

FORM

UPC



0 47700 25716 2

C6665671

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

BARBER - M24 0101148

Remington



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

MODEL 700TM M24

SERIAL NO.
C6665671

20

ORDER NO.
5716

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



5716 C6665671

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665671

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KL
600	Proof		9/25/91	KL
607	Check Headspace		9/25/91	KL
610	Dis-assemble Gun		9/25/91	KL
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	GB
617	Drill and Tap Sight Holes		OCT 2 1991	FB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	AA
	Apply Coating (Bolt)		10-14-91	AA
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KL
	C) Inspect Ejector Hole for Chamfer		10/16/91	KL
	D) Oil Firing Pin Ass'y		10/16/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	KL

op. #	BARBER MEM24 0101150	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 $\frac{1}{4}$	5 $\frac{3}{4}$	6			10-17-91	DH
	G) Safety Off Force	3 $\frac{1}{4}$	3	2 $\frac{1}{2}$			10-17-91	DH
	H) Trigger Pull Test & Retainability						10/17/91	JH
	I) Firing Pin Indent	.020	.020	.020			10-17-91	DH
	J) Assemble Stock						10/22/91	YK
	K) Assemble Swivel Studs						10/30/91	K
	L) Attach Front and Rear Sight Assemblies						10/22/91	YK
	M) Iron Sight Alignment						10/22/91	YK
	N) Detach Front & Rear Sights & place in numbered container						10/22/91	YK
	O) Attach Scope to Rifle						10/22/91	YK
	P) Detach & Attach Scope 20 Times						10/22/91	YK
640	Gallery Target & Test						10-23-91	DH
	A) Time						10-23-91	DH
	B) Malfunctions						10-23-91	DH
	C) Pierced Primers						10-23-91	DH
	D) Optical Clarity of Scope						10-23-91	DH
645	Inspect for Live Ammo						10-23-91	DH
655	Final Inspection							
	A) Headspace						10-30-91	AC
	B) Trigger Pull	267	273	260	264	264	10-28-91	DH
	C) Function						10-30-91	AC
660	Pack						12-17-91	VF

SWS TRIGGER PULL TEST

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

SERIAL NO C.6665671DATE 10/17/81TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.46	2.50	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.39	2.55	2.73	
PULL #3	2.46	2.49	2.30	2.60	
PULL #4	2.35	2.55	2.38	2.64	
PULL #5	2.50	2.54	2.44	2.64	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.28		
PULL #2	3.34	3.30		
PULL #3	3.19	3.26		
PULL #4	3.43	3.35		
PULL #5	3.41	3.38		
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	4.38		4.35
PULL #2	4.37	4.37		4.27
PULL #3	4.29	4.42		4.49
PULL #4	4.26	4.28		4.32
PULL #5	4.23	4.29		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665671
24 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.206306
1 TO 2	.299043
1 TO 3	.219317
1 TO 4	.491273
1 TO 5	.301144

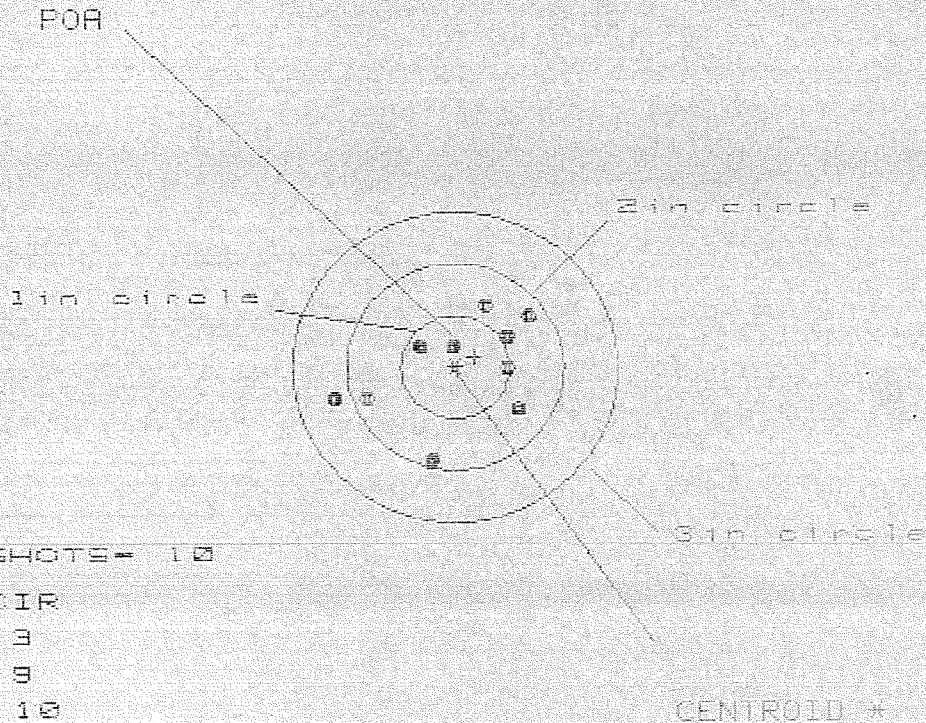
$\bar{x}_c$ ← POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .022
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0298
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0370411
THE AMP FOR THIS RIFLE IS: .933

