

BARBER - M24 0102267

FORM

UPC



0 47700 25716 2

C6665766

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0102269

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6665766

ORDER NO.
5716

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

20



5716 C6665766

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER **5716**

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665766

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	YH
600	Proof		9/25/91	YH
607	Check Headspace		9/25/91	YH
610	Dis-assemble Gun		9/25/91	YH
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/25/91	AS
	Apply Coating (Bolt)			
625	Final Assembly		12/3/91	YH
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	YH
	C) Inspect Ejector Hole for Chamfer		12/3/91	YH
	D) Oil Firing Pin Ass'y		12/3/91	YH
	E) Adjust Trigger Pull to Min Setting and Stake		12-4-91	YH

op. #	BARBER MEM24 0102271	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			12-4-91	SL
	G) Safety Off Force	4	4	4			12-4-91	SL
	H) Trigger Pull Test & Retainability						12-4-91	SL
	I) Firing Pin Indent	.0205	.0215	.0215			12-4-91	SL
	J) Assemble Stock						12/4/91	SL
	K) Assemble Swivel Studs						12-11-91	AC
	L) Attach Front and Rear Sight Assemblies						12/4/91	SL
	M) Iron Sight Alignment						12/4/91	SL
	N) Detach Front & Rear Sights & place in numbered container						12/4/91	SL
	O) Attach Scope to Rifle						12/4/91	SL
	P) Detach & Attach Scope 20 Times						12/4/91	SL
640	Gallery Target & Test						12/4/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						12/4/91	KT
655	Final Inspection							
	A) Headspace						12-11-91	AC
	B) Trigger Pull	238	224	226	225	227	12-5-91	DLH
	C) Function						12-11-91	AC
660	Pack						12-19-91	V

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665766DATE 12-4-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.45	2.50	2.38	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.45	2.55	2.24	
PULL #3	2.52	2.44	2.43	2.26	
PULL #4	2.33	2.59	2.44	2.25	
PULL #5	2.20	2.47	2.51	2.27	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.62		
PULL #2	3.55	3.58		
PULL #3	3.49	3.58		
PULL #4	3.38	3.60		
PULL #5	3.60	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.23	4.25		4.52
PULL #2	4.24	4.59		4.30
PULL #3	4.38	4.21		4.47
PULL #4	4.40	4.26		4.29
PULL #5	4.41	4.37		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665766
4 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.109142
1 TO 2	.245253
1 TO 3	.279789
1 TO 4	.451443
1 TO 5	.230009

421 8 ----POB

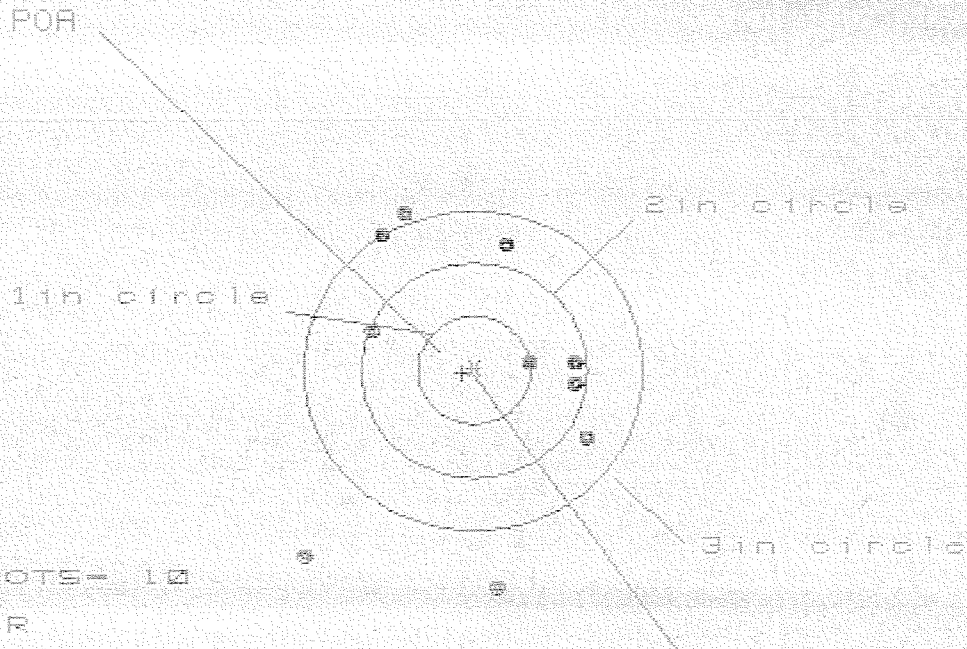
AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.104
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.8472
AVERAGE AVERAGE POI RADIUS FOR THIS RIFLE IS: .11421

