

C6225490

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



M-24

SCOPE #
1272

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225490

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	P/C.
	Magnaflux Bolt		9 22 88	P/C.
615	Rollmark Caliber			
617	Drill & Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		10-31-88	TJA
	Apply Coatings (Bolt)		10-31-88	TJA
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/2/88	RW
	C) Inspect Ejector Hole for Chamfer		11/2/88	RW

OVER

OP.#	READINGS	DATE	INITIAL
625	D) Oil Firing Pin Ass'y	11/6/88	RW
cont.	E) Adjust Trigger Pull to Min. Setting and Stake	3 NOV 88	JS
	F) Safety on Force	5 5 5 4 NOV 88	JS
	G) Safety off Force	3 3 3 4 NOV 88	JS
	H) Trigger Pull Test & Retainability	3 NOV 88	JS
	I) Firing Pin Indent	.0205 .0205 .020 4 NOV 88	JS
	J) Assemble Stock	11/7/88	RW
	K) Attach Front & Rear Sight Assemblies		
	L) Iron Sight Alignment	11/7/88	RW
	M) Detach Front & Rear Sights & place in numbered container	11/7/88	RW
	N) Attach Scope to Rifle	11/7/88	RW
	O) Detach & Attach Scope 20 times	11/8/88	RW
640	Gallery Target & Test	50 R 104 L 11/9/88	AC
	A) Optical Clarity of Scope	OK 11/9/88	AC
645	Inspect for Live Ammo	NONE 11/9/88	AC
655	Final Inspection A) Headspace	29 NOV 88	JS
	B) Trigger Pull	2.54 2.50 2.49 2.50 2.54	JS
	C) Function	29 NOV 88	JS
	D) Assemble Swivel Studs	29 NOV 88	JS
660	Pack	15 DEC 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. C6225490

DATE 3-28-90

TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.47	2.47	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.42	2.53	
PULL #3	2.42	2.47	2.48	
PULL #4	2.46	2.45	2.49	
PULL #5	2.47	2.46	2.54	
TOTAL	12.28	12.27	12.54	
AVG.	2.456	2.454	2.508	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.42	3.41	
PULL #2	3.42	3.40	
PULL #3	3.41	3.41	
PULL #4	3.43	3.44	
PULL #5	3.42	3.40	
TOTAL	17.10	17.06	
AVG.	3.42	3.412	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.21	4.23		
PULL #2	4.22	4.27		
PULL #3	4.22	4.28		
PULL #4	4.25	4.25		
PULL #5	4.25	4.25		
TOTAL	21.15	21.28		
AVG.	4.23	4.256		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225490

CENTROIDAL DISTANCES

0 TO	1	.55416
1 TO	2	.693643
1 TO	3	.614472
1 TO	4	1.16076
1 TO	5	.127577

4
2
1 2 (----POA
5 3

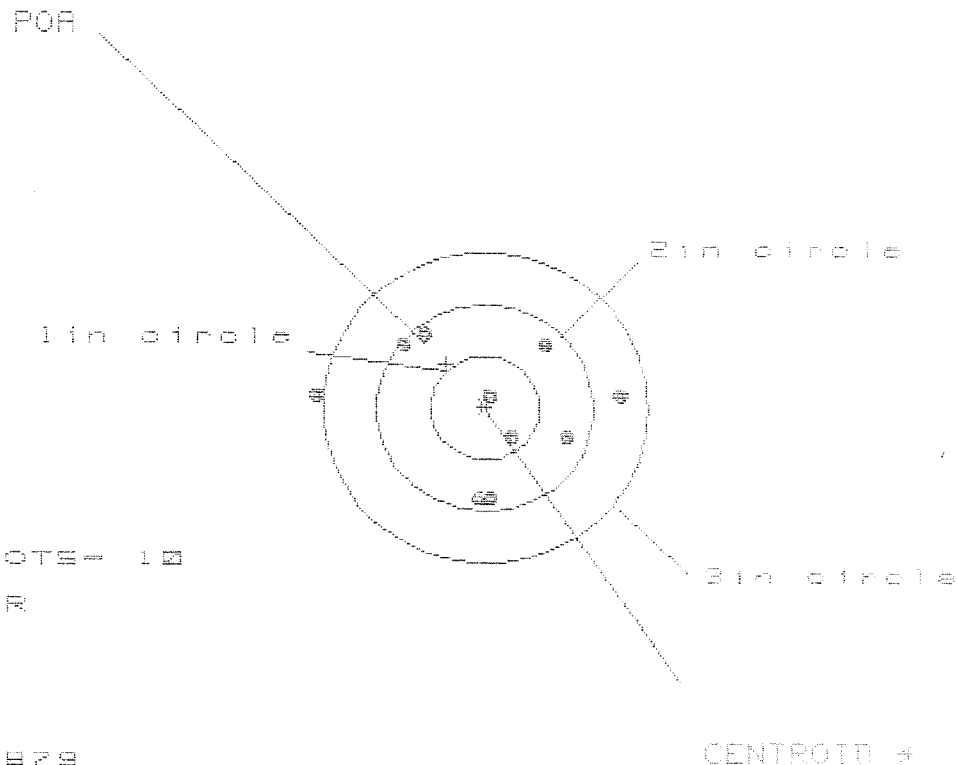
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .473
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1042
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .484341

