

BARBER - M24 0008899

Stead®

C6498850

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0008899 M240008938

Remington®
REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

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

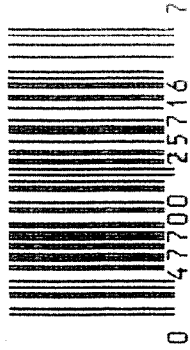
SERIAL NO.
C6498850

ORDER NO.
5716

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



LPC



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498850

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 12 90		RW
600	Proof	7 12 90		RW
607	Check Headspace	7 12 90		RW
610	Dis-assemble Gun	7 12 90		RW
612	Magnaflux Barrel Action		7-17-90	KR
	Magnaflux Bolt		7-17-90	KR
615	Rollmark Caliber		7-17-90	L.S.
617	Drill and Tap Sight Holes		7/23/90	FB
618	Polish Barrel RB		7/24/90	WB
620	Apply Coatings (Barrel Action)		8/6/90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		8/22/90	AC

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/22/90	WB
	G) Safety Off Force	2	2	2			8/22/90	WB
	H) Trigger Pull Test & Retainability						8/22/90	AC
	I) Firing Pin Indent	.023	.0225	.023			8/22/90	WB
	J) Assemble Stock						8/22/90	KS
	K) Assemble Swivel Studs						8/31/90	JS
	L) Attach Front and Rear Sight Assemblies						8/22/90	KS
	M) Iron Sight Alignment						8/22/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/22/90	KS
	O) Attach Scope to Rifle						8/22/90	KS
	P) Detach & Attach Scope 20 Times						8/22/90	KS
640	Gallery Target & Test						8/23/90	NF
	A) Time						8/23/90	NF
	B) Malfunctions						8/23/90	NF
	C) Pierced Primers						8/23/90	NF
	D) Optical Clarity of Scope						8/23/90	NF
645	Inspect for Live Ammo						8/23/90	NF
655	Final Inspection							
	A) Headspace						8/31/90	JS
	B) Trigger Pull	2.54	2.46	2.48	2.45	2.43	8/31/90	JS
	C) Function						8/31/90	JS
660	Pack						9/20/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6498850

DATE Aug 22, 1990

TESTER A.C.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.22	2.11	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.22	2.14	2.46	
PULL #3	2.29	2.27	2.20	2.48	
PULL #4	2.29	2.22	2.16	2.45	
PULL #5	2.31	2.20	2.06	2.43	
TOTAL	11.47	11.13	10.67	12.36	
AVG.	2.29	2.22	2.13	2.472	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.15		
PULL #2	3.16	3.19		
PULL #3	3.21	3.23		
PULL #4	3.25	3.22		
PULL #5	3.09	3.14		
TOTAL	15.91	15.93		
AVG.	3.18	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.29		4.13
PULL #2	4.26	4.34		4.21
PULL #3	4.22	4.43		4.30
PULL #4	4.31	4.38		4.25
PULL #5	4.29	4.44		4.38
TOTAL	21.37	21.88		21.27
AVG.	4.27	4.37		4.25

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498850
24 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.966686
1 TO	2	.814629
1 TO	3	.469248
1 TO	4	1.67548
1 TO	5	1.39838

$\frac{1}{5} \sum_{i=1}^5 x_i = \text{---POI}$
 $\frac{1}{5} \sum_{i=1}^5 y_i$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .087
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1564
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .178969

