

CB225104

MODEL 700TM M24

Model **700 M24TM**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONTRACT # DAAA21-87-C-0086

1179

GUN SERIAL # C6225104

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	9 12	88	FB
600	Proof	9 19	88	RW
607	Check Headspace	9 19	88	RW
610	Dis-assemble Gun	9 19	88	RW
612	Magnaflux Barrel Action		9 22 88	RW
	Magnaflux Bolt		9 22 88	RW
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coating (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/9/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/9/88	RW
	C) Inspect Ejector Hole for Chamfer		11/9/88	RW
	D) Oil Firing Pin Ass'y		11/9/88	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/10/88	JS

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	5	5	5			14/10/88	JS
	G) Safety Off Force	3	3	3			14/10/88	JS
	H) Trigger Pull Test & Retainability						11/10/88	JS
	I) Firing Pin Indent	.0205	.020	.0205			14/10/88	JS
	J) Assemble Stock						11/14/88	RW
	K) Assemble Swivel Studs						30/10/88	JS
	L) Attach Front and Rear Sight Assemblies						11/14/88	RW
	M) Iron Sight Alignment						11/14/88	RW
	N) Detach Front & Rear Sights & place in numbered container						11/14/88	RW
	O) Attach Scope to Rifle						11/15/88	W.B.
	P) Detach & Attach Scope 20 Times						11/15/88	W.B.
640	Gallery Target & Test	60 R	89 L				11/15/88	A.C.
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope						11/15/88	JS
645	Inspect for Live Ammo						11/15/88	JS
655	Final Inspection							
	A) Headspace						30/10/88	JS
	B) Trigger Pull	2.53	2.48	2.44	2.44	2.45	30/10/88	JS
	C) Function						30/10/88	JS
660	Pack						14 Dec 88	JS

0.2
SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6225104

DATE 11/16/88

TESTER JSB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.35	2.26	2.43	2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.31	2.32	2.48	
PULL #3	2.34	2.44	2.31	2.44	
PULL #4	2.46	2.37	2.34	2.44	
PULL #5	2.29	2.36	2.34	2.45	
TOTAL	11.72	11.74	11.74	12.34	
AVG.	2.344	2.348	2.348	2.468	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.25		
PULL #2	3.17	3.21		
PULL #3	3.14	3.20		
PULL #4	3.18	3.22		
PULL #5	3.17	3.22		
TOTAL	15.80	16.10		
AVG.	3.16	3.22		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.03	4.01		4.02
PULL #2	4.04	4.05		4.07
PULL #3	4.05	4.09		4.11
PULL #4	4.07	4.12		4.01
PULL #5	4.01	4.07		4.02
TOTAL	20.20	20.34		20.23
AVG.	4.04	4.068		4.046

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225104

CENTROIDAL DISTANCES

0 TO	1	.258907
1 TO	2	.333685
1 TO	3	.530617
1 TO	4	.534896
1 TO	5	.32871

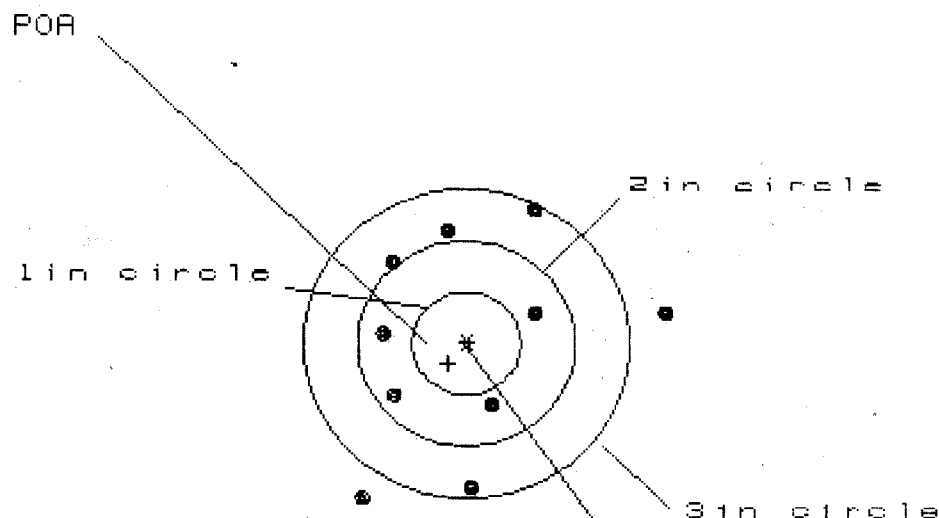
σ_{43}^2 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1924
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0846
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .210178
THE AMR FOR THIS RIFLE IS: .9948

