

FORM

UPC



06665711

*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0101619

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665711

ORDER NO.

5716

20

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



5716 C6665711

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665711

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	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	GL
617	Drill and Tap Sight Holes		OCT 4 1991	LB
618	Polish Barrel		10/8/91	WLB
620	Apply Coatings (Barrel Action)		10-22-91	JA
	Apply Coating (Bolt)		10-22-91	JA
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		11-7-91	GL

op. #	BARBER - M24 0101621 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-11-91	JH
	G) Safety Off Force	3	3	3			11-11-91	JH
	H) Trigger Pull Test & Retainability						11-7-91	JH
	I) Firing Pin Indent	.021	.021	.021			11-11-91	JH
	J) Assemble Stock						11/11/91	RW
	K) Assemble Swivel Studs						11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/11/91	RW
	M) Iron Sight Alignment						11/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	RW
	O) Attach Scope to Rifle						11/11/91	RW
	P) Detach & Attach Scope 20 Times						11/11/91	RW
640	Gallery Target & Test						11-14-91	AC
	A) Time						11-14-91	AC
	B) Malfunctions						11-14-91	AC
	C) Pierced Primers						11-14-91	AC
	D) Optical Clarity of Scope						11-14-91	AC
645	Inspect for Live Ammo						11-14-91	AC
655	Final Inspection							
	A) Headspace						11-17-91	D/H
	B) Trigger Pull	2.66	2.66	2.47	2.54	2.62	11-14-91	D/H
	C) Function						11-17-91	D/H
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-6665711DATE 11-7-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.51	2.54	266	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.56	2.55	266	
PULL #3	2.49	2.54	2.60	247	
PULL #4	2.53	2.48	2.46	254	
PULL #5	2.23	2.51	2.46	262	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.46		
PULL #2	3.56	3.48		
PULL #3	3.49	3.45		
PULL #4	3.52	3.42		
PULL #5	3.29	3.43		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.48		4.42
PULL #2	4.35	4.32		4.22
PULL #3	4.25	4.24		4.27
PULL #4	4.23	4.20		4.38
PULL #5	4.20	4.23		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665711
15 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.290663
1 TO	2	.272547
1 TO	3	.375755
1 TO	4	.102181
1 TO	5	.361068

22 <----POA

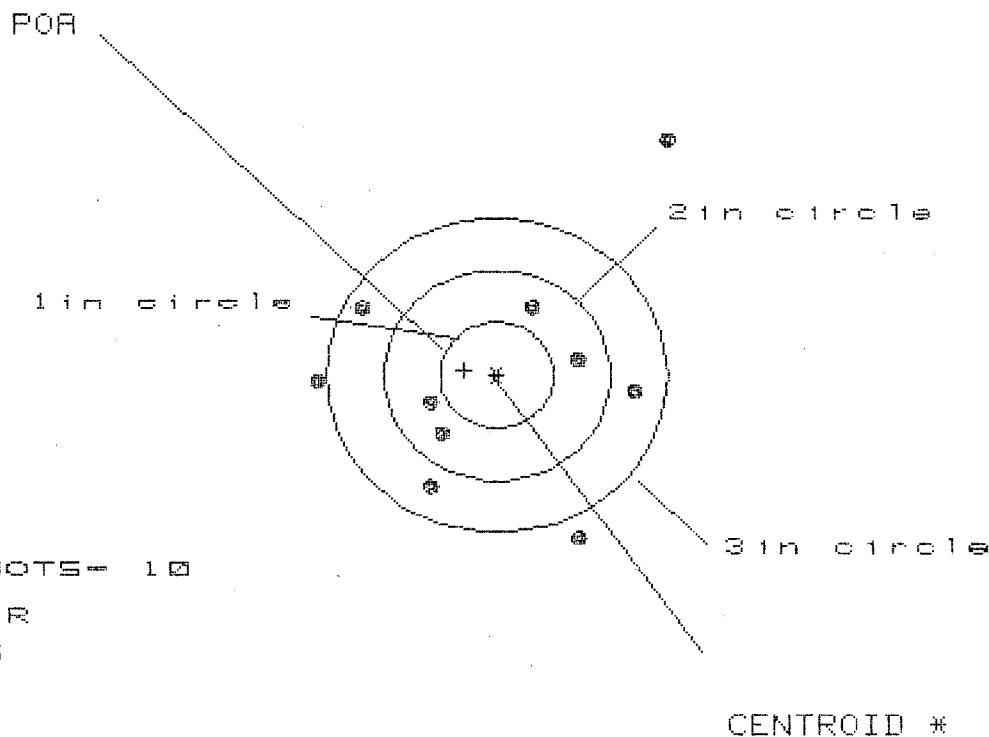
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1828
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1284
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .223360
THE AMR FOR THIS RIFLE IS: 1.036

