

CB22537B

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

88299

5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225378

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	1/22	FB
600	PROOF	1/28/88	RW
615	MAGNAFLUX BARREL	2/18/88	P/C.
	MAGNAFLUX BOLT	5/13/88	P/C.
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE # 1214

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225378

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		8/26/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/26/88	RW
	C) Inspect Ejector Hole for Chamfer		8/26/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/26/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		26 Aug 88	W.B. + R.S.
	F) Safety on Force	6.5 6.25 6.5	26 Aug 88	W.B. + R.S.
	G) Safety off Force	3.25 3.25 3.25	26 Aug 88	W.B. + R.S.
	H) Trigger Pull Test & Retainability		26 Aug 88	W.B. + R.S.
	I) Firing Pin Indent	.022 .0225 .023	26 Aug 88	W.B. + R.S.
	J) Assemble Stock		9/27/88	RW
	K) Assemble Swivel Studs		10-6-88	R.S.
	L) Attach Front & Rear Sight Assemblies		9/27/88	RW
	M) Iron Sight Alignment		9/27/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/27/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	Q.U.
640	Gallery Target & Test	68R 87L	10-5-88	AC
	A) Optical Clarity of Scope	OK	10-5-88	AC
645	Inspect for Live Ammo	NONE	10-5-88	AC
655	Final Inspection			
	A) Headspace		10-6-88	R.S.
	B) Trigger Pull		10-6-88	R.S.
	C) Function		10-6-88	R.S.
660	Pack		10-21-88	R.S.

SWS TRIGGER PULL TEST

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

SERIAL NO. C6225378

DATE 26 Aug. 88

TESTER W.B. + J.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.40	2.30	2.20	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.23	2.21	2.43	
PULL #3	2.56	2.21	2.24	2.50	
PULL #4	2.68	2.29	2.32	2.54	
PULL #5	2.59	2.20	2.30	2.56	
TOTAL	12.81	11.23	11.27	12.47	
AVG.	2.562	2.246	2.254	2.49	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.21		
PULL #2	3.32	3.27		
PULL #3	3.40	3.27		
PULL #4	3.41	3.28		
PULL #5	3.40	3.30		
TOTAL	16.88	16.33		
AVG.	3.376	3.266		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.21		4.11
PULL #2	4.26	4.22		4.12
PULL #3	4.24	4.23		4.16
PULL #4	4.22	4.22		4.14
PULL #5	4.23	4.24		4.16
TOTAL	21.31	21.12		20.69
AVG.	4.262	4.224		4.138

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225378

CENTROIDAL DISTANCES

0 TO	1	1.6188
1 TO	2	.571077
1 TO	3	.769603
1 TO	4	.306819
1 TO	5	.186271

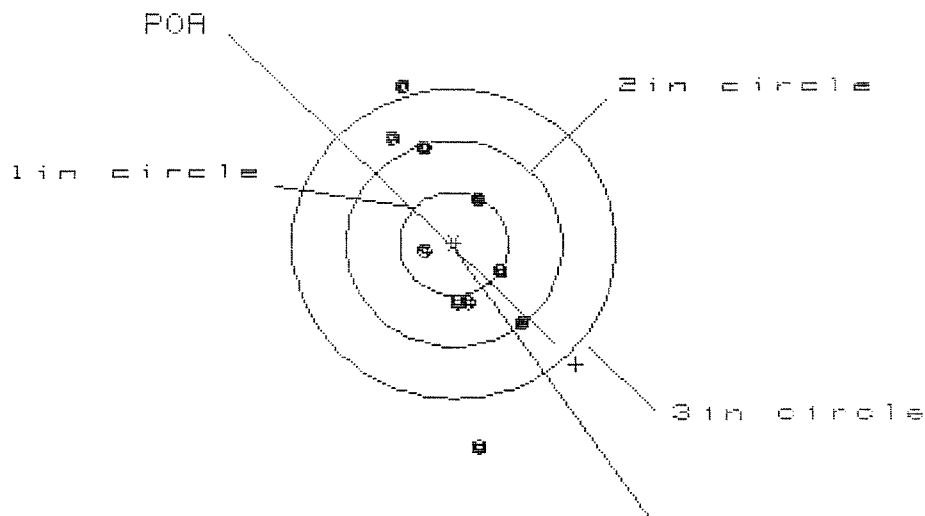
41 2
3
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0222
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .969
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.40849
THE AMR FOR THIS RIFLE IS: .9156

