

New Action

C6225374

E 6374502

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

* Includes 1 in chamber.

Remington

BARBER - M24 004391813955

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225374*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2/1</i>	<i>FB</i>
600	PROOF	<i>2/2/88</i>	<i>KW</i>
615	MAGNAFLUX BARREL	<i>2/18/88</i>	<i>P/C</i>
	MAGNAFLUX BOLT	<i>3/13/88</i>	<i>P/C</i>
620	COATING	<i>8/1/88</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 # C6225374

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

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

SERIAL NO. C6225374DATE 26 Aug 88TESTER W.B. + G.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.32	2.42	2.78	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.36	2.35	2.75	
PULL #3	2.65	2.35	2.37	2.73	
PULL #4	2.61	2.34	2.36	2.79	
PULL #5	2.59	2.42	2.37	2.78	
TOTAL	12.99	11.79	11.87	13.83	
AVG.	2.598	2.358	2.374	2.766	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.14		
PULL #2	3.14	3.13		
PULL #3	3.15	3.12		
PULL #4	3.15	3.12		
PULL #5	3.14	3.15		
TOTAL	15.70	15.66		
AVG.	3.14	3.132		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.26		4.35
PULL #2	4.28	4.23		4.28
PULL #3	4.25	4.27		4.28
PULL #4	4.22	4.26		4.25
PULL #5	4.23	4.24		4.27
TOTAL	21.30	21.26		21.43
AVG.	4.26	4.252		4.286

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225374

CENTROIDAL DISTANCES

0 TO	1	.490194
1 TO	2	.26091
1 TO	3	.877253
1 TO	4	1.07844
1 TO	5	1.03702

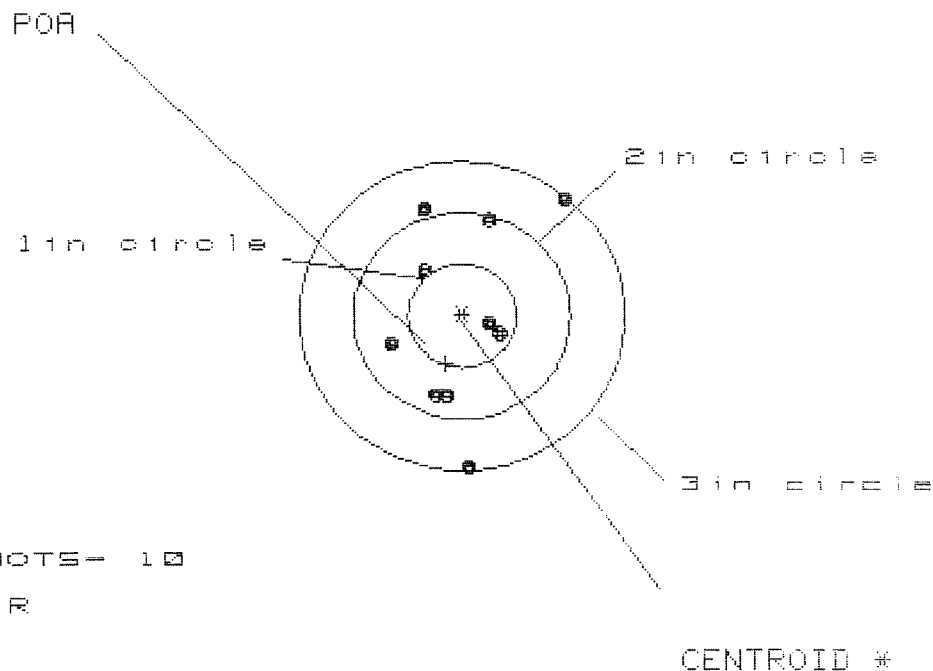
4
21
+ 3 <----POA
5

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4508
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .357
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .575039
THE AMR FOR THIS RIFLE IS: .88

