

UPC

E6349857



ORDER NO. 25705

BARREL LENGTH 24"

CAPACITY * 6

* ROUNDS IN CHAMBER

ISRAELI GUNS

CONTRACT # DAAE20-97-C-0182

GUN SERIAL # E 6349857

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>4</u> <u>4</u> <u>4.5</u>	6-2-97	JW
CONT.	G) SAFETY OFF FORCE	<u>2.5</u> <u>2.5</u> <u>2.5</u>	6-2-97	JW
	H) TRIGGER PULL TEST AND RETAINABILITY		5/30/97	JW
	I) FIRING PIN INDENT	<u>32</u> <u>21.5</u> <u>20.5</u>	6/2/97	JW
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		6/29/97	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6/5/97	RP
	M) IRON SIGHT ALIGNMENT		6/5/97	RP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6/5/97	RP
640	GALLERY TEST AND TARGET	R 70 L 90	6/11/97	NF
	A) MALFUNCTIONS		"	NF
	B) PIERCED PRIMERS		"	NF
645	INSPECT FOR LIVE AMMO		6/11/97	JW
655	FINAL INSPECTION A) HEADSPACE		6/20/97	RP
	B) TRIGGER PULL	<u>2.44</u> <u>2.49</u> <u>2.52</u> <u>2.54</u> <u>2.39</u>	6/18/97	CK
	C) FUNCTION		6/20/97	RP
660	PACK			

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # E6349857
17 Jun 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.033$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.122667$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.127028$

THE AMR FOR THIS RIFLE IS: $.714$

CENTROIDAL DISTANCES

Ø TO 1	.256759
1 TO 2	.145165
1 TO 3	.266175

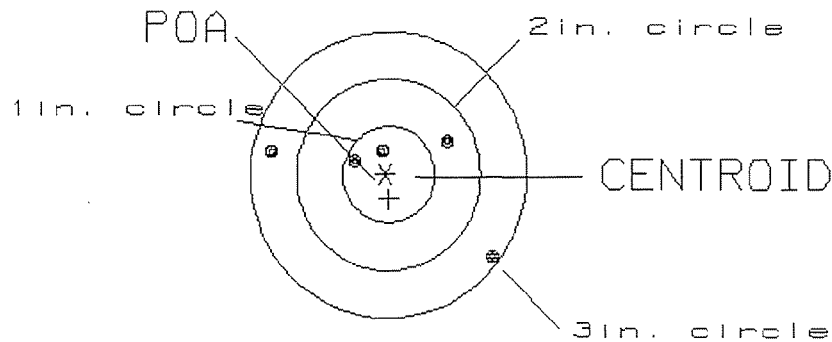
$\begin{matrix} 1 \\ 2 \\ 3 \end{matrix}$ <----POA

PATTERN #: [1]
 POA TO CENTROID: .256
 MIN RADIUS : .213
 MEAN RADIUS : .814
 MAX RADIUS : 1.437
 CENTROID X : -.030
 CENTROID Y : .255

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/EG349857.1.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 5

IN CIRCLE

HS= 2.41

2

VS= 1.21

3

GS= 2.65

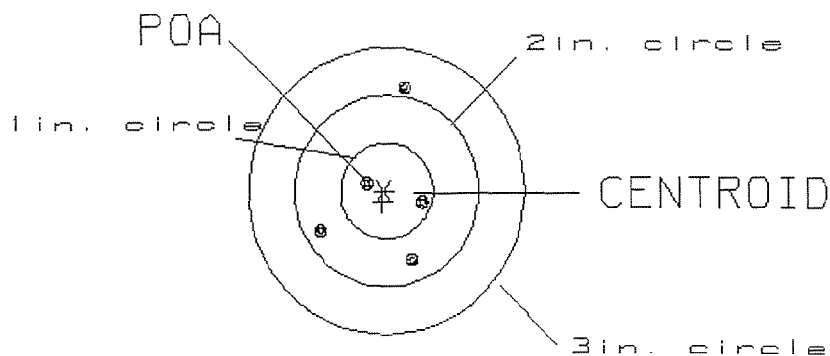
5

PATTERN #: [2]
 POA TO CENTROID: .120
 MIN RADIUS : .219
 MEAN RADIUS : .673
 MAX RADIUS : 1.116
 CENTROID X : .018
 CENTROID Y : .118

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349857.1.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 1.13

