

BARBER - M24 0101334

FORM

UPC



6665688

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0101334

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	
*INCLUDES 1 IN CHAMBER	

BARBER - M24 010133B

Remington



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

MODEL 700 TM M24

SERIAL NO.

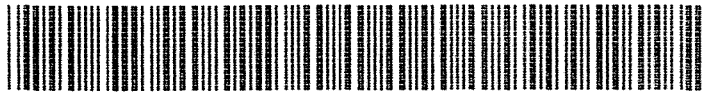
C6665688

ORDER NO.

5716

20

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



5716 C6665688

ORDER 5716

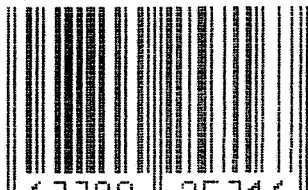
MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



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0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665688

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 26	91	RW
600	Proof	9 26	91	RW
607	Check Headspace	9 26	91	RW
610	Dis-assemble Gun	9 26	91	RW
612	Magnaflux Barrel Action		SEP 30 1991	KR
	Magnaflux Bolt		SEP 30 1991	KR
615	Rollmark Caliber		SEP 30 1991	LS
617	Drill and Tap Sight Holes		SEP 30 1991	ES
618	Polish Barrel		OCT 2 1991	WT
620	Apply Coatings (Barrel Action)		10-13-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/13/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/13/91	RW
	C) Inspect Ejector Hole for Chamfer		10/13/91	RW
	D) Oil Firing Pin Ass'y		10/13/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	JS

op. #	OP. NAME BARBER M24 0101338	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 $\frac{1}{4}$	4 $\frac{1}{4}$	4			10-22-91	DH
	G) Safety Off Force	3	3	2 $\frac{3}{4}$			10-22-91	DH
	H) Trigger Pull Test & Retainability						10/22/91	JU
	I) Firing Pin Indent	.022	.024	.022			10-22-91	DH
	J) Assemble Stock						10/23/91	RW
	K) Assemble Swivel Studs						10-30-91	Ac
	L) Attach Front and Rear Sight Assemblies						10/23/91	RW
	M) Iron Sight Alignment						10/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/23/91	RW
	O) Attach Scope to Rifle						10/23/91	RW
	P) Detach & Attach Scope 20 Times						10/23/91	RW
640	Gallery Target & Test						10/23/91	LT
	A) Time							LT
	B) Malfunctions							LT
	C) Pierced Primers							LT
	D) Optical Clarity of Scope							LT
645	Inspect for Live Ammo						10/23/91	LT
655	Final Inspection							
	A) Headspace						10-30-91	Ac
	B) Trigger Pull	259	260	261	255	249	10-25-91	DH
	C) Function						10-30-91	Ac
660	Pack						12-20-91	✓

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

SERIAL NO. C-6665688DATE 8/22/91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.45	2.48	259	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.38	2.40	260	
PULL #3	2.40	2.28	2.44	261	
PULL #4	2.37	2.48	2.48	255	
PULL #5	2.45	2.32	2.43	249	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.46		
PULL #2	3.55	3.44		
PULL #3	3.51	3.17		
PULL #4	3.60	3.47		
PULL #5	3.58	3.46		
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	4.35		4.29
PULL #2	4.34	4.37		4.26
PULL #3	4.34	4.32		4.25
PULL #4	4.23	4.25		4.23
PULL #5	4.28	4.25		4.30
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665688
23 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.259156
1 TO 2	.454059
1 TO 3	.207019
1 TO 4	.335452
1 TO 5	.33426

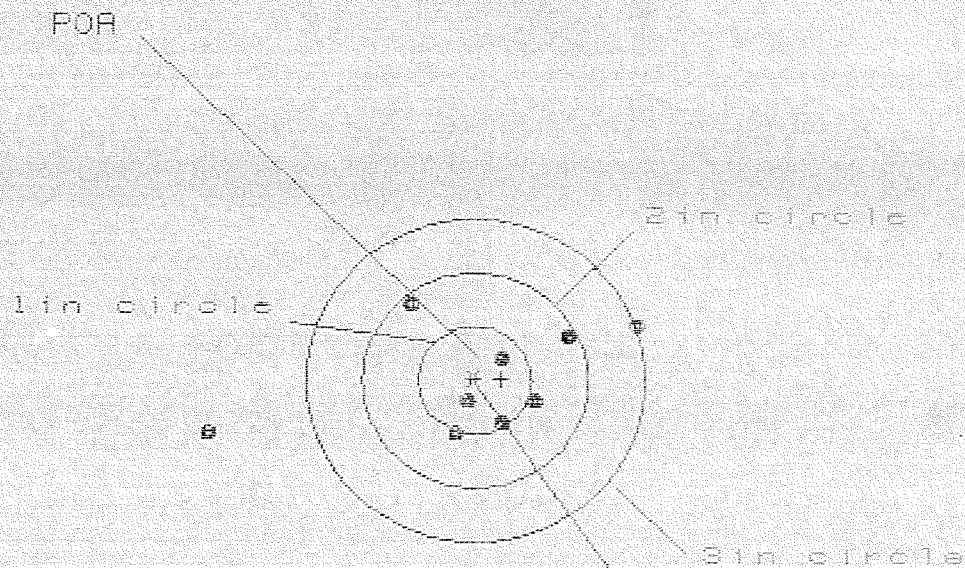
$\frac{4}{3} \times$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0146
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1592
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159868
THE AMR FOR THIS RIFLE IS: 1.051

