

BARBER - M24 0102917

FORM

UPC



0 47700 25716 7

C6665817

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0102919

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665817

ORDER NO.

5716

20

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



5716 C6665817

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

M-24

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665817

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KH
600	Proof		9/24/91	KH
607	Check Headspace		9/24/91	KH
610	Dis-assemble Gun		9/24/91	KH
612	Magnaflux Barrel Action	OCT 2 1991		KR
	Magnaflux Bolt	OCT 2 1991		KR
5	Rollmark Caliber	OCT 2 1991		28
617	Drill and Tap Sight Holes	OCT 2 1991		FB
618	Polish Barrel	OCT 2 1991		WB
620	Apply Coatings (Barrel Action)		10-14-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/25/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/25/91	KS
	C) Inspect Ejector Hole for Chamfer		10/25/91	KS
	D) Oil Firing Pin Ass'y		10/25/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		10/28/91	JA

op. #	BARBER - M24 0102921 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/2			10/28/91	WLB
	G) Safety Off Force	3	3	3			10/28/91	WLB
	H) Trigger Pull Test & Retainability						10/28/91	JH
	I) Firing Pin Indent	.022	.0215	.0215			10/28/91	WLB
	J) Assemble Stock						10/30/91	YK
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						10/30/91	YK
	M) Iron Sight Alignment						10/30/91	YK
	N) Detach Front & Rear Sights & place in numbered container						10/30/91	YK
	O) Attach Scope to Rifle						10/30/91	YK
	P) Detach & Attach Scope 20 Times						10/30/91	YK
640	Gallery Target & Test						10-31-91	AC
	A) Time						10-31-91	AC
	B) Malfunctions						10-31-91	AC
	C) Pierced Primers						10-31-91	AC
	D) Optical Clarity of Scope						10-31-91	AC
645	Inspect for Live Ammo						10-31-91	AC
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	266	257	248	247	246	11-5-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-19-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6665817DATE 10/28/91TESTER RL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.44	2.43	266	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.45	2.40	257	
PULL #3	2.44	2.49	2.48	248	
PULL #4	2.48	2.44	2.33	247	
PULL #5	2.64	2.46	2.44	246	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.29		
PULL #2	3.23	3.33		
PULL #3	3.25	3.25		
PULL #4	3.28	3.23		
PULL #5	3.59	3.18		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.27		4.45
PULL #2	4.48	4.46		4.36
PULL #3	4.34	4.43		4.45
PULL #4	4.21	4.27		4.48
PULL #5	4.31	4.30		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665817
31 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.280585
1 TO	2	.617785
1 TO	3	.609147
1 TO	4	.380426
1 TO	5	.521196

52
3.1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1814
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0156
THE RESULTING AVERAGE POI RELIUS FOR THIS RIFLE IS: .18207

