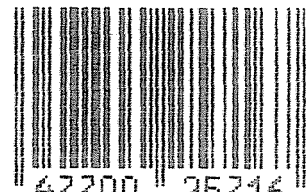


BARBER - M24 0101946

Shred®

FCI

UPC



0 47700 25716 7

C6665741

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0101946 M2400101985

MODEL 700 TM M24

ORDER NO.

5716

BARREL LENGTH

CAPACITY*

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665741

ORDER NO.

5716

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

20

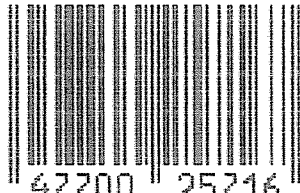


5716 C6665741

ORDER 5716

MODEL 700 TM M24

UPC

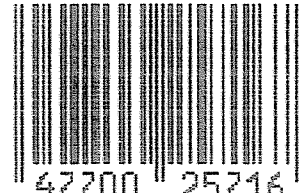


0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665741

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	LS
617	Drill and Tap Sight Holes		OCT 4 1991	F.B
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10/22/91	DK
	Apply Coating (Bolt)		10/22/91	DK
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		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	AL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/31/91	SH
	G) Safety Off Force	4	4	4			10/31/91	SH
	H) Trigger Pull Test & Retainability						10/31/91	SH
	I) Firing Pin Indent	10205	10205	1021			10/31/91	SH
	J) Assemble Stock						11/4/91	RW
	K) Assemble Swivel Studs						11-13-91	AC
	L) Attach Front and Rear Sight Assemblies						11/4/91	RW
	M) Iron Sight Alignment						11/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/4/91	RW
	O) Attach Scope to Rifle						11/4/91	RW
	P) Detach & Attach Scope 20 Times						11/4/91	RW
640	Gallery Target & Test						11-4-91	N
	A) Time						"	N
	B) Malfunctions						"	N
	C) Pierced Primers						"	N
	D) Optical Clarity of Scope						"	N
645	Inspect for Live Ammo						11-4-91	N
655	Final Inspection							
	A) Headspace						11-13-91	AC
	B) Trigger Pull	261	233	220	234	251	11-6-91	SH
	C) Function						11-13-91	AC
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6665741DATE 10/31/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.48	2.50	261	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.48	2.55	233	
PULL #3	2.54	2.53	2.51	220	
PULL #4	2.31	2.48	2.49	234	
PULL #5	2.52	2.57	2.51	251	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.26		
PULL #2	3.33	3.41		
PULL #3	3.40	3.40		
PULL #4	3.37	3.31		
PULL #5	3.34	3.45		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.46		4.56
PULL #2	4.35	4.42		4.56
PULL #3	4.38	4.50		4.50
PULL #4	4.28	4.51		4.52
PULL #5	4.48	4.46		4.56
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665741
4 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.270836
1 TO	2	.245367
1 TO	3	.239971
1 TO	4	.611236
1 TO	5	.337818

4 <----POA

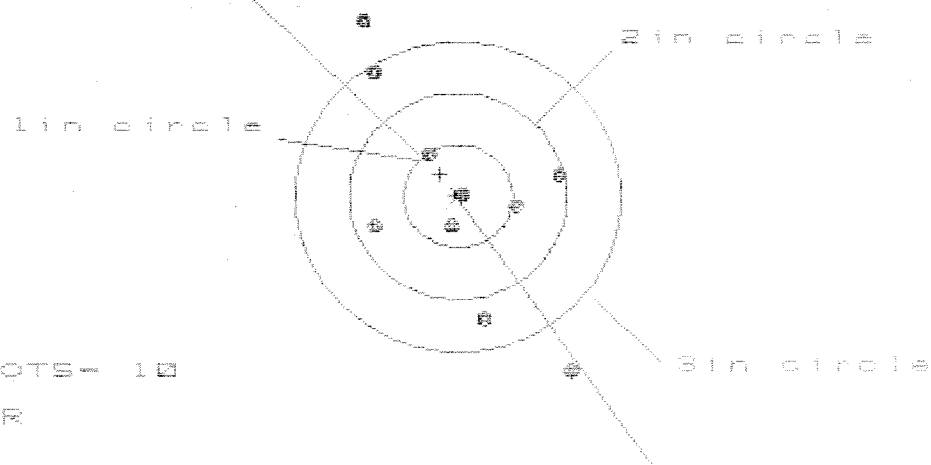
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0142
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0084
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0164965
THE AMR FOR THIS RIFLE IS: .9102

