

BARBER - M24 0104671

FORM

UPC



0 47700 25716 7

6665976

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

BARBER - M24 0104672

ORDER NO. 5716

MODEL 700 TM M24

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

BARBER - M24 0104672 M2400104711

BARBER - M24 0104673

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665976

ORDER NO.

5716

20

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



5716 C6665976

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 #

6665976

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KA
600	Proof		9/30/91	KA
607	Check Headspace		9/30/91	KA
610	Dis-assemble Gun		9/30/91	KA
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	LL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KA
	Apply Coating (Bolt)		11/1/91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		11/26/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/26/91	KA
	C) Inspect Ejector Hole for Chamfer		11/26/91	KA
	D) Oil Firing Pin Ass'y		11/26/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		12/2/91	KA

op. #	BARBER - M24 0104675 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			12/2/91	JK
	G) Safety Off Force	3	3	3			12/2/91	JK
	H) Trigger Pull Test & Retainability						12/2/91	JK
	I) Firing Pin Indent	.0205	.0205	.0205			12/2/91	JK
	J) Assemble Stock						12/2/91	KS
	K) Assemble Swivel Studs						12-9-91	A
	L) Attach Front and Rear Sight Assemblies						12/2/91	KS
	M) Iron Sight Alignment						12/2/91	KS
	N) Detach Front & Rear Sights & place in numbered container						12/2/91	KS
	O) Attach Scope to Rifle						12/2/91	KS
	P) Detach & Attach Scope 20 Times						12/2/91	KS
640	Gallery Target & Test						12/3/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						12/3/91	KT
655	Final Inspection							
	A) Headspace						12-9-91	AC
	B) Trigger Pull	256	256	256	252	245	12-4-91	DH
	C) Function						12-9-91	AC
660	Pack							

TIME

BARBER - M24 0104676
STAMSWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6665976DATE 11-27-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.53	2.40	2.39	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.42	2.48	2.56	
PULL #3	2.23	2.43	2.44	2.56	
PULL #4	2.41	2.44	2.50	2.52	
PULL #5	2.37	2.44	2.48	2.45	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.21		
PULL #2	3.54	3.39		
PULL #3	3.39	3.36		
PULL #4	3.42	3.20		
PULL #5	3.24	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	4.20	4.33		4.35
PULL #2	4.23	4.20		4.28
PULL #3	4.31	4.30		4.40
PULL #4	4.31	4.22		4.36
PULL #5	4.25	4.34		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6685976
3 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.354035
1 TO 2	.360555
1 TO 3	.317668
1 TO 4	.586629
1 TO 5	.459809

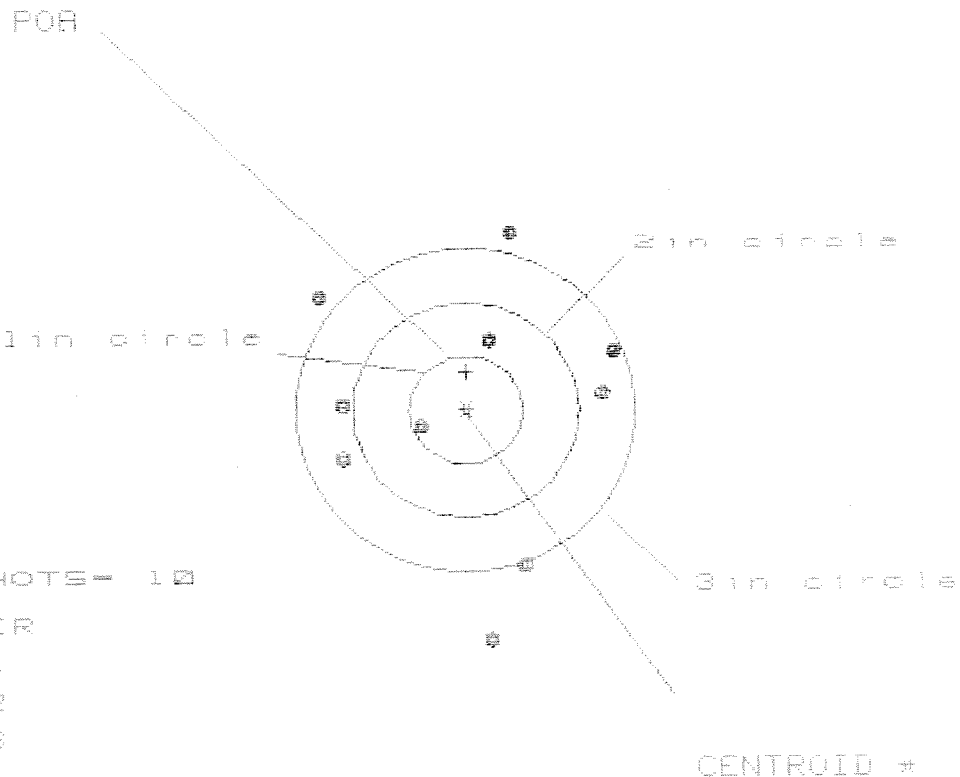
*5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1424
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0538
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .152224
THE AMR FOR THIS RIFLE IS: .9494

