

BARBER - M24 0031127

Small
in
the
world

FORM

UPC



C6649055

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0031127 M2400031166

ORDER NO. 5715

MODEL 700 TM M24

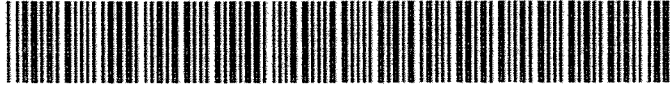
Remington

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

MODEL 700™ M24**SERIAL NO.****C6649055****ORDER NO.****5716**

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

20



5716 C6649055

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649055

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 28	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action	OCT	3 1991	Kcd
	Magnaflux Bolt	OCT	3 1991	Kcd
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	JA
	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		10-2-91	JH

op. #	BARBER - M24 0031131	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12-2-91	DH
	G) Safety Off Force	3	3	3			12-2-91	FL
	H) Trigger Pull Test & Retainability						12-2-91	RL
	I) Firing Pin Indent	1021	10215	10215			12-2-91	ML
	J) Assemble Stock						12/3/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/3/91	RW
	M) Iron Sight Alignment						12/3/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/3/91	RW
	O) Attach Scope to Rifle						12/3/91	RW
	P) Detach & Attach Scope 20 Times						12/3/91	RW
640	Gallery Target & Test						12-4-91	AC
	A) Time						12-4-91	AC
	B) Malfunctions						12-4-91	AC
	C) Pierced Primers						12-4-91	AC
	D) Optical Clarity of Scope						12-4-91	AC
645	Inspect for Live Ammo						12-4-91	AC
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	233	227	232	227	228	12-5-91	DH
	C) Function						12-7-91	AC
660	Pack						12-19-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO C-6649055DATE 12-2-91TESTER JA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.48	2.55	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.20	2.48	2.27	
PULL #3	2.45	2.41	2.44	2.32	
PULL #4	2.51	2.41	2.46	2.27	
PULL #5	2.51	2.53	2.49	2.28	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.50		
PULL #2	3.51	3.50		
PULL #3	3.55	3.53		
PULL #4	3.56	3.55		
PULL #5	3.44	3.59		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.30	4.34		4.17
PULL #2	4.28	4.39		4.17
PULL #3	4.25	4.25		4.20
PULL #4	4.22	4.27		4.16
PULL #5	4.30	4.20		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649055
4 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.549927
1 TO	2	.346621
1 TO	3	.593334
1 TO	4	.526047
1 TO	5	.409497

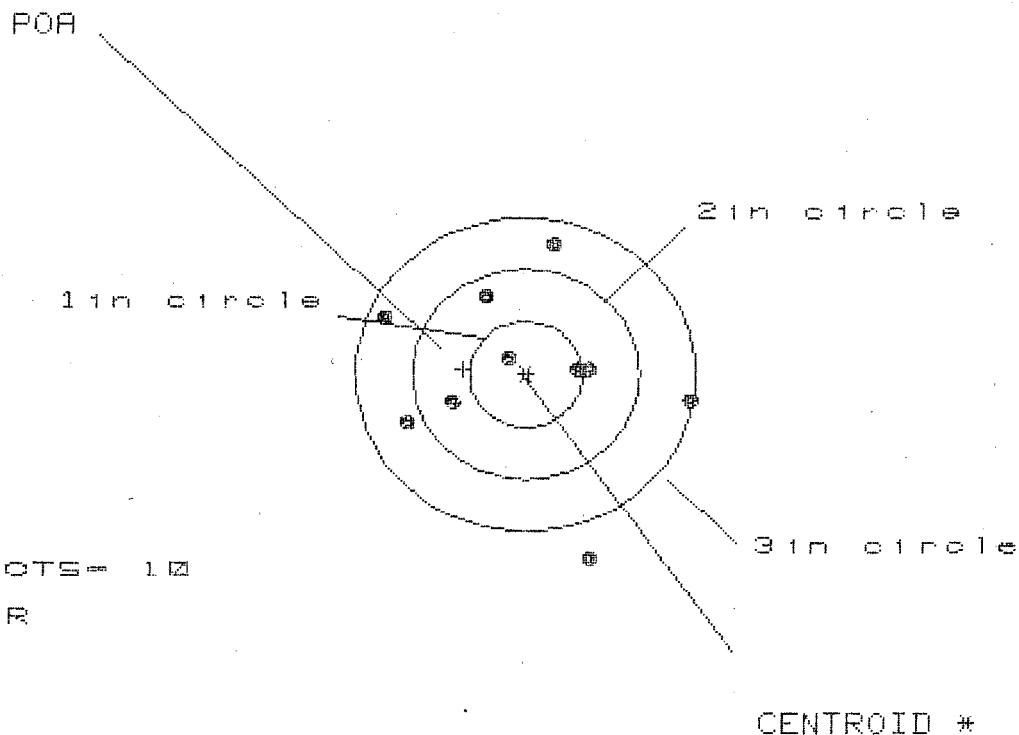
#5 12 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3196
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .08
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .32946
THE AMR FOR THIS RIFLE IS: .8768

