

BARBER - M24 0103260

FORM

UPC



0 47700 25716 7

06665845

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0103260 M2400103299

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

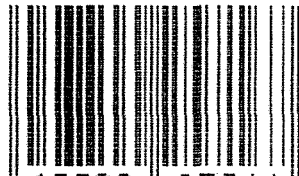
CAPACITY*

 		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6665845
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		ORDER NO. 5716



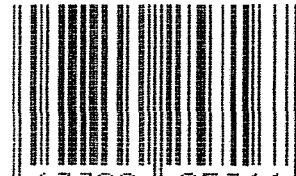
5716 C6665845

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665845

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/25/91	KH
600	Proof		9/25/91	KH
607	Check Headspace		9/25/91	KH
610	Dis-assemble Gun		9/25/91	KH
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
615	Rollmark Caliber		OCT 2 1991	LG
617	Drill and Tap Sight Holes		OCT 2 1991	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10/14/91	DA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/16/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/16/91	KH
	C) Inspect Ejector Hole for Chamfer		10/16/91	KH
	D) Oil Firing Pin Ass'y		10/16/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		10/17/91	JH

op. #	NAME BARBER - M24 0103264	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5 ³ ₄	5 ⁴ ₄			10-17-91	D/H
	G) Safety Off Force	3	3	3			10-17-91	D/H
	H) Trigger Pull Test & Retainability						10-17-91	KL
	I) Firing Pin Indent	.020	.020	.020			10-17-91	D/H
	J) Assemble Stock						10-22-91	KL
	K) Assemble Swivel Studs						10-30-91	AC
	L) Attach Front and Rear Sight Assemblies						10-22-91	KL
	M) Iron Sight Alignment						10-22-91	KL
	N) Detach Front & Rear Sights & place in numbered container						10-22-91	KL
	O) Attach Scope to Rifle						10-22-91	KL
	P) Detach & Attach Scope 20 Times						10-22-91	KL
640	Gallery Target & Test						10-23-91	D/H
	A) Time						10-23-91	D/H
	B) Malfunctions						10-23-91	D/H
	C) Pierced Primers						10-23-91	D/H
	D) Optical Clarity of Scope						10-23-91	D/H
645	Inspect for Live Ammo						10-23-91	D/H
655	Final Inspection							
	A) Headspace						10-20-91	AC
	B) Trigger Pull	266	265	278	277	272	10-24-91	D/H
	C) Function						10-30-91	AC
660	Pack						12-18-91	VF

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665845DATE 10-17-91TESTER JRL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.34	2.37	2.50	2.66	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.23	2.37	2.36	2.65	
PULL #3	2.53	2.56	2.58	2.78	
PULL #4	2.50	2.51	2.55	2.77	
PULL #5	2.39	2.46	2.51	2.72	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.23		
PULL #2	3.23	3.33		
PULL #3	3.24	3.41		
PULL #4	3.28	3.46		
PULL #5	3.26	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.37		4.32
PULL #2	4.40	4.52		4.47
PULL #3	4.18	4.37		4.31
PULL #4	4.34	4.38		4.48
PULL #5	4.46	4.40		4.60
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665845
24 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.37013
1 TO	2	.388973
1 TO	3	.617603
1 TO	4	.636284
1 TO	5	.53424

