

C6225058

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225058

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	9 12	8 8	FB
600	Proof	9 19	8 8	RW
607	Check Headspace	9 19	8 8	RW
610	Dis-assemble gun	9 19	8 8	RW
612	Magnaflux Barrel Action		9 22 88	pfe.
	Magnaflux Bolt		9 22 88	pfe.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/15/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/15/88	RW
	C) Inspect Ejector Hole for Chamfer		11/15/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y		11/15/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake		15 NOV 88	JSJ
	F) Safety on Force	5 5 5	17 NOV 88	JSJ
	G) Safety off Force	3 3 3	17 NOV 88	JSJ
	H) Trigger Pull Test & Retainability		15 NOV 88	JSJ
	I) Firing Pin Indent	.020 .020 .0205	17 NOV 88	JSJ
	J) Assemble Stock		11/17/88	RW
	K) Attach Front & Rear Sight Assemblies		12/6/88	RW
	L) Iron Sight Alignment		12/6/88	RW
	M) Detach Front & Rear Sights & place in numbered container		12/6/88	RW
	N) Attach Scope to Rifle		11/28/88	W3
	O) Detach & Attach Scope 20 times		11/28/88	W3
640	Gallery Target & Test	68 H 84 L	12/5/88	DH
	A) Optical Clarity of Scope		12/5/88	DH
645	Inspect for Live Ammo		12/5/88	DH
655	Final Inspection			
	A) Headspace		6 Dec 88	JSJ
	B) Trigger Pull	2.44 2.46 2.47	2.45 2.45	JSJ
	C) Function		6 Dec 88	JSJ
	D) Assemble Swivel Studs		6 Dec 88	JSJ
660	Pack		14 Dec 88	JSJ

6.2
SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6225058

DATE 15 NOV 88

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.34	2.37	2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.22	2.38	2.46	
PULL #3	2.40	2.13	2.57	2.47	
PULL #4	2.34	2.14	2.53	2.43	
PULL #5	2.41	2.32	2.52	2.45	
TOTAL	11.59	11.15	12.37	12.25	
AVG.	2.318	2.23	2.474	2.45	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.33		
PULL #2	3.02	3.17		
PULL #3	3.11	3.10		
PULL #4	3.23	3.27		
PULL #5	3.12	3.10		
TOTAL	15.52	15.97		
AVG.	3.104	3.194		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.13		4.37
PULL #2	4.12	4.26		4.20
PULL #3	4.12	4.17		4.07
PULL #4	4.19	4.18		4.19
PULL #5	4.16	4.05		4.19
TOTAL	20.68	20.79		21.02
AVG.	4.136	4.158		4.204

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225058

CENTROIDAL DISTANCES

0 TO	1	1.35081
1 TO	2	1.70439
1 TO	3	1.66401
1 TO	4	1.79899
1 TO	5	1.03128

+ 5 <----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4652
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2602
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .533024

THE AMR FOR THIS RIFLE IS: .8166

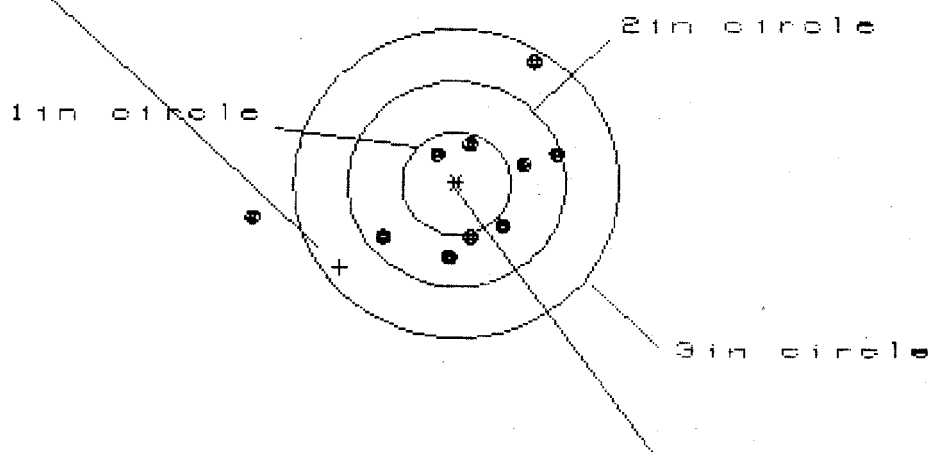
6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225058

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.777

VS= 1.942

GS= 3.026

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.895	.686	.753
MINIMUM X	:	-1.882	-.881	-.814
MAXIMUM Y	:	1.228	1.198	.489
MINIMUM Y	:	-.714	-.744	-.595
CENTROID X	:	1.078	1.287	1.220
CENTROID Y	:	.814	.844	.695
POA TO CENTROID in.	:	1.351	1.540	1.404
MIN RADIUS	:	.363	.358	.378
MEAN RADIUS	:	.827	.681	.591
MAX RADIUS	:	1.902	1.312	.899
HORIZONTAL SPREAD	:	2.777	1.567	1.567
VERTICAL SPREAD	:	1.942	1.942	1.084
EXTREME SPREAD	:	3.026	2.234	1.744
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225058

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in - 2

2 in - 8

3 in = 10

HS= 2.025

VS= 1.739

GS= 2.066

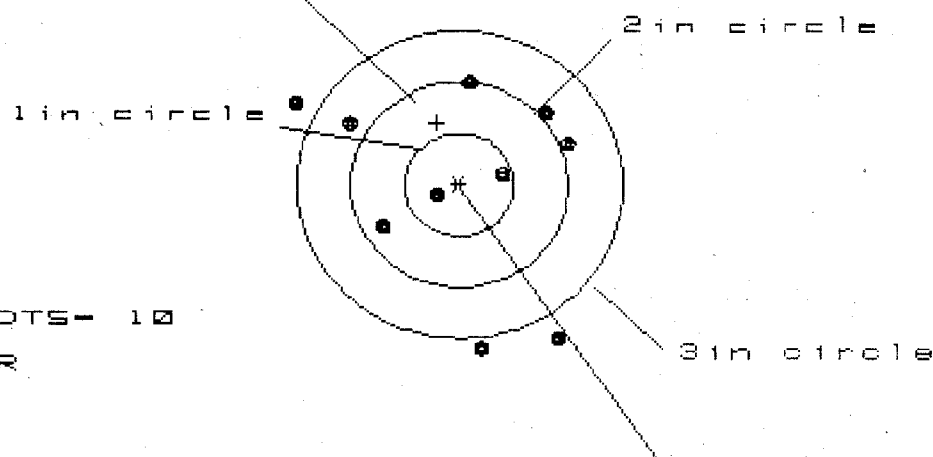
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.269	.929	.956
MINIMUM X	-.756	-.615	-.588
MAXIMUM Y	1.131	1.144	.540
MINIMUM Y	-.607	-.595	-.452
CENTROID X	.224	.083	.056
CENTROID Y	-.661	-.673	-.816
POA TO CENTROID in.	.697	.678	.818
MIN RADIUS	.250	.238	.129
MEAN RADIUS	.702	.617	.507
MAX RADIUS	1.274	1.164	.969
HORIZONTAL SPREAD	2.025	1.544	1.544
VERTICAL SPREAD	1.739	1.739	.992
EXTREME SPREAD	2.066	1.747	1.574
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225058

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 7

HS= 2.516

VS= 2.538

GS= 3.277

CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	1.144	.972
MINIMUM X	-1.476	-1.372	-1.108
MAXIMUM Y	.961	.799	.874
MINIMUM Y	-1.577	-1.739	-1.664
CENTROID X	.204	.100	.272
CENTROID Y	-.602	-.440	-.515
POA TO CENTROID in.	.635	.451	.582
MIN RADIUS	.178	.243	.280
MEAN RADIUS	1.078	.995	.914
MAX RADIUS	1.731	1.764	1.669
HORIZONTAL SPREAD	2.516	2.516	2.080
VERTICAL SPREAD	2.538	2.538	2.538
EXTREME SPREAD	3.277	2.873	2.541
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 4		
NUMBER IN THREE INCH CIRCLE	= 7		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225058

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.440

VS= 2.100

GS= 2.114

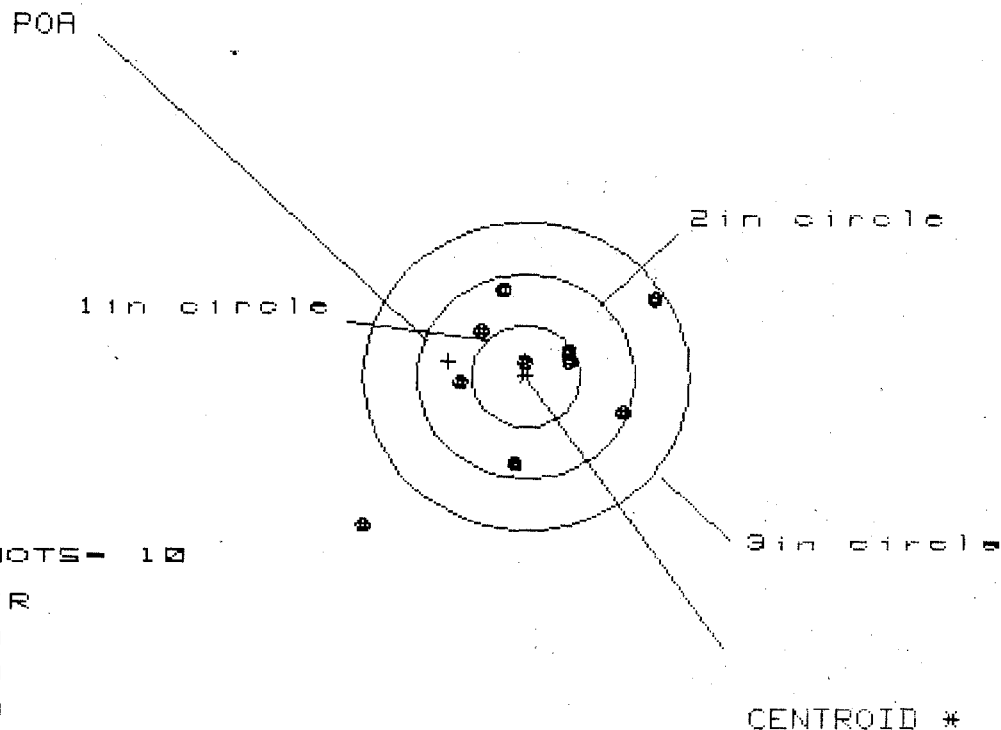
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.909	.878	.807
MINIMUM X	-.530	-.562	-.583
MAXIMUM Y	.909	.776	.494
MINIMUM Y	-1.191	-.859	-.762
CENTROID X	.111	.142	.213
CENTROID Y	-.703	-.570	-.667
POA TO CENTROID in.	.711	.588	.700
MIN RADIUS	.189	.105	.161
MEAN RADIUS	.641	.555	.501
MAX RADIUS	1.226	.959	.840
HORIZONTAL SPREAD	1.440	1.440	1.390
VERTICAL SPREAD	2.100	1.635	1.256
EXTREME SPREAD	2.114	1.815	1.568
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

6 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225058

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.730

VS= 2.275

GS= 3.474

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.183	1.012	.867
MINIMUM X	-1.547	-.773	-.647
MAXIMUM Y	.868	.711	.784
MINIMUM Y	-1.407	-.971	-.898
CENTROID X	.709	.880	.754
CENTROID Y	-.149	.008	-.065
POA TO CENTROID in.	.724	.880	.757
MIN RADIUS	.172	.142	.088
MEAN RADIUS	.835	.649	.585
MAX RADIUS	2.091	1.169	.953
HORIZONTAL SPREAD	2.730	1.785	1.514
VERTICAL SPREAD	2.275	1.682	1.682
EXTREME SPREAD	3.474	2.054	1.682
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

ORDER
97-13763

PAGE 2 OF 3

NATO

SCOPE	BASE
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SHIP TO:

U.S.ARMY APGSA
ATTN: STEAP-LO-GM, BLDG 507
ABERDEEN PROV.GRND MD
21065

CUST NO: 091561 C.O.D L

WRITE

UPS

☐ MARRED

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	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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INSPECT

En

F2

53

F5

C2

MAIN FAULT

PARTS

COMMENTS

96003 - Barrel

Refunder Cont Trigger Guard
Assy, Front & Rear Sight
Bases
Reziac Scope Base & Swivel
Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE _____

DATE _____

DATE	
------	--

DATE

DATE _____

OFFICE COPY

RD6925 REV. 6/96

M2400047980

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6225058
6 Aug 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .179
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .203
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .270647

THE AMR FOR THIS RIFLE IS: 1.016

CENTROIDAL DISTANCES

Ø TO	1	.270647
1 TO	2	Ø
1 TO	3	Ø
1 TO	4	Ø
1 TO	5	Ø

+  <----POA

BARREL

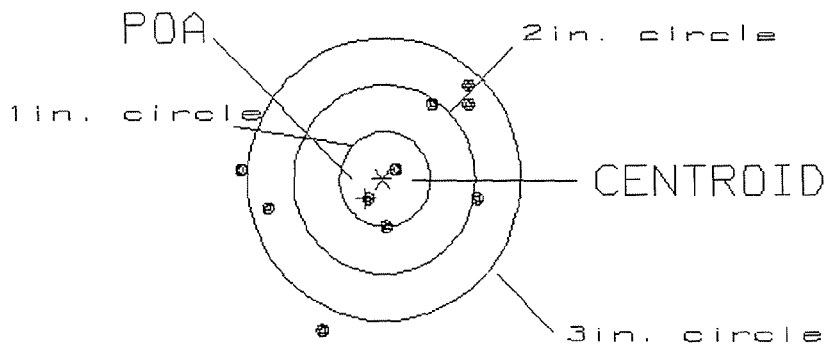
PATTERN #: 1

POA TO CENTROID: .271
 MIN RADIUS : .215
 MEAN RADIUS : 1.016
 MAX RADIUS : 1.738
 CENTROID X : .179
 CENTROID Y : .203

6 Aug 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.54

2

US= 2.59

4

GS= 3.04

8

21 DAY TURN - AROUND

*New
Barrel*

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. *C6225058*

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>8-7-97</i>	<i>RW</i>
605	CHECK HEADSPACE	<i>8-7-97</i>	<i>RW</i>
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY	<i>9-18-97</i>	<i>RW</i>
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE	<i>5</i>	<i>5</i>
D	SAFETY OFF FORCE	<i>2</i>	<i>2</i>
E	FIRING PIN INDENT		
640	TARGET	<i>9-22-97</i>	<i>RW</i>
655	FINAL INSPECT		
660	PACK		
QAR INSPECTION		SHIP DATE	

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6225058
22 Sep 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1432
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0778
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .16297

THE AMR FOR THIS RIFLE IS: .9466

CENTROIDAL DISTANCES

0	TO	1	.230495
1	TO	2	.36977
1	TO	3	.97269
1	TO	4	.333108
1	TO	5	.36563

1 +⁵
42 <----POA
3

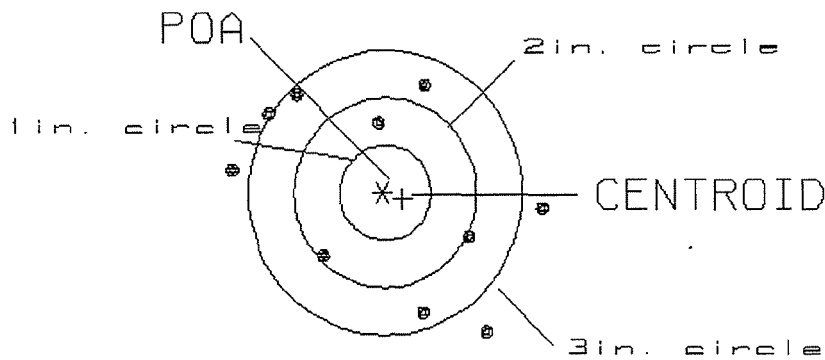
PATTERN #: 1

POA TO CENTROID: .230
 MIN RADIUS : .779
 MEAN RADIUS : 1.354
 MAX RADIUS : 1.855
 CENTROID X : -.222
 CENTROID Y : .062

19 Sep 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.41
 VS= 2.66
 GS= 3.42

0
 2
 6

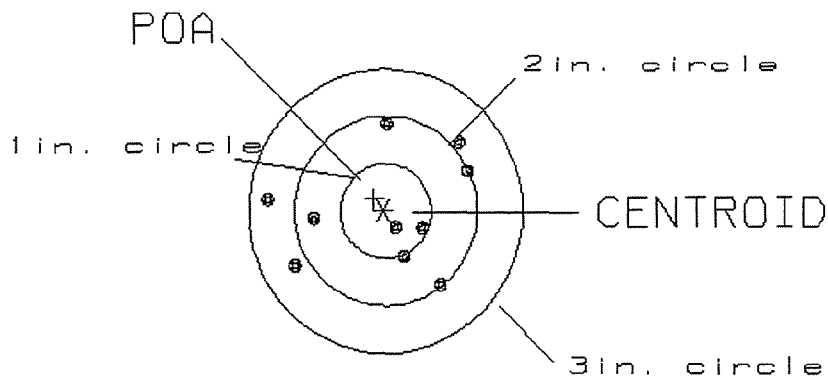
PATTERN #: 2

POA TO CENTROID: .158
 MIN RADIUS : .189
 MEAN RADIUS : .837
 MAX RADIUS : 1.310
 CENTROID X : .097
 CENTROID Y : -.125

19 Sep 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.22

2

VS= 1.65

6

GS= 2.24

10

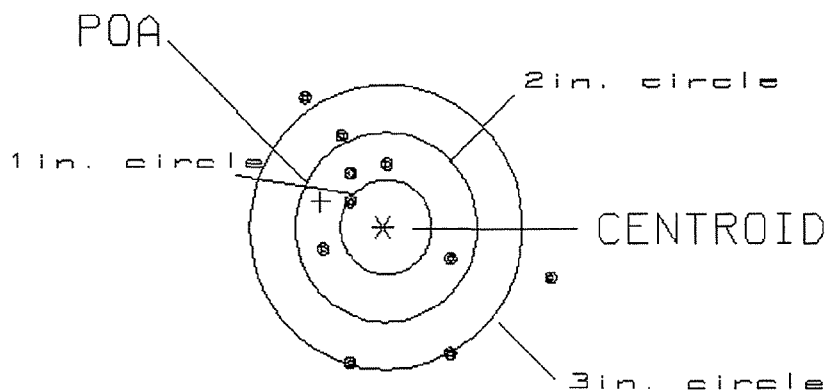
PATTERN #: 3

POA TO CENTROID: .743
 MIN RADIUS : .519
 MEAN RADIUS : 1.096
 MAX RADIUS : 1.883
 CENTROID X : .693
 CENTROID Y : -.268

19 Sep 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.71
 VS= 2.77
 GS= 3.32

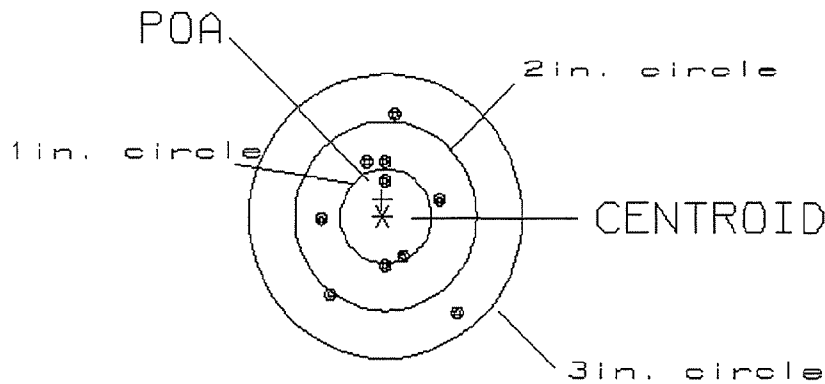
0
 5
 8

PATTERN #: 4
 POA TO CENTROID: .178
 MIN RADIUS : .388
 MEAN RADIUS : .733
 MAX RADIUS : 1.266
 CENTROID X : .009
 CENTROID Y : -.178

19 Sep 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.40

2

VS= 2.14

7

GS= 2.25

10

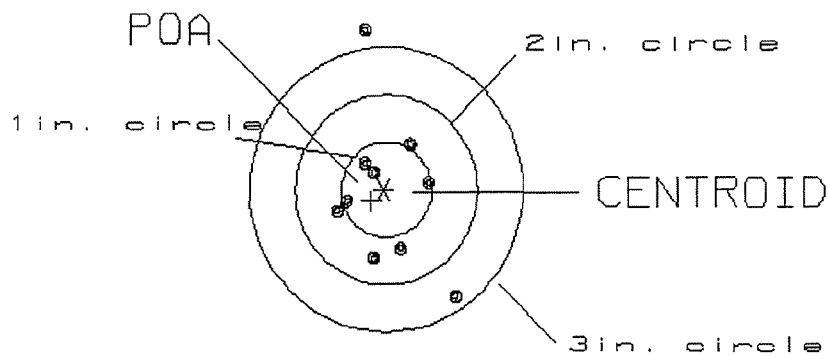
PATTERN #: 5

POA TO CENTROID: .184
 MIN RADIUS : .258
 MEAN RADIUS : .713
 MAX RADIUS : 1.748
 CENTROID X : .139
 CENTROID Y : .120

19 Sep 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225058

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.27

3

VS= 2.63

6

GS= 3.00

9

Final Inspection

Sni: C1A25058

DATE REC'D: 8-31-97

DATE RET'D:

Auditor:

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: