

BARBER - M24 0101357

FORM

UPC



0 47700 25716 7

C6665690

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0101357~~ M2409401396

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

Remington

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

MODEL 700TM M24**SERIAL NO.**

C6665690

ORDER NO.**5716**

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

20



5716 C6665690

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

5690
~~26665070~~

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/27/91	KH
600	Proof		9/27/91	KH
607	Check Headspace		9/27/91	KH
610	Dis-assemble Gun		9/27/91	KH
612	Magnaflux Barrel Action	OCT	4 1991	Kcd
	Magnaflux Bolt	OCT	4 1991	Kcd
615	Rollmark Caliber	OCT	4 1991	GS
617	Drill and Tap Sight Holes	OCT	4 1991	FB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-18-91	DA
	Apply Coating (Bolt)		10-18-91	DA
625	Final Assembly			
	A) Clean inside of Bolt Assembly		10/31/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/91	KH
	C) Inspect Ejector Hole for Chamfer		10/31/91	KH
	D) Oil Firing Pin Ass'y		10/31/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-1-91	JH

op. #	BARBER M24 0101361	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	6	5			11-1-91	JH
	G) Safety Off Force	4	4	4			11-1-91	JH
	H) Trigger Pull Test & Retainability						11-1-91	JH
	I) Firing Pin Indent	.0205	.020	.0205			11-1-91	JH
	J) Assemble Stock						11/1/91	JH
	K) Assemble Swivel Studs						12-14-91	JH
	L) Attach Front and Rear Sight Assemblies						11/1/91	JH
	M) Iron Sight Alignment						11/1/91	JH
	N) Detach Front & Rear Sights & place in numbered container						11/1/91	JH
	O) Attach Scope to Rifle						11/1/91	JH
	P) Detach & Attach Scope 20 Times						11/1/91	JH
640	Gallery Target & Test						11-4-91	DH
	A) Time						11-4-91	DH
	B) Malfunctions						11-4-91	DH
	C) Pierced Primers						11-4-91	DH
	D) Optical Clarity of Scope						11-4-91	DH
645	Inspect for Live Ammo						11-4-91	DH
655	Final Inspection							
	A) Headspace						12-14-91	JH
	B) Trigger Pull	237	230	244	244	246	11-6-91	DH
	C) Function						12-14-91	JH
660	Pack						12-17-91	JH

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

SERIAL NO. C-6665690DATE 11-1-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.26	2.50	2.48	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.42	2.42	2.30	
PULL #3	2.55	2.41	2.50	2.44	
PULL #4	2.44	2.44	2.55	2.44	
PULL #5	2.43	2.53	2.52	2.46	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.57		
PULL #2	3.55	3.44		
PULL #3	3.53	3.61		
PULL #4	3.55	3.64		
PULL #5	3.57	3.73		
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	4.33		4.28
PULL #2	4.44	4.47		4.46
PULL #3	4.46	4.42		4.40
PULL #4	4.43	4.51		4.44
PULL #5	4.35	4.49		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6665690
 5 NOV 1991

CENTROIDAL DISTANCES

0 TO	1	.0374433
1 TO	2	.528002
1 TO	3	.392658
1 TO	4	.425287
1 TO	5	.207791

2
1
3 <----POB

OF CENTER OF GRAVITY FOR THIS RIFLE IS: .1674
 THE CENTER OF GRAVITY FOR THIS RIFLE IS: -.013
 THE CENTER OF GRAVITY FOR THIS RIFLE IS: .167904

