

Speed®

FORM

UPC



06665883

BARBER - M24 0103643

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CALIBER

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665883

ORDER NO.

5716

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

20



5716 C6665883

ORDER 5716

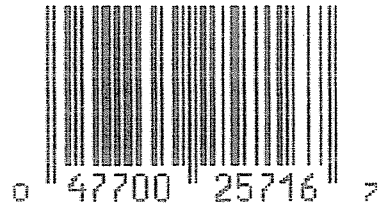
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CCCC5883

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/26/91	KH
600	Proof		9/26/91	KH
607	Check Headspace		9/26/91	KH
610	Dis-assemble Gun		9/26/91	KH
612	Magnaflux Barrel Action		OCT 4 1991	KCD
	Magnaflux Bolt		OCT 4 1991	KCD
615	Rollmark Caliber		OCT 4 1991	CS
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	TH
	Apply Coating (Bolt)		10-18-91	TH
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	KH
	C) Inspect Ejector Hole for Chamfer		11/11/91	KH
	D) Oil Firing Pin Ass'y		11/11/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-91	GH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			11-12-91	JK
	G) Safety Off Force	4	4				11-12-91	JK
	H) Trigger Pull Test & Retainability						11-12-91	JK
	I) Firing Pin Indent	.021	.021	.021			11-12-91	JK
	J) Assemble Stock						11/12/91	JK
	K) Assemble Swivel Studs						11-24-91	JK
	L) Attach Front and Rear Sight Assemblies						11/12/91	JK
	M) Iron Sight Alignment						11/12/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/12/91	JK
	O) Attach Scope to Rifle						11/12/91	JK
	P) Detach & Attach Scope 20 Times						11/12/91	JK
640	Gallery Target & Test						11-21-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-21-91	NF
655	Final Inspection							
	A) Headspace						11-26-91	JK
	B) Trigger Pull	288	288	278	277	277	11-22-91	D/H
	C) Function						11-26-91	JK
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665883DATE 11-12-91TESTER GU.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.57	2.55	2.88	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.55	2.53	2.88	
PULL #3	2.54	2.63	2.50	2.78	
PULL #4	2.56	2.61	2.58	2.77	
PULL #5	2.66	2.53	2.56	2.77	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.20		
PULL #2	3.44	3.35		
PULL #3	3.47	3.45		
PULL #4	3.49	3.52		
PULL #5	3.24	3.47		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.38		4.30
PULL #2	4.39	4.21		4.30
PULL #3	4.23	4.36		4.46
PULL #4	4.27	4.40		4.31
PULL #5	4.33	4.30		4.45
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665883
22 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.121696
1 TO	2	.209898
1 TO	3	.202675
1 TO	4	.230098
1 TO	5	.123102

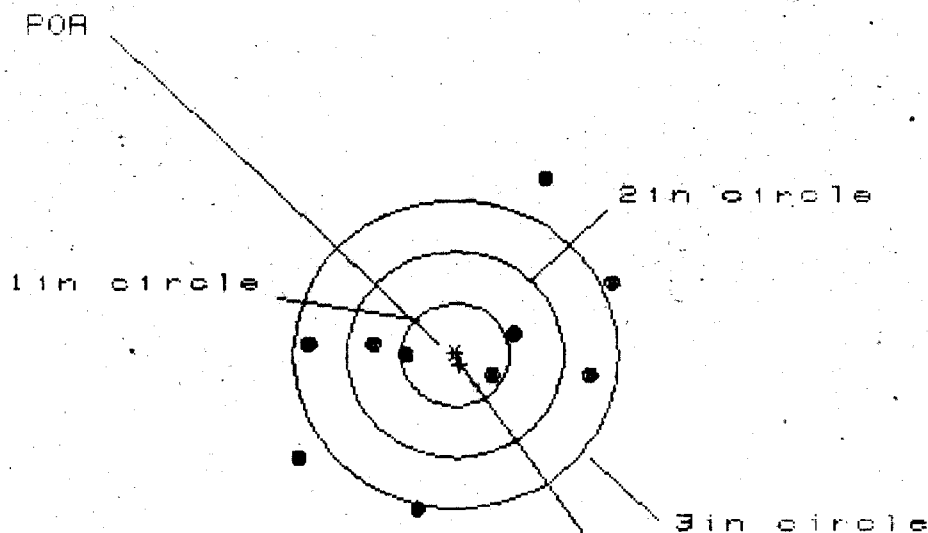
<----POA

THE WEIGHTED AVERAGE FOR THIS RIFLE IS: .0442
THE WEIGHTED AVERAGE FOR THIS RIFLE IS: .0888
THE WEIGHTED AVERAGE FOR RADIUS FOR THIS RIFLE IS: .0991921
THE WEIGHTED AVERAGE FOR THIS RIFLE IS: 1.088

