

BARBER - M24 0104719

FORM

UPC



0 47700 25716 7

06665980

*INCLUDES 1 IN CHAMBER

CAPACITY*

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104719 M2400104758

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

BARBER - M24 0104721

Remington



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

MODEL 700™ M24

SERIAL NO.

C6665980

ORDER NO.

5716

20

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



5716 C6665980

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665980

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KA
600	Proof		9/25/91	KA
607	Check Headspace		9/25/91	KA
610	Dis-assemble Gun		9/25/91	KA
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	GB
617	Drill and Tap Sight Holes		OCT 2 1991	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14/91	KA
	Apply Coating (Bolt)		10-14/91	KA
625	Final Assembly A) Clean inside of Bolt Assembly		10/30/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/30/91	KA
	C) Inspect Ejector Hole for Chamfer		10/30/91	KA
	D) Oil Firing Pin Ass'y		10/30/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	KA

op. #	BARBER M24 0104723	READINGS				DATE	INIT
625 cont.	F) Safety On Force	4	4	4		10/31/91	SH
	G) Safety Off Force	3	3	3		10/31/91	SH
	H) Trigger Pull Test & Retainability					10/31/91	SH
	I) Firing Pin Indent	020	020	020		10/31/91	SH
	J) Assemble Stock					10/31/91	SH
	K) Assemble Swivel Studs					11-12-91	SH
	L) Attach Front and Rear Sight Assemblies					10/31/91	SH
	M) Iron Sight Alignment					10/31/91	SH
	N) Detach Front & Rear Sights & place in numbered container					10/31/91	SH
	O) Attach Scope to Rifle					10/31/91	SH
	P) Detach & Attach Scope 20 Times					10/31/91	SH
640	Gallery Target & Test					11-1-91	DH
	A) Time					11-1-91	DH
	B) Malfunctions					11-1-91	DH
	C) Pierced Primers					11-1-91	DH
	D) Optical Clarity of Scope					11-1-91	DH
645	Inspect for Live Ammo					11-1-91	DH
655	Final Inspection						
	A) Headspace					11-12-91	SH
	B) Trigger Pull	278	275	277	269	267	11-5-91
	C) Function					11-12-91	SH
660	Pack					12-14-91	SH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665980

DATE 10/31/81

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.42	2.40	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.44	2.51	2.75	
PULL #3	2.32	2.39	2.55	2.77	
PULL #4	2.40	2.50	2.43	2.69	
PULL #5	2.40	2.45	2.44	2.67	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.23		
PULL #2	3.39	3.36		
PULL #3	3.34	3.34		
PULL #4	3.35	3.31		
PULL #5	3.34	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.54	4.27		4.40
PULL #2	4.25	4.29		4.26
PULL #3	4.31	4.26		4.31
PULL #4	4.38	4.38		4.31
PULL #5	4.36	4.40		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665980
1 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.25297
1 TO	2	.34603
1 TO	3	.174428
1 TO	4	.273057
1 TO	5	.787001

