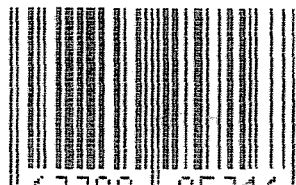


BARBER - M24 0104414

FURN

UPC



0 47700 25716 7

C6665952

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

MODEL 700 TM M24

ORDER NO. 5715

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24			SERIAL NO. C6665952
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		20	ORDER NO. 5716



5716 C6665952

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

CCCC5952

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/27/91	KH
600	Proof		9/27/91	KH
607	Check Headspace		9/27/91	KH
610	Dis-assemble Gun		9/27/91	KH
612	Magnaflux Barrel Action		OCT 4 1991	Ked
	Magnaflux Bolt		OCT 4 1991	Ked
615	Rollmark Caliber		OCT 4 1991	CB
617	Drill and Tap Sight Holes		OCT 4 1991	FB
618	Polish Barrel		OCT 4 1991	W.B.
620	Apply Coatings (Barrel Action)		10-18-91	JH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	KH
	C) Inspect Ejector Hole for Chamfer		11/14/91	KH
	D) Oil Firing Pin Ass'y		11/14/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-14-91	JH

op. #	BARBER MEM24 0104418	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6	6	11/15/91	JK
	G) Safety Off Force	4	4	4	4	4	11/15/91	JK
	H) Trigger Pull Test & Retainability						11-15-91	JK
	I) Firing Pin Indent	.0215	.0215	.0215	.0215	.0215	11/15/91	JK
	J) Assemble Stock						11/25/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	JK
	M) Iron Sight Alignment						11/25/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	JK
	O) Attach Scope to Rifle						11/25/91	JK
	P) Detach & Attach Scope 20 Times						11/25/91	JK
640	Gallery Target & Test						11-26-91	JK
	A) Time						"	JK
	B) Malfunctions						"	JK
	C) Pierced Primers						"	JK
	D) Optical Clarity of Scope						"	JK
645	Inspect for Live Ammo						11-26-91	JK
655	Final Inspection							
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	2.58	2.61	2.63	2.61	2.63	11-27-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-18-91	JK

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6665952

DATE 11-15-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.40	2.40	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.47	2.44	2.61	
PULL #3	2.57	2.51	2.49	2.63	
PULL #4	2.73	2.52	2.50	2.61	
PULL #5	2.44	2.48	2.50	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.59	3.61		
PULL #2	3.52	3.45		
PULL #3	3.55	3.53		
PULL #4	3.68	3.65		
PULL #5	3.46	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.60	4.47		4.67
PULL #2	4.46	4.55		4.47
PULL #3	4.44	4.63		4.67
PULL #4	4.52	4.57		4.42
PULL #5	4.50	4.65		4.45
TOTAL				
AVG.				

INITIAL CALCULATIONS
 116 0 0.065952

ADAL DISTANCES

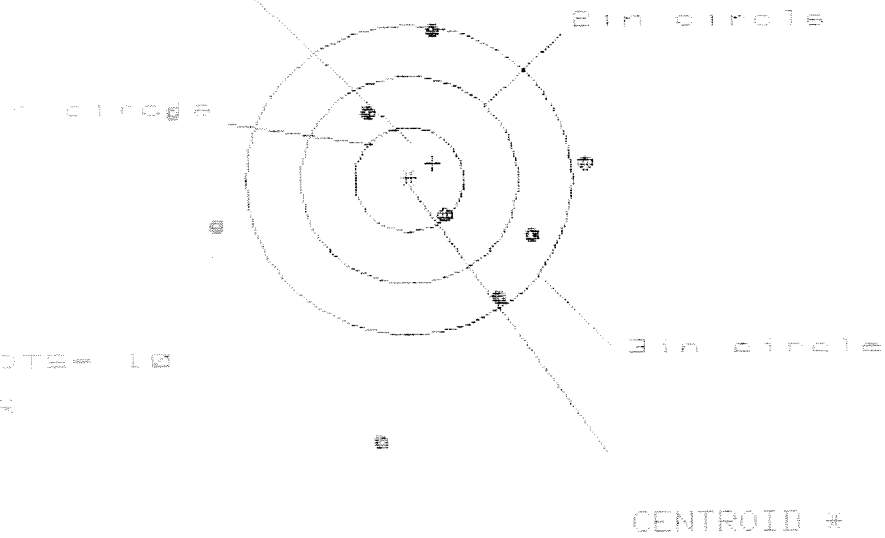
0	1	.269119
1	2	.267905
1	3	.301524
1	4	.406695
1	5	.250888

