

NEW ACTION

C6225478

E 6374536

MODEL 700TM M24

Model **700 M24TM**

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

RECEIVING AND ESTIMATING REPORT

COMMENTS

ORDER
R 96-02145

INITIAL CUSTOMER ORDER NO.

JJM 010806

SNIPER M-24

DATE RECEIVED	DATE OPENED	DATE CODE	SERIAL NUMBER	NEW SERIAL NUMBER	MODEL AND GRADE
01/17/96	01/17/96	PM 6-92	C6225478		700 7.62 NATO

ACCESSORIES SOFT CASE W/STUDS SCOPE BASE

FROM:

FREDRICKSON, ROBERT L
D CO 2ND BN 1ST SWTG
FT BRAGG

NC 28307

SHIP TO:

~~FREDRICKSON, ROBERT L~~
COMMANDER
D CO 2ND BN 1ST SWTG
FT BRAGG

NC

28307

CUST NO: 135960 C.O.D.L.

ACCOUNT NUMBER

ACCOUNT NUMBER N/C

WRITE ☐

PROM. DATE

ESTIMATED

VIA

DOOR

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

PARTS

COMMENTS

W 52 H 096 017 H 245
Barrel - 96003
Front Sight Base - 18844
Mag Spring - 15677

Repowder Cent Trigger Guard
Assy + Rear Sight Base
Rezinc Scope Base & 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

M2400061697

RD-6947-Rev 3
PAYMENT:
Mastercard / Visa (circle one)
Card #:
Exp. Date:
Signature:

RETURN:
☐ Clark Street Entrance
☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)
FIREARMS DELIVERED TO PLANT

FILE Nº 010806

DATE 1/17/96

CUSTOMER NAME:

ADDRESS:

ZIP:

PHONE:

FIREARM

MODEL:

GAUGE:

SERIAL #

REMINGTON EMPLOYEE:

YES ☐ NO ☒

EMPLOYEE #

DEPT. #

CHECK FOR AMMUNITION

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

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:

SIGNATURE: Robert L. Fredrickson
(Person delivering firearm to Plant)

DATE: 17 Jan 96

SIGNATURE: M. Seaman
(Security Officer)

DATE: 1/17/96

SIGNATURE: Richard Wright
(Firearm picked up by)

DATE: _____

Arm Service Copy

CONTRACT # DAAA21-87-C-0086

New Barrel

GUN SERIAL # C6225478

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		1/22/96	RW
600	Proof		1/22/96	RW
607.	Check Headspace		1/22/96	RW
610	Dis-assemble Gun		1/22/96	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		1/29/96	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/29/96	RW
	C) Inspect Ejector Hole for Chamfer		1/29/96	RW
	D) Oil Firing Pin Ass'y		1/29/96	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		1/31/96	BB
	A) Time			
	B) Malfunctions			
	C) Pierced Primers			
	D) Optical Clarity of Scope			
645	Inspect for Live Ammo		1/31/96	BB
655	Final Inspection			
	A) Headspace		2/1/96	Rw
	B) Trigger Pull			
	C) Function		2/1/96	Rw
660	Pack			

Final Inspection

Sn: C6225428

DATE REC'D: 1/17/96

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: _____

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225478
3 Jan 1988

CENTROIDAL DISTANCES

0 TO 1 - 1.06986
1 TO 2 .412921
1 TO 3 .3572
1 TO 4 .508296
1 TO 5 .233431

4
3
2
1

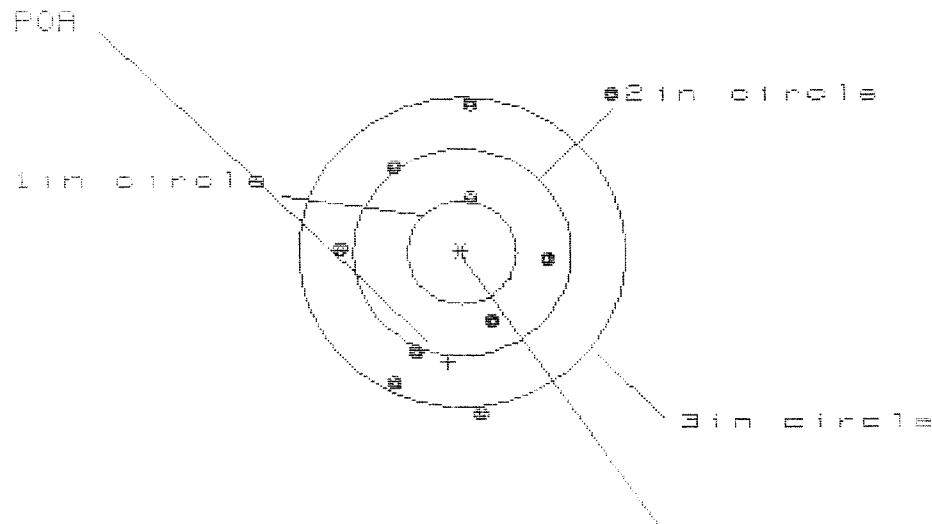
+ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0918
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: 1.1696
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: 1.1732
THE AMR FOR THIS RIFLE IS: 1.199

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225478

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 3

3in = 8

HS= 2.557

VS= 3.104

ES= 3.438

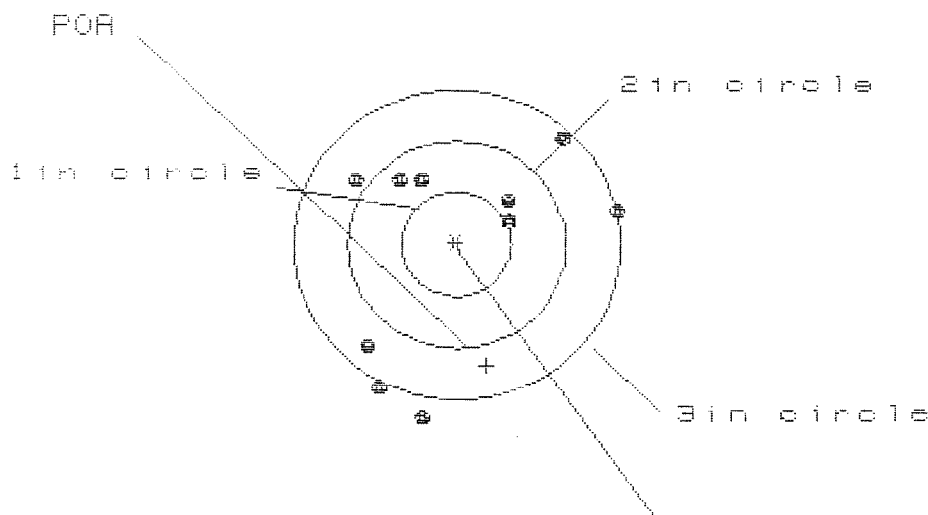
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.427	.965	1.006
MINIMUM X	:	-1.130	-.971	-.929
MAXIMUM Y	:	1.527	1.648	1.472
MINIMUM Y	:	-1.577	-1.407	-1.254
CENTROID X	:	.121	-.038	-.079
CENTROID Y	:	1.063	.893	1.069
POA TO CENTROID in.	:	1.070	.894	1.072
MIN RADIUS	:	.568	.625	.622
MEAN RADIUS	:	1.193	1.075	1.022
MAX RADIUS	:	2.090	1.672	1.507
HORIZONTAL SPREAD	:	2.557	1.936	1.936
VERTICAL SPREAD	:	3.104	3.055	2.726
EXTREME SPREAD	:	3.438	3.055	2.821
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

