

C6498751

MODEL 760TH M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.



Smith

Remington® **DUPONT**
REG. U.S. PAT. & TM. OFF.

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

MODEL 700™ M24

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

SERIAL NO.
C6498751

ORDER NO.
5716

01

5716 C6498751

UPC

0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6498751

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	5 17	90	RW
600	Proof	5 17	90	RW
607	Check Headspace	5 17	90	RW
610	Dis-assemble Gun	5 17	90	RW
612	Magnaflux Barrel Action		5/22/90	KCR
	Magnaflux Bolt		5/23/90	KCR
615	Rollmark Caliber		5/22/90	LS
617	Drill and Tap Sight Holes		5/23/90	FB
618	Polish Barrel RB		5/24/90	WB
620	Apply Coatings (Barrel Action)		6-4-90	TJH
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/12/90	RW
	C) Inspect Ejector Hole for Chamfer		6/12/90	RW
	D) Oil Firing Pin Ass'y		6/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-21-91 8/12/90	JH

BARBER - M24 0007016		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			7/25/90	94
	G) Safety Off Force	3	3	3			7/25/90	94
	H) Trigger Pull Test & Retainability						1-21-91 8/21/90	94
	I) Firing Pin Indent	0225	0225	0225			7/25/90	94
	J) Assemble Stock						7/30/90	RW
	K) Assemble Swivel Studs						8/21/90	94
	L) Attach Front and Rear Sight Assemblies						7/30/90	RW
	M) Iron Sight Alignment						7/30/90	RW
	N) Detach Front & Rear Sights & place in numbered container						7/30/90	RW
	O) Attach Scope to Rifle						7/30/90	RW
	P) Detach & Attach Scope 20 Times						7/30/90	RW
640	Gallery Target & Test						8-3-90	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						8-3-90	KT
655	Final Inspection							
	A) Headspace	2.39	2.35	2.34	2.30	2.25	8/21/90	94
	B) Trigger Pull	2.44	2.44	2.45	2.40	2.35	8/21/90	94
	C) Function						8/21/90	94
660	Pack						3/19/91	AF

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

SERIAL NO. 06498751DATE 1-21-91TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.47	2.28	2.29	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.15	2.20	2.35	
PULL #3	2.25	2.24	2.26	2.34	
PULL #4	2.23	2.31	2.33	2.30	
PULL #5	2.35	2.20	2.31	2.25	
TOTAL					
AVG.					

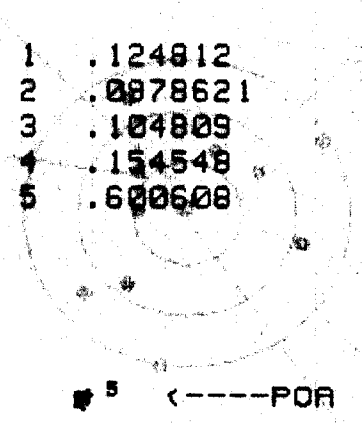
	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.27		
PULL #2	3.41	3.24		
PULL #3	3.46	3.22		
PULL #4	3.29	3.24		
PULL #5	3.28	3.15		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.34	4.20		4.10
PULL #2	4.25	4.19		4.17
PULL #3	4.25	4.17		4.21
PULL #4	4.23	4.21		4.18
PULL #5	4.15	4.23		2.55
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6498751
 22 Jan 1991

