

C6225076

MODEL 700™ M24

Model **700 M24™**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225076

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	Pfe.
	Magnaflux Bolt		9-14-88	Pfe.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		11/2/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		1/NOV88	JS
	F) Safety on Force	5 5 5	4/NOV88	JS
	G) Safety off Force	3 3 3	4/NOV88	JS
	H) Trigger Pull Test & Retainability		1/NOV88	JS
	I) Firing Pin Indent	.022 .022 .022	4/NOV88	JS
	J) Assemble Stock		11/9/88	RW
	K) Assemble Swivel Studs		30NOV88	JS
	L) Attach Front & Rear Sight Assemblies		11/9/88	RW
	M) Iron Sight Alignment		11/9/88	RW
	N) Detach Front & Rear Sights & place in numbered container		11/9/88	RW
	O) Attach Scope to Rifle		11/15/88	WB
	P) Detach & Attach Scope 20 times		11/15/88	WB
640	Gallery Target & Test	63 R 90L	11/16/88	DH
	A) Optical Clarity of Scope		11/16/88	DH
645	Inspect for Live Ammo		11/16/88	DH
655	Final Inspection			
	A) Headspace		30NOV88	JS
	B) Trigger Pull		30NOV88	JS
	C) Function		30NOV88	JS
660	Pack		14Dec88	JS

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225076

DATE 1/16/88

TESTER J. U. + D. 2.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.81	2.83	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.60	2.55	2.57	
PULL #3	2.41	2.53	2.69	2.61	
PULL #4	2.53	2.57	2.64	2.53	
PULL #5	2.58	2.53	2.62	2.58	
TOTAL	12.35	13.04	13.33	12.74	
AVG.	2.47	2.608	2.666	2.548	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.38		
PULL #2	3.13	3.23		
PULL #3	3.41	3.14		
PULL #4	3.20	3.18		
PULL #5	3.26	3.19		
TOTAL	16.09	16.12		
AVG.	3.218	3.224		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.24	4.23		4.17
PULL #2	4.06	4.23		4.32
PULL #3	4.27	4.27		4.49
PULL #4	4.07	4.29		4.26
PULL #5	4.36	4.40		4.41
TOTAL	21.00	21.42		21.65
AVG.	4.20	4.284		4.33

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225076

CENTROIDAL DISTANCES

0 TO	1	.312618
1 TO	2	.275182
1 TO	3	.350801
1 TO	4	.222524
1 TO	5	.26163

5 <----POA

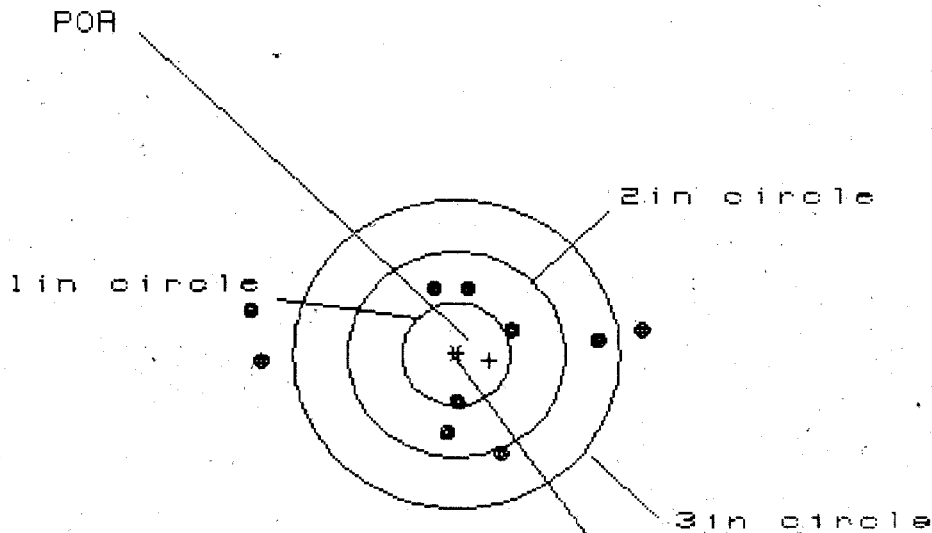
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1188
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0086
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .119111

