

UPC



C6665963

ORDER NO. 25705

BARREL LENGTH 24"

CAPACITY * 6

*INCLUDES 1 IN CHAMBER

ISRAELI GUNS

IS-B-YLS

GUN SERIAL # C 6665963

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		3/20/97	WJT
618	Polish Barrel		3/20/97	WJT
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>3</u> <u>3</u> <u>3</u>	<u>5-20-97</u>	<u>QW</u>
	G) SAFETY OFF FORCE	<u>2.5</u> <u>2.5</u> <u>2.5</u>	<u>5-20-97</u>	<u>QW</u>
	H) TRIGGER PULL TEST & RETAINABILITY			
	I) FIRING PIN INDENT	<u>22.5</u> <u>21</u> <u>22.5</u>	<u>5-20-97</u>	<u>QW</u>
	J) ASSEMBLE STOCK		<u>5/15/97</u>	<u>RP</u>
	K) ASSEMBLE SWIVEL STUDS		<u>6-24-97</u>	<u>RP</u>
	L) ATTACH FRONT AND REAR SIGHT ASSEMBLIES		<u>5-23-97</u>	<u>QW</u>
	M) IRON SIGHT ALIGNMENT		<u>5-23-97</u>	<u>QW</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERER CONTAINER		<u>5-23-97</u>	<u>QW</u>
640	GALLERY TEST AND TARGET	<u>L79</u> <u>R71</u>	<u>6/20/97</u>	<u>TM</u>
	A) MALFUNCTIONS		<u>6/20/97</u>	<u>TM</u>
	B) PIERCED PRIMERS		<u>6/20/97</u>	<u>TM</u>
645	INSPECT FOR LIVE AMMO		<u>6/20/97</u>	<u>TM</u>
655	FINAL INSPECTION			
	A) HEADSPACE		<u>6-24-97</u>	<u>RP</u>
	B) TRIGGER PULL	<u>2.77</u> <u>2.75</u> <u>2.63</u> <u>2.66</u> <u>2.76</u>	<u>6-28-97</u>	<u>CLC</u>
	FUNCTION		<u>6-24-97</u>	<u>RP</u>
660	PACK			

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6665963
20 Jun 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.091
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .231667
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .248898

THE AMR FOR THIS RIFLE IS: 1.048

CENTROIDAL DISTANCES

Ø TO	1	.447139
1 TO	2	.533371
1 TO	3	.391451

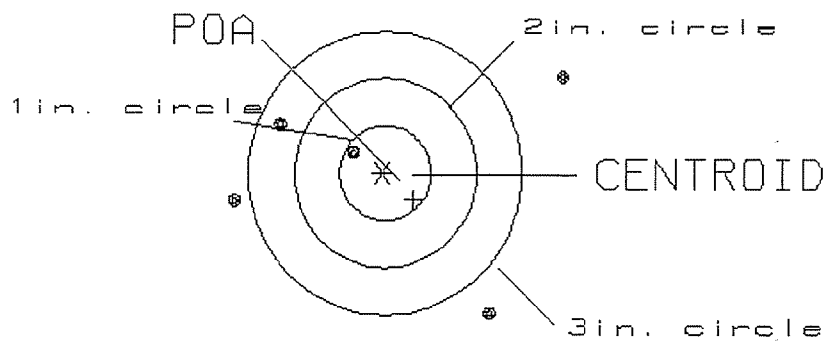
1 2
 3+ <----POA

PATTERN #: 1
 POA TO CENTROID: .447
 MIN RADIUS : .389
 MEAN RADIUS : 1.465
 MAX RADIUS : 2.197
 CENTROID X : -.347
 CENTROID Y : .282

20 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665963

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 3.57
 VS= 2.52
 GS= 3.79

1
 1
 2

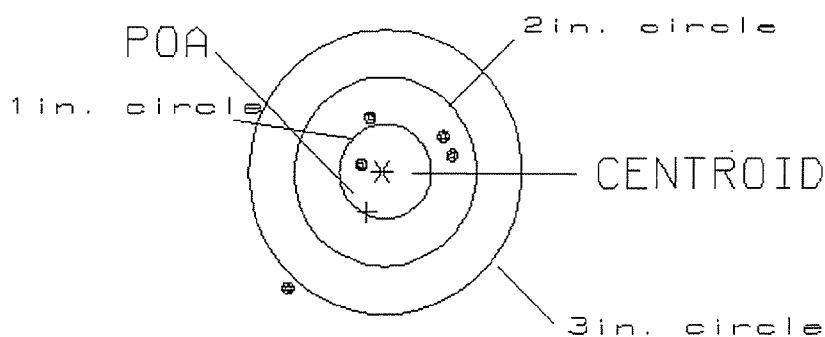
PATTERN #: 2

POA TO CENTROID: .459
 MIN RADIUS : .245
 MEAN RADIUS : .800
 MAX RADIUS : 1.613
 CENTROID X : .166
 CENTROID Y : .428

20 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665963

CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 1.79

1

VS= 1.83

4

GS= 2.34

4

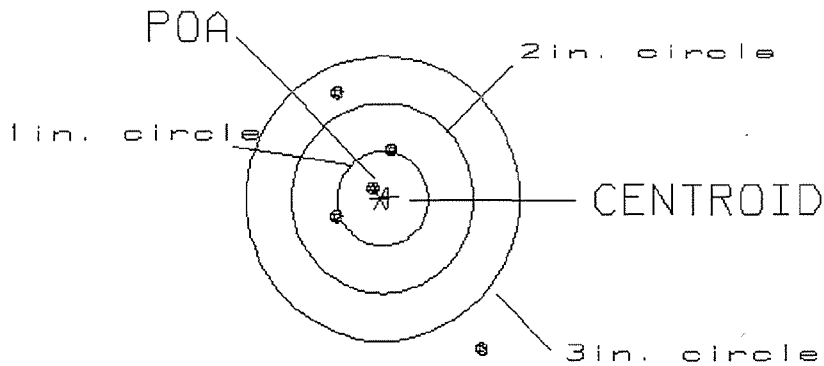
PATTERN #: 3

POA TO CENTROID: .093
 MIN RADIUS : .199
 MEAN RADIUS : .878
 MAX RADIUS : 1.898
 CENTROID X : -.092
 CENTROID Y : -.015

20 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665963

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 1.56
 VS= 2.69
 GS= 3.08

1
 3
 4

SWS TRIGGER PULL TEST

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

SERIAL NO. C6665963

DATE 5-7-97

TESTER EK

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.70	2.60	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.73	2.61	2.70	
PULL #3	2.61	2.45	2.52	
PULL #4	2.65	2.47	2.50	
PULL #5	2.51	2.56	2.49	
TOTAL	13.20	12.69	12.79	
AVG.	2.64	2.54	2.56	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.20	3.12	
PULL #2	3.13	3.33	
PULL #3	3.13	3.31	
PULL #4	3.19	3.19	
PULL #5	3.32	3.19	
TOTAL	15.97	16.14	
AVG.	3.19	3.23	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	4.01		3.99
PULL #2	4.06	3.84		4.22
PULL #3	4.09	4.02		4.06
PULL #4	3.98	4.02		4.26
PULL #5	3.93	3.94		4.16
TOTAL	20.03	19.83		20.69
AVG.	4.01	3.97		4.14