

FURN

UPC



0 47700 25716 2

06665702

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0101509

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665702

ORDER NO.

5716

20

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



5716 C6665702

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665702

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 4 1991	KR
	Magnaflux Bolt		OCT 4 1991	KR
615	Rollmark Caliber		OCT 4 1991	GS.
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	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/23/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/23/91	RW
	C) Inspect Ejector Hole for Chamfer		10/23/91	RW
	D) Oil Firing Pin Ass'y		10/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/30/91	JH

op. #	BARBER - M24 0101511 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10-30-91	DH
	G) Safety Off Force	3 1/4	2 3/4	3			10-30-91	DH
	H) Trigger Pull Test & Retainability						10/30/91	JM
	I) Firing Pin Indent	.020	.020	.020			10-30-91	DH
	J) Assemble Stock						11/4/91	Rev
	K) Assemble Swivel Studs						11-13-91	AC
	L) Attach Front and Rear Sight Assemblies						11/4/91	Rev
	M) Iron Sight Alignment						11/4/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	Rev
	O) Attach Scope to Rifle						11/4/91	Rev
		P) Detach & Attach Scope 20 Times						11/4/91
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						11-13-91	AC
	B) Trigger Pull	246	251	254	256	261	11-6-91	DH
	C) Function						11-13-91	AC
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-6665702DATE 10/30/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.40	2.38	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.31	2.36	2.51	
PULL #3	2.28	2.38	2.31	2.54	
PULL #4	2.32	2.36	2.38	2.56	
PULL #5	2.27	2.30	2.38	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.54		
PULL #2	3.55	3.43		
PULL #3	3.47	3.51		
PULL #4	3.34	3.38		
PULL #5	3.50	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.50		4.48
PULL #2	4.48	4.47		4.44
PULL #3	4.45	4.48		4.48
PULL #4	4.39	4.44		4.46
PULL #5	4.44	4.44		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665702
4 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.251072
1 TO	2	.704483
1 TO	3	.397454
1 TO	4	.306757
1 TO	5	.257099

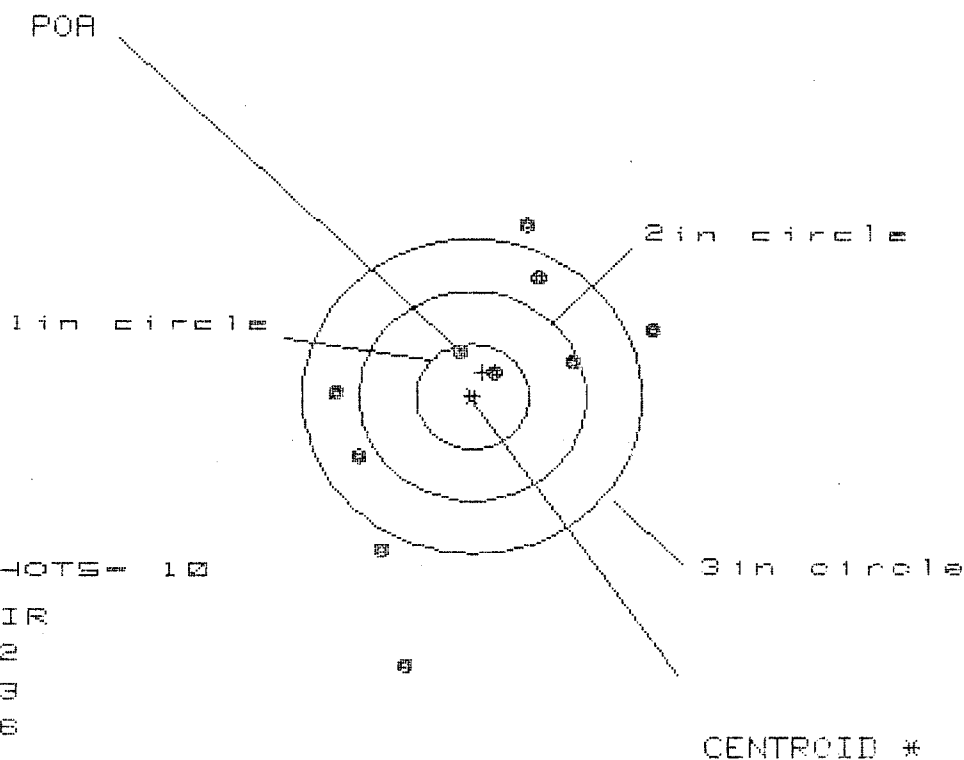
σ^2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1348
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .005
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .134893
THE AMR FOR THIS RIFLE IS: 1.005

