

C6522259

MODEL 760TM N24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington

MOD. <u>24</u>		GA. CAL. <u>308</u>	GUN # <u>2259</u>
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	5th Rd. tight in Mag.	KS
	2nd	adjusted mag B&A	KS
	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		

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522259

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8/13/90	KS
600	Proof		8/13/90	KS
607	Check Headspace		8/13/90	KS
610	Dis-assemble Gun		8/13/90	KS
612	Magnaflux Barrel Action		8/16	KCR
	Magnaflux Bolt		8/16	KCR
615	Rollmark Caliber		8/16	GL
617	Drill and Tap Sight Holes		8/23/90	F.B
618	Polish Barrel <i>RB</i>		8/23/90	WB
620	Apply Coatings (Barrel Action)		8/31/90	TSA
	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		7/14/90	WB

op. #	BARBER - M24 0002112					DATE	INIT
	OP. NAME	READINGS					
625 cont.	F) Safety On Force	5 1/2	5 1/2	5 1/2		9/14/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2		9/14/90	WB
	H) Trigger Pull Test & Retainability					9/14/90	WB
	I) Firing Pin Indent	.0225	.022	.022		9/14/90	WB
	J) Assemble Stock					9/14/90	KA
	K) Assemble Swivel Studs					9/16/90	JB
	L) Attach Front and Rear Sight Assemblies					9/14/90	KA
	M) Iron Sight Alignment					9/14/90	KA
	N) Detach Front & Rear Sights & place in numbered container					9/14/90	KA
	O) Attach Scope to Rifle					9/14/90	KA
	P) Detach & Attach Scope 20 Times					9/14/90	KA
640	Gallery Target & Test					9/15/90	AF
	A) Time					"	AF
	B) Malfunctions					"	AF
	C) Pierced Primers					"	AF
	D) Optical Clarity of Scope					"	AF
645	Inspect for Live Ammo					9/15/90	AF
655	Final Inspection						
	A) Headspace					9/16/90	JB
	B) Trigger Pull	2.43	2.47	2.51	2.44	2.37	9-16-90
	C) Function					9/16/90	JB
660	Pack					9-19-90	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6522259DATE 9/14/90TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.45	2.34	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.34	2.39	2.42	2.47	
PULL #3	2.32	2.49	2.35	2.51	
PULL #4	2.36	2.52	2.49	2.44	
PULL #5	2.44	2.36	2.40	2.37	
TOTAL	11.87	12.21	12.00	12.22	
AVG.	2.37	2.44	2.40	2.444	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.22		
PULL #2	3.13	3.05		
PULL #3	3.27	3.14		
PULL #4	3.31	3.15		
PULL #5	3.26	3.17		
TOTAL	16.18	15.73		
AVG.	3.23	3.14		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.00	3.90		4.08
PULL #2	3.97	3.85		4.04
PULL #3	3.97	3.90		4.03
PULL #4	4.00	3.85		4.11
PULL #5	3.97	3.87		4.14
TOTAL	19.91	19.37		20.40
AVG.	3.98	3.90		4.08

