

BARBER - M24 0030961

SMITH & WESSLEY

FORM

UPC



0 47700 25716 7

C6649041

CAPACITY*
*INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0030961 M2400031000

ORDER NO. 5715

TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649041

ORDER NO.

5716

20

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



5716 C6649041

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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MOD. _____		GA. CAL. _____	GUN # <u>6649041</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>operator sticks</i>	<i>RW</i>
	2nd	<i>Repaired</i> <i>K.S.</i>	
	3rd	<i>100 Rds test</i> <i>AC OK</i> <i>12-12-91</i>	
	4th		
		FUNCTION	RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	100 Rd test OK 12-12-91	
TEST AC		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649041

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 2	9 1	RW
612	Magnaflux Barrel Action	OCT	3 1991	KCR
	Magnaflux Bolt	OCT	3 1991	KCR
615	Rollmark Caliber	OCT	3 1991	EG
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	TH
	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		11-11-91	gcl

625 BARBER M24 0030967 cont.	Force	4	4	4	11-11-91	JH		
G) Safety Off Force		3	3	3	11-11-91	JH		
H) Trigger Pull Test & Retainability					11-11-91	JH		
I) Firing Pin Indent		.020	.0205	.0205	11-11-91	JH		
J) Assemble Stock					11/13/91	RW		
K) Assemble Swivel Studs					12-12-91	JH		
L) Attach Front and Rear Sight Assemblies					11/13/91	RW		
M) Iron Sight Alignment					11/13/91	RW		
N) Detach Front & Rear Sights & place in numbered container					11/13/91	RW		
O) Attach Scope to Rifle					11/13/91	RW		
P) Detach & Attach Scope 20 Times					11/13/91	RW		
640	Gallery Target & Test				11-15-91	AC		
	A) Time				11-15-91	AC		
	B) Malfunctions				11-15-91	AC		
	C) Pierced Primers				11-15-91	AC		
	D) Optical Clarity of Scope				11-15-91	AC		
645	Inspect for Live Ammo				11-15-91	AC		
655	Final Inspection							
	A) Headspace				12-12-91	JH		
	B) Trigger Pull	235	237	243	237	216	11-15-91	D/H
	C) Function						12-12-91	JH
660	Pack						12-17-91	V

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 0-6649041DATE 11-11-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.59	2.55	2.48	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.38	2.44	2.37	
PULL #3	2.52	2.44	2.39	2.43	
PULL #4	2.48	2.51	2.50	2.37	
PULL #5	2.48	2.46	2.51	2.16	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.25		
PULL #2	3.44	3.38		
PULL #3	3.37	3.51		
PULL #4	3.39	3.34		
PULL #5	3.54	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.33		4.35
PULL #2	4.40	4.35		4.35
PULL #3	4.35	4.37		4.26
PULL #4	4.34	4.38		4.23
PULL #5	4.23	4.35		4.31
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649041
18 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.264038
1 TO	2	.372776
1 TO	3	.336809
1 TO	4	.381792
1 TO	5	.285428

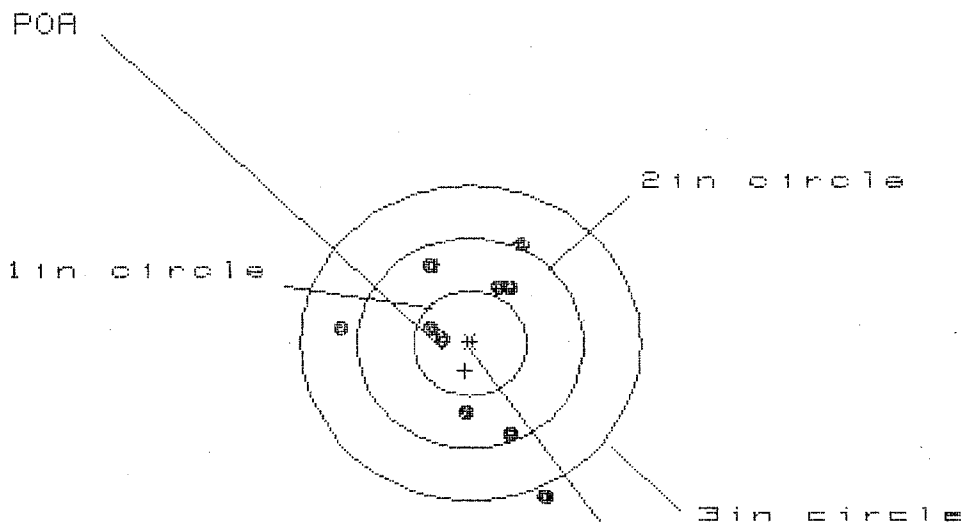
~~12~~ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0594
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179512
THE AMR FOR THIS RIFLE IS: .9746