15 Nov 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8665711

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 3.099

VS= 3.837

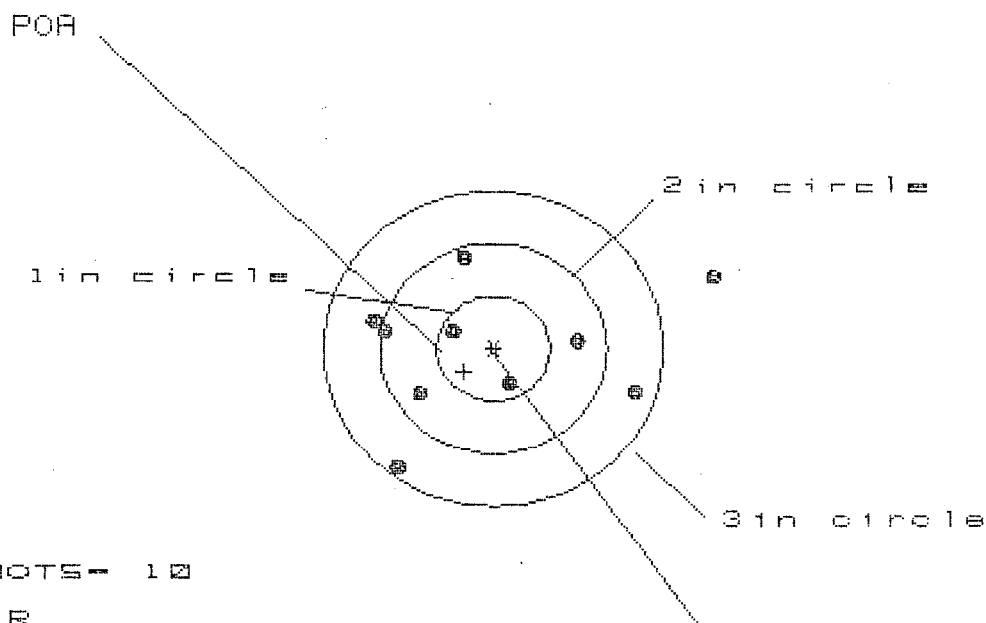
GS= 3.921

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.464	1.358	1.473
MINIMUM X	-1.635	-1.472	-1.357
MAXIMUM Y	2.277	.884	.721
MINIMUM Y	-1.560	-1.307	-.997
CENTROID X	.287	.124	.009
CENTROID Y	-.046	-.299	-.136
POA TO CENTROID in.	.290	.324	.136
MIN RADIUS	.629	.407	.341
MEAN RADIUS	1.266	1.060	.978
MAX RADIUS	2.707	1.600	1.477
HORIZONTAL SPREAD	3.099	2.830	2.830
VERTICAL SPREAD	3.837	2.191	1.718
EXTREME SPREAD	3.921	2.930	2.835
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

15 Nov 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 3.022

VS= 2.076

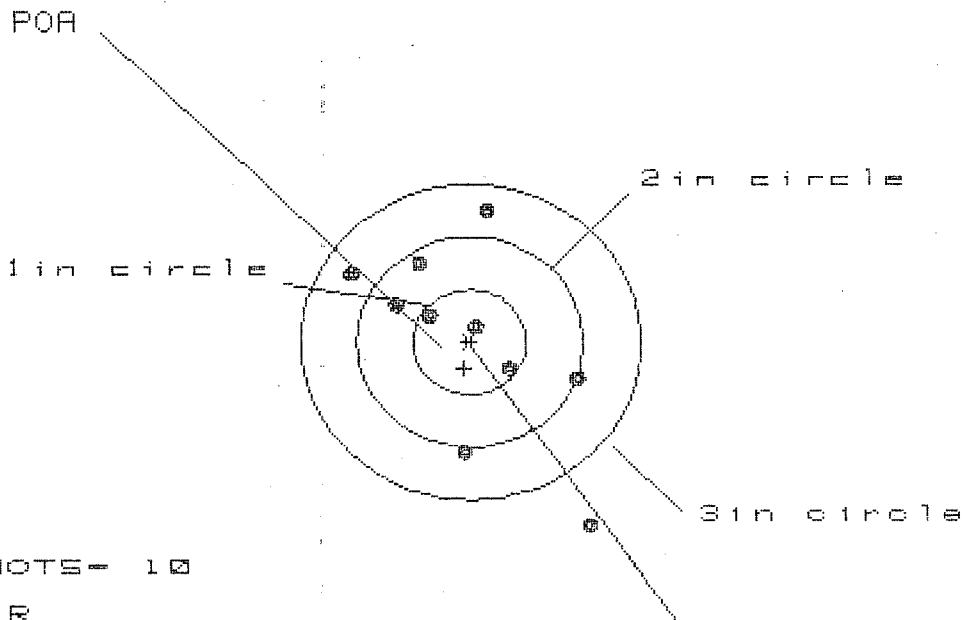
GS= 3.321

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.977	1.492	1.417
MINIMUM X	:	-1.045	-.825	-.900
MAXIMUM Y	:	.902	.972	.834
MINIMUM Y	:	-1.173	-1.104	-.510
CENTROID X	:	.258	.038	.113
CENTROID Y	:	.225	.155	.293
POA TO CENTROID in.	:	.342	.160	.314
MIN RADIUS	:	.306	.315	.246
MEAN RADIUS	:	1.009	.856	.798
MAX RADIUS	:	2.074	1.537	1.506
HORIZONTAL SPREAD	:	3.022	2.317	2.317
VERTICAL SPREAD	:	2.076	2.076	1.344
EXTREME SPREAD	:	3.321	2.430	2.430
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.063

VS= 2.974

GS= 3.141

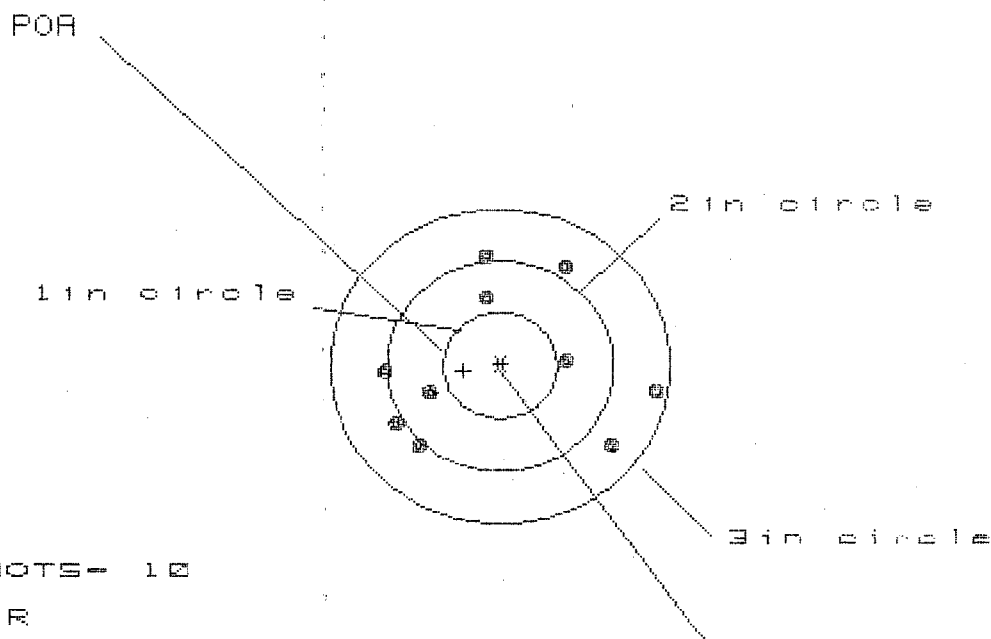
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.042	1.057	1.093
MINIMUM X	:	-1.021	-.905	-.868
MAXIMUM Y	:	1.269	1.080	.659
MINIMUM Y	:	-1.705	-1.231	-1.096
CENTROID X	:	.053	-.063	-.100
CENTROID Y	:	.248	.437	.302
POA TO CENTROID in.	:	.253	.442	.318
MIN RADIUS	:	.167	.119	.190
MEAN RADIUS	:	.917	.754	.713
MAX RADIUS	:	1.998	1.236	1.151
HORIZONTAL SPREAD	:	2.063	1.962	1.962
VERTICAL SPREAD	:	2.974	2.311	1.755
EXTREME SPREAD	:	3.141	2.318	2.188
NUMBER IN ONE INCH CIRCLE =	:	3		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

