

BARBER - M24 0104599

OPEN

UPC



0 47700 25716 7

06665970

*INCLUDES 1 IN CHAMBER

CAPACITY*

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104599 M2400104638

MODEL 700 TM M24

ORDER NO. 5716

BARBER JENOTU

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6665970

20

ORDER NO.
5716

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



5716 C6665970

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 # C6665970

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action	OCT	4 1991	KR
	Magnaflux Bolt	OCT	4 1991	KR
615	Rollmark Caliber	OCT	4 1991	g2
617	Drill and Tap Sight Holes	OCT	4 1991	LB
618	Polish Barrel		10/8/91	WB
620	Apply Coatings (Barrel Action)		10-22-91	JA
	Apply Coating (Bolt)		10-22-91	JA
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/91	RW
	C) Inspect Ejector Hole for Chamfer		10/22/91	RW
	D) Oil Firing Pin Ass'y		10/22/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/31/91	JA

op. #	BARBER - M24 0104603	READINGS					DATE	INIT
	OP. NAME							
625 cont.	F) Safety On Force	4	4	4			11-4-91	RY
	G) Safety Off Force	3	3	3			11-4-91	RY
	H) Trigger Pull Test & Retainability						10/31/91	RY
	I) Firing Pin Indent	.020	.020	.020			11-4-91	RY
	J) Assemble Stock						11/18/91	RW
	K) Assemble Swivel Studs						11-27-91	A
	L) Attach Front and Rear Sight Assemblies						11/18/91	RW
	M) Iron Sight Alignment						11/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						11/18/91	RW
	O) Attach Scope to Rifle						11/18/91	RW
	P) Detach & Attach Scope 20 Times						11/18/91	RW
640	Gallery Target & Test						11-19-91	N
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						11-19-91	AF
655	Final Inspection							
	A) Headspace						11-27-91	A
	B) Trigger Pull	252	257	251	250	252	11-20-91	D/H
	C) Function						11-27-91	A
660	Pack						12-19-91	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6665970DATE 10/31/91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.43	2.50	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.44	2.55	2.57	
PULL #3	2.34	2.48	2.49	2.51	
PULL #4	2.40	2.41	2.44	2.50	
PULL #5	2.44	2.48	2.41	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.45		
PULL #2	3.51	3.47		
PULL #3	3.47	3.48		
PULL #4	3.47	3.35		
PULL #5	3.49	3.49		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.53		4.47
PULL #2	4.39	4.51		4.51
PULL #3	4.51	4.48		4.39
PULL #4	4.49	4.43		4.49
PULL #5	4.53	4.52		4.48
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6665970
 20 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.293789
1 TO	2	.216009
1 TO	3	.17102
1 TO	4	.492546
1 TO	5	.345686

42.1 28 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0856
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1264
 THE RESULTING AVERAGE PC1 RADIUS FOR THIS RIFLE IS: .152658