16 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649041

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.834

VS= 2.412

GS= 2.455

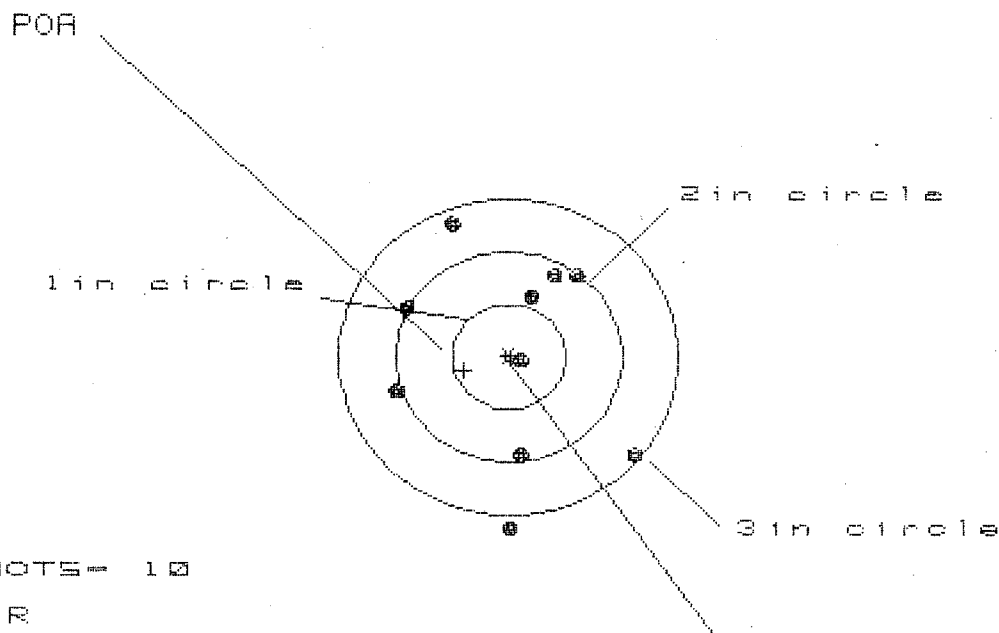
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.691	.548	.415
MINIMUM X	-1.143	-1.066	-.434
MAXIMUM Y	.934	.770	.769
MINIMUM Y	-1.478	-1.025	-1.026
CENTROID X	.046	-.031	.102
CENTROID Y	.260	.424	.425
POA TO CENTROID in.	.264	.425	.437
MIN RADIUS	.217	.220	.322
MEAN RADIUS	.807	.682	.637
MAX RADIUS	1.631	1.114	1.070
HORIZONTAL SPREAD	1.834	1.614	.849
VERTICAL SPREAD	2.412	1.795	1.795
EXTREME SPREAD	2.455	1.814	1.798
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

