

FORN

UPC



C6665704

•INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

BARBER - M24 0101533

Remington



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

MODEL 700TM M24

SERIAL NO.
C6665704

ORDER NO.
5716

20

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



5716 C6665704

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 # C6665704

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		LS
617	Drill and Tap Sight Holes	OCT 4 1991		LB
618	Polish Barrel		10/5/91	WB
620	Apply Coatings (Barrel Action)		10/22/91	JS
	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		10/24/91	JS

op. #	BARBER - M24 0101535 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/24/91	JK
	G) Safety Off Force	3	3	3			10/24/91	JK
	H) Trigger Pull Test & Retainability						6/24/91	JK
	I) Firing Pin Indent	.0205	.0205	.0205			10/24/91	JK
	J) Assemble Stock						11/6/91	RW
	K) Assemble Swivel Studs						11-27-91	K
	L) Attach Front and Rear Sight Assemblies						11/6/91	RW
	M) Iron Sight Alignment						11/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/6/91	RW
	O) Attach Scope to Rifle						11/6/91	RW
	P) Detach & Attach Scope 20 Times						11/6/91	RW
640	Gallery Target & Test						11/6/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/6/91	25
655	Final Inspection							
	A) Headspace						11-27-91	K
	B) Trigger Pull	280	212	211	212	212	11-15-91	D/L
	C) Function						11-27-91	K
660	Pack						12-17-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6665704

DATE 10/24/91

TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.60	2.50	2.10	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.34	2.37	2.12	
PULL #3	2.20	2.56	2.49	2.11	
PULL #4	2.29	2.51	2.38	2.12	
PULL #5	2.24	2.49	2.50	2.12	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.41		
PULL #2	3.67	3.40		
PULL #3	3.26	3.30		
PULL #4	3.39	3.42		
PULL #5	3.41	3.44		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.50		4.60
PULL #2	4.31	4.53		4.47
PULL #3	4.37	4.52		4.70
PULL #4	4.20	4.60		4.30
PULL #5	4.19	4.63		4.69
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665704
6 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.470306
1 TO	2	.644854
1 TO	3	.863669
1 TO	4	.30316
1 TO	5	.804873

+2³ <----POA
1⁴
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3504
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3206
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .476299
THE AMR FOR THIS RIFLE IS: 1.128

