

£ 6374564

2444

MODEL 700™ M24

Model	700 M24TH
Action	

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

00000

[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225341*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>1/22</i>	<i>FB</i>
600	PROOF	<i>1/28/88</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>PJC</i>
	MAGNAFLUX BOLT	<i>2/25/88</i>	<i>PJC</i>
620	COATING	<i>2/21/88</i>	<i>TJA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #
1270

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225341

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace	QUALITY AUDIT		
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		9/8/88	AW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/8/88	AW
	C) Inspect Ejector Hole for Chamfer		9/8/88	AW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/8/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		8 Sept 88	Ju. + RRS
	F) Safety on Force	4 4 4	8 Sept. 88	Ju. + RRS
	G) Safety off Force	2 2 2	8 Sept. 88	Ju. + RRS
	H) Trigger Pull Test & Retainability		8 Sept. 88	Ju. + RRS
	I) Firing Pin Indent	.0205 .021 .021	8 Sept. 88	Ju. + RRS
	J) Assemble Stock		9/20/88	RW
	K) Assemble Swivel Studs		10-7-88	JSJ
	L) Attach Front & Rear Sight Assemblies		9/20/88	RW
	M) Iron Sight Alignment		9/20/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/20/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	JSJ
640	Gallery Target & Test	50 R 105L	10/6/88	W.B.
	A) Optical Clarity of Scope		10/6/88	W.B.
645	Inspect for Live Ammo		10/6/88	W.B.
655	Final Inspection			
	A) Headspace		10-7-88	JSJ
	B) Trigger Pull		10-7-88	JSJ
	C) Function		10-7-88	JSJ
660	Pack		10-21-88	JSJ

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225341

DATE 8 Sept. 88

TESTER J. V. + G. S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.50	2.63	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.47	2.55	2.58	
PULL #3	2.35	2.48	2.54	2.56	
PULL #4	2.31	2.52	2.58	2.56	
PULL #5	2.43	2.52	2.50	2.60	
TOTAL	12.38	12.59	12.80	12.89	
AVG.	2.476	2.518	2.56	2.578	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.04		
PULL #2	3.06	3.04		
PULL #3	3.06	3.04		
PULL #4	3.09	3.06		
PULL #5	3.08	3.09		
TOTAL	15.40	15.27		
AVG.	3.08	3.054		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	3.97		4.19
PULL #2	4.06	4.12		4.16
PULL #3	4.10	4.09		4.16
PULL #4	4.10	4.11		4.17
PULL #5	4.07	4.06		4.17
TOTAL	20.33	20.35		20.85
AVG.	4.066	4.07		4.17

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225341

CENTROIDAL DISTANCES

0 TO	1	1.21876
1 TO	2	.874488
1 TO	3	.855337
1 TO	4	.237548
1 TO	5	1.24932

2
5 3 41

+ (----POA

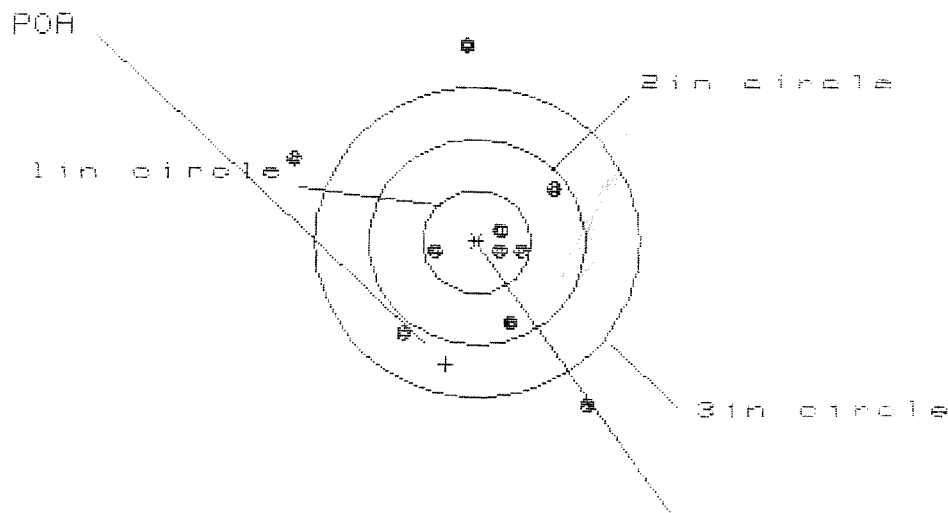
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.296
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.3028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.336

THE AMR FOR THIS RIFLE IS: 1.118

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225341

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 5

3 in = 7

HS = 2.636

VS = 3.445

GS = 3.618

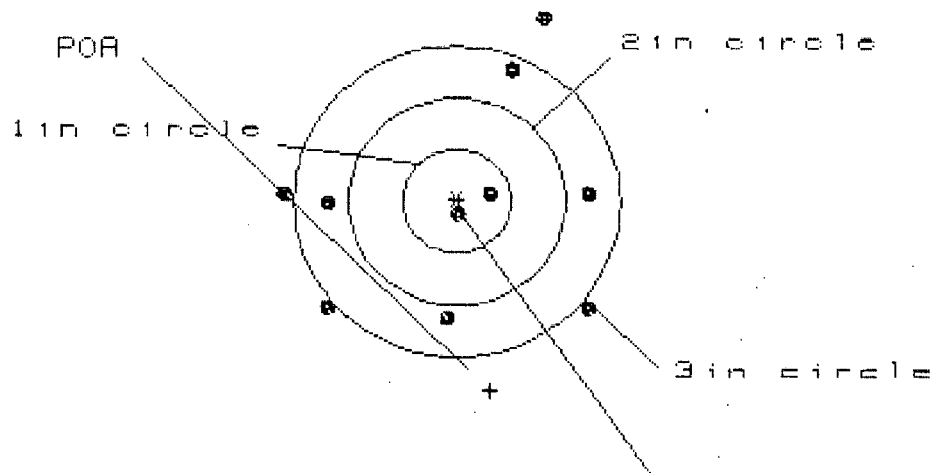
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.975	.961	.751
MINIMUM X	-1.661	-1.675	-.892
MAXIMUM Y	1.909	1.817	.873
MINIMUM Y	-1.536	-1.324	-1.196
CENTROID X	.289	.303	.513
CENTROID Y	1.184	.972	.845
POA TO CENTROID in.	1.218	1.018	.988
MIN RADIUS	.240	.247	.256
MEAN RADIUS	.970	.856	.704
MAX RADIUS	1.914	1.960	1.413
HORIZONTAL SPREAD	2.636	2.636	1.643
VERTICAL SPREAD	3.445	2.341	2.069
EXTREME SPREAD	3.618	3.525	2.090
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225341