10 <----POA

15: -.0053
 11: -.0404
 15: .0408142

FILE: PATTERNING/CENTERFIRE_PATT/08085952

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

OF RINGS

1 1

2 1

3 1

4 1

5 1

6 1

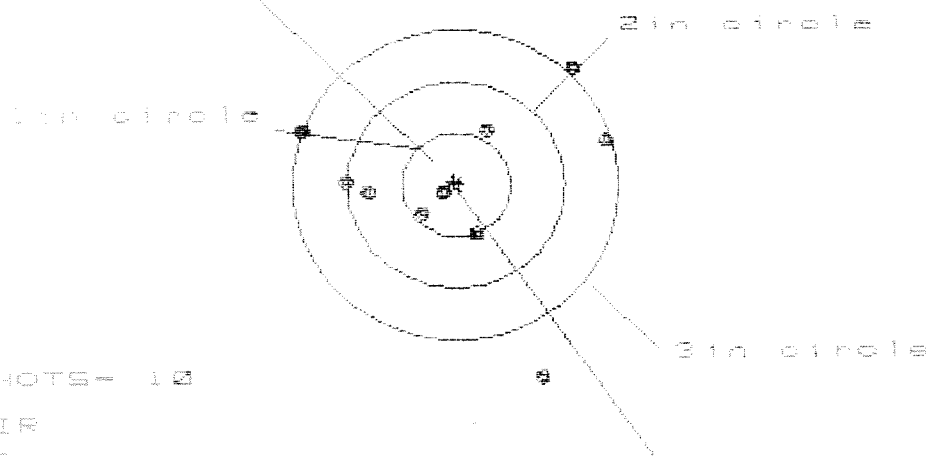
	10	9	8
1	1.568	1.547	1.276
2	2.106	-2.169	-2.045
3	1.040	1.753	1.883
4	2.1	-1.411	-1.361
5	1.177	-1.187	.884
6	-1.105	.132	.882
7	.873	.229	.117
8	.448	.559	.537
9	1.566	1.433	1.384
10	2.583	2.206	2.154
11	3.716	3.716	3.321
12	3.623	3.164	3.164
13	3.704	3.749	3.381
14			
15			
16			
17			
18			
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50			

