

BARBER - M24 0103366

FORN

UPC



0 47700 25716 2

06665855

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0103366 M2400103405

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.MODEL 700TM M24

SERIAL NO.

C6665855

ORDER NO.

5716

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

20



5716 C6665855

ORDER 5716

MODEL 700TM M24

UPC

ORDER 5716

MODEL 700TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665855

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/23/91	KL
600	Proof		9/23/91	KL
607	Check Headspace		9/23/91	KL
610	Dis-assemble Gun		9/23/91	KS
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	LB
618	Polish Barrel		OCT 2 1991	WB
620	Apply Coatings (Barrel Action)		10/8/91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/91	KL
	C) Inspect Ejector Hole for Chamfer		10/8/91	KL
	D) Oil Firing Pin Ass'y		10/8/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		10/9/91	DH

op. #	BARBER - M24 0103370 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5			10-9-91	AC
	G) Safety Off Force	4	4	4			10-9-91	AC
	H) Trigger Pull Test & Retainability						10-9-91	DH
	I) Firing Pin Indent	.020	.020	.020			10-9-91	AC
	J) Assemble Stock						10/10/91	RW
	K) Assemble Swivel Studs						10-17-91	AC
	L) Attach Front and Rear Sight Assemblies						10/10/91	RW
	M) Iron Sight Alignment						10/10/91	RW
	N) Detach Front & Rear Sights & place in numbered container						10/10/91	RW
	O) Attach Scope to Rifle						10/10/91	RW
	P) Detach & Attach Scope 20 Times						10/10/91	RW
640	Gallery Target & Test						10-15-91	DH
	A) Time						10-15-91	DH
	B) Malfunctions						10-15-91	DH
	C) Pierced Primers						10-15-91	DH
	D) Optical Clarity of Scope						10-15-91	DH
645	Inspect for Live Ammo						10-15-91	DH
655	Final Inspection							
	A) Headspace						10-17-91	AC
	B) Trigger Pull	2.59	2.71	2.76	2.78	2.74	10-15-91	DH
	C) Function						10-17-91	AC
660	Pack						12-17-91	N

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

SERIAL NO. 66665855DATE 10-9-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.61	2.65	2.63	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54	2.57	2.39	2.71	
PULL #3	2.70	2.68	2.73	2.76	
PULL #4	2.65	2.63	2.43	2.78	
PULL #5	2.65	2.57	2.73	2.74	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.36		
PULL #2	3.36	3.39		
PULL #3	3.36	3.47		
PULL #4	3.45	3.47		
PULL #5	3.33	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.44		4.04
PULL #2	4.41	4.44		4.03
PULL #3	4.35	4.47		4.13
PULL #4	4.59	4.55		4.08
PULL #5	4.00	4.48		4.15
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665855
15 Oct 1991

CENTROIDAL DISTANCES

0 TO	1	.154935
1 TO	2	.0988838
1 TO	3	.212603
1 TO	4	.301869
1 TO	5	.350956

46 (---FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0258
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .075
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0798136

THE AMR FOR THIS RIFLE IS: .8752

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00005055

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

CENTROID *

HS= 2.240

VS= 2.184

GS= 2.870

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.287

1.429

1.166

MINIMUM X

-.953

-.810

-.631

MAXIMUM Y

1.124

1.006

1.017

MINIMUM Y

-1.060

-.623

-.612

CENTROID X

-.154

-.297

-.475

CENTROID Y

.017

.135

.124

POA TO CENTROID in.

