

E 676 1523

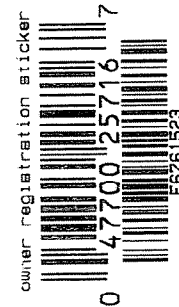
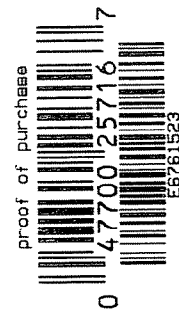
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MODEL 700[™] M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

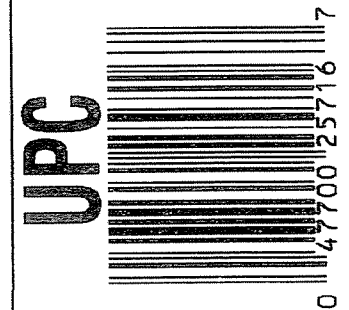


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6761523



CONTRACT #

GUN SERIAL # E6761523

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		9-26-01	AK
600	PROOF		9/27/01	AC
607	CHECK HEADSPACE		9-27-01	AK
610	DIS-ASSEMBLE GUN		9-27-01	AK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		SEP 29 2001 EJECTOR	AK
615	ROLLMARK CALIBER		9/29	(P)
617	DRILL AND TAP SIGHT HOLES			
620	APPLY COATINGS (BARREL ACTION)		10/8	HP
	(BOLT)		10/8	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-01	AK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-01	AK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-01	AK
	D) OIL FIRING PIN ASSEMBLY		10-17-01	AK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	12-14-01	AK

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>5.2</u>	10-18-01	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.2</u> <u>3.2</u> <u>2.5</u>	10-18-01	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	10-18-01	RA
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		12/13/01	REP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/13/01	REP
	M) IRON SIGHT ALIGNMENT		12/13/01	REP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/13/01	REP
640	GALLERY TEST AND TARGET	PASS FAIL	10-17-01	RW
	A) MALFUNCTIONS	PASS FAIL	10-17-01	RW
	B) PIERCED PRIMERS	PASS FAIL	10-17-01	RW
645	INSPECT FOR LIVE AMMO		10-17-01	RW
655	FINAL INSPECTION A) HEADSPACE		12/13/01	REP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.28</u> <u>2.47</u> <u>2.42</u> <u>2.60</u>	10-18-01	RA
	C) FUNCTION		12/13/01	REP
660	PACK		12/14/01	RA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. F6761523

DATE 9/19/01

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.29	2.27	2.26	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.28	2.26	
PULL #3	2.26	2.28	2.22	
PULL #4	2.30	2.23	2.21	
PULL #5	2.27	2.28	2.21	
TOTAL	1135	1134	1116	
AVG.	2.27	2.26	2.23	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.08	3.11	
PULL #2	3.17	3.08	
PULL #3	3.12	3.08	
PULL #4	3.08	3.13	
PULL #5	3.07	3.18	
TOTAL	1552	1558	
AVG.	3.10	3.11	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.13		4.07
PULL #2	4.18	4.22		4.12
PULL #3	4.14	4.06		4.11
PULL #4	4.16	4.21		4.22
PULL #5	4.03	4.23		4.04
TOTAL	2060	2085		2056
AVG.	4.12	4.17		4.11

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6761523
17 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0114
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2226
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .222892

THE AMR FOR THIS RIFLE IS: 1.002

CENTROIDAL DISTANCES

0 TO 1	.0936882
1 TO 2	.0518941
1 TO 3	.239286
1 TO 4	.28288
1 TO 5	.356523

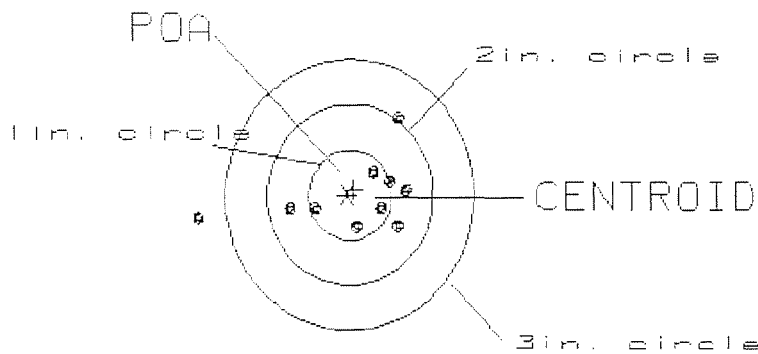
2+ <----POA
3 4
5

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .093
 MIN RADIUS : .358
 MEAN RADIUS : .696
 MAX RADIUS : 1.844
 CENTROID X : -.075
 CENTROID Y : -.056

17 Oct 2001

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CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.47
 VS= 1.26
 GS= 2.63

