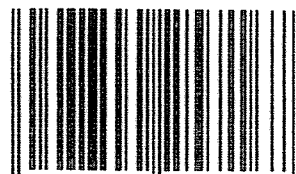


FORM

UPC



0 47700 25716 2

C6649239

INCLUDES 1 IN CHAMBER

BARBER - M24 0066811

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649239

ORDER NO.

5716

20

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



5716 C6649239

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 # C6649239

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 1 0 1991	KR
	Magnaflux Bolt		OCT 1 0 1991	KR
615	Rollmark Caliber		OCT 1 0 1991	GL
617	Drill and Tap Sight Holes		OCT 1 0 1991	WB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8/91	WB
	Apply Coating (Bolt)		11/8/91	WB
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		12-5-91	GL

op. #	BARBER MEM24 0066813	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-5-91	SH
	G) Safety Off Force	2	2	3			12-6-91	SH
	H) Trigger Pull Test & Retainability						12-5-91	SH
	I) Firing Pin Indent	1020	10205	10205			12-5-91	SH
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	RW
	L) Attach Front and Rear Sight Assemblies						12/6/91	RW
	M) Iron Sight Alignment						12/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	RW
	O) Attach Scope to Rifle						12/6/91	RW
	P) Detach & Attach Scope 20 Times						12/6/91	RW
640	Gallery Target & Test						12/6/91	KT
	A) Time						"	KT
	B) Malfunctions						"	1-7
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						12/6/91	KT
655	Final Inspection							
	A) Headspace						12-7-91	RW
	B) Trigger Pull	273	265	265	273	280	12-7-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06649239

DATE 12-5-91

TESTER 97

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.35	2.40	273	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.33	2.44	265	
PULL #3	2.45	2.40	2.39	265	
PULL #4	2.45	2.35	2.49	273	
PULL #5	2.35	2.29	2.50	280	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.49		
PULL #2	3.20	3.44		
PULL #3	3.22	3.25		
PULL #4	3.28	3.38		
PULL #5	3.24	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.38	4.33		4.34
PULL #2	4.18	4.36		4.37
PULL #3	4.45	4.31		4.38
PULL #4	4.32	4.33		4.40
PULL #5	4.31	4.35		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649239
6 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.179936
1 TO	2	.563863
1 TO	3	.854013
1 TO	4	.46924
1 TO	5	.165148

2 ⁴³ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0838
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .064
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .105444
THE AMR FOR THIS RIFLE IS: 1.138