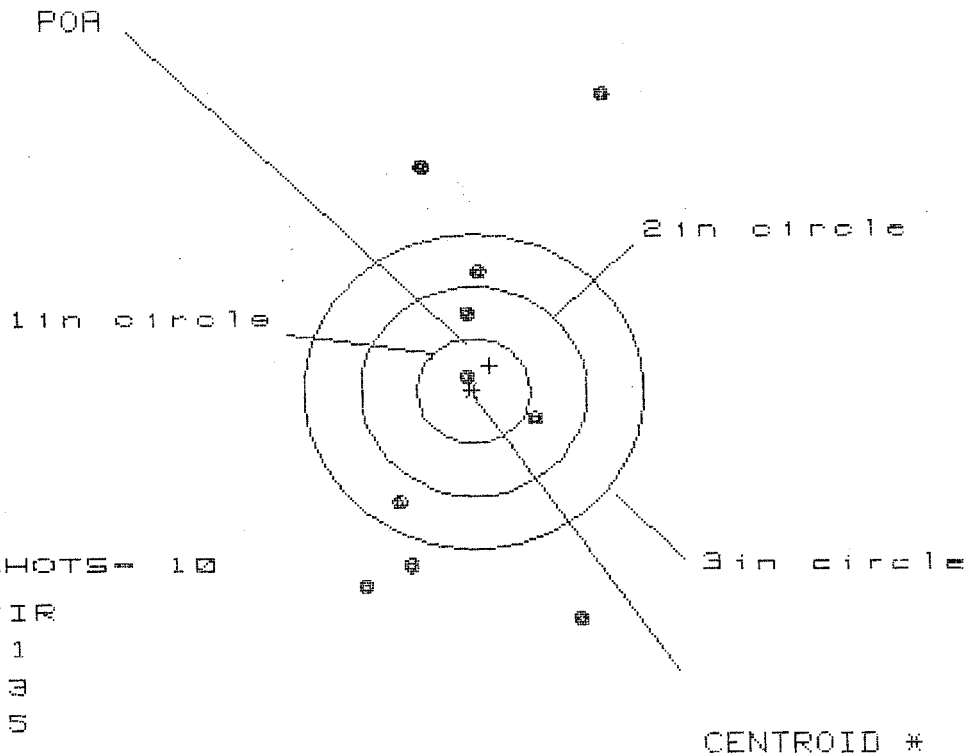
THE AMR FOR THIS RIFLE IS: 1.321

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685817

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 2.094

VS= 4.934

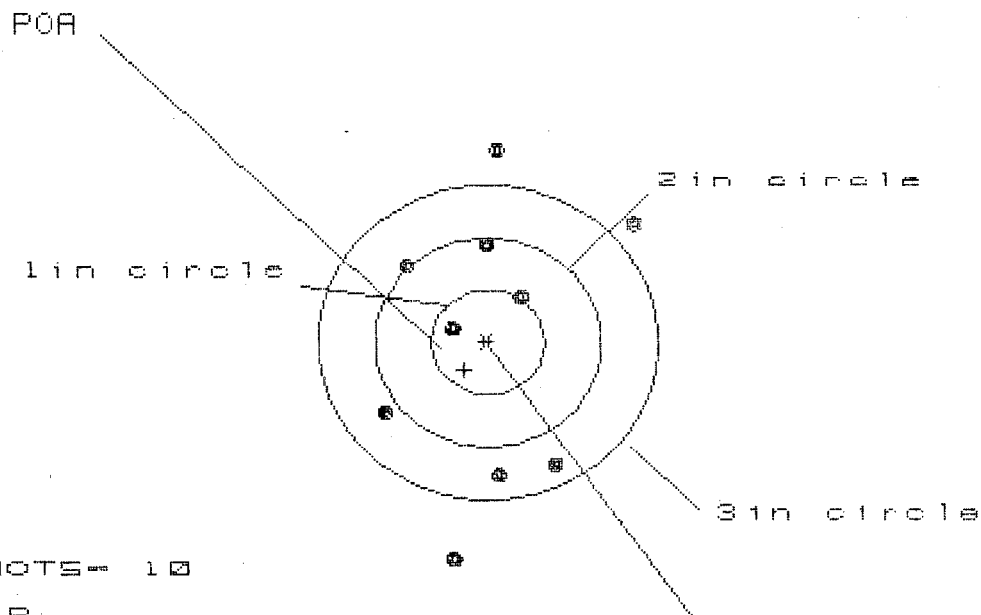
GS= 5.137

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.184	1.042	.774
MINIMUM X	-.910	-.779	-.649
MAXIMUM Y	2.826	2.484	2.260
MINIMUM Y	-2.108	-1.794	-1.775
CENTROID X	-.142	-.273	-.404
CENTROID Y	-.242	-.556	-.332
POA TO CENTROID in.	.281	.620	.523
MIN RADIUS	.118	.440	.309
MEAN RADIUS	1.532	1.372	1.266
MAX RADIUS	3.064	2.500	2.265
HORIZONTAL SPREAD	2.094	1.821	1.423
VERTICAL SPREAD	4.934	4.278	4.035
EXTREME SPREAD	5.137	4.478	4.066
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	5		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665817

