

FORM

UPC



0 47700 25716 7

C6665773

INCLUDES 1 IN CHAMBER

TM M24  
/00

5716

ORDER NO.

BARREL LENGTH

CAPACITY\*

BARBER - M24 0102353

*Remington*



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

MODEL 700 <sup>TM</sup> M24

SERIAL NO.

C6665773

ORDER NO.

5716

20

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



5716 C6665773

ORDER 5716

MODEL 700 <sup>TM</sup> M24

UPC

ORDER 5716

MODEL 700 <sup>TM</sup> M24

UPC



0 47700 25716 7



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665773

| OP. #        | OP. NAME                                                       | READINGS | DATE        | INIT |
|--------------|----------------------------------------------------------------|----------|-------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   | 9 26     | 91          | RW   |
| 600          | Proof                                                          | 9 26     | 91          | RW   |
| 607          | Check Headspace                                                | 9 26     | 91          | RW   |
| 610          | Dis-assemble Gun                                               | 9 26     | 91          | RW   |
| 612          | Magnaflux Barrel<br>Action                                     |          | SEP 30 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | SEP 30 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | SEP 30 1991 | SS   |
| 617          | Drill and Tap Sight Holes                                      |          | SEP 30 1991 | FS   |
| 618          | Polish Barrel                                                  |          | OCT 2 1991  | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-13-91    | JA   |
|              | Apply Coating (Bolt)                                           |          |             |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/13/91    | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/13/91    | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/13/91    | RW   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/13/91    | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/22/91    | JA   |

| op. #        | BARBER M24 0102355                                          | READINGS        |                 |                 |     |     | DATE     | INIT |
|--------------|-------------------------------------------------------------|-----------------|-----------------|-----------------|-----|-----|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 5 $\frac{1}{2}$ | 5               | 5               |     |     | 10-22-91 | DH   |
|              | G) Safety Off Force                                         | 2 $\frac{3}{4}$ | 2 $\frac{3}{4}$ | 2 $\frac{3}{4}$ |     |     | 10-22-91 | DH   |
|              | H) Trigger Pull Test & Retainability                        |                 |                 |                 |     |     | 10/22/91 | JD   |
|              | I) Firing Pin Indent                                        | .020            | .020            | .020            |     |     | 10-22-91 | DH   |
|              | J) Assemble Stock                                           |                 |                 |                 |     |     | 10/24/91 | RW   |
|              | K) Assemble Swivel Studs                                    |                 |                 |                 |     |     | 11-12-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |                 |                 |                 |     |     | 10/24/91 | RW   |
|              | M) Iron Sight Alignment                                     |                 |                 |                 |     |     | 10/24/91 | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |                 |                 |                 |     |     | 10/24/91 | RW   |
|              | O) Attach Scope to Rifle                                    |                 |                 |                 |     |     | 10/24/91 | RW   |
|              | P) Detach & Attach Scope 20 Times                           |                 |                 |                 |     |     | 10/24/91 | RW   |
| 640          | Gallery Target & Test                                       |                 |                 |                 |     |     | 10-25-91 | AC   |
|              | A) Time                                                     |                 |                 |                 |     |     | 10-25-91 | AC   |
|              | B) Malfunctions                                             |                 |                 |                 |     |     | 10-25-91 | AC   |
|              | C) Pierced Primers                                          |                 |                 |                 |     |     | 10-25-91 | AC   |
|              | D) Optical Clarity of Scope                                 |                 |                 |                 |     |     | 10-25-91 | AC   |
| 645          | Inspect for Live Ammo                                       |                 |                 |                 |     |     | 10-25-91 | AC   |
| 655          | Final Inspection                                            |                 |                 |                 |     |     |          |      |
|              | A) Headspace                                                |                 |                 |                 |     |     | 11-12-91 | AC   |
|              | B) Trigger Pull                                             | 241             | 266             | 241             | 242 | 238 | 10-30-91 | DH   |
|              | C) Function                                                 |                 |                 |                 |     |     | 11-12-91 | AC   |
| 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. C-6665773DATE 10/22/91TESTER JF