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665784

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 2.305

VS= 3.466

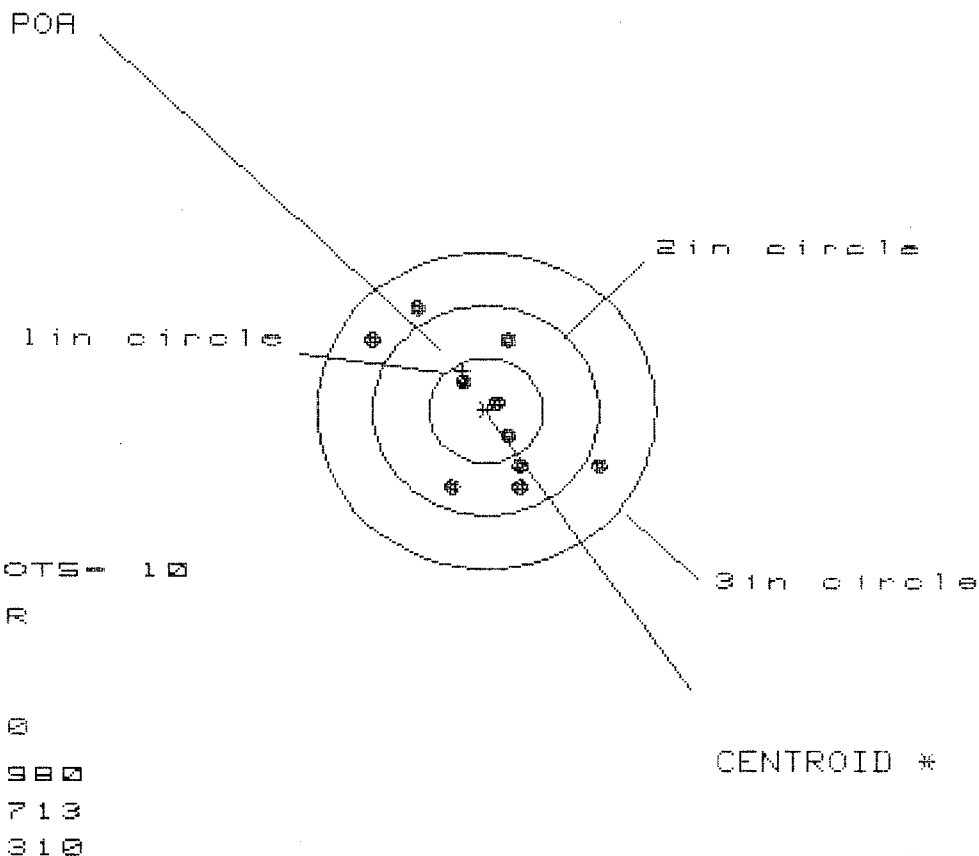
GS= 3.775

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.074	1.128
MINIMUM X	:	-.977	-.829	-.775
MAXIMUM Y	:	1.597	1.432	1.178
MINIMUM Y	:	-1.869	-2.034	-1.923
CENTROID X	:	.642	.494	.440
CENTROID Y	:	-.801	-.636	-.382
POA TO CENTROID in.	:	1.026	.806	.583
MIN RADIUS	:	.494	.292	.033
MEAN RADIUS	:	1.337	1.197	.982
MAX RADIUS	:	1.988	2.080	2.167
HORIZONTAL SPREAD	:	2.305	1.903	1.903
VERTICAL SPREAD	:	3.466	3.466	3.101
EXTREME SPREAD	:	3.775	3.651	3.516
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	6		