C 666 1091

FILE:/PATTERNING/CENTERFIRE_PATT/C6665883

CENTERFIRE PATTERNS * 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 6

HS = 2.989

VS = 3.200

GS = 3.577

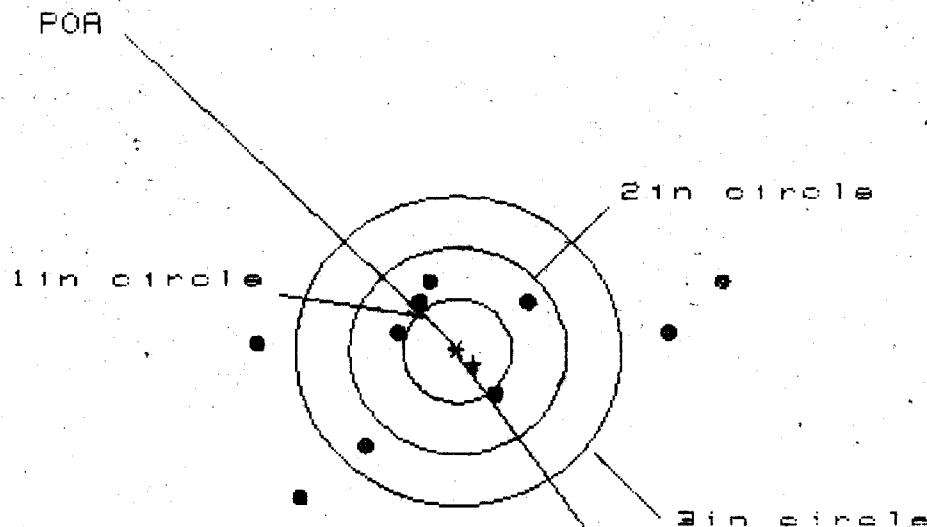
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.482	1.576	1.399
MINIMUM X	:	-1.507	-1.413	-1.464
MAXIMUM Y	:	1.733	.894	.797
MINIMUM Y	:	-1.467	-1.274	-1.371
CENTROID X	:	-.040	-.134	.043
CENTROID Y	:	.094	-.099	-.002
POS TO CENTROID in.	:	.102	.166	.043
MIN RADIUS	:	.437	.427	.322
MEAN RADIUS	:	1.174	1.084	.997
MAX RADIUS	:	1.927	1.812	1.611
HORIZONTAL SPREAD	:	2.989	2.989	2.863
VERTICAL SPREAD	:	3.200	2.168	2.168
EXTREME SPREAD	:	3.577	3.421	2.933
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

