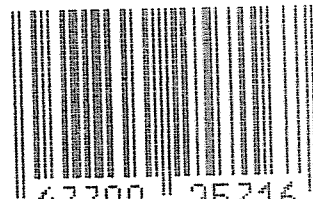


BARBER - M24 0102339

FORM

UPC



0 47700 25716 7

06665772

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24	ORDER NO.	5716
	BARREL LENGTH	
	CAPACITY*	

BARBER - M24 0102341

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665772

ORDER NO.

5716

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

20



5716 C6665772

ORDER 5716

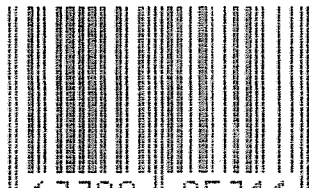
MODEL 700 TM M24

UPC

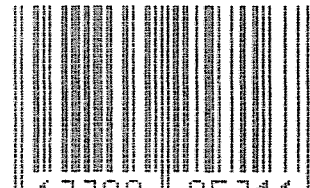
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665772

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26		RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GL
617	Drill and Tap Sight Holes		SEP 30 1991	FB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		10-13-91	TH
	Apply Coating (Bolt)			
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	TH

op. #	BARBER M24 0102343	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/18/91	OP
	G) Safety Off Force	3	3	3			10/18/91	OP
	H) Trigger Pull Test & Retainability						10/18/91	OP
	I) Firing Pin Indent	1023	10235	10235			10/18/91	OP
	J) Assemble Stock						10/18/91	RW
	K) Assemble Swivel Studs						10-22-91	AK
	L) Attach Front and Rear Sight Assemblies						10/18/91	RW
	M) Iron Sight Alignment						10/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/18/91	RW
	O) Attach Scope to Rifle						10/18/91	RW
	P) Detach & Attach Scope 20 Times						10/18/91	RW
640	Gallery Target & Test						10-21-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10-21-91	NF
655	Final Inspection							
	A) Headspace						10-22-91	AK
	B) Trigger Pull	248	255	263	269	276	10-22-91	OP
	C) Function						10-22-91	AK
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. 06665772DATE 10/18/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.61	2.50	248	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.60	2.36	2.55	255	
PULL #3	2.62	2.61	2.46	263	
PULL #4	2.59	2.47	2.45	269	
PULL #5	2.61	2.45	2.40	276	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.65		
PULL #2	3.56	3.36		
PULL #3	3.57	3.28		
PULL #4	3.60	3.15		
PULL #5	3.65	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	4.47	4.43		4.23
PULL #2	4.47	4.47		4.30
PULL #3	4.54	4.58		4.35
PULL #4	4.37	4.52		4.28
PULL #5	4.39	4.53		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665772
22 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.863883
1 TO	2	.613431
1 TO	3	.30096
1 TO	4	.868816
1 TO	5	.987244

