

FORM

UPC



0 47700 25716 7

06649209

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0066405

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649209

ORDER NO.

5716

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

20



5716 C6649209

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649209

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1 91		RW
600	Proof	10 1 91		RW
607	Check Headspace	10 1 91		RW
610	Dis-assemble Gun	10 1 91		RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	GL
617	Drill and Tap Sight Holes		OCT 10 1991	FJB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		12/3/91	KS
	Apply Coating (Bolt)		12/3/91	KS
625	Final Assembly A) Clean inside of Bolt Assembly		12/3/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/3/91	KS
	C) Inspect Ejector Hole for Chamfer		12/3/91	KS
	D) Oil Firing Pin Ass'y		12/3/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/6/91	JH

op. #	BARBER M24 0066407	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-6-91	JH
	G) Safety Off Force	4	5	4			12-6-91	JH
	H) Trigger Pull Test & Retainability						12-6-91	JH
	I) Firing Pin Indent	.020	.0205	.020			12-6-91	JH
	J) Assemble Stock						12-6-91	JH
	K) Assemble Swivel Studs						12-11-91	AC
	L) Attach Front and Rear Sight Assemblies						12-6-91	JH
	M) Iron Sight Alignment						12-6-91	JH
	N) Detach Front & Rear Sights & place in numbered container						12-6-91	JH
	O) Attach Scope to Rifle						12-6-91	JH
	P) Detach & Attach Scope 20 Times						12-6-91	JH
640	Gallery Target & Test						12-9-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						12-9-91	NF
655	Final Inspection							
	A) Headspace						12-11-91	AC
	B) Trigger Pull	2.42	2.17	2.18	2.31	2.30	12-12-91	JH
	C) Function						12-11-91	AC
660	Pack						12-18-91	NF

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

SERIAL NO. C-6649209DATE 12-6-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.44	2.50	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.54	2.55	2.17	
PULL #3	2.54	2.54	2.60	2.18	
PULL #4	2.48	2.59	2.51	2.31	
PULL #5	2.46	2.53	2.59	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.35		
PULL #2	3.61	3.38		
PULL #3	3.48	3.44		
PULL #4	3.51	3.36		
PULL #5	3.55	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.58		4.47
PULL #2	4.59	4.45		4.59
PULL #3	4.42	4.63		4.59
PULL #4	4.45	4.59		4.46
PULL #5	4.56	4.46		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649209
9 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.265601
1 TO	2	.330048
1 TO	3	.35948
1 TO	4	.30147
1 TO	5	.249128

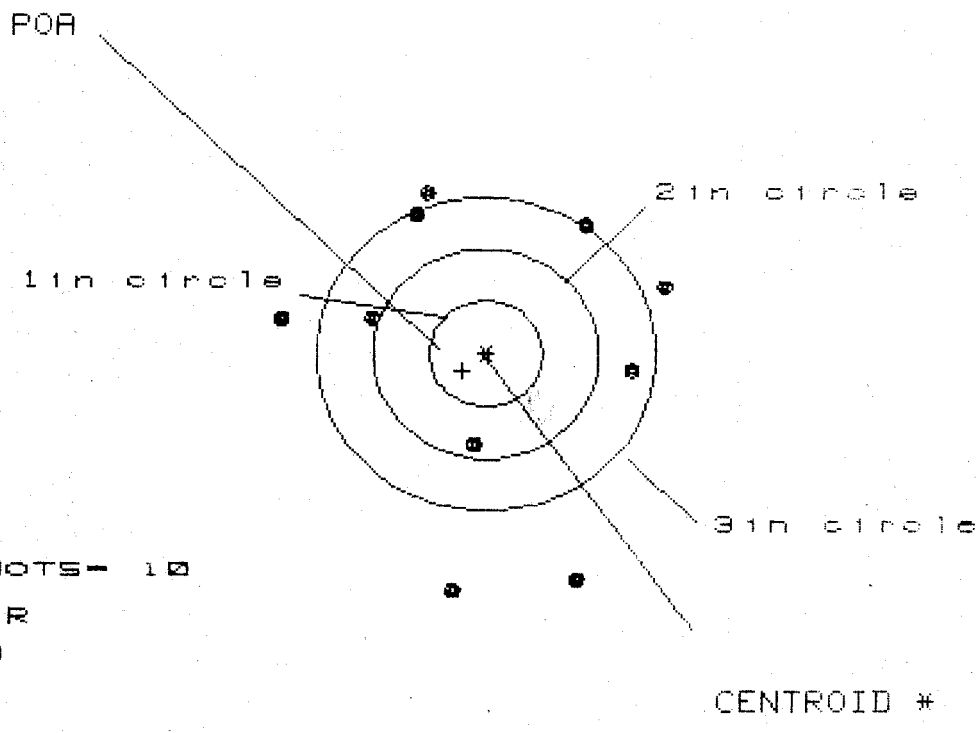
51 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0278
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0470833
THE AMR FOR THIS RIFLE IS: 1.256

5 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649289

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 1

3in = 4

HS= 3.329

VS= 3.812

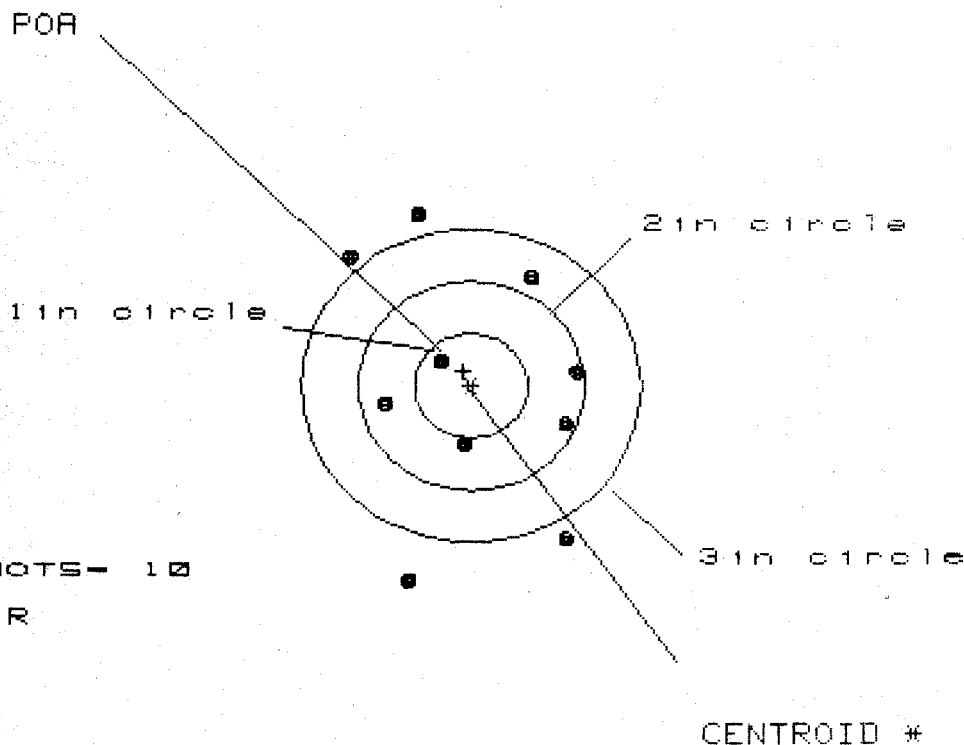
GS= 3.970

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.558	1.646	1.613
MINIMUM X	:	-1.771	-1.683	-1.716
MAXIMUM Y	:	1.572	1.331	1.021
MINIMUM Y	:	-2.240	-2.481	-1.370
CENTROID X	:	.212	.124	.158
CENTROID Y	:	.160	.401	.711
POA TO CENTROID in.	:	.266	.420	.728
MIN RADIUS	:	.834	.973	.927
MEAN RADIUS	:	1.592	1.482	1.314
MAX RADIUS	:	2.305	2.495	1.729
HORIZONTAL SPREAD	:	3.329	3.329	3.329
VERTICAL SPREAD	:	3.812	3.812	2.391
EXTREME SPREAD	:	3.970	3.817	3.342
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	4		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649203

