

C6225556

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

00299

5081

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225556

OPERATION		DATE	INT
#	NAME		
575- 580	ASSEMBLY 2	26	FLB
600	PROOF	29	RW
615	MAGNAFLUX BARREL	5/13/88	P/L
	MAGNAFLUX BOLT	5/13/88	P/L
620	COATING	8/1/88	JA
625- 630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

SCOPE #
1086

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225556

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock			
600	Proof			
607	Check Headspace	QUALITY AUDIT		
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		9/7/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/7/88	RW
	C) Inspect Ejector Hole for Chamfer		9/7/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		9/7/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		7 Sept 88	JS
	F) Safety on Force	6 6 6	7 Sept 88	JS
	G) Safety off Force	4 4 4	7 Sept 88	JS
	H) Trigger Pull Test & Retainability		7 Sept 88	JS
	I) Firing Pin Indent	.0225 .0225 .0225	7 Sept 88	JS
	J) Assemble Stock		9/21/88	RW
	K) Assemble Swivel Studs		10-7-88	JS
	L) Attach Front & Rear Sight Assemblies		9/21/88	RW
	M) Iron Sight Alignment		9/21/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/21/88	RW
	O) Attach Scope to Rifle		10/3/88	RW
	P) Detach & Attach Scope 20 times		10/4/88	JS
640	Gallery Target & Test	47 R 108 L	10-6-88	AC
	A) Optical Clarity of Scope	OK	10-6-88	AC
645	Inspect for Live Ammo	NONE	10-6-88	AC
655	Final Inspection			
	A) Headspace		10-7-88	JS
	B) Trigger Pull		10-7-88	JS
	C) Function		10-7-88	JS
660	Pack		10-21-88	JS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6225556

DATE 7 Sept 88

TESTER J.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.64	2.47	2.57	2.81	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.53	2.68	2.80	
PULL #3	2.62	2.52	2.62	2.78	
PULL #4	2.60	2.52	2.64	2.73	
PULL #5	2.56	2.50	2.61	2.82	
TOTAL	12.99	12.54	13.12	13.94	
AVG.	2.598	2.508	2.624	2.788	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.07		
PULL #2	3.17	3.07		
PULL #3	3.17	3.06		
PULL #4	3.18	3.18		
PULL #5	3.30	3.10		
TOTAL	15.96	15.48		
AVG.	3.192	3.096		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.04		4.33
PULL #2	4.32	4.12		4.33
PULL #3	4.23	4.19		4.31
PULL #4	4.22	4.20		4.33
PULL #5	4.22	4.14		4.30
TOTAL	21.27	20.69		21.60
AVG.	4.254	4.138		4.32

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225556

CENTROIDAL DISTANCES

Ø TO	1	1.4387
1 TO	2	1.7318
1 TO	3	1.82365
1 TO	4	.63729
1 TO	5	.749989

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(----POA

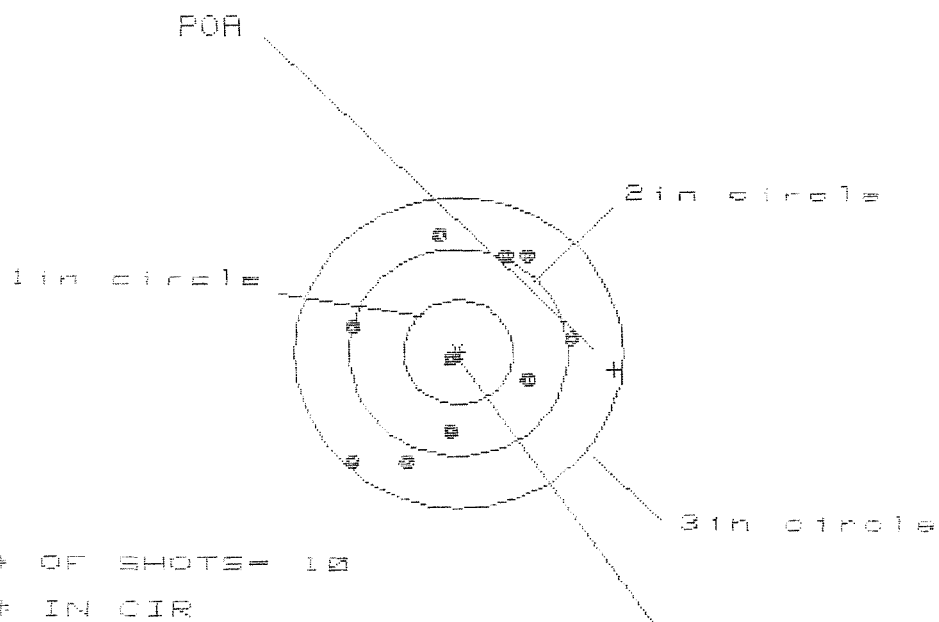
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.5496
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .3354
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .643858
 THE AMR FOR THIS RIFLE IS: 1.102