POI THIS RIFLE IS: 1.102

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665766

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.537

VS= 3.517

GS= 3.595

CENTROID *

PATTERN #

1

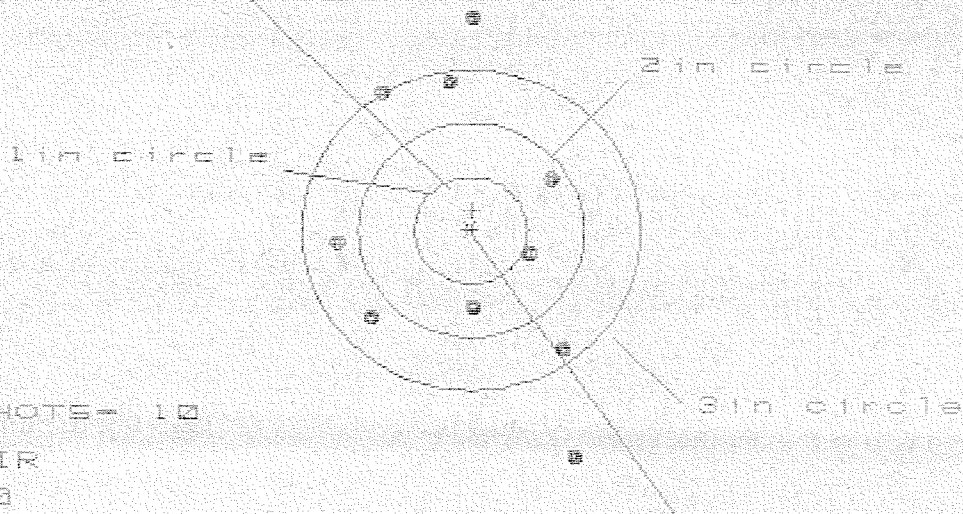
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.031	.864	.866
MINIMUM X	-1.506	-1.024	-1.022
MAXIMUM Y	1.495	1.304	1.028
MINIMUM Y	-2.022	-2.213	-1.091
CENTROID X	.106	.273	.271
CENTROID Y	.026	.217	.493
OP TO CENTROID in.	.109	.349	.563
1in RADIUS	.495	.344	.513
2in RADIUS	1.302	1.135	.988
3in RADIUS	2.283	2.213	1.393
HORIZONTAL SPREAD	2.537	1.888	1.888
VERTICAL SPREAD	3.517	3.517	2.119
EXTREME SPREAD	3.595	3.595	2.647
SHOTS IN ONE INCH CIRCLE	=	1	
SHOTS IN TWO INCH CIRCLE	=	4	
SHOTS IN THREE INCH CIRCLE	=	7	