2 Jan 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6225478

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 7

HS= 2.280

VS= 2.646

GS= 2.981

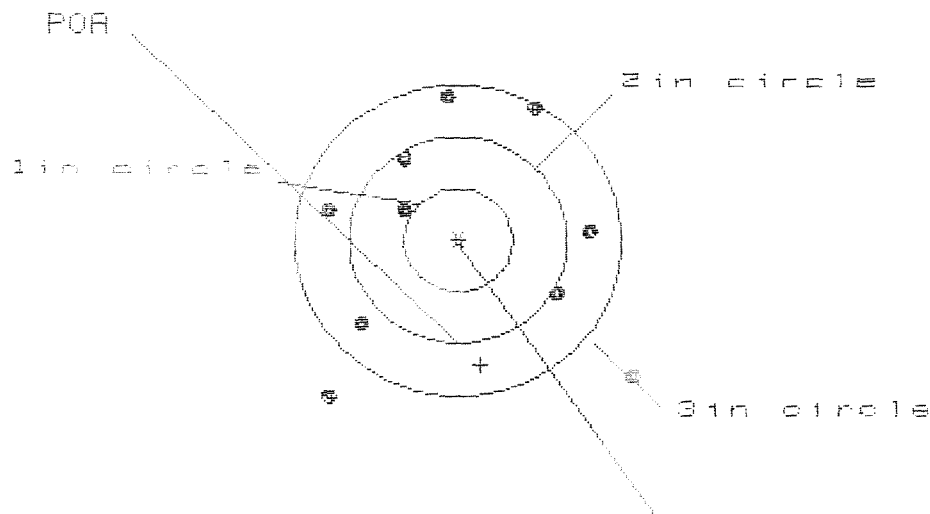
CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.585	1.467	1.169
MINIMUM X	:	-.875	-.913	-.730
MAXIMUM Y	:	1.014	.833	.856
MINIMUM Y	:	-1.632	-1.524	-1.501
CENTROID X	:	-.277	-.239	-.422
CENTROID Y	:	1.173	1.354	1.331
POA TO CENTROID in.	:	1.205	1.375	1.396
MIN RADIUS	:	.554	.483	.500
MEAN RADIUS	:	1.126	1.023	.964
MAX RADIUS	:	1.669	1.683	1.592
HORIZONTAL SPREAD	:	2.380	2.380	1.899
VERTICAL SPREAD	:	2.646	2.357	2.357
EXTREME SPREAD	:	2.981	2.905	2.905
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/06225478

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 8

HS= 2.835

VS= 2.835

GS= 3.384

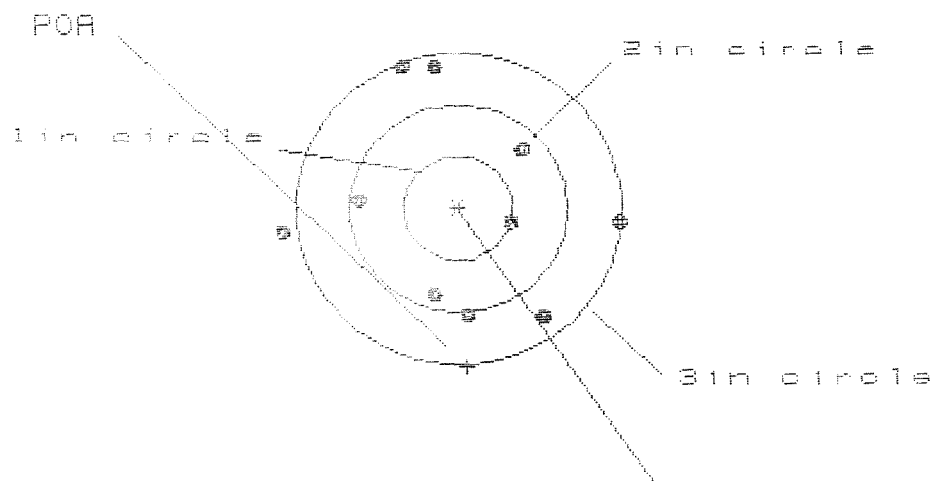
CENTROID *

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.625	1.343	1.215
MINIMUM X	-1.211	-1.031	-1.150
MAXIMUM Y	1.370	1.224	1.022
MINIMUM Y	-1.465	-1.511	-1.140
CENTROID X	-.205	-.385	-.257
CENTROID Y	1.209	1.355	1.557
POA TO CENTROID in.	1.226	1.409	1.578
MIN RADIUS	.583	.352	.422
MEAN RADIUS	1.304	1.170	1.055
MAX RADIUS	2.092	1.913	1.445
HORIZONTAL SPREAD	2.836	2.374	2.365
VERTICAL SPREAD	2.835	2.835	2.162
EXTREME SPREAD	3.384	3.384	2.680
NUMBER IN ONE INCH CIRCLE =	0	0	0
NUMBER IN TWO INCH CIRCLE =	2	2	2
NUMBER IN THREE INCH CIRCLE =	8	8	8

2 Jan 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225478

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

CENTROID #

IN CIR

1 in = 0

2 in = 5

3 in = 8

HE= 3.089

VE= 2.370

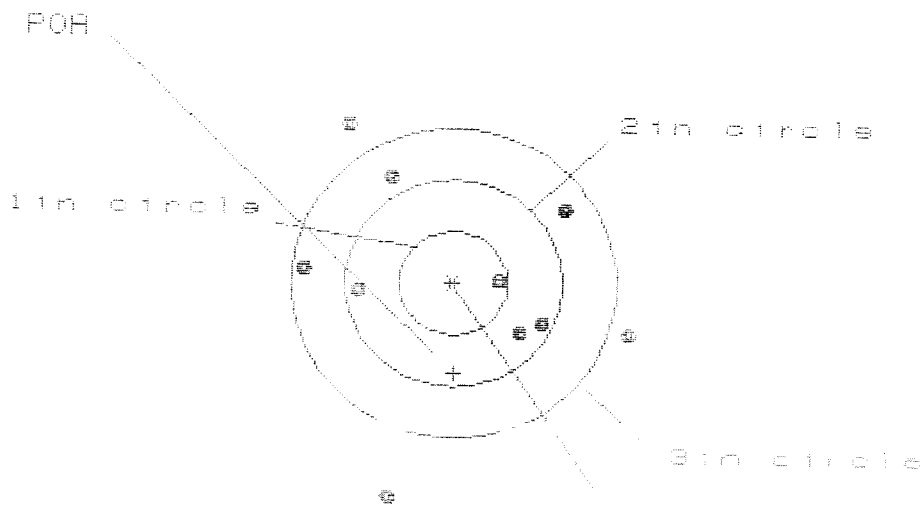
GE= 3.102

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.512	1.335	.751
MINIMUM X	:	-1.587	-1.083	-.916
MAXIMUM Y	:	1.373	1.346	1.329
MINIMUM Y	:	-.997	-1.024	-1.041
CENTROID X	:	-.082	.095	-.072
CENTROID Y	:	1.529	1.556	1.573
POA TO CENTROID in.	:	1.531	1.559	1.575
MIN RADIUS	:	.548	.398	.555
MEAN RADIUS	:	1.129	1.056	1.023
MAX RADIUS	:	1.607	1.517	1.432
HORIZONTAL SPREAD	:	3.099	2.418	1.667
VERTICAL SPREAD	:	2.370	2.370	2.370
EXTREME SPREAD	:	3.102	2.695	2.695
NUMBER IN ONE INCH CIRCLE =	:	0		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	8		

