

BARBER - M24 0066543

FORM

UPC



0 47700 25716 7

C6649215

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

BARBER - M24 0066545

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6649215

20

ORDER NO.
5716

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



5716 C6649215

ORDER **5716**

MODEL 700 TM M24

UPC



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ORDER **5716**

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649215

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	1 91		RW
610	Dis-assemble Gun	10 1 81		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 16 1991		LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8-91	1/5
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-21-91	GL

op. #	BARBER M24 0066547	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-21-91	84
	G) Safety Off Force	3	3	3			11-21-91	84
	H) Trigger Pull Test & Retainability						11-21-91	84
	I) Firing Pin Indent	.0205	.021	.021			11-21-91	84
	J) Assemble Stock						11/25/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	RW
	M) Iron Sight Alignment						11/26/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	RW
	O) Attach Scope to Rifle						11/25/91	RW
	P) Detach & Attach Scope 20 Times						11/25/91	RW
640	Gallery Target & Test						11/25/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/29/91	KT
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	2.44	2.44	2.21	2.30	2.30	11-26-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

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

SERIAL NO. C-6649215DATE 11-21-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.43	2.48	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.43	2.50	2.44	
PULL #3	2.42	2.44	2.55	2.21	
PULL #4	2.32	2.36	2.41	2.30	
PULL #5	2.45	2.36	2.44	2.30	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.68	3.49		
PULL #2	3.44	3.44		
PULL #3	3.69	3.47		
PULL #4	3.68	3.30		
PULL #5	3.68	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.55	4.43		4.35
PULL #2	4.36	4.43		4.38
PULL #3	4.51	4.46		4.35
PULL #4	4.46	4.46		4.40
PULL #5	4.38	4.37		4.38
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATION
FOR RIFLE # 06649215
25 AUG 1991

CENTROIDAL DISTANCES

0 TO	1	.0594811
1 TO	2	.152069
1 TO	3	.238948
1 TO	4	.126823
1 TO	5	.214201

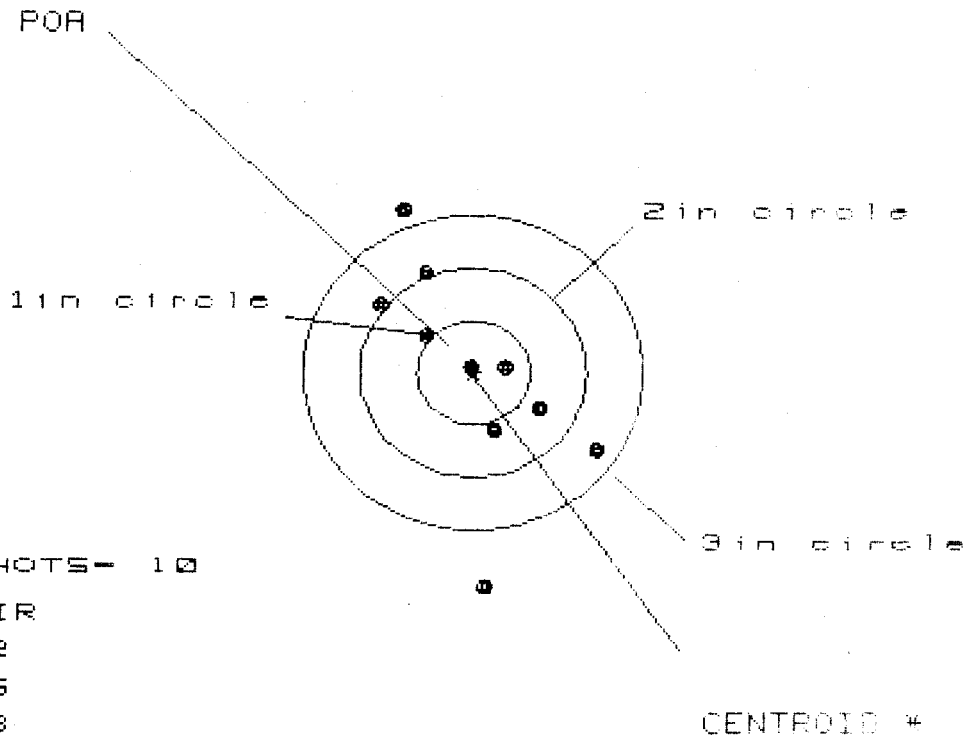
94 C-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0448
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0088
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .044575
POI FOR THIS RIFLE IS: 1.107