23 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CB665952

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 4

HSE = 5.888

VSE = 5.884

GSE = 5.848

CENTROID *

PATTERN #

22

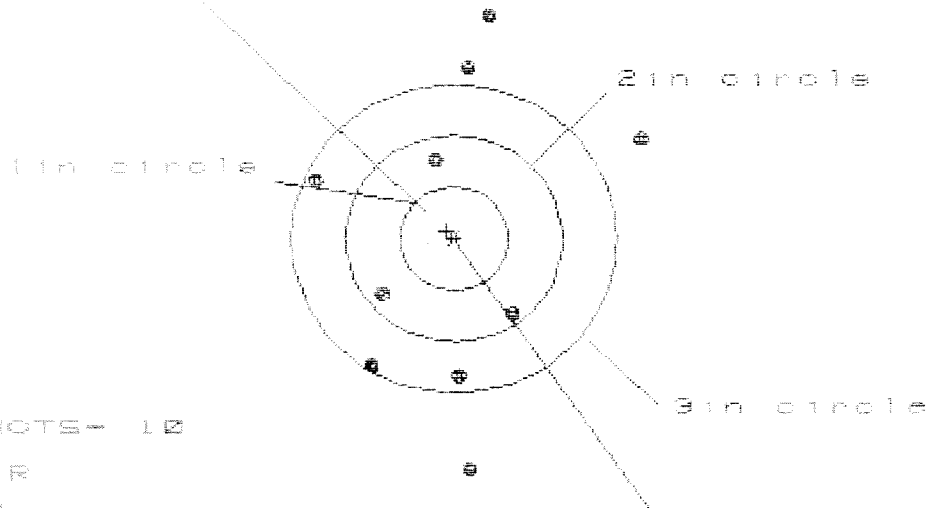
SHOTS (BEST OF)	10	9	8
MAXIMUM	1.381	1.467	1.689
MINIMUM	-1.455	-1.369	-1.227
MAXIMUM	1.178	.972	.456
MINIMUM	-1.856	-.634	-.512
DEVELOP	.018	-.068	-.210
DEVELOP	-.032	.174	.052
FOR TO CONTACT	.037	.187	.217
MIN SPREAD	.085	.225	.178
MAX SPREAD	.994	.891	.773
DEVELOP	2.009	1.498	1.643
DEVELOP	2.636	2.836	2.836
DEVELOP	3.034	1.686	.968
DEVELOP	2.243	2.837	2.837
FOR TO CONTACT		3	
FOR TO CONTACT		5	
FOR TO CONTACT		7	

30 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665952

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 5

3 in = 6

LE = 3.017

VE = 4.342

GE = 4.346

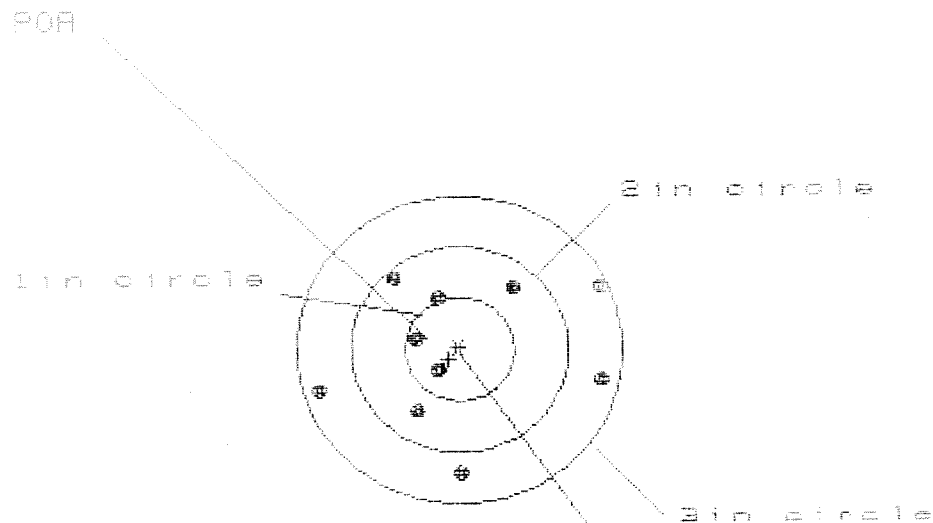
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.717	1.730	1.771
MINIMUM X	-1.300	-1.287	-1.246
MAXIMUM Y	3.142	1.897	1.618
MINIMUM Y	-2.200	-1.620	-1.382
CENTROID X	.069	.056	.015
CENTROID Y	-.069	.176	-.062
POA TO CENTROID in.	.097	.184	.063
MIN RADIOS	.741	.498	.727
MEAN RADIOS	1.470	1.379	1.288
MAX RADIOS	2.203	1.925	2.015
HORIZONTAL SPREAD	3.017	3.017	3.017
VERTICAL SPREAD	4.342	3.517	3.000
EXTREME SPREAD	4.346	3.588	3.354
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	6	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665952

