C6225492

MODEL 700™ M24

Model 700 M24™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.

Remington

M2400061936

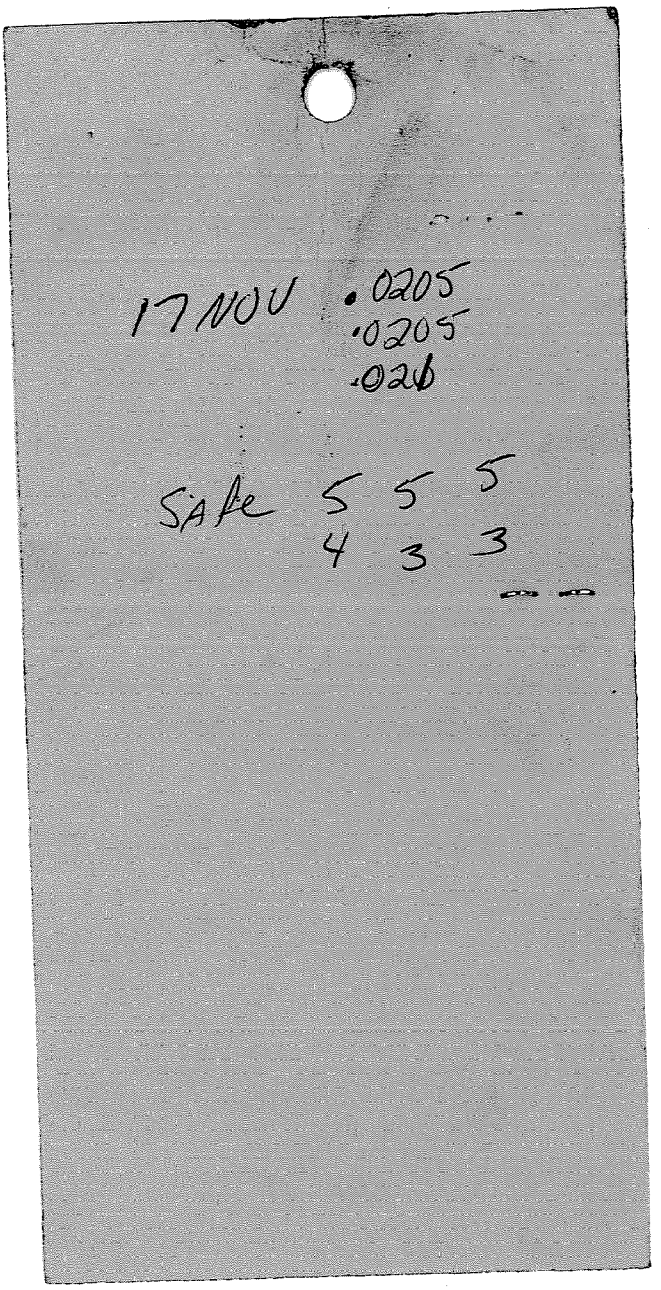
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225492

OPERATION #	OPERATION NAME	DATE	INT
575-580	ASSEMBLY 2 26		FB
600	PROOF 2 29		RW
615	MAGNAFLUX BARREL	5/13/88	pfl.
	MAGNAFLUX BOLT	5/13/88	pfl.
620	COATING	8/11/88	TJA
625-630	FINAL ASSEMBLY		
635	TEST		
640	TARGET		
	FIRING PIN INDENT		
660	PACK		


17 NOV .0205
.0205
.026
SAFE 5 5 5
4 3 3

66 Scope #

M-24

1286

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6225492

OP.#	OP. NAME	READINGS	DATE	INITIAI
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		10/31/88	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/31/88	RW
	C) Inspect Ejector Hole for Chamfer		10/31/88	RW

OVER

OP.#		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min. Setting and Stake			
	F) Safety on Force	5 | 5 | 5	16 Nov 88	GS
	G) Safety off Force	4 | 3 | 3	16 Nov 88	GS
	H) Trigger Pull Test & Retainabilty		16 Nov 88	GS
	I) Firing Pin Indent	.0205 | .0205 | .021	16 Nov 88	GS
	J) Assemble Stock		11/21/88	WB
	K) Assemble Swivel Studs		5 Dec 88	GS
	L) Attach Front & Rear Sight Assemblies		11/30/88	WB
	M) Iron Sight Alignment		11/30/88	WB
	N) Detach Front & Rear Sights & place in numbered container		11/30/88	WB
	0) Attach Scope to Rifle		11/29/88	WB
	P) Detach & Attach Scope 20 times		11/29/88	WB
640	Gallery Target & Test		12/1/88	DH
	A) Optical Clearity of Scope		12/1/88	DH
645	Inspect for Live Ammo		12/1/88	DH
655	Final Inspection A) Headspace		5 Dec 88	GS
	B) Trigger Pull		5 Dec 88	GS
	C) Function		5 Dec 88	GS
660	Pack		14 Dec 88	GS

SWS TRIGGER PULL TEST

66

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

SERIAL NO. C6225497

DATE 16 NOV 88

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.25	239	2.42	MIN. SETTING,
PULL #2	2.22	2.23	2.39	2.41	NO AVG. OF 5
PULL #3	2.20	2.25	2.40	2.41	READINGS ACCEPT-
PULL #4	2.20	2.23	2.37	2.46	ABLE LESS THAN 2#
PULL #5	2.18	2.25	2.40	2.46	
TOTAL	11.07	11.21	11.95	12.16	
AVG.	2.214	2.242	2.39	2.432	

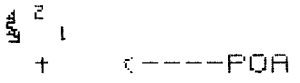
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.10		
PULL #2	3.16	3.20		
PULL #3	3.15	3.18		
PULL #4	3.12	3.13		
PULL #5	3.14	3.17		
TOTAL	15.74	15.78		
AVG.	3.148	3.156		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.15	4.22		4.19
PULL #2	4.16	4.15		4.13
PULL #3	4.14	4.14		4.15
PULL #4	4.11	4.22		4.14
PULL #5	4.13	4.15		4.13
TOTAL	20.69	20.88		20.74
AVG.	4.138	4.176		4.148