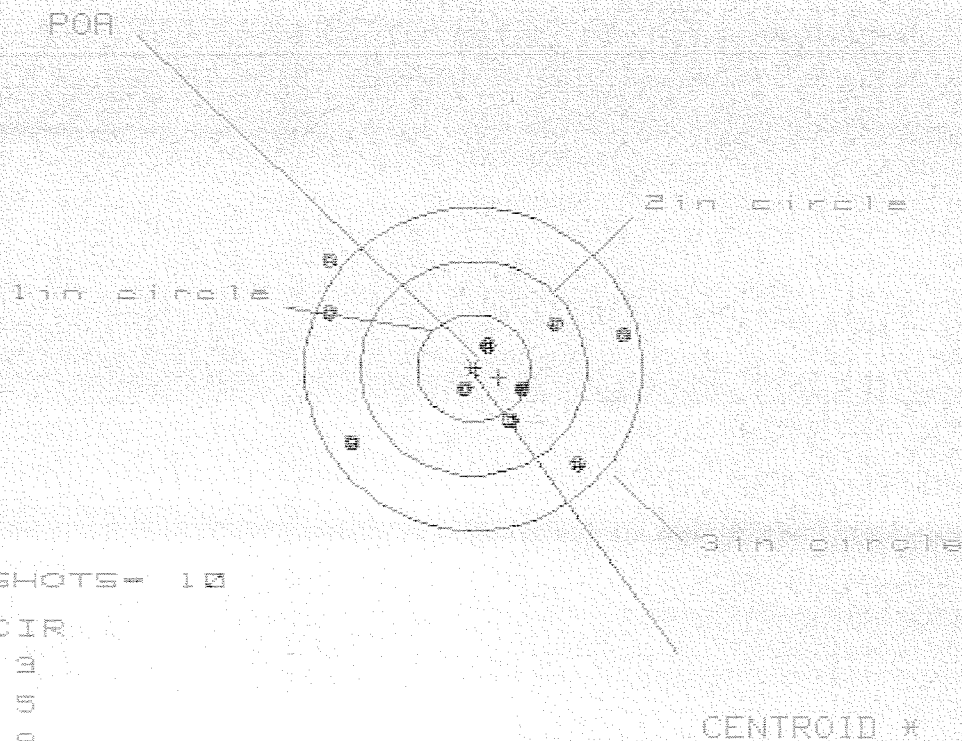
St 4 <----POA
St 3
St 1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .358975
THE AMR FOR THIS RIFLE IS: 1.084

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06865772

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.629

VS= 1.856

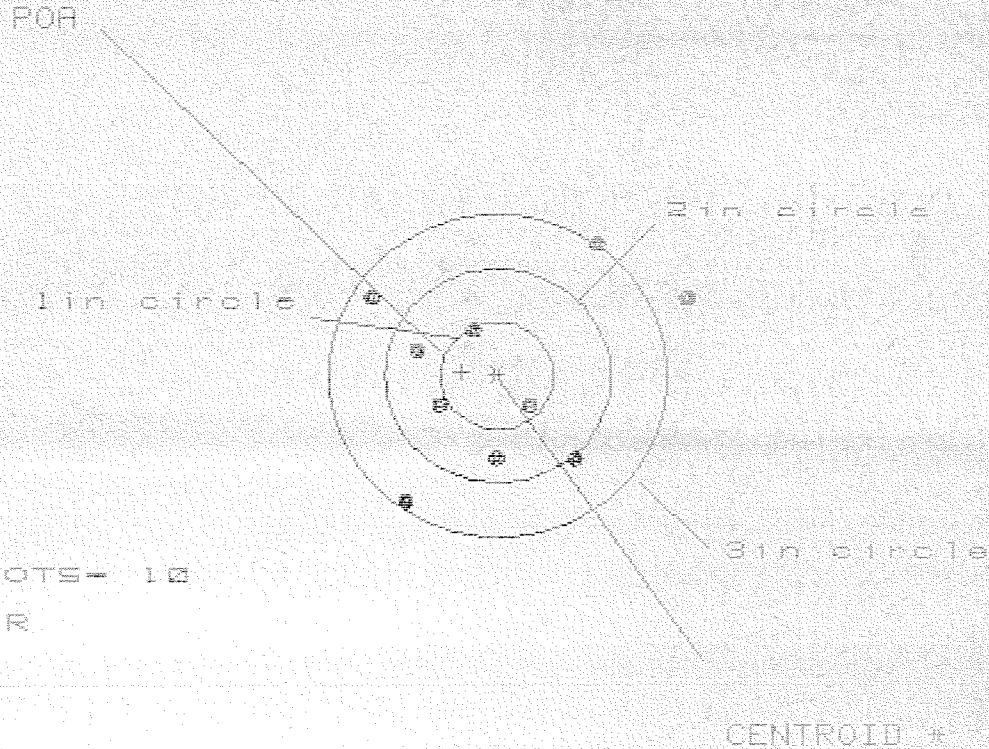
GS= 2.873

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.335	1.194	1.014
MINIMUM X	-1.294	-1.435	-1.397
MAXIMUM Y	.981	.667	.611
MINIMUM Y	-.875	-.766	-.682
CENTROID X	-.222	-.081	.099
CENTROID Y	.085	-.024	-.108
POA TO CENTROID in.	.238	.084	.146
MIN RADIUS	.204	.262	.095
MEAN RADIUS	.925	.818	.693
MAX RADIUS	1.606	1.583	1.478
HORIZONTAL SPREAD	2.629	2.629	2.411
VERTICAL SPREAD	1.856	1.433	1.293
EXTREME SPREAD	2.873	2.644	2.594
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665772

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.837

VS= 2.407

GS= 3.127

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.695	1.050	.994
MINIMUM X	-1.142	-.954	-.822
MAXIMUM Y	1.224	1.303	.976
MINIMUM Y	-1.183	-1.104	-.941
CENTROID X	.317	.129	-.003
CENTROID Y	-.033	-.112	-.275
POA TO CENTROID in.	.319	.171	.275
MIN RADIUS	.389	.344	.162
MEAN RADIUS	1.005	.876	.748
MAX RADIUS	1.840	1.674	1.276
HORIZONTAL SPREAD	2.837	2.004	1.816
VERTICAL SPREAD	2.407	2.407	1.917
EXTREME SPREAD	3.127	2.919	2.366
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	5	5	5
NUMBER IN THREE INCH CIRCLE =	9	9	9

21 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00665772

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 3

3in = 6

HS= 2.741

VS= 3.517

GS= 3.691

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.647	1.698	1.595
MINIMUM X	-1.094	-1.043	-1.146
MAXIMUM Y	1.200	.943	.704
MINIMUM Y	-2.317	-1.913	-1.557
CENTROID X	.281	.230	.333
CENTROID Y	-.661	-.404	-.165
POR TO CENTROID in.	.719	.465	.371
MIN RADIUS	.127	.290	.339
MEAN RADIUS	1.195	1.011	.867
MAX RADIUS	2.361	2.080	1.690
HORIZONTAL SPREAD	2.741	2.741	2.741
VERTICAL SPREAD	3.517	2.856	1.261
EXTREME SPREAD	3.691	2.978	2.952
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

21 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08665772

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 3.125

VS= 3.753

GS= 4.396

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.754	1.694	1.186
MINIMUM X	-1.371	-1.431	-1.219
MAXIMUM Y	1.302	1.030	1.011
MINIMUM Y	-2.451	-1.082	-.954
CENTROID X	.088	.140	-.072
CENTROID Y	-.249	.023	-.105
POA TO CENTROID in.	.262	.142	.127
MIN RADIUS	.308	.129	.179
MEAN RADIUS	1.136	.942	.814
MAX RADIUS	2.509	1.982	1.548
HORIZONTAL SPREAD	3.125	3.125	2.405
VERTICAL SPREAD	3.753	2.112	1.965
EXTREME SPREAD	4.396	3.772	2.648
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

21 Oct 1991

FILE: /PATTERNING/CENTERFIRE_PATT/0666572

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 4.027

VS= 4.714

GS= 5.715

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.543

1.041

.891

MINIMUM X

-1.484

-1.201

-.527

MAXIMUM Y

1.475

1.115

1.172

MINIMUM Y

-3.239

-.787

-.730

CENTROID X

.057

-.226

-.076

CENTROID Y

-.862

-.502

-.559

POA TO CENTROID in.

.864

.551

.564

MIN RADIUS

.464

.243

.185

MEAN RADIUS

1.160

.737

.660

MAX RADIUS

4.118

1.285

1.190

HORIZONTAL SPREAD

4.027

2.242

1.419

VERTICAL SPREAD

4.714

1.902

1.902

EXTREME SPREAD

5.715

2.376

1.937

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8