15 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225104

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.850

VS= 2.774

GS= 3.392

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.839	.870	.770
MINIMUM X	-1.011	-.807	-.690
MAXIMUM Y	1.266	1.303	1.119
MINIMUM Y	-1.508	-1.471	-1.542
CENTROID X	.168	-.036	.064
CENTROID Y	.197	.160	.344
POA TO CENTROID in.	.259	.165	.350
MIN RADIUS	.590	.615	.690
MEAN RADIUS	1.162	1.063	.976
MAX RADIUS	1.869	1.678	1.547
HORIZONTAL SPREAD	2.850	1.677	1.460
VERTICAL SPREAD	2.774	2.774	2.661
EXTREME SPREAD	3.392	3.242	2.738
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

15 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225104

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 - 10

HS- 1.476

VS- 2.141

GS- 2.517

CENTROID *

PATTERN #

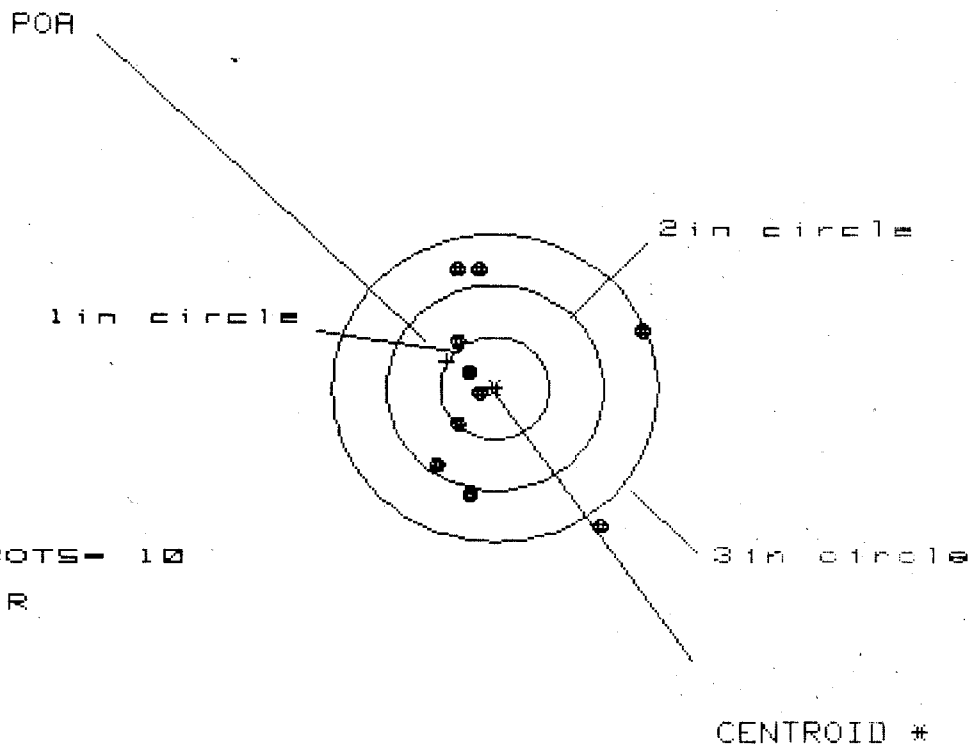
2

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.862	.811	.617
MINIMUM X	-.614	-.665	-.564
MAXIMUM Y	1.382	1.141	1.065
MINIMUM Y	-.759	-.606	-.488
CENTROID X	.357	.408	.307
CENTROID Y	-.078	-.231	-.155
POA TO CENTROID in.	.365	.469	.344
MIN RADIUS	.293	.180	.298
MEAN RADIUS	.749	.625	.582
MAX RADIUS	1.457	1.252	1.231
HORIZONTAL SPREAD	1.476	1.476	1.181
VERTICAL SPREAD	2.141	1.747	1.553
EXTREME SPREAD	2.517	1.772	1.762
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

15 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225104

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 1.934

VS= 2.563

GS= 2.902

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.407	1.518	.119
MINIMUM X	-.527	-.416	-.227
MAXIMUM Y	1.196	1.044	1.093
MINIMUM Y	-1.367	-1.227	-1.177
CENTROID X	.441	.330	.141
CENTROID Y	-.258	-.106	-.155
POA TO CENTROID in.	.511	.347	.210
MIN RADIUS	.186	.083	.115
MEAN RADIUS	.916	.791	.668
MAX RADIUS	1.692	1.569	1.179
HORIZONTAL SPREAD	1.934	1.934	.346
VERTICAL SPREAD	2.563	2.271	2.271
EXTREME SPREAD	2.902	2.335	2.274
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 5		
NUMBER IN THREE INCH CIRCLE	= 8		

