

66225133

New Action

E6374578

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



[illegible]

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225/33

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	2/1	FB
600	PROOF	2/2/88	RW
615	MAGNAFLUX BARREL	2/18/88	P/C
	MAGNAFLUX BOLT	5/13/88	P/C
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225133

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace			
610	Dis-assemble gun	QUALITY AUDIT		
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

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/26/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		26 Aug 88	W.B. + J.S.
	F) Safety on Force	6.5 6.5 6.25	26 Aug 88	W.B. + J.S.
	G) Safety off Force	2.5 2.5 2.5	26 Aug 88	W.B. + J.S.
	H) Trigger Pull Test & Retainability		26 Aug 88	W.B. + J.S.
	I) Firing Pin Indent	.023 .023 .0235	26 Aug 88	W.B. + J.S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-6-88	J.S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/3/88	J.S.
640	Gallery Target & Test	73 R 82 L	10/3/88	W.B.
	A) Optical Clarity of Scope		10/3/88	W.B.
645	Inspect for Live Ammo		10/3/88	A.C.
655	Final Inspection			
	A) Headspace		10-6-88	J.S.
	B) Trigger Pull		10-6-88	J.S.
	C) Function		10-6-88	J.S.
660	Pack		10-20-88	J.S.

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225133DATE 26 Aug 88TESTER W.B. + B.8

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.56	2.51	2.60	2.67	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.40	2.57	2.63	
PULL #3	2.47	2.37	2.52	2.62	
PULL #4	2.45	2.39	2.52	2.66	
PULL #5	2.47	2.37	2.53	2.65	
TOTAL	12.41	11.94	12.74	13.23	
AVG.	2.482	2.388	2.548	2.65	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.34		
PULL #2	3.26	3.31		
PULL #3	3.32	3.33		
PULL #4	3.31	3.30		
PULL #5	3.35	3.39		
TOTAL	16.53	16.67		
AVG.	3.306	3.334		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.32	4.28		4.15
PULL #2	4.22	4.29		4.27
PULL #3	4.32	4.31		4.29
PULL #4	4.32	4.28		4.23
PULL #5	4.35	4.31		4.26
TOTAL	21.53	21.47		21.20
AVG.	4.306	4.294		4.24

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225133

CENTROIDAL DISTANCES

0 TO	1	.955701
1 TO	2	.711557
1 TO	3	.616651
1 TO	4	1.04615
1 TO	5	1.45947

+
4 3 1
5
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1178
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.6908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .700772
THE AMR FOR THIS RIFLE IS: 1.165

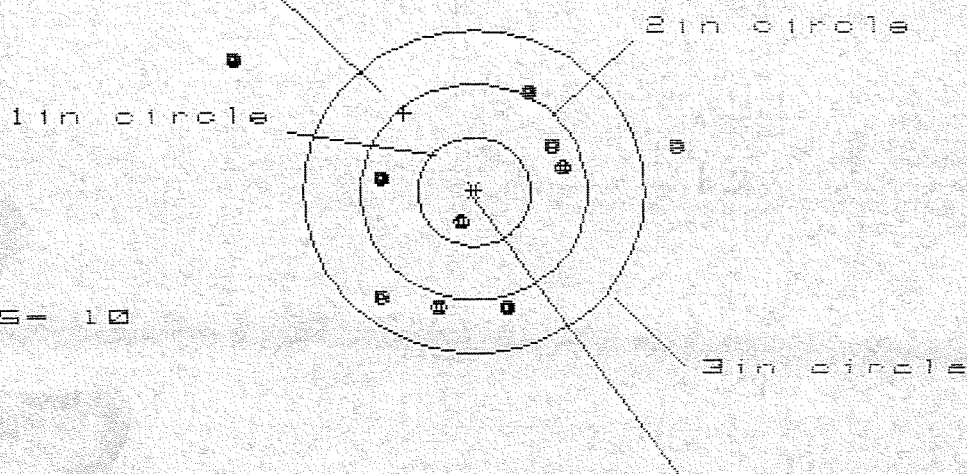
5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225133

