

NEW ACTION

C6225239

E 6374631

MODEL 700TM M24

Model 700 M24TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M2400011350

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225239

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		7/9/92	RW
600	Proof		7/9/92	RW
607	Check Headspace		7/9/92	RW
610	Dis-assemble Gun		7/9/92	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes		7/9/92	RW
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			

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		7-28-92	A
	A) Time		"	A
	B) Malfunctions		"	A
	C) Pierced Primers		"	A
	D) Optical Clarity of Scope		"	A
645	Inspect for Live Ammo		7-28-92	A
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06225239

29 JUL 1992

CENTROIDAL DISTANCES

0 TO 1	.30024
1 TO 2	.248497
1 TO 3	.62367
1 TO 4	.859745
1 TO 5	.0308058

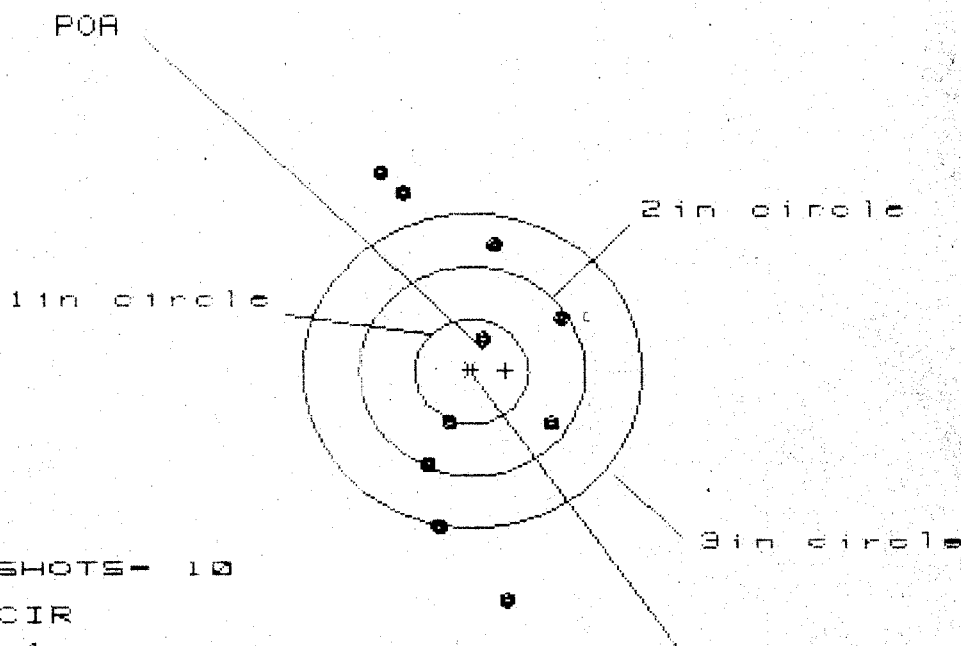
54⁴ ----- FOR
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.9064
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0308
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0393243
THE AMR FOR THIS RIFLE IS: 1.102