2 Jan 1988

FILE: PATTERNS/CENTERFIRE_PATT/08225478

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 4

3in = 7

ME= 3.001

VS= 3.645

GS= 3.663

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.572	1.503	1.372
MINIMUM X	:	-1.429	-1.498	-1.629
MAXIMUM Y	:	1.533	1.299	.913
MINIMUM Y	:	-2.112	-.717	-.555
CENTROID X	:	-.016	.053	.184
CENTROID Y	:	.874	1.188	.946
POB TO CENTROID in.	:	.874	1.189	.964
MIN RADIUS	:	.397	.394	.205
MEAN RADIUS	:	1.244	1.123	1.010
MAX RADIUS	:	2.200	1.668	1.630
HORIZONTAL SPREAD	:	3.001	3.001	3.001
VERTICAL SPREAD	:	3.645	2.016	1.468
EXTREME SPREAD	:	3.663	3.228	3.056
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

PAYMENT:

Mastercard / Visa (circle one)

Card #:

Exp. Date:

Signature

RETURN:

☐ Clark Street Entrance☒ Via US Mail or UPS

(PLEASE PRINT CLEARLY)

FIREARMS DELIVERED TO PLANT

FILE NO 007079DATE 6/20/92

CUSTOMER NAME:

DAVID HUSKINS

REMINGTON EMPLOYEE:

ADDRESS:

COMPANY DYES ☐ NO ☒

EMPLOYEE #

DEPT. #

ZIP:

240 BTL 1ST SURG,
FT. BRAGG, N.C.
29307-5000

PHONE:

919-432-9037

FIREARM

MODEL: M24

CHECK FOR AMMUNITION

GAUGE: .762SERIAL # ~~66225478~~ C 622 5478

CONDITION:

WOOD

GOOD

FAIR

POOR

FANCY

PLAIN

METAL

GOOD

FAIR

POOR

FANCY

PLAIN

BARREL

VT. RIB

PLAIN

DEER RSS

ACCESSORIES:

SCOPE: YES

NO

(BRAND NAME/POWER)

M3A-10SLING: YESNO

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:

RE BR RRELLD

SIGNATURE:

(Person delivering firearm to Plant)

DATE:

6/20/92

SIGNATURE:

(Security Officer)

DATE:

6/20/92

SIGNATURE:

(Firearm picked up by)

DATE:

6/22/92

Arm Service Copy

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225478
28 Jul 1992.

CENTROIDAL DISTANCES

0 TO 1	.104957
1 TO 2	.690514
1 TO 3	.537141
1 TO 4	.276742
1 TO 5	.65787

53 2 (----POA

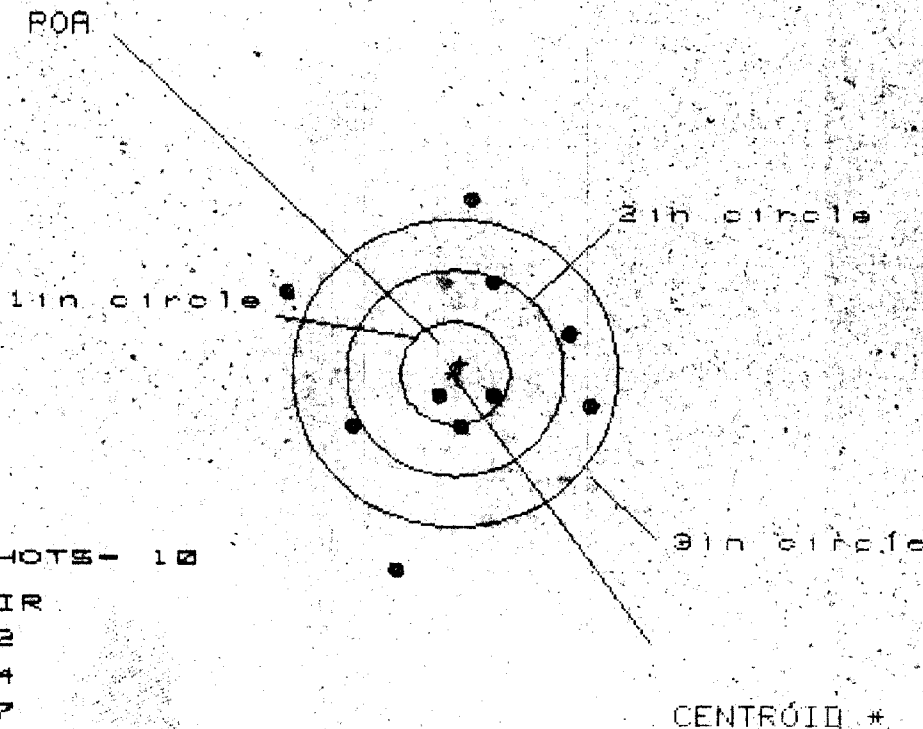
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.049
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.4648
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .467376

THE AMP FOR THIS RIFLE IS: 1.082

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/b6225478

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 7

HS = 2.707

VS = 3.597

GS = 3.656

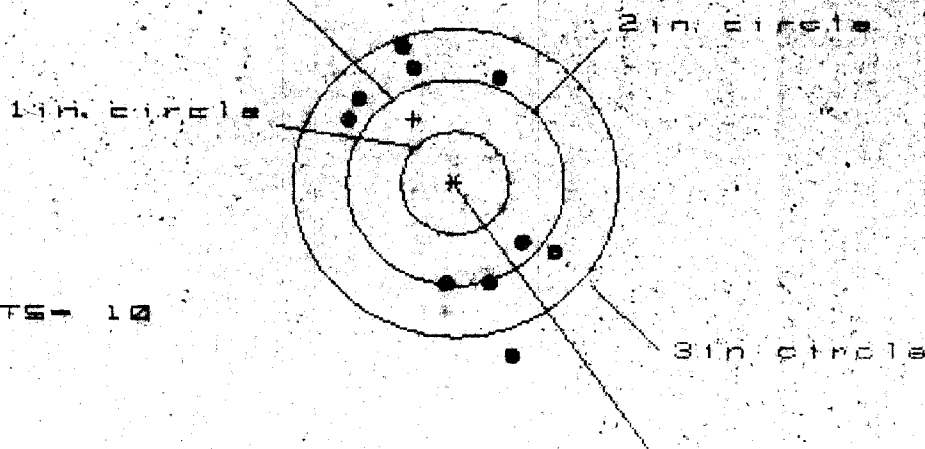
PATTERN #			
SHOTS (BEST OF)	:	10	9
MAXIMUM X	:	1.209	1.150
MINIMUM X	:	-1.498	-1.557
MAXIMUM Y	:	1.659	1.444
MINIMUM Y	:	-1.938	-1.741
CENTROID X	:	-.054	.005
CENTROID Y	:	-.090	.125
POA TO CENTROID in.	:	.105	.126
MIN RADIUS	:	.279	.487
MEAN RADIUS	:	1.099	1.008
MAX RADIUS	:	2.009	1.650
HORIZONTAL SPREAD	:	2.707	2.707
VERTICAL SPREAD	:	3.597	2.185
EXTREME SPREAD	:	3.656	2.919
NUMBER IN ONE INCH CIRCLE	=		2
NUMBER IN TWO INCH CIRCLE	=		4
NUMBER IN THREE INCH CIRCLE	=		7