THE AMR FOR THIS RIFLE IS: .9202

17 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225076

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.573

VS= 1.566

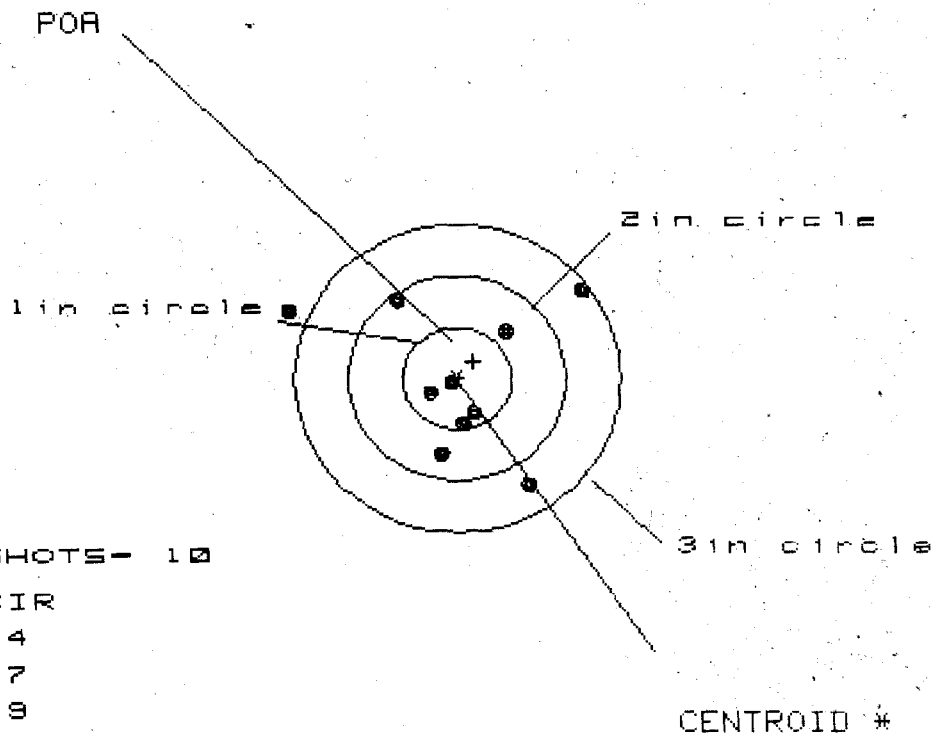
GS= 3.575

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.701	1.493	1.239
MINIMUM X	-1.872	-2.031	-.663
MAXIMUM Y	.616	.659	.658
MINIMUM Y	-.951	-.907	-.908
CENTROID X	-.307	-.099	.155
CENTROID Y	.059	.015	.016
POA TO CENTROID in.	.313	.100	.155
MIN RADIUS	.496	.403	.255
MEAN RADIUS	1.088	.969	.821
MAX RADIUS	1.913	2.031	1.282
HORIZONTAL SPREAD	3.573	3.524	1.902
VERTICAL SPREAD	1.566	1.566	1.566
EXTREME SPREAD	3.575	3.541	2.046
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225076

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.761

VS= 1.853

GS= 2.769

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.186	1.011	.599
MINIMUM X	:	-1.575	-.685	-.559
MAXIMUM Y	:	.844	.914	.925
MINIMUM Y	:	-1.009	-.939	-.824
CENTROID X	:	-.150	.025	-.101
CENTROID Y	:	-.167	-.237	-.352
POA TO CENTROID in.	:	.225	.239	.366
MIN RADIUS	:	.048	.183	.148
MEAN RADIUS	:	.777	.673	.541
MAX RADIUS	:	1.697	1.363	1.080
HORIZONTAL SPREAD	:	2.761	1.696	1.158
VERTICAL SPREAD	:	1.853	1.853	1.749
EXTREME SPREAD	:	2.769	2.098	2.098
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225076