CENTROIDAL DISTANCES

0 TO 1	.124812
1 TO 2	.0878621
1 TO 3	.104809
1 TO 4	.154548
1 TO 5	.600608



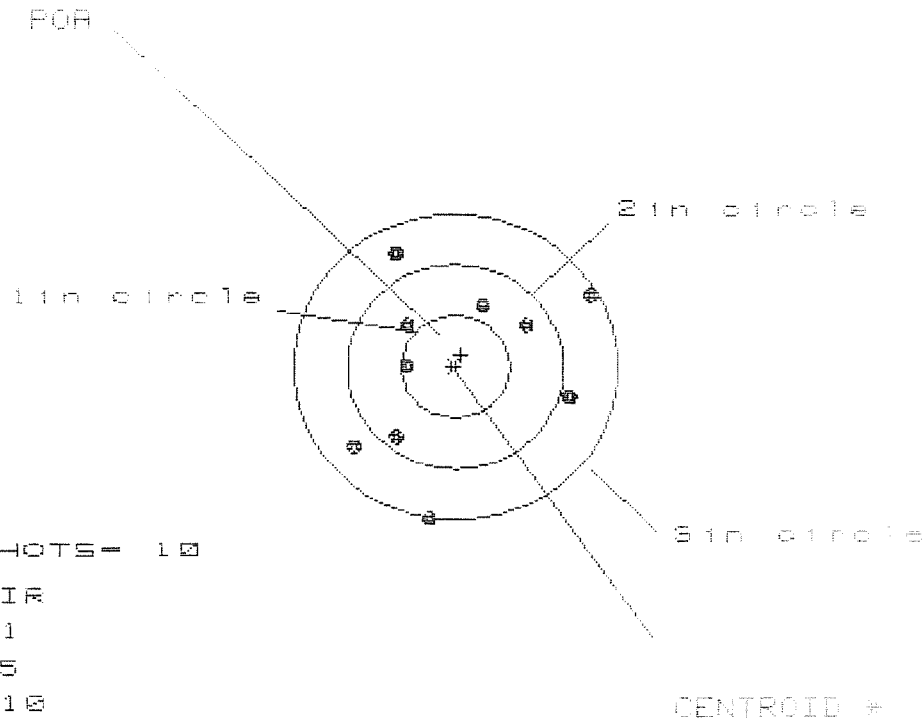
5 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0388
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0086
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0397417
 THE AMR FOR THIS RIFLE IS: .9648

22 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06498751

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 2.147

VS = 2.576

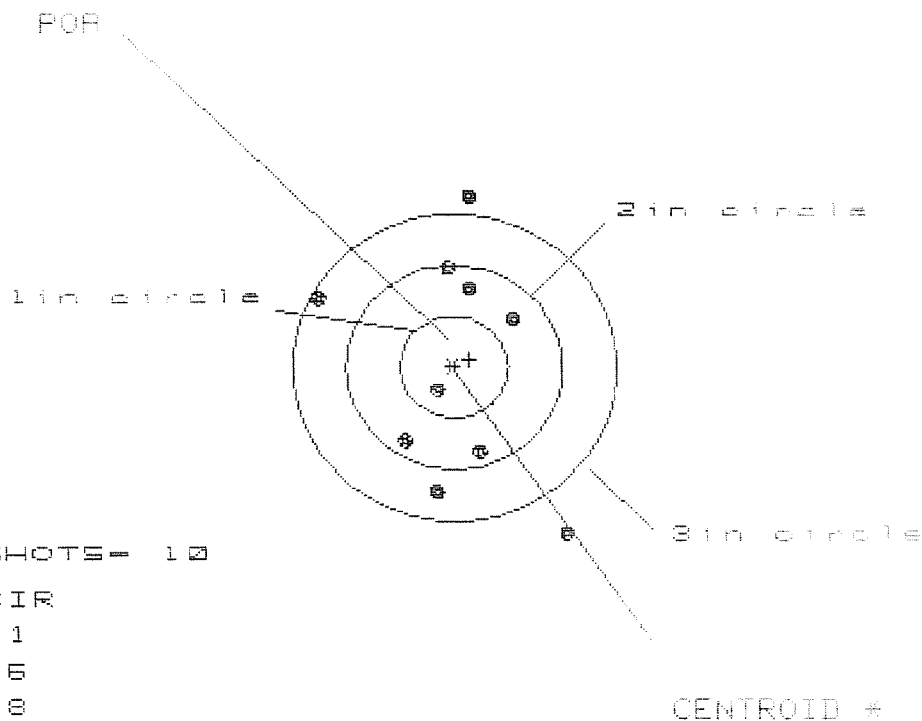
GS = 2.673

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.204	1.172	1.205
MINIMUM X	-.943	-.975	-.828
MAXIMUM Y	1.105	.942	1.014
MINIMUM Y	-1.471	-.998	-.926
CENTROID X	-.053	-.021	-.168
CENTROID Y	-.113	.050	-.022
FOR TO CENTROID in.	.125	.055	.169
MIN RADIUS	.404	.445	.287
MEAN RADIUS	.977	.895	.826
MAX RADIUS	1.499	1.395	1.266
HORIZONTAL SPREAD	2.147	2.147	2.033
VERTICAL SPREAD	2.576	1.940	1.940
EXTREME SPREAD	2.673	2.556	2.153
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

