

C6225297

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

* Includes 1 in chamber.

Remington

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225297*

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

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/7/88	AW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/7/88	AW
	C) Inspect Ejector Hole for Chamfer		9/7/88	AW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/7/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		7/28/88	JS
	F) Safety on Force	5.5 6 5.5	7/28/88	JS
	G) Safety off Force	3.5 3.5 3.5	7/28/88	JS
	H) Trigger Pull Test & Retainability		7/28/88	JS
	I) Firing Pin Indent	.022 .022 .022	7/28/88	JS
	J) Assemble Stock		9/16/88	RW
	K) Assemble Swivel Studs		10-12-88	JS
	L) Attach Front & Rear Sight Assemblies		9/16/88	RW
	M) Iron Sight Alignment		9/16/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/16/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times		10-5-88	JS
640	Gallery Target & Test	63 R 92L	10-8-88	DH
	A) Optical Clarity of Scope		10-8-88	DH
645	Inspect for Live Ammo		10-8-88	DH
655	Final Inspection			
	A) Headspace		10-12-88	JS
	B) Trigger Pull		10-14-88	JS
	C) Function		10-12-88	JS
660	Pack		10-21-88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225297

DATE 7 Sept. 88

TESTER LS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.42	2.42	2.60	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.43	2.48	2.60	
PULL #3	2.59	2.52	2.42	2.50	
PULL #4	2.60	2.47	2.47	2.51	
PULL #5	2.59	2.50	2.48	2.50	
TOTAL	12.99	12.34	12.27	12.71	
AVG.	2.598	2.468	2.454	2.542	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.11		
PULL #2	3.21	3.10		
PULL #3	3.15	3.15		
PULL #4	3.19	3.20		
PULL #5	3.20	3.24		
TOTAL	15.96	15.80		
AVG.	3.192	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.08		4.12
PULL #2	4.19	4.05		4.18
PULL #3	4.19	4.04		4.17
PULL #4	4.18	4.05		4.19
PULL #5	4.17	4.00		4.19
TOTAL	20.93	20.22		20.85
AVG.	4.186	4.044		4.17

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225297

CENTROIDAL DISTANCES

0 TO	1	1.47478
1 TO	2	.249722
1 TO	3	.635492
1 TO	4	.450245
1 TO	5	1.55633

3 1/2
4

5 + <----POA

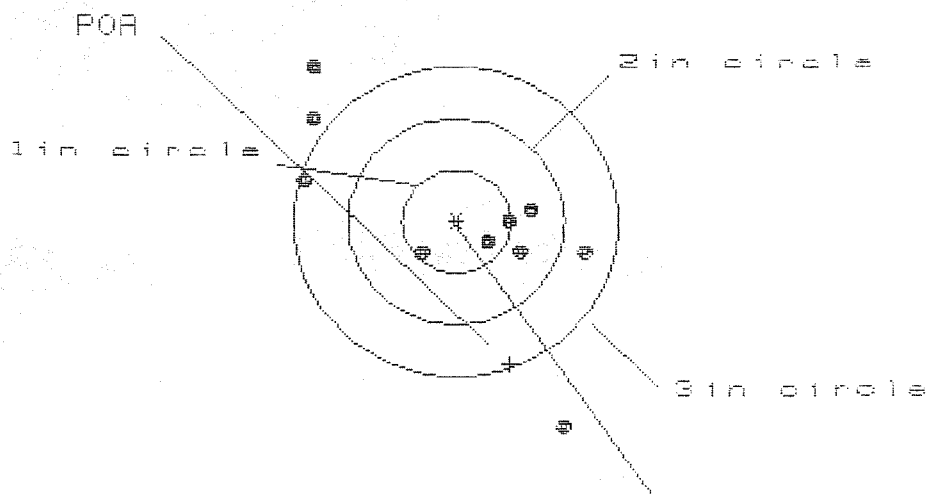
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.5654
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8826
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.04817

THE AMR FOR THIS RIFLE IS: 1.149

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225297

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

CENTROID #

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.628

VS= 3.454

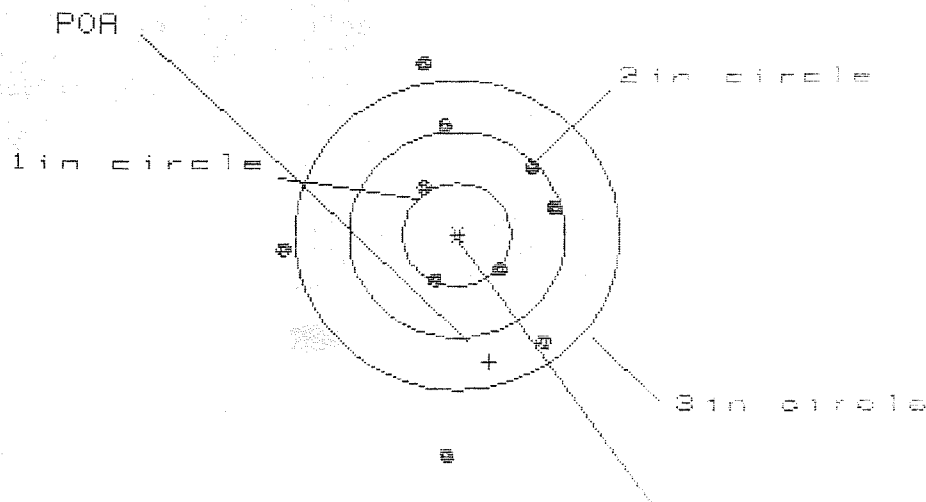
GS= 4.156

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.336	1.190
MINIMUM X	:	-1.407	-1.292	-1.438
MAXIMUM Y	:	1.505	1.288	.977
MINIMUM Y	:	-1.949	-.545	-.384
CENTROID X	:	-.490	-.605	-.459
CENTROID Y	:	1.391	1.608	1.447
POA TO CENTROID in.	:	1.475	1.718	1.518
MIN RADIUS	:	.411	.582	.420
MEAN RADIUS	:	1.126	1.047	.884
MAX RADIUS	:	2.207	1.734	1.667
HORIZONTAL SPREAD	:	2.628	2.628	2.628
VERTICAL SPREAD	:	3.454	1.833	1.361
EXTREME SPREAD	:	4.156	3.073	2.863
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/8225297