THE AMR FOR THIS RIFLE IS: .8918

24 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06498850

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.220

VS= 2.478

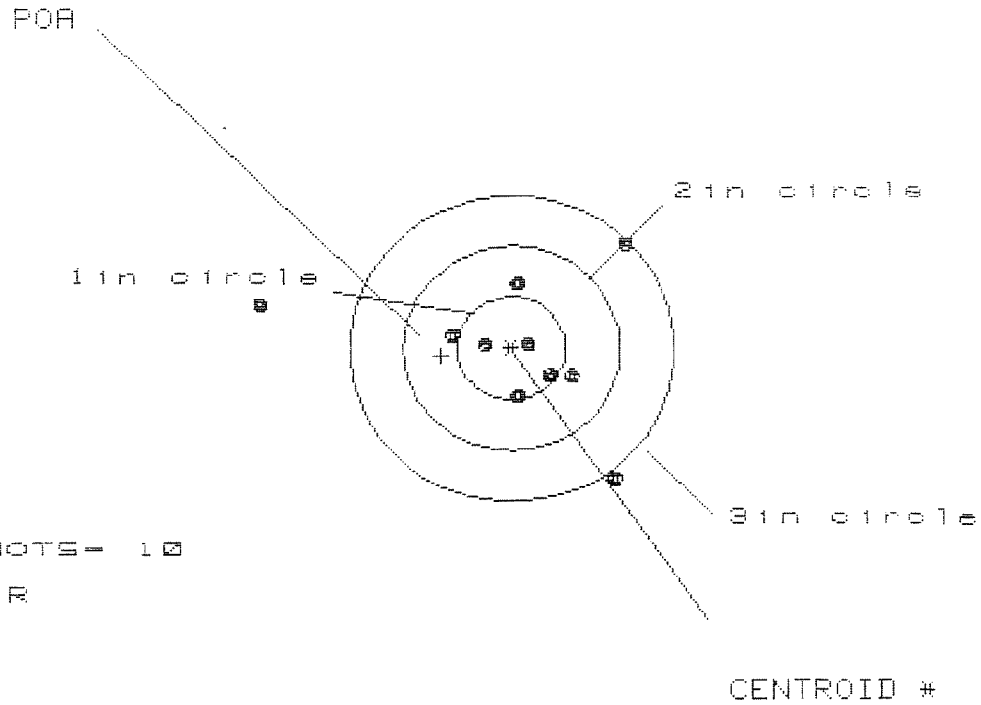
GS= 2.902

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.968	.829	.885
MINIMUM X	:	-1.252	-.876	-.820
MAXIMUM Y	:	1.363	1.265	.704
MINIMUM Y	:	-1.115	-1.213	-1.055
CENTROID X	:	.616	.755	.699
CENTROID Y	:	-.745	-.647	-.805
POA TO CENTROID in.	:	.967	.995	1.066
MIN RADIUS	:	.231	.333	.166
MEAN RADIUS	:	.872	.811	.720
MAX RADIUS	:	1.530	1.425	1.327
HORIZONTAL SPREAD	:	2.220	1.705	1.705
VERTICAL SPREAD	:	2.478	2.478	1.759
EXTREME SPREAD	:	2.902	2.496	2.154
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 8

HS = 3.444

VS = 2.293

CS = 3.801

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.054	.789	.877
MINIMUM X	:	-2.390	-.770	-.682
MAXIMUM Y	:	.981	1.033	.875
MINIMUM Y	:	-1.311	-1.260	-.526
CENTROID X	:	.648	.913	.825
CENTROID Y	:	.069	.018	.176
POA TO CENTROID in.	:	.651	.913	.843
MIN RADIUS	:	.114	.190	.094
MEAN RADIUS	:	.839	.653	.545
MAX RADIUS	:	2.434	1.445	1.239
HORIZONTAL SPREAD	:	3.444	1.559	1.559
VERTICAL SPREAD	:	2.293	2.293	1.401
EXTREME SPREAD	:	3.801	2.294	1.799
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 9