15 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6225184

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 4

3 in = 8

HS= 2.238

VS= 2.714

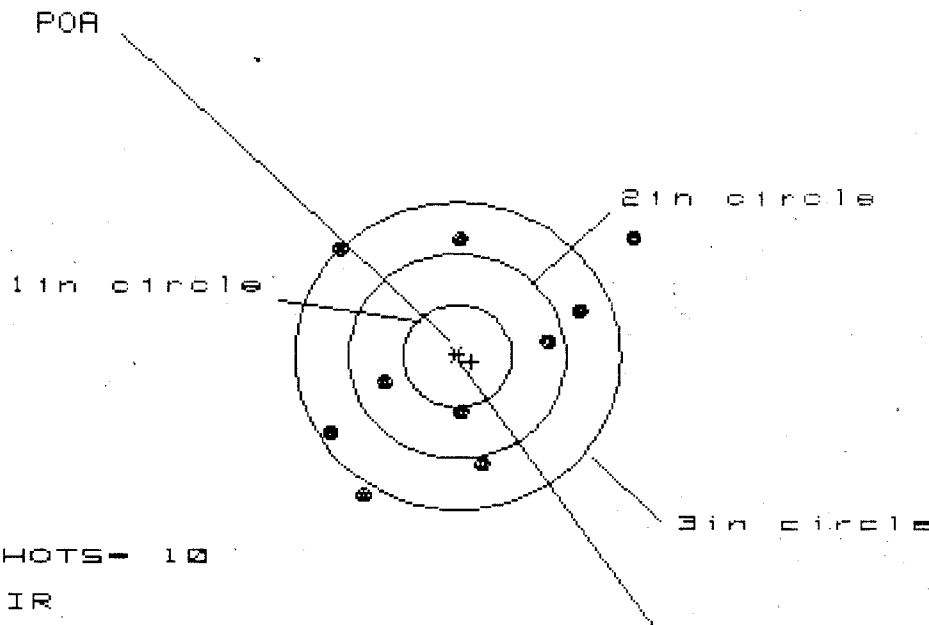
GS= 2.923

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.835	.679	.627
MINIMUM X	:	-1.403	-.437	-.489
MAXIMUM Y	:	1.526	1.449	1.308
MINIMUM Y	:	-1.188	-1.265	-1.083
CENTROID X	:	.123	.279	.331
CENTROID Y	:	-.336	-.259	-.441
POA TO CENTROID in.	:	.358	.381	.551
MIN RADIUS	:	.174	.224	.048
MEAN RADIUS	:	.955	.906	.790
MAX RADIUS	:	1.564	1.509	1.446
HORIZONTAL SPREAD	:	2.238	1.116	1.116
VERTICAL SPREAD	:	2.714	2.714	2.392
EXTREME SPREAD	:	2.923	2.808	2.420
NUMBER IN ONE INCH CIRCLE =	:		3	
NUMBER IN TWO INCH CIRCLE =	:		4	
NUMBER IN THREE INCH CIRCLE =	:		8	

15 May 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225104

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.743

VS= 2.507

GS= 3.517

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.608	1.289	1.202
MINIMUM X	-1.135	-0.956	-1.043
MAXIMUM Y	1.158	1.285	1.132
MINIMUM Y	-1.349	-1.222	-1.030
CENTROID X	-0.127	-0.306	-0.219
CENTROID Y	0.052	-0.075	0.078
POA TO CENTROID in.	0.137	0.315	0.232
MIN RADIUS	0.550	0.456	0.582
MEAN RADIUS	1.192	1.077	1.043
MAX RADIUS	1.973	1.445	1.384
HORIZONTAL SPREAD	2.743	2.245	2.245
VERTICAL SPREAD	2.507	2.507	2.162
EXTREME SPREAD	3.517	2.666	2.544
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	3	
NUMBER IN THREE INCH CIRCLE	=	8	

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER

R 94-22619

M-24 ATTN: FRED MARTIN/PAINTED OUTSIDE SHOP

INITIAL CUSTOMER ORDER NO.

FPS

DATE RECEIVED

DATE OPENED

DATE CODE

SERIAL NUMBER

NEW SERIAL NUMBER

MODEL AND GRADE

08/01/94

08/02/94

DI 9-88

C6225104

700 7.62

NATO

ACCESSORIES

W/STUDS

SCOPE MNTS

SCOPE BASE

FROM:

SHIP TO:

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA 98433

DEPT OF THE ARMY
B CO ARMS
2/75 RANGER BATTALION
FT LEWIS

WA

98433

CUST NO: 062072 C.O.D L

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

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

New Barrel

PARTS

COMMENTS

Barrel - 96003

Repowder Coat Trigger Guard
Assy Front & Rear Sight Bases
Reticle Scope Base Rings &
Swivel Studs

REPAIRMAN

PROOF

CLEAN

TEST

TARGET

PATTERN

GALLERY TESTER

DATE

DATE

DATE

DATE

DATE

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400049036

PACKING LIST		PACKED BY <i>Mr. Ray Fuller</i> <i>WG-10 Bin Armorer</i>	1. NO. BOXES /	2a. REQUISITION NO. 92062	
3. END ITEM 7.62mm M24 Sniper Weapons System (SW5)		4. DATE 26 July 1994		2b. ORDER NO.	
5. PAGE <u>1</u> OF <u>1</u> PAGES		QUANTITIES REQUIRED			
BOX NO. (a)	CONTENTS - STOCK NUMBER AND NOMENCLATURE (b)	UNIT OF ISSUE (c)	INITIAL OPERATION (d)	RUNNING SPARES (e)	TOTAL (f)
	7.62mm M24 Sniper Weapon System (SW5) Serial No. <u>C6225104</u> NSN: 1005-01-240-2136 <u>Note:</u> All Optic Scope Ring mounts Packed	Ea			1
6. THIS CERTIFIES THAT ITEMS LISTED HEREON ARE WITHIN THE SPECIFIED BOXES					
TYPED NAME AND TITLE			SIGNATURE		
<i>Ray Fuller WG-10 Bin Armorer</i>					