8 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/08825556

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 1.978

VS= 2.124

GS= 2.569

CENTROID *

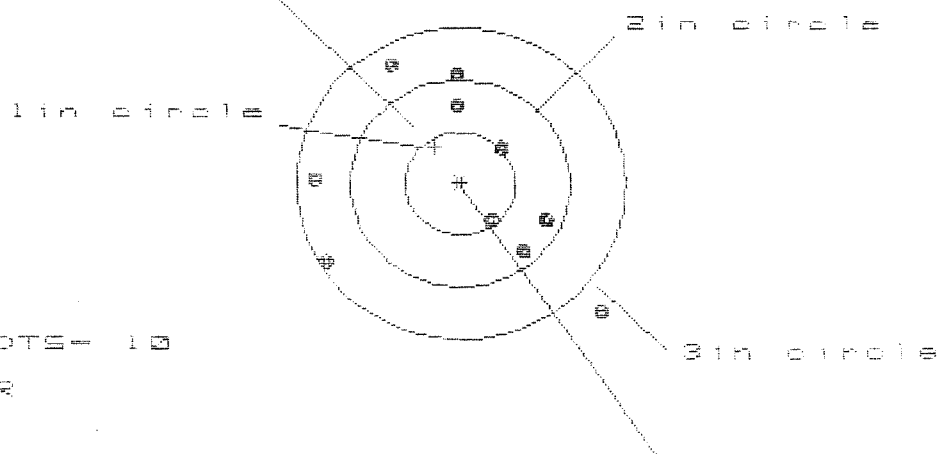
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.019	.912	.838
MINIMUM X	-.959	-1.048	-1.122
MAXIMUM Y	1.093	.979	.838
MINIMUM Y	-1.031	-1.124	-1.058
CENTROID X	-1.430	-1.323	-1.249
CENTROID Y	.158	.272	.413
POA TO CENTROID in.	1.438	1.351	1.315
MIN RADIUS	.120	.275	.433
MEAN RADIUS	.937	.883	.827
MAX RADIUS	1.408	1.271	1.123
HORIZONTAL SPREAD	1.978	1.960	1.960
VERTICAL SPREAD	2.124	2.103	1.896
EXTREME SPREAD	2.569	2.220	1.962
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