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 1.957

VS= 3.501

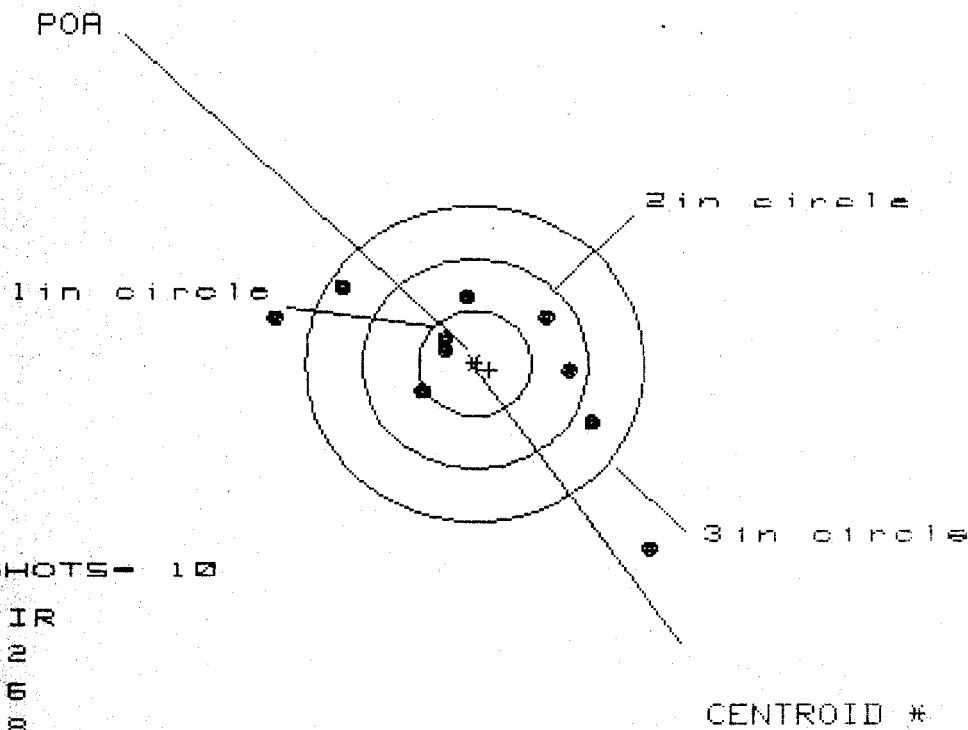
GS= 3.502

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.951	.891	.826
MINIMUM X	:	-1.016	-1.076	-1.141
MAXIMUM Y	:	1.680	1.478	1.244
MINIMUM Y	:	-1.821	-1.623	-1.438
CENTROID X	:	.066	.126	.191
CENTROID Y	:	-.136	.066	-.119
POA TO CENTROID in.	:	.152	.142	.225
MIN RADIUS	:	.400	.376	.495
MEAN RADIUS	:	1.169	1.082	1.004
MAX RADIUS	:	1.899	1.793	1.688
HORIZONTAL SPREAD	:	1.967	1.967	1.967
VERTICAL SPREAD	:	3.501	3.101	2.682
EXTREME SPREAD	:	3.502	3.355	3.251
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649203

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.282

VS= 2.537

GS= 3.972

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.180	.982
MINIMUM X	:	-1.754	-1.585	-1.146
MAXIMUM Y	:	.762	.565	.598
MINIMUM Y	:	-1.775	-.804	-.771
CENTROID X	:	-.133	-.302	-.104
CENTROID Y	:	.059	.256	.223
POA TO CENTROID in.	:	.145	.396	.246
MIN RADIUS	:	.309	.110	.298
MEAN RADIUS	:	1.020	.809	.732
MAX RADIUS	:	2.342	1.607	1.292
HORIZONTAL SPREAD	:	3.282	2.765	2.128
VERTICAL SPREAD	:	2.537	1.369	1.369
EXTREME SPREAD	:	3.972	2.965	2.530
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649209

