

FORM

UPC



0 47700 25716 7

C6665977

CAPACITY*
*INCLUDES 1 IN CHAMBER

BARBER - M24 0104684

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

BARBER - M24 0104685

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665977

ORDER NO.

5716

20

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



5716 C6665977

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665977

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KK
600	Proof		9/30/91	KK
607	Check Headspace		9/30/91	KK
610	Dis-assemble Gun		9/30/91	KK
612	Magnaflux Barrel Action	OCT	8 1991	KR
	Magnaflux Bolt	OCT	8 1991	KR
615	Rollmark Caliber	OCT	8 1991	LS
617	Drill and Tap Sight Holes	OCT	8 1991	LS
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/12/91	KK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/12/91	KK
	C) Inspect Ejector Hole for Chamfer		11/12/91	KK
	D) Oil Firing Pin Ass'y		11/12/91	KK
	E) Adjust Trigger Pull to Min Setting and Stake		12-13-91	JK

op. #	BARBER - M24 0104687 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-13-91	JK
	G) Safety Off Force	3	3	3			11-13-91	JK
	H) Trigger Pull Test & Retainability						11-13-91	JK
	I) Firing Pin Indent	1020	020	020			11-13-91	JK
	J) Assemble Stock						11-13-91	JK
	K) Assemble Swivel Studs						11-21-91	JK
	L) Attach Front and Rear Sight Assemblies						11-13-91	JK
	M) Iron Sight Alignment						11-13-91	JK
	N) Detach Front & Rear Sights & place in numbered container						11-13-91	JK
	O) Attach Scope to Rifle						11-13-91	JK
	P) Detach & Attach Scope 20 Times						11-13-91	JK
640	Gallery Target & Test						11-19-91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11-19-91	KT
655	Final Inspection							
	A) Headspace						11-21-91	JK
	B) Trigger Pull	252	262	273	274	274	11-20-91	JK
	C) Function						11-21-91	JK
660	Pack						12-19-91	JK

TIME TAG

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C-6665977DATE 11-13-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.56	2.49	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.54	2.50	2.62	
PULL #3	2.51	2.58	2.54	2.73	
PULL #4	2.53	2.52	2.51	2.74	
PULL #5	2.55	2.56	2.58	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.60		
PULL #2	3.48	3.55		
PULL #3	3.41	3.50		
PULL #4	3.58	3.53		
PULL #5	3.59	3.60		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.45		4.53
PULL #2	4.27	4.41		4.53
PULL #3	4.20	4.55		4.53
PULL #4	4.58	4.48		4.55
PULL #5	4.49	4.42		4.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665977
20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.115261
1 TO	2	.124523
1 TO	3	.231294
1 TO	4	.140346
1 TO	5	.0487545

92 <----POA

- THIS RIFLE IS: 10512
- THIS RIFLE IS: .1
- THIS RIFLE IS: 10512

1993

20 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685977

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIRCLES

1in = 3

2in = 8

3in = 8

HS = 2.204

VS = 2.216

GS = 2.420

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.370	.622
MINIMUM X	-.811	-.834	-.662
MAXIMUM Y	1.681	.994	.339
MINIMUM Y	-.535	-.348	-.224
CENTROID X	.082	.105	-.067
CENTROID Y	-.081	-.268	-.392
POA Y - CENTROID IN.	.115	.288	.398
MIN. FALLING	.283	.270	.187
MEAN FALLING	.787	.633	.463
MAX. FALLING	1.694	1.693	.679
HORIZONTAL SPREAD	2.204	2.204	1.284
VERTICAL SPREAD	2.216	1.342	.563
EXTREM. SPREAD	2.420	2.420	1.315
NUMBER ONE INCH CIRCLE =	3		
NUMBER TWO INCH CIRCLE =	8		
NUMBER THREE INCH CIRCLE =	8		

28 Nov 1991

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CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.439

VS= 2.565

GS= 2.568

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.609	.599	.569
MINIMUM X	:	-.830	-.840	-.870
MAXIMUM Y	:	1.397	.813	.686
MINIMUM Y	:	-1.168	-1.012	-.591
CENTROID X	:	.167	.177	.207
CENTROID Y	:	-.172	-.328	-.201
POA TO CENTROID in.	:	.240	.373	.288
MIN RADIUS	:	.221	.264	.184
MEAN RADIUS	:	.751	.675	.610
MAX RADIUS	:	1.400	1.078	1.007
HORIZONTAL SPREAD	:	1.439	1.439	1.439
VERTICAL SPREAD	:	2.565	1.825	1.277
EXTREME SPREAD	:	2.568	1.885	1.827
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

28 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685377

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 2

3 in = 7

HS = 2.241

VS = 3.444

CS = 3.513

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.234
MINIMUM X	-1.007
MAXIMUM Y	2.070
MINIMUM Y	-1.374
CENTROID X	-1.122
CENTROID Y	-1.190
POA TO CENTROID in.	.226
MIN RADIUS	.696
MEAN RADIUS	1.340
MAX RADIUS	2.150
HORIZONTAL SPREAD	2.241
VERTICAL SPREAD	3.444
EXTREME SPREAD	3.513
NUMBER IN ONE INCH CIRCLE	0
NUMBER IN TWO INCH CIRCLE	2
NUMBER IN THREE INCH CIRCLE	7

28 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B65377

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.665

VS= 2.787

GS= 2.790

PATTERN #

4

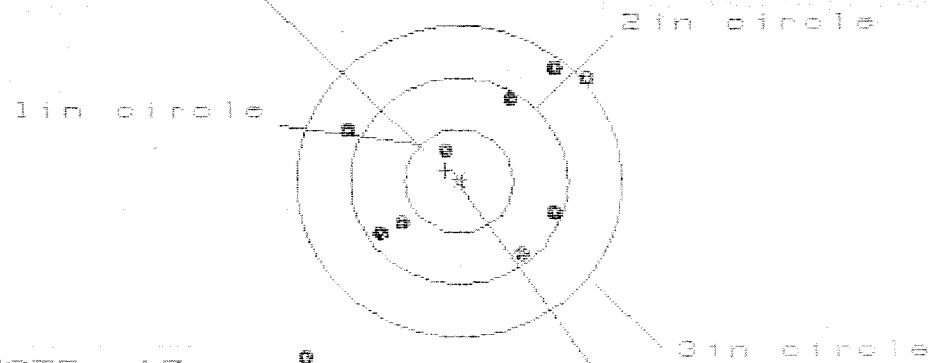
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	1.088	.934
MINIMUM X	:	-.533	-.577	-.441
MAXIMUM Y	:	1.622	1.123	1.064
MINIMUM Y	:	-1.165	-.984	-1.043
CENTROID X	:	.003	.047	-.089
CENTROID Y	:	-.197	-.378	-.319
POA TO CENTROID in.	:	.197	.381	.331
MIN RADIUS	:	.494	.601	.584
MEAN RADIUS	:	.998	.913	.866
MAX RADIUS	:	1.670	1.186	1.214
HORIZONTAL SPREAD	:	1.665	1.665	1.375
VERTICAL SPREAD	:	2.787	2.107	2.107
EXTREME SPREAD	:	2.790	2.279	2.279
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

20 Nov 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06665977

CENTERFIRE PATTERNS # 5

POR



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.606

VS = 2.771

GS = 3.771

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.134
MINIMUM X	-1.472
MAXIMUM Y	1.059
MINIMUM Y	-1.712
CENTROID X	.126
CENTROID Y	-.102
POR TO CENTROID (in.)	.162
MIN RADIUS	.277
MEAN RADIUS	1.089
MAX RADIUS	2.258
HORIZONTAL SPREAD	2.606
VERTICAL SPREAD	2.771
EXTREME SPREAD	3.771
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8