

BARBER - M24 0102683

FORM

UPC



C6665799

*INCLUDES 1 IN CHAMBER

BARBER - M24 0102684

MODEL 760 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0102685

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665799

ORDER NO.

5716

20

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



5716 C6665799

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665799

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	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 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	LS
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-8-91	DA
	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		12-5-91	PL

op. #	BARBER NAME M24 0102687	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	12-6-91	SL
	G) Safety Off Force	4	4	4	4	4	12-6-91	SL
	H) Trigger Pull Test & Retainability						12-5-91	SL
	I) Firing Pin Indent	.021	.021	.021	.021	.021	12-6-91	SL
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	A
	L) Attach Front and Rear Sight Assemblies						12/6/91	RW
	M) Iron Sight Alignment						12/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	RW
	O) Attach Scope to Rifle						12/6/91	RW
	P) Detach & Attach Scope 20 Times						12/6/91	RW
640	Gallery Target & Test						12-6-91	AC
	A) Time						12-6-91	AC
	B) Malfunctions						12-6-91	AC
	C) Pierced Primers						12-6-91	AC
	D) Optical Clarity of Scope						12-6-91	AC
645	Inspect for Live Ammo						12-6-91	AC
655	Final Inspection						12-7-91	A
	A) Headspace						12-7-91	A
	B) Trigger Pull	255	251	247	250	237	12-7-91	DL
	C) Function						12-7-91	AC
660	Pack						12-18-91	V

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

SERIAL NO. C-6665799DATE 12-5-91TESTER JH

	2.50# -- INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.54	2.50	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.47	2.48	2.51	
PULL #3	2.25	2.50	2.51	2.47	
PULL #4	2.53	2.20	2.39	2.50	
PULL #5	2.58	2.58	2.44	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.50		
PULL #2	3.31	3.50		
PULL #3	3.38	3.55		
PULL #4	3.39	3.33		
PULL #5	3.44	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.30		4.22
PULL #2	4.40	4.19		4.30
PULL #3	4.30	4.35		4.26
PULL #4	4.23	4.28		4.20
PULL #5	4.35	4.29		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6665799
 6 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.0616117
1 TO	2	.138798
1 TO	3	.553954
1 TO	4	.138611
1 TO	5	.165895

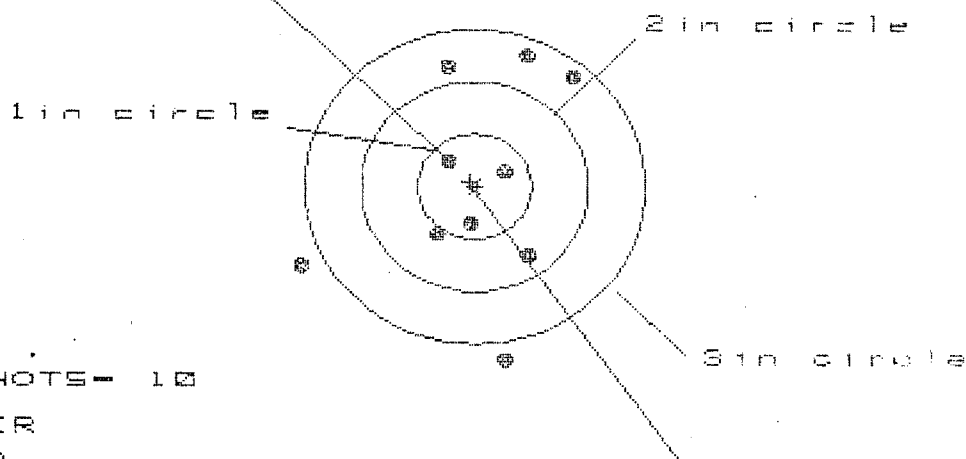
5³ <----POR

COORDINATE FOR THIS RIFLE IS: .0832
 COORDINATE FOR THIS RIFLE IS: -.0016
 AVERAGE POI RADIUS FOR THIS RIFLE IS: .0832134
 RIFLE IS: .936