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG225378

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 1.270

VS= 3.451

GS= 3.507

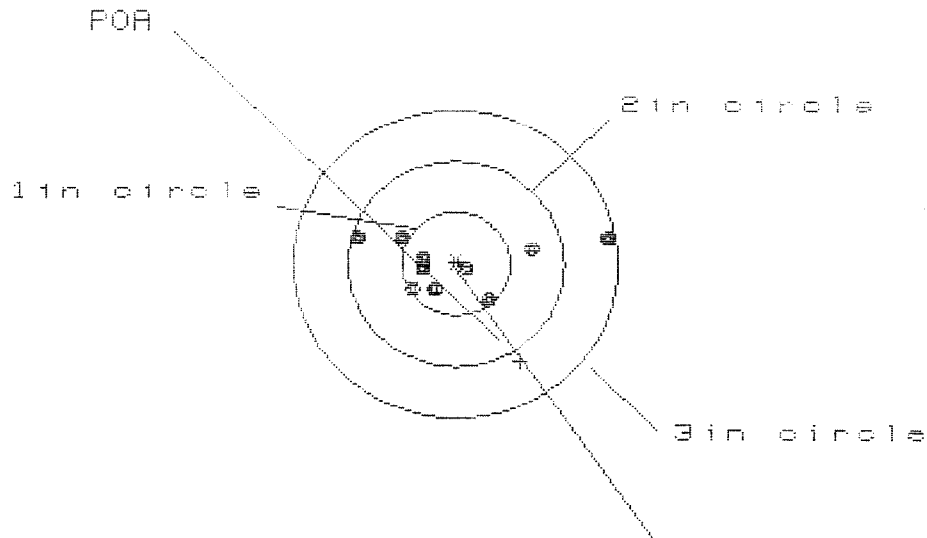
CENTROID +

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.655	.676	.624
MINIMUM X	:	-.615	-.594	-.646
MAXIMUM Y	:	1.521	1.306	1.005
MINIMUM Y	:	-1.930	-.988	-.824
CENTROID X	:	-1.125	-1.146	-1.094
CENTROID Y	:	1.164	1.379	1.215
POA TO CENTROID in.	:	1.619	1.793	1.635
MIN RADIUS	:	.274	.343	.312
MEAN RADIUS	:	.910	.802	.701
MAX RADIUS	:	1.939	1.371	1.194
HORIZONTAL SPREAD	:	1.270	1.270	1.270
VERTICAL SPREAD	:	3.451	2.294	1.829
EXTREME SPREAD	:	3.507	2.540	2.227
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225378

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 6

2in = 9

3in = 10

HS= 2.298

VS= .639

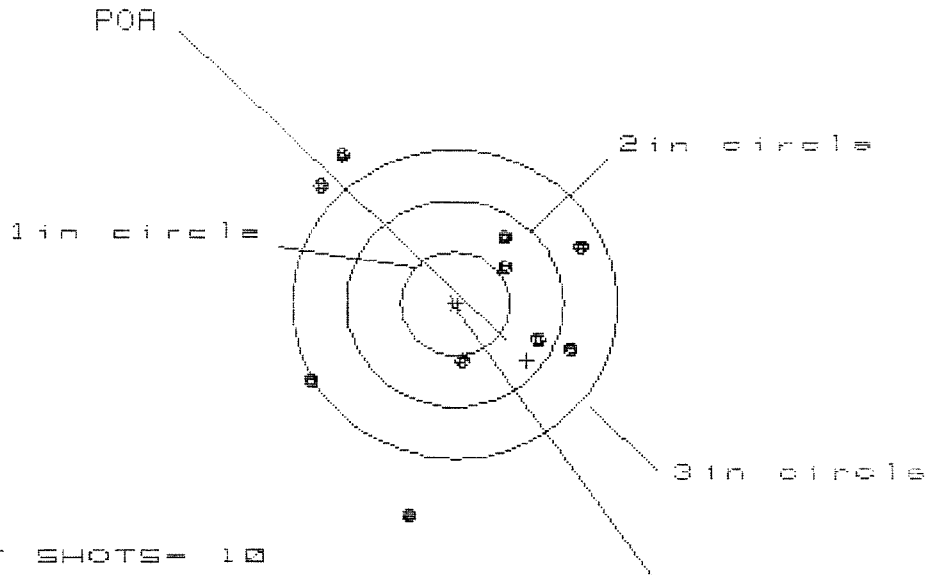
GS= 2.297

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	.818	.728
MINIMUM X	:	-.874	-.716	-.421
MAXIMUM Y	:	.284	.267	.299
MINIMUM Y	:	-.355	-.323	-.291
CENTROID X	:	-.598	-.756	-.666
CENTROID Y	:	.944	.912	.880
POA TO CENTROID in.	:	1.117	1.185	1.104
MIN RADIUS	:	.157	.110	.186
MEAN RADIUS	:	.555	.412	.376
MAX RADIUS	:	1.450	.838	.759
HORIZONTAL SPREAD	:	2.296	1.534	1.149
VERTICAL SPREAD	:	.639	.590	.590
EXTREME SPREAD	:	2.297	1.536	1.152
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225378

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 6

HS = 2.427

VS = 3.517

GS = 3.580

CENTROID +

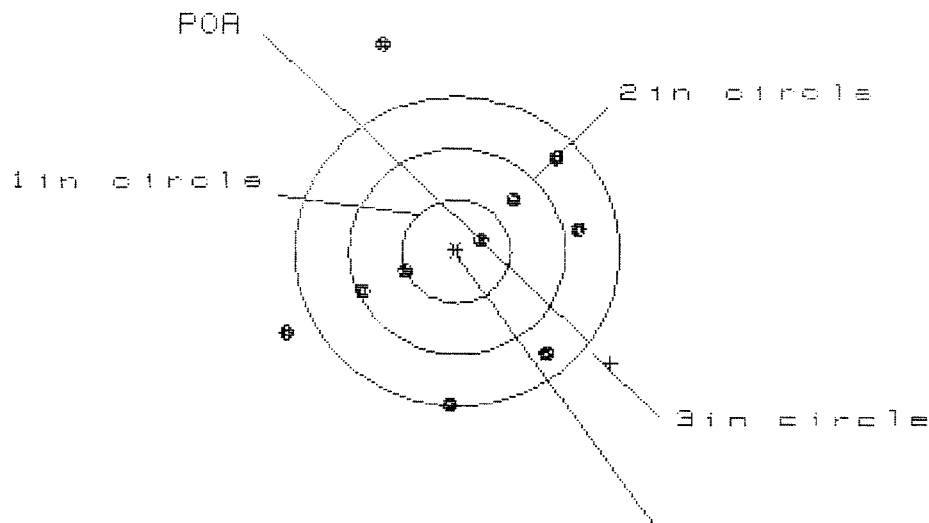
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.124
MINIMUM X	-1.303
MAXIMUM Y	1.467
MINIMUM Y	-2.050
CENTROID X	-.665
CENTROID Y	.547
POA TO CENTROID in.	.961
MIN RADIUS	.510
MEAN RADIUS	1.220
MAX RADIUS	2.086
HORIZONTAL SPREAD	2.427
VERTICAL SPREAD	3.517
EXTREME SPREAD	3.580
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	6

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225378

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.698

VS= 3.522

GS= 3.567

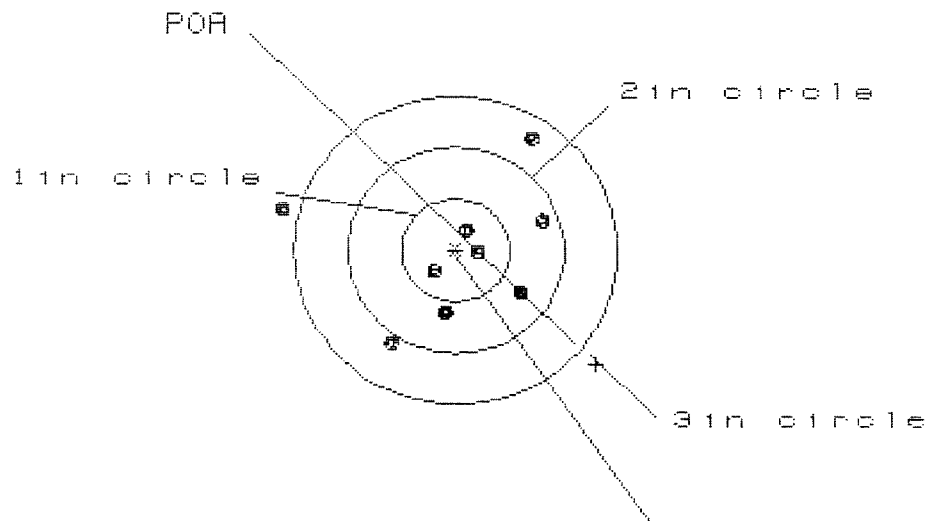
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.057	.852
MINIMUM X	:	-1.570	-1.641	-1.130
MAXIMUM Y	:	2.051	1.124	1.050
MINIMUM Y	:	-1.471	-1.243	-1.317
CENTROID X	:	-1.422	-1.351	-1.146
CENTROID Y	:	1.087	.859	.933
POA TO CENTROID in.	:	1.790	1.601	1.478
MIN RADIUS	:	.218	.328	.236
MEAN RADIUS	:	1.151	1.037	.924
MAX RADIUS	:	2.148	1.744	1.362
HORIZONTAL SPREAD	:	2.698	2.698	1.982
VERTICAL SPREAD	:	3.522	2.367	2.367
EXTREME SPREAD	:	3.567	3.033	2.572
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			4	
NUMBER IN THREE INCH CIRCLE =			5	

5 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/C6225378

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 9

HS= 2.495

VS= 2.042

GS= 2.499

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.848	.665	.735
MINIMUM X	:	-1.647	-.815	-.745
MAXIMUM Y	:	1.101	1.150	.502
MINIMUM Y	:	-.941	-.892	-.748
CENTROID X	:	-1.301	-1.118	-1.188
CENTROID Y	:	1.103	1.054	.910
POA TO CENTROID in.	:	1.706	1.536	1.496
MIN RADIUS	:	.189	.036	.191
MEAN RADIUS	:	.742	.603	.534
MAX RADIUS	:	1.706	1.280	1.056
HORIZONTAL SPREAD	:	2.495	1.480	1.480
VERTICAL SPREAD	:	2.042	2.042	1.250
EXTREME SPREAD	:	2.499	2.462	1.937
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 98-24064INITIAL
JJM

CUSTOMER ORDER NO.

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

11/12/98

11/13/98

C6225378

700 7.62

NATO

ACCESSORIES

FROM:

SHIP TO:

COMMANDER
1ST BN 1ST SFG A UNIT 35123
ATTN PROPERTY BOOK OFFICER
PSC 560 TORII STA. CA 96376COMMANDER
1ST BN 1ST SFG A UNIT 35123
ATTN PROPERTY BOOK OFFICER
PSC 560 TORII STA. CA
96376

CUST NO:198287 C.O.D.L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

FROM, DATE

ESTIMATED

VIA

UPS

GUN CONDITION

- ☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
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CYCLE

A1

B1

TRIGGER GROUP

B2

E1

F1

BOLT ASSY.

B3

E2

F2

BARREL ASSY.

B4

D1

E3

F3

REC. ASSY.

B5

D2

E4

F4

WOOD

C1

D3

E5

F5

METAL

C2

MAIN FAULT

PARTS

COMMENTS

Barrel

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 7/97

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400014069

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225325
19 Feb 1999

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0394
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1546
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159542

THE AMR FOR THIS RIFLE IS: 1.243

CENTROIDAL DISTANCES

Ø TO	1	.625236
1 TO	2	.890834
1 TO	3	.869005
1 TO	4	.674372
1 TO	5	.746539

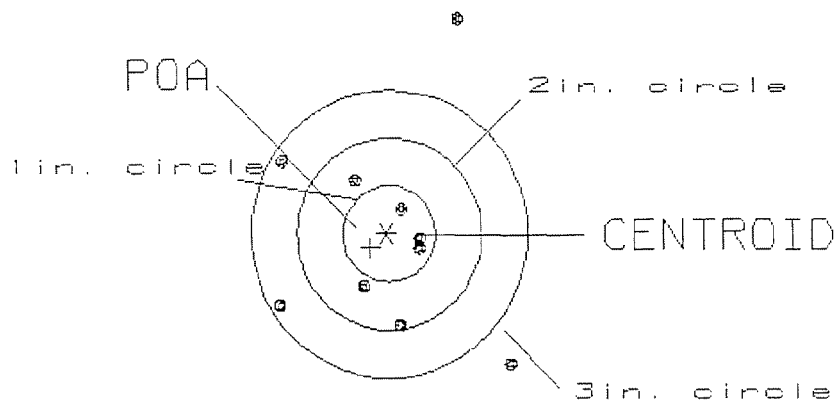
1 4 3
 5
+ <----POA
 2

PATTERN #: 5
 POA TO CENTROID: .229
 MIN RADIUS : .280
 MEAN RADIUS : 1.034
 MAX RADIUS : 2.367
 CENTROID X : .174
 CENTROID Y : .149

19 Feb 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225325

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.58

3

VS= 3.58

6

GS= 3.63

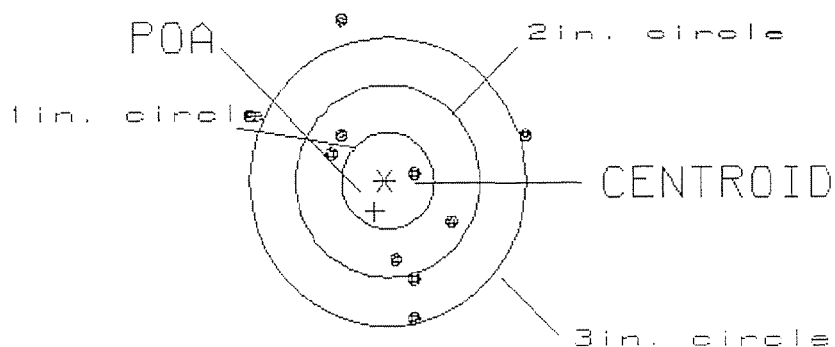
8

PATTERN #: 04
 POA TO CENTROID: .335
 MIN RADIUS : .266
 MEAN RADIUS : 1.064
 MAX RADIUS : 1.756
 CENTROID X : .111
 CENTROID Y : .317

