

C6348772

MODEL 700TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348772

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 11	89	RW
610	Dis-assemble Gun	9 11	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9-15-89	G.S.
7	Drill and Tap Sight Holes	9 15	89	JB
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4 Oct 89	SS

op. #	BARBER - M24 0063570 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/4/89	gcl
	G) Safety Off Force	3	3	3			10/4/89	gcl
	H) Trigger Pull Test & Retainability						4 Oct 89	gcl
	I) Firing Pin Indent	.021	.021	.0205			10/4/89	gcl
	J) Assemble Stock						10/6/89	RW
	K) Assemble Swivel Studs						9 Oct 89	gcl
	L) Attach Front and Rear Sight Assemblies						10/6/89	RW
	M) Iron Sight Alignment						10/6/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/6/89	RW
	O) Attach Scope to Rifle						10/6/89	gcl
	P) Detach & Attach Scope 20 Times						10/6/89	gcl
640	Gallery Target & Test						10-6-89	DH
	A) Time						10-6-89	DH
	B) Malfunctions						10-6-89	DH
	C) Pierced Primers						10-6-89	DH
	D) Optical Clarity of Scope						10-6-89	DH
645	Inspect for Live Ammo						10-6-89	DH
655	Final Inspection						9 Oct 89	gcl
	A) Headspace						9 Oct 89	gcl
	B) Trigger Pull	273	236	212	228	252	9 Oct 89	gcl
	C) Function						9 Oct 89	gcl
660	Pack						14 Dec 89	gcl

BARBER - M24 0063571

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 8772DATE 22 Mar 90TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.40	2.55	2.49	MIN. SETTING,
PULL #2	2.61	2.65	2.43	NO AVG. OF 5
PULL #3	2.60	2.54	2.43	READINGS ACCEPT-
PULL #4	2.37	2.48	2.22	ABLE LESS THAN 2#
PULL #5	2.54	2.50	2.32	
TOTAL	12.58	12.72		
AVG.	2.516	2.544		

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.11	3.10	
PULL #2	3.20	3.18	
PULL #3	3.18	3.10	
PULL #4	3.14	3.04	
PULL #5	3.11	3.08	
TOTAL	15.76	15.43	
AVG.	3.152	3.086	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.26		
PULL #2	4.29	4.25		
PULL #3	4.18	4.25		
PULL #4	4.26	4.27		
PULL #5	4.27	4.24		
TOTAL	21.06	21.27		
AVG.	4.212	4.254		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348772
6 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.676574
1 TO	2	.665472
1 TO	3	.840486
1 TO	4	.632724
1 TO	5	1.19598

243⁵ <----POA

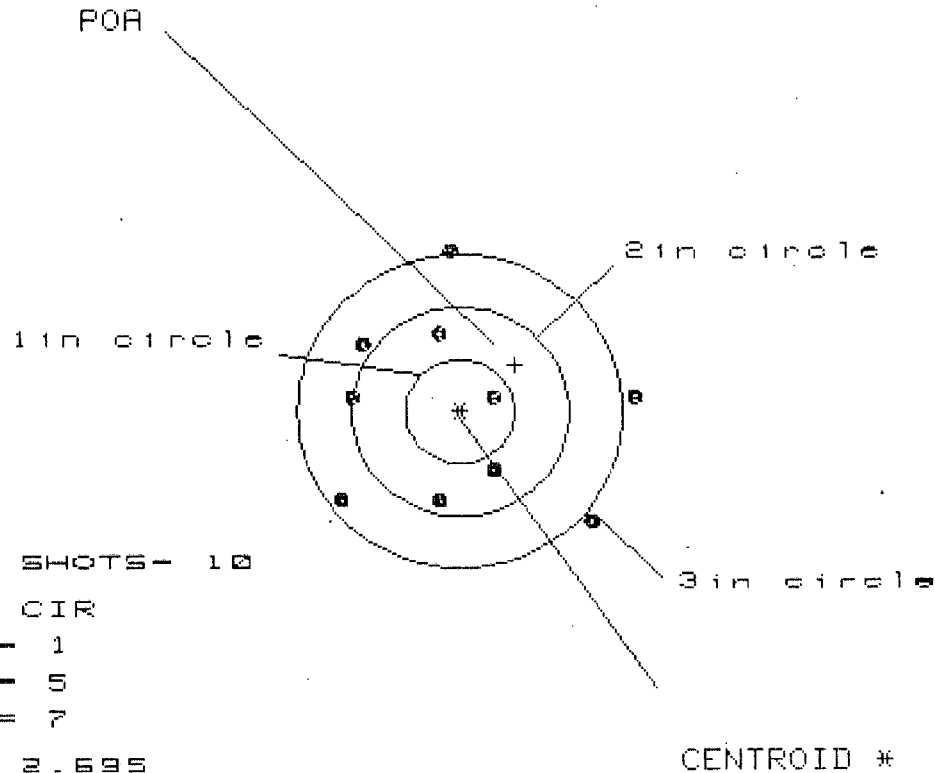
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0054
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0378
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0381838
THE AMP FOR THIS RIFLE IS: 1.062

