

C6225492

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

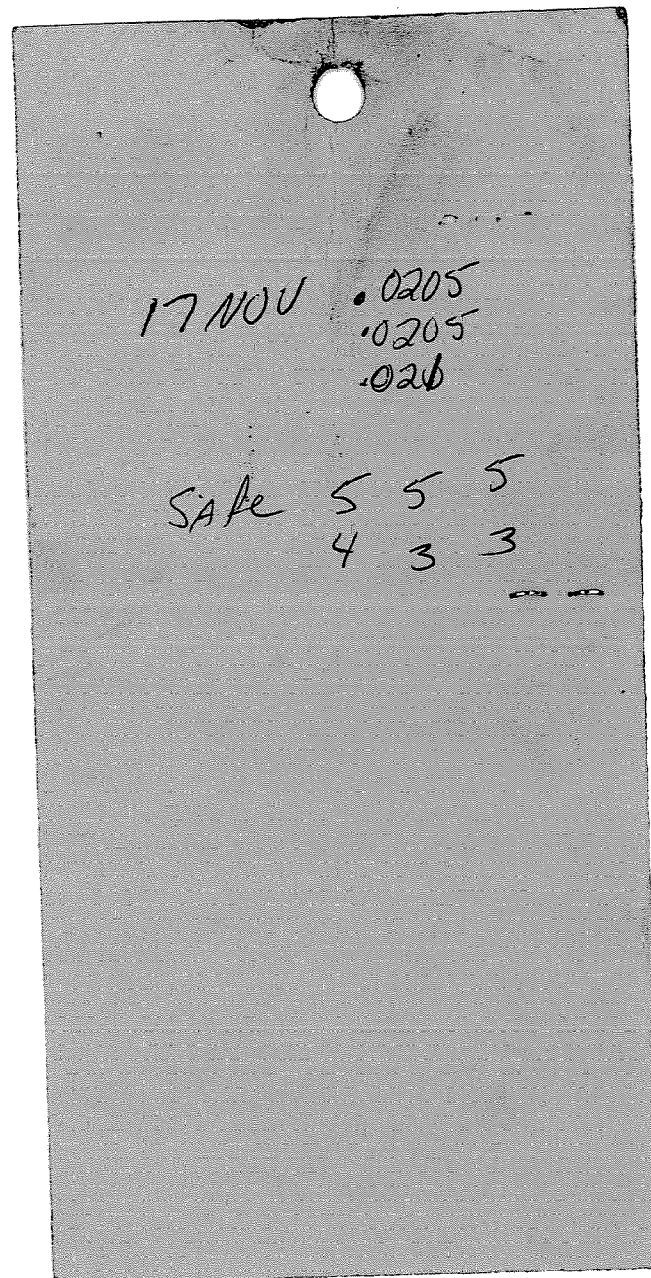


M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225492

OPERATION		DATE	INT
#	NAME		
575- 580	ASSEMBLY	2 26	FB
600	PROOF	2 29	RW
615	MAGNAFLUX BARREL	5/13/88	RFL
	MAGNAFLUX BOLT	5/13/88	RFL
620	COATING	8/11/88	TJA
625- 630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		



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		10/31/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/88	RW
	C) Inspect Ejector Hole for Chamfer		10/31/88	RW

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min. Setting and Stake			
	F) Safety on Force	5 5 5	16 Nov 88	JS
	G) Safety off Force	4 3 3	16 Nov 88	JS
	H) Trigger Pull Test & Retainability		16 Nov 88	JS
	I) Firing Pin Indent	.0705 .0705 .071	16 Nov 88	JS
	J) Assemble Stock		11/7/88	WB
	K) Assemble Swivel Studs		5 Dec 88	JS
	L) Attach Front & Rear Sight Assemblies		11/30/88	WB
	M) Iron Sight Alignment		11/30/88	WB
	N) Detach Front & Rear Sights & place in numbered container		11/30/88	WB
	O) Attach Scope to Rifle		11/29/88	WB
	P) Detach & Attach Scope 20 times		11/29/88	WB
640	Gallery Target & Test		12/1/88	DH
	A) Optical Clarity of Scope		12/1/88	DH
645	Inspect for Live Ammo		12/1/88	DH
655	Final Inspection A) Headspace		5 Dec 88	JS
	B) Trigger Pull		5 Dec 88	JS
	C) Function		5 Dec 88	JS
660	Pack		15 Dec 88	JS