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

US= 2.622

VS= 1.892

CS= 2.884

CENTROID *

PATTERN #

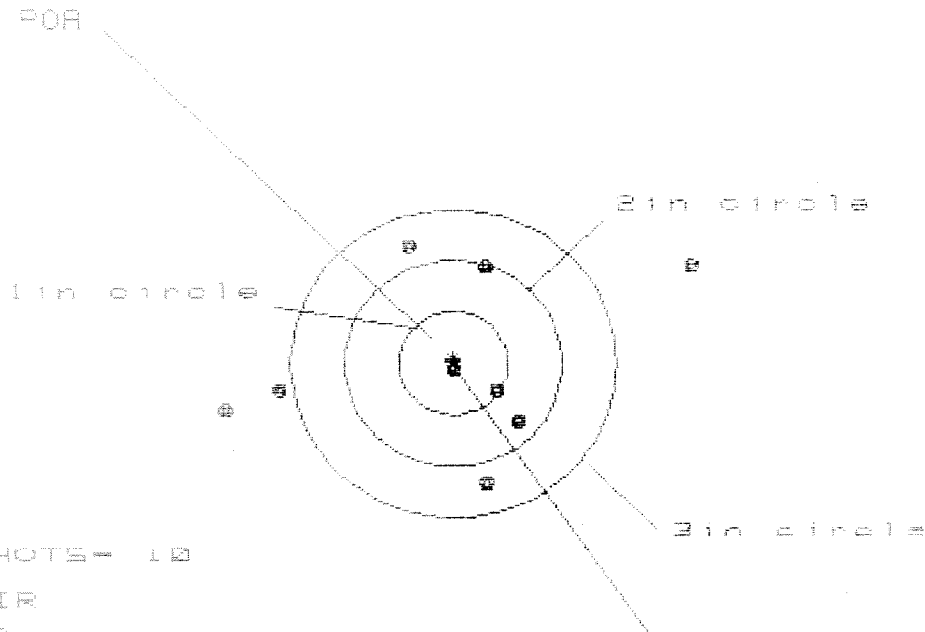
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.337	1.398	1.256
MINIMUM X	-1.285	-1.137	-1.560
MAXIMUM Y	.719	.788	.749
MINIMUM Y	-1.173	-1.104	-1.143
CENTROID X	.100	-.048	.094
CENTROID Y	.096	.027	.066
POA TO CENTROID in.	.139	.056	.114
MIN RADIUS	.227	.090	.202
MEAN RADIUS	.893	.792	.764
MAX RADIUS	1.473	1.413	1.279
HORIZONTAL SPREAD	2.622	2.535	1.816
VERTICAL SPREAD	1.892	1.892	1.892
EXTREME SPREAD	2.884	2.537	2.067
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

26 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665952

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 4

3 in = 7

HS= 4.333

VS= 2.234

QS= 4.535

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.189	1.882	1.644
MINIMUM X	-2.144	-1.991	-1.625
MAXIMUM Y	1.121	1.222	1.180
MINIMUM Y	-1.113	-1.012	-1.054
CENTROID X	.004	-.239	-.001
CENTROID Y	-.042	-.143	-.101
POA TO CENTROID (in.)	.042	.278	.101
MIN RADIUS	.091	.280	.048
MEAN RADIUS	1.147	1.055	.853
MAX RADIUS	2.370	1.930	1.642
HORIZONTAL SPREAD	4.333	2.783	2.269
VERTICAL SPREAD	2.234	2.234	2.234
EXTREME SPREAD	4.535	2.853	2.353
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665952
13 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.177341
1 TO 2	.173612
1 TO 3	.289278
1 TO 4	.24522
1 TO 5	.292181

