

C6611475

MODEL 700™ M24

Model S&S™

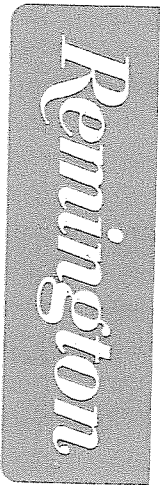
Action _____

Barrel Length _____

Capacity _____

Order No. 5715

*Includes 1 in chamber.



Sinclair

BARBER - M24 0077552

Remington		DU PONT REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700™ M24		SERIAL NO. C6611475	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		46	



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0077552

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611475

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/26/91	K.S.
600	Proof		3/26/91	K.S.
607	Check Headspace		3/26/91	K.S.
610	Dis-assemble Gun		3/26/91	K.S.
612	Magnaflux Barrel Action	APR 2 1991		KR
	Magnaflux Bolt	APR 2 1991		U
615	Rollmark Caliber	APR 2 1991		GL
617	Drill and Tap Sight Holes	APR 5 1991		FB
618	Polish Barrel	APR 5 1991		WB
620	Apply Coatings (Barrel Action)		4-16-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/10/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/10/91	KS
	C) Inspect Ejector Hole for Chamfer		4/10/91	KS
	D) Oil Firing Pin Ass'y		4/10/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/11/91	SM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4/11/91	SM
	G) Safety Off Force	3	3	3			4/11/91	SM
	H) Trigger Pull Test & Retainability						4/11/91	SM
	I) Firing Pin Indent	.0215	.022	.022			4/11/91	SM
	J) Assemble Stock						4/11/91	KS
	K) Assemble Swivel Studs						4-16-91	AC
	L) Attach Front and Rear Sight Assemblies						4/11/91	KS
	M) Iron Sight Alignment						4/11/91	KS
	N) Detach Front & Rear Sights & place in numbered container						4/11/91	KS
	O) Attach Scope to Rifle						4/11/91	KS
	P) Detach & Attach Scope 20 Times						4/11/91	KS
640	Gallery Target & Test						4-15-91	AC
	A) Time						4-15-91	AC
	B) Malfunctions						4-15-91	AC
	C) Pierced Primers						4-15-91	AC
	D) Optical Clarity of Scope						4-15-91	AC
645	Inspect for Live Ammo						4-15-91	AC
655	Final Inspection							
	A) Headspace						4-16-91	AC
	B) Trigger Pull	2.52	2.53	2.53	2.47	2.44	4/16/91	SM
	C) Function						4-16-91	AC
660	Pack						6-17-91	AC

TII.

BARBER - M24 0077555

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611475

DATE 4/11/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.47	2.40	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.42	2.46	2.53	
PULL #3	2.42	2.44	2.39	2.53	
PULL #4	2.44	2.31	2.43	2.47	
PULL #5	2.49	2.43	2.43	2.44	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.40		
PULL #2	3.35	3.33		
PULL #3	3.20	3.43		
PULL #4	3.34	3.43		
PULL #5	3.40	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.23		4.24
PULL #2	4.28	4.24		4.23
PULL #3	4.30	4.26		4.27
PULL #4	4.28	4.26		4.24
PULL #5	4.33	4.25		4.27
TOTAL				
AVG.				

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTONBARBER - M24 0077555
M24009977594

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611475
15 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0469574
1 TO	2	.222596
1 TO	3	.176799
1 TO	4	.230139
1 TO	5	.401005

45-45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0012
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0938
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0938077
THE AMR FOR THIS RIFLE IS: .857

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611475

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.349

VS= 2.119

GS= 2.359

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.455	.620	.667
MINIMUM X	:	-.894	-.732	-.655
MAXIMUM Y	:	.818	.761	.591
MINIMUM Y	:	-1.302	-1.358	-.520
CENTROID X	:	-.021	-.183	-.260
CENTROID Y	:	-.042	.014	.184
POA TO CENTROID in.	:	.048	.184	.319
MIN RADIUS	:	.166	.056	.098
MEAN RADIUS	:	.779	.641	.512
MAX RADIUS	:	1.542	1.493	.892
HORIZONTAL SPREAD	:	2.349	1.352	1.322
VERTICAL SPREAD	:	2.119	2.119	1.111
EXTREME SPREAD	:	2.359	2.282	1.727
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

15 Apr 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.083

VS = 1.737

GS = 2.511

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.862	.726	.605
MINIMUM X	:	-1.221	-.971	-.911
MAXIMUM Y	:	.713	.629	.634
MINIMUM Y	:	-1.024	-1.108	-1.030
CENTROID X	:	.024	.160	.281
CENTROID Y	:	-.260	-.176	-.254
POA TO CENTROID in.	:	.261	.237	.379
MIN RADIUS	:	.403	.254	.166
MEAN RADIUS	:	.895	.793	.723
MAX RADIUS	:	1.439	1.223	1.211
HORIZONTAL SPREAD	:	2.083	1.697	1.516
VERTICAL SPREAD	:	1.737	1.737	1.664
EXTREME SPREAD	:	2.511	2.076	2.076
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Apr 1991

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CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 1.535

VS = 2.443

GS = 2.495

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.820	.793	.823
MINIMUM X	:	-.715	-.742	-.712
MAXIMUM Y	:	1.267	.819	.690
MINIMUM Y	:	-1.176	-1.035	-.856
CENTROID X	:	.102	.129	.099
CENTROID Y	:	.085	-.056	.073
POA TO CENTROID in.	:	.133	.140	.123
MIN RADIUS	:	.413	.338	.411
MEAN RADIUS	:	.845	.791	.745
MAX RADIUS	:	1.289	1.140	1.074
HORIZONTAL SPREAD	:	1.535	1.535	1.535
VERTICAL SPREAD	:	2.443	1.854	1.545
EXTREME SPREAD	:	2.495	2.030	2.030
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

15 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811475

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.124

VS= 2.267

GS= 2.299

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.521	.537	.388
MINIMUM X	:	-.603	-.587	-.520
MAXIMUM Y	:	1.373	.884	.792
MINIMUM Y	:	-.894	-.742	-.511
CENTROID X	:	-.029	-.045	-.112
CENTROID Y	:	.188	.036	.128
POA TO CENTROID in.	:	.190	.057	.170
MIN RADIUS	:	.117	.205	.092
MEAN RADIUS	:	.649	.551	.498
MAX RADIUS	:	1.380	.915	.795
HORIZONTAL SPREAD	:	1.124	1.124	.908
VERTICAL SPREAD	:	2.267	1.626	1.303
EXTREME SPREAD	:	2.299	1.761	1.378
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

