

BARBER - M24 0102857

FORM

UPC



06665809

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0102857 M2400102896

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

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

SERIAL NO.

C6665309

ORDER NO.

5716

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

20



5716 C6665809

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 #

C6665809

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	KL
600	Proof		9/24/91	KL
607	Check Headspace		9/24/91	KL
610	Dis-assemble Gun		9/24/91	KL
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	GG
617	Drill and Tap Sight Holes		SEP 30 1991	LB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		10/2/91	KL
	Apply Coating (Bolt)			KL
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	RW
	C) Inspect Ejector Hole for Chamfer		10/8/91	RW
	D) Oil Firing Pin Ass'y		10/8/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/8/91	JL

op. #	BARBER - M24 0102861 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5.5	5	5.5			10/8/91	RW
	G) Safety Off Force	3	3	3			10/8/91	RW
	H) Trigger Pull Test & Retainability						10/8/91	gll
	I) Firing Pin Indent	.022	.0225	.0215			10/8/91	RW
	J) Assemble Stock						10/9/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/9/91	RW
	M) Iron Sight Alignment						10/9/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/9/91	RW
	O) Attach Scope to Rifle						10/9/91	RW
	P) Detach & Attach Scope 20 Times						10/9/91	RW
640	Gallery Target & Test						10-11-91	AC
	A) Time						10-11-91	AC
	B) Malfunctions						10-11-91	AC
	C) Pierced Primers						10-11-91	AC
	D) Optical Clarity of Scope						10-11-91	AC
645	Inspect for Live Ammo						10-11-91	AC
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	221	231	234	230	224	10-11-91	D/H
	C) Function						10-17-91	AC
660	Pack						12-17-91	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6665809

DATE 10/8/91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.50	2.45	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.44	2.48	2.31	
PULL #3	2.34	2.42	2.40	2.34	
PULL #4	2.36	2.48	2.42	2.30	
PULL #5	2.44	2.39	2.44	2.24	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.42		
PULL #2	3.44	3.47		
PULL #3	3.40	3.37		
PULL #4	3.39	3.46		
PULL #5	3.38	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	4.56	4.53		4.56
PULL #2	4.51	4.45		4.60
PULL #3	4.52	4.59		4.63
PULL #4	4.53	4.53		4.48
PULL #5	4.55	4.55		4.58
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665809
14 Oct 1991

CENTROIDAL DISTANCES

Ø TO	1	.116417
1 TO	2	.126127
1 TO	3	.395627
1 TO	4	.343548
1 TO	5	.117201

4
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0062
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0503829
THE AMR FOR THIS RIFLE IS: .046

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665803

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= .036

VS= 3.166

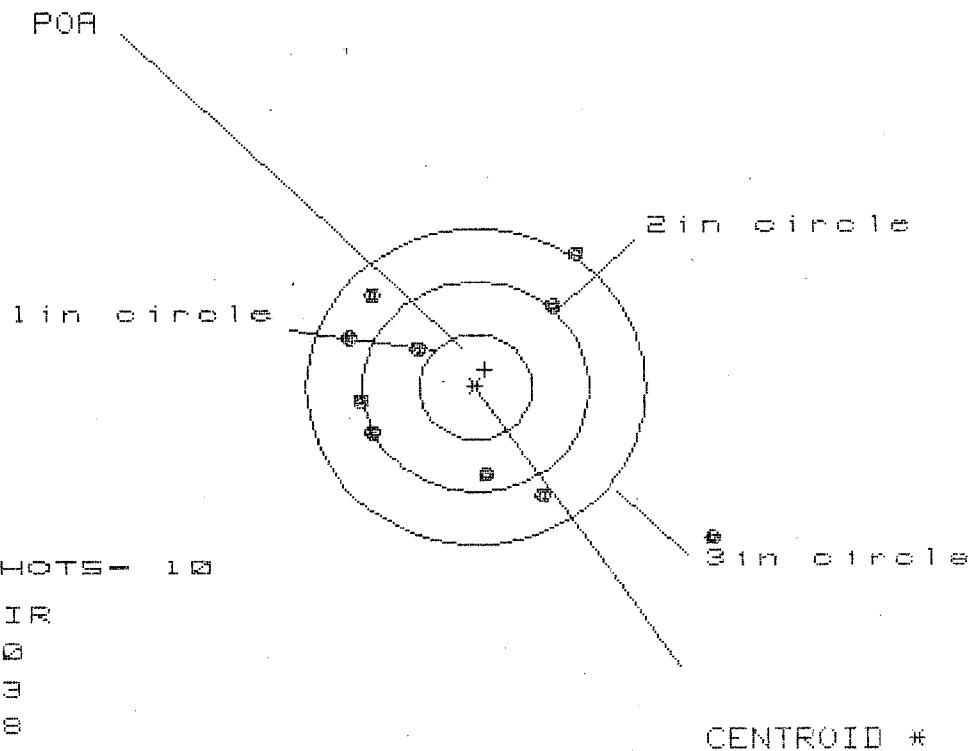
GS= 3.199

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.433	.357	.360
MINIMUM X	-.403	-.355	-.352
MAXIMUM Y	1.225	1.009	.808
MINIMUM Y	-1.941	-.786	-.660
CENTROID X	.028	-.020	-.023
CENTROID Y	-.113	.103	-.023
POA TO CENTROID in.	.116	.105	.032
MIN RADIUS	.144	.169	.140
MEAN RADIUS	.704	.531	.465
MAX RADIUS	1.989	1.009	.859
HORIZONTAL SPREAD	.836	.712	.712
VERTICAL SPREAD	3.166	1.795	1.468
EXTREME SPREAD	3.199	1.819	1.591
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 3.196

VS= 2.665

GS= 3.792

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.129	1.074	1.057
MINIMUM X	:	-1.067	-.831	-.696
MAXIMUM Y	:	1.267	1.112	.887
MINIMUM Y	:	-1.398	-1.161	-1.022
CENTROID X	:	-.084	-.320	-.455
CENTROID Y	:	-.171	-.016	-.155
POA TO CENTROID in.	:	.190	.321	.480
MIN RADIUS	:	.618	.335	.359
MEAN RADIUS	:	1.222	1.011	.913
MAX RADIUS	:	2.547	1.546	1.425
HORIZONTAL SPREAD	:	3.196	1.905	1.753
VERTICAL SPREAD	:	2.665	2.273	1.909
EXTREME SPREAD	:	3.792	2.463	2.432
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.393

VS= 2.071

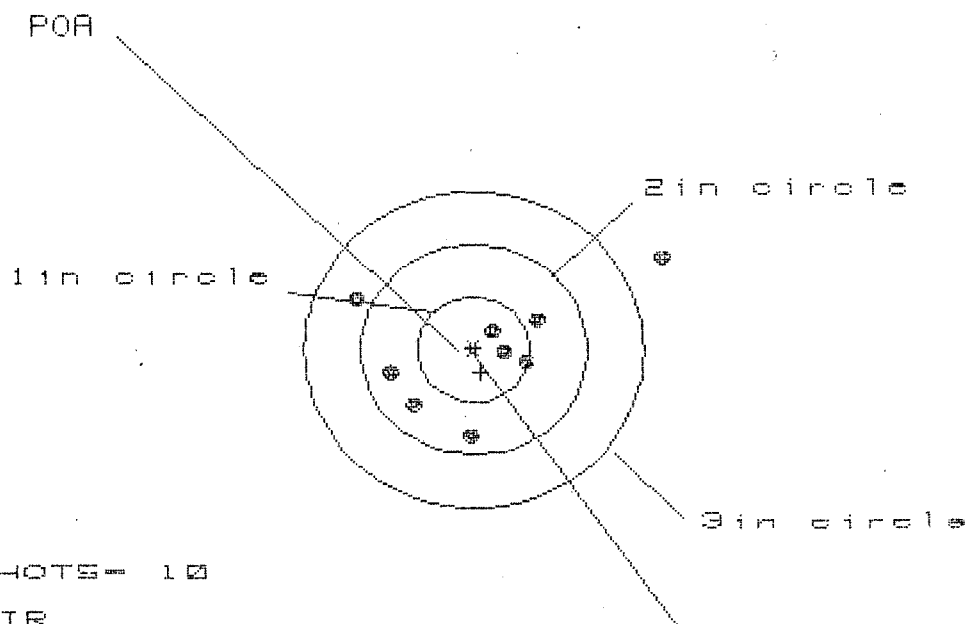
GS= 2.569

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.839	.667	.504
MINIMUM X	:	-1.554	-1.305	-.284
MAXIMUM Y	:	.938	.908	.868
MINIMUM Y	:	-1.133	-1.163	-1.203
CENTROID X	:	.392	.564	.727
CENTROID Y	:	.042	.072	.112
POA TO CENTROID in.	:	.394	.569	.736
MIN RADIUS	:	.172	.070	.149
MEAN RADIUS	:	.821	.678	.584
MAX RADIUS	:	1.578	1.343	1.209
HORIZONTAL SPREAD	:	2.393	1.972	.788
VERTICAL SPREAD	:	2.071	2.071	2.071
EXTREME SPREAD	:	2.569	2.187	2.078
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.682

VS= 1.707

GS= 2.718

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.658	.711	.606
MINIMUM X	:	-1.024	-.839	-.649
MAXIMUM Y	:	.903	.564	.487
MINIMUM Y	:	-.804	-.704	-.633
CENTROID X	:	-.064	-.249	-.144
CENTROID Y	:	.218	.118	.048
POA TO CENTROID in.	:	.228	.275	.151
MIN RADIUS	:	.225	.402	.315
MEAN RADIUS	:	.758	.627	.566
MAX RADIUS	:	1.888	1.011	.777
HORIZONTAL SPREAD	:	2.682	1.550	1.255
VERTICAL SPREAD	:	1.707	1.268	1.120
EXTREME SPREAD	:	2.718	1.626	1.360
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.427

VS= 1.637

GS= 2.435

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.283	1.386	.702
MINIMUM X	:	-1.144	-1.041	-.868
MAXIMUM Y	:	.716	.614	.619
MINIMUM Y	:	-.921	-.609	-.604
CENTROID X	:	-.022	-.125	-.298
CENTROID Y	:	-.007	.095	.090
POR TO CENTROID in.	:	.023	.157	.311
MIN RADIUS	:	.143	.117	.043
MEAN RADIUS	:	.725	.643	.528
MAX RADIUS	:	1.308	1.387	.883
HORIZONTAL SPREAD	:	2.427	2.427	1.570
VERTICAL SPREAD	:	1.637	1.223	1.223
EXTREME SPREAD	:	2.435	2.430	1.664
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	