

BARBER - M24 0105032

FORM

UPC



0 47700 25716 7

C6666014

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0105032~~ 0105071

BARBER - M24 0105033

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0105034

Remington



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

MODEL 700™ M24

SERIAL NO.

C6666014

ORDER NO.

5716

20

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



5716 C6666014

ORDER 5716

MODEL 700™ M24

UPC

ORDER 5716

MODEL 700™ M24

UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26666014

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/1/91	KH
600	Proof		10/1/91	KH
607	Check Headspace		10/1/91	KH
610	Dis-assemble Gun		10/1/91	KH
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GB
617	Drill and Tap Sight Holes		OCT 8 1991	FB
618	Polish Barrel		10/14/91	WB
620	Apply Coatings (Barrel Action)		11/1/91	TH
	Apply Coating (Bolt)			
625	Final Assembly		12/2/91	KH
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/2/91	KH
	C) Inspect Ejector Hole for Chamfer		12/2/91	KH
	D) Oil Firing Pin Ass'y		12/2/91	KH
	E) Adjust Trigger Pull to Min Setting and Stake		12/3/91	WB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			12/3/91	WLB
	G) Safety Off Force	2	2	2			12/3/91	WLB
	H) Trigger Pull Test & Retainability						12/3/91	WLB
	I) Firing Pin Indent	.020	.020	.020			12/3/91	WLB
	J) Assemble Stock						12/9/91	WLB
	K) Assemble Swivel Studs						12-12-91	WLB
	L) Attach Front and Rear Sight Assemblies						12/9/91	WLB
	M) Iron Sight Alignment						12/9/91	WLB
	N) Detach Front & Rear Sights & place in numbered container						12/9/91	WLB
	O) Attach Scope to Rifle						12/9/91	WLB
	P) Detach & Attach Scope 20 Times						12/9/91	WLB
640	Gallery Target & Test						12/10/91	KT
	A) Time							105
	B) Malfunctions							105
	C) Pierced Primers							105
	D) Optical Clarity of Scope							105
645	Inspect for Live Ammo						12/10/91	105
655	Final Inspection							
	A) Headspace						12-12-91	WLB
	B) Trigger Pull	2.77	2.63	2.69	2.69	2.70	12-12-91	WLB
	C) Function						12-12-91	WLB
660	Pack						12-18-91	WLB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6666014

DATE 12/3/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.45	2.42	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.33	2.57	2.46	2.63	
PULL #3	2.30	2.48	2.40	2.69	
PULL #4	2.34	2.48	2.50	2.69	
PULL #5	2.34	2.48	2.41	2.70	
TOTAL	11.64	12.46	12.19		
AVG.	2.33	2.49	2.44		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.15		
PULL #2	3.12	3.30		
PULL #3	3.11	3.17		
PULL #4	3.12	3.17		
PULL #5	3.11	3.08		
TOTAL	15.72	15.87		
AVG.	3.14	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.16		4.15
PULL #2	4.04	4.09		4.15
PULL #3	4.00	4.00		4.12
PULL #4	4.00	4.00		4.10
PULL #5	4.00	4.00		4.16
TOTAL	20.11	20.25		20.68
AVG.	4.02	4.05		4.13

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 0666014
11 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.353386
1 TO 2	.613249
1 TO 3	1.40855
1 TO 4	.690889
1 TO 5	.464634

