

FORM

UPC



0 47700 25716 7

C6649022

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARBER - M24

5716

ORDER NO.

LENGTH

MODEL 700 TM M24

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**

C6649022

ORDER NO.**5716**

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

20



5716 C6649022

ORDER 5716

MODEL 700™ M24

UPC**ORDER 5716**

MODEL 700™ M24

UPC

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649022

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action 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 Action	OCT	3 1991	KCD
	Magnaflux Bolt	OCT	3 1991	KCD
615	Rollmark Caliber	OCT	3 1991	GS
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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-25-91	JH

op. #	BARBER - M24 0030736 OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	6	6	11-26-91	JH
	G) Safety Off Force	3	3	3	11-26-91	JH
	H) Trigger Pull Test & Retainability				11-25-91	JH
	I) Firing Pin Indent	.0205	.0205	.0205	11-26-91	JH
	J) Assemble Stock				12/2/91	RW
	K) Assemble Swivel Studs				12-7-91	AC
	L) Attach Front and Rear Sight Assemblies				12/2/91	RW
	M) Iron Sight Alignment				12/2/91	RW
	N) Detach Front & Rear Sights & place in numbered container				12/2/91	RW
	O) Attach Scope to Rifle				12/2/91	RW
	P) Detach & Attach Scope 20 Times				12/2/91	RW
640	Gallery Target & Test				12/2/91	KT
	A) Time				"	KT
	B) Malfunctions				"	KT
	C) Pierced Primers				"	KT
	D) Optical Clarity of Scope				"	KT
645	Inspect for Live Ammo				12/2/91	KT
655	Final Inspection					
	A) Headspace				12-7-91	AC
	B) Trigger Pull	2.39	2.29	2.34	12-3-91	AC
	C) Function				12-7-91	AC
660	Pack				12-7-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649022DATE 11-25-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.56	2.49	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.57	2.47	2.29	
PULL #3	2.57	2.52	2.50	2.34	
PULL #4	2.44	2.55	2.54	2.28	
PULL #5	2.47	2.50	2.51	2.36	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.68		
PULL #2	3.57	3.22		
PULL #3	3.60	3.25		
PULL #4	3.57	3.31		
PULL #5	3.66	3.29		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.41		4.44
PULL #2	4.40	4.22		4.41
PULL #3	4.40	4.25		4.39
PULL #4	4.36	4.35		4.42
PULL #5	4.44	4.38		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649022
2 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.189771
1 TO	2	.19056
1 TO	3	.296057
1 TO	4	.277881
1 TO	5	.191471

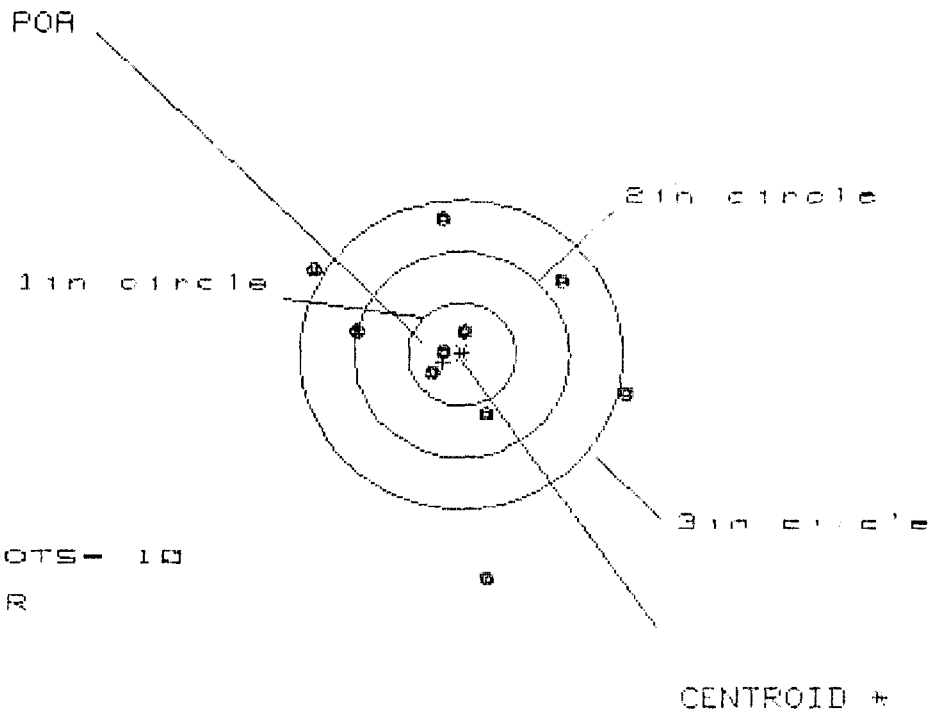
Y (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0356
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0356
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .03105
THE AME FOR THIS RIFLE IS: .9826