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225492

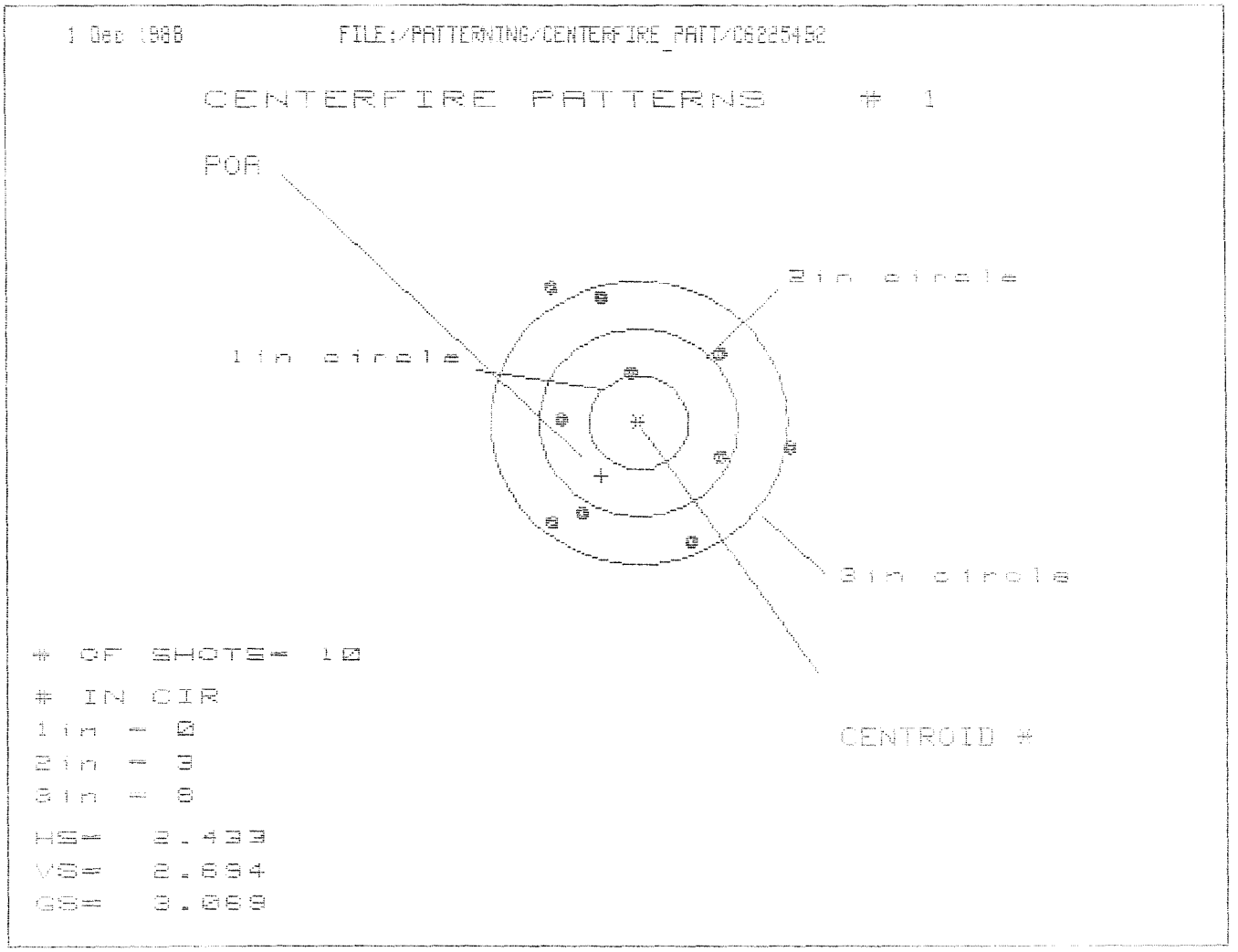
CENTROIDAL DISTANCES

0	TO	1	.6809
1	TO	2	.608823
1	TO	3	.882655
1	TO	4	.982846
1	TO	5	.96421



THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .7256
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .770911

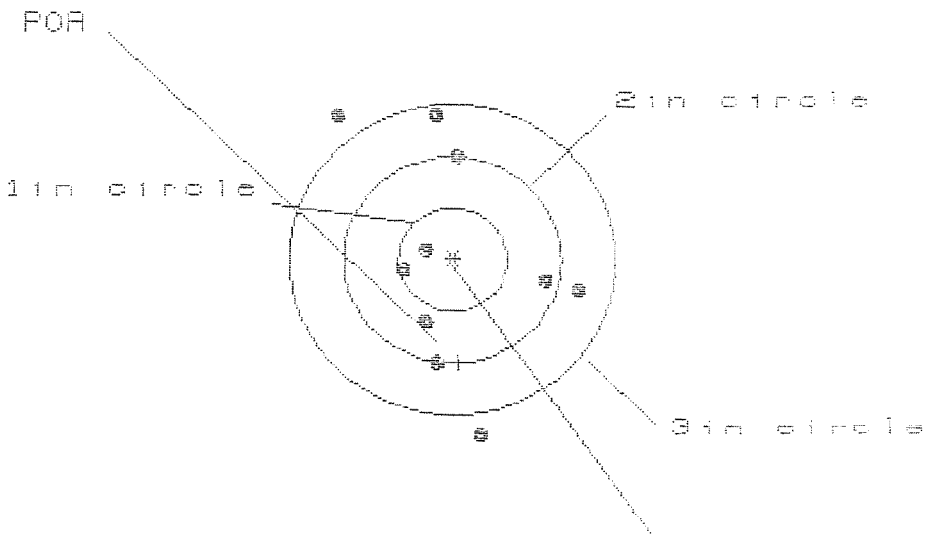
THE AMR FOR THIS RIFLE IS: .9868



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.528	1.428	.917
MINIMUM X	:	-.905	-1.005	-.827
MAXIMUM Y	:	1.427	1.460	1.440
MINIMUM Y	:	-1.267	-1.108	-1.128
CENTROID X	:	.380	.480	.302
CENTROID Y	:	.565	.406	.426
POA TO CENTROID in.	:	.681	.629	.522
MIN RADIUS	:	.521	.701	.649
MEAN RADIUS	:	1.178	1.116	1.061
MAX RADIUS	:	1.689	1.550	1.480
HORIZONTAL SPREAD	:	2.433	2.433	1.744
VERTICAL SPREAD	:	2.694	2.568	2.568
EXTREME SPREAD	:	3.069	2.751	2.751
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Dec 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C6223492