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS = 2.511

VS = 3.815

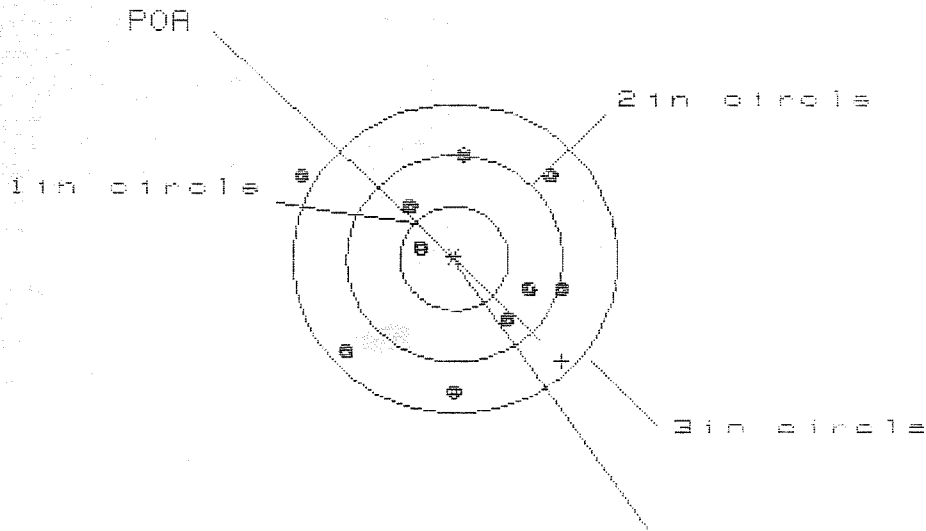
GS = 3.823

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.872	.862	.820
MINIMUM X	-1.639	-1.649	-1.691
MAXIMUM Y	1.706	1.471	.982
MINIMUM Y	-2.109	-1.311	-1.127
CENTROID X	-1.295	-1.285	-1.243
CENTROID Y	1.235	1.470	1.286
POA TO CENTROID in.	1.270	1.497	1.308
MIN RADIUS	.494	.338	.495
MEAN RADIUS	1.118	.986	.911
MAX RADIUS	2.111	1.684	1.699
HORIZONTAL SPREAD	2.511	2.511	2.511
VERTICAL SPREAD	3.815	2.782	2.109
EXTREME SPREAD	3.823	2.989	2.591
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225297

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.436

VS= 2.278

GS= 2.695

CENTROID #

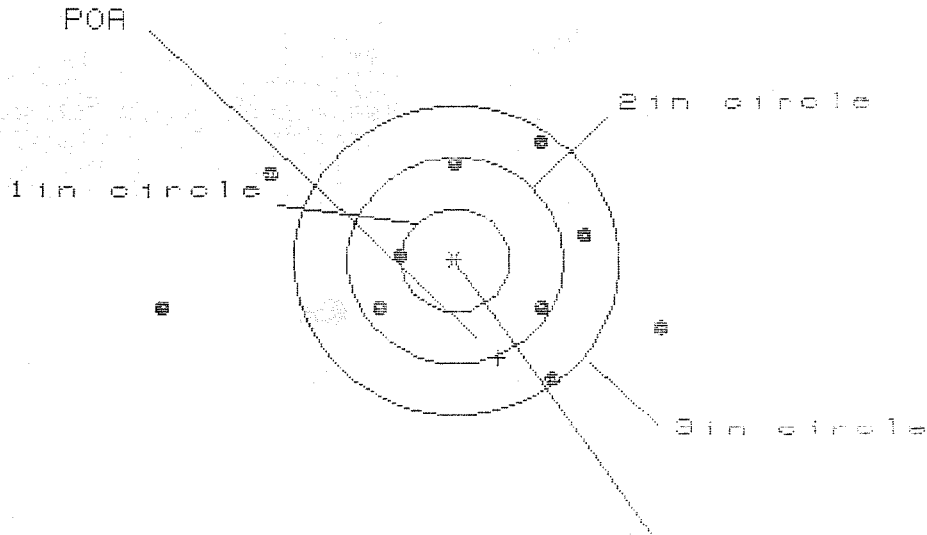
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.009	.850	.703
MINIMUM X	:	-1.427	-1.181	-.690
MAXIMUM Y	:	1.028	1.122	1.026
MINIMUM Y	:	-1.250	-1.156	-1.252
CENTROID X	:	-.983	-.824	-.677
CENTROID Y	:	.990	.896	.992
POA TO CENTROID in.	:	1.395	1.217	1.201
MIN RADIUS	:	.308	.488	.454
MEAN RADIUS	:	1.003	.915	.838
MAX RADIUS	:	1.662	1.408	1.288
HORIZONTAL SPREAD	:	2.436	2.031	1.393
VERTICAL SPREAD	:	2.278	2.278	2.278
EXTREME SPREAD	:	2.695	2.563	2.278
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	9		