THE AMP FOR THIS RIFLE IS: 1.093

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8685970

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID X

OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 1.823

VS = 3.023

GS = 3.530

PATTERN #

1

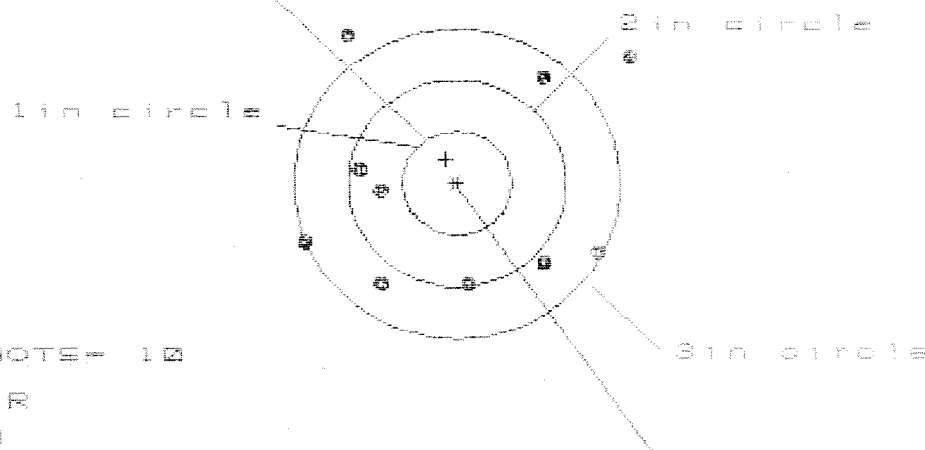
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.041	.546	.463
MINIMUM X	-.782	-.666	-.593
MAXIMUM Y	1.247	1.050	1.115
MINIMUM Y	-1.776	-1.343	-1.212
CENTROID X	.274	.158	.241
CENTROID Y	-.106	.091	-.040
POA TO CENTROID in.	.293	.182	.244
MIN RADIUS	.471	.562	.533
MEAN RADIUS	1.044	.923	.865
MAX RADIUS	2.059	1.437	1.349
HORIZONTAL SPREAD	1.823	1.212	1.056
VERTICAL SPREAD	3.023	2.393	2.327
EXTREME SPREAD	2.530	2.410	2.410
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665970

CENTERFIRE PATTERNS # 2

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 7

HS= 3.049

VS= 2.391

GS= 3.505

CENTROID *

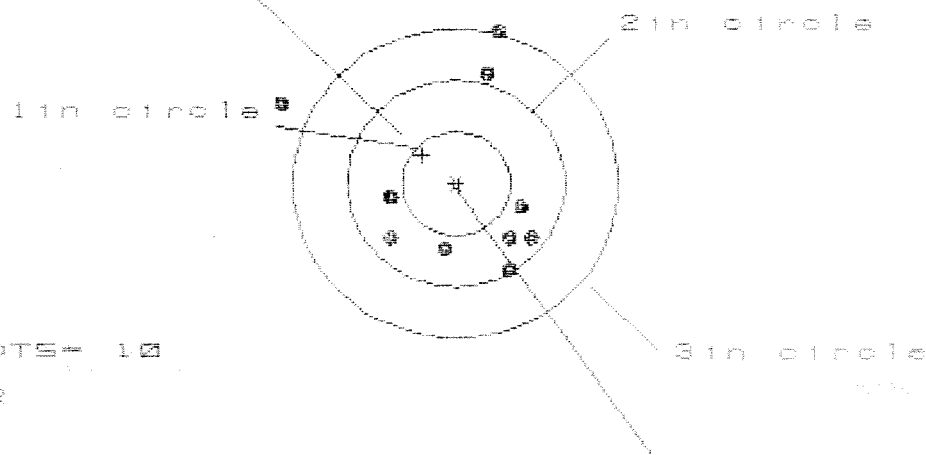
PATTERN #	2	10	9	8
SHOTS (BEST OF)	10	9	8	
MAXIMUM X	1.617	1.496	1.399	
MINIMUM X	-1.432	-1.252	-1.349	
MAXIMUM Y	1.450	1.583	1.396	
MINIMUM Y	-.941	-.808	-.611	
CENTROID X	.100	-.088	.017	
CENTROID Y	-.234	-.367	-.564	
POA TO CENTROID in.	.254	.375	.565	
MIN RADIUS	.697	.517	.636	
MEAN RADIUS	1.285	1.158	1.061	
MAX RADIUS	2.011	1.760	1.666	
HORIZONTAL SPREAD	3.049	2.748	2.748	
VERTICAL SPREAD	2.391	2.391	2.007	
EXTREME SPREAD	3.505	3.075	2.765	
NUMBER IN ONE INCH CIRCLE =		0		
NUMBER IN TWO INCH CIRCLE =		3		
NUMBER IN THREE INCH CIRCLE =		7		