3 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665976

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 6

HS= 2.662

VS= 3.742

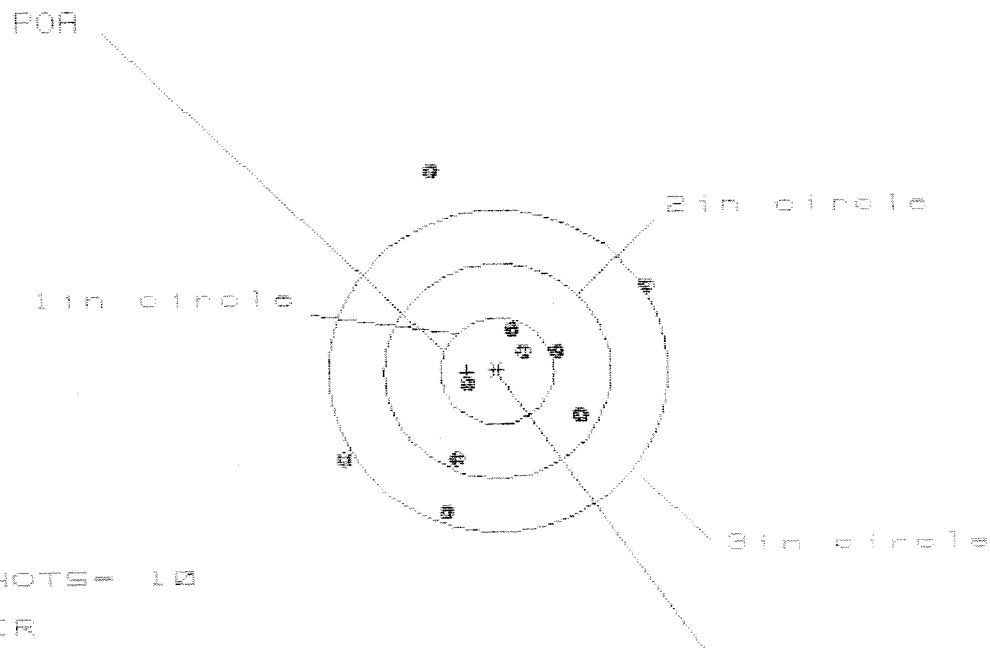
GS= 3.751

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.350	1.368	1.266
MINIMUM X	:	-1.312	-1.294	-1.279
MAXIMUM Y	:	1.643	1.409	1.516
MINIMUM Y	:	-2.099	-1.662	-1.554
CENTROID X	:	-.005	-.023	.139
CENTROID Y	:	-.354	-.120	-.228
POB TO CENTROID in.	:	.354	.122	.267
SPREAD	:	.390	.476	.526
SPREAD	:	1.308	1.199	1.152
SPREAD	:	2.106	1.751	1.603
SPREAD	:	2.662	2.662	2.485
SPREAD	:	3.742	3.071	3.071
SPREAD	:	3.751	3.123	3.073
ONE INCH CIRCLE	=		1	
TWO INCH CIRCLE	=		2	
THREE INCH CIRCLE	=		6	