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.231

VS= 3.899

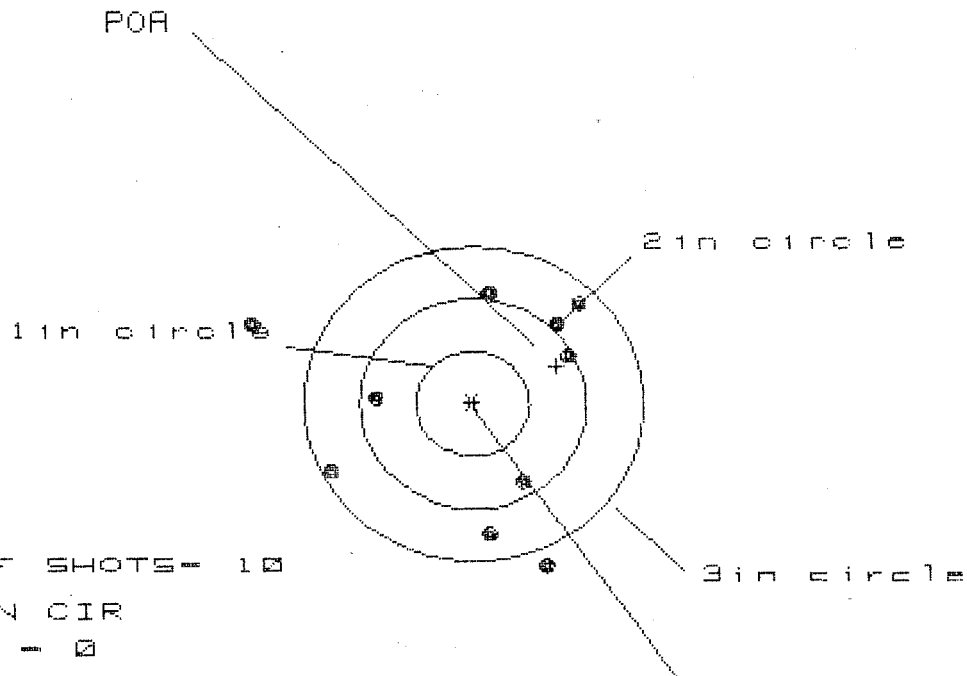
GS= 3.914

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.315	1.284	1.288
MINIMUM X	-.916	-.947	-.942
MAXIMUM Y	1.840	1.611	1.057
MINIMUM Y	-2.059	-1.468	-1.267
CENTROID X	.211	.242	.237
CENTROID Y	.265	.494	.293
POA TO CENTROID in.	.339	.550	.377
MIN RADIUS	.383	.312	.320
MEAN RADIUS	1.202	1.070	1.012
MAX RADIUS	2.078	1.611	1.667
HORIZONTAL SPREAD	2.231	2.231	2.231
VERTICAL SPREAD	3.899	3.079	2.324
EXTREME SPREAD	3.914	3.079	2.837
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665817

