

BARBER - M24 0105158

FORM

UPC



C66666122

*INCLUDES 1 IN CHAMBER

CAPACITY*

LENGTH

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700 TM M24****SERIAL NO.****C6666122****ORDER NO.****5716****20**

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



5716 C6666122

ORDER 5716MODEL 700 TM M24**UPC**

0 47700 25716 7

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0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6666122

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	DS
617	Drill and Tap Sight Holes	OCT	8 1991	LB
618	Polish Barrel		10/4/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	YK
	Apply Coating (Bolt)			YK
625	Final Assembly A) Clean inside of Bolt Assembly		11/7/91	YK
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/7/91	YK
	C) Inspect Ejector Hole for Chamfer		11/7/91	YK
	D) Oil Firing Pin Ass'y		11/7/91	YK
	E) Adjust Trigger Pull to Min Setting and Stake		11/8/91	YK

op. #	BARBER - M24 0105162 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/8/91	JK
	G) Safety Off Force	3	3	3			11-8-91	JK
	H) Trigger Pull Test & Retainability						11-8-91	JK
	I) Firing Pin Indent	10205	10205	10205			11-8-91	JK
	J) Assemble Stock						11/11/91	JK
	K) Assemble Swivel Studs						11-21-91	JK
	L) Attach Front and Rear Sight Assemblies						11/11/91	JK
	M) Iron Sight Alignment						11/11/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	JK
	O) Attach Scope to Rifle						11/11/91	JK
	P) Detach & Attach Scope 20 Times						11/11/91	JK
640	Gallery Target & Test						11-19-91	DH
	A) Time						11-19-91	DH
	B) Malfunctions						11-19-91	DH
	C) Pierced Primers						11-19-91	DH
	D) Optical Clarity of Scope						11-19-91	DH
645	Inspect for Live Ammo						11-19-91	DH
655	Final Inspection							
	A) Headspace						11-21-91	JK
	B) Trigger Pull	2.58	2.59	2.58	2.59	2.59	11-19-81	DH
	C) Function						11-21-91	JK
660	Pack						12-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6666122

DATE 11-8-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.47	2.50	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.37	2.43	2.59	
PULL #3	2.42	2.39	2.48	2.58	
PULL #4	2.39	2.39	2.38	2.59	
PULL #5	2.39	2.48	2.49	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.46		
PULL #2	3.33	3.46		
PULL #3	3.41	3.47		
PULL #4	3.25	3.43		
PULL #5	3.40	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.44		4.42
PULL #2	4.35	4.44		4.42
PULL #3	4.35	4.31		4.48
PULL #4	4.40	4.49		4.39
PULL #5	4.38	4.48		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666122
19 Nov 1991

CENTROIDAL DISTANCES

0	TO	1	.334175
1	TO	2	.222423
1	TO	3	.371131
1	TO	4	.503271
1	TO	5	.543346

$\mu_{x|y}$ <----POA

SE X-COORDINATE FOR THIS RIFLE IS: -.1346
Y-COORDINATE FOR THIS RIFLE IS: -.0654
AVERAGE POI RADIUS FOR THIS RIFLE IS: .149647
THIS RIFLE IS: .0618

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86686122

CENTERFIRE PATTERNS # 1

POA

11n circle

21n circle

31n circle

CENTROID *

OF SHOTS = 10

IN CIR

11n = 2

21n = 6

31n = 9

HS = 2.738

VS = 2.326

GS = 3.129

PATTERN # :

1

SHOTS (BEST OF) :

10

9

8

MAXIMUM X :

1.240

1.073

1.073

MINIMUM X :

-1.498

-.706

-.706

MAXIMUM Y :

.956

.827

.669

MINIMUM Y :

-1.371

-1.264

-.689

CENTROID X :

-.333

-.166

-.166

CENTROID Y :

.028

-.079

.079

POA TO CENTROID in. :

.334

.184

.184

11n circle :

.311

.450

.408

21n circle :

.937

.857

.781

31n circle :

1.777

1.264

1.237

Horizontal SPREAD :

2.738

1.779

1.779

Vertical SPREAD :

2.326

2.091

1.358

Overall SPREAD :

3.129

2.149

2.058

ONE INCH CIRCLE =

2

TWO INCH CIRCLE =

6

THREE INCH CIRCLE =

9

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666122

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.933

VS= 1.685

GS= 2.045

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.087	1.118	1.033
MINIMUM X	-.846	-.725	-.810
MAXIMUM Y	.732	.756	.839
MINIMUM Y	-.953	-.929	-.846
CENTROID X	-.157	-.278	-.193
CENTROID Y	.164	.140	.057
POR TO CENTROID in.	.227	.311	.201
MIN RADIUS	.097	.117	.185
MEAN RADIUS	.825	.782	.768
MAX RADIUS	1.109	1.131	1.037
HORIZONTAL SPREAD	1.933	1.843	1.843
VERTICAL SPREAD	1.685	1.685	1.685
EXTREME SPREAD	2.045	1.978	1.861
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 10		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666122

