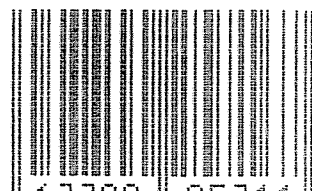


BARBER - M24 0065610

FORM

UPC



0 47700 25716 2

06649167

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0065610 06649167

MODEL 700 TM M24

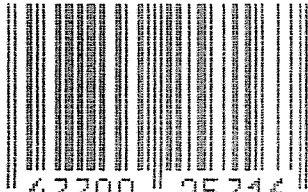
ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

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. C6649167	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716	



5716 C6649167

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649167

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/27/91	WB
620	Apply Coatings (Barrel Action)		8/28/91	JA
	Apply Coating (Bolt)		8/28/91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		8/30/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/30/91	RW
	C) Inspect Ejector Hole for Chamfer		8/30/91	RW
	D) Oil Firing Pin Ass'y		8/30/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	FL

op. #	BARBER - M24 0065614 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			9/11/91	SH
	G) Safety Off Force	3	3	3			9/11/91	SH
	H) Trigger Pull Test & Retainability						9-11-91	SH
	I) Firing Pin Indent	.023	.023	.023			9/11/91	SH
	J) Assemble Stock						10/7/91	RW
	K) Assemble Swivel Studs						10/14/91	SH
	L) Attach Front and Rear Sight Assemblies						10/7/91	RW
	M) Iron Sight Alignment						10/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/7/91	RW
	O) Attach Scope to Rifle						10/7/91	RW
	P) Detach & Attach Scope 20 Times						10/7/91	RW
640	Gallery Target & Test						10/10/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						10/10/91	KT
655	Final Inspection							
	A) Headspace						10/14/91	SH
	B) Trigger Pull	2.31	2.35	2.38	2.50	2.43	10/14/91	SH
	C) Function						10/14/91	SH
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. C6649167

DATE 9/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.42	2.50	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.46	2.48	2.35	
PULL #3	2.35	2.27	2.43	2.38	
PULL #4	2.39	2.45	2.44	2.50	
PULL #5	2.48	2.48	2.48	2.43	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.43		
PULL #2	3.27	3.41		
PULL #3	3.45	3.57		
PULL #4	3.31	3.50		
PULL #5	3.30	3.56		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.34		4.50
PULL #2	4.28	4.44		4.49
PULL #3	4.24	4.51		4.48
PULL #4	4.46	4.39		4.40
PULL #5	4.40	4.49		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649167
10 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.706614
1 TO 2	.727512
1 TO 3	1.04709
1 TO 4	1.5778
1 TO 5	.831291

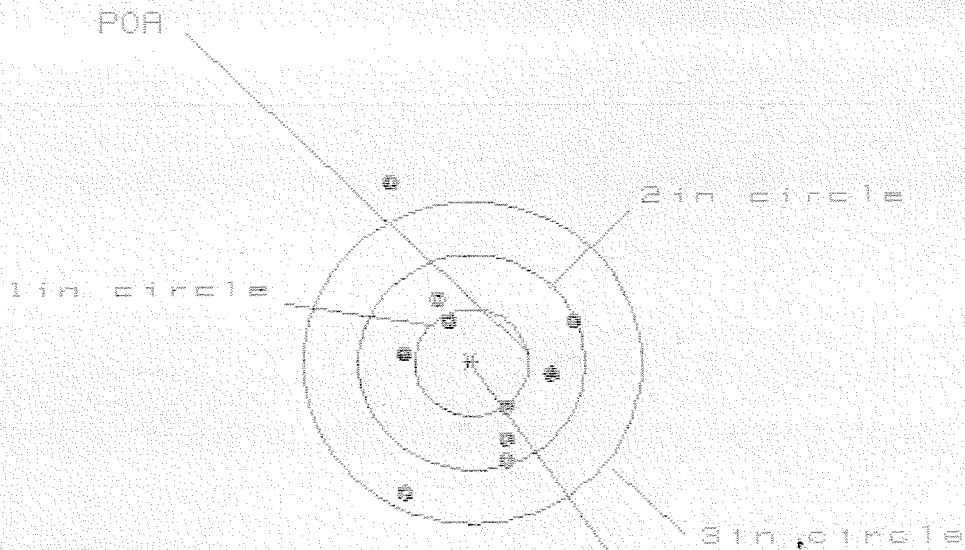
1 + 4 <----POA
53

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0544
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1858
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .1936
THE AMR FOR THIS RIFLE IS: .9824

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649167

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 8

3 in - 9

HS- 1.579

VS- 2.914

GS- 2.916

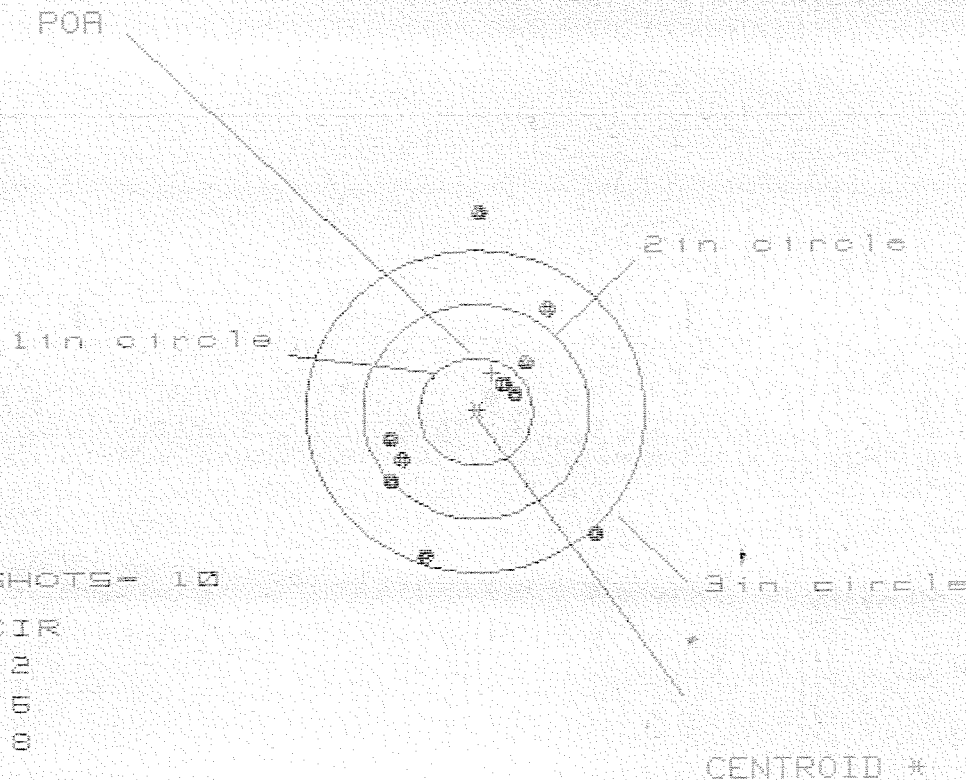
CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.852	.771	.684
MINIMUM X	-.727	-.699	-.769
MAXIMUM Y	1.721	.824	.698
MINIMUM Y	-1.193	-1.001	-.803
CENTROID X	-.698	-.617	-.530
CENTROID Y	.110	-.082	.044
POA TO CENTROID in.	.706	.622	.531
MIN RADIUS	.450	.322	.372
MEAN RADIUS	.880	.745	.675
MAX RADIUS	1.869	1.221	.841
HORIZONTAL SPREAD	1.579	1.470	1.453
VERTICAL SPREAD	2.914	1.825	1.501
EXTREME SPREAD	2.916	2.185	1.598
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649167

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.810

VS= 3.147

GS= 3.190

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.004	1.007	.756
MINIMUM X	-.806	-.803	-.677
MAXIMUM Y	1.832	1.208	1.091
MINIMUM Y	-1.315	-1.112	-1.229
CENTROID X	-.141	-.144	-.270
CENTROID Y	-.358	-.561	-.444
POA TO CENTROID in.	.384	.580	.520
MIN RADIUS	.358	.493	.513
MEAN RADIUS	.981	.894	.810
MAX RADIUS	1.832	1.378	1.327
HORIZONTAL SPREAD	1.810	1.810	1.433
VERTICAL SPREAD	3.147	2.320	2.320
EXTREME SPREAD	3.190	2.574	2.574
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0649167

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 7

HS= 3.770

VS= 1.648

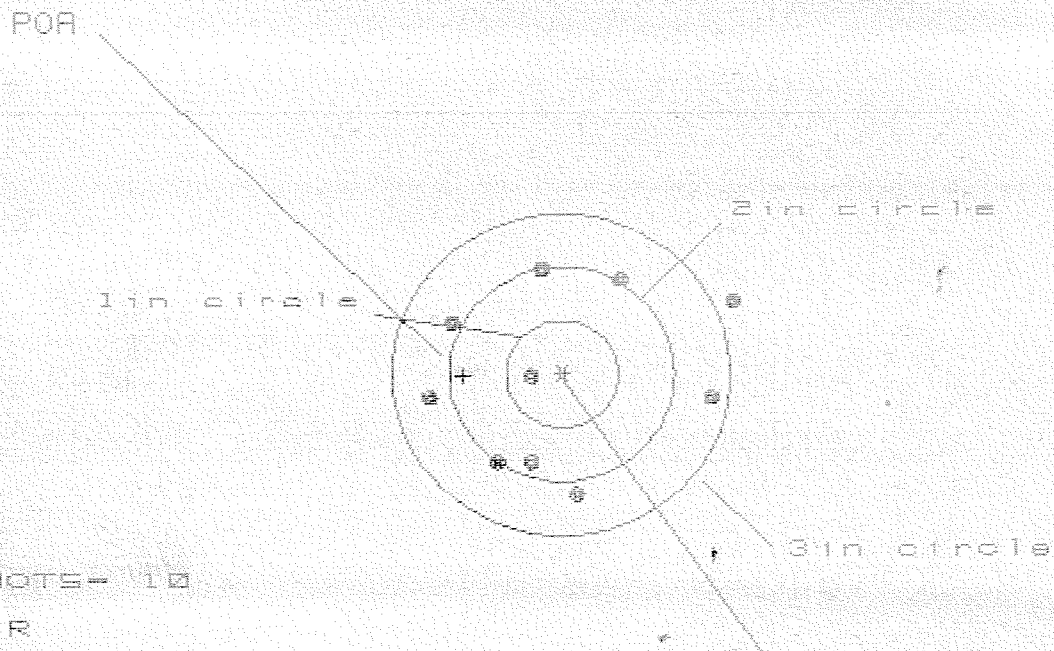
GS= 3.929

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.774
MINIMUM X	-1.996
MAXIMUM Y	.678
MINIMUM Y	-.970
CENTROID X	.254
CENTROID Y	-.326
POA TO CENTROID in.	.414
MIN RADIUS	.280
MEAN RADIUS	.941
MAX RADIUS	2.108
HORIZONTAL SPREAD	3.770
VERTICAL SPREAD	1.648
EXTREME SPREAD	3.929
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	7
NUMBER IN THREE INCH CIRCLE	7

18 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649167

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS= 2.634

VS= 2.066

GS= 2.782

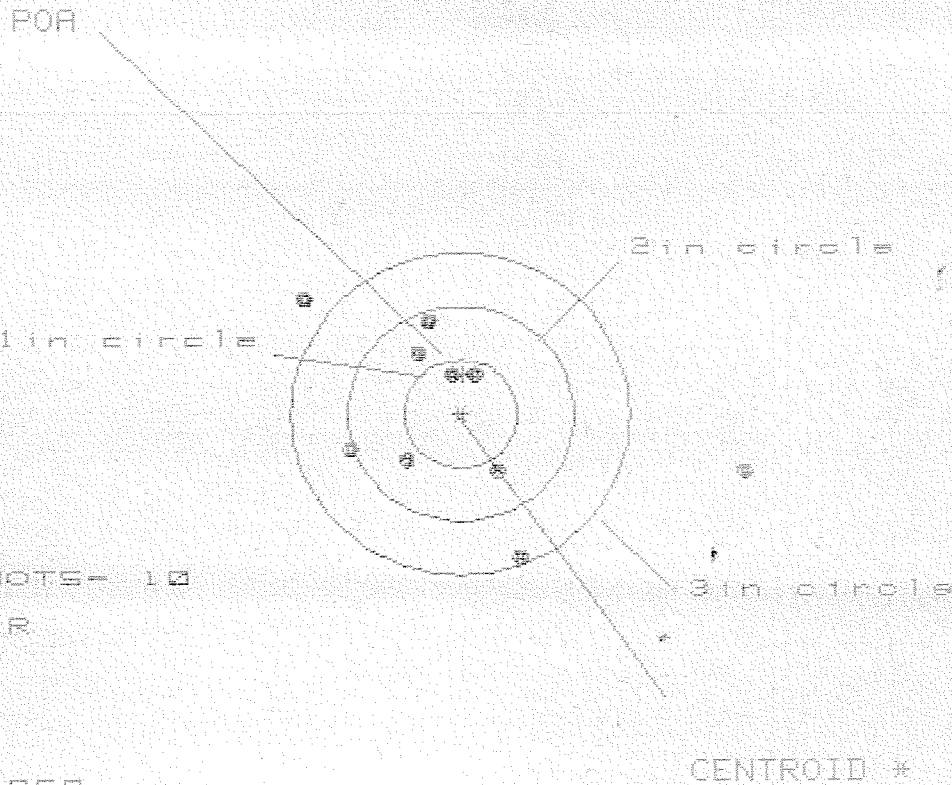
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.486	1.526	.911
MINIMUM X	-1.148	-.983	-.792
MAXIMUM Y	.981	1.058	1.045
MINIMUM Y	-1.085	-1.008	-1.021
CENTROID X	.877	.712	.521
CENTROID Y	.016	-.061	-.048
POA TO CENTROID in.	.877	.714	.523
MIN RADIUS	.310	.149	.056
MEAN RADIUS	1.058	.950	.839
MAX RADIUS	1.642	1.530	1.331
HORIZONTAL SPREAD	2.634	2.509	1.703
VERTICAL SPREAD	2.066	2.066	2.066
EXTREME SPREAD	2.782	2.509	2.081
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

10 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06645167

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.868

VS= 2.457

GS= 4.207

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.533	.829	.698
MINIMUM X	-1.335	-1.054	-.843
MAXIMUM Y	1.096	1.034	.973
MINIMUM Y	-1.361	-1.423	-1.294
CENTROID X	-.020	-.301	-.170
CENTROID Y	-.371	-.309	-.438
POA TO CENTROID in.	.371	.431	.469
MIN RADIUS	.357	.348	.420
MEAN RADIUS	1.052	.841	.767
MAX RADIUS	2.594	1.647	1.470
HORIZONTAL SPREAD	3.868	1.883	1.541
VERTICAL SPREAD	2.457	2.457	2.267
EXTREME SPREAD	4.207	3.096	2.417
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	