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649215

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 8

HS- 1.873

VS- 3.618

GS- 3.688

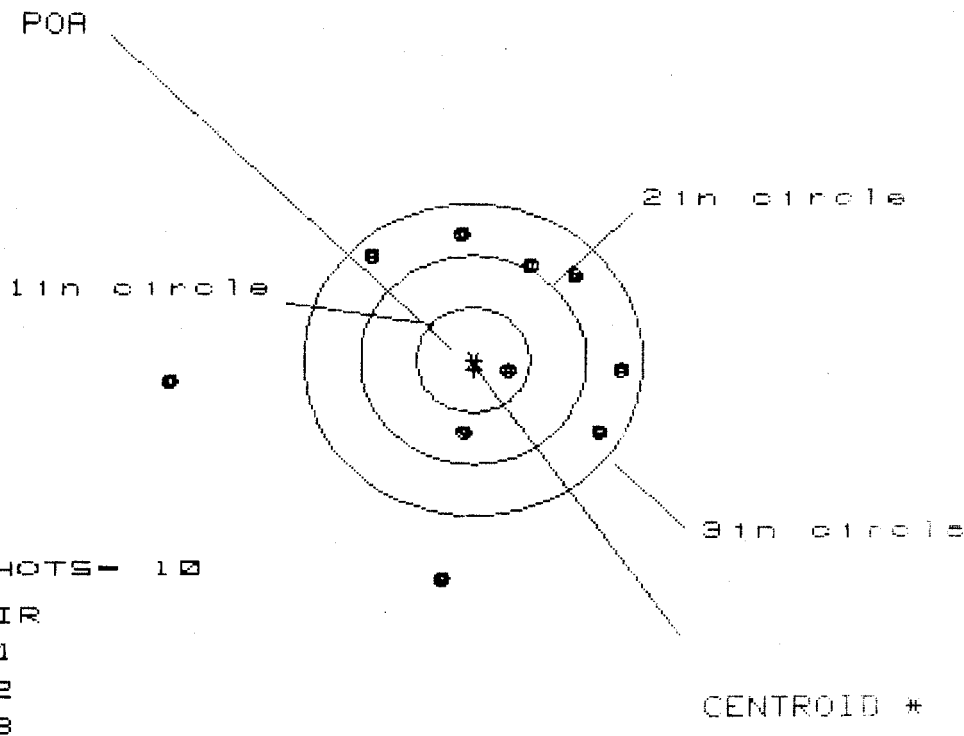
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.048	1.060	.987
MINIMUM X	-.825	-.813	-.886
MAXIMUM Y	1.586	1.360	.857
MINIMUM Y	-2.032	-.948	-.778
CENTROID X	.017	.005	.078
CENTROID Y	-.057	.169	-.001
CS TO CENTROID in.	.059	.169	.078
1 IN RADIUS	.090	.144	.049
2 IN RADIUS	.923	.792	.675
3 IN RADIUS	2.035	1.482	1.257
1 IN RADIUS SPREAD	1.873	1.873	1.873
2 IN RADIUS SPREAD	3.618	2.308	1.635
3 IN RADIUS SPREAD	3.688	2.837	2.328
1 IN RADIUS ONE INCH CIRCLE =		2	
2 IN RADIUS TWO INCH CIRCLE =		6	
3 IN RADIUS THREE INCH CIRCLE =		8	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649215

