

C6649113

MODEL 780™ M24

Model **SMS**™

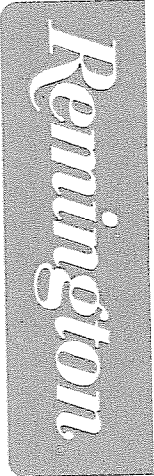
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



BARBER - M24 0064961

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6649113	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6649113



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 00649610000

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6649113

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/91	KA
600	Proof		6/27/91	KA
607	Check Headspace		6/27/91	KA
610	Dis-assemble Gun		6/27/91	KA
612	Magnaflux Barrel Action		JUL 18 1991	CS
	Magnaflux Bolt		JUL 18 1991	CS
615	Rollmark Caliber		JUL 18 1991	CS
617	Drill and Tap Sight Holes		JUL 18 1991	FB
618	Polish Barrel		JUL 20 1991	WB
620	Apply Coatings (Barrel Action)		8-7-91	KA
	Apply Coating (Bolt)			KA
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/91	KA
	C) Inspect Ejector Hole for Chamfer		8/29/91	KA
	D) Oil Firing Pin Ass'y		8/29/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		9/4/91	KA

op. #	OP. NAME BARBER - M24 0064963	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/4/91	SH
	G) Safety Off Force	5	5	5			9/4/91	SH
	H) Trigger Pull Test & Retainability						9/4/91	SH
	I) Firing Pin Indent	.023	.0215	.0215			9/4/91	SH
	J) Assemble Stock						9/4/91	SH
	K) Assemble Swivel Studs						9/12/91	SH
	L) Attach Front and Rear Sight Assemblies						9/4/91	SH
	M) Iron Sight Alignment						9/4/91	SH
	N) Detach Front & Rear Sights & place in numbered container						9/4/91	SH
	O) Attach Scope to Rifle						9/4/91	SH
	P) Detach & Attach Scope 20 Times						9/4/91	SH
640	Gallery Target & Test						9-5-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						9-5-91	NF
655	Final Inspection							
	A) Headspace						9-12-91	SH
	B) Trigger Pull	2.42	2.50	2.57	2.64	2.58	9-6-91	SH
	C) Function						9/12/91	SH
660	Pack						7-18-91	SH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C-6649113

DATE 9-4-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.33	2.39	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.35	2.32	2.50	
PULL #3	2.37	2.36	2.40	2.57	
PULL #4	2.33	2.38	2.35	2.64	
PULL #5	2.28	2.37	2.30	2.58	
TOTAL			2		
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.67	3.63		
PULL #2	3.59	3.52		
PULL #3	3.62	3.56		
PULL #4	3.58	3.59		
PULL #5	3.57	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	4.26	4.54		4.46
PULL #2	4.25	4.56		4.48
PULL #3	4.22	4.46		4.49
PULL #4	4.55	4.50		4.50
PULL #5	4.52	4.46		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649113
5 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.221741
1 TO	2	.174889
1 TO	3	.23821
1 TO	4	.631854
1 TO	5	.0547083

4 3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0446
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.041
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0605818
THE AMR FOR THIS RIFLE IS: .8154

