

BARBER - M24 0103437

FORM

UPC



0 47700 25716 7

06665861

CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

BARBER - M24 0103439

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665861

ORDER NO.

5716

20

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



5716 C6665861

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665861

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KR
600	Proof		9/23/91	KA
607	Check Headspace		9/23/91	KA
610	Dis-assemble Gun		9/23/91	KA
612	Magnaflux Barrel Action	SEP 30 1991		KR
	Magnaflux Bolt	SEP 30 1991		KR
615	Rollmark Caliber	SEP 30 1991		LL
617	Drill and Tap Sight Holes	SEP 30 1991		LB
618	Polish Barrel	OCT 2 1991		WB
620	Apply Coatings (Barrel Action)		10/2/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KA
	C) Inspect Ejector Hole for Chamfer		10/8/91	KA
	D) Oil Firing Pin Ass'y		10/8/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/91	DH

op. #	BARBER - M24 0103441 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	5	5			10-9-91	AC
	G) Safety Off Force	4	4	4			10-9-91	AC
	H) Trigger Pull Test & Retainability						10-9-91	DH
	I) Firing Pin Indent	.021	.020	.021			10-9-91	AC
	J) Assemble Stock						10/10/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/10/91	RW
	M) Iron Sight Alignment						10/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/10/91	RW
	O) Attach Scope to Rifle						10/10/91	RW
	P) Detach & Attach Scope 20 Times						10/10/91	RW
640	Gallery Target & Test						10/11/91	VS
	A) Time							1/2
	B) Malfunctions							1/2
	C) Pierced Primers							1/2
	D) Optical Clarity of Scope							1/2
645	Inspect for Live Ammo						10/11/91	RT
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.31	2.28	2.56	2.53	2.29	10/14/91	RT
	C) Function						10-17-91	AC
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. C6665861

DATE 10-9-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.35	2.72	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.31	2.77	2.28	
PULL #3	2.55	2.36	2.44	2.56	
PULL #4	2.54	2.32	2.76	2.53	
PULL #5	2.54	2.20	2.70	2.29	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.57		
PULL #2	3.57	3.57		
PULL #3	3.64	3.68		
PULL #4	3.49	3.55		
PULL #5	3.63	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.07		4.13
PULL #2	4.39	4.09		4.04
PULL #3	4.35	4.55		4.07
PULL #4	4.28	4.57		4.08
PULL #5	4.07	4.50		3.99
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665861
11 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.168618
1 TO	2	.246789
1 TO	3	.172012
1 TO	4	.393081
1 TO	5	.401966

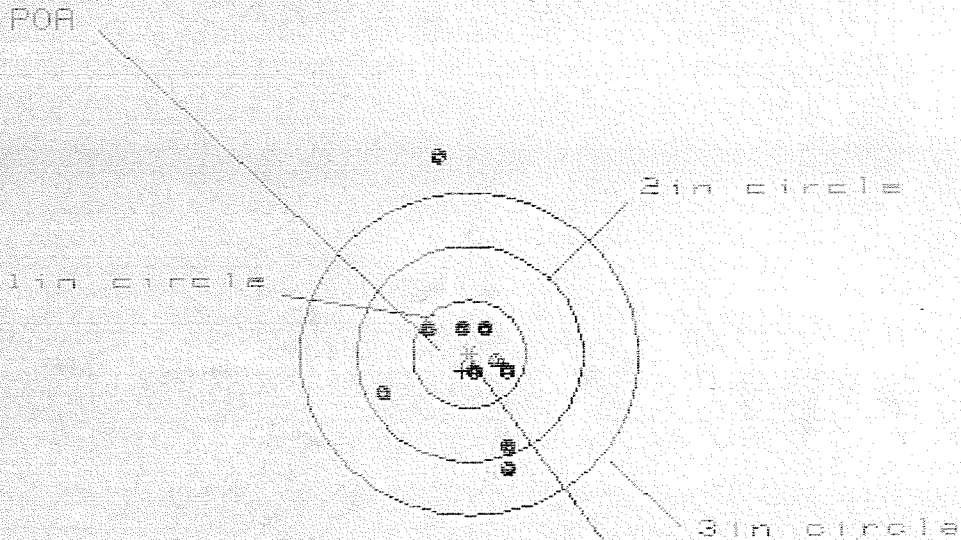
4.3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0262
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0448
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0518987
THE AMR FOR THIS RIFLE IS: .9266

