

C6225266

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

C6725266

GUN SERIAL # [REDACTED]

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 27 91		Rev
600	Proof	6 27 91		Rev
607	Check Headspace	6 27 01		Rev
610	Dis-assemble Gun	6 27 91		Rev
612	Magnaflux Barrel Action	JUL 1 1991		KCK
	Magnaflux Bolt	JUL 1 1991		KCK
615	Rollmark Caliber	JUL 1 1991		GL
617	Drill and Tap Sight Holes	JUL 2 1991		FB
618	Polish Barrel	JUL 2 1991		MB
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		7-24-91	YH

op. #	BARBER - M24 0011752					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	6	6	6		7-24-91	JE
	G) Safety Off Force	4	4	4		7-24-91	JE
	H) Trigger Pull Test & Retainability					7-24-91	JE
	I) Firing Pin Indent	.024	.024	.024		7-24-91	JE
	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					7-25-91	DH
	A) Time					7-25-91	DH
	B) Malfunctions					7-25-91	DH
	C) Pierced Primers					7-25-91	DH
	D) Optical Clarity of Scope					7-25-91	DH
645	Inspect for Live Ammo					7-25-91	DH
655	Final Inspection						
	A) Headspace						
	B) Trigger Pull	2.60	2.70	2.59	2.69	2.64	4/1/91
	C) Function	2.70	2.57	2.59	2.60	2.63	7-26-91
660	Pack					7-26-91	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C-6225266

DATE 7-24-91

TESTER JY

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.39	2.41	2.70	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.25	2.29	2.38	2.57	
PULL #3	2.39	2.43	2.26	2.59	
PULL #4	2.34	2.24	2.41	2.60	
PULL #5	2.35	2.39	2.44	2.63	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.35		
PULL #2	3.44	3.55		
PULL #3	3.50	3.38		
PULL #4	3.45	3.46		
PULL #5	3.46	3.48		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.49		4.57
PULL #2	4.48	4.48		4.35
PULL #3	4.42	4.35		4.54
PULL #4	4.46	4.33		4.56
PULL #5	4.44	4.56		4.60
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225266
26 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.00608276
1 TO	2	.167287
1 TO	3	.139714
1 TO	4	.309517
1 TO	5	.241696

5
4
3
2
1

<----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0796
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0396
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0889062

THE AMP FOR THIS RIFLE IS: .9316

26 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225266

CENTERFIRE PATTERNS

1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HE = 2.380

VS = 2.594

GS = 2.644

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.462	1.361	1.059
MINIMUM X	:	-.917	-.872	-.702
MAXIMUM Y	:	1.201	1.046	.974
MINIMUM Y	:	-1.393	-.792	-.864
CENTROID X	:	-.001	.101	-.069
CENTROID Y	:	-.006	.149	.221
POA TO CENTROID in.	:	.006	.180	.232
MIN RADIUS	:	.182	.140	.058
MEAN RADIUS	:	.962	.860	.766
MAX RADIUS	:	1.668	1.478	1.114
HORIZONTAL SPREAD	:	2.380	2.233	1.761
VERTICAL SPREAD	:	2.594	1.838	1.838
EXTREME SPREAD	:	2.644	2.501	1.969
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

26 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225266

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HST = 3.057

VS = 1.573

GS = 3.089

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.609	1.021	.862
MINIMUM X	:	-1.448	-1.269	-.965
MAXIMUM Y	:	.966	.899	.870
MINIMUM Y	:	-.607	-.366	-.395
CENTROID X	:	.158	-.021	.138
CENTROID Y	:	-.058	.009	.039
POA TO CENTROID in.	:	.168	.023	.143
MIN RADIUS	:	.169	.262	.267
MEAN RADIUS	:	.872	.786	.708
MAX RADIUS	:	1.720	1.290	1.042
HORIZONTAL SPREAD	:	3.057	2.290	1.827
VERTICAL SPREAD	:	1.573	1.265	1.265
EXTREME SPREAD	:	3.089	2.340	1.929
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225266

