

C6522224

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522224

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8/1/90	KS
600	Proof		8/1/90	KS
607	Check Headspace		8/1/90	KS
610	Dis-assemble Gun		8/1/90	KS
612	Magnaflux Barrel Action		8/7/90	KR
	Magnaflux Bolt		8/7/90	KR
615	Rollmark Caliber		5/7/90	GS
617	Drill and Tap Sight Holes		7/10/90	FB
618	Polish Barrel <i>P.B.</i>		7/14/90	WB
620	Apply Coatings (Barrel Action)		8/22/90	JA
	Apply Coating (Bolt)			
625	Final Assembly		8/23/90	KS
	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		9-11-90	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			8/27/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			8/27/90	WB
	H) Trigger Pull Test & Retainability						9-11-90	JH
	I) Firing Pin Indent	.023	.0225	.0275			8/27/90	WB
	J) Assemble Stock						8/27/90	KS
	K) Assemble Swivel Studs						9/12/90	Q28
	L) Attach Front and Rear Sight Assemblies						8/27/90	KS
	M) Iron Sight Alignment						8/27/90	KS
	N) Detach Front & Rear Sights & place in numbered container						8/27/90	KS
	O) Attach Scope to Rifle						8/27/90	KS
	P) Detach & Attach Scope 20 Times						8/27/90	KS
640	Gallery Target & Test						8-30-90	D/H
	A) Time						8-30-90	D/H
	B) Malfunctions						8-30-90	D/H
	C) Pierced Primers						8-30-90	D/H
	D) Optical Clarity of Scope						8-30-90	D/H
645	Inspect for Live Ammo						8-30-90	D/H
655	Final Inspection							
	A) Headspace						9/12/90	Q28
	B) Trigger Pull	2.31	2.35	2.36	2.31	2.23	9-11-90	JH
	C) Function						9/12/90	Q28
660	Pack						9/20/90	VF

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

SERIAL NO. C6522224DATE 9-11-90TESTER JFL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.27	2.31	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.45	2.24	2.35	2.11	
PULL #3	2.35	2.23	2.36	2.13	
PULL #4	2.26	2.30	2.31	2.12	
PULL #5	2.22	2.28	2.23	2.18	
TOTAL	11.79	11.32	11.56	10.81	
AVG.	2.358	2.264	2.312	2.162	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.49		
PULL #2	3.34	3.44		
PULL #3	3.38	3.50		
PULL #4	3.41	3.20		
PULL #5	3.40	3.10		
TOTAL	16.88	16.73		
AVG.	3.376	3.346		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.19		4.20
PULL #2	4.22	4.34		4.46
PULL #3	4.22	4.24		4.46
PULL #4	4.20	4.41		4.28
PULL #5	4.31	4.31		4.34
TOTAL	21.23	21.49		21.74
AVG.	4.246	4.298		4.348

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522224

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 1.917

VS= 1.800

GS= 2.230

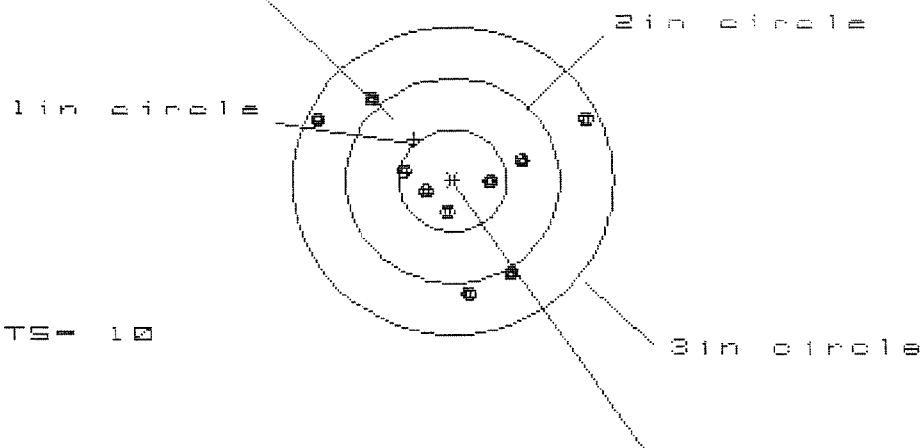
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.908	.796	.674
MINIMUM X	-1.009	-.977	-.818
MAXIMUM Y	.833	.726	.616
MINIMUM Y	-.967	-.876	-.898
CENTROID X	.273	.385	.507
CENTROID Y	-.779	-.672	-.562
POA TO CENTROID in.	.826	.774	.757
MIN RADIUS	.376	.277	.225
MEAN RADIUS	.829	.725	.611
MAX RADIUS	1.398	1.313	1.122
HORIZONTAL SPREAD	1.917	1.773	1.492
VERTICAL SPREAD	1.800	1.602	1.514
EXTREME SPREAD	2.230	1.986	1.945
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

