

FORM

UPC



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C6665692

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0101383

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665692

ORDER NO.

5716

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



5716 C6665692

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665692

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	81	RW
610	Dis-assemble Gun	10 1	81	RW
612	Magnaflux Barrel Action		OCT 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	JS.
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/91	JA

op. #	BARBER - M24 0101385 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/2	4 1/2	5 1/4			10-30-91	DH
	G) Safety Off Force	2	2	2 1/4			10-30-91	DH
	H) Trigger Pull Test & Retainability						10/30/91	JH
	I) Firing Pin Indent	.021	.020	.020			10-30-91	DH
	J) Assemble Stock						11/4/91	RW
	K) Assemble Swivel Studs						11-12-91	K
	L) Attach Front and Rear Sight Assemblies						11/4/91	RW
	M) Iron Sight Alignment						11/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	RW
	O) Attach Scope to Rifle						11/4/91	RW
	P) Detach & Attach Scope 20 Times						11/4/91	RW
640	Gallery Target & Test						11-4-91	N
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-4-91	NF
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	276	278	279	271	278	11-6-91	DH
	C) Function						11-12-91	K
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. C6665682DATE 10/30/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.35	2.30	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.22	2.32	2.78	
PULL #3	2.35	2.31	2.34	2.79	
PULL #4	2.31	2.29	2.40	2.71	
PULL #5	2.31	2.27	2.44	2.78	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.47		
PULL #2	3.46	3.54		
PULL #3	3.46	3.56		
PULL #4	3.20	3.44		
PULL #5	3.52	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.44		4.34
PULL #2	4.48	4.37		4.39
PULL #3	4.50	4.36		4.34
PULL #4	4.34	4.37		4.38
PULL #5	4.33	4.33		4.27
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665692
4 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.172012
1 TO	2	.207077
1 TO	3	.163025
1 TO	4	.157153
1 TO	5	.0896939

* <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .042
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0776
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .08823

THE AMR FOR THIS RIFLE IS: 1.365

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06060602

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 1

3 in = 3

HS = 4.315

VS = 3.870

GS = 4.490

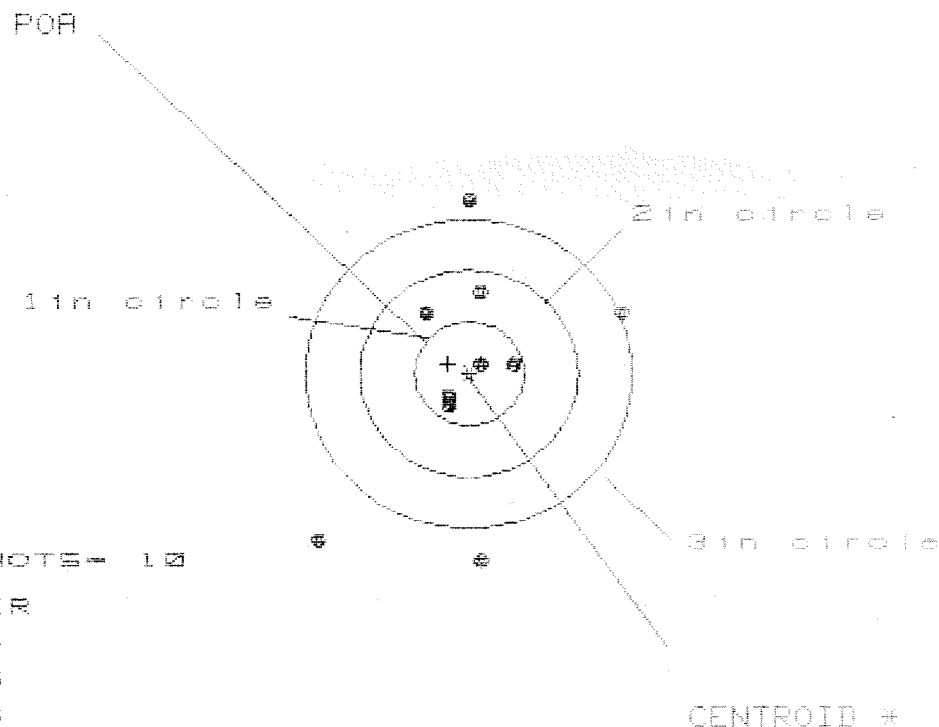
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.441	1.347	1.147
MINIMUM X	:	-1.874	-1.603	-1.725
MAXIMUM Y	:	2.026	1.870	1.620
MINIMUM Y	:	-1.844	-2.000	-1.751
CENTROID X	:	.002	-.269	-.069
CENTROID Y	:	-.172	-.016	.234
POA TO CENTROID in.	:	.172	.270	.244
MIN RADIUS	:	.553	.829	.718
MEAN RADIUS	:	1.831	1.720	1.530
MAX RADIUS	:	2.815	2.563	2.226
HORIZONTAL SPREAD	:	4.315	2.950	2.872
VERTICAL SPREAD	:	3.870	3.870	3.371
EXTREME SPREAD	:	4.490	4.488	3.739
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	1		
NUMBER IN THREE INCH CIRCLE	=	3		

