

BARBER - M24 0103248

FORM

UPC



0 47700 25716 7

C6665843

*INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0103248

MODEL 700 TM M24

ORDER NO.	5716
BARREL LENGTH	
CAPACITY*	

BARBER - M24 0103250

Remington



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

MODEL 700TM M24

SERIAL NO.

C6665843

ORDER NO.

5716

20

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



5716 C6665843

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665843

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KL
600	Proof		9/30/91	KL
607	Check Headspace		9/30/91	KL
610	Dis-assemble Gun		9/30/91	KL
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	LS
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KL
	Apply Coating (Bolt)		11/1/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/91	KL
	C) Inspect Ejector Hole for Chamfer		11/6/91	KL
	D) Oil Firing Pin Ass'y		11/6/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11/7/91	KL

op. #	BARBER - M24 0103252 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-7-91	JH
	G) Safety Off Force	3	3	3			11-7-91	JH
	H) Trigger Pull Test & Retainability						11-7-91	JH
	I) Firing Pin Indent	0205	0215	0215			11-7-91	JH
	J) Assemble Stock						11/11/91	JH
	K) Assemble Swivel Studs						11-21-91	JH
	L) Attach Front and Rear Sight Assemblies						11/11/91	JH
	M) Iron Sight Alignment						11/11/91	JH
	N) Detach Front & Rear Sights & place in numbered container						11/11/91	JH
	O) Attach Scope to Rifle						11/11/91	JH
P) Detach & Attach Scope 20 Times						11/11/91	JH	
640	Gallery Target & Test						11-19-91	DH
	A) Time						11-19-91	DH
	B) Malfunctions						11-19-91	DH
	C) Pierced Primers						11-19-91	DH
	D) Optical Clarity of Scope						11-19-91	DH
645	Inspect for Live Ammo						11-19-91	DH
655	Final Inspection							
	A) Headspace						11-21-91	JH
	B) Trigger Pull	2.59	2.28	2.45	2.43	2.41	11-19-91	DH
	C) Function						11-21-91	JH
660	Pack						12-14-91	NE

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665843DATE 11-7-91TESTER 921

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.46	2.44	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.48	2.56	2.28	
PULL #3	2.47	2.49	2.50	2.45	
PULL #4	2.47	2.56	2.43	2.43	
PULL #5	2.45	2.56	2.55	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.31		
PULL #2	3.47	3.16		
PULL #3	3.53	3.21		
PULL #4	3.20	3.45		
PULL #5	3.28	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.48		4.45
PULL #2	4.51	4.47		4.47
PULL #3	4.46	4.50		4.43
PULL #4	4.44	4.51		4.23
PULL #5	4.44	4.47		4.52
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665843
19 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.428622
1 TO 2	.31383
1 TO 3	.222697
1 TO 4	.535374
1 TO 5	.480677

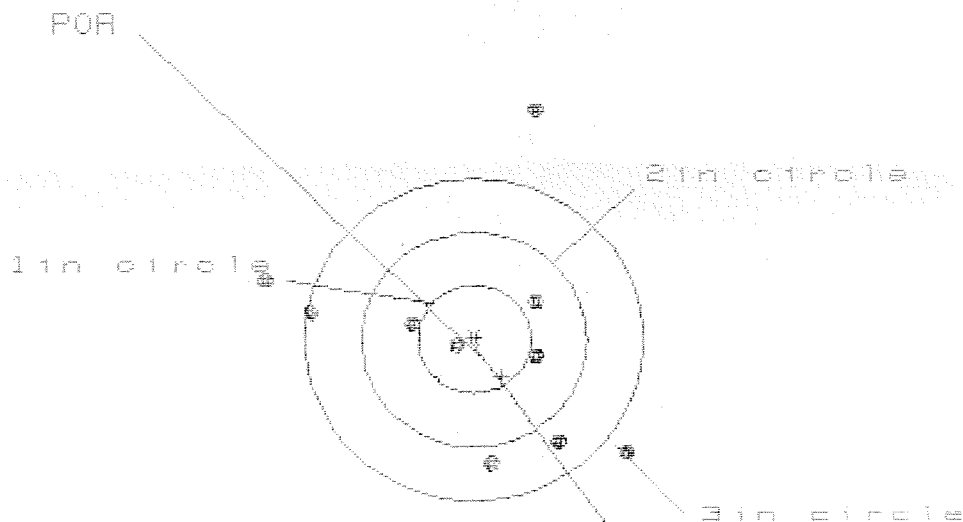
34f (----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2378
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3684
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .247442
THE AMP FOR THIS RIFLE IS: .9584

