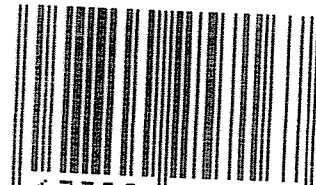


BARBER - M24 0066785

FORM

UPC



0 47700 25716 7

C6649237

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	Bolt hits stock	RW
	2nd		
	3rd		
	4th		

FUNCTION _____

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

BARBER - M24 0066789

Remington



VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700 TM M24

SERIAL NO.
C6649237

ORDER NO.
5716

20

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off. Marca Registrada Marque Deposee.



5716 C6649237

ORDER **5716**

MODEL 700 TM M24

UPC

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649237

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	9 1	RW
600	Proof	10 1	9 1	RW
607	Check Headspace			RW
610	Dis-assemble Gun	10 1	9 1	RW
612	Magnaflux Barrel Action		OCT 1 1991	KR
	Magnaflux Bolt		OCT 1 1991	KR
615	Rollmark Caliber		OCT 1 1991	GL
617	Drill and Tap Sight Holes		OCT 1 1991	LB
618	Polish Barrel		OCT 1 1991	WB
620	Apply Coatings (Barrel Action)		11/2/91	TH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-15-91	SM

op. #	BARBER M24 0066791	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/18/91	SL
	G) Safety Off Force	3	3	3			11/18/91	SL
	H) Trigger Pull Test & Retainability						11-15-91	SL
	I) Firing Pin Indent	.020	.020	.020			11/18/91	SL
	J) Assemble Stock						11/18/91	RW
	K) Assemble Swivel Studs						11-26-91	SL
	L) Attach Front and Rear Sight Assemblies						11/18/91	RW
	M) Iron Sight Alignment						11/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/18/91	RW
	O) Attach Scope to Rifle						11/18/91	RW
	P) Detach & Attach Scope 20 Times						11/18/91	RW
640	Gallery Target & Test						11-20-91	AC
	A) Time						11-20-91	AC
	B) Malfunctions						11-20-91	AC
	C) Pierced Primers						11-20-91	AC
	D) Optical Clarity of Scope						11-20-91	AC
645	Inspect for Live Ammo						11-20-91	AC
655	Final Inspection							
	A) Headspace						11-26-91	SL
	B) Trigger Pull	2.22	2.51	2.53	2.51	2.52	11-20-91	NH
	C) Function						11-26-91	SL
660	Pack						12-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649237

DATE 11-15-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.36	2.33	2.22	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.34	2.38	2.51	
PULL #3	2.26	2.30	2.30	2.53	
PULL #4	2.26	2.25	2.36	2.51	
PULL #5	2.24	2.29	2.28	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.49		
PULL #2	3.63	3.58		
PULL #3	3.54	3.67		
PULL #4	3.66	3.64		
PULL #5	3.52	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.18		4.57
PULL #2	4.46	4.29		4.51
PULL #3	4.54	4.39		4.26
PULL #4	4.34	4.48		4.60
PULL #5	4.37	4.45		4.63
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649237
20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.160424
1 TO	2	.494616
1 TO	3	.433267
1 TO	4	.437724
1 TO	5	.183872

3
2
1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1242
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .127017
THE AMR FOR THIS RIFLE IS: .9932