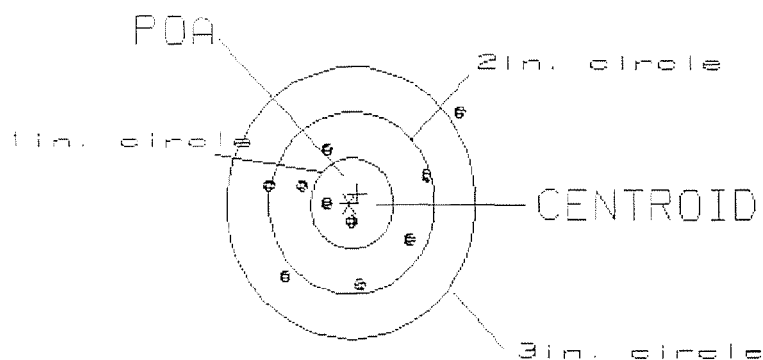
4
 8
 9

PATTERN #: E 2 C
 POA TO CENTROID: .142
 MIN RADIUS : .196
 MEAN RADIUS : .829
 MAX RADIUS : 1.609
 CENTROID X : -.097
 CENTROID Y : -.103

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CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.29
 US= 1.91
 GS= 2.73

2
 7
 9

PATTERN #: 030

POA TO CENTROID: .296

MIN RADIUS : .158

MEAN RADIUS : 1.016

MAX RADIUS : 1.813

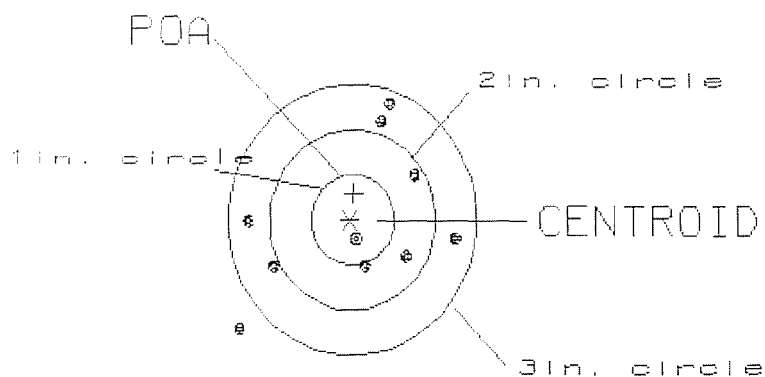
CENTROID X : -.042

CENTROID Y : -.293

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CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.60

2

VS= 2.53

4

GS= 3.10

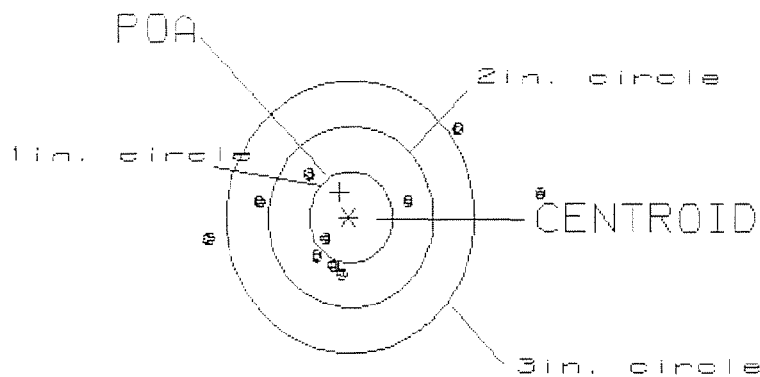
9

PATTERN #: 4
 POA TO CENTROID: .292
 MIN RADIUS : .363
 MEAN RADIUS : 1.025
 MAX RADIUS : 2.265
 CENTROID X : .110
 CENTROID Y : -.270

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CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.92
 VS= 1.57
 GS= 3.95

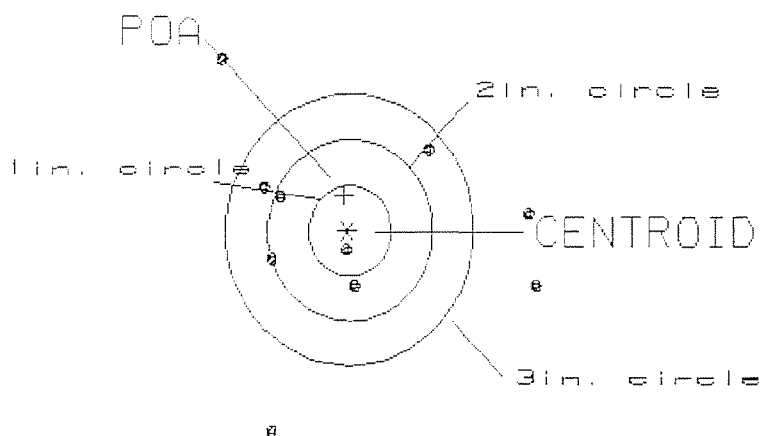
1
 6
 7

PATTERN #: 5
 POA TO CENTROID: .394
 MIN RADIUS : .178
 MEAN RADIUS : 1.445
 MAX RADIUS : 2.450
 CENTROID X : .047
 CENTROID Y : -.391

17 Oct. 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6751523

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.82
 VS= 4.06
 GS= 4.53

1
 4
 6