

BARBER - M24 0031071

Smead®

FORM

UPC



0 47700 25716 7

C6649051

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0031071 M2400031110

MODEL 700 TM M24

ORDER NO.

5716

BARBER - M24-0031073

Remington



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

MODEL 700™ M24

SERIAL NO.

C6649051

ORDER NO.

5716

20

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



5716 C6649051

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7



0 47700 25716 7

MOD. _____		GA. CAL. _____	GUN # <u>9051</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
<i>KT</i>	1st	<i>Shaver Brass</i>	<i>RW</i>
	<i>12/5</i>		
	2nd		
	<i>12/11</i>		
	3rd	<i>Repaired KS</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		

INTERCHANGEABILITY

BARBER - M24 0031076

M-24

1.285

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649051

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	9 26 91	RW
600	Proof		9 26 91	RW
607	Check Headspace		9 26 91	RW
610	Dis-assemble Gun		9 26 91	RW
612	Magnaflux Barrel Action		OCT 3 1991	KCR
	Magnaflux Bolt		OCT 3 1991	KCR
615	Rollmark Caliber		OCT 3 1991	CS
617	Drill and Tap Sight Holes		OCT 4 1991	FB
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		11-20-91	JP

op.	BARBER- M24 0031077	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11/20/91	SH
	G) Safety Off Force	3	3	3			11/20/91	SH
	H) Trigger Pull Test & Retainability						11-20-91	SH
	I) Firing Pin Indent	.020	.020	.020			11-20-91	SH
	J) Assemble Stock						12/5/91	RW
	K) Assemble Swivel Studs						12-12-91	SH
	L) Attach Front and Rear Sight Assemblies						12/5/91	RW
	M) Iron Sight Alignment						12/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/5/91	RW
	O) Attach Scope to Rifle						12/5/91	RW
	P) Detach & Attach Scope 20 Times						12/5/91	RW
640	Gallery Target & Test						12/5/91	KT
	A) Time						"	KT
	B) Malfunctions						"	KT
	C) Pierced Primers						"	KT
	D) Optical Clarity of Scope						"	KT
645	Inspect for Live Ammo						12/5/91	KT
655	Final Inspection							
	A) Headspace						12-12-91	SH
	B) Trigger Pull	232	234	242	250	253	12-7-91	D/T
	C) Function						12-12-91	SH
660	Pack						12-18-91	N

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6649051

DATE 11-20-91

TESTER gmi

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.48	2.52	2.50	2.32	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.50	2.44	2.34	
PULL #3	2.50	2.49	2.51	2.42	
PULL #4	2.55	2.54	2.55	2.50	
PULL #5	2.55	2.54	2.51	2.53	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.32		
PULL #2	3.27	3.28		
PULL #3	3.28	3.38		
PULL #4	3.36	3.46		
PULL #5	3.36	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.54		4.57
PULL #2	4.16	4.68		4.56
PULL #3	4.55	4.56		4.60
PULL #4	4.46	4.54		4.59
PULL #5	4.49	4.54		4.57
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649051
6 Dec 1991