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.958

VS= 2.521

GS= 3.481

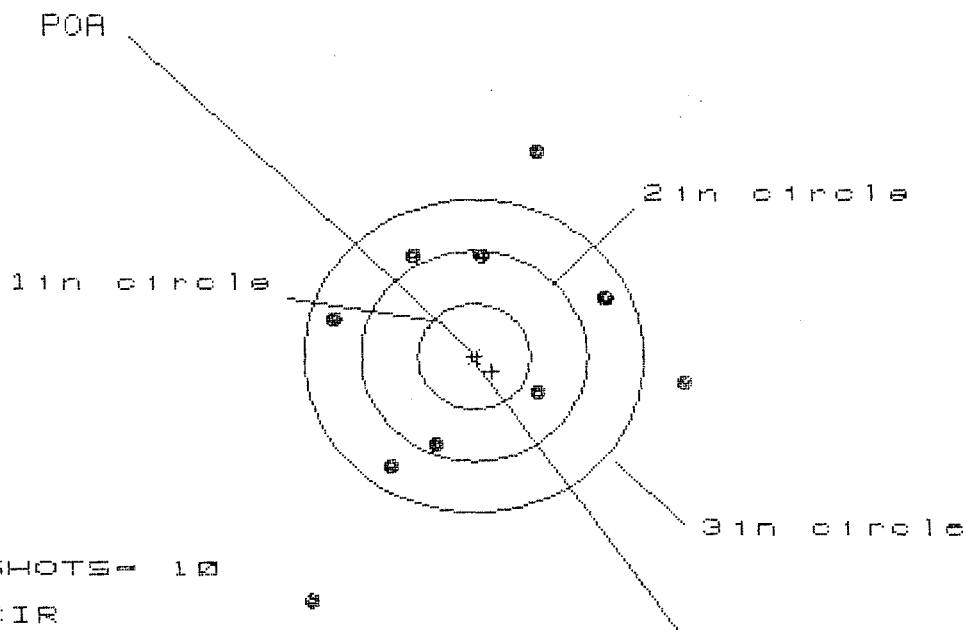
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.986	.766	.825
MINIMUM X	-1.972	-1.459	-1.480
MAXIMUM Y	1.019	1.101	.924
MINIMUM Y	-1.502	-1.420	-1.294
CENTROID X	-.740	-.520	-.579
CENTROID Y	-.358	-.440	-.263
POA TO CENTROID in.	.822	.682	.636
MIN RADIUS	.852	.672	.758
MEAN RADIUS	1.255	1.132	1.071
MAX RADIUS	2.108	1.554	1.571
HORIZONTAL SPREAD	2.958	2.225	2.225
VERTICAL SPREAD	2.521	2.521	2.218
EXTREME SPREAD	3.481	2.722	2.722
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665017

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.279

VS = 4.265

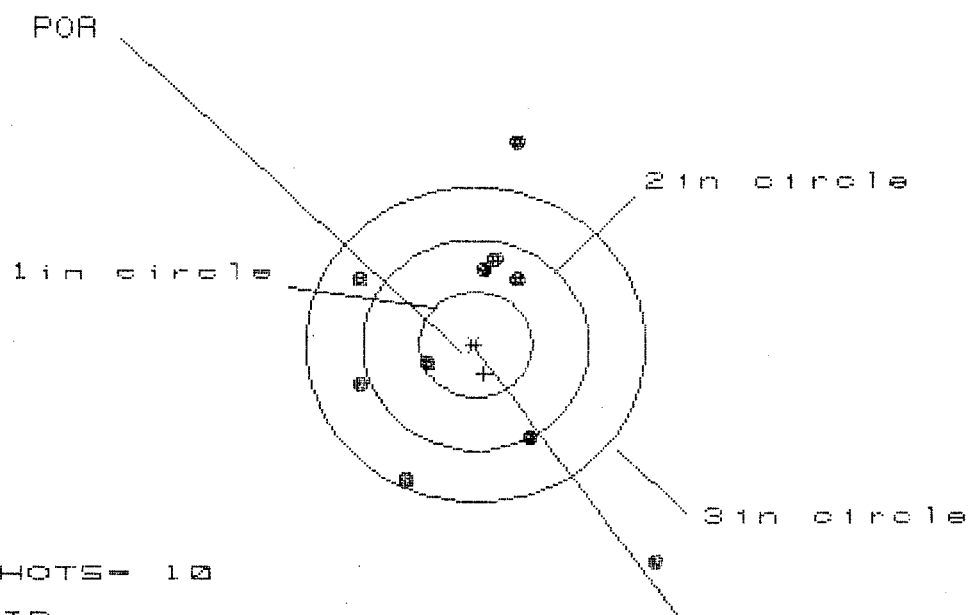
GS = 4.683

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.877	1.721	1.768
MINIMUM X	:	-1.402	-1.395	-1.348
MAXIMUM Y	:	1.914	1.653	.948
MINIMUM Y	:	-2.351	-1.325	-1.119
CENTROID X	:	-.160	-.004	-.051
CENTROID Y	:	.138	.399	.193
POA TO CENTROID in.	:	.211	.399	.199
MIN RADIUS	:	.671	.724	.620
MEAN RADIUS	:	1.421	1.248	1.182
MAX RADIUS	:	2.737	1.797	1.795
HORIZONTAL SPREAD	:	3.279	3.116	3.116
VERTICAL SPREAD	:	4.265	2.978	2.067
EXTREME SPREAD	:	4.683	3.233	3.184
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	7		

