

C6523413

MODEL 700™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

GFM

CONTRACT # DAAA21-87-C-0086

Repair

GUN SERIAL # C6523413

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		2/24/93	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/24/93	RW
	C) Inspect Ejector Hole for Chamfer		2/24/93	RW
	D) Oil Firing Pin Ass'y		2/24/93	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/24/93	RW

Op. #	BARBER - M24 0027641					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	5	5	5		2/24/93	RW
	G) Safety Off Force	3	3	3		2/24/93	RW
	H) Trigger Pull Test & Retainability					2/24/93	RW
	I) Firing Pin Indent						
	J) Assemble Stock						
	K) Assemble Swivel Studs						
	L) Attach Front and Rear Sight Assemblies					2/24/93	RW
	M) Iron Sight Alignment					2/24/93	RW
	N) Detach Front & Rear Sights & place in numbered container					2/24/93	RW
	O) Attach Scope to Rifle					2/24/93	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					3/3/93	RW
	B) Trigger Pull	2.63	2.59	2.60	2.59	3/3/93	RW
	C) Function					3/3/93	RW
660	Pack						

New Trigger Assy

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523413DATE 2/24/93TESTER RW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.55	2.80	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.66	2.47	2.55	
PULL #3	2.62	2.46	2.50	
PULL #4	2.57	2.48	2.52	
PULL #5	2.37	2.49	2.47	
TOTAL	12.89	12.45	12.84	
AVG.	2.58	2.49	2.57	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.00	3.25	
PULL #2	3.01	3.12	
PULL #3	3.14	3.23	
PULL #4	3.10	3.31	
PULL #5	3.15	3.25	
TOTAL	15.40	16.16	
AVG.	3.08	3.23	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.25		4.03
PULL #2	4.10	4.34		4.00
PULL #3	4.08	4.33		4.05
PULL #4	4.09	4.34		4.09
PULL #5	4.17	4.46		4.02
TOTAL	20.59	21.72		20.19
AVG.	4.12	4.34		4.04

Remington[®] **DUPONT**
REG. U.S. PAT. & TM. OFF.

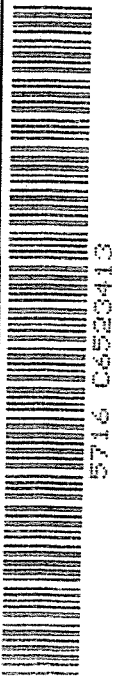
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700TM M24

SERIAL NO. 06523413

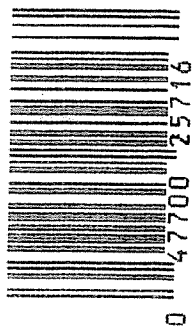
ORDER NO. 5716

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



5716 06523413

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523413

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KJ
600	Proof		10/4/90	KJ
607	Check Headspace		10/4/90	KJ
610	Dis-assemble Gun		10/4/90	KJ
612	Magnaflux Barrel Action		10/4/90	KR
	Magnaflux Bolt		10/9/90	KR
615	Rollmark Caliber		10/9/90	LS
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel <i>P/B</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-18-90	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/19/90	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		10-27-90	PH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			10/27/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			10/27/90	WB
	H) Trigger Pull Test & Retainability						10-27-90	DH
	I) Firing Pin Indent	.0205	.020	.020			10/27/90	WB
	J) Assemble Stock						11/3/90	KA
	K) Assemble Swivel Studs						11/19/90	QJ
	L) Attach Front and Rear Sight Assemblies						10/31/90	KA
	M) Iron Sight Alignment						10/31/90	KA
	N) Detach Front & Rear Sights & place in numbered container						10/31/90	KA
	O) Attach Scope to Rifle						10/31/90	KA
	P) Detach & Attach Scope 20 Times						10/31/90	KA
640	Gallery Target & Test						11-1-90	DH
	A) Time						11-1-90	DH
	B) Malfunctions						11-1-90	DH
	C) Pierced Primers						11-1-90	DH
	D) Optical Clarity of Scope						11-1-90	DH
645	Inspect for Live Ammo						11-1-90	DH
655	Final Inspection						11/19/90	QJ
	A) Headspace						11/19/90	QJ
	B) Trigger Pull	216	216	213	213	212	11/19/90	QJ
	C) Function						11/19/90	QJ
660	Pack						12/18/90	AF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6523413

DATE 10-26-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.20	2.33	2.16	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.24	2.55	2.16	
PULL #3	2.44	2.35	2.64	2.13	
PULL #4	2.41	2.32	2.60	2.13	
PULL #5	2.39	2.29	2.60	2.12	
TOTAL	2.22	11.40	12.72		
AVG.	2.44	2.28	2.54		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.15		
PULL #2	3.14	3.08		
PULL #3	3.14	3.18		
PULL #4	3.11	3.17		
PULL #5	3.95	3.19		
TOTAL	15.48	15.77		
AVG.	3.09	3.15		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.07		4.36
PULL #2	4.14	4.11		4.23
PULL #3	4.26	4.15		4.22
PULL #4	3.94	4.29		4.16
PULL #5	4.27	3.90		4.18
TOTAL	20.67	20.42		21.15
AVG.	4.13	4.08		4.23

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523413
1 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.435929
1 TO	2	.552558
1 TO	3	.605615
1 TO	4	.427103
1 TO	5	.534958

$\bar{x}_1$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.075
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0899175
THE AMR FOR THIS RIFLE IS: .0872

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523413

CENTERFIRE PATTERNS

1

POR

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.112

VS= 3.354

GS= 3.355

CENTROID *

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.269	1.190	.994
MINIMUM X	-.903	-.922	-.774
MAXIMUM Y	1.817	1.266	1.161
MINIMUM Y	-1.537	-1.336	-1.441
CENTROID X	.425	.444	.296
CENTROID Y	.097	-.104	.001
POR TO CENTROID in.	.436	.456	.296
MIN RADIUS	.370	.566	.436
MEAN RADIUS	1.104	1.014	.938
MAX RADIUS	1.825	1.567	1.446
HORIZONTAL SPREAD	2.112	2.112	1.768
VERTICAL SPREAD	3.354	2.602	2.682
EXTREME SPREAD	3.355	2.988	2.685
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		7	

1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523413

CENTERFIRE PATTERNS

2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.361

VS = 2.447

GS = 3.400

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.393	.721	.619
MINIMUM X	:	-.968	-.813	-.534
MAXIMUM Y	:	1.133	1.223	1.075
MINIMUM Y	:	-1.314	-1.188	-.696
CENTROID X	:	-.081	-.236	-.134
CENTROID Y	:	-.125	-.251	-.102
POA TO CENTROID in.	:	.149	.345	.169
MIN RADIUS	:	.186	.156	.131
MEAN RADIUS	:	.856	.741	.636
MAX RADIUS	:	1.796	1.440	1.076
HORIZONTAL SPREAD	:	2.361	1.534	1.153
VERTICAL SPREAD	:	2.447	2.411	1.770
EXTREME SPREAD	:	3.400	2.597	1.860
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

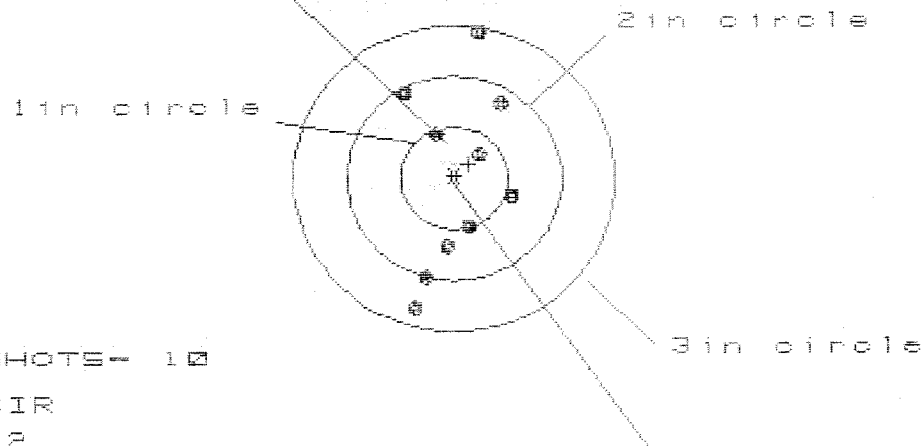
1 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523413

CENTERFIRE PATTERNS

3

POR



OF SHOTS - 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = .9556

VS = 2.6866

GS = 2.754

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.505	.528	.480
MINIMUM X	:	-.461	-.438	-.486
MAXIMUM Y	:	1.408	1.022	.882
MINIMUM Y	:	-1.278	-1.121	-.997
CENTROID X	:	-.134	-.157	-.109
CENTROID Y	:	-.136	-.292	-.152
POR TO CENTROID in.	:	.191	.332	.187
MIN RADIUS	:	.328	.375	.327
MEAN RADIUS	:	.816	.741	.673
MAX RADIUS	:	1.423	1.184	1.039
HORIZONTAL SPREAD	:	.966	.966	.966
VERTICAL SPREAD	:	2.686	2.143	1.879
EXTREME SPREAD	:	2.754	2.157	1.889
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

1 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523413

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.762

VS= 2.032

GS= 2.342

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

.773

.851

.804

MINIMUM X

:

-.989

-.911

-.958

MAXIMUM Y

:

.938

.816

.730

MINIMUM Y

:

-1.094

-.873

-.770

CENTROID X

:

.141

.063

.110

CENTROID Y

:

-.222

-.100

-.202

POA TO CENTROID in.:

.263

.118

.231

MIN RADIUS

:

.336

.217

.324

MEAN RADIUS

:

.777

.696

.675

MAX RADIUS

:

1.301

1.060

.962

HORIZONTAL SPREAD

:

1.762

1.762

1.762

VERTICAL SPREAD

:

2.032

1.689

1.500

EXTREME SPREAD

:

2.342

1.909

1.849

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

8

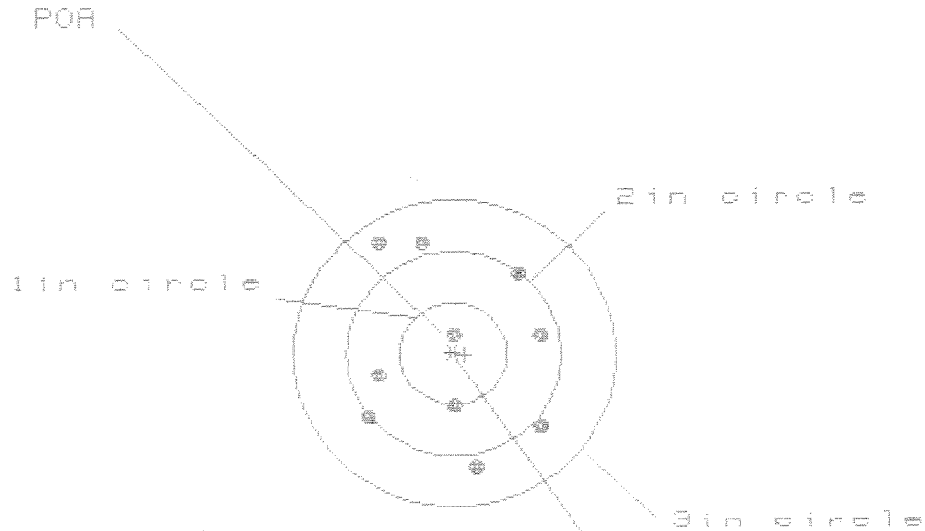
NUMBER IN THREE INCH CIRCLE =

10

1 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523413

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.649

VS= 2.191

GS= 2.355

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.826	.753	.775
MINIMUM X	-.824	-.896	-.874
MAXIMUM Y	1.069	1.186	1.060
MINIMUM Y	-1.122	-1.005	-.748
CENTROID X	-.103	-.030	-.052
CENTROID Y	.011	-.106	.020
POA TO CENTROID in.	.103	.110	.056
MIN RADIUS	.149	.258	.131
MEAN RADIUS	.883	.937	.802
MAX RADIUS	1.239	1.241	1.115
HORIZONTAL SPREAD	1.649	1.649	1.649
VERTICAL SPREAD	2.191	2.191	1.808
EXTREME SPREAD	2.355	2.257	2.117
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 93-02446

INITIAL FPS	CUSTOMER ORDER NO.	WOG 2 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 C6523413	NEW SERIAL NUMBER	MODEL AND GRADE 700 7-62 NATO
ACCESSORIES W/STUDS		W/SWIVELS		SOFT CASE	SCOPE BASE

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												
<i>Magazine Spring - 15677</i>	<i>Zinc phosphate Scope Base</i>												
<i>Trigger Assy - 96024</i>	<i>Scope Rings, Swivels, Swivel Studs.</i>												
<i>Front Sight Assy - 96118</i>	<i>Re-powder Coat Floor plate 1A4h,</i>												
<i>Rear Sight Assy - 96119</i>	<i>Trigger Guard, Barrel Assy - 96001,</i>												
<i>Front Guard Screw - 96010</i>	<i>Front + Rear Sight Bases</i>												
<i>Rear Guard Screw - 96015</i>													
<table border="1"> <tr> <td>REPAIRMAN <i>RW</i></td> <td>PROOF</td> <td>CLEAN <i>✓</i></td> <td>TEST <i>✓</i></td> <td>TARGET</td> <td>PATTERN</td> </tr> <tr> <td>GALLERY TESTER <i>RW</i></td> <td>DATE</td> <td>DATE <i>2/24/93</i></td> <td>DATE <i>2/26/93</i></td> <td>DATE</td> <td>DATE</td> </tr> </table>		REPAIRMAN <i>RW</i>	PROOF	CLEAN <i>✓</i>	TEST <i>✓</i>	TARGET	PATTERN	GALLERY TESTER <i>RW</i>	DATE	DATE <i>2/24/93</i>	DATE <i>2/26/93</i>	DATE	DATE
REPAIRMAN <i>RW</i>	PROOF	CLEAN <i>✓</i>	TEST <i>✓</i>	TARGET	PATTERN								
GALLERY TESTER <i>RW</i>	DATE	DATE <i>2/24/93</i>	DATE <i>2/26/93</i>	DATE	DATE								

OFFICE COPY

RD5925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0027693