

C6225327

New Remington

E 6374580

MODEL 700TM M24

Model 700 M24TM

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

Smead®

CONTRACT # DAAA21-87-C-0086GUN SERIAL # *C 6225327*

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 <i>RB</i>		<i>7/24/89</i>	<i>WB</i>
620	Apply Coatings (Barrel Action)		<i>7/25/89</i>	<i>TA</i>
	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		<i>7/27/89</i>	<i>JO</i>

op. #	BARBER M24 0012903 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability						7/27/89	JO
	I) Firing Pin Indent							
	J) Assemble Stock						7/30/89	RW
	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	2.05	2.01	2.05	2.07	2.07	8/2/89	JS
	C) Function						8/2/89	JS
660	Pack						8/3/89	WB

RECEIVING AND ESTIMATING REPORT

COMMENTS

WOG 4 OF 4/MODEL M24/W LEUPOLD SCOPE 10 POWER

INITIAL "B"	CUSTOMER ORDER NO.						
DATE RECEIVED 04/05/89	DATE OPENED 04/10/89	DATE CODE KI 5-88	SERIAL NUMBER C6225327	MODEL AND GRADE 9999 7.62 NATO		ORDER R 89-12002	
ACCESSORIES <i>W.B.</i> NO SLING STRAP W/STUDS W/SWIVELS							

FROM:

MAINTENANCE DIVISION USAIC
ATT ATZB-DL-MA-Q BLDG 228
FORT BENNING GA 31905-5174

SHIP TO:

MAINTENANCE DIVISION USAIC
ATT ATZB-DL-MA-Q BLDG 228
FORT BENNING GA

31905-5174

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	WRITE ☐	PROM. DATE	ESTIMATED	VIA UPS
----------------	--------------------	--------------------------------	------------	-----------	------------

REPAIR CHARGE	TAX	INSURANCE	UPS	PARCEL POST	TOTAL
---------------	-----	-----------	-----	-------------	-------

GUN CONDITION:

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

CUSTOMER'S REQUEST

REFIT STOCK TO BARREL ACTION

MAIN FAULT

1) STRIP & APPLY NEW BARREL COATING

MISSING PARTS IN DEPLOYMENT

2) RECOAT SWIVELS & STUDS

PARTS KIT REPLACED	3) CLEAN & TEST TRIGGER ASSEMBLY
1- 96023- SLING SWIVEL	4) REPAIR & FIT STOCK TO BARREL ACTION
1- 96022- SWIVEL STUD	5) CLEAN COMPONENT CARRYING CASE
1- 96044- REAR SCOPE DUST COVER	
1- 96060 - 1/2" COMBO WRENCH	
1- 96116 - CLEANING PATCHES	
1- SET OF ALLEN WRENCHES	
# 96108, 96109, 96110, 96111, 96112, 96051, 96052	
REPAIRMAN <i>RW</i>	PROOF <i>AC</i>
GALLERY TESTER <i>AC</i>	DATE 4/11/89
	DATE 4/11/89
	DATE 4/11/89
	DATE 4/11/89

RD6925 REV. 6/88

OFFICE COPY

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 001290412943

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

SERIAL NO. C62537
DATE 27 July 89
TESTER JRU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56		2.77	2.05	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.54		2.59	2.01	
PULL #3	2.60		2.63	2.05	
PULL #4	2.67		2.55	2.07	
PULL #5	2.67		2.49	2.07	
TOTAL	13.04		13.03	10.25	
AVG.	2.608		2.606	2.05	

	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	3.99			
PULL #2	4.20			
PULL #3	4.32			
PULL #4	4.32			
PULL #5	4.26			
TOTAL	21.09			
AVG.	4.218			

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6725327

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			
620	Apply Coatings (Barrel Action)		4/7/89	TJA
	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			