DD FORM 1 SEP 70 1750

DA FORM 2407
MAY 81

Final Inspection

In: C6225104 DATE REC'D: 8/1/94 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: _____

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225104

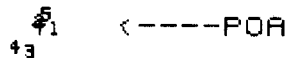
OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		8/3/94	RW
600	Proof		8/3/94	RW
607	Check Headspace		8/3/94	RW
610	Dis-assemble Gun		8/3/94	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/13/94	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/13/94	RW
	C) Inspect Ejector Hole for Chamfer		8/13/94	RW
	D) Oil Firing Pin Ass'y		8/13/94	RW
	E) Adjust Trigger Pull to Min Setting and Stake			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force							
	G) Safety Off Force							
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						8/16/94	RW
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo						8/16/94	RW
655	Final Inspection						8/16/94	WLB
	A) Headspace							
	B) Trigger Pull	2.43	2.49	2.38	2.30	2.40	8/16/94	RW
	C) Function						8/16/94	RW
660	Pack							

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225104
18 Aug 1994

CENTROIDAL DISTANCES

0 TO 1	.28003
1 TO 2	.299429
1 TO 3	.620133
1 TO 4	.805438
1 TO 5	.307508

 5 <-----POA
43

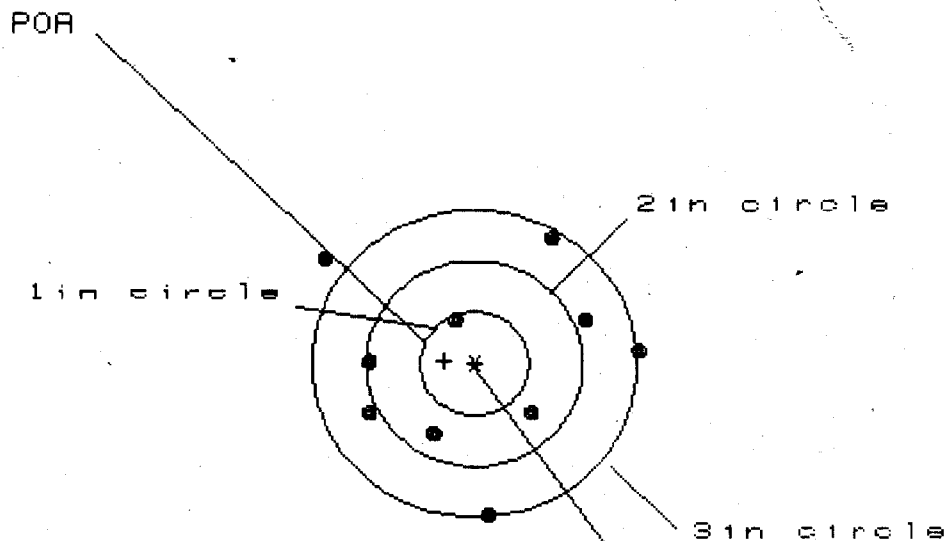
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0382
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .113426

