

BARBER - M24 0101691

FORM

UPC



06665717

INCLUDES 1 IN CHAMBER

BARBER - M24 0101692

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

BARBER - M24 0101693

Remington

DU PONT

REG. U.S. PAT. & TM. OFF.

VERY IMPORTANT:

Instruction Book

enclosed to assure

safe use of this

firearm.

MODEL 700TM M24

SERIAL NO.

C6665717

ORDER NO.

5716

20

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



ORDER 5716
MODEL 700TM M24
UPC



ORDER 5716
MODEL 700TM M24
UPC



GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665717

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26 91	9 26 91	RW
600	Proof	9 26 91	9 26 91	RW
607	Check Headspace	9 26 91	9 26 91	RW
610	Dis-assemble Gun	9 26 91	9 26 91	RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	LS
617	Drill and Tap Sight Holes		SEP 30 1991	FS
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	JA
	Apply Coating (Bolt)		10-13-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/18/91	JA

op. #	BARBER MEM 24 0101695	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/21/91	RL
	G) Safety Off Force	4	4	4			10/21/91	RL
	H) Trigger Pull Test & Retainability						10/18/91	RL
	I) Firing Pin Indent	1.020	1.020	1.020			10/21/91	RL
	J) Assemble Stock						10/21/91	RL
	K) Assemble Swivel Studs						10/22-91	AC
	L) Attach Front and Rear Sight Assemblies						10/21/91	RL
	M) Iron Sight Alignment						10/21/91	RL
	N) Detach Front & Rear Sights & place in numbered container						10/21/91	RL
	O) Attach Scope to Rifle						10/21/91	RL
	P) Detach & Attach Scope 20 Times						10/21/91	RL
640	Gallery Target & Test						10-21-91	NF
	A) Time						10-21-91	NF
	B) Malfunctions						10-21-91	NF
	C) Pierced Primers						10-21-91	NF
	D) Optical Clarity of Scope						10-21-91	NF
645	Inspect for Live Ammo						10-21-91	NF
655	Final Inspection							
	A) Headspace						10-22-91	AC
	B) Trigger Pull	2.42	2.32	2.51	2.57	2.61	10-22-91	D/H
	C) Function						10-22-91	AC
660	Pack						12-18-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665717

DATE 10/18/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.40	2.25	242	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.29	2.18	2.38	232	
PULL #3	2.23	2.41	2.44	2.51	
PULL #4	2.33	2.34	2.38	2.57	
PULL #5	2.32	2.23	2.36	2.61	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.42		
PULL #2	3.51	3.22		
PULL #3	3.57	3.24		
PULL #4	3.40	3.25		
PULL #5	3.46	3.26		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.36		4.40
PULL #2	4.32	4.36		4.33
PULL #3	4.34	4.38		4.42
PULL #4	4.36	4.36		4.40
PULL #5	4.32	4.33		4.41
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665717
21 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.263287
1 TO 2	.29382
1 TO 3	.276612
1 TO 4	.0388973
1 TO 5	.208279

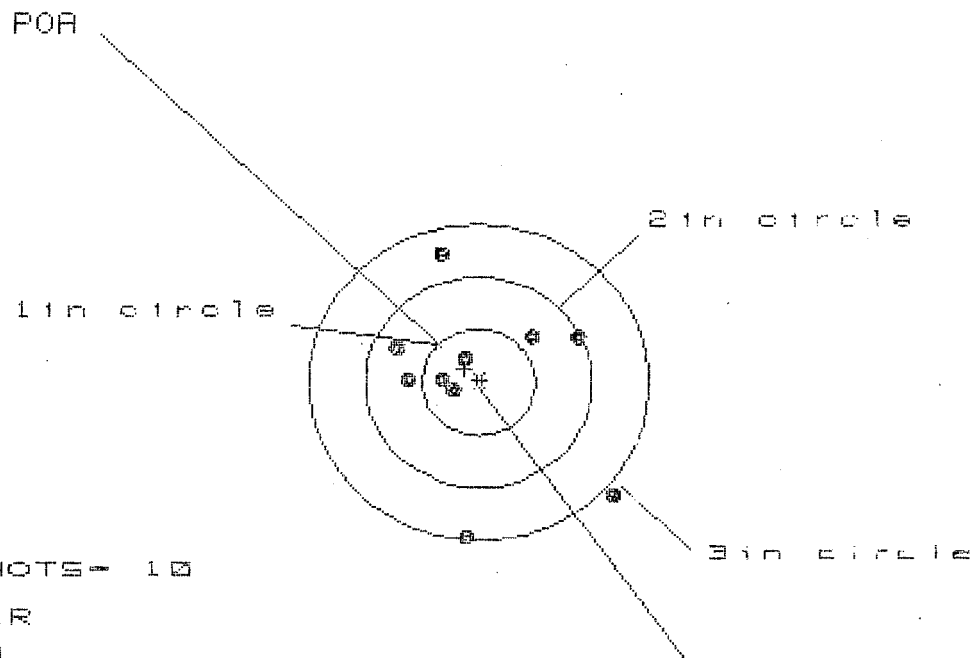
34 2 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1966
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0514
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137406
THE AMR FOR THIS RIFLE IS: .9712