6 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225556

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.604

VS= 2.359

ES= 2.977

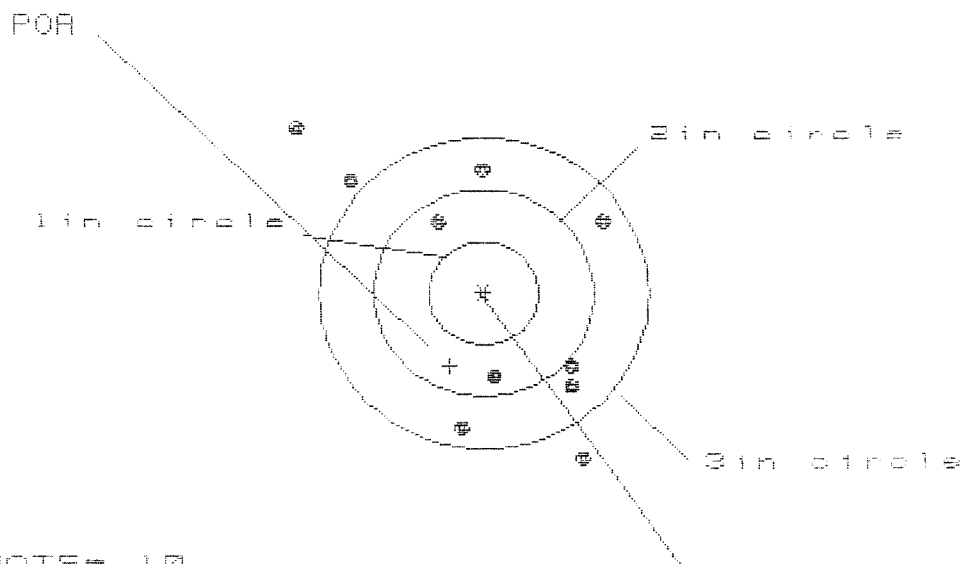
CENTROID X

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.236	.947	.812
MINIMUM X	-1.368	-1.231	-1.366
MAXIMUM Y	1.158	1.025	.916
MINIMUM Y	-1.201	-.872	-.886
CENTROID X	.225	.088	.223
CENTROID Y	-.352	-.219	-.110
POA TO CENTROID in.	.418	.236	.248
MIN RADIUS	.456	.565	.405
MEAN RADIUS	1.035	.959	.860
MAX RADIUS	1.723	1.390	1.385
HORIZONTAL SPREAD	2.604	2.178	2.178
VERTICAL SPREAD	2.359	1.897	1.802
EXTREME SPREAD	2.977	2.215	2.215
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225558

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 2

3 in = 7

HS= 2.869

VS= 3.199

ES= 4.117

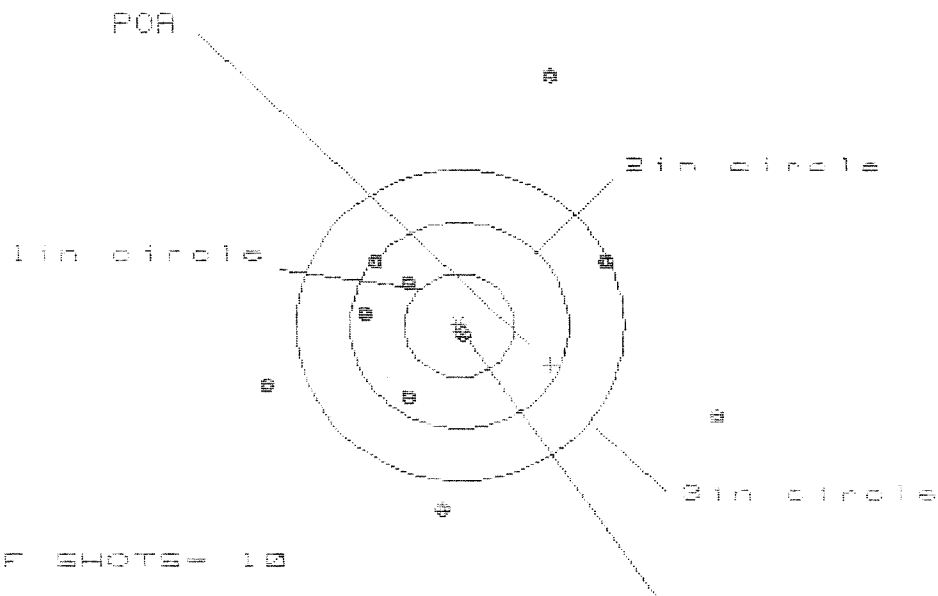
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.133	.940	1.023
MINIMUM X	:	-1.736	-1.366	-1.283
MAXIMUM Y	:	1.641	1.410	1.238
MINIMUM Y	:	-1.558	-1.375	-1.333
CENTROID X	:	.310	.563	.420
CENTROID Y	:	.704	.521	.693
FOR TO CENTROID in.	:	.769	.724	.811
MIN RADIUS	:	.788	.623	.779
MEAN RADIUS	:	1.357	1.200	1.168
MAX RADIUS	:	2.389	1.859	1.683
HORIZONTAL SPREAD	:	2.869	2.306	2.306
VERTICAL SPREAD	:	3.199	2.785	2.571
EXTREME SPREAD	:	4.117	3.326	2.792
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/CS225556

