

BARBER - M24 0066244

FURN

UPC



0 47700 25716 7

C6649200

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0066244 M2400066283

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0066246

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649200

ORDER NO.

5716

20

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



5716 C6649200

ORDER 5716

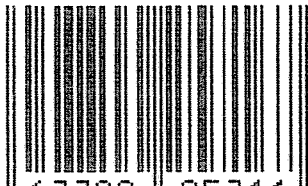
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649200

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action		OCT 10 1991	HR
	Magnaflux Bolt		OCT 10 1991	HR
615	Rollmark Caliber		OCT 10 1991	JS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/1/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/14/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/18/91	JS

op. #	BARBER M24 0066248	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-18-91	DH
	G) Safety Off Force	2	2 1/2	2 1/4			11-18-91	DH
	H) Trigger Pull Test & Retainability						11/18/91	JL
	I) Firing Pin Indent	.022	.021	.020			11-18-91	DH
	J) Assemble Stock						11/19/91	RW
	K) Assemble Swivel Studs						11-27-91	DH
	L) Attach Front and Rear Sight Assemblies						11/19/91	RW
	M) Iron Sight Alignment						11/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/19/91	RW
	O) Attach Scope to Rifle						11/19/91	RW
	P) Detach & Attach Scope 20 Times						11/19/91	RW
640	Gallery Target & Test						11-21-91	AC
	A) Time						11-21-91	AC
	B) Malfunctions						11-21-91	AC
	C) Pierced Primers						11-21-91	AC
	D) Optical Clarity of Scope						11-22-91	AC
645	Inspect for Live Ammo						11-21-91	AC
655	Final Inspection							
	A) Headspace						11-27-91	DH
	B) Trigger Pull	2.43	2.47	2.42	2.41	2.46	11-25-91	JL
	C) Function						11-27-91	DH
660	Pack						12-19-91	NF

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

SERIAL NO C-6649200DATE 11-18-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.38	2.40	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.41	2.35	2.47	
PULL #3	2.26	2.29	2.30	2.42	
PULL #4	2.35	2.40	2.44	2.41	
PULL #5	2.29	2.42	2.50	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.62	3.42		
PULL #2	3.30	3.45		
PULL #3	3.27	3.44		
PULL #4	3.33	3.44		
PULL #5	3.46	3.40		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.31		4.31
PULL #2	4.31	4.31		4.28
PULL #3	4.27	4.27		4.25
PULL #4	4.32	4.31		4.29
PULL #5	4.32	4.32		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649200
21 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.319265
1 TO	2	.543949
1 TO	3	.28654
1 TO	4	.267576
1 TO	5	.139807

34 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0342
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .118445
THE AMR FOR THIS RIFLE IS: 1.033