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in - 4

2 in - 6

3 in - 9

HS - 3.298

VS - 1.779

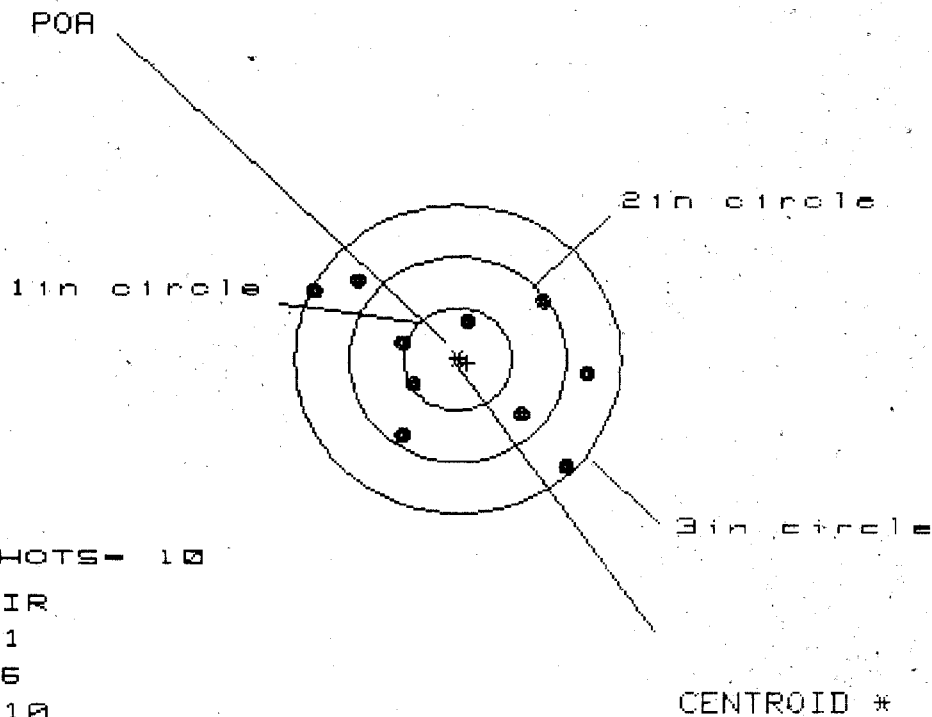
GS - 3.299

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.148	.909	.890
MINIMUM X	:	-2.150	-.822	-.709
MAXIMUM Y	:	1.009	.990	.955
MINIMUM Y	:	-.770	-.789	-.824
CENTROID X	:	.023	.262	.149
CENTROID Y	:	-.060	-.041	-.006
POA TO CENTROID in.	:	.064	.265	.149
MIN RADIUS	:	.214	.173	.153
MEAN RADIUS	:	.840	.664	.617
MAX RADIUS	:	2.157	1.287	1.189
HORIZONTAL SPREAD	:	3.298	1.731	1.599
VERTICAL SPREAD	:	1.779	1.779	1.779
EXTREME SPREAD	:	3.299	2.147	2.147
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225076

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.496

VS= 1.824

GS= 2.810

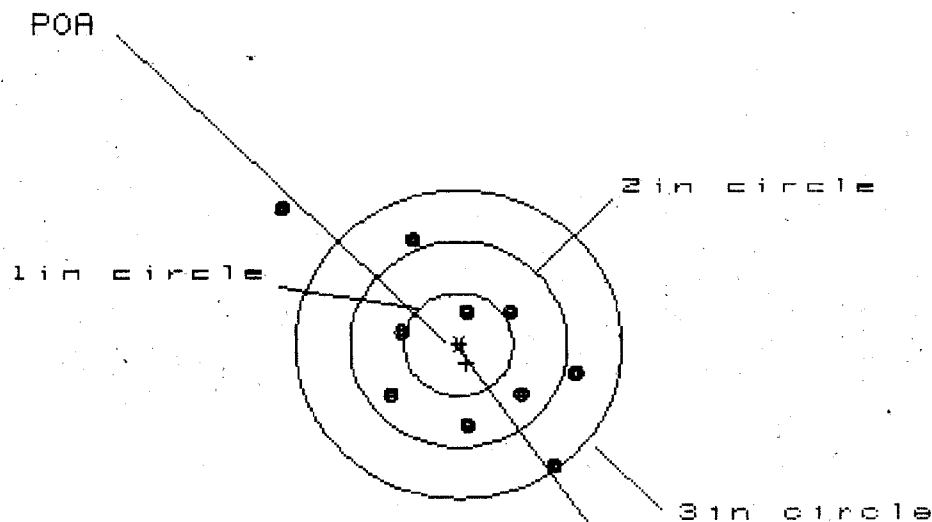
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.228	1.087	1.187
MINIMUM X	-1.268	-1.019	-.919
MAXIMUM Y	.775	.851	.729
MINIMUM Y	-1.049	-.973	-.751
CENTROID X	-.086	.054	-.046
CENTROID Y	.033	-.043	.079
POA TO CENTROID in.	.092	.069	.091
MIN RADIUS	.415	.491	.364
MEAN RADIUS	.930	.875	.806
MAX RADIUS	1.439	1.328	1.195
HORIZONTAL SPREAD	2.496	2.106	2.106
VERTICAL SPREAD	1.824	1.824	1.480
EXTREME SPREAD	2.810	2.581	2.277
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

17 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225076

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS = 2.780

VS = 2.480

GS = 3.562

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.119	.934	1.023
MINIMUM X	:	-1.661	-.827	-.738
MAXIMUM Y	:	1.334	1.167	1.043
MINIMUM Y	:	-1.146	-.998	-.770
CENTROID X	:	-.074	.111	.022
CENTROID Y	:	.178	.030	.154
POA TO CENTROID in.	:	.193	.114	.156
MIN RADIUS	:	.374	.475	.378
MEAN RADIUS	:	.966	.816	.754
MAX RADIUS	:	2.130	1.300	1.149
HORIZONTAL SPREAD	:	2.780	1.761	1.761
VERTICAL SPREAD	:	2.480	2.165	1.813
EXTREME SPREAD	:	3.562	2.517	2.013
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: **RE00014569** Serial: **C6225076** Model: **700** Center Fire Caliber: **7.62 NATO M-24 (5WS)** Repairman: Status: **Closed 9/27/00 3:02:25 PM**

Vaulty Repair

Address Information

Customer: **HSC 3RD BN 3RD SFG (A)** Received From: **HSC 3RD BN 3RD SFG (A)** Return To: **HSC 3RD BN 3RD SFG (A)** Received From:

Address 1: **BLDG J 2050** Address 2: PO Box: City: **FORT BRAGG** State: **NC** Zip Code: **28310** Country: **US**

FFL:

Contact / Condition **Problems** **Estimate** **History / Status** **Shipping / Billing**

Contact Information

Phone: Fax: Email: Comments:

Received Condition

Condition: Notes: CSR Notes:

Accessories Received

Code	Description	Qty
A007	With Stud	1
A010	Hard Case	1
A016	Scope Mounts	1
A017	Scope Base	1
A026	Scope	1

Repair Search **Refresh** **Close**

maglet 9/28/00 7:27 AM NUM INJ SCPL

Start Inb Na Ex Mi Par Al Om Pl 7:27 AM

Serial: **C6225076**Model: **700****RE00014569****BBL - 96003**

Final Inspection

S.N. C6225076

DATE REC'D: 9-26-00

DATE RET'D:

AUDITOR: RW

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:

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER		14569	
SERIAL NUMBER		C6225076	
LOG-IN DATE		9-26-00	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-28-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	10-3-00	RW
605	CHECK HEADSPACE	10-3-00	OK
610	DIS-ASSEMBLE GUN		
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	10-12-00	RW
655	FINAL INSPECT	10-25-00	CK
660	PACK		
		SHIP DATE	
		QAR INSPECTION DATE	

BARBER - M24 0048376

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225076
23 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1938
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .195899

THE AMR FOR THIS RIFLE IS: 1.274

CENTROIDAL DISTANCES

0 TO	1	.562542
1 TO	2	1.14797
1 TO	3	.0781857
1 TO	4	.287793
1 TO	5	1.01965

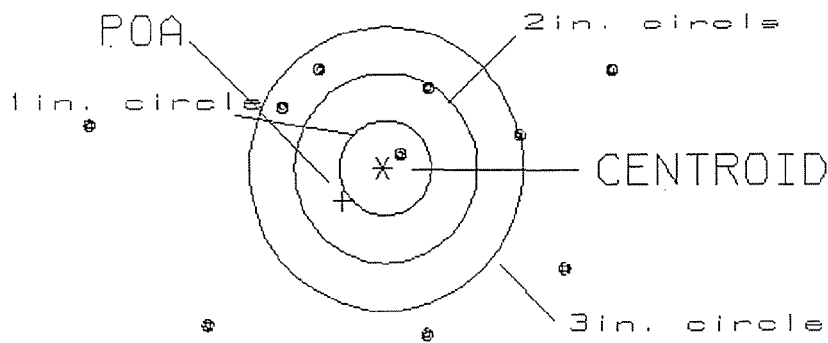
3
4
+ <----POA
5
2

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .563
 MIN RADIUS : .191
 MEAN RADIUS : 1.775
 MAX RADIUS : 3.248
 CENTROID X : .438
 CENTROID Y : .353

23 Oct 2000

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/c6225076

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 5.72

1

VS= 2.63

2

GS= 5.75

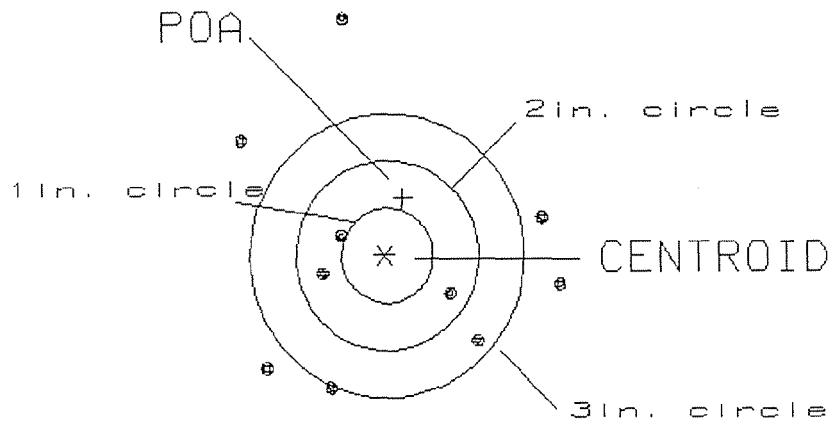
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PATTERN #: 2
 POA TO CENTROID: .636
 MIN RADIUS : .548
 MEAN RADIUS : 1.479
 MAX RADIUS : 2.534
 CENTROID X : -.193
 CENTROID Y : -.606

