

E670 3433

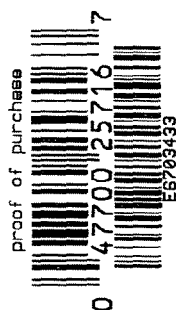


**MODEL 700™ M24**  
**BOLT ACTION CENTERFIRE RIFLE**  
**24" BARREL 7.62 NATO**

**DOCUMENT ENVELOPE ASSEMBLY:**

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

**46 FORM 1444**

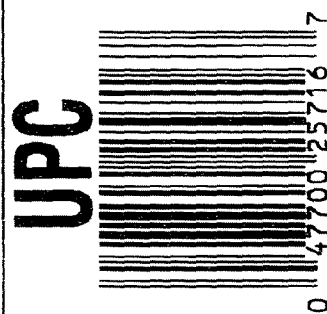


**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**E6703433**



GUN SERIAL # E6703433

| OP #         | OPERATION NAME                                                 | READINGS | DATE | INITIAL |
|--------------|----------------------------------------------------------------|----------|------|---------|
| 575 &<br>580 | ASSEMBLE ACTION<br>AND STOCK                                   |          | 3/01 | CK      |
| 600          | PROOF                                                          |          |      |         |
| 607          | CHECK HEADSPACE                                                |          |      |         |
| 610          | DIS-ASSEMBLE GUN                                               |          |      |         |
| 612          | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         |          |      |         |
| 615          | ROLLMARK CALIBER                                               |          |      |         |
| 617          | DRILL AND TAP<br>SIGHT HOLES                                   |          | 3/01 | WA      |
| 618          | POLISH BARREL                                                  |          |      |         |
| 620          | APPLY COATINGS<br>(BARREL ACTION)                              |          |      |         |
|              | (BOLT)                                                         |          |      |         |
| 625          | FINAL ASSEMBLY                                                 |          | "    | "       |
|              | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |          |      |         |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |          | "    | "       |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |          | "    | "       |
|              | D) OIL FIRING PIN ASSEMBLY                                     |          |      | CK      |
|              | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         |          | 3/01 | CK      |

| OP #  | OPERATION NAME                                                        | READINGS    |             |                                  | DATE    | INITIAL |
|-------|-----------------------------------------------------------------------|-------------|-------------|----------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE                                                    | <u>6.0</u>  | <u>5.0</u>  | <u>5.0</u>                       | 3/25    | Tjd     |
| CONT. | G) SAFETY OFF FORCE                                                   | <u>3.0</u>  | <u>4.0</u>  | <u>4.0</u>                       | 3/25    | Tjd     |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |             |             |                                  |         |         |
|       | I) FIRING PIN INDENT                                                  | <u>.021</u> | <u>.023</u> | <u>.021</u>                      | 3/25    | Tjd     |
|       | J) ASSEMBLE STOCK                                                     |             |             |                                  |         | CK      |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                           |             |             |                                  | 3/26/01 | Rep     |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                              |             |             |                                  |         |         |
|       | M) IRON SIGHT<br>ALIGNMENT                                            |             |             |                                  |         |         |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER |             |             |                                  |         |         |
| 640   | GALLERY TEST AND<br>TARGET                                            |             |             |                                  | 3-21-01 | Rw      |
|       | A) MALFUNCTIONS                                                       |             |             |                                  | 3-21-01 | Rw      |
|       | B) PIERCED PRIMERS                                                    |             |             |                                  | 3-21-01 | Rw      |
| 645   | INSPECT FOR LIVE AMMO                                                 |             |             |                                  | 3-21-01 | Rw      |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                      |             |             |                                  | 3/26/01 |         |
|       | B) TRIGGER PULL                                                       | <u>288</u>  | <u>295</u>  | <u>289</u> <u>285</u> <u>293</u> | 3-25    | Tjd     |
|       | C) FUNCTION                                                           |             |             |                                  | 3/26/01 |         |
| 660   | PACK                                                                  |             |             |                                  | 3/26/01 |         |