.155

.326

.491

MIN RADIUS

.485

.548

.403

MEAN RADIUS

.993

.894

.781

MAX RADIUS

1.667

1.431

1.317

HORIZONTAL SPREAD

2.240

2.239

1.798

VERTICAL SPREAD

2.184

1.629

1.629

EXTREME SPREAD

2.870

2.273

2.179

NUMBER IN ONE INCH CIRCLE =

1

NUMBER IN TWO INCH CIRCLE =

6

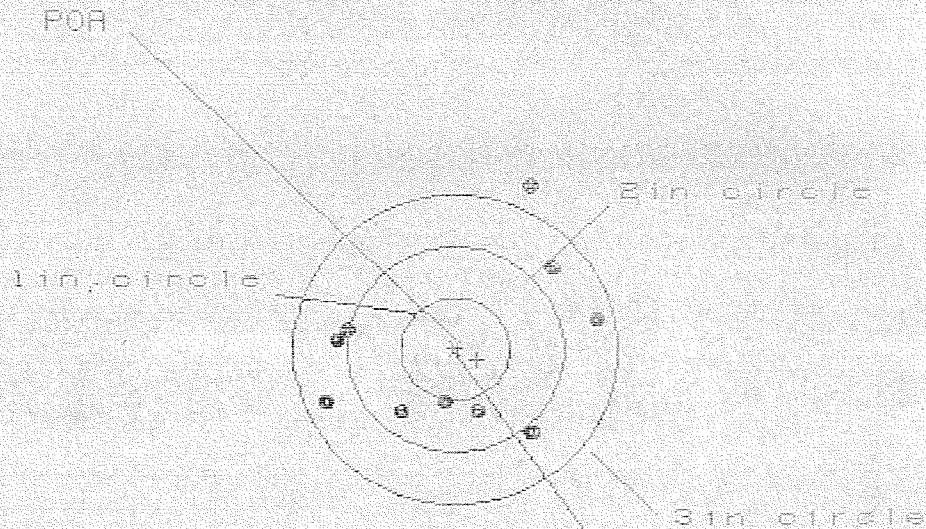
NUMBER IN THREE INCH CIRCLE =

9

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/00005055

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 9

HS= 2.543

VS= 2.421

GS= 2.844

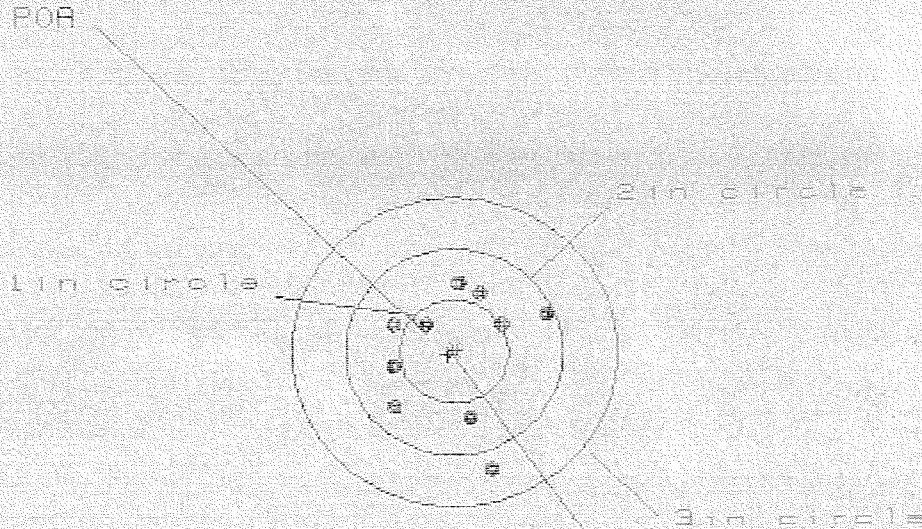
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.331	1.404	1.177
MINIMUM X	-1.212	-1.139	-0.963
MAXIMUM Y	1.633	1.016	1.078
MINIMUM Y	-0.788	-0.607	-0.545
CENTROID X	-0.201	-0.274	-0.450
CENTROID Y	0.104	-0.077	-0.139
POA TO CENTROID in.	0.226	0.285	0.471
MIN RADIUS	0.554	0.368	0.354
MEAN RADIUS	1.078	0.952	0.850
MAX RADIUS	1.762	1.489	1.596
HORIZONTAL SPREAD	2.543	2.543	2.140
VERTICAL SPREAD	2.421	1.623	1.623
EXTREME SPREAD	2.844	2.672	2.525
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		9	