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225374

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.533

VS= 2.517

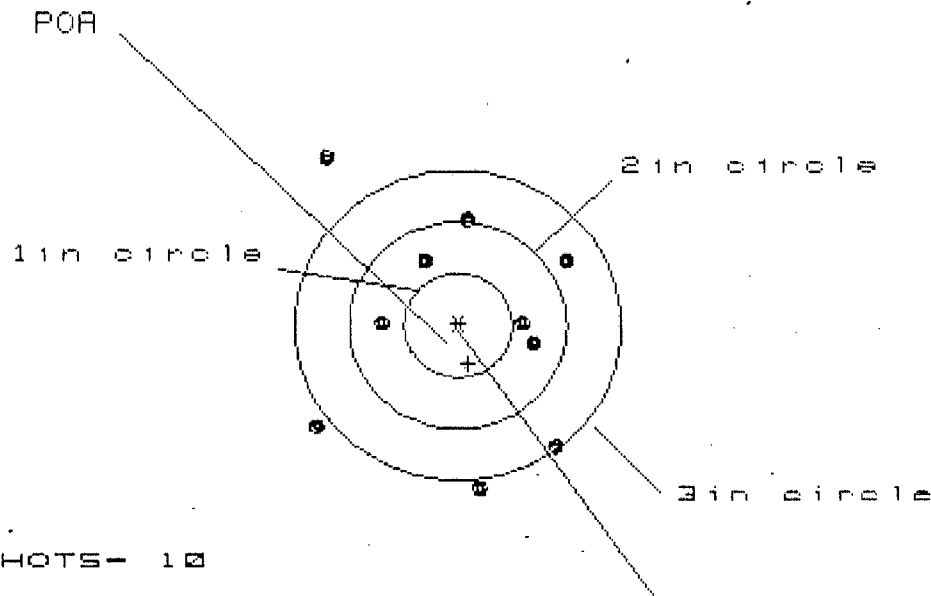
GS= 2.674

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.903	.903	.481
MINIMUM X	:	-.630	-.630	-.517
MAXIMUM Y	:	1.088	.930	.988
MINIMUM Y	:	-1.429	-.944	-.828
CENTROID X	:	.149	.149	.037
CENTROID Y	:	.467	.625	.509
POA TO CENTROID in.	:	.490	.643	.511
MIN RADIUS	:	.233	.302	.352
MEAN RADIUS	:	.831	.765	.687
MAX RADIUS	:	1.429	1.296	1.007
HORIZONTAL SPREAD	:	1.533	1.533	.998
VERTICAL SPREAD	:	2.517	1.874	1.816
EXTREME SPREAD	:	2.674	2.207	1.817
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CG225374

CENTERFIRE PATTERNS # 2

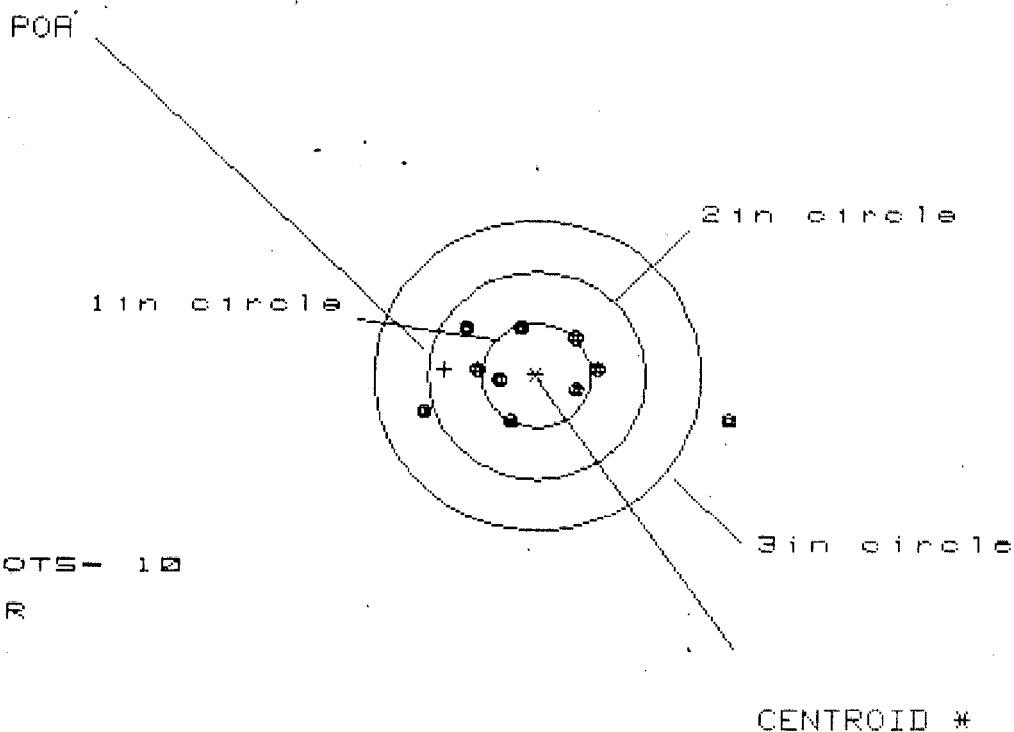


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.984	.848	.861
MINIMUM X	:	-1.284	-1.420	-1.407
MAXIMUM Y	:	1.604	1.230	1.050
MINIMUM Y	:	-1.618	-1.439	-1.197
CENTROID X	:	-.094	.042	.029
CENTROID Y	:	.372	.193	.373
POA TO CENTROID in.	:	.383	.198	.374
MIN RADIUS	:	.586	.498	.462
MEAN RADIUS	:	1.166	1.004	.907
MAX RADIUS	:	2.018	1.623	1.707
HORIZONTAL SPREAD	:	2.268	2.268	2.268
VERTICAL SPREAD	:	3.222	2.669	2.247
EXTREME SPREAD	:	3.537	2.752	2.752
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.843

VS= .898

GS= 2.849

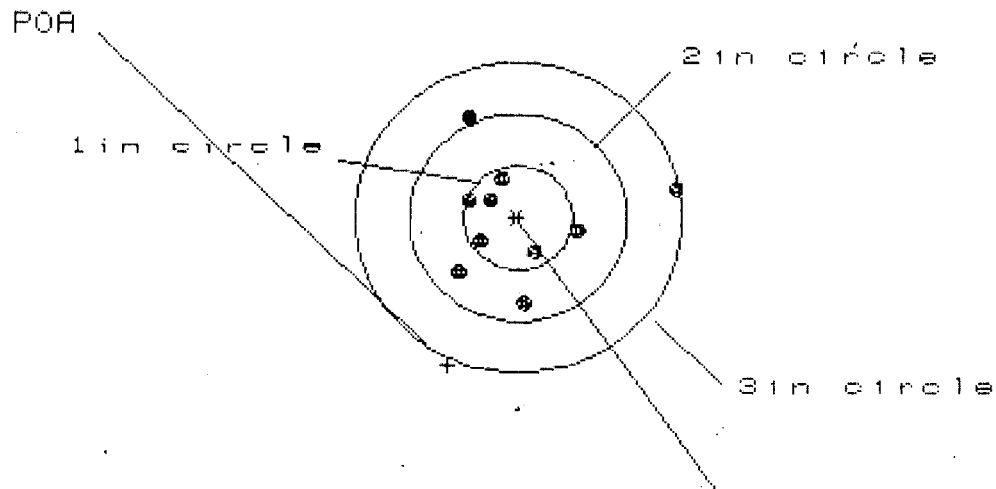
CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.777	.752	.643
MINIMUM X	-1.066	-.868	-.569
MAXIMUM Y	.418	.365	.320
MINIMUM Y	-.480	-.475	-.520
CENTROID X	.845	.647	.756
CENTROID Y	-.067	-.014	.031
POR TO CENTROID in.	.847	.647	.756
MIN RADIUS	.367	.189	.306
MEAN RADIUS	.712	.553	.506
MAX RADIUS	1.841	.937	.652
HORIZONTAL SPREAD	2.843	1.620	1.212
VERTICAL SPREAD	.898	.840	.840
EXTREME SPREAD	2.849	1.670	1.252
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