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703433

DATE 2-8-01

TESTER DA

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.37             | 2.64                     |                                | 2.33 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.51             | 2.57                     |                                | 2.26 |                                                                        |
| PULL #3 | 2.38             | 2.62                     |                                | 2.23 |                                                                        |
| PULL #4 | 2.30             | 2.62                     |                                | 2.26 |                                                                        |
| PULL #5 | 2.27             | 2.51                     |                                | 2.25 |                                                                        |
| TOTAL   | 1183             | 1296                     |                                | 1133 |                                                                        |
| AVG.    | 2.36             | 2.59                     |                                | 2.26 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.06             | 3.04                     |  |          |
| PULL #2 | 3.06             | 3.02                     |  |          |
| PULL #3 | 3.08             | 3.00                     |  |          |
| PULL #4 | 2.97             | 3.00                     |  |          |
| PULL #5 | 3.11             | 3.02                     |  |          |
| TOTAL   | 1528             | 1508                     |  |          |
| AVG.    | 3.05             | 3.01                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.03             | 4.01                     |                                | 4.25                                 |
| PULL #2 | 4.02             | 3.89                     |                                | 4.26                                 |
| PULL #3 | 4.15             | 3.88                     |                                | 4.06                                 |
| PULL #4 | 4.00             | 3.90                     |                                | 4.19                                 |
| PULL #5 | 4.15             | 3.85                     |                                | 4.17                                 |
| TOTAL   | 2035             | 1953                     |                                | 2093                                 |
| AVG.    | 4.07             | 3.90                     |                                | 4.18                                 |

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703433  
24 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0054  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.04  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0403629

THE AMR FOR THIS RIFLE IS: .9912

# CENTROIDAL DISTANCES

|   |    |   |          |
|---|----|---|----------|
| 0 | TO | 1 | .103942  |
| 1 | TO | 2 | .0117047 |
| 1 | TO | 3 | .31543   |
| 1 | TO | 4 | .144586  |
| 1 | TO | 5 | .315127  |

5 4<sup>2</sup> <----POA  
3

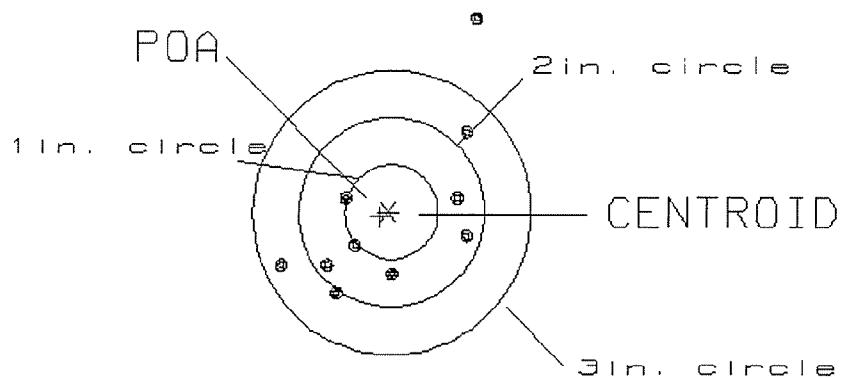
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .104  
 MIN RADIUS : .465  
 MEAN RADIUS : .987  
 MAX RADIUS : 2.266  
 CENTROID X : .090  
 CENTROID Y : .052