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG685690

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 2.187

VS = 2.494

GS = 2.877

CENTROID #

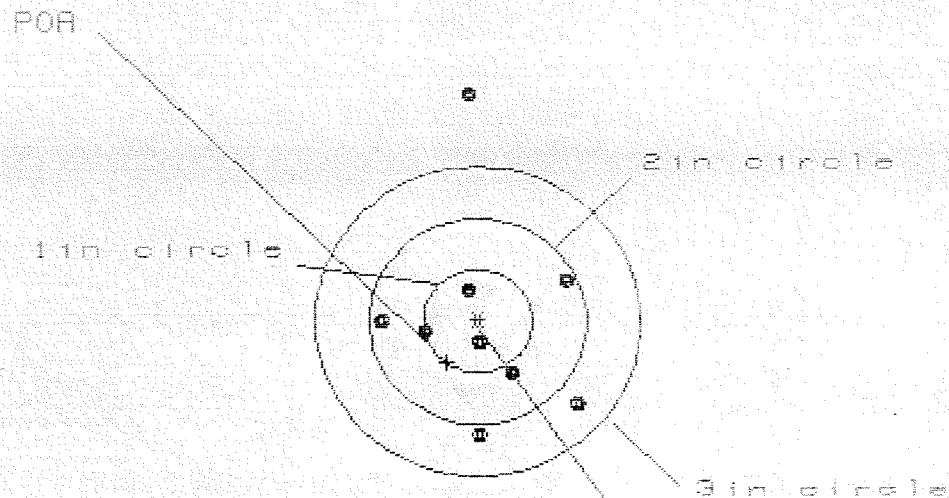
PATTERN #

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.114	1.230	.959
MINIMUM X	-1.073	-.957	-.803
MAXIMUM Y	1.168	1.021	1.129
MINIMUM Y	-1.326	-1.210	-1.102
CENTROID X	-.021	-.137	-.291
CENTROID Y	-.031	.116	.008
POA TO CENTROID in.	.037	.180	.291
MIN RADIUS	.507	.377	.237
MEAN RADIUS	1.072	.976	.878
99% RADIUS	1.690	1.507	1.339
HORIZONTAL SPREAD	2.187	2.187	1.762
VERTICAL SPREAD	2.494	2.231	2.231
EXTREME SPREAD	2.877	2.753	2.352
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

4 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6885690

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 1.776

VS= 3.237

GS= 3.238

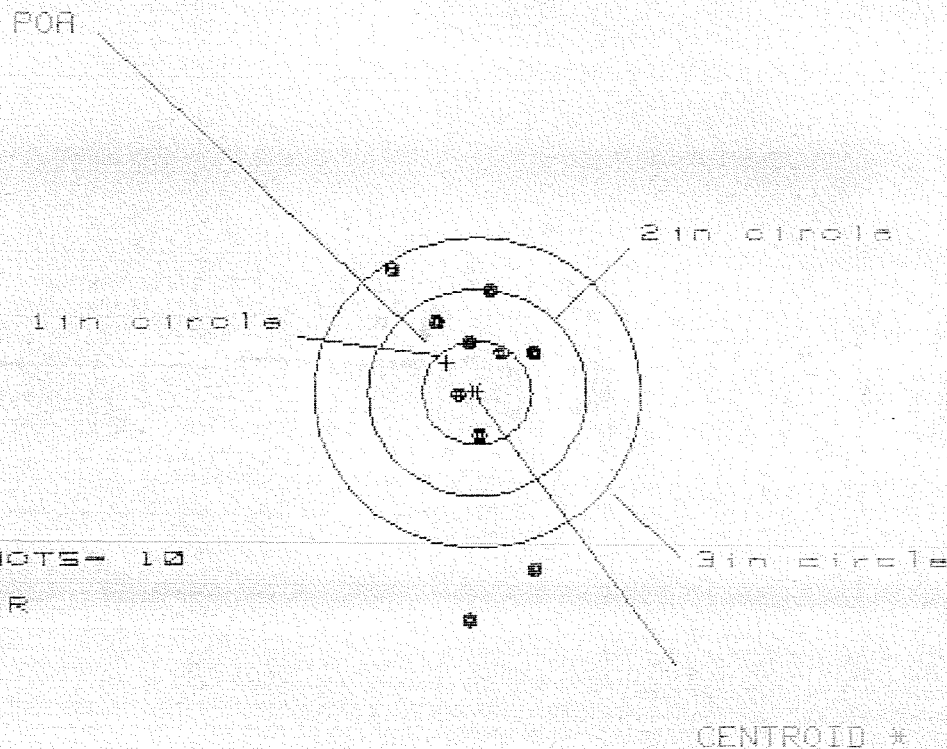
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.983	.875	.912
MINIMUM X	-.893	-.901	-.791
MAXIMUM Y	2.163	.606	.534
MINIMUM Y	-1.074	-.834	-.906
CENTROID X	.284	.292	.182
CENTROID Y	.408	.160	.232
POA TO CENTROID in.	.491	.333	.295
MIN RADIUS	.241	.010	.139
MEAN RADIUS	.838	.647	.590
MAX RADIUS	2.164	1.047	1.057
HORIZONTAL SPREAD	1.776	1.776	1.703
VERTICAL SPREAD	3.237	1.440	1.440
EXTREME SPREAD	3.238	1.967	1.736
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