18 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649041

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 9

HS= 2.056

VS= 2.912

GS= 2.955

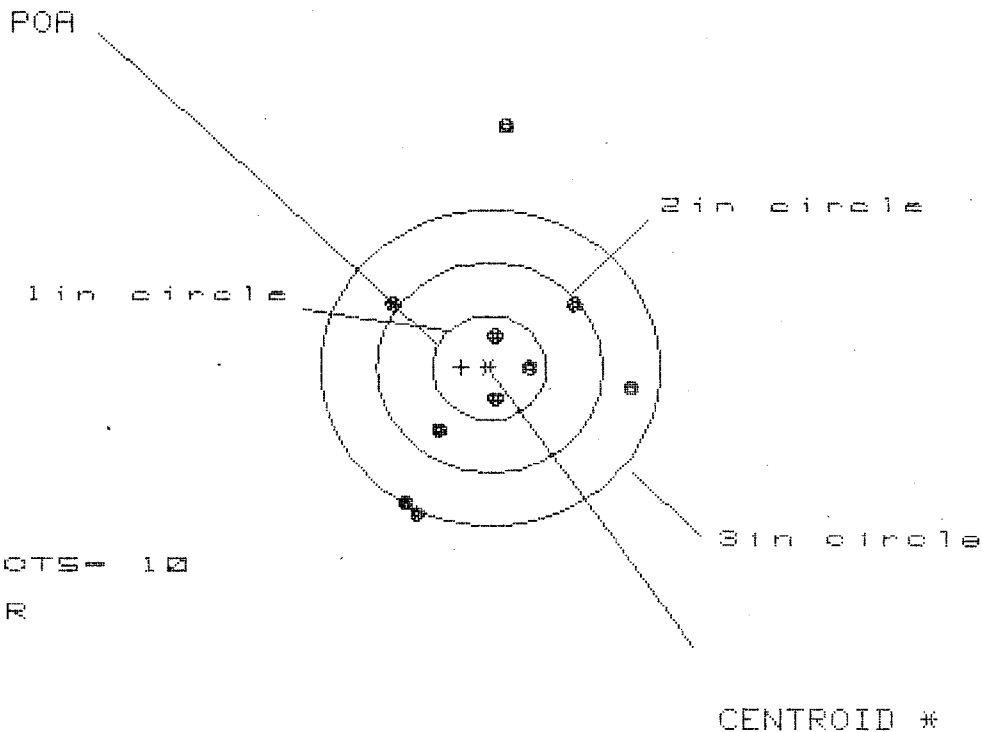
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.098	1.096	.740
MINIMUM X	:	-.958	-.960	-.823
MAXIMUM Y	:	1.270	1.088	.949
MINIMUM Y	:	-1.642	-1.130	-1.269
CENTROID X	:	.395	.397	.260
CENTROID Y	:	.129	.311	.450
POA TO CENTROID in.	:	.415	.505	.520
MIN RADIUS	:	.139	.282	.418
MEAN RADIUS	:	1.009	.919	.830
MAX RADIUS	:	1.642	1.558	1.283
HORIZONTAL SPREAD	:	2.056	2.056	1.563
VERTICAL SPREAD	:	2.912	2.218	2.218
EXTREME SPREAD	:	2.955	2.732	2.294
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Nov 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.076

VS= 3.664

GS= 3.755

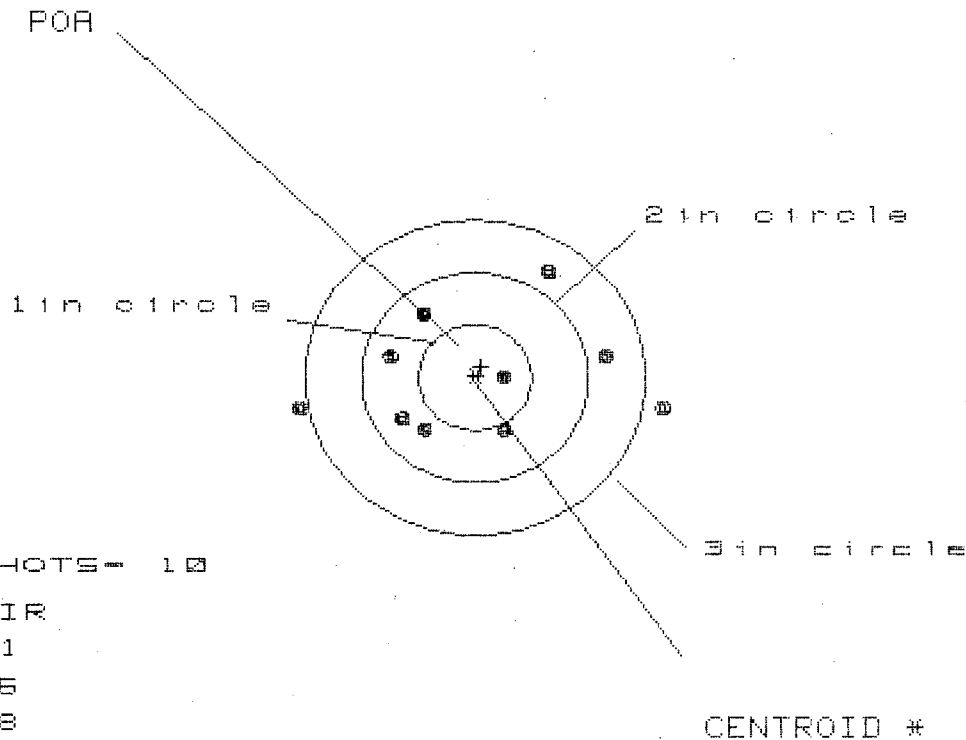
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.268	1.284	1.202
MINIMUM X	:	-.888	-.792	-.874
MAXIMUM Y	:	2.272	.900	.758
MINIMUM Y	:	-1.391	-1.139	-1.164
CENTROID X	:	.250	.234	.316
CENTROID Y	:	-.008	-.261	-.119
POA TO CENTROID in.	:	.250	.350	.338
MIN RADIUS	:	.303	.104	.183
MEAN RADIUS	:	1.019	.860	.783
MAX RADIUS	:	2.277	1.316	1.399
HORIZONTAL SPREAD	:	2.076	2.076	2.076
VERTICAL SPREAD	:	3.664	2.039	1.922
EXTREME SPREAD	:	3.755	2.410	2.337
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649041