11 OCT 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665861

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 6

2 in = 8

3 in = 9

HS= 1.086

VS= 2.810

GS= 2.868

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.372	.343	.377
MINIMUM X	-.714	-.743	-.709
MAXIMUM Y	1.798	.467	.365
MINIMUM Y	-1.012	-.812	-.728
CENTROID X	.064	.093	.059
CENTROID Y	.156	-.044	.058
POA TO CENTROID in.	.168	.103	.082
MIN RADIUS	.114	.090	.037
MEAN RADIUS	.627	.500	.427
MAX RADIUS	1.818	.858	.808
HORIZONTAL SPREAD	1.086	1.086	1.086
VERTICAL SPREAD	2.810	1.279	1.093
EXTREME SPREAD	2.868	1.430	1.287
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

17 Oct 1991

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CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.363

VS= 2.719

GS= 2.733

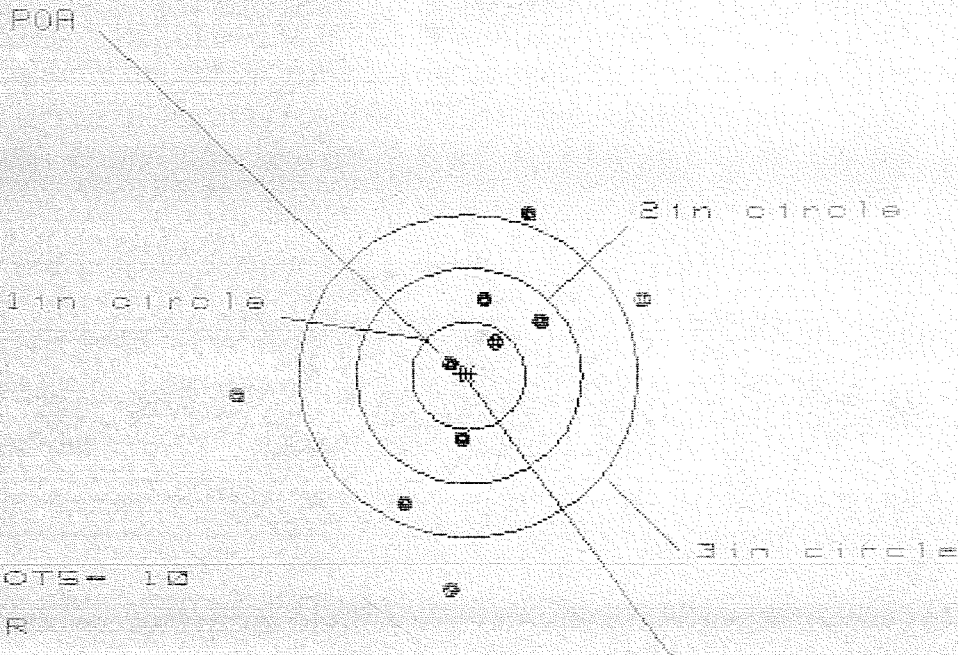
CENTROID #

PATTERN #	:	2	3	4
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	.919	.911
MINIMUM X	:	-1.300	-1.105	-1.113
MAXIMUM Y	:	1.394	1.328	1.274
MINIMUM Y	:	-1.325	-1.391	-1.225
CENTROID X	:	.027	.171	.179
CENTROID Y	:	-.080	-.014	-.180
POA TO CENTROID in.	:	.084	.172	.253
MIN RADIUS	:	.664	.648	.496
MEAN RADIUS	:	1.066	1.010	.952
MAX RADIUS	:	1.431	1.433	1.275
HORIZONTAL SPREAD	:	2.363	2.024	2.024
VERTICAL SPREAD	:	2.719	2.719	2.499
EXTREME SPREAD	:	2.733	2.733	2.534
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.520

