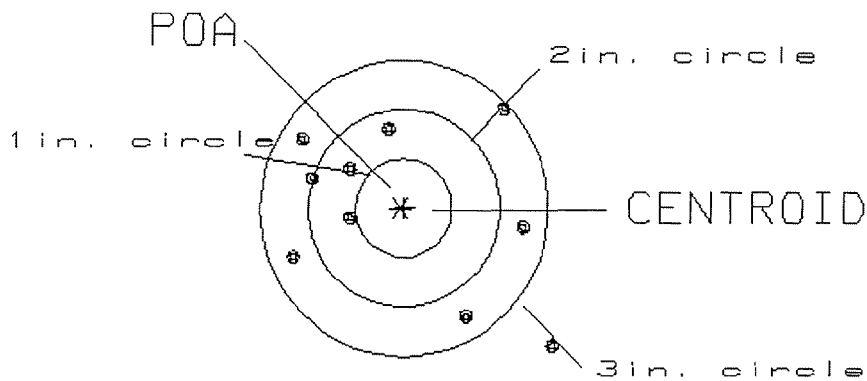
MAX RADIUS : 2.097

CENTROID X : -.042

CENTROID Y : -.007

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e0703433

CENTERFIRE PATTERN # 4

OF SHOTS= 10

IN CIRCLE

HS= 2.73

0

VS= 2.39

3

GS= 3.40

9

BARBER - M24 0121450

REMINGTON CENTERFIRE ACCURACY TEST

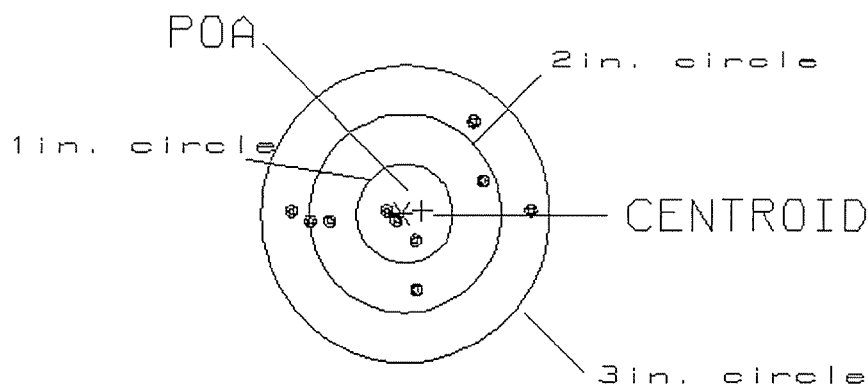
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5

POA TO CENTROID: .216
MIN RADIUS : .131
MEAN RADIUS : .780
MAX RADIUS : 1.351
CENTROID X : -.214
CENTROID Y : -.031

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e0703433

CENTERFIRE PATTERN # 5

OF SHOTS= 10

IN CIRCLE

HS= 2.50

3

VS= 1.79

7

GS= 2.50

10

BARBER - M24 0121451

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703433
22 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0278
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .336
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .337148