1.5 ← POA

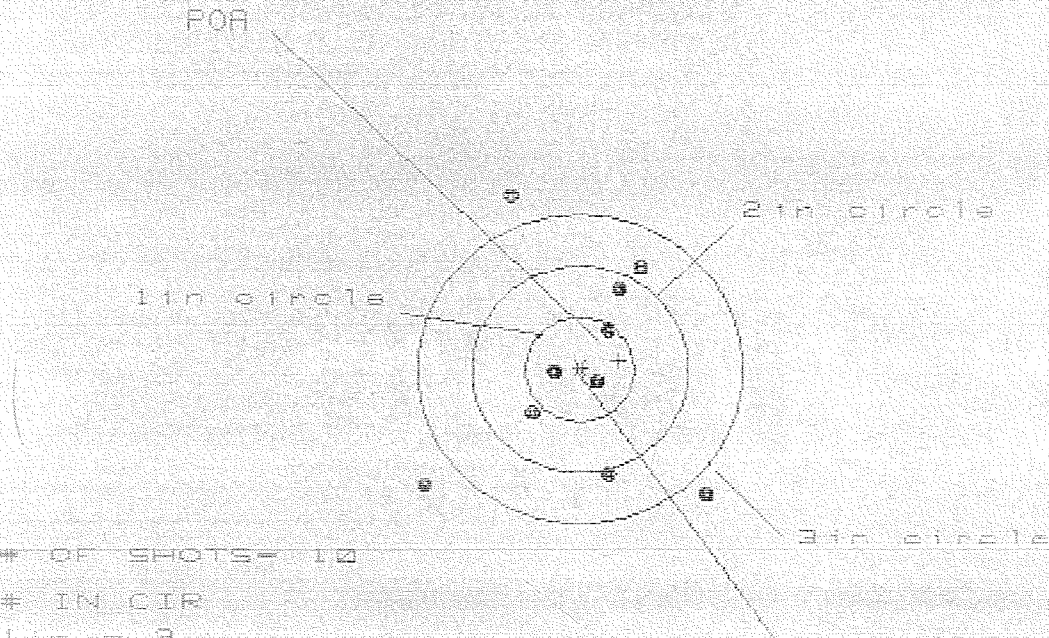
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .069
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1426
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .158416
THE ANR FOR THIS RIFLE IS: .9026

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6005045

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.581

VS= 2.910

GS= 3.455

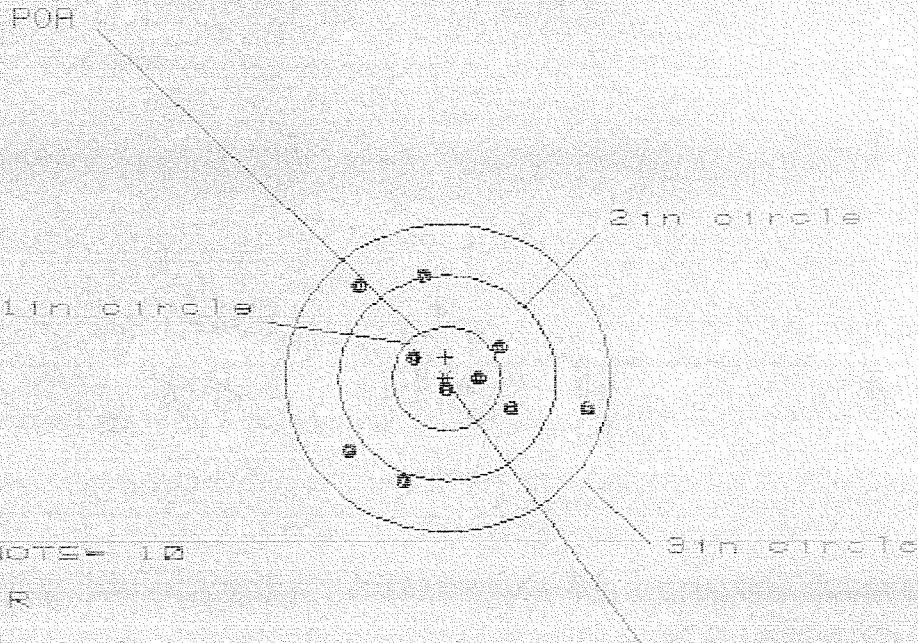
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.176	1.100	.915
MINIMUM X	-1.405	-1.481	-.663
MAXIMUM Y	1.725	1.179	1.059
MINIMUM Y	-1.185	-.993	-1.113
CENTROID X	-.360	-.284	-.099
CENTROID Y	-.086	-.278	-.158
POA TO CENTROID in.	.370	.397	.186
MIN RADIUS	.156	.095	.150
MEAN RADIUS	.972	.877	.763
MAX RADIUS	1.857	1.765	1.441
HORIZONTAL SPREAD	2.581	2.581	1.578
VERTICAL SPREAD	2.910	2.172	2.172
EXTREME SPREAD	3.455	2.911	2.255
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665845