30 Aug 1998

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 10

HS= 2.516

VS= 1.893

GS= 2.516

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.240	1.098	.622
MINIMUM X	:	-1.276	-.929	-.791
MAXIMUM Y	:	.836	.906	.989
MINIMUM Y	:	-1.057	-.987	-.904
CENTROID X	:	.358	.500	.362
CENTROID Y	:	-.398	-.468	-.551
POA TO CENTROID in.	:	.535	.685	.660
MIN RADIUS	:	.312	.221	.178
MEAN RADIUS	:	.818	.741	.652
MAX RADIUS	:	1.423	1.297	1.267
HORIZONTAL SPREAD	:	2.516	2.027	1.413
VERTICAL SPREAD	:	1.893	1.893	1.893
EXTREME SPREAD	:	2.516	2.189	2.189
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522224

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.616

VS= 2.357

GS= 2.359

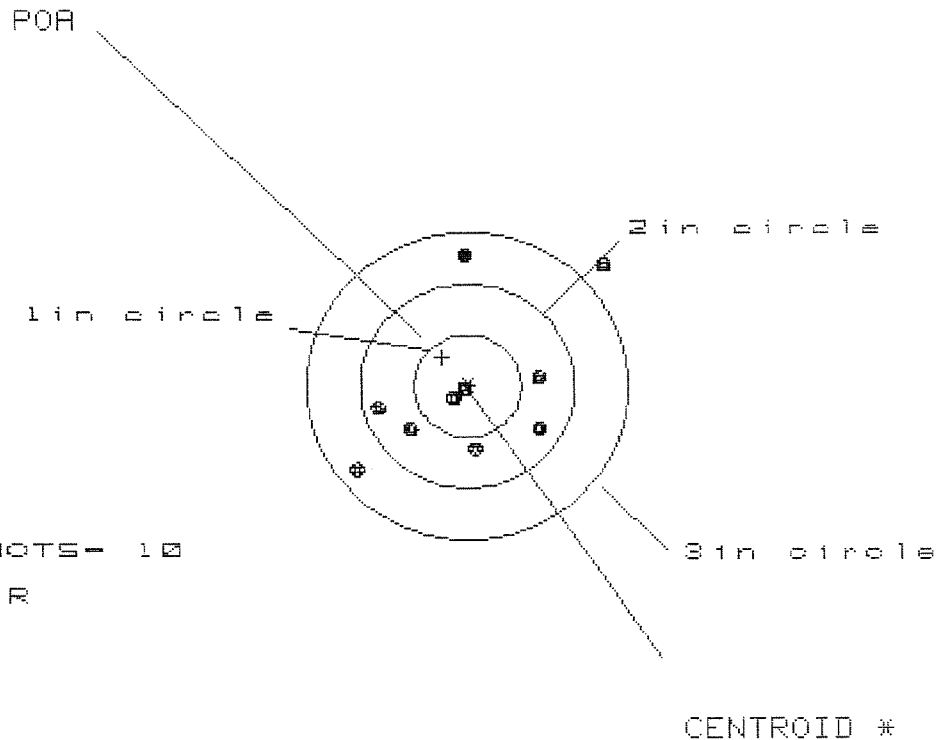
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.888
MINIMUM X	-.728
MAXIMUM Y	1.159
MINIMUM Y	-1.199
CENTROID X	.212
CENTROID Y	-1.232
POA TO CENTROID in.	1.250
MIN RADIUS	.396
MEAN RADIUS	.788
MAX RADIUS	1.319
HORIZONTAL SPREAD	1.616
VERTICAL SPREAD	2.357
EXTREME SPREAD	2.359
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06522224