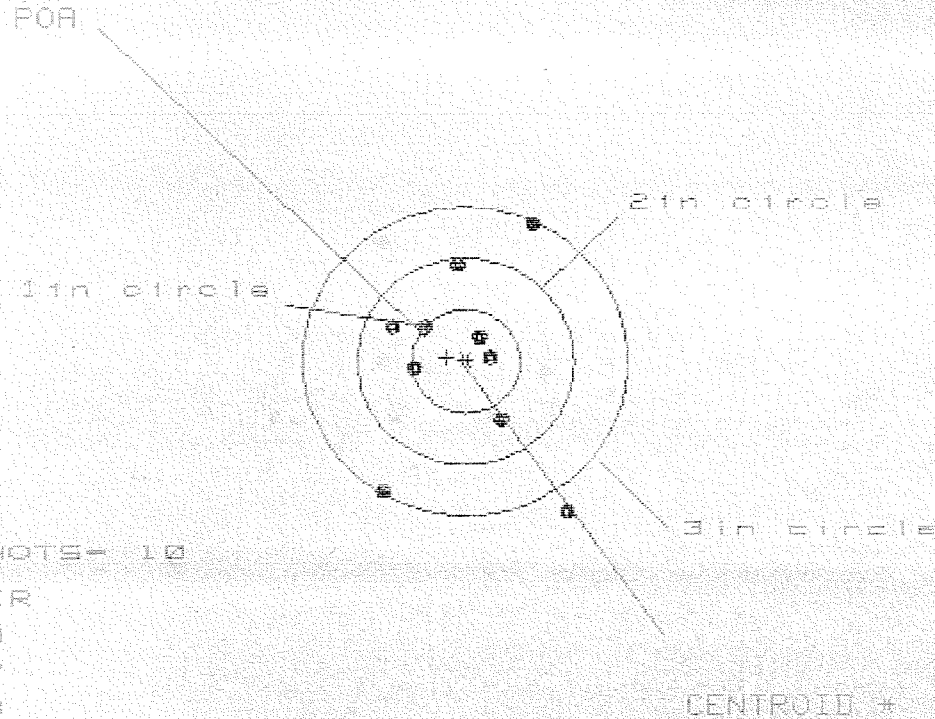
 ----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0160449
THE AMR FOR THIS RIFLE IS: .9206

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685952.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.640

VS= 2.853

GS= 2.999

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.911	.757	.542
MINIMUM X	-.729	-.627	-.533
MAXIMUM Y	1.384	1.220	.939
MINIMUM Y	-1.469	-1.441	-1.288
CENTROID X	.173	.071	-.023
CENTROID Y	-.039	.125	-.028
POA TO CENTROID IN.	.177	.144	.036
MIN RADIUS	.273	.268	.236
MEAN RADIUS	.868	.746	.664
MAX RADIUS	1.729	1.571	1.394
HORIZONTAL SPREAD	1.640	1.384	1.075
VERTICAL SPREAD	2.853	2.661	2.227
EXTREME SPREAD	2.999	2.999	2.321
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 7		
NUMBER IN THREE INCH CIRCLE	= 8		

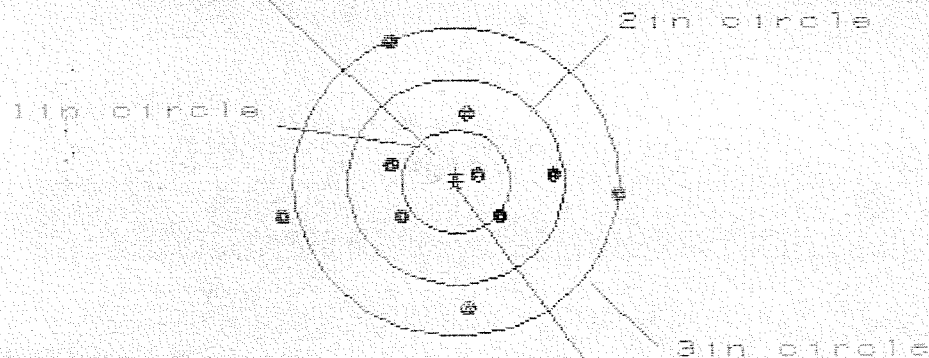
13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685952.1

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 3

HS= 3.055

VS= 2.668

GS= 3.063

CENTROID #

PATTERN #

SHOTS (BEST OF)

