

BARBER - M24 0101898

SHIELD
STEEL

FORM

UPC



06655736

*INCLUDES 1 IN CHAMBER

BARBER - M24 0101899

MODEL 700 TM M24

ORDER NO.
BARREL LENGTH

5716

BARBER - M24 0101900

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665736

ORDER NO.

5716

20

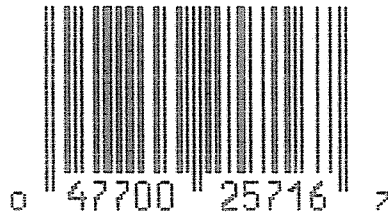
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6665736

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 # C6665736

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	LS
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/5/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/91	TH

BARBER - M24 0101902		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	4 $\frac{1}{2}$	4 $\frac{1}{2}$			10-30-91	DH
	G) Safety Off Force	3 $\frac{1}{4}$	3	3 $\frac{1}{4}$			10-30-91	DH
	H) Trigger Pull Test & Retainability						10/30/91	DH
	I) Firing Pin Indent	1020	1020	1020			10-30-91	DH
	J) Assemble Stock						10/30/91	RW
	K) Assemble Swivel Studs						11-8-91	AC
	L) Attach Front and Rear Sight Assemblies						10/30/91	RW
	M) Iron Sight Alignment						10/30/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/30/91	RW
	O) Attach Scope to Rifle						10/30/91	RW
	P) Detach & Attach Scope 20 Times						10/30/91	RW
640	Gallery Target & Test						10-30-91	N
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-30-91	NF
655	Final Inspection							
	A) Headspace						11-8-91	AC
	B) Trigger Pull	2.45	2.49	2.53	2.51	2.48	10-31-91	DH
	C) Function						11-8-91	AC
660	Pack						12-18-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6665736DATE 10/30/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.56	2.47	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.48	2.51	2.49	
PULL #3	2.49	2.44	2.46	2.53	
PULL #4	2.52	2.41	2.42	2.51	
PULL #5	2.56	2.49	2.50	2.48	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.58		
PULL #2	3.58	3.57		
PULL #3	3.43	3.54		
PULL #4	3.42	3.41		
PULL #5	3.57	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.51		4.45
PULL #2	4.38	4.49		4.54
PULL #3	4.43	4.57		4.39
PULL #4	4.43	4.40		4.50
PULL #5	4.39	4.53		4.49
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665736
30 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.326025
1 TO	2	.403243
1 TO	3	.428337
1 TO	4	.50198
1 TO	5	.34107

1.4 <----POA

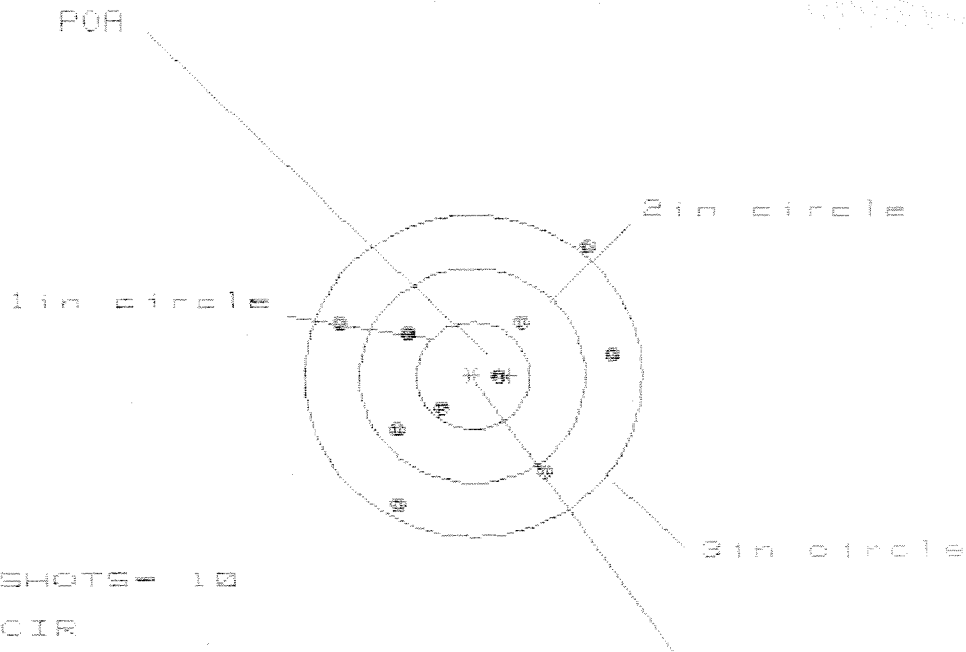
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0158
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0688
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0705503

