

BARBER - M24 0101740

FORM

UPC



0 47700 25716 7

06665721

INCLUDES 1 INCHAMBER

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.MODEL 700 TM M24

SERIAL NO.

C6665721

ORDER NO.

5716

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

20



5716 C6665721

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665721

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/24/91	KH
600	Proof		9/24/91	KH
607	Check Headspace		9/24/91	KH
610	Dis-assemble Gun		9/24/91	KH
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	LB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		7-01	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	RW
	C) Inspect Ejector Hole for Chamfer		10/8/91	RW
	D) Oil Firing Pin Ass'y		10/8/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10-8-91	JH

op. #	BARBER - M24 0101744 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6.5	6	6.5			10/8/91	RW
	G) Safety Off Force	3	3.5	3.5			10/8/91	RW
	H) Trigger Pull Test & Retainability						10/8/91	JF
	I) Firing Pin Indent	.0215	.021	.022			10/8/91	RW
	J) Assemble Stock						10/9/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/9/91	RW
	M) Iron Sight Alignment						10/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/91	RW
	O) Attach Scope to Rifle						10/9/91	RW
	P) Detach & Attach Scope 20 Times						10/9/91	RW
640	Gallery Target & Test						10-11-91	DH
	A) Time						10-11-91	DH
	B) Malfunctions						10-11-91	DH
	C) Pierced Primers						10-11-91	DH
	D) Optical Clarity of Scope						10-11-91	DH
645	Inspect for Live Ammo						10-11-91	DH
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.53	2.49	2.55	2.55	2.41	10-11-91	DH
	C) Function						10-17-91	AC
660	Pack						12-17-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665721

DATE 10-8-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.41	2.48	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.41	2.40	2.49	
PULL #3	2.37	2.36	2.38	2.55	
PULL #4	2.39	2.53	2.45	2.55	
PULL #5	2.33	2.45	2.51	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.56		
PULL #2	3.42	3.39		
PULL #3	3.46	3.49		
PULL #4	3.29	3.50		
PULL #5	3.29	3.55		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.52	4.47		4.27
PULL #2	4.28	4.57		4.53
PULL #3	4.44	4.43		4.40
PULL #4	4.47	4.43		4.20
PULL #5	4.50	4.13		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665721
14 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.124952
1 TO	2	.236544
1 TO	3	.375932
1 TO	4	.224511
1 TO	5	.0638201

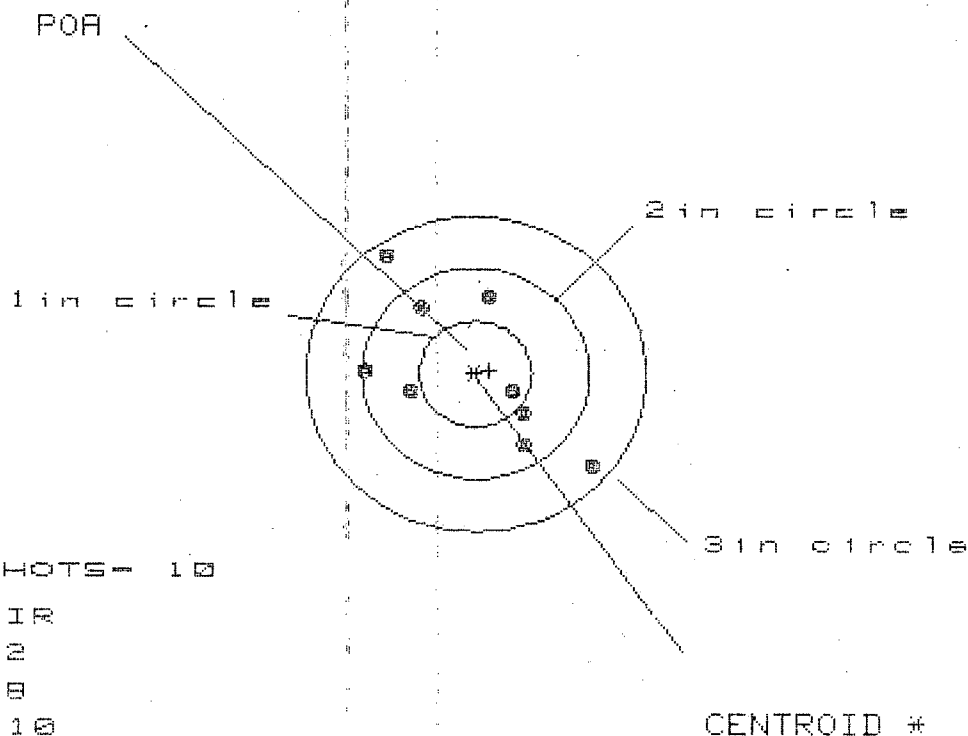
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0932
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0422
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102309
THE AMR FOR THIS RIFLE IS: .9098