5
138 <----FOR

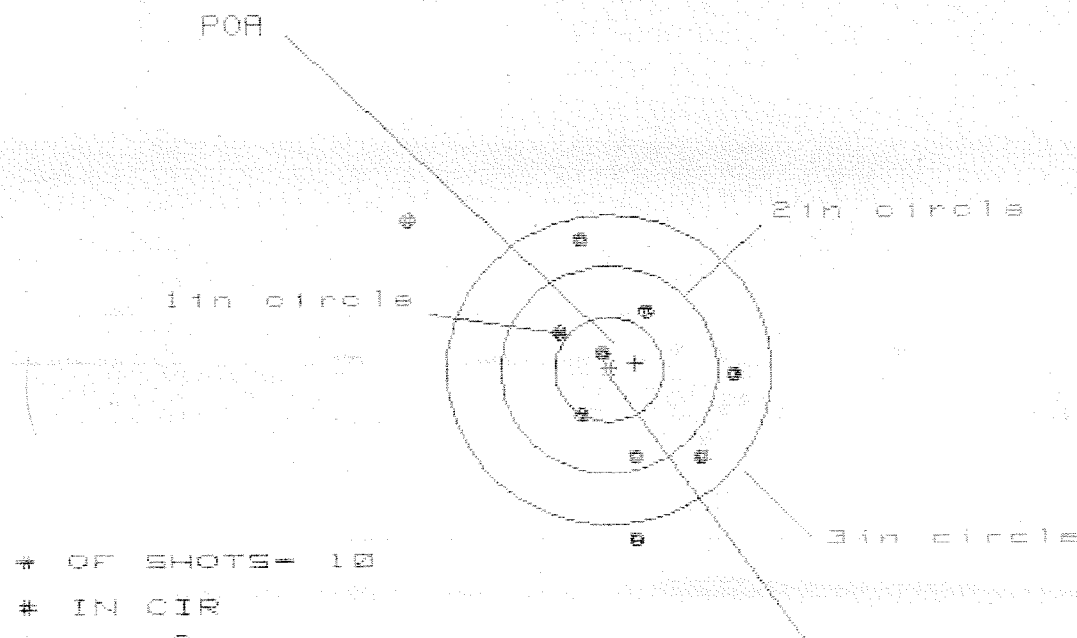
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0014
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0806
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0806127

THE ANR FOR THIS RIFLE IS: 1.007

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665380

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.944

VS = 3.148

CS = 3.734

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.139	.938	.938
MINIMUM X	-1.885	-.664	-.664
MAXIMUM Y	1.464	1.441	1.251
MINIMUM Y	-1.684	-1.522	-.910
CENTROID X	-.245	-.044	-.044
CENTROID Y	-.063	-.225	-.035
POA TO CENTROID in.	.252	.229	.057
MIN RADIUS	.218	.455	.319
MEAN RADIUS	1.056	.915	.819
MAX RADIUS	2.324	1.522	1.327
HORIZONTAL SPREAD	2.944	1.602	1.602
VERTICAL SPREAD	3.148	2.963	2.161
EXTREME SPREAD	3.734	2.996	2.421
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865380

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.8009

VS= 1.8001

GS= 2.817

CENTROID #

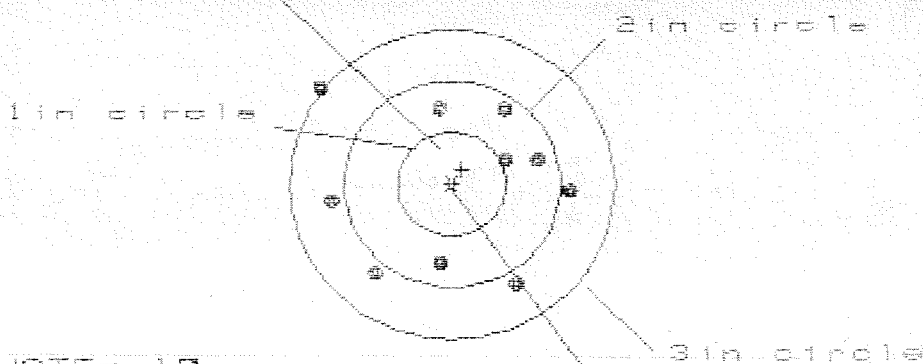
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.896	.683	.609
MINIMUM X	:	-1.913	-.803	-.877
MAXIMUM Y	:	1.044	.984	.505
MINIMUM Y	:	-.757	-.817	-.695
CENTROID X	:	.071	.284	.358
CENTROID Y	:	.078	.138	.015
POA TO CENTROID in.	:	.106	.316	.358
MIN RADIUS	:	.375	.155	.190
MEAN RADIUS	:	.844	.674	.509
MAX RADIUS	:	1.989	1.146	.878
HORIZONTAL SPREAD	:	2.809	1.486	1.486
VERTICAL SPREAD	:	1.801	1.801	1.199
EXTREME SPREAD	:	2.817	2.013	1.517
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865380

