

BARBER - M24 0101728

FORH

UPC



0 47700 25716 7

C6665720

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665720

ORDER NO.

5716

20

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



5716 C6665720

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 # C6665720

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	PW
600	Proof	10 1	91	PW
607	Check Headspace	10 1	91	PW
610	Dis-assemble Gun	10 1	91	PW
612	Magnaflux Barrel Action	OCT	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	28.
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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	PW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	PW
	C) Inspect Ejector Hole for Chamfer		10/22/91	PW
	D) Oil Firing Pin Ass'y		10/22/91	PW
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-91	JM

op. #	BARBER - M24 0101732 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-14-91	JH
	G) Safety Off Force	3	3	3			11-14-91	JH
	H) Trigger Pull Test & Retainability						11-12-91	JH
	I) Firing Pin Indent	.0205	.0205	.020			11-14-91	JH
	J) Assemble Stock						11/14/91	RW
	K) Assemble Swivel Studs						11-19-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/14/91	RW
	M) Iron Sight Alignment						11/14/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/91	RW
	O) Attach Scope to Rifle						11/14/91	RW
	P) Detach & Attach Scope 20 Times						11/14/91	RW
640	Gallery Target & Test						11-15-91	AC
	A) Time						11-15-91	AC
	B) Malfunctions						11-15-91	AC
	C) Pierced Primers						11-15-91	AC
	D) Optical Clarity of Scope						11-15-91	AC
645	Inspect for Live Ammo						11-15-91	AC
655	Final Inspection							
	A) Headspace						11-19-91	D/H
	B) Trigger Pull	235	239	245	245	245	11-15-91	DH
	C) Function						11-19-91	DH
660	Pack						12-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6665720DATE 11-12-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.42	2.48	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.29	2.46	2.39	
PULL #3	2.35	2.26	2.38	2.45	
PULL #4	2.41	2.38	2.35	2.45	
PULL #5	2.38	2.40	2.40	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.29		
PULL #2	3.48	3.47		
PULL #3	3.44	3.36		
PULL #4	3.38	3.48		
PULL #5	3.38	3.38		
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	4.33		4.35
PULL #2	4.41	4.19		4.42
PULL #3	4.34	4.32		4.28
PULL #4	4.30	4.58		4.32
PULL #5	4.30	4.41		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665720
18 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.334598
1 TO	2	.12881
1 TO	3	.306307
1 TO	4	.0401123
1 TO	5	.442669

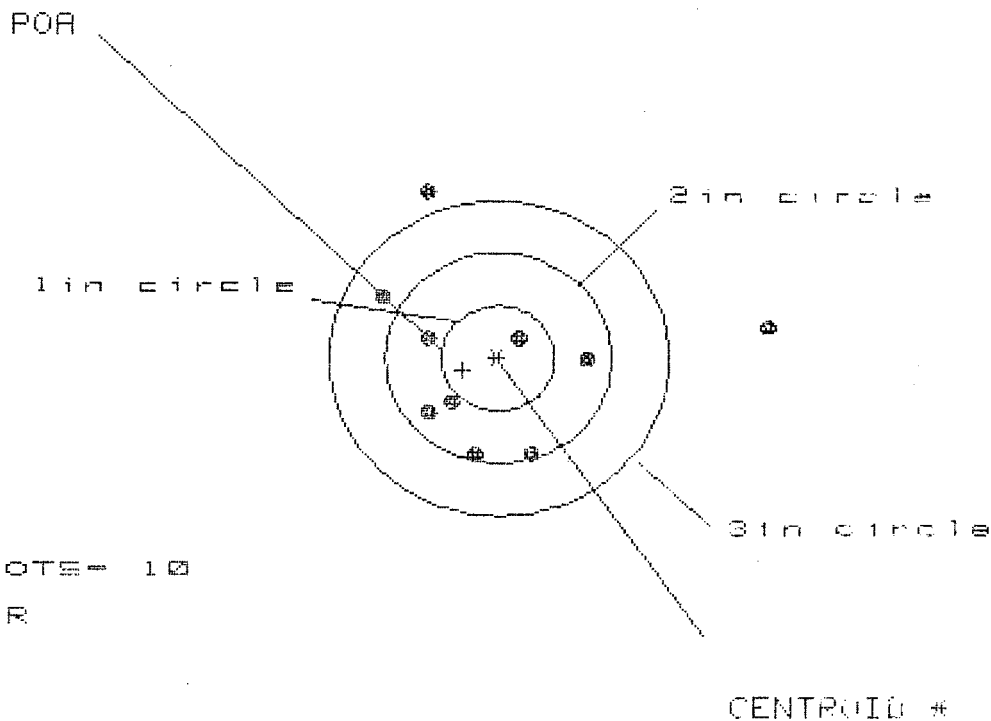
4³3 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2628
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0122
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .263083
THE AMR FOR THIS RIFLE IS: .9154

