

BARBER - M24 0104897

FORM

UPC



0 47700 25716 7

INCLUDES 1 IN CHAMBER
C6666004

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104897 04936

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0104899

Remington



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

MODEL 700TM M24

SERIAL NO.

C6666004

20

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

ORDER NO.

5716



5716 C6666004

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6666004

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KA
600	Proof		10/1/91	KA
607	Check Headspace		10/1/91	KA
610	Dis-assemble Gun		10/1/91	KA
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	JS
617	Drill and Tap Sight Holes		OCT 8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-1-91	KA
	Apply Coating (Bolt)			
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		11-27-91	JS

op. #	OP. NAME BARBER M24 0104901	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	11-27-91	QU
	G) Safety Off Force	3	3	3	11-27-91	QU
	H) Trigger Pull Test & Retainability				11-27-91	QU
	I) Firing Pin Indent	.021	.021	.0215	11-27-91	QU
	J) Assemble Stock				11/27/91	QU
	K) Assemble Swivel Studs				12-3-91	KE
	L) Attach Front and Rear Sight Assemblies				11/27/91	QU
	M) Iron Sight Alignment				11/27/91	QU
	N) Detach Front & Rear Sights & place in numbered container				11/27/91	QU
	O) Attach Scope to Rifle				11/27/91	QU
	P) Detach & Attach Scope 20 Times				11/27/91	QU
640	Gallery Target & Test				12-2-91	AC
	A) Time				12-2-91	AC
	B) Malfunctions				12-2-91	AC
	C) Pierced Primers				12-2-91	AC
	D) Optical Clarity of Scope				12-2-91	AC
645	Inspect for Live Ammo				12-2-91	AC
655	Final Inspection					
	A) Headspace				12-3-91	KE
	B) Trigger Pull	267	265	274	12-2-91	D/L
	C) Function				12-3-91	KE
660	Pack				12-20-91	N-

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 0666004

DATE 11-27-91

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.59	2.50	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.52	2.48	2.65	
PULL #3	2.55	2.69	2.58	2.74	
PULL #4	2.55	2.64	2.61	2.43	
PULL #5	2.43	2.56	2.60	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.66		
PULL #2	3.69	3.43		
PULL #3	3.53	3.66		
PULL #4	3.33	3.61		
PULL #5	3.66	3.68		
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	4.56		4.57
PULL #2	4.51	4.21		4.30
PULL #3	4.32	4.30		4.31
PULL #4	4.26	4.56		4.37
PULL #5	4.32	4.40		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666004
3 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.228355
1 TO	2	.275525
1 TO	3	.0739256
1 TO	4	.284114
1 TO	5	.285449

5₄

<----FOA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1076
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .113
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156034

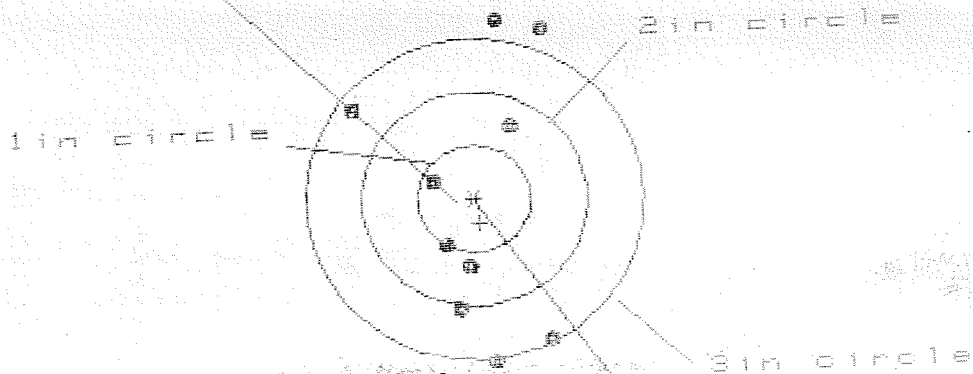
THE AMR FOR THIS RIFLE IS: .8496

2 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665004

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 4

3 in - 5

HS- 1.712

VS- 3.176

GS- 3.176

CENTROID #

PATTERN #

1

SHOTS (BEST OF)