CENTERFIRE PATTERNS

1

POB



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 3.916

VS= 2.290

GS= 4.001

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.821	1.589	.776
MINIMUM X	-2.095	-1.031	-.833
MAXIMUM Y	1.221	1.029	1.096
MINIMUM Y	-1.069	-.933	-.866
CENTROID X	.618	.850	.652
CENTROID Y	-.729	-.865	-.932
POB TO CENTROID in.	.955	1.213	1.137
MIN RADIUS	.237	.325	.116
MEAN RADIUS	1.149	.988	.872
MAX RADIUS	2.424	1.678	1.189
HORIZONTAL SPREAD	3.916	2.620	1.609
VERTICAL SPREAD	2.290	1.962	1.962
EXTREME SPREAD	4.001	2.957	2.267
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225133

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS = 3.002

VS = 3.216

GS = 3.549

CENTROID *

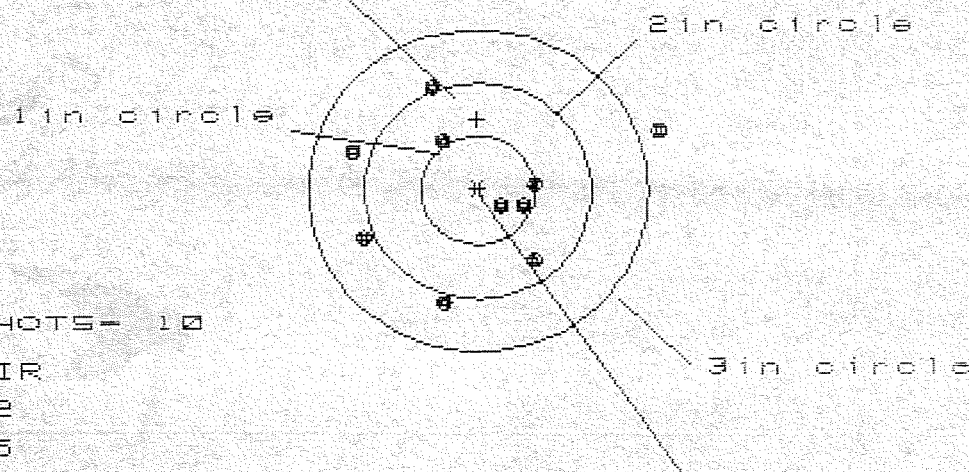
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.014	1.931	1.502
MINIMUM X	:	-.988	-1.071	-.829
MAXIMUM Y	:	2.045	1.592	1.628
MINIMUM Y	:	-1.171	-.944	-.908
CENTROID X	:	-.015	.068	-.174
CENTROID Y	:	-.404	-.631	-.667
POA TO CENTROID in.	:	.404	.635	.689
MIN RADIUS	:	.682	.814	.570
MEAN RADIUS	:	1.310	1.187	1.032
MAX RADIUS	:	2.176	1.952	1.703
HORIZONTAL SPREAD	:	3.002	3.002	2.331
VERTICAL SPREAD	:	3.216	2.536	2.536
EXTREME SPREAD	:	3.549	3.009	2.905
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225133

CENTERFIRE PATTERNS # 3

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.734

VS= 2.036

GS= 2.787

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.583	.718	.596
MINIMUM X	:	-1.151	-.975	-.992
MAXIMUM Y	:	1.001	1.059	1.107
MINIMUM Y	:	-1.035	-.977	-.930
CENTROID X	:	.005	-.171	-.049
CENTROID Y	:	-.662	-.720	-.767
POA TO CENTROID in.	:	.662	.740	.769
MIN RADIUS	:	.265	.393	.262
MEAN RADIUS	:	.879	.804	.744
MAX RADIUS	:	1.668	1.094	1.175
HORIZONTAL SPREAD	:	2.734	1.693	1.588
VERTICAL SPREAD	:	2.036	2.036	2.036
EXTREME SPREAD	:	2.787	2.040	2.040
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

