

BARBER - M24 0066433

FORM

UPC



0 47700 25716 7

C6649213

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0066433 M2400966472

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

BARBER - M24 0066435

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649213

ORDER NO.

5716

20

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



5716 C6649213

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



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GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649213

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	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	LS
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	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		12-6-91	JH

op. #	BARBER M24 0066437	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12-6-91	JA
	G) Safety Off Force	3	3	3			12-6-91	JA
	H) Trigger Pull Test & Retainability						12-6-91	JA
	I) Firing Pin Indent	.020	.021	.021			12-6-91	JA
	J) Assemble Stock						12/6/91	RW
	K) Assemble Swivel Studs						12-7-91	AC
	L) Attach Front and Rear Sight Assemblies						12/6/91	RW
	M) Iron Sight Alignment						12/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/6/91	RW
	O) Attach Scope to Rifle						12/6/91	RW
	P) Detach & Attach Scope 20 Times						12/6/91	RW
640	Gallery Target & Test						12-6-91	DA
	A) Time						12-6-91	DA
	B) Malfunctions						12-6-91	DA
	C) Pierced Primers						12-6-91	DA
	D) Optical Clarity of Scope						12-6-91	DA
645	Inspect for Live Ammo						12-6-91	DA
655	Final Inspection							
	A) Headspace						12-7-91	AC
	B) Trigger Pull	239	239	234	231	234	12-7-91	DA
	C) Function						12-7-91	AC
660	Pack						12-18-91	N

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649213DATE 12-6-91TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.44	2.41	2.39	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.43	2.44	2.39	
PULL #3	2.39	2.36	2.49	2.34	
PULL #4	2.39	2.41	2.38	2.31	
PULL #5	2.39	2.44	2.36	2.34	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.51	3.46		
PULL #2	3.27	3.44		
PULL #3	3.46	3.47		
PULL #4	3.33	3.47		
PULL #5	3.45	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.28		4.32
PULL #2	4.30	4.28		4.32
PULL #3	4.27	4.30		4.31
PULL #4	4.29	4.32		4.30
PULL #5	4.28	4.30		4.34
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649213
6 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.402613
1 TO 2	.490169
1 TO 3	.255327
1 TO 4	.374422
1 TO 5	.715153

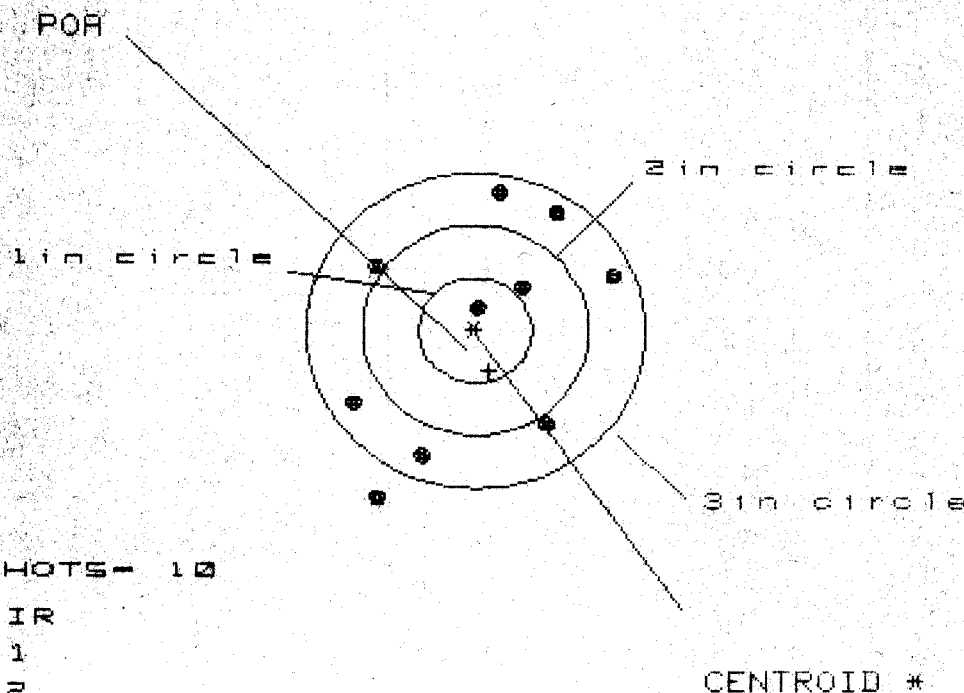
1
4
5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.0876$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.029$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.0922755$
THE AMR FOR THIS RIFLE IS: $.9454$