CENTROIDAL DISTANCES

0	TO	1	.393314
1	TO	2	.705437
1	TO	3	.674131
1	TO	4	.742122
1	TO	5	.707018

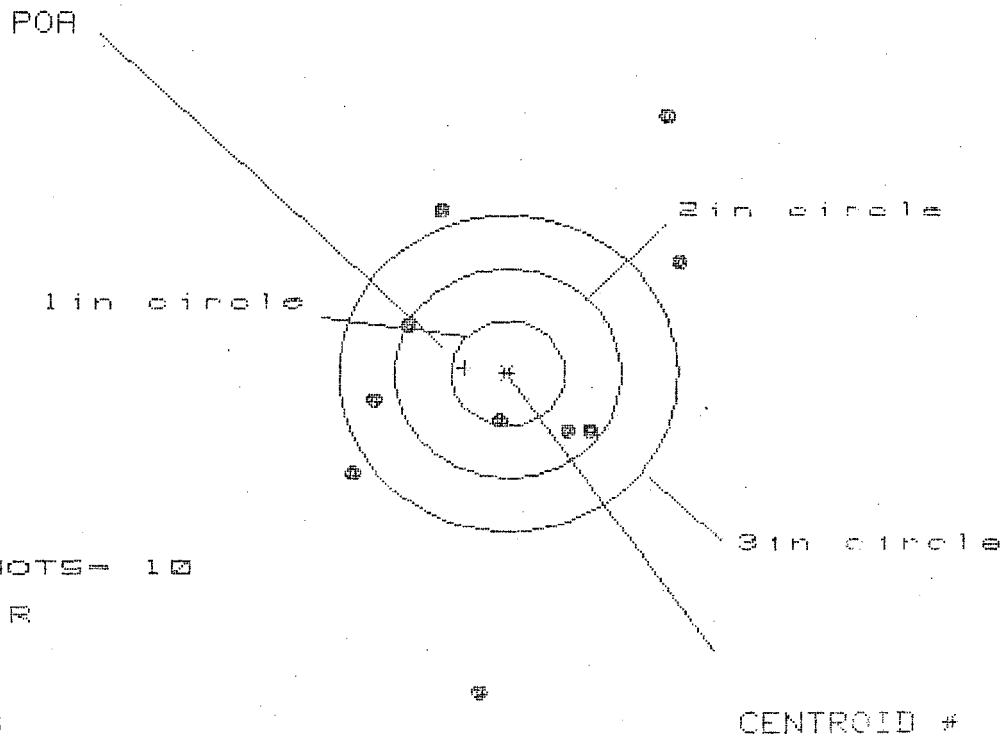
$\frac{1}{34} \pm 5$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1018
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1000
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .145260
THE AMR FOR THIS RIFLE IS: 1.285

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649051

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.891

VS= 5.483

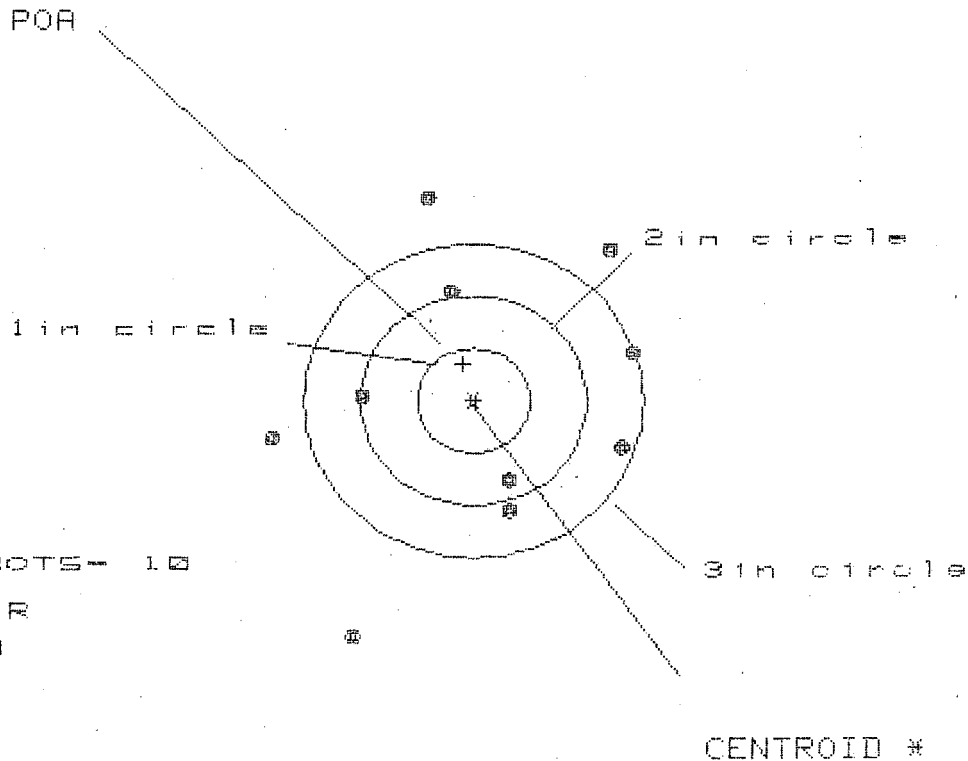
GS= 5.729

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.556	1.530	1.706
MINIMUM X	-1.335	-1.361	-1.185
MAXIMUM Y	2.486	2.153	1.490
MINIMUM Y	-2.997	-1.244	-.974
CENTROID X	.379	.405	.229
CENTROID Y	-.055	.278	.008
POA TO CENTROID in.	.383	.491	.230
MIN RADIUS	.405	.739	.482
MEAN RADIUS	1.534	1.402	1.183
MAX RADIUS	3.006	2.570	1.996
HORIZONTAL SPREAD	2.891	2.891	2.891
VERTICAL SPREAD	5.483	3.397	2.464
EXTREME SPREAD	5.729	4.379	3.522
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

8 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649051

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 1

3 in = 6

HS= 3.210

VS= 4.247

GS= 4.366

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.405
MINIMUM X	-1.805
MAXIMUM Y	1.961
MINIMUM Y	-2.286
CENTROID X	.090
CENTROID Y	-.347
POA TO CENTROID in.	.359
MIN RADIUS	.794
MEAN RADIUS	1.510
MAX RADIUS	2.523
HORIZONTAL SPREAD	3.210
VERTICAL SPREAD	4.247
EXTREME SPREAD	4.366
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	1
NUMBER IN THREE INCH CIRCLE =	6

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649051

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 1

2in = 2

3in = 4

HS = 3.113

VS = 3.653

GS = 4.076

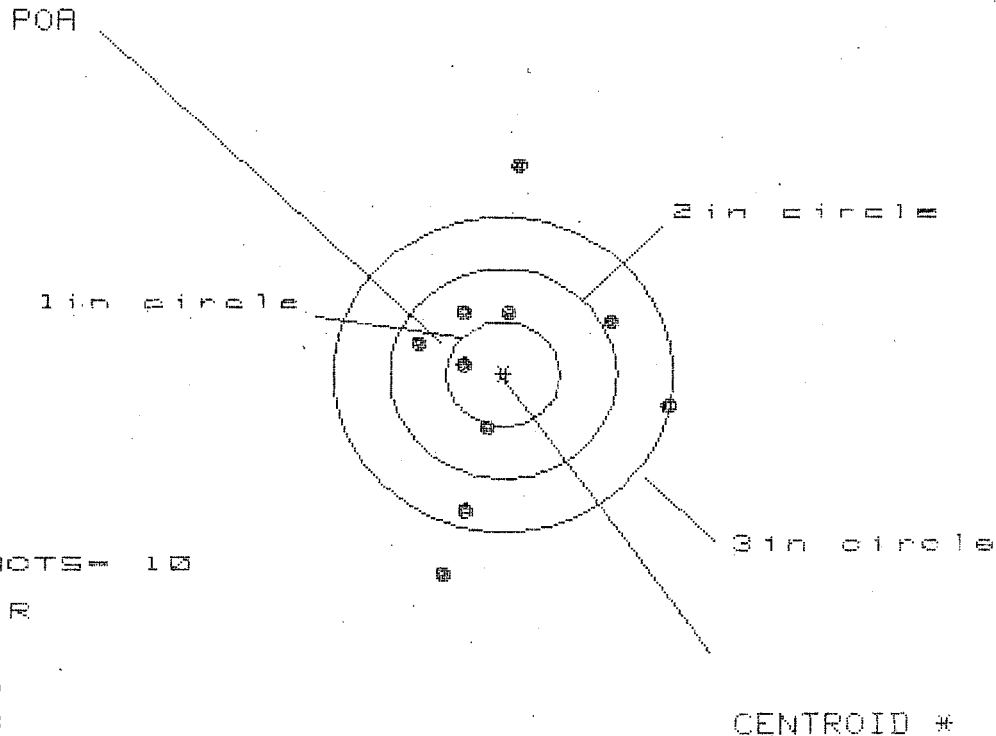
CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.561
MINIMUM X	-1.552
MAXIMUM Y	1.781
MINIMUM Y	-1.872
CENTROID X	-.092
CENTROID Y	-.333
POA TO CENTROID in.	.345
MIN RADIUS	.497
MEAN RADIUS	1.490
MAX RADIUS	2.432
HORIZONTAL SPREAD	3.113
VERTICAL SPREAD	3.653
EXTREME SPREAD	4.076
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	4