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 2.201

VS= 1.927

GS= 2.350

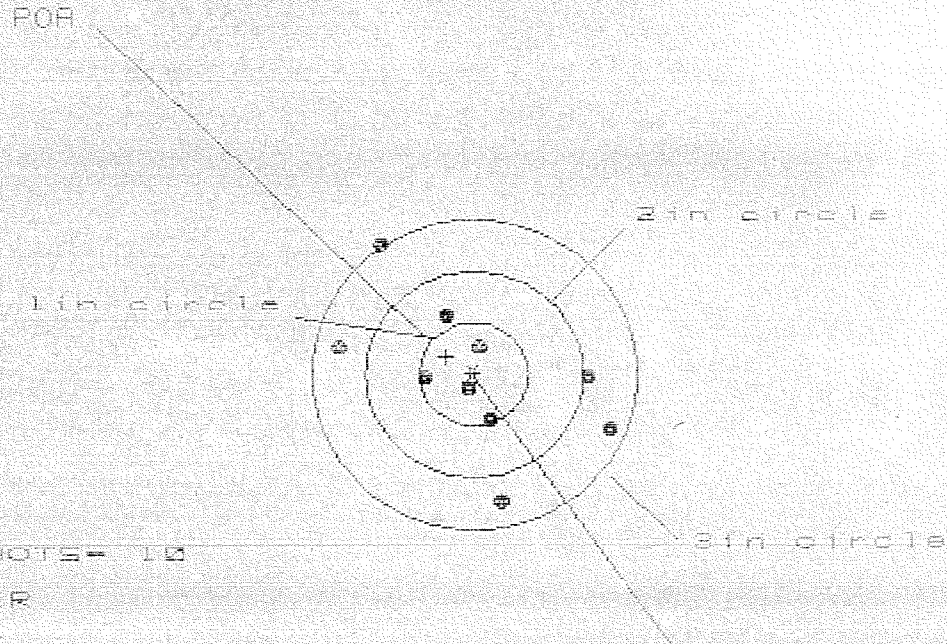
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.282	.778	.699
MINIMUM X	-.919	-.777	-.956
MAXIMUM Y	.971	.942	1.048
MINIMUM Y	-.956	-.985	-.879
CENTROID X	.010	-.132	-.053
CENTROID Y	-.206	-.177	-.263
POA TO CENTROID in.	.206	.221	.288
MIN RADIUS	.122	.198	.067
MEAN RADIUS	.774	.723	.660
MAX RADIUS	1.308	1.081	1.072
HORIZONTAL SPREAD	2.201	1.555	1.555
VERTICAL SPREAD	1.927	1.927	1.927
EXTREME SPREAD	2.350	1.937	1.937
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665045

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 9

HS = 2.484

VS = 2.500

GS = 2.802

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.273	1.177	1.126
MINIMUM X	-1.211	-1.307	-1.159
MAXIMUM Y	1.308	.691	.645
MINIMUM Y	-1.192	-1.046	-1.092
CENTROID X	.252	.348	.201
CENTROID Y	-.169	-.315	-.289
POA TO CENTROID in.	.304	.469	.336
MIN RADIUS	.177	.129	.078
MEAN RADIUS	.841	.754	.673
MAX RADIUS	1.564	1.357	1.203
HORIZONTAL SPREAD	2.484	2.484	2.285
VERTICAL SPREAD	2.500	1.737	1.737
EXTREME SPREAD	2.802	2.590	2.297
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB65845

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.565

VS= 2.707

GS= 2.805

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.682

.895

.952

MINIMUM X

-.883

-.696

-.639

MAXIMUM Y

1.464

1.406

1.094

MINIMUM Y

-1.243

-1.301

-1.125

CENTROID X

.269

.082

.025

CENTROID Y

-.182

-.124

-.300

POA TO CENTROID in.

.325

.149

.301

MIN RADIUS

.316

.456

.584

MEAN RADIUS

1.032

.941

.859

MAX RADIUS

1.760

1.479

1.182

HORIZONTAL SPREAD

2.565

1.591

1.591

VERTICAL SPREAD

2.707

2.707

2.219

EXTREME SPREAD

2.805

2.784

2.241

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

9

24 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665845

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 8

HS= 1.372

VS= 3.019

GS= 3.240

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.514	.554	.456
MINIMUM X	-.858	-.818	-.916
MAXIMUM Y	1.667	1.196	1.050
MINIMUM Y	-1.351	-1.166	-.790
CENTROID X	.174	.134	.232
CENTROID Y	-.070	-.256	-.110
POA TO CENTROID in.	.188	.289	.257
MIN RADIUS	.245	.324	.267
MEAN RADIUS	.894	.801	.696
MAX RADIUS	1.705	1.404	1.096
HORIZONTAL SPREAD	1.372	1.372	1.372
VERTICAL SPREAD	3.019	2.362	1.840
EXTREME SPREAD	3.240	2.550	1.931
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		8	