

BARBER - M24 0104587

FOEH

UPC



0 47700 25716 7

66655969

CAPACITY*
*INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665969

ORDER NO.

5716

20

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



5716 C6665969

ORDER 5716

MODEL 700™ M24

UPC



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ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665969

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		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	Kcd
	Magnaflux Bolt	OCT	4 1991	Kcd
615	Rollmark Caliber	OCT	4 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-27-91	KB
	Apply Coating (Bolt)		10-27-91	KB
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	KH
	C) Inspect Ejector Hole for Chamfer		11/11/91	KH
	D) Oil Firing Pin Ass'y		11/11/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-12-91	KH

op. #	BARBER M24 0104591	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-12-91	JK
	G) Safety Off Force	3	3	3			11-12-91	JK
	H) Trigger Pull Test & Retainability						11-12-91	JK
	I) Firing Pin Indent	1020	10205	10205			11-12-91	JK
	J) Assemble Stock						11-12-91	JK
	K) Assemble Swivel Studs						11-26-91	JK
	L) Attach Front and Rear Sight Assemblies						11-12-91	JK
	M) Iron Sight Alignment						11-12-91	JK
	N) Detach Front & Rear Sights & place in numbered container						11-12-91	JK
	O) Attach Scope to Rifle						11-12-91	JK
	P) Detach & Attach Scope 20 Times						11-12-91	JK
640	Gallery Target & Test						11-21-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11-21-91	KT
655	Final Inspection							
	A) Headspace						11-26-91	JK
	B) Trigger Pull	260	261	258	264	261	11-22-91	JK
	C) Function						11-26-91	JK
660	Pack						12-11-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C-665969

DATE 11-12-91

TESTER JFL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.41	2.44	260	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.39	2.30	261	
PULL #3	2.40	2.23	2.28	258	
PULL #4	2.40	2.20	2.20	264	
PULL #5	2.41	2.31	2.22	261	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.39		
PULL #2	3.37	3.28		
PULL #3	3.41	3.44		
PULL #4	3.38	3.33		
PULL #5	3.43	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.54		4.60
PULL #2	4.25	4.55		4.61
PULL #3	4.62	4.56		4.60
PULL #4	4.57	4.57		4.60
PULL #5	4.55	4.54		4.63
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665969
22 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.0854283
1 TO	2	.224199
1 TO	3	.176377
1 TO	4	.157204
1 TO	5	.191708

