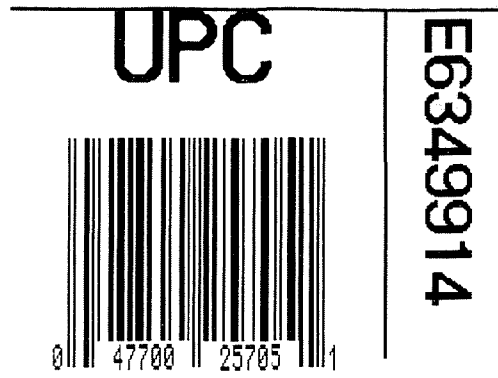




ORDER NO.	25705
BARREL LENGTH	24"
CAPACITY *	6
*INCLUDES 1 IN CHAMBER	

ISRAELI GUNS

CONTRACT # DAAE20-97-C-0182

GUN SERIAL # E 634 9914

OP. #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK			
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BARREL ACTION			
	MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES			
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			
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			

OP. #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) BARBER M24 0123636 SAFETY OFF FORCE	<u>3</u>	<u>3</u>	<u>3</u>	6-4-97	CK
CONT.	G) SAFETY OFF FORCE	<u>4</u>	<u>3.5</u>	<u>3.5</u>	6-4-97	CK
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>10215</u>	<u>.022</u>	<u>.0225</u>	6-4-97	CK
	J) ASSEMBLE STOCK					
	K) ASSEMBLE SWIVEL STUDS				6-20-97	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				6/5/97	RP
	M) IRON SIGHT ALIGNMENT				6/5/97	RP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				6/5/97	RP
640	GALLERY TEST AND TARGET	<u>L 76</u>	<u>R 64</u>		6/11/97	JW
	A) MALFUNCTIONS				6/11/97	JW
	B) PIERCED PRIMERS				6/11/97	JW
645	INSPECT FOR LIVE AMMO				6/11/97	NF
655	FINAL INSPECTION A) HEADSPACE				6/20/97	RP
	B) TRIGGER PULL	<u>2.76</u>	<u>2.79</u>	<u>2.78</u> <u>2.81</u> <u>2.83</u>	6/18/97	CK
	C) FUNCTION				6/20/97	RP
660	PACK					

BARBER - M24 0123637

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6349914
17 Jun 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.023$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.0296667$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0375381$

THE AMR FOR THIS RIFLE IS: $.6783$

CENTROIDAL DISTANCES

0 TO 1	.117034
1 TO 2	.274117
1 TO 3	.240235

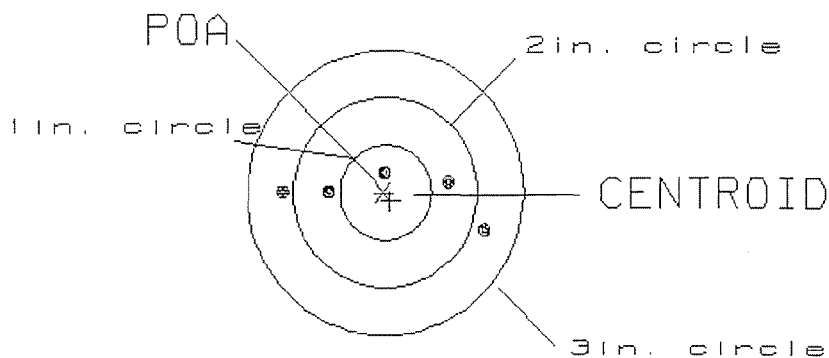
$\begin{matrix} 1 & 2 \\ + & \\ 3 \end{matrix}$ <----POA

PATTERN #: 1
 POA TO CENTROID: .117
 MIN RADIUS : .257
 MEAN RADIUS : .764
 MAX RADIUS : 1.168
 CENTROID X : -.076
 CENTROID Y : .089