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649237

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS- 10

* IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.317

VS= 1.582

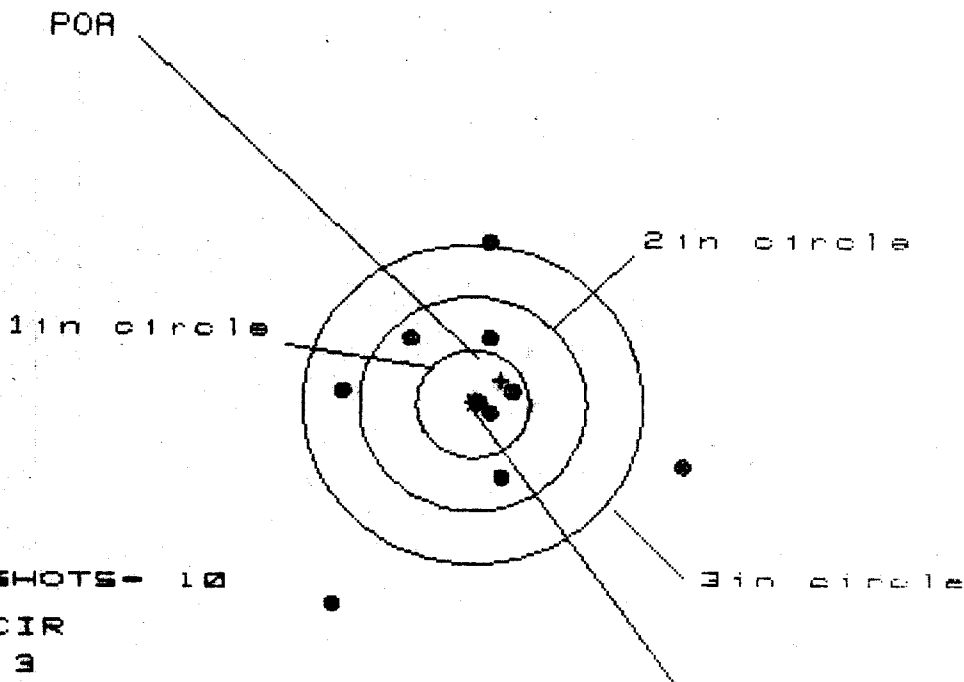
GS= 3.369

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.701	1.079	.901
MINIMUM X	:	-1.616	-1.427	-1.290
MAXIMUM Y	:	.710	.633	.611
MINIMUM Y	:	-.872	-.949	-.971
CENTROID X	:	.130	-.059	.119
CENTROID Y	:	.094	.171	.193
POA TO CENTROID in.	:	.160	.181	.227
MIN RADIUS	:	.113	.103	.079
MEAN RADIUS	:	.923	.816	.709
MAX RADIUS	:	1.836	1.438	1.302
HORIZONTAL SPREAD	:	3.317	2.506	2.191
VERTICAL SPREAD	:	1.582	1.582	1.582
EXTREME SPREAD	:	3.369	2.570	2.199
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649237

CENTERFIRE PATTERNS # 2



♦ OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 7

HS = 3.078

VS = 3.456

GS = 3.727

PATTERN #

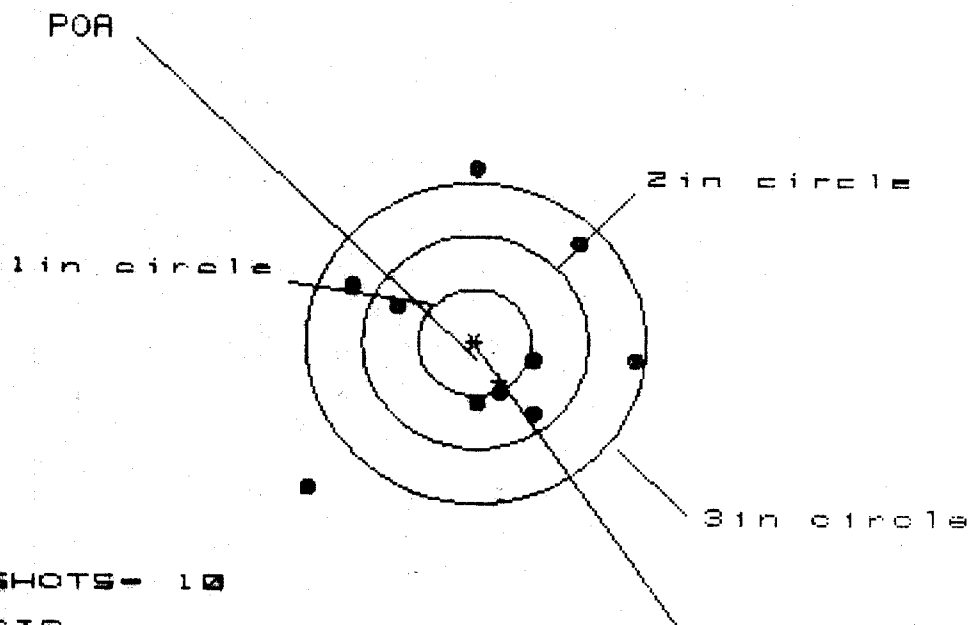
SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.833	1.695	.400
MINIMUM X	-1.245	-1.260	-1.048
MAXIMUM Y	1.564	1.354	1.255
MINIMUM Y	-1.892	-.848	-.947
CENTROID X	-.248	-.110	-.322
CENTROID Y	-.225	-.015	.084
POA TO CENTROID in.	.335	.111	.333
MIN RADIUS	.093	.159	.268
MEAN RADIUS	.972	.803	.685
MAX RADIUS	2.264	1.870	1.275
HORIZONTAL SPREAD	3.078	2.955	1.448
VERTICAL SPREAD	3.456	2.202	2.202
EXTREME SPREAD	3.727	3.030	2.204
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		7	

20 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649237

CENTERFIRE PATTERNS # 3



* OF SHOTS- 10
 * IN CIR
 1 in = 2
 2 in = 5
 3 in = 8
 HM = 2.8886
 VS = 2.982
 GS = 3.346