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.40             | 2.44                     | 2.45                           | 2.41 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.35             | 2.44                     | 2.25                           | 2.66 |                                                                        |
| PULL #3 | 2.43             | 2.44                     | 2.43                           | 2.41 |                                                                        |
| PULL #4 | 2.44             | 2.36                     | 2.48                           | 2.42 |                                                                        |
| PULL #5 | 2.48             | 2.43                     | 2.39                           | 2.38 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.67             | 3.22                     |  |          |
| PULL #2 | 3.55             | 3.32                     |  |          |
| PULL #3 | 3.45             | 3.27                     |  |          |
| PULL #4 | 3.46             | 3.30                     |  |          |
| PULL #5 | 3.46             | 3.39                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.39             | 4.46                     |                                | 4.23                                 |
| PULL #2 | 4.28             | 4.26                     |                                | 4.44                                 |
| PULL #3 | 4.34             | 4.46                     |                                | 4.21                                 |
| PULL #4 | 4.45             | 4.31                     |                                | 4.42                                 |
| PULL #5 | 4.25             | 4.36                     |                                | 4.47                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06665773  
25 Oct 1991

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .442019 |
| 1 TO | 2 | .379796 |
| 1 TO | 3 | .3828   |
| 1 TO | 4 | .62794  |
| 1 TO | 5 | .313211 |

4 1/5 <--- POB

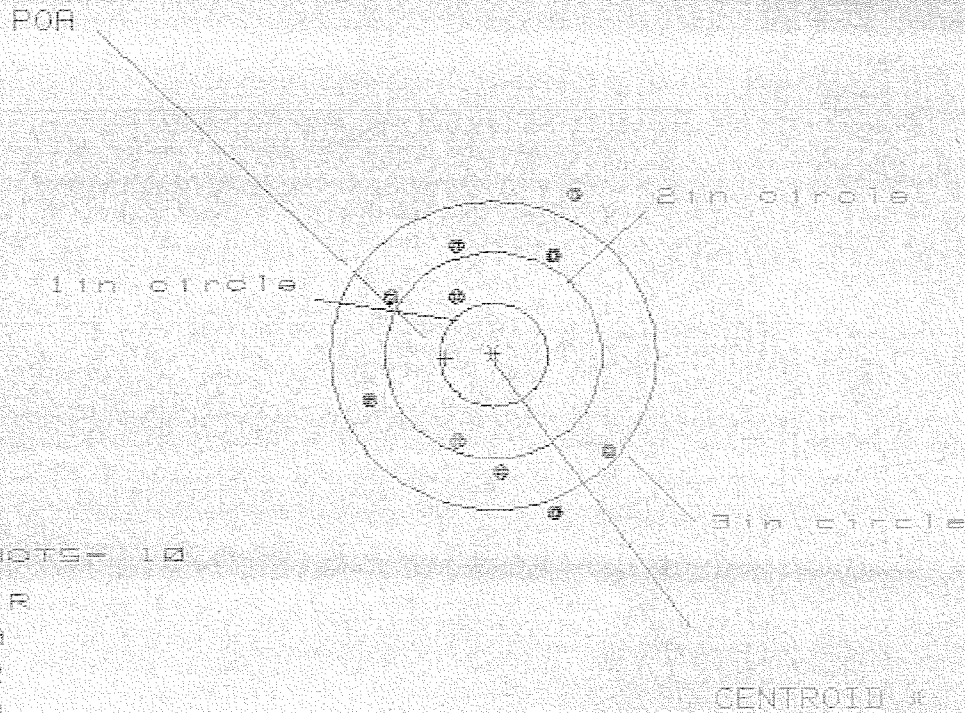
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2994  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2138  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .367901

THE AMR FOR THIS RIFLE IS: 1.174

25 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/06665723

## CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1 in = 0

2 in = 2

3 in = 8

HS= 2.107

VS= 3.087

GS= 3.094

| PATTERN #                   | 1      | 2      | 3      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | 1.014  | 1.103  | 1.189  |
| MINIMUM X                   | -1.093 | -1.004 | -.918  |
| MAXIMUM Y                   | 1.575  | 1.254  | 1.087  |
| MINIMUM Y                   | -1.512 | -1.337 | -1.170 |
| CENTROID X                  | .441   | .352   | .266   |
| CENTROID Y                  | .030   | -.145  | .022   |
| POA TO CENTROID in.         | .442   | .380   | .267   |
| MIN RADIUS                  | .624   | .675   | .572   |
| MEAN RADIUS                 | 1.194  | 1.114  | 1.042  |
| MAX RADIUS                  | 1.769  | 1.503  | 1.488  |
| HORIZONTAL SPREAD           | 2.107  | 2.107  | 2.107  |
| VERTICAL SPREAD             | 3.087  | 2.591  | 2.257  |
| EXTREME SPREAD              | 3.094  | 2.754  | 2.472  |
| NUMBER IN ONE INCH CIRCLE   | = 0    |        |        |
| NUMBER IN TWO INCH CIRCLE   | = 2    |        |        |
| NUMBER IN THREE INCH CIRCLE | = 8    |        |        |



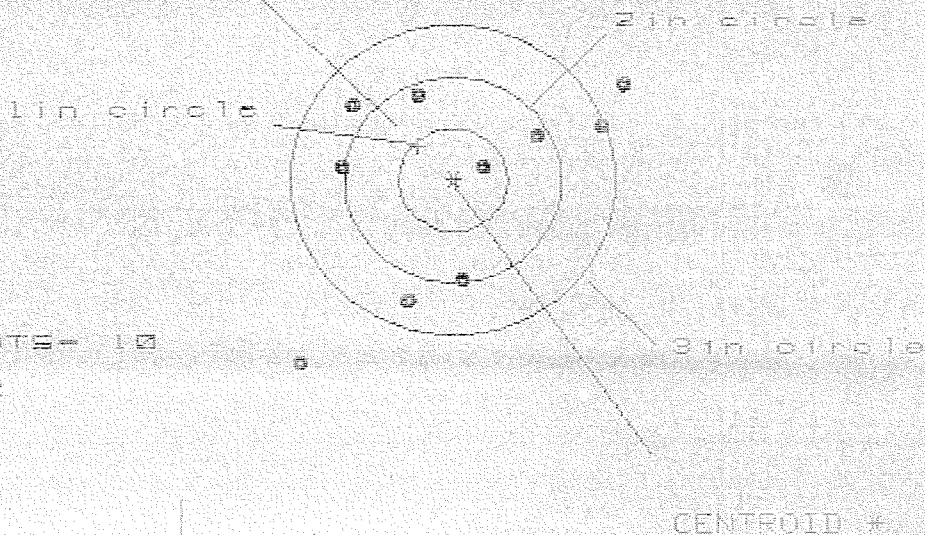
25 Oct 1991

FILE: \PATTERNING\CENTERFIRE\_PATT\06665773

## CENTERFIRE PATTERNS

# 2

POA



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.947

VS= 2.676

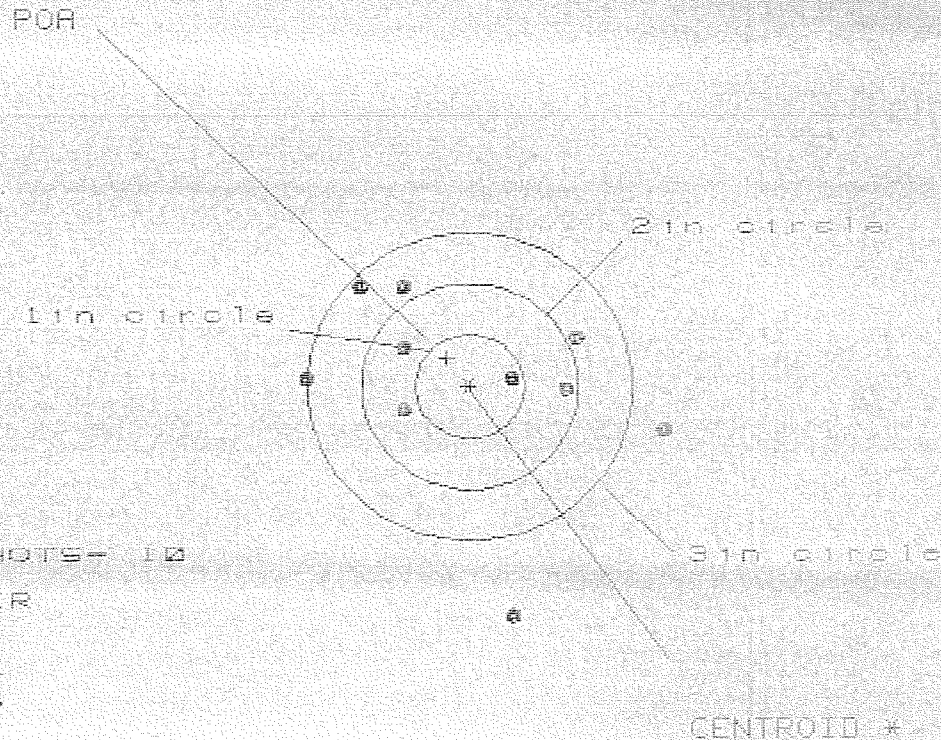
GS= 3.981

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.532  | 1.375  | 1.389  |
| MINIMUM X                     | -1.415 | -1.181 | -1.009 |
| MAXIMUM Y                     | .935   | .742   | .685   |
| MINIMUM Y                     | -1.741 | -1.336 | -1.243 |
| CENTROID X                    | .323   | .480   | .308   |
| CENTROID Y                    | -.331  | -.137  | -.230  |
| POA TO CENTROID in.           | .462   | .499   | .385   |
| MIN RADIUS                    | .322   | .129   | .301   |
| MEAN RADIUS                   | 1.193  | 1.036  | .977   |
| MAX RADIUS                    | 2.243  | 1.562  | 1.463  |
| HORIZONTAL SPREAD             | 2.947  | 2.556  | 2.398  |
| VERTICAL SPREAD               | 2.676  | 2.078  | 1.928  |
| EXTREME SPREAD                | 3.981  | 2.834  | 2.455  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |        |

25 Oct 1991

FILE: \PATTERNING\CENTERFIRE\_PATT\6665779

## CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.254

VS= 3.126

GS= 3.447

| PATTERN #                   | 3      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.755  |
| MINIMUM X                   | -1.509 |
| MAXIMUM Y                   | .951   |
| MINIMUM Y                   | -2.175 |
| CENTROID X                  | .211   |
| CENTROID Y                  | -.276  |
| POA TO CENTROID in.         | .347   |
| MIN RADIUS                  | .345   |
| MEAN RADIUS                 | 1.165  |
| MAX RADIUS                  | 2.216  |
| HORIZONTAL SPREAD           | 3.264  |
| VERTICAL SPREAD             | 3.126  |
| EXTREME SPREAD              | 3.447  |
| NUMBER IN ONE INCH CIRCLE   | 1      |
| NUMBER IN TWO INCH CIRCLE   | 4      |
| NUMBER IN THREE INCH CIRCLE | 7      |

25 Oct 1991

FILE: PATTERNING/CENTERFIRE PATT/08685773

## CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS= 10

# IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 3.011

VS= 2.869

GS= 3.515

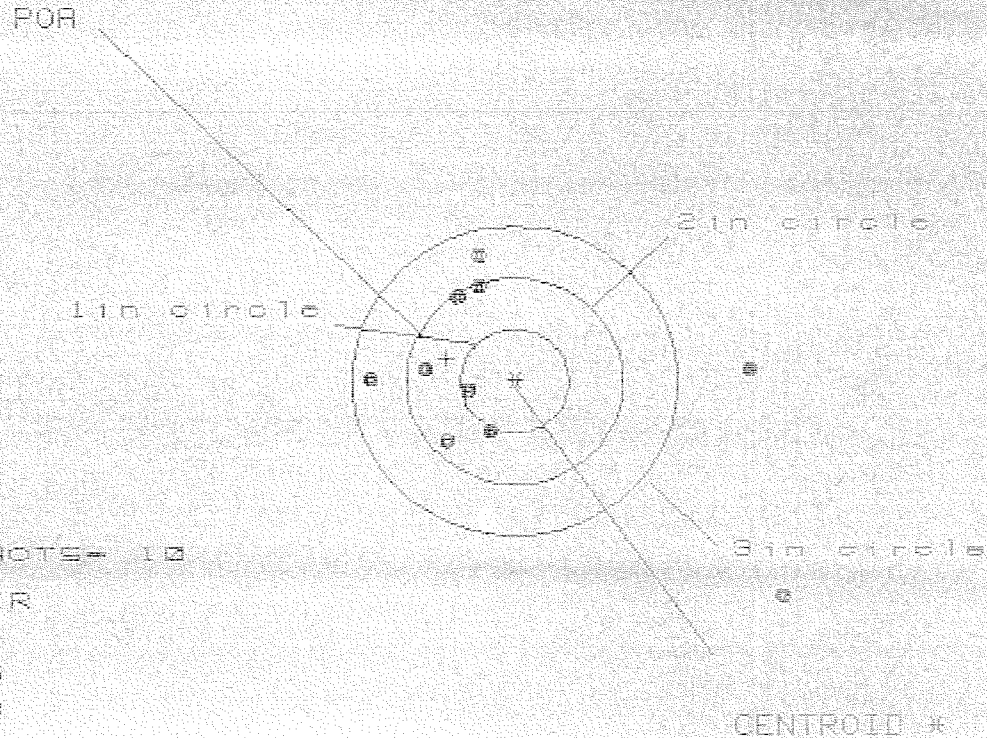
| PATTERN #                   | : | 4      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.303  | 1.113  | 1.109  |
| MINIMUM X                   | : | -1.708 | -1.563 | -1.567 |
| MAXIMUM Y                   | : | 1.068  | .984   | .748   |
| MINIMUM Y                   | : | -1.801 | -1.885 | -1.472 |
| CENTROID X                  | : | -.109  | .081   | .085   |
| CENTROID Y                  | : | -.273  | -.189  | .047   |
| POA TO CENTROID in.         | : | .294   | .205   | .097   |
| MIN RADIUS                  | : | .273   | .262   | .332   |
| MEAN RADIUS                 | : | 1.050  | .941   | .802   |
| MAX RADIUS                  | : | 1.969  | 1.886  | 1.501  |
| HORIZONTAL SPREAD           | : | 3.011  | 1.676  | 1.676  |
| VERTICAL SPREAD             | : | 2.869  | 2.869  | 2.220  |
| EXTREME SPREAD              | : | 3.515  | 3.079  | 2.617  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 7      |        |



25 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/06865723.1

## CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.785

VS= 3.335

GS= 4.346

| PATTERN #                     | 5      |        |       |
|-------------------------------|--------|--------|-------|
| SHOTS (BEST OF)               | 10     | 9      | 8     |
| MAXIMUM X                     | 2.421  | 2.463  | .387  |
| MINIMUM X                     | -1.364 | -1.095 | -.787 |
| MAXIMUM Y                     | 1.217  | .982   | .971  |
| MINIMUM Y                     | -2.118 | -.817  | -.829 |
| CENTROID X                    | .631   | .362   | .054  |
| CENTROID Y                    | -.219  | .016   | .027  |
| POA TO CENTROID in.           | .668   | .362   | .061  |
| MIN RADIUS                    | .421   | .341   | .294  |
| MEAN RADIUS                   | 1.269  | .944   | .686  |
| MAX RADIUS                    | 3.216  | 2.465  | .997  |
| HORIZONTAL SPREAD             | 3.785  | 3.558  | 1.174 |
| VERTICAL SPREAD               | 3.335  | 1.799  | 1.799 |
| EXTREME SPREAD                | 4.346  | 3.560  | 1.820 |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 8      |        |       |