

BARBER - M24 0066421

FORM

UPC



0 47700 25716 2

C6649211

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0066421 M2400066460

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700TM M24****SERIAL NO.****C6649211****ORDER NO.****5716**

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

20



5716 C6649211

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649211

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 0 1991	GL
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/8-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		12-10-91	JP

op. #	BARBER M24 0066425	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.0715	4.0723	3.74			12/10/91	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/10/91	WLB
	H) Trigger Pull Test & Retainability						12-10-91	JH
	I) Firing Pin Indent	.0715	.073	.072			12/10/91	WLB
	J) Assemble Stock						12/10/91	KH
	K) Assemble Swivel Studs						12-12-91	JH
	L) Attach Front and Rear Sight Assemblies						12/10/91	KH
	M) Iron Sight Alignment						12/10/91	KH
	N) Detach Front & Rear Sights & place in numbered container						12/10/91	KH
	O) Attach Scope to Rifle						12/10/91	KH
	P) Detach & Attach Scope 20 Times						12/10/91	KH
640	Gallery Target & Test						12/11/91	KT
	A) Time							KH
	B) Malfunctions							KH
	C) Pierced Primers							KH
	D) Optical Clarity of Scope							KH
645	Inspect for Live Ammo						12/11/91	KT
655	Final Inspection							
	A) Headspace						12-12-91	JH
	B) Trigger Pull	2.15	2.23	2.17	2.19	2.21	12-12-91	JH
	C) Function						12-12-91	JH
660	Pack						12-12-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649211DATE 12-10-81TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.69	2.39	2.44	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.34	2.36	2.23	
PULL #3	2.67	2.48	2.31	2.17	
PULL #4	2.22	2.48	2.45	2.19	
PULL #5	2.32	2.48	2.44	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.56	3.48		
PULL #2	3.59	3.51		
PULL #3	3.44	3.55		
PULL #4	3.49	3.43		
PULL #5	3.51	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.59	4.53		4.67
PULL #2	4.52	4.48		4.59
PULL #3	4.55	4.56		4.60
PULL #4	4.54	4.64		4.60
PULL #5	4.52	4.62		4.64
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649211
11 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.238537
1 TO 2	.49449
1 TO 3	.126696
1 TO 4	.239019
1 TO 5	.142302

2-5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0772
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0773749
THE AMR FOR THIS RIFLE IS: .8794

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649211

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.793

VS= 2.293

GS= 2.349

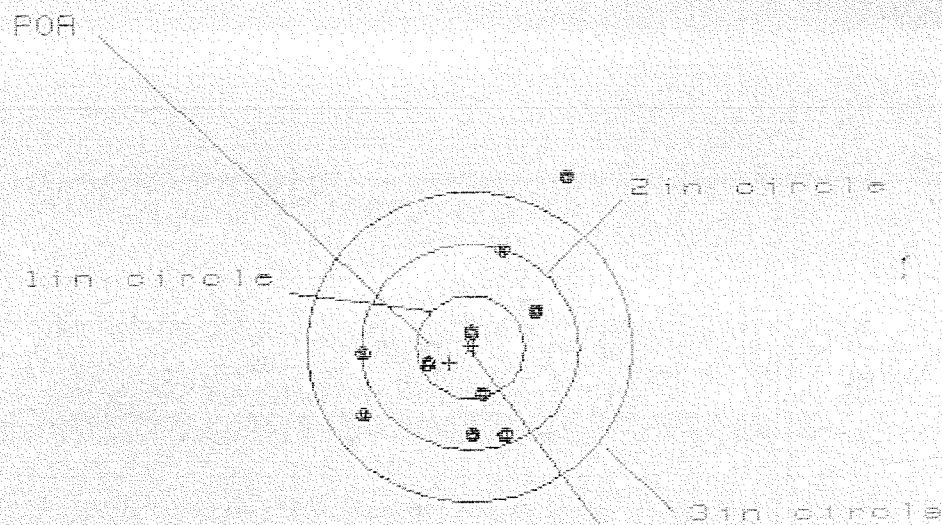
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.680	.732	.599
MINIMUM X	-1.113	-1.061	-1.711
MAXIMUM Y	1.100	.858	.848
MINIMUM Y	-1.113	-.982	-.992
CENTROID X	.238	.186	.319
CENTROID Y	.016	-.115	-.105
POA TO CENTROID in.	.239	.219	.336
MIN RADIUS	.140	.195	.081
MEAN RADIUS	.798	.748	.686
MAX RADIUS	1.269	1.064	.999
HORIZONTAL SPREAD	1.793	1.793	1.310
VERTICAL SPREAD	2.293	1.840	1.840
EXTREME SPREAD	2.349	1.840	1.840
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =		10	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649211

CENTERFIRE PATTERN # 5



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.906

VS= 2.494

GS= 2.971

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.915	.718	.607
MINIMUM X	-.991	-.889	-1.000
MAXIMUM Y	1.634	1.126	1.069
MINIMUM Y	-.860	-.678	-.736
CENTROID X	.193	.091	.202
CENTROID Y	.151	-.031	.027
POA TO CENTROID in.	.245	.096	.204
MIN RADIUS	.121	.254	.242
MEAN RADIUS	.854	.714	.675
MAX RADIUS	1.873	1.211	1.119
HORIZONTAL SPREAD	1.906	1.607	1.607
VERTICAL SPREAD	2.494	1.804	1.804
EXTREME SPREAD	2.971	2.076	1.830
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB49211