HS = 2.657

VS = 3.158

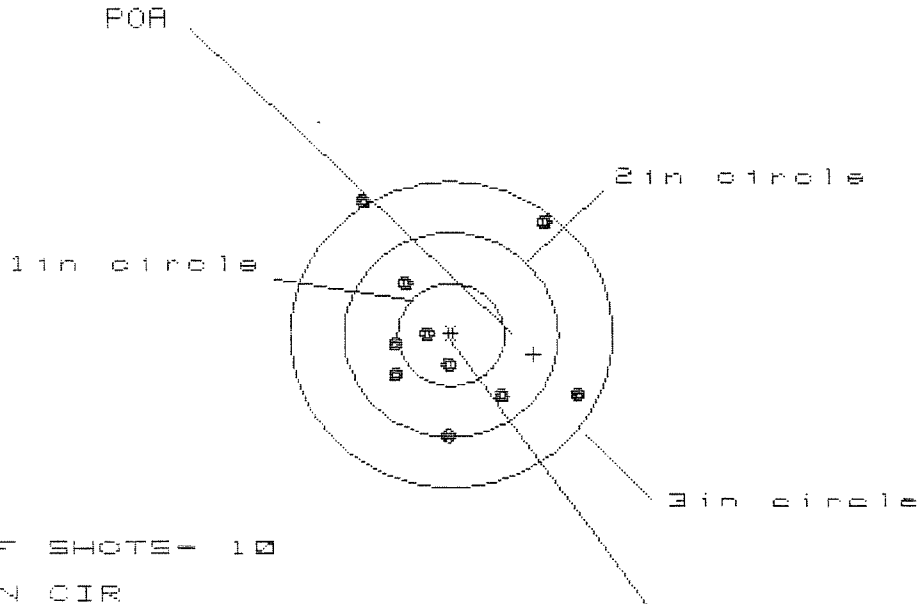
GS = 3.468

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.410
MINIMUM X	-1.247
MAXIMUM Y	1.074
MINIMUM Y	-2.084
CENTROID X	.151
CENTROID Y	-.682
POA TO CENTROID in.	.698
MIN RADIUS	.283
MEAN RADIUS	.971
MAX RADIUS	2.150
HORIZONTAL SPREAD	2.657
VERTICAL SPREAD	3.158
EXTREME SPREAD	3.468
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.950

VS= 2.368

GS= 2.759

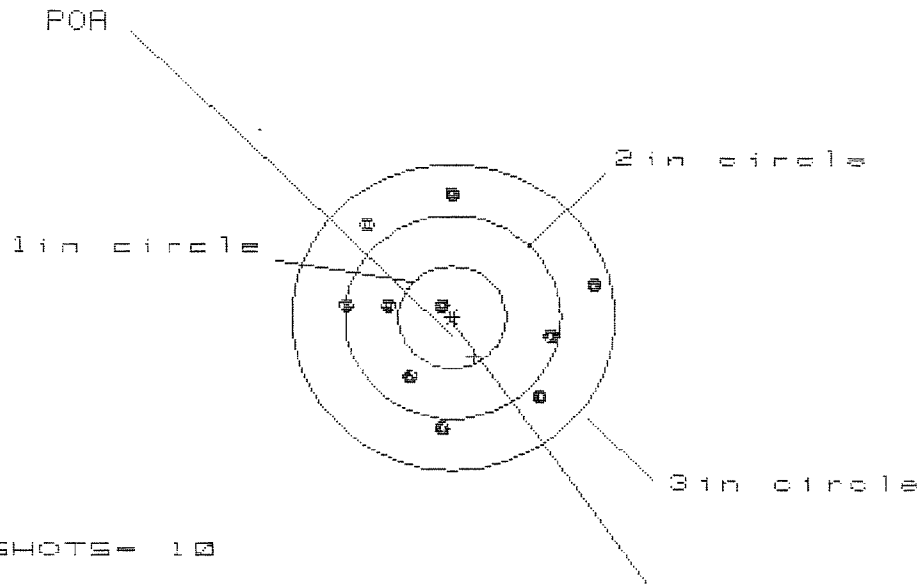
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.164	1.077	1.176
MINIMUM X	:	-.786	-.641	-.542
MAXIMUM Y	:	1.342	1.272	.781
MINIMUM Y	:	-1.026	-.877	-.718
CENTROID X	:	-.775	-.688	-.787
CENTROID Y	:	.189	.040	-.119
POA TO CENTROID in.	:	.798	.689	.796
MIN RADIUS	:	.271	.177	.021
MEAN RADIUS	:	.840	.745	.603
MAX RADIUS	:	1.555	1.497	1.214
HORIZONTAL SPREAD	:	1.950	1.718	1.718
VERTICAL SPREAD	:	2.368	2.149	1.499
EXTREME SPREAD	:	2.759	2.343	1.887
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.252

VS= 2.367

GS= 2.372

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.283	1.024	1.047
MINIMUM X	:	-.969	-.827	-.804
MAXIMUM Y	:	1.237	1.273	1.074
MINIMUM Y	:	-1.130	-1.094	-.935
CENTROID X	:	-.285	-.347	-.370
CENTROID Y	:	.387	.351	.192
POA TO CENTROID in.	:	.437	.494	.417
MIN RADIUS	:	.140	.117	.277
MEAN RADIUS	:	.937	.869	.814
MAX RADIUS	:	1.322	1.286	1.238
HORIZONTAL SPREAD	:	2.252	1.851	1.851
VERTICAL SPREAD	:	2.367	2.367	2.009
EXTREME SPREAD	:	2.372	2.372	2.298
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	