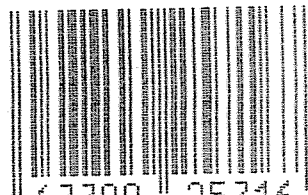


BARBER - M24 0104003

FORM

UPC



0 47700 25716 7

06665918

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

BARBER - M24 0104004

MODEL 700 TM M24

ORDER NO.

5216

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 010400404043

BARBER - M24 0104005

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665918

ORDER NO.

5716

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

20



5716 C6665918

ORDER 5716

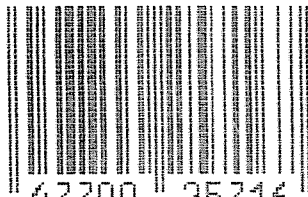
MODEL 700 TM M24

UPC

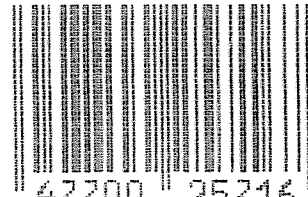
ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665918

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KL
600	Proof		9/23/91	KL
607	Check Headspace		9/23/91	KL
610	Dis-assemble Gun		9/23/91	KL
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	KL
617	Drill and Tap Sight Holes		SEP 30 1991	FB
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	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KL
	C) Inspect Ejector Hole for Chamfer		10/8/91	KL
	D) Oil Firing Pin Ass'y		10/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10-9-91	KL

op. #	BARBER - M24 0104007 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	7	6	6			10-9-91	AC
	G) Safety Off Force	3	3	3			10-9-91	AC
	H) Trigger Pull Test & Retainability						10-9-91	D/H
	I) Firing Pin Indent	.021	.020	.020			10-9-91	AC
	J) Assemble Stock						10/11/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/11/91	RW
	M) Iron Sight Alignment						10/11/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/11/91	RW
	O) Attach Scope to Rifle						10/11/91	RW
	P) Detach & Attach Scope 20 Times						10/11/91	RW
640	Gallery Target & Test						10-14-91	AC
	A) Time						10-14-91	AC
	B) Malfunctions						10-14-91	AC
	C) Pierced Primers						10-14-91	AC
	D) Optical Clarity of Scope						10-14-91	AC
645	Inspect for Live Ammo						10-14-91	AC
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.61	2.58	2.56	2.56	2.56	10-14-91	D/H
	C) Function						10-17-91	AC
660	Pack						12-18-91	N

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

SERIAL NO. C6665918
DATE 10-9-91
TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.54	2.63	2.61	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.57	2.61	2.58	
PULL #3	2.54	2.31	2.62	2.56	
PULL #4	2.56	2.60	2.62	2.56	
PULL #5	2.57	2.36	2.59	2.56	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.46		
PULL #2	3.54	3.53		
PULL #3	3.55	3.51		
PULL #4	3.45	3.42		
PULL #5	3.57	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.07		4.06
PULL #2	4.24	4.24		4.03
PULL #3	4.22	4.21		4.21
PULL #4	4.15	4.31		4.22
PULL #5	4.22	4.32		4.21
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665918
14 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.159
1 TO	2	.311642
1 TO	3	.30555
1 TO	4	.149937
1 TO	5	.200823

57 <----POA

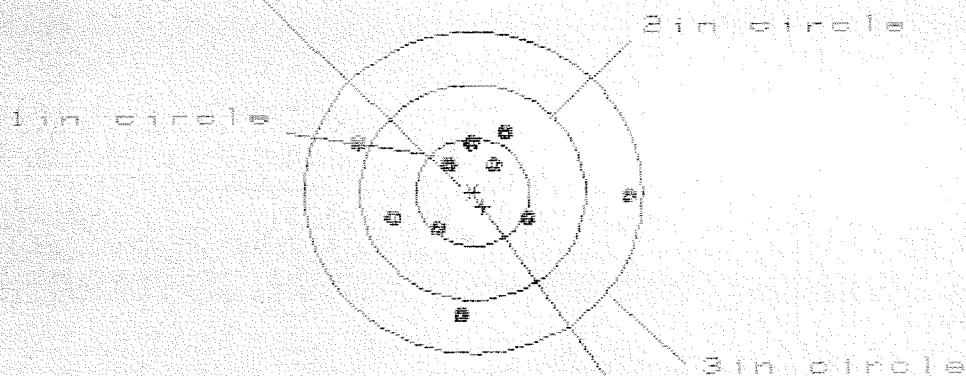
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0422
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0702
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0819078
THE AMR FOR THIS RIFLE IS: .8736