CENTERFIRE PATTERNS

3

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 1.020

VS = 2.176

GS = 3.157

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

1.646

.998

.850

-1.374

-1.191

-.917

1.053

1.021

1.096

-1.123

-1.155

-1.080

.127

-.056

.092

-.062

-.030

-.105

.141

.064

.140

.168

.237

.212

.934

.843

.768

1.672

1.332

1.113

3.020

2.189

1.767

2.176

2.176

2.176

3.157

2.237

2.189

2

5

8

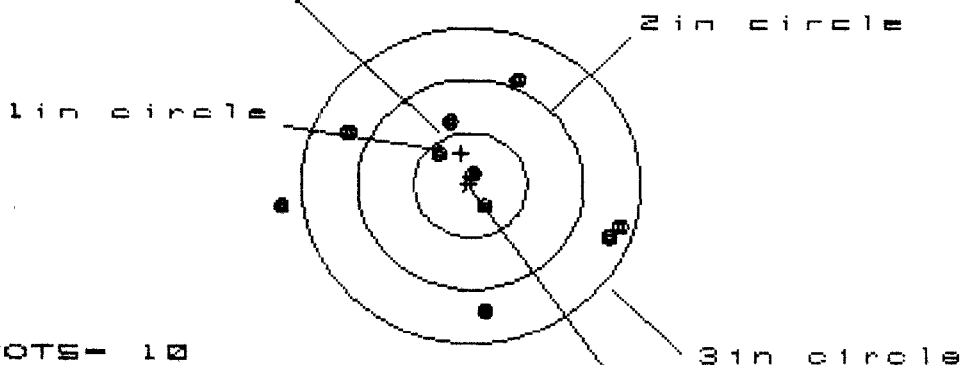
26 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6225266

CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 3

HS= 3.037

VS= 2.211

GS= 3.040

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.340	1.152	1.195
MINIMUM X	:	-1.697	-1.242	-1.098
MAXIMUM Y	:	.976	.952	.905
MINIMUM Y	:	-1.235	-1.259	-1.306
CENTROID X	:	.079	.267	.123
CENTROID Y	:	-.305	-.281	-.234
POA TO CENTROID, in.:	:	.315	.388	.265
MIN RADIUS	:	.141	.170	.060
MEAN RADIUS	:	.937	.853	.772
MAX RADIUS	:	1.711	1.326	1.307
HORIZONTAL SPREAD	:	3.037	2.394	2.293
VERTICAL SPREAD	:	2.211	2.211	2.211
EXTREME SPREAD	:	3.040	2.536	2.481
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

26 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06225266

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 1.813

VS= 2.336

GS= 2.816

CENTROID #

PATTERN #	1	5	9	8
SHOTS (BEST OF)	10		9	8
MAXIMUM X	.817	.752	.797	
MINIMUM X	-.996	-.906	-.861	
MAXIMUM Y	1.512	1.394	1.046	
MINIMUM Y	-.824	-.656	-.482	
CENTROID X	.035	-.055	-.100	
CENTROID Y	.233	.065	-.109	
POA TO CENTROID in.	.236	.086	.148	
MIN RADIUS	.320	.130	.080	
MEAN RADIUS	.953	.823	.701	
MAX RADIUS	1.718	1.440	1.315	
HORIZONTAL SPREAD	1.813	1.658	1.658	
VERTICAL SPREAD	2.336	2.050	1.528	
EXTREME SPREAD	2.816	2.293	2.085	
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	9		

BARBER-M24 0011760

ATTN: FRED MARTIN/MODEL 700 M24
NO CORR

FRS

ORDER

R 91-11306

SHIP TO:

GA
31905

R481579361

TOTAL	100
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☐ MARRED

- ① New BARREL & Power COAT ACTION
- ② Re-Powder COAT TRIGGER COUNT
- ③ New STOCK
- ④ New TRIGGER ASSY
- ⑤ New FIRING PIN ASSY PN 96007

③ New Stock
④ New Trigger Assy
⑤ New Firing Pin Assy PN 96007

GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
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RD6925 REV. 7/90

BARBER - M24 ~~0041988~~ **M2400011799**

MAINTENANCE REQUEST						PAGE NO.	NO. OF PAGES	REQUIREMENTS CONTROL SYMBOL																																																																																																								
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG						1	1	CSGLD - 1047(R1)																																																																																																								
SECTION I - EQUIPMENT DATA																																																																																																																
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD 03		PD AUTHENTICATION <i>[Signature]</i>																																																																																																								
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION CRESCENZ WPNS POOL 544-1625		B. LOCATION FT BENNING, GA 31905			C. UNIT IDENT CODE WOU255																																																																																																									
2. SERIAL NO. C6225266		3. NOUN NOMENCLATURE Rifle Sniper		4. LINE NO. E95387		5. MODEL M24		6. NATIONAL STOCK NUMBER 1005-01-240-2136																																																																																																								
7A. MAINTENANCE ACTIVITY INST MAINT DIV		B. LEVEL H	8. UTILIZATION CODE O	9A. MCSR ITEM	9B. ERC	9C. PACING ITEM	10. HOURS	11. MILES	12. ROUNDS	13. STARTS																																																																																																						
14. FAILURE DETECTED DURING (Select one - use ☒ or X) ☒ A Scla Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☐ D Normal Op ☐ F Inspection ☐ H Other					15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X) ☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☒ 1059 Other																																																																																																											
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). Rear Trigger Guard Screw Stripped, Barrel Finish worn Missing Scope Covers																																																																																																																
B. REMARKS 13,500 Rds Fired																																																																																																																
SECTION II - WORK ACCOMPLISHED																																																																																																																
17A. REPAIR ORGANIZATION/ACTIVITY MAINT DIV, DOL				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X) ☐ 1 TOE ☐ 2 TD ☐ 3 Contractor			19. AMS ACCT. CODE																																																																																																							
B. LOCATION FT BENNING, GA 31905																																																																																																																
<table border="1"><thead><tr><th rowspan="2">20A. ACT. CODE</th><th rowspan="2">B. FAILURE CODE</th><th colspan="3">C. COMPONENT/PART NOUN, SVC, OR MWO NO.</th><th rowspan="2">D. MANHOURS (Hrs. & tenths)</th><th rowspan="2">E. NATIONAL STOCK NUMBER</th><th rowspan="2">F. PART SOURCE CODE</th><th rowspan="2">G. QTY.</th><th rowspan="2">H. PARTS COST</th></tr><tr><th>(1) CB CODE</th><th>(2) REF DESIGN.</th><th>(3) MFR. CODE</th></tr></thead><tbody><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td></td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td>RX REPARABLE EX</td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td>BENCH STOCK</td><td></td><td></td><td>\$</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>.</td><td>OTHER PARTS</td><td></td><td></td><td>\$</td></tr></tbody></table>										20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST	(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE						.				\$						.				\$						.				\$						.				\$						.				\$						.				\$						.	RX REPARABLE EX			\$						.	BENCH STOCK			\$						.	OTHER PARTS			\$
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				I. TOTAL MANHOURS		J. TOTAL MANHOURS COST \$		K. TOTAL PARTS COST \$																																																																																																								
21. DELAY (Select One) ☐ 1 Parts ☐ 2 Manpower ☐ 3 Facilities ☐ 4 Funds ☐ 5 Tools																																																																																																																
22. Data Transcribed ☐																																																																																																																
23. SUBMITTED BY <i>[Signature]</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY																																																																																																								
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE																																																																																																								
28. DISPOSITION (Select One) ☐ A To User ☐ D Evacuated ☐ B To Stock ☐ E Cannibalization ☐ C Salvaged																																																																																																																

[illegible]

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6225266

OP. #	OP. NAME	READINGS	DATE	INIT
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 and Tap Sight Holes			
618	Polish Barrel RB		7/24/89	WB
620	Apply Coatings (Barrel Action)		7/24/89	TA
	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		7/28/89	J.V.

BARBER - M24 0011764

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability						7/28/89	GU
	I) Firing Pin Indent							
	J) Assemble Stock						7/30/89	RU
	K) Assemble Swivel Studs						7/31/89	WB
	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						8/2/89	JS
	A) Headspace							
	B) Trigger Pull	2.50	2.45	2.56	2.42	2.40	8/2/89	JS
	C) Function						8/2/89	JS
660	Pack						8/3/89	WB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6225266

DATE 28 July 89

TESTER J.A.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58		2.83	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.78		2.56	2.45	
PULL #3	2.77		2.61	2.56	
PULL #4	2.77		2.63	2.42	
PULL #5	2.77		2.60	2.40	
TOTAL	13.67		13.23	13.33	
AVG.	2.734		2.646	2.666	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.74			
PULL #2	4.52			
PULL #3	4.60			
PULL #4	4.61			
PULL #5	4.51			
TOTAL	22.88			
AVG.	4.576			

RECEIVING AND ESTIMATING REPORT

COMMENTS

SNIPER M-24 W/10X LEUPOLD SCOPE

INITIAL JJM	CUSTOMER ORDER NO.					
DATE RECEIVED 08/08/90	DATE OPENED 08/16/90	DATE CODE	SERIAL NUMBER C6225266	MODEL AND GRADE 9999 7.65 NATO		ORDER R 90-22055
ACCESSORIES SLING STRAP W/STUDS		W/SWIVELS		HARD CASE		

FROM:

MAINTANCE DIVISION USAIC
ATTN ATZB-DL-MA-Q
BLDG 226
FORT BENNING GA 31905-5173

SHIP TO:

MAINTANCE DIVISION USAIC
ATTN ATZB-DL-MA-Q
BLDG 226
FORT BENNING GA
31905-5173

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
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REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL
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GUN CONDITION:

☐ NEW☐ SLIGHTLY WORN☐ VERY WORN☐ MISUSED☐ MARRED

CUSTOMER'S REQUEST

MAIN FAULT

PARTS

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE

RD6925 REV. 6/88

WITH GUN

MAINTENANCE REQUEST				PAGE NO. 1	NO. OF PAGES 1	REQUIREMENTS CONTROL SYMBOL CSGLD - 1047(R1)			
For use of this form, see DA PAM 738-750; the proponent agency is DCSLOG									
SECTION I - EQUIPMENT DATA									
CONTROL NUMBER		WORK ORDER NO.		WESDC		ORG. PD 03		PD AUTHENTICATION <i>Imudmag</i>	
☒ Work Request ☐ MWO ☐ Warranty Claim		1A. ORGANIZATION <i>Weapons Pool B- MAJUT DIV, DOL</i>		B. LOCATION <i>Bldg 9106 Ft. Benning, Ga 31905</i>			C. UNIT IDENT CODE <i>W04255</i>		
2. SERIAL NO. <i>C6225266</i>		3. NOUN NOMENCLATURE <i>Rifle Sniper</i>		4. LINE NO. <i>R95387</i>		5. MODEL <i>M24</i>		6. NATIONAL STOCK NUMBER <i>1005-01-240-2136</i>	
7A. MAINTENANCE ACTIVITY		B. LEVEL <i>H</i>		8. UTILIZATION CODE <i>Q</i>		9A. MCSR ITEM		9B. ERC	
						9C. PACING ITEM		10. HOURS	
								11. MILES	
								12. ROUNDS	
								13. STARTS	
14. FAILURE DETECTED DURING (Select one - use ☒ or X)					15. FIRST INDICATION OF TROUBLE (Select one - use ☒ or X)				
☐ A Sch. Main. ☐ C Test ☐ E Storage ☐ G Flight ☐ B Handling ☒ Normal Op ☐ F Inspection ☐ H Other					☐ 068 Inoperative ☐ 258 Overheating ☐ 790 Out of Adjustment ☐ 008 Noisy ☐ 387 Low Performance ☐ Other				
16A. DESCRIBE DEFICIENCIES OR SYMPTOMS ON THE BASIS OF COMPLETE CHECKOUT AND DIAGNOSTIC PROCEDURE IN EQUIPMENT TM (Do not prescribe repairs). <i>PAINT Peeling off Barrel, STOCK Fibers wearing through</i>									
B. REMARKS <i>Reconditioning Not Done - Rifle checked & repaired for Function Only - Remington Arms Co. G.I. Held</i>									
SECTION II - WORK ACCOMPLISHED									
17A. REPAIR ORGANIZATION/ACTIVITY				C. UNIT IDENT. CODE		18. TYPE ORGANIZATION/ACTIVITY ACCOMPLISHING WORK (Select one - use ☒ or X)		19. AMS ACCT. CODE	
B. LOCATION						☐ 1 TOE ☐ 2 TD ☐ 3 Contractor			
20A. ACT. CODE	B. FAILURE CODE	C. COMPONENT/PART NOUN, SVC, OR MWO NO.			D. MANHOURS (Hrs. & tenths)	E. NATIONAL STOCK NUMBER	F. PART SOURCE CODE	G. QTY.	H. PARTS COST
		(1) CB CODE	(2) REF DESIGN.	(3) MFR. CODE					
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					.				\$
					I. TOTAL MANHOURS	J. TOTAL MANHOURS COST \$	K. TOTAL PARTS COST \$		
21. DELAY (Select One)		☐ 1 Parts		☐ 2 Manpower		☐ 3 Facilities		☐ 4 Funds	
		☐ 5 Tools		22. Data Transcribed					
23. SUBMITTED BY <i>Imudmag</i>		24. RECEIVED BY		25. WORK STARTED BY		26. INSPECTED BY		27. ACCEPTED BY	
JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE		JULIAN DATE	
28. DISPOSITION (Select One)									
☐ A To User					☐ D Evacuated				
☐ B To Stock					☐ E Cannibalization				
☐ C Salvaged									