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522259
15 Sep 1990

CENTROIDAL DISTANCES

0 TO	1	.195931
1 TO	2	.284754
1 TO	3	.11868
1 TO	4	.191086
1 TO	5	.310498

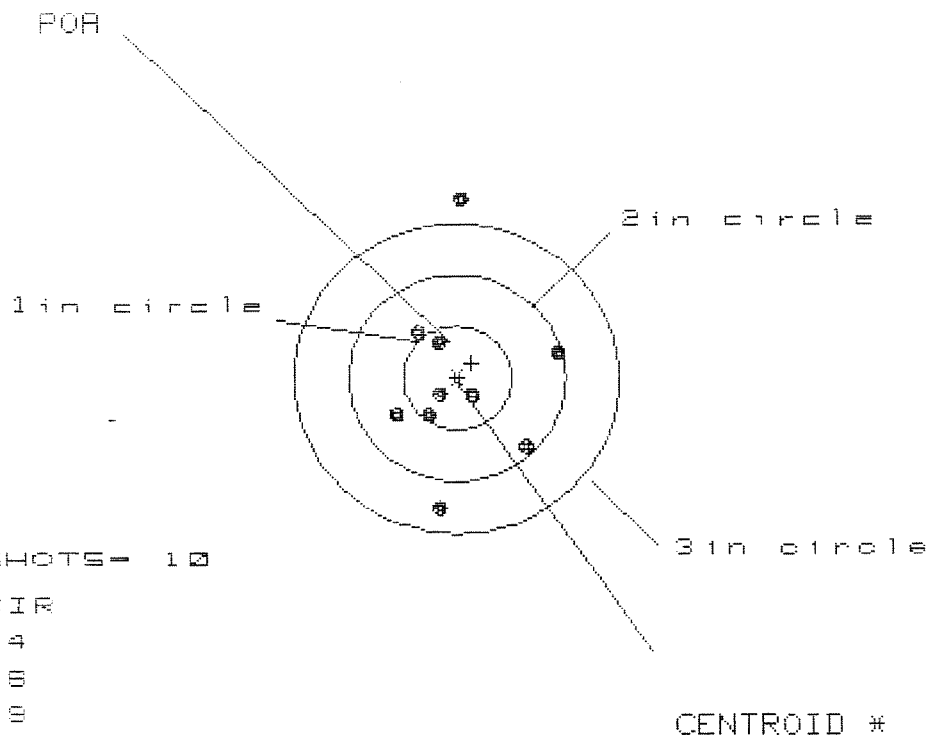
15 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.063
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0194
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0659193
THE AMR FOR THIS RIFLE IS: .8924

15 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522259

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 9

HS= 1.501

VS= 3.038

GS= 3.058

PATTERN #

1

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.927

.934

.909

MINIMUM X

-.574

-.567

-.592

MAXIMUM Y

1.783

.678

.546

MINIMUM Y

-1.255

-1.057

-.615

CENTROID X

-.135

-.142

-.117

CENTROID Y

-.142

-.340

-.208

POR TO CENTROID in.