66

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225492DATE 16 NOV 88TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.25	2.39	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.23	2.39	2.41	
PULL #3	2.20	2.25	2.40	2.41	
PULL #4	2.20	2.23	2.37	2.46	
PULL #5	2.18	2.25	2.40	2.46	
TOTAL	11.07	11.21	11.95	12.16	
AVG.	2.214	2.242	2.39	2.432	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.10		
PULL #2	3.16	3.20		
PULL #3	3.15	3.18		
PULL #4	3.12	3.13		
PULL #5	3.14	3.17		
TOTAL	15.74	15.78		
AVG.	3.148	3.156		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.22		4.19
PULL #2	4.16	4.15		4.13
PULL #3	4.14	4.14		4.15
PULL #4	4.11	4.22		4.14
PULL #5	4.13	4.15		4.13
TOTAL	20.69	20.88		20.74
AVG.	4.138	4.176		4.148

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225492

CENTROIDAL DISTANCES

0 TO	1	.6809
1 TO	2	.608823
1 TO	3	.882655
1 TO	4	.982846
1 TO	5	.96421

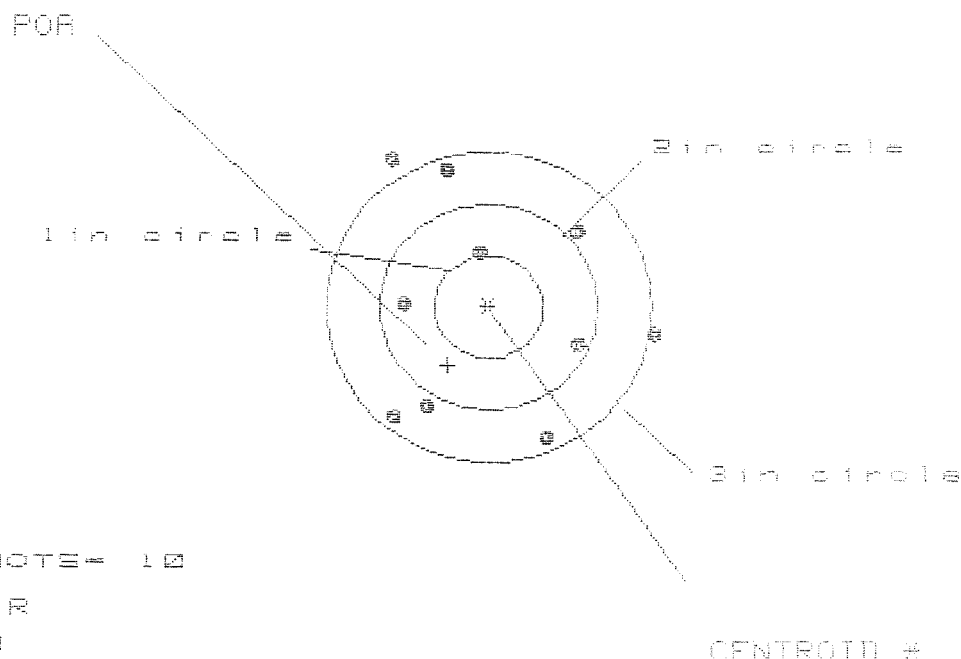
$\frac{1}{n} \sum_{i=1}^n x_i^2$
 + (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2604
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7256
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .778911
 THE AMR FOR THIS RIFLE IS: .9868