6 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348722

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 7

HS= 2.695

VS= 2.549

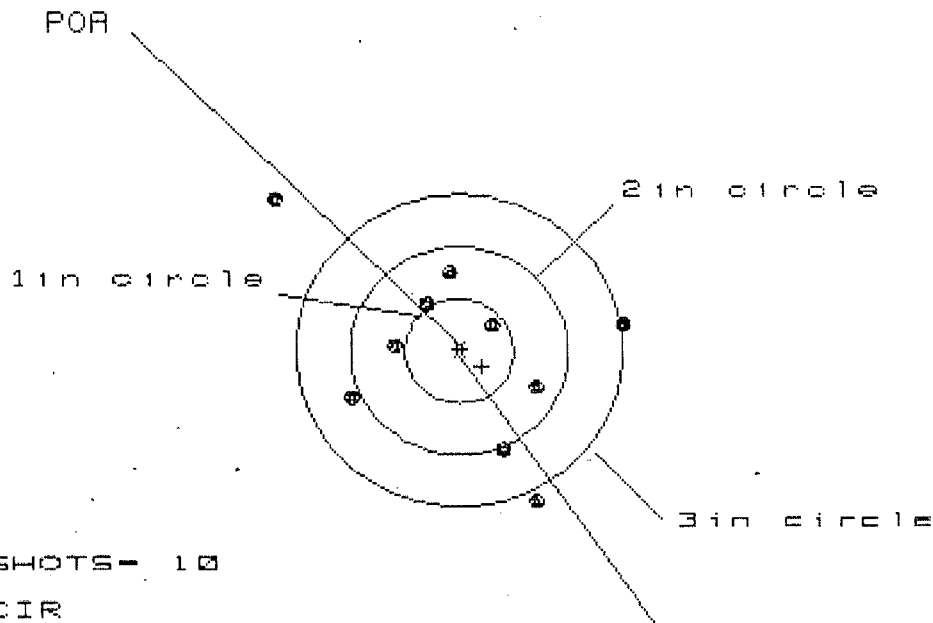
GS= 2.851

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.609	1.336	.673
MINIMUM X	-1.086	-.907	-.740
MAXIMUM Y	1.516	1.529	1.401
MINIMUM Y	-1.033	-1.020	-.966
CENTROID X	-.507	-.686	-.853
CENTROID Y	-.448	-.461	-.333
POA TO CENTROID in.	.676	.826	.915
MIN RADIUS	.345	.518	.608
MEAN RADIUS	1.073	1.004	.901
MAX RADIUS	1.613	1.681	1.423
HORIZONTAL SPREAD	2.695	2.243	1.413
VERTICAL SPREAD	2.549	2.549	2.367
EXTREME SPREAD	2.851	2.842	2.529
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