13 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8565843

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 3.223

VS= 3.361

GS= 3.603

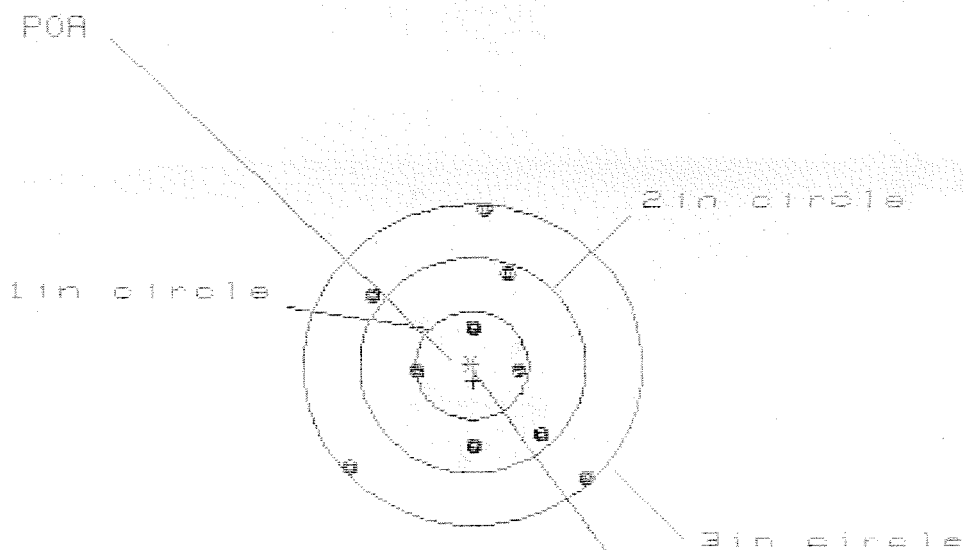
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	1.459	1.238
MINIMUM X	-1.830	-1.764	-1.572
MAXIMUM Y	2.177	.771	.693
MINIMUM Y	-1.184	-.942	-.845
CENTROID X	-.246	-.312	-.091
CENTROID Y	.351	.109	.012
POR TO CENTROID in.	.428	.330	.092
MIN RADIUS	.183	.208	.382
MEAN RADIUS	1.172	1.041	.911
MAX RADIUS	2.257	1.926	1.673
HORIZONTAL SPREAD	3.223	3.223	2.810
VERTICAL SPREAD	3.361	1.713	1.538
EXTREME SPREAD	3.603	3.603	3.103
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665843