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 4

HS= 4.122

VS= 4.176

GS= 4.278

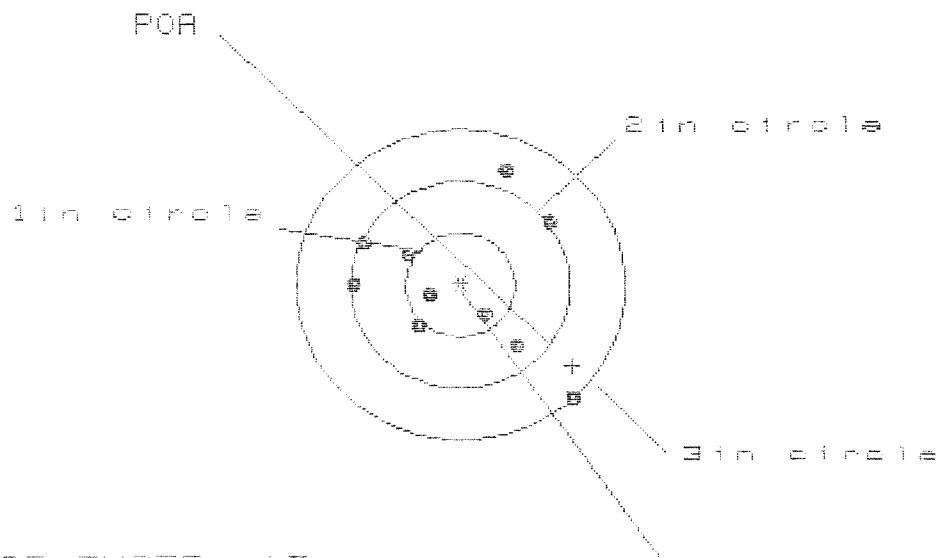
CENTROID #

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.349	1.612	1.743
MINIMUM X	-1.773	-1.512	-1.381
MAXIMUM Y	2.375	2.278	.827
MINIMUM Y	-1.801	-1.898	-1.613
CENTROID X	-.833	-1.094	-1.225
CENTROID Y	.381	.478	.193
POA TO CENTROID in.	.915	1.193	1.246
MIN RADIUS	.106	.331	.401
MEAN RADIUS	1.361	1.183	.994
MAX RADIUS	2.587	2.509	1.929
HORIZONTAL SPREAD	4.122	3.124	3.124
VERTICAL SPREAD	4.176	4.176	2.440
EXTREME SPREAD	4.278	4.278	3.356
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	6		

6 Oct 1988

FILE://PATTERNING/CENTERFIRE_PATT/06225556

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 10

HS= 2.031

VS= 2.148

GS= 2.416

CENTROID *

PATTERN #	5	6	7
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.057	.891	.957
MINIMUM X	-.974	-.856	-.790
MAXIMUM Y	1.095	.978	.664
MINIMUM Y	-1.053	-.748	-.626
CENTROID X	-1.020	-1.138	-1.204
CENTROID Y	.786	.903	.781
POA TO CENTROID in.	1.288	1.453	1.435
MIN RADIUS	.270	.231	.097
MEAN RADIUS	.818	.727	.643
MAX RADIUS	1.492	1.113	1.165
HORIZONTAL SPREAD	2.031	1.747	1.747
VERTICAL SPREAD	2.148	1.726	1.290
EXTREME SPREAD	2.416	1.874	1.874
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	7	7	7
NUMBER IN THREE INCH CIRCLE =	10	10	10