28 Jul 1992

FILE:/PATTERNING/CENTERFIRE_PATT/c6225478

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 9

HS = 1.918

VS = 2.936

GS = 3.116

CENTROID *

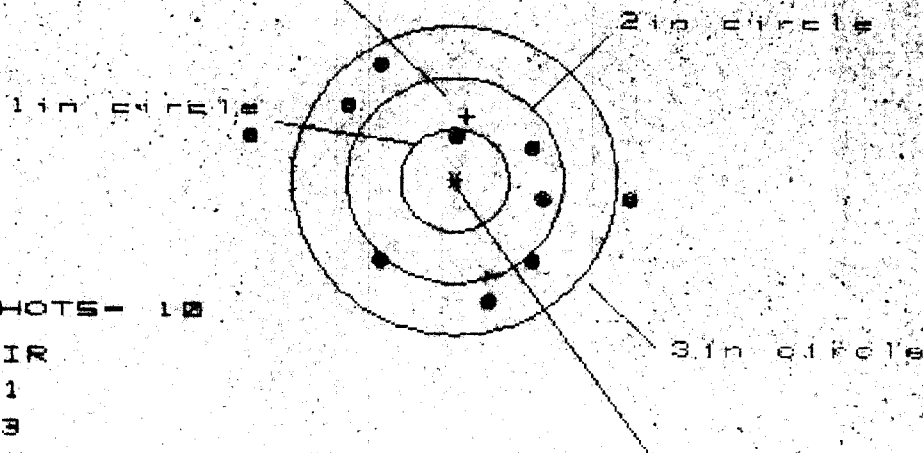
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.930	.992	.938
MINIMUM X	-.988	-.926	-.980
MAXIMUM Y	1.304	1.122	1.033
MINIMUM Y	-1.632	-1.147	-1.006
CENTROID X	.385	.323	.377
CENTROID Y	-.623	-.441	-.582
POA TO CENTROID in.	.732	.547	.693
MIN RADIUS	.888	.934	.922
MEAN RADIUS	1.163	1.087	1.065
MAX RADIUS	1.723	1.282	1.154
HORIZONTAL SPREAD	1.918	1.918	1.918
VERTICAL SPREAD	2.936	2.269	2.039
EXTREME SPREAD	3.116	2.402	2.275
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/C8225478

CENTERFIRE PATTERNS # 3

POA



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS = 3.499

VS = 2.306

GS = 3.549

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.644	1.438	.827
MINIMUM X	:	-1.855	-1.190	-1.011
MAXIMUM Y	:	1.146	1.194	1.180
MINIMUM Y	:	-1.160	-1.112	-1.126
CENTROID X	:	-.112	.094	-.085
CENTROID Y	:	-.624	-.672	-.658
POA TO CENTROID in.	:	.634	.679	.664
MIN RADIUS	:	.459	.553	.494
MEAN RADIUS	:	1.157	1.043	1.000
MAX RADIUS	:	1.905	1.474	1.364
HORIZONTAL SPREAD	:	3.499	2.628	1.838
VERTICAL SPREAD	:	2.306	2.306	2.306
EXTREME SPREAD	:	3.549	2.783	2.504
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/66225478

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 1.491

VS= 2.790

GS= 2.879

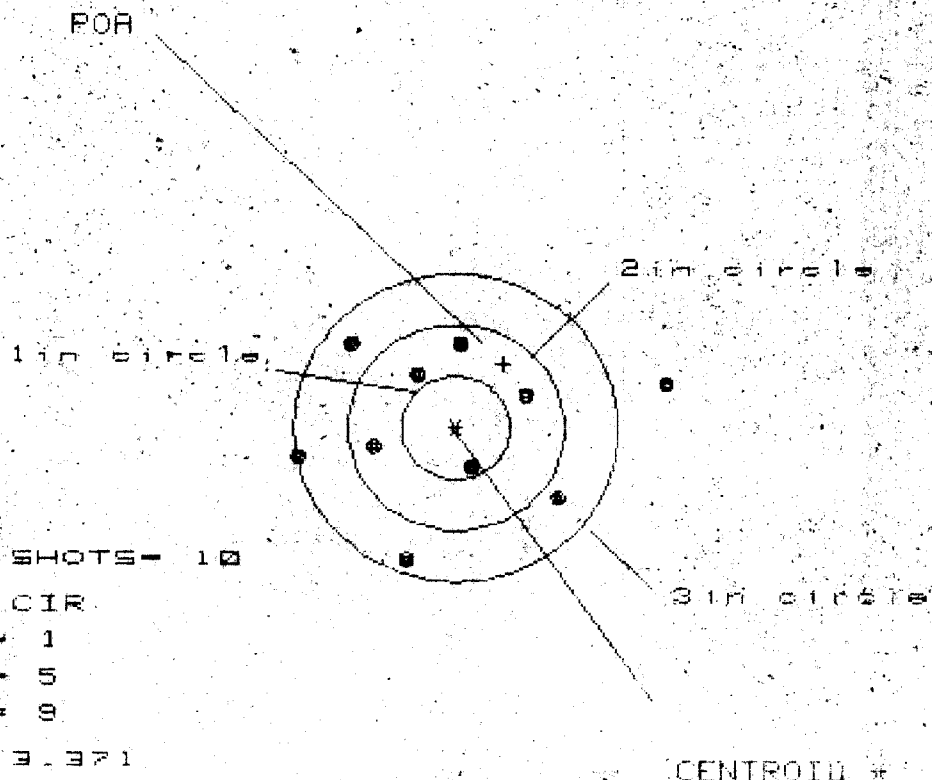
PATTERN #

	10	9	8
SHOTS (BEST OF)			
MAXIMUM X	.837	.780	.798
MINIMUM X	-.654	-.711	-.693
MAXIMUM Y	1.492	1.193	1.051
MINIMUM Y	-1.298	-1.132	-1.148
CENTROID X	-.023	.034	.016
CENTROID Y	-.365	-.531	-.389
POA TO CENTROID in.	.366	.532	.389
MIN RADIUS	.059	.156	.081
MEAN RADIUS	.926	.845	.796
MAX RADIUS	1.577	1.194	1.161
HORIZONTAL SPREAD	1.491	1.491	1.491
VERTICAL SPREAD	2.790	2.325	2.199
EXTREME SPREAD	2.879	2.334	2.209
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

28 Jul 1992

FILE: PATTERNING/CENTERFIRE_PATT/C6225478

CENTERFIRE PATTERNS # 5



* OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.371

VS= 2.147

GS= 3.440

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.956	1.207	1.050
MINIMUM X	-1.415	-1.198	-0.883
MAXIMUM Y	.850	.896	.868
MINIMUM Y	-1.297	-1.251	-1.279
CENTROID X	-.441	-.658	-.509
CENTROID Y	-.622	-.668	-.640
POA TO CENTROID in.	.762	.938	.818
MIN RADIUS	.452	.527	.469
MEAN RADIUS	1.067	.947	.903
MAX RADIUS	2.000	1.375	1.328
HORIZONTAL SPREAD	3.371	2.405	1.941
VERTICAL SPREAD	2.147	2.147	2.147
EXTREME SPREAD	3.440	2.456	2.456
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225478

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock		7/9/92	RW
600	Proof		7/9/92	RW
607	Check Headspace		7/9/92	RW
610	Dis-assemble Gun		7/9/92	RW
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes		7/9/92	RW
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	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		7-28-92	AC
	A) Time		"	AC
	B) Malfunctions		"	AC
	C) Pierced Primers		"	AC
	D) Optical Clarity of Scope		"	AC
645	Inspect for Live Ammo		7-28-92	AC
655	Final Inspection			
	A) Headspace			
	B) Trigger Pull			
	C) Function			
660	Pack			

RC 54

M-24

SCOPE #
88-1209CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6225478

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 RB		1/26/90	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	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						4/1/90	DH
	A) Time						4/1/90	DH
	B) Malfunctions						4/1/90	DH
	C) Pierced Primers						4/1/90	DH
	D) Optical Clarity of Scope						4/1/90	DH
645	Inspect for Live Ammo						4/1/90	DH
655	Final Inspection A) Headspace							
	B) Trigger Pull	2.52	2.50	2.51	2.54	2.57	4/1/90	gV
	C) Function							
660	Pack						4-12-90	DH

MOD. M-24 GA. CAL. 6225478 GUN # 6225478

#	TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
JES	1st	10/4/88	DE- 97 TH-1	
	2nd	10/4/88	Clean Ejector Hole	DW
	3rd			
	4th			

