

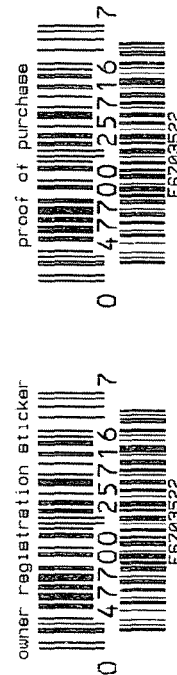
E 670 35 22

M2400122437

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

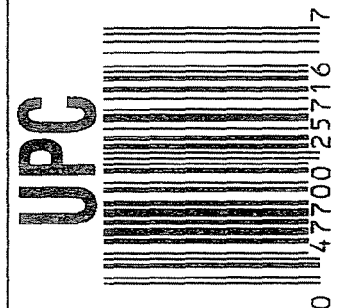
DOCUMENT ENVELOPE ASSEMBLY:
- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

E6703522



GUN SERIAL #

E 670 35 22

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-22-01	CK
600	PROOF		"	CK
607	CHECK HEADSPACE		"	CK
610	DIS-ASSEMBLE GUN		"	CK
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		4-22-01	RC
615	ROLLMARK CALIBER		4-22-01	RH
617	DRILL AND TAP SIGHT HOLES		4-22-01	RH
618	POLISH BARREL		4-22-01	GD
620	APPLY COATINGS (BARREL ACTION)		4-22-01	TH
	(BOLT)		4-22-01	TH
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5-1-01	RH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-1-01	RH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-1-01	RH
	D) OIL FIRING PIN ASSEMBLY		5-1-01	RH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		5-1-01	RH

OP #	OPERATION NAME	READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	<u>6⁰</u>	<u>5⁵⁰</u>	<u>5²⁵</u>	5/4/01	eff		
CONT.								
	G) SAFETY OFF FORCE	<u>3⁰</u>	<u>3²⁵</u>	<u>3⁵⁰</u>	5/4/01	eff		
	H) TRIGGER PULL TEST AND RETAINABILITY					eff		
	I) FIRING PIN INDENT	<u>.024</u>	<u>.026</u>	<u>.026</u>	5/4/01			
	J) ASSEMBLE STOCK				4-23-01	C/K		
	K) ASSEMBLE SWIVEL STUDS				10-29-00	eff		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10-29-00	eff		
	M) IRON SIGHT ALIGNMENT				10-29-00	eff		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10-29-00	eff		
640	GALLERY TEST AND TARGET				4/23/01	eff		
	A) MALFUNCTIONS				4/23/01	eff		
	B) PIERCED PRIMERS				4/23/01	eff		
645	INSPECT FOR LIVE AMMO				4/23/01	eff		
655	FINAL INSPECTION A) HEADSPACE				10/29/01	eff		
	B) TRIGGER PULL	<u>2.43</u>	<u>2.39</u>	<u>2.37</u>	<u>2.37</u>	<u>2.43</u>	5/4/01	eff
	C) FUNCTION				10-29-01	eff		
660	PACK				10/29/01	eff		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703522

DATE 4/23/01

TESTER DR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	220	222	213	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	220	222	211	
PULL #3	224	223	214	
PULL #4	239	225	216	
PULL #5	239	225	217	
TOTAL	1142	1117	1071	
AVG.	228	223	214	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	321	320		
PULL #2	323	321		
PULL #3	327	311		
PULL #4	322	314		
PULL #5	320	314		
TOTAL	1613	1580		
AVG.	322	316		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	433	416		4.02
PULL #2	431	414		4.00
PULL #3	408	421		4.03
PULL #4	427	423		4.00
PULL #5	426	423		398
TOTAL	2125	2097		2003
AVG.	425	419		4.00

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703522
30 Apr 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0978
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .141023

THE AMR FOR THIS RIFLE IS: 1.27

CENTROIDAL DISTANCES

0 TO	1	.469161
1 TO	2	.332758
1 TO	3	.485454
1 TO	4	.543383
1 TO	5	.607001

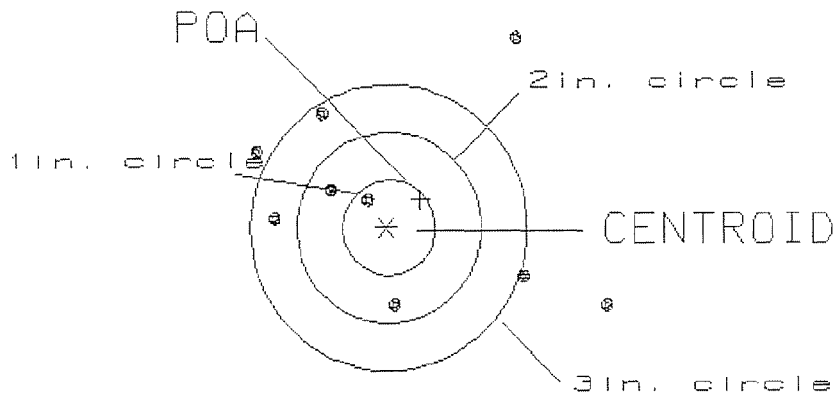
3
+⁵/₄ <----POA
1 2

PATTERN #: 010
 POA TO CENTROID: .469
 MIN RADIUS : .364
 MEAN RADIUS : 1.549
 MAX RADIUS : 2.766
 CENTROID X : -.364
 CENTROID Y : -.296

30 Apr 2001

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CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.83