4 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665690

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.351

VS= 3.428

GS= 3.502

CENTROID *

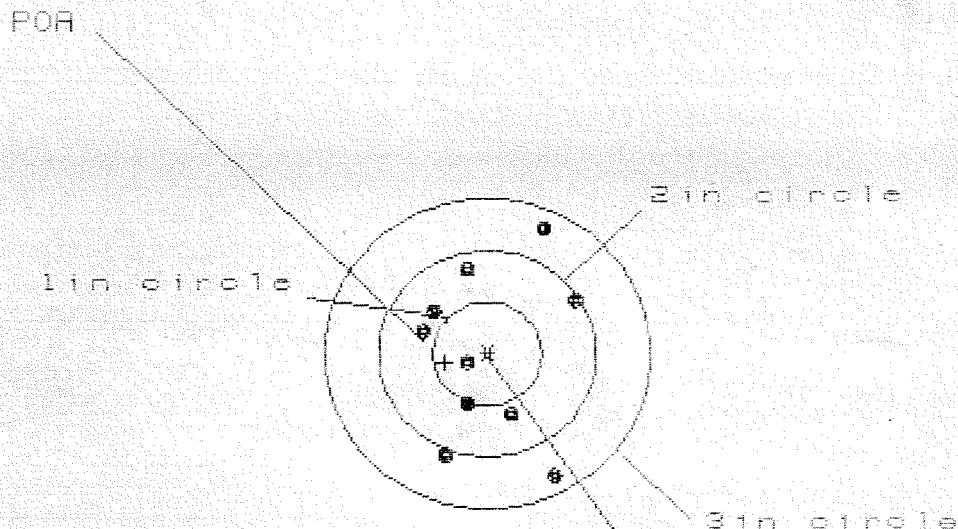
PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.571	.564	.621
MINIMUM X	-1.780	-1.787	-1.716
MAXIMUM Y	1.229	.985	.739
MINIMUM Y	-2.199	-1.968	-1.855
CENTROID X	.275	.282	.211
CENTROID Y	-.289	-.045	.201
POA TO CENTROID in.	.399	.285	.292
MIN RADIUS	.207	.260	.038
MEAN RADIUS	.949	.740	.522
MAX RADIUS	2.200	2.047	1.029
HORIZONTAL SPREAD	1.351	1.351	1.337
VERTICAL SPREAD	3.428	2.953	1.594
EXTREME SPREAD	3.502	3.247	1.764
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

4 Nov 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8665690

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 1.405

VS = 2.387

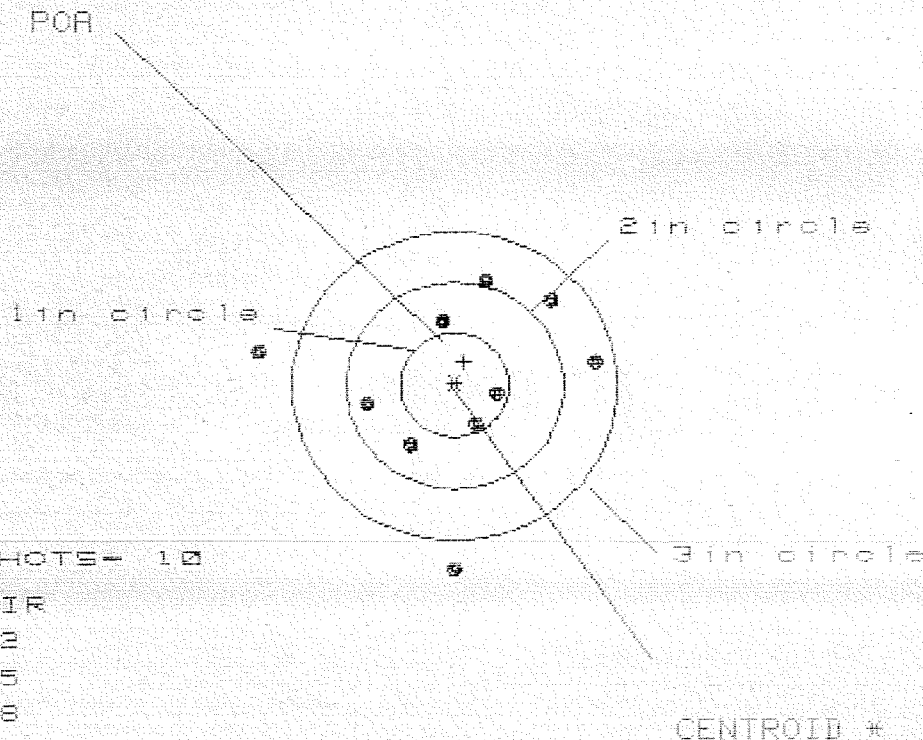
GS = 2.387

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.775	.834	.912
MINIMUM X	-.630	-.571	-.493
MAXIMUM Y	1.236	.906	.779
MINIMUM Y	-1.151	-1.013	-.921
CENTROID X	.389	.330	.252
CENTROID Y	.082	-.056	.071
POA TO CENTROID in.	.397	.334	.262
MIN RADIUS	.167	.147	.035
MEAN RADIUS	.803	.721	.641
MAX RADIUS	1.347	1.188	1.041
HORIZONTAL SPREAD	1.405	1.405	1.405
VERTICAL SPREAD	2.387	1.919	1.700
EXTREME SPREAD	2.387	2.029	1.828
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

4 Nov 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 3.098

VS = 2.886

GS = 3.098

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.306	1.303	1.078
MINIMUM X	-1.792	-1.795	-1.034
MAXIMUM Y	1.066	.863	.874
MINIMUM Y	-1.020	-.813	-.801
CENTROID X	-.090	-.087	.138
CENTROID Y	-.227	-.024	-.035
POA TO CENTROID in.	.244	.090	.142
MIN RADIUS	.383	.465	.306
MEAN RADIUS	1.036	.944	.810
MAX RADIUS	1.821	1.798	1.097
HORIZONTAL SPREAD	3.098	3.098	2.112
VERTICAL SPREAD	2.886	1.676	1.676
EXTREME SPREAD	3.098	3.098	2.155
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	