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914.1

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 2.27

1

VS= .61

3

GS= 2.30

5

BARBER - M24 0123639

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

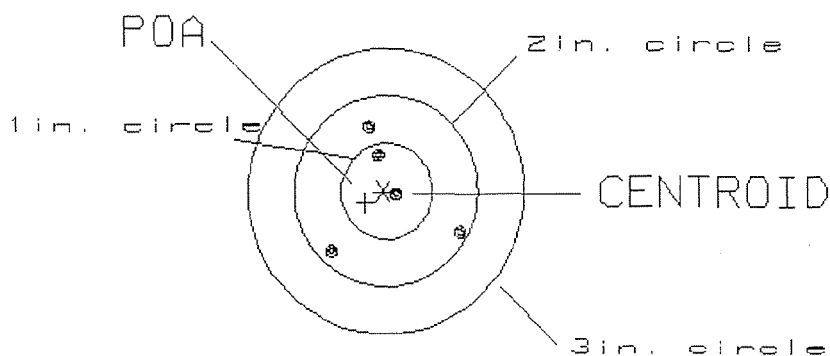
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .232
 MIN RADIUS : .118
 MEAN RADIUS : .575
 MAX RADIUS : .862
 CENTROID X : .196
 CENTROID Y : .123

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914.1

CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 1.33

2

VS= 1.22

5

GS= 1.39

5

BARBER - M24 0123640

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: C 3 C

POA TO CENTROID: .225

MIN RADIUS : .347

MEAN RADIUS : .696

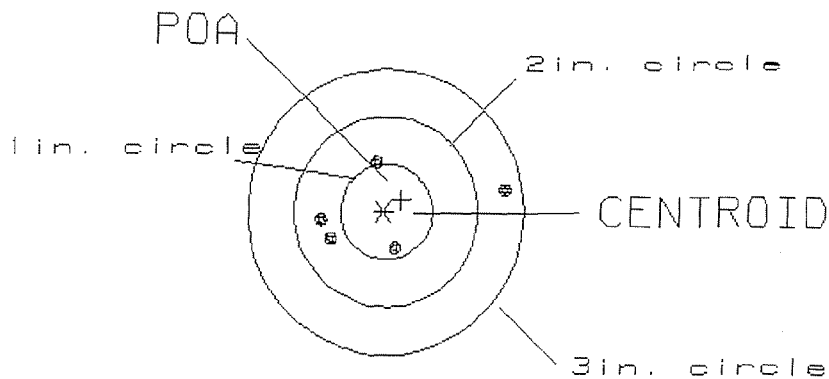
MAX RADIUS : 1.294

CENTROID X : -.189

CENTROID Y : -.123

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914.1

CENTERFIRE PATTERN # 3

OF SHOTS= 5

IN CIRCLE

HS= 1.94

2

US= .80

4

GS= 1.97

5

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6349914
11 Jun 1997THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.146$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.917$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.92855$ THE AMR FOR THIS RIFLE IS: 1.702

CENTROIDAL DISTANCES

0 TO 1	.273389
1 TO 2	3.51341
1 TO 3	.565616

3
+ 1 <----POA

2

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

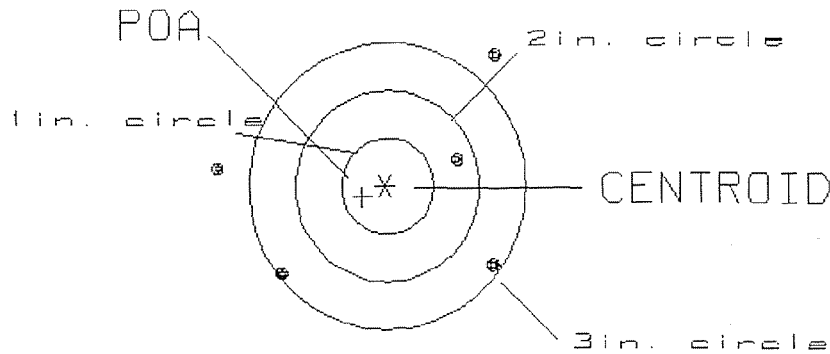
PATTERN #: 010

POA TO CENTROID: .273
 MIN RADIUS: .778
 MEAN RADIUS: 1.463
 MAX RADIUS: 1.877
 CENTROID X: .247
 CENTROID Y: .117

11 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 3.01

0

US= 2.32

1

GS= 3.25

3

REMINGTON CENTERFIRE ACCURACY TEST

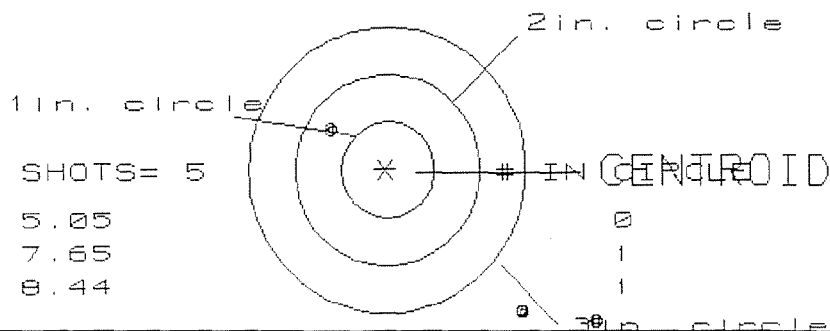
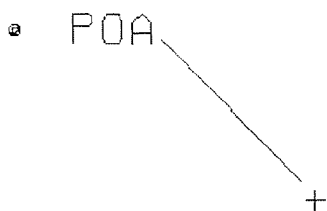
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2
 POA TO CENTROID: 3.355
 MIN RADIUS : .732
 MEAN RADIUS : 2.795
 MAX RADIUS : 5.864
 CENTROID X : -.477
 CENTROID Y : -3.321

11 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914

CENTERFIRE PATTERN # 2



OF SHOTS= 5

HS= 5.05

US= 7.65

GS= 8.44

BARBER - M24 0123644

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

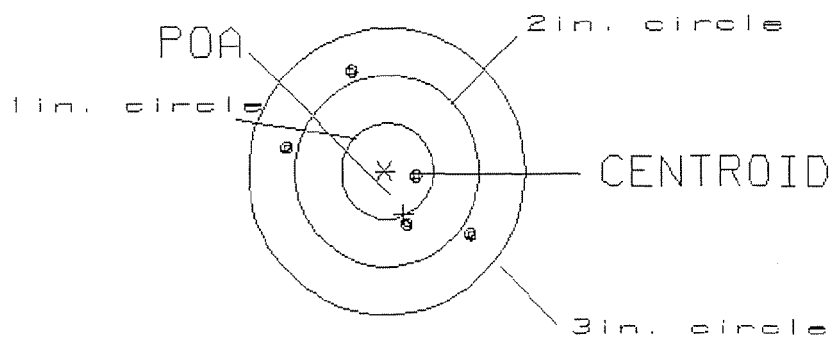
PATTERN #: 3

POA TO CENTROID: .499
 MIN RADIUS : .334
 MEAN RADIUS : .848
 MAX RADIUS : 1.109
 CENTROID X : -.208
 CENTROID Y : .453

11 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349914

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 1.95
 VS= 1.66
 GS= 2.14

1
 2
 5

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6349914

DATE 6-2-97

TESTER C.K.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.60	2.62	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.76	2.59	2.74	
PULL #3	2.76	2.53	2.77	
PULL #4	2.74	2.51	2.73	
PULL #5	2.77	2.57	2.71	
TOTAL	13.63	12.82	13.71	
AVG.	2.726	2.564	2.742	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.09	3.02	
PULL #2	3.16	2.84	
PULL #3	3.17	3.13	
PULL #4	3.17	3.11	
PULL #5	3.13	3.08	
TOTAL	15.71	15.18	
AVG.	3.142	3.036	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	3.77		4.02
PULL #2	3.87	3.94		4.11
PULL #3	3.98	4.02		4.03
PULL #4	4.04	3.97		3.66
PULL #5	3.90	3.96		4.16
TOTAL	19.82	19.66		19.98
AVG.	3.964	3.932		3.996

Do Not Use



ORDER 25705

MODEL 700™ M24

UPC



ORDER 25705

MODEL 700™ M24

UPC



SERIAL NO



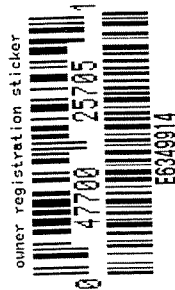
E6349914

Do Not Use

MODEL 700[™] M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO 6*

GREEN ENVELOPE CONTAINS:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- MUSEUM/COUNTRY STORE FLIER
- REMINGTON AUTHORIZED GUNSMITHS



46 FORM