

M240104839

FORM

UPC



0 47700 25716 7

66665993

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER M24 M2400104800

ORDER NO.

5716

MODEL 700 TM M24

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24****SERIAL NO.**
C6665993

20

ORDER NO.
5716

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



5716 C6665993

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665993

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	YK
600	Proof		9/30/91	YK
607	Check Headspace		9/30/91	YK
610	Dis-assemble Gun		9/30/91	YK
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	YK
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/14/91	YK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/14/91	YK
	C) Inspect Ejector Hole for Chamfer		11/14/91	YK
	D) Oil Firing Pin Ass'y		11/14/91	YK
	E) Adjust Trigger Pull to Min Setting and Stake		11-15-91	YK

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11/15/91	JK
	G) Safety Off Force	3	3	3			11/15/91	JK
	H) Trigger Pull Test & Retainability						11-15-91	JK
	I) Firing Pin Indent	.0205	.0205	.0205			11/15/91	JK
	J) Assemble Stock						11/22/91	JK
	K) Assemble Swivel Studs						11-22-91	AC
	L) Attach Front and Rear Sight Assemblies						11/22/91	JK
	M) Iron Sight Alignment						11/22/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/22/91	JK
	O) Attach Scope to Rifle						11/22/91	JK
	P) Detach & Attach Scope 20 Times						11/22/91	JK
640	Gallery Target & Test						11-25-91	DH
	A) Time						11-25-91	DH
	B) Malfunctions						11-25-91	DH
	C) Pierced Primers						11-25-91	DH
	D) Optical Clarity of Scope						11-25-91	DH
645	Inspect for Live Ammo						11-25-91	DH
655	Final Inspection						11-27-91	AC
	A) Headspace						11-27-91	AC
	B) Trigger Pull	2.43	2.51	2.54	2.57	2.55	11-26-91	DH
	C) Function						11-27-91	AC
660	Pack						12-18-91	N

I.I. STAG

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

SERIAL NO C-6665993DATE 11-15-81TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.29	2.41	2.27	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.33	2.30	2.51	
PULL #3	2.27	2.33	2.35	2.54	
PULL #4	2.26	2.31	2.44	2.57	
PULL #5	2.42	2.29	2.28	2.55	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.48		
PULL #2	3.51	3.46		
PULL #3	3.55	3.48		
PULL #4	3.43	3.45		
PULL #5	3.44	3.48		
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	4.48		4.25
PULL #2	4.31	4.57		4.28
PULL #3	4.36	4.60		4.22
PULL #4	4.45	4.26		4.32
PULL #5	4.46	4.25		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665993
25 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.124579
1 TO	2	.101843
1 TO	3	.255877
1 TO	4	.286439
1 TO	5	.437413

45
90

<----POA

WE FOR THIS RIFLE IS: -.0158
FOR THIS RIFLE IS: .0376
RADIUS FOR THIS RIFLE IS: .0407948
. . . .9768

23 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665893

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIRCLE

1in = 1

2in = 5

3in = 8

HM = 2.935

VM = 2.207

GM = 2.169

PATTERN #	1	2	3
SHOTS - BEST OF	10	9	8
WIND	1.323	1.144	.995
WIND	-1.612	-1.191	-.836
WIND	1.046	.970	.816
WIND	-1.161	-1.237	-.750
WIND	.084	.263	.412
WIND	-.092	-.016	.138
WIND	.125	.264	.435
WIND	.453	.361	.284
WIND	1.001	.883	.756
WIND	1.751	1.717	1.086
WIND	2.935	2.335	1.831
WIND	2.207	2.207	1.566
WIND	2.169	2.872	1.872
WIND		1	
WIND		5	
WIND		8	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685993

CENTERFIRE PATTERNS

2

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 8

HS= 2.379

VS= 2.906

GS= 3.064

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.873

.824

.630

MINIMUM X

-1.506

-1.555

-.969

MAXIMUM Y

1.400

1.232

1.158

MINIMUM Y

-1.506

-1.033

-1.107

CENTROID X

-.012

.037

.231

CENTROID Y

-.058

.110

.184

POR TO CENTROID in.

.059

.116

.295

MIN RADIUS

.670

.528

.477

MEAN RADIUS

1.030

.939

.825

MAX RADIUS

1.569

1.665

1.194

HORIZONTAL SPREAD

2.379

2.379

1.599

VERTICAL SPREAD

2.906

2.265

2.265

EXTREME SPREAD

3.064

2.738

2.271

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

8

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6565953

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.570

VS= 2.453

GS= 3.020

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.369	1.238	1.117
MINIMUM X	-1.202	-1.332	-1.453
MAXIMUM Y	1.272	1.140	.939
MINIMUM Y	-1.181	-1.312	-1.169
CENTROID X	-.164	-.033	.088
CENTROID Y	-.155	-.024	-.167
POA TO CENTROID in.	.226	.041	.188
MIN RADIUS	.185	.239	.273
MEAN RADIUS	1.025	.927	.833
MAX RADIUS	1.669	1.493	1.488
HORIZONTAL SPREAD	2.570	2.570	2.570
VERTICAL SPREAD	2.453	2.452	2.108
EXTREME SPREAD	3.020	2.683	2.683
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08685993

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.025

VS= 2.181

GS= 2.182

CENTROID #

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.295	.900	.876
MINIMUM X	-.731	-.587	-.611
MAXIMUM Y	1.098	1.136	.631
MINIMUM Y	-1.083	-1.045	-.903
CENTROID X	-.090	-.234	-.210
CENTROID Y	.148	.110	-.032
POA TO CENTROID in.	.174	.259	.212
MIN RADIUS	.244	.097	.133
MEAN RADIUS	.715	.606	.532
MAX RADIUS	1.341	1.153	1.080
HORIZONTAL SPREAD	2.026	1.487	1.487
VERTICAL SPREAD	2.181	2.181	1.534
EXTREME SPREAD	2.182	2.182	1.052
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

25 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG665993

CENTERFIRE PATTERNS # 5

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HE= 1.853

VS= 3.996

GS= 4.059

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.097	1.140	.606
MINIMUM X	-.766	-.723	-.580
MAXIMUM Y	2.375	1.345	1.175
MINIMUM Y	-1.621	-1.357	-.981
CENTROID X	.103	.060	-.083
CENTROID Y	.345	.081	.251
FOR TO CENTROID in.	.360	.101	.264
MIN RADIUS	.175	.304	.358
MEAN RADIUS	1.113	.940	.831
MAX RADIUS	2.406	1.773	1.311
HORIZONTAL SPREAD	1.863	1.863	1.186
VERTICAL SPREAD	3.996	2.702	2.156
EXTREME SPREAD	4.059	3.282	2.461
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		