.196

.369

.239

MIN RADIUS

.182

.112

.118

MEAN RADIUS

.745

.601

.541

MAX RADIUS

1.784

1.076

.976

HORIZONTAL SPREAD

1.501

1.501

1.501

VERTICAL SPREAD

3.038

1.735

1.161

EXTREME SPREAD

3.058

1.916

1.638

NUMBER IN ONE INCH CIRCLE =

4

NUMBER IN TWO INCH CIRCLE =

8

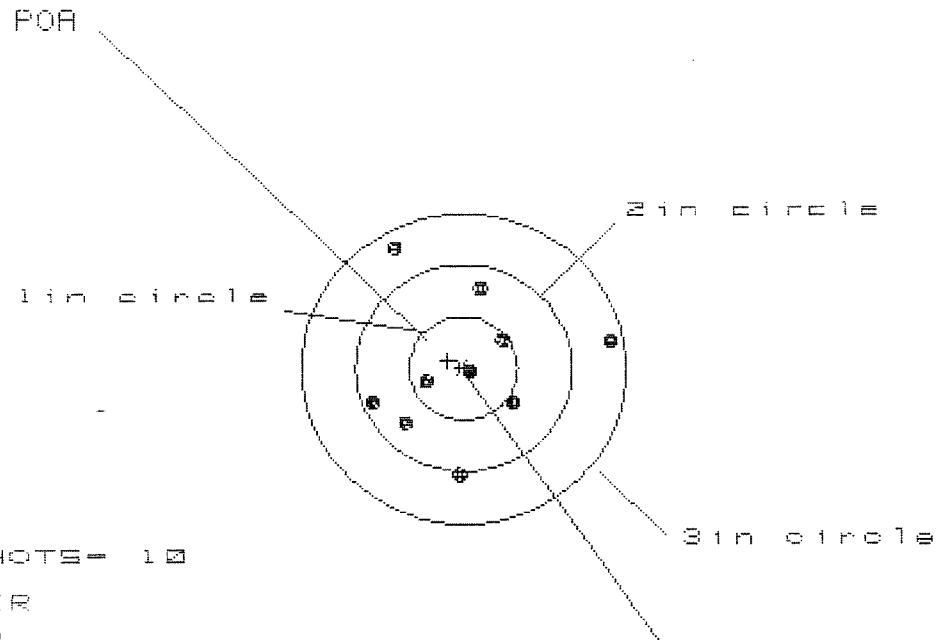
NUMBER IN THREE INCH CIRCLE =

9

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.248

VS= 2.170

GS= 2.344

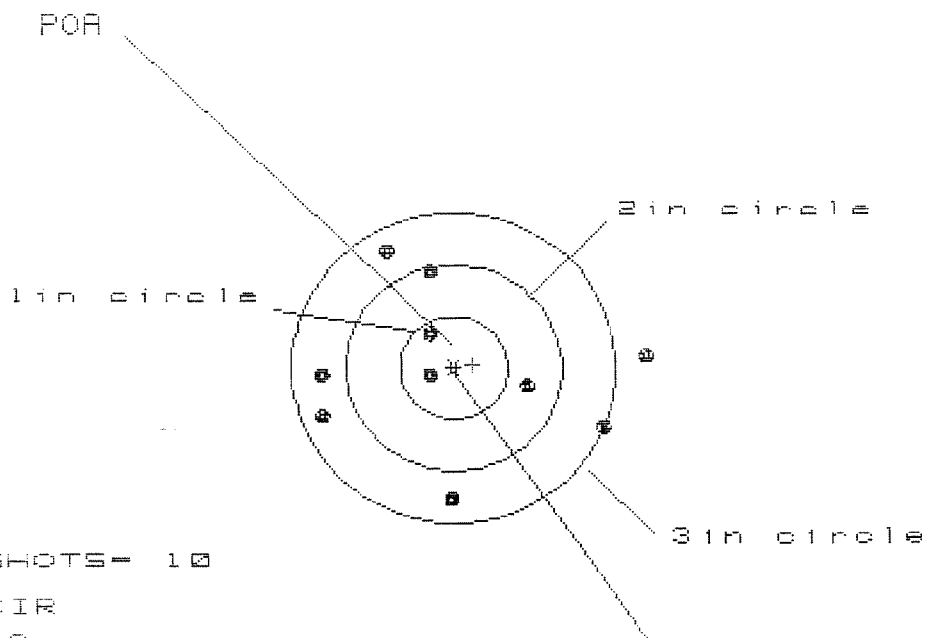
CENTROID *

PATTERN #	2	3	4
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.391	.584	.520
MINIMUM X	-.857	-.703	-.767
MAXIMUM Y	1.136	1.170	.909
MINIMUM Y	-1.034	-1.000	-.854
CENTROID X	.142	-.012	.052
CENTROID Y	-.076	-.110	-.256
POA TO CENTROID in.	.161	.110	.261
MIN RADIUS	.053	.210	.226
MEAN RADIUS	.760	.686	.596
MAX RADIUS	1.423	1.279	.956
HORIZONTAL SPREAD	2.248	1.287	1.287
VERTICAL SPREAD	2.170	2.170	1.763
EXTREME SPREAD	2.344	2.258	1.781
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 3