8 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225374

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

CENTROID *

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS = 1.928

VS = 1.862

GS = 2.096

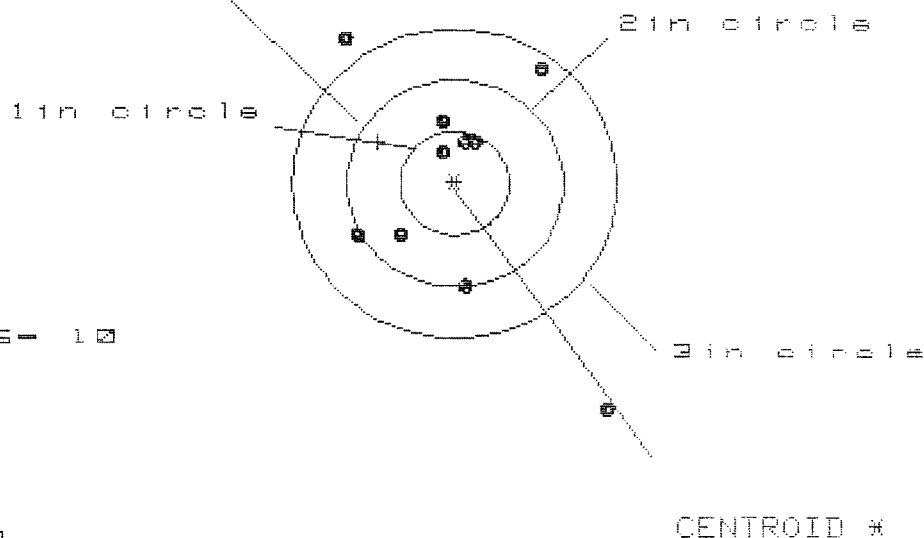
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.411	.729	.698
MINIMUM X	:	-.516	-.360	-.391
MAXIMUM Y	:	1.012	1.044	.555
MINIMUM Y	:	-.850	-.818	-.687
CENTROID X	:	.650	.494	.525
CENTROID Y	:	1.422	1.390	1.259
POA TO CENTROID in.	:	1.564	1.475	1.365
MIN RADIUS	:	.305	.211	.207
MEAN RADIUS	:	.666	.548	.478
MAX RADIUS	:	1.441	1.074	.709
HORIZONTAL SPREAD	:	1.928	1.089	1.089
VERTICAL SPREAD	:	1.862	1.862	1.242
EXTREME SPREAD	:	2.096	1.918	1.254
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS # 5

POA



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.481

VS = 3.621

GS = 4.389

CENTROID *

PATTERN #

:

5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.435	.968	.857
MINIMUM X	:	-1.046	-.886	-.843
MAXIMUM Y	:	1.439	1.196	1.013
MINIMUM Y	:	-2.182	-1.249	-1.099
CENTROID X	:	.704	.544	.655
CENTROID Y	:	-.489	-.166	-.316
POA TO CENTROID in.	:	.814	.569	.727
MIN RADIUS	:	.302	.088	.200
MEAN RADIUS	:	1.023	.781	.702
MAX RADIUS	:	2.612	1.489	1.327
HORIZONTAL SPREAD	:	2.481	1.854	1.700
VERTICAL SPREAD	:	3.621	2.445	2.112
EXTREME SPREAD	:	4.389	2.699	2.306
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225374

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	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		2/25/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/25/92	RW
	C) Inspect Ejector Hole for Chamfer		2/25/92	RW
	D) Oil Firing Pin Ass'y		2/25/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	BARBER M24 0013927	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			2/26/92	RW
	G) Safety Off Force	2	2	2			2/26/92	RW
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.020	.020			2/26/92	RW
	J) Assemble Stock						2/25/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						2/25/92	RW
	M) Iron Sight Alignment						2/25/92	RW
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2-26-92	AC
	A) Time						2-26-92	AC
	B) Malfunctions						2-26-92	AC
	C) Pierced Primers						2-26-92	AC
	D) Optical Clarity of Scope						2-26-92	AC
645	Inspect for Live Ammo						2-26-92	AC
655	Final Inspection							
	A) Headspace						2/26/92	RW
	B) Trigger Pull	2.35	2.30	2.45	2.46	2.36	2/26/92	RW
	C) Function						2/26/92	RW
660	Pack							

BARBER - M24 0013928

COMMENTS

R ORDER
92-03436

INITIAL	CUSTOMER ORDER NO.		M24		
JJM	67B16				
DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/28/92	01/28/92	KI 5-88	C6225374		700 7.62 NATO
ACCESSORIES	W/STUDS SCOPE BASE				

FROM:

SHIP TO:

CO D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC 28307

CG D 2ND BN 1ST SPWAR TNG GP
C/O CPT M K STEPHENSON
FT BRAGG NC
28307

CUST NO:046771 CJO.D

ACCOUNT NUMBER		ACCOUNT NUMBER N/C		WRITE ☐	CLEAN/TEST	PROM. DATE	ESTIMATED	VIA	DOOR
GUN CONDITION ☐ NEW ☐ LIGHTLY WORN ☐ WORN ☐ VERY WORN ☐ UNREPAIRABLE								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

- New BARREL

[illegible]

OFFICE COPY

BD6925 REV 8/91

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0043928 13967

(PLEASE PRINT CLEARLY)

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

FIREARMS DELIVERED TO PLANT

FILE Nº 006781DATE 1/27/92

OWNER'S NAME:

CPT M. K. STEPHENSON

REMINGTON EMPLOYEE:

OWNER'S ADDRESS:

Co D, 2nd BN, 1st SWTGYES ☐ NO ☐FT. BRAGG, NC

EMPLOYEE # _____

ZIP:

28307-5000

DEPT. # _____

PHONE:

(919) 396-7330

FIREARM

MODEL:

M24

CHECK FOR AMMUNITION

GAUGE:

308

SERIAL #

C6225374

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:

REBARREL

SIGNATURE: _____

(Person delivering firearm to plant)

DATE:

27 JAN 92

SIGNATURE: _____

(Security Officer)

DATE:

1/27/92

SIGNATURE: _____

(Firearm picked up by)

DATE:

1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225374
26 Feb 1992

CENTROIDAL DISTANCES

0 TO	1	.172743
1 TO	2	.414397
1 TO	3	.341459
1 TO	4	.524452
1 TO	5	.414281

$\frac{25}{134}$ <-----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0216
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .193609
THE AMR FOR THIS RIFLE IS: 1.339

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225374

CENTERFIRE PATTERNS # 1

POR

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 1

3in = 4

HS = 4.402

VS = 3.354

GS = 4.630

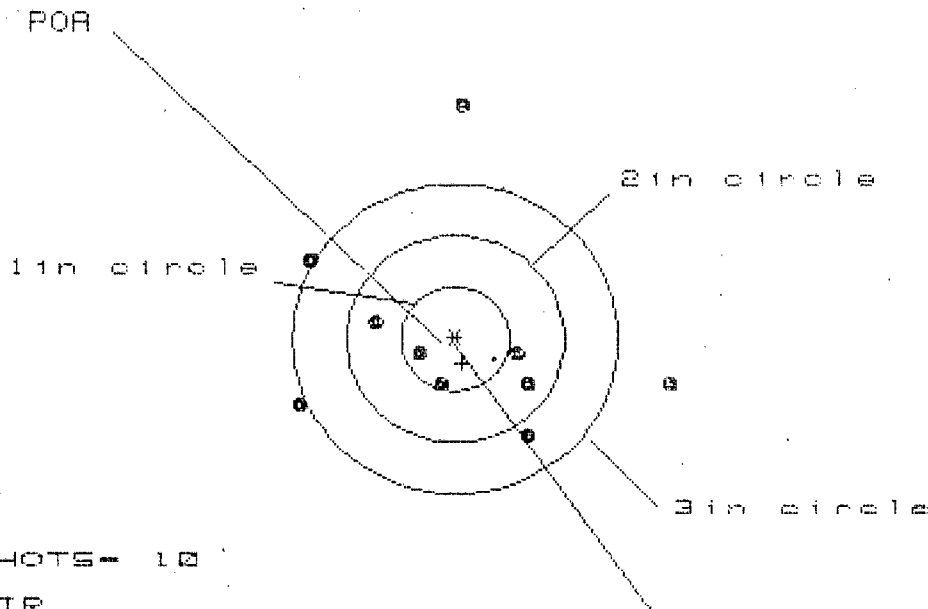
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.010	1.744	1.337
MINIMUM X	-2.392	-1.821	-1.603
MAXIMUM Y	1.597	1.516	1.595
MINIMUM Y	-1.757	-1.838	-1.759
CENTROID X	.016	.282	.064
CENTROID Y	-.172	-.091	-.170
POR TO CENTROID in.	.173	.297	.132
MIN RADIUS	.738	1.016	.785
MEAN RADIUS	1.718	1.623	1.572
MAX RADIUS	2.500	2.176	2.049
HORIZONTAL SPREAD	4.402	3.565	2.940
VERTICAL SPREAD	3.354	3.354	3.354
EXTREME SPREAD	4.630	4.002	3.870
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	1		
NUMBER IN THREE INCH CIRCLE =	4		

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 6

HS= 3.353

VS= 3.187

GS= 3.472

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.927	1.939	.958
MINIMUM X	-1.426	-1.414	-1.171
MAXIMUM Y	2.255	1.847	1.820
MINIMUM Y	-.932	-.681	-.788
CENTROID X	-.067	-.079	-.322
CENTROID Y	.234	-.017	.010
POA TO CENTROID in.	.243	.081	.322
MIN RADIUS	.367	.245	.146
MEAN RADIUS	1.151	.982	.839
MAX RADIUS	2.258	1.951	1.467
HORIZONTAL SPREAD	3.353	3.353	2.129
VERTICAL SPREAD	3.187	1.728	1.728
EXTREME SPREAD	3.472	3.472	2.652
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS # 3

POR

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 4.003

VS= 3.326

GS= 4.012

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	2.920
MINIMUM X	-1.083
MAXIMUM Y	.882
MINIMUM Y	-2.444
CENTROID X	.353
CENTROID Y	-.117
POR TO CENTROID in.	.372
MIN RADIUS	.463
MEAN RADIUS	1.192
MAX RADIUS	2.921
HORIZONTAL SPREAD	4.003
VERTICAL SPREAD	3.326
EXTREME SPREAD	4.012
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

26 Feb 1992

FILE://PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 3

3 in = 5

HS = 4.645

VS = 3.166

GS = 4.646

PATTERN #

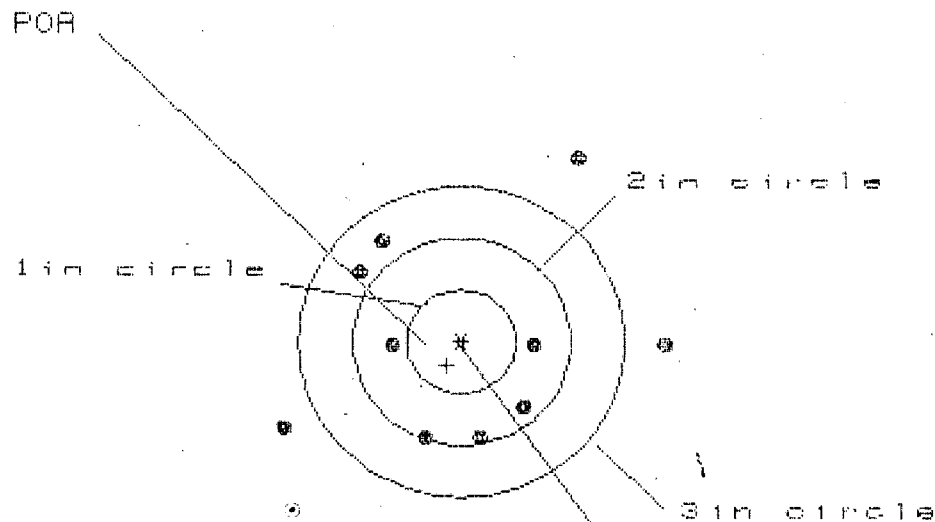
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.515	1.549	1.318
MINIMUM X	-2.130	-1.851	-.836
MAXIMUM Y	1.796	1.803	1.800
MINIMUM Y	-1.370	-1.363	-1.367
CENTROID X	.529	.250	.481
CENTROID Y	-.063	-.070	-.067
POA TO CENTROID in.	.533	.260	.486
MIN RADIUS	.662	.420	.619
MEAN RADIUS	1.516	1.356	1.307
MAX RADIUS	2.516	2.063	1.898
HORIZONTAL SPREAD	4.645	3.400	2.154
VERTICAL SPREAD	3.166	3.166	3.166
EXTREME SPREAD	4.646	3.651	3.609
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		5	

26 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225374

CENTERFIRE PATTERNS # 5



OF SHOTS- 10.

IN CIR

1in = 0

2in = 5

3in = 7

HS= 3.474

VS= 2.738

GS= 3.743

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.844	1.958	1.769
MINIMUM X	-1.638	-1.516	-1.052
MAXIMUM Y	1.769	1.203	1.120
MINIMUM Y	-0.969	-0.773	-0.856
CENTROID X	.131	.017	.206
CENTROID Y	.226	.038	.113
POR TO CENTROID in.	.262	.034	.235
MIN RADIUS	.625	.526	.563
MEAN RADIUS	1.215	1.089	1.017
MAX RADIUS	2.047	1.968	1.773
HORIZONTAL SPREAD	3.474	3.474	2.821
VERTICAL SPREAD	2.738	1.976	1.976
EXTREME SPREAD	3.743	3.581	2.889
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	