

06348900

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

M-24

Koller
0840

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348900

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	8 30	89	DW
600	Proof	8 30	89	DW
607	Check Headspace	8 30	89	DW
610	Dis-assemble Gun	8 30	89	DW
612	Magnaflux Barrel Action		8/31/89	KCR
	Magnaflux Bolt		8/31/89	KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes	9 1	89	EB
618	Polish Barrel <i>IRB</i>	9 1	89	BT
620	Apply Coatings (Barrel Action)		9-7-89	TA
	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		21 Sept 89	GS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			10/2/89	gM
	G) Safety Off Force	4	4	4			10/2/89	gM
	H) Trigger Pull Test & Retainability						28 Sep 89	gM
	I) Firing Pin Indent	.0205	.0205	.0205			10/2/89	gM
	J) Assemble Stock						10/2/89	RW
	K) Assemble Swivel Studs						4 Oct 89	gM
	L) Attach Front and Rear Sight Assemblies						10/2/89	RW
	M) Iron Sight Alignment						10/2/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/2/89	RW
	O) Attach Scope to Rifle						10/3/89	gM
	P) Detach & Attach Scope 20 Times						10/3/89	gM
640	Gallery Target & Test						10-3-89	A
	A) Time						10-3-89	A
	B) Malfunctions						10-3-89	A
	C) Pierced Primers						10-3-89	A
	D) Optical Clarity of Scope						10-3-89	A
645	Inspect for Live Ammo						10-3-89	A
655	Final Inspection							
	A) Headspace						4 Oct 89	gM
	B) Trigger Pull	271	266	259	241	241	4 Oct 89	gM
	C) Function						4 Oct 89	gM
660	Pack						14 Dec 89	gM

SWS TRIGGER PULL TEST

TIM:

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO C6348900

DATE 4-5-90

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.49	2.38	2.42	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.31	2.38	
PULL #3	2.39	2.31	2.40	
PULL #4	2.35	2.32	2.39	
PULL #5	2.38	2.29	2.42	
TOTAL	11.98	11.61	12.01	
AVG.	2.39	2.32	2.40	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.23	3.16	
PULL #2	3.21	3.19	
PULL #3	3.19	3.18	
PULL #4	3.14	3.18	
PULL #5	3.17	3.17	
TOTAL	15.94	15.90	
AVG.	3.18	3.18	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.03		
PULL #2	4.02	4.06		
PULL #3	4.08	4.07		
PULL #4	4.02	4.02		
PULL #5	4.08	4.02		
TOTAL	20.26	20.20		
AVG.	4.05	4.04		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348900
3 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.741456
1 TO	2	.482918
1 TO	3	.904947
1 TO	4	.573056
1 TO	5	.857226

3 5
2 4
1 1 ←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.172
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.263
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .31425

* THE AMR FOR THIS RIFLE IS: 1.088

3 Oct 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C834B980

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.474

VS= 3.401

GS= 3.630

CENTROID *

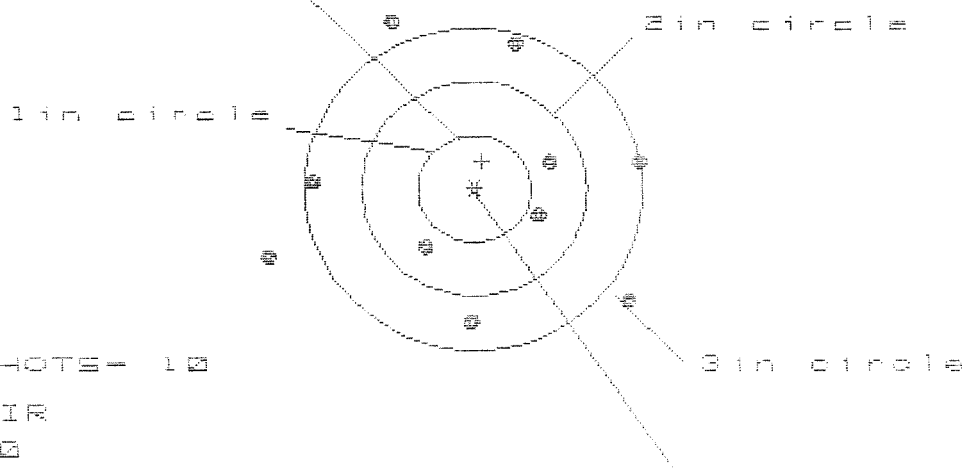
PATTERN #		10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.914	.906	.710
MINIMUM X	:	-1.560	-1.568	-1.392
MAXIMUM Y	:	2.020	1.500	.838
MINIMUM Y	:	-1.381	-1.156	-.969
CENTROID X	:	-.026	-.018	.178
CENTROID Y	:	-.741	-.966	-1.153
POA TO CENTROID in.	:	.742	.966	1.167
MIN RADIUS	:	.096	.142	.364
MEAN RADIUS	:	1.080	.969	.803
MAX RADIUS	:	2.022	2.170	1.474
HORIZONTAL SPREAD	:	2.474	2.474	2.102
VERTICAL SPREAD	:	3.401	2.656	1.807
EXTREME SPREAD	:	3.630	3.630	2.157
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	7		