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/8225297

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 4.581

VS= 2.332

GS= 4.584

CENTROID #

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.899	1.602	1.092
MINIMUM X	:	-2.682	-1.997	-1.797
MAXIMUM Y	:	1.145	1.095	1.012
MINIMUM Y	:	-1.187	-1.237	-1.320
CENTROID X	:	-0.390	-0.092	-0.292
CENTROID Y	:	0.952	1.002	1.085
POA TO CENTROID in.	:	1.028	1.006	1.124
MIN RADIUS	:	0.474	0.755	0.583
MEAN RADIUS	:	1.391	1.217	1.143
MAX RADIUS	:	2.720	2.141	1.924
HORIZONTAL SPREAD	:	4.581	3.599	2.889
VERTICAL SPREAD	:	2.332	2.332	2.332
EXTREME SPREAD	:	4.584	3.873	3.247
NUMBER IN ONE INCH CIRCLE =	:	1		
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	7		

BBL - 96003

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00009394** Serial: C6225297 Model 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Repairman: Status: New 5/18/00 8:22:52 AM

Verify Repair

Address Information

Customer: Received From Return To: Received From

Name: DEF DIST DEPOT ANNISTON DEF DIST DEPOT ANNISTON

Address 1: Address 2: PO Box: PO Box:

City: ANNISTON ANNISTON

State: AL Zip Code: 36201 4199 Country: US State: AL Zip Code: 36201 4199 Country: US

FFL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Condition: Poor

Condition Notes: CSR Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	2
A008	With Swivel	2
A010	Hard Case	1
A017	Scope Base	1

Repair Search Refresh Close

Start | naglet | 5/18/00 | 12:12 PM | CAPS | NUM | INS | SCFL | 12:12 PM

Inbox... Micro... SAP... Nagle... Audit | R&R... Arms... Prin... Remi...

Serial Number: **C6225297**Model: **700****RE00009394**

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

FINAL Inspection

S.O.:	DATE REC'D:	DATE RET'D:
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AUDITOR: *lw*

Item:

Barrel Assy.

☒ BARREL☒ RECEIVER☒ FRONT SIGHT BLOCK☒ REAR SIGHT BLOCK☒ SCREWS☒ FINISH

Scope Assy.

☐ Scope☐ Scope Rings☐ Mounting Screws☒ Mounting Base☒ Screws☒ Finish☐ Looseness☐ CLARITY

Misc.

☐ DD-250☐ BAR CODE☐ PACKAGING

Item:

Stock Assy.

☒ STOCK☒ SLING SWIVEL STUDS☒ ADJUSTABLE BUTT PLATE☒ LOCK NUTS☒ BARREL CLEARANCE☒ COLOR/FINISH

Systems Case

☐ Scope Case☐ Iron SIGHTS☐ Deployment Kit

Trigger

☒ SAFETY OPERATION☒ SET

Comments:

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225297
18 Jul 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.125$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $.1306$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.18078$

THE AMR FOR THIS RIFLE IS: 1.029

CENTROIDAL DISTANCES

0 TO 1	.343023
1 TO 2	.477326
1 TO 3	.568802
1 TO 4	.474094
1 TO 5	.388

4
5
1 + 2 3 <----POA

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

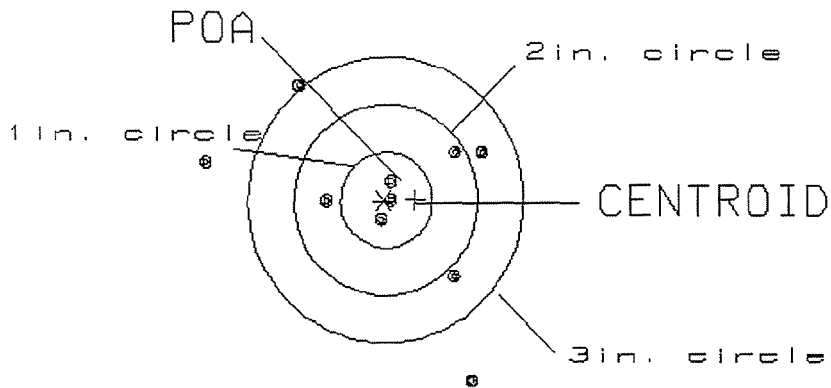
PATTERN #: 1

POA TO CENTROID: .343
 MIN RADIUS : .076
 MEAN RADIUS : .970
 MAX RADIUS : 2.074
 CENTROID X : -.343
 CENTROID Y : -.004

18 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225297.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.99
 VS= 3.01
 GS= 3.68