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649051

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.204

VS = 3.832

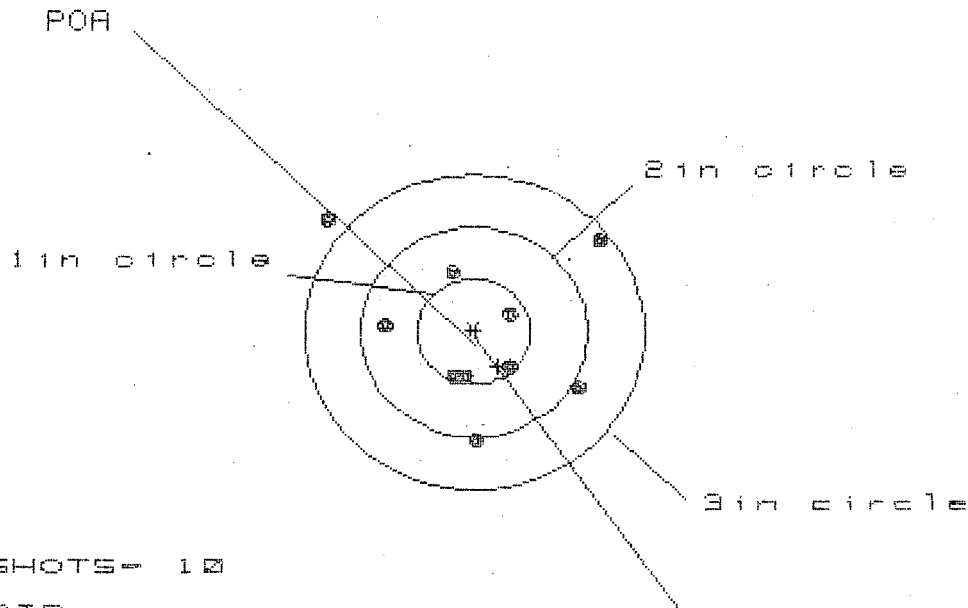
GS = 3.898

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.458	1.472	1.399
MINIMUM X	-.746	-.732	-.805
MAXIMUM Y	1.964	.832	.625
MINIMUM Y	-1.869	-1.650	-1.256
CENTROID X	.346	.332	.405
CENTROID Y	-.099	-.318	-.111
POA TO CENTROID in.	.360	.460	.420
MIN RADIUS	.377	.361	.438
MEAN RADIUS	1.086	.995	.877
MAX RADIUS	1.967	1.749	1.435
HORIZONTAL SPREAD	2.204	2.204	2.204
VERTICAL SPREAD	3.832	2.482	1.881
EXTREME SPREAD	3.898	2.822	2.280
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

8 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649051

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.367

VS= 2.020

GS= 2.660

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.086	.943	.864
MINIMUM X	-1.281	-.972	-.854
MAXIMUM Y	1.021	1.009	.785
MINIMUM Y	-.999	-.886	-.760
CENTROID X	-.214	-.071	-.189
CENTROID Y	.330	.217	.090
POA TO CENTROID in.	.393	.228	.210
MIN RADIUS	.292	.239	.204
MEAN RADIUS	.807	.685	.571
MAX RADIUS	1.638	1.382	.908
HORIZONTAL SPREAD	2.367	1.915	1.718
VERTICAL SPREAD	2.020	1.895	1.545
EXTREME SPREAD	2.660	2.187	1.813
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649051
14 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.0963379
1 TO 2	.0164924
1 TO 3	.234088
1 TO 4	.148708
1 TO 5	.314884