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225556

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		2/12/92	RW
600	Proof		2/12/92	RW
607	Check Headspace		2/12/92	RW
610	Dis-assemble Gun		2/12/92	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		2/24/92	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/24/92	RW
	C) Inspect Ejector Hole for Chamfer		2/24/92	RW
	D) Oil Firing Pin Ass'y		2/24/92	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/24/92	RW

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 1/2	3 1/2			2/25/92	WB
	G) Safety Off Force	2	2	2			2/25/92	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent	.020	.020	.020			2/25/92	WB
	J) Assemble Stock						2/24/92	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						2/24/92	RW
	M) Iron Sight Alignment						2/24/92	RW
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						2-24-92	AC
	A) Time						2-24-92	AC
	B) Malfunctions						2-24-92	AC
	C) Pierced Primers						2-24-92	AC
	D) Optical Clarity of Scope						2-24-92	AC
645	Inspect for Live Ammo						2-24-92	AC
655	Final Inspection						2/25/92	WB
	A) Headspace							
	B) Trigger Pull	2.48	2.46	2.47	2.41	2.48	2/24/92	WB
	C) Function						2/25/92	WB
660	Pack							

(PLEASE PRINT CLEARLY)

RETURN:

- ☐ Clark Street Entrance
☒ Via US Mail or UPS

FIREARMS DELIVERED TO PLANT

FILE Nº 006782DATE 27 JAN 92OWNER'S NAME: CPT STEPHENSONOWNER'S ADDRESS: Co D 2nd Bn 1st SWTGFT Bragg N.C.

ZIP: _____

PHONE: 919 396 7330

FIREARM

MODEL: M-24CHECK FOR AMMUNITION ☒GAUGE: 308 CalSERIAL # C6225556

CONDITION:

WOOD GOOD FAIR POOR FANCY PLAINMETAL GOOD FAIR POOR FANCY PLAINBARREL VT. RIB PLAIN DEER RSS

ACCESSORIES:

SCOPE: YES NO (BRAND NAME/POWER) _____SLING: YES NO GUN CASE: YES NO (HARD - SOFT)

EXTRA BBL FOR GUN MENTIONED ABOVE: _____

OTHER (Note in this area items missing or added from orig. equipment)

CUSTOMER REQUEST: Replace Barrel.SIGNATURE: Daniel E. Heath
(Person delivering firearm to Plant)DATE: 27 Jan 92SIGNATURE: Toni K...
(Security Officer)DATE: 1/27/92SIGNATURE: [Signature]
(Firearm picked up by)DATE: 1-28-92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # D6225556
24 Feb 1992