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C 6225266*

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

SCOPE #
1108

M-24

CONTRACT # DAAA21-87-C-0086

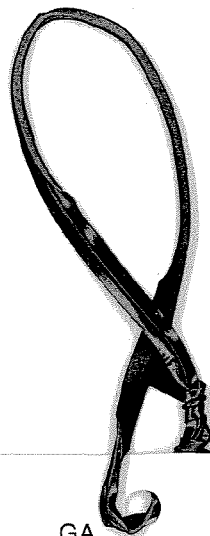
New Stock

GUN SERIAL # C6225266

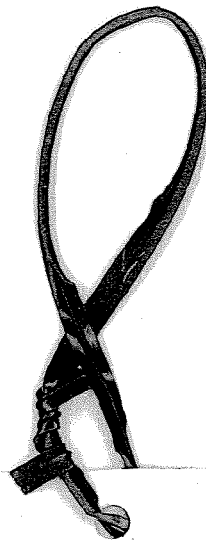
OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/13/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/13/88	RW
	C) Inspect Ejector Hole for Chamfer		9/13/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/13/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		13 Sept 88	JS
	F) Safety on Force	6" 6" 6"	13 Sept 88	JS
	G) Safety off Force	3" 3" 3.5"	13 Sept 88	JS
	H) Trigger Pull Test & Retainability		13 Sept 88	JS
	I) Firing Pin Indent	.0215 .0215 .0215	13 Sept 88	JS
	J) Assemble Stock		9/14/88	RW
	K) Assemble Swivel Studs			
	L) Attach Front & Rear Sight Assemblies		9/14/88	RW
	M) Iron Sight Alignment		9/14/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/14/88	RW
	O) Attach Scope to Rifle		10/5/88	RW
	P) Detach & Attach Scope 20 times	46 R 109L	10-5-88	JS
640	Gallery Target & Test		10-12-88	AC
	A) Optical Clarity of Scope		10-12-88	JS
645	Inspect for Live Ammo		10-12-88	JS
655	Final Inspection			
	A) Headspace		10-13-88	JS
	B) Trigger Pull		10-14-88	JS
	C) Function		10-13-88	JS
660	Pack		10-21-88	JS



MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
AC	1st	Cracked stock at Safe	
	2nd	New Stock	
	3rd		
	4th		
		FUNCTION	RD 6654 Rev 1



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06225266

DATE 13 Sept 88

TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.51	2.51	2.64 2.62	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.45	2.51 2.52	
PULL #3	2.45	2.44	2.45 2.63	
PULL #4	2.53	2.43	2.53 2.52	
PULL #5	2.42	2.45	2.44 2.46	
TOTAL	12.31	12.28	12.57 12.75	
AVG.	2.462	2.456	2.514 2.55	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.16		
PULL #2	3.09	3.18		
PULL #3	3.14	3.16		
PULL #4	3.11	3.16		
PULL #5	3.13	3.15		
TOTAL	15.59	15.81		
AVG.	3.118	3.162		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.17		4.03
PULL #2	4.20	4.12		4.06
PULL #3	4.17	4.15		4.13
PULL #4	4.23	4.13		4.06
PULL #5	4.23	4.13		4.06
TOTAL	21.02	20.7		20.34
AVG.	4.204	4.14		4.068