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865782

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 6

HS= 2.768

VS= 4.238

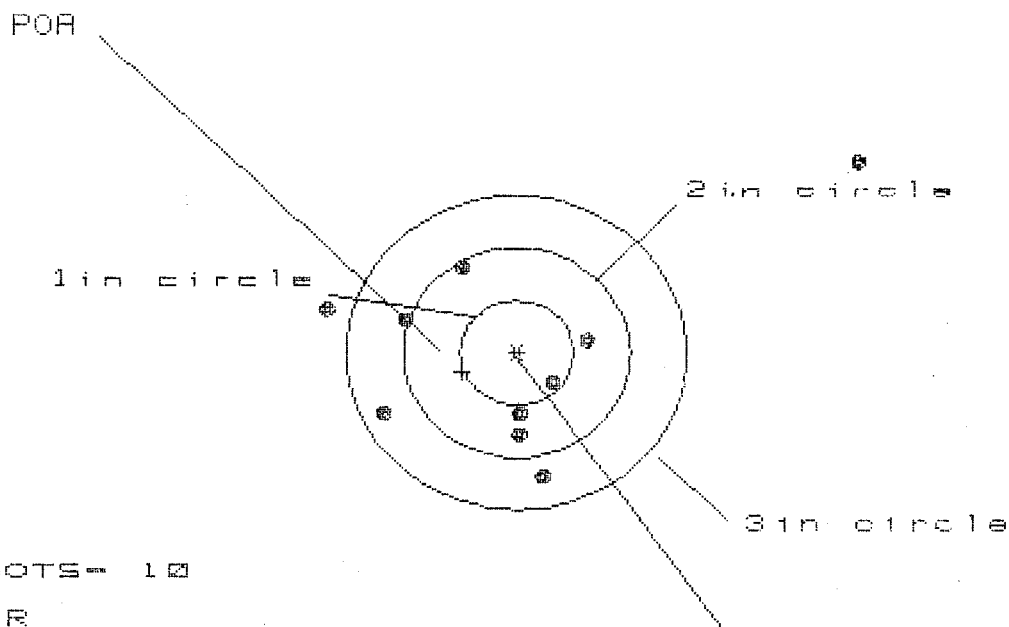
GS= 4.379

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.584	1.521	1.580
MINIMUM X	-1.184	-1.247	-1.188
MAXIMUM Y	1.683	1.399	.993
MINIMUM Y	-2.555	-1.711	-1.536
CENTROID X	-.091	-.028	-.087
CENTROID Y	-.234	.050	-.125
POA TO CENTROID in.	.251	.057	.152
MIN RADIUS	.277	.091	.189
MEAN RADIUS	1.308	1.088	1.061
MAX RADIUS	2.617	1.943	1.761
HORIZONTAL SPREAD	2.768	2.768	2.768
VERTICAL SPREAD	4.238	3.110	2.529
EXTREME SPREAD	4.379	3.408	3.203
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