3
 5
 8

BARBER - M24 0012255

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .162

MIN RADIUS : .307

MEAN RADIUS : 1.085

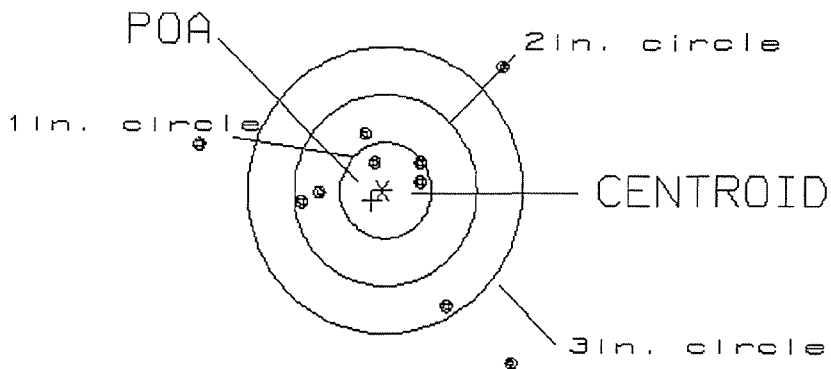
MAX RADIUS : 2.214

CENTROID X : .121

CENTROID Y : .108

18 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225297.1

CENTERFIRE PATTERN # 2

OF SHOTS= 10

IN CIRCLE

H3= 3.31

3

V3= 3.08

6

G3= 4.02

7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

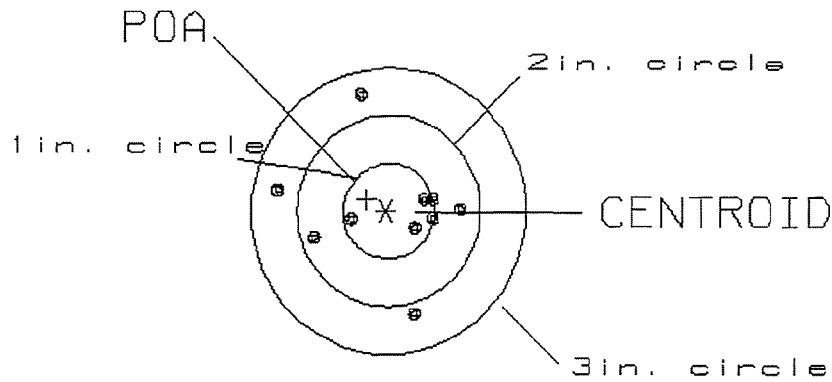
PATTERN #: 3

POA TO CENTROID: .246
 MIN RADIUS : .351
 MEAN RADIUS : .736
 MAX RADIUS : 1.231
 CENTROID X : .213
 CENTROID Y : -.124

18 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c5225297.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.95
 VS= 2.27
 GS= 2.34

4
 7
 10

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

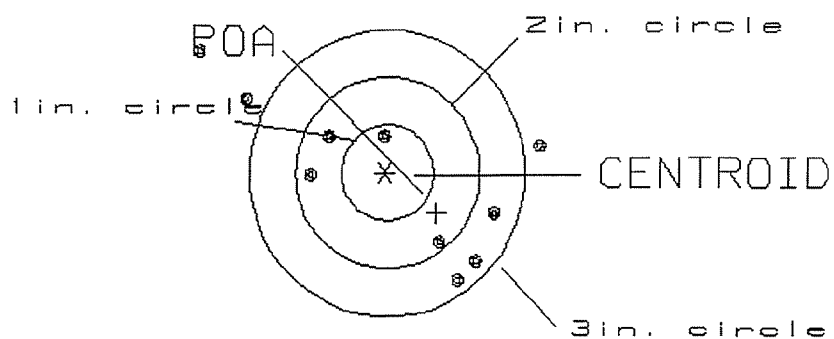
PATTERN #: 4

POA TO CENTROID: .699
 MIN RADIUS : .411
 MEAN RADIUS : 1.263
 MAX RADIUS : 2.438
 CENTROID X : -.561
 CENTROID Y : .417

18 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c5225297.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.76

1

VS= 2.39

4

GS= 3.90

7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

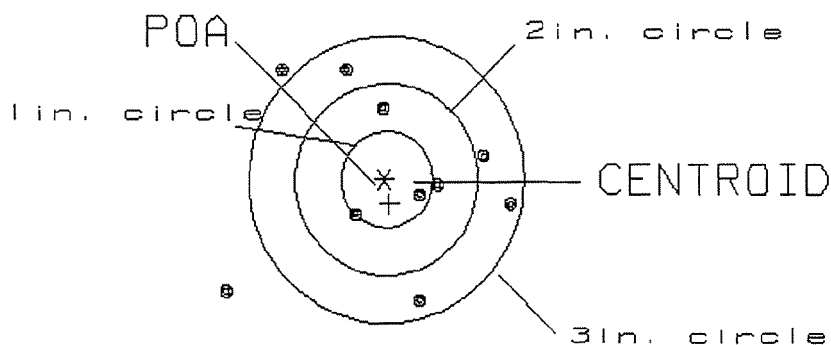
PATTERN #: 5

POA TO CENTROID: .262
 MIN RADIUS : .348
 MEAN RADIUS : 1.091
 MAX RADIUS : 2.055
 CENTROID X : -.055
 CENTROID Y : .256

18 Jul 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225297.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.05

1

VS= 2.49

4

GS= 3.18

8

BARBER - M24 **064223912298**

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225297.___0
FILE DATE AND TIME: 09/26/2007 08:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	0.016
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.835
The Distance from POA to Centroid Target #1:	0.101
The Distance from Centroid Target #2 to Centroid Target #1:	0.050
The Distance from Centroid Target #3 to Centroid Target #1:	0.075
The Distance from Centroid Target #4 to Centroid Target #1:	0.201
The Distance from Centroid Target #5 to Centroid Target #1:	0.140