BARBER - M24 0012907		READINGS			DATE	INIT
op. #	OP. NAME					
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	78 R	75 L		0 H	4/11/89
	A) Time	51647-114 \$ 1- 105407				4/
	B) Malfunctions	GROUP			0 H	4/
	C) Pierced Primers					89
	D) Optical Clarity of Scope					
645	Inspect for Live Ammo				0 H	4/11/89
655	Final Inspection				12 April 89	928
	A) Headspace				13 April 89	928
	B) Trigger Pull	215	221	223	237	223
	C) Function				12 April 89	928
660	Pack					

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

Repair

SERIAL NO. ~~662531~~ 662531
DATE 10 April 89
TESTER JJS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.19	2.35			MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.16	2.52			
PULL #3	2.21	2.57			
PULL #4	2.29	2.49			
PULL #5	2.25	2.46			
TOTAL	11.06	12.39			
AVG.	2.212	2.478			

	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				
PULL #2				
PULL #3				
PULL #4				
PULL #5				
TOTAL				
AVG.				

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225327*

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

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225327

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		8/23/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/23/88	RW
	C) Inspect Ejector Hole for Chamfer		8/23/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/23/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		24 Aug 88	J.U. W.B.
	F) Safety on Force	5 3/4 6 1/4 6 3/4	24 AUG 88	J.U. W.B.
	G) Safety off Force	3 3/4 3 1/4 3 1/4	24 AUG 88	J.U. W.B.
	H) Trigger Pull Test & Retainability		24 Aug 88	J.U. W.B.
	I) Firing Pin Indent	.022 .022 .022	24 AUG 88	J.U. W.B.
	J) Assemble Stock		8/25/88	RW
	K) Assemble Swivel Studs			
	L) Attach Front & Rear Sight Assemblies		9/6/88	RW
	M) Iron Sight Alignment		9/6/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/6/88	RW
	O) Attach Scope to Rifle	48E	9/8/88	RW
	P) Detach & Attach Scope 20 times	75 R 78 L	9/8/88	W.B.
640	Gallery Target & Test	13120	9/9/88	F.S.
	A) Optical Clarity of Scope	OK	9/9/88	F.S.
645	Inspect for Live Ammo		9/12/88	W.B.
655	Final Inspection			
	A) Headspace	OK	9/30/88	J.S.
	B) Trigger Pull	OK	9/30/88	J.S.
	C) Function	OK	9/30/88	J.S.
660	Pack		10-21-88	J.S.

88299

5081

GA. GUN
CAL. #

MOD. #	DATE	MALFUNCTION/DEFECT	ASSEM. #
640	1st	Ejector sticks down	5327
	2nd	Removed Brass from Ejector hole Cleaned Ejector hole	
6/14	3rd	SMB SMB	94
	4th	RETEST of 100 Rds	94

FUNCTION RD 6654 Rev 1



TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	<i>RETEST</i> <i>OK</i> <i>100 Rd.</i>	<i>9/14/88</i>
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225327

CENTROIDAL DISTANCES

0 TO	1	.245073
1 TO	2	.785132
1 TO	3	1.25775
1 TO	4	1.00948
1 TO	5	.935036

$\bar{x}$
 $\bar{y}$
t <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1728
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .5708
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .596383
THE AMR FOR THIS RIFLE IS: .8832