6 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6B49239

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID *

* OF SHOTS = 10

* IN CIR

1in = 1

2in = 3

3in = 8

H= 2.715

V= 2.301

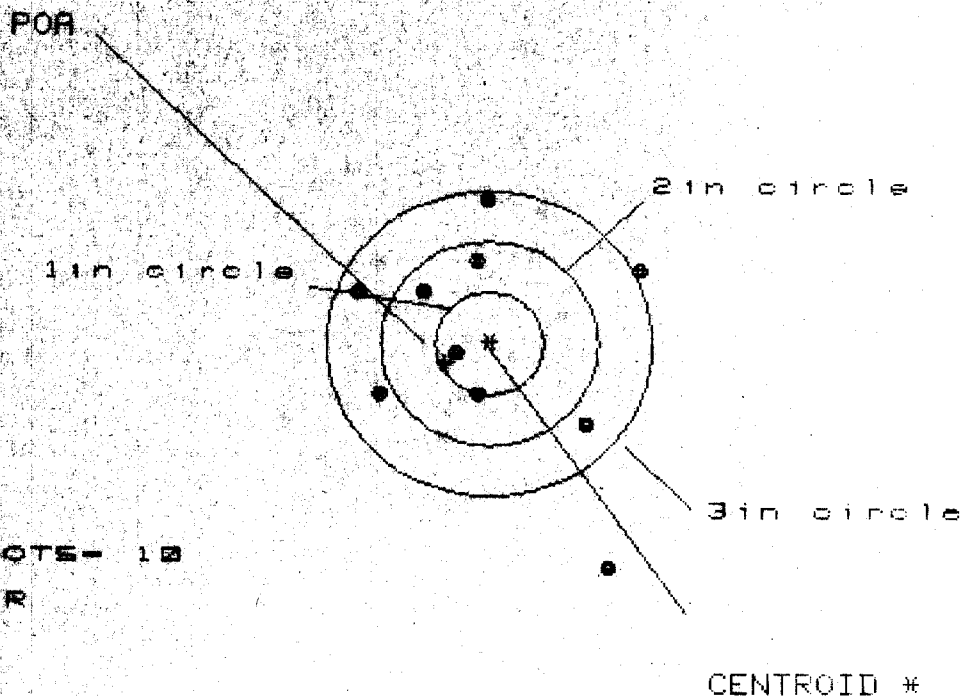
CS= 3.234

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.107	.928	.848
MINIMUM X	:	-1.608	-.850	-.734
MAXIMUM Y	:	1.054	.976	.948
MINIMUM Y	:	-1.247	-1.325	-1.203
CENTROID X	:	.099	.278	.162
CENTROID Y	:	.114	.192	.070
POA TO CENTROID in.	:	.151	.338	.176
MIN RADIUS	:	.249	.411	.243
MEAN RADIUS	:	1.084	1.002	.943
MAX RADIUS	:	1.755	1.390	1.241
HORIZONTAL SPREAD	:	2.715	1.778	1.582
VERTICAL SPREAD	:	2.301	2.301	2.151
EXTREME SPREAD	:	3.234	2.667	2.357
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

6 Dec 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6648239

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 5

HEI 2.574

VSI 3.593

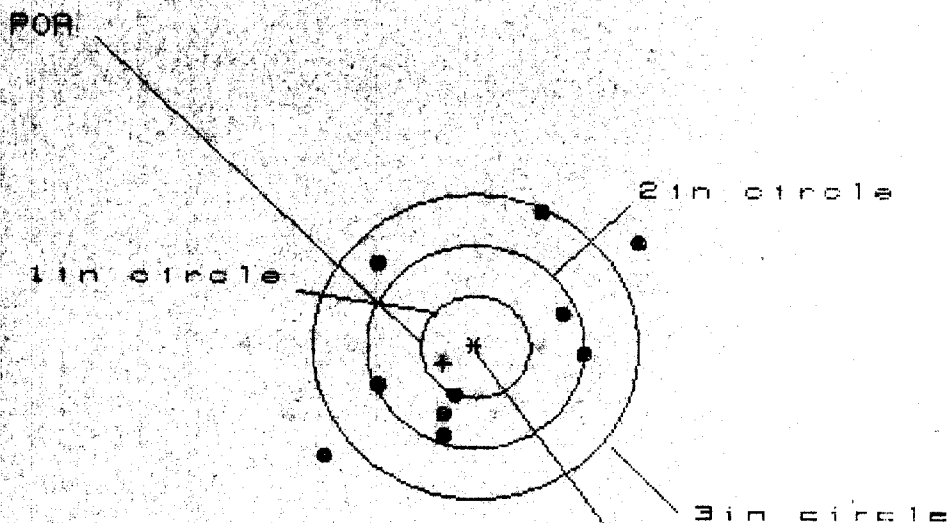
GSI 3.756

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.390	1.514	1.206
MINIMUM X	:	-1.184	-1.060	-.871
MAXIMUM Y	:	1.437	1.197	1.256
MINIMUM Y	:	-2.156	-.984	-.925
CENTROID X	:	.413	.289	.100
CENTROID Y	:	.186	.426	.367
POA TO CENTROID in.	:	.453	.515	.380
MIN RADIUS	:	.339	.410	.304
MEAN RADIUS	:	1.150	.972	.857
MAX RADIUS	:	2.427	1.585	1.520
HORIZONTAL SPREAD	:	2.574	2.574	2.077
VERTICAL SPREAD	:	3.593	2.181	2.181
EXTREME SPREAD	:	3.756	2.699	2.451
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	5		

