

BARBER - M24 0103164

FORM

UPC



0 47700 25716 2

INCLUDES 1 IN CHAMBER
C6665836

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0103164 0103203

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0103186

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665836

ORDER NO.
5716

20

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



5716 C6665836

ORDER 5716
MODEL 700™ M24
UPC

ORDER 5716
MODEL 700™ M24
UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665836

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9/25/91	KL
600	Proof		9/25/91	KL
607	Check Headspace		9/25/91	KL
610	Dis-assemble Gun		9/25/91	KL
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	KB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-1-91	KL
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/31/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/91	KL
	C) Inspect Ejector Hole for Chamfer		10/31/91	KL
	D) Oil Firing Pin Ass'y		10/31/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-1-91	KL

op. #	OP. NAME BARBER M24 0103168	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-1-91	JH
	G) Safety Off Force	3	3	3			11-1-91	JH
	H) Trigger Pull Test & Retainability						11-1-91	JH
	I) Firing Pin Indent	.0205	.020	.0205			11-1-91	JH
	J) Assemble Stock						11-1-91	JH
	K) Assemble Swivel Studs						11-12-91	AC
	L) Attach Front and Rear Sight Assemblies						11-1-91	JH
	M) Iron Sight Alignment						11-1-91	JH
	N) Detach Front & Rear Sights & place in numbered container						11-1-91	JH
	O) Attach Scope to Rifle						11-1-91	JH
	P) Detach & Attach Scope 20 Times						11-1-91	JH
640	Gallery Target & Test						11-4-91	DH
	A) Time						11-4-91	DH
	B) Malfunctions						11-4-91	DH
	C) Pierced Primers						11-4-91	DH
	D) Optical Clarity of Scope						11-4-91	DH
	645	Inspect for Live Ammo						11-4-91
655	Final Inspection							
	A) Headspace						11-12-91	AC
	B) Trigger Pull	231	215	210	212	228	11-6-91	DH
	C) Function						11-12-91	AC
660	Pack						12-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C-6665836

DATE 10/1/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.29	2.22	231	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.51	2.41	2.33	215	
PULL #3	2.50	2.36	2.48	210	
PULL #4	2.36	2.45	2.31	212	
PULL #5	2.55	2.18	2.25	228	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.69		
PULL #2	3.58	3.66		
PULL #3	3.59	3.67		
PULL #4	3.61	3.55		
PULL #5	3.48	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.26		4.35
PULL #2	4.25	4.33		4.30
PULL #3	4.23	4.28		4.39
PULL #4	4.32	4.36		4.32
PULL #5	4.28	4.33		4.40
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665836
5 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.383005
1 TO	2	.50908
1 TO	3	.501209
1 TO	4	.60945
1 TO	5	.511489

1 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .023
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0356
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0423835
THE AMR FOR THIS RIFLE IS: .9034

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685636

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.769

VS= 3.145

GS= 3.458

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.584	1.483	.633
MINIMUM X	-1.185	-1.286	-1.101
MAXIMUM Y	.982	.742	.602
MINIMUM Y	-2.163	-1.118	-.791
CENTROID X	-.002	.099	-.086
CENTROID Y	-.383	-.143	-.003
POA TO CENTROID in.	.383	.174	.086
MIN RADIUS	.177	.087	.251
MEAN RADIUS	.987	.763	.609
MAX RADIUS	2.346	1.857	1.355
HORIZONTAL SPREAD	2.769	2.769	1.734
VERTICAL SPREAD	3.145	1.860	1.393
EXTREME SPREAD	3.458	2.808	2.209
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