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 4.008

VS= 3.311

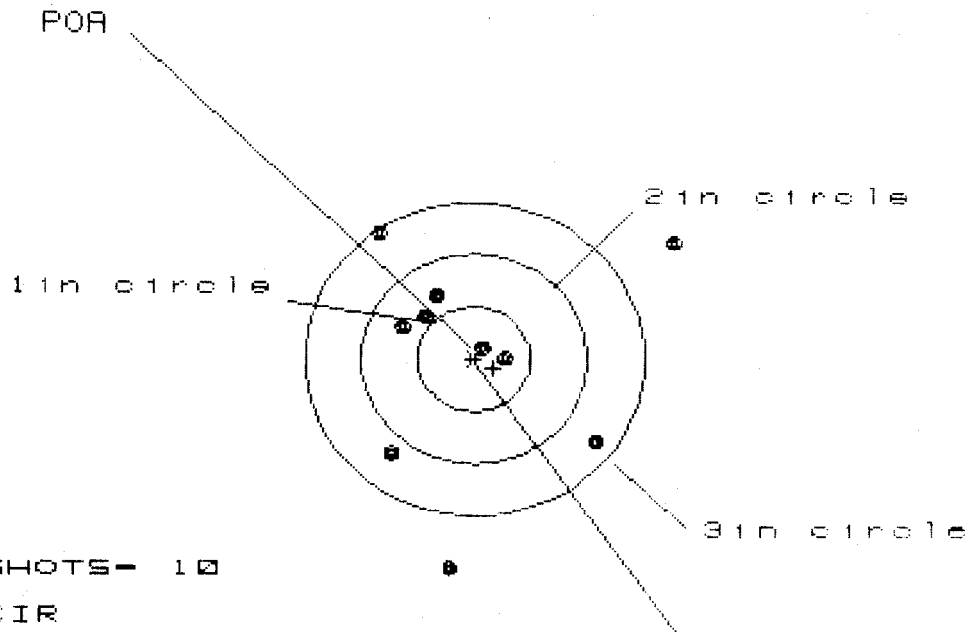
GS= 4.009

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.304	1.003	.931
MINIMUM X	:	-2.704	-1.230	-1.302
MAXIMUM Y	:	1.179	1.154	.884
MINIMUM Y	:	-2.132	-2.157	-1.014
CENTROID X	:	-.008	.293	.365
CENTROID Y	:	.093	.118	.388
POA TO CENTROID in.	:	.094	.316	.533
MIN RADIUS	:	.303	.088	.366
MEAN RADIUS	:	1.333	1.107	.951
RMS RADIUS	:	2.713	2.234	1.495
HORIZONTAL SPREAD	:	4.008	2.233	2.233
VERTICAL SPREAD	:	3.311	3.311	1.898
EXTREME SPREAD	:	4.009	3.314	2.646
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	8		

25 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 2

2in - 5

3in - 8

HS- 2.609

VS- 3.127

GS- 3.645

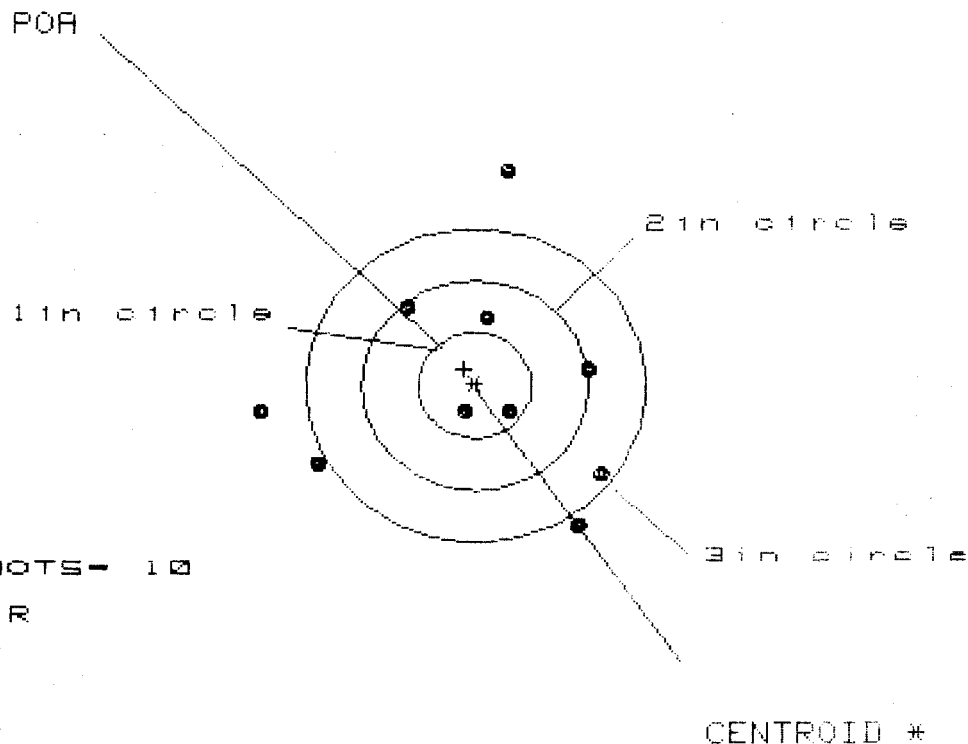
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.796	1.304	1.301
MINIMUM X	:	-.813	-.613	-.616
MAXIMUM Y	:	1.160	1.279	1.048
MINIMUM Y	:	-1.967	-1.848	-1.037
CENTROID X	:	-.169	-.369	-.366
CENTROID Y	:	.093	-.026	.205
POA TO CENTROID in.	:	.193	.369	.420
MIN RADIUS	:	.164	.375	.260
MEAN RADIUS	:	1.047	.945	.762
MAX RADIUS	:	2.092	1.848	1.593
HORIZONTAL SPREAD	:	2.609	1.917	1.917
VERTICAL SPREAD	:	3.127	3.127	2.085
EXTREME SPREAD	:	3.645	3.183	2.747
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08645215