CENTROIDAL DISTANCES

0 TO	1	.612396
1 TO	2	.369632
1 TO	3	.586502
1 TO	4	.83874
1 TO	5	1.04241

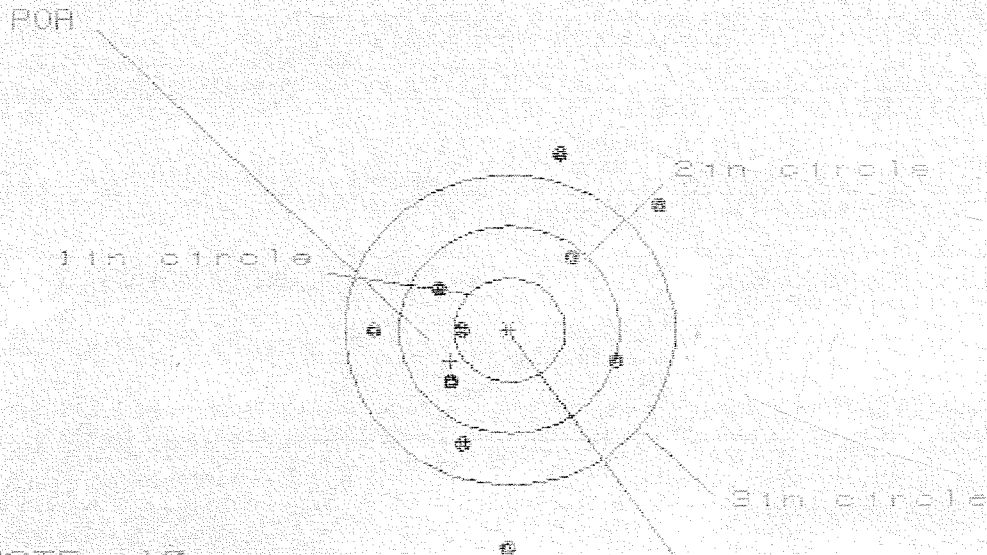
SP 1
5 4 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .191
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.9504
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .097538
THE AMR FOR THIS RIFLE IS: 1.173

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8225556

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.612

VS= 3.792

GS= 3.830

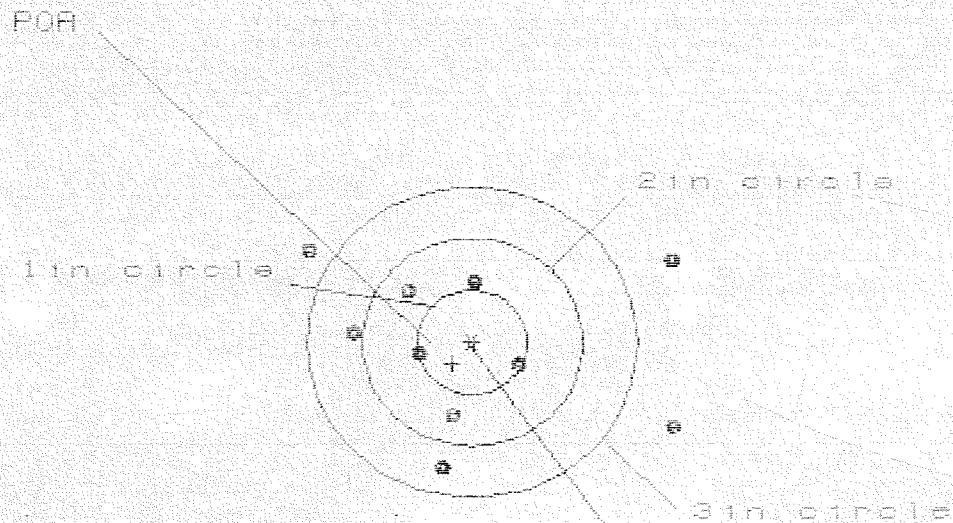
CENTROID #

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.395	1.386	1.155
MINIMUM X	:	-1.217	-1.226	-1.052
MAXIMUM Y	:	1.690	1.456	1.578
MINIMUM Y	:	-2.102	-1.319	-1.197
CENTROID X	:	.585	.544	.370
CENTROID Y	:	.290	.532	.410
POA TO CENTROID in.	:	.612	.761	.553
MIN RADIUS	:	.425	.470	.267
MEAN RADIUS	:	1.188	1.078	.952
MAX RADIUS	:	2.104	1.694	1.696
HORIZONTAL SPREAD	:	2.612	2.612	2.287
VERTICAL SPREAD	:	3.792	2.775	2.775
EXTREME SPREAD	:	3.830	2.961	2.929
NUMBER IN ONE INCH CIRCLE	=	1	1	1
NUMBER IN TWO INCH CIRCLE	=	4	4	4
NUMBER IN THREE INCH CIRCLE	=	7	7	7