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849055

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.5660

VS = 2.994

GS = 3.004

CENTROID *

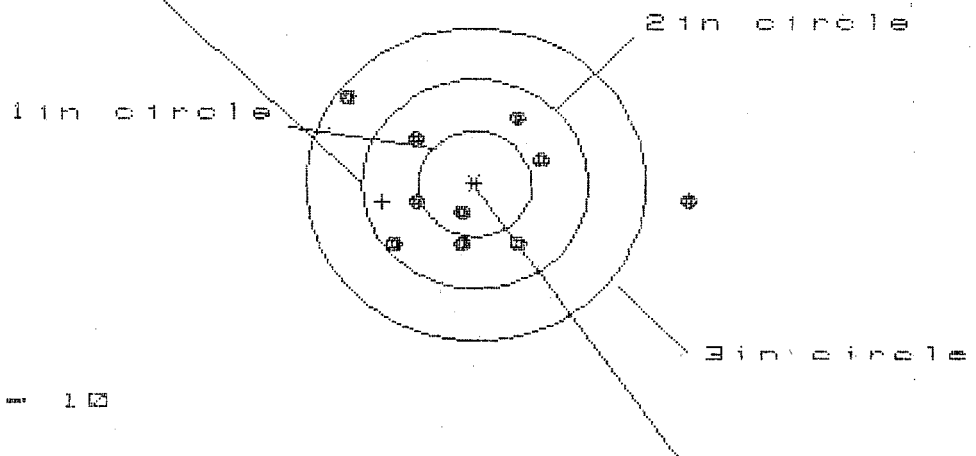
PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.450	1.510	.835
MINIMUM X	:	-1.210	-1.150	-.961
MAXIMUM Y	:	1.253	1.059	.999
MINIMUM Y	:	-1.741	-.682	-.743
CENTROID X	:	.548	.488	.299
CENTROID Y	:	-.046	.148	.209
POA TO CENTROID in.	:	.550	.510	.365
MIN RADIUS	:	.225	.058	.145
MEAN RADIUS	:	.983	.855	.762
MAX RADIUS	:	1.823	1.586	1.135
HORIZONTAL SPREAD	:	2.660	2.660	1.796
VERTICAL SPREAD	:	2.994	1.741	1.741
EXTREME SPREAD	:	3.004	2.793	2.202
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	9		

4 Dec 1991

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 8

3 in = 9

HS = 3.000

VS = 1.449

GS = 3.162

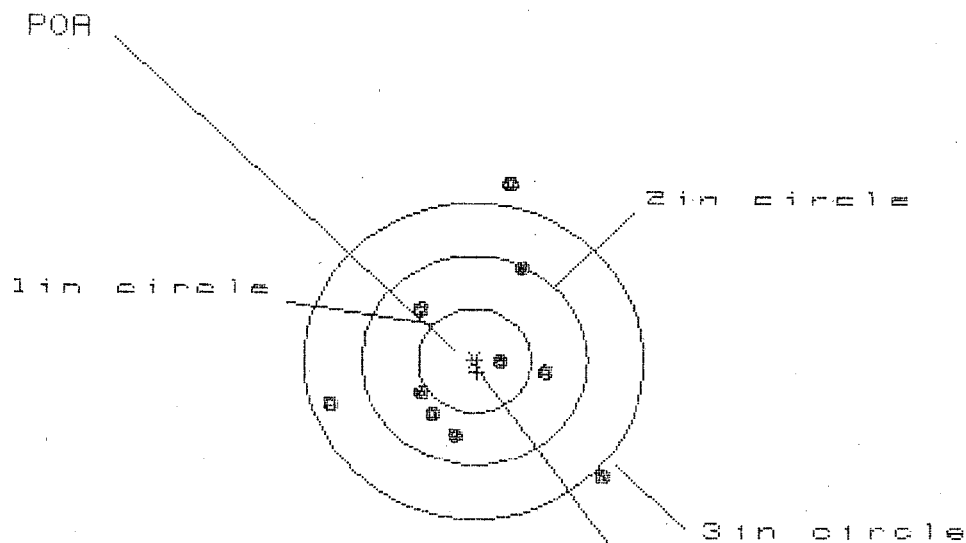
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.844	.825	.705
MINIMUM X	-1.164	-.959	-.609
MAXIMUM Y	.856	.843	.762
MINIMUM Y	-.593	-.606	-.501
CENTROID X	.823	.618	.738
CENTROID Y	.165	.178	.073
POA TO CENTROID in.	.839	.643	.742
MIN RADIUS	.299	.262	.176
MEAN RADIUS	.848	.713	.622
MAX RADIUS	1.848	1.277	.883
HORIZONTAL SPREAD	3.000	1.784	1.314
VERTICAL SPREAD	1.449	1.449	1.263
EXTREME SPREAD	3.162	2.129	1.645
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649055

