

~~SECRET~~
E670 3410

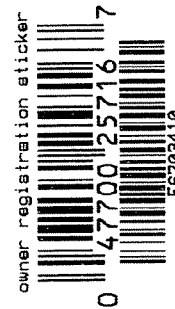
M2400121215

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

DOCUMENT ENVELOPE ASSEMBLY:

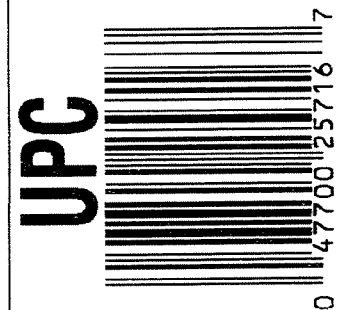
- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

E6703410



GUN SERIAL # E6703410

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-23-01	CK
600	PROOF		4-22-01	11
607	CHECK HEADSPACE		4-22-01	CK
610	DIS-ASSEMBLE GUN		4-22-01	CK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		4-22-01	CK
615	ROLLMARK CALIBER		4-22-01	CK
617	DRILL AND TAP SIGHT HOLES		4-22-01	CK
618	POLISH BARREL		4-22-01	GD
620	APPLY COATINGS (BARREL ACTION)		4-20-01	TH
	(BOLT)		4-20-01	TH
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-20-01	CK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-20-01	CK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-20-01	CK
	D) OIL FIRING PIN ASSEMBLY		4-20-01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		4-20-01	CK

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>8⁰</u> <u>7²⁵</u> <u>7¹⁵</u>	4/30/01	RH
CONT.	G) SAFETY OFF FORCE	<u>3⁰</u> <u>3⁰</u> <u>3⁰</u>	4/30/01	RH
	H) TRIGGER PULL TEST AND RETAINABILITY		4/30/01	RH
	I) FIRING PIN INDENT	<u>026</u> <u>022</u> <u>024</u>	4/30/01	RH
	J) ASSEMBLE STOCK		4/30/01	RH
	K) ASSEMBLE SWIVEL STUDS		8-16/01	RH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8/14/01	RH
	M) IRON SIGHT ALIGNMENT		8/16/01	RH
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8/16/01	RH
640	GALLERY TEST AND TARGET		4/24/01	RH
	A) MALFUNCTIONS		4/24/01	RH
	B) PIERCED PRIMERS		4/24/01	RH
645	INSPECT FOR LIVE AMMO		4/24/01	RH
655	FINAL INSPECTION A) HEADSPACE		8/14/01	RH
	B) TRIGGER PULL	<u>2.68</u> <u>2.63</u> <u>2.52</u> <u>2.63</u> <u>2.68</u>	4/30/01	RH
	C) FUNCTION		4/30/01	RH
660	PACK		8/16/01	RH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E670 3410

DATE 3/31/01

TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.68	2.63	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.62	2.62	2.73	
PULL #3	2.70	2.55	2.74	
PULL #4	2.64	2.68	2.65	
PULL #5	2.70	2.41	2.64	
TOTAL	1333	1294	1339	
AVG.	2.66	2.58	2.67	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.01	3.00	
PULL #2	3.07	3.00	
PULL #3	3.10	3.07	
PULL #4	3.04	3.00	
PULL #5	3.05	3.01	
TOTAL	1527	1508	
AVG.	3.05	3.01	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.24		4.14
PULL #2	4.15	4.26		4.11
PULL #3	4.17	4.25		4.14
PULL #4	4.17	4.14		4.14
PULL #5	4.20	4.14		4.05
TOTAL	2079	2103		2058
AVG.	4.15	4.20		4.11

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703410
24 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .421573

THE AMR FOR THIS RIFLE IS: 1.082

CENTROIDAL DISTANCES

0 TO	1	.58957
1 TO	2	.12657
1 TO	3	.759539
1 TO	4	.415217
1 TO	5	.0883912

3 + <----POA
4
5¹

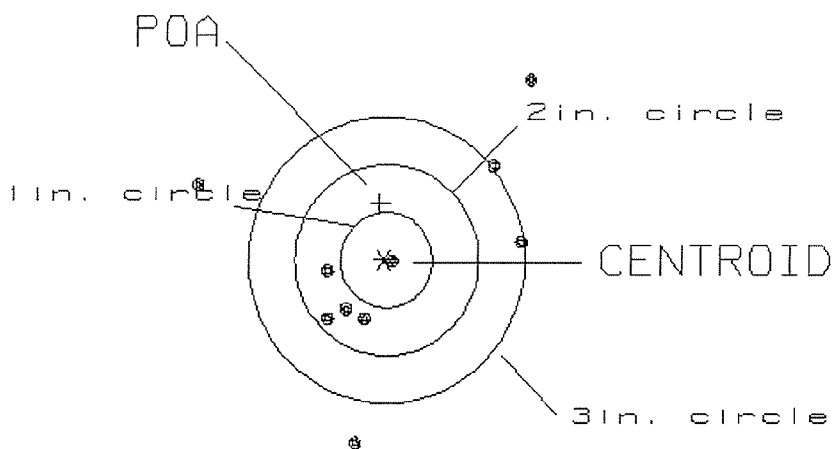
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .590
 MIN RADIUS : .088
 MEAN RADIUS : 1.261
 MAX RADIUS : 2.473
 CENTROID X : .043
 CENTROID Y : -.588

24 Apr 2001

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CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.58
 VS= 3.87
 GS= 4.29