6 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649213

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 2

3 in = 9

HS = 2.300

VS = 2.862

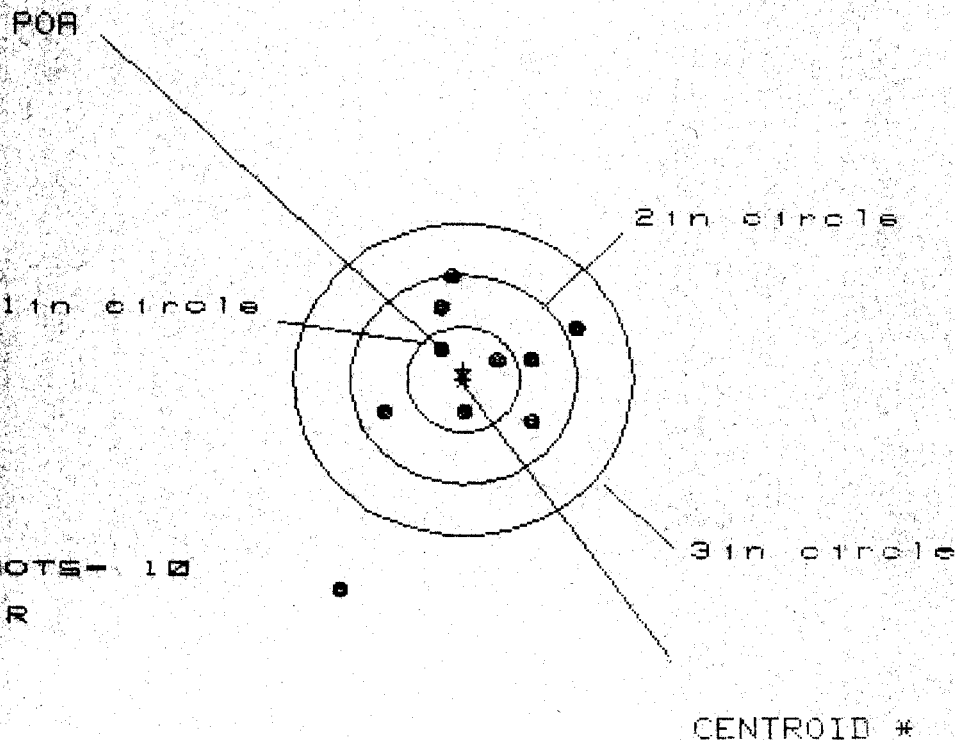
GS = 3.164

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.263	1.164	1.248
MINIMUM X	:	-1.045	-1.144	-1.060
MAXIMUM Y	:	1.327	1.156	1.280
MINIMUM Y	:	-1.535	-1.351	-1.227
CENTROID X	:	-.121	-.022	-.106
CENTROID Y	:	.384	.555	.431
POA TO CENTROID in.	:	.403	.555	.444
MIN RADIUS	:	.223	.137	.180
MEAN RADIUS	:	1.139	1.032	1.021
MAX RADIUS	:	1.773	1.454	1.346
HORIZONTAL SPREAD	:	2.308	2.308	2.308
VERTICAL SPREAD	:	2.862	2.507	2.507
EXTREME SPREAD	:	3.164	2.634	2.599
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	2		
NUMBER IN THREE INCH CIRCLE	=	9		