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/0664966

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.158

VS = 2.648

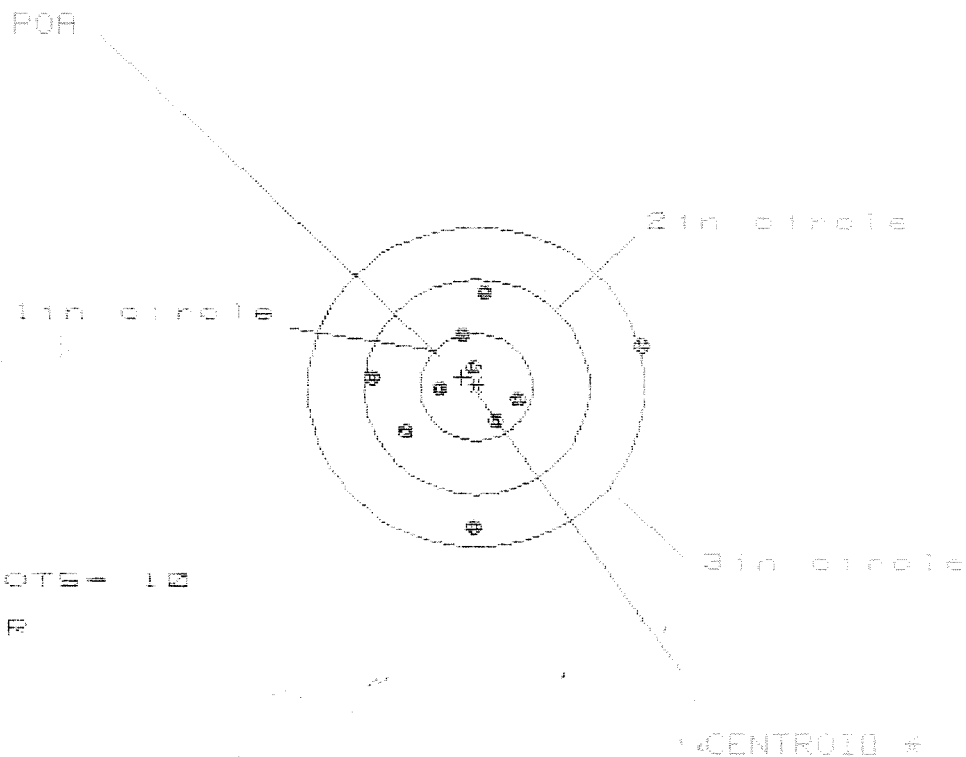
GS = 2.825

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.317	.854	.914
MINIMUM X	-.841	-.695	-.635
MAXIMUM Y	1.310	1.161	.988
MINIMUM Y	-1.339	-.812	-.666
CENTROID X	.212	.066	.086
CENTROID Y	.065	.214	.069
POA TO CENTROID in.	.222	.224	.069
MIN RADIUS	.095	.179	.247
MEAN RADIUS	.862	.711	.642
MAX RADIUS	1.878	1.257	1.068
HORIZONTAL SPREAD	2.158	1.549	1.549
VERTICAL SPREAD	2.649	1.973	1.655
EXTREME SPREAD	2.825	2.131	1.727
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066496113

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 4

2in = 8

3in = 9

HS = 2.395

VS = 2.200

GS = 2.421

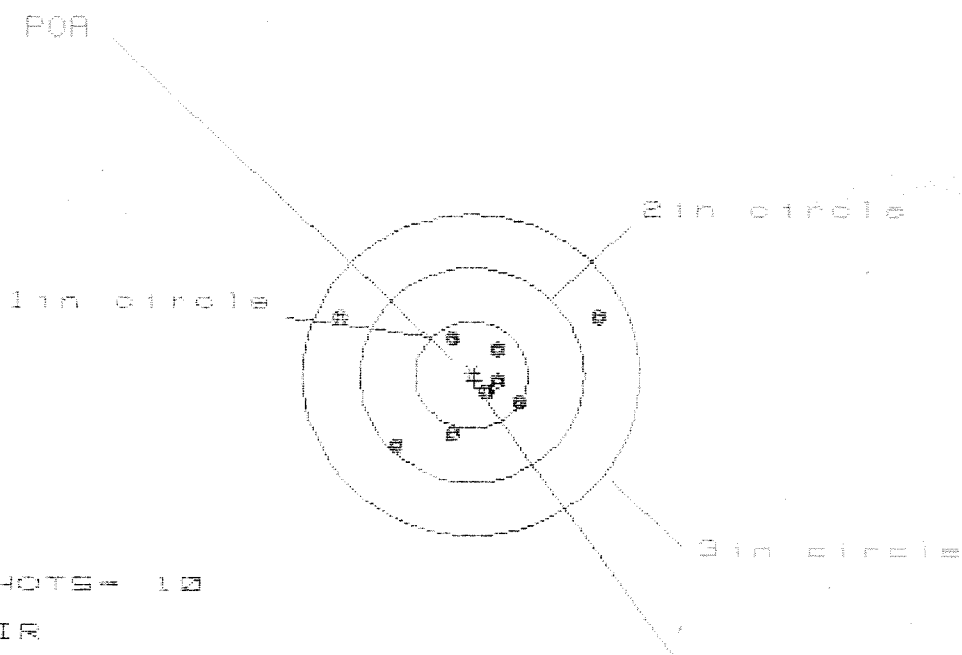
CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.492	.544	.558
MINIMUM X	-.903	-.737	-.723
MAXIMUM Y	.896	.943	.786
MINIMUM Y	-1.304	-1.257	-.552
CENTROID X	.131	-.035	-.049
CENTROID Y	-.090	-.137	.020
POA TO CENTROID in.	.158	.142	.053
MIN RADIUS	.269	.117	.151
MEAN RADIUS	.715	.607	.510
MAX RADIUS	1.552	1.262	.815
HORIZONTAL SPREAD	2.395	1.281	1.281
VERTICAL SPREAD	2.200	2.200	1.338
EXTREME SPREAD	2.421	2.202	1.480
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

5 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 5

2in = 8

3in = 10

HS= 2.297

VS= 1.195

GS= 2.297

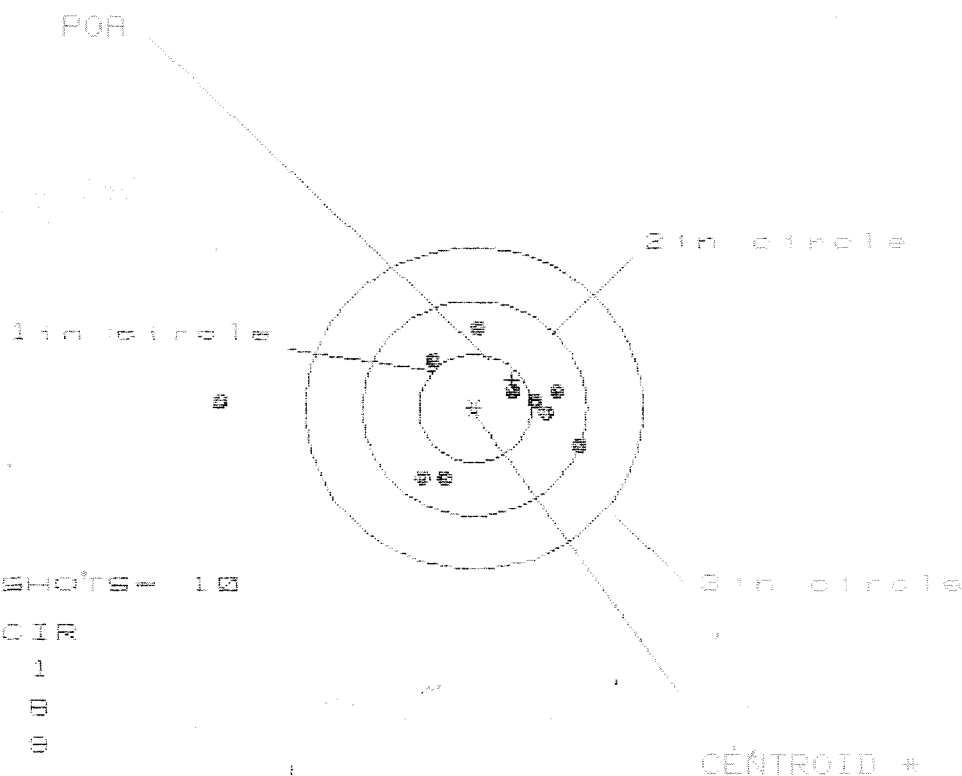
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.187	.975	.455
MINIMUM X	-1.198	-.823	-.792
MAXIMUM Y	.559	.616	.478
MINIMUM Y	-.636	-.579	-.582
CENTROID X	-.026	.106	-.016
CENTROID Y	.055	-.002	-.079
POA TO CENTROID in.	.061	.106	.081
MIN RADIUS	.134	.064	.070
MEAN RADIUS	.576	.456	.385
MAX RADIUS	1.297	1.153	.862
HORIZONTAL SPREAD	2.297	1.798	1.156
VERTICAL SPREAD	1.195	1.195	.988
EXTREME SPREAD	2.297	2.159	1.268
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