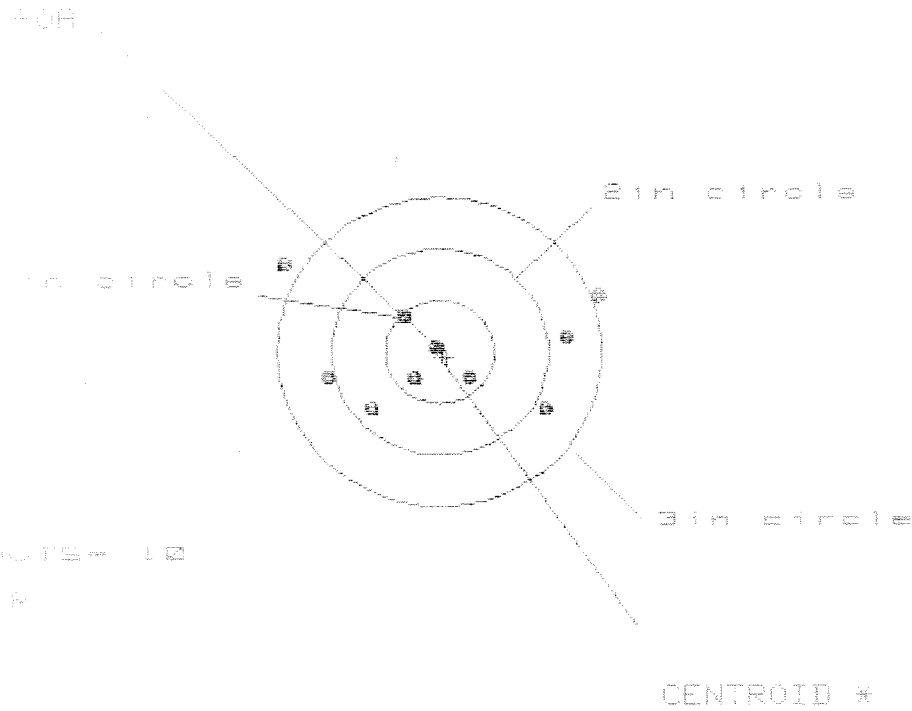
39 (----POR

0.000000 IS: -.0154
0.000000 IS: -.0208
0.000000 RIFLE IS: .0258885

27 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665969

CENTERFIRE PATTERNS # 1



* 10 DEGREE = 10

* 10 DEGREE = 10

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10

9

8

1.437

1.274

1.136

-1.461

-1.216

-1.057

.640

.653

.539

-.137

-.469

-.307

.094

.096

-.063

.011

-.040

-.122

.017

.104

.137

.011

.125

.236

.011

.176

.692

.011

1.432

1.174

.011

2.498

2.193

.011

1.122

.926

.011

2.632

2.231

0

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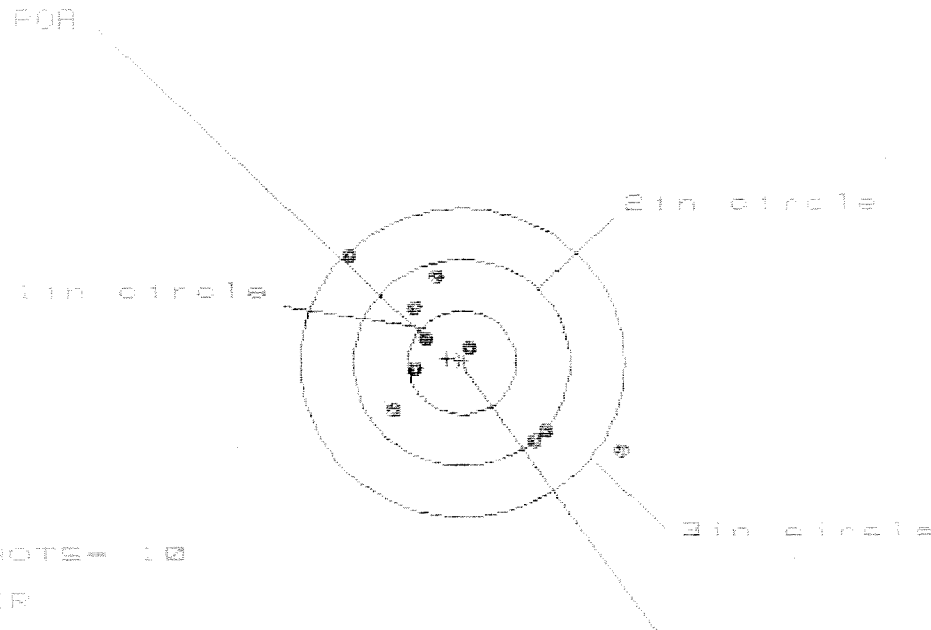
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21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685363

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 4

3 in = 6

MEAN = 2.551

STD = 1.685

CEX = 3.172

CENTROID *

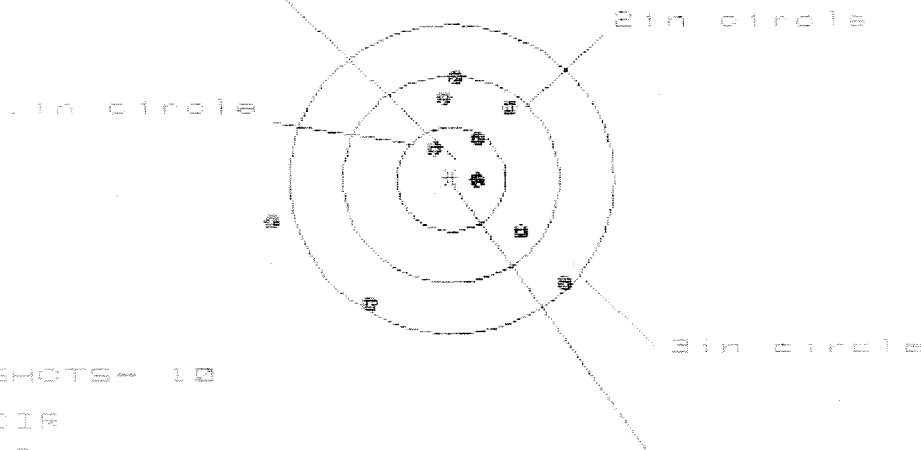
PATTERN #		10	9	8
SHOTS (BEST OF)		10	9	8
MAXIMUM		1.564	.902	.792
MINIMUM		-1.047	-.880	-.544
MEAN		1.064	.973	.876
STD		.821	.829	.708
CEX		.137	-.030	.079
MEAN		-.040	.051	-.070
STD		.142	.060	.106
MEAN		.103	.176	.167
MEAN		.040	.703	.645
MEAN		1.714	1.311	1.041
MEAN		2.551	1.782	1.337
MEAN		1.685	1.602	1.584
MEAN		3.172	2.511	1.814
MEAN	2 in circle		3	
MEAN	3 in circle		7	
MEAN	4 in circle		9	

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6885969

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HE = 2.871

VE = 2.193

GE = 2.735

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	.813	.531
MINIMUM X	-1.672	-.927	-.825
MAXIMUM Y	1.013	.965	.831
MINIMUM Y	-1.186	-1.228	-1.362
CENTROID X	-.237	-.051	-.153
CENTROID Y	.086	.054	.189
POA TO CENTROID DIST	.237	.075	.242
MIN RANGE	.242	.087	.255
MAX RANGE	.906	.771	.677
MAX RANGE	1.727	1.539	1.592
HORIZONTAL SPREAD	2.671	1.740	1.356
VERTICAL SPREAD	2.193	2.193	2.193
EXTREME SPREAD	2.735	2.318	2.318
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	9	

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08865969

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

CENTROID #

HE = 2.821

VE = 3.387

GE = 3.633

PATTERN #

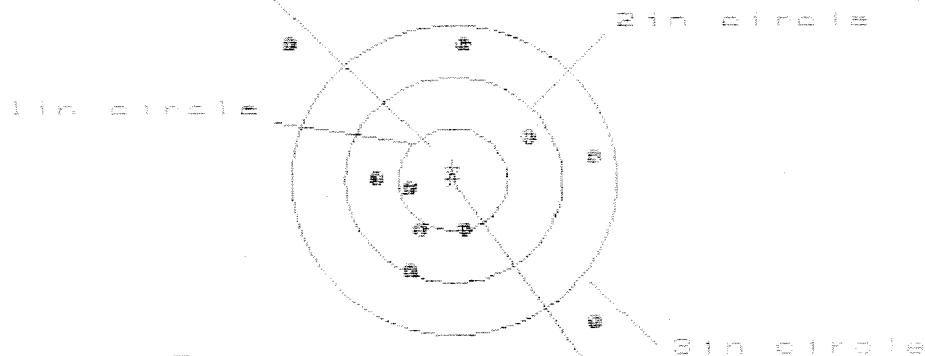
	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.028	.930	.968
MINIMUM X	-1.028	-1.126	-1.068
MAXIMUM Y	1.631	1.150	.952
MINIMUM Y	-1.766	-1.585	-1.163
CENTROID X	.001	.179	.141
CENTROID Y	.000	-.101	.017
POA TO CENTROID INCH	.001	.255	.142
MIN RADIOS	.391	.455	.453
MEAN RADIOS	1.129	1.029	.954
MAX RADIOS	1.854	1.614	1.220
HORIZONTAL SPREAD	2.056	2.056	2.056
VERTICAL SPREAD	3.397	2.735	2.115
EXTREME SPREAD	3.633	2.903	2.185
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

22 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66659B3

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 6

ME = 2.724

VE = 2.785

GE = 2.886

CENTROID #

PATTERN #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.252	1.088	1.216
MINIMUM X	-1.472	-1.840	-1.704
MAXIMUM Y	1.359	1.434	1.275
MINIMUM Y	-1.426	-1.275	-1.898
CAUS	.009	.173	.037
CENTROID	-1.133	-1.274	-1.115
POB	.123	.324	.129
MIN X	.463	.366	.491
MEAN X	1.048	.937	.827
MAX X	2.004	1.676	1.276
HORIZONTAL SPREAD	2.734	1.928	1.928
VERTICAL SPREAD	2.785	2.789	2.173
EXTENSIVE SPREAD	3.836	2.954	2.221
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	6	6	6
NUMBER IN THREE INCH CIRCLE =	8	8	8