2

VS= 1.62

4

GS= 1.83

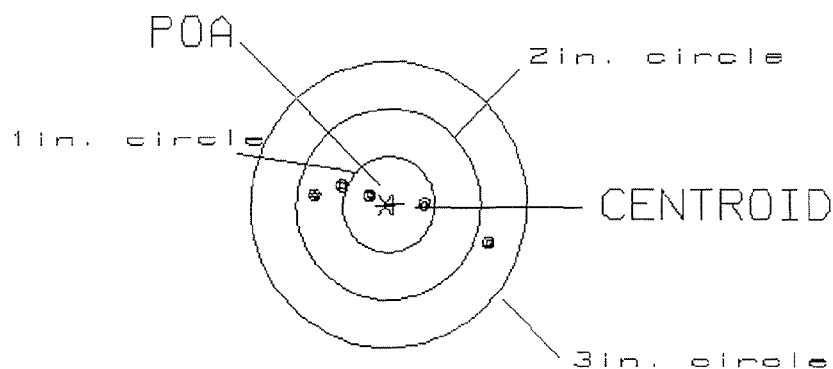
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PATTERN #: 3
 POA TO CENTROID: .088
 MIN RADIUS : .271
 MEAN RADIUS : .655
 MAX RADIUS : 1.209
 CENTROID X : -.087
 CENTROID Y : -.005

17 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349857.1.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 1.94

2

VS= .67

4

GS= 2.01

5

Remington Test Lab, Ilion, N.Y.

Recheck 6-17-97

Centroidal distance calculations for Rifle # E6349857
11 Jun 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.612
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.719
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.82469

THE AMR FOR THIS RIFLE IS: 1.46

CENTROIDAL DISTANCES

0 TO	1	3.43362
1 TO	2	2.79443
1 TO	3	2.13799

1

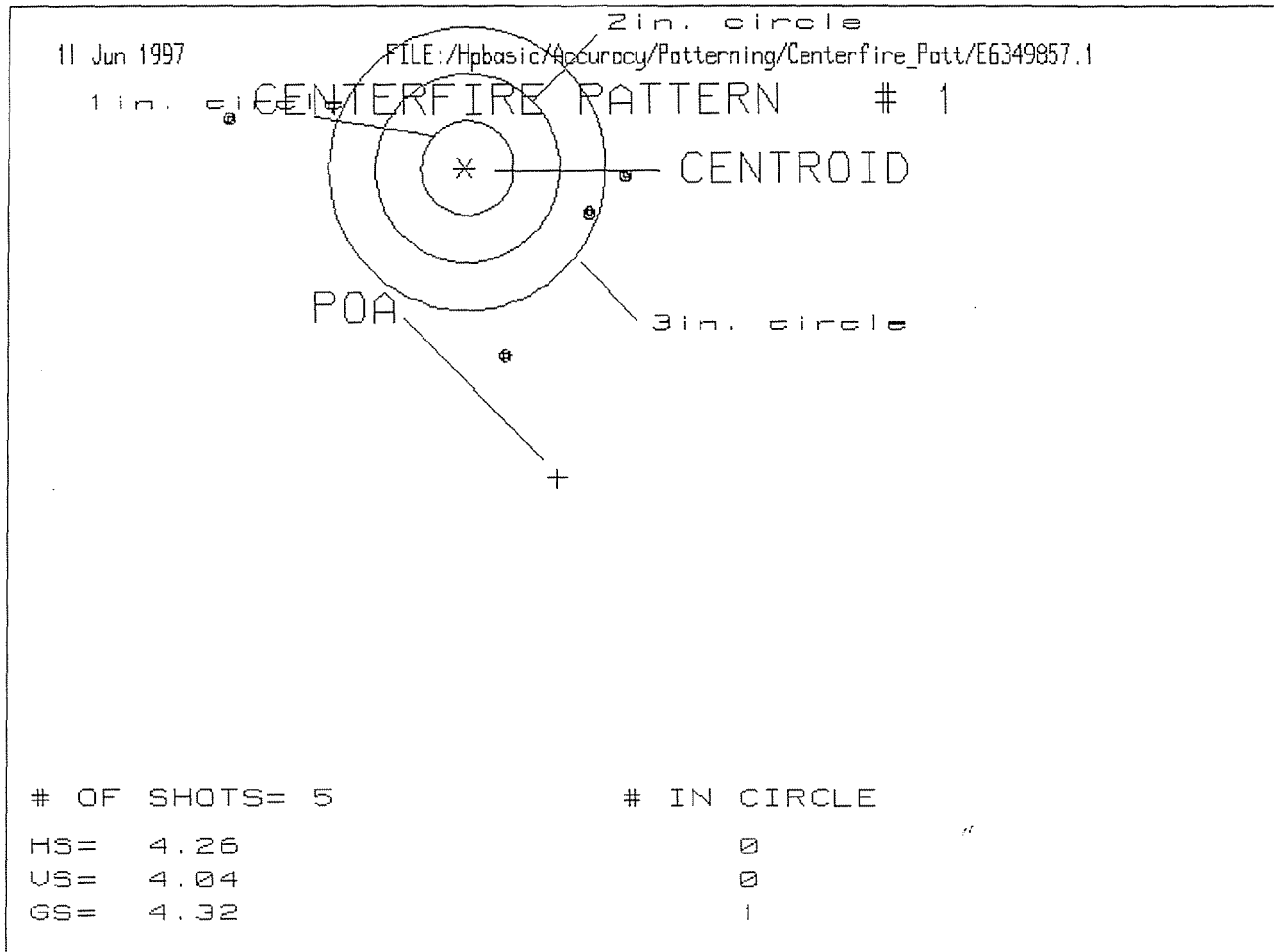
3

2

+

<----POA

PATTERN #: 1
 POA TO CENTROID: 3.434
 MIN RADIUS : 1.367
 MEAN RADIUS : 1.985
 MAX RADIUS : 2.631
 CENTROID X : -1.022
 CENTROID Y : 3.278