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08865692

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 5

3in = 6

HS = 2.737

VS = 3.449

GS = 3.590

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.369	1.217	1.217
MINIMUM X	:	-1.368	-.547	-.547
MAXIMUM Y	:	1.690	1.510	1.268
MINIMUM Y	:	-1.759	-1.939	-.688
CENTROID X	:	.193	.345	.345
CENTROID Y	:	-.092	.088	.336
POA TO CENTROID in.	:	.214	.356	.478
MIN RADIUS	:	.104	.142	.375
MEAN RADIUS	:	.970	.839	.719
MAX RADIUS	:	2.119	1.939	1.274
HORIZONTAL SPREAD	:	2.737	1.764	1.764
VERTICAL SPREAD	:	3.449	3.449	1.956
EXTREME SPREAD	:	3.590	3.451	1.973
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

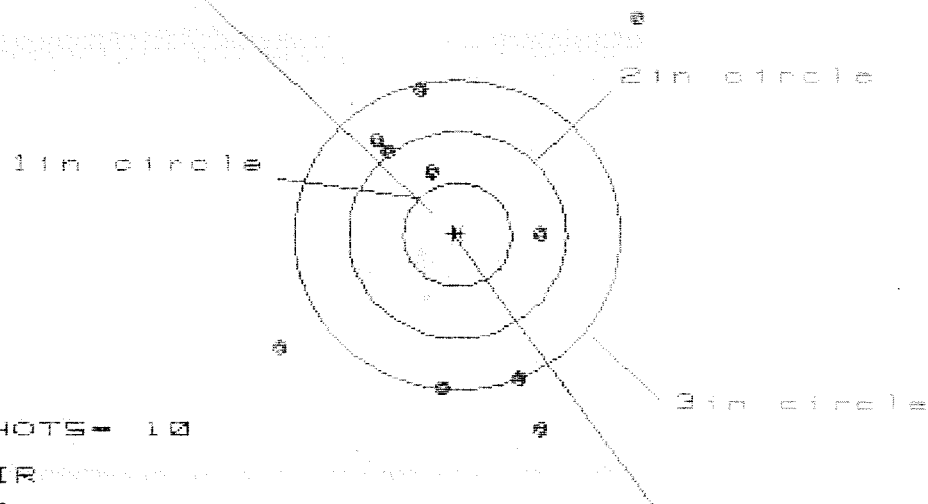
4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685692

CENTERFIRE PATTERNS

3

POA



OF SHOTS = 10

IN CIRCLES

1in = 0

2in = 2

3in = 6

HS = 3.348

VS = 3.956

GS = 4.588

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.683
MINIMUM X	-1.665
MAXIMUM Y	2.084
MINIMUM Y	-1.872
CENTROID X	.038
CENTROID Y	-.013
POA TO CENTROID in.	.040
MIN RADIUS	.624
MEAN RADIUS	1.470
MAX RADIUS	2.679
HORIZONTAL SPREAD	3.348
VERTICAL SPREAD	3.956
EXTREME SPREAD	4.588
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	2
NUMBER IN THREE INCH CIRCLE	6