6 Dec 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.078

VS= 3.003

GS= 3.235

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.956

.831

.589

-1.123

-.874

-.770

1.016

.795

.829

-1.987

-.637

-.603

.000

.125

.021

-.091

.130

.096

.091

.180

.098

.277

.149

.254

.825

.616

.583

2.282

.998

.891

2.078

1.705

1.359

3.003

1.432

1.432

3.235

1.863

1.591

3

7

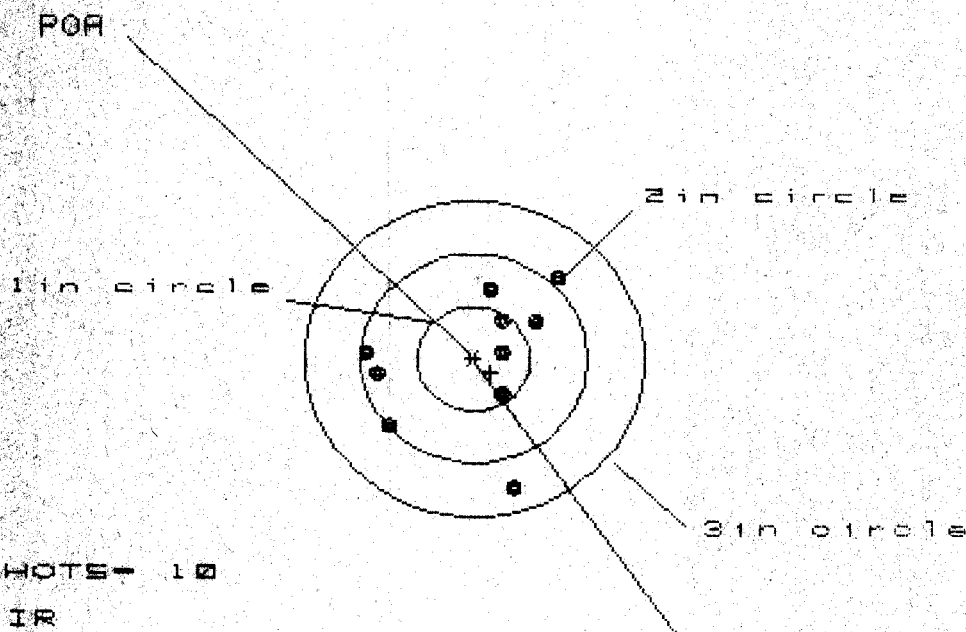
9

6 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6849213

CENTERFIRE PATTERNS

3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.677

VS = 2.069

GS = 2.115

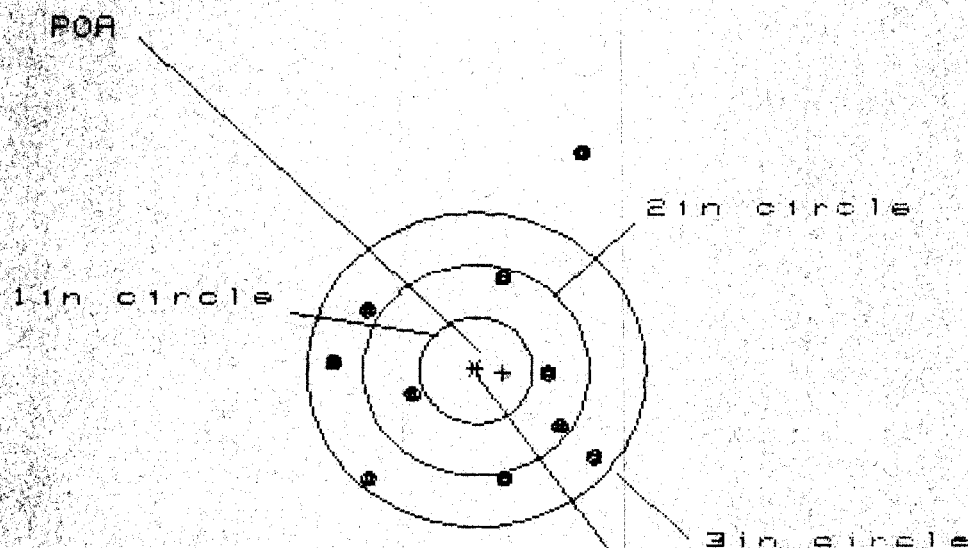
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.762	.798	.661
MINIMUM X	:	-.915	-.879	-.779
MAXIMUM Y	:	.806	.665	.647
MINIMUM Y	:	-1.263	-.767	-.683
CENTROID X	:	-.147	-.183	-.283
CENTROID Y	:	.130	.271	.188
POA TO CENTROID in.	:	.197	.327	.339
MIN RADIUS	:	.265	.312	.397
MEAN RADIUS	:	.757	.685	.654
MAX RADIUS	:	1.304	1.059	.930
HORIZONTAL SPREAD	:	1.677	1.677	1.440
VERTICAL SPREAD	:	2.069	1.432	1.331
EXTREME SPREAD	:	2.115	2.094	1.613
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

6 Dec 1991

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.369

VS= 3.121

GS= 3.619

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.065	1.167	1.065
MINIMUM X	:	-1.304	-1.202	-1.304
MAXIMUM Y	:	2.099	1.077	.979
MINIMUM Y	:	-1.022	-.789	-.886
CENTROID X	:	-.237	-.339	-.237
CENTROID Y	:	.028	-.205	-.107
POA TO CENTROID in.	:	.239	.396	.260
MIN RADIUS	:	.620	.498	.613
MEAN RADIUS	:	1.150	.996	.970
MAX RADIUS	:	2.290	1.302	1.323
HORIZONTAL SPREAD	:	2.369	2.369	2.369
VERTICAL SPREAD	:	3.121	1.866	1.865
EXTREME SPREAD	:	3.619	2.533	2.533
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Dec 1991

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.910

VS= 2.738

GS= 2.827

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.801	.788	.859
MINIMUM X	:	-1.109	-1.122	-1.052
MAXIMUM Y	:	1.296	1.135	.781
MINIMUM Y	:	-1.442	-1.016	-.874
CENTROID X	:	.067	.080	.010
CENTROID Y	:	-.306	-.145	-.287
POA TO CENTROID in.	:	.313	.166	.287
MIN RADIUS	:	.143	.268	.201
MEAN RADIUS	:	.856	.792	.720
MAX RADIUS	:	1.447	1.292	1.310
HORIZONTAL SPREAD	:	1.910	1.910	1.910
VERTICAL SPREAD	:	2.738	2.151	1.655
EXTREME SPREAD	:	2.827	2.348	2.348
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	10		