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225452

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.433

VS = 2.694

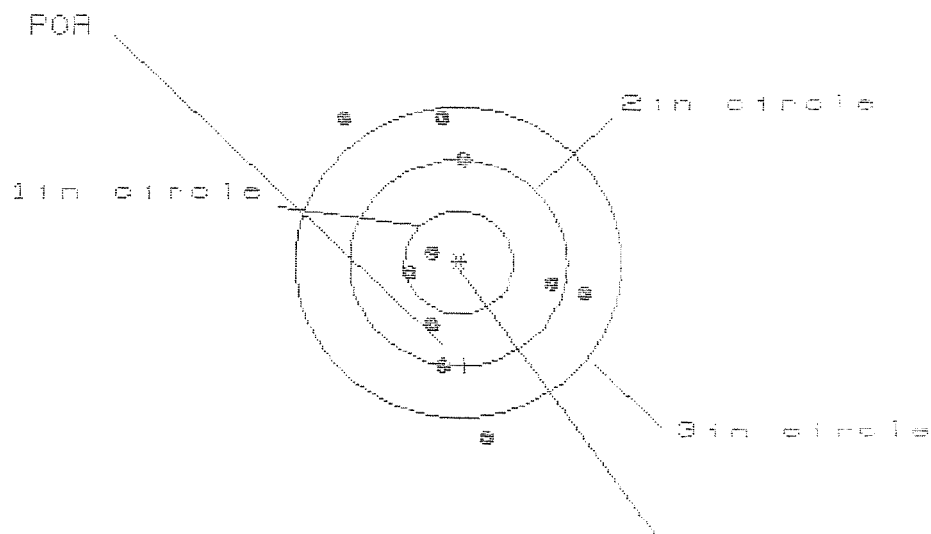
GS = 3.069

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.528	1.428	.917
MINIMUM X	-.905	-1.005	-1.827
MAXIMUM Y	1.427	1.460	1.440
MINIMUM Y	-1.267	-1.108	-1.128
CENTROID X	.380	.480	.302
CENTROID Y	.565	.406	.426
POA TO CENTROID in.	.681	.629	.522
MIN RADIUS	.521	.701	.649
MEAN RADIUS	1.178	1.116	1.061
MAX RADIUS	1.689	1.550	1.480
HORIZONTAL SPREAD	2.433	2.433	1.744
VERTICAL SPREAD	2.694	2.568	2.568
EXTREME SPREAD	3.069	2.751	2.751
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	8		

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8285482

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 8

HS = 2.228

VS = 3.102

GS = 3.336

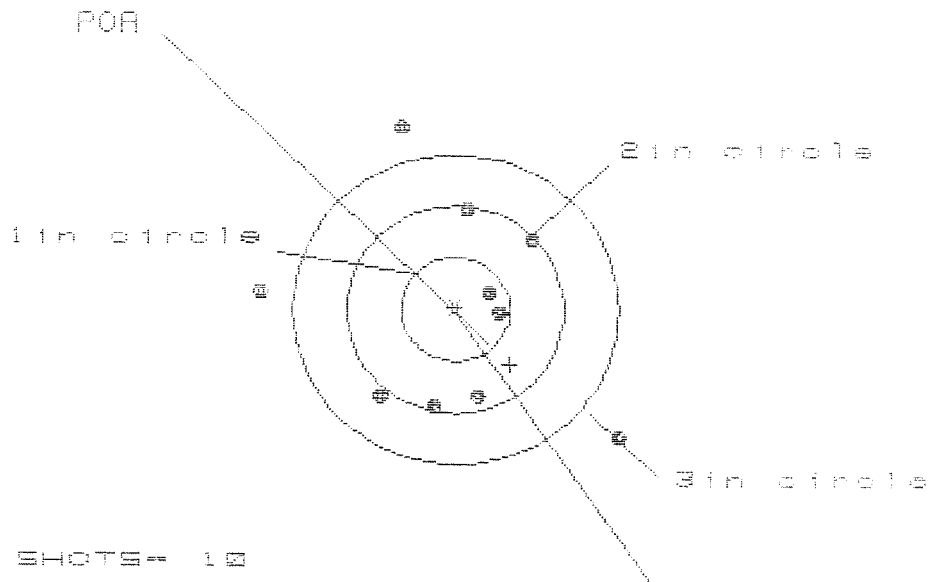
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.159	1.041	1.053
MINIMUM X	-1.069	-.584	-.572
MAXIMUM Y	1.387	1.538	1.343
MINIMUM Y	-1.715	-1.564	-1.050
CENTROID X	-.049	.069	.057
CENTROID Y	.997	.846	1.041
POA TO CENTROID in.	.999	.849	1.043
MIN RADIUS	.254	.428	.348
MEAN RADIUS	1.028	.946	.865
MAX RADIUS	1.732	1.567	1.362
HORIZONTAL SPREAD	2.228	1.625	1.625
VERTICAL SPREAD	3.102	3.102	2.393
EXTREME SPREAD	3.336	3.120	2.393
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225482