28 Jan 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS = 2.220

VS = 3.303

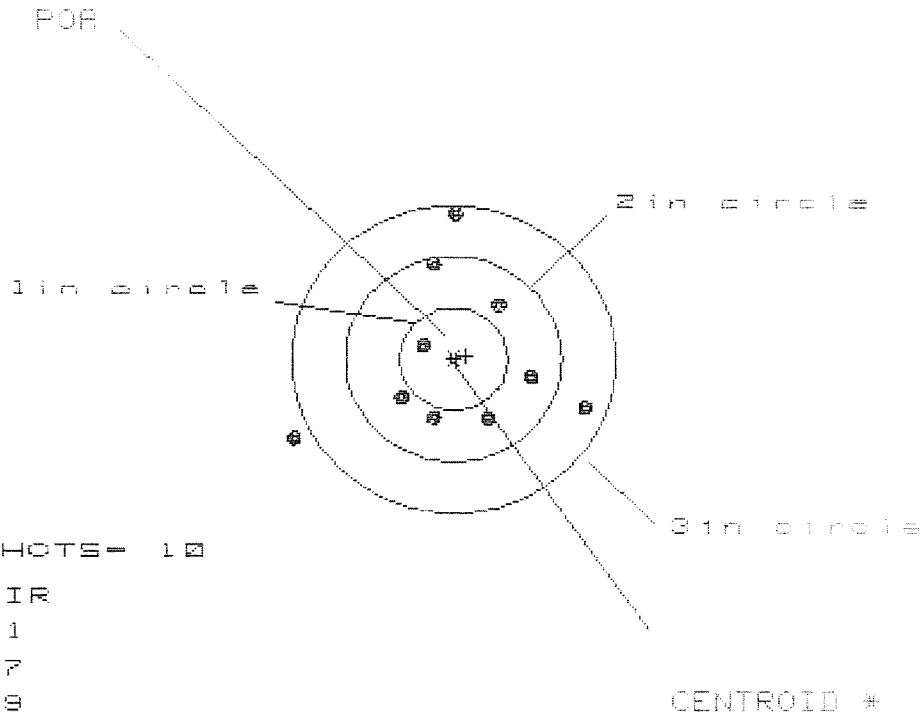
GS = 3.425

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.011	.631	.658
MINIMUM X	-1.209	-1.097	-1.070
MAXIMUM Y	1.649	1.465	.962
MINIMUM Y	-1.654	-1.385	-1.282
CENTROID X	-.144	-.256	-.283
CENTROID Y	-.077	.107	-.076
FOR TO CENTROID in.	.163	.277	.293
MIN RADIUS	.228	.385	.284
MEAN RADIUS	1.057	.954	.868
MAX RADIUS	1.939	1.481	1.249
HORIZONTAL SPREAD	2.220	1.728	1.728
VERTICAL SPREAD	3.303	2.850	2.164
EXTREME SPREAD	3.425	2.866	2.166
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.596

VS = 2.222

GS = 2.709

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.193
MINIMUM X	-1.503
MAXIMUM Y	1.449
MINIMUM Y	-1.773
CENTROID X	-1.117
CENTROID Y	-1.030
POA TO CENTROID in.	1.120
MIN RADIUS	1.343
MEAN RADIUS	1.908
MAX RADIUS	1.690
HORIZONTAL SPREAD	2.696
VERTICAL SPREAD	2.222
EXTREME SPREAD	2.709
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	9

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CENTERFIRE PATTERNS # 4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.270

VS = 2.007

GS = 2.810

CENTROID +

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.217	1.111	.722
MINIMUM X	-1.053	-1.159	-1.020
MAXIMUM Y	1.087	.910	.839
MINIMUM Y	-.920	-.800	-.871
CENTROID X	.024	.130	-.009
CENTROID Y	.021	-.099	-.028
POR TO CENTROID in.	.032	.164	.029
MIN RADIUS	.310	.341	.321
MEAN RADIUS	.872	.806	.733
MAX RADIUS	1.448	1.250	1.121
HORIZONTAL SPREAD	2.270	2.270	1.740
VERTICAL SPREAD	2.007	1.710	1.710
EXTREME SPREAD	2.810	2.439	2.056
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

28 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08498751

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 10

HS= 2.176

VS= 2.242

GS= 2.672

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.071	1.175	1.123
MINIMUM X	-1.105	-1.001	-1.053
MAXIMUM Y	1.033	.993	.857
MINIMUM Y	-1.209	-1.095	-1.138
CENTROID X	.484	.380	.432
CENTROID Y	.156	.042	.178
POA TO CENTROID in	.509	.383	.467
MIN RADIUS	.349	.368	.294
MEAN RADIUS	1.010	.953	.917
MAX RADIUS	1.394	1.216	1.162
HORIZONTAL SPREAD	2.176	2.176	2.176
VERTICAL SPREAD	2.242	2.088	1.995
EXTREME SPREAD	2.672	2.213	2.213
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		10	