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B900

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 7

HS= 3.239

VS= 2.823

GS= 3.348

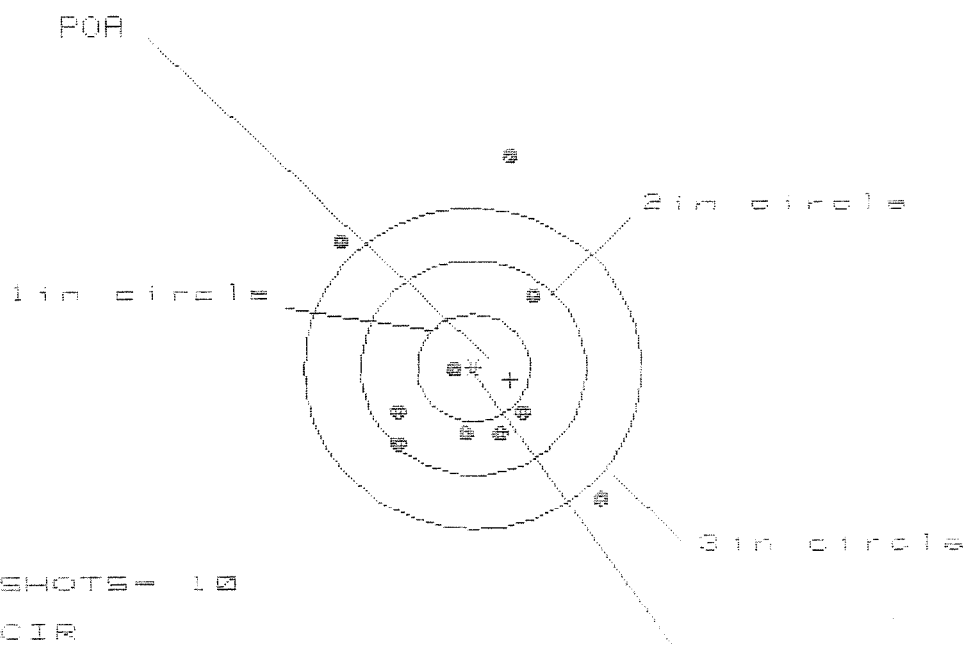
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.430	1.229	1.117
MINIMUM X	:	-1.809	-1.632	-1.744
MAXIMUM Y	:	1.607	1.540	1.535
MINIMUM Y	:	-1.216	-1.283	-1.090
CENTROID X	:	-.069	.132	.244
CENTROID Y	:	-.260	-.193	-.386
POA TO CENTROID in.	:	.269	.234	.457
MIN RADIUS	:	.598	.460	.260
MEAN RADIUS	:	1.292	1.193	1.076
MAX RADIUS	:	1.904	1.786	1.758
HORIZONTAL SPREAD	:	3.239	2.861	2.861
VERTICAL SPREAD	:	2.823	2.823	2.625
EXTREME SPREAD	:	3.348	3.327	2.992
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348300

