

C6225332

MODEL 700<sup>TM</sup> M24

Model 700 M24<sup>TM</sup>

Action \_\_\_\_\_

Barrel Length \_\_\_\_\_

Capacity \_\_\_\_\_

Order No. 5716

\*Includes 1 in chamber.

*Remington*

M2400013027

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

00299

5081

**M-24**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225332*

| OPERATION |                   | DATE           | INT        |
|-----------|-------------------|----------------|------------|
| #         | NAME              |                |            |
| 575-580   | ASSEMBLY          | <i>2/1</i>     | <i>FB</i>  |
| 600       | PROOF             | <i>2/9/88</i>  | <i>RW</i>  |
| 615       | MAGNAFLUX BARREL  | <i>2/18/88</i> | <i>P/C</i> |
|           | MAGNAFLUX BOLT    | <i>2/25/88</i> | <i>P/C</i> |
| 620       | COATING           | <i>3/21/88</i> | <i>TJA</i> |
| 625-630   | FINAL ASSEMBLY    |                |            |
| 635       | TEST              |                |            |
| 640       | TARGET            |                |            |
|           | FIRING PIN INDENT |                |            |
| 660       | PACK              |                |            |

M-24

SCOPE #  
1194

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225332

| OP.#         | OP. NAME                                                       | READINGS                                                                           | DATE   | INITIAL |
|--------------|----------------------------------------------------------------|------------------------------------------------------------------------------------|--------|---------|
| 575 &<br>580 | Assemble Action<br>and stock                                   |  |        |         |
| 600          | Proof                                                          |                                                                                    |        |         |
| 607          | Check Headspace                                                |                                                                                    |        |         |
| 610          | Dis-assemble gun                                               |                                                                                    |        |         |
| 612          | Magnaflux Barrel<br>Action                                     |                                                                                    |        |         |
|              | Magnaflux Bolt                                                 |                                                                                    |        |         |
| 615          | Rollmark Caliber                                               |                                                                                    |        |         |
| 617          | Drill & Tap Sight Holes                                        |                                                                                    |        |         |
| 618          | Polish Barrel                                                  |                                                                                    |        |         |
| 620          | Apply Coatings<br>(Barrel Action)                              |                                                                                    |        |         |
|              | Apply Coatings (Bolt)                                          |                                                                                    |        |         |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |                                                                                    | 9/9/88 | RW      |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |                                                                                    | 9/9/88 | RW      |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |                                                                                    | 9/9/88 | RW      |

