

BARBER - M24 0104340

FORM

UPC



0 47700 25716 7

C6665945

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO.

5716

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665945

ORDER NO.
5716

20

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



5716 C6665945

ORDER 5716
MODEL 700™ M24
UPC

ORDER 5716
MODEL 700™ M24
UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665945

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KA
600	Proof		10/1/91	KA
607	Check Headspace		10/1/91	KA
610	Dis-assemble Gun		10/1/91	KA
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KA
	Apply Coating (Bolt)		11/1/91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		11/13/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/13/91	KA
	C) Inspect Ejector Hole for Chamfer		11/13/91	KA
	D) Oil Firing Pin Ass'y		11/13/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		11/14/91	KA

op. #	BARBER M24 0104344	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/14/91	JK
	G) Safety Off Force	3	3	3			11/14/91	JK
	H) Trigger Pull Test & Retainability						11/14/91	JK
	I) Firing Pin Indent	020	1020	020			11/14/91	JK
	J) Assemble Stock						11/14/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/14/91	JK
	M) Iron Sight Alignment						11/14/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/14/91	JK
	O) Attach Scope to Rifle						11/14/91	JK
	P) Detach & Attach Scope 20 Times						11/14/91	JK
640	Gallery Target & Test						11/20/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/20/91	KT
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	2.62	2.54	2.55	2.54	2.54	11/21/91	JK
	C) Function						11-27-91	D/H
660	Pack						12-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665945

DATE 11-14/91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.50	2.48	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.43	2.40	2.54	
PULL #3	2.50	2.22	2.38	2.55	
PULL #4	2.41	2.45	2.55	2.54	
PULL #5	2.48	2.47	2.51	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.49		
PULL #2	3.48	3.50		
PULL #3	3.23	3.61		
PULL #4	3.61	3.51		
PULL #5	3.39	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.50		4.55
PULL #2	4.60	4.34		4.46
PULL #3	4.40	4.50		4.28
PULL #4	4.41	4.52		4.43
PULL #5	4.60	4.55		4.54
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665945
21 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.897669
1 TO	2	1.31983
1 TO	3	1.10222
1 TO	4	1.21162
1 TO	5	.926214

1
 $\sigma_2^2 \sigma_3^2$ <----FOA

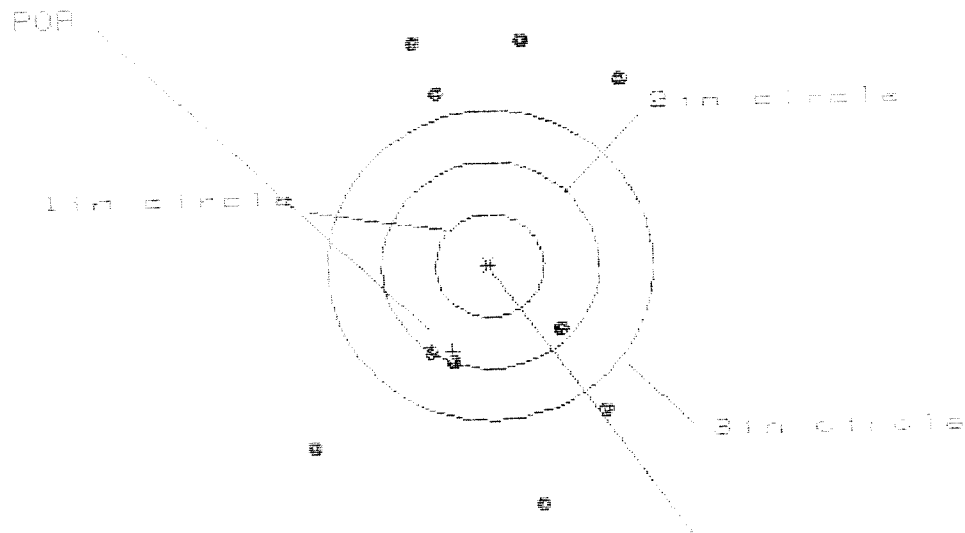
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0092
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .014
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0167923
 THE AMR FOR THIS RIFLE IS: 1.158

