

BARBER - M24 0030770

FORM

UPC



0 47700 25716 7

C6649025

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

5716

ORDER NO.

MODEL 700 TM M24

BARBER - M24 0030772

Remington



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

MODEL 700TM M24

SERIAL NO.
C6649025

ORDER NO.
5716

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



5716 C6649025

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649025

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	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
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	TH
	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		11/18/91	JU.

op. #	BARBER NAME M24 0030774	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-4-91	JK
	G) Safety Off Force	2	2	2			12-4-91	JK
	H) Trigger Pull Test & Retainability						11/18/91	JK
	I) Firing Pin Indent	.020	.020	.020			12-4-91	JK
	J) Assemble Stock						12/4/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/4/91	RW
	M) Iron Sight Alignment						12/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/91	RW
	O) Attach Scope to Rifle						12/4/91	RW
	P) Detach & Attach Scope 20 Times						12/4/91	RW
640	Gallery Target & Test						12-4-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-4-91	NF
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	263	266	271	271	270	12-5-91	DH
	C) Function						12-7-91	AC
660	Pack						12-20-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649025
~~C665726~~

DATE 11-18-91

TESTER J28

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.22	2.39	2.74 263	MIN. SETTING,
PULL #2	2.31	2.27	2.27	2.73 266	NO AVG. OF 5
PULL #3	2.24	2.22	2.35	2.78 271	READINGS ACCEPT-
PULL #4	2.21	2.31	2.39	2.67 271	ABLE LESS THAN 2#
PULL #5	2.39	2.54	2.48	2.72 270	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.52	3.48		
PULL #2	3.50	3.51		
PULL #3	3.49	3.55		
PULL #4	3.51	3.50		
PULL #5	3.55	3.50		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.53	4.35		4.61
PULL #2	4.69	4.40		4.46
PULL #3	4.28	4.50		4.58
PULL #4	4.33	4.45		4.63
PULL #5	4.51	4.49		4.62
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649025
4 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.400151
1 TO	2	.319751
1 TO	3	.349954
1 TO	4	.53581
1 TO	5	.270542

134
3

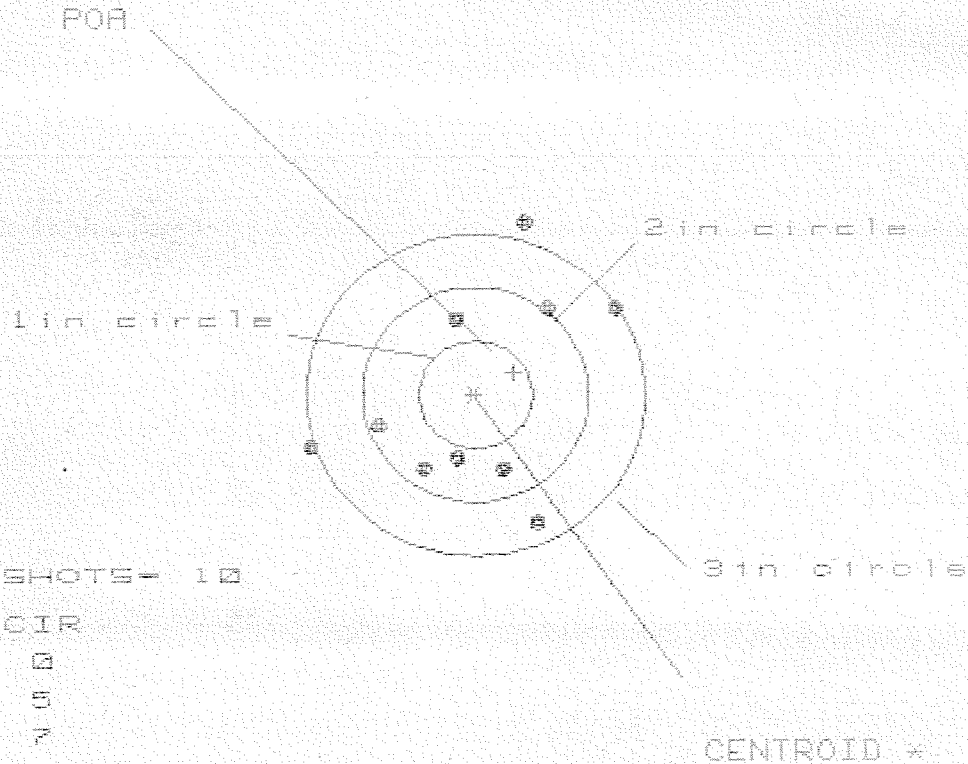
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0838
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.226
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .241036
THE AMR FOR THIS RIFLE IS: 1.061