THE AMR FOR THIS RIFLE IS: 1.193

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08223490

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.879

VS= 1.573

GS= 2.880

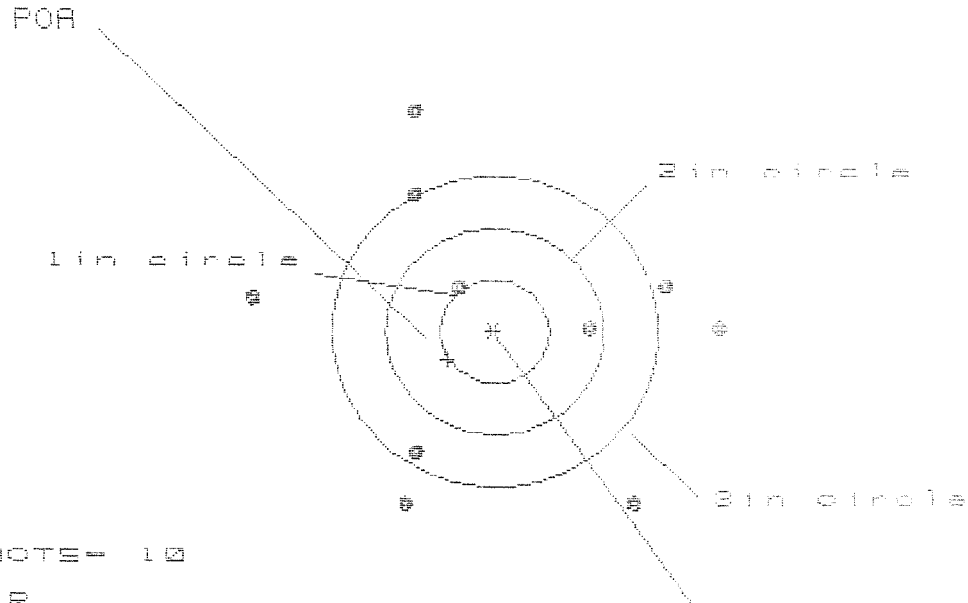
CENTROID *

PATTERN #				
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.264	1.107	.748
MINIMUM X	:	-1.595	-.967	-.829
MAXIMUM Y	:	.711	.727	.739
MINIMUM Y	:	-.862	-.846	-.834
CENTROID X	:	.358	.535	.397
CENTROID Y	:	-.423	-.439	-.451
POR TO CENTROID in.	:	.554	.692	.601
MIN RADIUS	:	.879	.184	.187
MEAN RADIUS	:	.864	.764	.715
MAX RADIUS	:	1.601	1.168	1.064
HORIZONTAL SPREAD	:	2.879	2.074	1.577
VERTICAL SPREAD	:	1.573	1.573	1.573
EXTREME SPREAD	:	2.880	2.147	1.823
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225490