28 Jul 1992

FILE://PATTERNING/CENTERFIRE_PATT/06225239

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 1.588

VS= 4.154

GS= 4.292

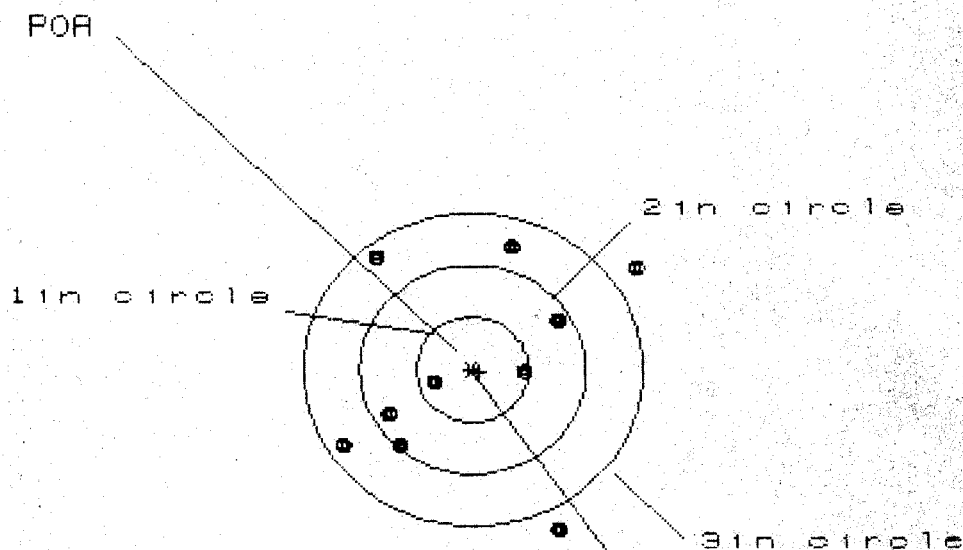
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.812	.845	.752
MINIMUM X	:	-.776	-.743	-.619
MAXIMUM Y	:	1.952	1.707	1.651
MINIMUM Y	:	-2.203	-1.775	-1.562
CENTROID X	:	-.300	-.333	-.240
CENTROID Y	:	-.012	.233	.020
POA TO CENTROID in.	:	.300	.407	.241
MIN RADIUS	:	.354	.190	.305
MEAN RADIUS	:	1.254	1.138	1.021
MAX RADIUS	:	2.223	1.861	1.764
HORIZONTAL SPREAD	:	1.588	1.588	1.372
VERTICAL SPREAD	:	4.154	3.482	3.213
EXTREME SPREAD	:	4.292	3.515	3.224
NUMBER IN ONE INCH CIRCLE	=	1	5	6
NUMBER IN TWO INCH CIRCLE	=	5	5	6
NUMBER IN THREE INCH CIRCLE	=	6	5	6