1

VS= 4.60

3

GS= 5.11

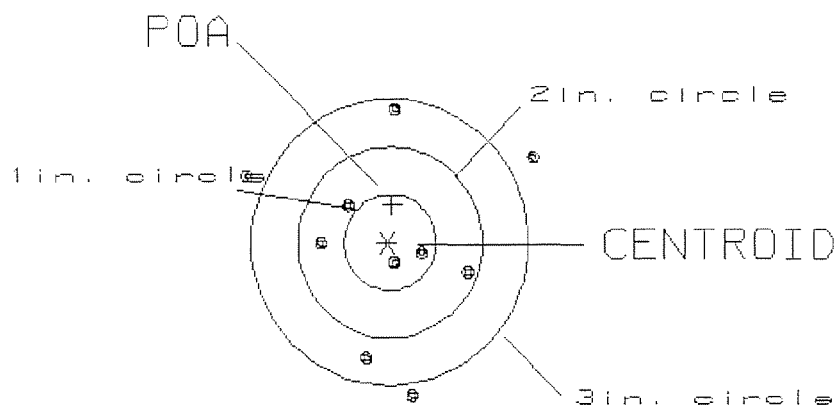
5

PATTERN #: F 2 E
 POA TO CENTROID: .396
 MIN RADIUS : .207
 MEAN RADIUS : 1.059
 MAX RADIUS : 1.801
 CENTROID X : -.046
 CENTROID Y : -.394

30 Apr 2001

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CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.13

2

VS= 3.01

5

GS= 3.14

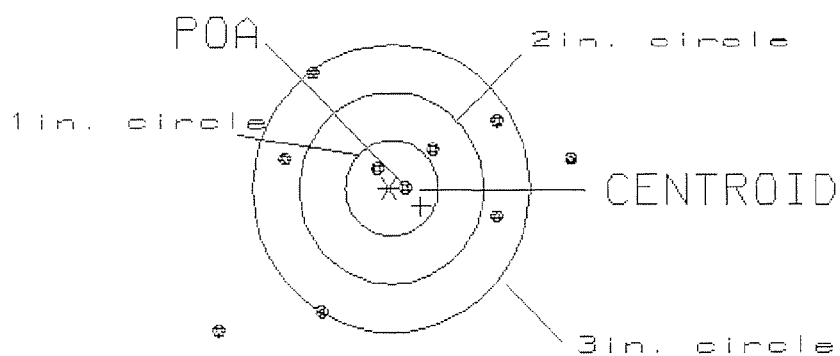
7

PATTERN #: E 3 E
 POA TO CENTROID: .391
 MIN RADIUS : .130
 MEAN RADIUS : 1.206
 MAX RADIUS : 2.449
 CENTROID X : -.343
 CENTROID Y : .189

30 Apr 2001

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CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.86

2

VS= 2.70

3

GS= 4.28

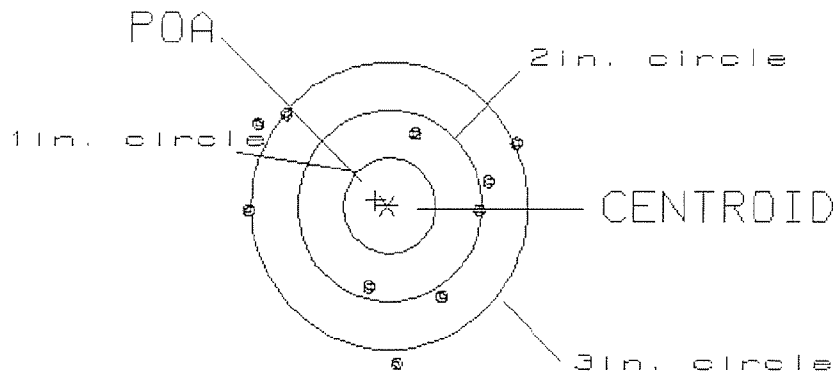
7

PATTERN #: 4
 POA TO CENTROID: .137
 MIN RADIUS : .769
 MEAN RADIUS : 1.256
 MAX RADIUS : 1.618
 CENTROID X : .124
 CENTROID Y : -.057

30 Apr 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/e6703522

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.91
 VS= 2.61
 GS= 3.00

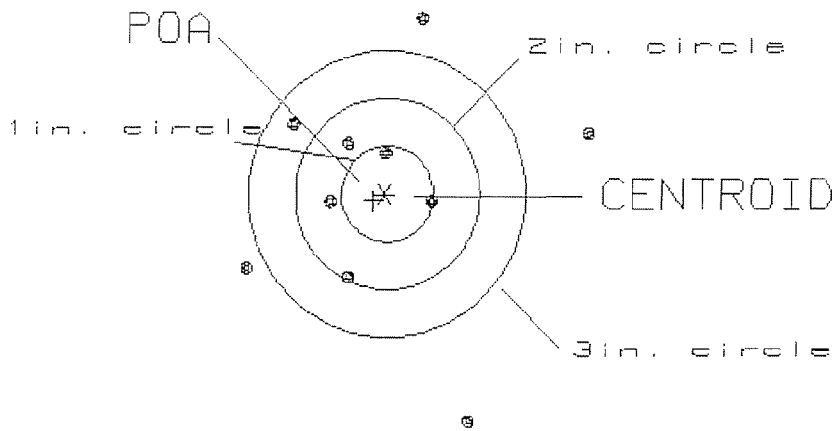
0
 3
 6

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .139
 MIN RADIUS : .452
 MEAN RADIUS : 1.278
 MAX RADIUS : 2.501
 CENTROID X : .121
 CENTROID Y : .069

30 Apr 2001

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CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.70
 VS= 4.19
 GS= 4.21

1
 5
 6