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 7

HS= 2.327

VS= 3.246

GS= 3.402

CENTROID *

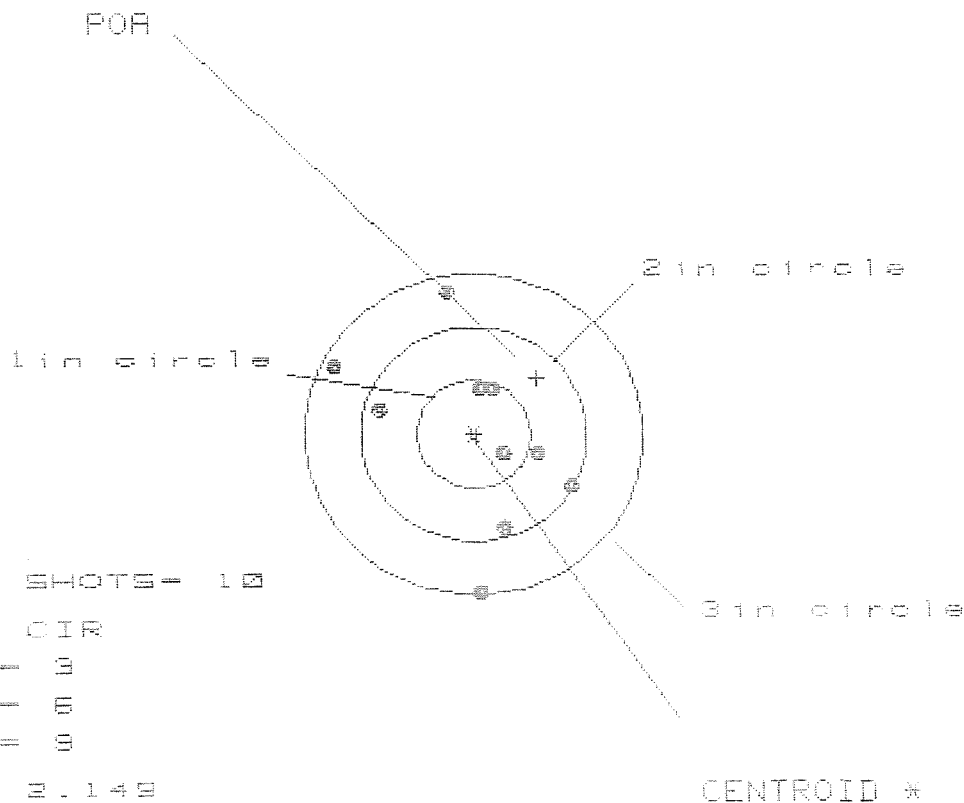
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	1.196	.722
MINIMUM X	:	-1.162	-1.131	-.981
MAXIMUM Y	:	1.999	1.457	1.329
MINIMUM Y	:	-1.247	-1.025	-.605
CENTROID X	:	-.331	-.362	-.512
CENTROID Y	:	.111	-.111	.018
POA TO CENTROID in.	:	.349	.379	.512
MIN RADIUS	:	.138	.274	.134
MEAN RADIUS	:	1.002	.841	.758
MAX RADIUS	:	2.018	1.844	1.651
HORIZONTAL SPREAD	:	2.327	2.327	1.703
VERTICAL SPREAD	:	3.246	2.482	1.933
EXTREME SPREAD	:	3.402	3.402	2.320
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348980

CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 2.149

VS= 2.811

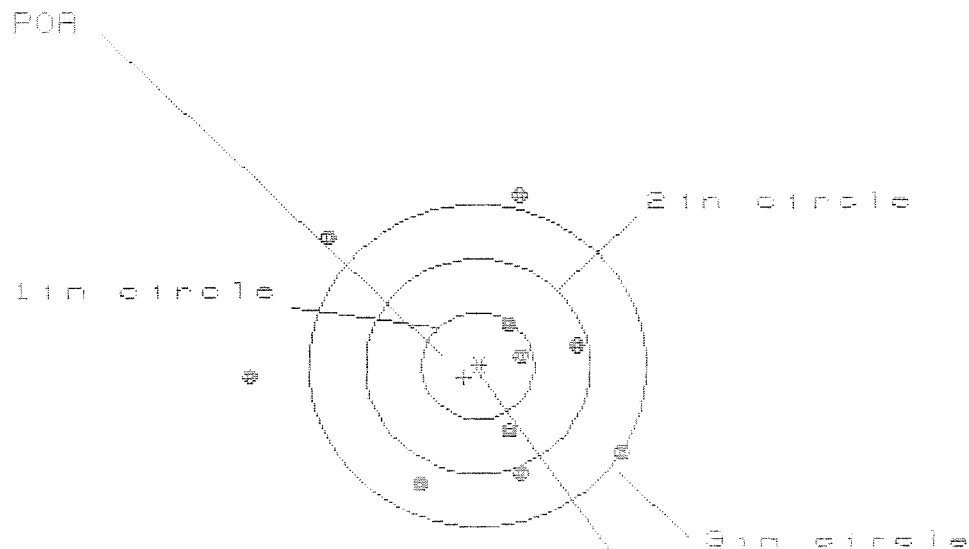
GS= 2.819

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.870	.871	.712
MINIMUM X	-1.279	-1.278	-.969
MAXIMUM Y	1.310	1.144	1.206
MINIMUM Y	-1.500	-.988	-.927
CENTROID X	-.558	-.559	-.400
CENTROID Y	-.528	-.362	-.423
POA TO CENTROID IN.	.769	.666	.582
MIN RADIUS	.302	.325	.262
MEAN RADIUS	.887	.802	.701
MAX RADIUS	1.501	1.370	1.258
HORIZONTAL SPREAD	2.149	2.149	1.680
VERTICAL SPREAD	2.811	2.132	2.132
EXTREME SPREAD	2.819	2.440	2.185
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

3 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348300

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 4

3in = 6

HS= 3.339

VS= 2.720

GS= 3.406

CENTROID *

PATTERN #		5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	1.077	.883
MINIMUM X	:	-2.036	-1.550	-.945
MAXIMUM Y	:	1.630	1.616	1.769
MINIMUM Y	:	-1.090	-1.104	-.951
CENTROID X	:	.124	.350	.544
CENTROID Y	:	.103	.117	-.036
POA TO CENTROID in.	:	.161	.369	.545
MIN RADIUS	:	.435	.216	.244
MEAN RADIUS	:	1.181	1.023	.867
MAX RADIUS	:	2.040	1.971	1.770
HORIZONTAL SPREAD	:	3.339	2.627	1.928
VERTICAL SPREAD	:	2.720	2.720	2.720
EXTREME SPREAD	:	3.406	3.317	2.855
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 97-10034

INITIAL CUSTOMER ORDER NO.

JJM

WOG 1 OF 4
M-24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
05/22/97	05/22/97		C6348900		700 7.62 NATO
ACCESSORIES		W/STUDS		SCOPE BASE	

FROM:

U.S. ARMY
2/5 SFG (A)
BLDG 3213
FT CAMPBELL

KY 42223

SHIP TO:

U.S. ARMY
2/5 SFG (A)
BLDG 3213
FT CAMPBELL

KY

42223

CUST NO: 149382 C.O.D.L.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C	PROM. DATE	ESTIMATED	VIA
				UPS

WRITE ☐

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

W52H097206H243

PARTS

COMMENTS

Barrel 96001
Firing pin Assy 96007Repowder Coat Trigger Guard
Assy, Front & Rear Sight Bases
Re-line Scope Base & Swivel
Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

KT

5-27-97

7-14-97

7-18-97

7-18-97

OFFICE COPY

RD6925 REV. 11/95

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400041143

21 DAY TURN - AROUND

*New
Barrel*

M-24

CONTRACT # DAAA09-92-C-0834

R&E NO.

SERIAL NO. *C6348900*

LOG IN DATE: / /		DATE	INIT.
INSPECT & VERIFY:			
OP. #	OP. NAME		
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL & TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	<i>5-27-97</i>	<i>AP</i>
605	CHECK HEADSPACE	<i>5-27-97</i>	<i>AP</i>
610	DIS-ASSEMBLE		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY	<i>7-14-97</i>	<i>Rw</i>
B	TRIGGER PULL TEST		
C	SAFETY ON FORCE		
D	SAFETY OFF FORCE		
E	FIRING PIN INDENT	<i>.021</i>	<i>.021</i>
		<i>.022</i>	
640	TARGET	<i>7/18/97</i>	<i>KT</i>
655	FINAL INSPECT		
660	PACK		