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225076

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.49
 VS= 3.86
 GS= 3.86

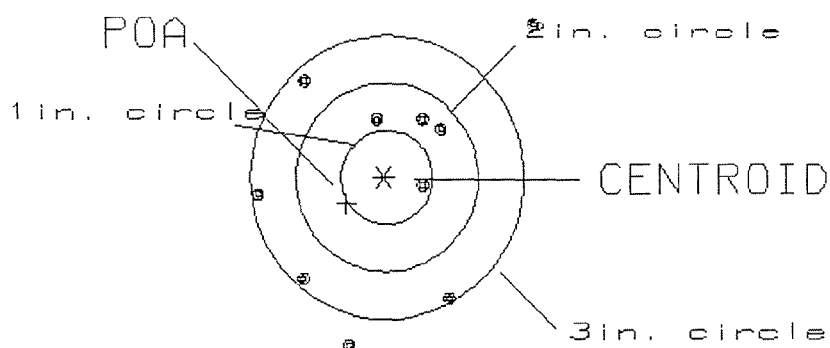
0
 3
 4

PATTERN #: 5 3 5
 POA TO CENTROID: .496
 MIN RADIUS : .438
 MEAN RADIUS : 1.229
 MAX RADIUS : 2.306
 CENTROID X : .410
 CENTROID Y : .280

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225076

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.03

1

VS= 3.42

4

GS= 4.01

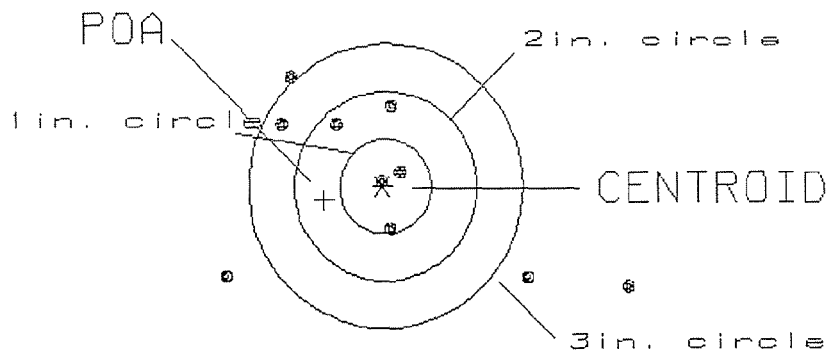
9

PATTERN #: 4
 POA TO CENTROID: .659
 MIN RADIUS : .094
 MEAN RADIUS : 1.201
 MAX RADIUS : 2.859
 CENTROID X : .642
 CENTROID Y : .150

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225076

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

H3= 4.40
 V3= 2.19
 G3= 4.40

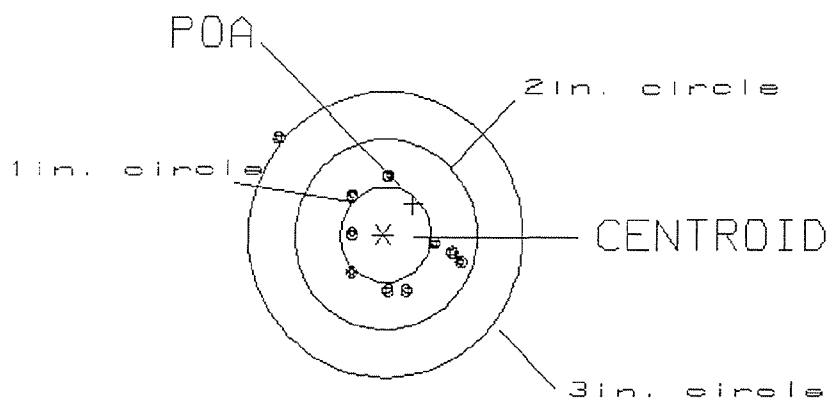
3
 5
 6

PATTERN #: 5
 POA TO CENTROID: .458
 MIN RADIUS : .375
 MEAN RADIUS : .684
 MAX RADIUS : 1.554
 CENTROID X : -.328
 CENTROID Y : -.320

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225076

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.00

3

VS= 1.68

9

GS= 2.38

9