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665817

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.630

VS= 3.966

GS= 4.144

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.598	.690	.762
MINIMUM X	-1.032	-.855	-.783
MAXIMUM Y	1.923	1.696	.765
MINIMUM Y	-2.043	-1.512	-1.300
CENTROID X	-.076	-.253	-.325
CENTROID Y	.275	.502	.289
POA TO CENTROID in.	.285	.562	.435
MIN RADIUS	.406	.419	.203
MEAN RADIUS	1.197	.994	.887
MAX RADIUS	2.593	1.791	1.358
HORIZONTAL SPREAD	2.630	1.545	1.545
VERTICAL SPREAD	3.966	3.208	2.064
EXTREME SPREAD	4.144	3.373	2.215
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665817
5 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.371529
1 TO	2	.539075
1 TO	3	.391564
1 TO	4	.473178
1 TO	5	.669347

SP, <----POA

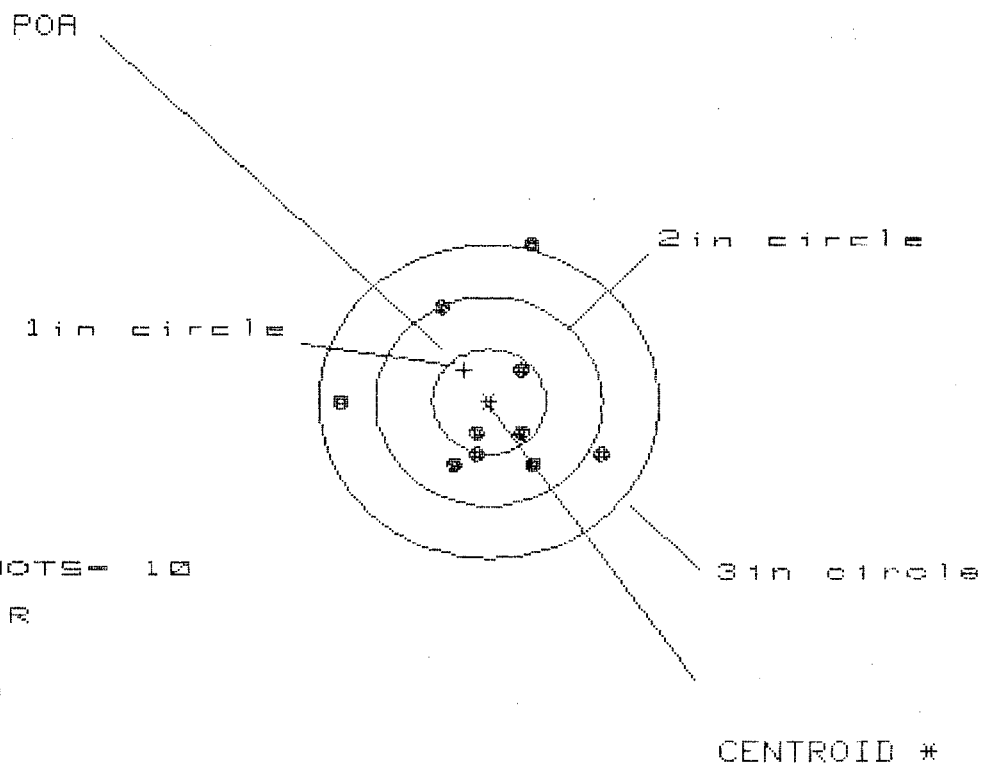
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0796
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0376
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0880336
THE AMR FOR THIS RIFLE IS: .9498