3 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 7

HS= 2.706

VS= 3.174

GS= 3.175

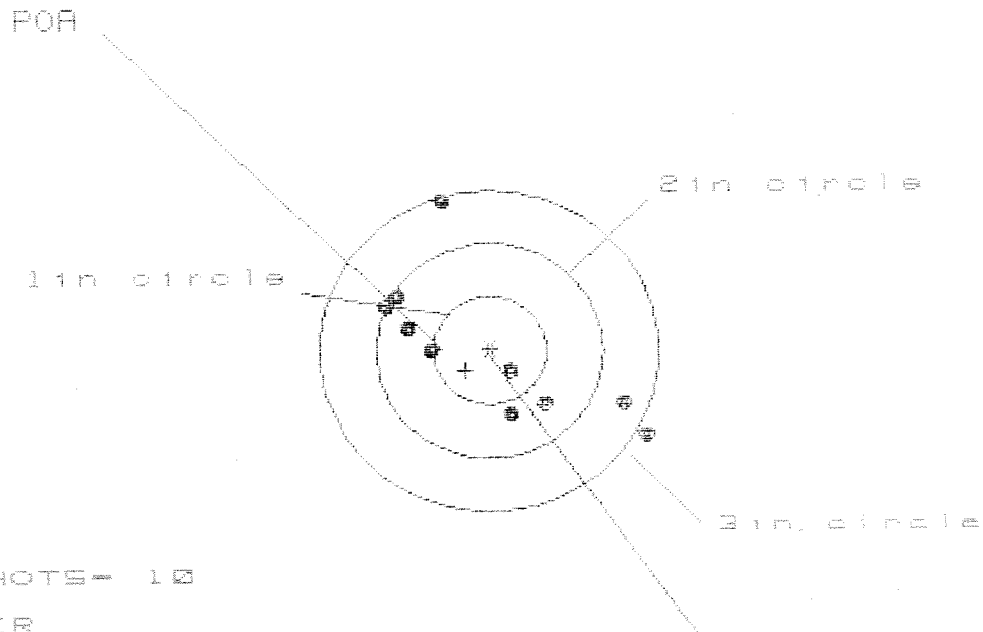
CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.338	1.277	1.099
MINIMUM X	:	-1.368	-1.429	-.714
MAXIMUM Y	:	1.889	1.011	.937
MINIMUM Y	:	-1.285	-1.075	-1.149
CENTROID X	:	.273	.334	.512
CENTROID Y	:	.012	-.198	-.124
POA TO CENTROID in.	:	.274	.388	.527
MIN RADIUS	:	.279	.358	.362
WEAR RADIUS	:	.985	.878	.769
PA RADIUS	:	1.966	1.629	1.444
HORIZONTAL SPREAD	:	2.706	2.706	1.812
VERTICAL SPREAD	:	3.174	2.086	2.086
EXTREME SPREAD	:	3.175	3.147	2.763
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Dec 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.258

VS= 2.261

GS= 2.876

CENTROID #

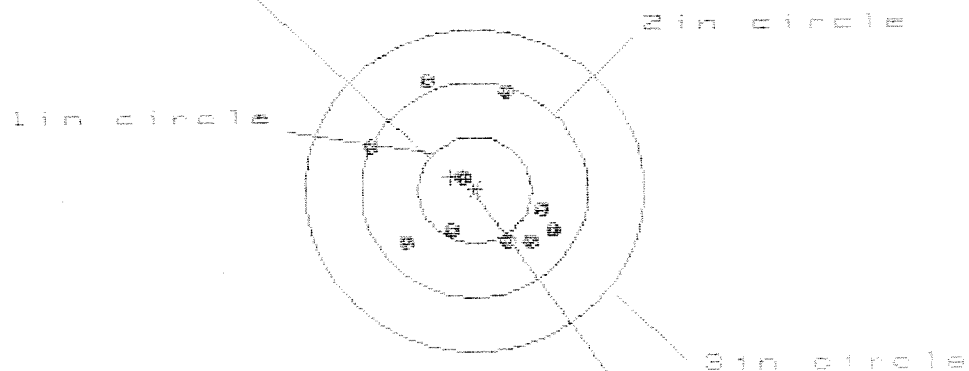
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.345	1.286	1.251
MINIMUM X	-.913	-.764	-.799
MAXIMUM Y	1.433	1.342	.617
MINIMUM Y	-.828	-.679	-.512
CENTROID X	.217	.068	.103
CENTROID Y	.189	.280	.113
POP TO CENTROID in.	.287	.288	.153
MIN RADIUS	.301	.382	.357
MEAN RADIUS	.915	.827	.742
MAX RADIUS	1.579	1.430	1.332
HORIZONTAL SPREAD	2.258	2.050	2.050
VERTICAL SPREAD	2.261	2.021	1.129
EXTREME SPREAD	2.876	2.516	2.273
NUMBER IN ONE INCH CIRCLE	= 1		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