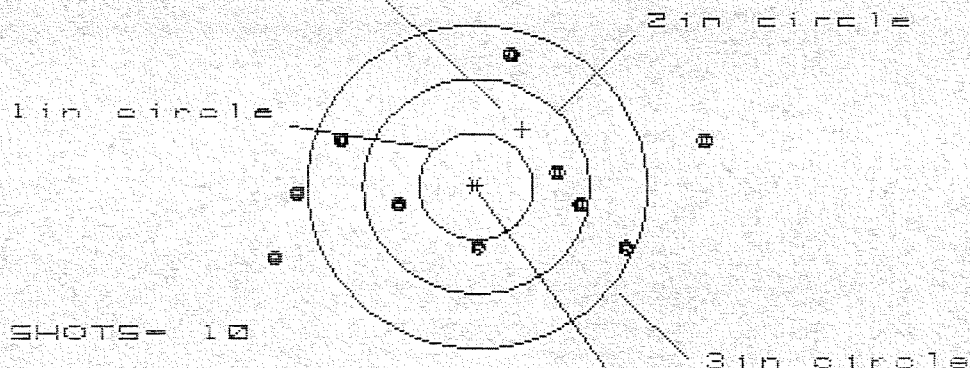
5 Oct 1986

FILE:/PATTERNING/CENTERFIRE_PATT/06225133

CENTERFIRE PATTERNS

4

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 3.850

VS = 1.938

GS = 3.997

CENTROID *

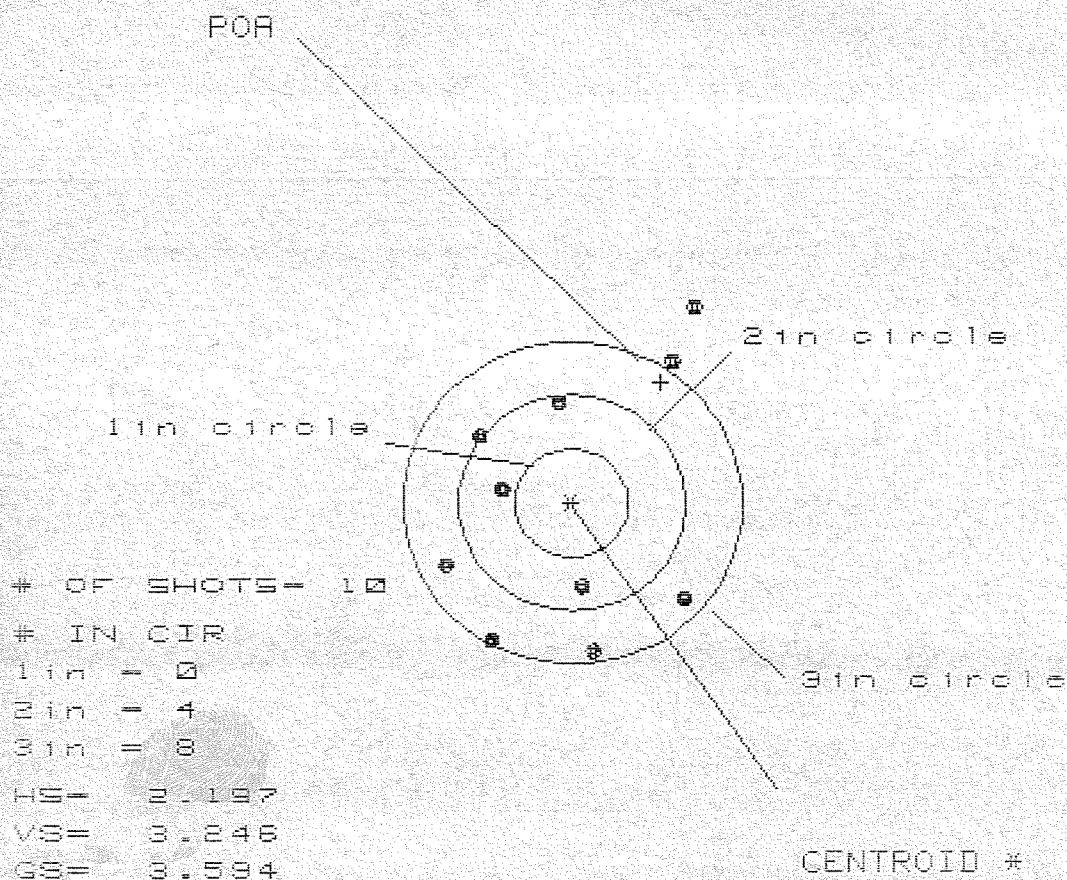
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.037	1.525	1.327
MINIMUM X	:	-1.813	-1.586	-1.545
MAXIMUM Y	:	1.268	1.314	1.236
MINIMUM Y	:	-.670	-.624	-.591
CENTROID X	:	-.410	-.637	-.439
CENTROID Y	:	-.535	-.581	-.502
POA TO CENTROID in.	:	.675	.862	.667
MIN RADIUS	:	.560	.462	.595
MEAN RADIUS	:	1.239	1.135	1.051
MAX RADIUS	:	2.077	1.705	1.551
HORIZONTAL SPREAD	:	3.850	3.111	2.871
VERTICAL SPREAD	:	1.938	1.938	1.826
EXTREME SPREAD	:	3.997	3.115	2.901