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665817.1

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 9

HS= 2.299

VS= 2.141

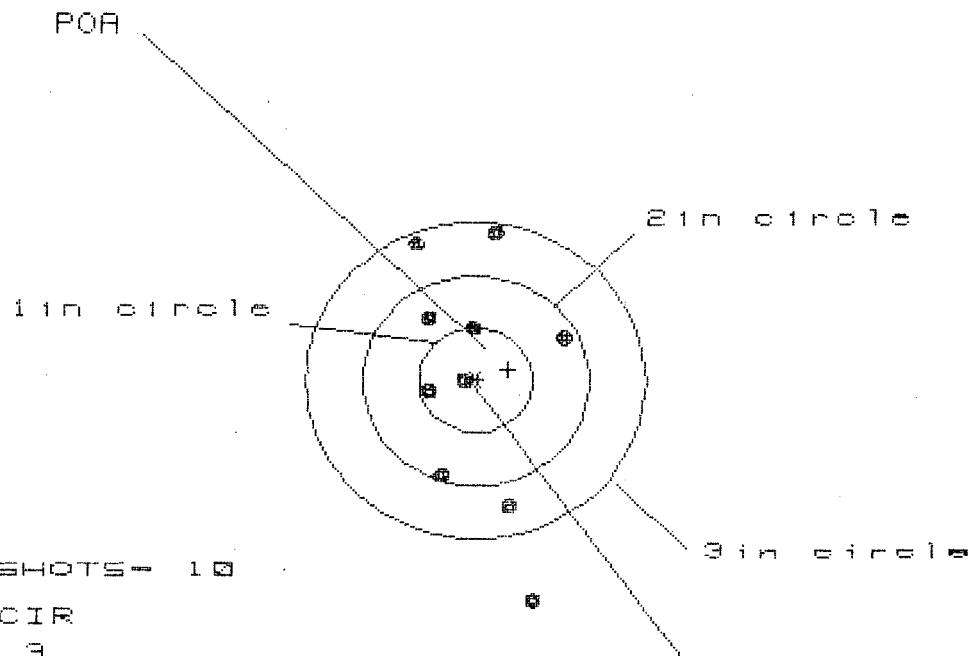
GS= 2.356

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.987	1.029	.870
MINIMUM X	:	-1.312	-1.270	-.555
MAXIMUM Y	:	1.541	1.098	1.122
MINIMUM Y	:	-.600	-.429	-.405
CENTROID X	:	.215	.173	.332
CENTROID Y	:	-.303	-.474	-.498
POA TO CENTROID in.	:	.371	.505	.598
MIN RADIUS	:	.329	.162	.219
MEAN RADIUS	:	.809	.674	.579
MAX RADIUS	:	1.587	1.284	1.251
HORIZONTAL SPREAD	:	2.299	2.299	1.425
VERTICAL SPREAD	:	2.141	1.527	1.527
EXTREME SPREAD	:	2.356	2.356	2.012
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665817.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.315

