

BARBER - M24 0101248

FORM

UPC



0 47700 25716 7

C6665680

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0101248~~ M2400101287

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24**

SERIAL NO.

C6665680

ORDER NO.

5716

20

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



5716 C6665680

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 # C6665680

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	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	GL
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel		10/5/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	DA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/23/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-5-91	JH

op. #	BARBER - M24 0101252	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			11/5/91	WB
	G) Safety Off Force	3	3	3			11/5/91	WB
	H) Trigger Pull Test & Retainability						11-5-91	JH
	L) Firing Pin Indent	.0205	.020	.0215			11/5/91	WB
	J) Assemble Stock						11/5/91	RW
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11/5/91	RW
	M) Iron Sight Alignment						11/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	RW
	O) Attach Scope to Rifle						11/5/91	RW
	P) Detach & Attach Scope 20 Times						11/5/91	RW
640	Gallery Target & Test						11-5-91	N
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11-5-91	AF
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	246	246	247	259	265	11-6-91	D/H
	C) Function						11-12-91	AC
660	Pack						12-19-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665680

DATE 11-5-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.39	2.51	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.48	2.55	2.46	
PULL #3	2.35	2.53	2.50	2.47	
PULL #4	2.35	2.52	2.55	2.59	
PULL #5	2.39	2.58	2.58	2.65	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.39		
PULL #2	3.45	3.28		
PULL #3	3.39	3.21		
PULL #4	3.31	3.24		
PULL #5	3.45	3.20		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.40		4.47
PULL #2	4.40	4.45		4.44
PULL #3	4.42	4.20		4.44
PULL #4	4.39	4.36		4.33
PULL #5	4.39	4.47		4.42
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665688
5 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.167726
1 TO 2	.239794
1 TO 3	.219386
1 TO 4	.154467
1 TO 5	.312424

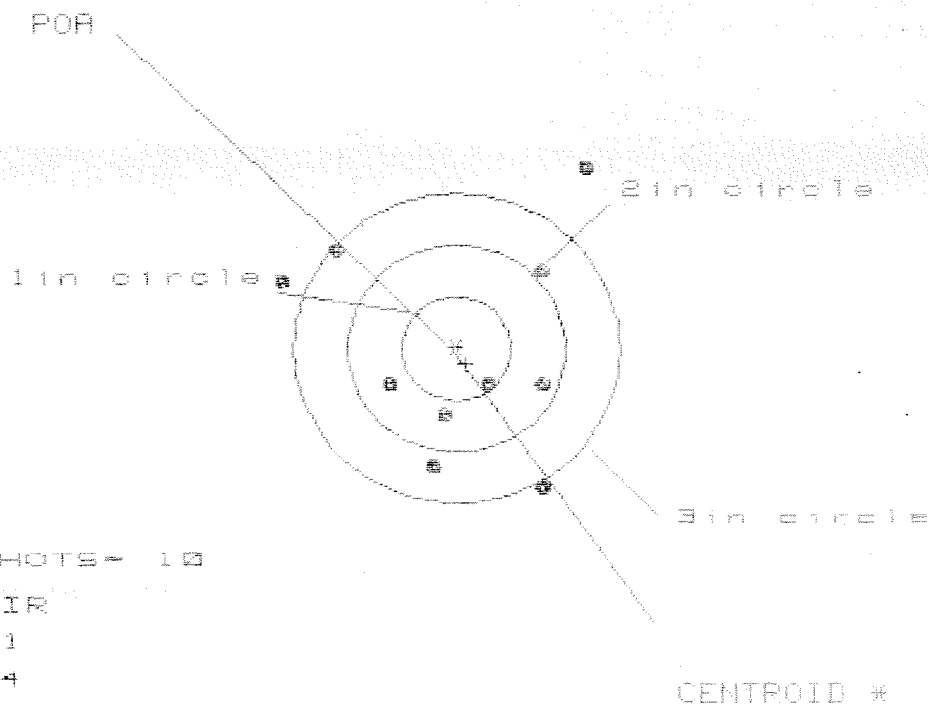
-----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .059
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0739685
THE AMR FOR THIS RIFLE IS: 1.055

5 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665680

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 2.866

VS = 3.139

GS = 3.288

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.287	.921	.731
MINIMUM X	-1.659	-1.525	-1.143
MAXIMUM Y	1.763	1.190	1.293
MINIMUM Y	-1.376	-1.180	-1.077
CENTROID X	-.086	-.220	-.030
CENTROID Y	.144	-.052	-.155
POB TO CENTROID in.	.168	.226	.158
MIN RADIUS	.488	.421	.267
MEAN RADIUS	1.192	1.043	.913
MAX RADIUS	2.137	1.734	1.726
HORIZONTAL SPREAD	2.866	2.446	1.874
VERTICAL SPREAD	3.139	2.370	2.370
EXTREME SPREAD	3.288	3.136	3.000
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685680