FUNCTION

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

DSMB14R1005012402136

W52H090019H226 W25G1Z035679000C6225478 W15BW9 90019

TITLE: SMALL ARMS SERIALIZATION (SASP) CARD
CONTACT #DAAA21-87-G-0001
CDRL ITEM A010

FROM: REMINGTON ARMS CO., INC.
ILION, NY 13357

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225478
12 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.121198
1 TO	2	.395294
1 TO	3	.464303
1 TO	4	.572729
1 TO	5	.180036

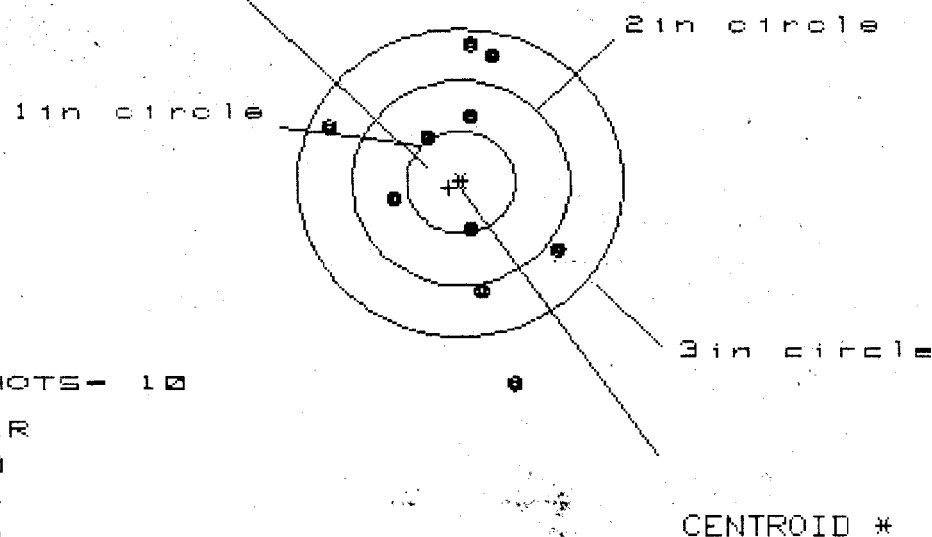
$\frac{S^4}{2^3}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1258
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0302
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129374
THE AMR FOR THIS RIFLE IS: .9222

CG225478

CENTERFIRE PATTERNS # 1

POA



OF SHOTS- 10

IN CIR

1in - 0

2in - 4

3in - 9

HS- 2.021

VS- 3.339

GS- 3.358

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.855

.909

.933

MINIMUM X

-1.166

-1.112

-1.088

MAXIMUM Y

1.395

1.178

1.127

MINIMUM Y

-1.944

-1.264

-1.116

CENTROID X

.108

.054

.030

CENTROID Y

.055

.271

.123

POA TO CENTROID in.

.121

.276

.127

MIN RADIUS

.515

.406

.504

MEAN RADIUS

1.056

.922

.886

MAX RADIUS

2.005

1.288

1.196

HORIZONTAL SPREAD

2.021

2.021

2.021

VERTICAL SPREAD

3.339

2.442

2.243

EXTREME SPREAD

3.358

2.442

2.243

NUMBER IN ONE INCH CIRCLE =

0

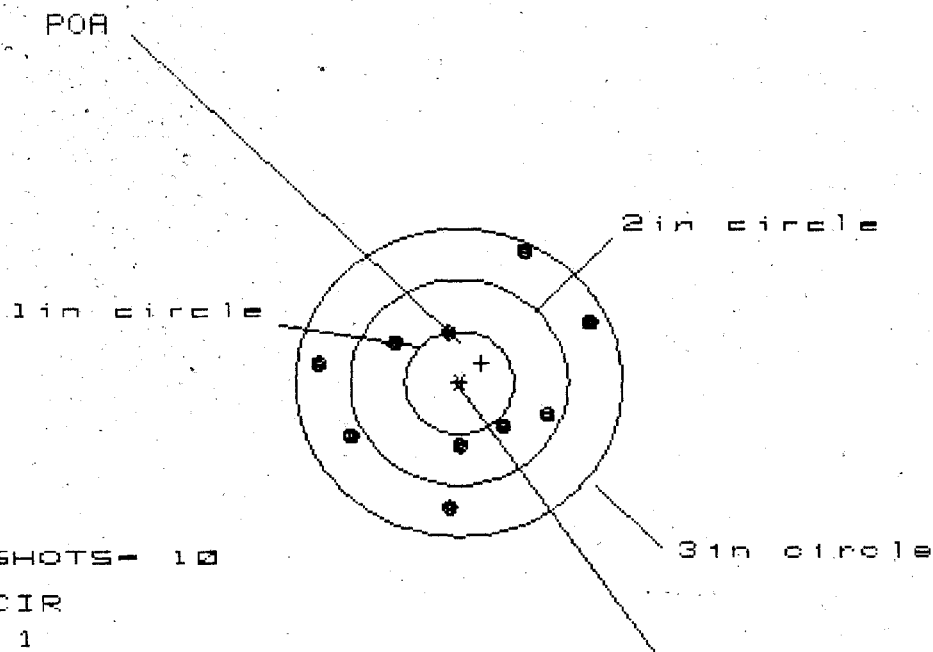
NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 1

2in - 5

3in = 10

HS- 2.457

VS= 2.507

GS= 2.607

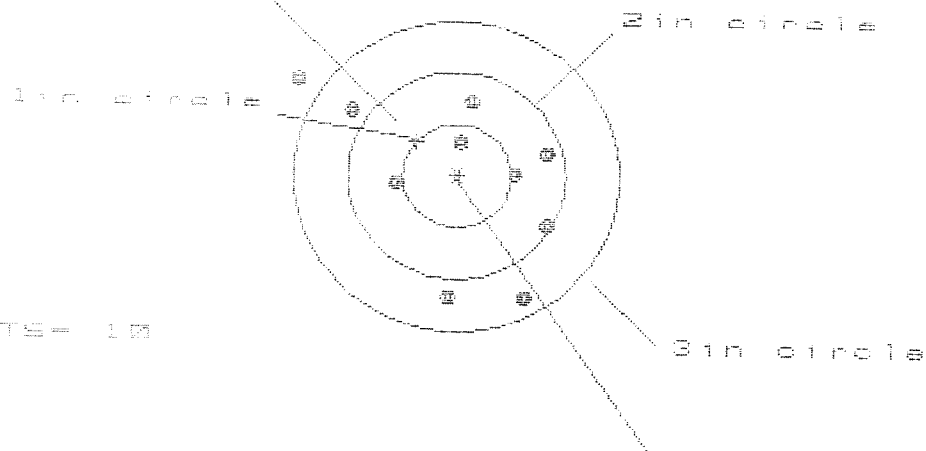
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.195	1.267	1.023
MINIMUM X	:	-1.262	-1.190	-1.031
MAXIMUM Y	:	1.335	.765	.719
MINIMUM Y	:	-1.172	-1.024	-.928
CENTROID X	:	-.203	-.275	-.434
CENTROID Y	:	-.189	-.337	-.433
POA TO CENTROID in.	:	.278	.435	.613
MIN RADIUS	:	.480	.500	.460
MEAN RADIUS	:	.975	.904	.824
MAX RADIUS	:	1.484	1.480	1.120
HORIZONTAL SPREAD	:	2.457	2.457	2.054
VERTICAL SPREAD	:	2.507	1.789	1.647
EXTREME SPREAD	:	2.607	2.500	2.118
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTERFIRE PATTERNS

