

C6225065

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225065*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	<i>1/28/88</i>	<i>KW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>PJC</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>PJC</i>
620	COATING	<i>3/21/88</i>	<i>ISA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225065

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)			
622	Final Assembly A) Clean inside of Bolt Assembly		9/8/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/8/88	RW
	C) Inspect Ejector Hole for Chamfer		9/8/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/8/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		8 Sept 88	D.S. + J.U.
	F) Safety on Force	6 6 6	8 Sept 88	D.S. + J.U.
	G) Safety off Force	3 3 3	8 Sept 88	D.S. + J.U.
	H) Trigger Pull Test & Retainability		8 Sept 88	D.S. + J.U.
	I) Firing Pin Indent	0.022 0.022 0.022	8 Sept 88	D.S. + J.U.
	J) Assemble Stock		9/16/88	RW
	K) Assemble Swivel Studs		10-13-88	JDS
	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	D.S.
640	Gallery Target & Test	47R 108L	10-12-88	AC
	A) Optical Clarity of Scope		10-12-88	D.H.
645	Inspect for Live Ammo		10-12-88	D.H.
655	Final Inspection			
	A) Headspace		10-13-88	JDS
	B) Trigger Pull		10-14-88	JDS
	C) Function		10-13-88	JDS
660	Pack		14 Dec 88	JDS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225065

DATE 8 Sept 88

TESTER J. U. + R. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.20	2.49	2.79	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.30	2.46	2.90	
PULL #3	2.52	2.28	2.44	2.83	
PULL #4	2.62	2.28	2.42	2.61	
PULL #5	2.54	2.36	2.50	2.60	
TOTAL	12.88	11.42	12.31	13.79	
AVG.	2.576	2.284	2.462	2.758	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.33		
PULL #2	3.30	3.34		
PULL #3	3.27	3.33		
PULL #4	3.30	3.33		
PULL #5	3.31	3.37		
TOTAL	16.51	16.70		
AVG.	3.302	3.34		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.17	4.16		4.03
PULL #2	4.16	4.16		4.02
PULL #3	4.17	4.13		4.04
PULL #4	4.18	4.14		4.03
PULL #5	4.18	4.19		4.07
TOTAL	20.86	20.78		20.16
AVG.	4.172	4.156		4.032

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225065

CENTROIDAL DISTANCES

0 TO	1	.232777
1 TO	2	.6364
1 TO	3	.147014
1 TO	4	.266008
1 TO	5	.237699

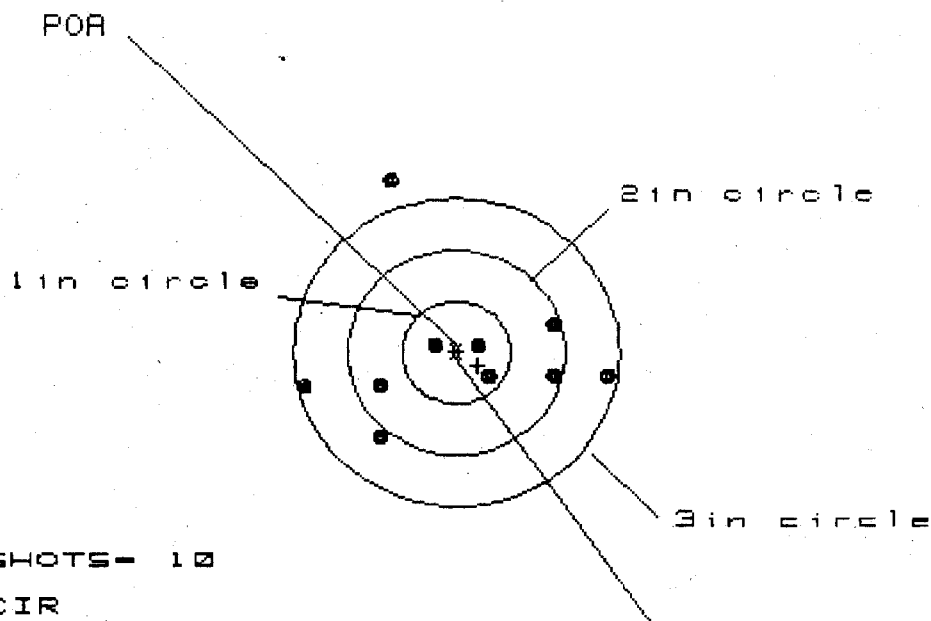
34 ←----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.29
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0544
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .295059
THE AMR FOR THIS RIFLE IS: .9132

