

BARBER - M24 0103425

FORM

UPC



0 47700 25716 7

C6665860

*INCLUDES 1 IN CHAMBER

CAPACITY*

CAPACITY

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0103425 M2400103464

MODEL 700 TM M24

ORDER NO.

5716

BARBER / LENGTH

BARBER - M24 0103427

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665860

ORDER NO.

5716

20

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



5716 C6665860

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 #

C6665860

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		CS
617	Drill and Tap Sight Holes	OCT 4 1991		LB
618	Polish Barrel	OCT 4 1991		WB
620	Apply Coatings (Barrel Action)		10-12-91	PA
	Apply Coating (Bolt)			
625	Final Assembly		11/4/91	KH
	A) Clean inside of Bolt Assembly		11/4/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/91	KH
	C) Inspect Ejector Hole for Chamfer		11/4/91	KH
	D) Oil Firing Pin Ass'y		11/4/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11-5-91	SM

op. #	OP NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-5-91	SL
	G) Safety Off Force	3	3	3			11-5-91	SL
	H) Trigger Pull Test & Retainability						11-5-91	SL
	I) Firing Pin Indent	.023	.023	.023			11-5-91	SL
	J) Assemble Stock						11/5/91	SL
	K) Assemble Swivel Studs						11-15-91	SL
	L) Attach Front and Rear Sight Assemblies						11/5/91	SL
	M) Iron Sight Alignment						11/5/91	SL
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	SL
	O) Attach Scope to Rifle						11/5/91	SL
	P) Detach & Attach Scope 20 Times						11/5/91	SL
640	Gallery Target & Test						11-17-91	SL
	A) Time							SL
	B) Malfunctions							SL
	C) Pierced Primers							SL
	D) Optical Clarity of Scope							SL
645	Inspect for Live Ammo						11-7-91	SL
655	Final Inspection						11-15-91	SL
	A) Headspace							SL
	B) Trigger Pull	2.45	2.55	2.52	2.52	2.52	11-13-91	AC
	C) Function						11-15-91	AC
660	Pack						12-9-91	SL

SWS TRIGGER PULL TESTAVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6665860DATE 11-5-91TESTER JR

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.23	2.25	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.43	2.20	2.55	
PULL #3	2.37	2.36	2.22	2.52	
PULL #4	2.40	2.45	2.43	2.52	
PULL #5	2.24	2.36	2.48	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.51		
PULL #2	3.43	3.28		
PULL #3	3.55	3.41		
PULL #4	3.67	3.55		
PULL #5	3.57	3.52		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.51	4.35		4.44
PULL #2	4.44	4.30		4.41
PULL #3	4.41	4.33		4.45
PULL #4	4.39	4.42		4.38
PULL #5	4.41	4.41		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665860
7 Nov 1991

CENTROIDAL DISTANCES

0 TO 1	.438617
1 TO 2	.827957
1 TO 3	1.22256
1 TO 4	.248204
1 TO 5	.14903

3
2
+
4
5
(----POR

RIFLE IS: -.0532

RIFLE IS: -.0716

THIS RIFLE IS: .0922703

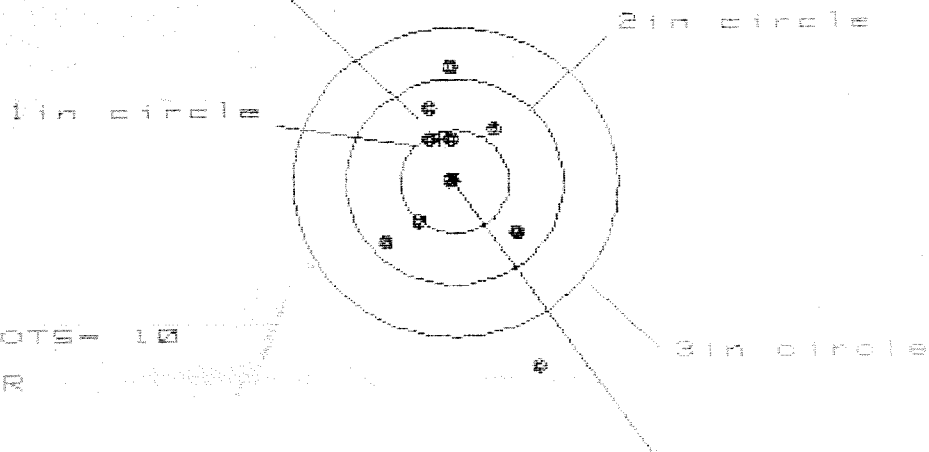
2 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CBB85860

CENTERFIRE PATTERNS

1

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 8

X = 2.421

Y = 5.625

Z = 5.816

CENTROID #

FOR

10

1	.741	.649	.652
2	-.680	-.598	-.595
3	1.057	.874	.661
4	-1.338	-.766	-.657
5	.136	.054	.051
6	-.417	-.224	-.333
7	.243	.230	.337
8	.084	.217	.110
9	.754	.590	.556
10	1.089	.972	.886
11	1.421	1.247	1.247
12	1.805	1.640	1.318
13	2.916	1.755	1.485