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 2

3 in = 6

HS= 2.822

VS= 2.838

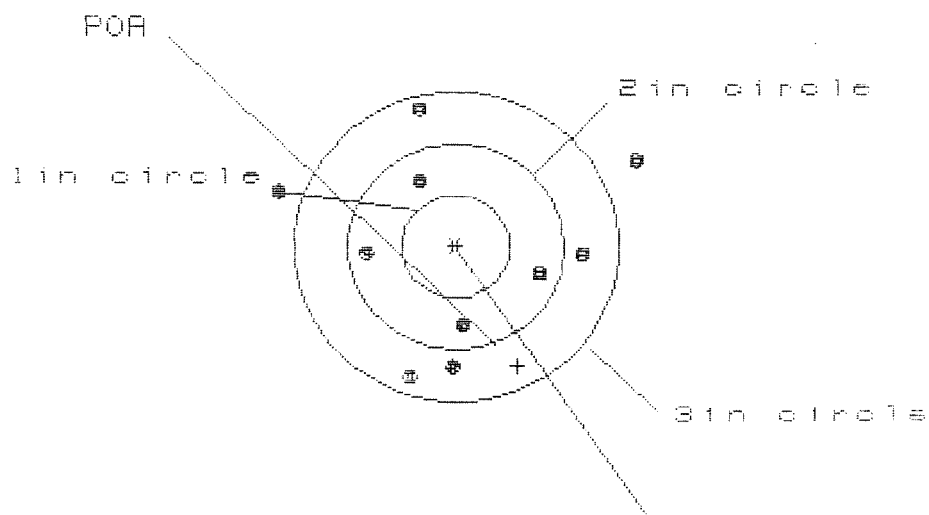
GS= 3.372

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.246	1.333	1.458
MINIMUM X	-1.576	-1.489	-1.322
MAXIMUM Y	1.755	1.468	1.365
MINIMUM Y	-1.083	-0.888	-0.991
CENTROID X	-0.308	-0.395	-0.562
CENTROID Y	1.823	1.628	1.731
POA TO CENTROID in.	1.848	1.675	1.820
MIN RADIUS	.116	.101	.225
MEAN RADIUS	1.199	1.107	1.057
MAX RADIUS	1.924	1.584	1.562
HORIZONTAL SPREAD	2.822	2.822	2.780
VERTICAL SPREAD	2.838	2.356	2.356
EXTREME SPREAD	3.372	3.043	2.817
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225341

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.337

VS= 2.677

GS= 3.338

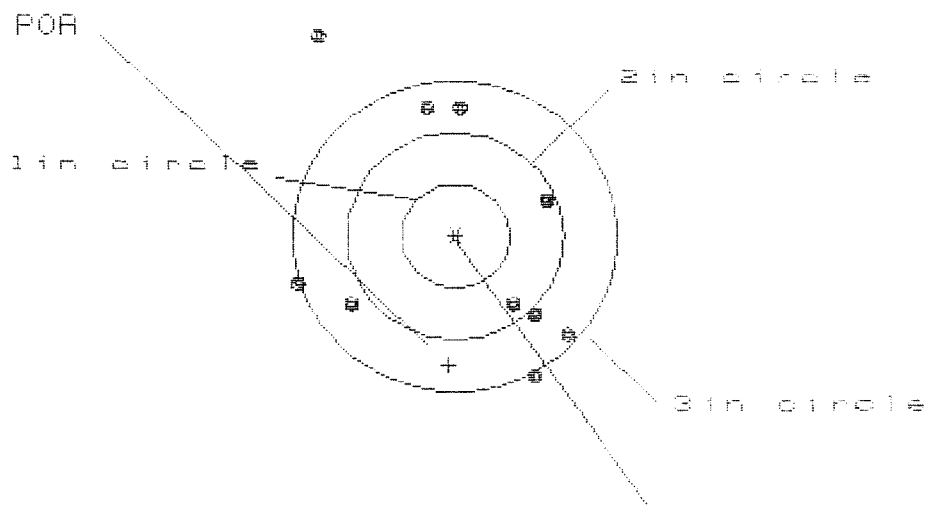
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.701	1.373	1.193
MINIMUM X	:	-1.626	-1.437	-0.866
MAXIMUM Y	:	1.384	1.477	1.559
MINIMUM Y	:	-1.293	-1.200	-1.118
CENTROID X	:	-0.566	-0.755	-0.575
CENTROID Y	:	1.160	1.067	0.985
POA TO CENTROID in.	:	1.291	1.307	1.141
MIN RADIUS	:	0.719	0.665	0.545
MEAN RADIUS	:	1.192	1.090	1.015
MAX RADIUS	:	1.894	1.581	1.596
HORIZONTAL SPREAD	:	3.327	2.810	2.059
VERTICAL SPREAD	:	2.677	2.677	2.677
EXTREME SPREAD	:	3.338	2.870	2.680
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225341

