

BARBER - M24 0102594

FORM

UPC



0 47700 25716 7

C6665793

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY\*

**Remington**

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

**MODEL 700™ M24****SERIAL NO.****C6665793****ORDER NO.****5716**

20

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



5716 C6665793

**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 #

**C6665793**

| OP. #        | OP. NAME                                                       | READINGS | DATE       | INIT |
|--------------|----------------------------------------------------------------|----------|------------|------|
| 575 &<br>580 | Assemble Action<br>and Stock                                   |          | 9/25/91    | KL   |
| 600          | Proof                                                          |          | 9/25/91    | KL   |
| 607          | Check Headspace                                                |          | 9/25/91    | KL   |
| 610          | Dis-assemble Gun                                               |          | 9/25/91    | KL   |
| 612          | Magnaflux Barrel<br>Action                                     |          | OCT 2 1991 | KR   |
|              | Magnaflux Bolt                                                 |          | OCT 2 1991 | KR   |
| 615          | Rollmark Caliber                                               |          | OCT 2 1991 | GB   |
| 617          | Drill and Tap Sight Holes                                      |          | OCT 2 1991 | LB   |
| 618          | Polish Barrel                                                  |          | OCT 4 1991 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |          | 10-14-91   | JA   |
|              | Apply Coating (Bolt)                                           |          |            |      |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |          | 10/16/91   | KL   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |          | 10/16/91   | KL   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |          | 10/16/91   | KL   |
|              | D) Oil Firing Pin Ass'y                                        |          | 10/16/91   | KL   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |          | 10/24/91   | JA   |

| op. #        | OP NAME                                                     | READINGS |      |       |     | DATE     | INIT     |
|--------------|-------------------------------------------------------------|----------|------|-------|-----|----------|----------|
| 625<br>cont. | F) Safety On Force                                          | 6        | 6    | 6     |     | 10/24/91 | SH       |
|              | G) Safety Off Force                                         | 4        | 4    | 4     |     | 10/24/91 | SH       |
|              | H) Trigger Pull Test & Retainability                        |          |      |       |     | 10/24/91 | SH       |
|              | I) Firing Pin Indent                                        | .0206    | .020 | .0205 |     | 10/24/91 | SH       |
|              | J) Assemble Stock                                           |          |      |       |     | 10/24/91 | SH       |
|              | K) Assemble Swivel Studs                                    |          |      |       |     | 10-30-91 | SH       |
|              | L) Attach Front and Rear Sight Assemblies                   |          |      |       |     | 10/24/91 | SH       |
|              | M) Iron Sight Alignment                                     |          |      |       |     | 10/24/91 | SH       |
|              | N) Detach Front & Rear Sights & place in numbered container |          |      |       |     | 10/24/91 | SH       |
|              | O) Attach Scope to Rifle                                    |          |      |       |     | 10/24/91 | SH       |
|              | P) Detach & Attach Scope 20 Times                           |          |      |       |     | 10/24/91 | SH       |
| 640          | Gallery Target & Test                                       |          |      |       |     | 10-25-91 | NF       |
|              | A) Time                                                     |          |      |       |     | "        | NF       |
|              | B) Malfunctions                                             |          |      |       |     | "        | NF       |
|              | C) Pierced Primers                                          |          |      |       |     | "        | NF       |
|              | D) Optical Clarity of Scope                                 |          |      |       |     | "        | NF       |
| 645          | Inspect for Live Ammo                                       |          |      |       |     | 10-25-91 | NF       |
| 655          | Final Inspection                                            |          |      |       |     |          |          |
|              | A) Headspace                                                |          |      |       |     | 10-30-91 | SH       |
|              | B) Trigger Pull                                             | 254      | 254  | 268   | 274 | 259      | 10-29-91 |
|              | C) Function                                                 |          |      |       |     | 10-30-91 | SH       |
| 660          | Pack                                                        |          |      |       |     | 12-11-91 | NF       |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-666579-3