19 Feb 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225325

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 2.98

1

US= 3.10

5

GS= 3.18

7

PATTERN #: 3

POA TO CENTROID: .410

MIN RADIUS : .760

MEAN RADIUS : 1.476

MAX RADIUS : 3.324

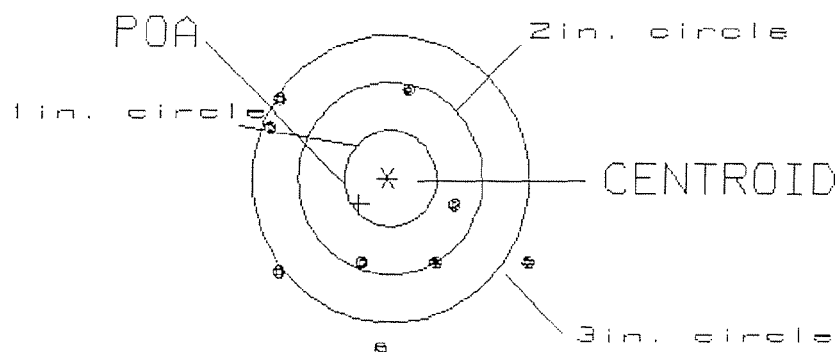
CENTROID X : .307

CENTROID Y : .271

19 Feb 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225325

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.81

0

VS= 4.66

4

GS= 5.03

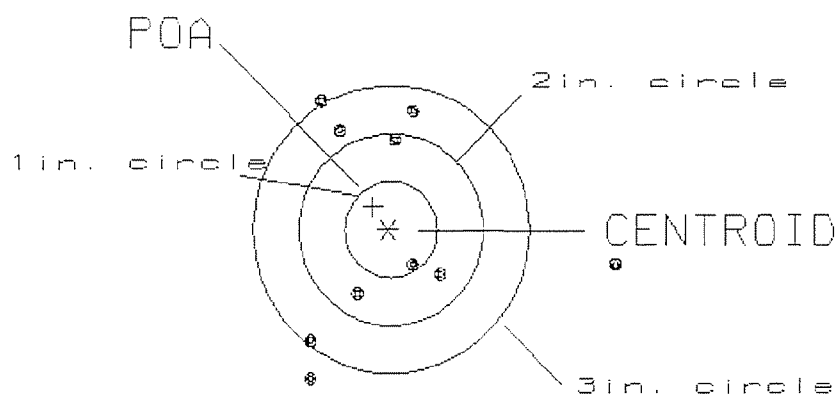
6

PATTERN #: 2
 POA TO CENTROID: .290
 MIN RADIUS : .453
 MEAN RADIUS : 1.260
 MAX RADIUS : 2.479
 CENTROID X : .167
 CENTROID Y : -.238

19 Feb 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225325

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.36

1

VS= 2.89

4

GS= 3.64

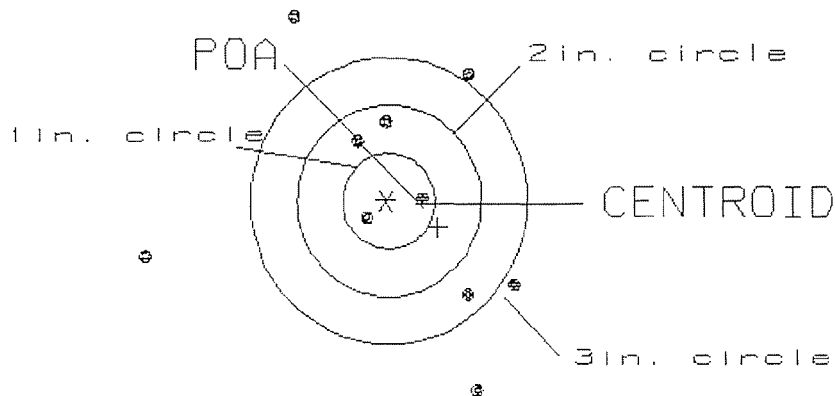
7

PATTERN #: 1
 POA TO CENTROID: .626
 MIN RADIUS : .270
 MEAN RADIUS : 1.383
 MAX RADIUS : 2.751
 CENTROID X : -.562
 CENTROID Y : .274

19 Feb 1999

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225325

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.01
 VS= 3.89
 GS= 4.40

2
 4
 5