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 2.579

VS= 3.316

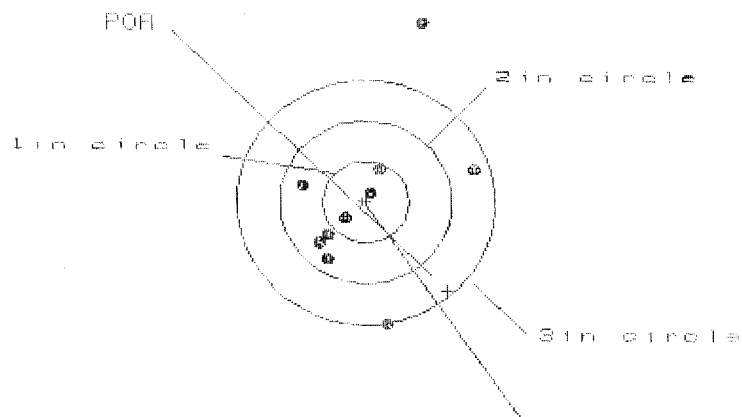
GS= 3.836

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.078	.941	.737
MINIMUM X	-1.501	-1.638	-1.322
MAXIMUM Y	1.945	1.492	1.464
MINIMUM Y	-1.371	-1.155	-1.183
CENTROID X	.062	.199	.403
CENTROID Y	1.254	1.038	1.066
POA TO CENTROID in.	1.255	1.057	1.140
MIN RADIUS	.878	.641	.546
MEAN RADIUS	1.337	1.182	1.082
MAX RADIUS	2.302	1.653	1.567
HORIZONTAL SPREAD	2.579	2.579	2.059
VERTICAL SPREAD	3.316	2.647	2.647
EXTREME SPREAD	3.836	2.801	2.801
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		

6 OCT 1986

FILE:/PATTERNING/CENTERFIRE_PATT/08225341

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 0

HS= 2.008

VS= 3.704

GS= 3.719

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.241	1.309	1.353
MINIMUM X	:	-1.767	-1.699	-1.655
MAXIMUM Y	:	2.205	1.847	1.490
MINIMUM Y	:	-1.499	-1.254	1.044
CENTROID X	:	-1.957	-1.025	-1.069
CENTROID Y	:	1.093	1.848	1.005
POA TO CENTROID in.	:	1.453	1.331	1.467
MIN RADIUS	:	1.111	1.183	1.164
MEAN RADIUS	:	1.891	1.705	1.609
MAX RADIUS	:	2.288	1.460	1.439
HORIZONTAL SPREAD	:	2.008	2.008	2.008
VERTICAL SPREAD	:	3.704	1.901	1.134
EXTREME SPREAD	:	3.719	2.130	2.044
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225341

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		JUL 29 1991	RW
600	Proof		JUL 29 1991	RW
607	Check Headspace		JUL 29 1991	RW
610	Dis-assemble Gun		JUL 29 1991	RW
612	Magnaflux Barrel Action		JUL 30 1991	KCR
	Magnaflux Bolt		JUL 30 1991	KCR
615	Rollmark Caliber		JUL 30 1991	CS
617	Drill and Tap Sight Holes		JUL 30 1991	LB
618	Polish Barrel		JUL 31 1991	WB
620	Apply Coatings (Barrel Action)		AUG 1 1991	TJA
	Apply Coating (Bolt)		AUG 1 1991	TJA
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. #	BARBER - M24 0013154	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						9-25-91	AC
	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						9-23-91	AF
	A) Time						"	AF
	B) Malfunctions						"	AF
	C) Pierced Primers						"	AF
	D) Optical Clarity of Scope						"	AF
645	Inspect for Live Ammo						9-23-91	AF
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.26	2.20	2.25	2.21	2.19	9/24/91	AF
	C) Function						9-25-91	AC
660	Pack						9/25/91	WB

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06625341
23 Sep 1991

CENTROIDAL DISTANCES

0 TO 1	.282676
1 TO 2	.342218
1 TO 3	.171773
1 TO 4	.134347
1 TO 5	.428747

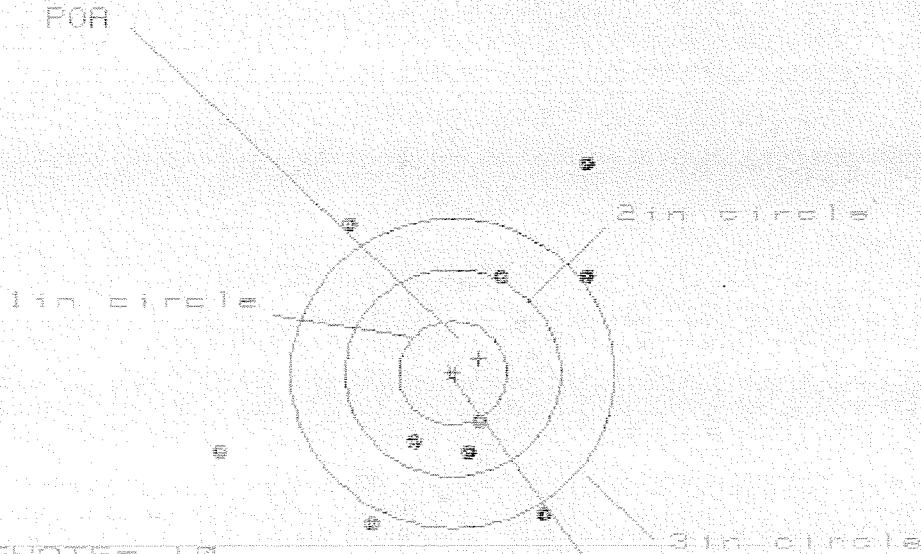
-----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0468
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1764
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .182502
THE AMR FOR THIS RIFLE IS: 1.219