4 Dec 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06649825

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HS= 2.778

VS= 2.862

GS= 3.074

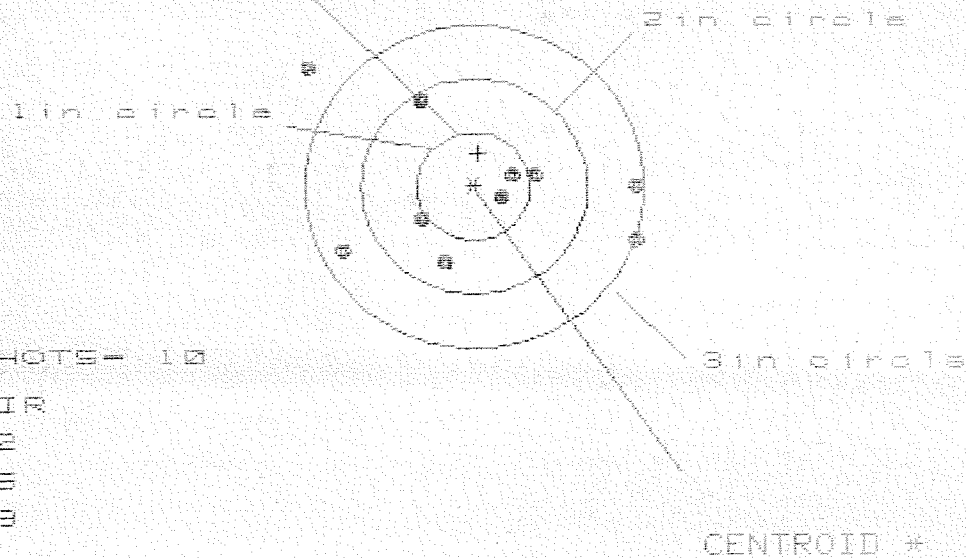
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.285	1.338	1.158
MINIMUM X	-1.493	-1.440	-.957
MAXIMUM Y	1.655	.996	.954
MINIMUM Y	-1.287	-1.023	-1.065
CENTROID X	-.340	-.393	-.213
CENTROID Y	-.211	-.395	-.353
POA TO CENTROID in.	.400	.557	.412
MIN RADIUS	.633	.442	.514
MEAN RADIUS	1.103	.995	.946
MAX RADIUS	1.722	1.659	1.491
HORIZONTAL SPREAD	2.778	2.778	2.115
VERTICAL SPREAD	2.862	2.019	2.019
EXTREME SPREAD	3.074	3.074	2.375
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649025