CENTERFIRE PATTERNS # 2



OF SHOTS- 10
IN CIR
1 in = 0
2 in = 2
3 in = 3
H= 4.323
V= 3.800
G= 4.331

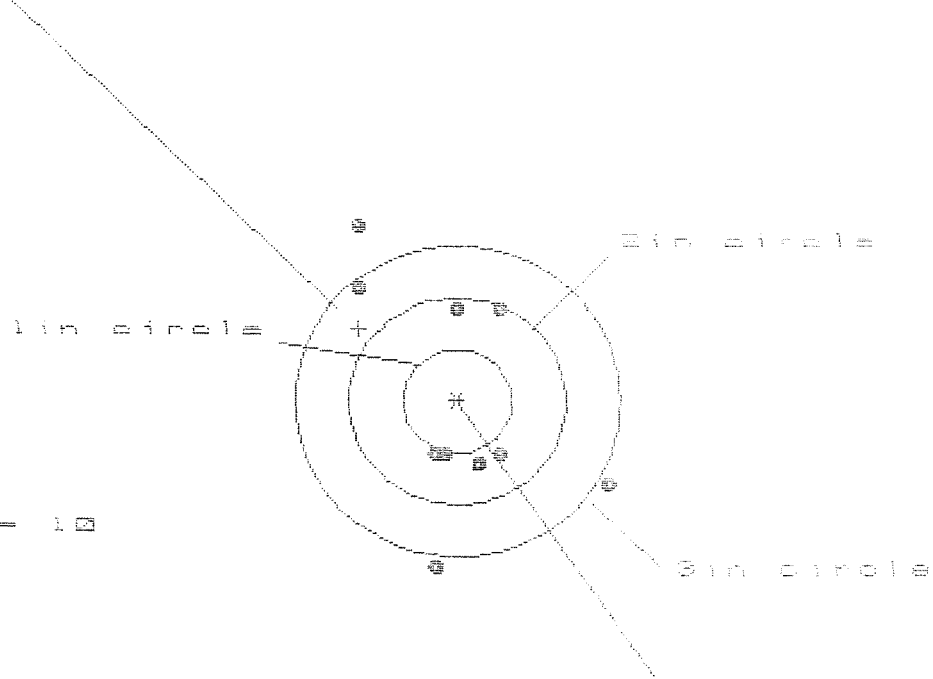
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.052	1.799	1.681
MINIMUM X	:	-2.271	-1.060	-1.177
MAXIMUM Y	:	2.097	2.130	1.583
MINIMUM Y	:	-1.703	-1.670	-1.404
CENTROID X	:	.429	.682	.799
CENTROID Y	:	.267	.234	-.032
FOR TO CENTROID in.	:	.505	.721	.800
MIN RADIUS	:	.547	.584	.547
MEAN RADIUS	:	1.637	1.544	1.434
MAX RADIUS	:	2.298	2.329	1.955
HORIZONTAL SPREAD	:	4.323	2.859	2.859
VERTICAL SPREAD	:	3.800	3.800	2.987
EXTREME SPREAD	:	4.331	4.258	3.600
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		3	

5 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8225490

CENTERFIRE PATTERNS # 3

POB



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 7

HS= 2.299

VS= 3.330

GS= 3.419

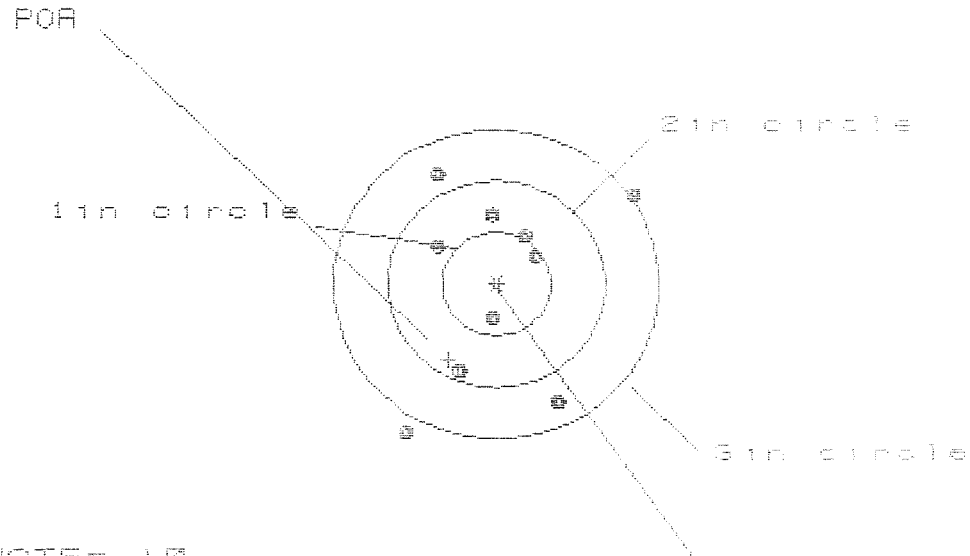
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.384	1.283	1.241
MINIMUM X	:	-1.915	-1.995	-1.038
MAXIMUM Y	:	1.721	1.331	1.154
MINIMUM Y	:	-1.609	-1.418	-1.795
CENTROID X	:	.908	1.009	1.051
CENTROID Y	:	-.697	-.888	-.711
POB TO CENTROID in.	:	1.144	1.345	1.209
MIN RADIUS	:	.546	.368	.541
MEAN RADIUS	:	1.078	.927	.891
MAX RADIUS	:	1.949	1.663	1.552
HORIZONTAL SPREAD	:	2.299	2.279	2.279
VERTICAL SPREAD	:	3.330	2.749	1.949
EXTREME SPREAD	:	3.419	2.999	2.999
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225490