3 Dec 1991

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CENTERFIRE PATTERNS # 3

POR



OF SHOTS- 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.629

VS= 1.491

GS= 1.783

CENTROID *

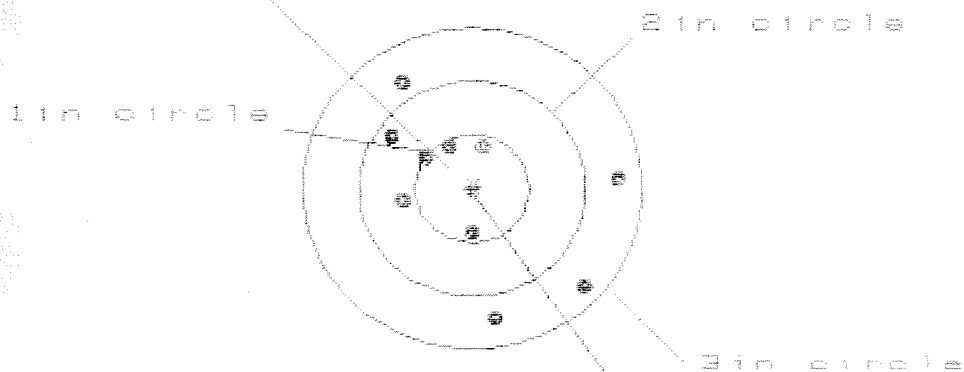
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.716	.669	.548
MINIMUM X	-.913	-.960	-.800
MAXIMUM Y	.977	.998	1.060
MINIMUM Y	-.514	-.405	-.343
CENTROID X	.212	.259	.380
CENTROID Y	-.122	-.231	-.293
POR TO CENTROID in.	.245	.347	.479
MIN RADIUS	.171	.287	.289
MEAN RADIUS	.700	.639	.557
MAX RADIUS	1.067	1.081	1.067
HORIZONTAL SPREAD	1.629	1.629	1.349
VERTICAL SPREAD	1.491	1.403	1.403
EXTREME SPREAD	1.783	1.783	1.678
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	9	
NUMBER IN THREE INCH CIRCLE	=	10	

3 Oct 1991

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CENTERFIRE PATTERNS # 2

FOR



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.276

VS= 2.251

GS= 2.519

CENTROID *

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM	1.321	1.430	.515
MINIMUM	-.755	-.646	-.468
MAXIMUM	1.007	.903	.895
MINIMUM	-1.244	-1.348	-1.355
CENTROID	.015	-.094	-.272
CENTROID	.006	.110	.117
FOR TO CENTROID	.016	.144	.297
MIN SPREAD	.376	.277	.256
MAX SPREAD	.839	.741	.619
MAX EAT	1.353	1.431	1.450
MIN EAT	2.076	2.076	.983
VERTICAL SPREAD	2.251	2.251	2.251
HORIZONTAL SPREAD	2.519	2.407	2.407
NUMBER OF SHOTS IN 1IN CIRCLE	=	3	
NUMBER OF SHOTS IN 2IN CIRCLE	=	6	
NUMBER OF SHOTS IN 3IN CIRCLE	=	10	