SERIAL NUMBER: C6225297. 0

TARGET NUMBER: 1

FILE DATE: 09/26/2007

FILE TIME: 08:05

X CENTROID: 0.097

Y CENTROID: 0.028

POA TO CENTROID: 0.101

HORZ SPREAD: 2.594

VERT SPREAD: 1.775

GROUP SPREAD: 2.883

MIN RADIUS: 0.178

MAX RADIUS: 1.605

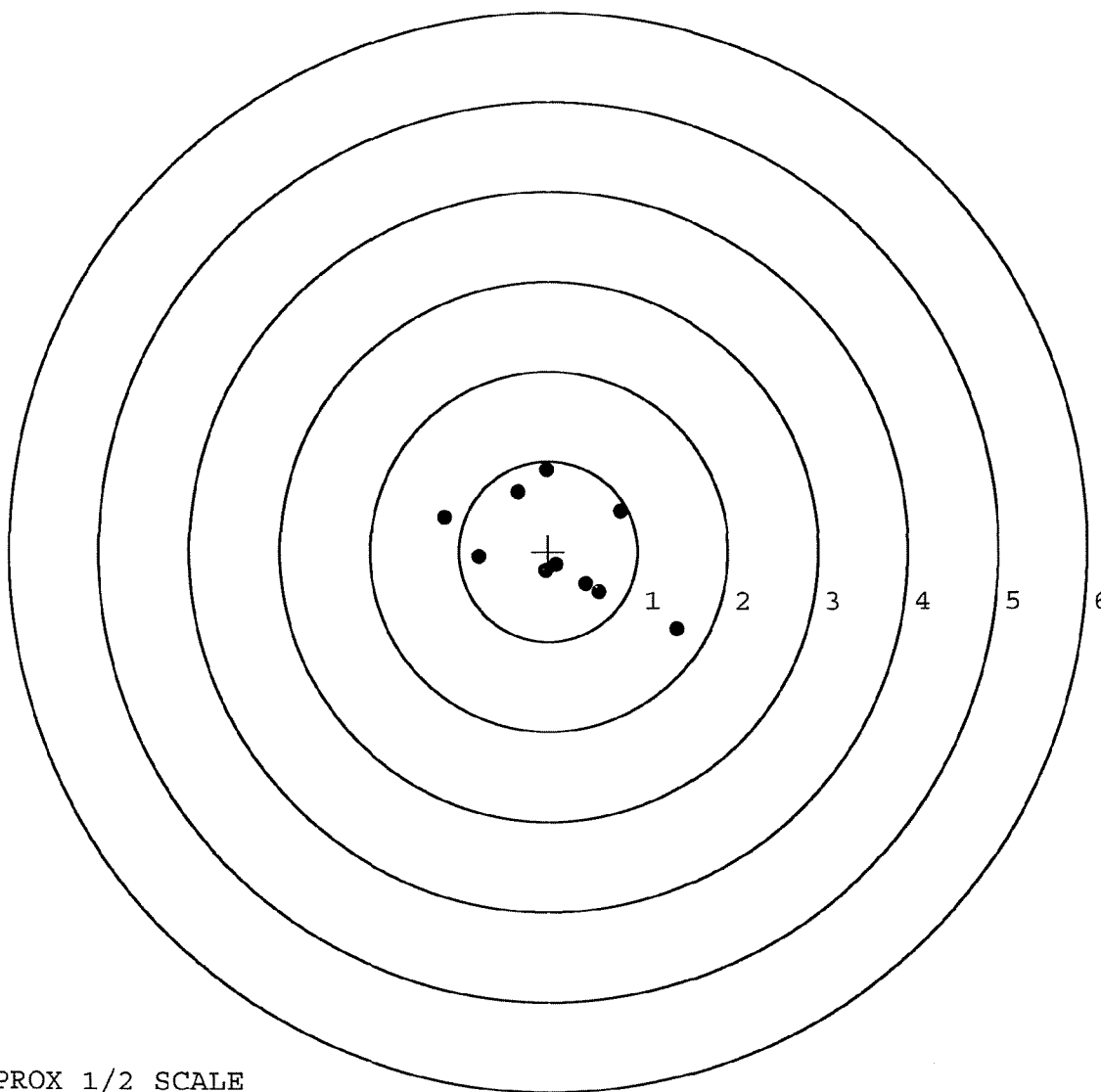
MEAN RADIUS: 0.791

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.017	0.903
2:	-0.344	0.657
3:	0.810	0.445
4:	-1.167	0.385
5:	-0.778	-0.055
6:	1.427	-0.872
7:	0.567	-0.456
8:	-0.032	-0.218
9:	0.087	-0.150
10:	0.421	-0.363