VS = 3.465

GS = 3.729

CENTROID #

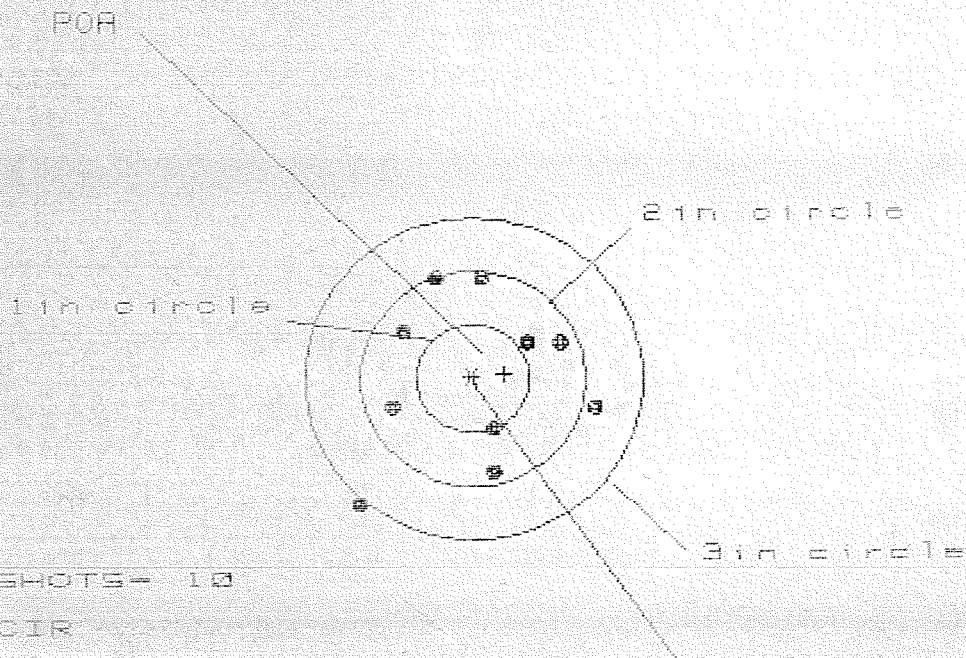
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.579	1.352	1.307
MINIMUM X	-2.041	-1.801	-1.846
MAXIMUM Y	1.479	1.454	1.203
MINIMUM Y	-1.986	-2.011	-1.427
CENTROID X	.062	.289	.334
CENTROID Y	-.016	.009	.260
POA TO CENTROID in.	.064	.289	.423
MIN RADIUS	.227	.333	.105
MEAN RADIUS	1.133	1.021	.327
MAX RADIUS	2.053	2.043	1.659
HORIZONTAL SPREAD	3.620	2.153	2.153
VERTICAL SPREAD	3.465	3.465	2.630
EXTREME SPREAD	3.729	3.531	2.858
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS= 2.072

VS= 2.146

GS= 2.387

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.063	.950	.787
MINIMUM X	-1.010	-.811	-.692
MAXIMUM Y	.965	.834	.779
MINIMUM Y	-1.181	-.972	-1.027
CENTROID X	-.279	-.167	-.286
CENTROID Y	-.036	.095	.150
POA TO CENTROID in.	.282	.192	.323
MIN RADIUS	.439	.438	.519
MEAN RADIUS	.882	.790	.752
MAX RADIUS	1.553	1.048	1.045
HORIZONTAL SPREAD	2.072	1.761	1.479
VERTICAL SPREAD	2.146	1.806	1.806
EXTREME SPREAD	2.387	1.868	1.830
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	8	8	8
NUMBER IN THREE INCH CIRCLE =	9	9	9

[1 Oct 1991]

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CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 1.904

VS= 2.832

GS= 2.882

PATTERN #

:

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.900	.859	.740
MINIMUM X	-1.004	-1.045	-1.164
MAXIMUM Y	1.002	.798	.508
MINIMUM Y	-1.830	-.581	-.481
CENTROID X	-.005	.036	.155
CENTROID Y	-.240	-.036	-.136
POA TO CENTROID in.	.240	.051	.206
MIN RADIUS	.366	.217	.187
MEAN RADIUS	.925	.774	.686
MAX RADIUS	1.868	1.240	1.128
HORIZONTAL SPREAD	1.904	1.904	1.904
VERTICAL SPREAD	2.832	1.379	.989
EXTREME SPREAD	2.882	2.088	1.554
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	