QAR INSPECTION

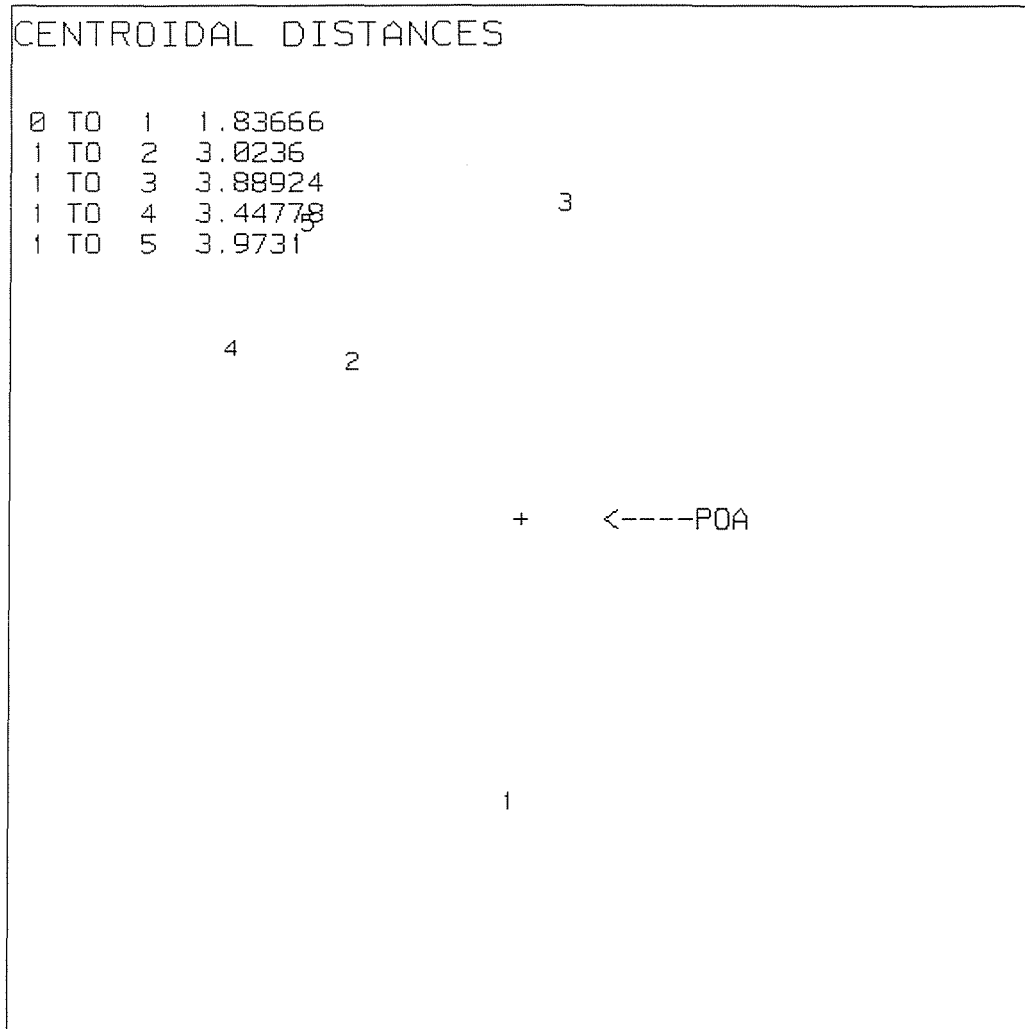
SHIP DATE

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6348900
18 Jul 1997

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.841
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .8446
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.1919