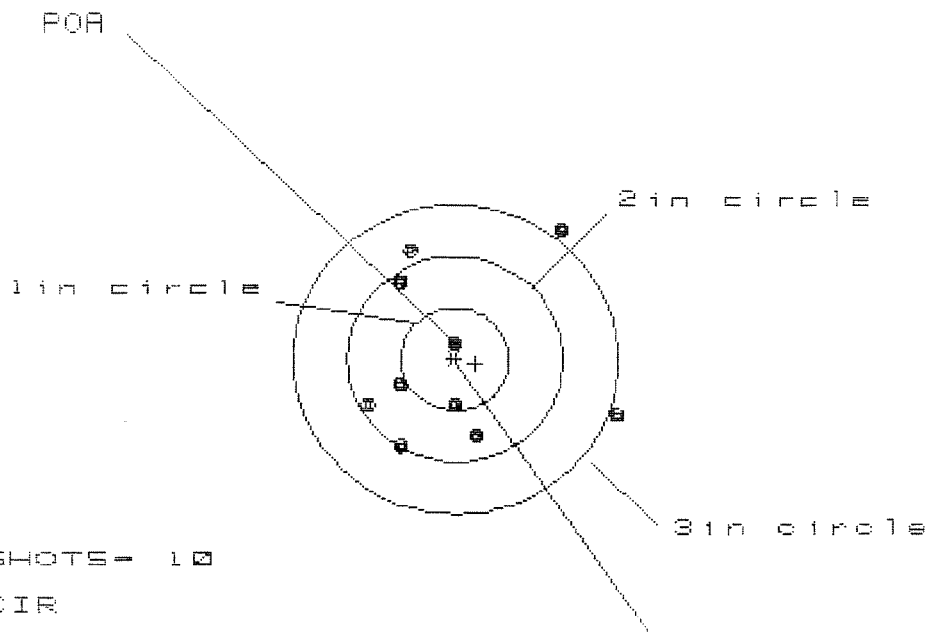


PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.768
MINIMUM X	-1.212
MAXIMUM Y	1.170
MINIMUM Y	-1.245
CENTROID X	-0.177
CENTROID Y	-0.001
POA TO CENTROID in.	0.180
MIN RADIUS	0.210
MEAN RADIUS	1.059
MAX RADIUS	1.771
HORIZONTAL SPREAD	2.979
VERTICAL SPREAD	2.415
EXTREME SPREAD	3.014
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS = 2.209

VS = 2.114

GS = 2.554

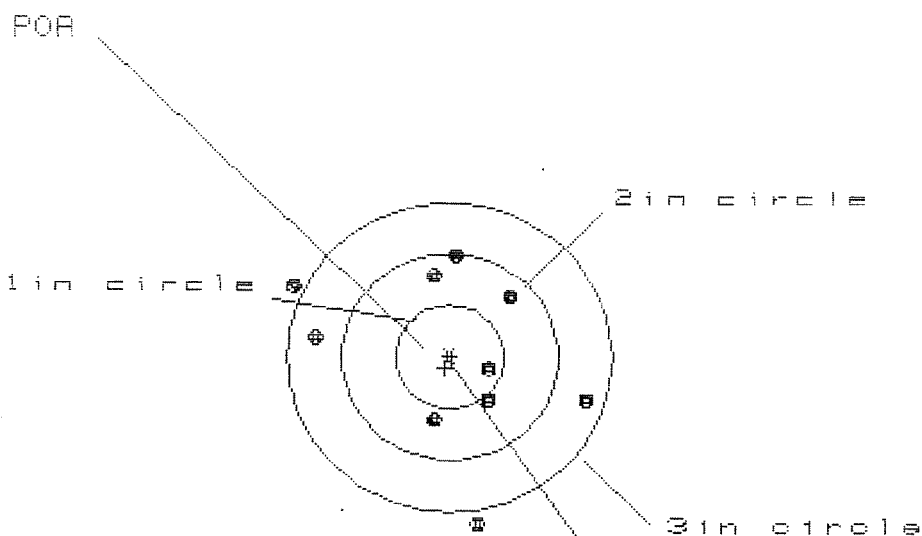
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.447	1.555	.484
MINIMUM X	-.762	-.654	-.459
MAXIMUM Y	1.232	1.212	1.167
MINIMUM Y	-.882	-.745	-.789
CENTROID X	-.190	-.298	-.492
CENTROID Y	.041	-.096	-.051
POA TO CENTROID in.	.194	.313	.495
MIN RADIUS	.168	.327	.238
MEAN RADIUS	.895	.787	.666
MAX RADIUS	1.571	1.595	1.169
HORIZONTAL SPREAD	2.209	2.209	.944
VERTICAL SPREAD	2.114	1.957	1.957
EXTREME SPREAD	2.554	2.399	1.959
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIRC

1 in = 1

2 in = 6

3 in = 8

CENTROID *

HS = 2.642

VS = 2.589

GS = 2.853

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.226	1.251	1.077
MINIMUM X	-1.422	-1.391	-1.432
MAXIMUM Y	.989	.811	.873
MINIMUM Y	-1.601	-.834	-.772
CENTROID X	.045	.014	.188
CENTROID Y	.111	.289	.227
POA TO CENTROID in.	.120	.289	.295
MIN RADIUS	.417	.530	.358
MEAN RADIUS	1.003	.928	.825
MAX RADIUS	1.625	1.477	1.437
HORIZONTAL SPREAD	2.642	2.542	2.589
VERTICAL SPREAD	2.590	1.645	1.645
EXTREME SPREAD	2.853	2.853	2.589
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

Remington  REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

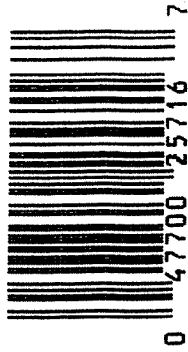
SERIAL NO. C6522259	ORDER NO. 5716
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5716 C6522259

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