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C866574)

CENTERFIRE PATTERNS # 1

FOR



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.957

VS = 3.362

GS = 3.895

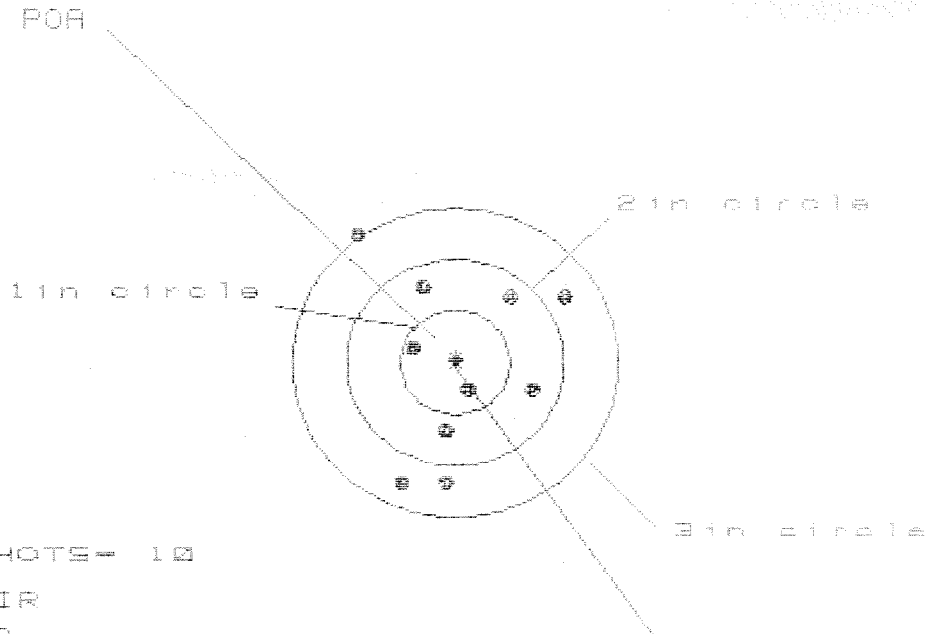
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.053	1.031	.931
MINIMUM X	-.914	-.797	-.775
MAXIMUM Y	1.672	1.485	1.165
MINIMUM Y	-1.690	-1.361	-1.176
CENTROID X	.166	.049	.149
CENTROID Y	-.214	-.027	-.212
FOR TO CENTROID in.	.271	.056	.259
MIN RADIUS	.067	.273	.084
MEAN RADIUS	.968	.874	.726
MAX RADIUS	1.991	1.685	1.387
HORIZONTAL SPREAD	1.967	1.828	1.706
VERTICAL SPREAD	3.362	2.846	2.341
EXTREME SPREAD	3.895	3.067	2.545
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665741

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.892

VS= 2.393

GS= 2.498

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.976	.874	.801
MINIMUM X	-.916	-.580	-.519
MAXIMUM Y	1.241	.906	.779
MINIMUM Y	-1.152	-1.014	-1.111
CENTROID X	-.008	.094	.167
CENTROID Y	-.041	-.179	-.052
POA TO CENTROID in.	.042	.202	.175
MIN RADIUS	.317	.168	.307
MEAN RADIUS	.882	.786	.745
MAX RADIUS	1.543	1.180	1.145
HORIZONTAL SPREAD	1.892	1.454	1.321
VERTICAL SPREAD	2.393	1.920	1.890
EXTREME SPREAD	2.498	2.319	2.080
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865741