CENTROID *

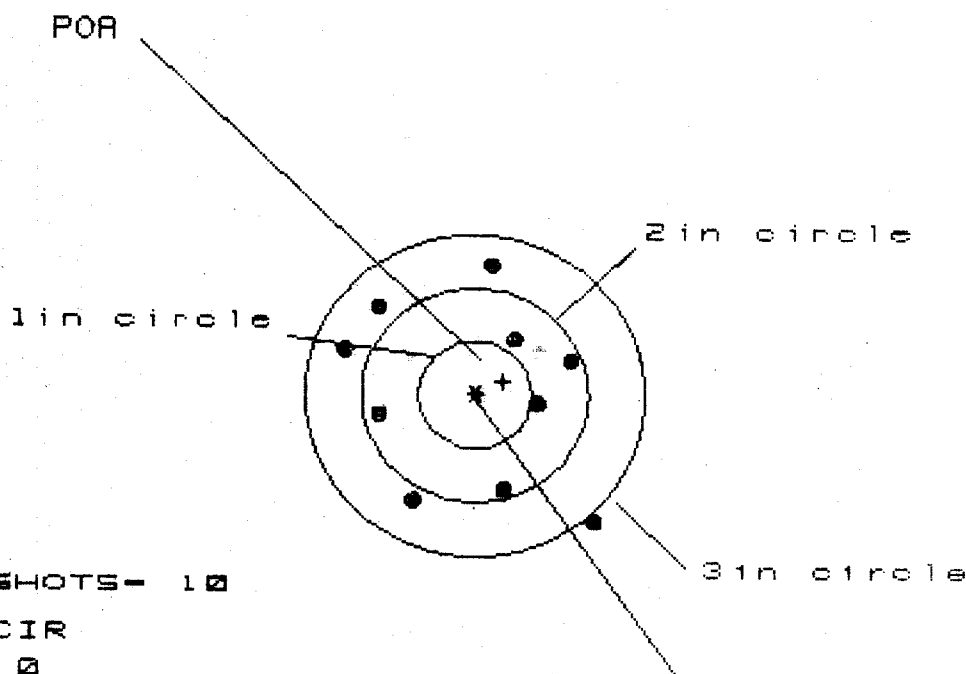
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.364	1.194	1.168
MINIMUM X	:	-1.532	-1.276	-1.302
MAXIMUM Y	:	1.644	1.494	.959
MINIMUM Y	:	-1.348	-.853	-.667
CENTROID X	:	-.212	-.042	-.016
CENTROID Y	:	.360	.510	.324
POA TO CENTROID in.	:	.418	.512	.324
MIN RADIUS	:	.472	.448	.307
MEAN RADIUS	:	1.077	.970	.847
MAX RADIUS	:	2.041	1.508	1.434
HORIZONTAL SPREAD	:	2.896	2.470	2.470
VERTICAL SPREAD	:	2.992	2.347	1.625
EXTREME SPREAD	:	3.346	2.574	2.574
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 2.122

VS= 2.356

GS= 2.722

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.007	.943	.818
MINIMUM X	:	-1.115	-1.004	-.843
MAXIMUM Y	:	1.184	1.054	1.096
MINIMUM Y	:	-1.172	-1.095	-1.053
CENTROID X	:	-.249	-.360	-.235
CENTROID Y	:	-.125	.005	-.037
POA TO CENTROID in.	:	.278	.360	.238
MIN RADIUS	:	.609	.675	.619
MEAN RADIUS	:	1.021	.956	.926
MAX RADIUS	:	1.545	1.164	1.174
HORIZONTAL SPREAD	:	2.122	1.947	1.661
VERTICAL SPREAD	:	2.356	2.149	2.149
EXTREME SPREAD	:	2.722	2.250	2.250
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

20 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649237

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.656

VS= 2.779

GS= 3.567

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.071	.894	.713
MINIMUM X	:	-1.585	-1.012	-.900
MAXIMUM Y	:	1.386	1.232	1.336
MINIMUM Y	:	-1.393	-1.259	-1.155
CENTROID X	:	-.042	.135	.023
CENTROID Y	:	.029	.184	.080
POA TO CENTROID in.	:	.051	.228	.083
MIN RADIUS	:	.274	.050	.193
MEAN RADIUS	:	.973	.801	.759
MAX RADIUS	:	2.110	1.395	1.380
HORIZONTAL SPREAD	:	2.656	1.906	1.613
VERTICAL SPREAD	:	2.779	2.491	2.491
EXTREME SPREAD	:	3.567	2.707	2.707
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	