20 Nov 1991

FILE/PATTERNING/CENTERFIRE_PATT/08605945

CENTERFIRE PATTERNS

1



OF SHOTS = 12

IN CIR

1 in = 2

2 in = 2

3 in = 2

1 in = 2.666

2 in = 4.533

3 in = 4.666

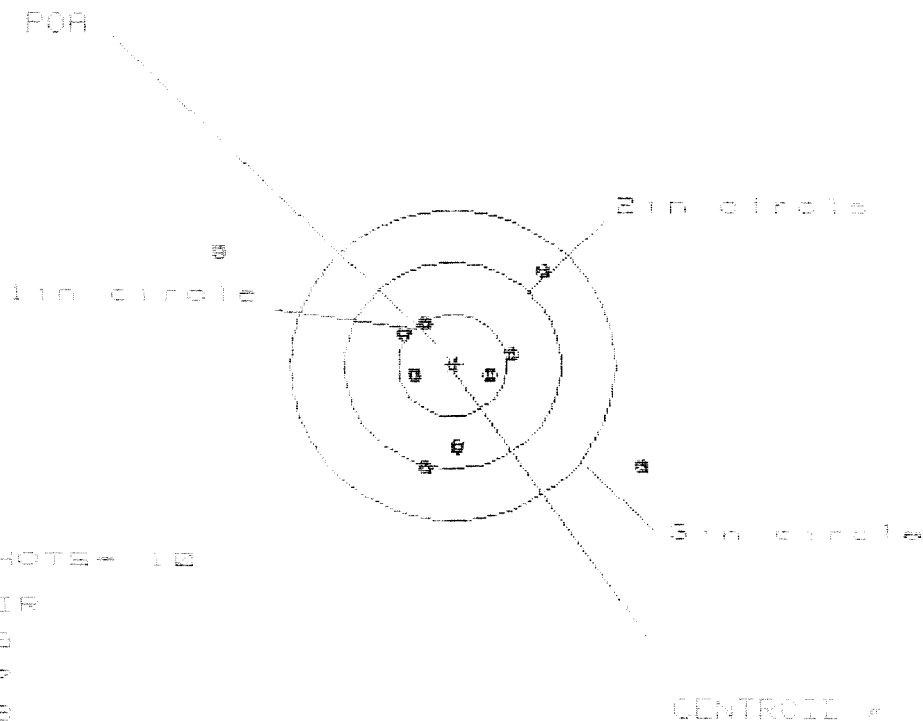
CENTERFIRE #

PHASE	10	9	8
10 INCH	1.268	1.318	1.122
9 INCH	-1.620	-1.570	-1.774
8 INCH	2.165	1.982	1.655
7 INCH	-2.370	-1.975	-1.966
6 INCH	.363	.313	.569
5 INCH	.821	1.084	1.331
4 INCH	.897	1.128	1.425
3 INCH	.802	1.096	1.215
2 INCH	1.730	1.723	1.616
1 INCH	2.412	2.523	2.101
SPREAD	2.898	2.888	1.896
SPREAD	4.535	3.877	3.561
SPREAD	4.662	4.557	3.228
ONE INCH CIRCLE	=	0	
TWO INCH CIRCLE	=	2	
THREE INCH CIRCLE	=	2	

28 Nov 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8665945

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 8

HE = 3.841

VS = 2.149

GS = 4.401

CENTROID =

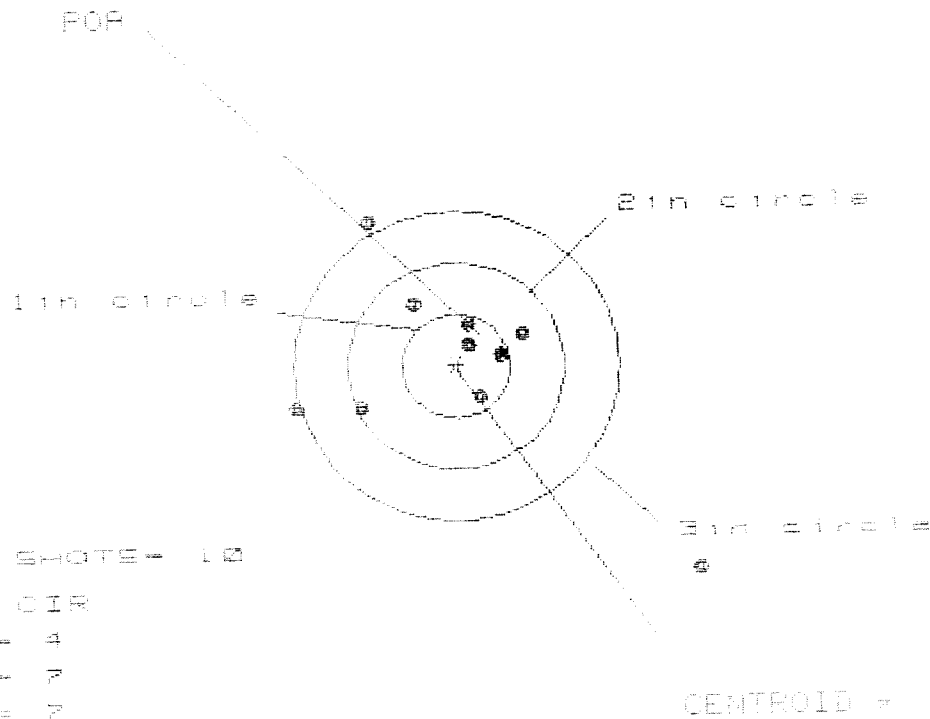
PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.699	1.461	1.738
MINIMUM X	-2.142	-1.697	-1.515
MAXIMUM Y	1.139	1.069	1.558
MINIMUM Y	-1.010	-1.883	-1.932
CENTROID X	-1.044	1.194	1.012
CENTROID Y	-1.011	-1.138	-1.027
POA TO CENTROID in.	1.045	1.238	1.330
1in Radius	1.360	1.129	1.332
2in Radius	1.975	1.803	1.569
3in Radius	2.426	1.707	1.209
HCF-CENTRAL SPREAD	3.841	2.158	1.253
VER-100% SPREAD	2.149	1.952	1.898
CR-100% SPREAD	4.401	2.520	2.138
ALL ONE INCH CIRCLE =		3	
ALL TWO INCH CIRCLE =		7	
ALL THREE INCH CIRCLE =		8	