THE AMR FOR THIS RIFLE IS: .9946

30 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685736.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.448

VS = 2.413

GS = 2.965

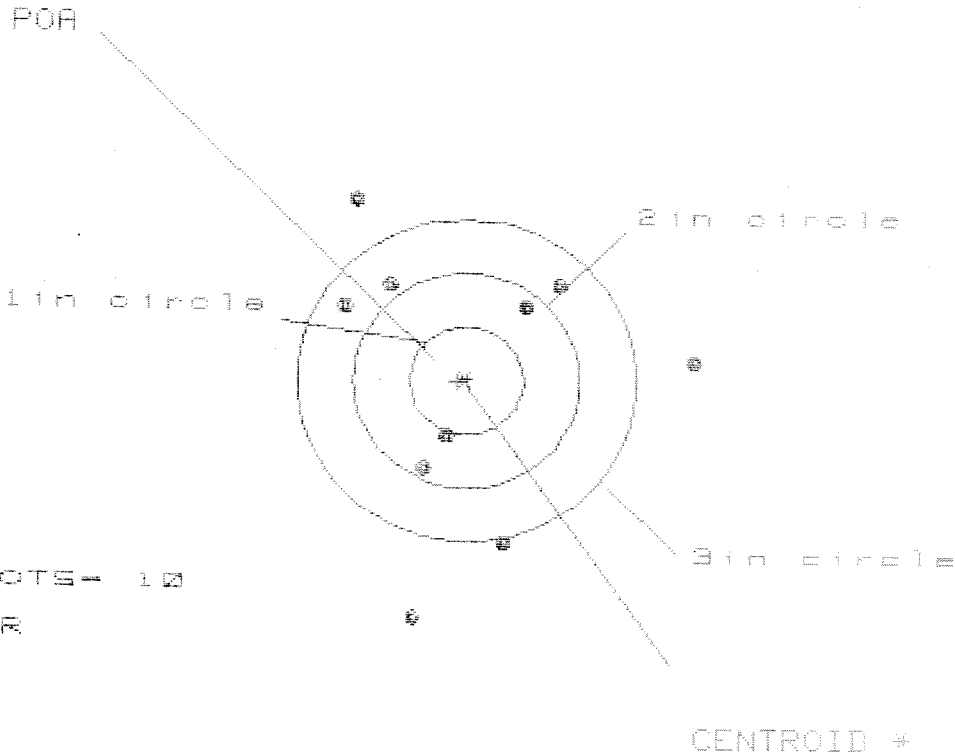
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.255	1.368	1.295
MINIMUM X	:	-1.194	-1.081	-1.154
MAXIMUM Y	:	1.223	.622	.490
MINIMUM Y	:	-1.190	-1.054	-.855
CENTROID X	:	-.326	-.439	-.366
CENTROID Y	:	-.004	-.140	-.008
POA TO CENTROID in.	:	.326	.461	.366
MIN RADIUS	:	.222	.252	.262
MEAN RADIUS	:	.939	.851	.802
MAX RADIUS	:	1.593	1.418	1.317
HORIZONTAL SPREAD	:	2.449	2.449	2.449
VERTICAL SPREAD	:	2.413	1.676	1.345
EXTREME SPREAD	:	2.965	2.462	2.462
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

30 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 3

3in = 6

HS = 3.149

VS = 3.897

GS = 3.933

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.047	1.999	1.042
MINIMUM X	:	-1.102	-1.150	-0.900
MAXIMUM Y	:	1.696	1.452	1.447
MINIMUM Y	:	-2.201	-1.753	-1.758
CENTROID X	:	.077	.125	-.125
CENTROID Y	:	.010	.254	.259
POA TO CENTROID in.	:	.078	.283	.287
MIN RADIUS	:	.566	.642	.777
MEAN RADIUS	:	1.373	1.260	1.145
MAX RADIUS	:	2.242	2.000	1.835
HORIZONTAL SPREAD	:	3.149	3.149	1.942
VERTICAL SPREAD	:	3.897	3.205	3.205
EXTREME SPREAD	:	3.933	3.453	3.453
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 2