CENTERFIRE PATTERNS # 2



\# OF SHOTS= 10

\# IN CIR

1in = 3

2in = 4

3in = 8

HS= 2.328

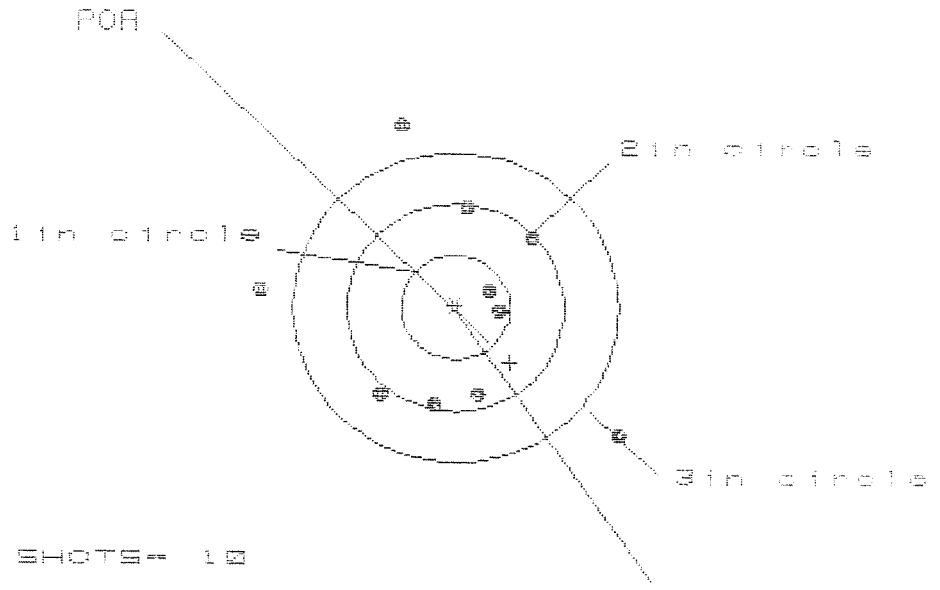
VS= 3.102

GS= 3.336

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.159	1.041	1.053
MINIMUM X	:	-1.069	-.584	-.572
MAXIMUM Y	:	1.387	1.538	1.343
MINIMUM Y	:	-1.715	-1.564	-1.050
CENTROID X	:	-.049	.069	.057
CENTROID Y	:	.997	.846	1.041
POA TO CENTROID in.	:	.999	.849	1.043
MIN RADIUS	:	.254	.428	.348
MEAN RADIUS	:	1.028	.946	.865
MAX RADIUS	:	1.732	1.567	1.362
HORIZONTAL SPREAD	:	2.228	1.625	1.625
VERTICAL SPREAD	:	3.102	3.102	2.393
EXTREME SPREAD	:	3.336	3.120	2.393
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Dec 1988 FILE:/PATTERNING/CENTERFIRE_PATT/C8225492