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.104

VS= 2.527

GS= 2.691

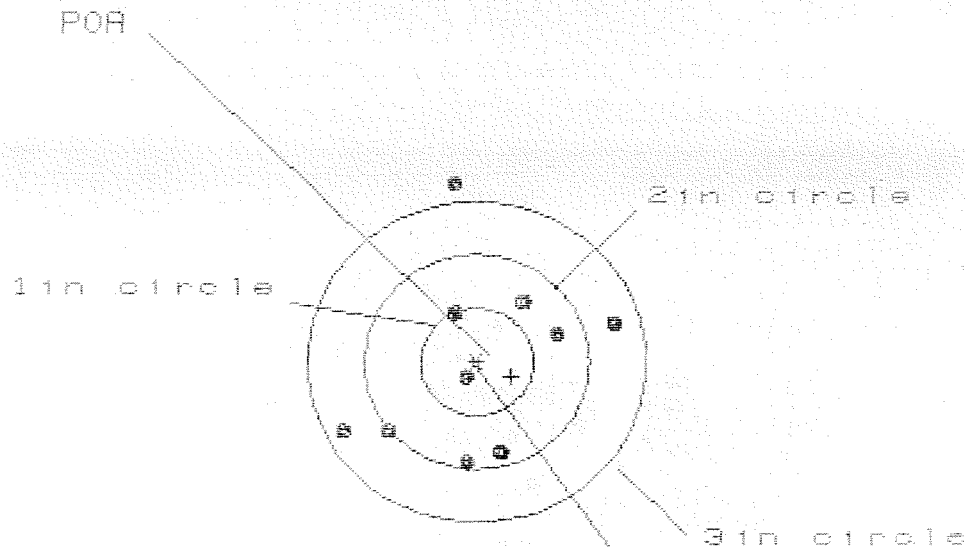
CENTROID *

PATTERN #	2	1	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.025	1.037	.756
MINIMUM X	-1.079	-1.067	-.937
MAXIMUM Y	1.505	1.054	.947
MINIMUM Y	-1.022	-.854	-.849
CENTROID X	-.011	-.023	-.153
CENTROID Y	.143	-.025	.082
POA TO CENTROID in.	.143	.034	.174
MIN RADIUS	.351	.389	.333
MEAN RADIUS	.917	.847	.776
MAX RADIUS	1.509	1.344	1.265
HORIZONTAL SPREAD	2.104	2.104	1.693
VERTICAL SPREAD	2.527	1.908	1.796
EXTREME SPREAD	2.691	2.520	2.248
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685043

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.380

VS= 2.591

GS= 2.592

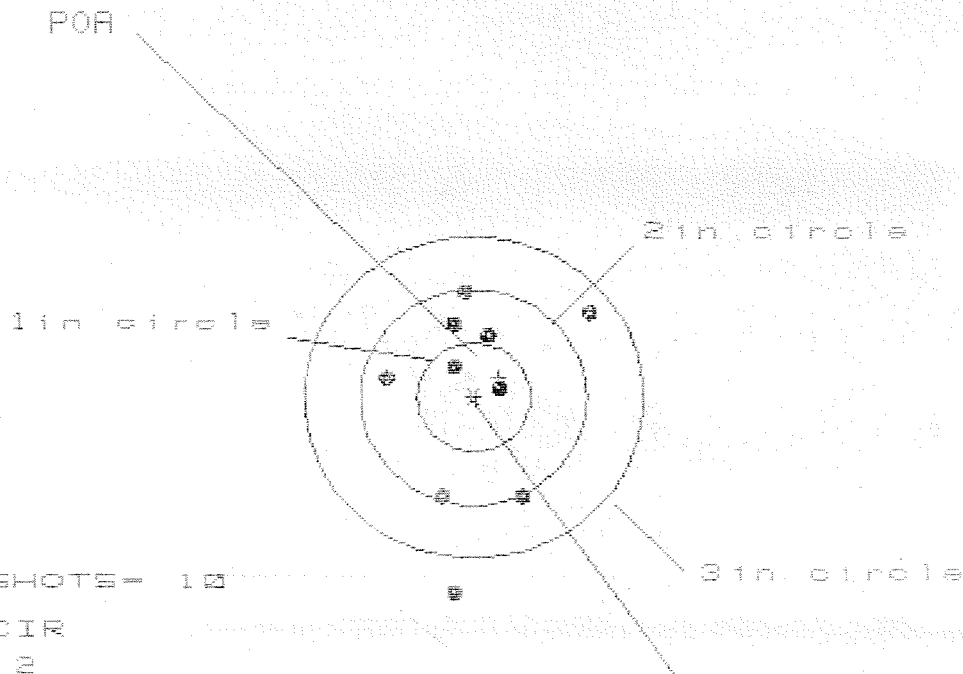
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.172	1.152	.999
MINIMUM X	-1.208	-1.228	-.932
MAXIMUM Y	1.618	.729	.675
MINIMUM Y	-.973	-.793	-.847
CENTROID X	-.311	-.291	-.138
CENTROID Y	.138	-.042	.012
POA TO CENTROID in.	.340	.294	.138
MIN RADIUS	.134	.096	.230
MEAN RADIUS	.903	.810	.747
MAX RADIUS	1.628	1.300	1.108
HORIZONTAL SPREAD	2.380	2.380	1.931
VERTICAL SPREAD	2.591	1.522	1.522
EXTREME SPREAD	2.592	2.567	2.192
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06855043

