

BARBER - M24 0030708

FORM

UPC



0 47700 25716 7

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

C6649020

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0030708

5716

ORDER NO.

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6649020

20

ORDER NO.
5716

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



5716 C6649020

ORDER 5716
MODEL 700 TM M24
UPC

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649020

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	9 1	RW
600	Proof	9 26	9 1	RW
607	Check Headspace	9 26	9 1	RW
610	Dis-assemble Gun	9 26	9 1	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/18/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	RW
	C) Inspect Ejector Hole for Chamfer		10/18/91	RW
	D) Oil Firing Pin Ass'y		10/18/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/13/91	JH

op. #	BARBER M24 0030712	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-18-91	D/H
	G) Safety Off Force	2 1/2	2	2			11-18-91	D/H
	H) Trigger Pull Test & Retainability						11-18-91	SL
	I) Firing Pin Indent	.020	.020	.020			11-18-91	D/H
	J) Assemble Stock						11/19/91	RW
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/19/91	RW
	M) Iron Sight Alignment						11/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/19/91	RW
	O) Attach Scope to Rifle						11/19/91	RW
	P) Detach & Attach Scope 20 Times						11/19/91	RW
640	Gallery Target & Test						11-21-91	AC
	A) Time						11-21-91	AC
	B) Malfunctions						11-21-91	AC
	C) Pierced Primers						11-21-91	AC
	D) Optical Clarity of Scope						11-21-91	AC
645	Inspect for Live Ammo						11-21-91	AC
655	Final Inspection A) Headspace						11-27-91	D/H
	B) Trigger Pull	2.60	2.60	2.56	2.57	2.39	11-25-91	SL
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649020

DATE 11-18-91

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.43	2.40	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.30	2.48	2.60	
PULL #3	2.35	2.44	2.43	2.56	
PULL #4	2.39	2.36	2.41	2.57	
PULL #5	2.39	2.37	2.39	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.57	3.42		
PULL #2	3.40	3.59		
PULL #3	3.48	3.59		
PULL #4	3.32	3.52		
PULL #5	3.41	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	4.44	4.30		4.29
PULL #2	4.27	4.36		4.29
PULL #3	4.35	4.39		4.46
PULL #4	4.34	4.46		4.34
PULL #5	4.41	4.37		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649020
21 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.449018
1 TO	2	.444397
1 TO	3	.718816
1 TO	4	.614044
1 TO	5	.301692

43
50 <----POR
1

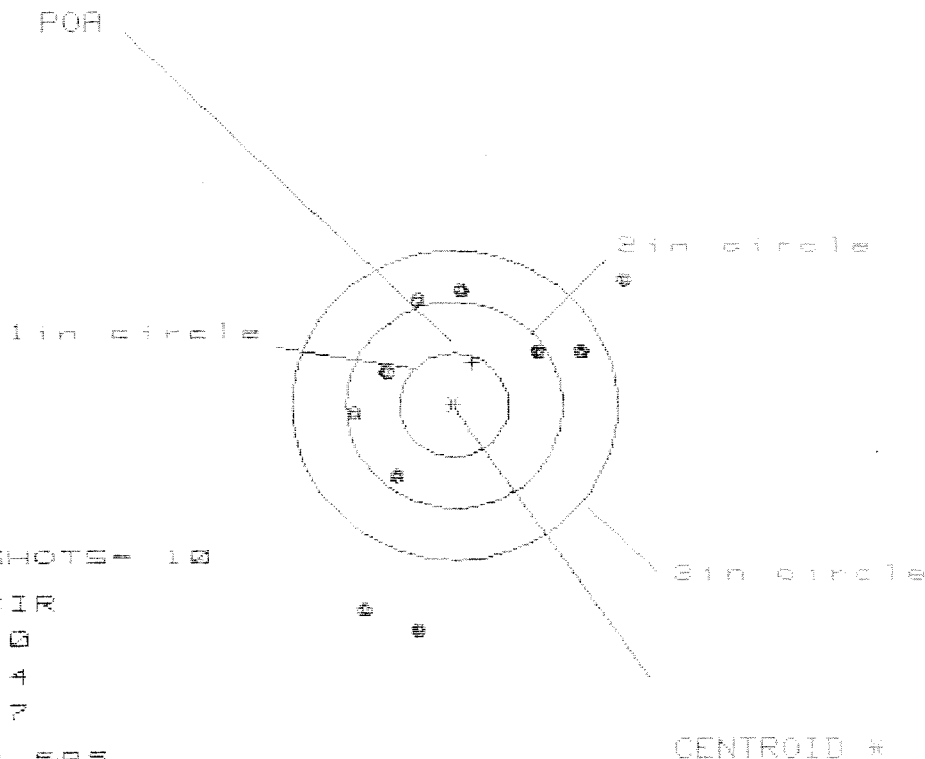
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0074
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0704
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0755440

THE AMR FOR THIS RIFLE IS: 1.135

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849020

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS= 2.585

VS= 3.439

GS= 4.036

CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.606	1.570	1.459
MINIMUM X	:	-0.979	-1.015	-1.126
MAXIMUM Y	:	1.264	1.023	.750
MINIMUM Y	:	-2.175	-2.182	-1.154
CENTROID X	:	-0.169	-0.133	-0.022
CENTROID Y	:	-0.416	-0.175	.099
POA TO CENTROID in.	:	.449	.230	.101
MIN RADIUS	:	.720	.678	.633
MEAN RADIUS	:	1.333	1.193	1.005
MAX RADIUS	:	2.198	2.356	1.641
HORIZONTAL SPREAD	:	2.585	2.585	2.585
VERTICAL SPREAD	:	3.439	3.205	1.904
EXTREME SPREAD	:	4.039	4.039	2.895
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	7		