6 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346772

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 7

HS= 3.194

VS= 2.875

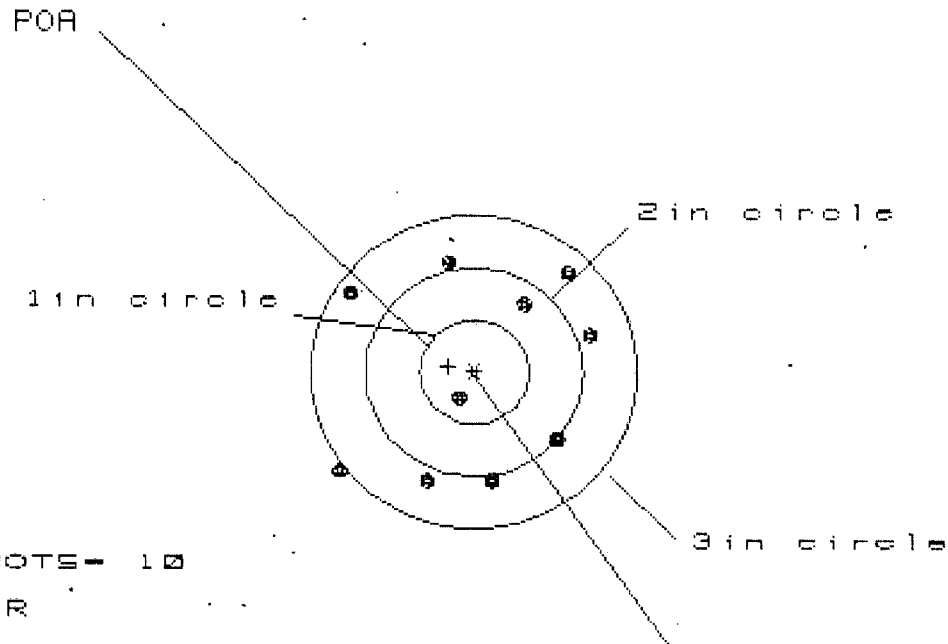
GS= 3.742

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.547	1.364	1.435
MINIMUM X	-1.647	-1.172	-1.101
MAXIMUM Y	1.452	.917	.759
MINIMUM Y	-1.423	-1.261	-.963
CENTROID X	-.205	-.022	-.093
CENTROID Y	.145	-.017	.141
POA TO CENTROID in.	.251	.028	.169
MIN RADIUS	.391	.457	.329
MEAN RADIUS	1.059	.934	.848
MAX RADIUS	2.196	1.424	1.457
HORIZONTAL SPREAD	3.194	2.536	2.536
VERTICAL SPREAD	2.875	2.178	1.722
EXTREME SPREAD	3.742	2.629	2.629
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	7	

6 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348772

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.304

VS= 2.083

GS= 2.862

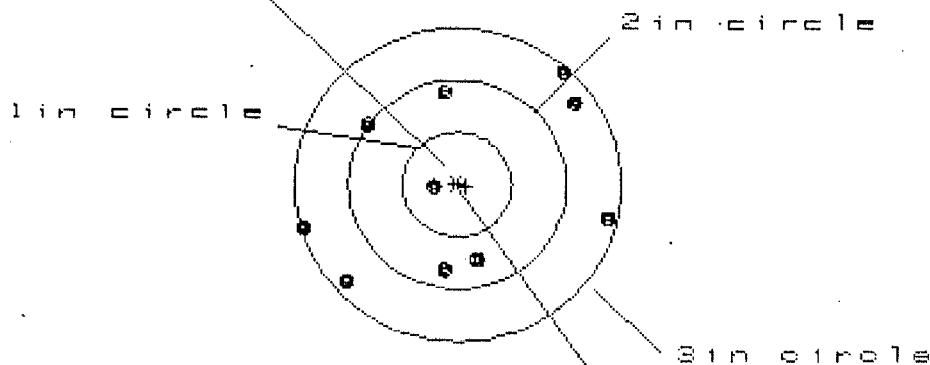
PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.033
MINIMUM X	-1.271
MAXIMUM Y	1.076
MINIMUM Y	-1.007
CENTROID X	.237
CENTROID Y	-.057
POA TO CENTROID in.	.244
MIN RADIUS	.239
MEAN RADIUS	1.058
MAX RADIUS	1.603
HORIZONTAL SPREAD	2.304
VERTICAL SPREAD	2.083
EXTREME SPREAD	2.862
NUMBER IN ONE INCH CIRCLE	1
NUMBER IN TWO INCH CIRCLE	3
NUMBER IN THREE INCH CIRCLE	9

