

BARBER - M24 0060067

C6225400

C670 1861 NEW #

MODEL 700TM M24

Model **SWS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0060067~~ 060106

Smead

No. 215751

C 6725400

NEW BBL ACTION

SEE

C 6702861

Remington®

MODEL 700™ H24

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

DUPONT

REG. U.S. PAT. & TM. OFF.

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

SERIAL NO.
C6225400

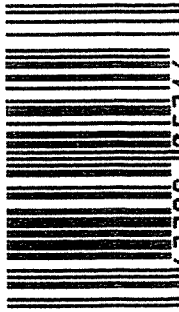
ORDER NO.
5716

Ø1



5716 C6225400

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225400

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	QUALITY AUDIT	1 25 89	RW
600	Proof		1 25 89	RW
607	Check Headspace		1 25 89	RW
610	Dis-assemble Gun		1 25 89	RW
612	Magnaflux Barrel Action		1-27-89	pk.
	Magnaflux Bolt		1-27-89	KCR
615	Rollmark Caliber		1-28-89	L.S.
617	Drill and Tap Sight Holes	2 1 89		FB
618	Polish Barrel	2 1 89		BT
620	Apply Coatings (Barrel Action)		2-10-89	TSA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/30/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/30/89	RW
	C) Inspect Ejector Hole for Chamfer		3/30/89	RW
	D) Oil Firing Pin Ass'y		3/30/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/30/89	RW

BARBER - M24 0060071

op. #	OP. NAME	READINGS			DATE	INITIAL
625 cont.	F) Safety On Force	4	4	4	3 April 89	JS
	G) Safety Off Force	3	3	3	3 April 89	JS
	H) Trigger Pull Test & Retainability				31 Mar 89	JS
	I) Firing Pin Indent	.021	.0215	.021	3 April 89	JS
	J) Assemble Stock				4/7/89	RW
	K) Assemble Swivel Studs				12 April 89	JS
	L) Attach Front and Rear Sight Assemblies				4/7/89	RW
	M) Iron Sight Alignment				4/7/89	RW
	N) Detach Front & Rear Sights & place in numbered container				4/7/89	RW
	O) Attach Scope to Rifle				4/7/89	JU.
	P) Detach & Attach Scope 20 Times				4/10/89	JU.
640	Gallery Target & Test	50 R	102 L		4/10/89	DH
	A) Time				4/10/89	DH
	B) Malfunctions				4/10/89	DH
	C) Pierced Primers				4/10/89	DH
	D) Optical Clarity of Scope				4/10/89	DH
645	Inspect for Live Ammo				4/10/89	DH
655	Final Inspection					
	A) Headspace				12 April 89	JS
	B) Trigger Pull	2.42	2.25	2.17	12 April 89	JS
	C) Function				12 April 89	JS
660	Pack				26 June 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6225400DATE 4-3-90TESTER JPL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.42		2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.41		2.30	
PULL #3	2.51	2.38		2.28	
PULL #4	2.40	2.38		2.18	
PULL #5	2.36	2.43		2.28	
TOTAL	12.42	12.02		11.32	
AVG.	2.484	2.404		2.264	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.42		
PULL #2	3.48	3.40		
PULL #3	3.48	3.43		
PULL #4	3.44	3.46		
PULL #5	3.39	3.43		
TOTAL	17.20	17.14		
AVG.	3.44	3.428		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.48	4.46		
PULL #2	4.45	4.46		
PULL #3	4.43	4.41		
PULL #4	4.50	4.42		
PULL #5	4.39	4.18		
TOTAL	22.25	21.93		
AVG.	4.45	4.386		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225400
12 Apr 1989

CENTROIDAL DISTANCES

0 TO	1	.696638
1 TO	2	.149513
1 TO	3	.256907
1 TO	4	.36096
1 TO	5	.293411

+ 5²₄ C----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .7046
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .221
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .738446
THE AMR FOR THIS RIFLE IS: .9084