OVER

| OP.#         |                                                             | READINGS          | DATE     | INITIAL  |
|--------------|-------------------------------------------------------------|-------------------|----------|----------|
| 625<br>cont. | D) Oil Firing Pin Ass'y                                     |                   | 9/9/88   | RW       |
|              | E) Adjust Trigger Pull to Min. Setting and Stake            |                   | 9/8/88   | RW       |
|              | F) Safety on Force                                          | 6 6 6             | 9/8/88   | RW       |
|              | G) Safety off Force                                         | 5 3.5 3.5         | 9/8/88   | RW       |
|              | H) Trigger Pull Test & Retainability                        |                   | 9/8/88   | RW       |
|              | I) Firing Pin Indent                                        | 0.022 0.022 0.025 | 9/8/88   | RW       |
|              | J) Assemble Stock                                           |                   | 9/15/88  | RW       |
|              | K) Assemble Swivel Studs                                    |                   | 10-12-88 | RW       |
|              | L) Attach Front & Rear Sight Assemblies                     |                   | 9/15/88  | RW       |
|              | M) Iron Sight Alignment                                     |                   | 9/15/88  | RW       |
|              | N) Detach Front & Rear Sights & place in numbered container |                   | 9/15/88  | RW       |
|              | O) Attach Scope to Rifle                                    |                   | 10/5/88  | RW       |
|              | P) Detach & Attach Scope 20 times                           |                   | 10-5-88  | RW       |
| 640          | Gallery Target & Test                                       | 85 R 70L          | 10/11/88 | W.B.     |
|              | A) Optical Clarity of Scope                                 |                   | 10/11/88 | W.B.     |
| 645          | Inspect for Live Ammo                                       |                   | 10/11/88 | W.B. AC. |
| 655          | Final Inspection                                            |                   |          |          |
|              | A) Headspace                                                |                   | 10-12-88 | RW       |
|              | B) Trigger Pull                                             |                   | 10-14-88 | RW       |
|              | C) Function                                                 |                   | 10-12-88 | RW       |
| 660          | Pack                                                        |                   | 10-21-88 | RW       |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225332  
DATE 9 Sept 88  
TESTER J. H. + G. S.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |       | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|-------|------------------------------------------------------------------------|
| PULL #1 | 2.69             | 2.56                     | 2.73                           | 2.74  | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.67             | 2.52                     | 2.72                           | 2.74  |                                                                        |
| PULL #3 | 2.62             | 2.49                     | 2.70                           | 2.92  |                                                                        |
| PULL #4 | 2.61             | 2.50                     | 2.73                           | 2.68  |                                                                        |
| PULL #5 | 2.58             | 2.50                     | 2.70                           | 2.60  |                                                                        |
| TOTAL   | 13.17            | 12.57                    | 13.58                          | 13.68 |                                                                        |
| AVG.    | 2.634            | 2.514                    | 2.716                          | 2.736 |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.37             | 3.44                     |  |          |
| PULL #2 | 3.40             | 3.50                     |  |          |
| PULL #3 | 3.42             | 3.49                     |  |          |
| PULL #4 | 3.45             | 3.48                     |  |          |
| PULL #5 | 3.45             | 3.49                     |  |          |
| TOTAL   | 17.09            | 17.40                    |  |          |
| AVG.    | 3.418            | 3.48                     |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.27             | 4.17                     |                                | 4.11                                 |
| PULL #2 | 4.26             | 4.29                     |                                | 4.13                                 |
| PULL #3 | 4.23             | 4.31                     |                                | 4.13                                 |
| PULL #4 | 4.29             | 4.28                     |                                | 4.01                                 |
| PULL #5 | 4.28             | 4.31                     |                                | 4.13                                 |
| TOTAL   | 21.33            | 21.26                    |                                | 20.51                                |
| AVG.    | 4.266            | 4.252                    |                                | 4.102                                |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6225332

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .631596 |
| 1 TO | 2 | .44893  |
| 1 TO | 3 | 1.4136  |
| 1 TO | 4 | .482954 |
| 1 TO | 5 | .503668 |

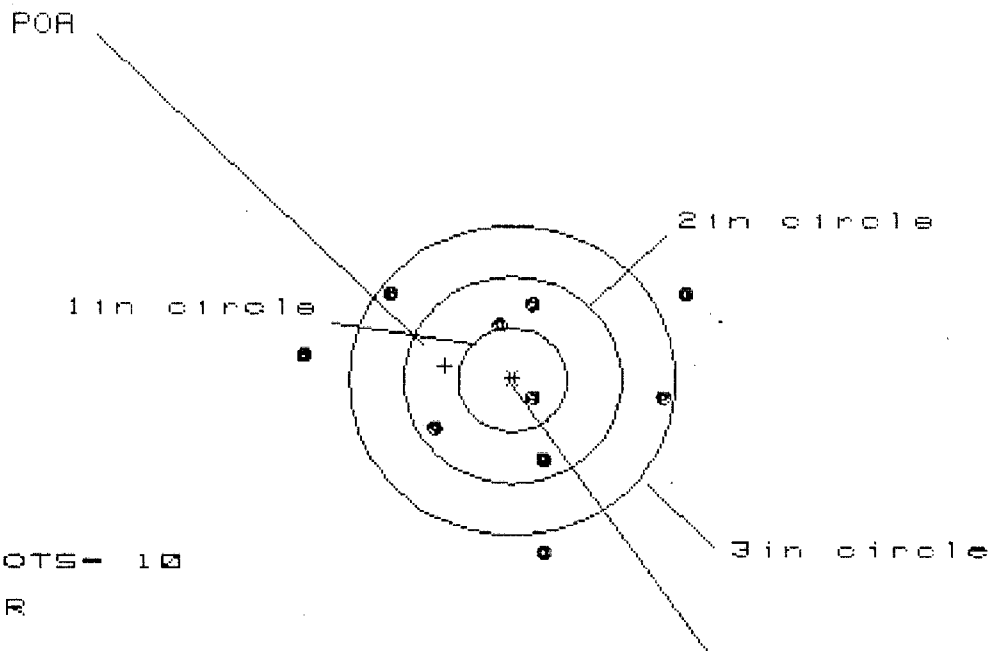
+ 1 2 <-----POA  
3  
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .9858  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.5568  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.13218  
THE AMR FOR THIS RIFLE IS: .9246