4 Nov 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 4.600

VS = 3.047

GS = 4.900

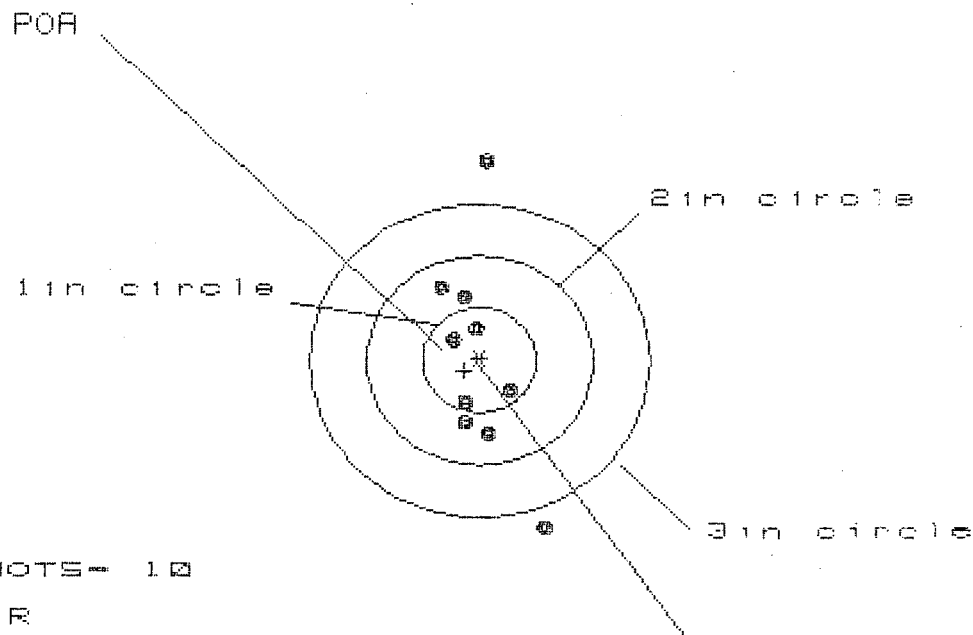
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	3.028	.979	.814
MINIMUM X	:	-1.652	-1.315	-1.046
MAXIMUM Y	:	1.847	1.030	1.105
MINIMUM Y	:	-1.200	-.995	-.920
CENTROID X	:	.479	.142	.307
CENTROID Y	:	.180	-.025	-.100
POR TO CENTROID in.	:	.512	.144	.322
MIN RADIUS	:	.476	.499	.334
MEAN RADIUS	:	1.222	.920	.812
MAX RADIUS	:	3.547	1.445	1.145
HORIZONTAL SPREAD	:	4.600	2.294	1.860
VERTICAL SPREAD	:	3.047	2.025	2.025
EXTREME SPREAD	:	4.900	2.440	2.132
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

4 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10
 # IN CIR
 1in = 4
 2in = 8
 3in = 8
 HS = .836
 VS = 3.518
 GS = 3.549

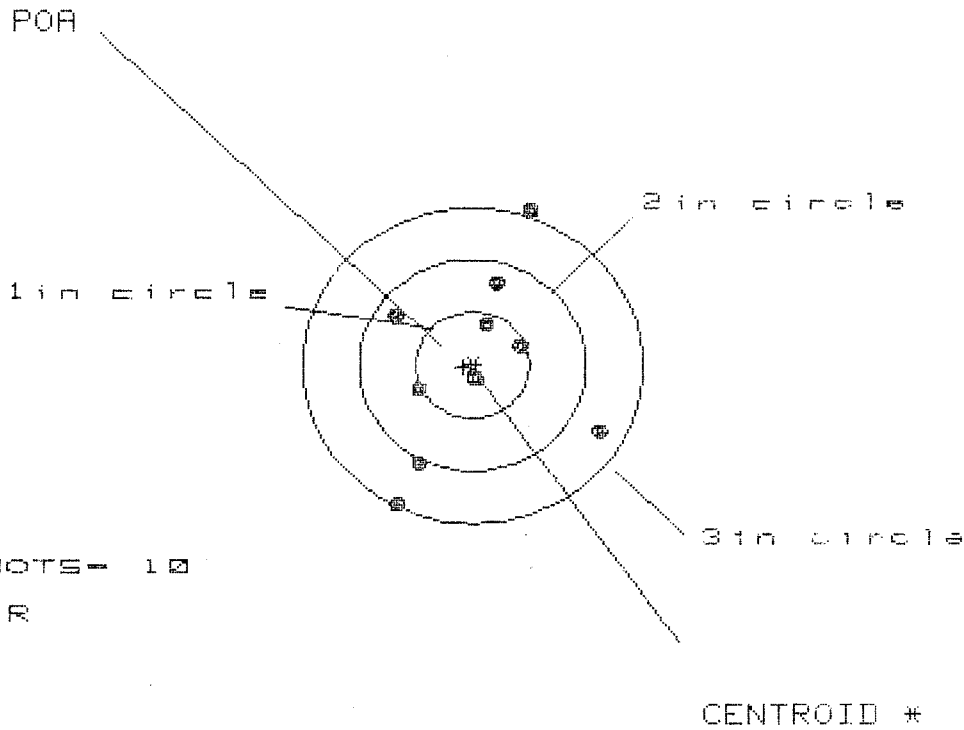
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.536	.543	.353
MINIMUM X	:	-.388	-.293	-.225
MAXIMUM Y	:	1.878	.934	.755
MINIMUM Y	:	-1.640	-1.431	-.684
CENTROID X	:	.132	.125	.057
CENTROID Y	:	.095	-.114	.065
POA TO CENTROID in.	:	.163	.169	.087
MIN RADIUS	:	.293	.193	.294
MEAN RADIUS	:	.773	.632	.509
MAX RADIUS	:	1.879	1.531	.788
HORIZONTAL SPREAD	:	.836	.836	.578
VERTICAL SPREAD	:	3.518	2.365	1.439
EXTREME SPREAD	:	3.549	2.508	1.497
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			8	