DATE 10/24/91

TESTER JF

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.34             | 2.39                     | 2.38                           | 2.54 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.46             | 2.36                     | 2.44                           | 2.54 |                                                                        |
| PULL #3 | 2.38             | 2.44                     | 2.40                           | 2.68 |                                                                        |
| PULL #4 | 2.36             | 2.40                     | 2.43                           | 2.74 |                                                                        |
| PULL #5 | 2.35             | 2.42                     | 2.41                           | 2.59 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.68             | 3.56                     |  |          |
| PULL #2 | 3.55             | 3.31                     |  |          |
| PULL #3 | 3.58             | 3.55                     |  |          |
| PULL #4 | 3.53             | 3.36                     |  |          |
| PULL #5 | 3.63             | 3.47                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.60             | 4.37                     |                                | 4.43                                 |
| PULL #2 | 4.40             | 4.36                     |                                | 4.29                                 |
| PULL #3 | 4.47             | 4.49                     |                                | 4.28                                 |
| PULL #4 | 4.44             | 4.43                     |                                | 4.18                                 |
| PULL #5 | 4.42             | 4.45                     |                                | 4.34                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # 06665793  
25 Oct 1991

CENTROIDAL DISTANCES

|      |   |        |
|------|---|--------|
| 0 TO | 1 | 176511 |
| 1 TO | 2 | 128787 |
| 1 TO | 3 | 08422  |
| 1 TO | 4 | 281585 |
| 1 TO | 5 | 469596 |

5  
43 <--- POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0022  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0256  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0256944  
THE AMR FOR THIS RIFLE IS: 1.043

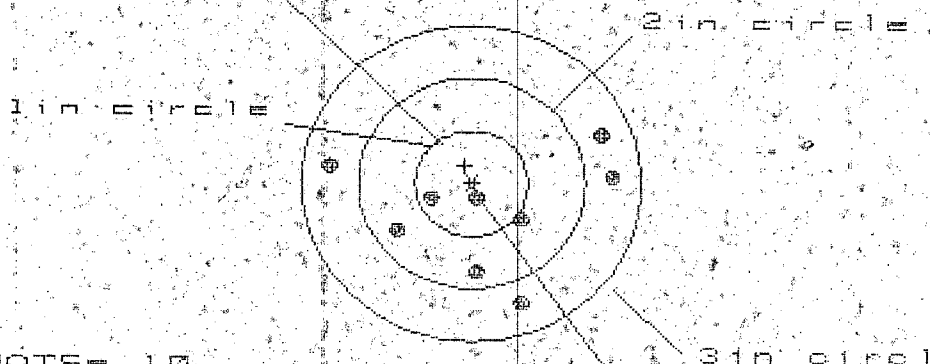
25 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/C8665793

## CENTERFIRE PATTERNS

# 1

POB



# OF SHOTS - 10

# IN CIR

1 in = 0

2 in = 5

3 in = 0

H51 = 0.405

VS = 0.000

GO = 0.000

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X : 1.263 1.143 1.123

MINIMUM X : -1.232 -1.342 -1.199

MAXIMUM Y : 2.150 .747 .789

MINIMUM Y : -1.145 -.906 -.864

CENTROID X : .060 .180 .037

CENTROID Y : -.166 -.405 -.447

POB TO CENTROID in. : .176 .443 .449

MIN RADIUS : .163 .112 .141

MEAN RADIUS : 1.000 .786 .722

MAX RADIUS : 2.405 1.416 1.373

HORIZONTAL SPREAD : 2.485 2.485 2.322

VERTICAL SPREAD : 3.295 1.653 1.653

EXTREME SPREAD : 3.622 2.488 2.341

NUMBER IN ONE INCH CIRCLE = 2

NUMBER IN TWO INCH CIRCLE = 5

NUMBER IN THREE INCH CIRCLE = 9

25 Oct 1991

FILE: PATTERNING/CENTERFIRE PATT/C6665793

## CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 1

2 in = 3

3 in = 5

HS= 2.620

VS= 3.495

GS= 3.669

CENTROID \*

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

-1.596

-1.493

-1.498

MINIMUM X

-1.024

-1.127

-1.123

MAXIMUM Y

1.539

1.321

1.067

MINIMUM Y

-1.956

-2.034

-1.554

CENTROID X

.029

.132

.127

CENTROID Y

-.041

.177

.431

POA TO CENTROID in.

.050

.221

.449

MIN RADIUS

.459

.295

.386

MEAN RADIUS

1.334

1.211

1.079

MAX RADIUS

2.166

2.034

1.917

HORIZONTAL SPREAD

2.620

2.620

2.620

VERTICAL SPREAD

3.495

3.355

2.621

EXTREME SPREAD

3.669

3.355

3.070

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

5

25 Oct 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6665793

## CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID .\*

# OF SHOTS = 10

# IN CIR

1 in = 3

2 in = 9

3 in = 10

HS = 1.870

VS = 1.203

GS = 1.995

PATTERN #

3

| SHOTS (BEST OF)               | 10     | 9      | 8     |
|-------------------------------|--------|--------|-------|
| MAXIMUM X                     | .810   | .692   | .562  |
| MINIMUM X                     | -1.060 | -1.043 | -.824 |
| MAXIMUM Y                     | .694   | .640   | .681  |
| MINIMUM Y                     | -.509  | -.563  | -.522 |
| CENTROID X                    | .133   | .251   | .381  |
| CENTROID Y                    | -.124  | -.070  | -.111 |
| POA TO CENTROID in.           | .182   | .261   | .397  |
| MIN RADIUS                    | .296   | .295   | .292  |
| MEAN RADIUS                   | .712   | .646   | .571  |
| MAX RADIUS                    | 1.164  | 1.092  | .852  |
| HORIZONTAL SPREAD             | 1.870  | 1.735  | 1.386 |
| VERTICAL SPREAD               | 1.203  | 1.203  | 1.203 |
| EXTREME SPREAD                | 1.995  | 1.908  | 1.529 |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |       |
| NUMBER IN TWO INCH CIRCLE =   | 9      |        |       |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |       |

25 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/CS665793

## CENTERFIRE PATTERNS # 4

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 = 3.356

VS = 3.039

GS = 3.396

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.068

.814

.870

MINIMUM X

-2.288

-1.496

-1.440

MAXIMUM Y

1.450

1.432

1.286

MINIMUM Y

-1.589

-1.607

-1.428

CENTROID X

-.213

.041

-.015

CENTROID Y

-.097

-.079

-.258

POA TO CENTROID in.

.234

.089

.259

MIN RADIUS

.259

.121

.101

MEAN RADIUS

1.050

.893

.814

MAX RADIUS

2.294

1.635

1.449

HORIZONTAL SPREAD

3.356

1.310

1.310

VERTICAL SPREAD

3.039

3.039

2.714

EXTREME SPREAD

3.396

3.131

2.719

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

7

25 Oct 1991

FILE: PATTERNING/CENTERFIRE\_PATT/C6685793

## CENTERFIRE PATTERNS. # 5.

POA

1 in circle

2 in circle

3 in circle

# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.563

VS= 5.527

GS= 5.544

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.693

.731

.726

MINIMUM X

-.870

-.832

-.837

MAXIMUM Y

3.770

1.400

1.232

MINIMUM Y

-1.757

-1.338

-1.788

CENTROID X

.002

-.036

-.031

CENTROID Y

.300

-.119

.049

POA TO CENTROID in.

.300

.124

.058

MIN RADIUS

.236

.090

.046

MEAN RADIUS

1.117

.710

.628

MAX RADIUS

3.786

1.401

1.234

HORIZONTAL SPREAD

1.563

1.563

1.563

VERTICAL SPREAD

5.527

2.738

2.020

EXTREME SPREAD

5.544

2.740

2.074

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8