VS = 3.579

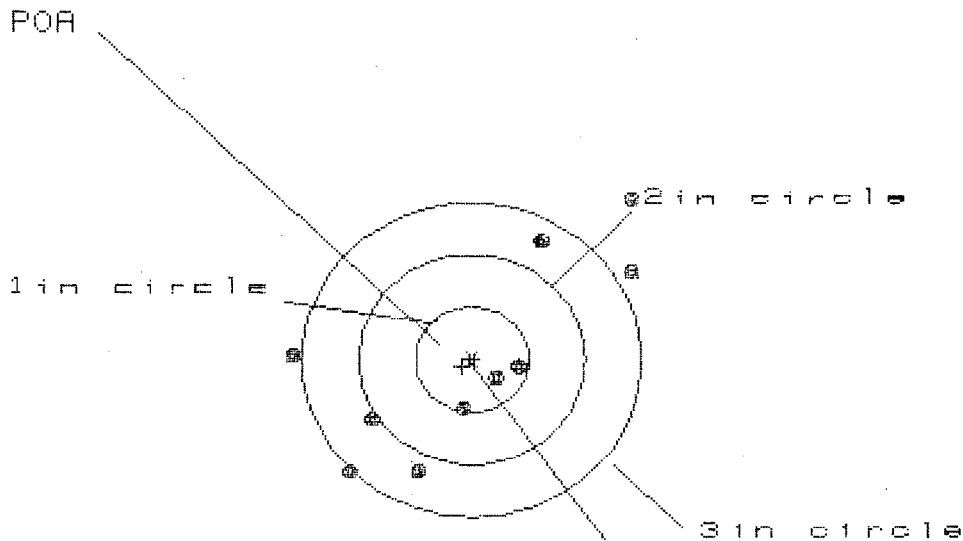
GS = 3.627

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.785	.842	.874
MINIMUM X	:	-.538	-.473	-.441
MAXIMUM Y	:	1.449	1.212	1.259
MINIMUM Y	:	-2.130	-1.436	-1.284
CENTROID X	:	-.286	-.343	-.375
CENTROID Y	:	-.104	.133	-.019
POA TO CENTROID in.	:	.384	.368	.376
MIN RADIUS	:	.113	.206	.051
MEAN RADIUS	:	.991	.818	.754
MAX RADIUS	:	2.191	1.476	1.338
HORIZONTAL SPREAD	:	1.315	1.315	1.315
VERTICAL SPREAD	:	3.579	2.648	2.543
EXTREME SPREAD	:	3.627	2.671	2.671
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685817.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 5

HS= 3.016

VS= 2.616

GS= 3.629

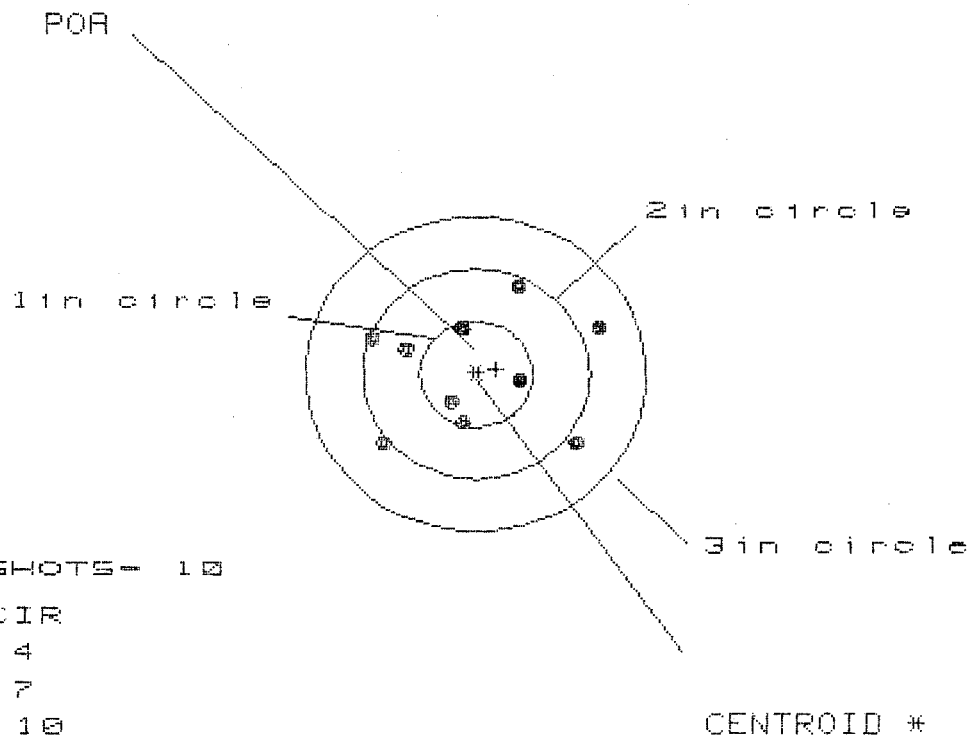
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.432	1.590	.955
MINIMUM X	:	-1.584	-1.426	-1.227
MAXIMUM Y	:	1.506	1.306	1.426
MINIMUM Y	:	-1.110	-.943	-.823
CENTROID X	:	.084	-.073	-.272
CENTROID Y	:	.066	-.101	-.221
POA TO CENTROID in.	:	.107	.125	.350
MIN RADIUS	:	.233	.333	.338
MEAN RADIUS	:	1.151	1.019	.895
MAX RADIUS	:	2.069	1.856	1.716
HORIZONTAL SPREAD	:	3.016	3.016	2.182
VERTICAL SPREAD	:	2.616	2.249	2.249
EXTREME SPREAD	:	3.629	3.163	2.816
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			5	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665817.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 4