15 Nov 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS= 2.480

VS= 1.800

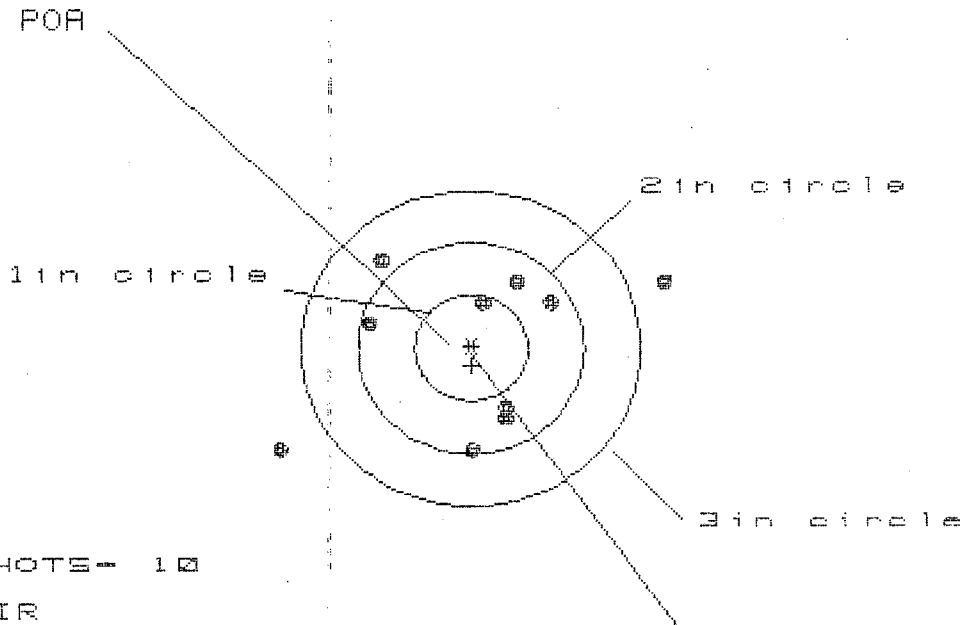
GS= 2.487

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.414	1.114	.850
MINIMUM X	-1.066	-.909	-.770
MAXIMUM Y	1.086	1.056	.962
MINIMUM Y	-.722	-.752	-.840
CENTROID X	.322	.165	.026
CENTROID Y	.050	.080	.174
POA TO CENTROID in.	.326	.183	.176
MIN RADIUS	.549	.552	.512
MEAN RADIUS	.973	.903	.829
MAX RADIUS	1.439	1.344	1.161
HORIZONTAL SPREAD	2.480	2.023	1.620
VERTICAL SPREAD	1.800	1.800	1.802
EXTREME SPREAD	2.487	2.128	2.048
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

15 May 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 8

HS= 3.452

VS= 1.757

GS= 3.788

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.717	1.524	.712
MINIMUM X	:	-1.736	-1.085	-.895
MAXIMUM Y	:	.812	.787	.771
MINIMUM Y	:	-.945	-1.028	-.964
CENTROID X	:	-.006	.187	-.003
CENTROID Y	:	.165	.270	.206
POA TO CENTROID in.	:	.165	.329	.206
MIN RADIUS	:	.396	.311	.355
MEAN RADIUS	:	1.014	.883	.791
MAX RADIUS	:	1.976	1.607	1.133
HORIZONTAL SPREAD	:	3.452	2.609	1.607
VERTICAL SPREAD	:	1.757	1.735	1.735
EXTREME SPREAD	:	3.788	2.634	1.931
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	7		
NUMBER IN THREE INCH CIRCLE =	:	8		