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665721

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 2.026

VS= 2.058

GS= 2.749

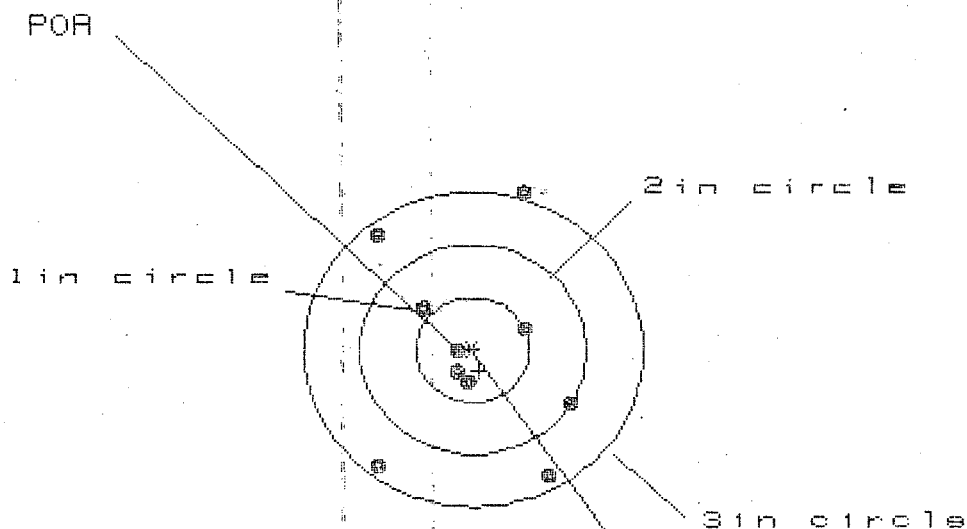
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	.958	.483
MINIMUM X	-.982	-1.068	-.949
MAXIMUM Y	1.161	.849	.753
MINIMUM Y	-.898	-.769	-.643
CENTROID X	-.122	-.036	-.155
CENTROID Y	-.027	-.156	-.060
POA TO CENTROID in.	.125	.160	.167
MIN RADIUS	.381	.248	.395
MEAN RADIUS	.796	.698	.648
MAX RADIUS	1.398	1.228	.950
HORIZONTAL SPREAD	2.026	2.026	1.432
VERTICAL SPREAD	2.058	1.618	1.396
EXTREME SPREAD	2.749	2.227	1.563
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

14 Oct 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.719

VS = 2.745

GS = 2.897

CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	.843
MINIMUM X	-.876
MAXIMUM Y	1.516
MINIMUM Y	-1.229
CENTROID X	-.059
CENTROID Y	.201
POA TO CENTROID in.	.210
MIN RADIUS	.163
MEAN RADIUS	.856
MAX RADIUS	1.586
HORIZONTAL SPREAD	1.719
VERTICAL SPREAD	2.745
EXTREME SPREAD	2.897
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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FILE:/PATTERNING/CENTERFIRE_PATT/C8665721

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.290

VS = 3.026

GS = 3.272

CENTROID #

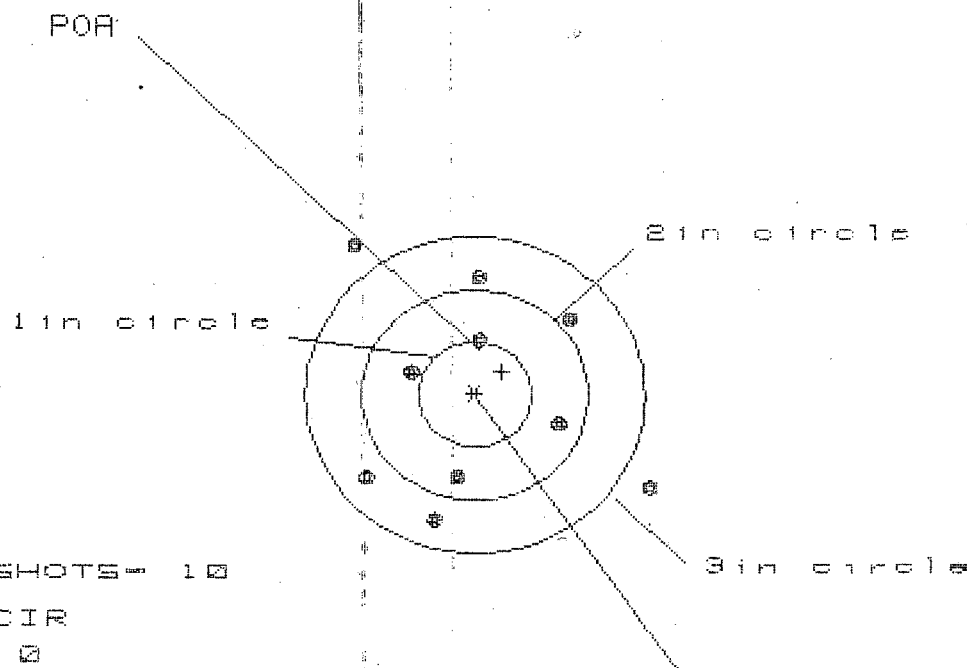
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.998	.995	.833
MINIMUM X	:	-1.292	-1.295	-1.409
MAXIMUM Y	:	1.158	.951	1.069
MINIMUM Y	:	-1.868	-1.291	-1.173
CENTROID X	:	.025	.028	.190
CENTROID Y	:	.319	.526	.408
POA TO CENTROID in.	:	.320	.527	.450
MIN RADIUS	:	.332	.505	.342
MEAN RADIUS	:	1.098	1.014	.889
MAX RADIUS	:	1.868	1.602	1.495
HORIZONTAL SPREAD	:	2.290	2.290	2.242
VERTICAL SPREAD	:	3.026	2.242	2.242
EXTREME SPREAD	:	3.272	2.716	2.343
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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FILE:/PATTERNING/CENTERFIRE_PATT/06B65721