24 Oct 1991

FILE://PATTERNING/CENTERFIRE_PATT/C8585621

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.794

VS = 1.446

GS = 1.942

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.680	.556	.509
MINIMUM X	-1.114	-.932	-.979
MAXIMUM Y	.582	.551	.439
MINIMUM Y	-.864	-.895	-.557
CENTROID X	-.181	-.057	-.010
CENTROID Y	-.099	-.068	.044
POA TO CENTROID in.	.207	.089	.045
MIN RADIUS	.240	.271	.245
MEAN RADIUS	.673	.598	.523
MAX RADIUS	1.148	.987	1.072
HORIZONTAL SPREAD	1.794	1.488	1.488
VERTICAL SPREAD	1.446	1.446	.996
EXTREME SPREAD	1.942	1.670	1.670
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 9		
NUMBER IN THREE INCH CIRCLE	= 10		

24 Oct 1991

FILE: \PATTERNING\ CENTERFIRE_PATT\08665671

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.845

VS= 2.211

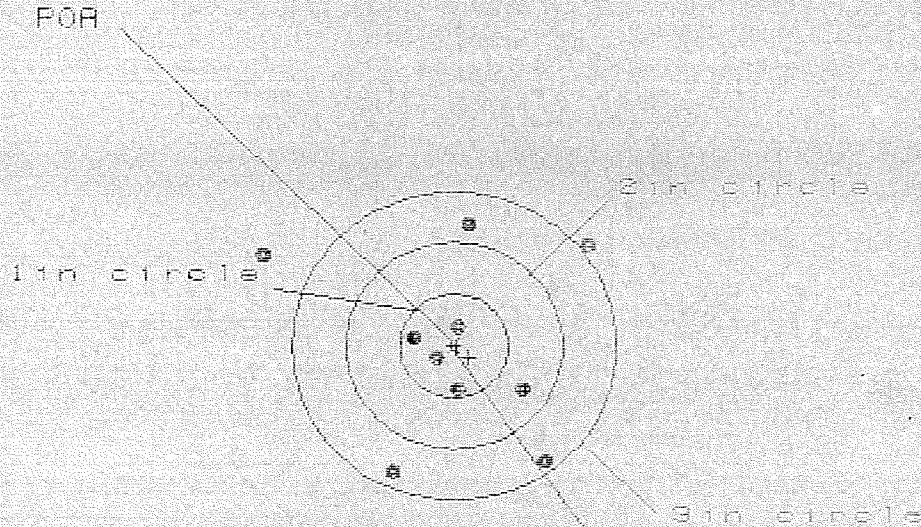
GS= 2.215

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.779	.827	.800
MINIMUM X	:	-1.066	-1.018	-.914
MAXIMUM Y	:	.881	.733	.814
MINIMUM Y	:	-1.331	-.765	-.684
CENTROID X	:	.112	.064	-.040
CENTROID Y	:	-.104	.044	-.037
POA TO CENTROID in.	:	.152	.077	.054
MIN RADIUS	:	.249	.245	.359
MEAN RADIUS	:	.803	.726	.689
MAX RADIUS	:	1.400	1.053	.939
HORIZONTAL SPREAD	:	1.845	1.845	1.714
VERTICAL SPREAD	:	2.211	1.498	1.498
EXTREME SPREAD	:	2.215	2.062	1.741
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

