

C6349163

MODEL 700TM M24

Model **SMS** TM

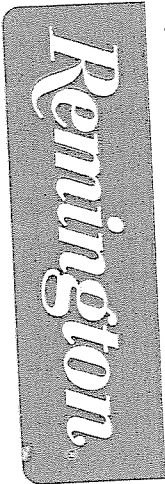
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349163

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A.C.
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-3	89	RW
612	NEW BARREL 10/30/89 Magnaflux Barrel Action	REJECT	10/13/89	KCR
	Magnaflux Bolt		10/13/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake			

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

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6349163

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		11-2 89	RW
600	Proof		11-2 89	RW
607	Check Headspace		11-2 89	RW
610	Dis-assemble Gun		11-2 89	RW
612	Magnaflux Barrel Action		11-9-89	KCR
	Magnaflux Bolt		11-9-89	KCR
615	Rollmark Caliber			
17	Drill and Tap Sight Holes		11 9 89	YB
618	Polish Barrel RB		11 9 89	BT
620	Apply Coatings (Barrel Action)		11-17-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/27/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/27/89	RW
	C) Inspect Ejector Hole for Chamfer		11/27/89	RW
	D) Oil Firing Pin Ass'y		11/27/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Dec 89	gds

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op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			4 Dec 89	JS
	G) Safety Off Force	3	3	3			4 Dec 89	JS
	H) Trigger Pull Test & Retainability						4 Dec 89	JS
	I) Firing Pin Indent	.021	.0215	.022			4 Dec 89	JS
	J) Assemble Stock						12/4/89	RW
	K) Assemble Swivel Studs						6 Dec 89	JS
	L) Attach Front and Rear Sight Assemblies						12/4/89	RW
	M) Iron Sight Alignment						12/4/89	RW
	N) Detach Front & Rear Sights & place in numbered container						12/4/89	RW
	O) Attach Scope to Rifle						4 Dec 89	JS
	P) Detach & Attach Scope 20 Times						4 Dec 89	JS
640	Gallery Target & Test						12-5-89	
	A) Time						12-5-89	
	B) Malfunctions						12-5-89	
	C) Pierced Primers						12-5-89	
	D) Optical Clarity of Scope						12-5-89	
645	Inspect for Live Ammo						12-5-89	
655	Final Inspection						6 Dec 89	JS
	A) Headspace						6 Dec 89	JS
	B) Trigger Pull	2.79	2.75	2.73	2.70	2.71	6 Dec 89	JS
	C) Function						6 Dec 89	JS
660	Pack						13 Dec 89	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6349163DATE 13 Mar 90TESTER JSB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	244	256		2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	248	258		2.79	
PULL #3	260	263		2.78	
PULL #4	256	250		2.74	
PULL #5	253	261		2.52	
TOTAL	1261	1288			
AVG.	2522	2576			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	325	314		
PULL #2	339	339		
PULL #3	342	342		
PULL #4	340	347		
PULL #5	315	340		
TOTAL	1661	1682		
AVG.	3322	3364		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	464	450		
PULL #2	450	444		
PULL #3	448	440		
PULL #4	442	441		
PULL #5	443	447		
TOTAL	2287	2222		
AVG.	4578	4444		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349163
5 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.381177
1 TO	2	.433046
1 TO	3	.672536
1 TO	4	.92618
1 TO	5	.570639

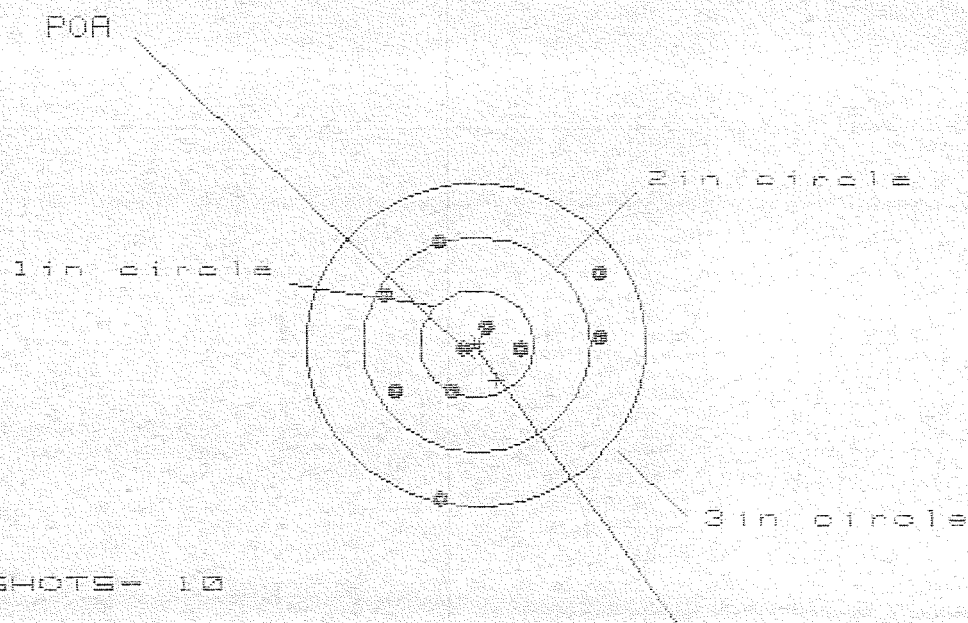
$\frac{1}{4} +$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.429
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .443178
THE AMR FOR THIS RIFLE IS: .8528

