

E 676 1541

M2400113423

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

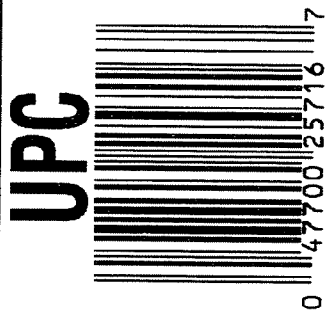


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6761561



GUN SERIAL # E6761561

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		9-24-01	AK
600	PROOF		9/25/01	AC
607	CHECK HEADSPACE	MAGNA - FLUX	9-25-01	AK
610	DIS-ASSEMBLE GUN	INSPECTED	9-25-01	AK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	SEP 26 2001 OPERATOR: DRD		
615	ROLLMARK CALIBER		9/27	JB
617	DRILL AND TAP SIGHT HOLES	9/28 BWT SEND TO NEXT OP	9/27	AK
620	APPLY COATINGS (BARREL ACTION)		10/3	HP
	(BOLT)		10/3	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-10-01	AK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-10-01	AK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-10-01	AK
	D) OIL FIRING PIN ASSEMBLY		10-10-01	AK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>6.0</u> <u>6.0</u>	10-18-01	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-18-01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	10-18-01	DA
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		11-6-01	AC
	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	PASS FAIL	10-16-01	AC
	A) MALFUNCTIONS	PASS FAIL ^{OH} after firing	10-16-01	AC
	B) PIERCED PRIMERS	PASS FAIL	10-16-01	AC
645	INSPECT FOR LIVE AMMO		10-16-01	AC
655	FINAL INSPECTION A) HEADSPACE		11-6-01	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.31</u> <u>2.26</u> <u>2.31</u> <u>2.30</u>	10-18-01	DA
	C) FUNCTION		11-6-01	AC
660	PACK		10-3-01	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E 696 1561

DATE 10/3/01

TESTER DTA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.64		2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.67		2.76	
PULL #3	2.60	2.75		2.75	
PULL #4	2.74	2.81		2.71	
PULL #5	2.76	2.46		2.75	
TOTAL	1314	1333		1330	
AVG.	2.62	2.66		2.66	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.15		
PULL #2	3.11	3.00		
PULL #3	3.12	3.17		
PULL #4	3.00	3.16		
PULL #5	3.02	3.12		
TOTAL	1534	1560		
AVG.	3.06	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.20		4.11
PULL #2	4.09	4.26		4.33
PULL #3	4.00	4.28		4.26
PULL #4	3.94	4.20		4.20
PULL #5	4.12	4.21		4.21
TOTAL	2025	2115		2111
AVG.	4.05	4.23		

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6761561
17 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.02
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0204
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0285685

THE AMP FOR THIS RIFLE IS: .9562

CENTROIDAL DISTANCES

0 TO 1	.440542
1 TO 2	.354239
1 TO 3	.799791
1 TO 4	.413621
1 TO 5	.696604

3 5
2 4 <----POA
1

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .441

MIN RADIUS : .231

MEAN RADIUS : .887

MAX RADIUS : 1.722

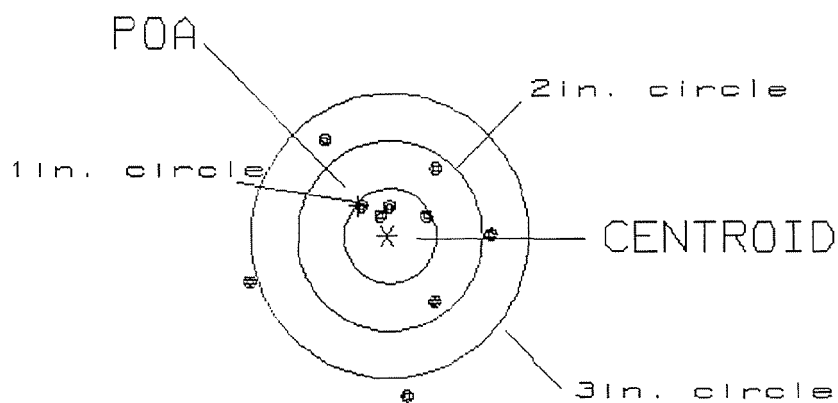
CENTROID X : .309

CENTROID Y : -.314

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CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.65