THE AMR FOR THIS RIFLE IS: 1.076

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/C6225104

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in - 1

2in - 4

3in = 7

HS- 2.853

VS= 2.725

GS= 2.988

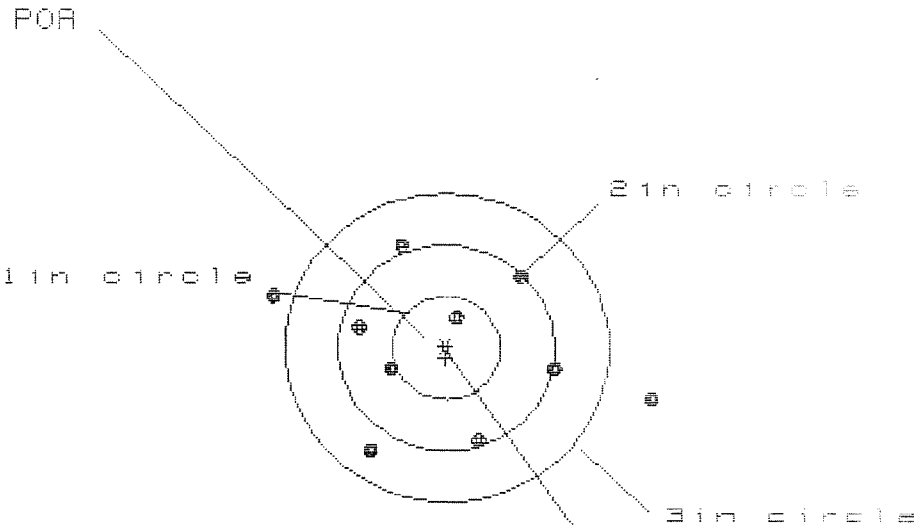
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.497	1.347	1.344
MINIMUM X	:	-1.356	-1.151	-1.154
MAXIMUM Y	:	1.202	1.312	1.135
MINIMUM Y	:	-1.523	-1.413	-1.753
CENTROID X	:	.279	.429	.432
CENTROID Y	:	-.024	-.134	.043
POR TO CENTROID in.	:	.280	.450	.434
MIN RADIUS	:	.477	.569	.498
MEAN RADIUS	:	1.120	1.051	.996
MAX RADIUS	:	1.678	1.413	1.344
HORIZONTAL SPREAD	:	2.853	2.498	2.498
VERTICAL SPREAD	:	2.725	2.725	1.888
EXTREME SPREAD	:	2.988	2.780	2.556
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/06225184