FILE:/PATTERNING/CENTERFIRE_PATT/C6865789

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

CENTROID #

X = 2.384

Y = 2.920

Z = 2.956

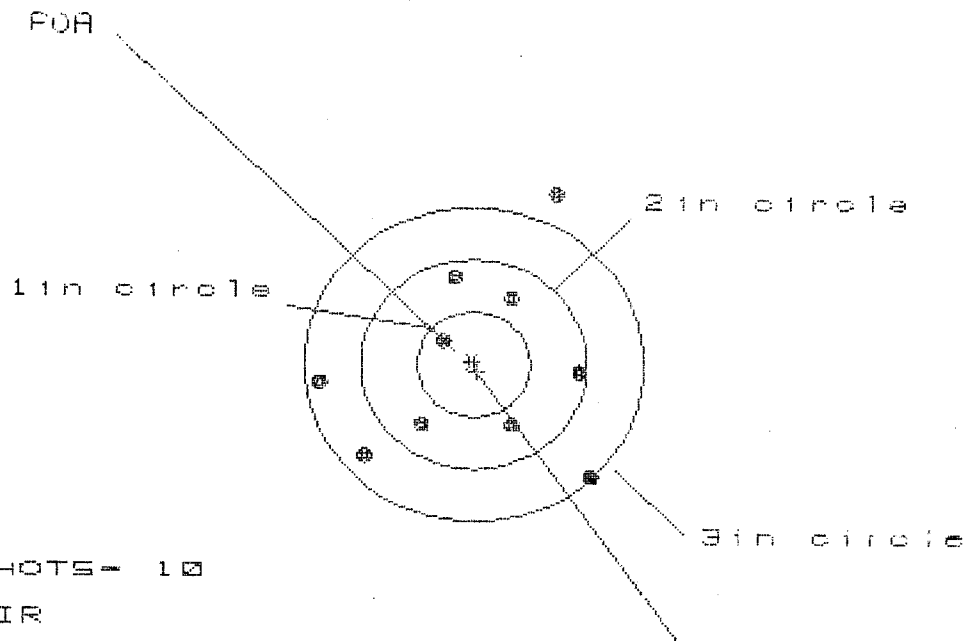
PATTERN #

1

SHOT OF	10	9	8
X	.853	.682	.700
Y	-1.532	-.544	-.526
Z	1.265	1.184	.967
W	-1.655	-1.736	-.927
V	.036	.207	.189
U	-.050	.031	.248
T	.062	.209	.312
S	.329	.143	.179
R	.967	.875	.763
Q	1.697	1.742	1.809
P	2.384	1.226	1.226
O	2.920	2.920	1.894
N	2.956	2.923	1.923
M	1 in H CIRCLE =	3	
L	2 in H CIRCLE =	5	
K	3 in H CIRCLE =	8	