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685720

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 3.382

VS= 2.548

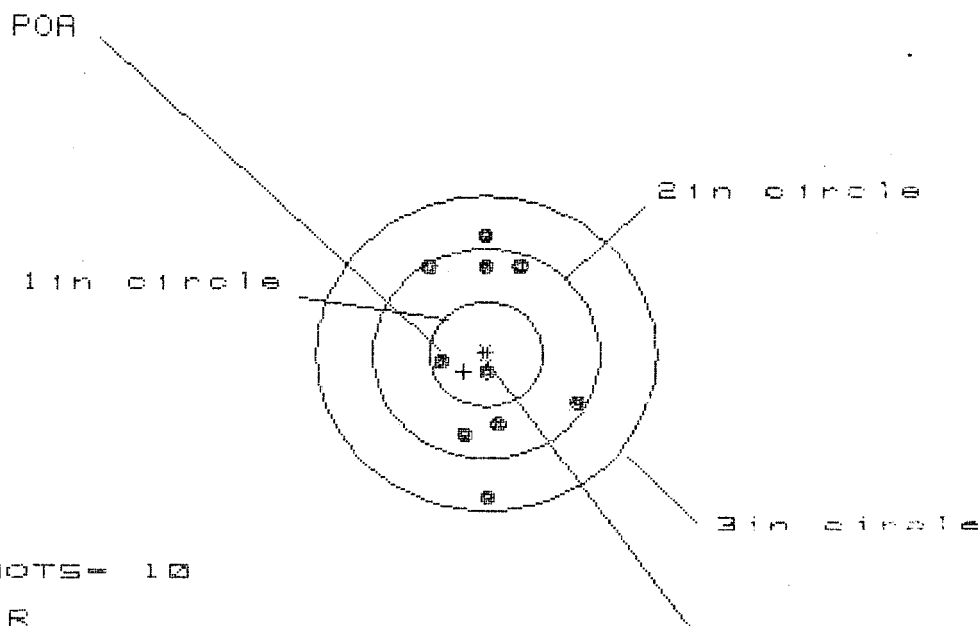
GS= 3.392

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.347	1.017	.974
MINIMUM X	-1.035	-.774	-.817
MAXIMUM Y	1.591	1.623	.779
MINIMUM Y	-.957	-.925	-.722
CENTROID X	.316	.055	.098
CENTROID Y	.110	.078	-.125
POA TO CENTROID in.	.334	.095	.159
MIN RADIUS	.248	.423	.296
MEAN RADIUS	1.023	.836	.703
MAX RADIUS	2.365	1.659	1.129
HORIZONTAL SPREAD	3.382	1.791	1.791
VERTICAL SPREAD	2.548	2.548	1.501
EXTREME SPREAD	3.392	2.687	1.973
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665720