CENTERFIRE PATTERNS # 3

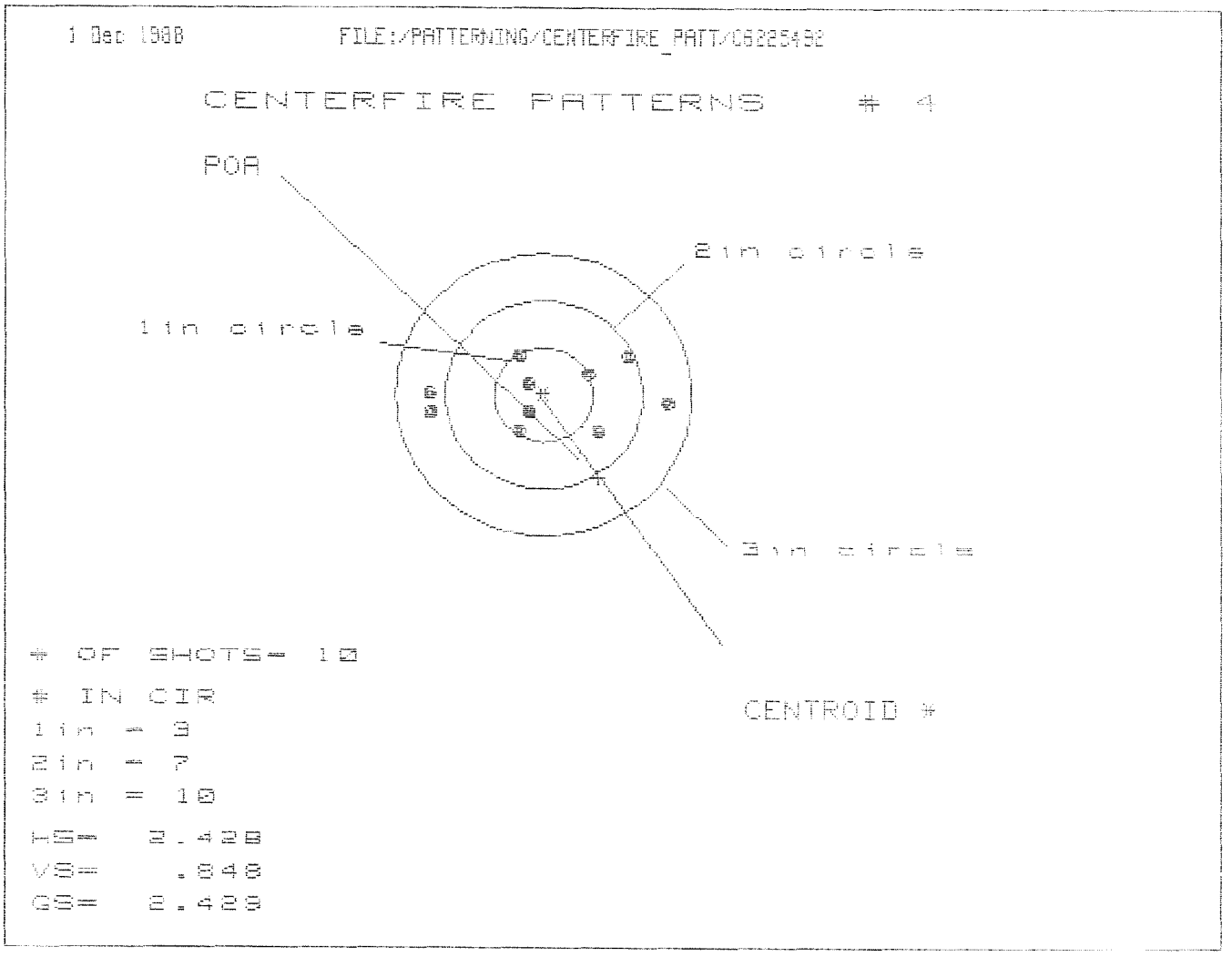


OF SHOTS= 10

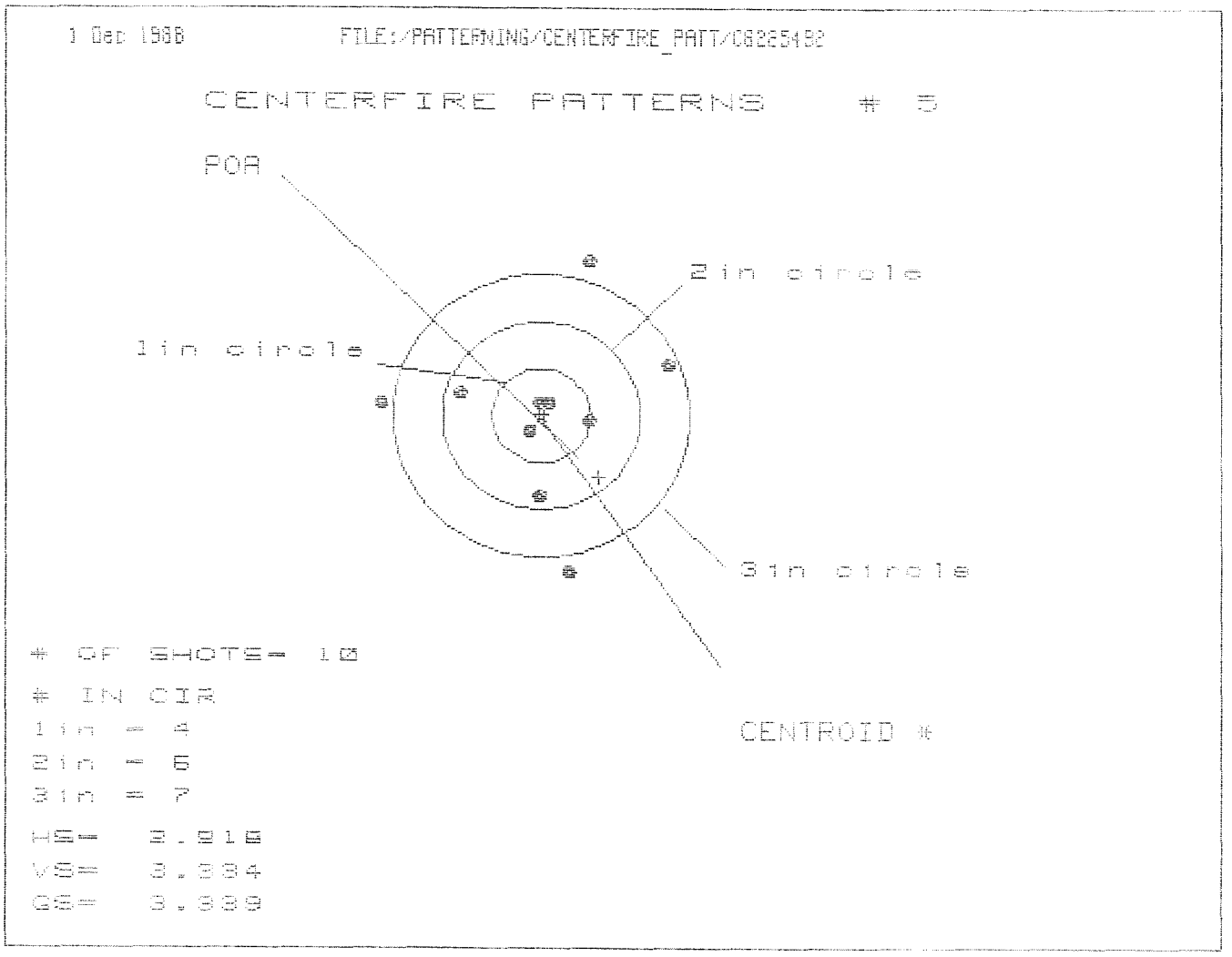
# IN CIR
1in = 3
2in = 5
3in = 7

HS= 3.265
VS= 2.966
GS= 3.611

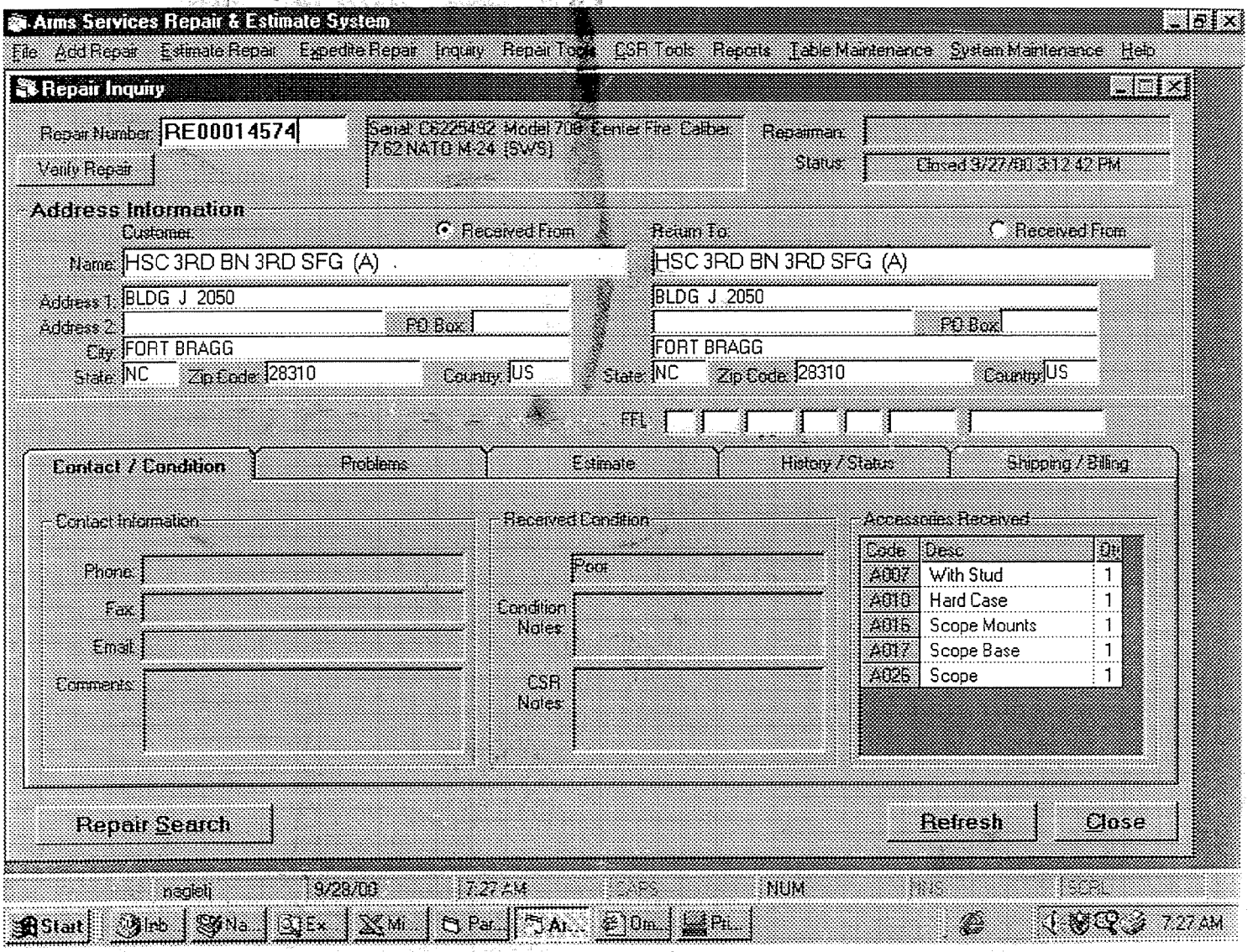
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.517	.839	.792
MINIMUM X	:	-1.748	-1.579	-1.626
MAXIMUM Y	:	1.769	1.636	1.076
MINIMUM Y	:	-1.197	-1.072	-.868
CENTROID X	:	-.502	-.671	-.624
CENTROID Y	:	.531	.664	.460
POA TO CENTROID in.	:	.731	.944	.775
MIN RADIUS	:	.371	.498	.489
MEAN RADIUS	:	1.108	1.041	.927
MAX RADIUS	:	1.933	1.678	1.645
HORIZONTAL SPREAD	:	3.265	2.418	2.418
VERTICAL SPREAD	:	2.966	2.708	1.944
EXTREME SPREAD	:	3.611	2.730	2.471
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	[redacted]		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.292	.985	.861
MINIMUM X	:	-1.136	-.993	-1.087
MAXIMUM Y	:	.432	.420	.394
MINIMUM Y	:	-.416	-.428	-.454
CENTROID X	:	-.551	-.694	-.570
CENTROID Y	:	.880	.892	.910
POA TO CENTROID in.	:	1.038	1.131	1.081
MIN RADIUS	:	.209	.130	.195
MEAN RADIUS	:	.708	.625	.577
MAX RADIUS	:	1.297	1.066	1.087
HORIZONTAL SPREAD	:	2.428	1.970	1.940