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649022

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS = 2.888

VS = 3.488

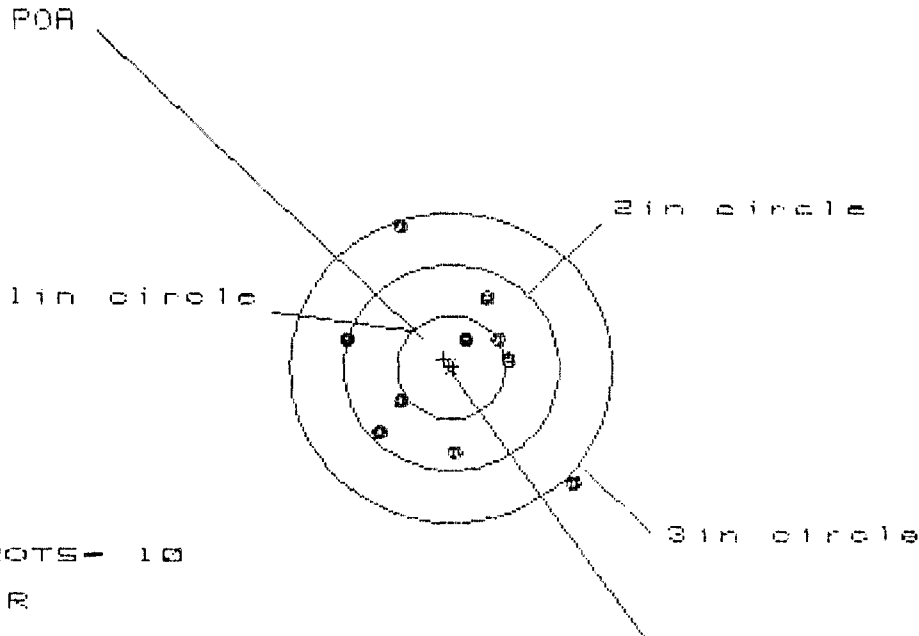
GS = 3.511

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.481	1.503	1.329
MINIMUM X	-1.407	-1.385	-1.164
MAXIMUM Y	1.332	1.092	1.166
MINIMUM Y	-2.156	-1.795	-1.721
CENTROID X	.173	.151	.325
CENTROID Y	.078	.318	.244
POA TO CENTROID in.	.190	.352	.406
MIN RADIUS	.128	.113	.079
MEAN RADIUS	1.015	.893	.808
MAX RADIUS	2.165	1.609	1.421
HORIZONTAL SPREAD	2.888	2.888	2.493
VERTICAL SPREAD	3.488	1.887	1.887
EXTREME SPREAD	3.511	3.113	2.559
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649022