1	2	8	9
2	8	8	9
3	8	8	9
4	8	8	9
5	8	8	9
6	8	8	9
7	8	8	9
8	8	8	9
9	8	8	9
10	8	8	9

7 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06565860

CENTERFIRE PATTERNS # 2

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

CENTROID #

HS= 3.708

VS= 3.275

GS= 3.759

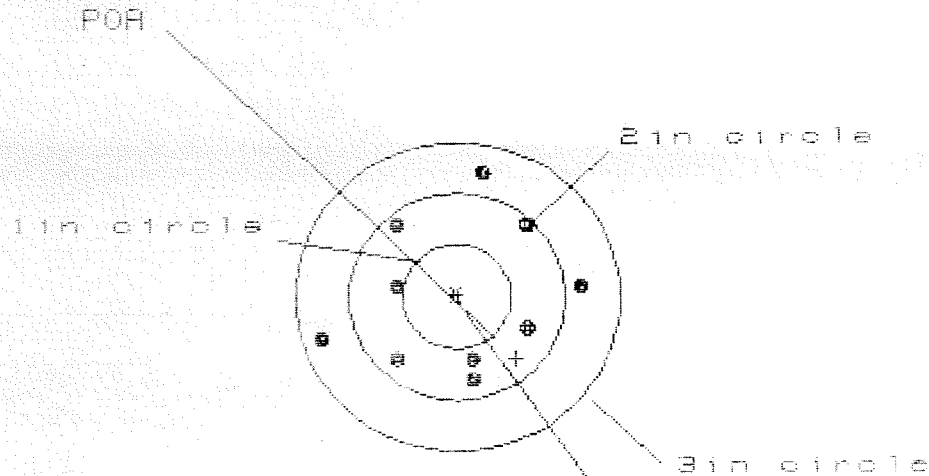
PATTERN #

	10	9	8
SHOTS BEST OF	10	9	8
MAXIMUM X	1.537	1.612	1.350
MINIMUM X	-2.168	-2.093	-1.092
MAXIMUM Y	2.098	.891	.937
MINIMUM Y	-1.177	-.944	-.898
CENTROID X	-.332	-.407	-.145
CENTROID Y	.266	.033	-.013
POA TO CENTROID	.426	.408	.145
MIN RANGE	.230	.472	.484
MEAN RANGE	1.180	1.077	.921
MAX RANGE	2.202	2.125	1.414
HORIZONTAL SPREAD	3.705	3.705	2.442
VERTICAL SPREAD	3.275	1.835	1.835
EXTREMUM SPREAD	3.759	3.759	2.534
NUMBER OF 1IN CIRCLES	= 2		
NUMBER OF 2IN CIRCLES	= 5		
NUMBER OF 3IN CIRCLES	= 7		

7 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66656880

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in - 0

2in - 7

3in - 10

HS = 2.421

VS = 2.047

GS = 2.472

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.128	.984	1.002
MINIMUM X	-1.293	-.727	-.709
MAXIMUM Y	1.220	1.177	.775
MINIMUM Y	-.827	-.870	-.723
CENTROID X	-.544	-.400	-.418
CENTROID Y	.599	.642	.495
POA TO CENTROID in.	.809	.757	.648
MIN RADIUS	.530	.613	.506
MEAN RADIUS	.901	.848	.781
MAX RADIUS	1.350	1.186	1.050
HORIZONTAL SPREAD	2.421	1.711	1.711
VERTICAL SPREAD	2.047	2.047	1.498
EXTREME SPREAD	2.472	2.054	1.800
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

7 Nov 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6665860

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.793

VS= 1.991

GS= 2.193

PATTERN #

4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.979	1.056	1.084
MINIMUM X	-.814	-.737	-.709
MAXIMUM Y	1.081	.980	.918
MINIMUM Y	-.910	-.838	-.716
CENTROID X	.310	.233	.205
CENTROID Y	-.240	-.139	-.261
POA TO CENTROID in.	.392	.271	.332
MIN RADIUS	.459	.394	.355
MEAN RADIUS	.858	.811	.778
MAX RADIUS	1.143	1.127	1.118
HORIZONTAL SPREAD	1.793	1.793	1.793
VERTICAL SPREAD	1.991	1.818	1.834
EXTREME SPREAD	2.193	1.968	1.968
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	10	

2 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/066650660

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS = 2.298

VS = 2.451

GS = 2.568

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.810	.645	.612
MINIMUM X	-1.488	-1.181	-1.214
MAXIMUM Y	.989	.942	.754
MINIMUM Y	-1.462	-1.509	-1.355
CENTROID X	.139	.304	.337
CENTROID Y	-.566	-.519	-.331
POR TO CENTROID (in)	.582	.602	.472
MIN RADIUS	.426	.256	.190
MEAN RADIUS	.989	.873	.736
MAX RADIUS	1.545	1.532	1.486
HORIZONTAL SPREAD	2.298	1.826	1.826
VERTICAL SPREAD	2.451	2.451	2.108
EXTREME SPREAD	2.568	2.568	2.568
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 9		