5 Dec 1989

FILE: /PATTERNING/CENTERFIRE_PATT/08348163

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 6

3 in = 10

HS= 1.936

VS= 2.369

GS= 2.529

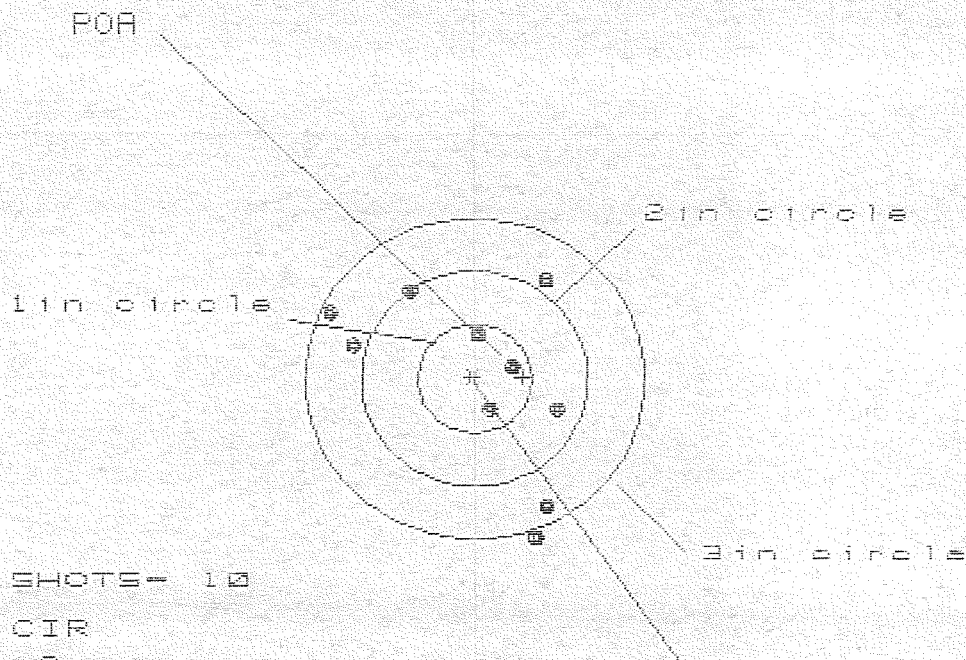
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.078	1.042	1.150
MINIMUM X	-.858	-.894	-.764
MAXIMUM Y	.948	.790	.856
MINIMUM Y	-1.421	-.605	-.539
CENTROID X	-.180	-.144	-.274
CENTROID Y	.336	.494	.428
POA TO CENTROID in.	.381	.514	.509
MIN RADIUS	.144	.088	.162
MEAN RADIUS	.777	.704	.635
MAX RADIUS	1.458	1.166	1.151
HORIZONTAL SPREAD	1.936	1.936	1.914
VERTICAL SPREAD	2.369	1.395	1.395
EXTREME SPREAD	2.529	2.131	1.964
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