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 6

2in = 5

3in = 8

HS = 2.359

VS = 2.995

GS = 3.309

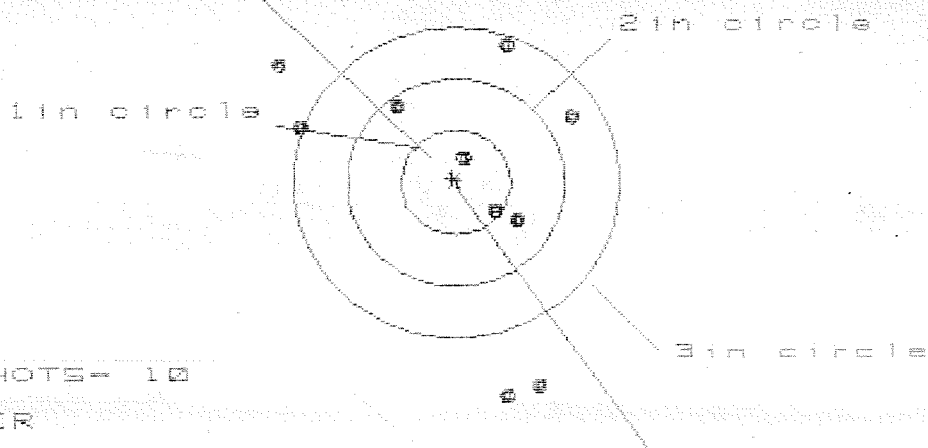
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.184	1.159	.985
MINIMUM X	:	-1.175	-1.200	-1.055
MAXIMUM Y	:	1.760	1.084	.954
MINIMUM Y	:	-1.235	-1.039	-1.012
CENTROID X	:	.079	.104	-.041
CENTROID Y	:	-.030	-.226	-.096
POA TO CENTROID in.	:	.084	.248	.104
MIN RADIUS	:	.508	.439	.588
MEAN RADIUS	:	1.180	1.005	.936
MAX RADIUS	:	1.774	1.557	1.244
HORIZONTAL SPREAD	:	2.359	2.359	2.040
VERTICAL SPREAD	:	2.995	2.123	1.966
EXTREME SPREAD	:	3.309	2.913	2.408
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C5665660

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 2.598

VS= 3.432

GS= 3.950

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.020	1.108	1.179
MINIMUM X	:	-1.678	-1.590	-1.519
MAXIMUM Y	:	1.360	1.139	.853
MINIMUM Y	:	-2.072	-2.293	-1.869
CENTROID X	:	.035	-.053	-.124
CENTROID Y	:	-.039	.182	.468
POA TO CENTROID in.	:	.053	.189	.484
MIN RADIUS	:	.269	.114	.296
MEAN RADIUS	:	1.283	1.159	1.005
MAX RADIUS	:	2.140	2.362	1.629
HORIZONTAL SPREAD	:	2.698	2.698	2.698
VERTICAL SPREAD	:	3.432	3.432	1.722
EXTREME SPREAD	:	3.950	3.832	2.734
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

5 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066656B0

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 6

3in = 9

HS= 2.455

VS= 2.865

GS= 3.440

CENTROID #

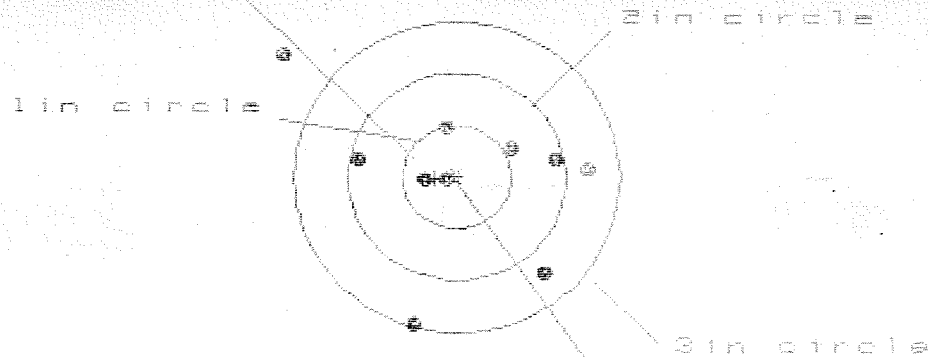
PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.306
MINIMUM X	-1.149
MAXIMUM Y	1.745
MINIMUM Y	-1.120
CENTROID X	.068
CENTROID Y	.132
POA TO CENTROID in.	.149
MIN RADIUS	.158
MEAN RADIUS	.780
MAX RADIUS	2.179
HORIZONTAL SPREAD	2.455
VERTICAL SPREAD	2.865
EXTREME SPREAD	3.440
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

5 May 1931

FILE:/PATTERNING/CENTERFIRE_PATT-066636B0

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.819

VS= 2.519

GS= 3.168

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.199	1.819	.958
MINIMUM X	:	-1.628	-1.896	-1.164
MAXIMUM Y	:	1.138	.611	.454
MINIMUM Y	:	-1.381	-1.254	-1.899
CENTROID X	:	.199	.379	.448
CENTROID Y	:	.016	-.111	.045
POA TO CENTROID in.	:	.208	.395	.458
MIN RADIUS	:	.182	.306	.342
MEAN RADIUS	:	.918	.815	.717
MAX RADIUS	:	1.988	1.369	1.178
HORIZONTAL SPREAD	:	2.819	2.115	2.115
VERTICAL SPREAD	:	2.519	1.865	1.353
EXTREME SPREAD	:	3.168	2.138	2.115
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	