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649200

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 2.077

VS= 3.065

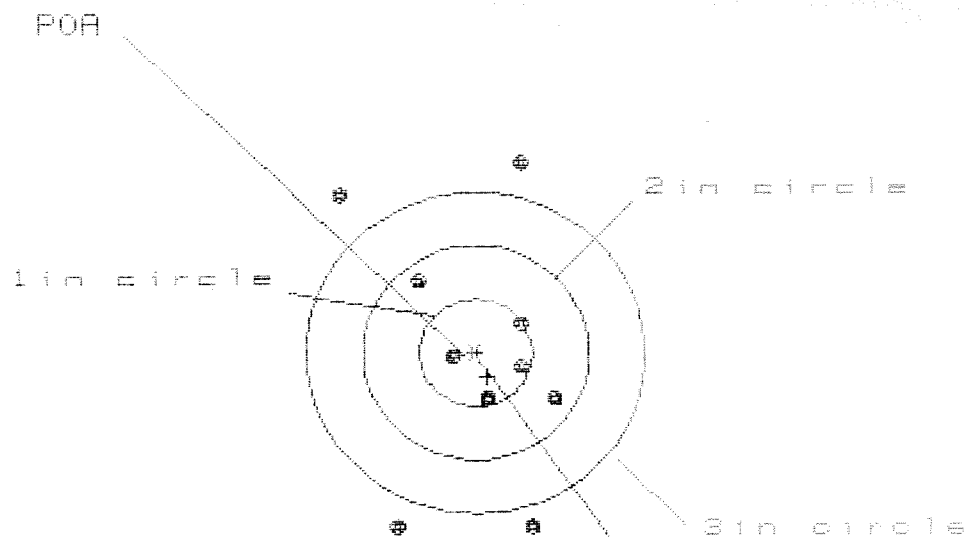
GS= 3.069

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.950	.990	1.058
MINIMUM X	-1.127	-1.087	-1.018
MAXIMUM Y	1.562	.969	.803
MINIMUM Y	-1.503	-1.330	-1.056
CENTROID X	.263	.223	.135
CENTROID Y	-.181	-.354	-.188
POA TO CENTROID in.	.319	.419	.243
MIN RADIUS	.124	.131	.054
MEAN RADIUS	1.004	.938	.842
MAX RADIUS	1.603	1.438	1.157
HORIZONTAL SPREAD	2.077	2.077	2.077
VERTICAL SPREAD	3.065	2.299	1.859
EXTREME SPREAD	3.069	2.339	2.110
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648200

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 6

HS= 1.871

VS= 3.460

GS= 3.623

CENTROID #

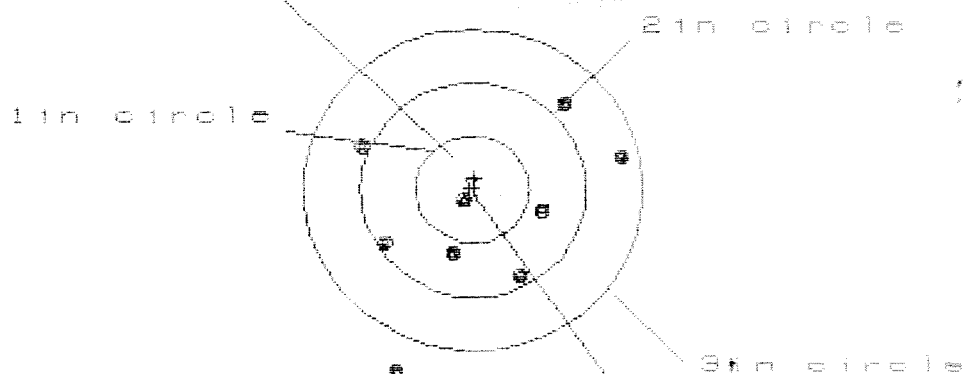
PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.674	.542	.576
MINIMUM X	:	-1.196	-.802	-.768
MAXIMUM Y	:	1.815	1.981	1.059
MINIMUM Y	:	-1.645	-1.479	-1.232
CENTROID X	:	-.099	.034	.000
CENTROID Y	:	.225	.060	-.187
POA TO CENTROID in.	:	.246	.069	.187
MIN RADIUS	:	.203	.220	.053
MEAN RADIUS	:	1.047	.917	.781
MAX RADIUS	:	1.908	1.999	1.452
HORIZONTAL SPREAD	:	1.871	1.344	1.344
VERTICAL SPREAD	:	3.460	3.460	2.291
EXTREME SPREAD	:	3.623	3.623	2.473
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

21 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649200

CENTERFIRE PATTERNS # 3

POR



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.266

VS = 4.135

GS = 4.137

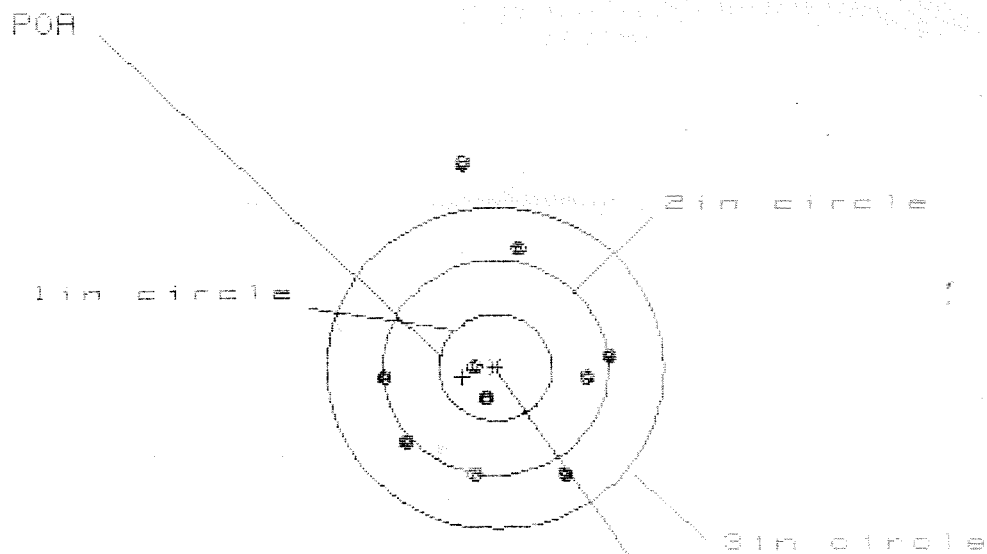
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.328	1.262	1.162
MINIMUM X	:	-0.938	-1.004	-1.104
MAXIMUM Y	:	2.442	1.040	.862
MINIMUM Y	:	-1.693	-1.421	-.732
CENTROID X	:	-.013	.053	.153
CENTROID Y	:	-.104	-.376	-.198
POR TO CENTROID in.	:	.105	.380	.250
MIN RADIUS	:	.123	.199	.219
MEAN RADIUS	:	1.115	.916	.830
MAX RADIUS	:	2.514	1.630	1.210
HORIZONTAL SPREAD	:	2.266	2.266	2.266
VERTICAL SPREAD	:	4.135	2.461	1.594
EXTREME SPREAD	:	4.137	2.930	2.292
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Nov 1991