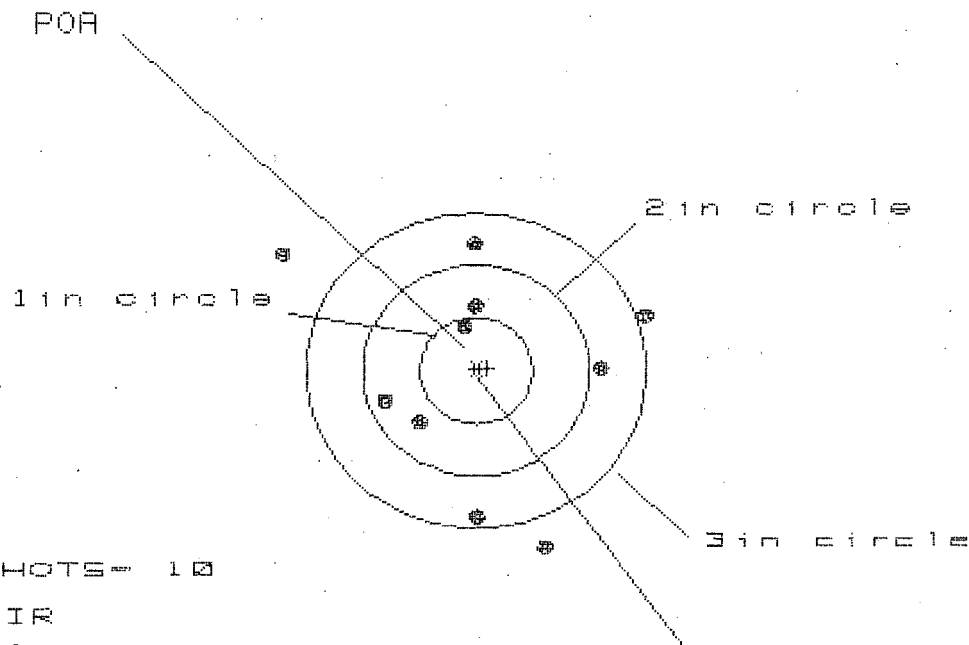
5445 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.1554$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0374$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.159837$
THE AMR FOR THIS RIFLE IS: 1.08

14 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649051.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.208

