

BARBER - M24 0104847

FORM

UPC



0 47700 25716 7

C6665991

CAPACITY*
*INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0104847 M2400104886

BARBER - M24 0104848

5716

ORDER NO.

BARREL LENGTH

MODEL 700 TM M24

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700TM M24****SERIAL NO.****C6665991****ORDER NO.****5716**

20

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



5716 C6665991

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

ORDER 5716MODEL 700TM M24**UPC**

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26665991

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/30/91	KH
600	Proof		9/30/91	KH
607	Check Headspace		9/30/91	KH
610	Dis-assemble Gun		9/30/91	KH
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	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11-91	HA
	Apply Coating (Bolt)		11-91	HA
625	Final Assembly A) Clean inside of Bolt Assembly		11/13/91	KH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/13/91	KH
	C) Inspect Ejector Hole for Chamfer		11/13/91	KH
	D) Oil Firing Pin Ass'y		11/13/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		11/14/91	HA

op. #	BARBER M24 0104851	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			11-14-91	JK
	G) Safety Off Force	3	3	3			11-14-91	JK
	H) Trigger Pull Test & Retainability						11/14/91	JK
	I) Firing Pin Indent	.0205	.0215	.0215			11-14-91	JK
	J) Assemble Stock						11/14/91	JK
	K) Assemble Swivel Studs						11-27-91	D/H
	L) Attach Front and Rear Sight Assemblies						11/14/91	JK
	M) Iron Sight Alignment						11/14/91	JK
	N) Detach Front & Rear Sights & place in numbered container						11/14/91	JK
	O) Attach Scope to Rifle						11/14/91	JK
	P) Detach & Attach Scope 20 Times						11/14/91	JK
640	Gallery Target & Test						11/20/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						11/20/91	KT
655	Final Inspection						11-27-91	D/H
	A) Headspace							
	B) Trigger Pull	2.55	2.62	2.68	2.29	2.49	11/21/91	JK
	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-6665991DATE 11-14-91TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.43	2.48	2.55	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.51	2.53	2.62	
PULL #3	2.40	2.39	2.50	2.68	
PULL #4	2.43	2.53	2.46	2.29	
PULL #5	2.50	2.44	2.48	2.49	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.33		
PULL #2	3.58	3.51		
PULL #3	3.54	3.58		
PULL #4	3.44	3.50		
PULL #5	3.52	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.35		4.40
PULL #2	4.27	4.32		4.25
PULL #3	4.21	4.51		4.29
PULL #4	4.24	4.43		4.45
PULL #5	4.25	4.41		4.44
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665991
21 Nov 1991

CENTROIDAL DISTANCES

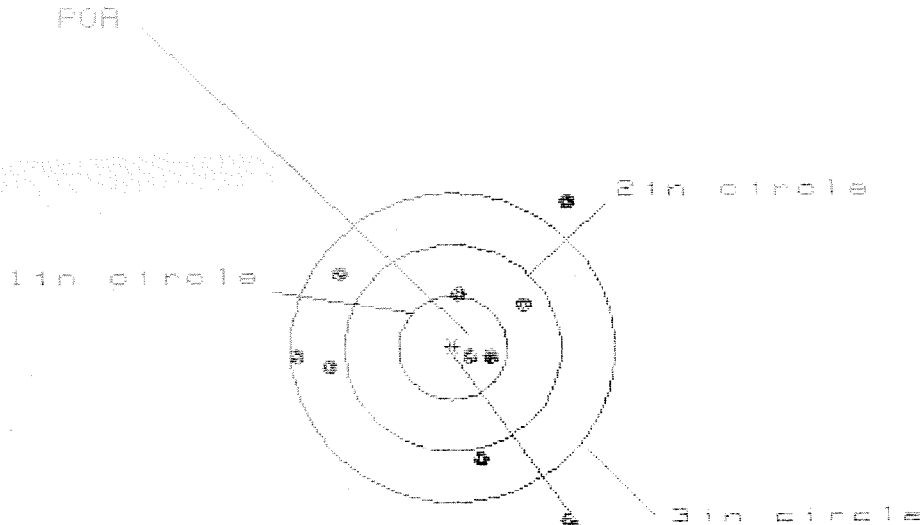
0 TO	1	.361858
1 TO	2	.282631
1 TO	3	.663883
1 TO	4	.445687
1 TO	5	.328032

$f_{q,2}$ <----POA

COINATE FOR THIS RIFLE IS: -.051
DATE FOR THIS RIFLE IS: .1164
POI RADIUS FOR THIS RIFLE IS: .127082
RIFLE IS: .896

FILE:/PATTERNING/CENTERFIRE_PATT/C8885391

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 8

HS= 2.519

VS= 3.133

GS= 3.262

CENTROID #

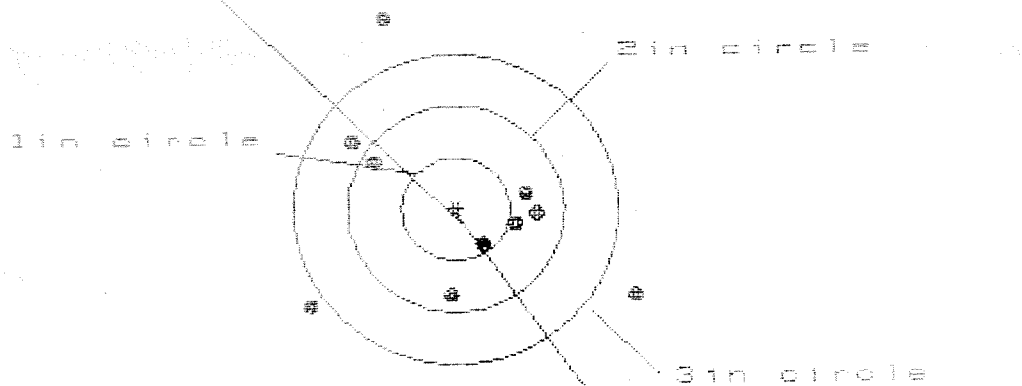
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.094	1.165	.909
MINIMUM X	-1.425	-1.303	-1.158
MAXIMUM Y	1.441	1.253	.741
MINIMUM Y	-1.692	-1.287	-1.131
SCATTER	-.354	-.476	-.621
CENTROID X	.075	.263	.107
FOR 3in DIAID IN.	.362	.544	.630
FOR 2in DIAID IN.	.122	.332	.388
FOR 1in DIAID IN.	1.059	.959	.874
MAX. SPREAD	2.015	1.710	1.237
HORIZONTAL SPREAD	2.519	2.468	2.067
VERTICAL SPREAD	3.133	2.540	1.872
TOTAL SPREAD	3.262	2.878	2.266
1in DIAID IN. CIRCLE =	2		
2in DIAID IN. CIRCLE =	4		
3in DIAID IN. CIRCLE =	8		

18 NOV 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665391

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 7

HS= 2.968

VS= 2.784

GS= 3.477

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.616	1.544	.848
MINIMUM X	-1.352	-1.424	-1.291
MAXIMUM Y	1.820	.874	.797
MINIMUM Y	-.964	-.762	-.839
CENTROID X	-.248	-.176	-.369
CENTROID Y	.337	.135	.212
FOR TO CENTROID in.	.418	.222	.426
MIN RADIUS	.415	.216	.419
MEAN RADIUS	1.064	.930	.868
MAX RADIUS	1.930	1.665	1.490
HORIZONTAL SPREAD	2.968	2.968	2.079
VERTICAL SPREAD	2.784	1.636	1.636
EXTREME SPREAD	3.477	2.971	2.314
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	7	

28 NOV 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08665391

CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.778

VS = 2.073

GS = 2.095

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.747	.769	.643
MINIMUM X	-1.031	-1.009	-.269
MAXIMUM Y	1.065	.851	.861
MINIMUM Y	-1.008	-.890	-.888
CENTROID X	.072	.050	.176
CENTROID Y	-.056	-.174	-.184
POR TO CENTROID in.	.091	.181	.255
MIN RADIUS	.089	.128	.170
MEAN RADIUS	.679	.625	.559
MAX RADIUS	1.093	1.012	.904
HORIZONTAL SPREAD	1.778	1.778	.912
VERTICAL SPREAD	2.073	1.741	1.741
EXTREME SPREAD	2.095	1.851	1.742
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

02 Nov 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865381

CENTERFIRE PATTERNS # 5

FOR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 5

2in = 7

3in = 9

HS = 2.077

VS = 2.310

GS = 2.695

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.769	.659	.481
MINIMUM X	-1.308	-1.418	-.243
MAXIMUM Y	1.384	.587	.577
MINIMUM Y	-.926	-.772	-.782
CENTROID X	-.027	.083	.261
CENTROID Y	.049	-.105	-.095
FOR TO CENTROID in.	.056	.134	.277
MIN RADIUS	.101	.049	.100
MEAN RADIUS	.712	.564	.450
MAX RADIUS	1.703	1.420	.789
HORIZONTAL SPREAD	2.077	2.077	.724
VERTICAL SPREAD	2.310	1.359	1.359
EXTREME SPREAD	2.695	2.120	1.365
NUMBER IN ONE INCH CIRCLE	=	5	
NUMBER IN TWO INCH CIRCLE	=	7	
NUMBER IN THREE INCH CIRCLE	=	9	

(93)

FILE:/PATTERNING/CENTERFIRE_PATT/08865991

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.105

VS= 1.060

GS= 3.124

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.518	1.675	1.498
MINIMUM X	-1.587	-1.418	-1.367
MAXIMUM Y	.512	.415	.445
MINIMUM Y	-.548	-.491	-.461
CENTROID X	.302	.133	.310
CENTROID Y	.177	.120	.090
POA TO CENTROID-in.	.350	.179	.323
MIN RADII	.319	.102	.324
MEAN RADII	.966	.070	.813
MAX RADII	1.682	1.686	1.507
HORIZONTAL SPREAD	3.105	3.093	2.865
VERTICAL SPREAD	1.060	.906	.906
EXTREME SPREAD	3.124	3.124	2.867
NUMBER IN ONE INCH CIRCLE	=	3	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	7	