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225327A

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in - 4

2in - 8

3in = 9

HS= 2.151

VS= 2.797

GS= 2.816

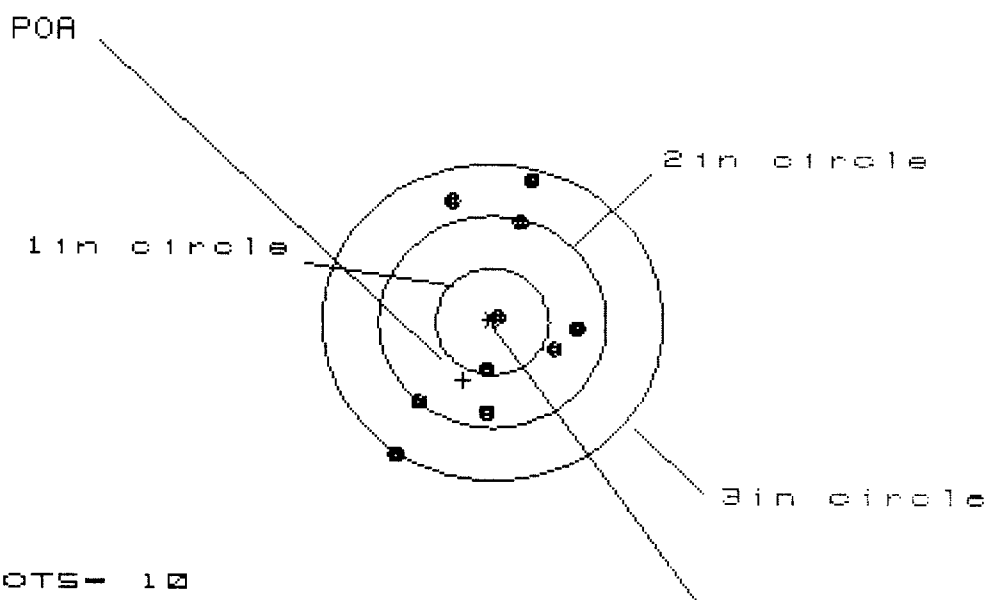
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.315	.605
MINIMUM X	:	-.794	-.836	-.672
MAXIMUM Y	:	2.030	.648	.658
MINIMUM Y	:	-.767	-.542	-.532
CENTROID X	:	.110	.152	-.012
CENTROID Y	:	-.219	-.444	-.454
POA TO CENTROID in.	:	.245	.470	.454
MIN RADIUS	:	.185	.307	.231
MEAN RADIUS	:	.807	.642	.534
MAX RADIUS	:	2.065	1.317	.744
HORIZONTAL SPREAD	:	2.151	2.151	1.277
VERTICAL SPREAD	:	2.797	1.190	1.190
EXTREME SPREAD	:	2.816	2.164	1.474
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225327A

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 6

3 in = 9

HS= 1.579

VS= 2.610

GS= 2.843

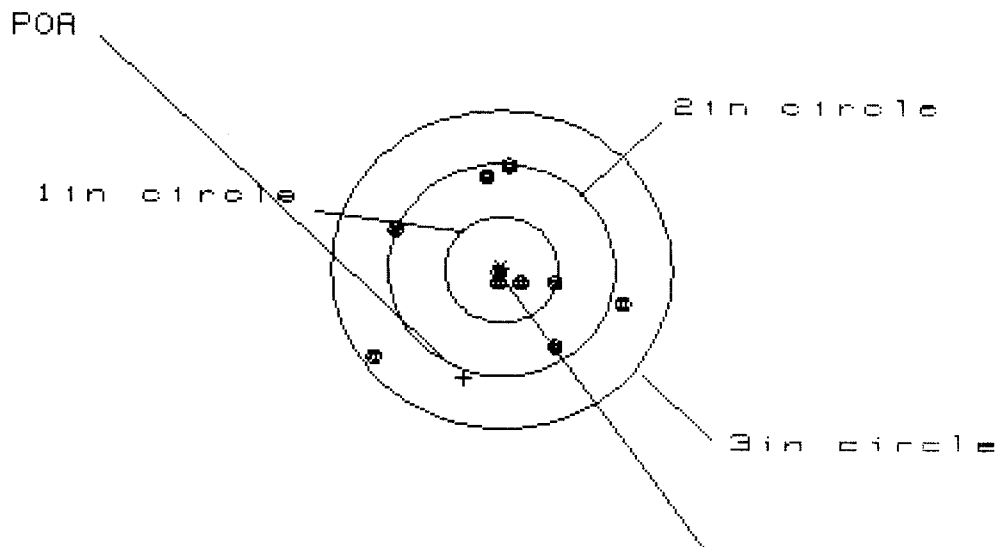
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.755	.664	.690
MINIMUM X	:	-.824	-.704	-.678
MAXIMUM Y	:	1.320	1.176	1.187
MINIMUM Y	:	-1.290	-.967	-.820
CENTROID X	:	.253	.344	.318
CENTROID Y	:	.553	.697	.550
POA TO CENTROID in.	:	.608	.777	.635
MIN RADIUS	:	.097	.088	.062
MEAN RADIUS	:	.880	.805	.728
MAX RADIUS	:	1.531	1.195	1.266
HORIZONTAL SPREAD	:	1.579	1.368	1.368
VERTICAL SPREAD	:	2.610	2.143	2.007
EXTREME SPREAD	:	2.843	2.244	2.027
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225327A