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.110

VS= 2.417

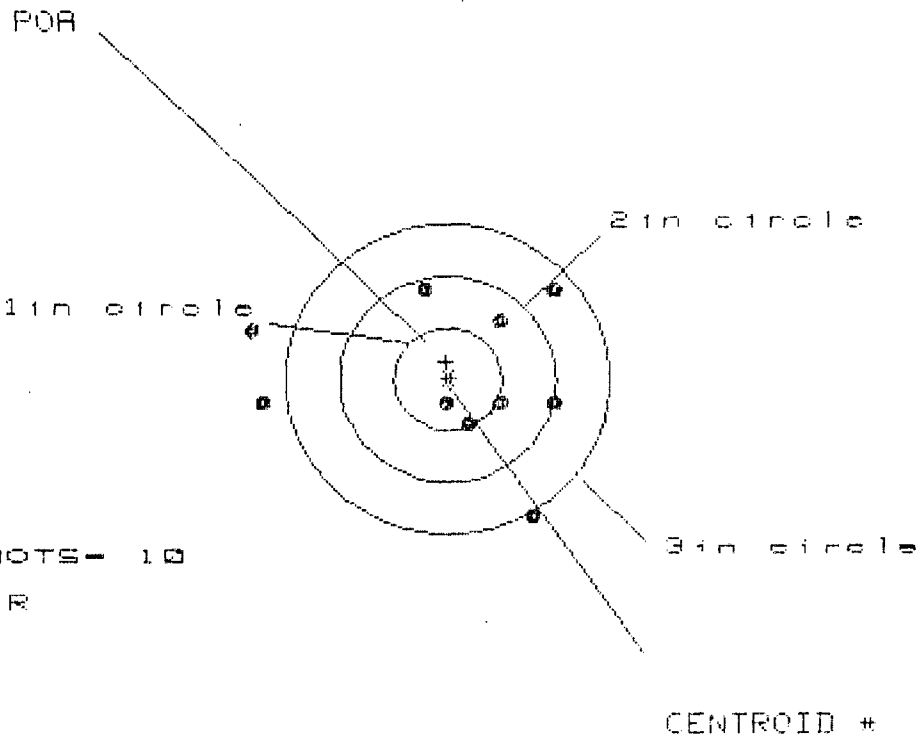
GS= 2.870

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.125	.665	.628
MINIMUM X	-.985	-.860	-.897
MAXIMUM Y	1.333	1.212	.676
MINIMUM Y	-1.084	-.945	-.793
CENTROID X	.065	-.060	-.023
CENTROID Y	-.079	.042	-.110
POA TO CENTROID in.	.182	.073	.112
MIN RADIUS	.385	.272	.367
MEAN RADIUS	.833	.748	.676
MAX RADIUS	1.562	1.248	.956
HORIZONTAL SPREAD	2.110	1.525	1.525
VERTICAL SPREAD	2.417	2.157	1.469
EXTREME SPREAD	2.870	2.195	1.614
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649022

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.871

VS= 2.242

GS= 3.218

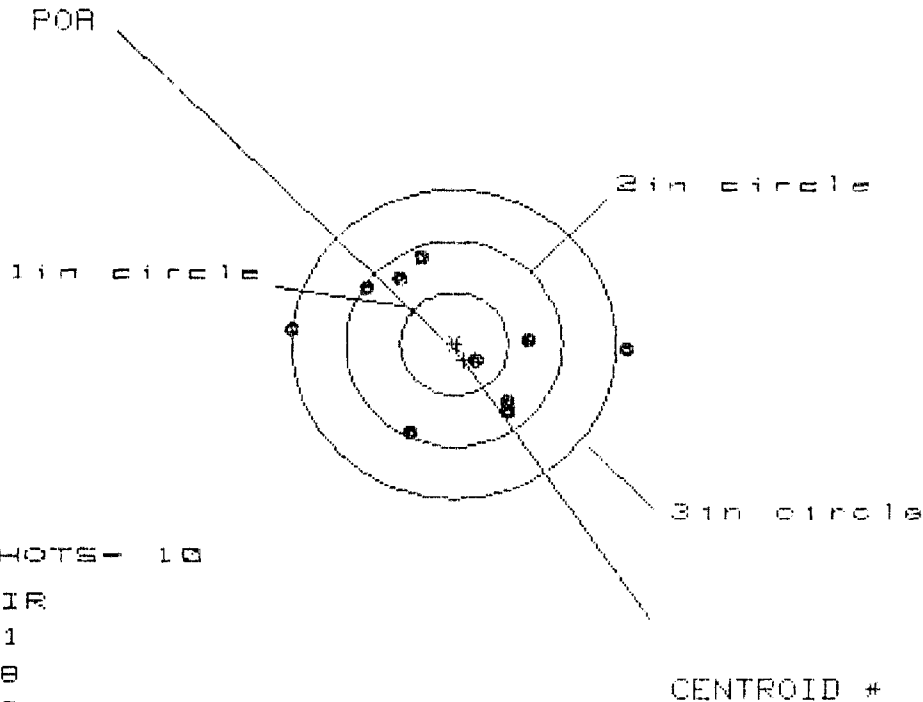
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.019	.813	.571
MINIMUM X	-1.852	-1.937	-.678
MAXIMUM Y	.894	.942	.924
MINIMUM Y	-1.348	-1.300	-1.318
CENTROID X	.016	.222	.464
CENTROID Y	-.173	-.221	-.203
POA TO CENTROID in.	.173	.313	.506
MIN RADIUS	.194	.282	.217
MEAN RADIUS	1.035	.893	.739
MAX RADIUS	1.903	1.942	1.371
HORIZONTAL SPREAD	2.871	2.750	1.249
VERTICAL SPREAD	2.242	2.242	2.242
EXTREME SPREAD	3.218	2.939	2.478
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	7	