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/e6703433

# CENTERFIRE PATTERN # 1



# OF SHOTS= 10

# IN CIRCLE

HS= 2.16

1

VS= 2.90

6

GS= 3.37

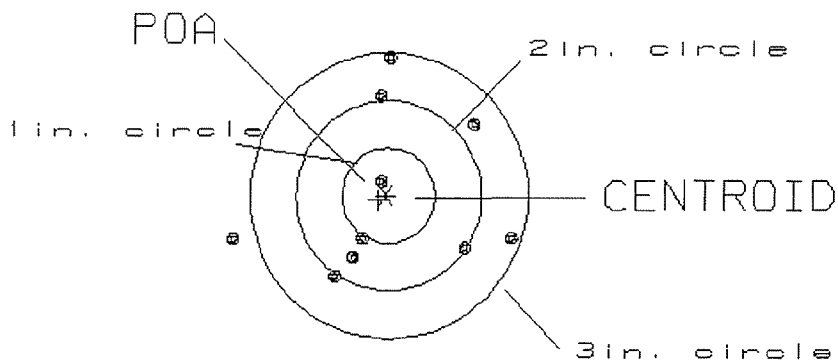
9

PATTERN #: 2  
 POA TO CENTROID: .092  
 MIN RADIUS : .206  
 MEAN RADIUS : 1.042  
 MAX RADIUS : 1.765  
 CENTROID X : .079  
 CENTROID Y : .048

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/ed703433

# CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 3.03

1

VS= 2.34

3

GS= 3.03

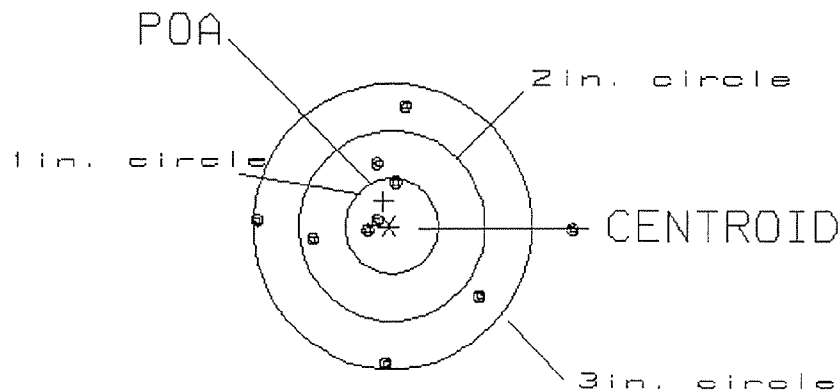
9

PATTERN #: ☐ 3 ☐  
 POA TO CENTROID: .269  
 MIN RADIUS : .170  
 MEAN RADIUS : .985  
 MAX RADIUS : 1.908  
 CENTROID X : .060  
 CENTROID Y : -.262

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/e0703433

# CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 3.41

3

VS= 2.74

5

GS= 3.41

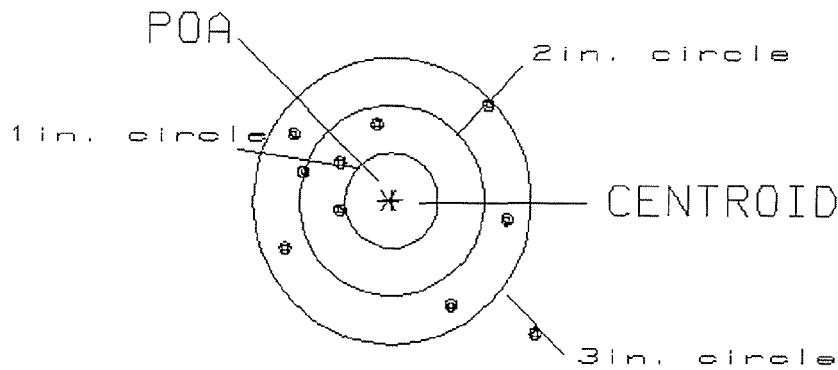
8

PATTERN #: ☐ 4 ☐  
 POA TO CENTROID: .043  
 MIN RADIUS : .534  
 MEAN RADIUS : 1.162  
 MAX RADIUS : 2.097  
 CENTROID X : -.042  
 CENTROID Y : -.007

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/0703433

# CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 2.73  
 US= 2.39  
 GS= 3.40

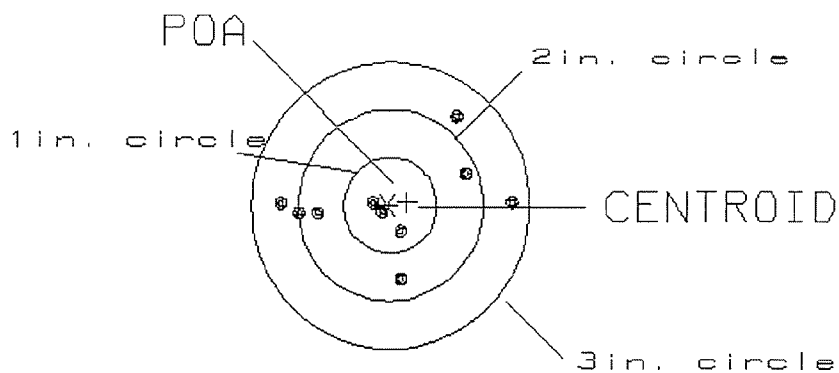
0  
 3  
 9

PATTERN #: 5  
 POA TO CENTROID: .216  
 MIN RADIUS : .131  
 MEAN RADIUS : .780  
 MAX RADIUS : 1.351  
 CENTROID X : -.214  
 CENTROID Y : -.031

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/e0703433

# CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 2.50

3

VS= 1.79

7

GS= 2.50

10

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703433  
22 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0278

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .336

THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .337148

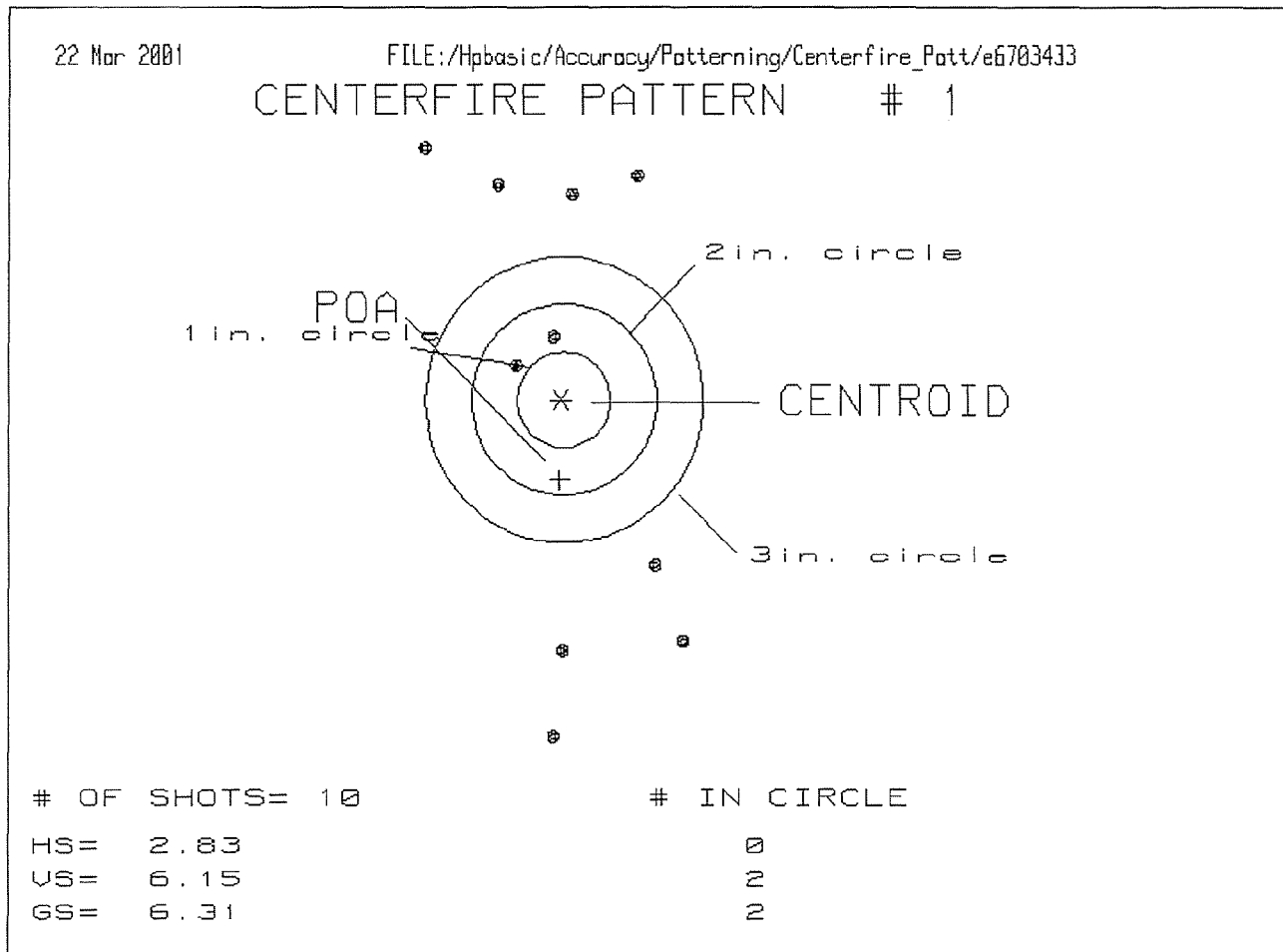
THE AMR FOR THIS RIFLE IS: 1.309

# CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .838117 |
| 1 TO | 2 | .792063 |
| 1 TO | 3 | .665586 |
| 1 TO | 4 | .263638 |
| 1 TO | 5 | .821862 |

1  
4  
3  
5 4 <----POA

PATTERN #: ☐ 1 ☐  
 POA TO CENTROID: .838  
 MIN RADIUS : .626  
 MEAN RADIUS : 2.239  
 MAX RADIUS : 3.517  
 CENTROID X : .014  
 CENTROID Y : .838

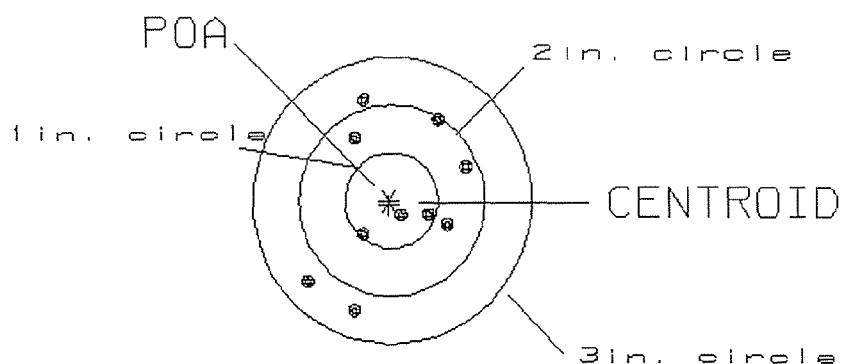


PATTERN #: ☐ 2 ☐  
 POA TO CENTROID: .046  
 MIN RADIUS : .142  
 MEAN RADIUS : .784  
 MAX RADIUS : 1.250  
 CENTROID X : .004  
 CENTROID Y : .046

22 Mar 2001

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# CENTERFIRE PATTERN # 2



# OF SHOTS= 10

# IN CIRCLE

HS= 1.75

3

VS= 2.25

7

GS= 2.25

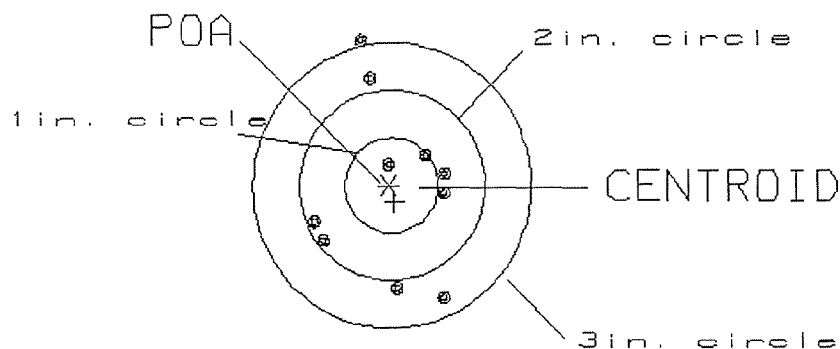
10

PATTERN #: ☐ 3 ☐  
 POA TO CENTROID: .189  
 MIN RADIUS : .187  
 MEAN RADIUS : .860  
 MAX RADIUS : 1.539  
 CENTROID X : -.064  
 CENTROID Y : .177