4 Nov 1991

FILE://PATTERNING/CENTERFIRE_PATT/06605836

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 9

HS= 2.492

VS= 2.230

GS= 2.522

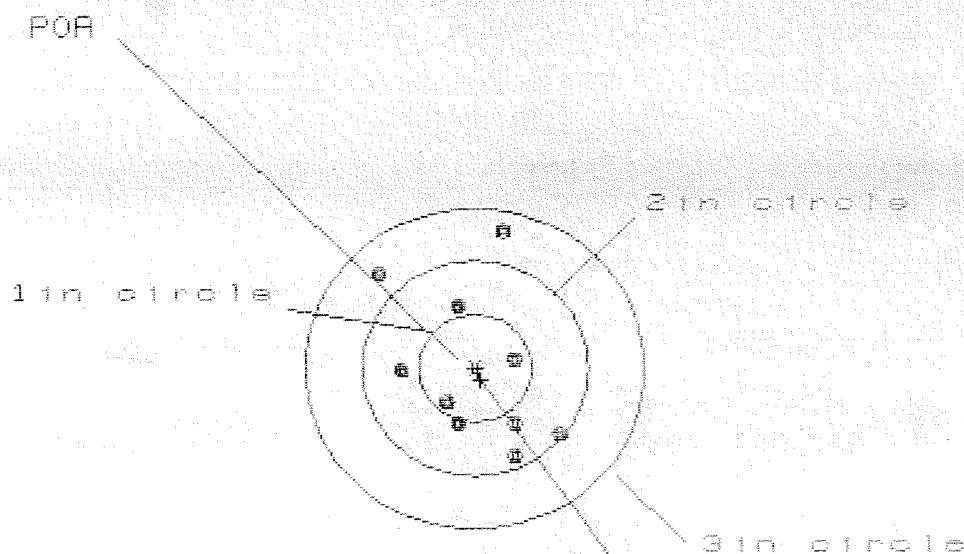
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.785	.679
MINIMUM X	:	-1.536	-1.286	-1.188
MAXIMUM Y	:	.937	.997	1.120
MINIMUM Y	:	-1.293	-1.233	-1.110
CENTROID X	:	.007	.178	.080
CENTROID Y	:	.126	.066	-.057
POA TO CENTROID in.	:	.126	.190	.098
MIN RADIUS	:	.567	.387	.450
MEAN RADIUS	:	1.074	.983	.950
MAX RADIUS	:	1.627	1.297	1.197
HORIZONTAL SPREAD	:	2.492	2.071	1.867
VERTICAL SPREAD	:	2.230	2.230	2.230
EXTREME SPREAD	:	2.522	2.517	2.320
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665836

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1in = 3

2in = 8

3in = 10

HS = 1.571

VS = 2.079

GS = 2.174

CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.790	.692
MINIMUM X	:	-.804	-.781	-.757
MAXIMUM Y	:	1.245	1.020	.821
MINIMUM Y	:	-.834	-.696	-.568
CENTROID X	:	-.049	-.072	.026
CENTROID Y	:	.116	-.022	-.150
POA TO CENTROID in.	:	.126	.075	.152
MIN RADIUS	:	.348	.274	.275
MEAN RADIUS	:	.742	.657	.551
MAX RADIUS	:	1.263	1.285	.851
HORIZONTAL SPREAD	:	1.571	1.571	1.449
VERTICAL SPREAD	:	2.079	1.716	1.389
EXTREME SPREAD	:	2.174	2.174	1.559
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

4 Nov 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C6665826

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.536

VS= 2.912

GS= 2.913

CENTROID *

PATTERN #

4

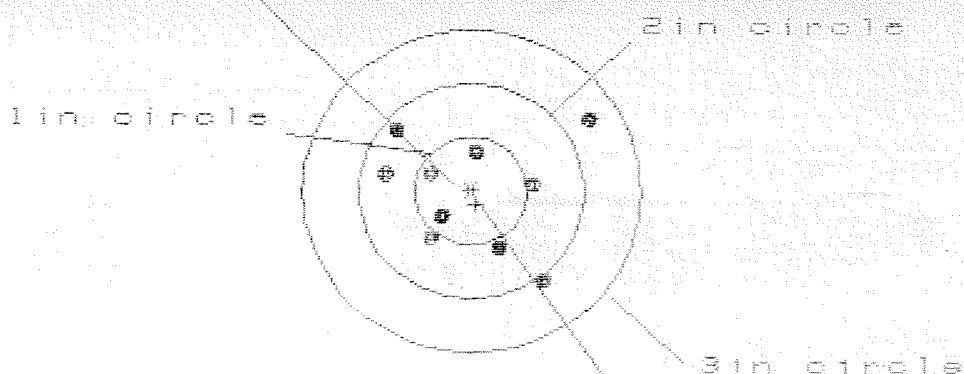
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.170	1.205	1.038
MINIMUM X	-1.366	-1.331	-1.789
MAXIMUM Y	1.799	1.287	1.274
MINIMUM Y	-1.113	-1.913	-1.926
CENTROID X	.200	.165	.332
CENTROID Y	.192	-.008	.005
POA TO CENTROID in.	.277	.166	.332
MIN RADIUS	.052	.208	.268
MEAN RADIUS	1.032	.937	.892
MAX RADIUS	1.826	1.344	1.293
HORIZONTAL SPREAD	2.536	2.536	1.826
VERTICAL SPREAD	2.912	2.200	2.200
EXTREME SPREAD	2.913	2.536	2.202
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B85836

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.843

VS= 1.426

GS= 1.910

CENTROID #

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.085
MINIMUM X	-.758
MAXIMUM Y	.627
MINIMUM Y	-.799
CENTROID X	-.041
CENTROID Y	.127
POA TO CENTROID in.	.134
MIN RADIUS	.380
MEAN RADIUS	.682
MAX RADIUS	1.253
HORIZONTAL SPREAD	1.843
VERTICAL SPREAD	1.426
EXTREME SPREAD	1.910
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10