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665666

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 8

HS= 3.850

VS= 1.192

GS= 3.986

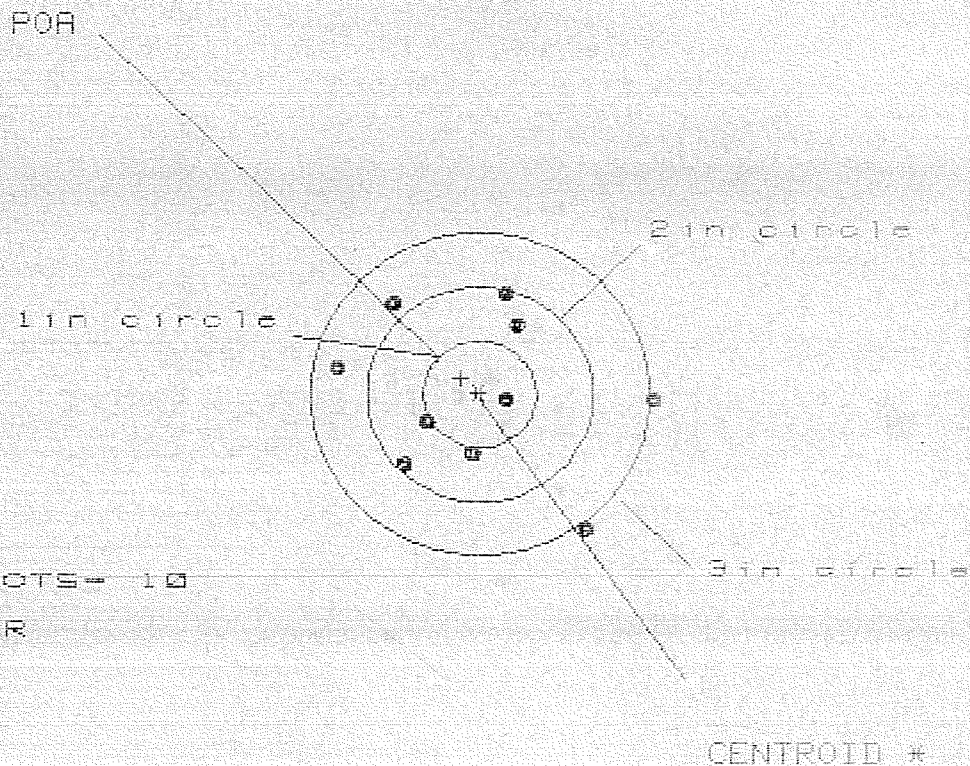
CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.455	1.189	.744
MINIMUM X	:	-2.395	-.810	-.661
MAXIMUM Y	:	.715	.663	.725
MINIMUM Y	:	-.476	-.522	-.460
CENTROID X	:	-.232	.034	-.115
CENTROID Y	:	-.010	.042	-.020
POA TO CENTROID in.	:	.233	.054	.117
MIN RADIUS	:	.199	.124	.216
MEAN RADIUS	:	.799	.602	.486
MAX RADIUS	:	2.442	1.291	.981
HORIZONTAL SPREAD	:	3.850	1.999	1.405
VERTICAL SPREAD	:	1.192	1.185	1.185
EXTREME SPREAD	:	3.986	2.005	1.434
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665688