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.828

VS= 2.726

GS= 2.884

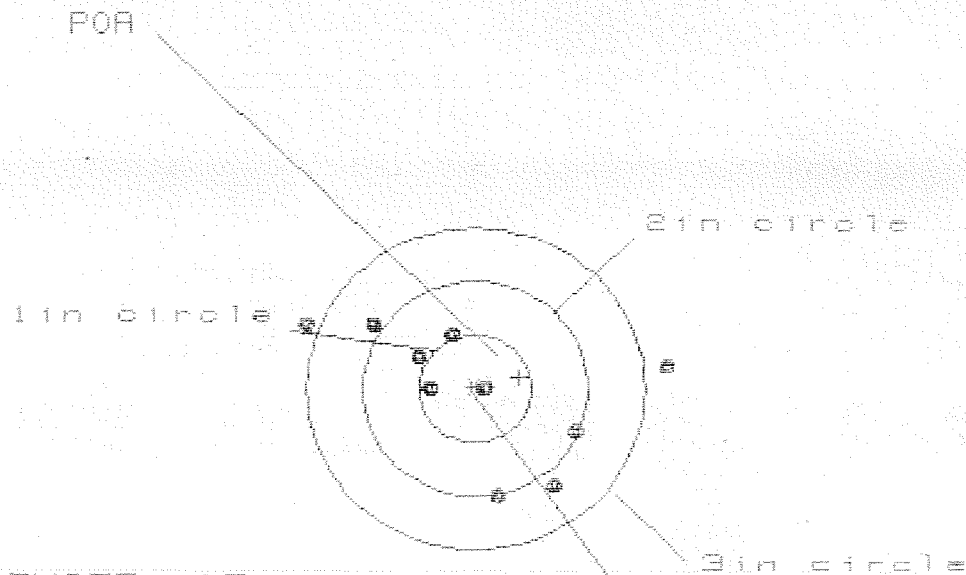
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.037	1.016	.487
MINIMUM X	:	-.791	-.812	-.685
MAXIMUM Y	:	.968	.764	.834
MINIMUM Y	:	-1.766	-1.145	-1.075
CENTROID X	:	-.226	-.205	-.332
CENTROID Y	:	-.184	.012	-.058
POA TO CENTROID in.	:	.291	.205	.337
MIN RADIUS	:	.219	.200	.190
MEAN RADIUS	:	.878	.729	.677
MAX RADIUS	:	1.776	1.200	1.180
HORIZONTAL SPREAD	:	1.828	1.828	1.172
VERTICAL SPREAD	:	2.726	1.909	1.909
EXTREME SPREAD	:	2.884	2.140	1.966
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685843

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 3.188

VS= 1.609

GS= 3.216

CENTROID #

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.684	1.052	.887
MINIMUM X	-1.504	-1.316	-.909
MAXIMUM Y	.654	.673	.750
MINIMUM Y	-.955	-.936	-.859
CENTROID X	-.395	-.583	-.418
CENTROID Y	-.106	-.125	-.202
POA TO CENTROID in.	.409	.596	.464
MIN RADIUS	.111	.257	.141
MEAN RADIUS	.922	.821	.741
MAX RADIUS	1.693	1.454	1.179
HORIZONTAL SPREAD	3.188	2.368	1.796
VERTICAL SPREAD	1.609	1.609	1.609
EXTREME SPREAD	3.216	2.674	2.258
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		