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 3.433

VS= 1.949

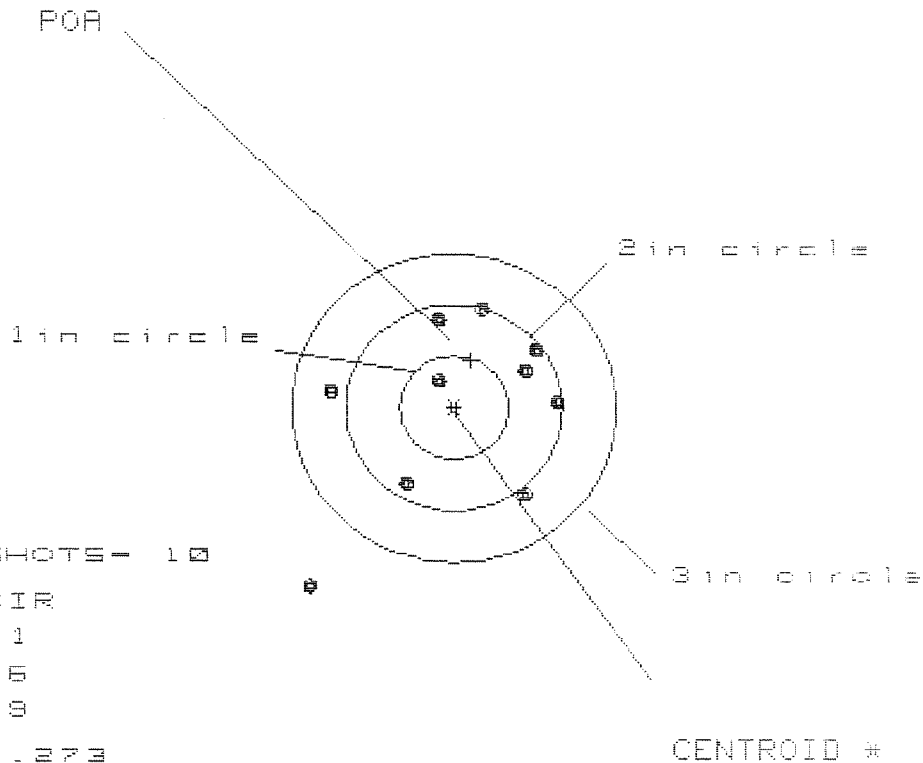
GS= 3.584

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.873	1.251	1.082
MINIMUM X	:	-1.560	-1.352	-.787
MAXIMUM Y	:	.980	.922	.979
MINIMUM Y	:	-.969	-1.027	-.970
CENTROID X	:	.006	-.202	-.033
CENTROID Y	:	.099	.157	.100
POA TO CENTROID in.	:	.099	.256	.105
MIN RADIUS	:	.328	.371	.341
MEAN RADIUS	:	1.057	.933	.871
MAX RADIUS	:	1.943	1.426	1.171
HORIZONTAL SPREAD	:	3.433	2.603	1.869
VERTICAL SPREAD	:	1.949	1.949	1.949
EXTREME SPREAD	:	3.584	2.709	2.235
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Aug 1994