3

POB



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

MEAN = 0.000

MEAN = 0.174

MEAN = 0.973

CENTROID #

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.722	.778
MINIMUM X	-1.419	-1.098	-1.042
MAXIMUM Y	.967	.862	.724
MINIMUM Y	-1.287	-1.099	-1.230
CENTROID X	.369	.526	.470
CENTROID Y	-.329	-.437	-.299
POB TO CENTROID in.	.494	.684	.557
MIN RADIUS	.361	.399	.340
MEAN RADIUS	.945	.846	.781
MAX RADIUS	1.717	1.321	1.245
HORIZONTAL SPREAD	2.298	1.820	1.820
VERTICAL SPREAD	2.174	1.961	1.954
EXTREME SPREAD	2.973	2.401	2.136
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	

CENTERFIRE PATTERNS

4

FOR

1 in circle

2 in circle

3 in circle

CENTROID *

* OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 9

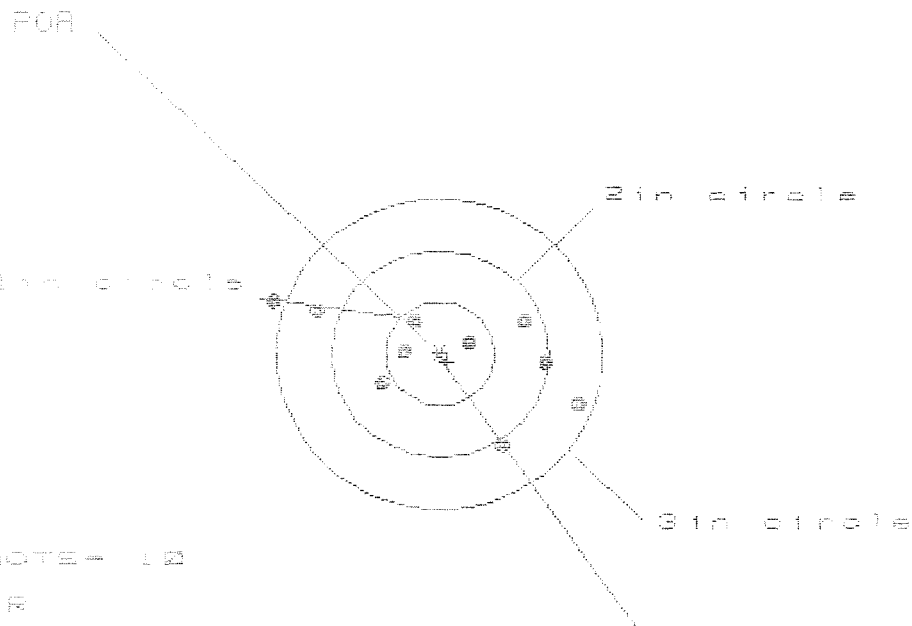
ME = 1.788

MS = 2.474

CE = 2.985

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.944	.961
MINIMUM X	-.874	-.819	-.802
MAXIMUM Y	1.429	.795	.685
MINIMUM Y	-1.045	-.887	-.379
CENTROID X	.425	.370	.353
CENTROID Y	.532	.374	.484
FOR TO CENTROID in.	.681	.526	.599
MIN RADIUS	.424	.273	.385
MEAN RADIUS	.781	.687	.655
MAX RADIUS	1.513	.965	1.010
HORIZONTAL SPREAD	1.763	1.763	1.763
VERTICAL SPREAD	2.474	1.682	1.063
EXTREME SPREAD	2.509	1.764	1.764
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

CENTERFIRE PATTERNS # 5



OF SHOTS = 10
 # IN CIR
 1 in = 3
 2 in = 6
 3 in = 9
 ME = 2.727
 SE = 1.668
 GE = 2.668

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.234	1.067	.891
MINIMUM X	:	-1.503	-1.266	-1.133
MAXIMUM Y	:	.518	.438	.379
MINIMUM Y	:	-.850	-.793	-.844
CENTROID X	:	-.070	.097	-.036
CENTROID Y	:	.082	.025	.076
POR TO CENTROID IN.	:	.108	.100	.084
MIN RADIUS	:	.262	.176	.234
MEAN RADIUS	:	.854	.766	.704
MAX RADIUS	:	1.590	1.337	1.195
HORIZONTAL SPREAD	:	2.737	2.333	2.024
VERTICAL SPREAD	:	1.368	1.223	1.223
EXTREME SPREAD	:	2.989	2.486	2.077
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6225478*

OPERATION		DATE	INT
#	NAME		
575-580	ASSEMBLY	<i>2 26</i>	<i>FB</i>
600	PROOF	<i>2 29</i>	<i>RW</i>
615	MAGNAFLUX BARREL	<i>5/13/88</i>	<i>PFL</i>
	MAGNAFLUX BOLT	<i>5/13/88</i>	<i>PFL</i>
620	COATING	<i>2/11/88</i>	<i>ISA</i>
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		

Score #
1209

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225478

OP.#	OP. NAME	READINGS	DATE	INITIAL
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 & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	Apply Coatings (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/29/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/29/88	RW
	C) Inspect Ejector Hole for Chamfer		8/29/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		8/29/88	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		29aug88	L.H. + G.S.
	F) Safety on Force	5.75 5 5.5	29aug88	J. U. + G.S.
	G) Safety off Force	3 3 3	29aug88	J. U. + G.S.
	H) Trigger Pull Test & Retainability		29aug88	J. U. + G.S.
	I) Firing Pin Indent	.022 .022 .022	29aug88	J. U. + G.S.
	J) Assemble Stock		9/26/88	RW
	K) Assemble Swivel Studs		10-6-88	G.S.
	L) Attach Front & Rear Sight Assemblies		9/26/88	RW
	M) Iron Sight Alignment		9/26/88	RW
	N) Detach Front & Rear Sights & place in numbered container		9/26/88	RW
	O) Attach Scope to Rifle		10/1/88	RW
	P) Detach & Attach Scope 20 times		10/1/88	JEP
640	Gallery Target & Test	61 R 94 L	10/4/88	JES
	A) Optical Clarity of Scope		10/4/88	JEP
645	Inspect for Live Ammo		10/4/88	JEP
655	Final Inspection			
	A) Headspace		10-6-88	G.S.
	B) Trigger Pull		10-6-88	G.S.
	C) Function		10-6-88	G.S.
660	Pack		10-21-88	G.S.

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C0225478
DATE 29 Aug 88
TESTER J.D. + R.S.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.31	2.33	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.59	2.36	2.26	2.70	
PULL #3	2.41	2.32	2.25	2.76	
PULL #4	2.51	2.30	2.34	2.76	
PULL #5	2.53	2.31	2.32	2.79	
TOTAL	12.64	11.60	11.50	13.73	
AVG.	2.528	2.32	2.30	2.75	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.07		
PULL #2	3.08	3.05		
PULL #3	3.08	3.06		
PULL #4	3.05	3.06		
PULL #5	3.06	3.04		
TOTAL	15.37	15.28		
AVG.	3.074	3.056		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.26	4.23		4.05
PULL #2	4.25	4.22		4.08
PULL #3	4.24	4.22		4.15
PULL #4	4.26	4.20		4.14
PULL #5	4.26	4.17		4.18
TOTAL	21.27	21.04		20.50
AVG.	4.254	4.208		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225478