4 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685766

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.094

VS= 4.090

GS= 4.184

CENTROID *

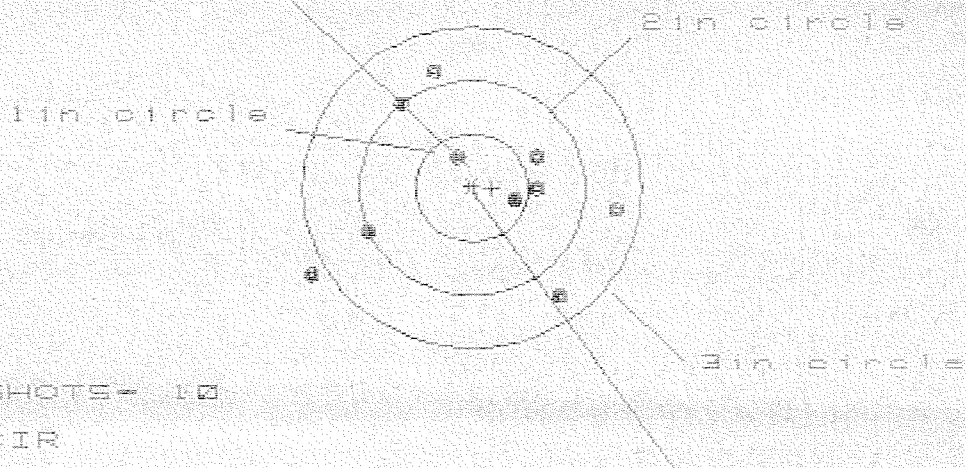
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.896	.903	.917
MINIMUM X	-1.198	-1.099	-1.085
MAXIMUM Y	1.969	1.734	1.329
MINIMUM Y	-2.121	-1.353	-1.137
CENTROID X	-.012	-.111	-.125
CENTROID Y	-.189	.046	-.170
POA TO CENTROID in.	.190	.120	.211
MIN RADIUS	.576	.787	.687
MEAN RADIUS	1.312	1.204	1.110
MAX RADIUS	2.302	1.737	1.461
HORIZONTAL SPREAD	2.094	2.002	2.002
VERTICAL SPREAD	4.090	3.087	2.466
EXTREME SPREAD	4.184	3.187	2.887
NUMBER IN ONE INCH CIRCLE	= 0		
NUMBER IN TWO INCH CIRCLE	= 3		
NUMBER IN THREE INCH CIRCLE	= 7		

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665766

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.662

VS= 2.124

GS= 2.724

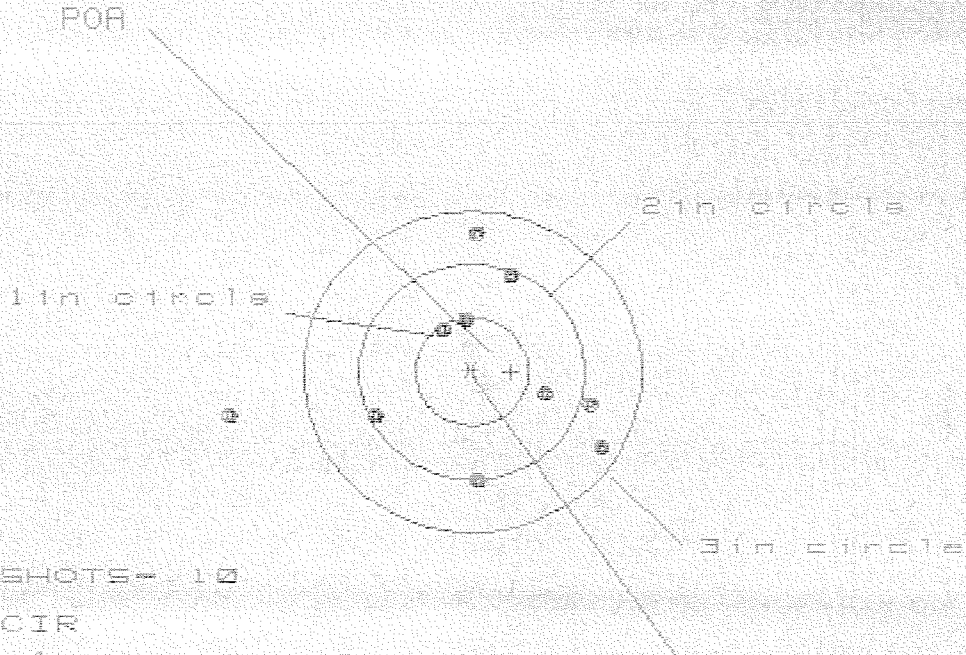
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.246	1.089	.711
MINIMUM X	-1.415	-1.067	-.931
MAXIMUM Y	1.141	1.055	1.020
MINIMUM Y	-.983	-1.069	-1.104
CENTROID X	-.173	-.016	-.152
CENTROID Y	.005	.091	.126
POA TO CENTROID in.	.174	.092	.198
MIN RADIUS	.355	.274	.271
MEAN RADIUS	.927	.817	.783
MAX RADIUS	1.613	1.214	1.313
HORIZONTAL SPREAD	2.662	2.156	1.642
VERTICAL SPREAD	2.124	2.124	2.124
EXTREME SPREAD	2.724	2.395	2.395
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9