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649022

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 8

HE = 2.098

VS = 1.727

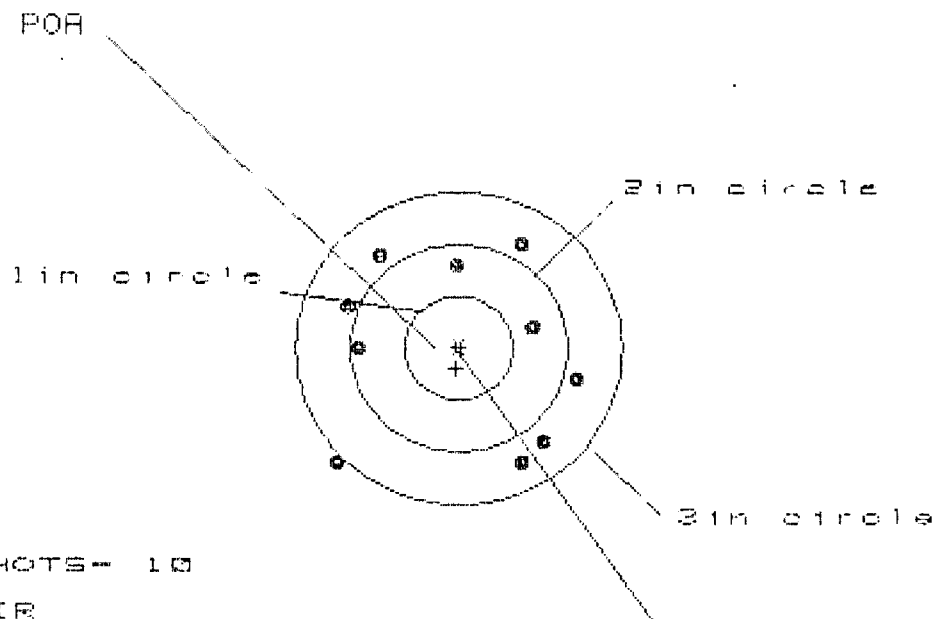
GS = 3.103

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.593	.902	.736
MINIMUM X	:	-1.505	-1.328	-.753
MAXIMUM Y	:	.839	.834	.850
MINIMUM Y	:	-.888	-.893	-.877
CENTROID X	:	-.094	-.271	-.105
CENTROID Y	:	.155	.160	.144
POA TO CENTROID in.	:	.181	.315	.178
MIN RADIUS	:	.259	.417	.262
MEAN RADIUS	:	.928	.862	.772
MAX RADIUS	:	1.594	1.335	.974
HORIZONTAL SPREAD	:	3.098	2.238	1.489
VERTICAL SPREAD	:	1.727	1.727	1.727
EXTREME SPREAD	:	3.103	2.232	1.732
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Oct 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8649022

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.234

VS= 2.088

GS= 2.671

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.089	.961	1.014
MINIMUM X	-1.145	-1.109	-1.056
MAXIMUM Y	.967	.850	.695
MINIMUM Y	-1.121	-1.238	-1.153
CENTROID X	.023	.151	.096
CENTROID Y	.197	.314	.463
POR TO CENTROID in.	.199	.348	.479
MIN RADIUS	.766	.612	.572
MEAN RADIUS	1.102	1.027	.967
MAX RADIUS	1.556	1.308	1.271
HORIZONTAL SPREAD	2.234	2.070	2.070
VERTICAL SPREAD	2.088	2.088	1.848
EXTREME SPREAD	2.671	2.353	2.315
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		8	