VERTICAL SPREAD	:	.848	.848	.848
EXTREME SPREAD	:	2.429	2.071	1.982
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.310	1.389	1.399
MINIMUM X	:	-1.608	-1.579	-1.519
MAXIMUM Y	:	1.638	1.450	.494
MINIMUM Y	:	-1.696	-1.079	-.098
CENTROID X	:	-.580	-.609	-.669
CENTROID Y	:	.655	.843	.662
POA TO CENTROID in.	:	.875	1.040	.941
MIN RADIUS	:	.139	.070	.170
MEAN RADIUS	:	.912	.824	.719
MAX RADIUS	:	1.716	1.579	1.528
HORIZONTAL SPREAD	:	2.918	2.918	2.918
VERTICAL SPREAD	:	3.384	2.529	1.392
EXTREME SPREAD	:	3.389	2.937	2.937
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	



Serial Number: C6225492

Model: 700

RE00014574

BBL 96003
BOLT 96005

Final Inspection

S/N: C6225492	DATE REC'D: 9-26-00	DATE RET'D:

AUDITOR: RW

Item:

Barrel Assy.
- ✓ Barrel
- ✓ Receiver
- ✓ Front Sight Block
- ✓ Rear Sight Block
- ✓ Screws
- ✓ Finish

Item:

Stock Assy.
- ✓ Stock
- ✓ Sling Swivel Studs
- ✓ Adjustable Butt Plate
- ✓ Lock Nuts
- ✓ Barrel Clearance
- ✓ Color/Finish

Scope Assy.
- ✓ Scope
- ✓ Scope Rings
- ✓ Mounting Screws
- ✓ Mounting Base
- ✓ Screws
- ✓ Finish
- ✓ Looseness
- ✓ Clarity