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.582

VS = 2.341

GS = 2.936

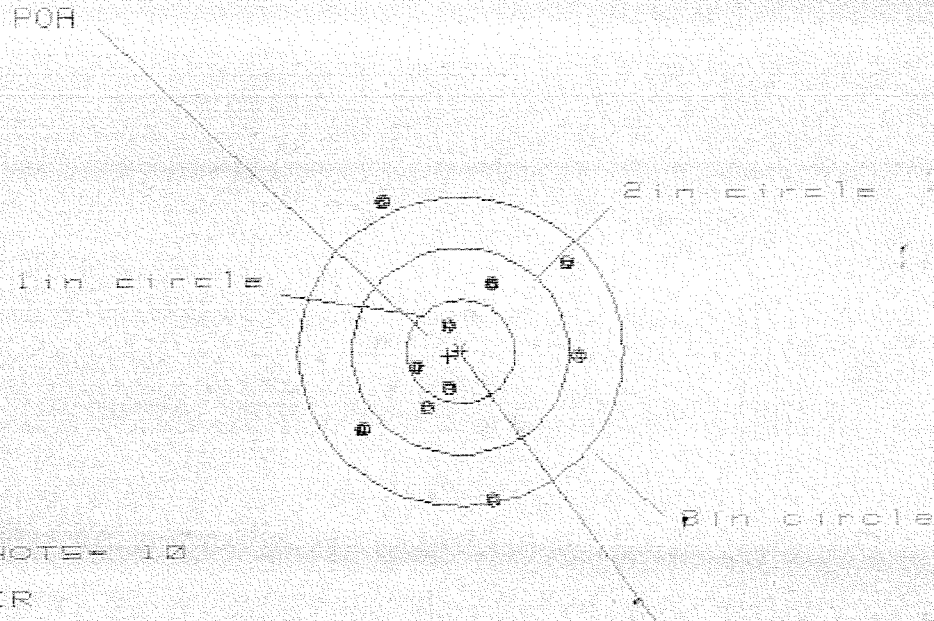
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.444	.913	.890
MINIMUM X	-1.138	-.977	-.900
MAXIMUM Y	1.167	1.037	.904
MINIMUM Y	-1.174	-1.266	-1.137
CENTROID X	.097	-.064	-.141
CENTROID Y	-.177	-.047	-.176
POA TO CENTROID in.	.202	.079	.225
MIN RADIUS	.306	.178	.328
MEAN RADIUS	1.006	.861	.828
MAX RADIUS	1.861	1.271	1.341
HORIZONTAL SPREAD	2.582	1.890	1.890
VERTICAL SPREAD	2.341	2.303	2.041
EXTREME SPREAD	2.936	2.415	2.284
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

11 Dec 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8649211

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS= 1.836

VS= 2.942

GS= 3.091

CENTROID *

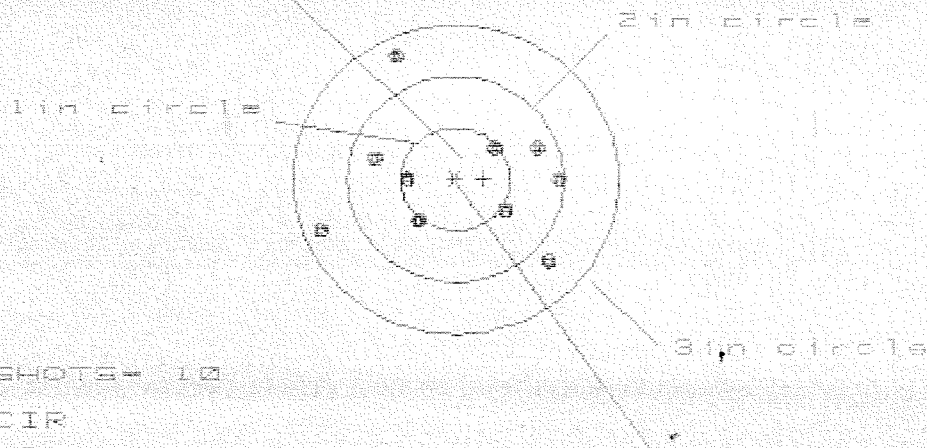
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.071	.992	1.011
MINIMUM X	-.965	-.944	-.925
MAXIMUM Y	1.506	1.020	.861
MINIMUM Y	-1.435	-1.268	-.738
CENTROID X	.114	.193	.174
CENTROID Y	.042	-.126	.033
POA TO CENTROID in.	.122	.231	.177
MIN RADIUS	.236	.269	.270
MEAN RADIUS	.891	.807	.733
MAX RADIUS	1.666	1.337	1.234
HORIZONTAL SPREAD	1.936	1.936	1.936
VERTICAL SPREAD	2.942	2.288	1.599
EXTREME SPREAD	3.091	2.414	2.414
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

[1] Dec 1993

FILE:/PATTERNING/CENTERFIRE_PATT/06649211

CENTERFIRE PATTERNS # 2

POB



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.198

VS= 2.024

GS= 2.485

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.910	.767	.681
MINIMUM X	-1.288	-1.874	-1.960
MAXIMUM Y	1.184	1.127	.397
MINIMUM Y	-.840	-.897	-.757
CENTROID X	-.256	-.113	-.027
CENTROID Y	-.006	.051	-.003
POB TO CENTROID in.	.256	.124	.033
MIN RADIUS	.483	.338	.352
MEAN RADIUS	.848	.772	.688
MAX RADIUS	1.389	1.319	1.011
HORIZONTAL SPREAD	2.198	1.641	1.641
VERTICAL SPREAD	2.024	2.024	1.154
EXTREME SPREAD	2.485	2.485	1.940
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	10	