

E6703529

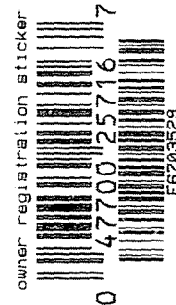
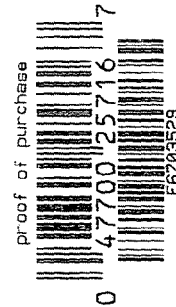
M2400122551

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

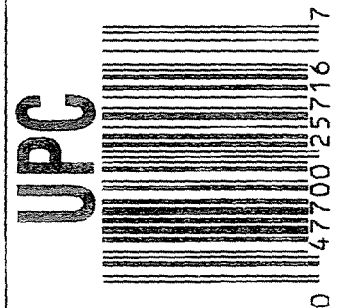


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

E6703529



AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. E6703529

DATE 5/21/01

TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	239	226		216	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	235	239		215	
PULL #3	232	236		211	
PULL #4	242	222		212	
PULL #5	232	232		214	
TOTAL	1180	1155		1070	
AVG.	236	231		214	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	318	311		
PULL #2	317	309		
PULL #3	315	312		
PULL #4	313	310		
PULL #5	314	319		
TOTAL	1577	1561		
AVG.	315	312		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	426	422		4.14
PULL #2	424	425		4.19
PULL #3	412	421		4.22
PULL #4	426	420		4.17
PULL #5	426	422		4.22
TOTAL	2114	2110		2094
AVG.	422	422		418

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6703529
5 Sep 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0864$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0354$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0933709$

THE AMR FOR THIS RIFLE IS: 1.133

CENTROIDAL DISTANCES

0 TO	1	.529854
1 TO	2	.508193
1 TO	3	.531989
1 TO	4	1.42962
1 TO	5	.591594

4 5
 $\oplus$ <----POA
 1

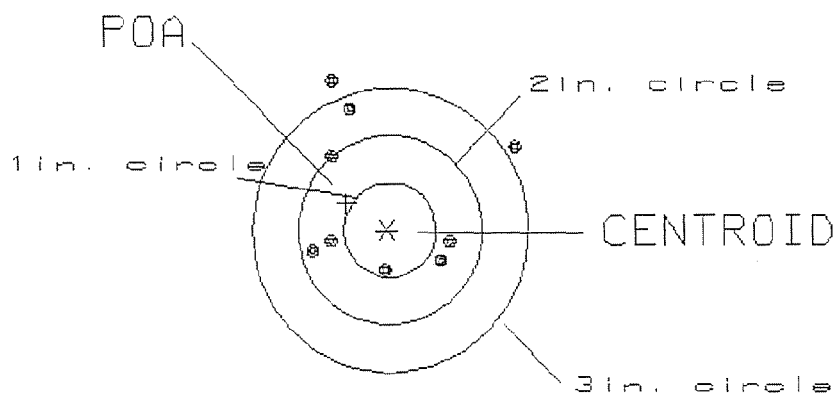
PATTERN #: 1

POA TO CENTROID: .529
 MIN RADIUS : .394
 MEAN RADIUS : 1.233
 MAX RADIUS : 3.501
 CENTROID X : .447
 CENTROID Y : -.283

5 Sep 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6703529

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.15
 VS= 5.03
 GS= 5.20

1
 6
 7

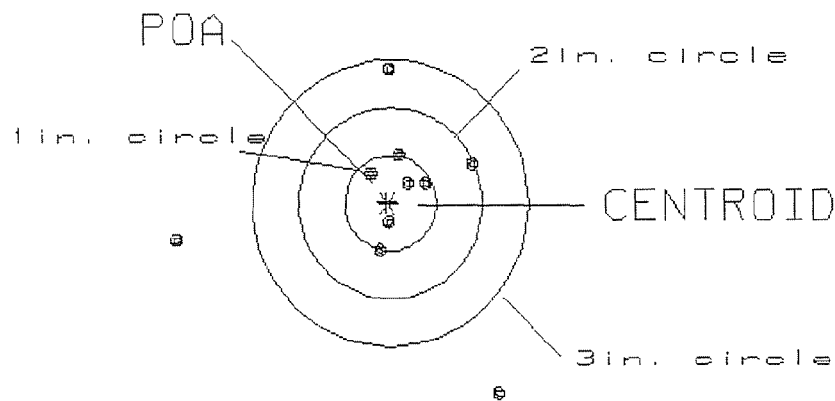
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .021
 MIN RADIUS : .194
 MEAN RADIUS : .942
 MAX RADIUS : 2.356
 CENTROID X : .019
 CENTROID Y : -.009

5 Sep 2001

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CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.50