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685682

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIRCLES

1in = 3

2in = 3

3in = 8

HS= 2.453

VS= 4.124

CS= 4.150

CENTROID *

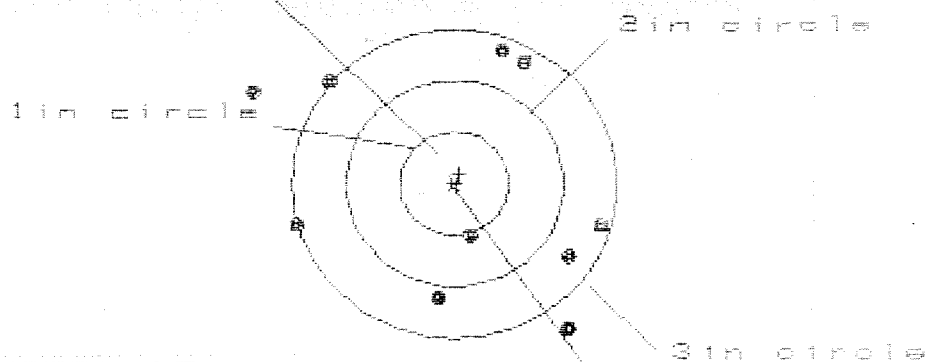
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.421
MINIMUM X	-1.032
MAXIMUM Y	2.076
MINIMUM Y	-2.048
CENTROID X	.021
CENTROID Y	-.016
POA TO CENTROID in.	.026
MIN RADIUS	.430
MEAN RADIUS	1.169
MAX RADIUS	2.232
HORIZONTAL SPREAD	2.453
VERTICAL SPREAD	4.124
EXTREME SPREAD	4.150
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685692

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIRC

1 in = 6

2 in = 1

3 in = 6

HS = 3.216

VS = 2.709

GS = 3.639

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.383	1.180	1.278
MINIMUM X	-1.833	-1.682	-1.583
MAXIMUM Y	1.339	1.441	1.283
MINIMUM Y	-1.370	-1.268	-1.122
CENTROID X	-.044	.159	.060
CENTROID Y	-.095	-.197	-.039
POA TO CENTROID in.	.105	.254	.072
MIN RADIUS	.526	.422	.570
MEAN RADIUS	1.387	1.277	1.262
MAX RADIUS	2.052	1.729	1.640
HORIZONTAL SPREAD	3.216	2.862	2.862
VERTICAL SPREAD	2.709	2.709	2.405
EXTREME SPREAD	3.639	3.177	2.879
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		1	
NUMBER IN THREE INCH CIRCLE =		6	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665692
6 Nov 1991

CENTROIDAL DISTANCES

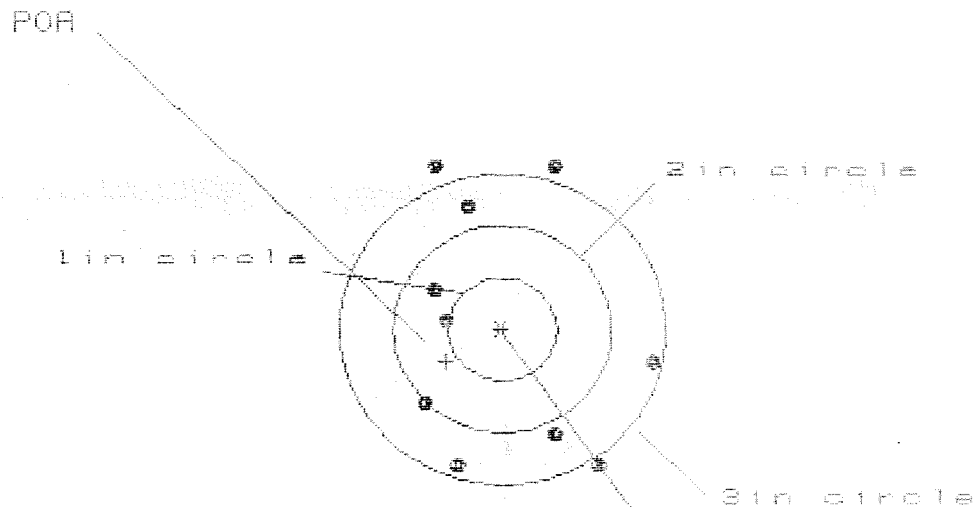
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1 TO	3	.463418
1 TO	4	.620291
1 TO	5	.420595

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5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB65692.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 2.053