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.760

VS = 2.175

GS = 2.774

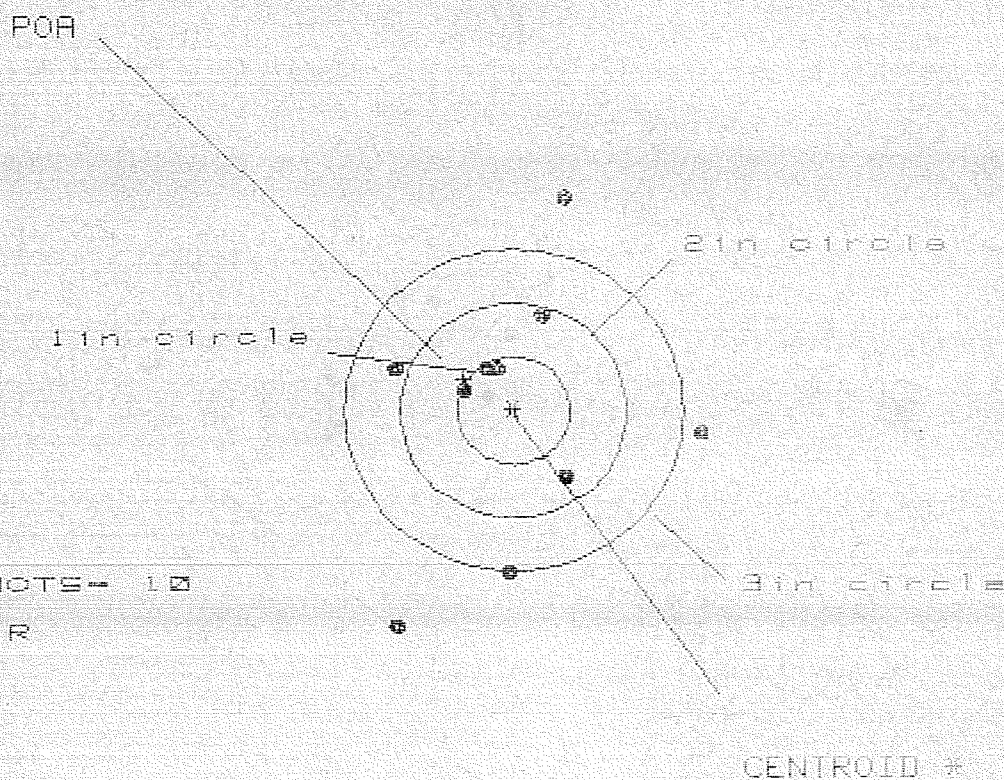
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.501	1.603	.663
MINIMUM X	-1.259	-1.157	-.956
MAXIMUM Y	.958	.822	.802
MINIMUM Y	-1.217	-.799	-.819
CENTROID X	.167	.065	-.136
CENTROID Y	-.150	-.014	.006
POA TO CENTROID in.	.224	.066	.136
MIN RADIUS	.287	.435	.427
MEAN RADIUS	.947	.881	.781
MAX RADIUS	1.527	1.612	.961
HORIZONTAL SPREAD	2.760	2.760	1.619
VERTICAL SPREAD	2.175	1.621	1.621
EXTREME SPREAD	2.774	2.774	1.848
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66656B0

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.746

VS= 4.028

GS= 4.306

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.705	1.589	1.635
MINIMUM X	:	-1.041	-1.128	-1.082
MAXIMUM Y	:	2.029	1.807	.877
MINIMUM Y	:	-1.999	-1.686	-1.460
CENTROID X	:	.444	.560	.514
CENTROID Y	:	-.290	-.068	-.294
POA TO CENTROID in.	:	.530	.564	.592
MIN RADIUS	:	.441	.319	.479
MEAN RADIUS	:	1.177	1.030	.939
MAX RADIUS	:	2.254	1.843	1.648
HORIZONTAL SPREAD	:	2.746	2.717	2.717
VERTICAL SPREAD	:	4.028	3.493	2.337
EXTREME SPREAD	:	4.306	3.532	2.790
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	7		

23 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685688

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 3.973

VS= 2.777

GS= 4.299

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.774	1.530	1.080
MINIMUM X	-2.199	-1.420	-1.229
MAXIMUM Y	1.014	.825	.581
MINIMUM Y	-1.763	-1.952	-.899
CENTROID X	-.009	.235	.044
CENTROID Y	-.259	-.070	.174
POA TO CENTROID in.	.259	.246	.179
MIN RADIUS	.275	.291	.324
MEAN RADIUS	1.297	1.059	.844
MAX RADIUS	2.781	2.480	1.440
HORIZONTAL SPREAD	3.973	2.950	2.309
VERTICAL SPREAD	2.777	2.777	1.480
EXTREME SPREAD	4.299	3.471	2.656
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		