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in - 8

HS- 3.110

VS- 1.539

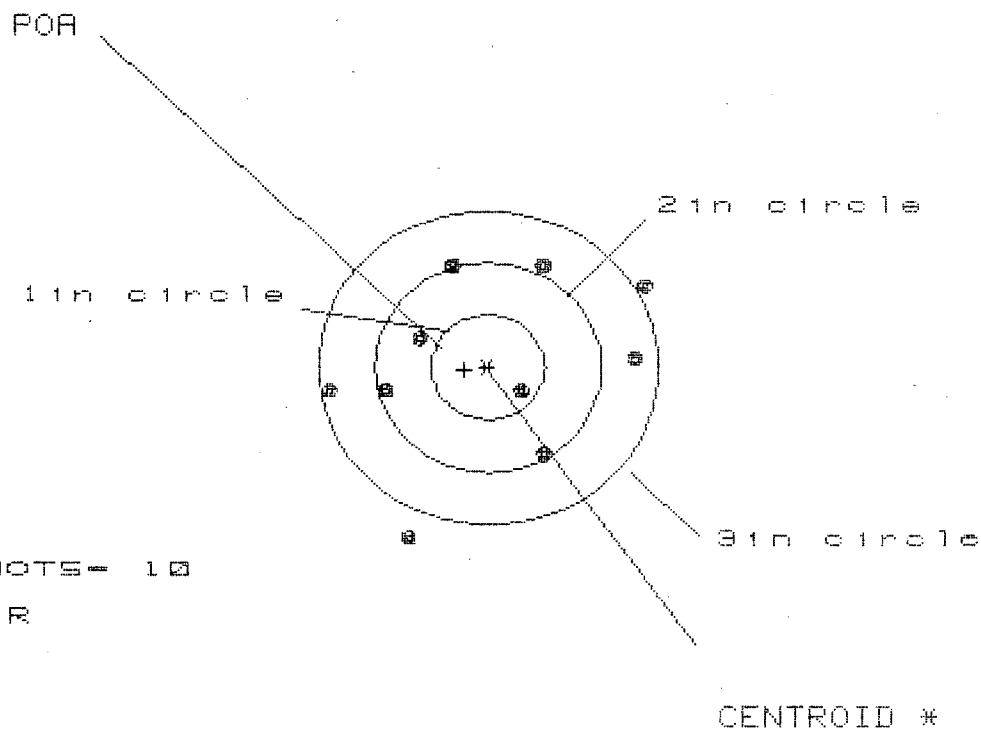
GS- 3.110

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.608	1.294	1.129
MINIMUM X	:	-1.502	-1.323	-.774
MAXIMUM Y	:	1.040	1.004	.960
MINIMUM Y	:	-.499	-.535	-.579
CENTROID X	:	-.052	-.231	-.066
CENTROID Y	:	-.109	-.073	-.029
POA TO CENTROID in.	:	.121	.242	.072
MIN RADIUS	:	.244	.425	.273
MEAN RADIUS	:	.932	.840	.771
MAX RADIUS	:	1.640	1.369	1.159
HORIZONTAL SPREAD	:	3.110	2.617	1.903
VERTICAL SPREAD	:	1.539	1.539	1.539
EXTREME SPREAD	:	3.110	2.668	1.942
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849041

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 2.855

VS = 2.543

GS = 3.117

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.403	1.328	1.400
MINIMUM X	-1.452	-1.527	-1.361
MAXIMUM Y	.966	.790	.861
MINIMUM Y	-1.577	-1.043	-.972
CENTROID X	.208	.283	.117
CENTROID Y	.025	.200	.129
POA TO CENTROID in.	.209	.347	.174
MIN RADIUS	.361	.430	.494
MEAN RADIUS	1.106	1.028	.961
MAX RADIUS	1.717	1.579	1.400
HORIZONTAL SPREAD	2.855	2.855	2.761
VERTICAL SPREAD	2.543	1.833	1.933
EXTREME SPREAD	3.117	3.014	2.779
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		