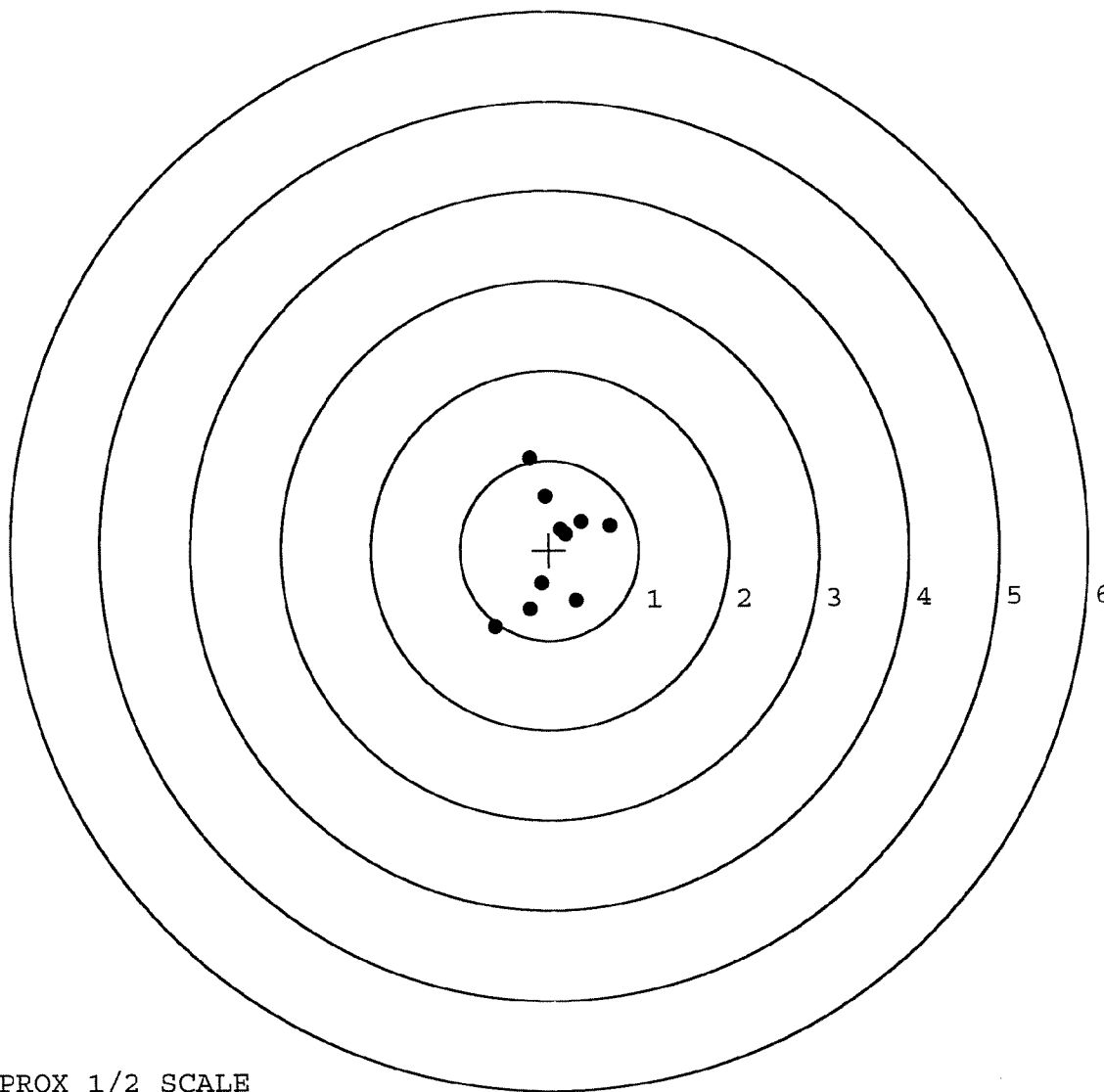


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225297. __0
 TARGET NUMBER: 2
 FILE DATE: 09/26/2007
 FILE TIME: 08:05

POINT#	X	Y
1:	0.189	0.177
2:	-0.614	-0.853
3:	-0.223	-0.655
4:	-0.087	-0.370
5:	0.294	-0.565
6:	0.686	0.272
7:	0.360	0.314
8:	0.132	0.229
9:	-0.041	0.603
10:	-0.209	1.024

X CENTROID: 0.049
 Y CENTROID: 0.018
 POA TO CENTROID: 0.052
 HORZ SPREAD: 1.300
 VERT SPREAD: 1.877
 GROUP SPREAD: 1.920
 MIN RADIUS: 0.212
 MAX RADIUS: 1.094
 MEAN RADIUS: 0.605
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

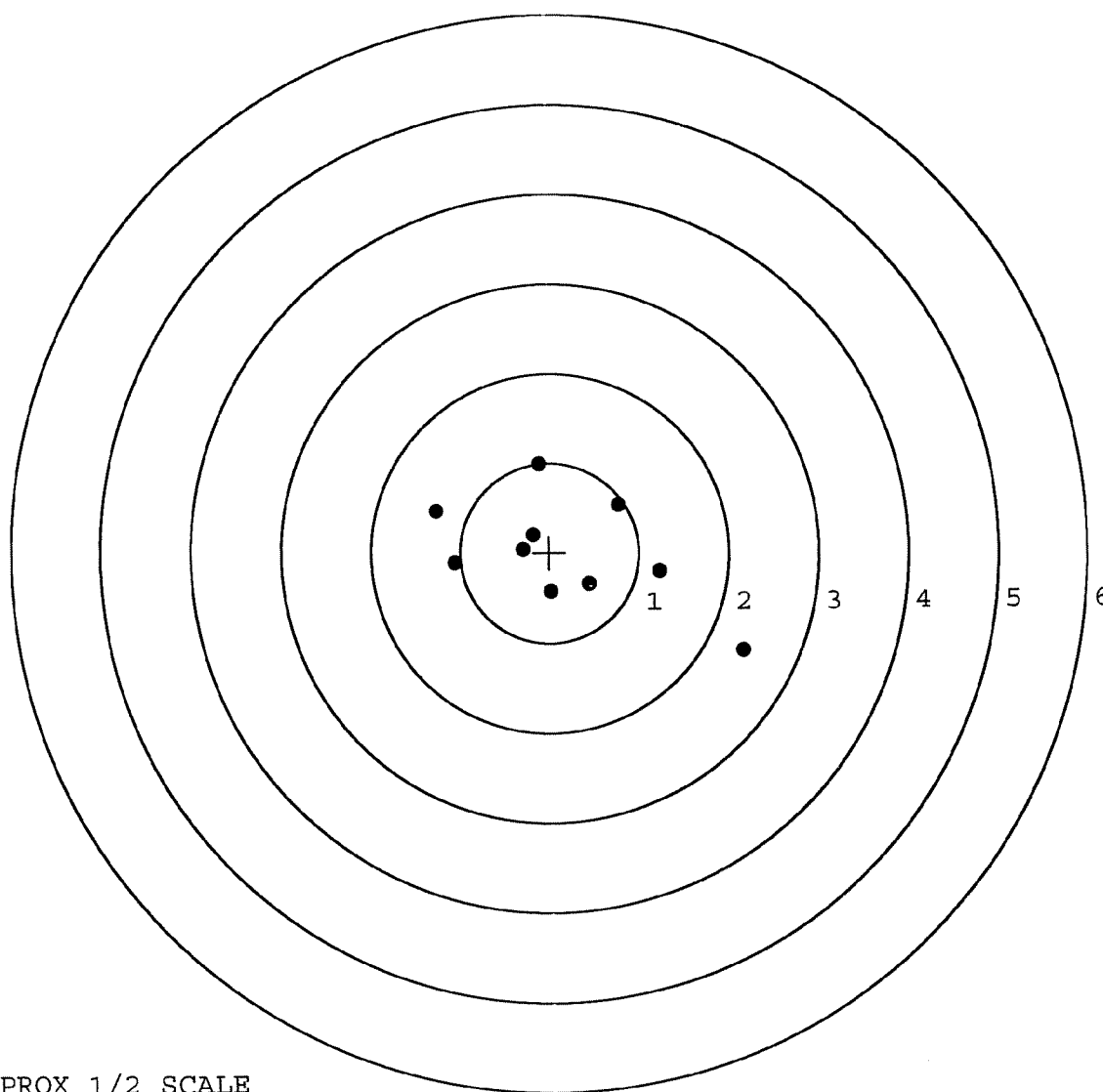


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225297. __0
 TARGET NUMBER: 3
 FILE DATE: 09/26/2007
 FILE TIME: 08:05