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225065

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.800

VS= 2.487

GS= 2.801

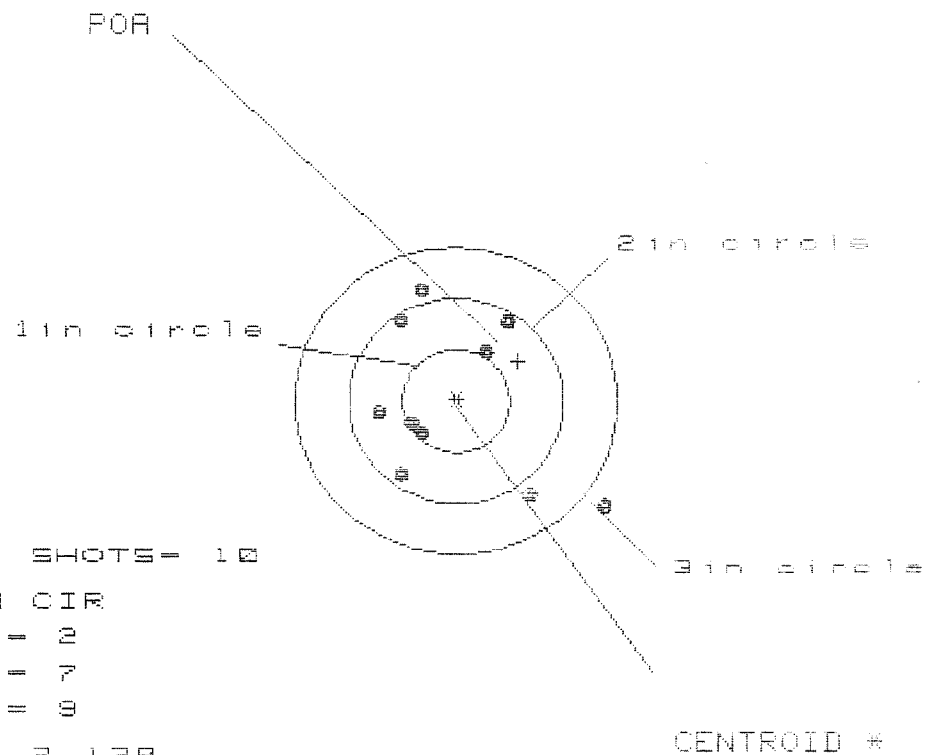
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.358	1.288	1.100
MINIMUM X	-1.442	-1.512	-1.003
MAXIMUM Y	1.667	.504	.490
MINIMUM Y	-.820	-.635	-.649
CENTROID X	-.197	-.127	.061
CENTROID Y	.124	-.061	-.047
POA TO CENTROID in.	.233	.141	.077
MIN RADIUS	.188	.241	.100
MEAN RADIUS	.924	.816	.698
MAX RADIUS	1.780	1.516	1.195
HORIZONTAL SPREAD	2.800	2.800	2.103
VERTICAL SPREAD	2.487	1.139	1.139
EXTREME SPREAD	2.801	2.801	2.189
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225085

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.138

VS = 2.130

GS = 2.786

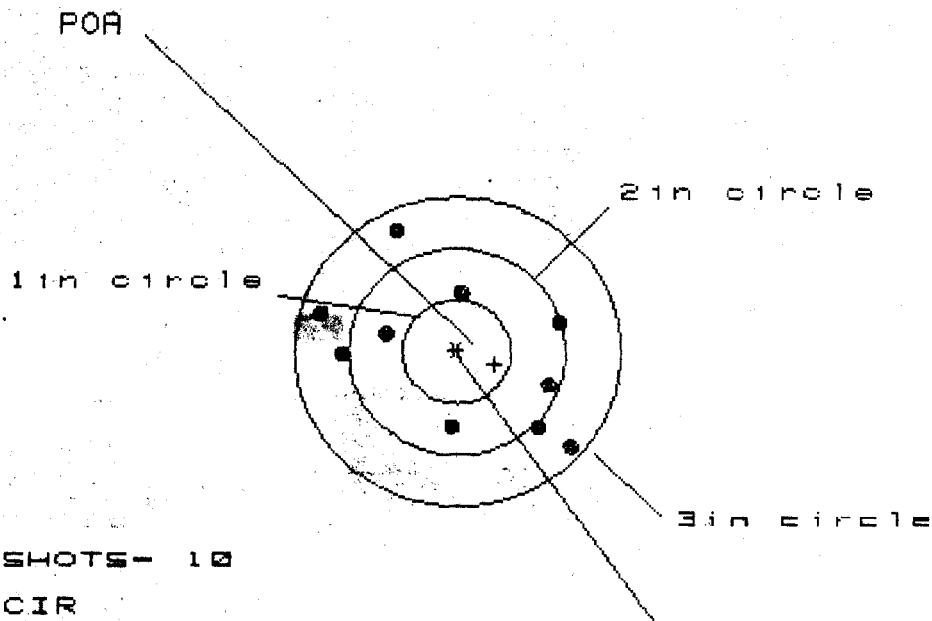
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.426	.866	.840
MINIMUM X	:	-.712	-.553	-.579
MAXIMUM Y	:	1.115	1.002	.825
MINIMUM Y	:	-1.015	-1.024	-.898
CENTROID X	:	-.579	-.738	-.712
CENTROID Y	:	-.385	-.272	-.398
POA TO CENTROID in.	:	.696	.787	.815
MIN RADIUS	:	.434	.381	.313
MEAN RADIUS	:	.909	.784	.740
MAX RADIUS	:	1.751	1.341	1.230
HORIZONTAL SPREAD	:	2.138	1.419	1.419
VERTICAL SPREAD	:	2.130	2.026	1.723
EXTREME SPREAD	:	2.786	2.294	2.140
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE PATT/C6225065

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.341

VS = 2.076

GS = 2.677

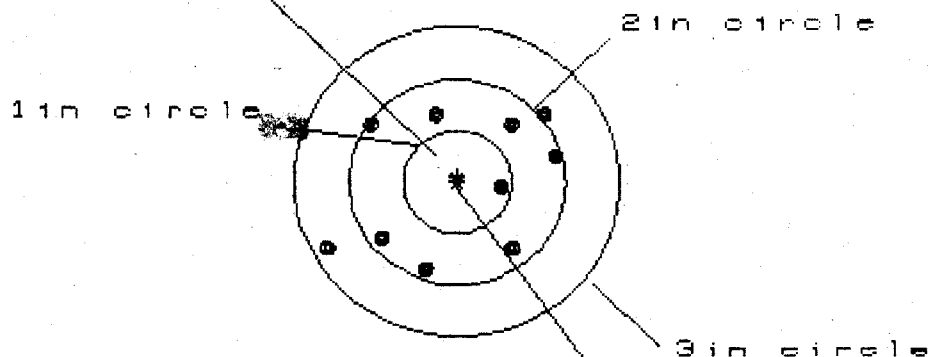
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.077	1.088	.945
MINIMUM X	-1.264	-1.145	-1.057
MAXIMUM Y	1.199	1.102	1.142
MINIMUM Y	-.877	-.824	-.784
CENTROID X	-.344	-.463	-.320
CENTROID Y	.122	.219	.179
POA TO CENTROID in.	.365	.513	.367
MIN RADIUS	.612	.528	.555
MEAN RADIUS	.997	.940	.904
MAX RADIUS	1.389	1.190	1.286
HORIZONTAL SPREAD	2.341	2.233	2.002
VERTICAL SPREAD	2.076	1.926	1.926
EXTREME SPREAD	2.677	2.262	2.262
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225065