Systems Case
- ___ Scope Case
- ___ Iron Sights
- ___ Depoyment Kit

Trigger
- ✓ Safety Operation
- ✓ Set
- ___

Comments: _____

Misc.
- ___ DD-250
- ___ Bar Code
- ___ Packaging

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

R & E NUMBER	14574
SERIAL NUMBER	C6225492
LOG-IN DATE	9-26-00

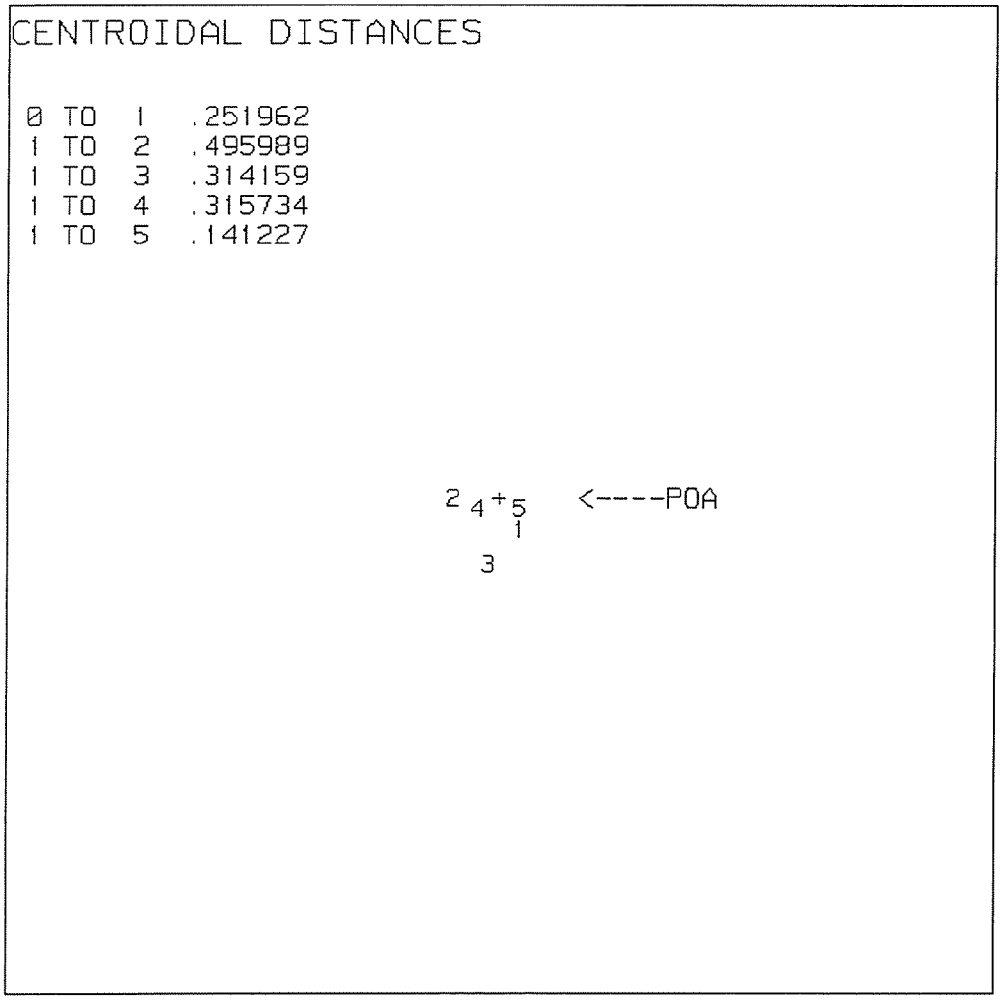
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-28-00	CK
560 A	RE-BARREL AT CUSTOM SHOP		
B	DRILL AND TAP		
C	POLISH		
575	ASSEMBLE		
600	PROOF	10-3-00	RW
605	CHECK HEADSPACE	10-3-00	CK
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
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	10-17-00	RW
655	FINAL INSPECT	10-25-00	CK
660	PACK		
		SHIP DATE	
	QAR INSPECTION DATE		

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6225492
25 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.057
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.16
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .16985

THE AMR FOR THIS RIFLE IS: 1.155



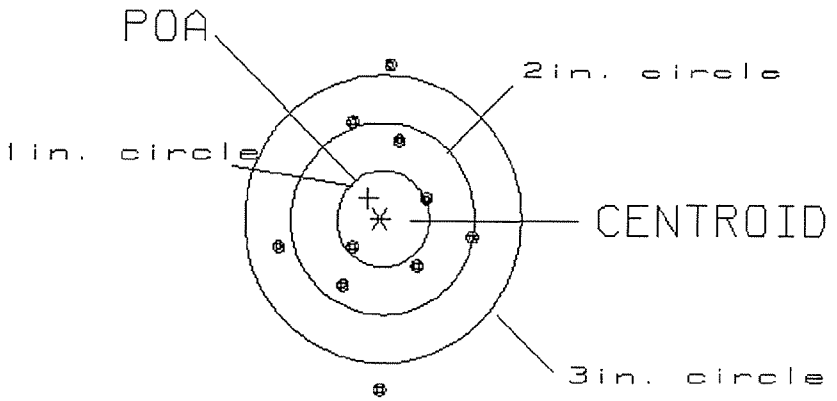
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 1 □

POA TO CENTROID:		.252
MIN RADIUS	:	.372
MEAN RADIUS	:	.972
MAX RADIUS	:	1.739
CENTROID X	:	.133
CENTROID Y	:	-.214

25 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 1



# OF SHOTS= 10	# IN CIRCLE
HS= 2.13	1
VS= 3.35	5
GS= 3.35	8

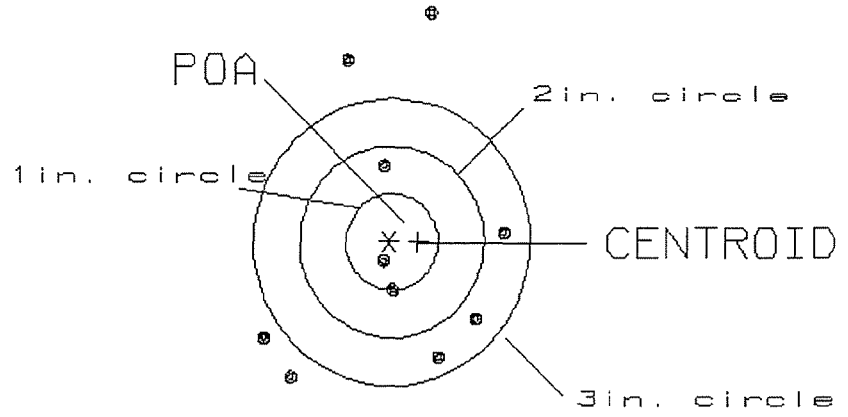
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 2 □

POA TO CENTROID:		.313
MIN RADIUS	:	.224
MEAN RADIUS	:	1.307
MAX RADIUS	:	2.403
CENTROID X	:	-.313
CENTROID Y	:	.003

25 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 2



# OF SHOTS= 10	# IN CIRCLE
HS= 2.66	1
VS= 3.72	3
GS= 4.01	6

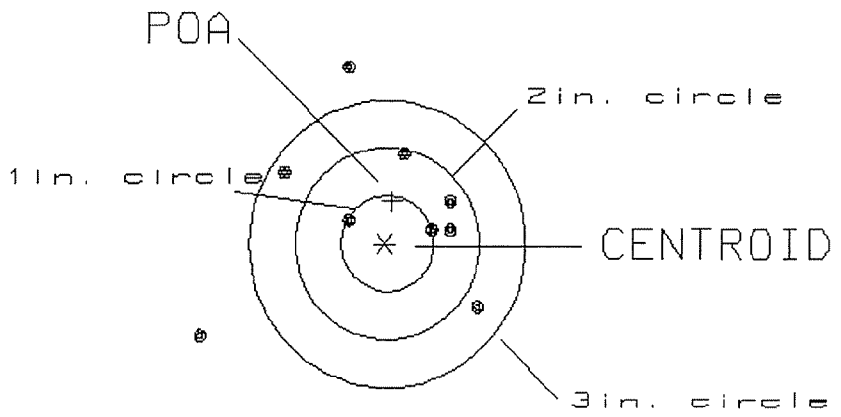
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 3 □