THE AMR FOR THIS RIFLE IS: 1.309

CENTROIDAL DISTANCES

0 TO 1	.838117
1 TO 2	.792063
1 TO 3	.665586
1 TO 4	.263638
1 TO 5	.821862

1
4
3
5 4 <----POA

BARBER - M24 0121452

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .838

MIN RADIUS : .626

MEAN RADIUS : 2.239

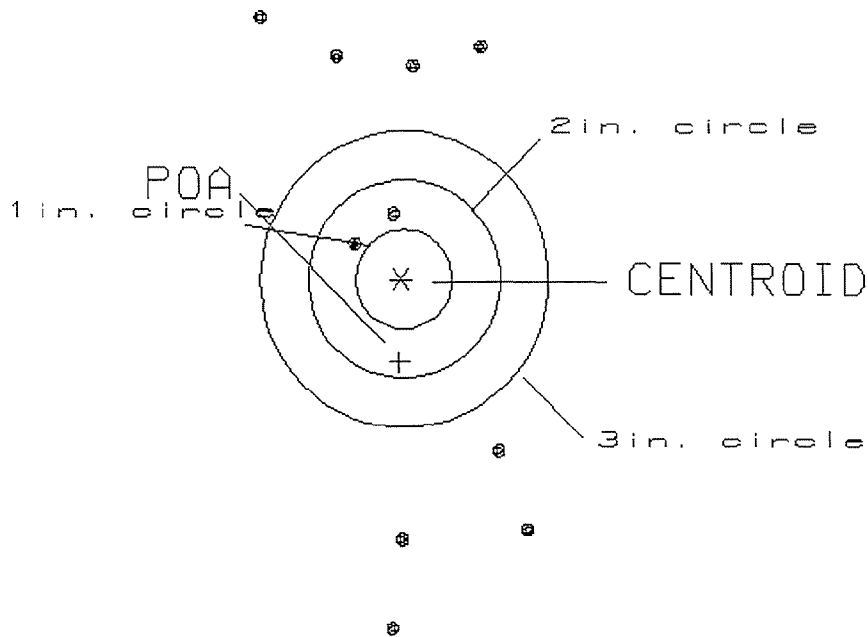
MAX RADIUS : 3.517

CENTROID X : .014

CENTROID Y : .838

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 1

OF SHOTS= 10

IN CIRCLE

HS= 2.83

0

VS= 6.15

2

GS= 6.31

2

BARBER - M24 0121453

REMINGTON CENTERFIRE ACCURACY TEST

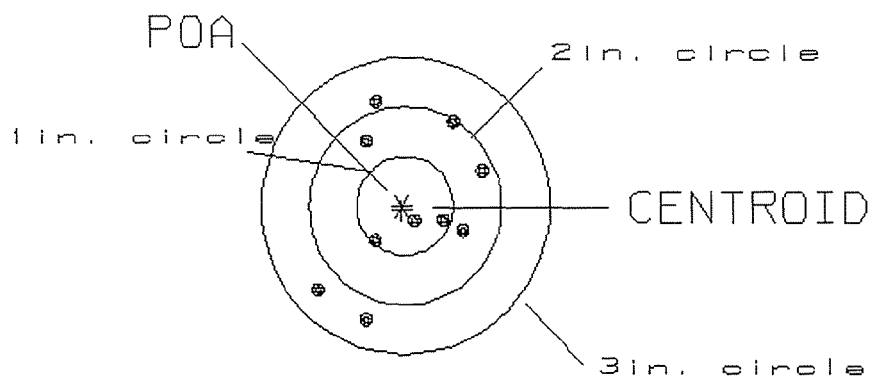
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
POA TO CENTROID: .046
MIN RADIUS : .142
MEAN RADIUS : .784
MAX RADIUS : 1.250
CENTROID X : .004
CENTROID Y : .046

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.75

3

VS= 2.25

7

GS= 2.25

10

BARBER - M24 0121454

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .189

MIN RADIUS : .187

MEAN RADIUS : .860

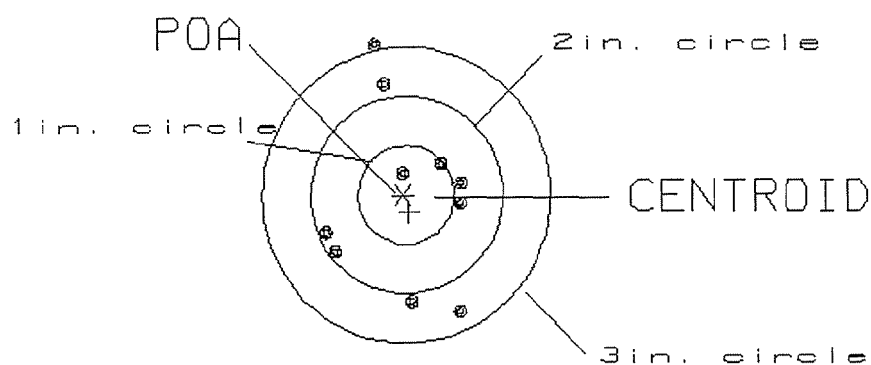
MAX RADIUS : 1.539

CENTROID X : -.064

CENTROID Y : .177

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 3

OF SHOTS= 10

IN CIRCLE

HS= 1.40

2

VS= 2.72

6

GS= 2.89

9

BARBER - M24 0121455

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .587

MIN RADIUS : .591

MEAN RADIUS : 1.154

MAX RADIUS : 1.891

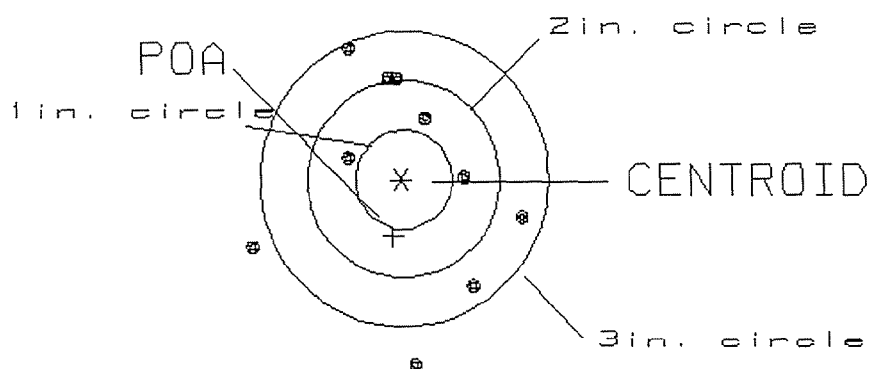
CENTROID X : .077

CENTROID Y : .582

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.78

0

VS= 3.19

3

GS= 3.28

8

BARBER - M24 0121456

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .174

MIN RADIUS : .696

MEAN RADIUS : 1.506

MAX RADIUS : 2.679

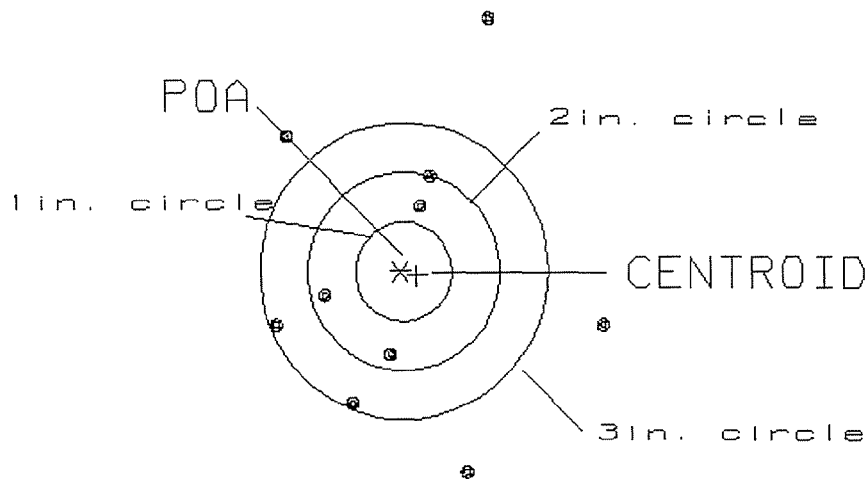
CENTROID X : -.170

CENTROID Y : .037

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703433

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.40

0

VS= 4.59

4

GS= 4.59

6