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 2.081

VS = 2.511

GS = 3.083

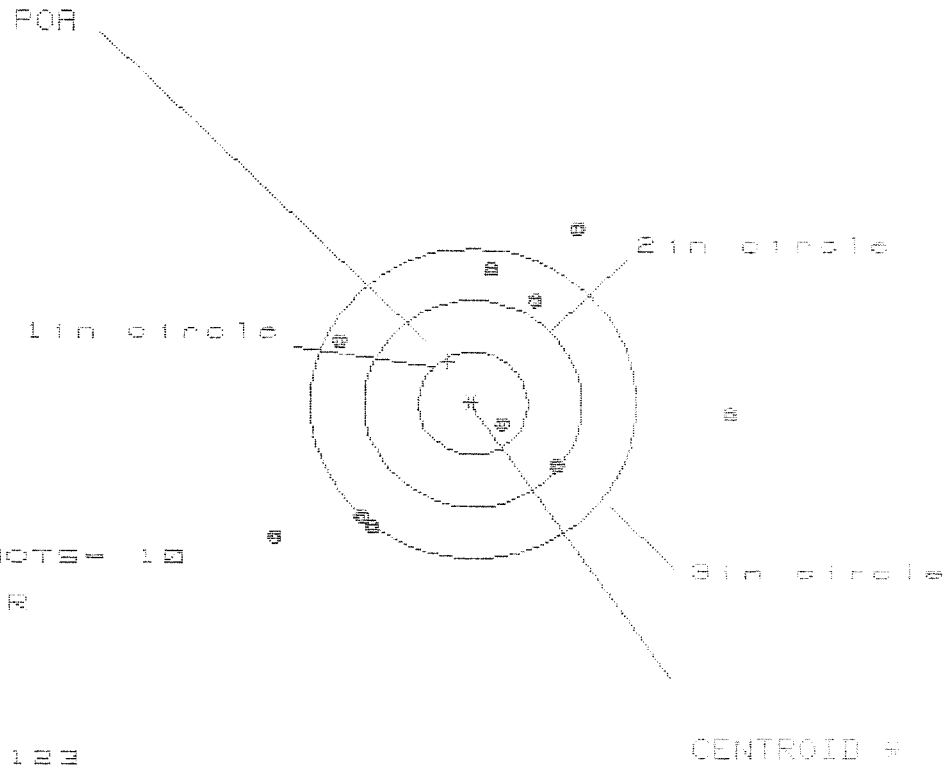
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.238	1.144	.576
MINIMUM X	-.843	-.668	-.525
MAXIMUM Y	1.093	.935	1.023
MINIMUM Y	-1.418	-1.253	-1.165
CENTROID X	.438	.532	.389
CENTROID Y	.735	.893	.885
POR TO CENTROID in.	.856	1.039	.894
MIN RADIUS	.323	.257	.396
MEAN RADIUS	.918	.807	.746
MAX RADIUS	1.650	1.341	1.380
HORIZONTAL SPREAD	2.081	1.812	1.101
VERTICAL SPREAD	2.511	2.188	2.188
EXTREME SPREAD	3.083	2.438	2.438
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