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.052

VS = 2.511

GS = 3.192

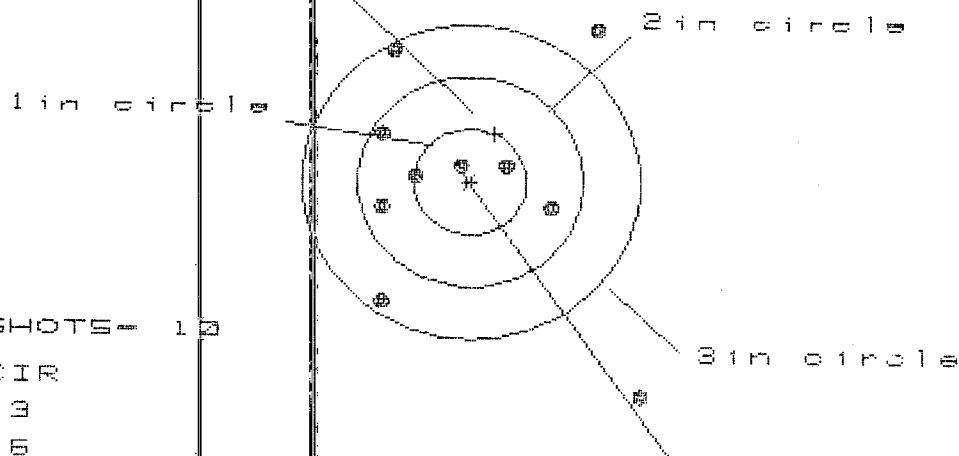
PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.892	.773	.756
MINIMUM X	-1.160	-1.279	-1.183
MAXIMUM Y	1.168	1.019	.792
MINIMUM Y	-1.343	-.823	-.696
CENTROID X	-.140	-.021	-.117
CENTROID Y	-.289	-.140	-.267
POR TO CENTROID in.	.321	.141	.292
MIN RADIUS	.249	.438	.281
MEAN RADIUS	.916	.814	.745
MAX RADIUS	1.722	1.304	1.189
HORIZONTAL SPREAD	2.052	2.052	1.939
VERTICAL SPREAD	2.511	1.842	1.488
EXTREME SPREAD	3.192	2.413	2.022
NUMBER IN ONE INCH CIRCLE	1		
NUMBER IN TWO INCH CIRCLE	6		
NUMBER IN THREE INCH CIRCLE	9		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666122

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 2.324

VS= 3.470

GS= 3.887

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.492	1.251	1.032
MINIMUM X	-1.832	-.666	-.510
MAXIMUM Y	1.477	1.256	1.166
MINIMUM Y	-1.993	-1.361	-1.204
CENTROID X	-.214	-.380	-.536
CENTROID Y	-.461	-.240	-.397
POA TO CENTROID in.	.509	.449	.667
MIN RADIUS	.192	.096	.128
MEAN RADIUS	1.067	.865	.730
MAX RADIUS	2.490	1.773	1.307
HORIZONTAL SPREAD	2.324	1.917	1.542
VERTICAL SPREAD	3.470	2.617	2.370
EXTREME SPREAD	3.887	3.243	2.375
NUMBER IN ONE INCH CIRCLE	3		
NUMBER IN TWO INCH CIRCLE	6		
NUMBER IN THREE INCH CIRCLE	8		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8686122

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID +

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.051

VS= 3.148

GS= 3.465

PATTERN #	5	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.903	.825	.643
MINIMUM X	-1.148	-1.226	-1.123
MAXIMUM Y	1.267	1.058	1.131
MINIMUM Y	-1.881	-1.363	-1.240
CENTROID X	.171	.249	.146
CENTROID Y	.231	.440	.317
POA TO CENTROID in.	.287	.505	.349
MIN RADIUS	.494	.396	.500
MEAN RADIUS	1.064	.937	.892
MAX RADIUS	2.006	1.466	1.397
HORIZONTAL SPREAD	2.051	2.051	1.766
VERTICAL SPREAD	3.148	2.421	2.421
EXTREME SPREAD	3.465	2.676	2.676
NUMBER IN ONE INCH CIRCLE	1		
NUMBER IN TWO INCH CIRCLE	5		
NUMBER IN THREE INCH CIRCLE	9		