

FORM

UPC



C66666011

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

BARBER - M24 0104996

Remington



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

MODEL 700TM M24

SERIAL NO.

C6666011

ORDER NO.

5716

20

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



5716 C6666011

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 #

C6666011

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	Kd
600	Proof		9/30/91	Kd
607	Check Headspace		9/30/91	Kd
610	Dis-assemble Gun		9/30/91	Kd
612	Magnaflux Barrel Action	OCT	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	GB
617	Drill and Tap Sight Holes	OCT	8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	Kd
	Apply Coating (Bolt)		11/1/91	Kd
625	Final Assembly A) Clean inside of Bolt Assembly		11/1/91	Kd
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/1/91	Kd
	C) Inspect Ejector Hole for Chamfer		11/1/91	Kd
	D) Oil Firing Pin Ass'y		11/1/91	Kd
	E) Adjust Trigger Pull to Min Setting and Stake		11-4-91	Kd

op. #	BARBER - M24 0104998		READINGS					DATE	INIT
	OP. NAME								
625 cont.	F) Safety On Force		5	5	5			11-4-91	JK
	G) Safety Off Force		4	4	4			11-4-91	JK
	H) Trigger Pull Test & Retainability							11-4-91	JK
	I) Firing Pin Indent		.021	.021	.021			11-4-91	JK
	J) Assemble Stock							11-4-91	JK
	K) Assemble Swivel Studs							11-12-91	K
	L) Attach Front and Rear Sight Assemblies							11-4-91	JK
	M) Iron Sight Alignment							11-4-91	JK
	N) Detach Front & Rear Sights & place in numbered container							11-4-91	JK
	O) Attach Scope to Rifle							11-4-91	JK
	P) Detach & Attach Scope 20 Times							11-4-91	JK
640	Gallery Target & Test							11-5-91	AC
	A) Time							11-5-91	AC
	B) Malfunctions							11-5-91	AC
	C) Pierced Primers							11-5-91	AC
	D) Optical Clarity of Scope							11-5-91	AC
645	Inspect for Live Ammo							11-5-91	AC
655	Final Inspection								
	A) Headspace							11-12-91	K
	B) Trigger Pull		2.37	2.36	2.40	2.32	2.46	11-6-91	DIH
	C) Function							11-12-91	AC
660	Pack							12-19-91	NE

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

SERIAL NO. C666011
DATE 11-4-91
TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.43	2.46	237	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.31	2.38	236	
PULL #3	2.42	2.44	2.42	240	
PULL #4	2.51	2.46	2.48	232	
PULL #5	2.49	2.37	2.35	246	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.65	3.48		
PULL #2	3.55	3.32		
PULL #3	3.55	3.38		
PULL #4	3.55	3.28		
PULL #5	3.46	3.37		
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	4.51		4.40
PULL #2	4.44	4.36		4.43
PULL #3	4.41	4.49		4.50
PULL #4	4.32	4.49		4.30
PULL #5	4.47	4.40		4.51
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666011
5 Nov 1991

CENTROIDAL DISTANCES

0	TO	1	.124423
1	TO	2	.115663
1	TO	3	.0790759
1	TO	4	.256702
1	TO	5	.386683

POI ←-----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0892
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0956033
THE AMR FOR THIS RIFLE IS: .9636