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.943

VS= 1.764

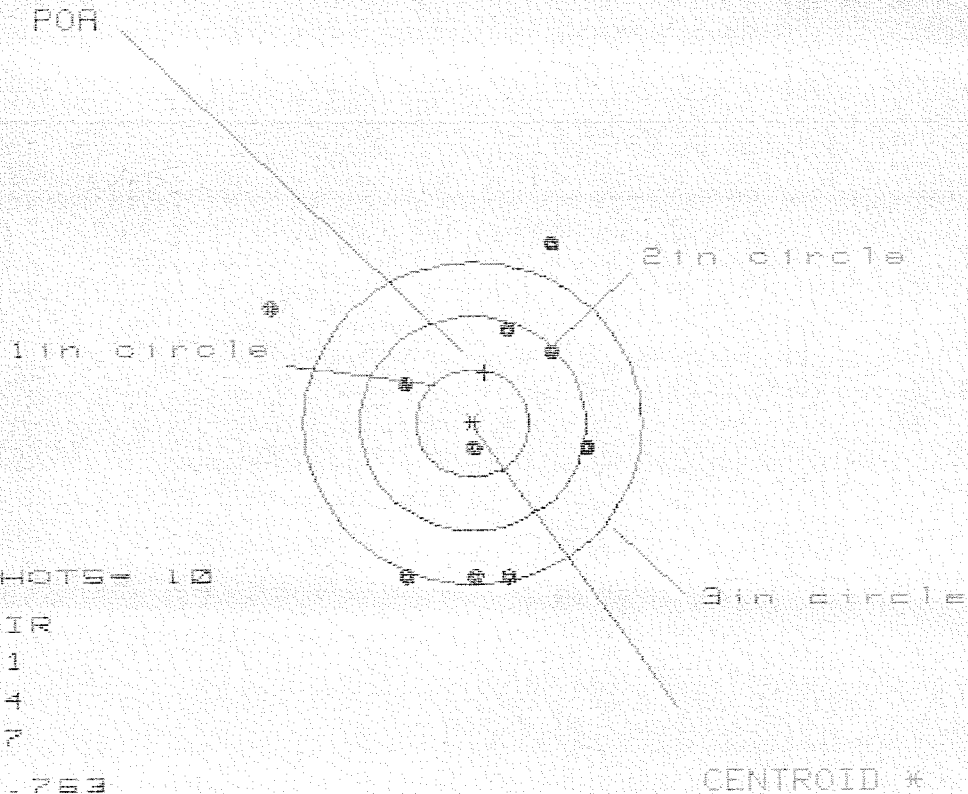
GS= 3.281

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.442	1.276	1.429
MINIMUM X	-1.501	-1.363	-1.210
MAXIMUM Y	1.097	.886	.846
MINIMUM Y	-.667	-.546	-.587
CENTROID X	-.035	.131	-.022
CENTROID Y	-.307	-.428	-.388
POA TO CENTROID in.	.309	.448	.388
MIN RADIUS	.274	.088	.241
MEAN RADIUS	.952	.816	.768
MAX RADIUS	1.859	1.448	1.429
HORIZONTAL SPREAD	2.943	2.639	2.639
VERTICAL SPREAD	1.764	1.432	1.432
EXTREME SPREAD	3.281	2.699	2.699
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

4 Dec 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6645025

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 2.753

VS = 3.078

GS = 3.361

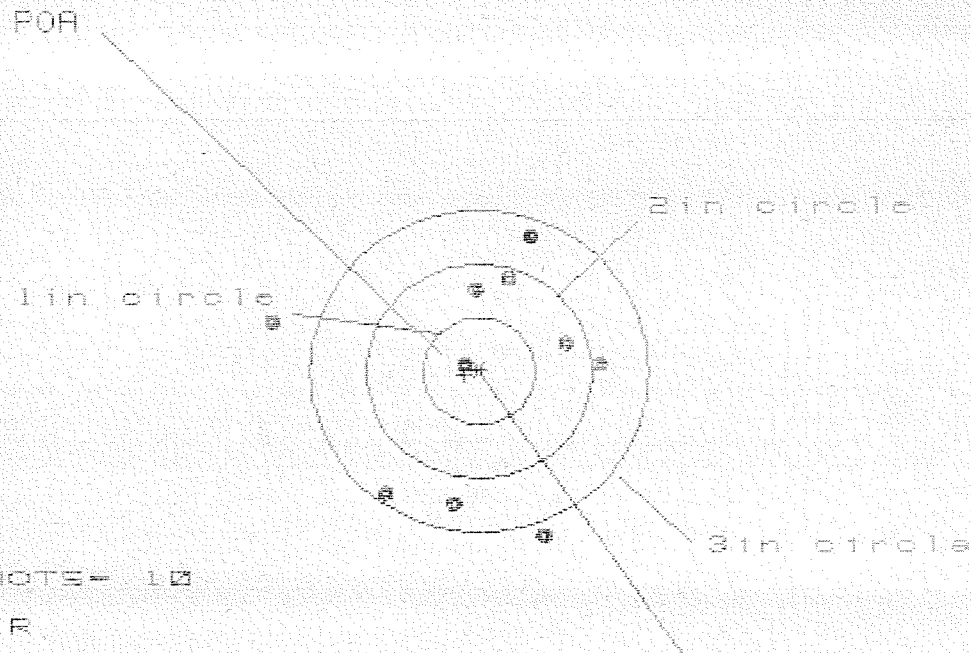
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.016	.822	.890
MINIMUM X	:	-1.747	-.832	-.764
MAXIMUM Y	:	1.661	1.782	1.204
MINIMUM Y	:	-1.417	-1.296	-1.073
CENTROID X	:	-.108	.086	.018
CENTROID Y	:	-.473	-.594	-.817
POA TO CENTROID in.	:	.485	.601	.817
MIN RADIUS	:	.191	.243	.228
MEAN RADIUS	:	1.201	1.093	.988
MAX RADIUS	:	2.060	1.865	1.306
HORIZONTAL SPREAD	:	2.763	1.654	1.654
VERTICAL SPREAD	:	3.078	3.078	2.277
EXTREME SPREAD	:	3.361	3.361	2.467
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			7	