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885918

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.421

VS= 1.752

GS= 2.467

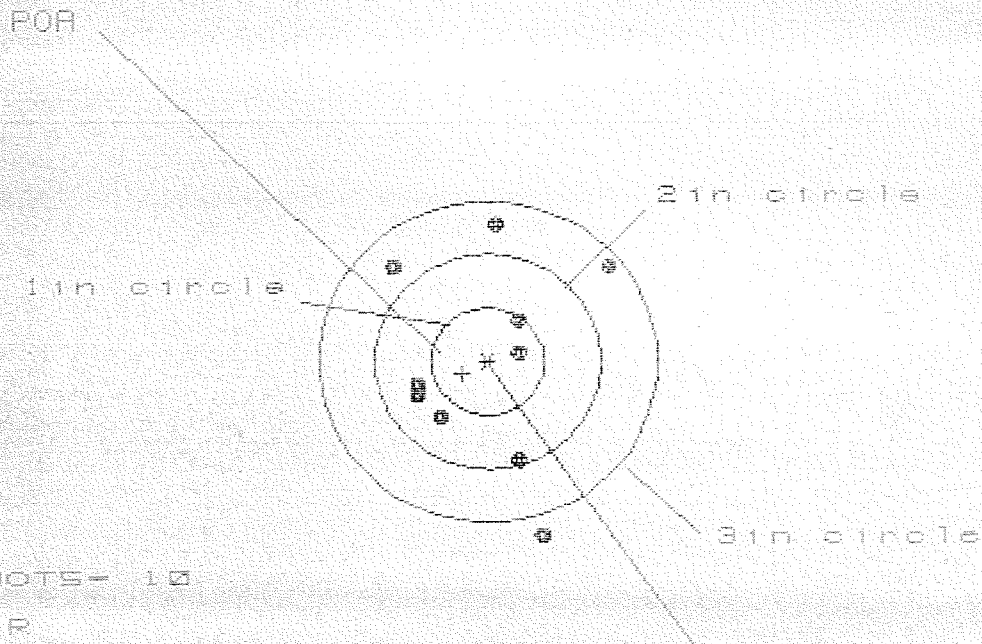
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.409	.675	.675
MINIMUM X	-1.012	-.856	-.856
MAXIMUM Y	.576	.574	.427
MINIMUM Y	-1.176	-1.178	-.494
CENTROID X	-.084	-.240	-.240
CENTROID Y	.135	.137	.284
POA TO CENTROID in.	.159	.277	.372
MIN RADIUS	.325	.270	.124
MEAN RADIUS	.720	.634	.534
MAX RADIUS	1.409	1.178	.909
HORIZONTAL SPREAD	2.421	1.531	1.531
VERTICAL SPREAD	1.752	1.752	.921
EXTREME SPREAD	2.467	1.841	1.687
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885918

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 1.913

VS= 2.918

GS= 2.939

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.111	1.161	.483
MINIMUM X	-.802	-.752	-.607
MAXIMUM Y	1.298	1.119	1.202
MINIMUM Y	-1.619	-1.063	-.980
CENTROID X	.227	.177	.032
CENTROID Y	.115	.295	.212
POA TO CENTROID in.	.255	.345	.214
MIN RADIUS	.281	.316	.454
MEAN RADIUS	.920	.830	.753
MAX RADIUS	1.680	1.339	1.237
HORIZONTAL SPREAD	1.913	1.913	1.090
VERTICAL SPREAD	2.918	2.182	2.182
EXTREME SPREAD	2.939	2.190	2.190
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665918

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 1.553

VS= 3.348

GS= 3.691

CENTROID *

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.679

.582

.481

MINIMUM X

-.874

-.759

-.686

MAXIMUM Y

1.577

1.381

1.072

MINIMUM Y

-1.771

-.844

-.672

CENTROID X

.147

.244

.171

CENTROID Y

-.065

.131

-.041

POA TO CENTROID in.