12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06025400

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.248

VS = 2.953

GS = 3.266

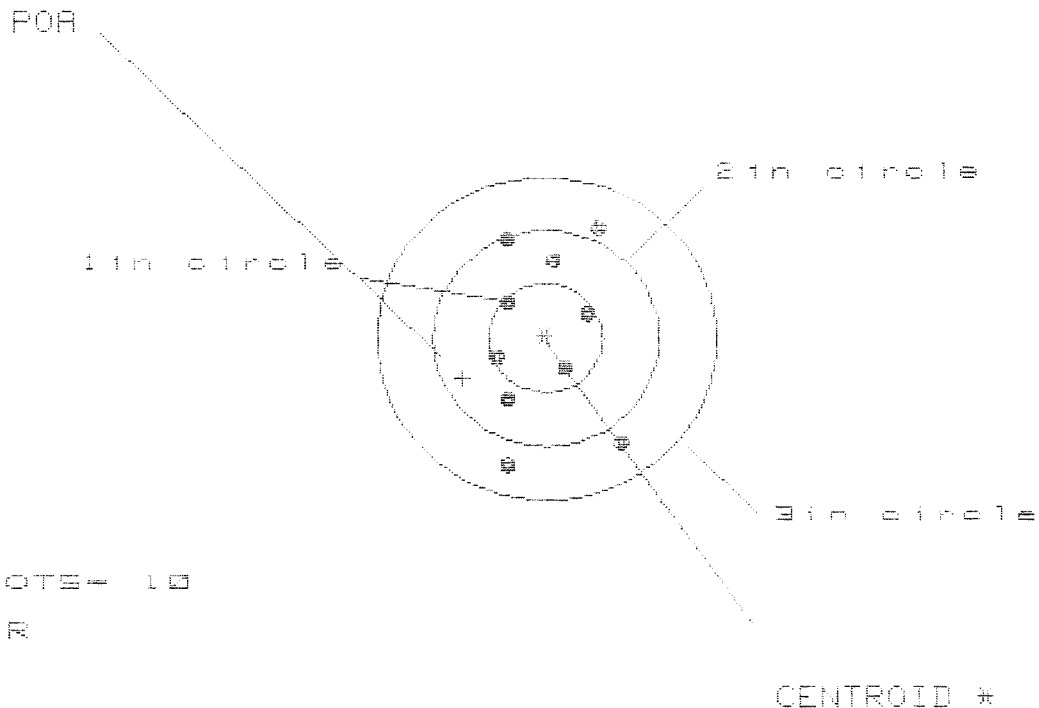
CENTROID *

PATTERN #		1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.973	.513	.440
MINIMUM X	:	-1.276	-1.168	-1.241
MAXIMUM Y	:	1.413	1.242	1.379
MINIMUM Y	:	-1.540	-1.081	-.944
CENTROID X	:	.651	.543	.616
CENTROID Y	:	.248	.419	.282
POA TO CENTROID in.	:	.697	.686	.677
MIN RADIUS	:	.430	.603	.476
MEAN RADIUS	:	1.023	.960	.882
MAX RADIUS	:	1.822	1.300	1.414
HORIZONTAL SPREAD	:	2.249	1.681	1.681
VERTICAL SPREAD	:	2.953	2.323	2.323
EXTREME SPREAD	:	3.266	2.363	2.363
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225480

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.100

VS = 2.287

GS = 2.429

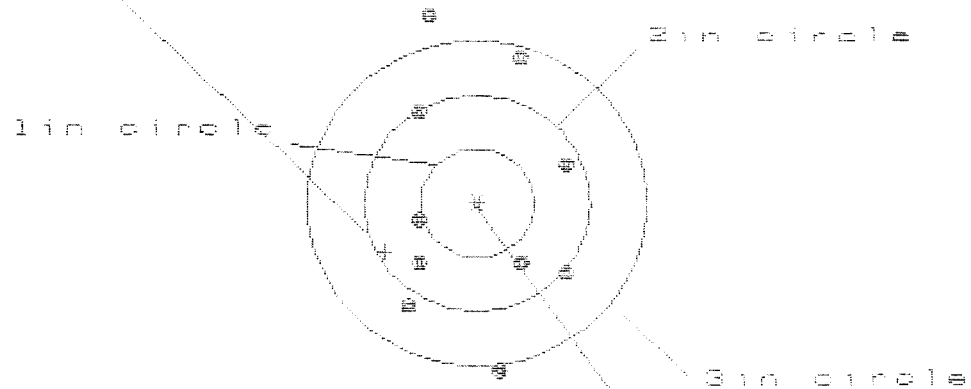
PATTERN #	2	2	2
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.649	.610	.664
MINIMUM X	-.451	-.490	-.436
MAXIMUM Y	1.076	.942	.864
MINIMUM Y	-1.211	-1.098	-.981
CENTROID X	.736	.775	.721
CENTROID Y	.371	.505	.388
POR TO CENTROID in.	.824	.925	.818
MIN RADIUS	.374	.380	.397
MEAN RADIUS	.773	.709	.680
MAX RADIUS	1.259	1.257	1.185
HORIZONTAL SPREAD	1.100	1.100	1.100
VERTICAL SPREAD	2.287	2.040	1.845
EXTREME SPREAD	2.429	2.092	2.092
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