FILE://PATTERNING/CENTERFIRE_PATT/08649200

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.020

VS = 2.953

GS = 3.087

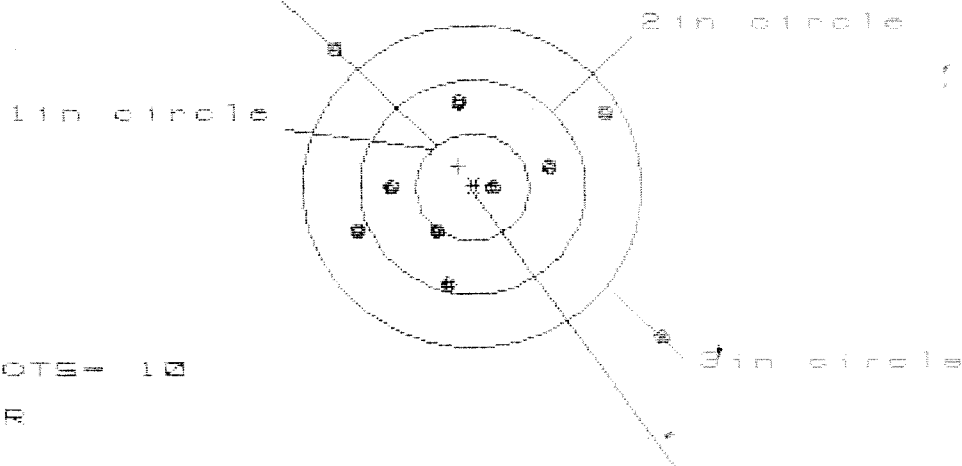
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.983	.951	1.023
MINIMUM X	-1.037	-1.069	-.997
MAXIMUM Y	1.962	1.283	1.187
MINIMUM Y	-.992	-.774	-.870
CENTROID X	.292	.324	.252
CENTROID Y	.085	-.132	-.036
POA TO CENTROID in.	.304	.350	.255
MIN RADIUS	.152	.130	.150
MEAN RADIUS	.960	.813	.784
MAX RADIUS	1.983	1.290	1.204
HORIZONTAL SPREAD	2.020	2.020	2.020
VERTICAL SPREAD	2.953	2.057	2.057
EXTREME SPREAD	3.087	2.105	2.086
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

21 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649200

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 2.936

VS= 2.757

GS= 4.028

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.689	1.319	1.187
MINIMUM X	:	-1.248	-1.060	-.955
MAXIMUM Y	:	1.321	1.161	.822
MINIMUM Y	:	-1.436	-1.105	-.960
CENTROID X	:	.124	-.064	.068
CENTROID Y	:	-.196	-.036	-.181
POA TO CENTROID in.	:	.232	.074	.194
MIN RADIUS	:	.129	.347	.184
MEAN RADIUS	:	1.040	.907	.796
MAX RADIUS	:	2.217	1.572	1.387
HORIZONTAL SPREAD	:	2.936	2.379	2.142
VERTICAL SPREAD	:	2.757	2.266	1.781
EXTREME SPREAD	:	4.028	2.497	2.416
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	