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 4

HS= 3.172

VS= 3.516

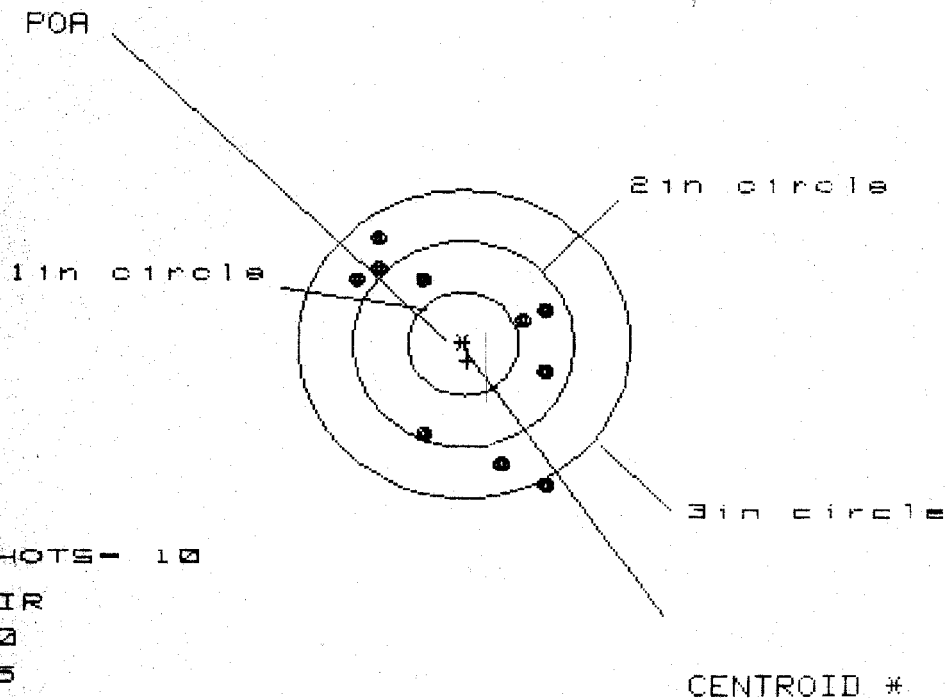
GS= 3.906

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.551	1.134	1.005
MINIMUM X	:	-1.621	-1.449	-1.578
MAXIMUM Y	:	1.832	1.985	2.200
MINIMUM Y	:	-1.684	-1.531	-1.316
CENTROID X	:	.082	-.090	.039
CENTROID Y	:	-.112	-.265	-.480
POA TO CENTROID in.	:	.139	.280	.481
MIN RADIUS	:	.119	.344	.483
MEAN RADIUS	:	1.476	1.413	1.287
MAX RADIUS	:	2.074	2.005	2.200
HORIZONTAL SPREAD	:	3.172	2.583	2.583
VERTICAL SPREAD	:	3.516	3.516	3.516
EXTREME SPREAD	:	3.906	3.906	3.771
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	4		

9 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649209

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 1.714

VS = 2.413

GS = 2.855

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.782	.856	.774
MINIMUM X	:	-.932	-.845	-.927
MAXIMUM Y	:	1.075	.927	.733
MINIMUM Y	:	-1.338	-1.351	-1.235
CENTROID X	:	-.037	-.124	-.042
CENTROID Y	:	.168	.316	.200
POA TO CENTROID in.	:	.172	.340	.205
MIN RADIUS	:	.564	.560	.558
MEAN RADIUS	:	1.021	.945	.917
MAX RADIUS	:	1.549	1.410	1.276
HORIZONTAL SPREAD	:	1.714	1.701	1.701
VERTICAL SPREAD	:	2.413	2.278	1.968
EXTREME SPREAD	:	2.855	2.512	2.251
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649209
16 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.0277308
1 TO	2	.349503
1 TO	3	.164128
1 TO	4	.24683
1 TO	5	.102489

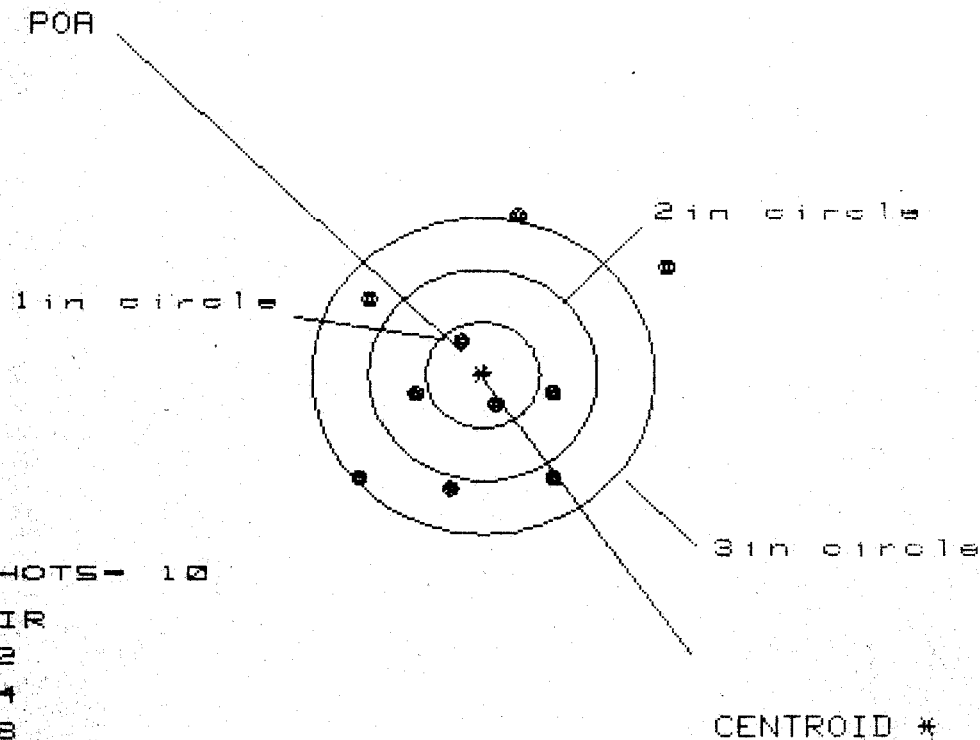
<----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0422
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1706
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .175742
THE AMR FOR THIS RIFLE IS: .8886

16 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649283.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 2.526

VS = 2.609

GS = 3.322

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.574	.782	.837
MINIMUM X	-1.052	-.877	-.822
MAXIMUM Y	1.538	1.654	1.084
MINIMUM Y	-1.071	-.955	-.748
CENTROID X	-.012	-.187	-.242
CENTROID Y	-.025	-.141	-.348
POA TO CENTROID in.	.028	.234	.424
MIN RADIUS	.306	.343	.360
MEAN RADIUS	1.041	.925	.810
MAX RADIUS	1.891	1.712	1.334
HORIZONTAL SPREAD	2.626	1.659	1.659
VERTICAL SPREAD	2.609	2.609	1.832
EXTREME SPREAD	3.322	2.849	2.372
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

16 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649289.1

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.047

VS= 2.133

GS= 2.134

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.563	.576	.601
MINIMUM X	:	-.484	-.471	-.446
MAXIMUM Y	:	1.095	.830	.715
MINIMUM Y	:	-1.038	-.916	-.760
CENTROID X	:	.114	.101	.076
CENTROID Y	:	-.351	-.473	-.358
POA TO CENTROID in.	:	.369	.483	.366
MIN RADIUS	:	.056	.165	.048
MEAN RADIUS	:	.596	.539	.474
MAX RADIUS	:	1.102	.938	.763
HORIZONTAL SPREAD	:	1.047	1.047	1.047
VERTICAL SPREAD	:	2.133	1.746	1.475
EXTREME SPREAD	:	2.134	1.813	1.509
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

16 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649209.1

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.200

VS= 2.963

GS= 3.391

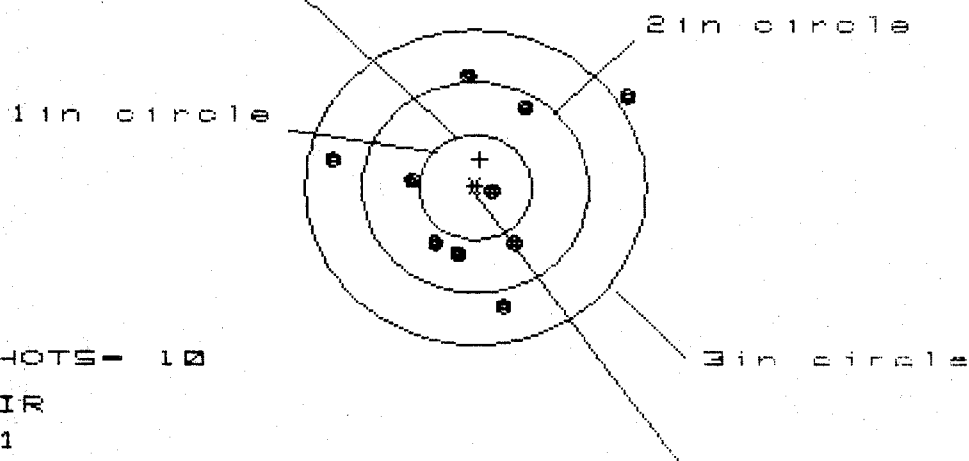
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.893	.969	.859
MINIMUM X	:	-1.387	-1.311	-1.421
MAXIMUM Y	:	1.141	.939	.987
MINIMUM Y	:	-1.822	-1.622	-1.505
CENTROID X	:	.061	-.015	.095
CENTROID Y	:	-.172	.030	-.087
POA TO CENTROID in.	:	.183	.034	.129
MIN RADIUS	:	.515	.686	.584
MEAN RADIUS	:	1.185	1.093	1.053
MAX RADIUS	:	1.948	1.622	1.507
HORIZONTAL SPREAD	:	2.280	2.280	2.280
VERTICAL SPREAD	:	2.963	2.561	2.492
EXTREME SPREAD	:	3.391	2.718	2.643
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		

16 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649289.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.604

VS= 2.183

GS= 2.675

CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.331	.542	.402
MINIMUM X	:	-1.274	-1.126	-.567
MAXIMUM Y	:	1.020	1.116	1.160
MINIMUM Y	:	-1.163	-1.067	-1.022
CENTROID X	:	-.042	-.190	-.050
CENTROID Y	:	-.270	-.366	-.410
POA TO CENTROID in.	:	.273	.413	.413
MIN RADIUS	:	.103	.246	.138
MEAN RADIUS	:	.863	.768	.697
MAX RADIUS	:	1.590	1.180	1.162
HORIZONTAL SPREAD	:	2.604	1.668	.969
VERTICAL SPREAD	:	2.183	2.183	2.183
EXTREME SPREAD	:	2.675	2.209	2.209
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649209.1

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in - 3

2in - 7

3in = 10

HS= 1.877

VS= 2.053

GS= 2.099

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.842	.727	.718
MINIMUM X	:	-1.035	-.508	-.517
MAXIMUM Y	:	.954	.912	.770
MINIMUM Y	:	-1.099	-1.141	-.692
CENTROID X	:	.090	.205	.214
CENTROID Y	:	-.035	.007	.150
POA TO CENTROID in.	:	.096	.205	.261
MIN RADIUS	:	.341	.365	.366
MEAN RADIUS	:	.758	.714	.654
MAX RADIUS	:	1.100	1.143	.927
HORIZONTAL SPREAD	:	1.877	1.235	1.235
VERTICAL SPREAD	:	2.053	2.053	1.461
EXTREME SPREAD	:	2.099	2.099	1.721
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		