VS= 2.815

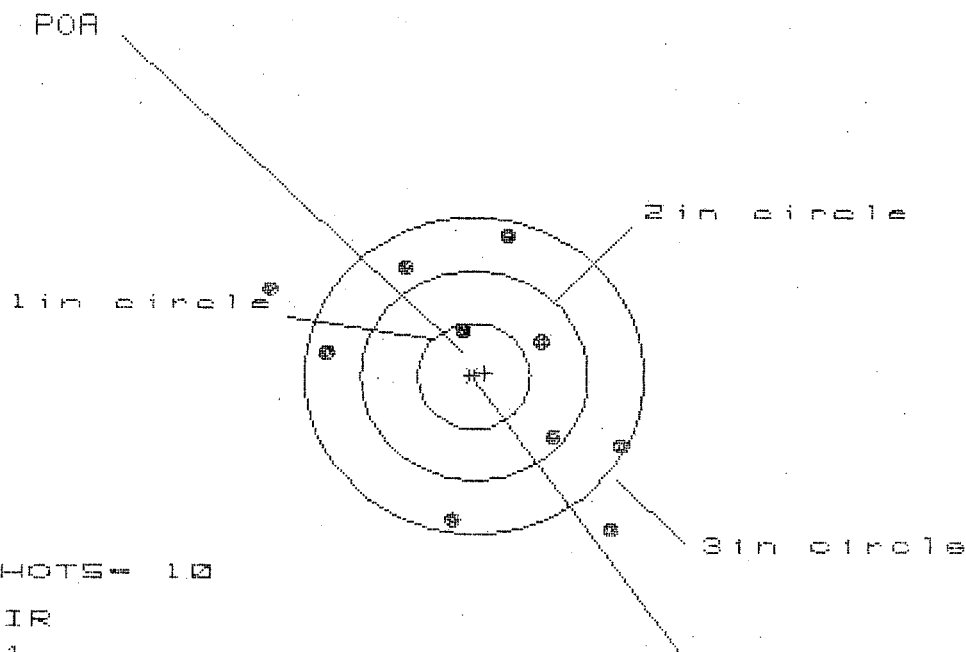
GS= 3.616

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.502	1.313	1.368
MINIMUM X	-1.706	-1.040	-0.985
MAXIMUM Y	1.180	1.304	1.116
MINIMUM Y	-1.635	-1.511	-1.463
CENTROID X	-0.095	.094	.039
CENTROID Y	-0.016	-0.140	.048
POA TO CENTROID in.	.097	.169	.062
MIN RADIUS	.408	.601	.414
MEAN RADIUS	1.157	1.073	.971
MAX RADIUS	2.043	1.574	1.469
HORIZONTAL SPREAD	3.208	2.353	2.353
VERTICAL SPREAD	2.815	2.815	2.579
EXTREME SPREAD	3.616	2.889	2.579
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

14 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649051.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 1

2in = 3

3in = 8

HS = 3.080

VS = 2.834

GS = 3.762

CENTROID #

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.293
MINIMUM X	-1.786
MAXIMUM Y	1.346
MINIMUM Y	-1.488
CENTROID X	-.099
CENTROID Y	-.032
POA TO CENTROID in.	.104
MIN RADIUS	.440
MEAN RADIUS	1.260
MAX RADIUS	1.961
HORIZONTAL SPREAD	3.080
VERTICAL SPREAD	2.834
EXTREME SPREAD	3.762
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8

14 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649051.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 1.700

VS= 2.492

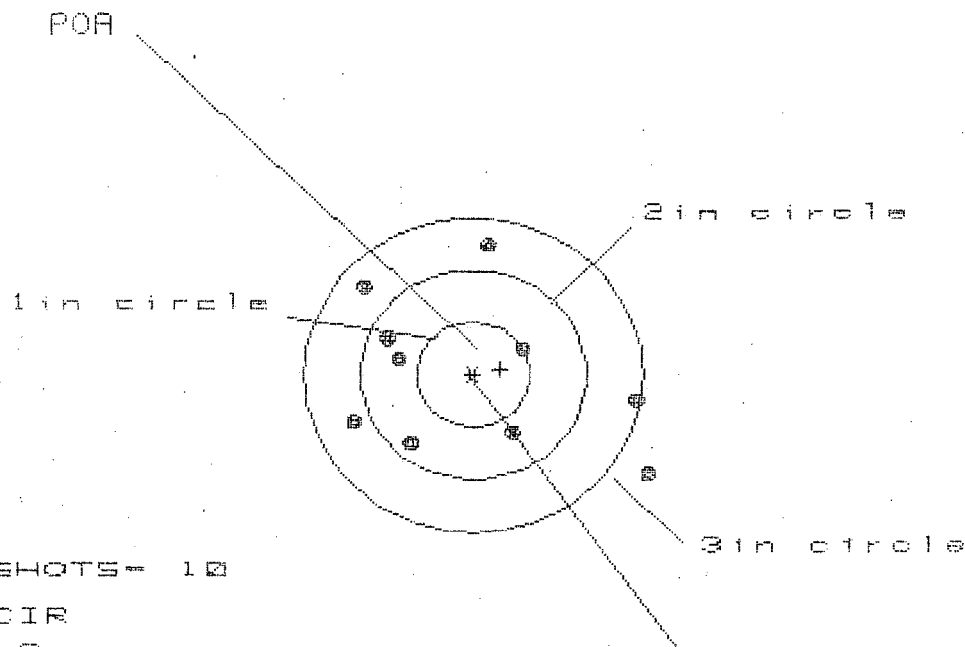
GS= 2.673

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.746	.640	.562
MINIMUM X	:	-.954	-.882	-.960
MAXIMUM Y	:	1.195	1.051	1.128
MINIMUM Y	:	-1.297	-1.155	-1.023
CENTROID X	:	.036	.142	.220
CENTROID Y	:	-.210	-.066	-.198
POA TO CENTROID in.	:	.213	.157	.296
MIN RADIUS	:	.205	.233	.086
MEAN RADIUS	:	.974	.892	.827
MAX RADIUS	:	1.610	1.320	1.167
HORIZONTAL SPREAD	:	1.700	1.522	1.522
VERTICAL SPREAD	:	2.492	2.206	2.151
EXTREME SPREAD	:	2.673	2.542	2.233
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