FILE:/PATTERNING/CENTERFIRE_PATT/CG225104

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.273

VS= 2.702

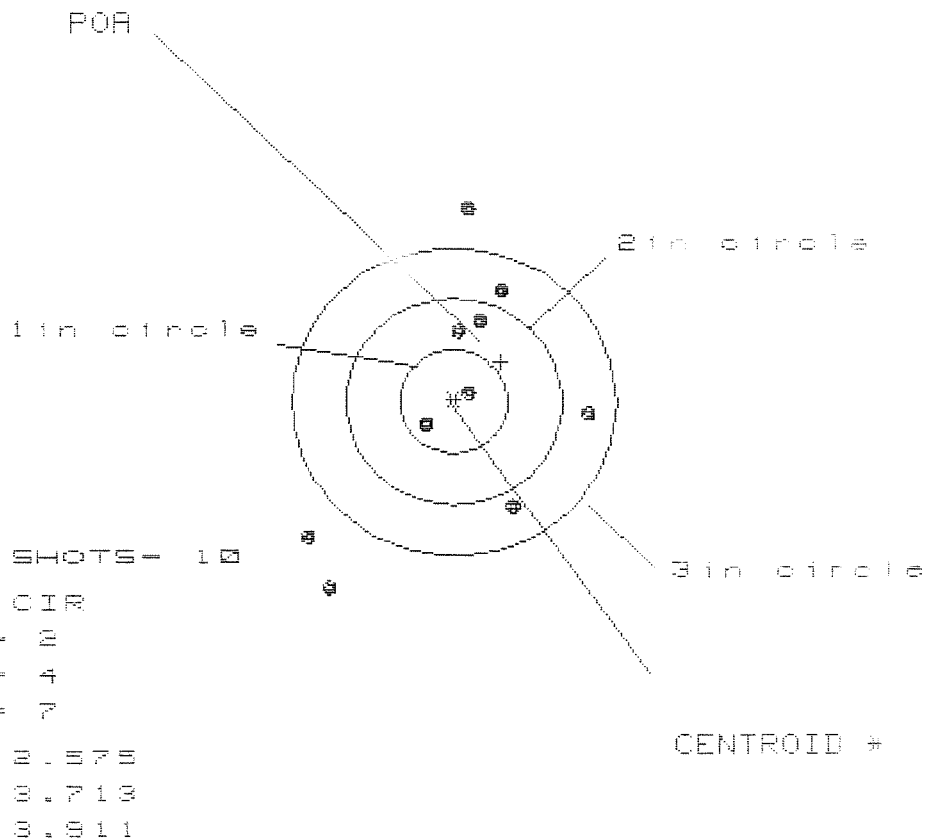
GS= 3.138

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.942	.794	.631
MINIMUM X	-1.331	-1.305	-1.763
MAXIMUM Y	.995	.805	.807
MINIMUM Y	-1.707	-.994	-.992
CENTROID X	-.159	-.011	.152
CENTROID Y	-.463	-.273	-.275
POA TO CENTROID in.	.489	.273	.314
MIN RADIUS	.239	.244	.342
MEAN RADIUS	.992	.809	.727
MAX RADIUS	2.165	1.305	1.175
HORIZONTAL SPREAD	2.273	2.099	1.394
VERTICAL SPREAD	2.702	1.799	1.799
EXTREME SPREAD	3.138	2.105	1.845
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