4

VS= 3.48

7

GS= 3.86

8

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .012

MIN RADIUS : .314

MEAN RADIUS : 1.143

MAX RADIUS : 2.761

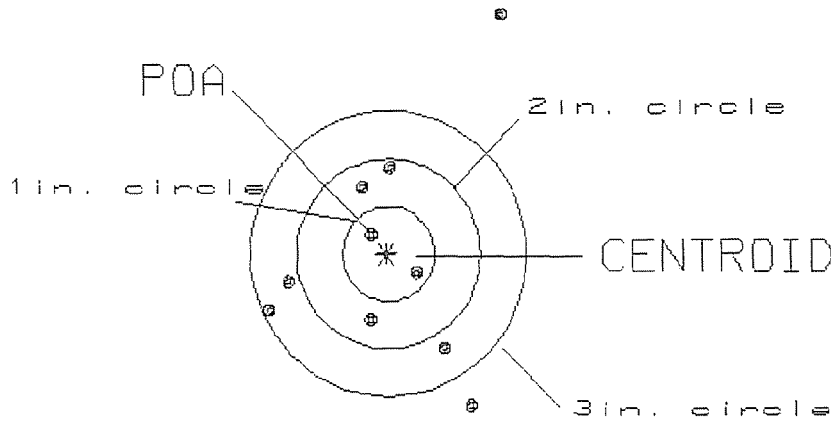
CENTROID X : -.009

CENTROID Y : -.009

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CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.51

2

VS= 4.07

5

GS= 4.08

8

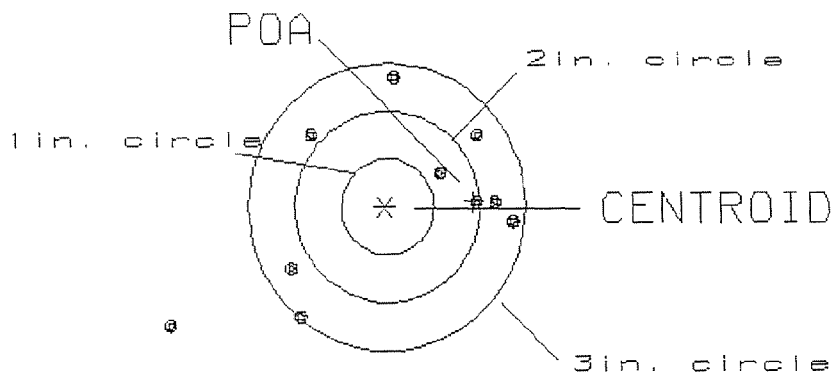
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .966
 MIN RADIUS : .676
 MEAN RADIUS : 1.322
 MAX RADIUS : 2.635
 CENTROID X : -.964
 CENTROID Y : -.053

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CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.67
 VS= 2.60
 GS= 3.84

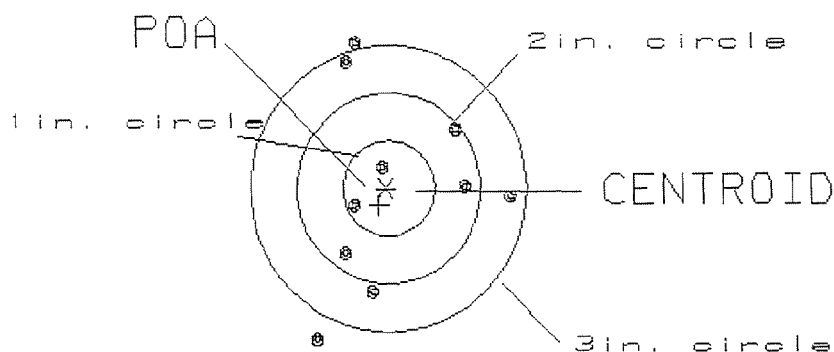
0
 1
 8

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .192
 MIN RADIUS : .233
 MEAN RADIUS : 1.024
 MAX RADIUS : 1.776
 CENTROID X : .075
 CENTROID Y : .177

5 Sep 2001

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CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.07

2

VS= 3.11

5

GS= 3.13

8

GUN SERIAL # E6703529

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		7/25/01	RTH
600	PROOF		7/25/01	RTH
607	CHECK HEADSPACE		7/25/01	RTH
610	DIS-ASSEMBLE GUN		7/25/01	RTH
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		7/26/01	AC
615	ROLLMARK CALIBER		7/26/01	RTH
617	DRILL AND TAP SIGHT HOLES		7/26/01	BT
618	POLISH BARREL		7/27/01	GP
620	APPLY COATINGS (BARREL ACTION)		8/1/01	TA
	(BOLT)		8/1/01	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8/15/01	RTH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8/15/01	RTH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8/15/01	RTH
	D) OIL FIRING PIN ASSEMBLY		8/15/01	RTH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		8/15/01	RTH

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	<u>5.5</u> <u>5.5</u> <u>6.0</u>	9/10/01	DA
CONT.				
	G) SAFETY OFF FORCE	<u>2.5</u> <u>2.5</u> <u>3.0</u>	9/10/01	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10-25-01	RL
	I) FIRING PIN INDENT	<u>.021</u> <u>.021</u> <u>.023</u>	9/10/01	DA
	J) ASSEMBLE STOCK		7/25/01	RL
	K) ASSEMBLE SWIVEL STUDS		10-25-01	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-25-01	RL
	M) IRON SIGHT ALIGNMENT		10-25-01	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-25-01	RL
640	GALLERY TEST AND TARGET		9/4	RL
	A) MALFUNCTIONS		9/4	RL
	B) PIERCED PRIMERS		9/4	RL
645	INSPECT FOR LIVE AMMO		9/4	RL
655	FINAL INSPECTION A) HEADSPACE		10-25-01	RL
	B) TRIGGER PULL	<u>2.36</u> <u>2.32</u> <u>2.32</u> <u>2.35</u> <u>2.31</u>	9/10/01	DA
	C) FUNCTION		10-25-01	RL
660	PACK		10-26-01	DA