24 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/05685671

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 8

HS = 2.997

VS = 2.385

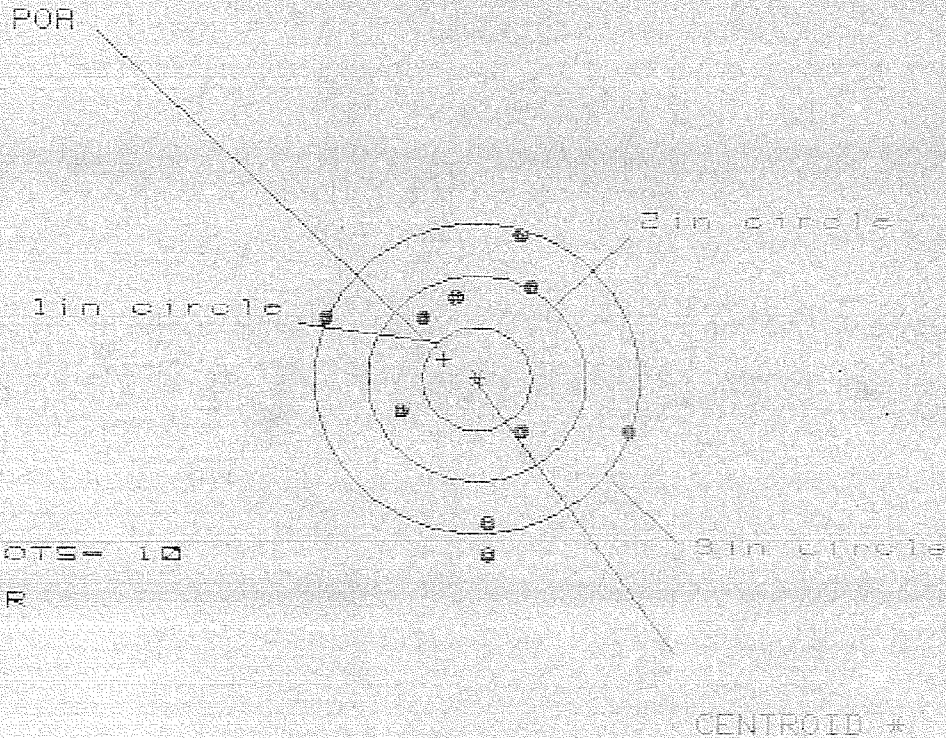
GS = 3.208

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.276
MINIMUM X	-1.721
MAXIMUM Y	1.168
MINIMUM Y	-1.217
CENTROID X	-0.133
CENTROID Y	.115
POA TO CENTROID in.	.176
MIN RADIUS	.232
MEAN RADIUS	.952
MAX RADIUS	1.924
HORIZONTAL SPREAD	2.997
VERTICAL SPREAD	2.385
EXTREME SPREAD	3.208
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.716

VS= 3.088

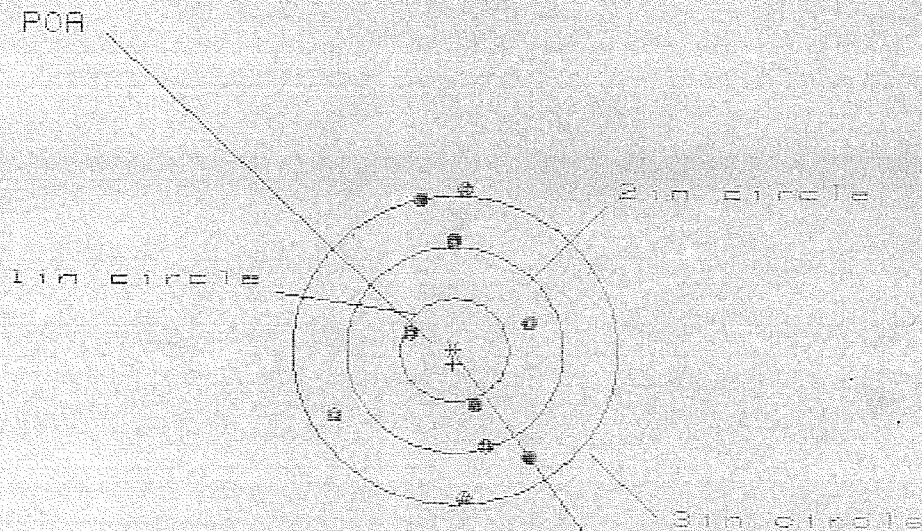
GS= 3.102

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.364	1.194
MINIMUM X	:	-1.360	-1.352	-1.839
MAXIMUM Y	:	1.428	1.243	1.296
MINIMUM Y	:	-1.660	-1.579	-1.526
CENTROID X	:	.301	.294	.464
CENTROID Y	:	-.194	-.009	-.061
POR TO CENTROID in.	:	.358	.295	.468
MIN RADIUS	:	.626	.661	.663
MEAN RADIUS	:	1.145	1.065	1.024
MAX RADIUS	:	1.661	1.585	1.527
HORIZONTAL SPREAD	:	2.716	2.716	2.833
VERTICAL SPREAD	:	3.088	2.822	2.822
EXTREME SPREAD	:	3.102	2.915	2.832
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.817

VS = 3.047

GS = 3.047

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.661
MINIMUM X	-1.156
MAXIMUM Y	1.601
MINIMUM Y	-1.446
CENTROID X	.011
CENTROID Y	.133
POA TO CENTROID in.	.133
MIN RADIUS	.476
MEAN RADIUS	1.092
MAX RADIUS	1.603
HORIZONTAL SPREAD	1.817
VERTICAL SPREAD	3.047
EXTREME SPREAD	3.047
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9