22 Nov 1991

FILE:/PATTERNS/CENTERFIRE_PAT/06665683

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 6

HS = 4.322

VS = 2.165

GS = 4.504

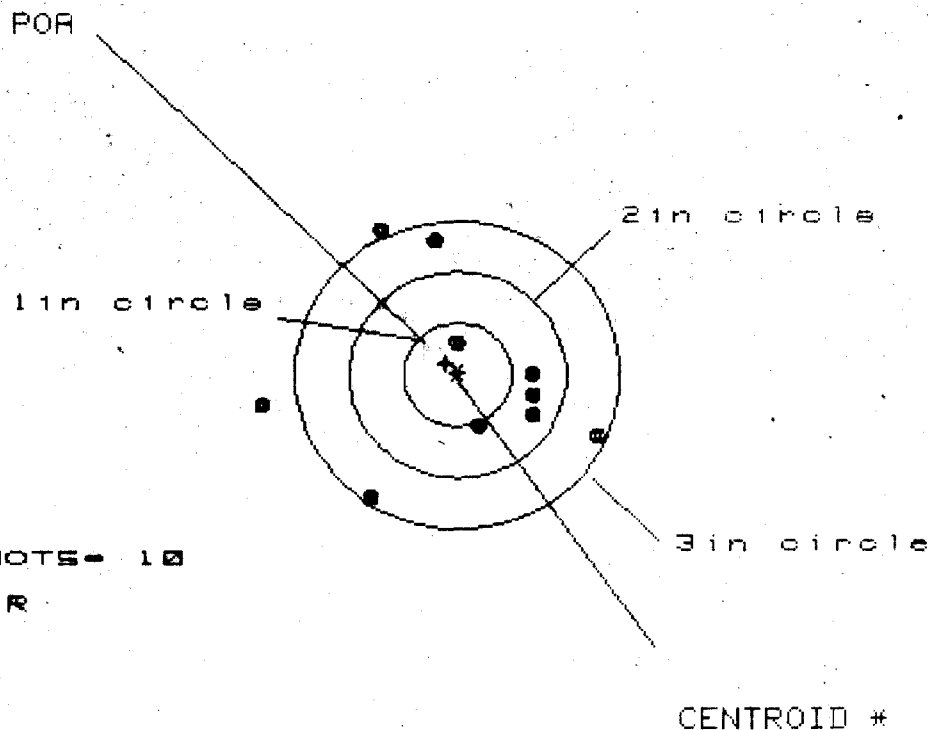
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.476	2.182	2.032
MINIMUM X	-1.846	-1.570	-1.720
MAXIMUM Y	.712	.789	.617
MINIMUM Y	-1.453	-1.374	-1.026
CENTROID X	-.145	-.421	-.271
CENTROID Y	.120	.041	.213
POA TO CENTROID in.	.189	.423	.344
MIN RADIUS	.535	.328	.394
MEAN RADIUS	1.291	1.121	1.004
MAX RADIUS	2.577	2.194	2.033
HORIZONTAL SPREAD	4.322	3.752	3.752
VERTICAL SPREAD	2.165	2.163	1.643
EXTREME SPREAD	4.504	3.752	3.752
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

22 Nov 1991

FILE:/PATTERNS/CENTERFIRE_PATT/C6665883

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.123

VS = 2.618

GS = 3.130

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.265	1.059	.947
MINIMUM X	:	-1.858	-.984	-1.096
MAXIMUM Y	:	1.419	1.383	1.489
MINIMUM Y	:	-1.199	-1.235	-1.062
CENTROID X	:	.109	.315	.427
CENTROID Y	:	-.112	-.076	-.249
POA TO CENTROID in.	:	.156	.324	.494
MIN RADIUS	:	.356	.391	.353
MEAN RADIUS	:	1.071	.933	.791
MAX RADIUS	:	1.887	1.648	1.574
HORIZONTAL SPREAD	:	3.123	2.043	2.043
VERTICAL SPREAD	:	2.618	2.618	2.551
EXTREME SPREAD	:	3.130	2.770	2.617
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C08045803

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.961

VS= 3.578

GS= 3.679

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.850	.794	.801
MINIMUM X	:	-1.111	-1.167	-1.068
MAXIMUM Y	:	1.285	1.031	.849
MINIMUM Y	:	-2.292	-1.452	-.839
CENTROID X	:	.214	.270	.171
CENTROID Y	:	.253	.508	.690
POA TO CENTROID in.	:	.332	.575	.711
MIN RADIUS	:	.380	.526	.320
MEAN RADIUS	:	1.091	.910	.780
MAX RADIUS	:	2.348	1.655	1.160
HORIZONTAL SPREAD	:	1.961	1.961	1.869
VERTICAL SPREAD	:	3.578	2.483	1.688
EXTREME SPREAD	:	3.679	2.533	2.000
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665683

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.618

VS= 2.368

GS= 2.380

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.806	.800	.828
MINIMUM X	:	-.812	-.818	-.790
MAXIMUM Y	:	.960	.803	.661
MINIMUM Y	:	-1.403	-1.139	-.807
CENTROID X	:	.083	.089	.062
CENTROID Y	:	.089	.246	.388
POA TO CENTROID in.	:	.122	.261	.393
MIN RADIUS	:	.168	.189	.238
MEAN RADIUS	:	.808	.711	.635
MAX RADIUS	:	1.409	1.159	1.130
HORIZONTAL SPREAD	:	1.618	1.618	1.618
VERTICAL SPREAD	:	2.368	1.942	1.468
EXTREME SPREAD	:	2.380	1.942	1.905
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	8		
NUMBER IN THREE INCH CIRCLE =	:	10		