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C6225332

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 5

3in = 7

HS= 3.493

VS= 2.570

GS= 3.546

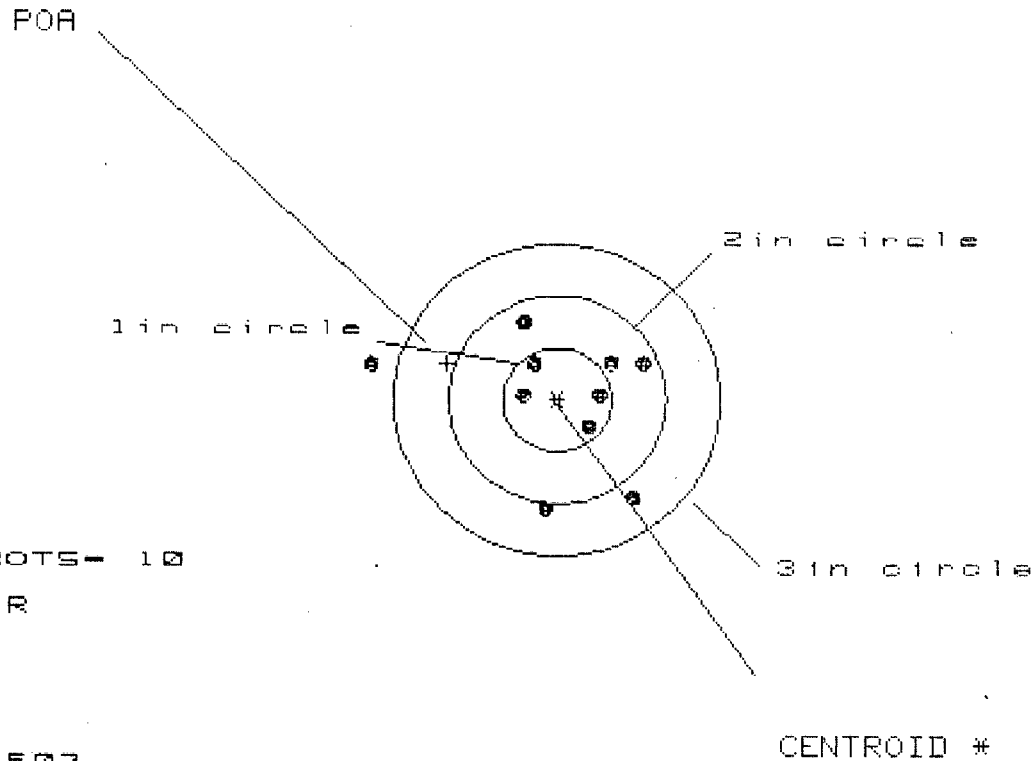
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.556  | 1.341  | 1.311  |
| MINIMUM X                     | -1.937 | -1.305 | -1.137 |
| MAXIMUM Y                     | .873   | .902   | .957   |
| MINIMUM Y                     | -1.697 | -1.668 | -1.555 |
| CENTROID X                    | .617   | .832   | .664   |
| CENTROID Y                    | -.135  | -.164  | -.277  |
| POR TO CENTROID in.           | .631   | .848   | .720   |
| MIN RADIUS                    | .208   | .115   | .114   |
| MEAN RADIUS                   | 1.146  | 1.042  | .956   |
| MAX RADIUS                    | 1.954  | 1.672  | 1.581  |
| HORIZONTAL SPREAD             | 3.493  | 2.646  | 2.448  |
| VERTICAL SPREAD               | 2.570  | 2.570  | 2.512  |
| EXTREME SPREAD                | 3.546  | 2.886  | 2.886  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/06225332

