

BARBER - M24 0104051

FORM

UPC



0 47700 25716 7

6665923

*INCLUDES 1 IN CHAMBER

CAPACITY*

BARREL LENGTH

U.S.U

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104090

5715

ORDER NO

MODEL TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6665923

ORDER NO.

5716

20

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



5716 C6665923

ORDER 5716

MODEL 700 TM M24

UPC

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665923

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/27/91	KJ
600	Proof		9/27/91	KJ
607	Check Headspace		9/27/91	KJ
610	Dis-assemble Gun		9/27/91	KJ
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	KB
618	Polish Barrel	OCT	4 1991	WB
620	Apply Coatings (Barrel Action)		10-12-91	JH
	Apply Coating (Bolt)		10-12-91	JH
625	Final Assembly A) Clean inside of Bolt Assembly		11/4/91	KJ
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/4/91	KJ
	C) Inspect Ejector Hole for Chamfer		11/4/91	KJ
	D) Oil Firing Pin Ass'y		11/4/91	KJ
	E) Adjust Trigger Pull to Min Setting and Stake		11/5/91	JH

op. #	BARBER M24 0104055	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			11-5-91	JK
	G) Safety Off Force	3	3	3			11-5-91	JK
	H) Trigger Pull Test & Retainability						11-13-91	JK
	I) Firing Pin Indent	.021	.021	.021			11/5/91	JK
	J) Assemble Stock						11/5/91	JK
	K) Assemble Swivel Studs						11-13-91	K
	L) Attach Front and Rear Sight Assemblies						11/5/91	JK
	M) Iron Sight Alignment						11/5/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/5/91	JK
	O) Attach Scope to Rifle						11/5/91	JK
	P) Detach & Attach Scope 20 Times						11/5/91	JK
640	Gallery Target & Test						11/6/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/12/91	KT
655	Final Inspection							
	A) Headspace						11-13-91	AC
	B) Trigger Pull	2.46	2.38	2.48	2.52	2.52	11-12-91	AC
	C) Function						11-13-91	AC
660	Pack						12-18-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO C6665923

DATE 11-5-91

TESTER *XL*

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.40	2.45	2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.30	2.48	2.38	
PULL #3	2.37	2.47	2.43	2.48	
PULL #4	2.49	2.40	2.48	2.52	
PULL #5	2.48	2.41	2.40	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.36		
PULL #2	3.39	3.36		
PULL #3	3.36	3.21		
PULL #4	3.26	3.33		
PULL #5	3.38	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.32		4.30
PULL #2	4.33	4.31		4.30
PULL #3	4.28	4.33		4.30
PULL #4	4.25	4.28		4.32
PULL #5	4.28	4.33		4.32
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06665923

6 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.608317
1 TO	2	1.07246
1 TO	3	1.23678
1 TO	4	.507765
1 TO	5	.761202

1
 0.1 <----POA
 0.2

0. THIS RIFLE IS: .0646

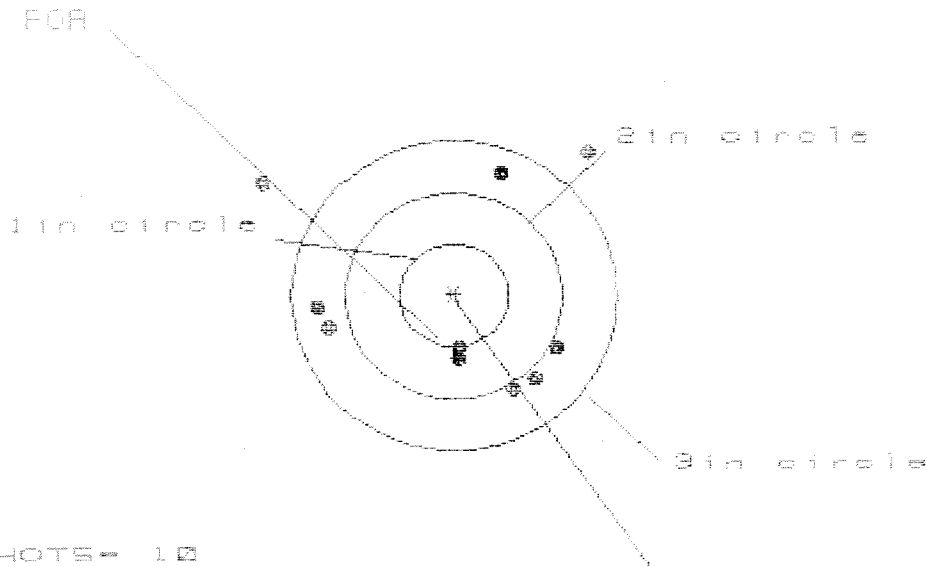
0. THIS RIFLE IS: -.0708

0. FOR THIS RIFLE IS: .095693

5 MAY 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865323

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 8

MEAN = 2.888

SE = 3.041

CE = 3.108

CENTROID #

PATTERNING

P

SHOT	OF	10	9	8
MR. 1	1	1.192	.999	.919
MR. 2	1	-1.736	-1.442	-1.317
MR. 3	1	1.442	1.562	1.520
MR. 4	1	-.899	-.779	-.583
MR. 5	1	-.848	.153	.028
MR. 6	1	.607	.487	.291
MR. 7	1	.609	.510	.293
MR. 8	1	.511	.412	.193
MR. 9	1	1.209	1.066	.900
MR. 10	1	2.047	1.855	1.575
MR. 11	1	2.915	2.441	2.236
MR. 12	1	2.341	2.341	2.103
MR. 13	1	3.168	2.889	2.281
MR. 14	1			
MR. 15	1			
MR. 16	1			
MR. 17	1			
MR. 18	1			
MR. 19	1			
MR. 20	1			

6 May 1991

FILE: PATTERNING/CENTERFIRE_PATT/C8865923

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in - 2

2in - 5

3in - 10

HS = 1.562

VS = 2.731

GS = 2.764

CENTROID #

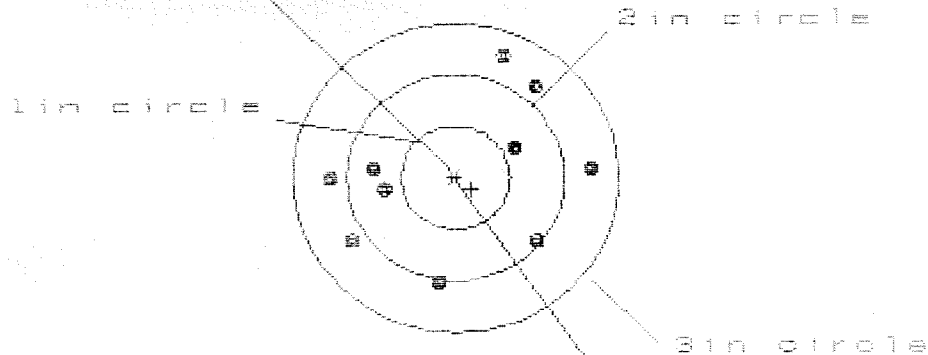
PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM	.620	.599	.625
MINIMUM	-.942	-.963	-.937
MAXIMUM	1.266	1.103	.673
MINIMUM	-1.465	-1.171	-1.033
CENTROID	-.238	-.217	-.243
CENTROID	-.128	.035	-.103
POB TO CENTROID	.270	.219	.264
MIN RAD	.436	.375	.420
MEAN RAD	.918	.831	.800
MAX RAD	1.477	1.350	1.236
HORIZONTAL SPREAD	1.562	1.562	1.562
VERTICAL SPREAD	2.731	2.274	1.706
EXTREME SPREAD	2.764	2.363	2.147
NUMBER IN 1 INCH CIRCLE	= 2		
NUMBER IN 2 INCH CIRCLE	= 5		
NUMBER IN 3 INCH CIRCLE	= 10		

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8605923

CENTERFIRE PATTERNS # 4

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.345

VS= 2.222

GS= 2.349

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.224	1.274	.924
MINIMUM X	-1.121	-1.071	-.911
MAXIMUM Y	1.168	.979	1.007
MINIMUM Y	-1.054	-.924	-.896
CENTROID X	-.144	-.193	-.353
CENTROID Y	.110	-.020	-.048
POA TO CENTROID in.	.181	.194	.356
MIN RADIUS	.641	.592	.434
MEAN RADIUS	.991	.949	.875
MAX RADIUS	1.251	1.294	1.358
HORIZONTAL SPREAD	2.345	2.345	1.835
VERTICAL SPREAD	2.222	1.903	1.903
EXTREME SPREAD	2.349	2.349	2.194
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	10	

6 Nov 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6585923

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 10

HS = 2.315

VS = 1.991

GS = 2.599

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	1.361	1.496
MINIMUM X	-1.081	-.954	-.783
MAXIMUM Y	.876	.938	.891
MINIMUM Y	-1.115	-1.018	-1.065
CENTROID X	.430	.304	.133
CENTROID Y	-.537	-.634	-.587
POA TO CENTROID in.	.688	.703	.601
MIN RADIUS	.232	.084	.099
MEAN RADIUS	1.009	.930	.832
MAX RADIUS	1.440	1.414	1.538
HORIZONTAL SPREAD	2.315	2.315	2.279
VERTICAL SPREAD	1.991	1.956	1.956
EXTREME SPREAD	2.599	2.334	2.331
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

6 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665923

CENTERFIRE PATTERNS # 2

POA

1 in circle

3 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 7

3 in - 9

HS= 2.461

VS= 1.601

GS= 2.487

CENTROID #

PATTERN #

2

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.460	1.327	.904
MINIMUM X	-1.001	-.839	-.673
MAXIMUM Y	.876	.818	.821
MINIMUM Y	-.725	-.783	-.780
CENTROID X	.315	.153	-.013
CENTROID Y	-.405	-.347	-.350
POA TO CENTROID in.	.513	.379	.350
MIN RADIUS	.380	.254	.198
MEAN RADIUS	.838	.713	.601
MAX RADIUS	1.549	1.327	1.195
HORIZONTAL SPREAD	2.461	2.166	1.577
VERTICAL SPREAD	1.601	1.601	1.601
EXTREME SPREAD	2.467	2.206	1.833
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	