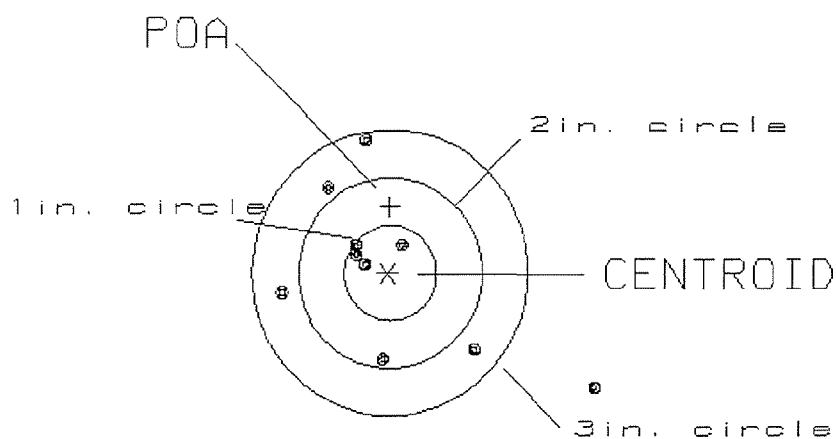
1
 5
 6

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .696
 MIN RADIUS : .284
 MEAN RADIUS : .994
 MAX RADIUS : 2.574
 CENTROID X : -.023
 CENTROID Y : -.696

24 Apr 2001

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CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.43

3

VS= 2.62

5

GS= 3.67

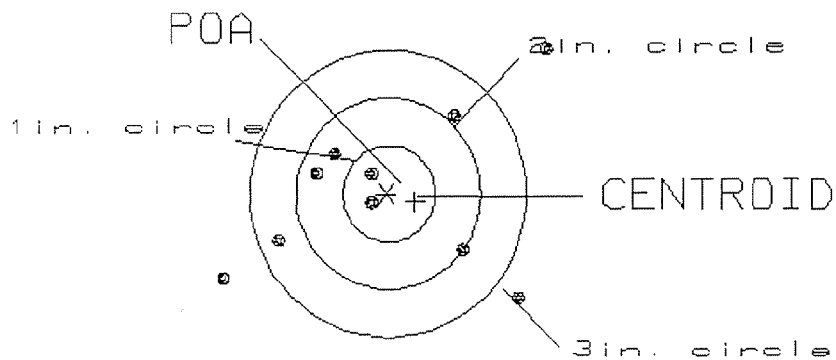
9

PATTERN #: 030
 POA TO CENTROID: .322
 MIN RADIUS : .238
 MEAN RADIUS : 1.146
 MAX RADIUS : 2.290
 CENTROID X : -.311
 CENTROID Y : .084

24 Apr 2001

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CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.49

2

VS= 2.60

5

GS= 4.23

7

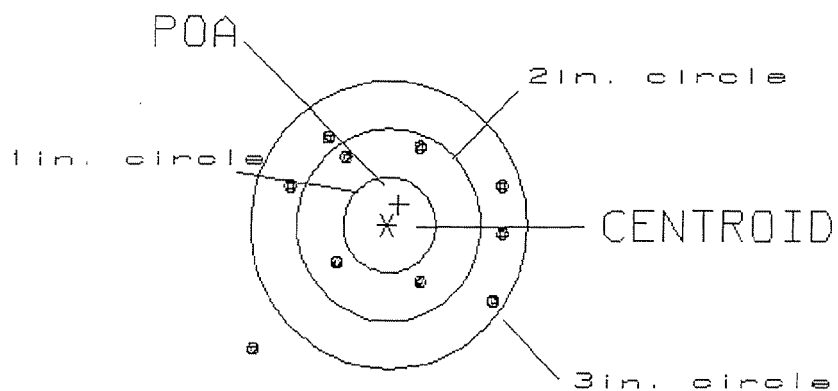
PATTERN #: 4

POA TO CENTROID: .248
 MIN RADIUS : .704
 MEAN RADIUS : 1.121
 MAX RADIUS : 1.960
 CENTROID X : -.131
 CENTROID Y : -.211

24 Apr 2001

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CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.67
 VS= 2.19
 GS= 3.16

0
 4
 9

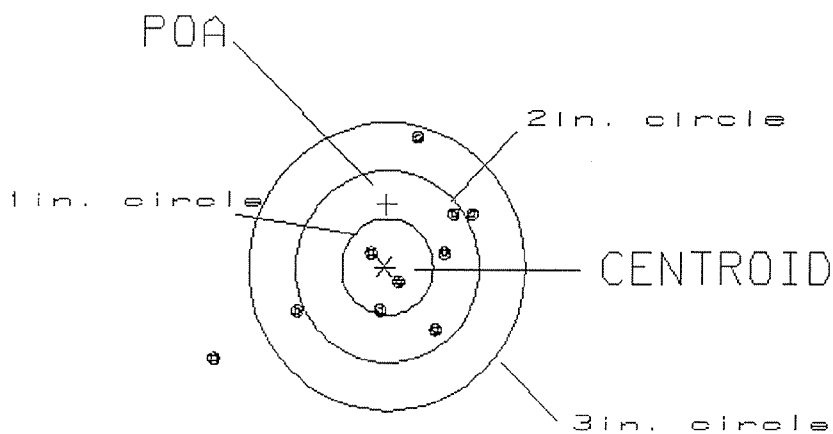
PATTERN #: 5

POA TO CENTROID: .650
 MIN RADIUS : .195
 MEAN RADIUS : .890
 MAX RADIUS : 2.147
 CENTROID X : -.020
 CENTROID Y : -.650

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CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.85
 VS= 2.32
 GS= 3.21

2
 6
 9