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.245

VS= 2.541

GS= 2.542

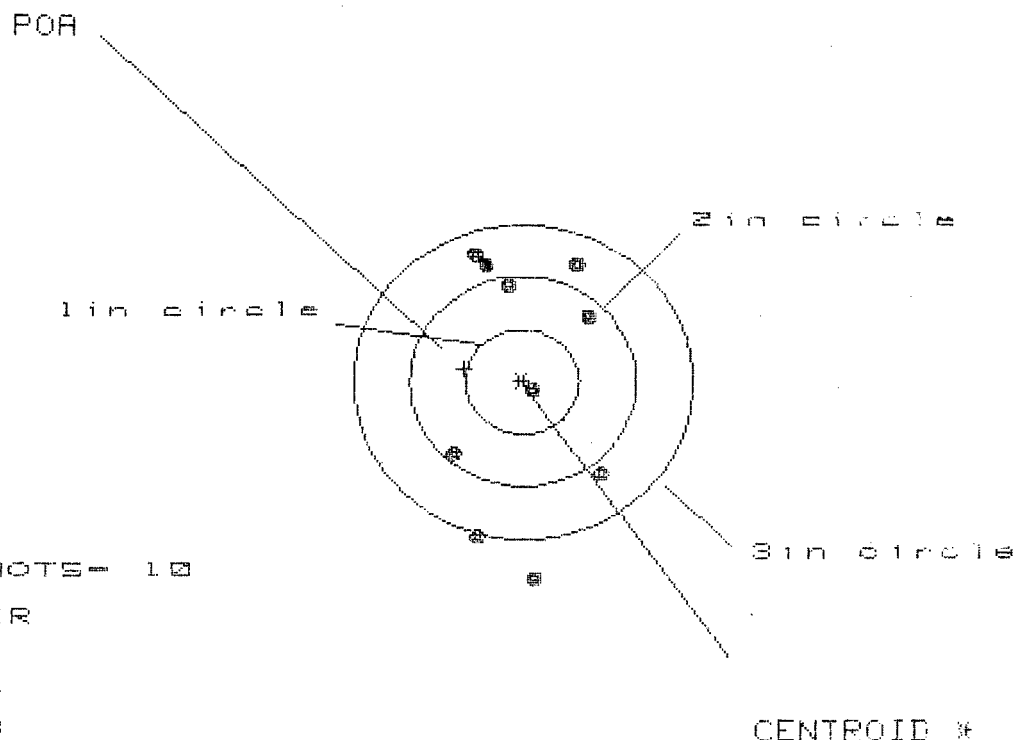
CENTROID #

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.755	.757	.752
MINIMUM X	:	-.490	-.488	-.493
MAXIMUM Y	:	1.142	.986	.780
MINIMUM Y	:	-1.399	-.890	-.766
CENTROID X	:	.200	.198	.203
CENTROID Y	:	.166	.322	.198
POA TO CENTROID in.	:	.260	.378	.284
MIN RADIUS	:	.182	.337	.215
MEAN RADIUS	:	.805	.741	.692
MAX RADIUS	:	1.399	1.004	.924
HORIZONTAL SPREAD	:	1.245	1.245	1.245
VERTICAL SPREAD	:	2.541	1.876	1.546
EXTREME SPREAD	:	2.542	1.882	1.811
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665720

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 1.325

VS= 3.167

GS= 3.218

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.692
MINIMUM X	-.633
MAXIMUM Y	1.244
MINIMUM Y	-1.923
CENTROID X	.516
CENTROID Y	-.122
POA TO CENTROID in.	.538
MIN RADIUS	.074
MEAN RADIUS	1.096
MAX RADIUS	1.926
HORIZONTAL SPREAD	1.325
VERTICAL SPREAD	3.167
EXTREME SPREAD	3.218
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 4
NUMBER IN THREE INCH CIRCLE	= 8

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665720

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.229

VS= 1.474

GS= 2.672

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.200	.764	.652
MINIMUM X	:	-1.029	-.896	-.824
MAXIMUM Y	:	.641	.548	.508
MINIMUM Y	:	-.833	-.840	-.771
CENTROID X	:	.276	.143	.255
CENTROID Y	:	.113	.206	.137
POA TO CENTROID in.	:	.299	.251	.290
MIN RADIUS	:	.187	.116	.158
MEAN RADIUS	:	.720	.616	.560
MAX RADIUS	:	1.461	1.101	1.129
HORIZONTAL SPREAD	:	2.229	1.660	1.476
VERTICAL SPREAD	:	1.474	1.388	1.279
EXTREME SPREAD	:	2.672	1.799	1.799
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C9665720

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID

OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 1.697

VS = 2.498

GS = 2.648

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.890	.803	.605
MINIMUM X	:	-.807	-.894	-.092
MAXIMUM Y	:	1.215	1.073	.856
MINIMUM Y	:	-1.283	-1.064	-.930
CENTROID X	:	.006	.093	.091
CENTROID Y	:	-.206	-.064	.196
POA TO CENTROID in.	:	.206	.113	.218
MIN RADIUS	:	.281	.370	.243
MEAN RADIUS	:	.933	.858	.810
MAX RADIUS	:	1.501	1.350	1.252
HORIZONTAL SPREAD	:	1.697	1.697	1.697
VERTICAL SPREAD	:	2.498	2.137	1.786
EXTREME SPREAD	:	2.648	2.274	2.200
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	