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225239

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.575

VS= 2.663

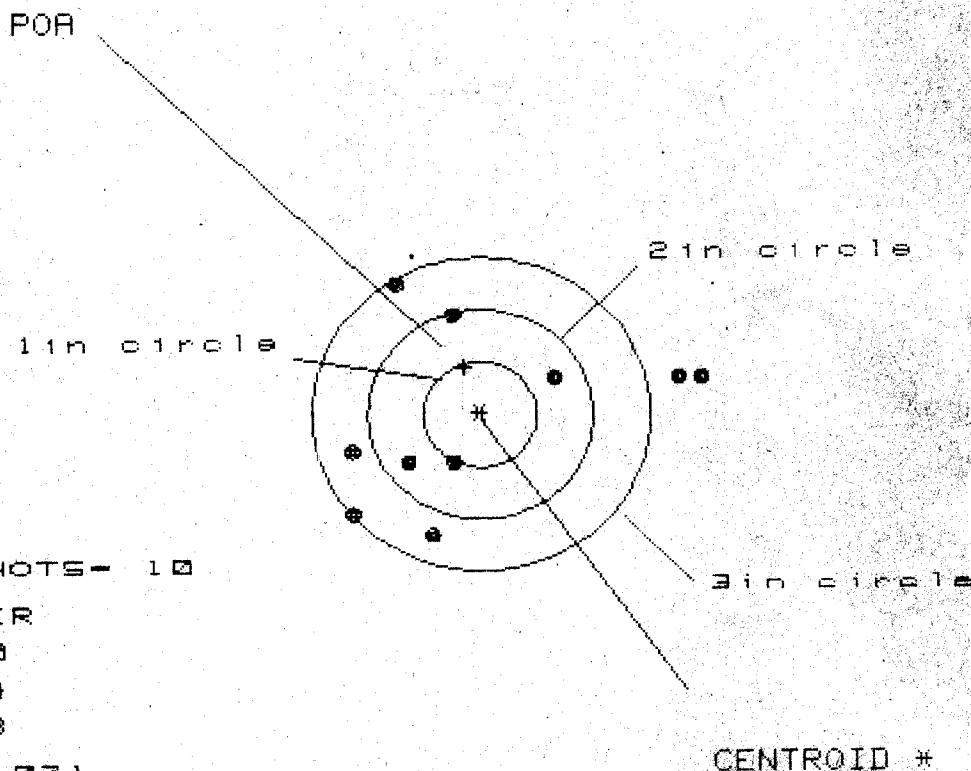
GS= 3.094

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.429	.935	.988
MINIMUM X	:	-1.146	-.987	-.871
MAXIMUM Y	:	1.139	1.244	1.067
MINIMUM Y	:	-1.524	-1.419	-.842
CENTROID X	:	-.056	-.215	-.331
CENTROID Y	:	.023	-.082	.095
POA TO CENTROID in.	:	.060	.230	.345
MIN RADIUS	:	.395	.227	.194
MEAN RADIUS	:	1.096	1.001	.905
MAX RADIUS	:	1.713	1.699	1.263
HORIZONTAL SPREAD	:	2.575	1.922	1.859
VERTICAL SPREAD	:	2.663	2.663	1.989
EXTREME SPREAD	:	3.094	3.071	2.457
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225239

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 3.071

VS= 2.416

GS= 3.315

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.951	1.984	1.166
MINIMUM X	-1.120	-.904	-.656
MAXIMUM Y	1.283	1.322	1.371
MINIMUM Y	-1.133	-1.094	-1.045
CENTROID X	.140	-.076	-.324
CENTROID Y	-.454	-.493	-.542
POA TO CENTROID in.	.475	.499	.632
MIN RADIUS	.542	.428	.388
MEAN RADIUS	1.213	1.083	.916
MAX RADIUS	1.982	2.023	1.381
HORIZONTAL SPREAD	3.071	2.888	1.822
VERTICAL SPREAD	2.416	2.416	2.416
EXTREME SPREAD	3.315	3.150	2.435
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