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 7

3 in - 8

HS = 2.334

VS = 2.821

GS = 2.914

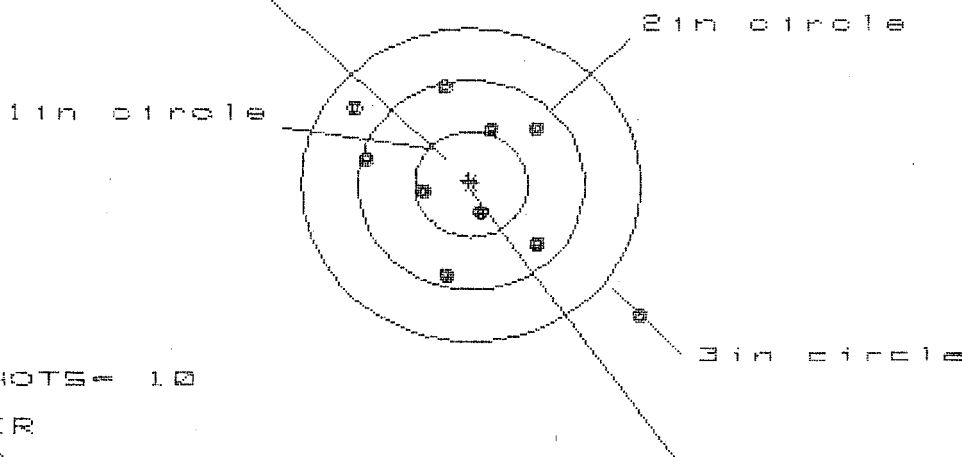
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.077
MINIMUM X	-1.257
MAXIMUM Y	1.741
MINIMUM Y	-1.080
CENTROID X	-.025
CENTROID Y	.108
POA TO CENTROID in.	.111
MIN RADIUS	.215
MEAN RADIUS	.905
MAX RADIUS	1.776
HORIZONTAL SPREAD	2.334
VERTICAL SPREAD	2.821
EXTREME SPREAD	2.914
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

4 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649055

CENTERFIRE PATTERNS # 4

POA



OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.472

VS = 2.144

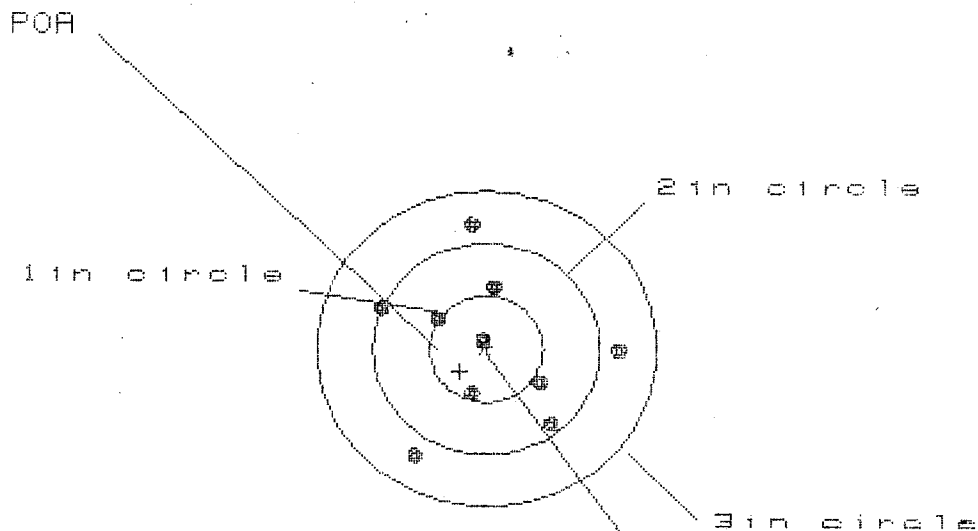
GS = 3.177

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.443	.737	.628
MINIMUM X	:	-1.029	-.868	-.834
MAXIMUM Y	:	.893	.754	.830
MINIMUM Y	:	-1.251	-1.044	-.968
CENTROID X	:	.022	-.139	-.030
CENTROID Y	:	-.039	.100	.025
POA TO CENTROID in.	:	.045	.171	.039
MIN RADIUS	:	.245	.350	.321
MEAN RADIUS	:	.888	.757	.711
MAX RADIUS	:	1.910	1.058	.991
HORIZONTAL SPREAD	:	2.472	1.605	1.462
VERTICAL SPREAD	:	2.144	1.798	1.798
EXTREME SPREAD	:	3.177	2.069	1.798
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			9	

4 Dec 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.042

VS= 2.213

GS= 2.258

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.149	1.088	1.050
MINIMUM X	:	-.893	-.962	-.992
MAXIMUM Y	:	1.165	1.049	.590
MINIMUM Y	:	-1.047	-.790	-.659
CENTROID X	:	.230	.299	.329
CENTROID Y	:	.212	.328	.197
POA TO CENTROID in.	:	.313	.444	.384
MIN RADIUS	:	.091	.117	.170
MEAN RADIUS	:	.760	.707	.654
MAX RADIUS	:	1.218	1.093	1.061
HORIZONTAL SPREAD	:	2.042	2.042	2.042
VERTICAL SPREAD	:	2.213	1.839	1.249
EXTREME SPREAD	:	2.258	2.084	2.084
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	