15 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08665855

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 9

3in = 10

HS= 1.421

VS= 1.728

GS= 1.753

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.829
MINIMUM X	-.593
MAXIMUM Y	.636
MINIMUM Y	-1.092
CENTROID X	.058
CENTROID Y	.033
POA TO CENTROID in.	.067
MIN RADIUS	.394
MEAN RADIUS	.679
MAX RADIUS	1.134
HORIZONTAL SPREAD	1.421
VERTICAL SPREAD	1.728
EXTREME SPREAD	1.753
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	9
NUMBER IN THREE INCH CIRCLE =	10

15 Oct 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08685855

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 2.581

VS = 2.379

GS = 2.939

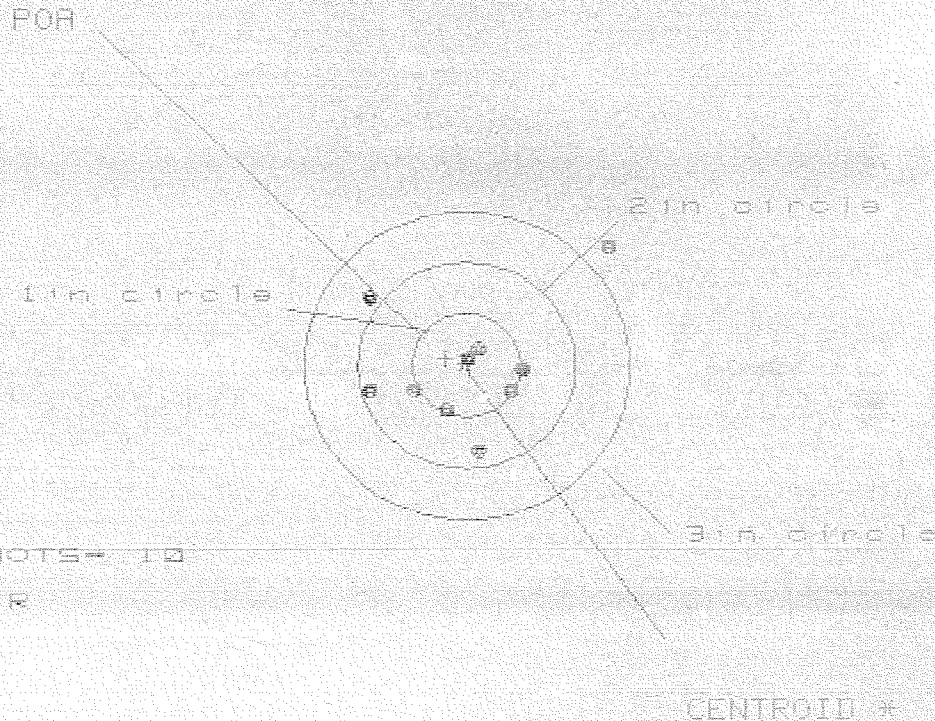
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.391
MINIMUM X	-1.190
MAXIMUM Y	1.601
MINIMUM Y	-1.778
CENTROID X	-0.019
CENTROID Y	.287
POA TO CENTROID in.	.289
MIN RADIUS	.096
MEAN RADIUS	.953
MAX RADIUS	1.754
HORIZONTAL SPREAD	2.581
VERTICAL SPREAD	2.379
EXTREME SPREAD	2.939
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	8

(5 Oct 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/06665835

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 5

2 in = 8

3 in = 9

HS= 2.140

VS= 2.016

GS= 2.571

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.285
MINIMUM X	-.855
MAXIMUM Y	1.166
MINIMUM Y	-.850
CENTROID X	.187
CENTROID Y	-.066
POA TO CENTROID in.	.198
MIN RADIUS	.039
MEAN RADIUS	.673
MAX RADIUS	1.735
HORIZONTAL SPREAD	2.140
VERTICAL SPREAD	2.016
EXTREME SPREAD	2.571
NUMBER IN ONE INCH CIRCLE =	5
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	9