23 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6625341

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 0

2in = 3

3in = 4

HS= 3.402

VS= 3.546

CS= 4.419

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.236	1.373	1.119
MINIMUM X	-2.166	-2.029	-1.061
MAXIMUM Y	2.041	1.666	1.595
MINIMUM Y	-1.505	-1.278	-1.349
CENTROID X	-.245	-.381	-.127
CENTROID Y	-.141	-.368	-.297
POA TO CENTROID in.	.232	.529	.323
MIN RADIUS	.500	.452	.306
MEAN RADIUS	1.428	1.279	1.153
MAX RADIUS	2.380	2.107	1.916
HORIZONTAL SPREAD	3.402	3.402	2.180
VERTICAL SPREAD	3.546	2.944	2.944
EXTREME SPREAD	4.419	3.840	3.305
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	4		

23 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8625341

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 8

HS = 2.581

VS = 4.847

GS = 4.142

CENTROID #

PATTERN #

2

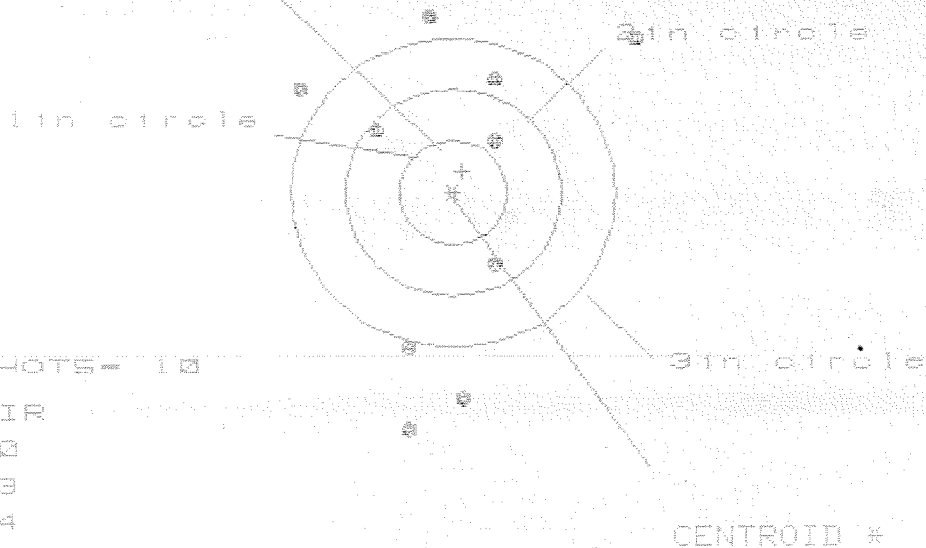
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.329	1.242	1.245
MINIMUM X	-1.252	-1.339	-1.336
MAXIMUM Y	2.100	1.092	.878
MINIMUM Y	-1.947	-1.713	-1.251
CENTROID X	.087	.174	.171
CENTROID Y	-.058	-.292	-.878
POA TO CENTROID in.	.105	.339	.188
MIN RADIUS	.479	.543	.411
MEAN RADIUS	1.176	1.056	.934
MAX RADIUS	2.240	1.713	1.453
HORIZONTAL SPREAD	2.581	2.581	2.581
VERTICAL SPREAD	4.847	2.805	2.128
EXTREME SPREAD	4.142	2.842	2.789
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

23 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6625341

CENTERFIRE PATTERNS # 3

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 4

HS = 2.106

VS = 4.044

GS = 4.323

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.712

1.671

.601

MINIMUM X

-1.394

-1.435

-1.226

MAXIMUM Y

1.732

1.475

1.628

MINIMUM Y

-2.312

-2.282

-2.129

CENTROID X

-.086

-.045

-.254

CENTROID Y

-.206

.051

-.102

POA TO CENTROID in.

.223

.068

.274

MIN RADIUS

.680

.471

.730

MEAN RADIUS

1.528

1.395

1.321

MAX RADIUS

2.341

2.284

2.150

HORIZONTAL SPREAD

3.106

3.106

1.827

VERTICAL SPREAD

4.044

3.757

3.757

EXTREME SPREAD

4.323

3.844

3.770

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

3

NUMBER IN THREE INCH CIRCLE =

4

23 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6625341

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.875

VS= 2.708

GS= 2.774

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.875	.877	.956
MINIMUM X	-1.000	-.998	-.919
MAXIMUM Y	1.690	.869	.764
MINIMUM Y	-1.028	-.841	-.592
CENTROID X	-.113	-.115	-.194
CENTROID Y	-.116	-.302	-.197
POA TO CENTROID in.	.161	.324	.277
MIN RADIUS	.177	.363	.264
MEAN RADIUS	.860	.755	.707
MAX RADIUS	1.681	1.175	1.171
HORIZONTAL SPREAD	1.875	1.875	1.875
VERTICAL SPREAD	2.708	1.710	1.356
EXTREME SPREAD	2.774	2.232	2.232
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

23 Sep 1991

FILE: PATTERNING/CENTERFIRE_PATT/C6625341

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS - 10

IN CIR

1in = 3

2in = 4

3in = 6

LS = 1.759

VS = 3.524

GS = 3.524

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 =

5

10

9

8

-.915

-.892

-.788

-.844

-.867

-.689

1.922

1.775

1.081

-1.602

-1.389

-1.167

.123

.146

.255

-.361

-.574

-.796

.381

.593

.728

.315

.235

.160

1.103

.976

.820

1.934

1.976

1.282

1.759

1.759

1.472

3.524

3.164

2.248

3.524

3.236

2.42

3

4

6

RECEIVING AND ESTIMATING REPORT

COMMENTS
M-24 SNIPER

ORDER
R 91-14528

SCOPE BASE

SHIP TO:

CD D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
USA 28367

VIA
DOOR

TOTAL	100
-------	-----

☐ MARRED

CUSTOMER'S REQUEST

- 1) NEW BARREL
- 2) RE-POWDER COAT TRIGGER GUNAD ASSY
- 3) CLEAN FIRE CONTROL

MAIN FAULT

PARTS

PATTERN

DATE _____

RD6925 REV. 7/90

BARBER - M24 0043181

BARBER M24-0013162 RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 93-26584

INITIAL FPS	CUSTOMER ORDER NO. 8326	M06 6 OF 7 M-24 ATTN: FRED MARTIN W/ADJUSTABLE RECOIL PAD			
DATE RECEIVED 12/09/93	DATE OPENED 12/09/93	DATE CODE OL 7-91	SERIAL NUMBER C6225341	NEW SERIAL NUMBER	MODEL AND GRADE 700 7.62 NATO
ACCESSORIES W/STUDS		SCOPE BASE			

FROM:

SHIP TO:

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

U. S. ARMY
THOMPSON, ALLAN R
CO. D 2ND BN. 1ST SWTG
FT BRAGG NC 28307

CUST NO: 088383 C.O.D L

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

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
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

Replace Barrel Assy

PARTS

COMMENTS

Barrel Assy - 96003
Front Sight mounting - Base - 96011 Studs.

Re-zinc - Scope Base & Swivel
Repainter Coat - Floor plate, latch,
Trigger Guard & Rear Sight Base

W52 H094011/H229

REPAIRMAN RW	PROOF ✓	CLEAN ✓	TEST ✓	TARGET ✓	PATTERN
GALLERY TESTER RW	DATE 12/23/93	DATE 12/29/93	DATE 12/29/93	DATE 12/29/93	DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0013162

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225341

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		12/16/93	RW
600	Proof		12/16/93	RW
607	Check Headspace		12/16/93	RW
610	Dis-assemble Gun		12/16/93	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/28/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/28/93	RW
	C) Inspect Ejector Hole for Chamfer		12/28/93	RW
	D) Oil Firing Pin Ass'y		12/28/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
5 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						12/29/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						12/29/93	RW
655	Final Inspection						1/3/94	RW
	A) Headspace						1/3/94	RW
	B) Trigger Pull	2.72	2.66	2.69	2.77	2.71	1/3/94	RW
	C) Function						1/3/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225341
11 Jan 1994

CENTROIDAL DISTANCES

0 TO	1	.311082
1 TO	2	.43569
1 TO	3	.242887
1 TO	4	.206039
1 TO	5	.268888

21 <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1976
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0794
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .212956
THE AMR FOR THIS RIFLE IS: .9222

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225341

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.843

VS= 1.719

GS= 2.232

PATTERN #

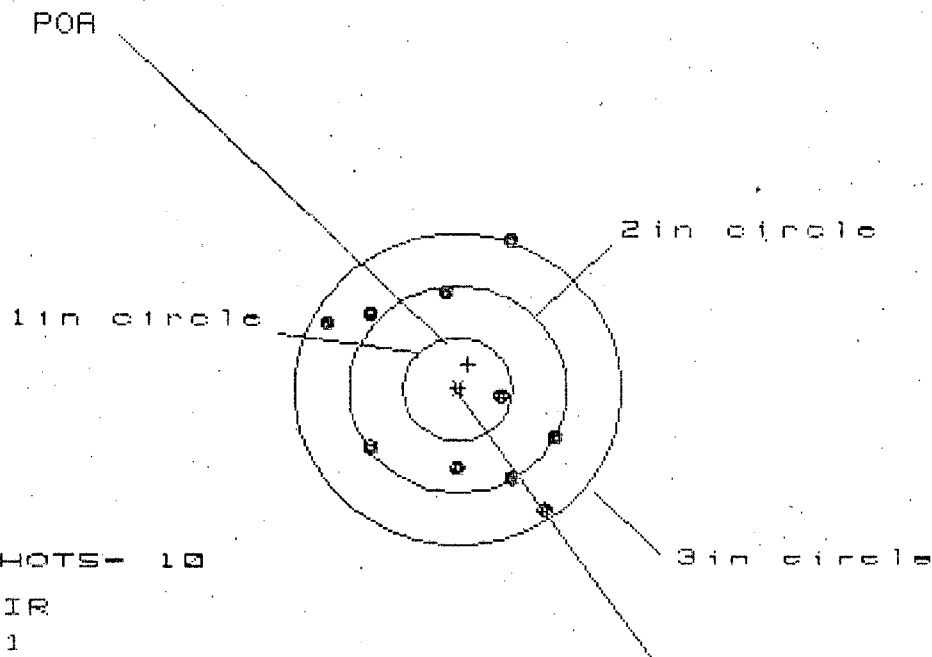
216

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.902	.718	.600
MINIMUM X	-1.041	-.940	-.602
MAXIMUM Y	.764	.664	.657
MINIMUM Y	-.955	-1.055	-1.062
CENTROID X	.304	.203	.321
CENTROID Y	-.066	.034	.041
POA TO CENTROID in.	.311	.206	.323
MIN RADIUS	.298	.315	.210
MEAN RADIUS	.776	.712	.664
MAX RADIUS	1.275	1.072	1.064
HORIZONTAL SPREAD	1.943	1.658	1.202
VERTICAL SPREAD	1.719	1.719	1.719
EXTREME SPREAD	2.232	1.846	1.846
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225341

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.097

VS= 2.626

GS= 2.729

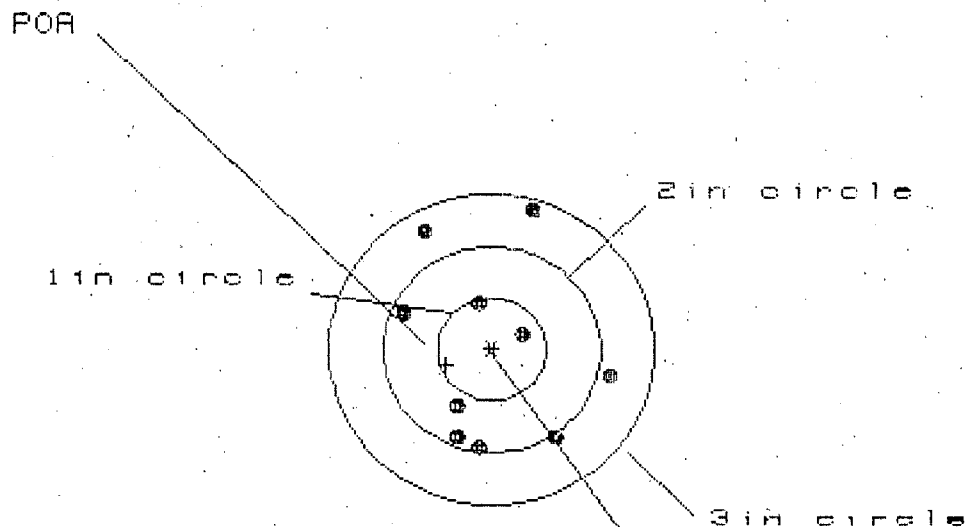
CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.862	.915	.767
MINIMUM X	-1.235	-1.182	-.941
MAXIMUM Y	1.459	1.097	1.202
MINIMUM Y	-1.167	-1.005	-.900
CENTROID X	-.095	-.148	-.000
CENTROID Y	-.241	-.403	-.508
POA TO CENTROID in.	.259	.429	.508
MIN RADIUS	.377	.418	.311
MEAN RADIUS	1.051	.978	.879
MAX RADIUS	1.533	1.450	1.383
HORIZONTAL SPREAD	2.097	2.097	1.708
VERTICAL SPREAD	2.626	2.102	2.102
EXTREME SPREAD	2.729	2.729	2.511
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C8225341

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.949

VS= 2.335

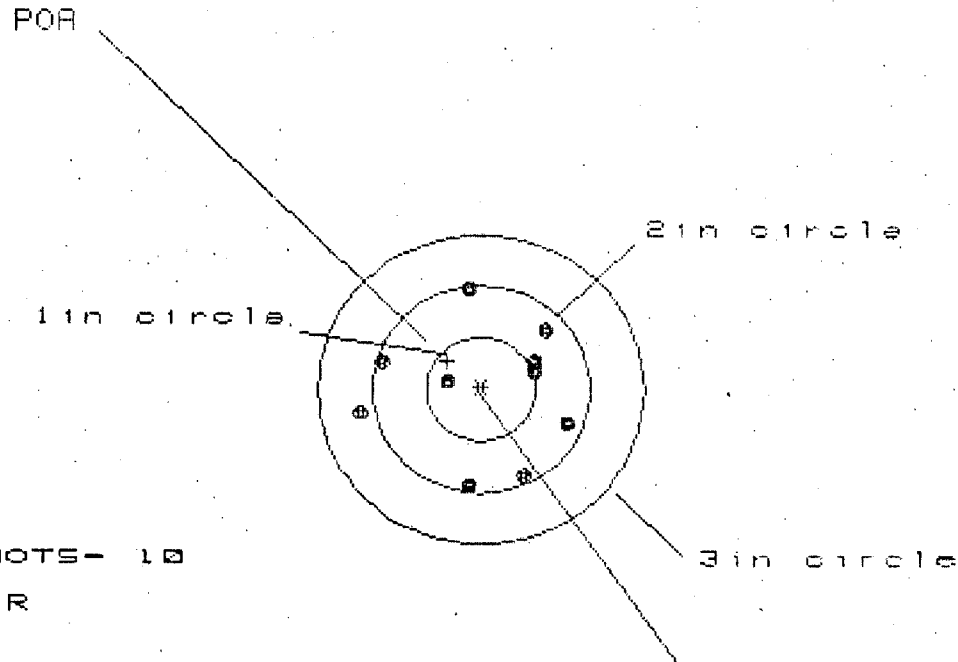
GS= 2.395

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.108	1.150	1.079
MINIMUM X	-.841	-.799	-.870
MAXIMUM Y	1.340	1.347	.766
MINIMUM Y	-.995	-.846	-.678
CENTROID X	.417	.375	.446
CENTROID Y	.149	.000	-.168
POA TO CENTROID in.	.443	.375	.477
MIN RADIUS	.321	.443	.433
MEAN RADIUS	.919	.854	.759
MAX RADIUS	1.390	1.460	1.119
HORIZONTAL SPREAD	1.949	1.949	1.949
VERTICAL SPREAD	2.335	2.193	1.444
EXTREME SPREAD	2.395	2.387	2.055
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225341

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.886

VS= 1.936

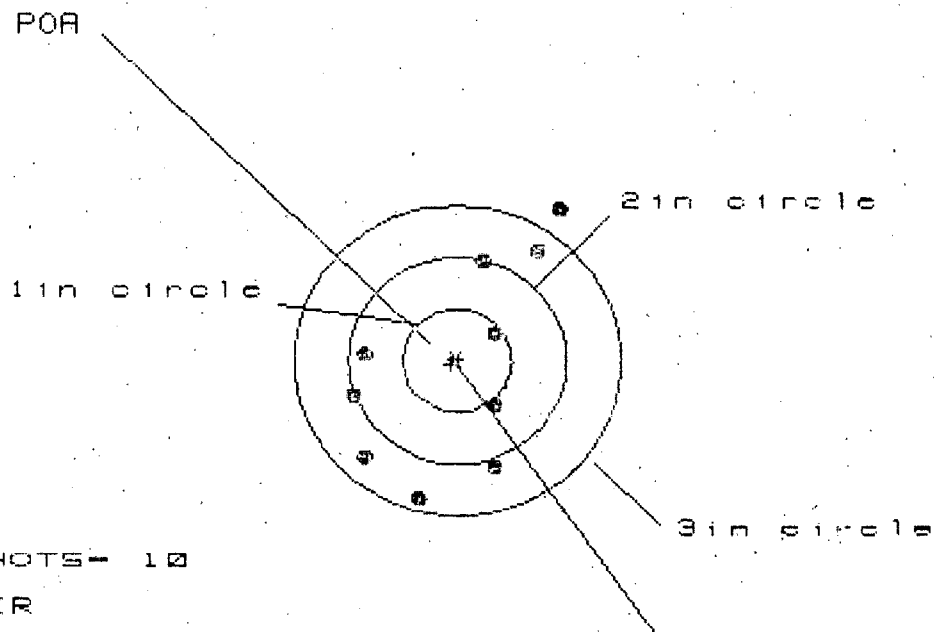
GS= 1.937

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.802	.681	.648
MINIMUM X	-1.084	-1.066	-1.099
MAXIMUM Y	.994	.965	.671
MINIMUM Y	-.942	-.971	-.850
CENTROID X	.308	.429	.462
CENTROID Y	-.272	-.243	-.364
POA TO CENTROID in.	.411	.493	.588
MIN RADIUS	.333	.357	.391
MEAN RADIUS	.797	.742	.707
MAX RADIUS	1.116	1.102	1.169
HORIZONTAL SPREAD	1.886	1.747	1.747
VERTICAL SPREAD	1.936	1.936	1.522
EXTREME SPREAD	1.937	1.937	1.856
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

11 Jan 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225341

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 1.907

VS= 2.770

GS= 3.047

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.956	.824	.798
MINIMUM X	-.951	-.845	-.871
MAXIMUM Y	1.478	1.271	1.130
MINIMUM Y	-1.292	-1.128	-1.041
CENTROID X	.054	-.052	-.026
CENTROID Y	.033	-.131	.010
POA TO CENTROID in.	.064	.141	.028
MIN RADIUS	.449	.528	.524
MEAN RADIUS	1.068	.976	.949
MAX RADIUS	1.760	1.515	1.383
HORIZONTAL SPREAD	1.907	1.669	1.669
VERTICAL SPREAD	2.770	2.399	2.171
EXTREME SPREAD	3.047	2.612	2.582
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	9		

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6225341
4 Mar 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: $-.348$
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: $-.0036$
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: $.348019$

THE AMR FOR THIS RIFLE IS: 1.309

CENTROIDAL DISTANCES

Ø TO	1	.345654
1 TO	2	.338498
1 TO	3	1.01314
1 TO	4	.5858
1 TO	5	.435147

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

REMINGTON CENTERFIRE ACCURACY TEST

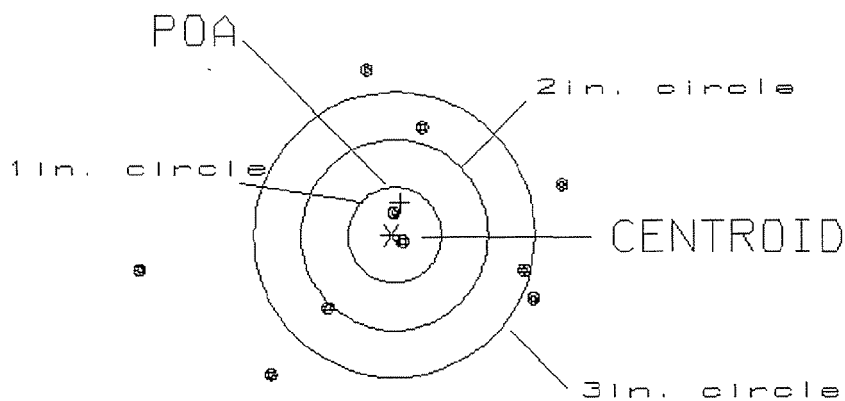
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .346
 MIN RADIUS : .110
 MEAN RADIUS : 1.417
 MAX RADIUS : 2.781
 CENTROID X : -.089
 CENTROID Y : -.334

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225341

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.55
 VS= 3.22
 GS= 4.63

2
 2
 5

REMINGTON CENTERFIRE ACCURACY TEST

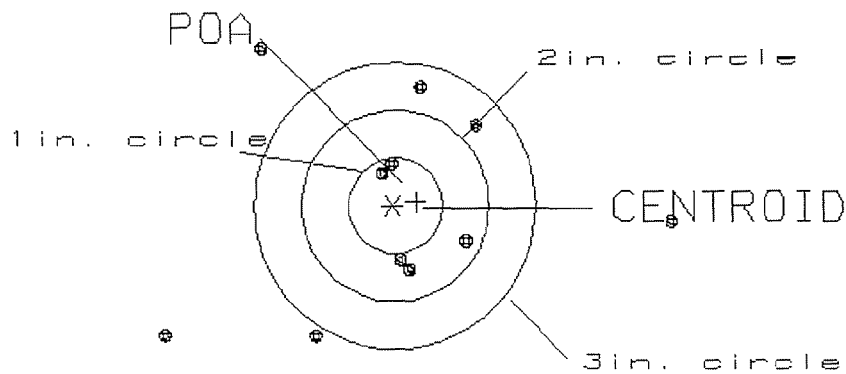
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: .258
 MIN RADIUS : .370
 MEAN RADIUS : 1.368
 MAX RADIUS : 2.973
 CENTROID X : -.255
 CENTROID Y : -.039

4 Mar 1997

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/C6225341

CENTERFIRE PATTERN # 2



OF SHOTS= 11

IN CIRCLE

HS= 5.42

2

US= 3.03

5

GS= 5.56

7

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

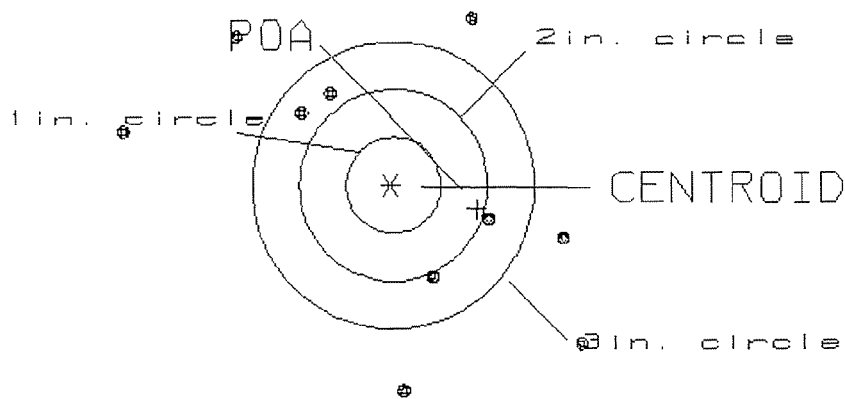
PATTERN #: 3

POA TO CENTROID: .952
 MIN RADIUS : 1.023
 MEAN RADIUS : 1.841
 MAX RADIUS : 2.954
 CENTROID X : -.919
 CENTROID Y : .247

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225341

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 4.89

0

VS= 3.92

0

GS= 5.38

4

REMINGTON CENTERFIRE ACCURACY TEST

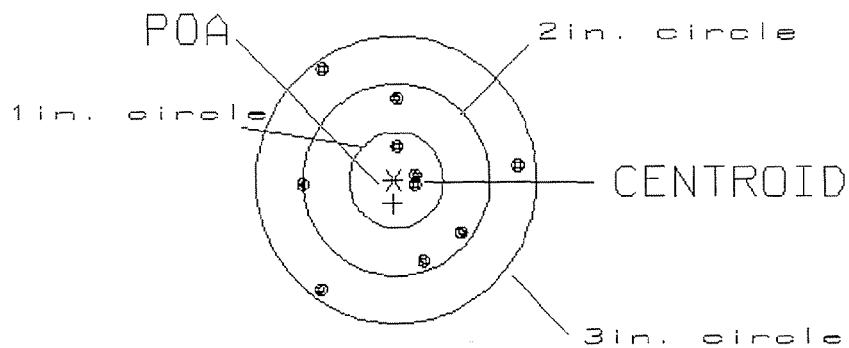
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 4
 POA TO CENTROID: .245
 MIN RADIUS : .167
 MEAN RADIUS : .840
 MAX RADIUS : 1.413
 CENTROID X : 0.000
 CENTROID Y : .245

4 Mar 1997

FILE:/Hp/basic/Accuracy/Patterning/Centerfire_Patt/C6225341

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.25

3

VS= 2.26

7

GS= 2.42

10

REMINGTON CENTERFIRE ACCURACY TEST

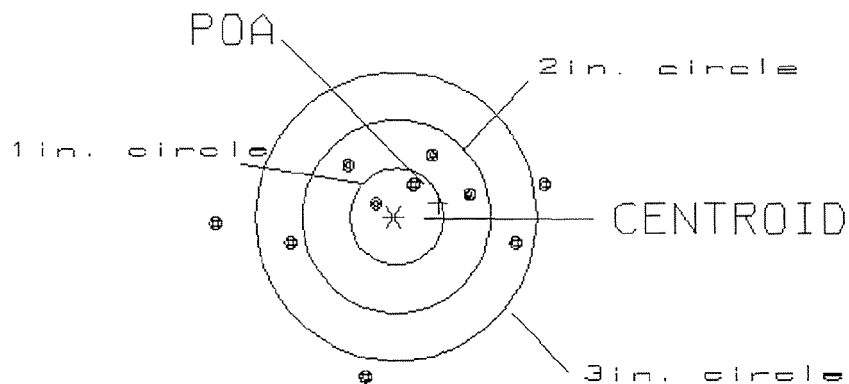
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: [5]
 POA TO CENTROID: .496
 MIN RADIUS : .292
 MEAN RADIUS : 1.078
 MAX RADIUS : 1.973
 CENTROID X : -.477
 CENTROID Y : -.137

4 Mar 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6225341

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 3.51
 VS= 2.30
 GS= 3.54

2
 5
 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

N^o 011783

DATE

1/16/97

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

MODEL: M-24

CHECK FOR AMMUNITION

GAUGE:

SERIAL # C6225341

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAIN

METAL GOOD FAIR POOR FANCY PLAIN

BARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER)

SLING: YES NO 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:

SIGNATURE: [Signature]
(Person delivering firearm to Plant)

DATE: 16 JAN 97

SIGNATURE: [Signature]
(Security Officer)

DATE: 1/16/97

SIGNATURE: [Signature]
(Firearm picked up by)

DATE:

Arm Service Copy

21 DAY TURN - AROUND

M-24

CONTRACT # DAAA09-92-C-0834

New Barrel

R&E NO.

SERIAL NO. C 6225341

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

605 CHECK HEADSPACE

610 DIS-ASSEMBLE

612 MAGNAFLUX

615 ROLLMARK CALIBER

618 ROTO-BLAST

620 APPLY COATINGS

625 A FINAL ASSEMBLY

B TRIGGER PULL TEST

C SAFETY ON FORCE

D SAFETY OFF FORCE

E FIRING PIN INDENT

640 TARGET

655 FINAL INSPECT

660 PACK

QAR INSPECTION

SHIP DATE

2/28/97

AC

2/21/97

AC

3/28/97

AC

Final Inspection

Sn: C622534 / DATE REC'D: 1/17/97 DATE RET'D:

Auditor: AN

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: _____