24 Feb 1992

FILE: /PATTERNING/CENTERFIRE_PATT/C8225556

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 3.273

VS= 2.128

GS= 3.677

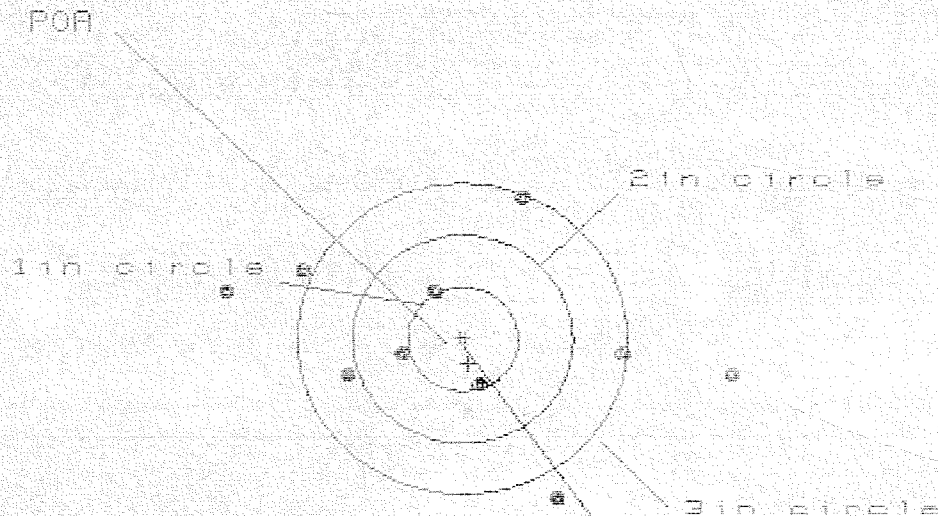
CENTROID *

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.792	1.991	.851
MINIMUM X	-1.481	-1.282	-1.033
MAXIMUM Y	.898	.986	.980
MINIMUM Y	-1.230	-1.142	-1.228
CENTROID X	.177	-.022	-.271
CENTROID Y	.206	.118	.264
POR TO CENTROID in.	.272	.120	.339
MIN RADIUS	.445	.239	.079
MEAN RADIUS	1.099	.965	.784
MAX RADIUS	1.959	2.107	1.971
HORIZONTAL SPREAD	3.273	3.273	1.884
VERTICAL SPREAD	2.128	2.128	2.128
EXTREME SPREAD	3.677	3.677	2.425
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C6225556