NUMBER IN ONE INCH CIRCLE	=	0
NUMBER IN TWO INCH CIRCLE	=	4
NUMBER IN THREE INCH CIRCLE	=	7

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225133

CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.087	1.132	1.254
MINIMUM X	:	-1.110	-.989	-.867
MAXIMUM Y	:	1.831	1.573	1.286
MINIMUM Y	:	-1.415	-1.212	-1.015
CENTROID X	:	-.787	-.908	-1.030
CENTROID Y	:	-1.124	-1.327	-1.524
POA TO CENTROID in.	:	1.372	1.608	1.840
MIN RADIUS	:	.618	.591	.497
MEAN RADIUS	:	1.246	1.114	.991
MAX RADIUS	:	2.130	1.853	1.331
HORIZONTAL SPREAD	:	2.197	2.121	2.121
VERTICAL SPREAD	:	3.246	2.785	2.301
EXTREME SPREAD	:	3.594	3.081	2.318
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225133

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/18/92	RW
607	Check Headspace		2/18/92	RW
610	Dis-assemble Gun		2/18/92	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			
	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		2/21/92	WB

op. #	DESCRIPTION	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/25/92	WB
	G) Safety Off Force	2	2	2			2/25/92	WB
	H) Trigger Pull Test & Retainability						2/21/92	WB
	I) Firing Pin Indent	.020	.020	.020			2/25/92	WB
	J) Assemble Stock						2/24/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						2/24/92	RW
	M) Iron Sight Alignment						2/24/92	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						2-24-92	A
	A) Time						2-24-92	A
	B) Malfunctions						2-24-92	A
	C) Pierced Primers						2-24-92	A
	D) Optical Clarity of Scope						2-24-92	A
645	Inspect for Live Ammo						2-24-92	A
655	Final Inspection						2/25/92	WB
	A) Headspace							
	B) Trigger Pull	2.41	2.69	2.35	2.38	2.35	2-25-92	WB
	C) Function						2/25/92	WB
660	Pack							

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6225133

DATE 2/21/92

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.48	2.78	2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.39	2.35	2.43	2.69	
PULL #3	2.34	2.20	2.78	2.35	
PULL #4	2.37	2.21	2.39	2.38	
PULL #5	2.38	2.38	2.31	2.35	
TOTAL	11.94	11.62	11.69		
AVG.	2.39	2.32	2.34		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.17		
PULL #2	3.09	3.08		
PULL #3	3.17	3.08		
PULL #4	3.16	3.16		
PULL #5	3.10	3.09		
TOTAL	15.67	15.58		
AVG.	3.13	3.12		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.13		4.32
PULL #2	4.01	4.30		4.06
PULL #3	4.12	4.09		4.08
PULL #4	4.21	4.26		4.27
PULL #5	4.12	4.11		4.04
TOTAL	20.61	20.89		20.77
AVG.	4.12	4.18		4.15

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPSFILE N^o 006777DATE 27 JAN 92OWNER'S NAME: CPT MK STEPHENSON REMINGTON EMPLOYEE:OWNER'S ADDRESS: Co D, 2nd BN, 1st SWTG YES ☐ NO ☐EMPLOYEE # DEPT. # ZIP: 28307-5000PHONE: (919) 396-7330FIREARM MODEL: M24CHECK FOR AMMUNITION ☒GAUGE: 308SERIAL # C6225733

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAINMETAL GOOD FAIR POOR FANCY PLAINBARREL 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: REBARRELSIGNATURE: [Signature]
(Person delivering firearm to Plant)DATE: 27 JAN 92SIGNATURE: [Signature]
(Security Officer)DATE: 1/27/92SIGNATURE: [Signature]
(Firearm picked up by)DATE: 1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225133
24 Feb 1992

