

BARBER - M24 0104835

FORM

UPC



0 47700 25716 7

C6665990

*INCLUDES 1 IN CHAMBER

CAPACITY*

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104835 M2400104874

BARBER - M24 0104836

ORDER NO. 57

BARREL LENGTH

MODEL 700 TM M24

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6665990

20

ORDER NO.
5716

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



5716 C6665990

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 #

C6665990

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KL
600	Proof		9/30/91	KL
607	Check Headspace		9/30/91	KL
610	Dis-assemble Gun		9/30/91	KL
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	KL
	Apply Coating (Bolt)		11/1/91	KL
625	Final Assembly A) Clean inside of Bolt Assembly		11/21/91	KL
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/21/91	KL
	C) Inspect Ejector Hole for Chamfer		11/21/91	KL
	D) Oil Firing Pin Ass'y		11/21/91	KL
	E) Adjust Trigger Pull to Min Setting and Stake		11-22-91	KL

op. #	BARBER M24 0104839	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	6	6			11/25/91	JK
	G) Safety Off Force	4	4	4			11/25/91	JK
	H) Trigger Pull Test & Retainability						11-22-91	JK
	I) Firing Pin Indent	.0205	.0205	.0205			11-25-91	JK
	J) Assemble Stock						11/25/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/25/91	JK
	M) Iron Sight Alignment						11/25/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/25/91	JK
	O) Attach Scope to Rifle						11/25/91	JK
	P) Detach & Attach Scope 20 Times						11/25/91	JK
640	Gallery Target & Test						11-26-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						11-26-91	NF
655	Final Inspection						11-27-91	D/H
	A) Headspace						11-27-91	D/H
	B) Trigger Pull	237	237	229	238	239	11-27-91	D/H
	C) Function						11-27-91	D/H
660	Pack						12-19-91	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6665990DATE 11-22-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.54	2.55	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.53	2.68	2.25	2.37	
PULL #3	2.51	2.69	2.48	2.29	
PULL #4	2.54	2.68	2.60	2.38	
PULL #5	2.59	2.68	2.61	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.42		
PULL #2	3.19	3.46		
PULL #3	3.45	3.46		
PULL #4	3.34	3.34		
PULL #5	3.35	3.53		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.47	4.48		4.36
PULL #2	4.53	4.39		4.42
PULL #3	4.25	4.36		4.41
PULL #4	4.31	4.19		4.37
PULL #5	4.27	4.22		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06668990
28 Nov 1991

CENTROIDAL DISTANCES

0 TO	1	.21285
1 TO	2	.288196
1 TO	3	.195243
1 TO	4	.180942
1 TO	5	.332862

32 <----FOR

COORDINATE FOR THIS RIFLE IS: .0656
COORDINATE FOR THIS RIFLE IS: -.0146
LARGE POI RADIUS FOR THIS RIFLE IS: .0572051
LARGE IS: .0656

FILE: PATTERNING/CENTERFIRE_PATT/06685990

CENTERFIRE PATTERNS

1

FOR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIRCLE

1in = 3

2in = 6

3in = 9

HS= 3.028

VS= 2.365

GS= 3.108

CENTROID *

PATTERN #

:

1

SHOTS BEST OF

:

10

9

8

MAXIMUM X

:

1.352

1.166

.673

MINIMUM X

:

-1.676

-1.040

-.894

MAXIMUM Y

:

1.282

1.227

1.246

MINIMUM Y

:

-1.083

-1.138

-1.119

CENTROID X

:

.149

.335

.189

CENTROID Y

:

.152

.207

.188

FOR THE CENTROID (in.)

:

.212

.394

.267

1st RADIUS

:

.024

.210

.077

2nd RADIUS

:

.890

.794

.720

3rd RADIUS

:

1.748

1.261

1.254

HORIZONTAL SPREAD

:

3.028

2.206

1.567

VERTICAL SPREAD

:

2.365

2.365

2.365

3.108 SPREAD

:

3.108

2.365

2.365

NUMBER OF ONE INCH CIRCLE =

:

3

NUMBER OF TWO INCH CIRCLE =

:

6

NUMBER OF THREE INCH CIRCLE =

:

9

26 Nov 1981

FILE:/PATTERNING/CENTERFIRE PAIT/C8665399

CENTERFIRE PATTERNS # 2

POR

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.251

VS= 1.936

GS= 2.469

CENTROID #

PATTERN #

2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.105	.978	.585
MINIMUM X	-1.145	-.899	-.777
MAXIMUM Y	.832	.755	.785
MINIMUM Y	-1.104	-1.181	-1.151
CENTROID X	.100	.228	.105
CENTROID Y	-.132	-.055	-.085
POR TO CENTROID in.	.166	.234	.136
MIN RADIUS	.081	.230	.113
MEAN RADIUS	.805	.738	.695
MAX RADIUS	1.339	1.222	1.167
HORIZONTAL SPREAD	2.251	1.877	1.363
VERTICAL SPREAD	1.936	1.936	1.936
EXTREME SPREAD	2.469	2.022	2.022
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

23 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06685990

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 1.774

VS= 2.722

GS= 2.851

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.783

.825

.787

MINIMUM X

-.991

-.949

-.643

MAXIMUM Y

.795

.488

.513

MINIMUM Y

-2.018

-1.688

-1.575

CENTROID X

.127

.085

.283

CENTROID Y

-.042

.183

.150

POR TO CENTROID in.

.133

.201

.253

MIN RADIUS

.124

.139

.217

MEAN RADIUS

.737

.547

.500

MAX RADIUS

2.053

1.025

.911

HORIZONTAL SPREAD

1.774

1.774

1.350

VERTICAL SPREAD

2.722

1.088

1.088

EXTREME SPREAD

2.851

1.975

1.391

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

NUMBER IN THREE INCH CIRCLE =

9

20 Nov 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6685990

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.991

VS= 2.198

GS= 2.356

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.066

1.118

1.009

MINIMUM X

-.925

-.873

-.886

MAXIMUM Y

1.231

.756

.611

MINIMUM Y

-.967

-.931

-.736

CENTROID X

.077

.025

.134

CENTROID Y

-.014

-.150

-.245

POA TO CENTROID in.

.078

.153

.279

MIN RADIUS

.424

.568

.445

MEAN RADIUS

.850

.792

.730

MAX RADIUS

1.316

1.155

1.017

HORIZONTAL SPREAD

1.991

1.991

1.895

VERTICAL SPREAD

2.198

1.587

1.347

EXTREME SPREAD

2.356

2.181

1.957

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

6

NUMBER IN THREE INCH CIRCLE =

10

PDF



* IN CIR

[illegible]

CENTROID

1. 1.1.1.1 1.1.2.1

5