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649025

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.835

VS= 2.797

GS= 3.084

CENTROID #

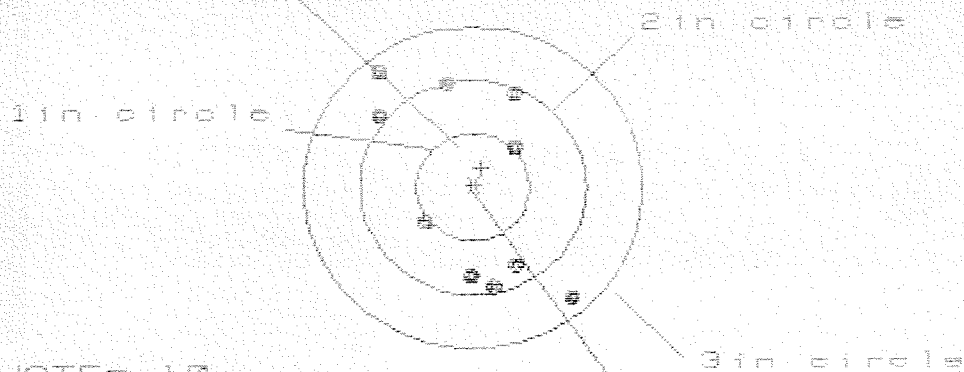
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	.847	.890
MINIMUM X	-1.789	-1.066	-1.023
MAXIMUM Y	1.275	1.331	1.147
MINIMUM Y	-1.522	-1.466	-1.315
CENTROID X	.136	.334	.291
CENTROID Y	.035	-.020	.163
POA TO CENTROID in.	.140	.335	.334
MIN RADIUS	.194	.397	.325
MEAN RADIUS	1.122	1.034	.935
MAX RADIUS	1.857	1.506	1.607
HORIZONTAL SPREAD	2.835	1.913	1.913
VERTICAL SPREAD	2.797	2.797	2.462
EXTREME SPREAD	3.084	2.799	2.720
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649025

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 10

HS= 1.743

VS= 2.036

GS= 2.679

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.914	.518	.427
MINIMUM X	-.829	-.727	-.818
MAXIMUM Y	1.037	.926	.949
MINIMUM Y	-.999	-1.047	-.932
CENTROID X	-.072	-.174	-.083
CENTROID Y	-.174	-.063	-.178
POA TO CENTROID in.	.188	.185	.197
MIN RADIUS	.501	.521	.512
MEAN RADIUS	.927	.875	.824
MAX RADIUS	1.355	1.176	1.032
HORIZONTAL SPREAD	1.743	1.245	1.245
VERTICAL SPREAD	2.036	1.973	1.881
EXTREME SPREAD	2.679	2.232	1.935
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		