6 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B772

CENTERFIRE PATTERNS # 4

POR



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.795

VS = 1.934

GS = 2.827

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.389	1.233	1.340
MINIMUM X	:	-1.406	-1.197	-1.090
MAXIMUM Y	:	1.040	.994	.945
MINIMUM Y	:	-.894	-.940	-.816
CENTROID X	:	-.079	.077	-.030
CENTROID Y	:	.018	.064	-.060
POR TO CENTROID in.	:	.081	.100	.067
MIN RADIUS	:	.208	.370	.247
MEAN RADIUS	:	1.080	1.045	.983
MAX RADIUS	:	1.466	1.522	1.369
HORIZONTAL SPREAD	:	2.795	2.430	2.430
VERTICAL SPREAD	:	1.934	1.934	1.761
EXTREME SPREAD	:	2.827	2.825	2.729
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

6 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346772

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 1.914

VS = 3.113

GS = 3.123

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.964	1.014
MINIMUM X	-.965	-.950	-.900
MAXIMUM Y	1.697	.962	.809
MINIMUM Y	-1.416	-1.228	-1.050
CENTROID X	.527	.512	.462
CENTROID Y	.153	-.035	.118
POA TO CENTROID in.	.549	.513	.477
MIN RADIUS	.580	.465	.508
MEAN RADIUS	1.040	.948	.898
MAX RADIUS	1.702	1.291	1.159
HORIZONTAL SPREAD	1.914	1.914	1.914
VERTICAL SPREAD	3.113	2.190	1.859
EXTREME SPREAD	3.123	2.364	2.306
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

File Edit Repair Estimate Repair Expand Repair Window Repair Tools GSP Tools Reports Table Maintenance System Maintenance Help

Repair Number: **RE00021323** Serial: C6348772 Model: 700 Center Fire Caliber: 7.62 NATO M-24 (SWS) Repairman: Status: Closed 1/22/01 10:27:31 AM

Verify Repair

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: HSC 3/10 SFG (A) HSC 3/10 SFG (A)

Address 1: Address 2: PO Box: PO Box:

City: FORT CARSON FORT CARSON

State: CO Zip Code: 80913 Country: US State: CO Zip Code: 80913 Country: US

FPL:

Contact / Condition Problems Estimate History / Status Shipping / Billing

Contact Information: Phone: Fax: Email: Comments:

Received Condition: Fair Condition Notes: CSH Notes:

Accessories Received:

Code	Desc	Qty
A007	With Stud	1
A009	With Swivel	1
A016	Scope Mounts	1
A017	Scope Base	1
A026	Scope	1

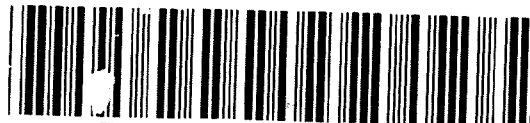
Repair Search Refresh Close

1/22/01 2:59 PM CAPS NUM

Start In Mag At Exp Mtr Ass Part Rep SA Sto 2:58 PM

Number: **C6348772**

Model: **700**



RE00021323

BARBER - M24 0063579

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6348772
1 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0578
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1484
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .159259