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665717

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS= 1.9000

VS= 2.692

GS= 2.705

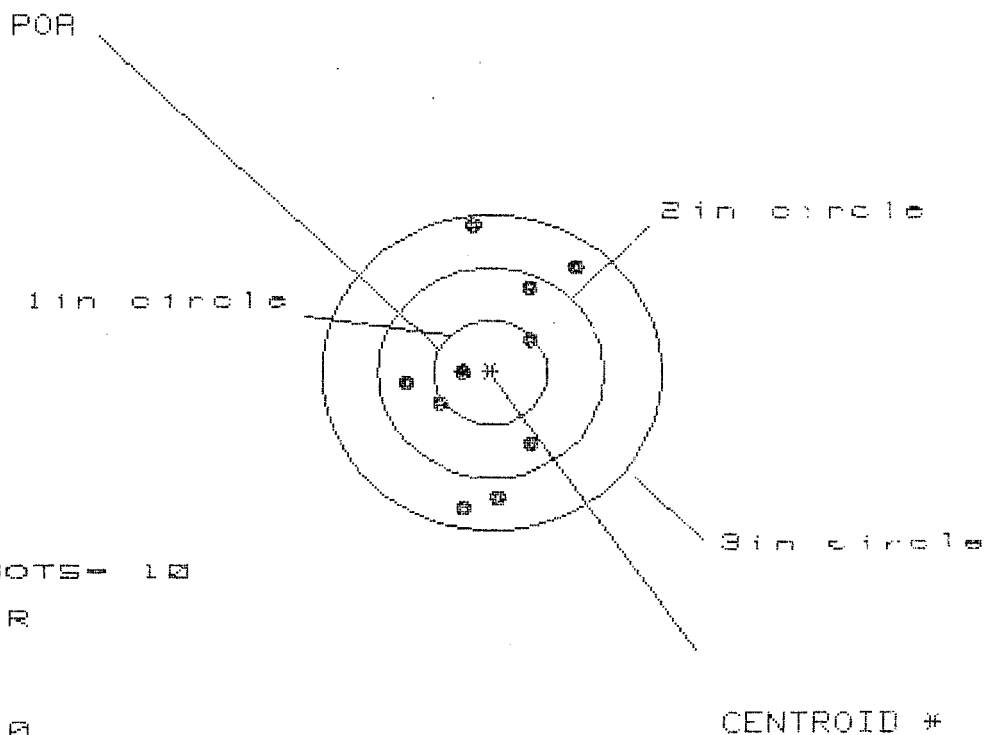
CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	1.035	1.037
MINIMUM X	-.765	-.639	-.637
MAXIMUM Y	1.188	1.070	.867
MINIMUM Y	-1.504	-1.622	-.395
CENTROID X	.124	-.002	-.004
CENTROID Y	-.130	-.012	.191
POA TO CENTROID in.	.179	.012	.191
MIN RADIUS	.204	.074	.143
MEAN RADIUS	.826	.695	.594
MAX RADIUS	1.555	1.623	1.049
HORIZONTAL SPREAD	1.900	1.674	1.674
VERTICAL SPREAD	2.692	2.692	1.262
EXTREME SPREAD	2.705	2.704	1.681
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665717

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 10

HS = 1.515

VS = 2.788

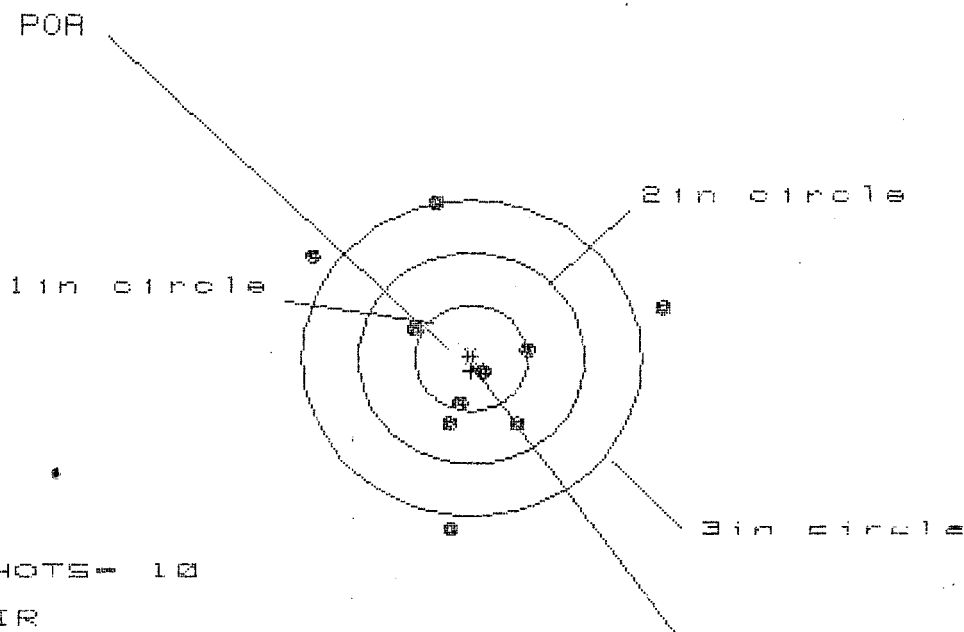
GS = 2.790

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.777	.759	.726
MINIMUM X	:	-.738	-.756	-.789
MAXIMUM Y	:	1.459	1.159	1.013
MINIMUM Y	:	-1.329	-1.166	-1.142
CENTROID X	:	.250	.268	.301
CENTROID Y	:	-.011	-.174	-.028
POA TO CENTROID in.	:	.251	.319	.302
MIN RADIUS	:	.276	.322	.325
MEAN RADIUS	:	.900	.828	.777
MAX RADIUS	:	1.468	1.385	1.246
HORIZONTAL SPREAD	:	1.515	1.515	1.515
VERTICAL SPREAD	:	2.788	2.325	2.155
EXTREME SPREAD	:	2.790	2.541	2.286
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665717

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 6

HS = 3.142

VS = 3.144

GS = 3.170

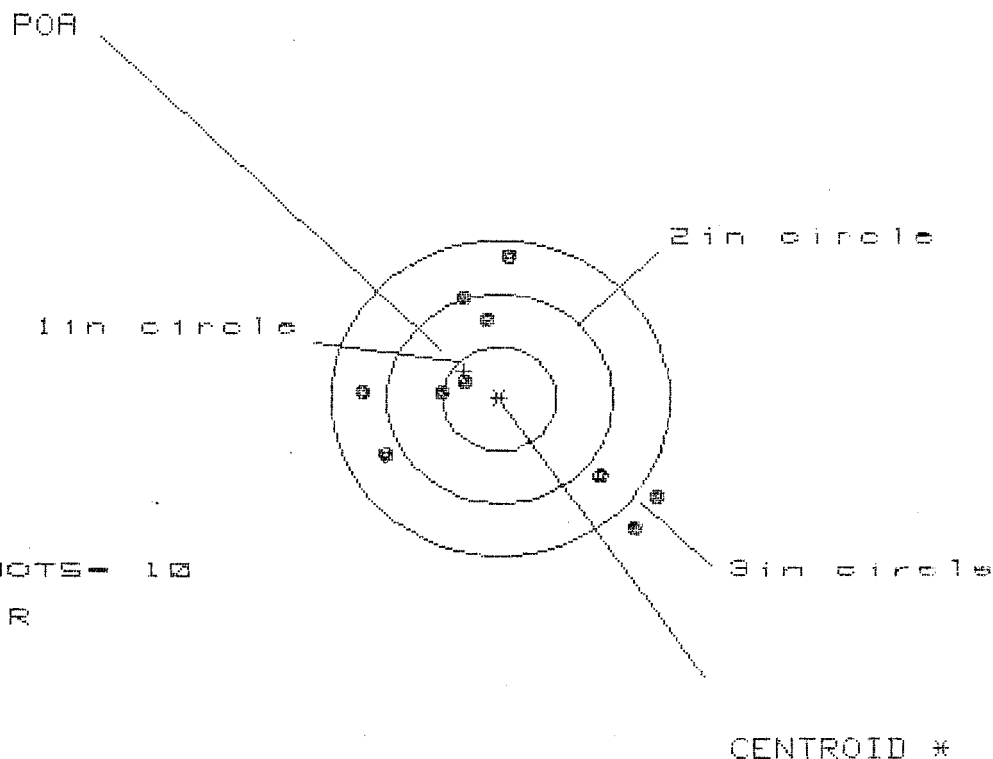
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.717	.673	.518
MINIMUM X	:	-1.425	-1.234	-.443
MAXIMUM Y	:	1.523	1.580	1.704
MINIMUM Y	:	-1.621	-1.564	-1.440
CENTROID X	:	.002	-.189	-.034
CENTROID Y	:	.121	.064	-.060
POA TO CENTROID in.	:	.121	.199	.069
MIN RADIUS	:	.111	.263	.144
MEAN RADIUS	:	.964	.873	.732
MAX RADIUS	:	1.792	1.584	1.724
HORIZONTAL SPREAD	:	3.142	1.907	.961
VERTICAL SPREAD	:	3.144	3.144	3.144
EXTREME SPREAD	:	3.170	3.146	3.146
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

21 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 3

3 in = 8

HS = 2.593

VS = 2.588

GS = 2.802

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.367	1.501	1.169
MINIMUM X	:	-1.226	-1.092	-.905
MAXIMUM Y	:	1.363	1.227	1.096
MINIMUM Y	:	-1.225	-1.050	-.970
CENTROID X	:	.315	.181	-.006
CENTROID Y	:	-.263	-.127	.064
POA TO CENTROID in.	:	.411	.222	.007
MIN RADIUS	:	.365	.203	.128
MEAN RADIUS	:	1.091	.964	.793
MAX RADIUS	:	1.716	1.831	1.519
HORIZONTAL SPREAD	:	2.593	2.593	2.074
VERTICAL SPREAD	:	2.588	2.277	2.066
EXTREME SPREAD	:	2.802	2.764	2.254
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

EXTRAORDINARY SPECIMEN **BARBER - M24-0101702**

3.141

3.124

1.980

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

6

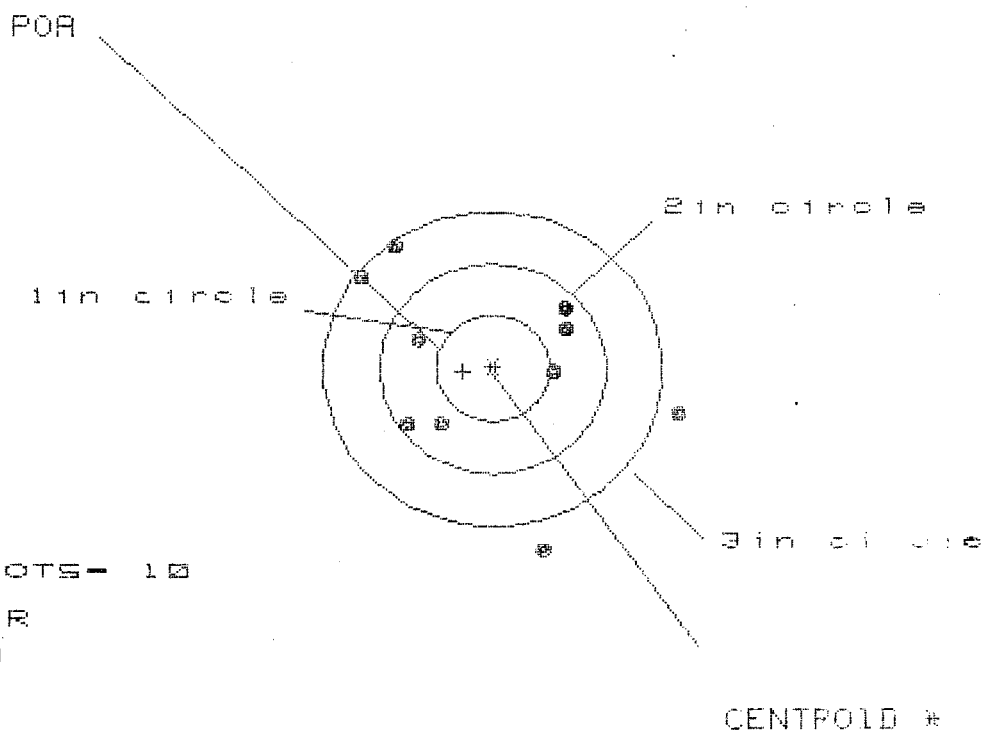
NUMBER IN THREE INCH CIRCLE =

8

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE PATT/06685717

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 0

2in = 6

3in = 8

HS = 2.867

VS = 2.851

GS = 3.141

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.684	.797	.874
MINIMUM X	-1.183	-.996	-.919
MAXIMUM Y	1.175	1.124	.908
MINIMUM Y	-1.676	-1.727	-.824
CENTROID X	.262	.075	-.062
CENTROID Y	.026	.077	.293
POA TO CENTROID in.	.263	.107	.293
MIN RADIUS	.530	.520	.378
MEAN RADIUS	1.075	.988	.867
MAX RADIUS	1.745	1.832	1.082
HORIZONTAL SPREAD	2.867	1.793	1.793
VERTICAL SPREAD	2.851	2.851	1.732