3
2 454 <----POA
1

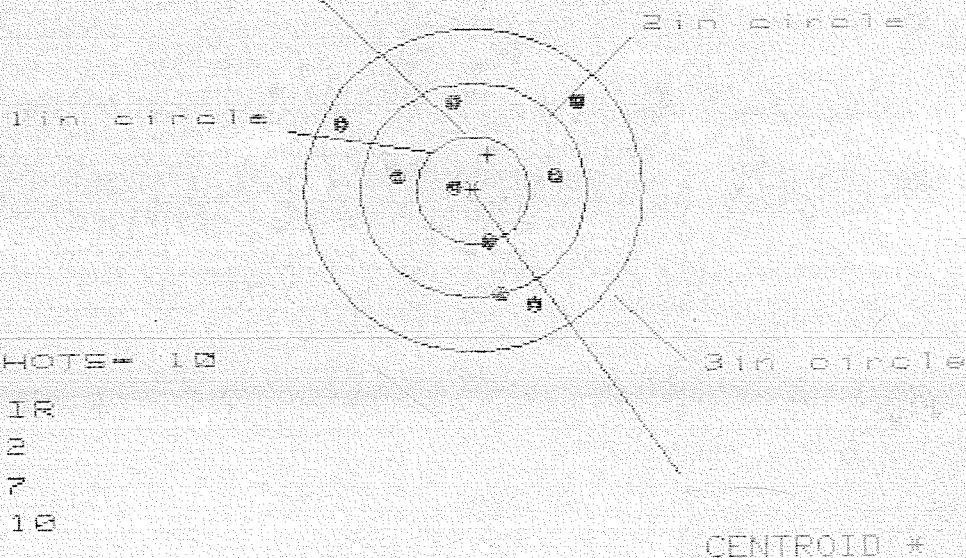
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0122
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1778
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .178218
THE AMR FOR THIS RIFLE IS: 1.095

(1 Dec 1991)

FILE:/PATTERNING/CENTERFIRE_PATT/C8666014.1

CENTERFIRE PATTERNS # 1

POB



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 2.077

VS= 1.966

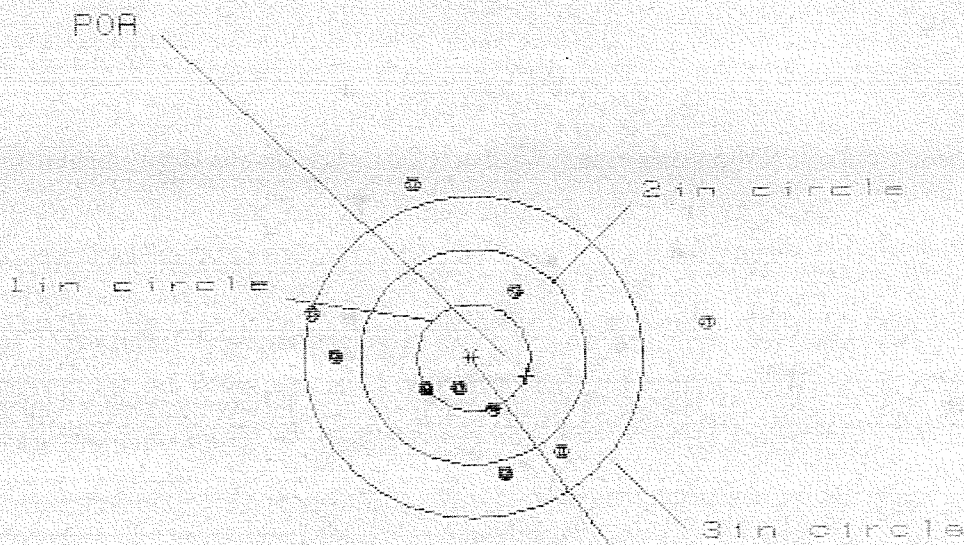
GS= 2.426

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.884	.751	.803
MINIMUM X	:	-1.193	-.842	-.790
MAXIMUM Y	:	.857	.922	.792
MINIMUM Y	:	-1.109	-1.044	-1.045
CENTROID X	:	-.129	.004	-.040
CENTROID Y	:	-.329	-.394	-.264
POB TO CENTROID in.	:	.354	.394	.268
MIN RADIUS	:	.203	.350	.270
MEAN RADIUS	:	.803	.755	.693
MAX RADIUS	:	1.329	1.190	1.128
HORIZONTAL SPREAD	:	2.077	1.593	1.593
VERTICAL SPREAD	:	1.966	1.966	1.837
EXTREME SPREAD	:	2.426	2.058	1.963
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6666014.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 3.451

VS= 2.736

GS= 3.452

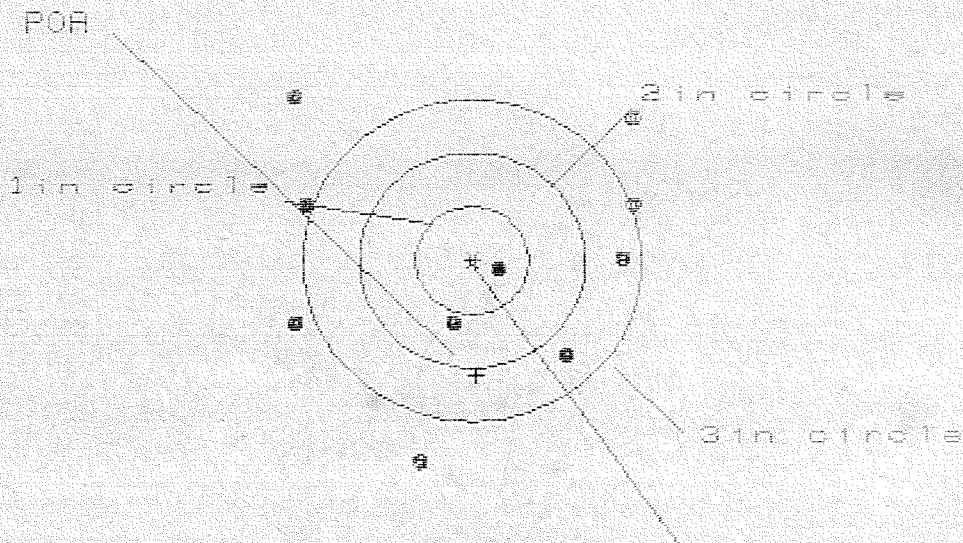
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.048	1.005	.965
MINIMUM X	-1.403	-1.176	-1.216
MAXIMUM Y	1.621	1.661	.898
MINIMUM Y	-1.115	-1.075	-.868
CENTROID X	-.474	-.701	-.661
CENTROID Y	.178	.138	-.070
POA TO CENTROID in.	.506	.715	.665
MIN RADIUS	.248	.236	.100
MEAN RADIUS	1.087	.953	.810
MAX RADIUS	2.079	1.691	1.394
HORIZONTAL SPREAD	3.451	2.181	2.181
VERTICAL SPREAD	2.736	2.736	1.766
EXTREME SPREAD	3.452	2.867	2.557
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8865014.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS= 3.030

VS= 3.400

GS= 3.762

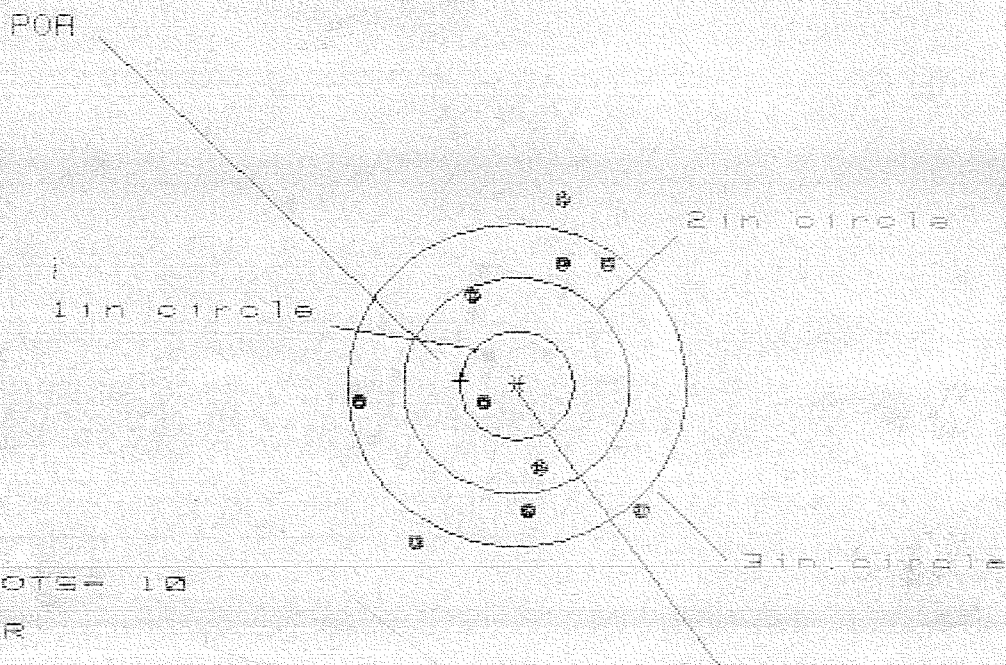
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.465	1.291	1.399
MINIMUM X	:	-1.565	-1.721	-1.560
MAXIMUM Y	:	1.520	1.533	.921
MINIMUM Y	:	-1.880	-1.711	-1.520
CENTROID X	:	-.029	.145	-.016
CENTROID Y	:	1.076	.907	.716
POA TO CENTROID in.	:	1.076	.919	.716
MIN RADIUS	:	.254	.136	.282
MEAN RADIUS	:	1.417	1.283	1.187
MAX RADIUS	:	2.182	2.004	1.759
HORIZONTAL SPREAD	:	3.030	3.012	2.959
VERTICAL SPREAD	:	3.400	3.244	2.441
EXTREME SPREAD	:	3.762	3.762	3.161
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		5	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66666014.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 2.468

VS= 3.213

GS= 3.462

CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.082	1.121	1.009
MINIMUM X	:	-1.387	-1.347	-1.459
MAXIMUM Y	:	1.754	1.370	1.212
MINIMUM Y	:	-1.459	-1.264	-1.160
CENTROID X	:	.499	.459	.571
CENTROID Y	:	-.041	-.236	-.078
POA TO CENTROID in.	:	.500	.516	.576
MIN RADIUS	:	.368	.271	.416
MEAN RADIUS	:	1.243	1.155	1.115
MAX RADIUS	:	1.789	1.570	1.518
HORIZONTAL SPREAD	:	2.468	2.468	2.468
VERTICAL SPREAD	:	3.213	2.634	2.372
EXTREME SPREAD	:	3.462	3.119	2.658
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

11 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666014.1

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.312

VS= 1.738

GS= 2.376

CENTROID *

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.158	1.198	1.070
MINIMUM X	:	-1.154	-1.025	-.956
MAXIMUM Y	:	.851	.769	.736
MINIMUM Y	:	-.887	-.969	-1.002
CENTROID X	:	.194	.065	.193
CENTROID Y	:	.005	.087	.120
POB TO CENTROID in.	:	.194	.108	.227
MIN RADIUS	:	.201	.196	.089
MEAN RADIUS	:	.926	.856	.813
MAX RADIUS	:	1.370	1.203	1.205
HORIZONTAL SPREAD	:	2.312	2.223	2.026
VERTICAL SPREAD	:	1.738	1.738	1.738
EXTREME SPREAD	:	2.376	2.228	2.216
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06666014
10 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.238665
1 TO	2	.424019
1 TO	3	.566286
1 TO	4	.536173
1 TO	5	.408385

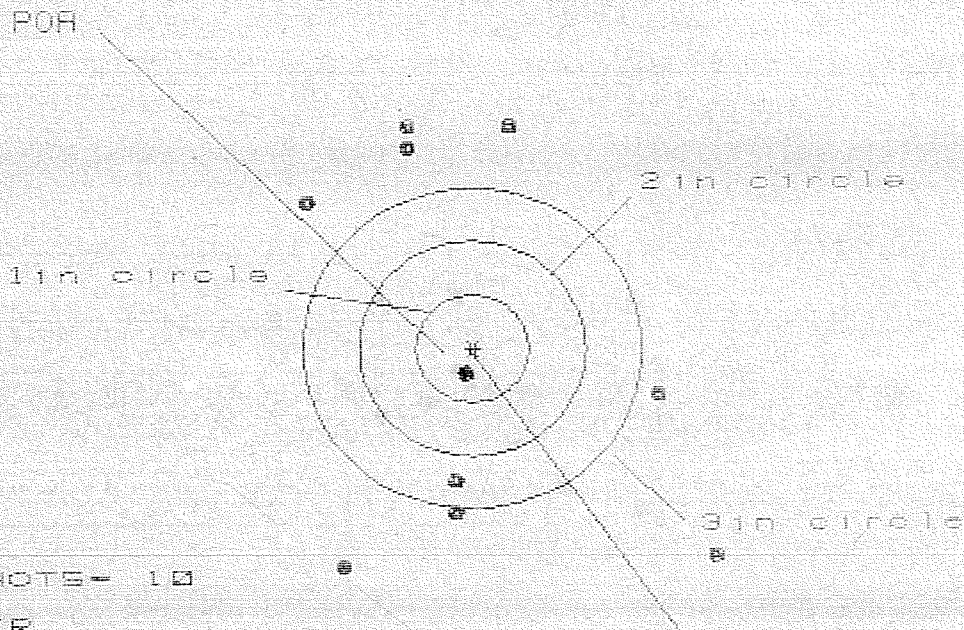
$\frac{1}{5}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .026
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.133
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .135518
THE AMR FOR THIS RIFLE IS: 1.327

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666014

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 1

3 in = 2

HS = 3.516

VS = 4.128

GS = 4.845

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.102	1.922	1.803
MINIMUM X	-1.414	-1.180	-1.299
MAXIMUM Y	2.117	1.903	1.625
MINIMUM Y	-2.011	-2.225	-2.040
CENTROID X	.060	-.174	-.055
CENTROID Y	.231	.445	.723
POA TO CENTROID in.	.238	.477	.725
MIN RADIUS	.278	.494	.753
MEAN RADIUS	1.820	1.706	1.609
MAX RADIUS	2.851	2.419	2.040
HORIZONTAL SPREAD	3.516	3.102	3.102
VERTICAL SPREAD	4.128	4.128	3.665
EXTREME SPREAD	4.845	4.364	3.690
NUMBER IN ONE INCH CIRCLE =	1	1	1
NUMBER IN TWO INCH CIRCLE =	1	1	1
NUMBER IN THREE INCH CIRCLE =	2	2	2

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08686014

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.313

VS = 2.025

GS = 3.062

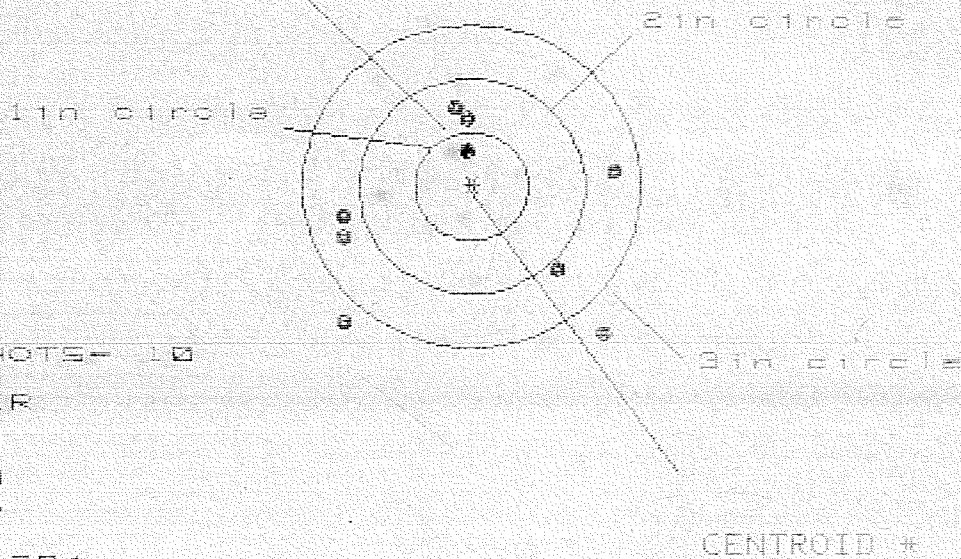
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.347	1.301	1.201
MINIMUM X	:	-.966	-.816	-.916
MAXIMUM Y	:	.826	.692	.771
MINIMUM Y	:	-1.200	-.675	-.588
CENTROID X	:	.256	.106	.206
CENTROID Y	:	-.145	-.012	-.099
POA TO CENTROID in.	:	.294	.107	.228
MIN RADIUS	:	.187	.069	.126
MEAN RADIUS	:	.911	.662	.619
MAX RADIUS	:	1.804	1.323	1.244
HORIZONTAL SPREAD	:	2.313	2.117	2.117
VERTICAL SPREAD	:	2.025	1.367	1.359
EXTREME SPREAD	:	3.062	2.201	2.201
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8666014

CENTERFIRE PATTERNS # 3

POR



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 7

HS= 2.384

VS= 3.928

GS= 4.115

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.239
MINIMUM X	-1.145
MAXIMUM Y	2.546
MINIMUM Y	-1.382
CENTROID X	.042
CENTROID Y	-.335
POR TO CENTROID in.	.337
MIN RADIUS	.295
MEAN RADIUS	1.241
MAX RADIUS	2.588
HORIZONTAL SPREAD	2.384
VERTICAL SPREAD	3.928
EXTREME SPREAD	4.115
NUMBER IN ONE INCH CIRCLE	= 1
NUMBER IN TWO INCH CIRCLE	= 3
NUMBER IN THREE INCH CIRCLE	= 7

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8866014

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS = 3.373

VS = 2.959

GS = 3.572

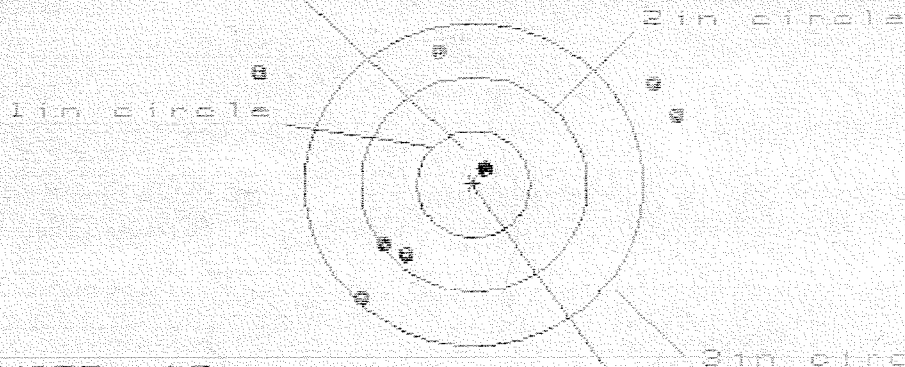
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	.760	.849
MINIMUM X	:	-2.352	-.698	-.689
MAXIMUM Y	:	1.465	1.441	1.251
MINIMUM Y	:	-1.494	-1.518	-1.127
CENTROID X	:	-.131	.130	.041
CENTROID Y	:	-.270	-.246	-.056
POA TO CENTROID in.	:	.300	.278	.069
MIN RADIUS	:	.285	.285	.082
MEAN RADIUS	:	1.044	.891	.774
MAX RADIUS	:	2.362	1.677	1.267
HORIZONTAL SPREAD	:	3.373	1.458	1.458
VERTICAL SPREAD	:	2.959	2.959	2.378
EXTREME SPREAD	:	3.572	3.124	2.398
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

11/22/91

FILE:/PATTERNING/CENTERFIRE_PATT/C6866014

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 2

3 in = 5

HS= 3.696

VS= 6.301

GS= 6.353

CENTROID +

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.769	1.883	1.923
MINIMUM X	-1.927	-1.813	-1.773
MAXIMUM Y	2.284	1.837	1.851
MINIMUM Y	-4.017	-1.537	-1.307
CENTROID X	-.097	-.211	-.251
CENTROID Y	-.146	.301	.071
POA TO CENTROID in.	.175	.367	.261
MIN RADIUS	.150	.393	.270
MEAN RADIUS	1.719	1.432	1.340
MAX RADIUS	4.146	1.919	1.969
HORIZONTAL SPREAD	3.696	3.696	3.696
VERTICAL SPREAD	6.301	3.374	2.358
EXTREME SPREAD	6.353	3.725	3.725
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		