THE AMR FOR THIS RIFLE IS: 1.174



REMINGTON CENTERFIRE ACCURACY TEST

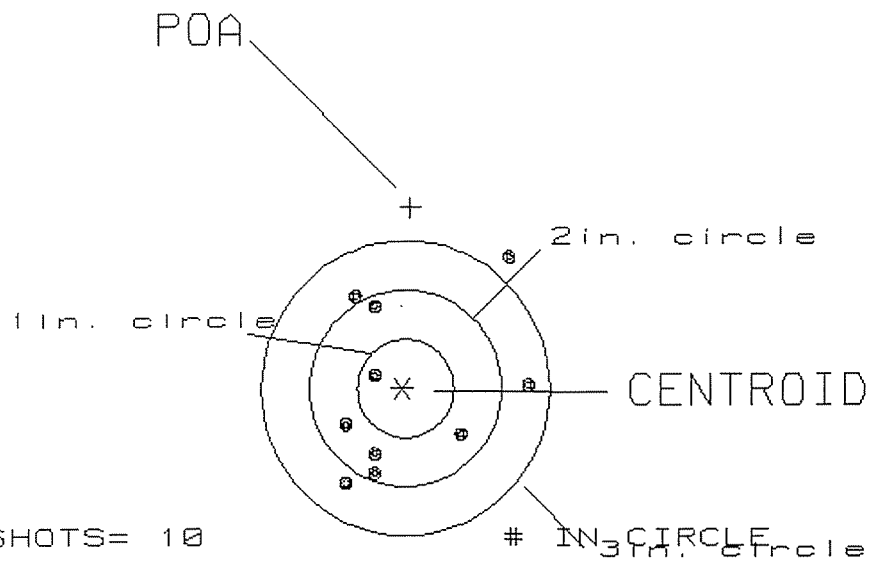
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: 1.837
 MIN RADIUS : .350
 MEAN RADIUS : .955
 MAX RADIUS : 1.712
 CENTROID X : -.078
 CENTROID Y : -1.835

18 Jul 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348900

CENTERFIRE PATTERN # 1



OF SHOTS= 10

HS= 1.94
 VS= 2.31
 GS= 2.87

IN 3 in. circle
 1
 6
 9

REMINGTON CENTERFIRE ACCURACY TEST

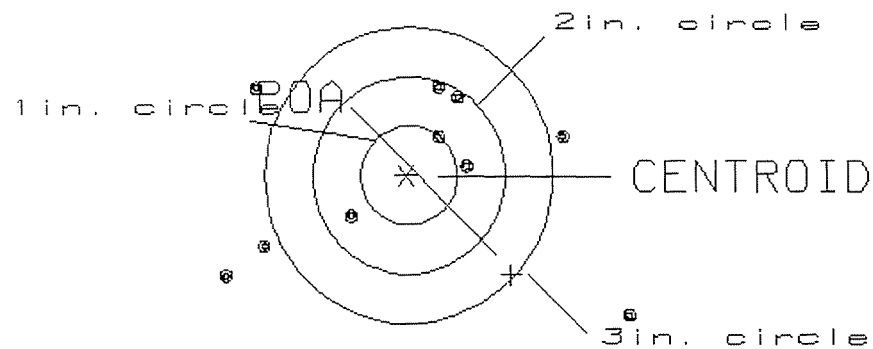
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 2 ☐
 POA TO CENTROID: 1.493
 MIN RADIUS : .491
 MEAN RADIUS : 1.370
 MAX RADIUS : 2.709
 CENTROID X : -1.099
 CENTROID Y : 1.011

18 Jul 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348900

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 4.28

1

VS= 2.30

5

GS= 4.55

5

REMINGTON CENTERFIRE ACCURACY TEST

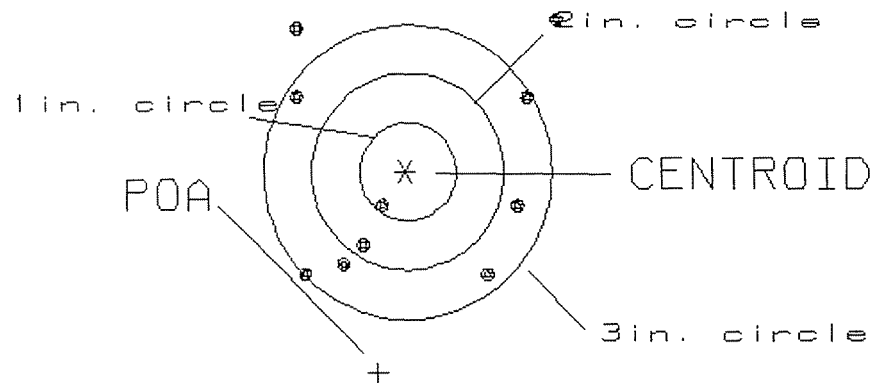
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 3
 POA TO CENTROID: 2.057
 MIN RADIUS : .477
 MEAN RADIUS : 1.337
 MAX RADIUS : 2.176
 CENTROID X : .266
 CENTROID Y : 2.039