4 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6665766

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 3.287

VS= 2.291

GS= 3.301

CENTROID *

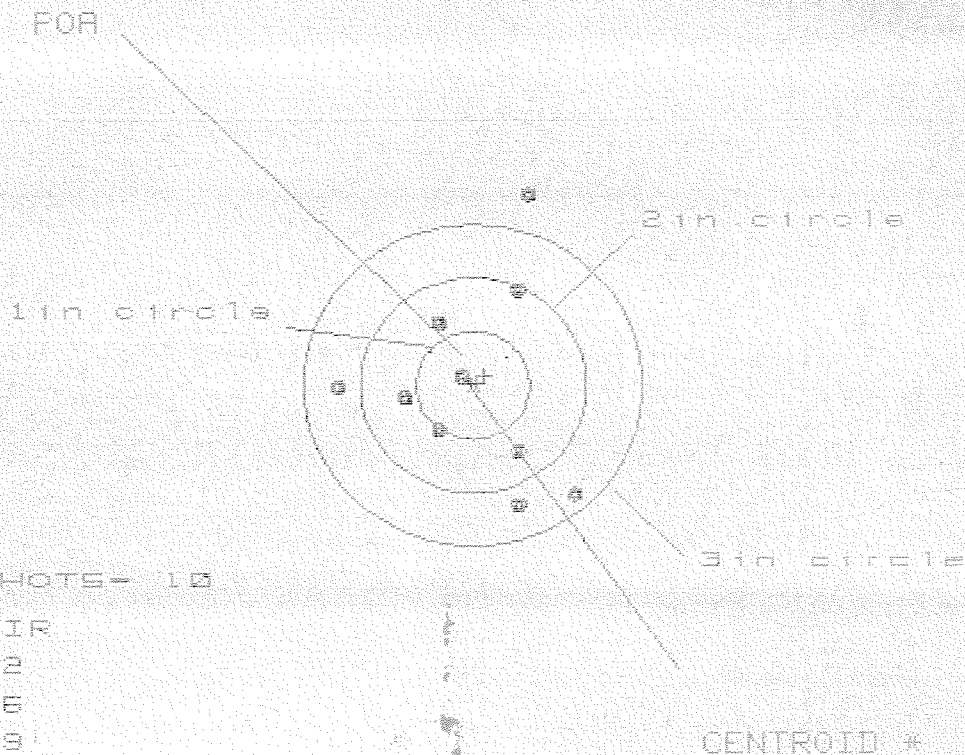
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	.893	.942
MINIMUM X	:	-2.155	-1.122	-1.010
MAXIMUM Y	:	1.298	1.253	1.158
MINIMUM Y	:	-.993	-1.038	-1.133
CENTROID X	:	-.345	-.106	-.217
CENTROID Y	:	.006	.051	.146
POA TO CENTROID in.	:	.345	.118	.262
MIN RADIUS	:	.452	.493	.438
MEAN RADIUS	:	1.055	.901	.850
MAX RADIUS	:	2.193	1.268	1.161
HORIZONTAL SPREAD	:	3.287	2.015	1.952
VERTICAL SPREAD	:	2.291	2.291	2.291
EXTREME SPREAD	:	3.301	2.291	2.291
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Dec 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6665766

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.035

VS= 2.946

GS= 2.948

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.852	.904	.599
MINIMUM X	-1.183	-1.131	-1.018
MAXIMUM Y	1.791	1.080	.978
MINIMUM Y	-1.155	-.956	-1.058
CENTROID X	-.096	-.148	-.261
CENTROID Y	-.084	-.283	-.181
FOR TO CENTROID in.	.127	.320	.317
MIN RADIUS	.168	.313	.203
MEAN RADIUS	.915	.794	.712
MAX RADIUS	1.852	1.222	1.183
HORIZONTAL SPREAD	2.035	2.035	1.617
VERTICAL SPREAD	2.946	2.036	2.036
EXTREME SPREAD	2.948	2.249	2.036
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	