FILE:/PATTERNING/CENTERFIRE_PATT/C8685799

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.371

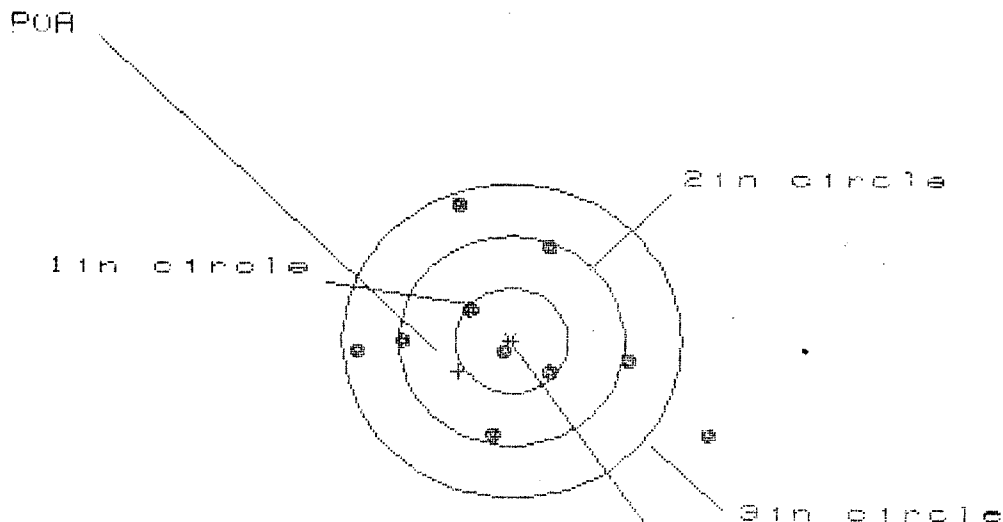
MS= 2.769

GS= 3.029

PATTERN #	1	2	3
BEST OF	10	9	8
MAXIMUM X	.984	1.063	1.139
MINIMUM X	-1.387	-1.308	-1.175
MAXIMUM Y	1.667	1.023	.909
MINIMUM Y	-1.102	-.917	-.800
CENTROID X	-.032	-.111	-.244
CENTROID Y	.071	-.114	.000
IN TO CENTROID in.	.078	.159	.244
ONE RADIUS	.370	.474	.322
TWO RADIUS	1.018	.921	.846
THREE RADIUS	1.811	1.404	1.181
ONE INCH SPREAD	2.371	2.371	2.314
TWO INCH SPREAD	2.769	1.940	1.709
THREE INCH SPREAD	3.029	2.542	2.317
ONE INCH INCH CIRCLE =		1	
TWO INCH INCH CIRCLE =		6	
THREE INCH INCH CIRCLE =		9	

FILE:/PATTERNING/CENTERFIRE_PATT/56865799

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 3.126

VS = 2.171

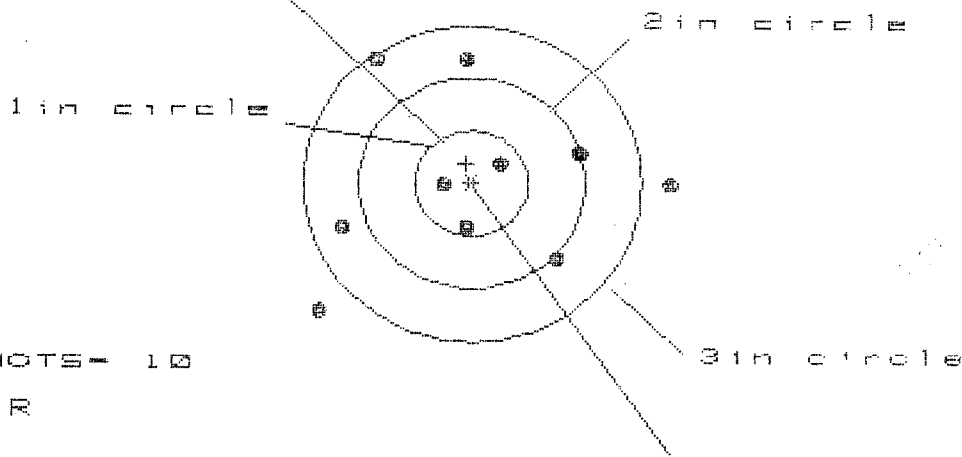
GS = 3.218

PATTERN #	3		
HITS (BEST OF)	10	9	8
MAXIMUM X	1.727	1.231	1.080
MINIMUM X	-1.399	-1.207	-.933
MAXIMUM Y	1.288	1.190	1.163
MINIMUM Y	-.883	-.952	-.980
CENTROID X	.467	.275	.426
CENTROID Y	.298	.396	.423
MAX. RADIUS CENTROID in.	.554	.482	.601
MIN. RADIUS	.124	.250	.237
MAX. RADIUS	.965	.847	.795
MIN. RADIUS	1.940	1.277	1.239
HORIZONTAL SPREAD	3.126	2.438	2.013
VERTICAL SPREAD	2.171	2.142	2.142
MEAN SPREAD	3.218	2.441	2.170
HITS IN ONE INCH CIRCLE =		2	
HITS IN TWO INCH CIRCLE =		6	
HITS IN THREE INCH CIRCLE =		9	