CENTROIDAL DISTANCES

0 TO 1	.0865852
1 TO 2	.599254
1 TO 3	.351262
1 TO 4	.350956
1 TO 5	.0487647

$\frac{5}{4} 3^2$ <----POA

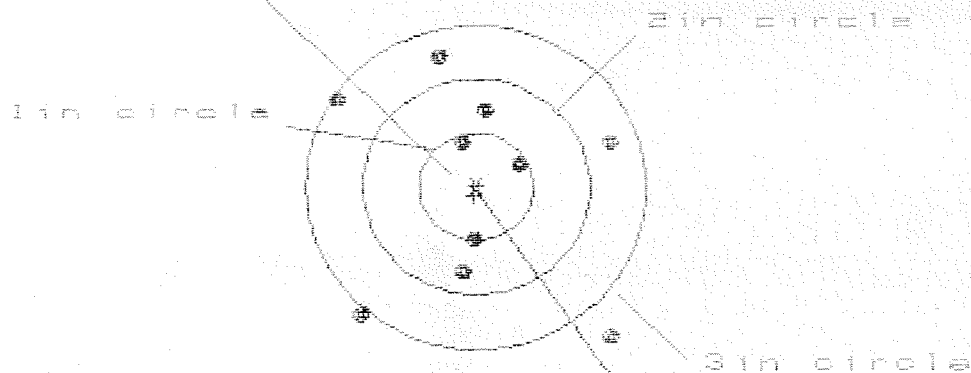
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1574
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .098
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .185415
THE AMR FOR THIS RIFLE IS: 1.187

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225133

CENTERFIRE PATTERNS # 1

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.425

VS= 2.580

GS= 3.296

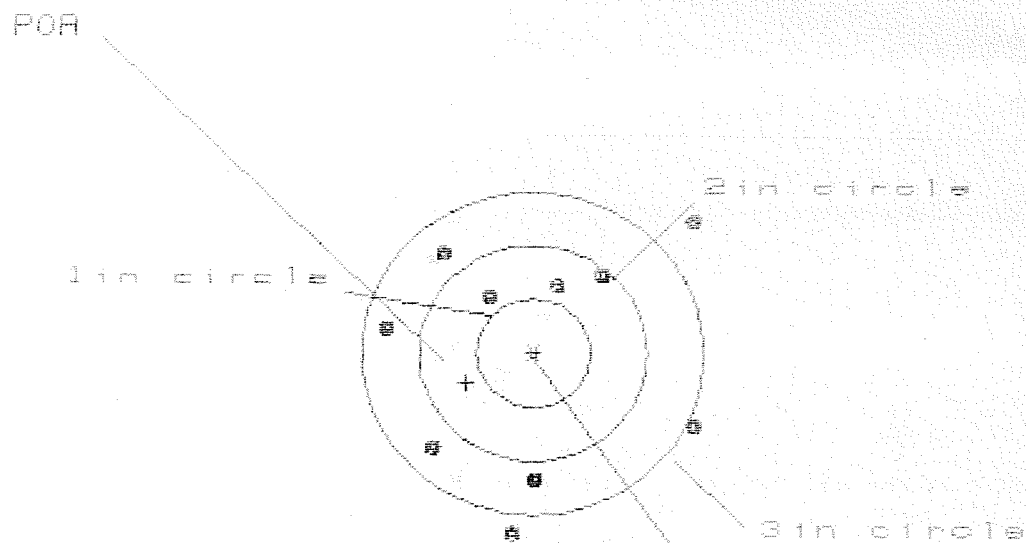
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.155	1.276	1.170
MINIMUM X	-1.270	-1.142	-1.248
MAXIMUM Y	1.185	1.030	1.056
MINIMUM Y	-1.395	-1.386	-1.083
CENTROID X	.021	-.107	-.001
CENTROID Y	.084	.239	.413
POA TO CENTROID in.	.087	.262	.413
MIN RADIUS	.426	.289	.143
MEAN RADIUS	1.015	.912	.777
MAX RADIUS	1.811	1.624	1.347
HORIZONTAL SPREAD	2.425	2.418	2.418
VERTICAL SPREAD	2.580	2.416	1.939
EXTREME SPREAD	3.296	2.672	2.458
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225133