.161

.277

.176

MIN RADIUS

.172

.352

.186

MEAN RADIUS

.853

.739

.605

MAX RADIUS

1.974

1.498

1.106

HORIZONTAL SPREAD

1.553

1.341

1.167

VERTICAL SPREAD

3.348

2.225

1.744

EXTREME SPREAD

3.691

2.411

1.833

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

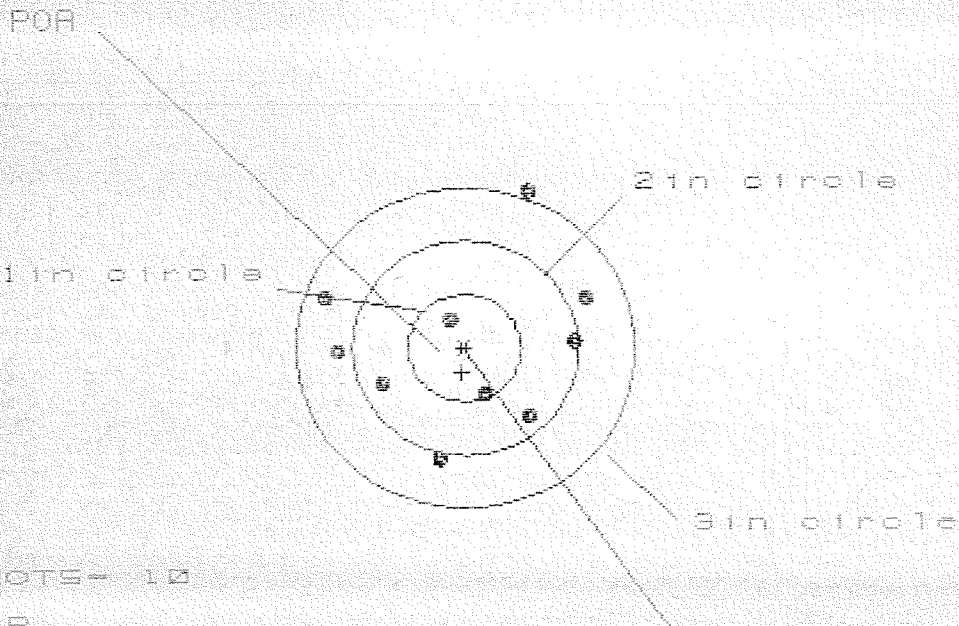
NUMBER IN THREE INCH CIRCLE =

8

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6885318

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.321

VS= 2.586

GS= 2.697

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.090	1.154	1.008
MINIMUM X	-1.231	-1.167	-1.207
MAXIMUM Y	1.514	.627	.683
MINIMUM Y	-1.072	-.904	-.826
CENTROID X	.032	-.032	.114
CENTROID Y	.230	.062	-.016
POA TO CENTROID in.	.233	.070	.115
MIN RADIUS	.264	.401	.256
MEAN RADIUS	.972	.880	.804
MAX RADIUS	1.618	1.325	1.219
HORIZONTAL SPREAD	2.321	2.321	2.215
VERTICAL SPREAD	2.586	1.531	1.509
EXTREME SPREAD	2.697	2.321	2.274
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 9		

14 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665318

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 4

2in = 6

3in = 8

HS= 2.874

VS= 2.404

GS= 3.070

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.587
MINIMUM X	-1.287
MAXIMUM Y	.916
MINIMUM Y	-1.488
CENTROID X	-.111
CENTROID Y	-.064
POA TO CENTROID (in.)	.128
MIN RADIUS	.219
MEAN RADIUS	.903
MAX RADIUS	1.832
HORIZONTAL SPREAD	2.874
VERTICAL SPREAD	2.404
EXTREME SPREAD	3.070
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	8