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.109

VS= 1.849

GS= 2.192

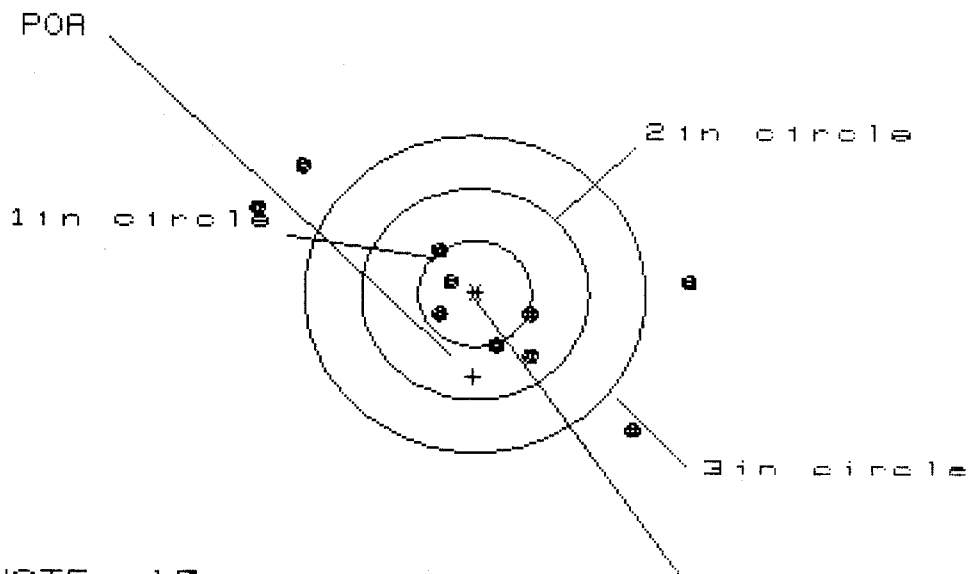
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.021	.980	.501
MINIMUM X	:	-1.088	-1.031	-.918
MAXIMUM Y	:	.985	.889	.843
MINIMUM Y	:	-.864	-.780	-.826
CENTROID X	:	.332	.453	.340
CENTROID Y	:	1.019	1.115	1.161
POA TO CENTROID in.	:	1.071	1.203	1.210
MIN RADIUS	:	.066	.217	.179
MEAN RADIUS	:	.697	.634	.592
MAX RADIUS	:	1.389	1.078	.966
HORIZONTAL SPREAD	:	2.109	1.931	1.419
VERTICAL SPREAD	:	1.849	1.669	1.669
EXTREME SPREAD	:	2.192	2.050	1.792
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225327A

