

FORM

UPC



C6665718

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0101706

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665718

ORDER NO.
5716

20

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



5716 C6665718

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26665718

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	10/1/91	YK
600	Proof		10/1/91	YK
607	Check Headspace		10/1/91	YK
610	Dis-assemble Gun		10/1/91	YK
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	YK
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/91	YK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/91	YK
	C) Inspect Ejector Hole for Chamfer		11/6/91	YK
	D) Oil Firing Pin Ass'y		11/6/91	YK
	E) Adjust Trigger Pull to Min Setting and Stake		11-7-91	YK

op. #	BARBER - M24 0101708	READINGS			DATE	INIT
625 cont.	F) Safety On Force	5	5	5	11-7-91	JH
	G) Safety Off Force	3	3	3	11-7-91	JH
	H) Trigger Pull Test & Retainability				11-7-91	JH
	I) Firing Pin Indent	.021	.021	.021	11-7-91	JH
	J) Assemble Stock				11/7/91	KH
	K) Assemble Swivel Studs				11-21-91	JH
	L) Attach Front and Rear Sight Assemblies				11/7/91	KH
	M) Iron Sight Alignment				11/7/91	KH
	N) Detach Front & Rear Sights & place in numbered container				11/7/91	KH
	O) Attach Scope to Rifle				11/7/91	KH
	P) Detach & Attach Scope 20 Times				11/7/91	KH
640	Gallery Target & Test				11-19-91	DH
	A) Time				11-19-91	DH
	B) Malfunctions				11-19-91	DH
	C) Pierced Primers				11-19-91	DH
	D) Optical Clarity of Scope				11-19-91	DH
645	Inspect for Live Ammo				11-19-91	DH
655	Final Inspection					
	A) Headspace				11-21-91	JH
	B) Trigger Pull	2.73	2.79	2.79	11-19-91	DH
	C) Function				11-21-91	JH
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. 06665718DATE 11-7-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.50	2.35	2.44	2.73	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.41	2.48	2.79	
PULL #3	2.40	2.45	2.43	2.79	
PULL #4	2.64	2.26	2.45	2.68	
PULL #5	2.41	2.49	2.50	2.76	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.36		
PULL #2	3.41	3.41		
PULL #3	3.42	3.28		
PULL #4	3.42	3.39		
PULL #5	3.37	3.39		
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	4.40		4.52
PULL #2	4.30	4.46		4.55
PULL #3	4.26	4.53		4.20
PULL #4	4.50	4.51		4.41
PULL #5	4.39	4.52		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665718
19 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.0965401
1 TO	2	.247952
1 TO	3	.424444
1 TO	4	1.05255
1 TO	5	.659337

$\frac{3}{t_2} s^4$ <----POA

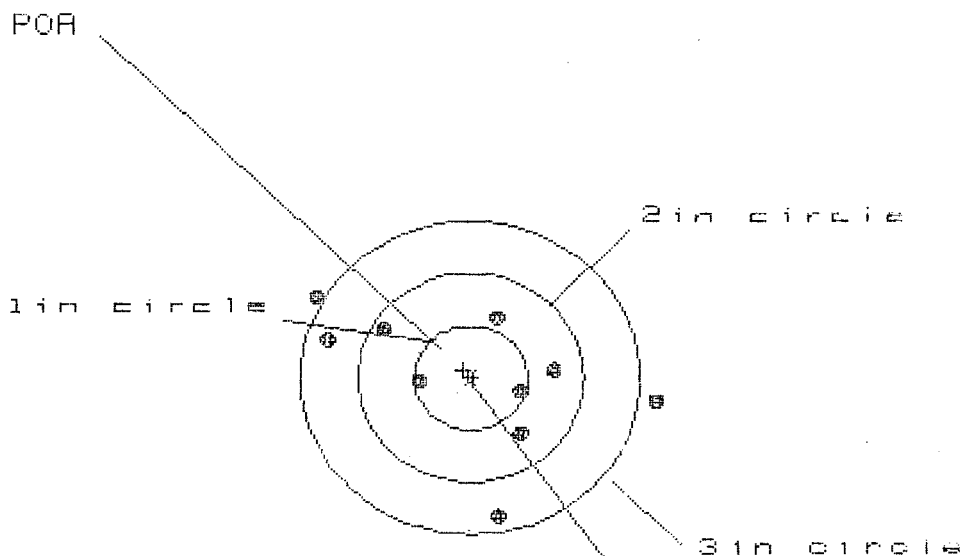
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4518
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1054
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .463931

THE AMR FOR THIS RIFLE IS: .9652

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665718

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 3.049

VS= 2.026

GS= 3.205

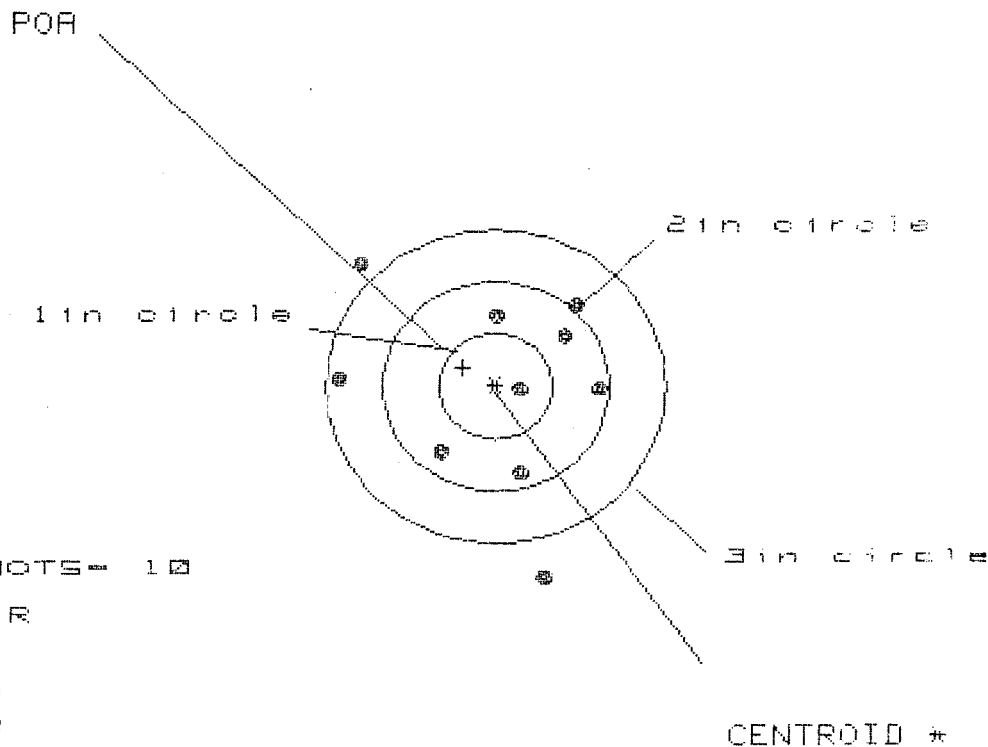
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.674	.874	.725
MINIMUM X	-1.375	-1.189	-1.222
MAXIMUM Y	.727	.698	.605
MINIMUM Y	-1.299	-1.328	-1.241
CENTROID X	.062	-.124	.025
CENTROID Y	-.074	-.045	-.132
POA TO CENTROID in.	.097	.132	.135
MIN RADIUS	.421	.245	.381
MEAN RADIUS	.970	.887	.809
MAX RADIUS	1.694	1.404	1.297
HORIZONTAL SPREAD	3.049	2.063	1.947
VERTICAL SPREAD	2.026	2.026	1.846
EXTREME SPREAD	3.205	2.610	2.267
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685718

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.366

VS = 2.957

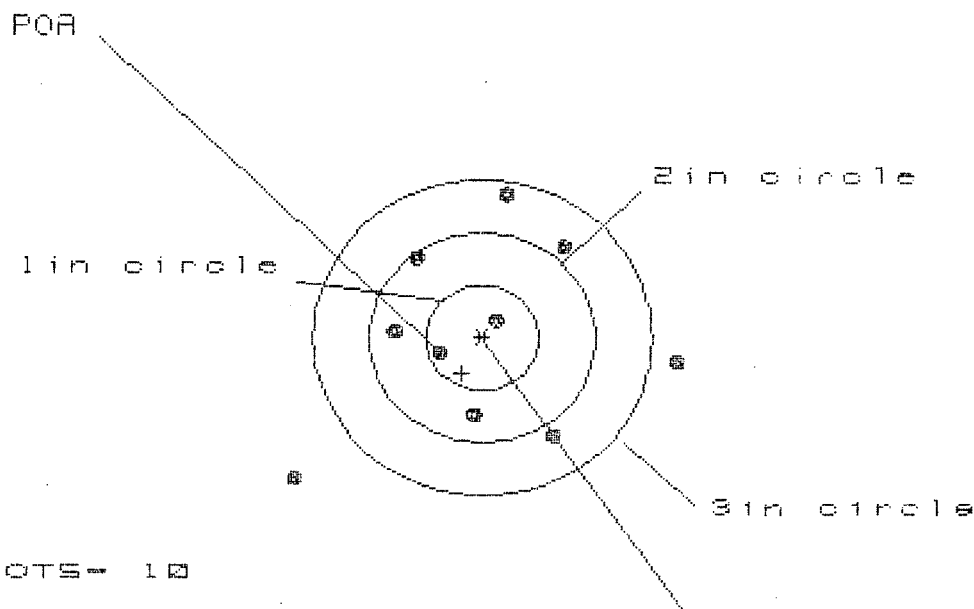
GS = 3.331

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.960	1.003	.864
MINIMUM X	-1.406	-1.363	-1.502
MAXIMUM Y	1.128	.925	.722
MINIMUM Y	-1.829	-.979	-.863
CENTROID X	.288	.245	.384
CENTROID Y	-.176	.027	-.089
POA TO CENTROID in.	.338	.247	.394
MIN RADIUS	.229	.338	.158
MEAN RADIUS	1.022	.920	.816
MAX RADIUS	1.868	1.445	1.502
HORIZONTAL SPREAD	2.366	2.366	2.366
VERTICAL SPREAD	2.957	1.904	1.585
EXTREME SPREAD	3.331	2.384	2.366
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG665718

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HSI = 3.354

VS = 2.727

GS = 3.557

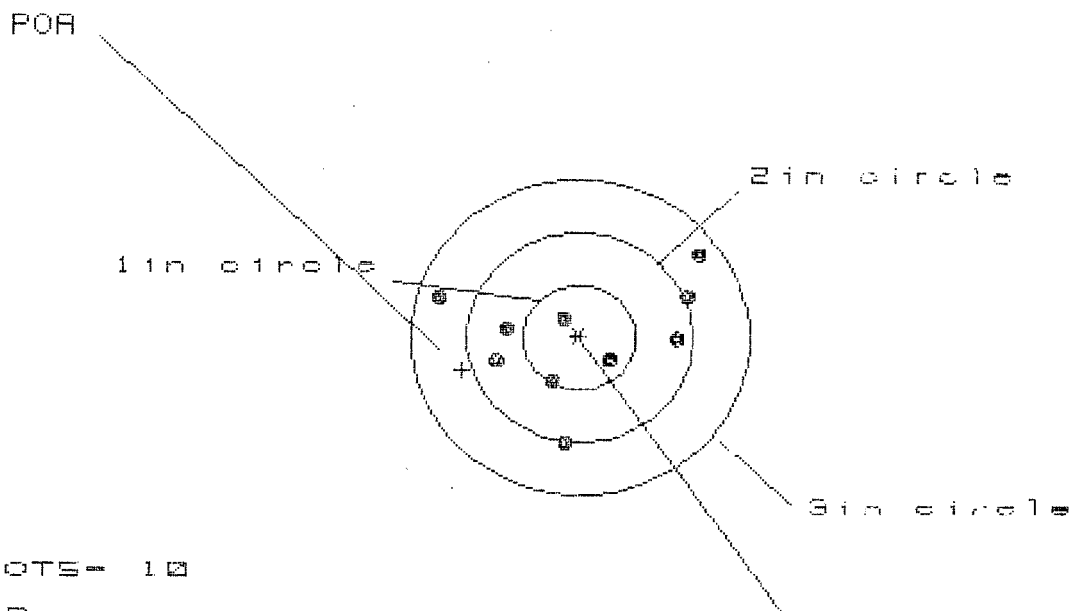
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.713	1.529	.739
MINIMUM X	:	-1.651	-.913	-.721
MAXIMUM Y	:	1.377	1.227	1.184
MINIMUM Y	:	-1.350	-1.036	-1.079
CENTROID X	:	.179	.363	.171
CENTROID Y	:	.334	.484	.527
POA TO CENTROID in.	:	.379	.604	.554
MIN RADIUS	:	.176	.068	.140
MEAN RADIUS	:	1.045	.922	.814
MAX RADIUS	:	2.133	1.568	1.239
HORIZONTAL SPREAD	:	3.364	2.442	1.460
VERTICAL SPREAD	:	2.727	2.263	2.263
EXTREME SPREAD	:	3.557	2.458	2.302
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

19 May 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.250

VS= 1.706

GS= 2.290

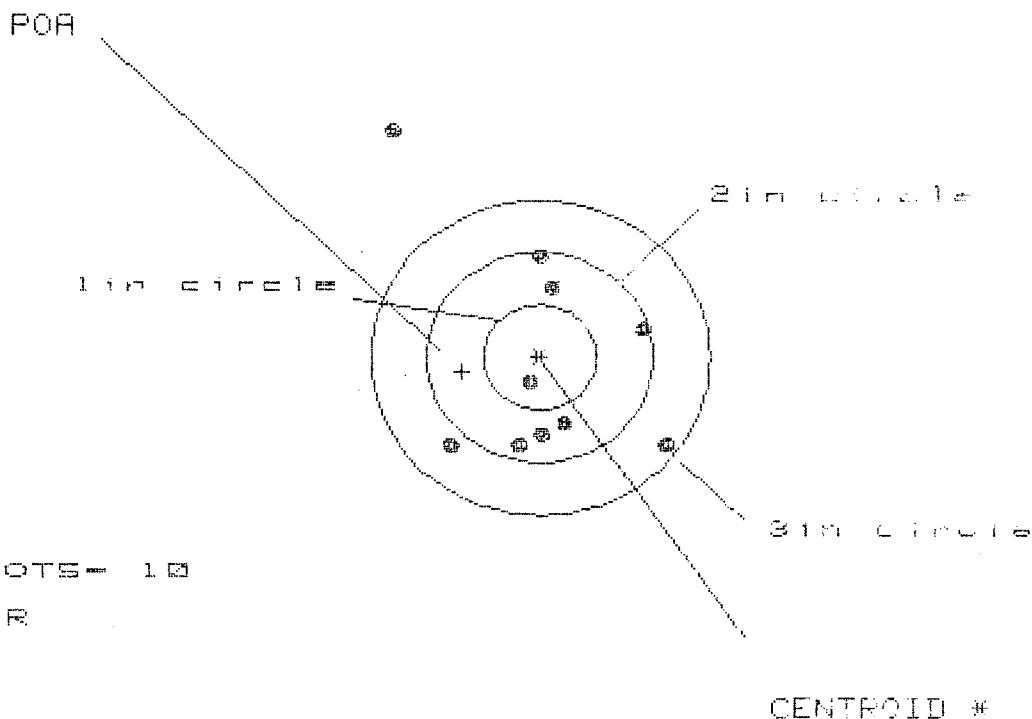
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.056	1.095	.960
MINIMUM X	:	-1.202	-1.085	-.719
MAXIMUM Y	:	.744	.446	.502
MINIMUM Y	:	-.962	-.879	-.823
CENTROID X	:	1.042	.925	1.060
CENTROID Y	:	.310	.227	.171
POA TO CENTROID in.	:	1.087	.952	1.074
MIN RADIUS	:	.269	.291	.212
MEAN RADIUS	:	.776	.698	.637
MAX RADIUS	:	1.292	1.183	1.083
HORIZONTAL SPREAD	:	2.258	2.180	1.679
VERTICAL SPREAD	:	1.706	1.325	1.325
EXTREME SPREAD	:	2.290	2.180	1.769
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6865718

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.473

VS = 3.064

GS = 3.937

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.147	1.000	.860
MINIMUM X	-1.326	-.965	-.840
MAXIMUM Y	2.212	1.165	1.089
MINIMUM Y	-.852	-.606	-.637
CENTROID X	.688	.835	.710
CENTROID Y	.133	-.113	-.037
POA TO CENTROID in.	.701	.843	.711
MIN RADIUS	.224	.248	.120
MEAN RADIUS	1.013	.784	.725
MAX RADIUS	2.579	1.173	1.089
HORIZONTAL SPREAD	2.473	1.965	1.700
VERTICAL SPREAD	3.064	1.771	1.726
EXTREME SPREAD	3.937	2.106	1.987
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	