2in = 9

3in = 9

HS= 1.635

VS= 2.487

GS= 2.789

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.076	.889	.862
MINIMUM X	:	-.559	-.439	-.466
MAXIMUM Y	:	1.671	.639	.570
MINIMUM Y	:	-.736	-.551	-.371
CENTROID X	:	.102	-.018	.009
CENTROID Y	:	.013	-.172	-.103
POA TO CENTROID in.	:	.103	.173	.194
MIN RADIUS	:	.291	.137	.194
MEAN RADIUS	:	.724	.507	.511
MAX RADIUS	:	1.987	.913	.873
HORIZONTAL SPREAD	:	1.635	1.328	1.328
VERTICAL SPREAD	:	2.487	1.190	.941
EXTREME SPREAD	:	2.789	1.423	1.423
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Oct 1991

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CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 3.245

VS= 2.007

CS= 3.358

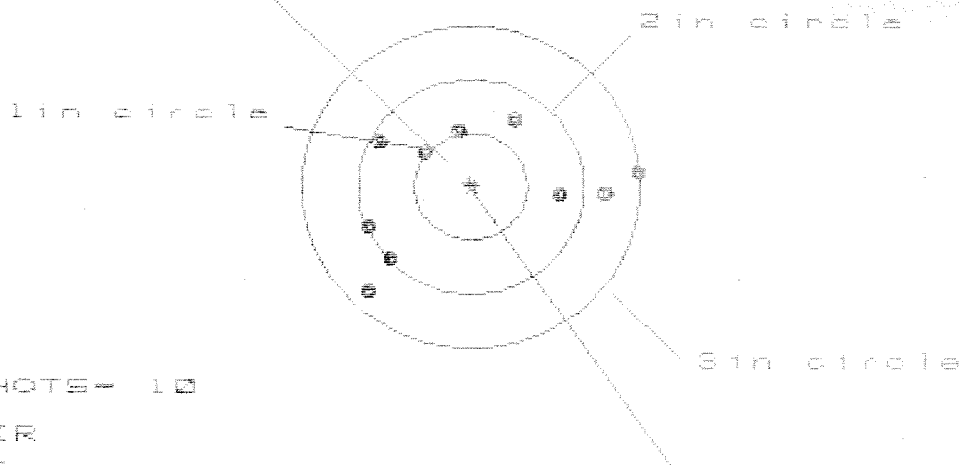
PATTERN #	:	4	3	2
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.246	1.182
MINIMUM X	:	-1.799	-1.156	-1.000
MAXIMUM Y	:	.998	1.064	1.039
MINIMUM Y	:	-1.010	-.943	-.968
CENTROID X	:	.054	.254	.098
CENTROID Y	:	-.332	-.398	-.373
POA TO CENTROID in.	:	.336	.472	.386
MIN RADIUS	:	.293	.173	.233
MEAN RADIUS	:	.968	.822	.776
MAX RADIUS	:	1.896	1.492	1.392
HORIZONTAL SPREAD	:	3.245	2.402	2.182
VERTICAL SPREAD	:	2.007	2.007	2.007
EXTREME SPREAD	:	3.358	2.515	2.452
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 10

HS= 2.455

VS= 1.596

GS= 2.674

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.493	1.391	1.293
MINIMUM X	-.962	-.796	-.894
MAXIMUM Y	.608	.610	.496
MINIMUM Y	-.988	-.978	-.757
CENTROID X	.014	-.152	-.054
CENTROID Y	-.031	-.041	.081
POB TO CENTROID in.	.034	.158	.097
MIN RADIUS	.558	.450	.436
MEAN RADIUS	.969	.889	.825
MAX RADIUS	1.496	1.391	1.300
HORIZONTAL SPREAD	2.455	2.187	2.187
VERTICAL SPREAD	1.596	1.596	1.253
EXTREME SPREAD	2.674	2.388	2.211
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	