6 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8649233

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 - 1 1

2 - 3 5

3 - 1 8

H01 2.955

V01 2.332

G01 3.591

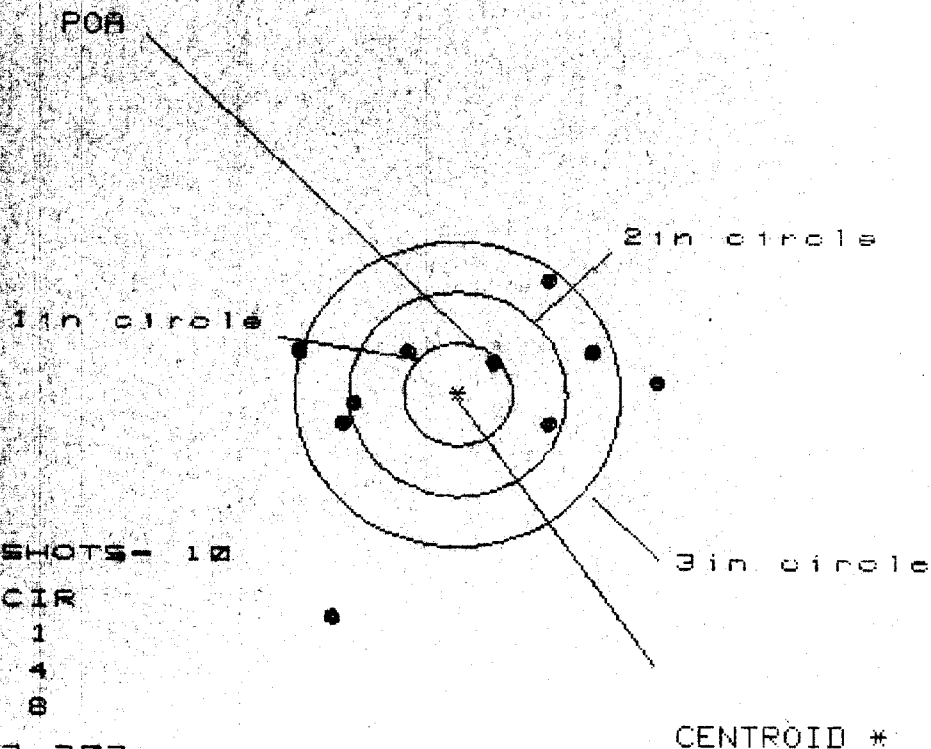
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.544	1.201	1.046
MINIMUM X	:	-1.411	-1.240	-.897
MAXIMUM Y	:	1.307	1.420	1.306
MINIMUM Y	:	-1.025	-.912	-.867
CENTROID X	:	.298	.127	.282
CENTROID Y	:	.168	.055	.169
POA TO CENTROID in.	:	.342	.138	.329
MIN RADIUS	:	.500	.342	.494
MEAN RADIUS	:	1.120	1.000	.951
MAX RADIUS	:	1.847	1.622	1.449
HORIZONTAL SPREAD	:	2.955	2.441	1.943
VERTICAL SPREAD	:	2.332	2.332	2.173
EXTREME SPREAD	:	3.591	3.087	2.355
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6649239

CENTERFIRE PATTERNS # 2



* OF SHOTS - 10

* IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 3.203

VS = 3.234

GS = 3.802

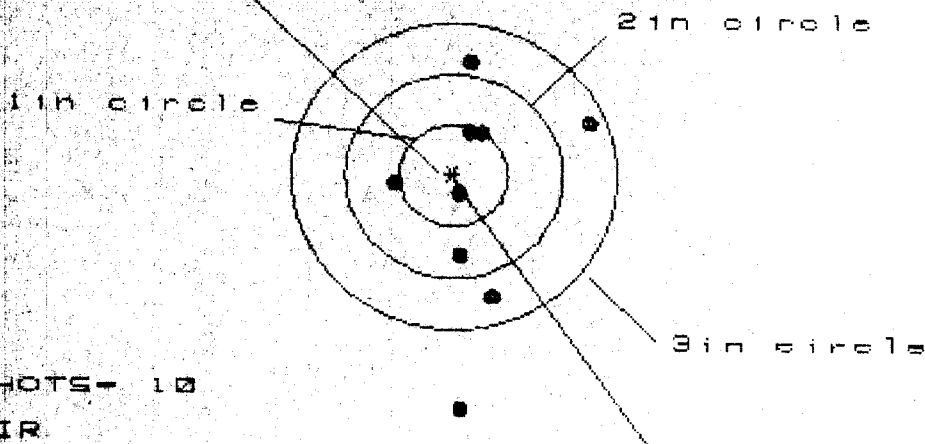
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.788	1.655	1.325
MINIMUM X	-1.415	-1.548	-1.341
MAXIMUM Y	1.095	.858	.847
MINIMUM Y	-2.139	-.551	-.562
CENTROID X	-.335	-.202	-.409
CENTROID Y	-.319	-.082	-.071
POB TO CENTROID in.	.463	.218	.416
MIN RADIUS	.450	.214	.369
MEAN RADIUS	1.226	1.049	.965
MAX RADIUS	2.448	1.658	1.349
HORIZONTAL SPREAD	3.203	3.203	2.666
VERTICAL SPREAD	3.234	1.409	1.409
EXTREME SPREAD	3.802	3.212	2.666
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649239

CENTERFIRE PATTERNS # 1

POB



* OF SHOTS- 10

* IN CIR

1 in = 3

2 in = 5

3 in = 8

HSI = 2.034

VS = 4.256

GS = 4.662

CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.213	1.011	.996
MINIMUM X	:	-1.821	-.719	-.734
MAXIMUM Y	:	1.971	1.329	1.071
MINIMUM Y	:	-2.285	-2.066	-1.185
CENTROID X	:	-.056	.146	.161
CENTROID Y	:	.171	-.048	.210
POB TO CENTROID in.	:	.180	.154	.265
MIN RADIUS	:	.224	.151	.306
MEAN RADIUS	:	1.111	.928	.755
MAX RADIUS	:	2.683	2.069	1.189
HORIZONTAL SPREAD	:	3.034	1.730	1.730
VERTICAL SPREAD	:	4.256	3.395	2.256
EXTREME SPREAD	:	4.662	3.395	2.263
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	