CENTROIDAL DISTANCES

0 TO	1	.496891
1 TO	2	.782413
1 TO	3	.645732
1 TO	4	.388209
1 TO	5	1.01708

1

C-----POA

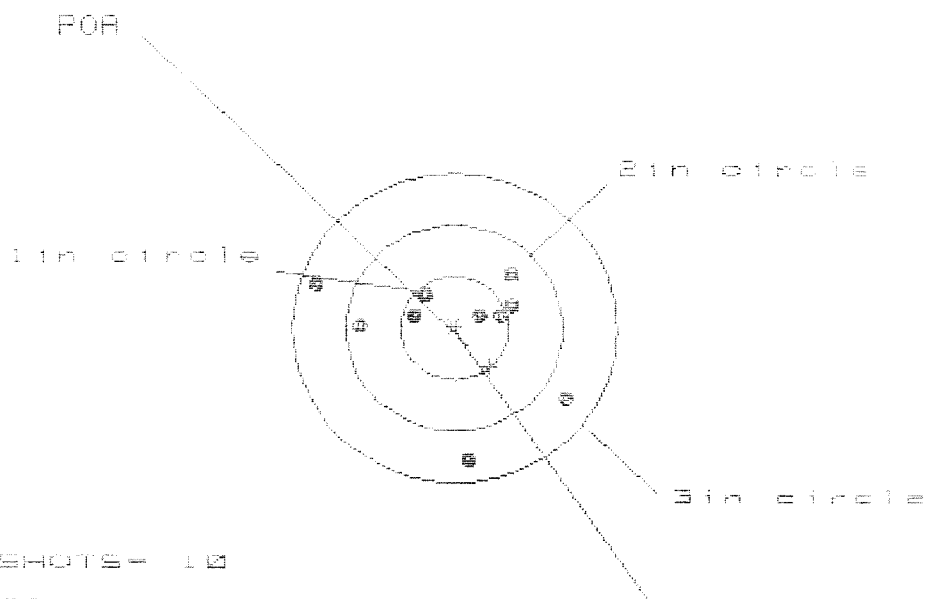
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1506
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .243388
THE AMR FOR THIS RIFLE IS: .9526

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225478

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.351

VS= 1.745

GS= 2.576

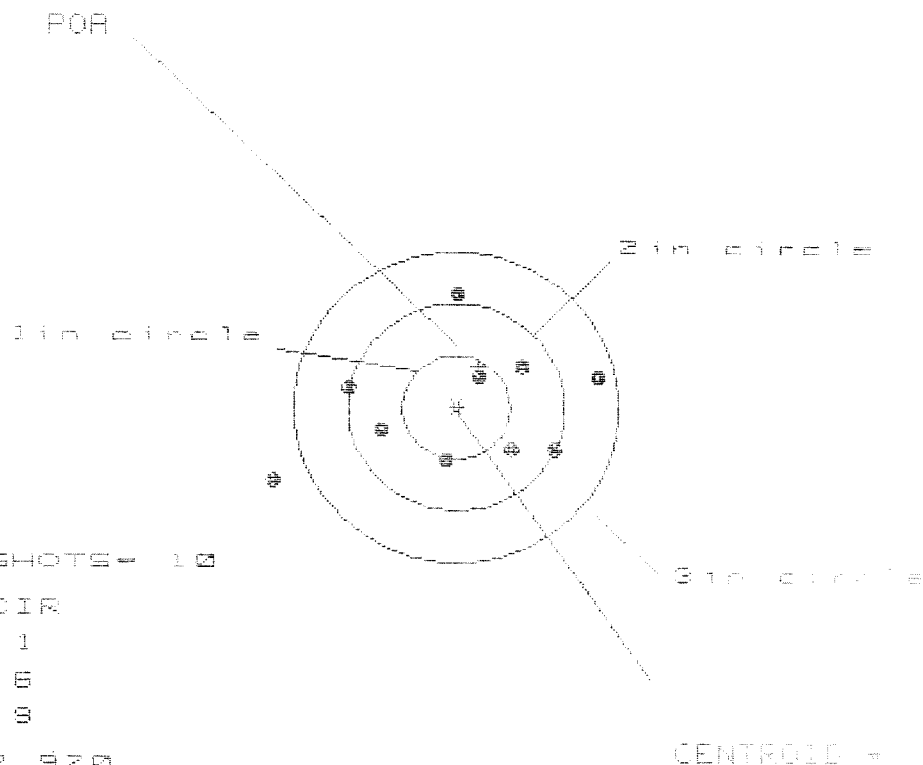
CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.040	.895	.896
MINIMUM X	:	-1.311	-1.062	-1.061
MAXIMUM Y	:	.483	.528	.376
MINIMUM Y	:	-1.262	-1.217	-.756
CENTROID X	:	-.326	-.181	-.182
CENTROID Y	:	.375	.330	.482
FOR TO CENTROID in.	:	.497	.376	.515
MIN RADIUS	:	.261	.186	.083
MEAN RADIUS	:	.773	.692	.582
MAX RADIUS	:	1.372	1.217	1.172
HORIZONTAL SPREAD	:	2.351	1.957	1.957
VERTICAL SPREAD	:	1.745	1.745	1.132
EXTREME SPREAD	:	2.576	2.068	2.068
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225478