18 Aug 1984

FILE:/PATTERNING/CENTERFIRE_PATT/06225184

CENTERFIRE PATTERN # 4

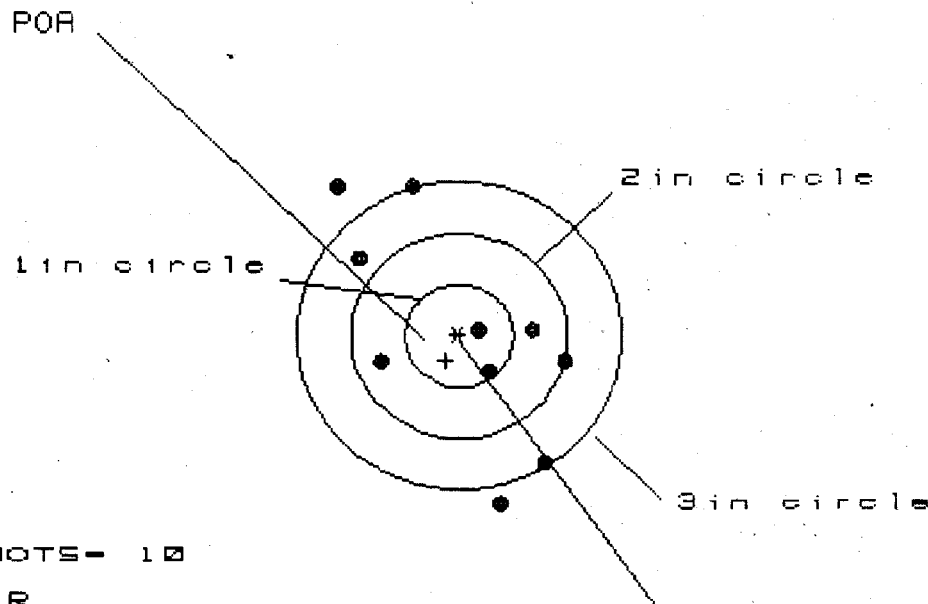


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.244	1.120	1.119
MINIMUM X	:	-1.331	-1.455	-1.456
MAXIMUM Y	:	1.886	1.683	1.125
MINIMUM Y	:	-1.827	-1.537	-1.327
CENTROID X	:	-.440	-.316	-.315
CENTROID Y	:	-.387	-.184	-.394
POR TO CENTROID in.	:	.586	.366	.505
MIN RADIUS	:	.122	.131	.087
MEAN RADIUS	:	1.149	1.002	.923
MAX RADIUS	:	2.139	2.116	1.970
HORIZONTAL SPREAD	:	2.575	2.575	2.575
VERTICAL SPREAD	:	3.713	3.220	2.452
EXTREME SPREAD	:	3.911	3.530	3.012
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Aug 1994

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.045

VS= 3.104

GS= 3.380

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.949	.827	.858
MINIMUM X	-1.096	-1.077	-1.046
MAXIMUM Y	1.477	1.635	1.452
MINIMUM Y	-1.627	-1.469	-1.234
CENTROID X	.123	.245	.214
CENTROID Y	.241	.083	.266
POA TO CENTROID in.	.270	.258	.342
MIN RADIUS	.132	.168	.043
MEAN RADIUS	1.064	.947	.876
MAX RADIUS	1.795	1.709	1.525
HORIZONTAL SPREAD	2.045	1.904	1.904
VERTICAL SPREAD	3.104	3.104	2.686
EXTREME SPREAD	3.380	3.191	2.908
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		