20 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685945

CENTERFIRE PATTERNS

4



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 7

XS= 3.712

YS= 3.480

ZS= 4.575

PATTERN #	1	4	8
SHOTS - BEAT OF	10	9	8
MAXIMUM X	2.192	.864	.797
MINIMUM X	-1.520	-1.277	-1.344
MAXIMUM Y	1.456	1.231	.510
MINIMUM Y	-2.824	-.613	-.459
CENTROID X	-.416	-.659	-.592
CENTROID Y	-.107	.118	-.036
POB TO CENTROID (in)	.429	.670	.593
1in RADIUS	.266	.332	.320
2in RADIUS	1.012	.783	.780
3in RADIUS	2.983	1.416	1.420
HORIZONTAL SPREAD	3.712	2.141	2.141
VERTICAL SPREAD	3.480	1.844	.969
DIAGONAL SPREAD	4.575	2.255	2.255
1in RADIUS ONE INCH CIRCLE =		4	
2in RADIUS TWO INCH CIRCLE =		7	
3in RADIUS THREE INCH CIRCLE =		7	

20 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885943

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 5

3 in = 5

HS = 2.818

VS = 1.939

GS = 3.221

PATTERN #

3

	10	9	8
GROUP (BEST OF)	2.321	.907	.948
MINIMUM X	-1.895	-1.637	-1.596
MINIMUM Y	1.093	1.107	.846
MINIMUM Z	-1.846	-1.832	-1.594
MINIMUM W	.385	.127	.086
CENTROID X	-1.281	-1.295	-1.433
CENTROID Y	.477	.321	.442
POA TO CENTROID (in)	.463	.309	.430
1 in radius	.913	.684	.616
2 in radius	2.325	1.156	1.082
3 in radius	3.216	1.544	1.544
4 in radius	1.939	1.939	1.340
5 in radius	3.221	1.943	1.574
ONE INCH CIRCLE =		2	
TWO INCH CIRCLE =		8	
THREE INCH CIRCLE =		9	

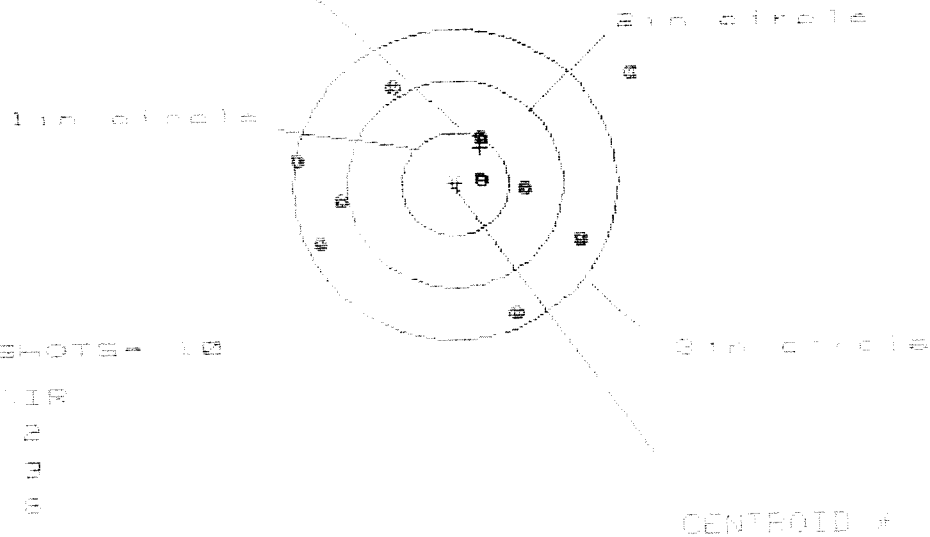
28 Nov 1961

FILE:/PATTERNING/CENTERFIRE_PATT/C8685945

CENTERFIRE PATTERNS

2

POB



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 3

3 in = 5

LB= 2.103

LB= 2.262

LB= 2.318

PATTERN #

2

	10	9	8
SHOT - BEST OF	1.599	1.288	1.123
1st SHOT	-1.594	-1.327	-1.285
2nd SHOT	1.025	1.026	1.071
3rd SHOT	-1.237	-1.123	-1.078
4th SHOT	-1.242	-1.419	-1.254
5th SHOT	-1.352	-1.485	-1.511
6th SHOT	1.427	1.617	1.571
7th SHOT	1.274	1.479	1.358
8th SHOT	1.110	1.039	1.071
9th SHOT	1.899	1.375	1.357
10th SHOT	3.103	2.615	2.488
11th SHOT	2.262	2.149	2.149
12th SHOT	2.318	2.735	2.440
1 in circle	2		
2 in circle	3		
3 in circle	5		