9 Nov 1988

FILE:/PATTERNING/CENTERFIRE_PATT/08225490

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 1

2in = 1

3in = 5

HS = 4.123

VS = 3.025

GS = 4.291

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.338	1.232	1.041
MINIMUM X	:	-1.785	-1.525	-1.194
MAXIMUM Y	:	1.722	1.709	1.544
MINIMUM Y	:	-1.303	-1.316	-1.351
CENTROID X	:	.232	-.028	.163
CENTROID Y	:	-.403	-.390	-.226
POR TO CENTROID in.	:	.465	.391	.278
MIN RADIUS	:	.344	.577	.517
MEAN RADIUS	:	1.466	1.373	1.266
MAX RADIUS	:	2.341	2.107	1.862
HORIZONTAL SPREAD	:	4.123	2.757	2.295
VERTICAL SPREAD	:	3.025	3.025	2.895
EXTREME SPREAD	:	4.291	4.093	3.475
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		5	

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225490
14 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0458
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2926
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .296163

THE AMR FOR THIS RIFLE IS: 1.088

CENTROIDAL DISTANCES

0 TO	1	.643653
1 TO	2	.567651
1 TO	3	.654753
1 TO	4	.535844
1 TO	5	.389647

1
5 4
2 +3 <----POA

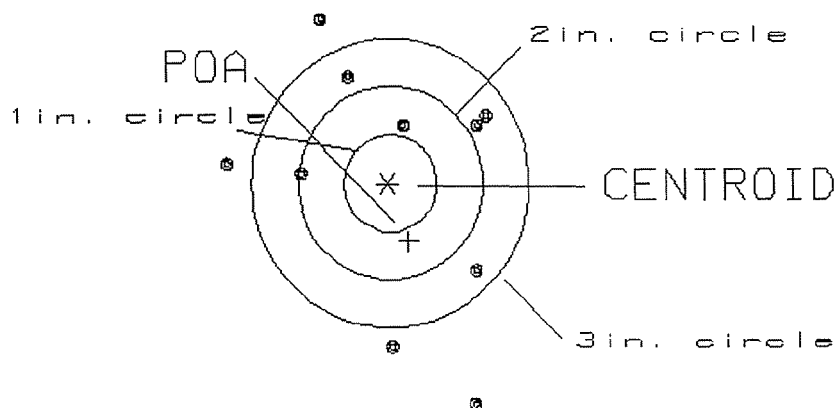
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .643
 MIN RADIUS : .630
 MEAN RADIUS : 1.422
 MAX RADIUS : 2.487
 CENTROID X : -.233
 CENTROID Y : .600

14 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225490

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.78
 VS= 4.02
 GS= 4.34

0
 2
 6

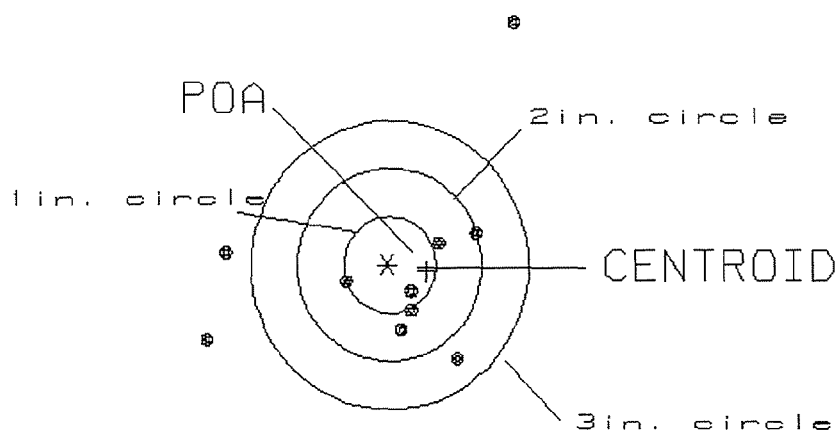
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .436
 MIN RADIUS : .354
 MEAN RADIUS : 1.140
 MAX RADIUS : 2.829
 CENTROID X : -.431
 CENTROID Y : .068