THE AMR FOR THIS RIFLE IS: .9624

CENTROIDAL DISTANCES

0 TO	1	.191167
1 TO	2	.25319
1 TO	3	.251432
1 TO	4	.209022
1 TO	5	.277995

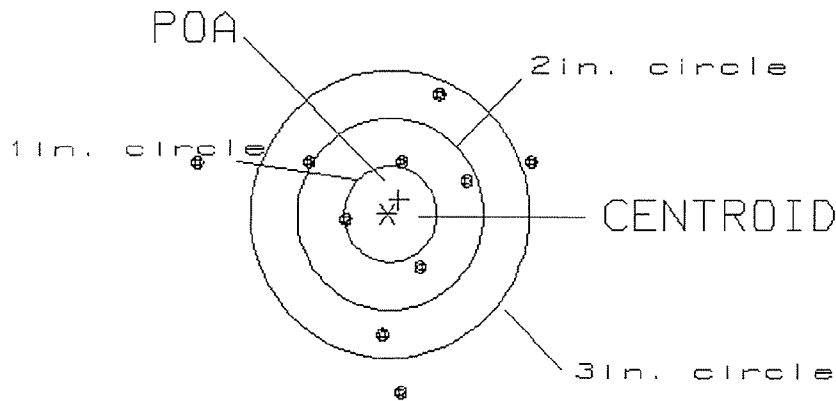
+2 <----POA
1 5

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .191
 MIN RADIUS : .489
 MEAN RADIUS : 1.173
 MAX RADIUS : 2.126
 CENTROID X : -.121
 CENTROID Y : -.148

1 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348772

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.54
 VS= 3.13
 GS= 3.54

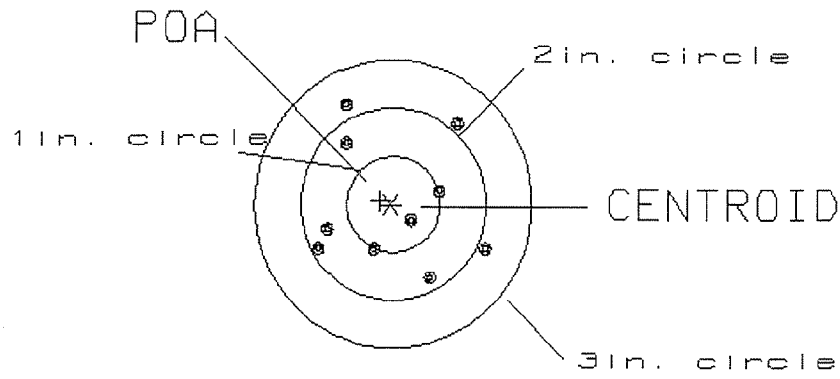
1
 4
 7

PATTERN #: ☐ 2 ☐
POA TO CENTROID: .115
MIN RADIUS : .292
MEAN RADIUS : .796
MAX RADIUS : 1.102
CENTROID X : .108
CENTROID Y : -.040

1 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348772

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.76

3

VS= 1.77

7

GS= 2.08

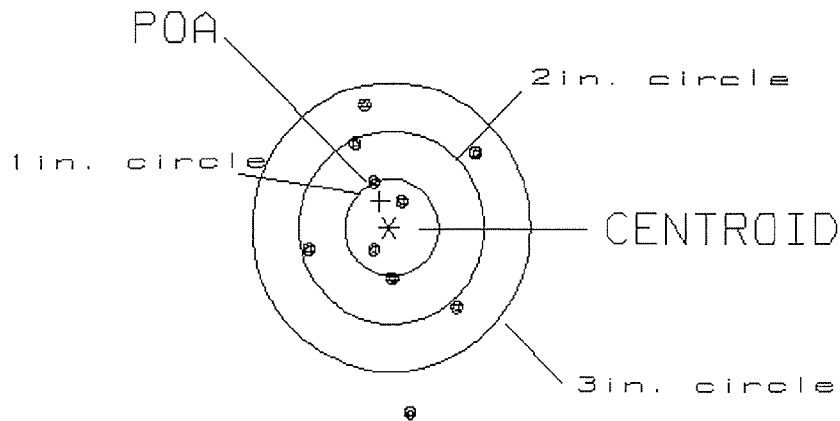
10

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .291
 MIN RADIUS : .297
 MEAN RADIUS : .899
 MAX RADIUS : 1.975
 CENTROID X : .096
 CENTROID Y : -.275

1 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348772

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 1.71
 VS= 3.21
 GS= 3.26

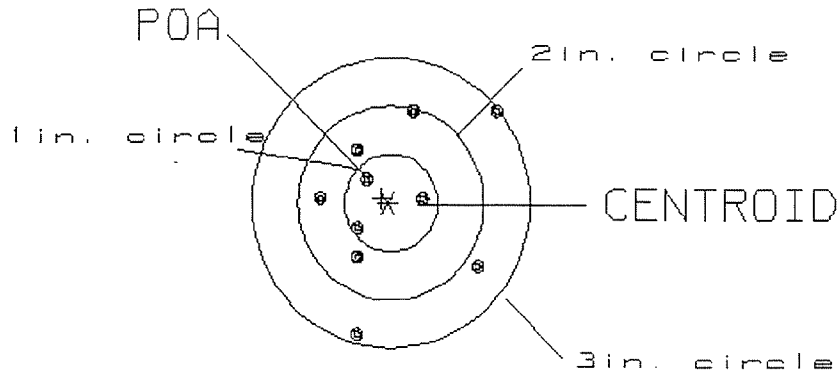
3
 6
 9

PATTERN #: 4
 POA TO CENTROID: .078
 MIN RADIUS : .355
 MEAN RADIUS : .843
 MAX RADIUS : 1.479
 CENTROID X : .062
 CENTROID Y : -.047

1 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348772

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 1.91
 VS= 2.37
 GS= 2.79

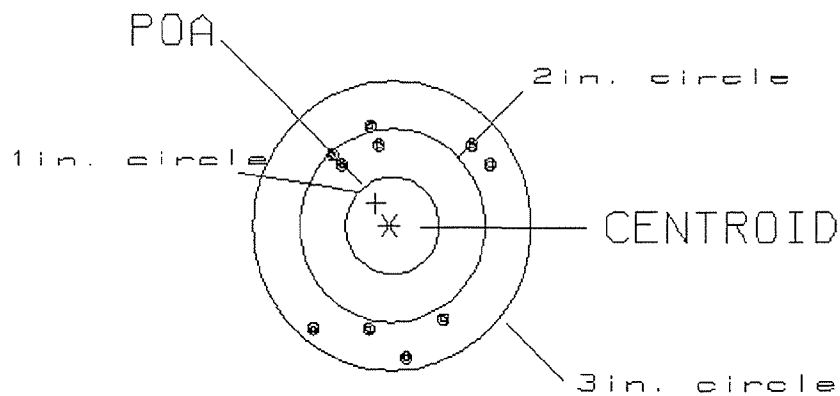
2
 7
 10

PATTERN #: 050
POA TO CENTROID: .273
MIN RADIUS : .770
MEAN RADIUS : 1.101
MAX RADIUS : 1.384
CENTROID X : .144
CENTROID Y : -.232

1 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6348772

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.89

0

VS= 2.40

3

GS= 2.55

10

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

R & E NUMBER <u>21323</u>			
SERIAL NUMBER <u>C-6348772</u>			
LOG-IN DATE <u>1-22-01</u>			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	1-27-01	C/C
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	1-30-01	CK
605	CHECK HEADSPACE	1-30-01	CK
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	2-7-01	CK
655	FINAL INSPECT	2-12-01	CK
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Final Inspection

S.O. C-6348772

DATE REC'D: 1-22-01

DATE RET'D:

AUDITOR CK.

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:

Remington[®]

DU PONT
REG. U.S. PAT. & TM. OFF.

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

MODEL 700TM H24

SERIAL NO.
C6348772

ORDER NO.
5716

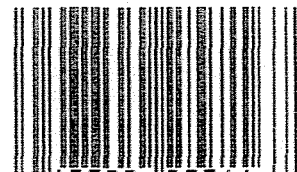
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

01



5716 C6348772

UPC



0 47700 25716 7