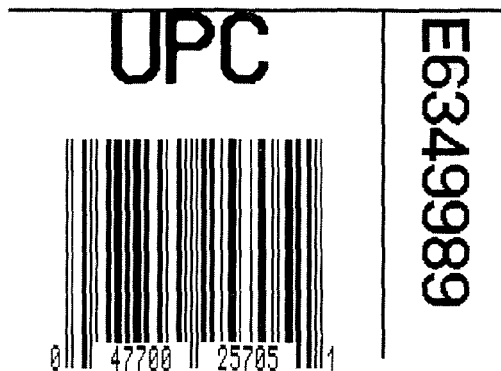




ORDER NO.	25705
BARREL LENGTH	24"
CAPACITY *	6
*INCLUDES 1 IN CHAMBER	

ISRAELI GUNS

IS-B-YLS

GUN SERIAL # E6349989

OP. #	OP. 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)			
	Apply Coating (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 Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

OP. #	OP. NAME	READINGS	DATE	INITIA
625 CONT.	F) SAFETY ON FORCE	<u>4</u> <u>4</u> <u>4</u>	<u>6-3-97</u>	
	G) SAFETY OFF FORCE	<u>3.5</u> <u>3.5</u> <u>3.5</u>	<u>6-3-97</u>	
	H) TRIGGER PULL TEST & RETAINABILITY			
	I) FIRING PIN INDENT	<u>.022</u> <u>.021</u> <u>.021</u>	<u>6-3-97</u>	
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		<u>6-20-97</u>	<u>RP</u>
	L) ATTACH FRONT AND REAR SIGHT ASSEMBLIES		<u>5-28-97</u>	<u>RP</u>
	M) IRON SIGHT ALIGNMENT		<u>5-28-97</u>	<u>RP</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERER CONTAINER		<u>5-28-97</u>	<u>RP</u>
640	GALLERY TEST AND TARGET	<u>L-77</u> <u>R-73</u>	<u>6-10-97</u>	<u>NF</u>
	A) MALFUNCTIONS		<u>"</u>	<u>NF</u>
	B) PIERCED PRIMERS		<u>"</u>	<u>NF</u>
645	INSPECT FOR LIVE AMMO		<u>6-10-97</u>	<u>JP</u>
655	FINAL INSPECTION			
	A) HEADSPACE		<u>6-20-97</u>	<u>RP</u>
	B) TRIGGER PULL	<u>2.77</u> <u>2.76</u> <u>2.73</u> <u>2.69</u> <u>2.66</u>	<u>6-18-97</u>	<u>CR</u>
	FUNCTION		<u>6-20-97</u>	<u>RP</u>
660	PACK			

BARBER - M24 0124553

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6349989
17 Jun 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .00466667
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .043
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0432525

THE AMR FOR THIS RIFLE IS: .798

CENTROIDAL DISTANCES

Ø TO 1 .224154
1 TO 2 .309739
1 TO 3 .340767

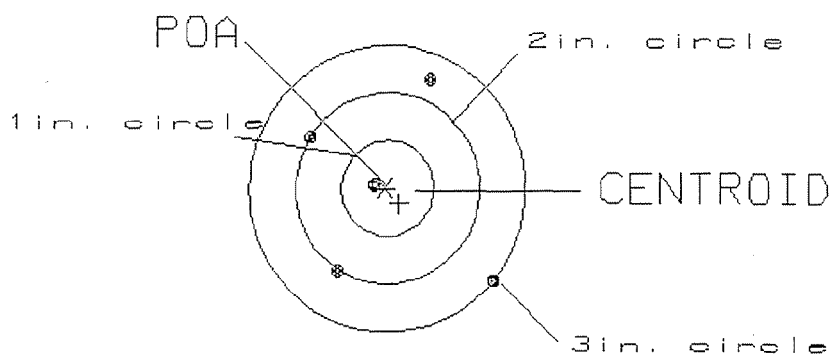
1 3
2 <---POA

PATTERN #: 010
 POA TO CENTROID: .224
 MIN RADIUS : .128
 MEAN RADIUS : .976
 MAX RADIUS : 1.474
 CENTROID X : -.158
 CENTROID Y : .159