4 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.033

VS= 2.740

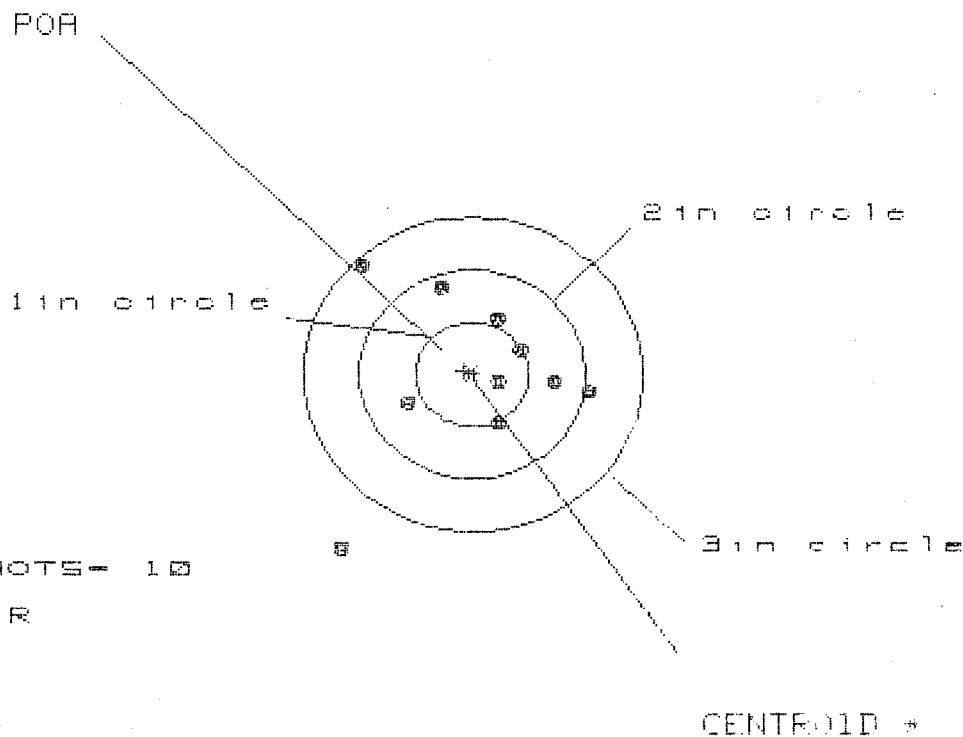
GS= 3.017

PATTERN #	4	4	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.106	1.166	1.082
MINIMUM X	-.727	-.667	-.727
MAXIMUM Y	1.440	.910	.767
MINIMUM Y	-1.300	-1.140	-.887
CENTROID X	.081	.021	.105
CENTROID Y	.020	-.140	.003
POA TO CENTROID in.	.083	.141	.105
MIN RADIUS	.174	.119	.150
MEAN RADIUS	.857	.783	.692
MAX RADIUS	1.536	1.321	1.245
HORIZONTAL SPREAD	1.833	1.833	1.809
VERTICAL SPREAD	2.740	2.050	1.654
EXTREME SPREAD	3.017	2.259	2.109
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

4 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.268

VS= 2.688

GS= 2.688

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.072	.939	.799
MINIMUM X	:	-1.196	-1.120	-.807
MAXIMUM Y	:	1.060	.880	.785
MINIMUM Y	:	-1.620	-.631	-.521
CENTROID X	:	.073	.206	.346
CENTROID Y	:	-.036	.144	.034
POA TO CENTROID in.	:	.081	.251	.348
MIN RADIUS	:	.230	.295	.189
MEAN RADIUS	:	.866	.704	.576
MAX RADIUS	:	2.014	1.424	.947
HORIZONTAL SPREAD	:	2.268	2.059	1.606
VERTICAL SPREAD	:	2.688	1.511	1.306
EXTREME SPREAD	:	2.688	2.420	1.703
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	