VS= 2.905

GS= 3.288

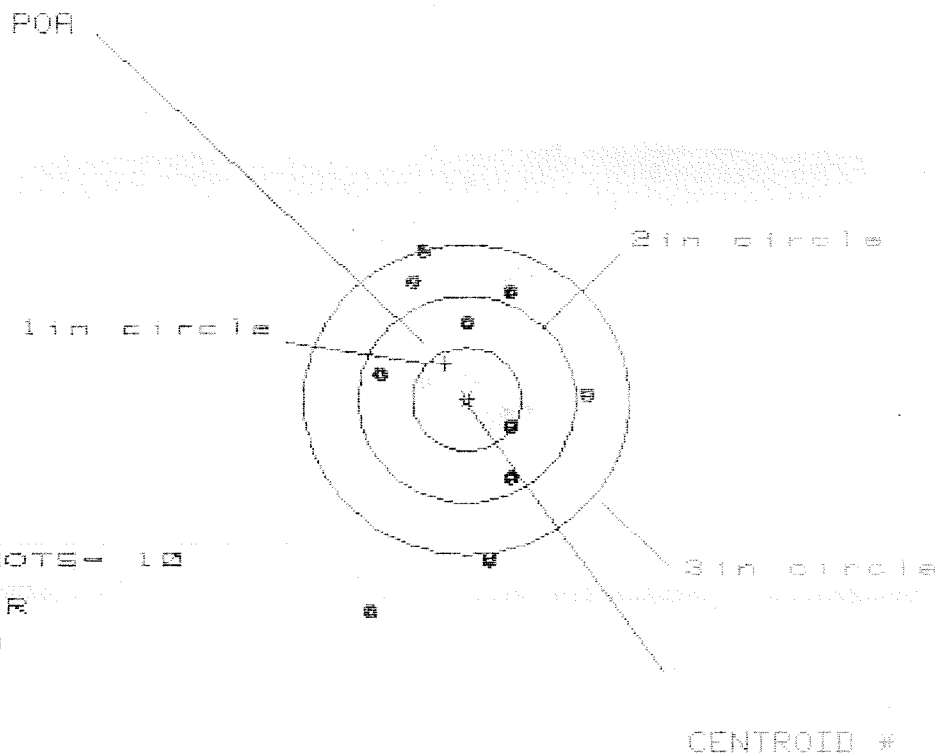
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.287	1.393
MINIMUM X	-.698	-.766	-.659
MAXIMUM Y	1.561	1.734	1.588
MINIMUM Y	-1.344	-1.171	-1.289
CENTROID X	.518	.586	.479
CENTROID Y	.313	.140	.286
POA TO CENTROID in.	.605	.603	.559
MIN RADIUS	.503	.609	.468
MEAN RADIUS	1.224	1.168	1.110
MAX RADIUS	1.677	1.776	1.661
HORIZONTAL SPREAD	2.053	2.053	2.053
VERTICAL SPREAD	2.905	2.905	2.877
EXTREME SPREAD	3.288	3.005	3.005
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685692.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 0

