

BARBER - M24 0102893

FORM

UPC



0 47700 25716 7

C6665814

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.

C6665814

20

ORDER NO.

5716

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



5716 C6665814

ORDER 5716

MODEL 700TM M24

UPC



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ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6665814*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	<i>RW</i>
600	Proof	10 1	91	<i>RW</i>
607	Check Headspace	10 1	91	<i>RW</i>
610	Dis-assemble Gun	10 1	91	<i>RW</i>
612	Magnaflux Barrel Action	OCT	8 1991	<i>KR</i>
	Magnaflux Bolt	OCT	8 1991	<i>KR</i>
615	Rollmark Caliber	OCT	8 1991	<i>GL</i>
617	Drill and Tap Sight Holes	OCT	8 1991	<i>LB</i>
618	Polish Barrel		10/15/91	<i>W/B</i>
620	Apply Coatings (Barrel Action)		11-8-91	<i>TH</i>
	Apply Coating (Bolt)			<i>TH</i>
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/91	<i>RW</i>
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	<i>RW</i>
	C) Inspect Ejector Hole for Chamfer		11/14/91	<i>RW</i>
	D) Oil Firing Pin Ass'y		11/14/91	<i>RW</i>
	E) Adjust Trigger Pull to Min Setting and Stake		11-19-91	<i>GL</i>

op. #	BARBER M24 0102897	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2	4 1/2	4 1/2	11/19/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	11/19/91	WB
	H) Trigger Pull Test & Retainability						11/19/91	JL
	I) Firing Pin Indent	.022	.0215	.0215	.0215	.0215	11/19/91	WB
	J) Assemble Stock						11/20/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/20/91	RW
	M) Iron Sight Alignment						11/20/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/20/91	RW
	O) Attach Scope to Rifle						11/20/91	RW
	P) Detach & Attach Scope 20 Times						11/20/91	RW
640	Gallery Target & Test						11-20-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						11-20-91	N
655	Final Inspection						11-27-91	D/H
	A) Headspace							
	B) Trigger Pull	2.21	2.22	2.20	2.24	2.21	11/21/91	JL
	C) Function						11-27-91	D/H
660	Pack						12-14-91	N

AVERAGE BULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 0-6665814DATE 11-19-91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.30	2.48	2.21	MIN. SETTING
PULL #2	2.26	2.27	2.51	2.22	NO AVG. OF 5
PULL #3	2.34	2.39	2.38	2.20	READINGS ACCEPT-
PULL #4	2.35	2.43	2.30	2.24	ABLE LESS THAN 2#
PULL #5	2.33	2.44	2.25	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.31		
PULL #2	3.33	3.33		
PULL #3	3.50	3.25		
PULL #4	3.65	3.20		
PULL #5	3.38	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.62	4.31		4.24
PULL #2	4.64	4.20		4.23
PULL #3	4.66	4.22		4.28
PULL #4	4.58	4.18		4.18
PULL #5	4.31	4.23		4.23
TOTAL				
AVG.				

DISTANCE CALCULATIONS
 RIFLE # C6665814
 1991

CENTROIDAL DISTANCES

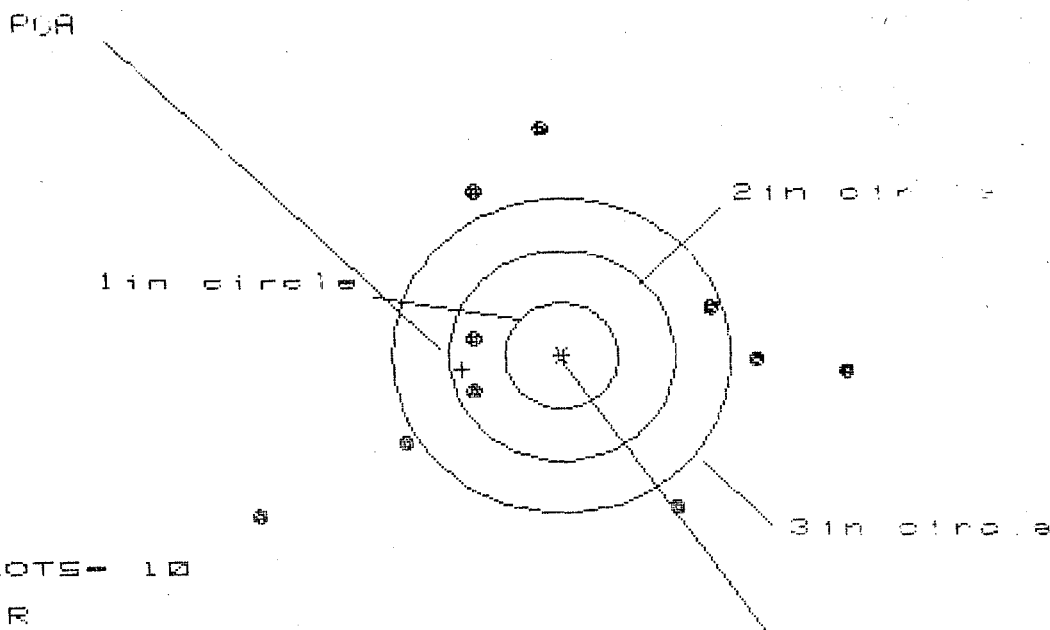
1 TO	1	.8908
1 TO	2	.792902
1 TO	3	.690016
1 TO	4	.434256
1 TO	5	.478851

34 1 <----POA

AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4128
 AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1172
 AVERAGE POI RADIUS FOR THIS RIFLE IS: .429115
 RANGE FOR THIS RIFLE IS: 1.112

FILE:/PATTERNING/CENTERFIRE_PATT/08665814

CENTERFIRE PATTERNS



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 3

HS= 5.238

VS= 3.699

GS= 5.431

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

2.538

2.238

1.687

MINIMUM X

-2.700

-1.710

-1.431

MAXIMUM Y

2.141

1.968

1.931

MINIMUM Y

-1.558

-1.601

-1.638

CENTROID X

.880

1.180

.901

CENTROID Y

.137

.310

.347

POA TO CENTROID in.

.891

1.220

.965

MIN RADIUS

.767

1.054

.777

MEAN RADIUS

1.772

1.618

1.503

MAX RADIUS

3.117

2.257

1.943

HORIZONTAL SPREAD

5.238

3.948

3.118

VERTICAL SPREAD

3.699

3.569

3.569

EXTREME SPREAD

5.431

4.013

3.781

NUMBER IN ONE INCH CIRCLE

=

0

NUMBER IN TWO INCH CIRCLE

=

2

NUMBER IN THREE INCH CIRCLE

=

3

13 JUL 1981

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS= 3.331

VS= 2.478

GS= 3.385

PATTERN #

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.202	.757	.848
MINIMUM X	:	-1.129	-.884	-.793
MAXIMUM Y	:	1.068	1.034	.854
MINIMUM Y	:	-1.410	-1.444	-1.199
CENTROID X	:	.423	.178	.088
CENTROID Y	:	-.006	.028	.208
POA TO CENTROID in.	:	.423	.181	.226
MIN RADIUS	:	.203	.284	.319
MEAN RADIUS	:	1.062	.906	.784
MAX RADIUS	:	2.223	1.616	1.242
HORIZONTAL SPREAD	:	3.331	1.641	1.641
VERTICAL SPREAD	:	2.478	2.478	2.053
EXTREME SPREAD	:	3.385	2.602	2.363
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Nov 1931

FILE:/PATTERNING/CENTERFIRE_PATT/06665814

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 3.000

VS= 2.093

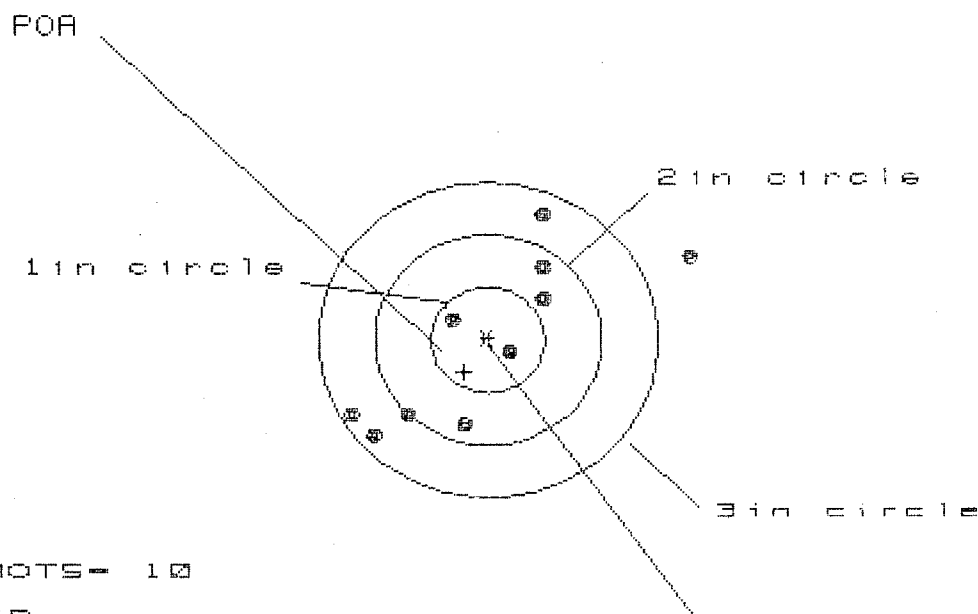
GS= 3.262

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.894	1.315	1.202
MINIMUM X	:	-1.114	-.904	-.769
MAXIMUM Y	:	.962	.925	1.036
MINIMUM Y	:	-1.131	-1.168	-1.056
CENTROID X	:	.447	.237	.350
CENTROID Y	:	.170	.207	.096
POA TO CENTROID in.	:	.478	.314	.363
MIN RADIUS	:	.085	.138	.059
MEAN RADIUS	:	.965	.825	.742
MAX RADIUS	:	1.923	1.585	1.562
HORIZONTAL SPREAD	:	3.008	2.219	1.971
VERTICAL SPREAD	:	2.093	2.093	2.093
EXTREME SPREAD	:	3.262	2.546	2.393
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS= 2.995

VS= 2.894

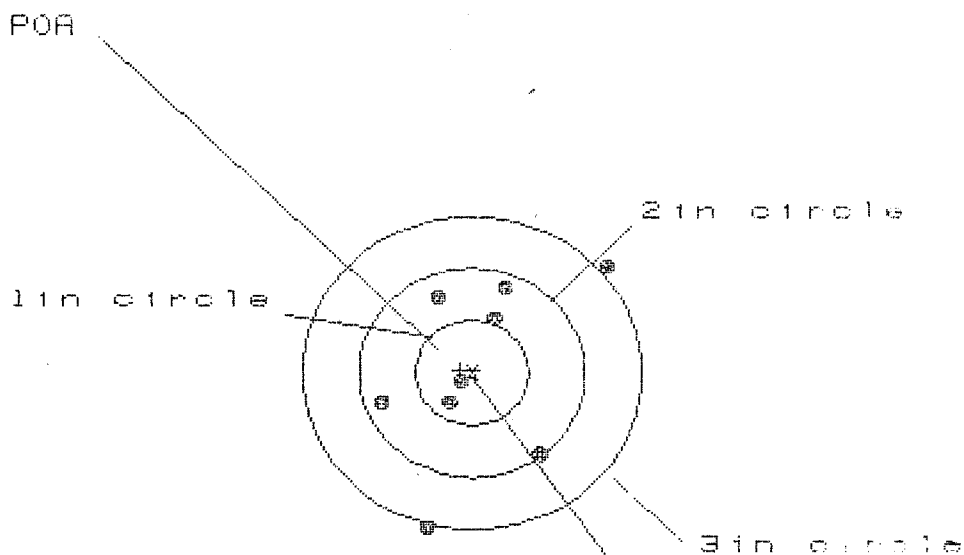
GS= 3.316

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.792	.729	.625
MINIMUM X	-1.203	-1.004	-1.108
MAXIMUM Y	1.152	1.237	1.130
MINIMUM Y	-.942	-.857	-.782
CENTROID X	.211	.012	.116
CENTROID Y	.306	.221	.328
POA TO CENTROID in.	.372	.221	.348
MIN RADIUS	.181	.306	.261
MEAN RADIUS	.972	.859	.799
MAX RADIUS	1.948	1.403	1.301
HORIZONTAL SPREAD	2.995	1.733	1.733
VERTICAL SPREAD	2.894	2.894	1.912
EXTREME SPREAD	3.316	2.569	2.461
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 1.949

VS= 2.480

GS= 2.952

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.160	.723	.684
MINIMUM X	-.789	-.660	-.699
MAXIMUM Y	1.051	.934	.770
MINIMUM Y	-1.429	-1.312	-.809
CENTROID X	.103	-.026	.013
CENTROID Y	-.021	-.138	.026
POA TO CENTROID in.	.105	.140	.029
1IN RADIUS	.154	.085	.102
MEAN RADIUS	.791	.668	.589
MAX RADIUS	1.566	1.349	1.059
HORIZONTAL SPREAD	1.949	1.383	1.383
VERTICAL SPREAD	2.480	2.246	1.579
EXTREME SPREAD	2.952	2.362	1.728
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	