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.503

VS= 1.779

GS= 2.695

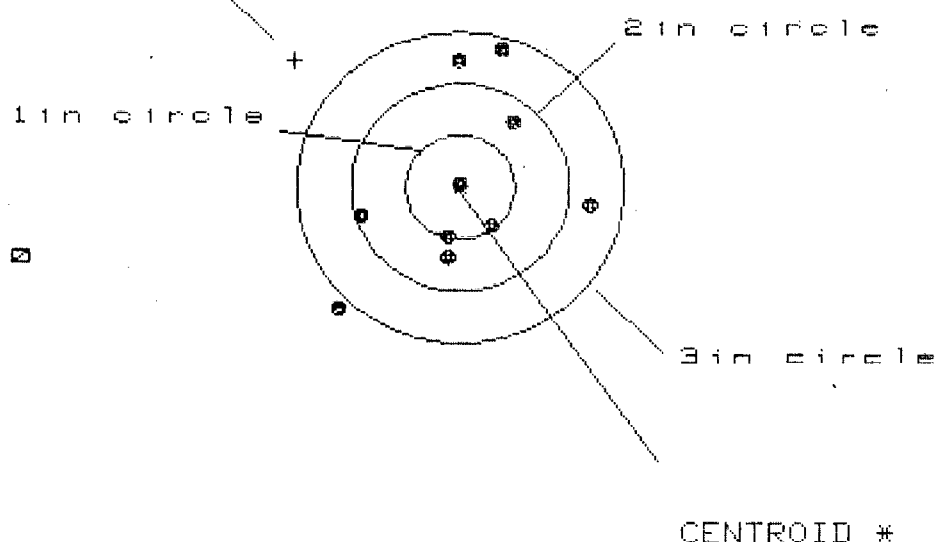
| PATTERN #                   | : | 2      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | .818   | .630   | .694   |
| MINIMUM X                   | : | -1.685 | -.526  | -.462  |
| MAXIMUM Y                   | : | .724   | .759   | .645   |
| MINIMUM Y                   | : | -1.055 | -1.020 | -1.133 |
| CENTROID X                  | : | 1.010  | 1.198  | 1.134  |
| CENTROID Y                  | : | -.352  | -.387  | -.274  |
| POA TO CENTROID in.         | : | 1.070  | 1.259  | 1.166  |
| MIN RADIUS                  | : | .313   | .199   | .248   |
| MEAN RADIUS                 | : | .765   | .630   | .566   |
| MAX RADIUS                  | : | 1.715  | 1.071  | 1.163  |
| HORIZONTAL SPREAD           | : | 2.503  | 1.156  | 1.156  |
| VERTICAL SPREAD             | : | 1.779  | 1.779  | 1.779  |
| EXTREME SPREAD              | : | 2.695  | 1.962  | 1.790  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/06225332

# CENTERFIRE PATTERNS # 3

POA



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.371

VS= 2.454

GS= 2.899

| PATTERN #                     | 3      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.211  | 1.082  | 1.113  |
| MINIMUM X                     | -1.160 | -1.083 | -1.051 |
| MAXIMUM Y                     | 1.301  | 1.172  | 1.289  |
| MINIMUM Y                     | -1.153 | -.836  | -.689  |
| CENTROID X                    | 1.511  | 1.640  | 1.609  |
| CENTROID Y                    | -1.230 | -1.101 | -1.248 |
| POA TO CENTROID in.           | 1.948  | 1.976  | 2.036  |
| MIN RADIUS                    | .043   | .199   | .141   |
| MEAN RADIUS                   | .902   | .836   | .755   |
| MAX RADIUS                    | 1.636  | 1.200  | 1.298  |
| HORIZONTAL SPREAD             | 2.371  | 2.165  | 2.165  |
| VERTICAL SPREAD               | 2.454  | 2.008  | 1.978  |
| EXTREME SPREAD                | 2.899  | 2.168  | 2.168  |
| NUMBER IN ONE INCH CIRCLE =   | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 5      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

12 Oct 1988

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# CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID \*