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665704

CENTERFIRE PATTERNS # 4

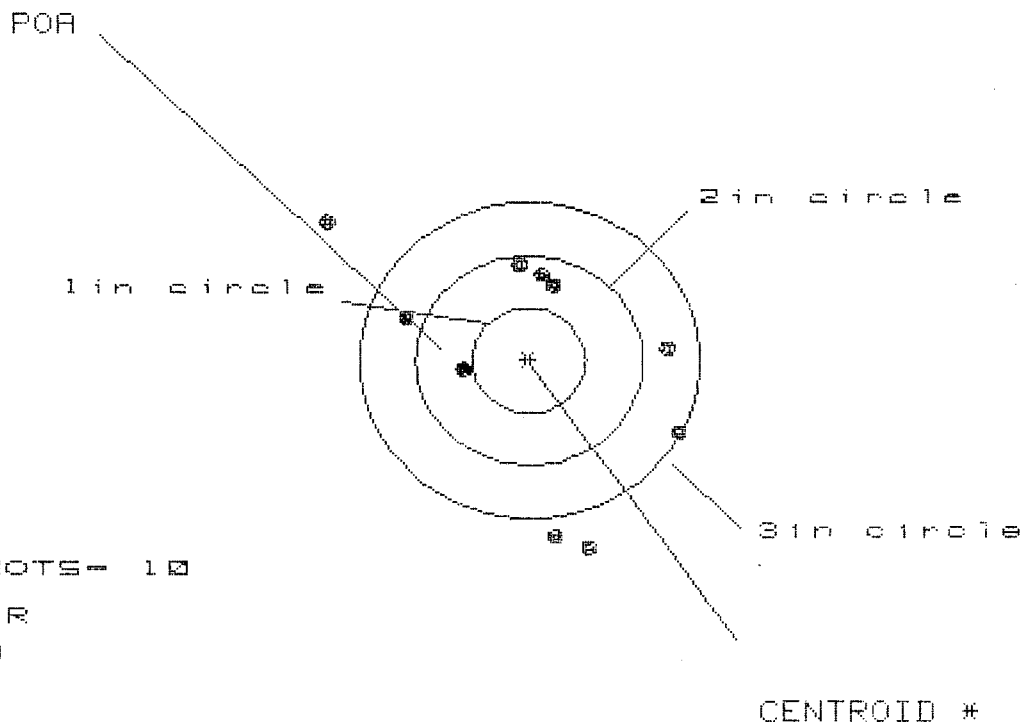


PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.899	.805
MINIMUM X	-.973	-.753	-.459
MAXIMUM Y	.954	1.032	.913
MINIMUM Y	-.759	-.681	-.552
CENTROID X	.203	.311	.405
CENTROID Y	-.377	-.455	-.584
POA TO CENTROID in.	.428	.551	.711
MIN RADIUS	.097	.169	.058
MEAN RADIUS	.724	.656	.553
MAX RADIUS	1.200	1.277	.913
HORIZONTAL SPREAD	1.980	1.652	1.264
VERTICAL SPREAD	1.713	1.713	1.465
EXTREME SPREAD	2.310	2.193	1.533
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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FILE:/PATTERNING/CENTERFIRE_PATT/C6665704

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 7

HS= 3.087

VS= 3.129

GS= 3.868

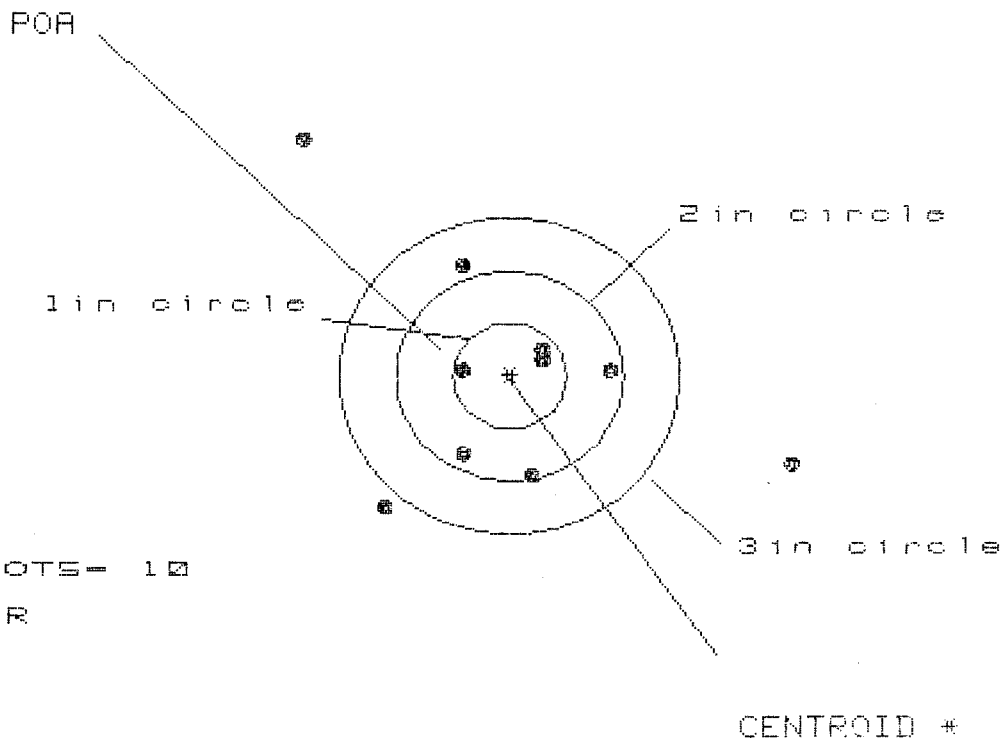
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.088	1.123
MINIMUM X	:	-1.799	-1.265	-1.230
MAXIMUM Y	:	1.300	1.024	.814
MINIMUM Y	:	-1.829	-1.685	-1.718
CENTROID X	:	.582	.782	.747
CENTROID Y	:	.083	-.061	.149
POA TO CENTROID in.	:	.588	.784	.762
MIN RADIUS	:	.611	.804	.624
MEAN RADIUS	:	1.256	1.161	1.040
MAX RADIUS	:	2.219	1.787	1.721
HORIZONTAL SPREAD	:	3.087	2.353	2.353
VERTICAL SPREAD	:	3.129	2.709	2.532
EXTREME SPREAD	:	3.868	2.758	2.599
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6865784

