

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. #	OP. NAME	READINGS					DATE	INIT
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	2.60	3/3/93	RW
	C) Function						3/3/93	RW
660	Pack							

SWS TRIGGER PULL TEST

New Trigger Assy

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6523413

DATE 2/24/93

TESTER 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

COMMENTS

ORDER

R 93-02446

FPS

MOG 2 OF 30 W/10X SCOPE & DEPLOYMENT KIT
M24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/25/93	01/25/93	EK 10-90	C6523413		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 29307

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

UDS

GUN CONDITION

☐ NEW
☐ LIGHTLY WORN
☐ WORN
☐ VERY WORN
☐ UNREPAIRABLE
☐ MARRED

REPAIR CHARGE

EXCISE

TAX

INSURANCE

UPS

PARCEL POST

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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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

PARTS

COMMENTS

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE _____

DATE

DATE _____

DATE

DATE _____

RD6925 REV. 1/92

M2400027682




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

MODEL 700™ H24

SERIAL NO.

06523413

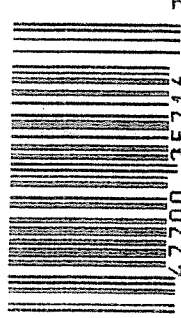
ORDER NO.

5716

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

01

UPC



0 47700 25716 7



5716 06523413

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	DH

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

SWS TRIGGER PULL TEST

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

$\bar{x}_4$ ←----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: .8872

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

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.361

VS = 2.447

GS = 3.400

CENTROID *

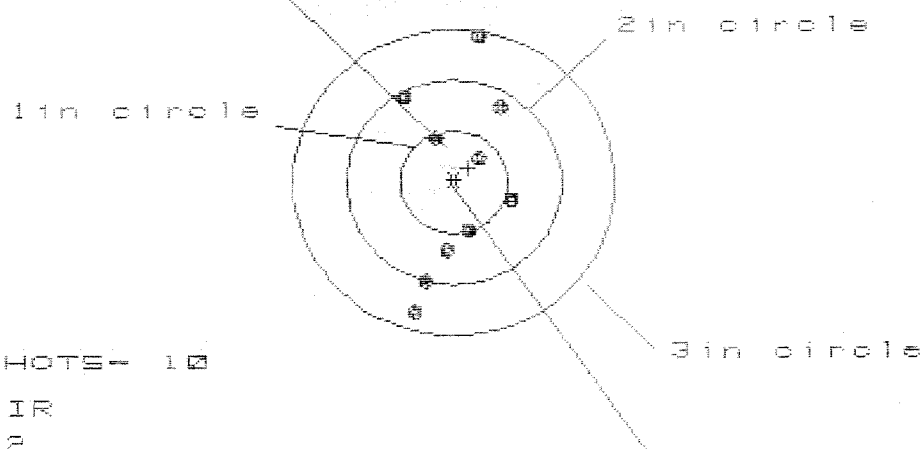
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.393	.721	.619
MINIMUM X	-.968	-.813	-.534
MAXIMUM Y	1.133	1.223	1.075
MINIMUM Y	-1.314	-1.188	-.696
CENTROID X	-.081	-.236	-.134
CENTROID Y	-.125	-.251	-.102
POA TO CENTROID in.	.149	.345	.169
MIN RADIUS	.186	.156	.131
MEAN RADIUS	.856	.741	.636
MAX RADIUS	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

POA



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
POA 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

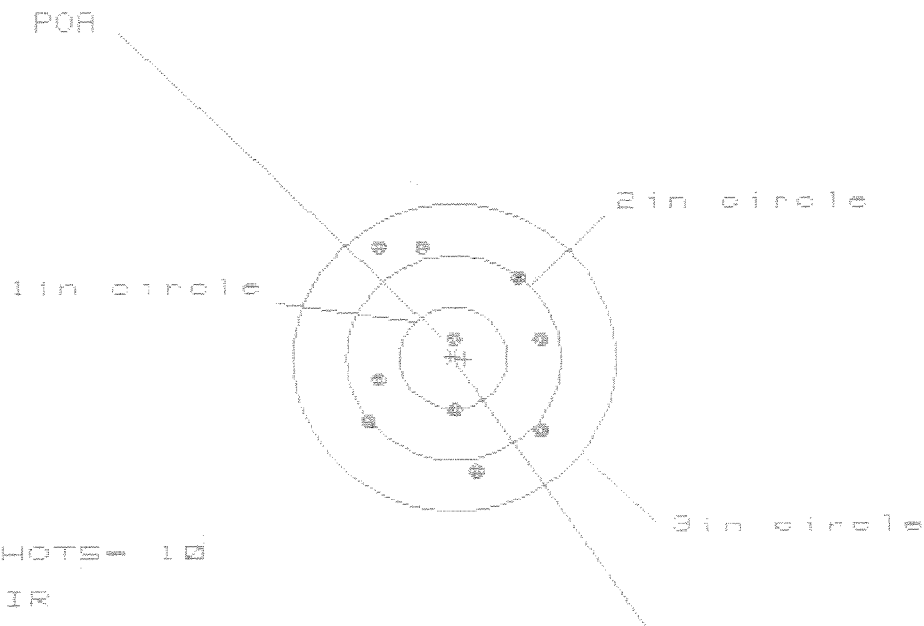
GS= 2.342

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 1998

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		
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
Magazine Spring - 15677	Zinc phosphate Scope Base
Trigger Assy - 96024	Scope Rings, Swivels, Swivel Studs
Front Sight Assy - 96118	Re-powder Coat Floor plate 1A4h,
Rear Sight Assy - 96119	Trigger Guard, Barrel Assy - 96001,
Front Guard Screw - 96010	Front + Rear Sight Bases
Rear Guard Screw - 96015	

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
RW		✓	✓		
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
RW		2/24/93	2/26/93		

OFFICE COPY

RD5925 REV. 1/92

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400027693