2in - 7

3in = 10

HS= 1.944

VS= 1.531

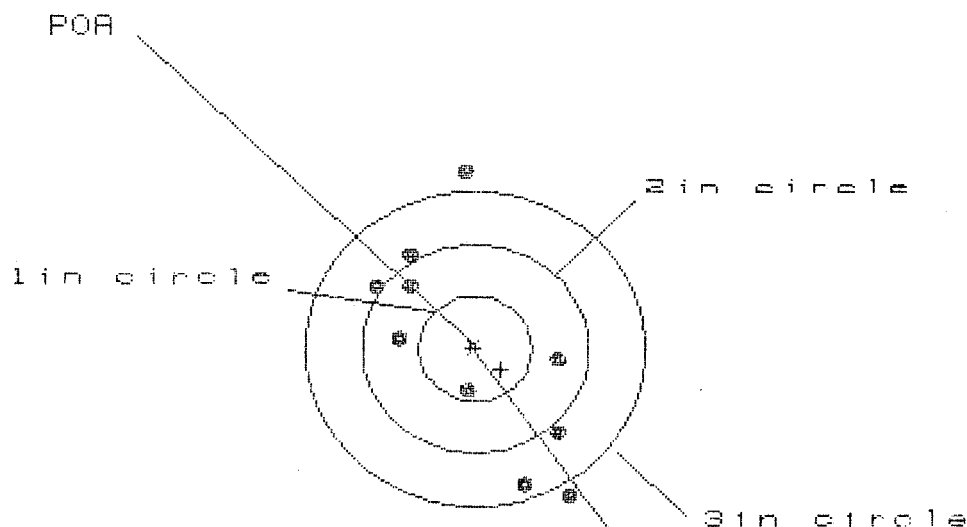
GS= 2.182

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	1.010	.919
MINIMUM X	-.898	-.781	-.872
MAXIMUM Y	.826	.870	.787
MINIMUM Y	-.705	-.661	-.650
CENTROID X	-.181	-.298	-.207
CENTROID Y	-.044	-.088	-.005
POA TO CENTROID in.	.186	.310	.207
MIN RADIUS	.304	.210	.323
MEAN RADIUS	.741	.684	.648
MAX RADIUS	1.119	1.158	1.126
HORIZONTAL SPREAD	1.944	1.791	1.791
VERTICAL SPREAD	1.531	1.531	1.437
EXTREME SPREAD	2.182	2.009	2.009
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865817.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 1

3in = 8

HS= 1.723

VS= 3.081

GS= 3.231

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.877	.867	.835
MINIMUM X	-.846	-.856	-.748
MAXIMUM Y	1.702	1.125	.976
MINIMUM Y	-1.379	-1.189	-1.255
CENTROID X	-.230	-.220	-.328
CENTROID Y	.197	.008	.157
POA TO CENTROID in.	.303	.220	.364
MIN RADIUS	.432	.249	.390
MEAN RADIUS	1.057	.967	.893
MAX RADIUS	1.705	1.472	1.372
HORIZONTAL SPREAD	1.723	1.723	1.583
VERTICAL SPREAD	3.081	2.314	2.231
EXTREME SPREAD	3.231	2.709	2.446
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		