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649020

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 5

3in = 8

HS = 2.953

VS = 2.570

GS = 2.939

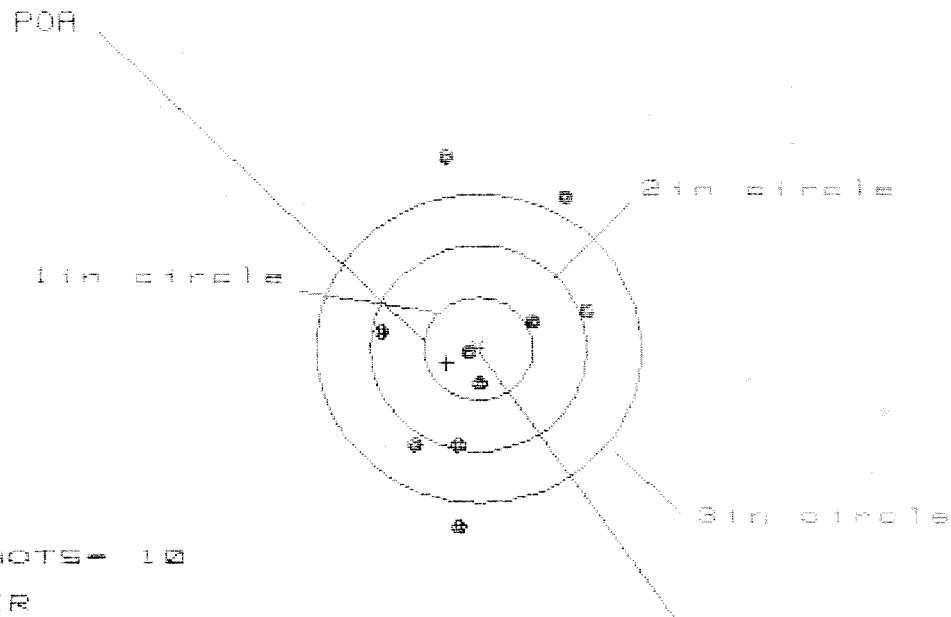
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.217	1.036	.911
MINIMUM X	:	-1.636	-1.154	-1.279
MAXIMUM Y	:	1.302	1.325	1.169
MINIMUM Y	:	-1.268	-1.245	-.806
CENTROID X	:	.123	.304	.429
CENTROID Y	:	-.081	-.104	.052
POR TO CENTROID in.	:	.147	.322	.432
MIN RADIUS	:	.638	.564	.545
MEAN RADIUS	:	1.093	1.005	.909
MAX RADIUS	:	1.649	1.596	1.280
HORIZONTAL SPREAD	:	2.853	2.190	2.190
VERTICAL SPREAD	:	2.570	2.570	1.975
EXTREME SPREAD	:	2.939	2.674	2.270
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8549020

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 7

HS = 1.924

VS = 3.611

GS = 3.616

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.014	.977	.954
MINIMUM X	:	-.910	-.947	-.970
MAXIMUM Y	:	1.847	1.667	1.472
MINIMUM Y	:	-1.764	-1.559	-1.962
CENTROID X	:	.295	.332	.355
CENTROID Y	:	.133	-.072	.123
POA TO CENTROID in.	:	.323	.340	.376
MIN RADIUS	:	.119	.188	.167
MEAN RADIUS	:	1.040	.919	.846
MAX RADIUS	:	1.877	1.819	1.632
HORIZONTAL SPREAD	:	1.924	1.924	1.924
VERTICAL SPREAD	:	3.611	3.226	2.434
EXTREME SPREAD	:	3.616	3.352	2.715
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649020

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.507

VS= 3.338

GS= 3.366

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.442	1.540	1.514
MINIMUM X	:	-1.065	-0.905	-0.931
MAXIMUM Y	:	1.706	1.827	0.795
MINIMUM Y	:	-1.632	-1.511	-1.282
CENTROID X	:	.110	-.050	-.024
CENTROID Y	:	.131	.010	-.219
POA TO CENTROID in.	:	.171	.051	.320
MIN RADIUS	:	.328	.233	.091
MEAN RADIUS	:	1.114	.997	.879
MAX RADIUS	:	1.910	1.839	1.607
HORIZONTAL SPREAD	:	2.507	2.445	2.445
VERTICAL SPREAD	:	3.338	3.338	2.077
EXTREME SPREAD	:	3.366	3.366	2.446
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B49620

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS= 2.774

VS= 3.329

GS= 3.337

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.223	1.267	1.311
MINIMUM X	:	-1.551	-1.567	-1.696
MAXIMUM Y	:	1.531	1.331	1.303
MINIMUM Y	:	-1.798	-1.449	-1.477
CENTROID X	:	-.222	-.206	-.010
CENTROID Y	:	-.119	.031	.109
POA TO CENTROID in.	:	.252	.221	.169
MIN RADIUS	:	.314	.115	.231
MEAN RADIUS	:	1.094	.991	.917
MAX RADIUS	:	1.804	1.583	1.478
HORIZONTAL SPREAD	:	2.774	2.774	1.707
VERTICAL SPREAD	:	3.329	2.780	2.780
EXTREME SPREAD	:	3.337	2.845	2.781
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	