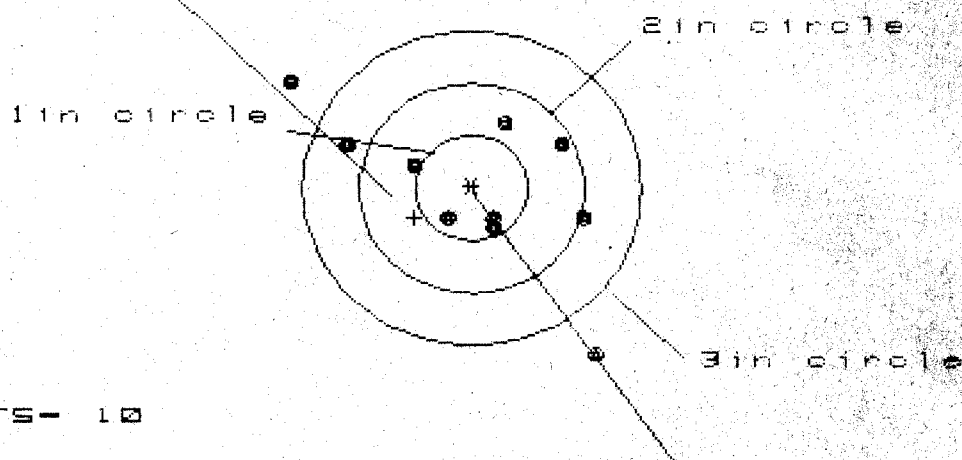
28 Jul 1932

FILE:/PATTERNING/CENTERFIRE_PATT/C6225239

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.676

VS= 2.608

GS= 3.737

CENTROID #

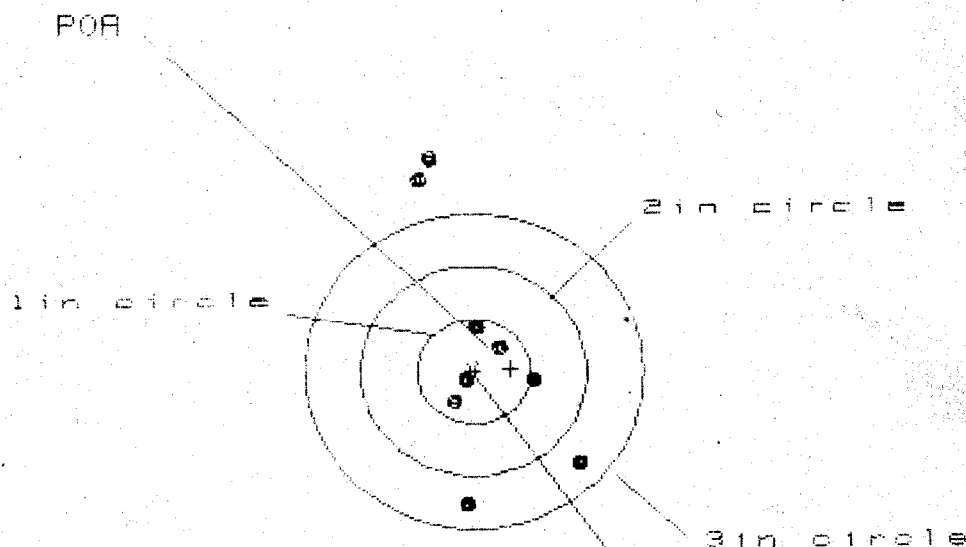
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.069	1.069	.883
MINIMUM X	:	-1.607	-1.489	-1.191
MAXIMUM Y	:	1.007	.829	.580
MINIMUM Y	:	-1.601	-.511	-.407
CENTROID X	:	.509	.391	.577
CENTROID Y	:	.279	.457	.353
POA TO CENTROID in.	:	.581	.601	.676
MIN RADIUS	:	.340	.425	.408
MEAN RADIUS	:	.931	.836	.690
MAX RADIUS	:	1.925	1.704	1.249
HORIZONTAL SPREAD	:	2.676	2.558	2.074
VERTICAL SPREAD	:	2.608	1.340	.987
EXTREME SPREAD	:	3.737	2.846	2.187
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/08225239

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 1.564

VS= 3.875

GS= 3.884

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.968	.932	.853
MINIMUM X	-.596	-.632	-.562
MAXIMUM Y	2.056	2.027	1.829
MINIMUM Y	-1.819	-1.591	-1.263
CENTROID X	-.325	-.289	-.210
CENTROID Y	-.030	-.258	-.060
POA TO CENTROID in.	.327	.388	.218
MIN RADIUS	.154	.182	.230
MEAN RADIUS	1.015	.889	.762
MAX RADIUS	2.082	2.084	1.913
HORIZONTAL SPREAD	1.564	1.564	1.415
VERTICAL SPREAD	3.875	3.618	3.092
EXTREME SPREAD	3.884	3.621	3.115
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature:

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 007080DATE 6/20/92

CUSTOMER NAME:

DAVID HUSKINS

REMINGTON EMPLOYEE:

ADDRESS:

COMPANY DYES ☐ NO ☒2ND BTL. 1ST SGT

EMPLOYEE # _____

FT. BRAGG, N.C.

DEPT. # _____

919-432-9037

ZIP:

PHONE:

919-432-9037

FIREARM

MODEL:

M24

CHECK FOR AMMUNITION

GAUGE:

.762

SERIAL #

C 622 5239

CONDITION:

SYNTHETIC
~~WOOD~~

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES:

881024

SCOPE:

YES

NO

(BRAND NAME/POWER)

M 3A-10

SLING: YES

NOSCOPE

GUN CASE:

YES

NO

(HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE:

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST:

RE BARRELED

SIGNATURE:

David E. Huskins

(Person delivering firearm to Plant)

DATE:

6/20/92

SIGNATURE:

[Signature]

(Security Officer)

DATE:

6/20/92

SIGNATURE:

[Signature]

(Firearm picked up by)

DATE:

6/22/92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 6225239

CENTROIDAL DISTANCES

0 TO	1	.993419
1 TO	2	.286698
1 TO	3	.617768
1 TO	4	.375366
1 TO	5	.241448

+ <----POA
4
215
3

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .532
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.8804
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.02865