5 Sep 1981

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CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 0

3in = 0

HS= 0.004

VS= 1.422

GS= 0.004

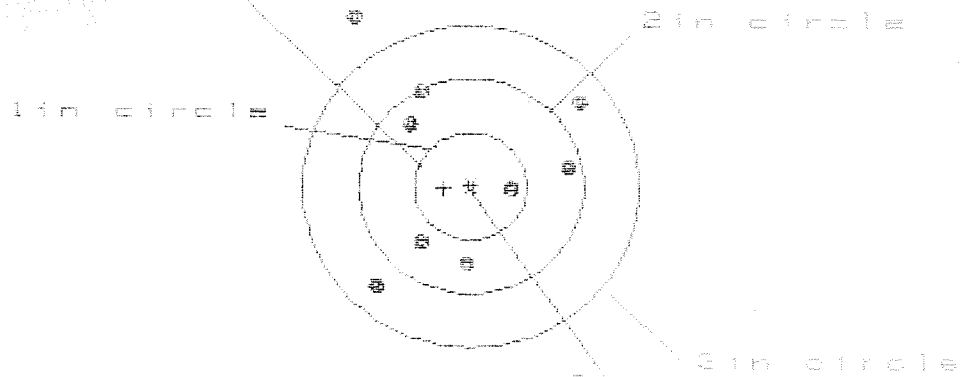
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.968	.717	.578
MINIMUM X	-2.256	-.737	-.647
MAXIMUM Y	.778	.784	.736
MINIMUM Y	-.644	-.638	-.686
CENTROID X	-.334	-.083	-.173
CENTROID Y	-.253	-.259	-.211
POA TO CENTROID in.	.419	.272	.272
MIN RADIUS	.364	.211	.212
MEAN RADIUS	.854	.627	.610
MAX RADIUS	2.257	.975	.943
HORIZONTAL SPREAD	3.224	1.454	1.225
VERTICAL SPREAD	1.422	1.422	1.422
EXTREME SPREAD	3.254	1.585	1.528
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	0		
NUMBER IN THREE INCH CIRCLE =	0		

5 Sep 1931

FILE:/PATTERNING/CENTERFIRE_PATT/0664970113

CENTERFIRE PATTERNS # 5

POB



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 1.998

VS = 3.375

GS = 3.921

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.002	1.113	1.002
MINIMUM X	:	-1.996	-1.885	-1.823
MAXIMUM Y	:	1.538	1.334	.804
MINIMUM Y	:	-1.937	-1.081	-.914
CENTROID X	:	.240	.129	.239
CENTROID Y	:	.018	.222	.055
POB TO CENTROID in.	:	.241	.257	.246
MIN RADIUS	:	.359	.502	.359
MEAN RADIUS	:	1.070	.950	.848
MAX RADIUS	:	2.091	1.601	1.265
HORIZONTAL SPREAD	:	1.998	1.998	1.825
VERTICAL SPREAD	:	3.375	2.415	1.718
EXTREME SPREAD	:	3.921	2.484	2.484
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	