5 Dec 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.987

VS= 2.399

GS= 2.724

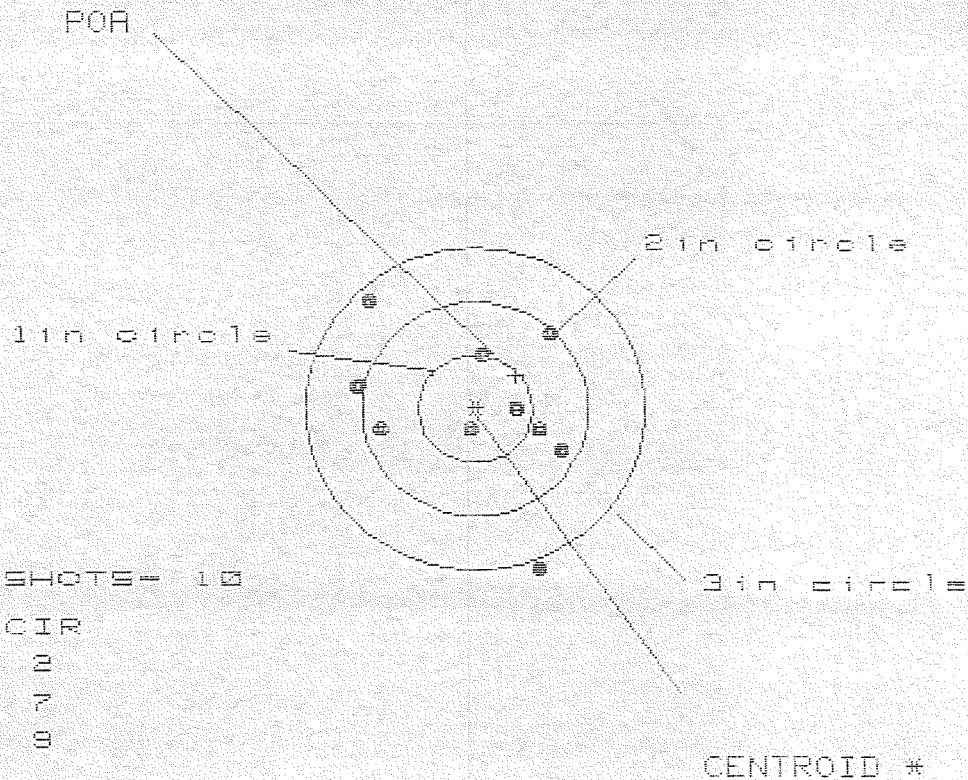
CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.714	.773	.621
MINIMUM X	-1.273	-1.214	-1.130
MAXIMUM Y	.948	.787	.840
MINIMUM Y	-1.451	-1.323	-1.270
CENTROID X	-.428	-.487	-.335
CENTROID Y	-.019	.142	.089
POA TO CENTROID in.	.429	.507	.347
MIN RADIUS	.320	.239	.273
MEAN RADIUS	.935	.854	.776
MAX RADIUS	1.545	1.477	1.366
HORIZONTAL SPREAD	1.987	1.987	1.751
VERTICAL SPREAD	2.399	2.110	2.110
EXTREME SPREAD	2.724	2.562	2.294
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

5 Dec 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 1.840

VS= 2.507

GS= 2.819

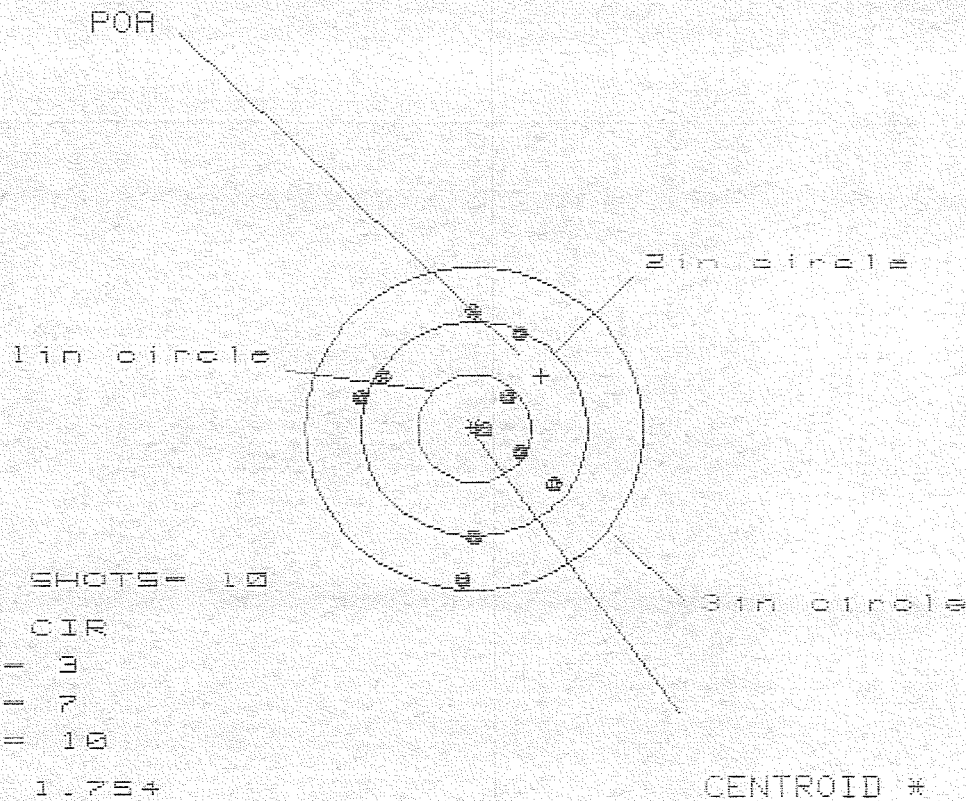
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.797	.855	.740
MINIMUM X	-1.043	-.985	-1.100
MAXIMUM Y	.973	.803	.632
MINIMUM Y	-1.534	-.514	-.414
CENTROID X	-.360	-.418	-.303
CENTROID Y	-.312	-.142	-.242
POA TO CENTROID in.	.476	.441	.388
MIN RADIUS	.184	.349	.268
MEAN RADIUS	.841	.759	.670
MAX RADIUS	1.620	1.217	1.109
HORIZONTAL SPREAD	1.840	1.840	1.840
VERTICAL SPREAD	2.507	1.317	1.046
EXTREME SPREAD	2.919	2.205	1.922
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