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.345

VS= 2.062

ES= 3.036

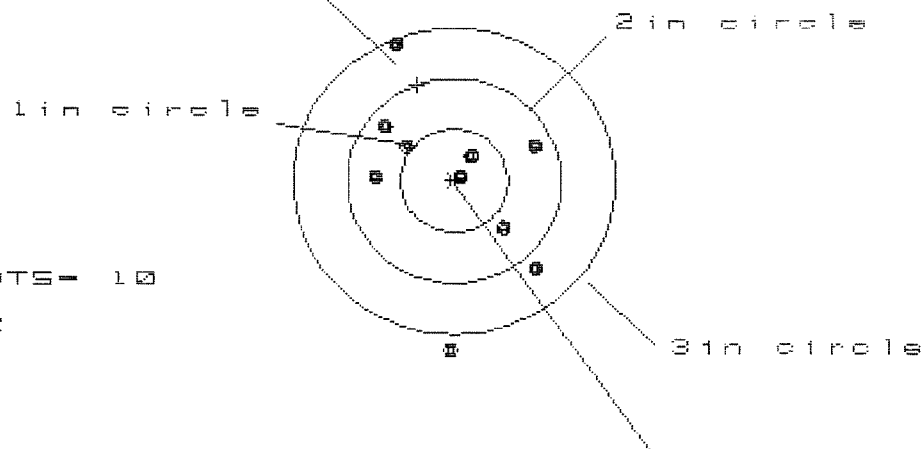
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	.812	.694
MINIMUM X	:	-1.079	-.938	-.802
MAXIMUM Y	:	1.296	1.425	1.346
MINIMUM Y	:	-.766	-.637	-.600
CENTROID X	:	.234	.093	.211
CENTROID Y	:	-.284	-.413	-.334
POA TO CENTROID in.	:	.368	.424	.395
MIN RADIUS	:	.030	.037	.033
MEAN RADIUS	:	.821	.687	.635
MAX RADIUS	:	1.718	1.433	1.346
HORIZONTAL SPREAD	:	2.345	1.750	1.496
VERTICAL SPREAD	:	2.062	2.062	1.946
EXTREME SPREAD	:	3.036	2.333	1.946
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Aug 1990

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.499

VS = 2.939

CS = 2.981

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.802	.799	.733
MINIMUM X	:	-.697	-.700	-.766
MAXIMUM Y	:	1.319	1.139	.491
MINIMUM Y	:	-1.620	-1.000	-.857
CENTROID X	:	.343	.346	.412
CENTROID Y	:	-.942	-.762	-.905
POA TO CENTROID in.	:	1.003	.837	.994
MIN RADIUS	:	.071	.184	.029
MEAN RADIUS	:	.804	.695	.613
MAX RADIUS	:	1.620	1.280	1.128
HORIZONTAL SPREAD	:	1.499	1.499	1.499
VERTICAL SPREAD	:	2.939	2.139	1.348
EXTREME SPREAD	:	2.981	2.518	1.943
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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ORDER NO. 5716

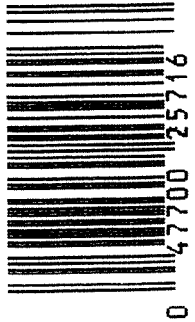
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5716 C6522224

UPC



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