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.007

VS= 3.308

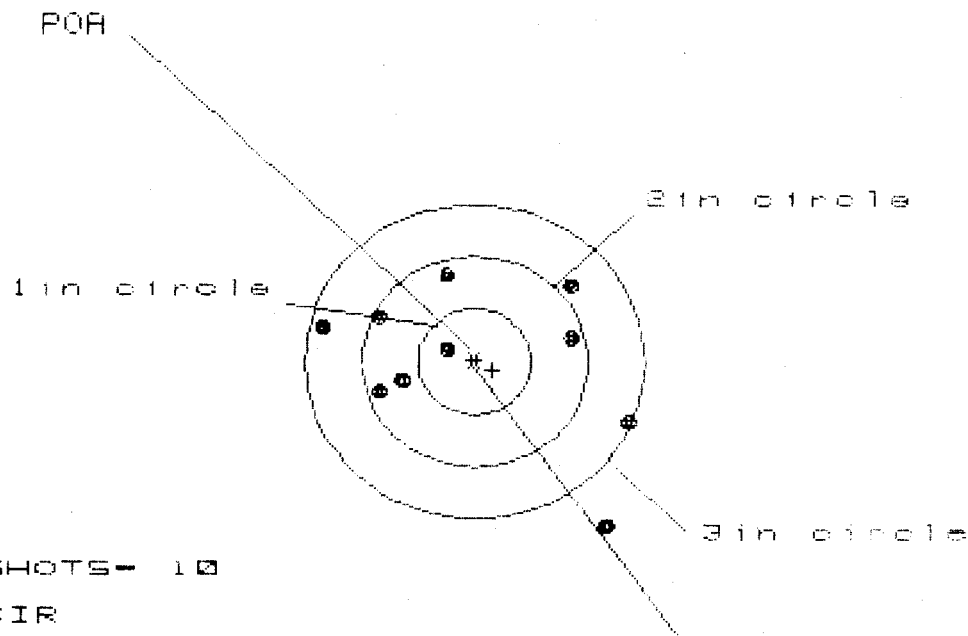
GS= 3.362

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.114	1.153	.921
MINIMUM X	:	-1.893	-1.854	-1.566
MAXIMUM Y	:	2.009	.986	.983
MINIMUM Y	:	-1.299	-1.076	-1.079
CENTROID X	:	.095	.056	.288
CENTROID Y	:	-.157	-.380	-.377
POA TO CENTROID in.	:	.184	.384	.474
4IN RADIUS	:	.288	.062	.104
1IN RADIUS	:	1.184	1.068	.936
2IN RADIUS	:	2.040	1.854	1.647
HORIZONTAL SPREAD	:	3.007	3.007	2.487
VERTICAL SPREAD	:	3.308	2.062	2.062
EXTREME SPREAD	:	3.362	3.061	2.596
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	6		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649215

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS- 2.770

VS= 2.352

GS= 3.089

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.399	1.522	1.187
MINIMUM X	-1.371	-1.248	-1.058
MAXIMUM Y	.803	.630	.532
MINIMUM Y	-1.549	-.787	-.550
CENTROID X	-.154	-.277	-.467
CENTROID Y	.072	.245	.343
POA TO CENTROID in.	.170	.370	.580
1 in RADIUS	.240	.130	.202
2 in RADIUS	1.046	.901	.761
3 in RADIUS	1.904	1.713	1.243
HORIZONTAL SPREAD	2.770	2.770	2.245
VERTICAL SPREAD	2.352	1.417	1.082
TREND SPREAD	3.089	2.916	2.256
SHOTS IN ONE INCH CIRCLE =	1		
SHOTS IN TWO INCH CIRCLE =	6		
SHOTS IN THREE INCH CIRCLE =	8		