4

VS= 2.73

6

GS= 2.88

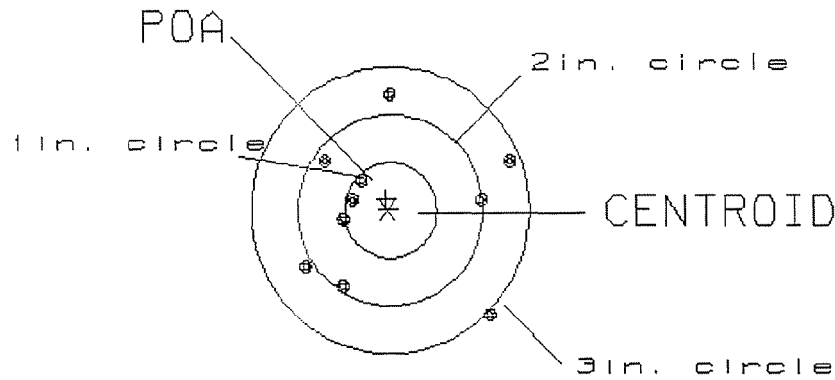
8

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .113
 MIN RADIUS : .405
 MEAN RADIUS : .925
 MAX RADIUS : 1.574
 CENTROID X : .018
 CENTROID Y : -.112

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CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.14

3

VS= 2.26

6

GS= 2.54

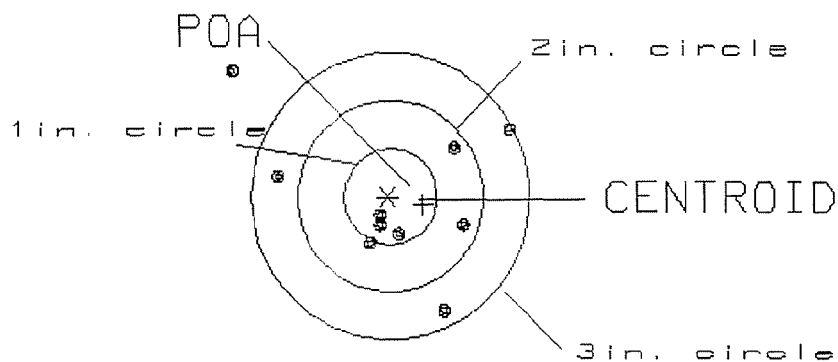
9

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .393
 MIN RADIUS : .236
 MEAN RADIUS : .929
 MAX RADIUS : 2.210
 CENTROID X : -.383
 CENTROID Y : .087

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CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.00

3

VS= 2.48

6

GS= 3.42

9

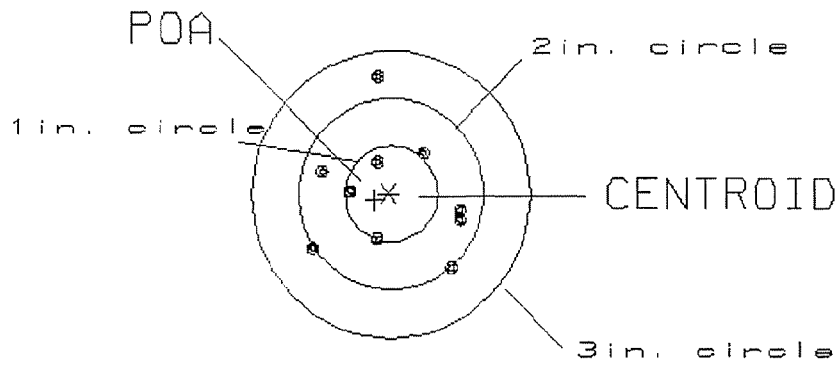
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .163
 MIN RADIUS : .412
 MEAN RADIUS : .760
 MAX RADIUS : 1.209
 CENTROID X : .148
 CENTROID Y : .067

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CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.59

2

VS= 2.01

6

GS= 2.17

10

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .256

MIN RADIUS : .542

MEAN RADIUS : 1.280

MAX RADIUS : 2.482

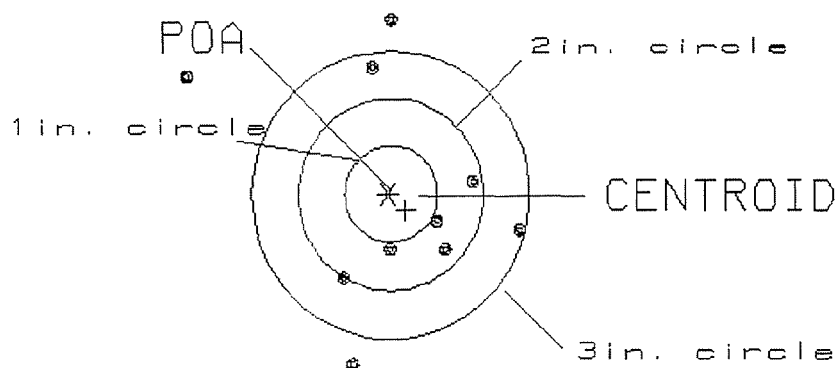
CENTROID X : -.192

CENTROID Y : .170

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CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.53

0

VS= 3.67

4

GS= 3.85

7