2in = 4

3in = 7

HS = 1.909

VS = 3.494

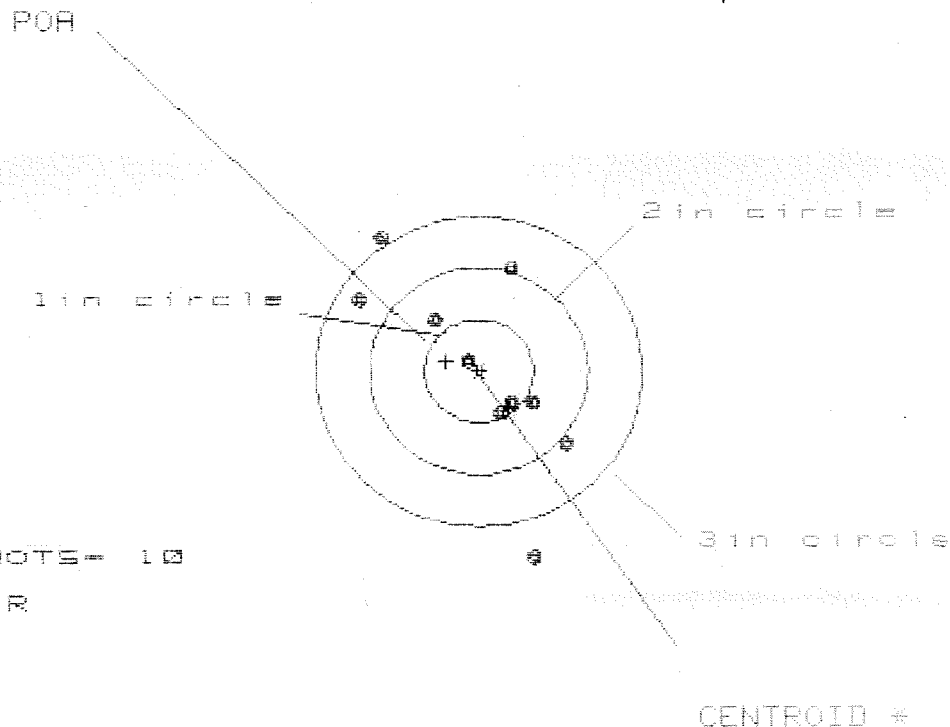
GS = 3.526

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	.961	.973
MINIMUM X	:	-.853	-.845	-.834
MAXIMUM Y	:	1.466	1.241	1.015
MINIMUM Y	:	-2.027	-1.808	-1.178
CENTROID X	:	.196	.291	.279
CENTROID Y	:	-.348	-.122	.104
POA TO CENTROID in.	:	.399	.316	.298
MIN RADIUS	:	.501	.490	.269
MEAN RADIUS	:	1.150	.995	.854
MAX RADIUS	:	2.200	1.810	1.226
HORIZONTAL SPREAD	:	1.909	1.806	1.806
VERTICAL SPREAD	:	3.494	3.049	2.193
EXTREME SPREAD	:	3.526	3.102	2.336
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G8665682.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.974

VS= 3.140

GS= 3.409

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.832	.883	.781
MINIMUM X	:	-1.142	-1.091	-1.193
MAXIMUM Y	:	1.330	1.129	.929
MINIMUM Y	:	-1.810	-.908	-.767
CENTROID X	:	.302	.251	.353
CENTROID Y	:	-.097	.104	-.037
POA TO CENTROID in.	:	.317	.272	.355
MIN RADIUS	:	.154	.142	.183
MEAN RADIUS	:	.928	.829	.731
MAX RADIUS	:	1.867	1.394	1.347
HORIZONTAL SPREAD	:	1.974	1.974	1.974
VERTICAL SPREAD	:	3.140	2.037	1.696
EXTREME SPREAD	:	3.409	2.653	2.415
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685682.1

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 1.845

VS= 3.855

GS= 4.305

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	.942	.612
MINIMUM X	:	-.905	-1.003	-.885
MAXIMUM Y	:	2.300	2.019	1.857
MINIMUM Y	:	-1.555	-1.300	-1.117
CENTROID X	:	.262	.360	.242
CENTROID Y	:	-.252	-.507	-.345
POA TO CENTROID in.	:	.363	.622	.421
MIN RADIUS	:	.426	.192	.332
MEAN RADIUS	:	1.179	.964	.909
MAX RADIUS	:	2.461	2.079	1.955
HORIZONTAL SPREAD	:	1.945	1.945	1.497
VERTICAL SPREAD	:	3.855	3.319	2.974
EXTREME SPREAD	:	4.305	3.349	3.162
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

6 Nov 1991

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.103

VS = 2.926

GS = 3.121

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.289	1.256	1.351
MINIMUM X	:	-.814	-.847	-.752
MAXIMUM Y	:	1.708	1.583	1.454
MINIMUM Y	:	-1.218	-1.028	-1.054
CENTROID X	:	.318	.351	.257
CENTROID Y	:	-.057	-.247	-.118
POA TO CENTROID in.	:	.323	.429	.282
MIN RADIUS	:	.366	.340	.437
MEAN RADIUS	:	1.021	.920	.871
MAX RADIUS	:	1.733	1.586	1.454
HORIZONTAL SPREAD	:	2.103	2.103	2.103
VERTICAL SPREAD	:	2.926	2.611	2.508
EXTREME SPREAD	:	3.121	2.748	2.591
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	