

C6523378

MODEL 700™ M24

Model SMS™

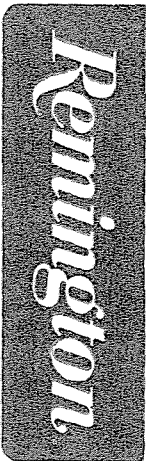
Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.



GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523378

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)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/18/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/18/93	RW
	C) Inspect Ejector Hole for Chamfer		2/18/93	RW
	D) Oil Firing Pin Ass'y		2/18/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/18/93	RW

Op. #	BARBER - M24 0026994 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.5	4	4			2/18/93	RW
	G) Safety Off Force	3	3	3			2/18/93	RW
	H) Trigger Pull Test & Retainability						2/18/93	RW
	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						2/18/93	RW
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2/26/93	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						2/26/93	RW
655	Final Inspection							
	A) Headspace						3/4/93	RW
	B) Trigger Pull	2.57	2.60	2.55	2.63	2.62	3/4/93	RW
	C) Function						3/4/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy

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

SERIAL NO. C6523378DATE 2/18/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.45	2.59		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.34	2.62		
PULL #3	2.45	2.32	2.59		
PULL #4	2.45	2.36	2.61		
PULL #5	2.49	2.41	2.63		
TOTAL	12.31	11.88	13.04		
AVG.	2.46	2.38	2.61		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.22		
PULL #2	3.12	3.25		
PULL #3	3.20	3.07		
PULL #4	3.10	3.19		
PULL #5	3.25	3.16		
TOTAL	15.86	15.89		
AVG.	3.17	3.18		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.09	4.35		4.24
PULL #2	4.21	4.20		4.20
PULL #3	4.13	4.18		4.10
PULL #4	4.27	4.11		4.17
PULL #5	4.02	4.23		4.12
TOTAL	20.72	21.07		20.83
AVG.	4.14	4.21		4.17



VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24	SERIAL NO. C6523378
	ORDER NO. 5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

01



5716 C6523378

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6523378

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KL
600	Proof		10/4/90	KL
607	Check Headspace		10/4/90	KL
610	Dis-assemble Gun		10/4/90	KL
612	Magnaflux Barrel Action		10/9/90	KR
	Magnaflux Bolt		10/9/90	KR
615	Rollmark Caliber		10/9/90	LL
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-12-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10-12-90	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/19-90	WB
	C) Inspect Ejector Hole for Chamfer		10-19-90	WB
	D) Oil Firing Pin Ass'y		10-19-90	WB
	E) Adjust Trigger Pull to Min Setting and Stake		11-6-90	JH

op. #	OP. NAME	READINGS				DATE	INIT	
525 cont.	F) Safety On Force	4	4.5	4.5	11-2-90	KT		
	G) Safety Off Force	2.14	2.14	4.52	11-2-90	KT		
	H) Trigger Pull Test & Retainability				11-6-90	JL		
	I) Firing Pin Indent	.025	.025	.026	11-2-90	KT		
	J) Assemble Stock				11-6-90	KS		
	K) Assemble Swivel Studs				11-20-90	928		
	L) Attach Front and Rear Sight Assemblies				11-6-90	KS		
	M) Iron Sight Alignment				11-6-90	KS		
	N) Detach Front & Rear Sights & place in numbered container				11-6-90	KS		
	O) Attach Scope to Rifle				11-6-90	KS		
	P) Detach & Attach Scope 20 Times				11-6-90	KS		
640	Gallery Target & Test				11-8-90	KT		
	A) Time				11-8-90	KT		
	B) Malfunctions				11-8-90	KT		
	C) Pierced Primers				11-8-90	KT		
	D) Optical Clarity of Scope				11-8-90	KT		
645	Inspect for Live Ammo				11-8-90	KT		
655	Final Inspection							
	A) Headspace				11-20-90	928		
	B) Trigger Pull	2.30	2.33	2.27	2.28	2.37	11-20-90	928
	C) Function						11-20-90	928
660	Pack						12-17-90	DH

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523378

DATE 11/6/90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.16	2.23	2.35	230	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.30	2.35	2.29	233	
PULL #3	2.31	2.28	2.40	227	
PULL #4	2.30	2.40	2.38	228	
PULL #5	2.22	2.38	2.22	237	
TOTAL	11.35	11.64	11.64		
AVG.	2.27	2.328	2.328		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.37		
PULL #2	3.28	3.16		
PULL #3	3.20	3.21		
PULL #4	3.20	3.38		
PULL #5	3.20	3.19		
TOTAL	16.01	16.31		
AVG.	3.202	3.262		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.19	4.14		4.33
PULL #2	4.41	4.40		4.38
PULL #3	4.39	4.24		4.26
PULL #4	4.26	4.44		4.44
PULL #5	4.10	4.45		4.41
TOTAL	21.35	21.67		21.82
AVG.	4.27	4.334		4.364

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523378
9 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.531327
1 TO	2	.81931
1 TO	3	.660019
1 TO	4	.596802
1 TO	5	.889427

5.29
+ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1118
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1466
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .184366
THE AMR FOR THIS RIFLE IS: .9056

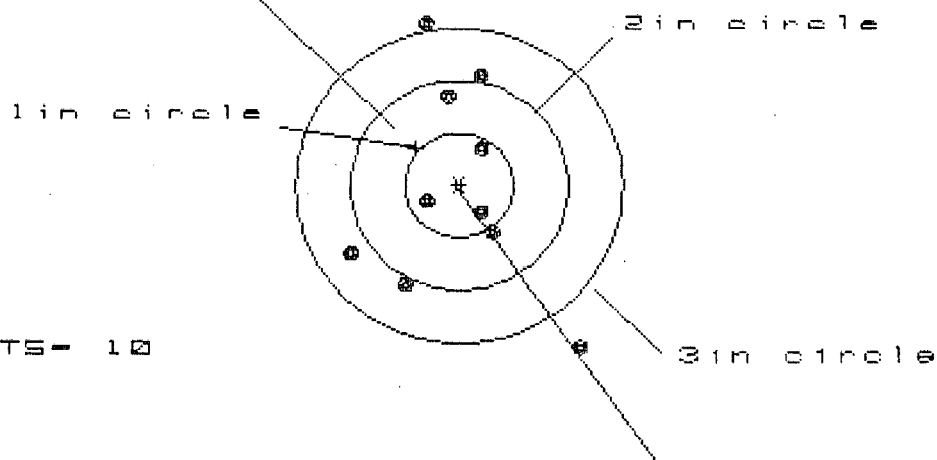
9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523378

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.000

VS= 3.068

GS= 3.365

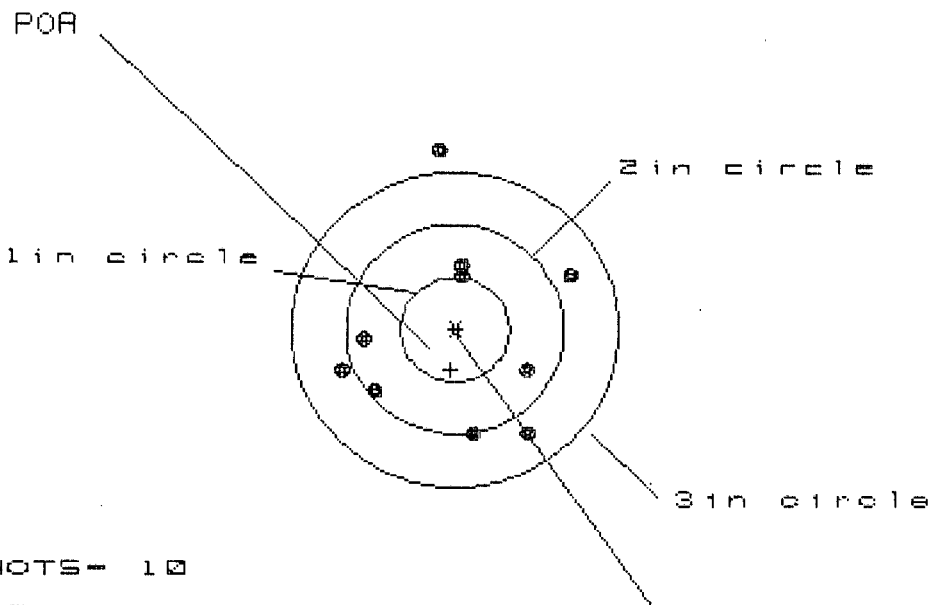
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.117	.445	.427
MINIMUM X	-.962	-.838	-.856
MAXIMUM Y	1.534	1.364	1.041
MINIMUM Y	-1.534	-1.087	-.917
CENTROID X	.398	.273	.291
CENTROID Y	-.352	-.182	-.352
POA TO CENTROID in.	.531	.328	.457
MIN RADIUS	.271	.298	.176
MEAN RADIUS	.907	.801	.703
MAX RADIUS	1.898	1.371	1.081
HORIZONTAL SPREAD	2.080	1.283	1.283
VERTICAL SPREAD	3.068	2.451	1.958
EXTREME SPREAD	3.365	2.460	2.067
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.113

VS= 2.745

GS= 2.760

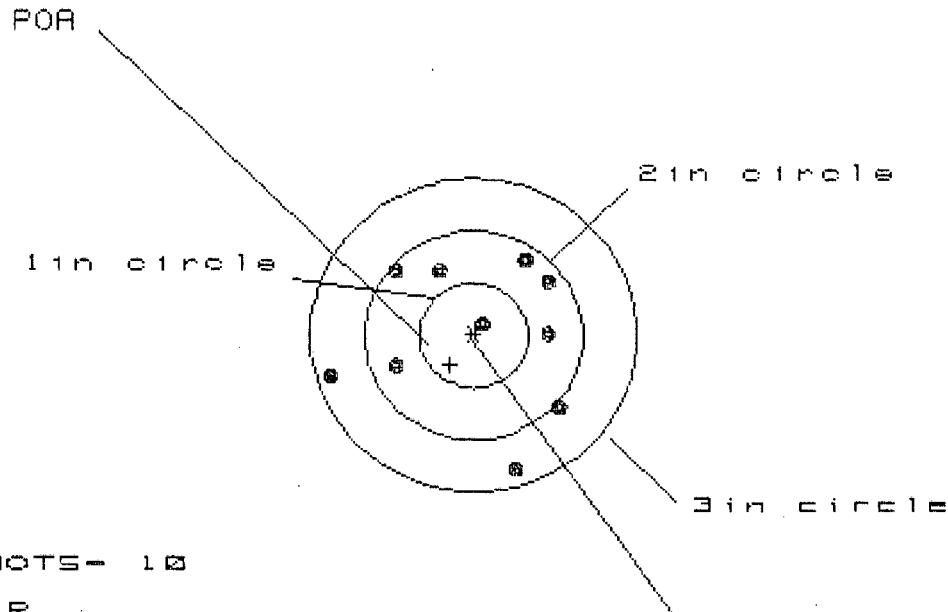
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.055	1.045	.827
MINIMUM X	:	-1.058	-1.068	-.938
MAXIMUM Y	:	1.719	.853	.937
MINIMUM Y	:	-1.026	-.835	-.751
CENTROID X	:	.036	.046	-.084
CENTROID Y	:	.383	.192	.108
POA TO CENTROID in.	:	.385	.197	.137
MIN RADIUS	:	.491	.677	.654
MEAN RADIUS	:	.990	.899	.844
MAX RADIUS	:	1.722	1.240	1.004
HORIZONTAL SPREAD	:	2.113	2.113	1.764
VERTICAL SPREAD	:	2.745	1.688	1.688
EXTREME SPREAD	:	2.760	2.265	1.789
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.127

VS= 1.989

GS= 2.175

CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.800	.652	.677
MINIMUM X	-1.327	-.898	-.873
MAXIMUM Y	.731	.692	.530
MINIMUM Y	-1.258	-1.297	-.912
CENTROID X	.218	.366	.341
CENTROID Y	.283	.322	.484
POA TO CENTROID in.	.357	.487	.592
MIN RADIUS	.137	.050	.126
MEAN RADIUS	.871	.786	.704
MAX RADIUS	1.374	1.312	1.136
HORIZONTAL SPREAD	2.127	1.550	1.550
VERTICAL SPREAD	1.989	1.989	1.442
EXTREME SPREAD	2.175	2.175	2.043
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 2.113

VS= 2.049

GS= 2.278

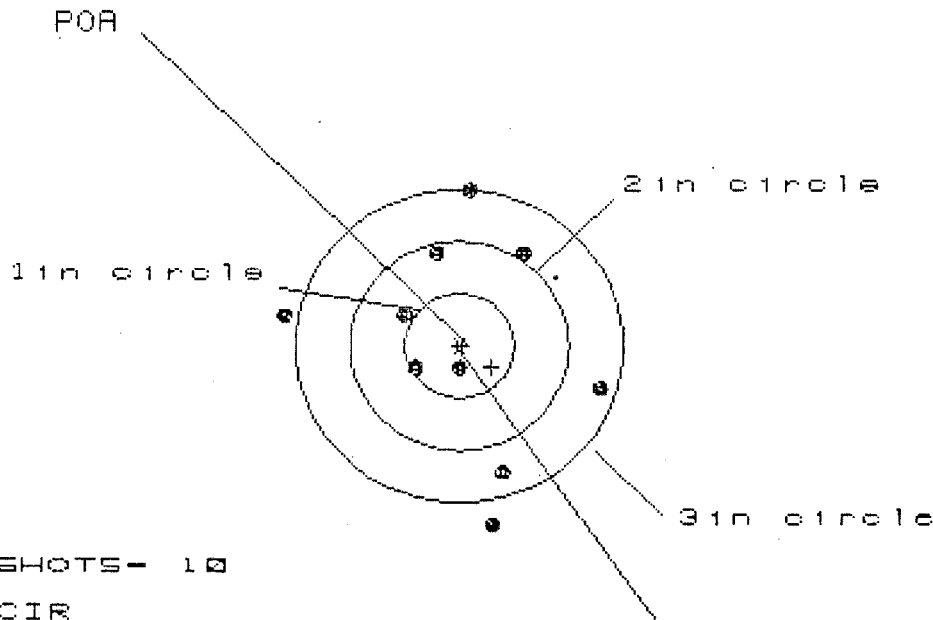
CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.786	.638	.663
MINIMUM X	:	-1.327	-.396	-.371
MAXIMUM Y	:	.939	.977	.843
MINIMUM Y	:	-1.110	-1.072	-.602
CENTROID X	:	.200	.348	.323
CENTROID Y	:	.211	.173	.307
POA TO CENTROID in.	:	.291	.388	.445
MIN RADIUS	:	.259	.211	.345
MEAN RADIUS	:	.706	.628	.580
MAX RADIUS	:	1.371	1.090	.896
HORIZONTAL SPREAD	:	2.113	1.034	1.034
VERTICAL SPREAD	:	2.049	2.049	1.445
EXTREME SPREAD	:	2.278	2.087	1.668
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 8

HSI = 2.836

VS = 3.188

GS = 3.184

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.266	1.300	1.108
MINIMUM X	-1.570	-1.536	-.649
MAXIMUM Y	1.461	1.270	1.284
MINIMUM Y	-1.719	-1.417	-1.403
CENTROID X	-.293	-.327	-.135
CENTROID Y	.208	.399	.385
POA TO CENTROID in.	.359	.516	.408
MIN RADIUS	.198	.391	.406
MEAN RADIUS	1.054	.968	.908
MAX RADIUS	1.746	1.540	1.420
HORIZONTAL SPREAD	2.836	2.836	1.757
VERTICAL SPREAD	3.188	2.687	2.687
EXTREME SPREAD	3.184	2.919	2.697
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 93-02449

INITIAL FFS	CUSTOMER ORDER NO.		WOG 3 OF 30 W/10X SCOPE & DEPLOYMENT KIT M24			
DATE RECEIVED 01/25/93	DATE OPENED 01/25/93	DATE CODE EK 10-90	SERIAL NUMBER C6523378	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62	NATO
ACCESSORIES W/STUDS		W/SWIVELS		SCOPE BASE	SOFT CASE	

FROM:

SHIP TO:

MCHALE, EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

MCHALE, EDWARD J CPT;SF
HSC 3RD BN 3RD SFG (A)
FT BRAGG NC 28307

CUST NO: 073985 C.O.D L

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

Rust on Gun

PARTS

COMMENTS

Trigger Assy - 96024
Magazine Spring - 15677
Zinc phosphate Scope Base,
Scope Rings, Swivels & Swivel Studs.
Re-powder Coat Floor plate, latch,
Trigger Guard & Barrel Assy - 96001

REPAIRMAN RW	PROOF	CLEAN ✓	TEST ✓	TARGET	PATTERN
GALLERY TESTER RW	DATE	DATE 2/18/93	DATE 2/26/93	DATE	DATE

OFFICE COPY

RD6925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0027007