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 2.524

VS = 2.586

GS = 3.383

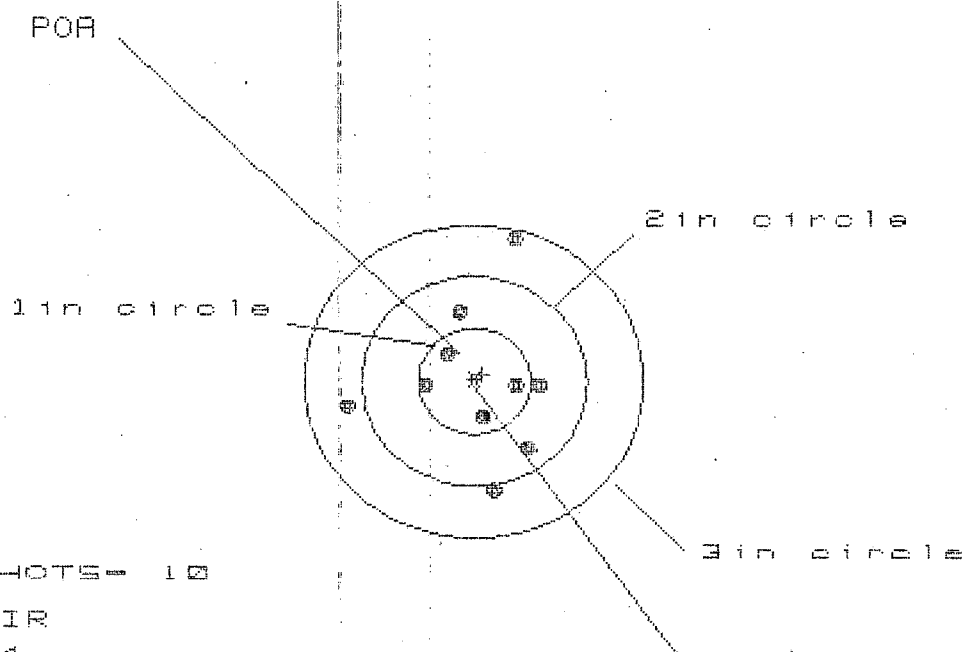
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.490	1.375	.898
MINIMUM X	:	-1.034	-1.107	-.935
MAXIMUM Y	:	1.413	1.251	1.166
MINIMUM Y	:	-1.173	-1.016	-1.101
CENTROID X	:	-.240	-.125	-.297
CENTROID Y	:	-.218	-.375	-.290
POA TO CENTROID in.	:	.324	.396	.415
MIN RADIUS	:	.523	.639	.586
MEAN RADIUS	:	1.093	1.015	.932
MAX RADIUS	:	1.751	1.535	1.201
HORIZONTAL SPREAD	:	2.524	2.482	1.833
VERTICAL SPREAD	:	2.586	2.267	2.267
EXTREME SPREAD	:	3.383	2.483	2.365
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.727

VS= 2.366

GS= 2.375

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.571	.609	.469
MINIMUM X	-1.156	-1.118	-.532
MAXIMUM Y	1.330	.802	.795
MINIMUM Y	-1.036	-.888	-.895
CENTROID X	-.070	-.108	.032
CENTROID Y	-.064	-.212	-.205
POA TO CENTROID in.	.095	.238	.208
MIN RADIUS	.308	.203	.147
MEAN RADIUS	.706	.625	.539
MAX RADIUS	1.373	1.120	.895
HORIZONTAL SPREAD	1.727	1.727	1.001
VERTICAL SPREAD	2.366	1.690	1.690
EXTREME SPREAD	2.375	1.735	1.706
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		