5 Oct 1989

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CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 3

2in = 7

3in = 10

HS = 1.754

VS = 2.475

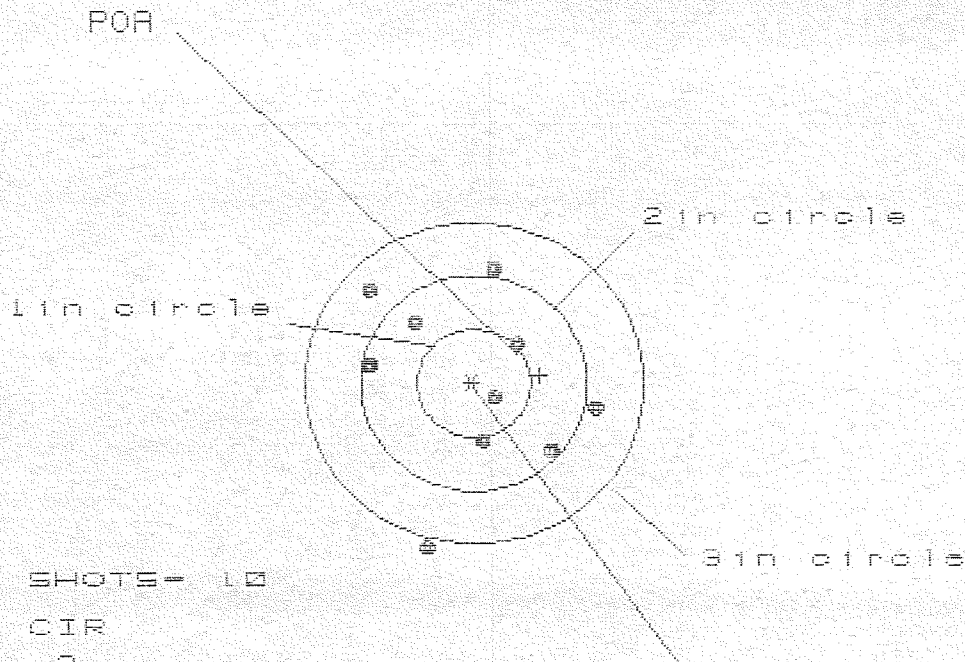
GS = 2.477

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.703	.694	.695
MINIMUM X	:	-1.051	-1.060	-1.059
MAXIMUM Y	:	1.101	.948	.861
MINIMUM Y	:	-1.374	-1.151	-1.032
CENTROID X	:	-.595	-.586	-.587
CENTROID Y	:	-.492	-.339	-.458
POA TO CENTROID in.	:	.772	.677	.744
MIN RADIUS	:	.082	.163	.079
MEAN RADIUS	:	.833	.764	.729
MAX RADIUS	:	1.377	1.151	1.088
HORIZONTAL SPREAD	:	1.754	1.754	1.754
VERTICAL SPREAD	:	2.475	2.099	1.893
EXTREME SPREAD	:	2.477	2.099	1.943
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

5 Dec 1988

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS = 1.946

VS = 2.622

GS = 2.691

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.052	1.009	.894
MINIMUM X	-.894	-.937	-1.052
MAXIMUM Y	1.059	.886	.976
MINIMUM Y	-1.563	-.767	-.677
CENTROID X	-.582	-.539	-.424
CENTROID Y	-.069	.104	.014
POA TO CENTROID in.	.586	.549	.424
MIN RADIUS	.240	.327	.195
MEAN RADIUS	.878	.787	.713
MAX RADIUS	1.609	1.176	1.057
HORIZONTAL SPREAD	1.946	1.946	1.946
VERTICAL SPREAD	2.622	1.653	1.653
EXTREME SPREAD	2.691	2.250	1.993
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

BARBER - M24 0109142

Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM H24		SERIAL NO. C6349163	
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.		01	ORDER NO. 5716
 5716 C6349163			

UPC



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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0109142