

UPC



E6374675

ISSUED IN CHARGE

ORDER NO. 25705

BARREL LENGTH 24"

CAPACITY * 6

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6374675
4 Nov 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.254333
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .073
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .264602

THE AMR FOR THIS RIFLE IS: .9693

CENTROIDAL DISTANCES

0 TO 1	.486483
1 TO 2	.587729
1 TO 3	.448759

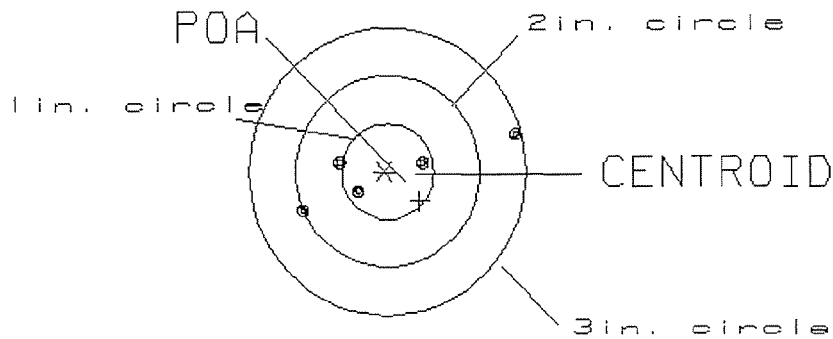
1
3 +2 <----POA

PATTERN #: 1
 POA TO CENTROID: .487
 MIN RADIUS : .384
 MEAN RADIUS : .764
 MAX RADIUS : 1.489
 CENTROID X : -.379
 CENTROID Y : .305

4 Nov 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6374675.1

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 2.38

3

VS= .88

3

GS= 2.54

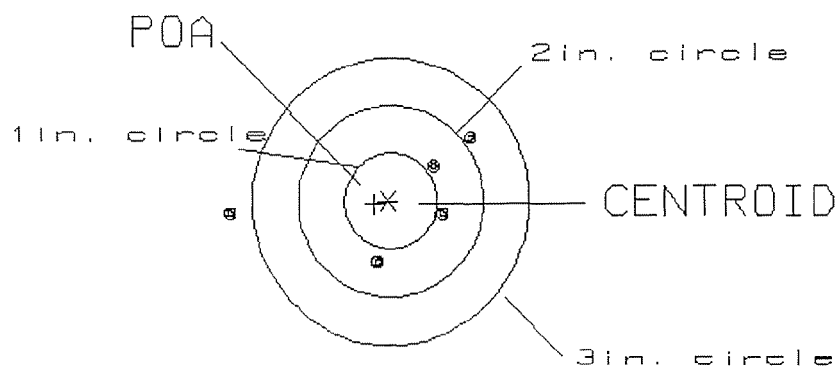
5

PATTERN #: 2
 POA TO CENTROID: .146
 MIN RADIUS : .578
 MEAN RADIUS : .945
 MAX RADIUS : 1.792
 CENTROID X : .142
 CENTROID Y : .033

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CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 2.66

0

VS= 1.32

3

GS= 2.77

4

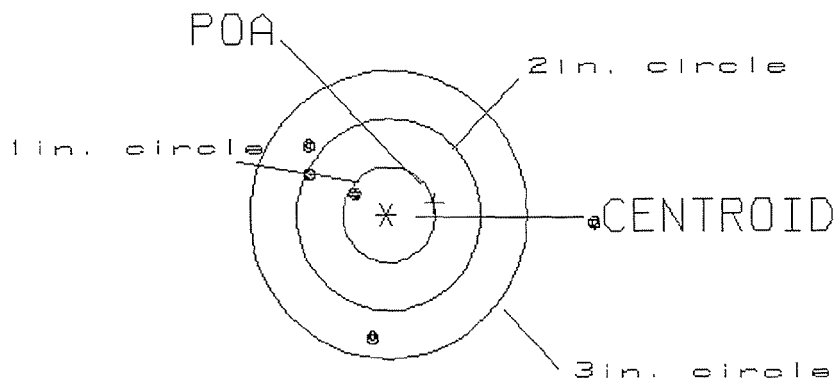
PATTERN #: 3

POA TO CENTROID: .540
 MIN RADIUS : .444
 MEAN RADIUS : 1.199
 MAX RADIUS : 2.243
 CENTROID X : -.526
 CENTROID Y : -.119

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CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 3.10

1

VS= 1.95

2

GS= 3.18

4

ISRAELI GUNS

CONTRACT # DAAE20-97-C-0182

GUN SERIAL # E 6374675

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) SAFETY ON FORCE	<u>5</u> <u>6</u> <u>6</u>	10-29-97	CR
CONT.	G) SAFETY OFF FORCE	<u>3</u> <u>3</u> <u>3</u>	10-29-97	CR
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT	<u>.022</u> <u>.022</u> <u>.023</u>	10-29-97	CR
	J) ASSEMBLE STOCK		10-23-97	CR
	K) ASSEMBLE SWIVEL STUDS		11/10/97	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-23-97	CR
	M) IRON SIGHT ALIGNMENT		10-23-97	CR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-23-97	CR
640	GALLERY TEST AND TARGET	L-90 R-60	11-4-97	DB
	A) MALFUNCTIONS		11-4-97	
	B) PIERCED PRIMERS		11-4-97	
645	INSPECT FOR LIVE AMMO		11-4-97	DB TM
655	FINAL INSPECTION A) HEADSPACE		11/10/97	RP
	B) TRIGGER PULL	<u>2.48</u> <u>2.45</u> <u>2.51</u> <u>2.45</u> <u>2.51</u>	11/4/97	WS
	C) FUNCTION		11/10/97	RP
660	PACK			

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6374675

DATE 10-17-97

TESTER TM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.31	2.36	2.36	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.29	2.37	
PULL #3	2.51	2.38	2.38	
PULL #4	2.38	2.41	2.32	
PULL #5	2.55	2.30	2.35	
TOTAL	12.20	11.74	11.78	
AVG.	2.44	2.34	2.35	

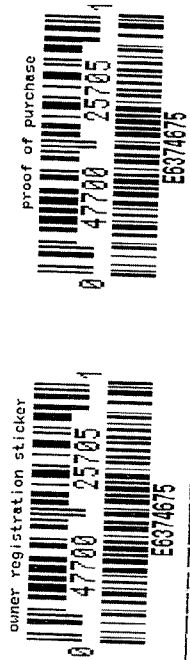
	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.16	3.12	
PULL #2	3.13	3.13	
PULL #3	3.01	2.91	
PULL #4	3.18	3.01	
PULL #5	3.19	3.19	
TOTAL	15.67	15.44	
AVG.	3.13	3.08	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.99	3.94		4.14
PULL #2	3.96	3.96		4.16
PULL #3	3.96	3.95		4.22
PULL #4	3.90	3.93		3.97
PULL #5	3.98	3.94		4.12
TOTAL	19.79	19.72		20.61
AVG.	3.95	3.94		4.12

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



Do Not Use

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VERY IMPORTANT
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ATTACHED TO ASSURE
SAFE USE OF THIS
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