POINT#	X	Y
1:	-0.112	0.989
2:	-1.273	0.479
3:	-1.066	-0.109
4:	-0.186	0.199
5:	-0.300	0.038
6:	0.017	-0.437
7:	0.440	-0.349
8:	0.778	0.529
9:	1.227	-0.220
10:	2.151	-1.099

X CENTROID: 0.168
 Y CENTROID: 0.002
 POA TO CENTROID: 0.168
 HORZ SPREAD: 3.424
 VERT SPREAD: 2.088
 GROUP SPREAD: 3.770
 MIN RADIUS: 0.405
 MAX RADIUS: 2.268
 MEAN RADIUS: 0.972
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8

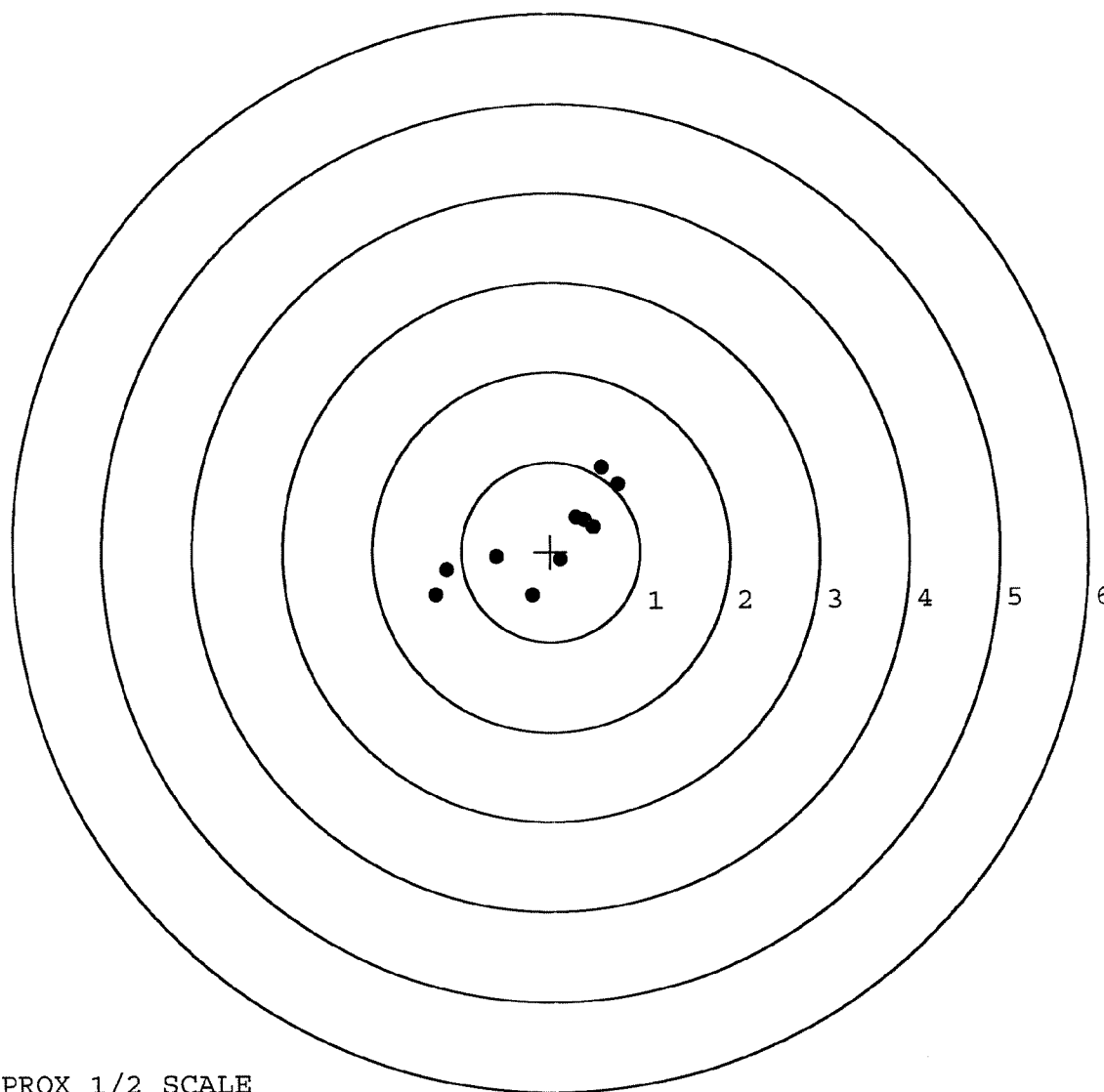


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225297. __0
 TARGET NUMBER: 4
 FILE DATE: 09/26/2007
 FILE TIME: 08:05

POINT#	X	Y
1:	0.758	0.750
2:	0.574	0.939
3:	0.484	0.277
4:	0.288	0.381
5:	0.113	-0.093
6:	-0.213	-0.485
7:	-0.610	-0.058
8:	-1.172	-0.194
9:	-1.298	-0.468
10:	0.384	0.357

X CENTROID: -0.069
 Y CENTROID: 0.141
 POA TO CENTROID: 0.157
 HORZ SPREAD: 2.056
 VERT SPREAD: 1.424
 GROUP SPREAD: 2.390
 MIN RADIUS: 0.296
 MAX RADIUS: 1.371
 MEAN RADIUS: 0.759
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