POA TO CENTROID:		.451
MIN RADIUS	:	.443
MEAN RADIUS	:	1.293
MAX RADIUS	:	2.902
CENTROID X	:	-.081
CENTROID Y	:	-.444

25 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 3



# OF SHOTS= 10		# IN CIRCLE
HS=	3.00	2
VS=	4.64	5
GS=	4.82	7

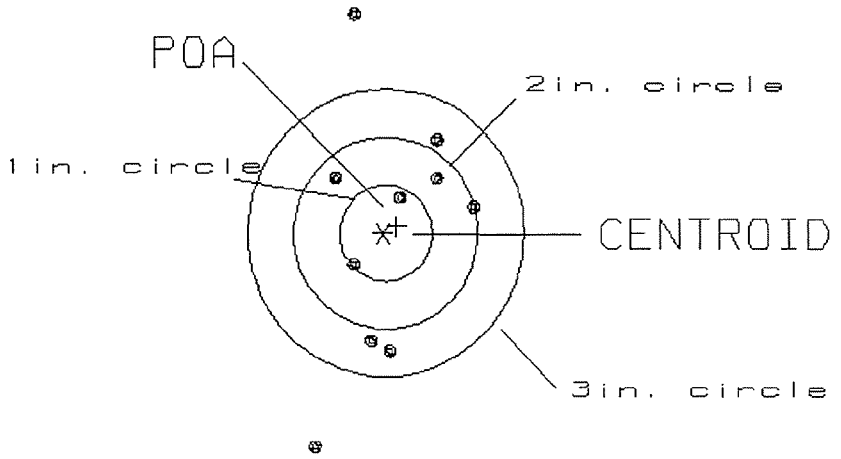
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 4 ☐

POA TO CENTROID:		.165
MIN RADIUS	:	.373
MEAN RADIUS	:	1.144
MAX RADIUS	:	2.393
CENTROID X	:	-.149
CENTROID Y	:	-.072

25 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 4



# OF SHOTS= 10	# IN CIRCLE
HS= 1.69	2
VS= 4.51	5
GS= 4.53	8

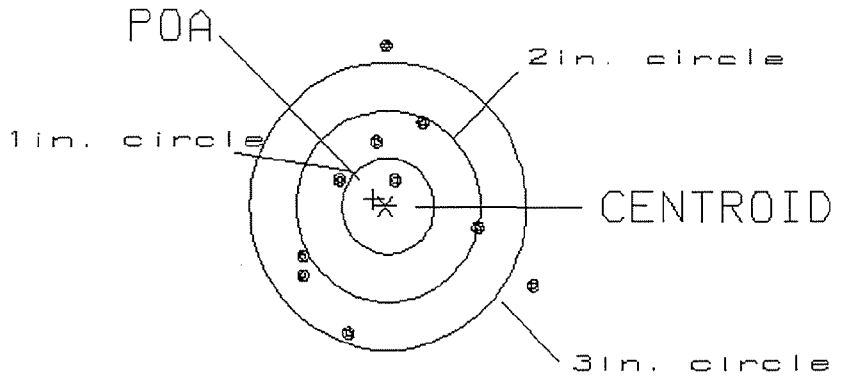
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 5 □

POA TO CENTROID:		.145
MIN RADIUS	:	.306
MEAN RADIUS	:	1.061
MAX RADIUS	:	1.757
CENTROID X	:	.125
CENTROID Y	:	-.073

25 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492.1

CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 2.48	1
VS= 2.99	5
GS= 3.02	8

Remington Test Lab, Ilion, N.Y.

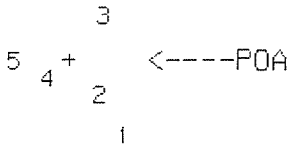
Centroidal distance calculations for Rifle # c6225492
23 Oct 2000

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .05
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1156
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .12595

THE AMR FOR THIS RIFLE IS: 1.379

CENTROIDAL DISTANCES

0	TO	1	.619137
1	TO	2	.313158
1	TO	3	.810711
1	TO	4	.633834
1	TO	5	.890021



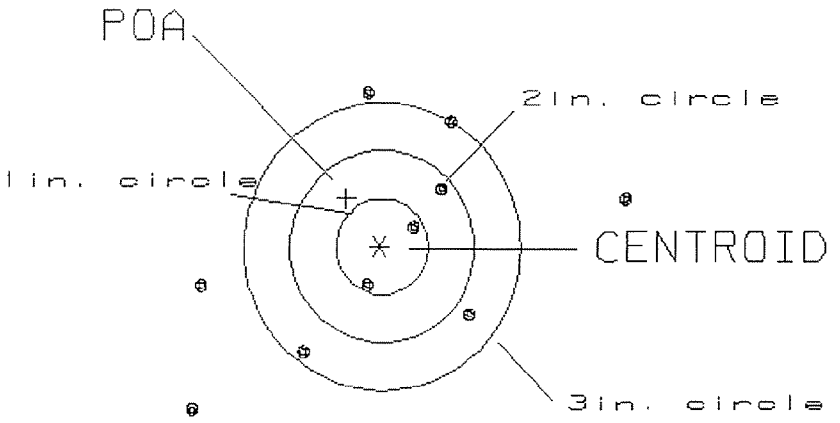
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 1 □