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 2.697

VS= 2.883

GS= 3.306

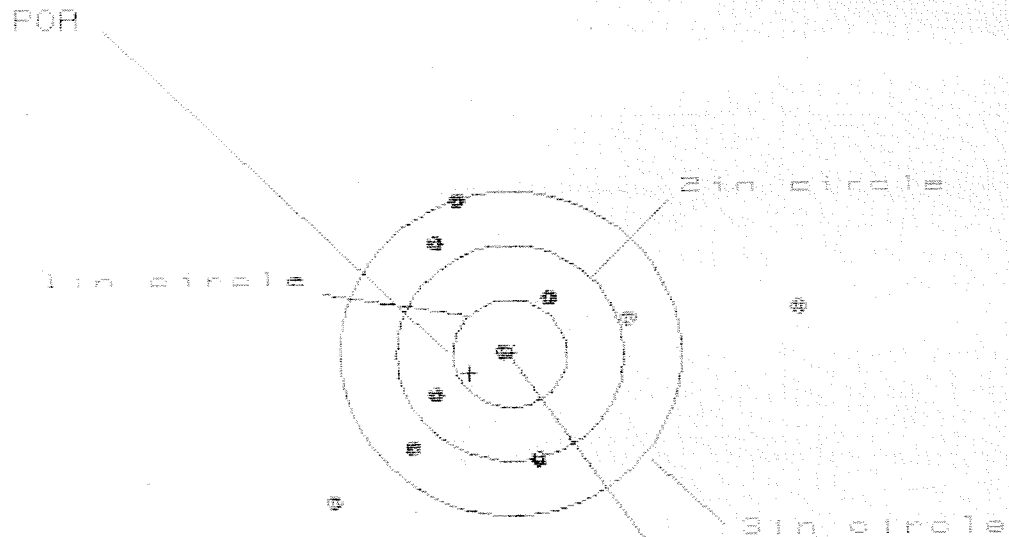
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.395	1.534	1.526
MINIMUM X	:	-1.302	-1.147	-1.155
MAXIMUM Y	:	1.225	1.107	.917
MINIMUM Y	:	-1.658	-1.522	-1.191
CENTROID X	:	.590	.435	.444
CENTROID Y	:	.272	.136	.326
POA TO CENTROID in.	:	.650	.456	.551
MIN RADIUS	:	.635	.695	.518
MEAN RADIUS	:	1.227	1.154	1.072
MAX RADIUS	:	1.856	1.631	1.697
HORIZONTAL SPREAD	:	2.697	2.681	2.681
VERTICAL SPREAD	:	2.883	2.629	2.108
EXTREME SPREAD	:	3.306	2.843	2.843
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