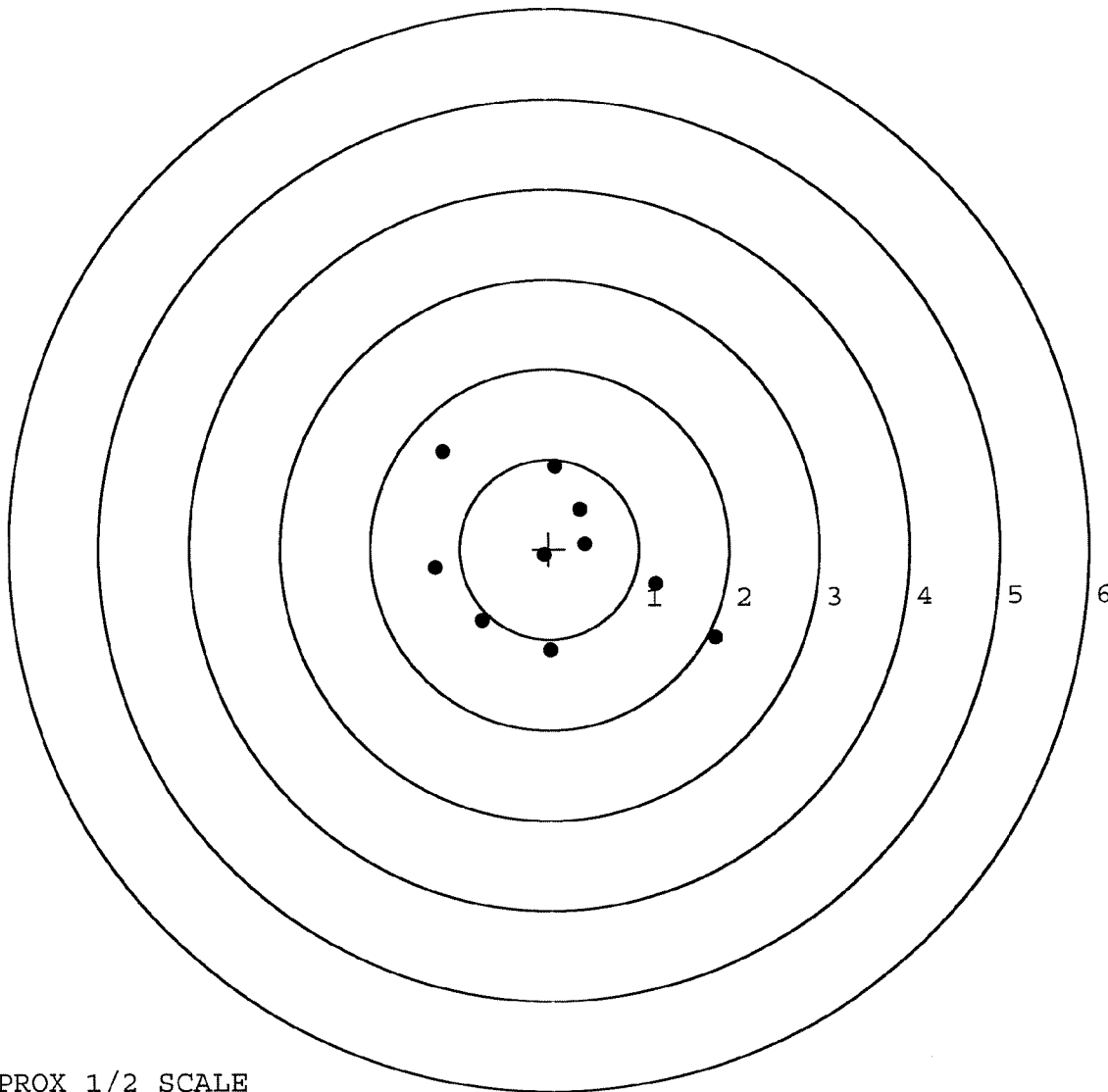


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225297. 0
 TARGET NUMBER: 5
 FILE DATE: 09/26/2007
 FILE TIME: 08:05

POINT#	X	Y
1:	-1.184	1.098
2:	-1.280	-0.201
3:	0.080	0.921
4:	0.348	0.443
5:	0.401	0.059
6:	-0.054	-0.068
7:	-0.754	-0.796
8:	0.008	-1.132
9:	1.184	-0.400
10:	1.835	-0.995

X CENTROID: 0.058
 Y CENTROID: -0.107
 POA TO CENTROID: 0.122
 HORZ SPREAD: 3.115
 VERT SPREAD: 2.230
 GROUP SPREAD: 3.674
 MIN RADIUS: 0.119
 MAX RADIUS: 1.986
 MEAN RADIUS: 1.046
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149R & E NUMBER 131826SERIAL NUMBER C6225297LOG-IN DATE 7-30-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	8-27-07	RJL
505	RE-BARREL	9-14-07	RJL
560	ASSEMBLE	9-14-07	RJL
600	PROOF	9-14-07	mon
605	CHECK HEADSPACE	9-14-07	mon
610	DIS-ASSEMBLE GUN	9-17-07	TRW
612	MAGNAFLUX	9-18-07	TRW
510	DRILL AND TAP	9-17-07	TRW
615	ROLLMARK CALIBER	9-17-07	CW
618	ROTO-BLAST	9-18-07	LS
620	APPLY COATINGS	9-18-07	TRW
625	FINAL ASSEMBLY	9-25-07	RJL
640	FUNCTION TEST AND	9-25-07	mon
650	TARGET	9-25-07	mon
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-25-07	SD
	A) HEADSPACE	9-25-07	mon
	B) TRIGGER PULL	9-25-07	mon
		285 285 2.81 2.92 2.75 9-26-07	DA
680	F) SAFETY ON FORCE	4.5 4.5 4.5 9-26-07	DA
	G) SAFETY OFF FORCE	2.5 2.0 2.0 9-26-07	DA
	I) FIRING PIN INDENT	.0225 .023 .023 9-26-07	DA
690	PACK	10-4-07	DA