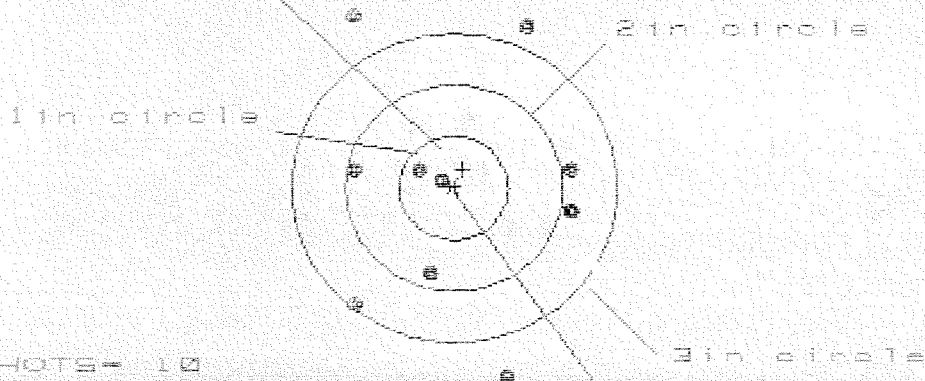
	10	9	8
MAXIMUM X	1.490	1.316	1.219
MINIMUM X	-1.565	-1.776	-1.826
MAXIMUM Y	1.402	1.367	1.775
MINIMUM Y	-1.266	-1.301	-1.130
CENTROID X	.002	.176	.273
CENTROID Y	-.069	-.034	-.205
POA TO CENTROID in.	.069	.179	.341
MIN RADIUS	.246	.074	.219
MEAN RADIUS	.941	.840	.744
MAX RADIUS	1.597	1.572	1.220
HORIZONTAL SPREAD	3.055	2.892	2.045
VERTICAL SPREAD	2.668	2.668	1.905
EXTREME SPREAD	3.063	2.765	2.067
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 3		

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665952.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 1.977

VS= 3.521

GS= 3.789

CENTROID +

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.054

.952

.998

MINIMUM X

-.923

-1.021

-1.975

MAXIMUM Y

1.727

1.736

1.536

MINIMUM Y

-1.794

-1.603

-1.099

CENTROID X

-.079

.023

-.024

CENTROID Y

-.179

-.370

-.170

POA TO CENTROID in. X

.195

.371

.172

MIN RADIUS

.086

.292

.135

MEAN RADIUS

1.118

1.037

.930

MAX RADIUS

1.953

1.838

1.667

HORIZONTAL SPREAD

1.977

1.973

1.973

VERTICAL SPREAD

3.521

3.339

2.635

EXTREME SPREAD

3.789

3.347

3.095

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

7

13 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665952.1

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.725

VS= 1.786

GS= 2.887

CENTROID *

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.276	.983	.819
MINIMUM X	-1.449	-1.387	-.652
MAXIMUM Y	1.105	1.197	1.192
MINIMUM Y	-.681	-.589	-.594
CENTROID X	-.050	-.192	-.028
CENTROID Y	.063	-.029	-.024
POA TO CENTROID in.	.080	.194	.037
MIN RADIUS	.216	.333	.199
MEAN RADIUS	.837	.746	.670
MAX RADIUS	1.518	1.308	1.196
HORIZONTAL SPREAD	2.725	2.290	1.471
VERTICAL SPREAD	1.786	1.786	1.786
EXTREME SPREAD	2.887	2.342	1.870
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

FILE:/PATTERNING/CENTERFIRE_PATT/C6665952.1

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 = 10

HS= 2.374

VS= 1.630

GS= 2.609

CENTROID *

PATTERN #

SHOTS (BEST OF)

	10	9	8
MAXIMUM X	1.313	.863	.743
MINIMUM X	-1.056	-.909	-.588
MAXIMUM Y	.715	.783	.680
MINIMUM Y	-.915	-.847	-.950
CENTROID X	.034	-.113	.001
CENTROID Y	.218	.150	.253
POA TO CENTROID in.	.221	.188	.253
MIN RADIUS	.312	.374	.270
MEAN RADIUS	.839	.770	.682
MAX RADIUS	1.453	1.225	1.117
HORIZONTAL SPREAD	2.374	1.772	1.337
VERTICAL SPREAD	1.630	1.630	1.630
EXTREME SPREAD	2.808	1.859	1.700
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		