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225266

CENTROIDAL DISTANCES

0 TO	1	1.11817
1 TO	2	1.03492
1 TO	3	.528046
1 TO	4	1.08705
1 TO	5	1.05566

3 1

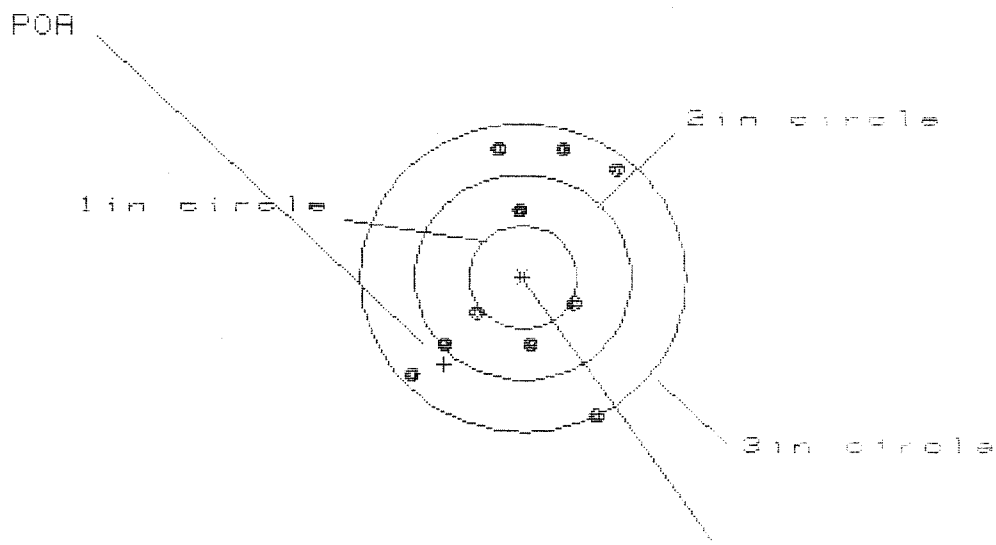
+ 52 < ----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4646
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .235
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .520652
THE AMR FOR THIS RIFLE IS: .9618

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225266

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 1.876

VS = 2.672

GS = 2.765

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.821	.898	.776
MINIMUM X	-1.055	-.978	-.764
MAXIMUM Y	1.291	1.137	1.001
MINIMUM Y	-1.381	-1.093	-.985
CENTROID X	.730	.653	.775
CENTROID Y	.847	1.001	1.137
POA TO CENTROID in.	1.118	1.195	1.376
MIN RADIUS	.509	.481	.353
MEAN RADIUS	1.017	.957	.882
MAX RADIUS	1.546	1.466	1.247
HORIZONTAL SPREAD	1.876	1.876	1.540
VERTICAL SPREAD	2.672	2.230	1.986
EXTREME SPREAD	2.765	2.765	2.359
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225266

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 8

AS= 3.082

VS= 3.449

GS= 4.233

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.863	1.001	.873
MINIMUM X	:	-1.229	-1.022	-.675
MAXIMUM Y	:	2.610	.995	.997
MINIMUM Y	:	-.839	-.549	-.547
CENTROID X	:	.640	.433	.560
CENTROID Y	:	-.184	-.474	-.476
POA TO CENTROID in.	:	.666	.642	.735
MIN RADIUS	:	.446	.242	.259
MEAN RADIUS	:	1.038	.694	.845
MAX RADIUS	:	3.207	1.136	1.204
HORIZONTAL SPREAD	:	3.092	2.023	1.549
VERTICAL SPREAD	:	3.449	1.544	1.544
EXTREME SPREAD	:	4.233	2.038	1.980
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225266

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HSE = 2.0000

VSE = 2.2200

GSE = 2.3400

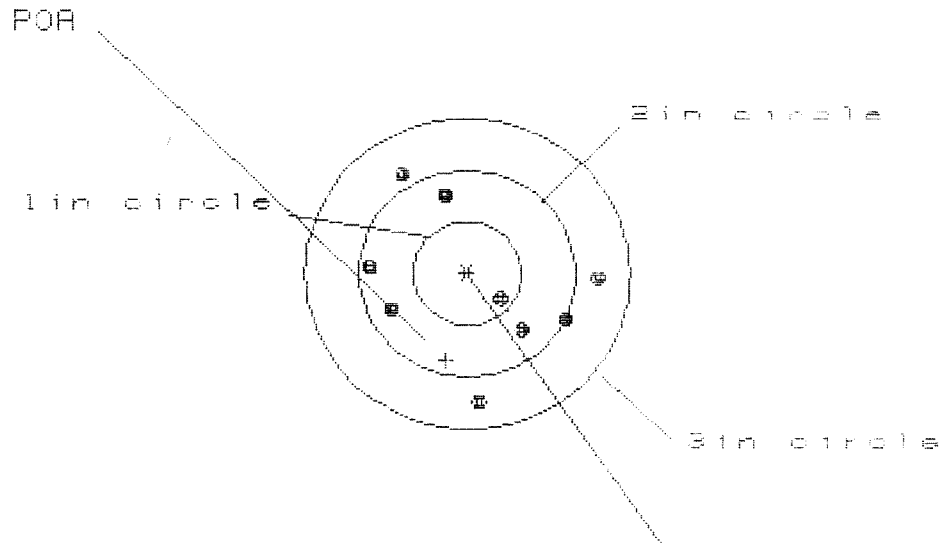
CENTROID +

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	1.176	1.101
MINIMUM X	-.926	-.912	-.987
MAXIMUM Y	1.009	.874	.928
MINIMUM Y	-1.211	-.644	-.534
CENTROID X	.202	.187	.262
CENTROID Y	.840	.975	.865
POR TO CENTROID in.	.864	.993	.904
MIN RADIUS	.396	.506	.374
MEAN RADIUS	.939	.907	.872
MAX RADIUS	1.218	1.188	1.129
HORIZONTAL SPREAD	2.088	2.088	2.088
VERTICAL SPREAD	2.220	1.518	1.462
EXTREME SPREAD	2.340	2.120	2.091
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225266

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HSI = 2.0000

VSI = 2.2200

QSI = 2.3400

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.161	1.176	1.101
MINIMUM X	-.926	-.912	-.987
MAXIMUM Y	1.009	.874	.928
MINIMUM Y	-1.211	-.644	-.534
CENTROID X	.202	.187	.262
CENTROID Y	.840	.975	.865
POA TO CENTROID in.	.864	.993	.904
MIN RADIUS	.396	.506	.374
MEAN RADIUS	.939	.907	.872
MAX RADIUS	1.218	1.188	1.129
HORIZONTAL SPREAD	2.088	2.088	2.088
VERTICAL SPREAD	2.220	1.518	1.462
EXTREME SPREAD	2.340	2.120	2.091
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225266

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 8

HS= 3.445

VS= 2.203

GS= 3.908

PATTERN #	1	4	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.355	1.123	.497
MINIMUM X	-2.090	-.738	-.597
MAXIMUM Y	.761	.805	.631
MINIMUM Y	-1.442	-1.398	-1.036
CENTROID X	.368	.601	.460
CENTROID Y	-.178	-.222	-.048
POR TO CENTROID in.	.409	.641	.463
MIN RADIUS	.129	.301	.219
MEAN RADIUS	.894	.768	.585
MAX RADIUS	2.128	1.793	1.097
HORIZONTAL SPREAD	3.445	1.861	1.094
VERTICAL SPREAD	2.203	2.203	1.667
EXTREME SPREAD	3.908	2.663	1.673
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

12 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C82252B6

CENTERFIRE PATTERNS # 5

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= 2.614

VS= 2.210

GS= 2.847

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.215	.870	.712
MINIMUM X	-1.399	-1.264	-.899
MAXIMUM Y	.963	.863	.880
MINIMUM Y	-1.247	-1.347	-1.330
CENTROID X	.383	.248	.407
CENTROID Y	-.150	-.050	-.067
POR TO CENTROID in.	.412	.254	.412
MIN RADIUS	.361	.435	.355
MEAN RADIUS	.921	.856	.777
MAX RADIUS	1.508	1.353	1.360
HORIZONTAL SPREAD	2.614	2.134	1.611
VERTICAL SPREAD	2.210	2.210	2.210
EXTREME SPREAD	2.847	2.265	2.265
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	