		10	9	8
MAXIMUM X	:	.621	.685	.721
MINIMUM X	:	-1.091	-1.022	-.985
MAXIMUM Y	:	1.643	1.817	1.298
MINIMUM Y	:	-1.533	-1.359	-1.132
CENTROID X	:	-.039	-.108	-.144
CENTROID Y	:	.225	.051	-.176
POA TO CENTROID in.	:	.229	.119	.228
MIN RADIUS	:	.362	.362	.194
MEAN RADIUS	:	1.103	1.000	.838
MAX RADIUS	:	1.686	1.841	1.630
HORIZONTAL SPREAD	:	1.712	1.707	1.707
VERTICAL SPREAD	:	3.176	3.176	2.430
EXTREME SPREAD	:	3.176	3.176	2.791
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666004

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

CENTROID *

HS = 2.107

VS = 2.347

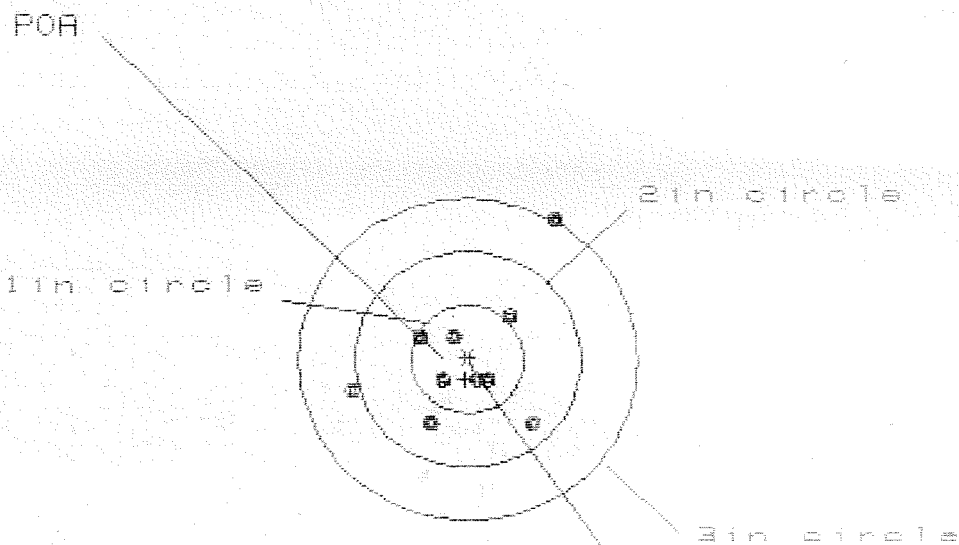
GS = 2.452

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.930	.801	.883
MINIMUM X	:	-1.177	-1.074	-.992
MAXIMUM Y	:	1.282	1.164	.869
MINIMUM Y	:	-1.065	-.993	-.848
CENTROID X	:	-.056	-.159	-.241
CENTROID Y	:	-.050	.068	-.077
POA TO CENTROID in.	:	.075	.173	.253
MIN RADIUS	:	.189	.236	.091
MEAN RADIUS	:	.872	.918	.729
MAX RADIUS	:	1.414	1.336	1.077
HORIZONTAL SPREAD	:	2.107	1.875	1.875
VERTICAL SPREAD	:	2.347	2.157	1.717
EXTREME SPREAD	:	2.452	2.446	2.079
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Dec 1951

FILE:/PATTERNING/CENTERFIRE_PATT/08606004

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 1.825

VS= 1.928

GS= 2.398

CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.815	.675	.560
MINIMUM X	:	-1.010	-.920	-.437
MAXIMUM Y	:	1.295	.536	.522
MINIMUM Y	:	-.633	-.490	-.504
CENTROID X	:	.025	-.065	.050
CENTROID Y	:	.188	.045	.059
POA TO CENTROID in.	:	.190	.079	.077
MIN RADIUS	:	.219	.158	.093
MEAN RADIUS	:	.615	.493	.427
MAX RADIUS	:	1.529	.927	.728
HORIZONTAL SPREAD	:	1.825	1.595	.997
VERTICAL SPREAD	:	1.928	1.026	1.026
EXTREME SPREAD	:	2.398	1.630	1.298
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08666004

CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.649

VS = 2.476

GS = 2.483

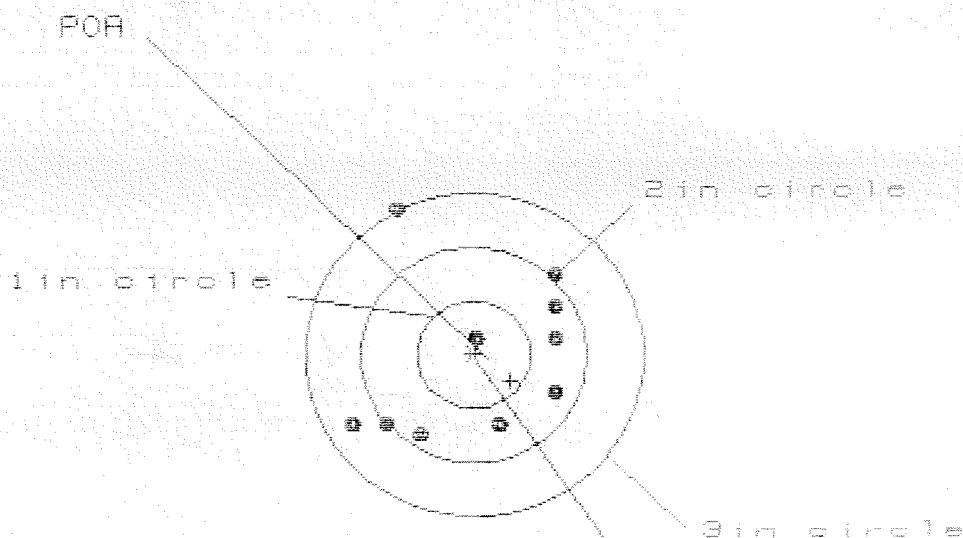
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.154	.249	.170
MINIMUM X	:	-.495	-.367	-.306
MAXIMUM Y	:	1.259	1.180	.800
MINIMUM Y	:	-1.217	-1.296	-1.148
CENTROID X	:	-.144	-.272	-.303
CENTROID Y	:	-.039	.040	-.108
POR TO CENTROID in.	:	.149	.275	.322
MIN RADIUS	:	.284	.248	.226
MEAN RADIUS	:	.770	.686	.617
MAX RADIUS	:	1.354	1.298	1.153
HORIZONTAL SPREAD	:	1.649	.616	.506
VERTICAL SPREAD	:	2.476	2.476	1.949
EXTREME SPREAD	:	2.483	2.483	1.951
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

2 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86666004

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.758

VS= 2.138

GS= 2.231

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.720	.640	.580
MINIMUM X	-1.038	-1.118	-1.044
MAXIMUM Y	1.385	.895	.838
MINIMUM Y	-.753	-.599	-.656
CENTROID X	-.324	-.244	-.104
CENTROID Y	.241	.087	.144
POA TO CENTROID in.	.404	.259	.177
MIN RADIUS	.175	.328	.326
MEAN RADIUS	.888	.796	.719
MAX RADIUS	1.564	1.207	1.174
HORIZONTAL SPREAD	1.758	1.758	1.544
VERTICAL SPREAD	2.138	1.494	1.494
EXTREME SPREAD	2.231	2.217	2.067
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		