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 7

HSP = 3.065

VSP = 2.966

ESP = 3.611

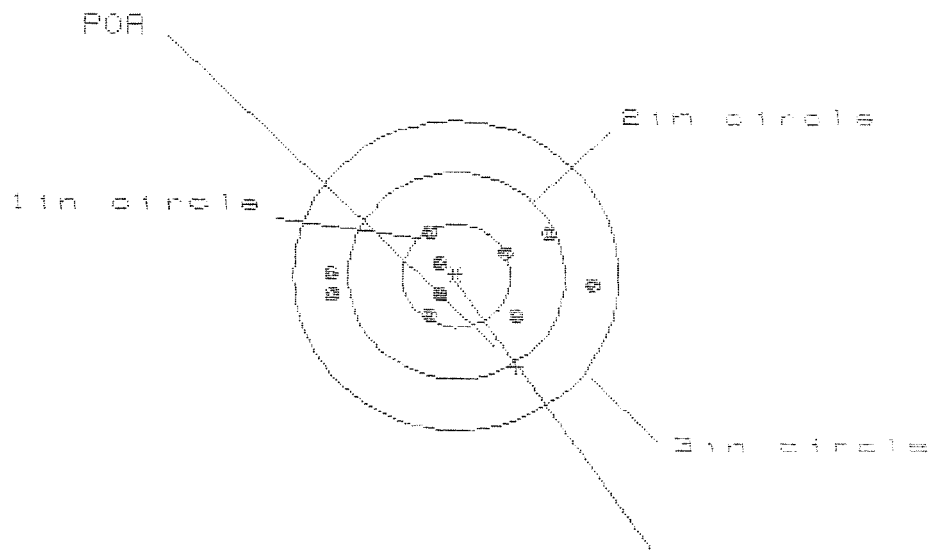
CENTROID #

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.517	.839	.792
MINIMUM X	-1.748	-1.579	-1.626
MAXIMUM Y	1.769	1.636	1.076
MINIMUM Y	-1.197	-1.072	-1.868
CENTROID X	-.502	-.671	-.624
CENTROID Y	.531	.664	.468
POA TO CENTROID in.	.731	.944	.775
MIN RADIUS	.371	.498	.489
MEAN RADIUS	1.108	1.041	.927
MAX RADIUS	1.933	1.678	1.645
HORIZONTAL SPREAD	3.265	2.418	2.418
VERTICAL SPREAD	2.966	2.708	1.944
EXTREME SPREAD	3.611	2.730	2.471
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