THE AMR FOR THIS RIFLE IS: 1.012

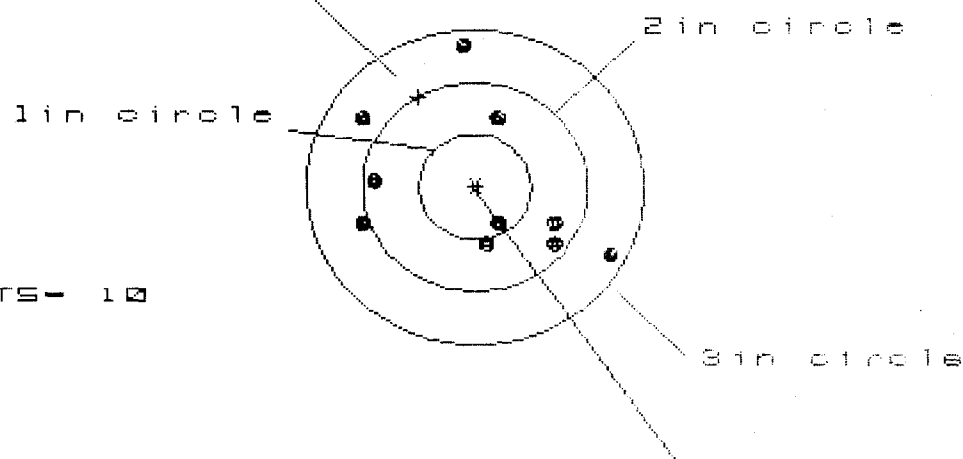
11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225239

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.199

VS= 1.962

GS= 2.494

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.176	1.162	.840
MINIMUM X	-1.023	-1.037	-.892
MAXIMUM Y	1.371	.841	.787
MINIMUM Y	-.591	-.439	-.477
CENTROID X	.499	.513	.368
CENTROID Y	-.859	-1.011	-.957
POA TO CENTROID in.	.994	1.134	1.025
MIN RADIUS	.386	.250	.393
MEAN RADIUS	.923	.842	.807
MAX RADIUS	1.377	1.279	1.132
HORIZONTAL SPREAD	2.199	2.199	1.732
VERTICAL SPREAD	1.962	1.280	1.264
EXTREME SPREAD	2.494	2.494	2.090
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

11 Oct 1988

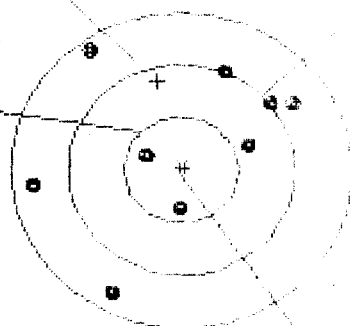
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CENTERFIRE PATTERNS

2

POA

1 in circle



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 3

3 in - 9

HS- 2.297

VS- 3.248

GS- 3.446

CENTROID

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.965	1.004	.910
MINIMUM X	:	-1.332	-1.293	-1.387
MAXIMUM Y	:	1.119	.883	.801
MINIMUM Y	:	-2.129	-1.360	-1.250
CENTROID X	:	.213	.174	.268
CENTROID Y	:	-.839	-.603	-.713
POA TO CENTROID in.	:	.866	.627	.762
MIN RADIUS	:	.329	.313	.400
MEAN RADIUS	:	1.066	.923	.879
MAX RADIUS	:	2.158	1.468	1.411
HORIZONTAL SPREAD	:	2.297	2.297	2.237
VERTICAL SPREAD	:	3.248	2.243	2.051
EXTREME SPREAD	:	3.446	2.427	2.427
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