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 7

HS = 2.842

VS = 2.820

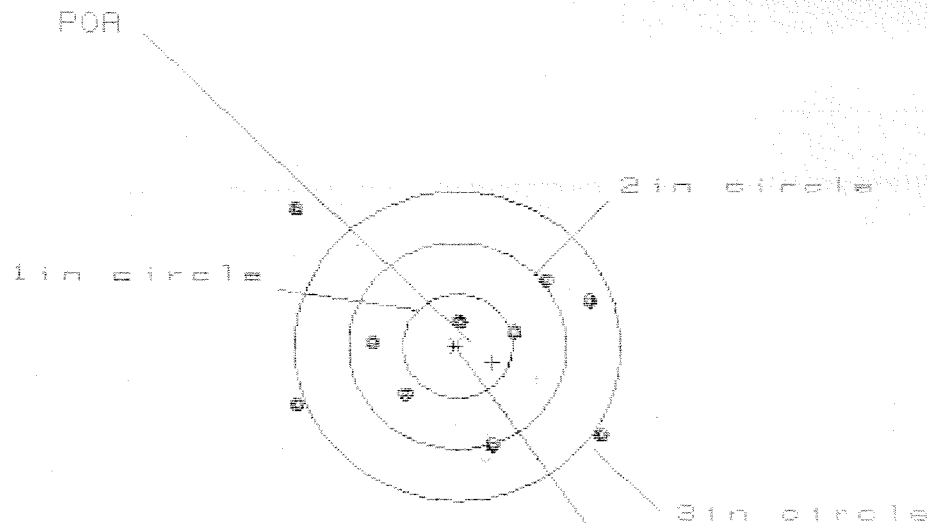
GS = 3.232

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.385	1.347	.831
MINIMUM X	-1.257	-1.295	-1.127
MAXIMUM Y	1.084	.891	.986
MINIMUM Y	-1.736	-1.096	-1.001
CENTROID X	.101	.139	-.029
CENTROID Y	.017	.210	.115
POA TO CENTROID in.	.103	.252	.118
MIN RADIUS	.066	.225	.228
MEAN RADIUS	.919	.815	.718
MAX RADIUS	1.769	1.697	1.507
HORIZONTAL SPREAD	2.642	2.642	1.958
VERTICAL SPREAD	2.820	1.987	1.987
EXTREME SPREAD	3.232	3.232	2.609
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

4 May 1991 FILE:/PATTERNING/CENTERFIRE_PATT/C9665741

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.782

VS= 2.295

GS= 3.478

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.315	1.155	.951
MINIMUM X	:	-1.467	-1.627	-1.155
MAXIMUM Y	:	1.313	.781	.724
MINIMUM Y	:	-.982	-.836	-.893
CENTROID X	:	-.319	-.159	.045
CENTROID Y	:	.158	.012	.069
POA TO CENTROID in.	:	.355	.159	.082
MIN RADIUS	:	.275	.441	.271
MEAN RADIUS	:	1.071	.966	.854
MAX RADIUS	:	1.948	1.690	1.195
HORIZONTAL SPREAD	:	2.782	2.782	2.106
VERTICAL SPREAD	:	2.295	1.617	1.617
EXTREME SPREAD	:	3.478	2.930	2.260
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685741

CENTERFIRE PATTERNS # 5

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.042

VS= 2.246

GS= 2.250

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.010
MINIMUM X	-1.032
MAXIMUM Y	1.234
MINIMUM Y	-1.012
CENTROID X	.131
CENTROID Y	.122
POR TO CENTROID in.	.179
MIN RADIUS	.169
MEAN RADIUS	.711
MAX RADIUS	1.340
HORIZONTAL SPREAD	2.042
VERTICAL SPREAD	2.246
EXTREME SPREAD	2.250
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	10