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/EG349989.1

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 2.02

1

VS= 2.10

1

GS= 2.49

5

BARBER - M24 0124555

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .108

MIN RADIUS : .433

MEAN RADIUS : .781

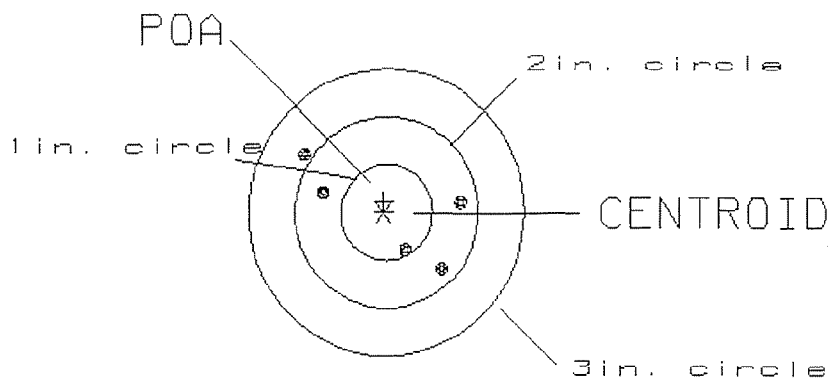
MAX RADIUS : 1.077

CENTROID X : -.001

CENTROID Y : -.108

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349989.1

CENTERFIRE PATTERN # 2

OF SHOTS= 5

IN CIRCLE

HS= 1.65

1

VS= 1.20

4

GS= 1.92

5

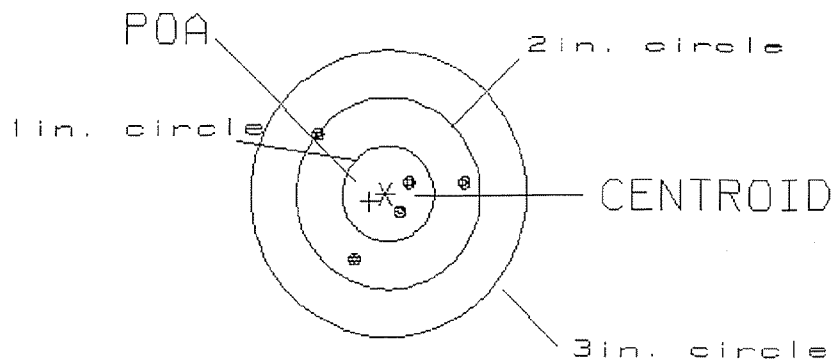
PATTERN #: 3

POA TO CENTROID: .190
 MIN RADIUS : .234
 MEAN RADIUS : .637
 MAX RADIUS : .997
 CENTROID X : .173
 CENTROID Y : .078

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349989.1

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 1.62

2

VS= 1.31

5

GS= 1.69

5

Centroidal distance calculations for Rifle # E6349989
10 Jun 1997

THE AMR FOR THIS RIFLE IS: 1.56

0	TO	1	.947979
1	TO	2	1.85302
1	TO	3	1.89511

2

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

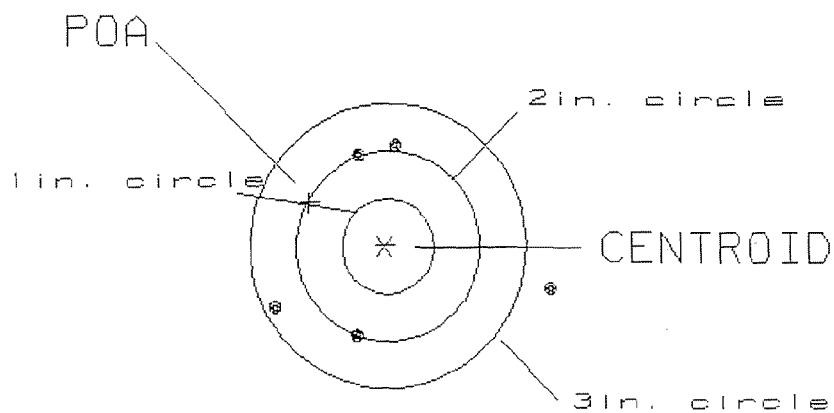
PATTERN #: 1

POA TO CENTROID: .948
 MIN RADIUS : .984
 MEAN RADIUS : 1.248
 MAX RADIUS : 1.860
 CENTROID X : .830
 CENTROID Y : -.458

10 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349989

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 3.01
 VS= 1.96
 GS= 3.01

0
 2
 4

REMINGTON CENTERFIRE ACCURACY TEST

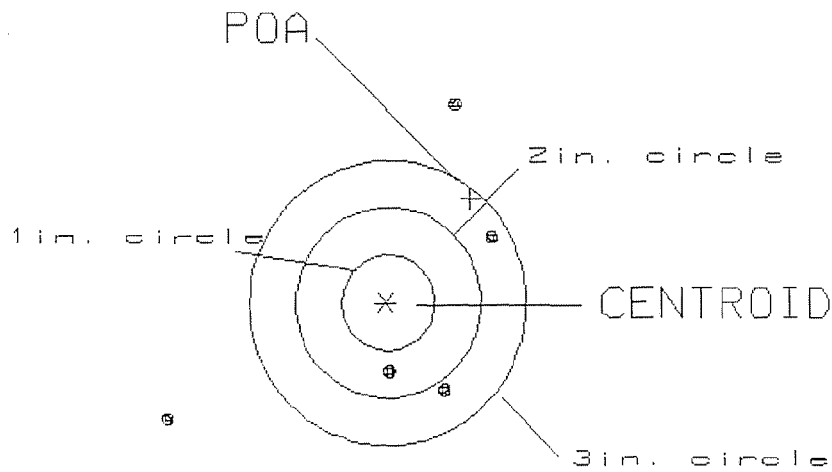
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 02
 POA TO CENTROID: 1.419
 MIN RADIUS : .667
 MEAN RADIUS : 1.581
 MAX RADIUS : 2.649
 CENTROID X : -.913
 CENTROID Y : -1.087

10 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349989

CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 3.42
 VS= 3.35
 GS= 4.52

0
 1
 3

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

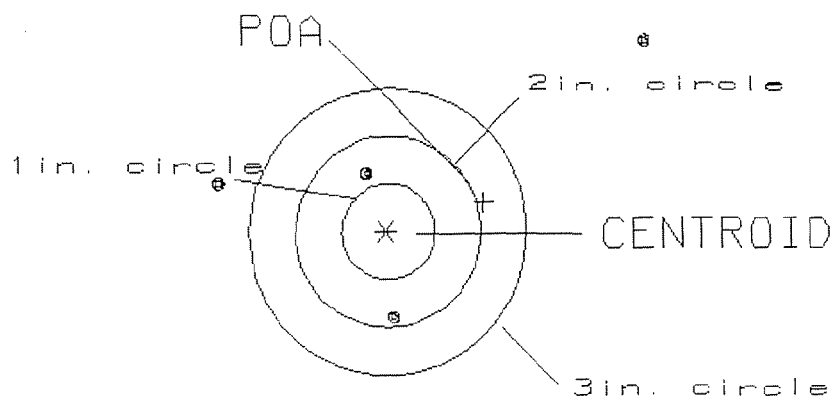
PATTERN #: 3

POA TO CENTROID: 1.103
 MIN RADIUS : .650
 MEAN RADIUS : 1.850
 MAX RADIUS : 3.389
 CENTROID X : -1.059
 CENTROID Y : -.306

10 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349989

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 4.56

0

VS= 4.28

2

GS= 5.48

2

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. E6349989DATE 5-14-92TESTER A.P

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.55	2.53	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.64	2.57	
PULL #3	2.59	2.39	2.43	
PULL #4	2.54	2.58	2.49	
PULL #5	2.46	2.56	2.51	
TOTAL	12.68	12.70	12.51	
AVG.	2.54	2.54	2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	2.95	2.94	
PULL #2	3.01	2.91	
PULL #3	2.99	2.91	
PULL #4	3.12	2.93	
PULL #5	2.95	2.87	
TOTAL	15.02	14.54	
AVG.	3.00	2.91	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.99	3.99		3.93
PULL #2	3.95	3.93		4.12
PULL #3	4.12	3.91		4.04
PULL #4	3.93	4.05		3.96
PULL #5	3.98	4.02		4.02
TOTAL	19.97	19.90		20.07
AVG.	3.99	3.98		4.01

Do Not Use

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

KEY: UPON RANT
INSTRUCTION BOOK
SUCCESS NO. 25506
SAFE USE OF THIS
PRODUCT

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46
ORDER NO
25705

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SERIAL NO



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

GREEN ENVELOPE CONTAINING:

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



46 FORM