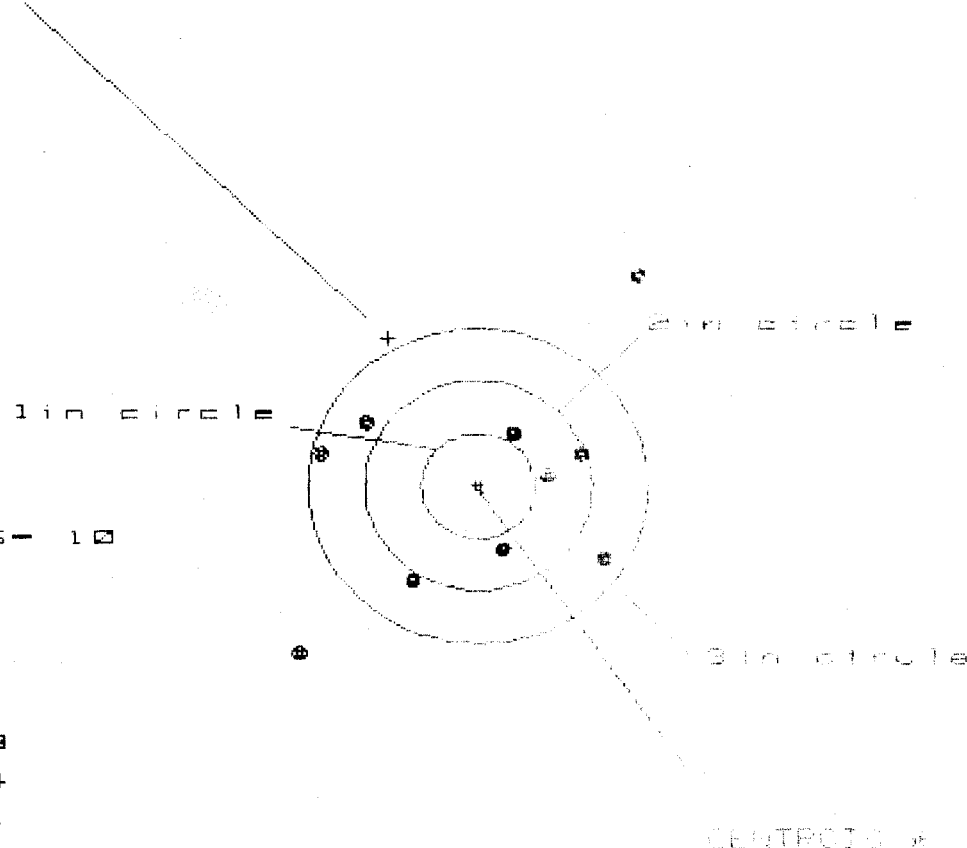
11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT 8225039

CENTERFIRE PATTERNS

3

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.000

VS= 3.574

GS= 4.671

PATTERN #	:	3	9	3
SHOTS (BEST OF)	:	10	9	3
MAXIMUM X	:	1.383	1.260	1.076
MINIMUM X	:	-1.625	-1.471	-1.449
MAXIMUM Y	:	2.003	.798	.630
MINIMUM Y	:	-1.571	-1.349	-1.887
CENTROID X	:	.788	.634	.818
CENTROID Y	:	-1.405	-1.627	-1.459
POA TO CENTROID in.	:	1.611	1.747	1.672
MIN RADIUS	:	.645	.555	.613
MEAN RADIUS	:	1.270	1.143	.995
MAX RADIUS	:	2.434	1.996	1.495
HORIZONTAL SPREAD	:	3.008	2.731	2.525
VERTICAL SPREAD	:	3.574	2.147	1.517
EXTREME SPREAD	:	4.671	3.150	2.726
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225239

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in = 8

HS= 2.947

VS= 2.522

GS= 3.147

CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.370	1.110	.932
MINIMUM X	:	-1.577	-1.425	-1.165
MAXIMUM Y	:	1.159	1.048	1.047
MINIMUM Y	:	-1.363	-1.474	-1.475
CENTROID X	:	.425	.273	.451
CENTROID Y	:	-.491	-.381	-.380
POA TO CENTROID in.	:	.650	.468	.590
MIN RADIUS	:	.173	.358	.258
MEAN RADIUS	:	1.113	1.037	.983
MAX RADIUS	:	1.695	1.554	1.508
HORIZONTAL SPREAD	:	2.947	2.535	2.097
VERTICAL SPREAD	:	2.522	2.522	2.522
EXTREME SPREAD	:	3.147	2.731	2.561
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