22 Mar 2001

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# CENTERFIRE PATTERN # 3



# OF SHOTS= 10

# IN CIRCLE

HS= 1.40

2

VS= 2.72

6

GS= 2.89

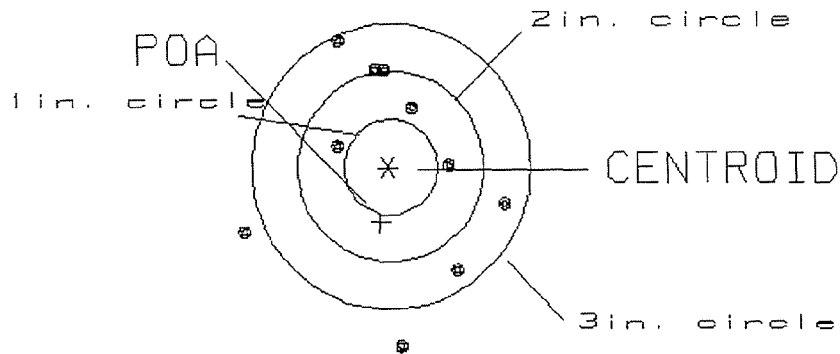
9

PATTERN #: ☐ 4 ☐  
 POA TO CENTROID: .587  
 MIN RADIUS : .591  
 MEAN RADIUS : 1.154  
 MAX RADIUS : 1.891  
 CENTROID X : .077  
 CENTROID Y : .582

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire\_Patt/e6703433

# CENTERFIRE PATTERN # 4



# OF SHOTS= 10

# IN CIRCLE

HS= 2.78

0

VS= 3.19

3

GS= 3.28

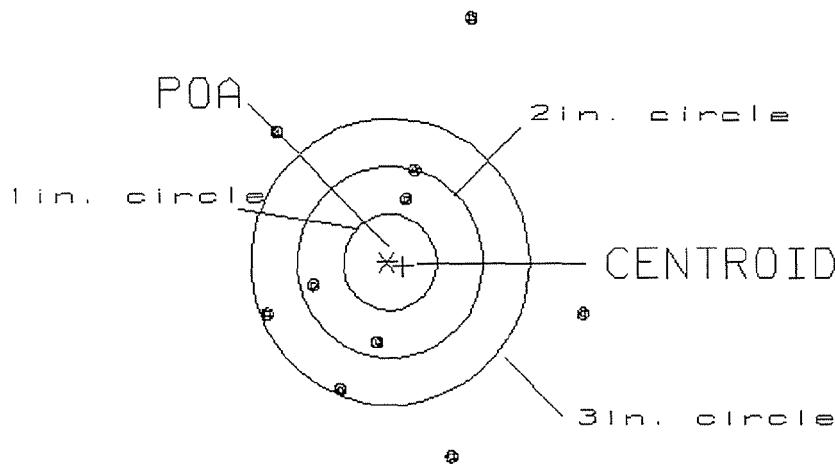
8

PATTERN #: 5  
 POA TO CENTROID: .174  
 MIN RADIUS : .696  
 MEAN RADIUS : 1.506  
 MAX RADIUS : 2.679  
 CENTROID X : -.170  
 CENTROID Y : .037

22 Mar 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire\_Patt/e6703433

# CENTERFIRE PATTERN # 5



# OF SHOTS= 10

# IN CIRCLE

HS= 3.40  
 VS= 4.59  
 GS= 4.59

0  
 4  
 6