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C866601

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.537

VS= 2.619

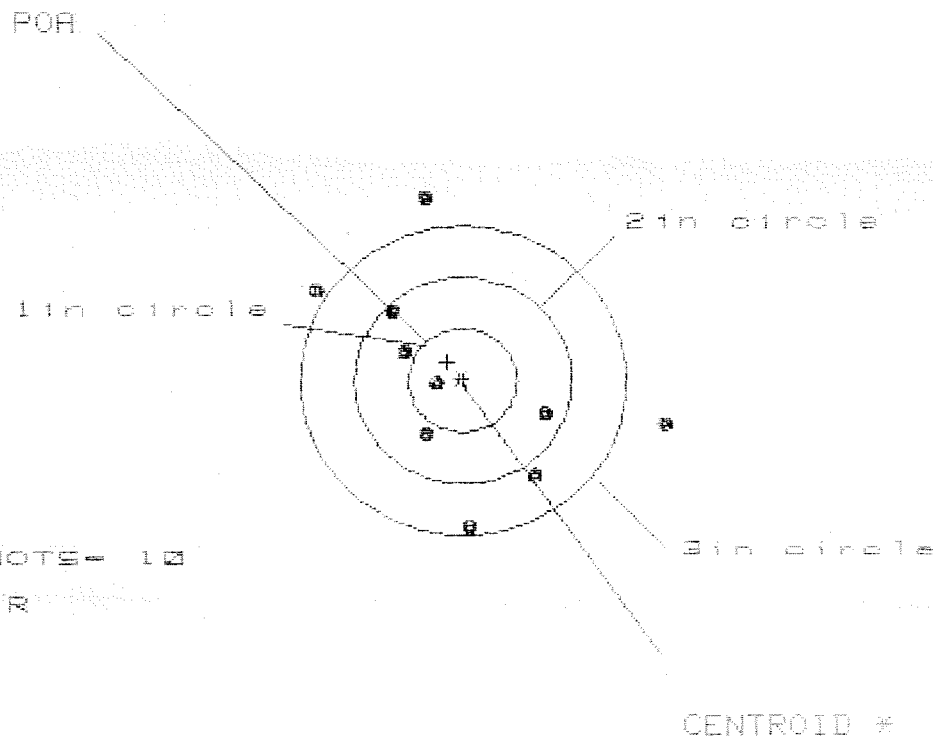
GS= 3.022

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.517	1.432	1.186
MINIMUM X	:	-1.020	-1.105	-.926
MAXIMUM Y	:	1.540	.845	.879
MINIMUM Y	:	-1.079	-.908	-.874
CENTROID X	:	.045	.130	-.049
CENTROID Y	:	-.116	-.297	-.321
POA TO CENTROID in.	:	.125	.315	.325
MIN RADIUS	:	.431	.514	.349
MEAN RADIUS	:	1.001	.923	.819
MAX RADIUS	:	1.721	1.457	1.346
HORIZONTAL SPREAD	:	2.537	2.537	2.112
VERTICAL SPREAD	:	2.619	1.753	1.753
EXTREME SPREAD	:	3.022	2.572	2.175
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

5 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0865001

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 7

HS = 3.201

VS = 3.188

GS = 3.453

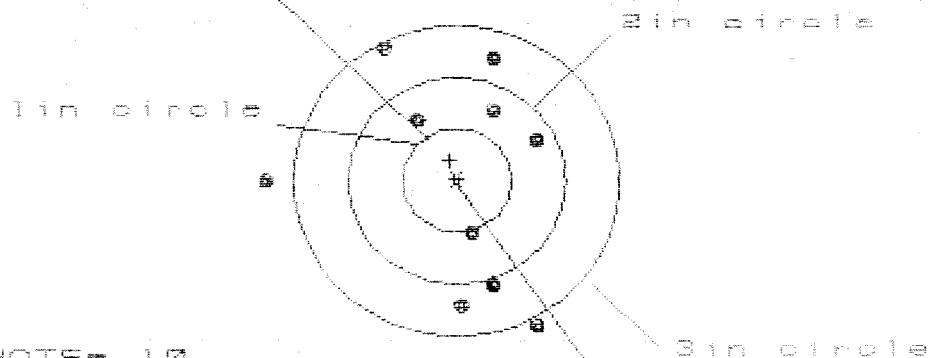
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.843	.992	.975
MINIMUM X	:	-1.358	-1.134	-1.171
MAXIMUM Y	:	1.772	1.728	1.068
MINIMUM Y	:	-1.416	-1.460	-1.244
CENTROID X	:	.142	-.062	-.045
CENTROID Y	:	-.179	-.135	-.351
POA TO CENTROID in.	:	.229	.148	.353
MIN RADIUS	:	.233	.070	.158
MEAN RADIUS	:	1.110	.982	.882
MAX RADIUS	:	1.885	1.733	1.585
HORIZONTAL SPREAD	:	3.201	2.146	2.146
VERTICAL SPREAD	:	3.188	3.188	2.312
EXTREME SPREAD	:	3.453	3.217	2.725
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06680011

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.499

VS= 2.731

GS= 3.083

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.759
MINIMUM X	-1.740
MAXIMUM Y	1.285
MINIMUM Y	-1.446
CENTROID X	.063
CENTROID Y	-.193
POA TO CENTROID in.	.203
MIN RADIUS	.488
MEAN RADIUS	1.108
MAX RADIUS	1.740
HORIZONTAL SPREAD	2.499
VERTICAL SPREAD	2.731
EXTREME SPREAD	3.083
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	5

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8686011

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HE= 1.923

VE= 1.633

GS= 2.232

CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	.884	.982
MINIMUM X	-.963	-1.039	-.941
MAXIMUM Y	.970	.867	.950
MINIMUM Y	-.663	-.555	-.447
CENTROID X	-.069	.007	-.091
CENTROID Y	.114	.006	-.102
POA TO CENTROID in.	.133	.009	.137
MIN RADIUS	.244	.170	.027
MEAN RADIUS	.764	.698	.594
MAX RADIUS	1.198	1.171	1.034
HORIZONTAL SPREAD	1.923	1.923	1.923
VERTICAL SPREAD	1.633	1.422	1.397
EXTREME SPREAD	2.232	2.138	1.932
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

3 Nov 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C666601

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.892

VS= 1.515

GS= 2.192

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.897

.787

.875

MINIMUM X

-.995

-.835

-.747

MAXIMUM Y

.684

.624

.569

MINIMUM Y

-.831

-.891

-.814

CENTROID X

.265

.375

.287

CENTROID Y

.202

.262

.184

POA TO CENTROID in.

.333

.458

.341

MIN RADIUS

.434

.358

.445

MEAN RADIUS

.835

.794

.771

MAX RADIUS

1.134

1.040

.952

HORIZONTAL SPREAD

1.892

1.622

1.622

VERTICAL SPREAD

1.515

1.515

1.374

EXTREME SPREAD

2.192

1.962

1.815

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

10