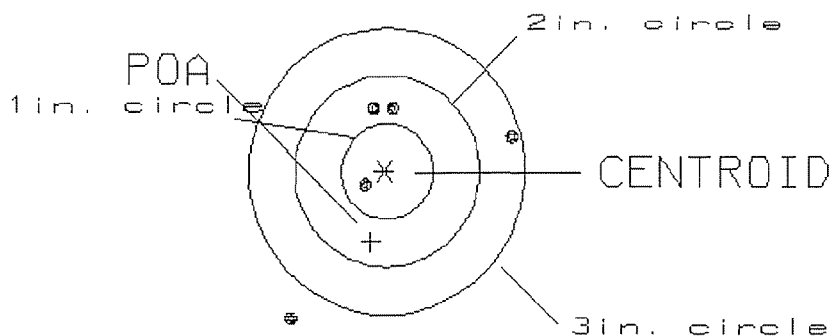


PATTERN #: E 2 E
 POA TO CENTROID: .751
 MIN RADIUS : .255
 MEAN RADIUS : .953
 MAX RADIUS : 1.844
 CENTROID X : .143
 CENTROID Y : .738

11 Jun 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/E6349857.1

CENTERFIRE PATTERN # 2



OF SHOTS= 5

IN CIRCLE

HS= 2.42

1

VS= 2.13

3

GS= 3.08

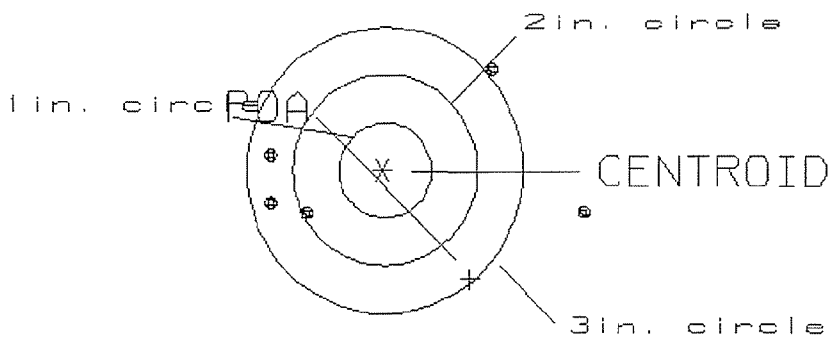
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PATTERN #: 3
 POA TO CENTROID: 1.489
 MIN RADIUS : .923
 MEAN RADIUS : 1.443
 MAX RADIUS : 2.156
 CENTROID X : -.957
 CENTROID Y : 1.141

11 Jun 1997

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/E6349857.1

CENTERFIRE PATTERN # 3



OF SHOTS= 5

IN CIRCLE

HS= 3.39

0

VS= 1.47

1

GS= 3.39

3

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. E6349857DATE 5-30-97TESTER J.W

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.57	2.60	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.61	2.52	2.48	
PULL #3	2.61	2.52	2.50	
PULL #4	2.41	2.48	2.47	
PULL #5	2.50	2.51	2.47	
TOTAL	12.7	12.63	12.41	
AVG.	2.54	2.526	2.482	

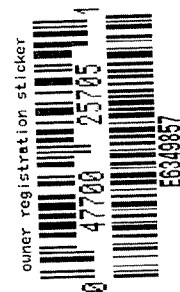
	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	2.96	3.12	
PULL #2	3.00	3.00	
PULL #3	3.01	2.96	
PULL #4	2.99	3.07	
PULL #5	3.01	2.98	
TOTAL	14.97	15.13	
AVG.	2.994	3.026	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.14	3.96		3.97
PULL #2	4.02	3.86		4.01
PULL #3	4.08	3.75		3.92
PULL #4	4.07	3.72		3.65
PULL #5	4.12	3.62		4.03
TOTAL	20.43	18.91		19.58
AVG.	4.086	3.782		3.916

MODEL 700[™] M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO 6*

GREEN ENVELOPE CONTAINING:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- MUSEUM/COUNTRY STORE FLIER
- REMINGTON AUTHORIZED GUNSMITHS



46 FORM

Do Not Use

VERY IMPORTANT
INSTRUCTION: Book
engaged to assure
safe use of this
firearm.

SERIAL NO.
E6349857

46

ORDER NO.
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MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO 6*

REG. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

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