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 4.551

VS= 2.844

GS= 4.619

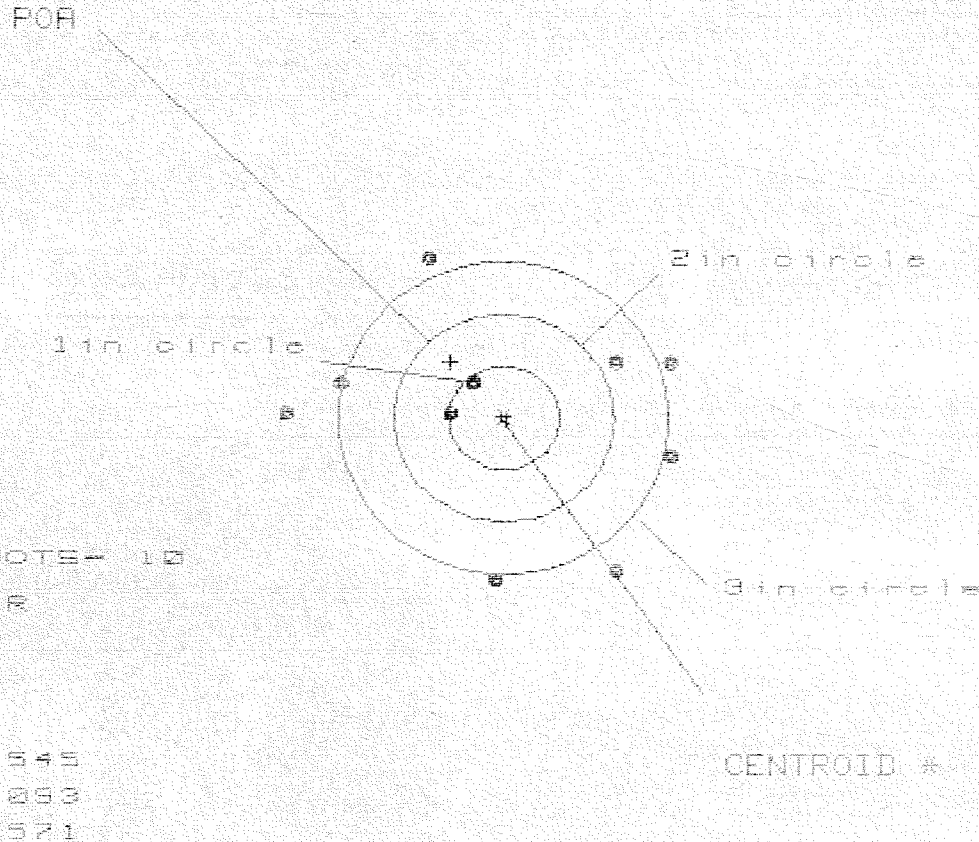
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.435	1.678	1.447
MINIMUM X	:	-2.116	-1.845	-1.377
MAXIMUM Y	:	1.342	1.300	1.348
MINIMUM Y	:	-1.502	-1.544	-1.497
CENTROID X	:	-.048	-.319	-.088
CENTROID Y	:	.234	.276	.229
POA TO CENTROID in.	:	.239	.422	.245
MIN RADIUS	:	.495	.320	.501
MEAN RADIUS	:	1.343	1.170	1.095
MAX RADIUS	:	2.464	1.895	1.731
HORIZONTAL SPREAD	:	4.551	3.523	2.824
VERTICAL SPREAD	:	2.844	2.844	2.844
EXTREME SPREAD	:	4.619	3.562	3.140
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

24 Feb 1992

FILE:/PATTERNING/CENTERFIRE_PATT/06225556

CENTERFIRE PATTERNS # 4



PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.523	1.298	1.380
MINIMUM X	-2.022	-1.698	-1.538
MAXIMUM Y	1.517	1.521	1.344
MINIMUM Y	-1.576	-1.572	-1.750
CENTROID X	.481	.706	.606
CENTROID Y	-.539	-.543	-.366
POA TO CENTROID in.	.722	.890	.709
MIN RADIUS	.458	.629	.451
MEAN RADIUS	1.376	1.306	1.235
MAX RADIUS	2.022	1.788	1.760
HORIZONTAL SPREAD	3.545	2.996	2.996
VERTICAL SPREAD	3.093	3.093	3.093
EXTREME SPREAD	3.571	3.415	3.160
NUMBER IN ONE INCH CIRCLE =	2	2	2
NUMBER IN TWO INCH CIRCLE =	2	2	2
NUMBER IN THREE INCH CIRCLE =	3	3	3

24 Feb 1992

FILE: \PATTERNING\CENTERFIRE_PATT\06225356

CENTERFIRE PATTERNS # 5

POB

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 2.485

VS = 1.906

GS = 2.785

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.286	.828	.696
MINIMUM X	-1.199	-1.056	-.987
MAXIMUM Y	.639	.668	.592
MINIMUM Y	-1.267	-1.196	-1.264
CENTROID X	-.196	-.333	-.201
CENTROID Y	-.451	-.522	-.454
POB TO CENTROID in.	.490	.619	.496
MIN RADIUS	.241	.397	.251
MEAN RADIUS	.858	.816	.727
MAX RADIUS	1.436	1.204	1.264
HORIZONTAL SPREAD	2.485	1.884	1.683
VERTICAL SPREAD	1.906	1.856	1.656
EXTREME SPREAD	2.785	1.975	1.652
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		