24 Feb 1992

FILE: PATTERNING/CENTERFIRE_PATT/08225133

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 7

HS= 4.152

VS= 2.828

GS= 4.524

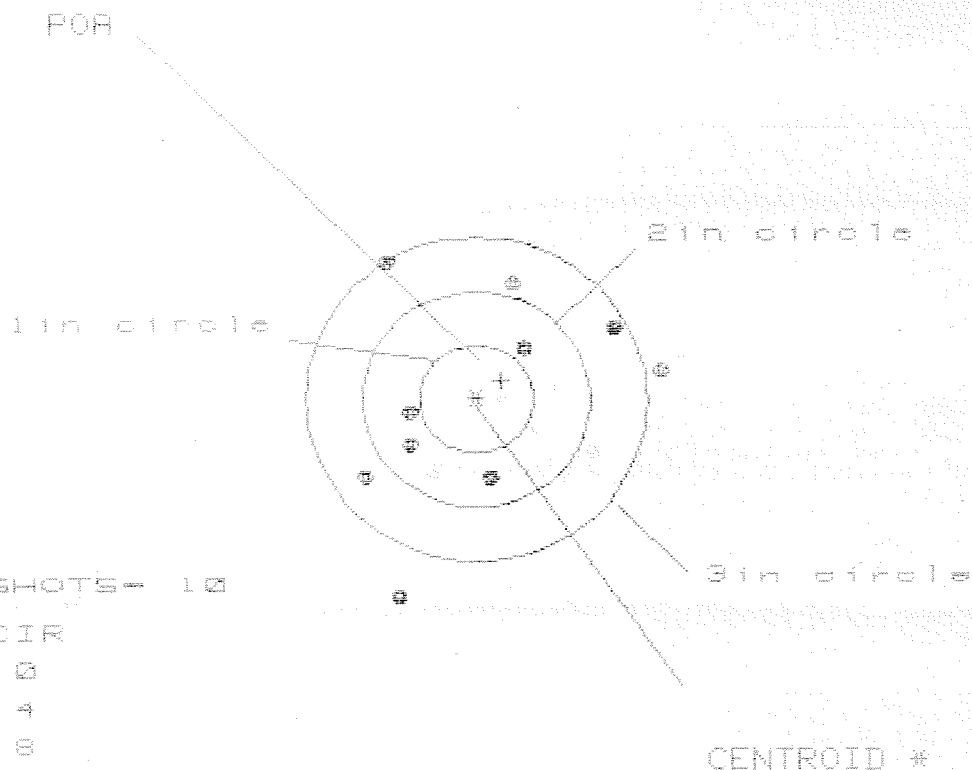
CENTROID *

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.572	1.375	1.213
MINIMUM X	-1.588	-1.294	-1.785
MAXIMUM Y	1.413	1.455	1.284
MINIMUM Y	-1.415	-1.373	-1.139
CENTROID X	.368	.074	.236
CENTROID Y	.176	.134	.385
POA TO CENTROID in.	.401	.153	.386
MIN RADIUS	.070	.259	.110
MEAN RADIUS	1.223	1.066	.932
MAX RADIUS	2.600	1.987	1.340
HORIZONTAL SPREAD	4.152	2.669	1.918
VERTICAL SPREAD	2.828	2.828	2.423
EXTREME SPREAD	4.524	3.176	2.542
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	7		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225133

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.521

VS= 3.037

GS= 3.192

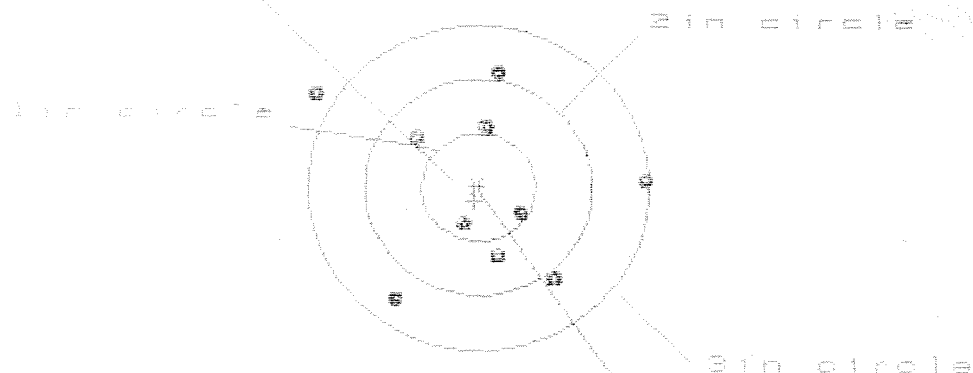
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.569	1.488	1.372
MINIMUM X	-0.952	-1.033	-0.847
MAXIMUM Y	1.260	1.063	1.076
MINIMUM Y	-1.777	-0.964	-0.951
CENTROID X	-0.218	-0.137	-0.323
CENTROID Y	-0.173	0.024	0.011
POA TO CENTROID in.	0.279	0.139	0.323
MIN RADIUS	0.630	0.429	0.585
MEAN RADIUS	1.155	1.060	0.990
MAX RADIUS	1.921	1.492	1.470
HORIZONTAL SPREAD	2.521	2.521	2.219
VERTICAL SPREAD	3.037	2.027	2.027
EXTREME SPREAD	3.192	2.729	2.653
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	4	4	4
NUMBER IN THREE INCH CIRCLE =	8	8	8

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/08225193

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS-- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.887

VS= 2.882

GS= 3.001

CENTROID #

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.436	1.275	.645
MINIMUM X	-1.451	-.906	-.746
MAXIMUM Y	1.104	1.199	1.215
MINIMUM Y	-.989	-.894	-.878
CENTROID X	.834	.195	.005
CENTROID Y	.131	.036	.020
POA TO CENTROID in.	.135	.198	.041
MIN RADIUS	.299	.266	.195
MEAN RADIUS	.916	.807	.737
MAX RADIUS	1.683	1.282	1.230
HORIZONTAL SPREAD	2.887	2.181	1.391
VERTICAL SPREAD	2.093	2.093	2.093
EXTREME SPREAD	3.001	2.489	2.294
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	