1 FILE:/PATTERNING/CENTERFIRE_PATT/C6665793

CENTERFIRE PATTERNS # 4

FOA



OF SHOTS- 10

IN CIR

1in = 3

2in = 3

3in = 4

XS= 3.141

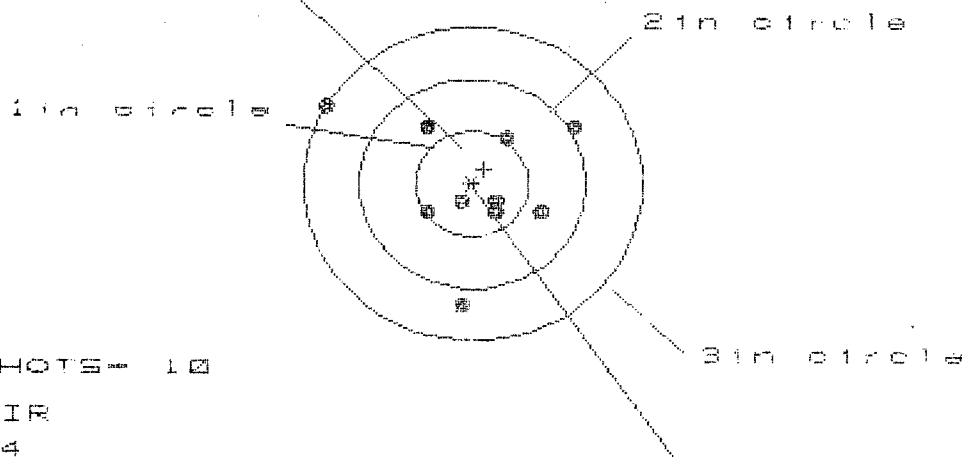
YS= 2.410

ZS= 3.349

CENTROID *

SPRN #	4	9	8
BEAT OF	10	9	8
MIN X	1.767	1.615	1.044
MIN Y	-1.374	-1.252	-1.051
MIN Z	1.205	1.071	1.049
MIN X	-1.205	-0.861	-0.883
MIN Y	0.049	0.201	-0.000
MIN Z	-0.188	-0.054	-0.032
CENTROID in.	0.194	0.208	0.032
SPRN	0.276	0.114	0.302
SPRN	1.049	0.953	0.867
SPRN	1.828	1.624	1.306
SPRN	3.141	2.867	2.095
SPRN	2.410	1.932	1.932
SPRN	3.349	2.919	2.489
ONE INCH CIRCLE	=	3	
TWO INCH CIRCLE	=	3	
THREE INCH CIRCLE	=	8	

FOH



OF SHOTS - 10

IF4 CIR

4-2-1964

210 - 7

3111 = 10

15- 2, 193

9 - 1.957

2-277

CENTROID A.

ITEM #	5		
BEETLE OFF	10	9	8
BEETLE	.934	.795	.767
BEETLE	-1.249	-.524	-.552
BEETLE	.764	.646	.508
BEETLE	-1.192	-1.108	-.300
BEETLE	-.104	.035	.063
BEETLE	-.139	-.223	-.085
BEETLE	.173	.226	.106
BEETLE	.234	.117	.201
BEETLE	.681	.564	.539
BEETLE	1.465	1.130	.904
BEETLE	2.183	1.319	1.319
BEETLE	1.957	1.754	.808
BEETLE	2.277	2.003	1.531
BEETLE	INCH	INCH	INCH
BEETLE	INCH	INCH	INCH
BEETLE	INCH	INCH	INCH