CENTERFIRE PATTERNS # 3

FOR



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.275

VS= 1.936

GS= 2.617

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.075	.941	.995
MINIMUM X	:	-1.200	-1.248	-1.194
MAXIMUM Y	:	.927	.842	.729
MINIMUM Y	:	-1.009	-.906	-.843
CENTROID X	:	-.088	.046	-.008
CENTROID Y	:	-.139	-.242	-.129
POA TO CENTROID in.	:	.165	.247	.129
MIN RADIUS	:	.489	.440	.414
MEAN RADIUS	:	.964	.884	.858
MAX RADIUS	:	1.517	1.249	1.208
HORIZONTAL SPREAD	:	2.275	2.189	2.189
VERTICAL SPREAD	:	1.936	1.748	1.572
EXTREME SPREAD	:	2.617	2.193	2.193
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665980

CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.327

VS= 2.887

GS= 3.094

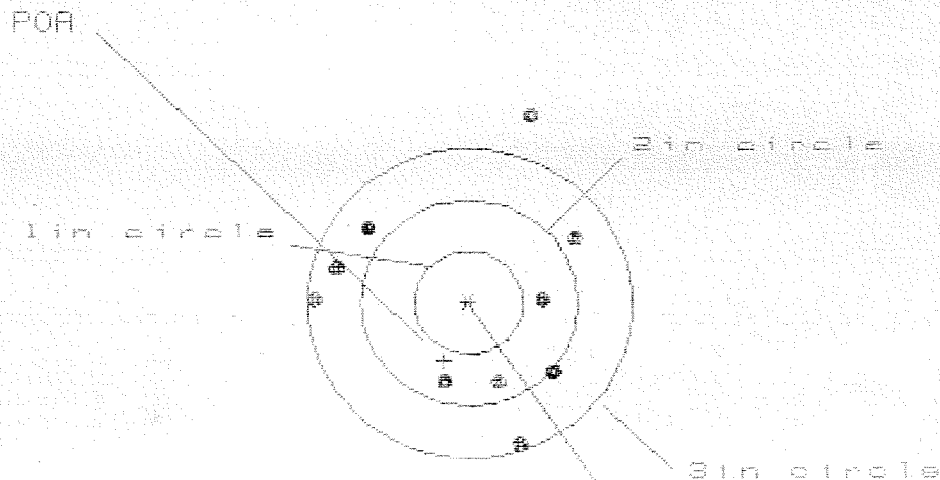
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.182	1.252	1.151
MINIMUM X	:	-1.145	-1.075	-.919
MAXIMUM Y	:	1.203	1.016	.880
MINIMUM Y	:	-1.684	-1.347	-1.220
CENTROID X	:	.027	-.043	-.199
CENTROID Y	:	-.039	.148	.021
POR TO CENTROID in.	:	.048	.154	.200
MIN RADIUS	:	.310	.207	.192
MEAN RADIUS	:	.999	.883	.792
MAX RADIUS	:	1.798	1.612	1.271
HORIZONTAL SPREAD	:	2.327	2.327	2.070
VERTICAL SPREAD	:	2.887	2.363	2.100
EXTREME SPREAD	:	3.094	2.950	2.142
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

1 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8885960

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS= 2.395

VS= 3.147

GS= 3.150

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.964	1.030	.960
MINIMUM X	:	-1.431	-1.365	-1.313
MAXIMUM Y	:	1.825	.952	.979
MINIMUM Y	:	-1.322	-1.119	-1.092
CENTROID X	:	.228	.162	.332
CENTROID Y	:	.566	.363	.336
POA TO CENTROID in.	:	.610	.397	.473
MIN RADIUS	:	.656	.610	.600
MEAN RADIUS	:	1.172	1.059	.986
MAX RADIUS	:	1.920	1.381	1.447
HORIZONTAL SPREAD	:	2.395	2.395	2.173
VERTICAL SPREAD	:	3.147	2.071	2.071
EXTREME SPREAD	:	3.150	2.479	2.479
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	9		