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

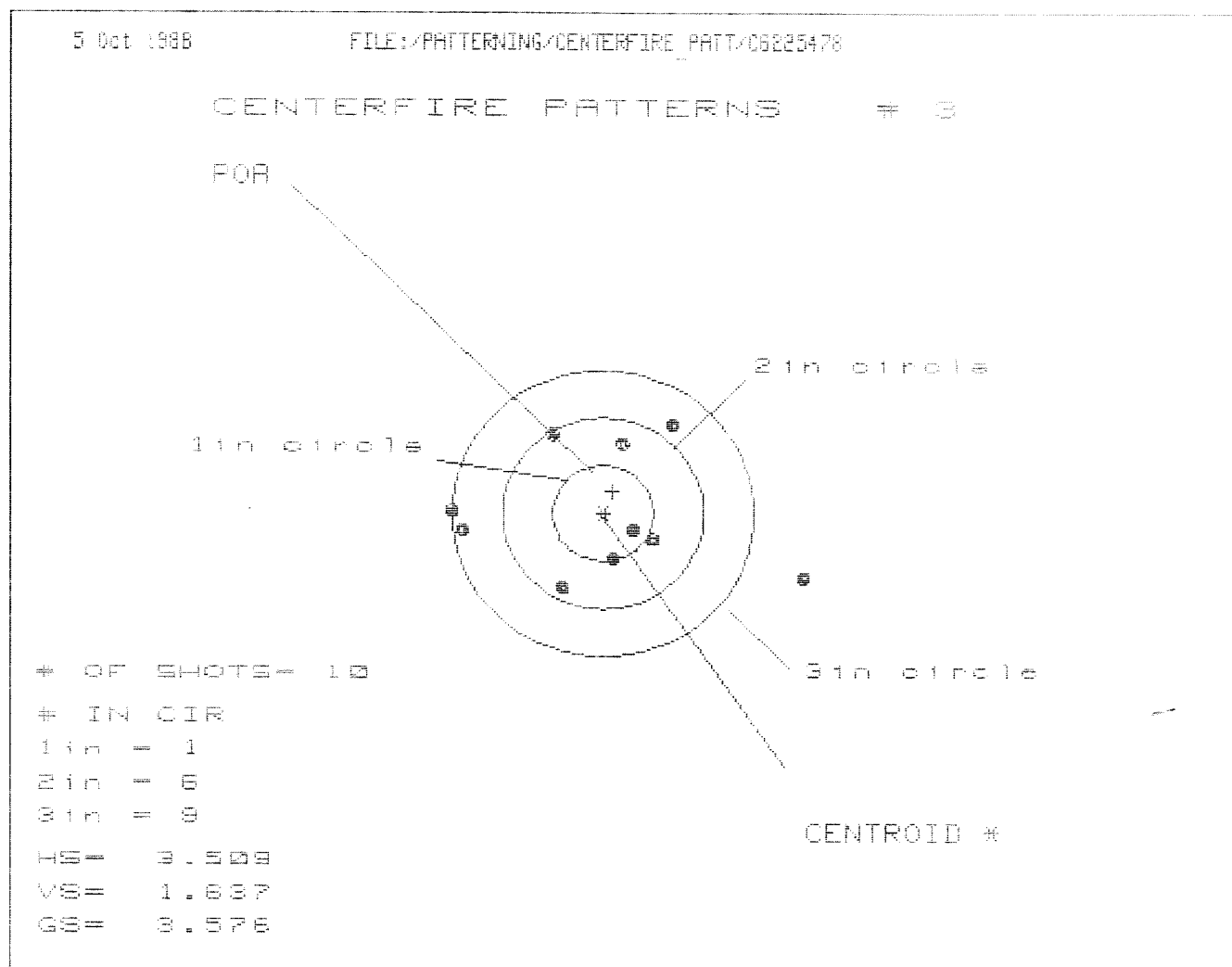
HS= 2.970

VS= 1.748

GS= 3.133

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.280	1.092	.941
MINIMUM X	:	-1.690	-1.184	-1.647
MAXIMUM Y	:	1.058	.981	1.010
MINIMUM Y	:	-.691	-.599	-.580
CENTROID X	:	-.205	-.017	-.154
CENTROID Y	:	-.398	-.321	-.350
POR TO CENTROID in.	:	.447	.321	.382
MIN RADIUS	:	.321	.184	.253
MEAN RADIUS	:	.911	.777	.740
MAX RADIUS	:	1.826	1.187	1.053
HORIZONTAL SPREAD	:	2.970	2.276	1.888
VERTICAL SPREAD	:	1.748	1.570	1.570
EXTREME SPREAD	:	3.133	2.281	1.973
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

VERTICAL	SPREAD :	1.748	1.570	1.570
EXTREME	SPREAD :	3.133	2.281	1.973
NUMBER IN ONE	INCH CIRCLE =		1	
NUMBER IN TWO	INCH CIRCLE =		6	
NUMBER IN THREE	INCH CIRCLE =		9	



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.025	.952	.795
MINIMUM X	:	-1.484	-1.259	-1.325
MAXIMUM Y	:	.913	.840	.836
MINIMUM Y	:	-.724	-.797	-.801
CENTROID X	:	-.095	-.320	-.163
CENTROID Y	:	-.228	-.155	-.151
FOR TO CENTROID in.	:	.247	.356	.222
MINIMUM X	:	1.376	1.170	1.290

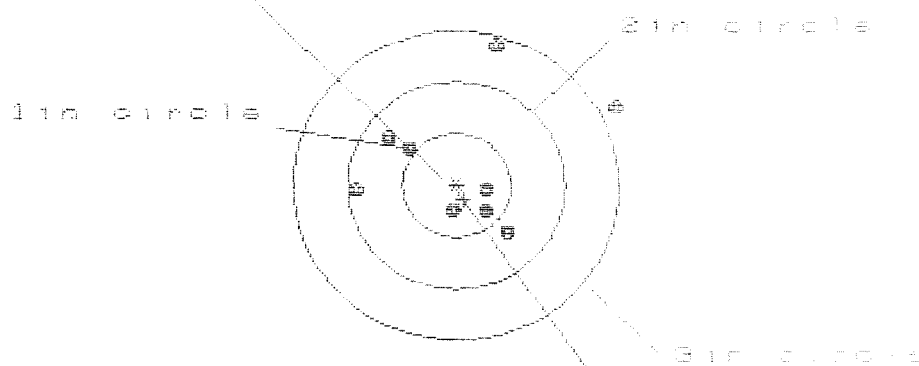
MEAN RADIUS	:	1.017	.908	.834
MAX RADIUS	:	2.129	1.270	1.357
HORIZONTAL SPREAD	:	3.509	2.211	2.120
VERTICAL SPREAD	:	1.637	1.637	1.637
EXTREME SPREAD	:	3.576	2.402	2.402
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08205478

CENTERFIRE PATTERNS # 4

POR



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 2.400

VS = 3.200

GS = 3.400

CENTROID #

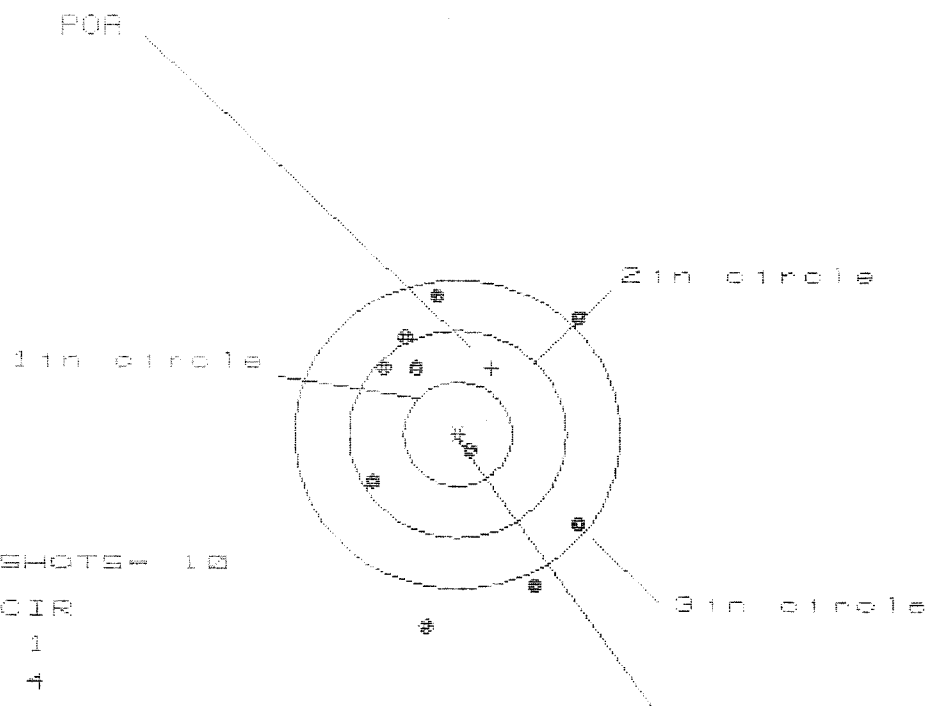
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.498	1.404	.565
MINIMUM X	:	-.932	-1.026	-.050
MAXIMUM Y	:	1.344	1.137	1.202
MINIMUM Y	:	-1.859	-.672	-.607
CENTROID X	:	-.071	.023	-.153

CENTROID Y	:	.140	.346	.281
POA TO CENTROID in.:	:	.156	.347	.320
MIN RADIUS	:	.226	.259	.346
MEAN RADIUS	:	.889	.782	.661
MAX RADIUS	:	2.041	1.499	1.299
HORIZONTAL SPREAD	:	2.430	2.430	1.415
VERTICAL SPREAD	:	3.203	1.809	1.809
EXTREME SPREAD	:	3.489	2.535	1.892
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

5 Oct 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08285478

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 4

3in = 7

HS = 1.925

VS = 3.223

GS = 3.303

CENTROID #

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.097	1.068	1.185
MINIMUM X	:	-0.829	-0.858	-0.724

MAXIMUM Y	:	1.376	1.170	1.290
MINIMUM Y	:	-1.847	-1.656	-1.536
CENTROID X	:	-.313	-.284	-.417
CENTROID Y	:	-.642	-.436	-.556
POA TO CENTROID in.:		.714	.521	.695
MIN RADIUS	:	.202	.393	.328
MEAN RADIUS	:	1.173	1.081	1.016
MAX RADIUS	:	1.866	1.773	1.718
HORIZONTAL SPREAD	:	1.926	1.926	1.910
VERTICAL SPREAD	:	3.223	2.826	2.826
EXTREME SPREAD	:	3.303	2.962	2.962
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	