CENTERFIRE PATTERNS

2



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 4.224

VS= 3.566

GS= 5.275

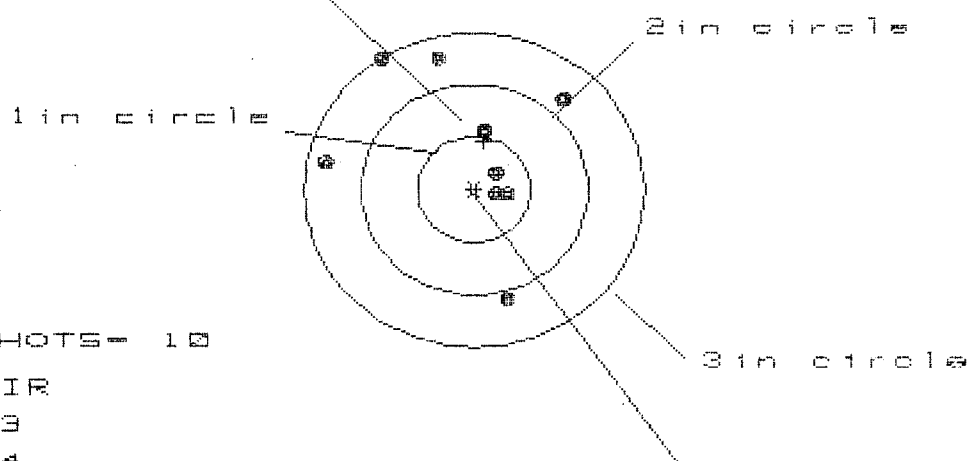
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.441	2.243	.950
MINIMUM X	:	-1.783	-1.315	-1.034
MAXIMUM Y	:	2.299	1.262	1.187
MINIMUM Y	:	-1.267	-1.012	-1.087
CENTROID X	:	.413	.611	.330
CENTROID Y	:	-.056	-.311	-.236
POA TO CENTROID in.	:	.416	.686	.406
MIN RADIUS	:	.350	.429	.400
MEAN RADIUS	:	1.212	1.026	.835
MAX RADIUS	:	2.909	2.323	1.501
HORIZONTAL SPREAD	:	4.224	3.558	1.984
VERTICAL SPREAD	:	3.566	2.274	2.274
EXTREME SPREAD	:	5.275	3.581	2.397
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665704

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 2.115

VS= 4.610

GS= 4.827

CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.794	.859	.762
MINIMUM X	:	-1.321	-1.256	-1.353
MAXIMUM Y	:	1.291	.922	1.012
MINIMUM Y	:	-3.319	-1.427	-1.312
CENTROID X	:	-.088	-.153	-.056
CENTROID Y	:	-.462	-.093	-.208
POA TO CENTROID in.:	:	.470	.179	.215
MIN RADIUS	:	.189	.200	.207
MEAN RADIUS	:	1.112	.818	.732
MAX RADIUS	:	3.371	1.478	1.353
HORIZONTAL SPREAD	:	2.115	2.115	2.115
VERTICAL SPREAD	:	4.610	2.349	2.324
EXTREME SPREAD	:	4.827	2.622	2.404
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	8		