# OF SHOTS = 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.912

VS = 2.834

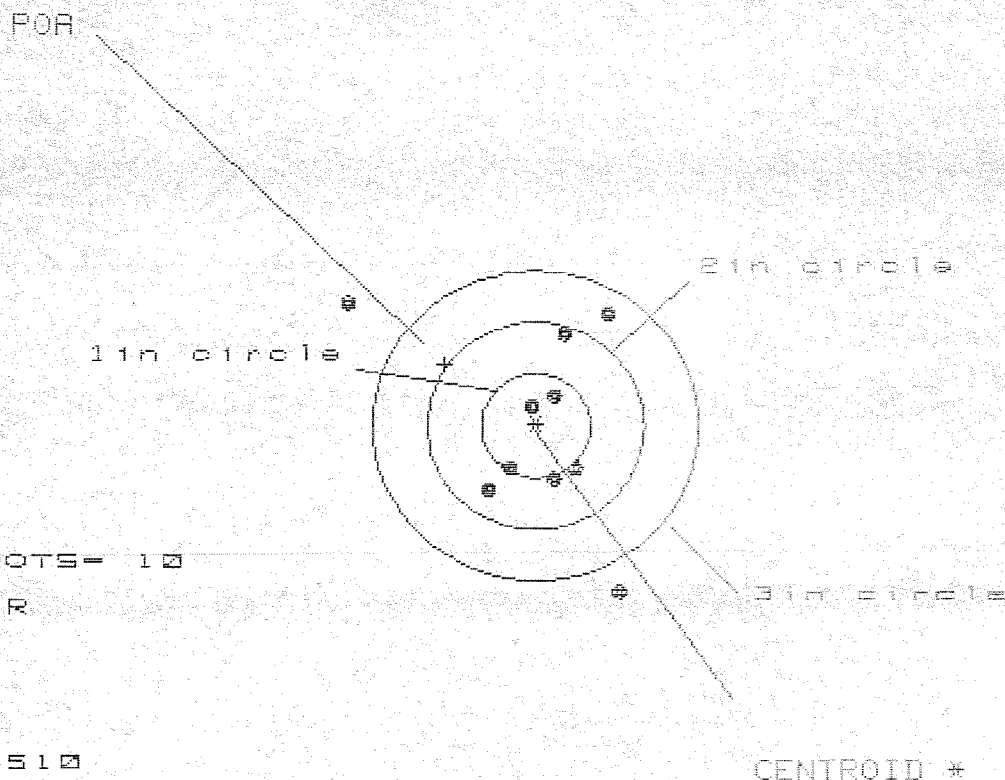
GS = 3.000

| PATTERN #                   | : | 4      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.091  | 1.130  | 1.057 |
| MINIMUM X                   | : | -.822  | -.782  | -.855 |
| MAXIMUM Y                   | : | 1.594  | 1.268  | 1.135 |
| MINIMUM Y                   | : | -1.240 | -1.063 | -.698 |
| CENTROID X                  | : | .958   | .918   | .991  |
| CENTROID Y                  | : | -.477  | -.654  | -.521 |
| POA TO CENTROID in.         | : | 1.070  | 1.127  | 1.120 |
| MIN RADIUS                  | : | .398   | .373   | .426  |
| MEAN RADIUS                 | : | .914   | .807   | .759  |
| MAX RADIUS                  | : | 1.634  | 1.341  | 1.210 |
| HORIZONTAL SPREAD           | : | 1.912  | 1.912  | 1.912 |
| VERTICAL SPREAD             | : | 2.834  | 2.331  | 1.833 |
| EXTREME SPREAD              | : | 3.000  | 2.477  | 2.249 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE\_PATT/C8225332

# CENTERFIRE PATTERNS # 5



# OF SHOTS = 10

# IN CIR

1in = 3

2in = 7

3in = 8

HS = 2.510

VS = 2.863

GS = 3.807

| PATTERN #                     | : | 5      |        |       |
|-------------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | .800   | .610   | .574  |
| MINIMUM X                     | : | -1.710 | -.618  | -.542 |
| MAXIMUM Y                     | : | 1.215  | 1.175  | .986  |
| MINIMUM Y                     | : | -1.648 | -1.513 | -.682 |
| CENTROID X                    | : | .833   | 1.023  | .947  |
| CENTROID Y                    | : | -.590  | -.725  | -.536 |
| POA TO CENTROID in.           | : | 1.021  | 1.254  | 1.088 |
| MIN RADIUS                    | : | .186   | .298   | .204  |
| MEAN RADIUS                   | : | .896   | .755   | .626  |
| MAX RADIUS                    | : | 2.098  | 1.631  | 1.141 |
| HORIZONTAL SPREAD             | : | 2.510  | 1.228  | 1.116 |
| VERTICAL SPREAD               | : | 2.863  | 2.688  | 1.668 |
| EXTREME SPREAD                | : | 3.807  | 2.690  | 2.007 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |       |