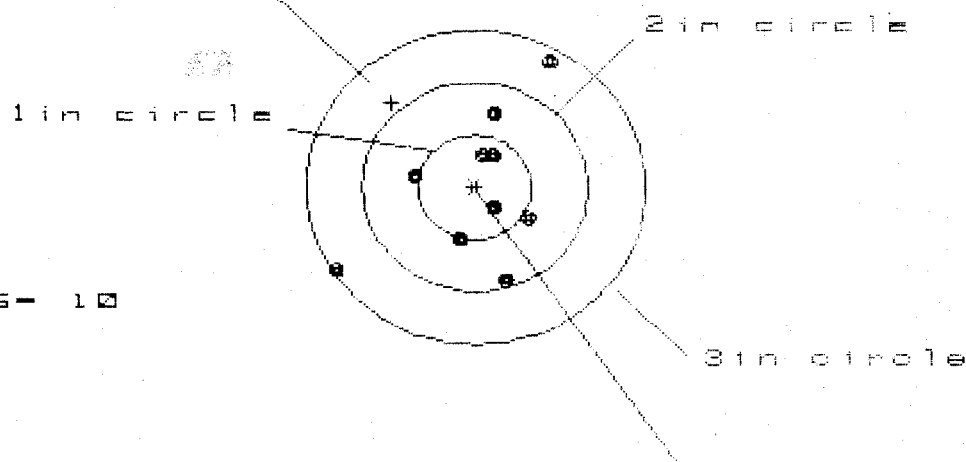
11 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/6225239

CENTERFIRE PATTERNS

5

POA



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.845

VS= 2.090

GS= 2.695

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.623	.487	.375
MINIMUM X	:	-1.222	-.672	-.611
MAXIMUM Y	:	1.202	1.117	.741
MINIMUM Y	:	-.888	-.973	-.834
CENTROID X	:	.735	.871	.810
CENTROID Y	:	-.808	-.723	-.862
POA TO CENTROID in.	:	1.092	1.132	1.183
MIN RADIUS	:	.197	.228	.107
MEAN RADIUS	:	.690	.594	.504
MAX RADIUS	:	1.441	1.218	.864
HORIZONTAL SPREAD	:	1.845	1.159	.986
VERTICAL SPREAD	:	2.090	2.090	1.575
EXTREME SPREAD	:	2.695	2.115	1.579
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6225739

DATE 12 Sept. 88

TESTER J. V. W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.37	2.28	2.24	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.35	2.18	2.27	
PULL #3	2.70	2.32	2.22	2.22	
PULL #4	2.49	2.28	2.24	2.18	
PULL #5	2.71	2.36	2.20	2.20	
TOTAL	12.72	11.68	11.12	11.11	
AVG.	2.544	2.336	2.26	2.222	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.10		
PULL #2	3.17	3.09		
PULL #3	3.07	3.13		
PULL #4	3.15	3.12		
PULL #5	3.20	3.14		
TOTAL	15.85	15.58		
AVG.	3.17	3.116		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	3.96		4.25
PULL #2	4.05	4.01		4.22
PULL #3	4.14	3.94		4.27
PULL #4	4.13	4.04		4.19
PULL #5	4.17	4.01		4.21
TOTAL	20.69	19.96		21.14
AVG.	4.14	3.99		4.23

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225239

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	4/	FB
600	PROOF	2/2/88	AW
615	MAGNAFLUX BARREL	2/18/88	PJC
	MAGNAFLUX BOLT	2/25/88	PJC
620	COATING	3/21/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

Scope # 1172

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225239

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		9/12/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/12/88	RW
	C) Inspect Ejector Hole for Chamfer		9/12/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/12/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		12 Sept 88	Sw u.B.
	F) Safety on Force	$5\frac{3}{4}$ $5\frac{3}{4}$ $5\frac{3}{4}$	12 Sept 88	J.V. u.B.
	G) Safety off Force	3 3 3	12 Sept 88	J.V. u.B.
	H) Trigger Pull Test & Retainability		12 Sept 88	J.V. u.B.
	I) Firing Pin Indent	.071 .0715 .071	12 Sept 88	J.V. u.B.
	J) Assemble Stock		9/15/88	RW
	K) Assemble Swivel Studs		10-12-88	YS
	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	YS
640	Gallery Target & Test	41 R 114 L	10/11/88	DT.
	A) Optical Clarity of Scope		10/11/88	JL
645	Inspect for Live Ammo		10/11/88	JL
655	Final Inspection		10-12-88	YS
	A) Headspace		10-14-88	YS
	B) Trigger Pull		10-12-88	YS
	C) Function		10-12-88	YS
660	Pack		10-20-88	JL

88299

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80