14 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649051.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 2.628

VS = 2.115

GS = 3.016

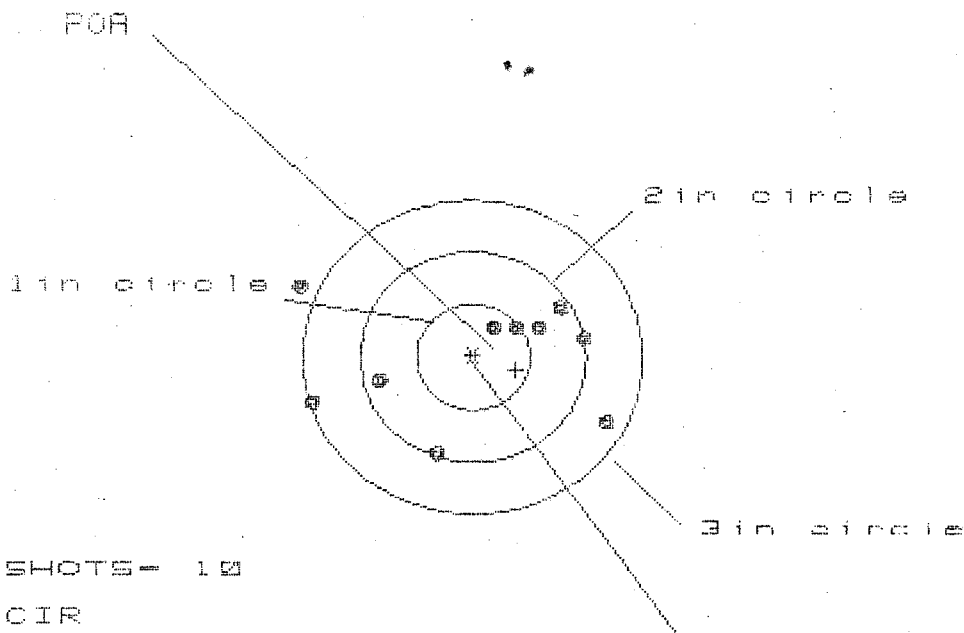
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.546	1.605	.936
MINIMUM X	:	-1.082	-.910	-.709
MAXIMUM Y	:	1.208	1.108	1.065
MINIMUM Y	:	-.906	-.774	-.817
CENTROID X	:	-.240	-.412	-.613
CENTROID Y	:	-.049	.052	.095
POA TO CENTROID in.	:	.245	.415	.620
MIN RADIUS	:	.534	.469	.271
MEAN RADIUS	:	1.040	.927	.795
MAX RADIUS	:	1.792	1.641	1.179
HORIZONTAL SPREAD	:	2.628	2.515	1.545
VERTICAL SPREAD	:	2.115	1.882	1.882
EXTREME SPREAD	:	3.016	2.582	2.031
NUMBER IN ONE INCH CIRCLE =			0	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

14 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649851.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 3

HS= 2.686

VS= 1.657

GS= 2.998

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	.991	.793
MINIMUM X	-1.525	-1.587	-1.185
MAXIMUM Y	.706	.594	.554
MINIMUM Y	-.951	-.872	-.912
CENTROID X	-.379	-.209	-.011
CENTROID Y	.120	.041	.081
POA TO CENTROID in.	.397	.213	.091
MIN RADIUS	.349	.379	.306
MEAN RADIUS	.971	.863	.716
MAX RADIUS	1.681	1.618	1.203
HORIZONTAL SPREAD	2.686	2.578	1.978
VERTICAL SPREAD	1.657	1.466	1.466
EXTREME SPREAD	2.998	2.588	2.014
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	