14 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225490

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.32
 VS= 3.42
 GS= 4.63

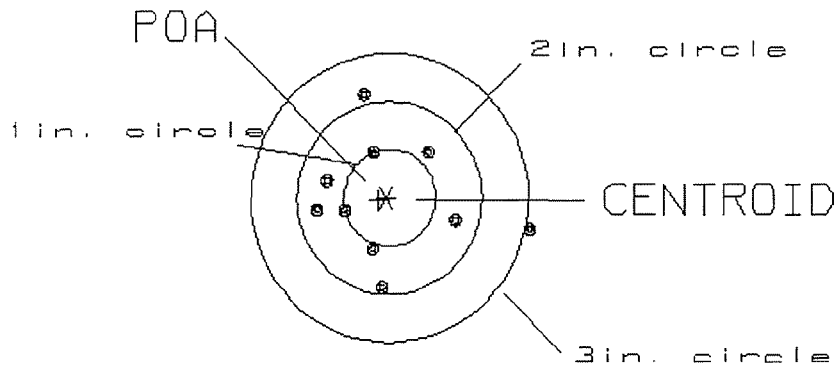
3
 6
 7

PATTERN #: ☐ 3 ☐
 POA TO CENTROID: .086
 MIN RADIUS : .471
 MEAN RADIUS : .806
 MAX RADIUS : 1.571
 CENTROID X : .082
 CENTROID Y : .026

14 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225490

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.33

2

VS= 2.01

6

GS= 2.34

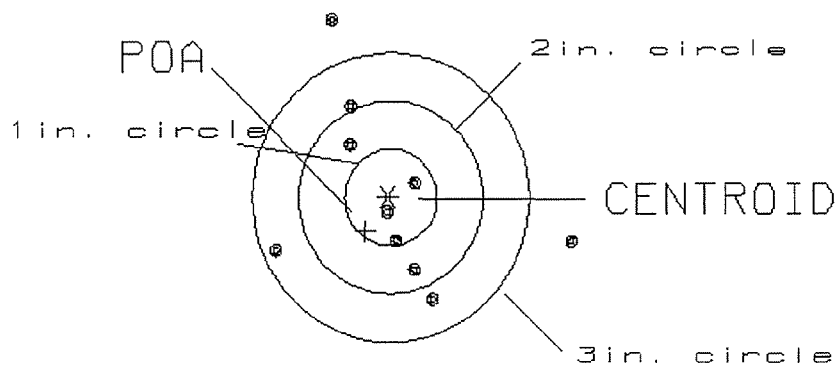
9

PATTERN #: 4
 POA TO CENTROID: .427
 MIN RADIUS : .213
 MEAN RADIUS : 1.003
 MAX RADIUS : 1.979
 CENTROID X : .242
 CENTROID Y : .352

14 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225490

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.15

2

VS= 2.90

5

GS= 3.49

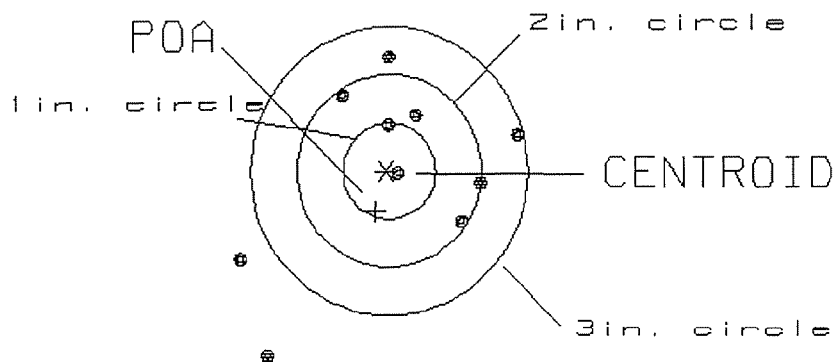
8

PATTERN #: ☐ 5 ☐
 POA TO CENTROID: .431
 MIN RADIUS : .071
 MEAN RADIUS : 1.070
 MAX RADIUS : 2.304
 CENTROID X : .111
 CENTROID Y : .417

14 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225490

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.93

2

VS= 3.03

6

GS= 3.53

8

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER 22080			
SERIAL NUMBER C-6225490			
LOG-IN DATE 1-31-01			
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	2-2-01	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	2-12-01	CK
605	CHECK HEADSPACE	2-12-01	CK
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET	3-12-01	CK
655	FINAL INSPECT	3-15-01	CK
660	PACK		
		SHIP DATE	
QAR INSPECTION DATE			

Final Inspection

Sni C-6225490

DATE REC'D: 1-31-81

DATE RET'D:

AUDITOR: CK

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: