

BARBER - M24 0101629

FORM

UPC



0 47700 25716 7

C6665712

CAPACITY*
*INCLUDES 1 IN CHAMBER

SUBJECT TO PROTECTIVE ORDER

BARBER - M24 0101629 01668

MODEL 700 TM M24

ORDER NO.

5716

BARREL LENGTH

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665712

ORDER NO.

5716

20

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



5716 C6665712

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665712

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action		SEP 3 0 1991	KR
	Magnaflux Bolt		SEP 3 0 1991	KR
615	Rollmark Caliber		SEP 3 0 1991	LS
617	Drill and Tap Sight Holes		SEP 3 0 1991	FB
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/91	SL

Op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 $\frac{1}{4}$	5 $\frac{1}{2}$			10-18-91	DH
	G) Safety Off Force	3	3	3			10-18-91	DH
	H) Trigger Pull Test & Retainability						10/18/91	JU
	I) Firing Pin Indent	1,020	1,020	1,021			10-18-91	DH
	J) Assemble Stock						10/18/91	RW
	K) Assemble Swivel Studs						10-22-91	AC
	L) Attach Front and Rear Sight Assemblies						10/18/91	RW
	M) Iron Sight Alignment						10/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/18/91	RW
	O) Attach Scope to Rifle						10/18/91	RW
	P) Detach & Attach Scope 20 Times						10/18/91	RW
640	Gallery Target & Test						10-18-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-18-91	NF
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	229	210	212	213	213	10-21-91	DH
	C) Function						10-22-91	AC
660	Pack						12-20-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-6665712DATE 10-18-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.22	2.22	2.20	2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.18	2.25	2.10	
PULL #3	2.30	2.17	2.18	2.12	
PULL #4	2.31	2.15	2.22	2.13	
PULL #5	2.33	2.15	2.20	2.13	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.43		
PULL #2	3.32	3.44		
PULL #3	3.42	3.46		
PULL #4	3.42	3.52		
PULL #5	3.39	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	4.34	4.40		4.19
PULL #2	4.21	4.38		4.26
PULL #3	4.24	4.44		4.24
PULL #4	4.28	4.30		4.33
PULL #5	4.36	4.20		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665712
18 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.233808
1 TO	2	.335121
1 TO	3	.431419
1 TO	4	.426456
1 TO	5	.202744

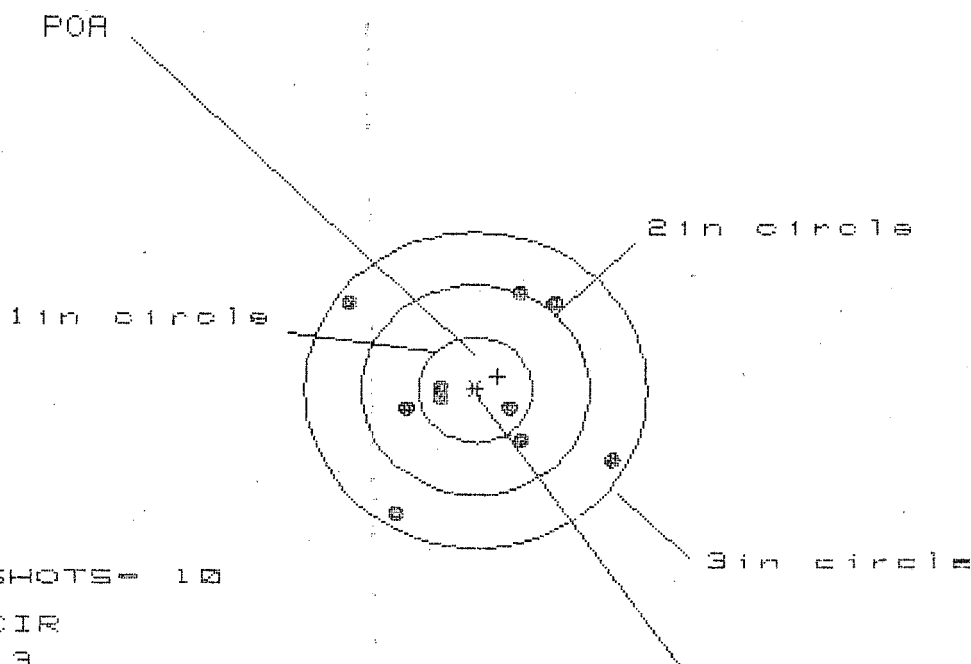
←---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0234
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0444567
THE AMR FOR THIS RIFLE IS: 1.024

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865712

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 10

HS = 2.350

VS = 2.095

GS = 2.756

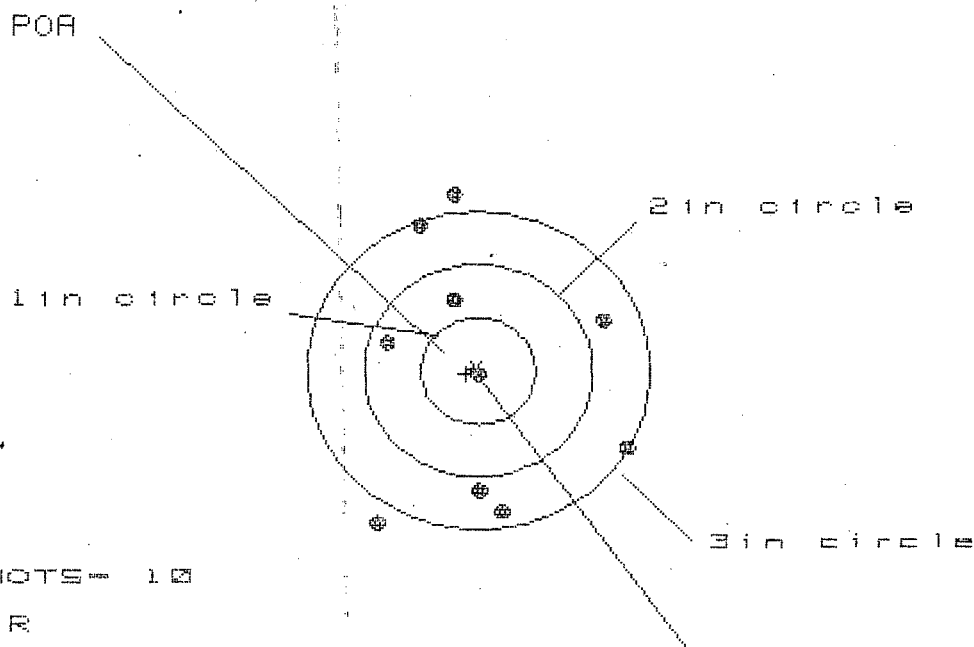
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.220	.866	.742
MINIMUM X	-1.130	-.995	-.701
MAXIMUM Y	.930	.858	.947
MINIMUM Y	-1.165	-1.237	-1.148
CENTROID X	-.195	-.330	-.206
CENTROID Y	-.129	-.057	-.146
POA TO CENTROID in.	.234	.335	.252
MIN RADIUS	.263	.173	.249
MEAN RADIUS	.841	.764	.704
MAX RADIUS	1.384	1.365	1.345
HORIZONTAL SPREAD	2.350	1.961	1.443
VERTICAL SPREAD	2.095	2.095	2.095
EXTREME SPREAD	2.756	2.483	2.483
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665712

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 2.124

VS = 3.116

GS = 3.178

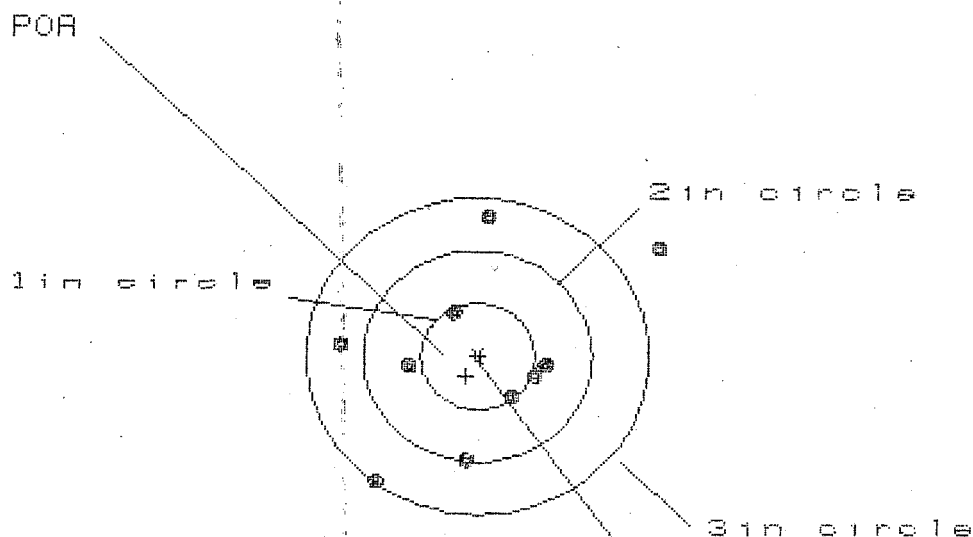
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.258	1.231	1.119
MINIMUM X	-.866	-.893	-.914
MAXIMUM Y	1.708	1.605	1.453
MINIMUM Y	-1.408	-1.218	-1.327
CENTROID X	.100	.127	.239
CENTROID Y	.030	-.160	-.007
POA TO CENTROID in.	.104	.204	.239
MIN RADIUS	.028	.207	.129
MEAN RADIUS	1.156	1.104	1.034
MAX RADIUS	1.725	1.690	1.588
HORIZONTAL SPREAD	2.124	2.124	2.033
VERTICAL SPREAD	3.116	2.823	2.779
EXTREME SPREAD	3.178	2.868	2.868
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6665712

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.815

VS= 2.464

GS= 3.388

CENTROID *

PATTERN #	:	3
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.605
MINIMUM X	:	-1.210
MAXIMUM Y	:	1.282
MINIMUM Y	:	-1.182
CENTROID X	:	.104
CENTROID Y	:	.182
POA TO CENTROID in.	:	.210
MIN RADIUS	:	.498
MEAN RADIUS	:	.966
MAX RADIUS	:	1.912
HORIZONTAL SPREAD	:	2.815
VERTICAL SPREAD	:	2.464
EXTREME SPREAD	:	3.388
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	5
NUMBER IN THREE INCH CIRCLE	=	8

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CENTERFIRE PATTERNS

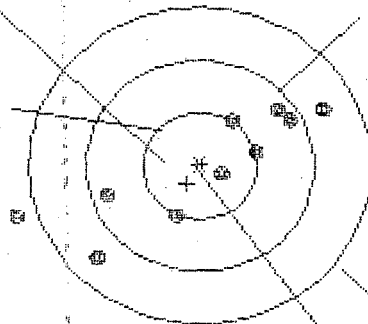
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POA

1in circle

2in circle

3in circle



CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.746

VS= 1.422

GS= 2.948

PATTERN #

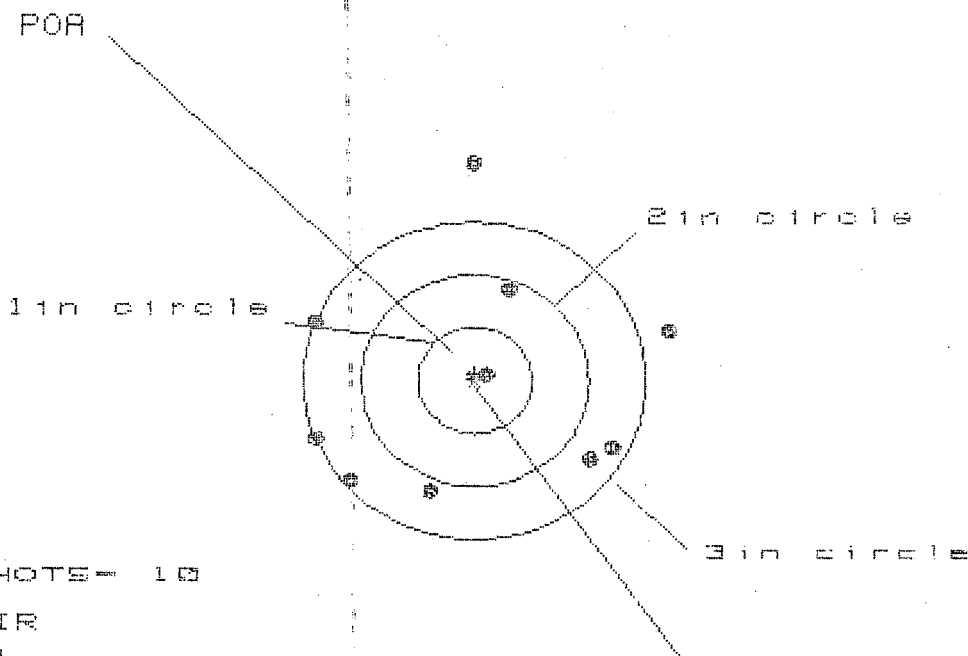
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.125	.945	.806
MINIMUM X	-1.621	-1.114	-1.101
MAXIMUM Y	.567	.511	.397
MINIMUM Y	-.855	-.911	-.657
CENTROID X	.112	.292	.431
CENTROID Y	.167	.223	.337
POA TO CENTROID in.	.201	.368	.547
MIN RADIUS	.182	.142	.151
MEAN RADIUS	.856	.719	.591
MAX RADIUS	1.698	1.439	1.173
HORIZONTAL SPREAD	2.746	2.059	1.907
VERTICAL SPREAD	1.422	1.422	1.054
EXTREME SPREAD	2.948	2.502	2.068
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6665712

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 3.159

VS= 3.150

GS= 3.281

CENTROID

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.749
MINIMUM X	-1.410
MAXIMUM Y	2.073
MINIMUM Y	-1.077
CENTROID X	-.004
CENTROID Y	-.061
POA TO CENTROID in.	.061
MIN RADIUS	.123
MEAN RADIUS	1.303
MAX RADIUS	2.073
HORIZONTAL SPREAD	3.159
VERTICAL SPREAD	3.150
EXTREME SPREAD	3.281
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	2
NUMBER IN THREE INCH CIRCLE	7