1 Dec 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225498

CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

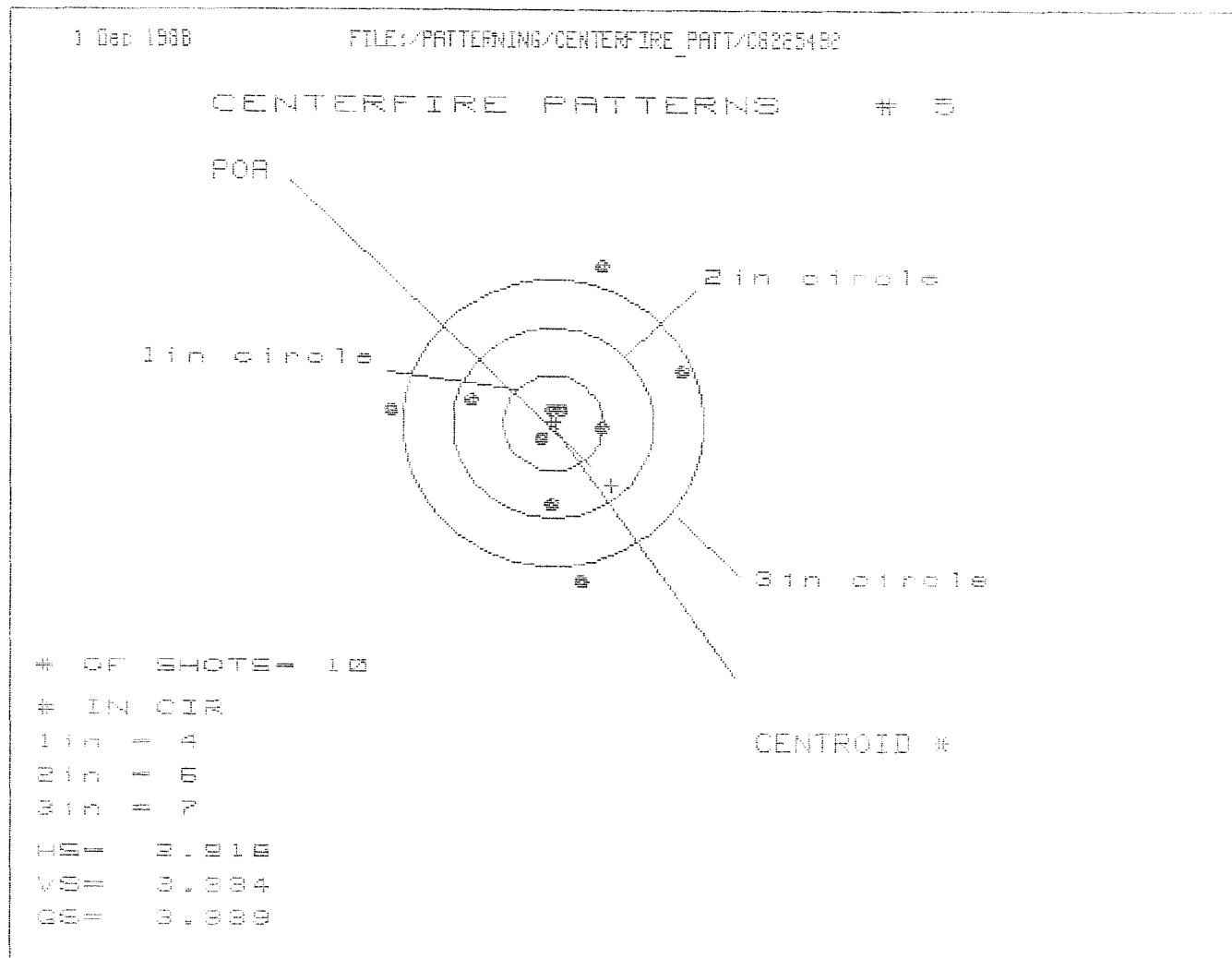
H0 = 0.420

V0 = .848

G0 = 2.429

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.292	.985	.861
MINIMUM X	-1.136	-.993	-1.087
MAXIMUM Y	.432	.420	.394
MINIMUM Y	-.416	-.428	-.454
CENTROID X	-.551	-.694	-.570
CENTROID Y	.880	.892	.918
POA TO CENTROID in.	1.038	1.131	1.081
MIN RADIUS	.209	.130	.195
MEAN RADIUS	.708	.625	.577
MAX RADIUS	1.297	1.066	1.087
HORIZONTAL SPREAD	2.428	1.978	1.940
VERTICAL SPREAD	.848	.848	.848
EXTREME SPREAD	2.429	2.071	1.982
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	



PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.310	1.339	1.399
MINIMUM X	-1.608	-1.579	-1.519
MAXIMUM Y	1.638	1.450	.494
MINIMUM Y	-1.696	-1.079	-1.898
CENTROID X	-.580	-.609	-.669
CENTROID Y	.655	.843	.662
FOR TO CENTROID in.	.875	1.040	.941
MIN RADIUS	.139	.070	.170
MEAN RADIUS	.912	.824	.719
MAX RADIUS	1.716	1.579	1.528
HORIZONTAL SPREAD	2.918	2.918	2.918
VERTICAL SPREAD	3.334	2.529	1.392
EXTREME SPREAD	3.339	2.937	2.937
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	7		

Serial Number:

C6225492

Model: 700



RE00014574

BBL
Boit

96003
96005

Final Inspection

Sn: C6225492

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

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:

Misc.

- ☐ DD-250
- ☐ BAR CODE
- ☐ PACKAGING

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

[illegible]

BARBER - M24 0061912

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225492
25 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.057
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.16
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .16985

THE AMR FOR THIS RIFLE IS: 1.155

CENTROIDAL DISTANCES

0	TO	1	.251962
1	TO	2	.495989
1	TO	3	.314159
1	TO	4	.315734
1	TO	5	.141227

2 4 + 5 <----POA
1
3

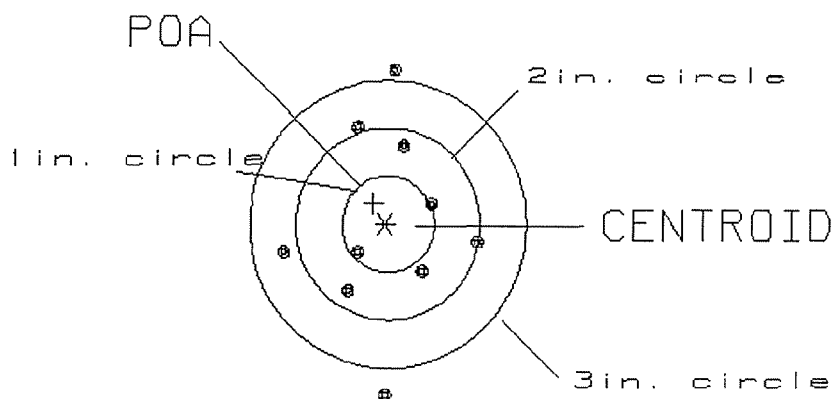
PATTERN #: 1

POA TO CENTROID: .252
 MIN RADIUS : .372
 MEAN RADIUS : .972
 MAX RADIUS : 1.739
 CENTROID X : .133
 CENTROID Y : -.214

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.13
 VS= 3.35
 GS= 3.35

1
 5
 0

BARBER - M24 0061914

REMINGTON CENTERFIRE ACCURACY TEST

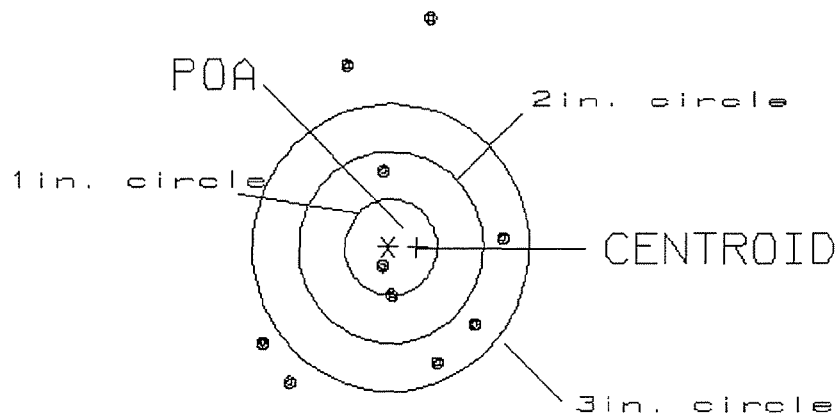
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2
 POA TO CENTROID: .313
 MIN RADIUS : .224
 MEAN RADIUS : 1.307
 MAX RADIUS : 2.403
 CENTROID X : -.313
 CENTROID Y : .003

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.66
 VS= 3.72
 GS= 4.01

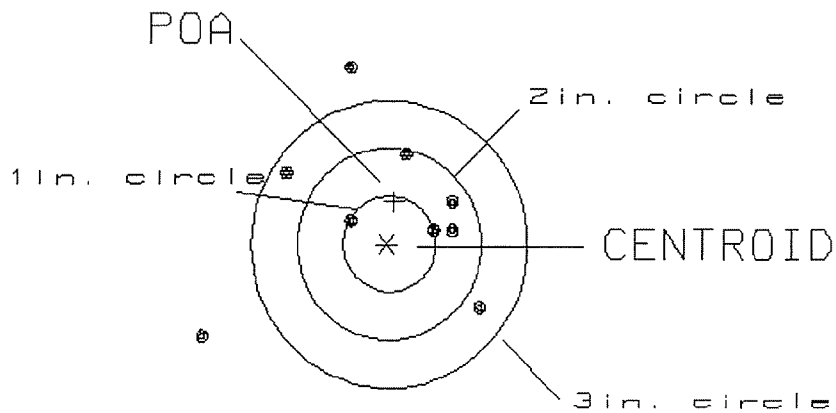
1
 3
 6

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .451
 MIN RADIUS : .443
 MEAN RADIUS : 1.293
 MAX RADIUS : 2.902
 CENTROID X : -.081
 CENTROID Y : -.444

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.00
 VS= 4.64
 GS= 4.82

2
 5
 7

BARBER - M24 0061916

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .165

MIN RADIUS : .373

MEAN RADIUS : 1.144

MAX RADIUS : 2.393

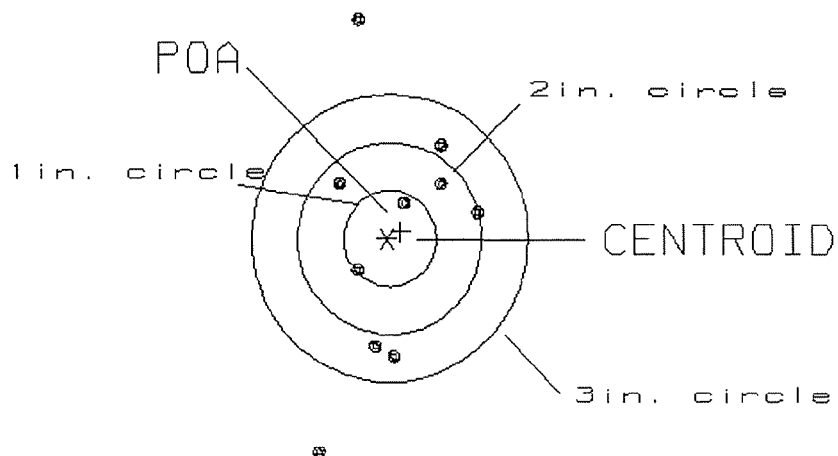
CENTROID X : -.149

CENTROID Y : -.072

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.69

2

VS= 4.51

5

GS= 4.53

8

BARBER - M24 0061917

REMINGTON CENTERFIRE ACCURACY TEST

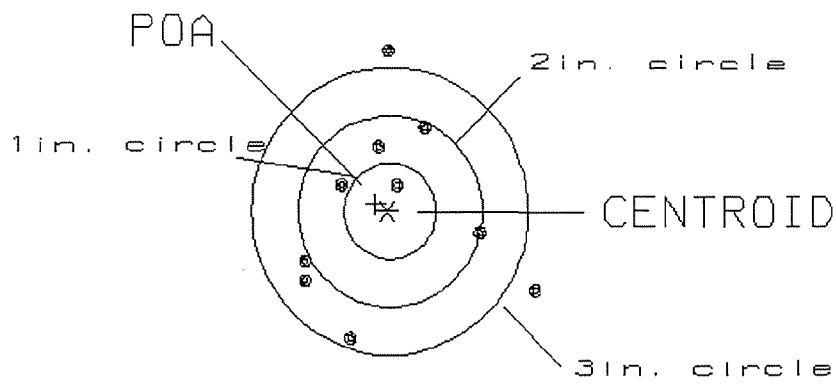
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .145
MIN RADIUS : .306
MEAN RADIUS : 1.061
MAX RADIUS : 1.757
CENTROID X : .125
CENTROID Y : -.073

25 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 5

OF SHOTS= 10

IN CIRCLE

HS= 2.48

1

VS= 2.99

5

GS= 3.02

8

BARBER - M24 0061918

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225492
23 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1156
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12595

THE AMR FOR THIS RIFLE IS: 1.379

CENTROIDAL DISTANCES

0 TO	1	.619137
1 TO	2	.313158
1 TO	3	.810711
1 TO	4	.633834
1 TO	5	.890021

3
5 4 + <----POA
2
1

BARBER - M24 0061919

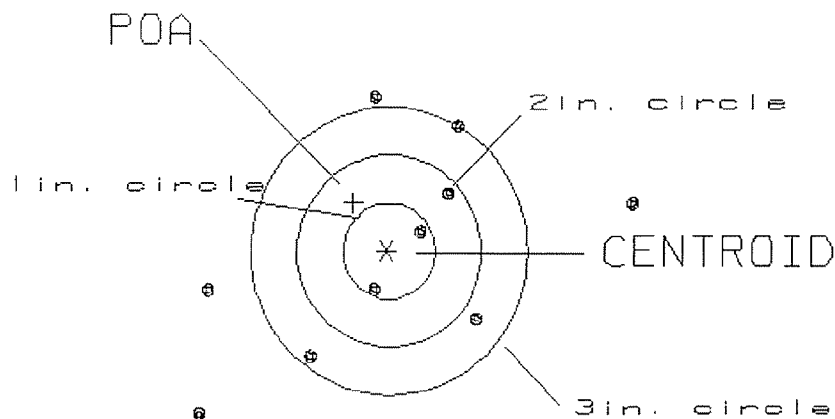
REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
POA TO CENTROID: .619
MIN RADIUS : .394
MEAN RADIUS : 1.462
MAX RADIUS : 2.646
CENTROID X : .361
CENTROID Y : -.503

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 1

OF SHOTS= 10

IN CIRCLE

HS= 4.62

2

VS= 3.30

3

GS= 5.12

6

BARBER - M24 0061920

REMINGTON CENTERFIRE ACCURACY TEST

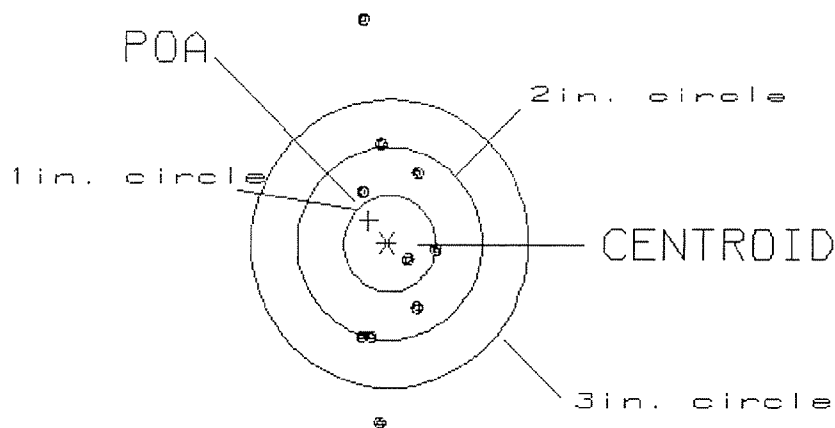
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2
 POA TO CENTROID: .308
 MIN RADIUS : .213
 MEAN RADIUS : 1.017
 MAX RADIUS : 2.374
 CENTROID X : .199
 CENTROID Y : -.235

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= .86

1

VS= 4.23

7

GS= 4.24

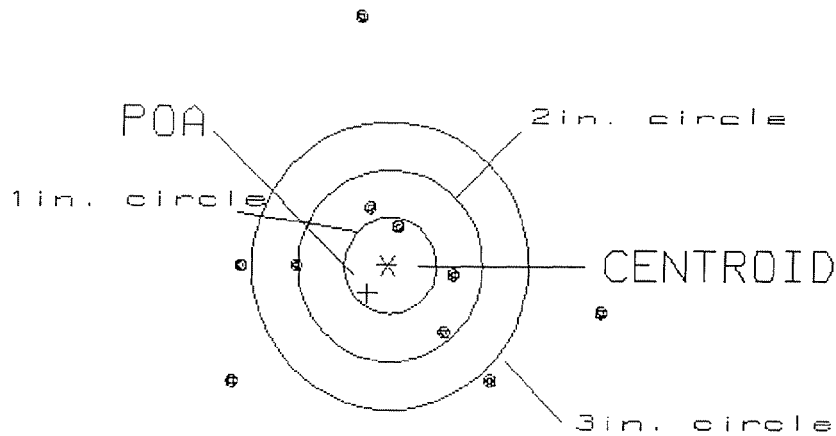
8

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .366
 MIN RADIUS : .431
 MEAN RADIUS : 1.401
 MAX RADIUS : 2.660
 CENTROID X : .218
 CENTROID Y : .295

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.97

1

VS= 3.87

5

GS= 4.13

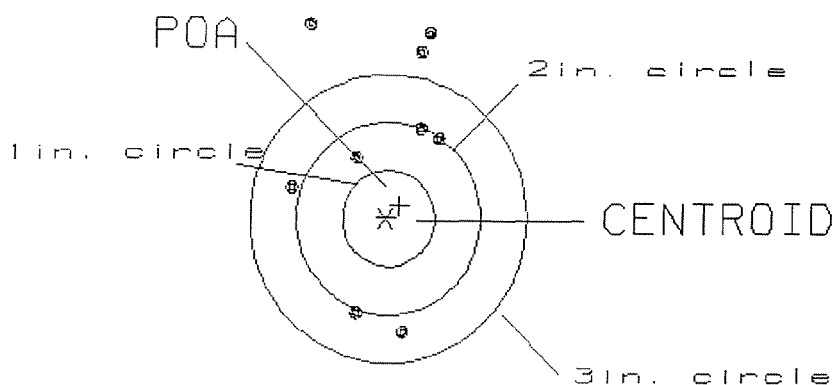
5

PATTERN #: ☐ 4 ☐
 POA TO CENTROID: .198
 MIN RADIUS : .721
 MEAN RADIUS : 1.634
 MAX RADIUS : 3.138
 CENTROID X : -.150
 CENTROID Y : -.128

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 4



OF SHOTS= 11

•

IN CIRCLE

H3= 1.54

0

US= 5.11

3

GS= 5.27

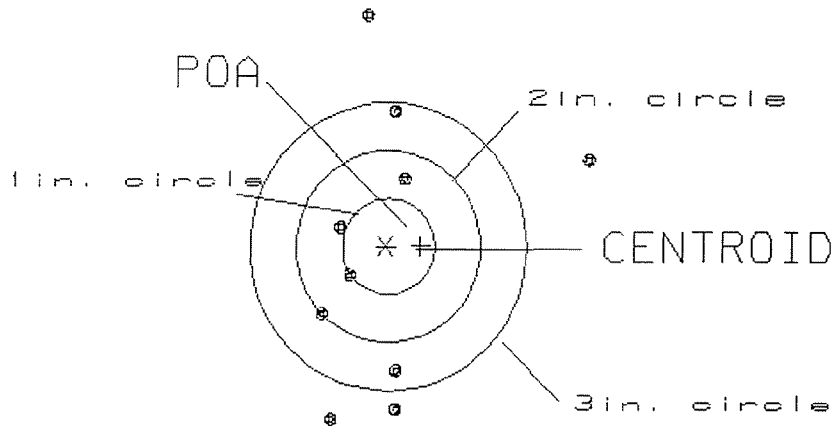
6

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .378
 MIN RADIUS : .506
 MEAN RADIUS : 1.382
 MAX RADIUS : 2.398
 CENTROID X : -.378
 CENTROID Y : -.007

23 Oct 2000

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.94
 VS= 4.14
 GS= 4.16

0
 3
 6