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.128

VS= 1.581

GS= 2.405

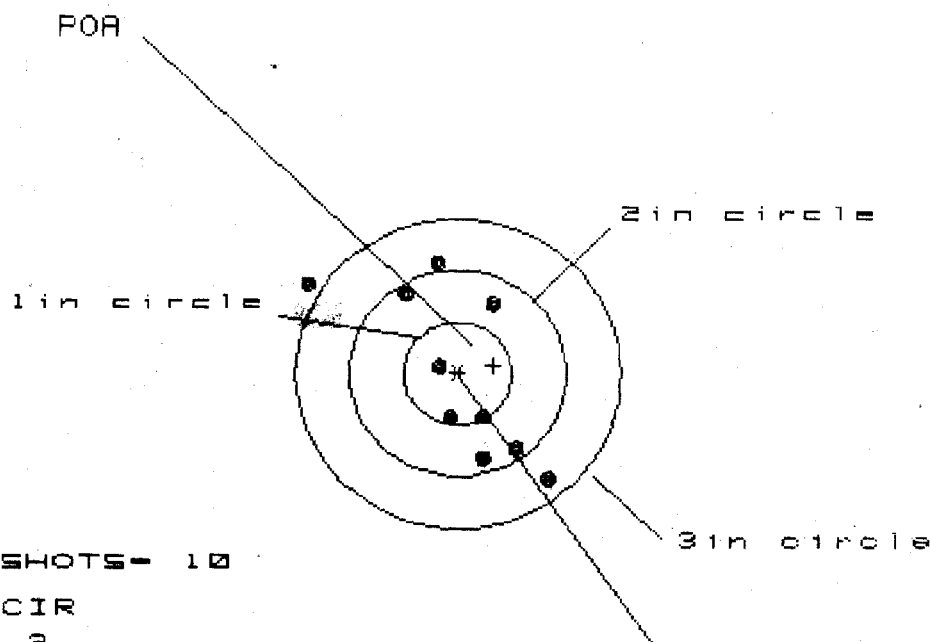
CENTROID *

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.922	.788	.877
MINIMUM X	-1.206	-.980	-.891
MAXIMUM Y	.700	.633	.708
MINIMUM Y	-.881	-.948	-.873
CENTROID X	-.003	.131	.042
CENTROID Y	-.058	.008	-.067
POA TO CENTROID in.	.059	.131	.079
MIN RADIUS	.374	.274	.328
MEAN RADIUS	.884	.809	.798
MAX RADIUS	1.345	1.108	1.070
HORIZONTAL SPREAD	2.128	1.768	1.768
VERTICAL SPREAD	1.581	1.581	1.581
EXTREME SPREAD	2.405	1.897	1.828
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225065

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 2.173

VS = 2.093

GS = 2.848

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.642	.499
MINIMUM X	-1.378	-.597	-.517
MAXIMUM Y	1.083	1.176	1.061
MINIMUM Y	-1.010	-.917	-.851
CENTROID X	-.327	-.174	-.254
CENTROID Y	-.075	-.168	-.053
POA TO CENTROID in.	.335	.241	.259
MIN RADIUS	.149	.328	.208
MEAN RADIUS	.852	.756	.708
MAX RADIUS	1.610	1.211	1.082
HORIZONTAL SPREAD	2.173	1.239	1.016
VERTICAL SPREAD	2.093	2.093	1.912
EXTREME SPREAD	2.848	2.291	1.979
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

BARBER - M24 0048109 PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> <i>WG-10 Bn. Armorer.</i>		1. NO. BOXES <i>1</i>		2a. REQUISITION NO. <i>92061</i> 2b. ORDER NO.	
3. END ITEM <i>7.62mm M24 Sniper Weapons System (SW5)</i>				4. DATE <i>26 July 1994</i> 5. PAGE <i>1</i> OF <i>1</i> PAGES			
BOX NO.	CONTENTS - STOCK NUMBER AND NOMENCLATURE	UNIT OF ISSUE	QUANTITIES REQUIRED				
(a)	(b)	(c)	INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)		
	<i>7.62mm M24 Sniper Weapon System (SW5) Serial No. <u>C6225065</u></i> <i>NSN: 1005-01-240-2136</i> <i>Soft Rifle Carrying Case</i> <i>NSN: 1005-01-262-2818</i> <i>Note: All Optic Scope Ring mounts Packed</i>	<i>Ea</i> <i>Ea</i>			<i>1</i> <i>1</i>		
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES							
TYPED NAME AND TITLE <i>Ray Fuller WG-10 Bn. Armorer</i>			SIGNATURE 				

DD FORM 1750
1 SEP 70

USE TYPEWRITER OR PRINT FIRMLY ON HARD SURFACE WITH HARD PENCIL OR BALLPOINT PEN

DA FORM 2407
MAY 81

EDITION OF JUL 79 IS OBSOLETE

NMP COPY 3

BARBER - M24 ~~0048116~~ **M2400048149**

Final Inspection

In: C6225065 DATE REC'D: 8/1/94 DATE RET'D:
 Auditor: RW

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: _____

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C 6225065

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	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		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER - M24 0048113 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						8/16/99	CCB
	B) Trigger Pull	2.47	2.45	2.66	2.59	2.61	8/16/99	CCB
	C) Function							
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225065
18 Aug 1994

CENTROIDAL DISTANCES

Ø TO 1	.461411
1 TO 2	.362862
1 TO 3	.252161
1 TO 4	.538391
1 TO 5	.518206

 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1782
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1982
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .26653
THE AMR FOR THIS RIFLE IS: .8578

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08225085

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.799

VS = 2.996

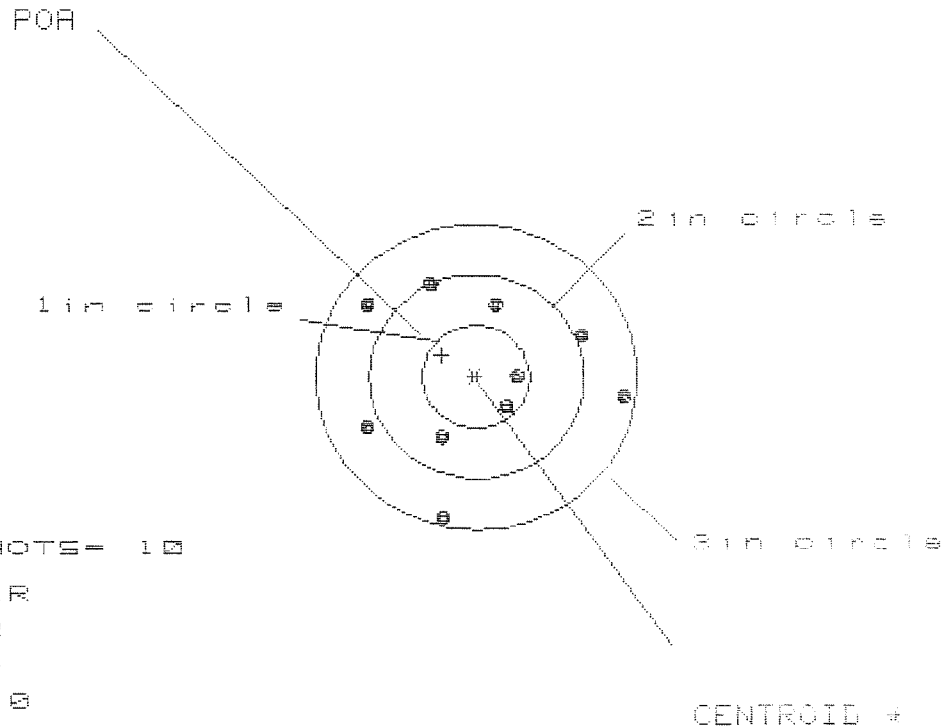
GS = 3.104

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.814	.839	.768
MINIMUM X	-.985	-.960	-1.031
MAXIMUM Y	1.362	1.180	.531
MINIMUM Y	-1.634	-.702	-.554
CENTROID X	.056	.031	.102
CENTROID Y	-.458	-.276	-.424
POR TO CENTROID in.	.461	.278	.436
MIN RADIUS	.351	.325	.293
MEAN RADIUS	.880	.775	.694
MAX RADIUS	1.649	1.310	1.176
HORIZONTAL SPREAD	1.799	1.799	1.799
VERTICAL SPREAD	2.996	1.882	1.085
EXTREME SPREAD	3.104	2.017	1.983
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225085

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS = 2.457

VS = 2.273

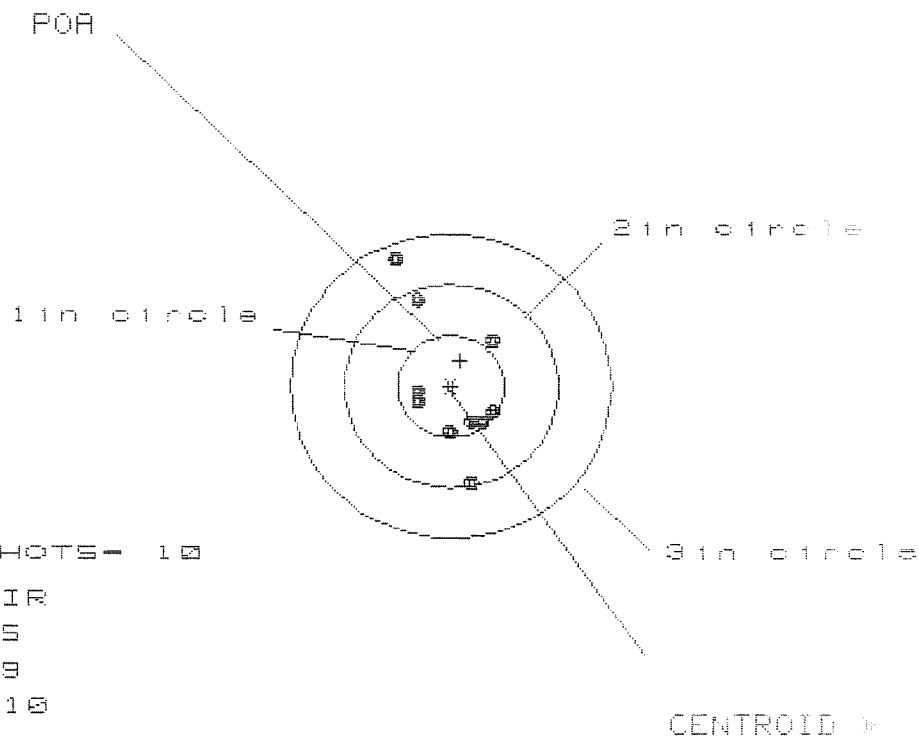
GS = 2.624

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.400	1.113	1.092
MINIMUM X	:	-1.057	-.902	-.923
MAXIMUM Y	:	.925	.903	.732
MINIMUM Y	:	-1.348	-1.370	-.749
CENTROID X	:	.319	.164	.185
CENTROID Y	:	-.208	-.186	-.015
POA TO CENTROID in.	:	.381	.248	.186
MIN RADIUS	:	.352	.506	.508
MEAN RADIUS	:	.940	.892	.822
MAX RADIUS	:	1.413	1.380	1.120
HORIZONTAL SPREAD	:	2.457	2.015	2.015
VERTICAL SPREAD	:	2.273	2.273	1.481
EXTREME SPREAD	:	2.624	2.275	2.139
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			10	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225065

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS= .921

VS= 2.201

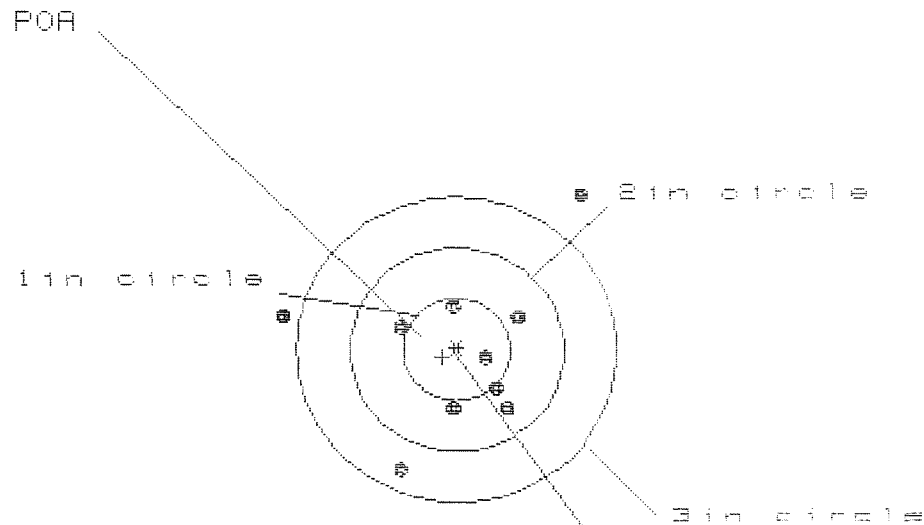
GS= 2.290

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.435	.301	.392
MINIMUM X	:	-.486	-.393	-.382
MAXIMUM Y	:	1.247	.992	.890
MINIMUM Y	:	-.954	-.815	-.874
CENTROID X	:	-.088	-.034	-.046
CENTROID Y	:	-.251	-.390	-.288
POR TO CENTROID in.	:	.266	.391	.291
MIN RADIUS	:	.287	.275	.326
MEAN RADIUS	:	.630	.512	.490
MAX RADIUS	:	1.338	1.055	.956
HORIZONTAL SPREAD	:	.921	.774	.774
VERTICAL SPREAD	:	2.201	1.807	1.264
EXTREME SPREAD	:	2.290	1.863	1.362
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/08280005

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.830

VS= 2.667

CS= 3.195

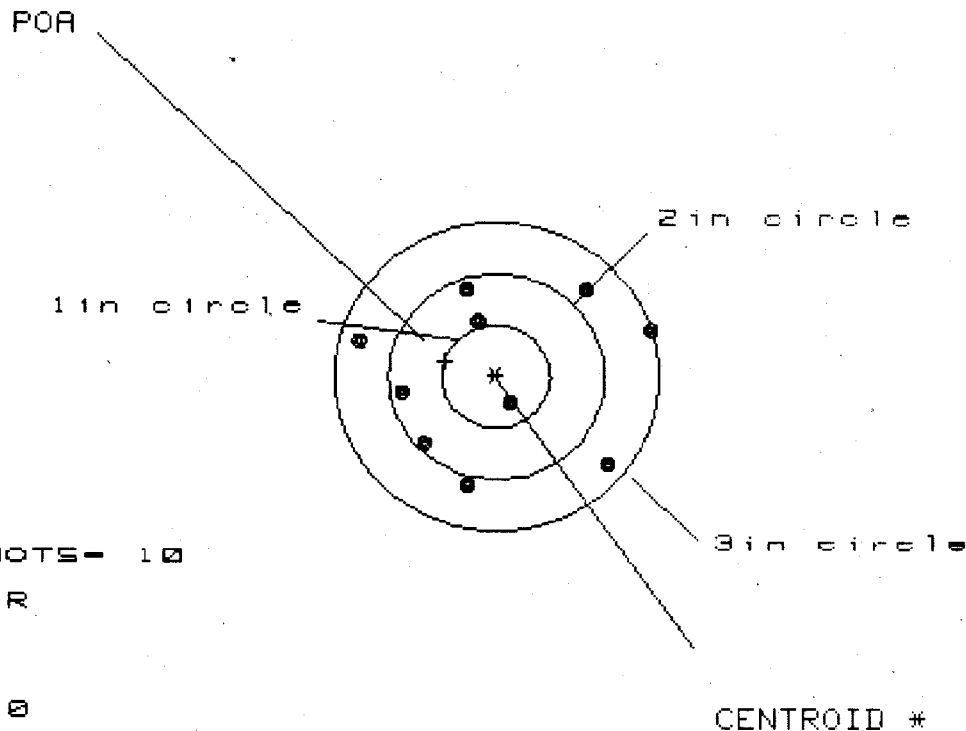
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.200	.653	.466
MINIMUM X	-1.630	-1.496	-.612
MAXIMUM Y	1.517	.545	.607
MINIMUM Y	-1.150	-.982	-.920
CENTROID X	.132	-.002	.185
CENTROID Y	.075	-.093	-.155
POR TO CENTROID in.	.152	.093	.241
MIN RADIUS	.233	.388	.264
MEAN RADIUS	.848	.733	.501
MAX RADIUS	1.934	1.575	1.105
HORIZONTAL SPREAD	2.830	2.149	1.078
VERTICAL SPREAD	2.667	1.527	1.527
EXTREME SPREAD	3.195	2.254	1.814
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225065

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.643

VS= 1.900

GS= 2.648

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.416	1.142	1.110
MINIMUM X	-1.227	-1.070	-.927
MAXIMUM Y	.876	.930	.825
MINIMUM Y	-1.024	-.970	-1.075
CENTROID X	.472	.315	.172
CENTROID Y	-.149	-.203	-.098
POA TO CENTROID in.	.495	.375	.198
MIN RADIUS	.326	.393	.478
MEAN RADIUS	.991	.918	.839
MAX RADIUS	1.497	1.418	1.381
HORIZONTAL SPREAD	2.643	2.212	2.037
VERTICAL SPREAD	1.900	1.900	1.900
EXTREME SPREAD	2.648	2.529	2.173
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		