18 Jul 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348900

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.68

1

VS= 2.64

2

GS= 3.62

8

REMINGTON CENTERFIRE ACCURACY TEST

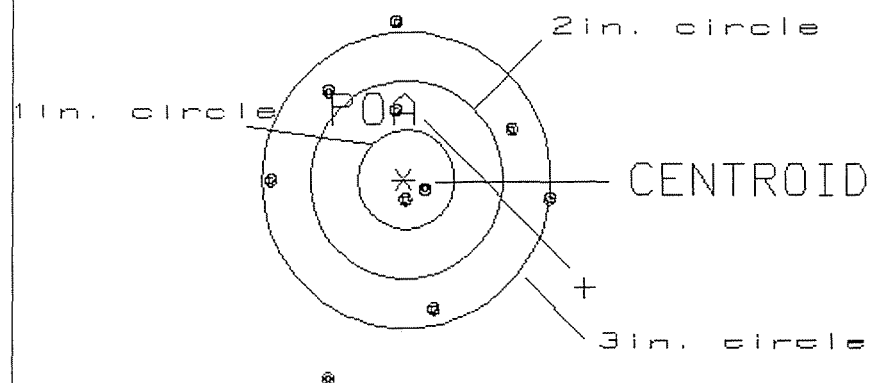
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 4
 POA TO CENTROID: 2.186
 MIN RADIUS : .164
 MEAN RADIUS : 1.148
 MAX RADIUS : 2.139
 CENTROID X : -1.892
 CENTROID Y : 1.097

18 Jul 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348900

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.81

2

VS= 3.55

3

GS= 3.61

8

REMINGTON CENTERFIRE ACCURACY TEST

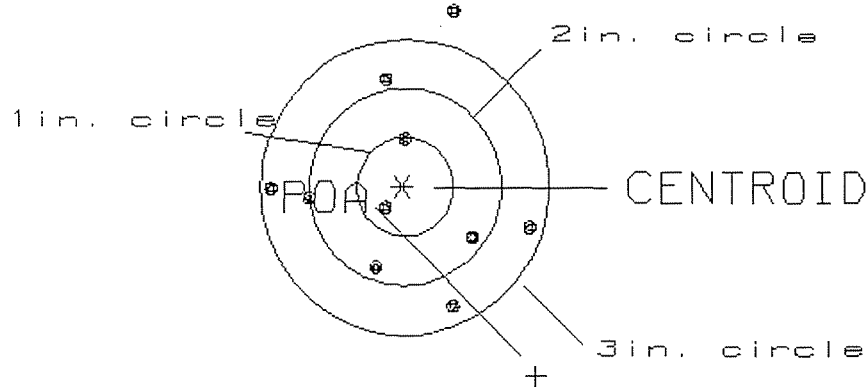
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5
 POA TO CENTROID: 2.370
 MIN RADIUS : .247
 MEAN RADIUS : 1.060
 MAX RADIUS : 1.879
 CENTROID X : -1.402
 CENTROID Y : 1.911

18 Jul 1997

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6348988

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.71

2

VS= 3.06

4

GS= 3.06

9

Final Inspection

Sn: C6348900

DATE REC'D: 5-22-97

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: _____




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

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

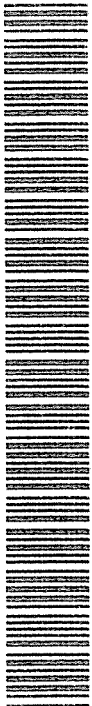
MODEL 700™ M24

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

01

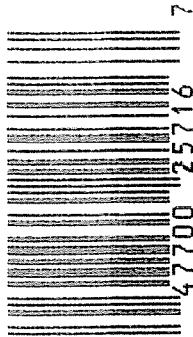
SERIAL NO.
C6348900

ORDER NO.
5716



5716 C6348900

UPC



0 47700 25716 7