19 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685970

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 0

2in = 7

3in = 8

HS= 2.325

VS= 2.321

QS= 2.691

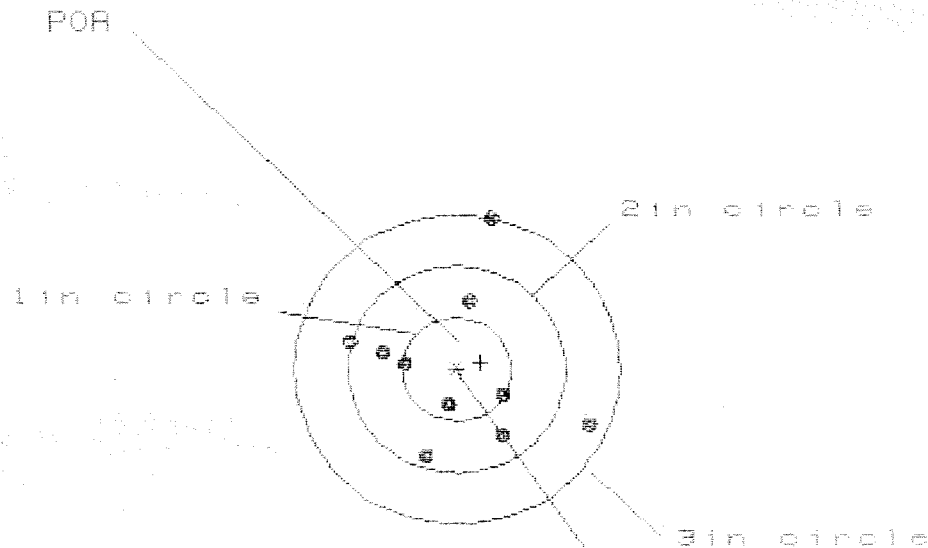
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.723	.545	.566
MINIMUM X	-1.602	-.828	-.807
MAXIMUM Y	1.522	1.609	1.376
MINIMUM Y	-.800	-.712	-.511
CENTROID X	.306	.484	.463
CENTROID Y	-.274	-.362	-.564
POA TO CENTROID in.	.411	.605	.729
MIN RADIUS	.624	.425	.410
MEAN RADIUS	.979	.845	.690
MAX RADIUS	1.787	1.618	1.380
HORIZONTAL SPREAD	2.325	1.373	1.373
VERTICAL SPREAD	2.321	2.321	1.806
EXTREME SPREAD	2.691	2.327	1.903
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6685970

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.230

VS= 2.253

GS= 2.388

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.262	1.299	.636
MINIMUM X	-.968	-.931	-.768
MAXIMUM Y	1.419	.839	.788
MINIMUM Y	-.834	-.676	-.727
CENTROID X	-.217	-.254	-.417
CENTROID Y	-.067	-.225	-.174
POA TO CENTROID in.	.227	.339	.452
MIN RADIUS	.384	.222	.306
MEAN RADIUS	.832	.735	.645
MAX RADIUS	1.459	1.361	.865
HORIZONTAL SPREAD	2.230	2.230	1.404
VERTICAL SPREAD	2.253	1.515	1.515
EXTREME SPREAD	2.388	2.388	1.656
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

19 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08885970

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 2

3in = 6

HS= 3.177

VS= 2.157

GS= 3.388

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.520	1.336	1.154
MINIMUM X	-1.657	-1.733	-1.915
MAXIMUM Y	1.010	1.064	.927
MINIMUM Y	-1.147	-1.093	-.769
CENTROID X	-.035	.149	.331
CENTROID Y	.049	-.005	.131
POA TO CENTROID in.	.060	.150	.358
MIN RADIUS	.655	.620	.698
MEAN RADIUS	1.324	1.254	1.155
MAX RADIUS	1.728	1.847	1.979
HORIZONTAL SPREAD	3.177	3.069	3.069
VERTICAL SPREAD	2.157	2.157	1.697
EXTREME SPREAD	3.388	3.321	3.321
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		