12 Apr 1989

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CENTERFIRE PATTERNS # 3

POR



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 1.436

VS = 3.293

GS = 3.354

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.759	.775
MINIMUM X	:	-.626	-.677	-.661
MAXIMUM Y	:	1.790	1.574	1.411
MINIMUM Y	:	-1.503	-1.304	-.896
CENTROID X	:	.811	.862	.846
CENTROID Y	:	.449	.250	.413
POR TO CENTROID in.	:	.927	.898	.942
MIN RADIUS	:	.505	.516	.528
MEAN RADIUS	:	1.084	.965	.931
MAX RADIUS	:	1.848	1.611	1.456
HORIZONTAL SPREAD	:	1.436	1.436	1.436
VERTICAL SPREAD	:	3.293	2.878	2.307
EXTREME SPREAD	:	3.354	2.886	2.522
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

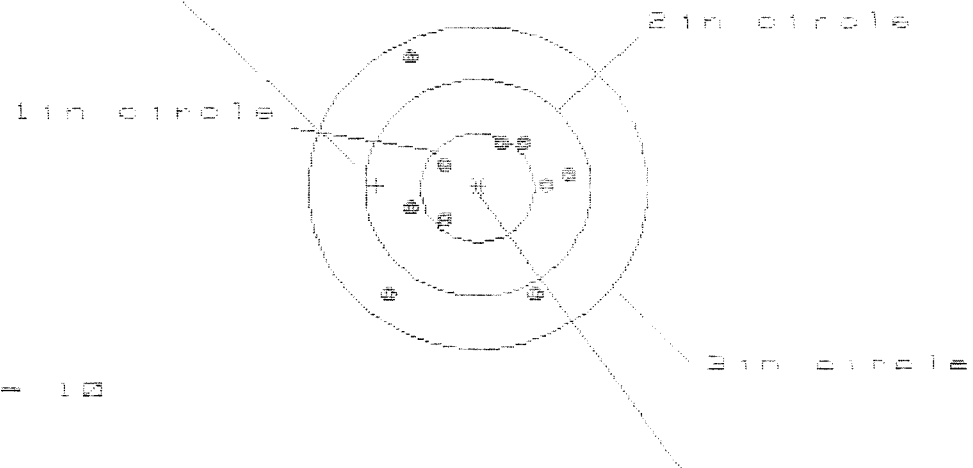
12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08025400

CENTERFIRE PATTERNS

4

POR



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.557

VS = 2.112

GS = 2.353

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.805	.744	.642
MINIMUM X	:	-.752	-.813	-.759
MAXIMUM Y	:	1.168	.584	.483
MINIMUM Y	:	-.944	-.814	-.915
CENTROID X	:	.895	.956	1.058
CENTROID Y	:	-.018	-.148	-.047
POR TO CENTROID in.	:	.895	.968	1.059
MIN RADIUS	:	.382	.428	.405
MEAN RADIUS	:	.749	.692	.614
MAX RADIUS	:	1.293	1.146	.969
HORIZONTAL SPREAD	:	1.557	1.557	1.401
VERTICAL SPREAD	:	2.112	1.398	1.398
EXTREME SPREAD	:	2.353	1.891	1.434
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Apr 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08225400

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.915

VS= 2.399

GS= 2.960

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.889
MINIMUM X	-1.106
MAXIMUM Y	1.546
MINIMUM Y	-.854
CENTROID X	.430
CENTROID Y	.055
POA TO CENTROID in.	.434
MIN RADIUS	.203
MEAN RADIUS	.913
MAX RADIUS	1.744
HORIZONTAL SPREAD	1.915
VERTICAL SPREAD	2.399
EXTREME SPREAD	2.960
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9