POA TO CENTROID:		.619
MIN RADIUS	:	.394
MEAN RADIUS	:	1.462
MAX RADIUS	:	2.646
CENTROID X	:	.361
CENTROID Y	:	-.503

23 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 1



# OF SHOTS= 10	# IN CIRCLE
HS= 4.62	2
VS= 3.30	3
GS= 5.12	6

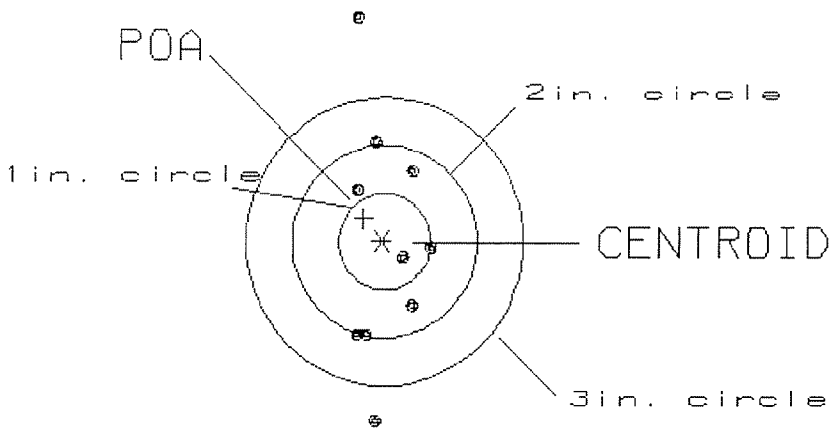
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 2

POA TO CENTROID:		.308
MIN RADIUS	:	.213
MEAN RADIUS	:	1.017
MAX RADIUS	:	2.374
CENTROID X	:	.199
CENTROID Y	:	-.235

23 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 2



# OF SHOTS= 10	# IN CIRCLE
HS= .86	1
VS= 4.23	7
GS= 4.24	8

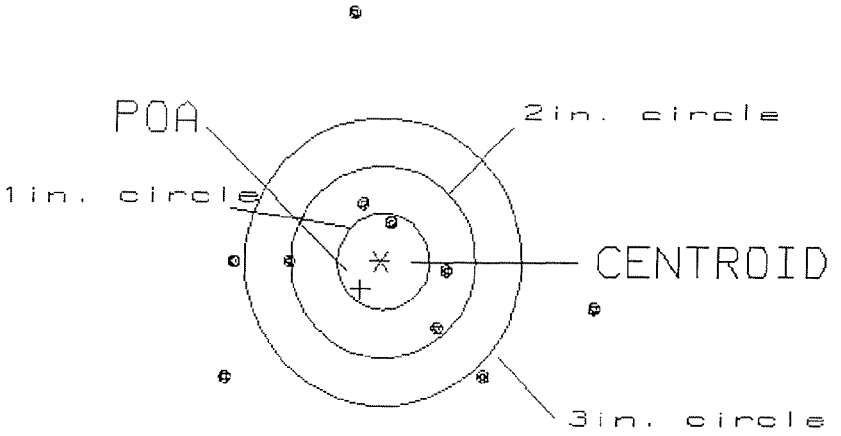
REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 3

POA TO CENTROID:		.366
MIN RADIUS	:	.431
MEAN RADIUS	:	1.401
MAX RADIUS	:	2.660
CENTROID X	:	.218
CENTROID Y	:	.295

23 Oct 2000 FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6225492

CENTERFIRE PATTERN # 3



# OF SHOTS= 10	# IN CIRCLE
HS= 3.97	1
VS= 3.87	5
GS= 4.13	5

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 4

POA TO CENTROID:	.198
MIN RADIUS :	.721
MEAN RADIUS :	1.634
MAX RADIUS :	3.138
CENTROID X :	-.150
CENTROID Y :	-.128

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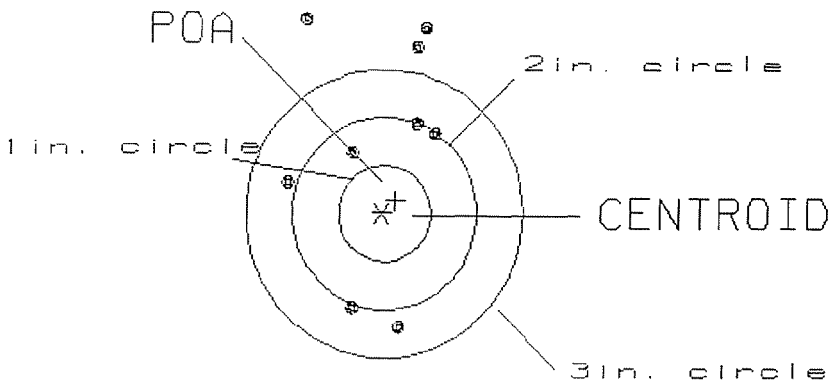
CENTERFIRE PATTERN # 4



OF SHOTS= 11 # IN CIRCLE

HS= 1.54	0
VS= 5.11	3
GS= 5.27	6

REMINGTON CENTERFIRE ACCURACY TEST REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: □ 5 □

POA TO CENTROID:		.378
MIN RADIUS	:	.506
MEAN RADIUS	:	1.382
MAX RADIUS	:	2.398
CENTROID X	:	-.378
CENTROID Y	:	-.007

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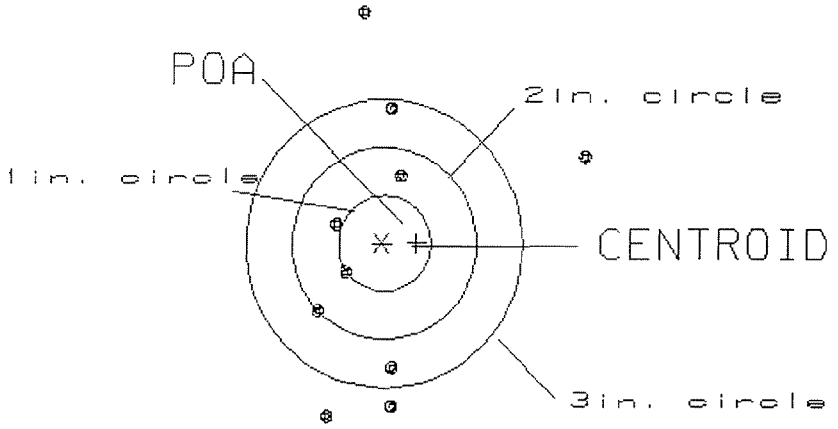
CENTERFIRE PATTERN # 5



# OF SHOTS= 10	# IN CIRCLE
HS= 2.94	0
VS= 4.14	3
GS= 4.16	6