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in - 3

2 in - 5

3 in - 6

HS- 3.813

VS= 2.482

GS= 3.934

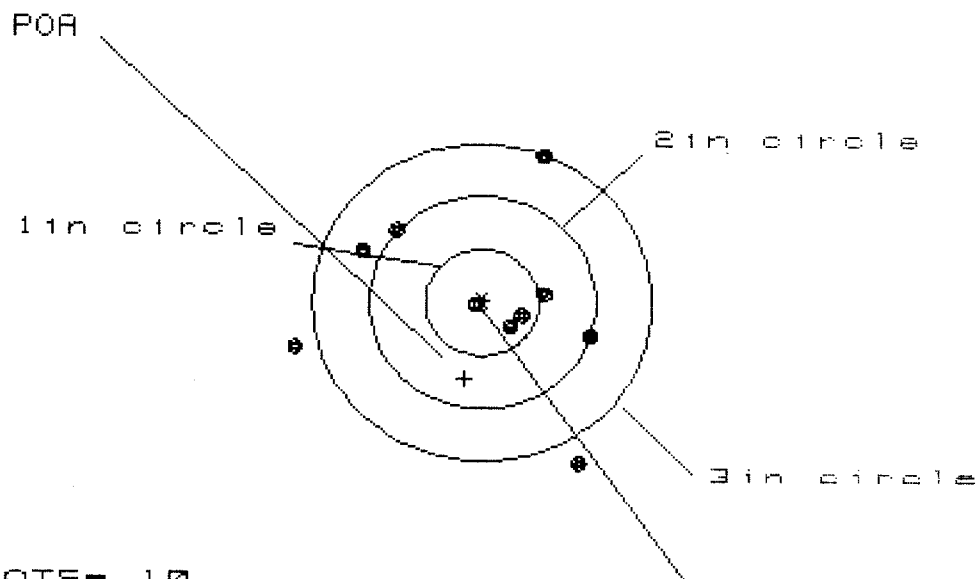
CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.872	1.656	1.434
MINIMUM X	:	-1.941	-1.775	-.793
MAXIMUM Y	:	1.218	1.310	.628
MINIMUM Y	:	-1.274	-1.182	-1.018
CENTROID X	:	.015	.231	.453
CENTROID Y	:	.786	.694	.530
POA TO CENTROID in.	:	.786	.731	.697
MIN RADIUS	:	.249	.273	.082
MEAN RADIUS	:	1.078	.952	.778
MAX RADIUS	:	2.110	2.206	1.491
HORIZONTAL SPREAD	:	3.813	3.431	2.227
VERTICAL SPREAD	:	2.492	2.492	1.646
EXTREME SPREAD	:	3.934	3.858	2.365
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

12 Sep 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225327A

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.653

VS= 2.853

GS= 2.884

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.978	.792	.879
MINIMUM X	:	-1.675	-1.234	-1.147
MAXIMUM Y	:	1.388	1.340	1.151
MINIMUM Y	:	-1.465	-1.513	-.600
CENTROID X	:	.154	.340	.253
CENTROID Y	:	.715	.763	.952
POA TO CENTROID in.	:	.731	.835	.985
MIN RADIUS	:	.116	.201	.359
MEAN RADIUS	:	.954	.842	.774
MAX RADIUS	:	1.729	1.665	1.242
HORIZONTAL SPREAD	:	2.653	2.026	2.026
VERTICAL SPREAD	:	2.853	2.853	1.751
EXTREME SPREAD	:	2.884	2.870	2.184
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C 6725327DATE 24 Aug 88TESTER J.V. W.B.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.49	2.46	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.19	2.42	2.51	2.82	
PULL #3	2.23	2.44	2.54	2.53	
PULL #4	2.25	2.45	2.53	2.80	
PULL #5	2.28	2.36	2.55	2.82	
TOTAL	11.19	12.16	12.59	13.77	
AVG.	2.24	2.44	2.52	2.75	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.02		
PULL #2	3.09	3.02		
PULL #3	3.09	2.99		
PULL #4	3.06	2.98		
PULL #5	3.07	2.96		
TOTAL	15.36	14.97		
AVG.	3.07	2.99		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.37	4.38		4.20
PULL #2	4.41	4.41		4.18
PULL #3	4.38	4.45		4.20
PULL #4	4.45	4.48		4.16
PULL #5	4.41	4.52		4.23
TOTAL	22.02	22.24		20.97
AVG.	4.40	4.44		4.19