

06225338

MODEL 760TM M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington®

MODEL 700™ M24

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

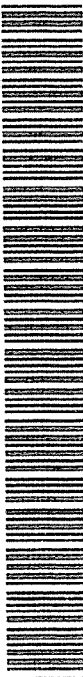
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

REG. U.S. PAT. & T.M. OFF.

DUPONT

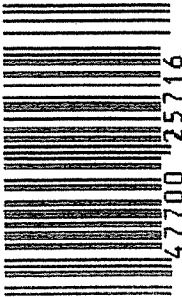
SERIAL NO.
C6225338

ORDER NO.
5716



5716 C6225338

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225338

OP.#	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and stock	8	9/88	FB
600	Proof	9	7/88	RW
607	Check Headspace	9	7/88	RW
610	Dis-assemble gun	9	7/88	RW
612	Magnaflux Barrel Action		9-14-88	pfe.
	Magnaflux Bolt		9-14-88	pfe
615	Rollmark Caliber		10-22	ES.
617	Drill & Tap Sight Holes		10-23	FB
618	Polish Barrel		10-24	W&T
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		1/11/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/11/89	RW
	C) Inspect Ejector Hole for Chamfer		1/11/89	RW

OVER

OP. #		READINGS	DATE	INITIAL
625 cont.	D) Oil Firing Pin Ass'y		1/11/89	RW
	E) Adjust Trigger Pull to Min. Setting and Stake		9 Jan 89	JSB
	F) Safety on Force	6 6 6	11 Jan 89	JSB
	G) Safety off Force	3 3 3	11 Jan 89	JSB
	H) Trigger Pull Test & Retainability		9 Jan 89	JSB
	I) Firing Pin Indent	.0215 .0215 .021	11 Jan 89	JSB
	J) Assemble Stock		1/11/89	RW
	K) Assemble Swivel Studs		1/22/89	CS
	L) Attach Front & Rear Sight Assemblies		1/11/89	RW
	M) Iron Sight Alignment		1/11/89	RW
	N) Detach Front & Rear Sights & place in numbered container		1/11/89	RW
	O) Attach Scope to Rifle		16 Jan 89	JSB
	P) Detach & Attach Scope 20 times		16 Jan 89	JSB
640	Gallery Target & Test	65R 87L	1/20/89	DH
	A) Optical Clarity of Scope		1/20/89	DH
645	Inspect for Live Ammo		1/20/89	DH
655	Final Inspection			
	A) Headspace		27 Jan 89	JSB
	B) Trigger Pull		27 Jan 89	JSB
	C) Function		27 Jan 89	JSB
660	Pack		23 Mar 89	JSB

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 66225338

DATE 4-4-90

TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	² 2.57	² 2.47		² 2.44	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.57	2.45		2.41	
PULL #3	2.42	2.45		2.40	
PULL #4	2.47	2.53		2.40	
PULL #5	2.50	2.51		2.49	
TOTAL	12.53	12.41		12.14	
AVG.	2.506	2.482		2.428	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	² 3.43	² 3.44		
PULL #2	3.47	3.50		
PULL #3	3.48	3.51		
PULL #4	3.52	3.50		
PULL #5	3.48	3.54		
TOTAL	17.38	17.49		
AVG.	3.476	3.498		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	² 4.44	² 4.43		
PULL #2	4.54	4.40		
PULL #3	4.50	4.51		
PULL #4	4.48	4.45		
PULL #5	4.49	4.47		
TOTAL	22.45	22.26		
AVG.	4.49	4.452		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6225338
26 Jan 1989

CENTROIDAL DISTANCES

0 TO	1	.323934
1 TO	2	.676385
1 TO	3	.687874
1 TO	4	.136605
1 TO	5	.318567

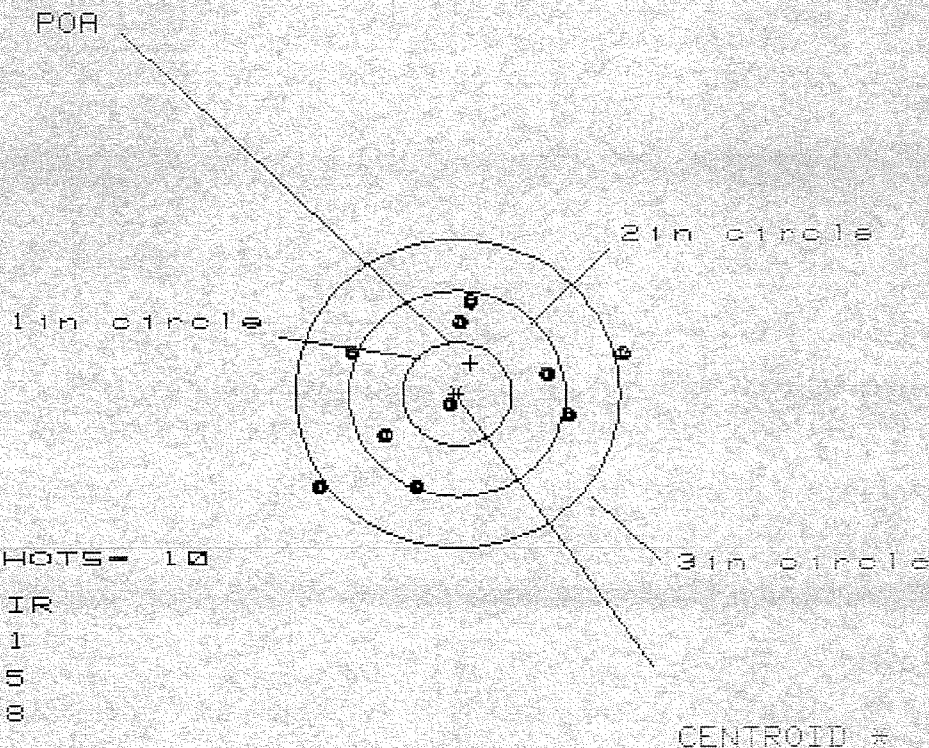
$\sum_{i=1}^5 x_i^2$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .014
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1796
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .180145
THE AMR FOR THIS RIFLE IS: .9846

23 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/CG225338

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.780

VS= 1.854

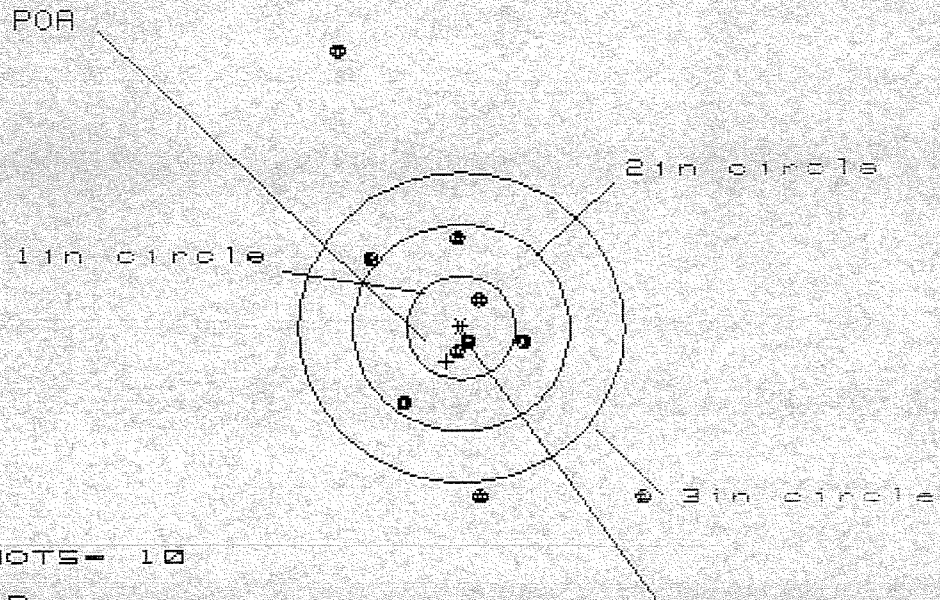
GS= 3.044

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.517	1.170	1.033
MINIMUM X	:	-1.263	-1.094	-.979
MAXIMUM Y	:	.910	.949	.844
MINIMUM Y	:	-.944	-.905	-1.010
CENTROID X	:	-.127	-.296	-.159
CENTROID Y	:	-.298	-.337	-.232
POA TO CENTROID in.	:	.324	.449	.281
MIN RADIUS	:	.102	.134	.158
MEAN RADIUS	:	.952	.979	.803
MAX RADIUS	:	1.559	1.382	1.076
HORIZONTAL SPREAD	:	2.780	2.264	2.012
VERTICAL SPREAD	:	1.854	1.854	1.854
EXTREME SPREAD	:	3.044	2.362	2.113
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

23 Jan 1989

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 2.782

VS= 4.305

GS= 5.126

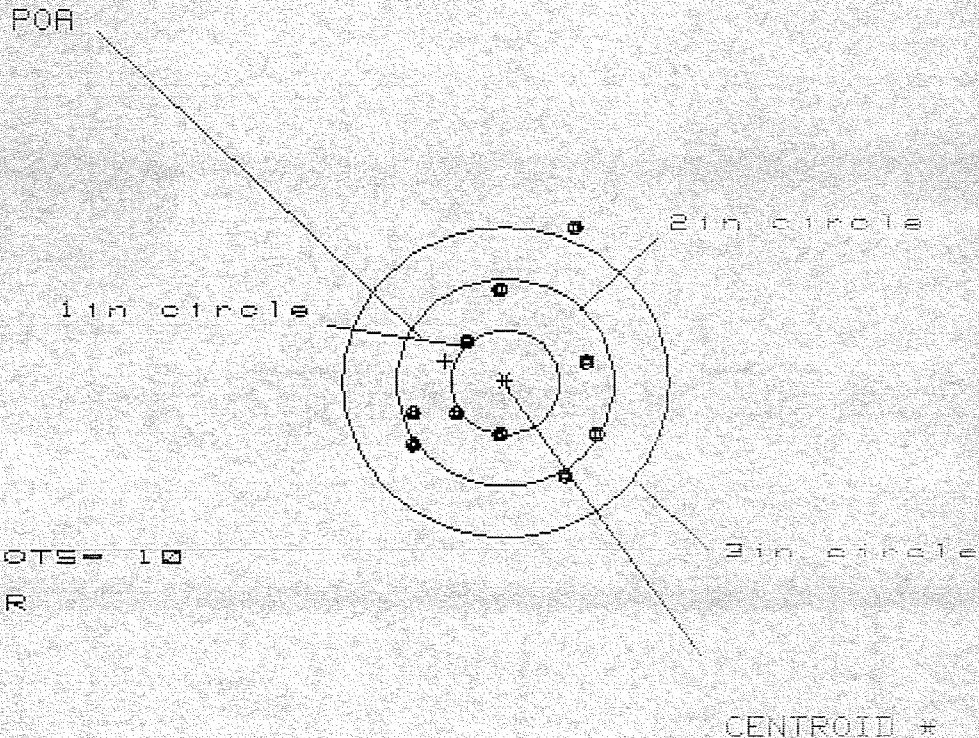
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.664	1.540	.603
MINIMUM X	:	-1.118	-.951	-.759
MAXIMUM Y	:	2.673	1.164	.997
MINIMUM Y	:	-1.632	-1.335	-1.469
CENTROID X	:	.134	.258	.066
CENTROID Y	:	.326	.029	.196
POA TO CENTROID in.	:	.353	.260	.207
MIN RADIUS	:	.168	.134	.098
MEAN RADIUS	:	1.087	.880	.696
MAX RADIUS	:	2.897	2.038	1.481
HORIZONTAL SPREAD	:	2.782	2.491	1.362
VERTICAL SPREAD	:	4.305	2.499	2.466
EXTREME SPREAD	:	5.126	3.372	2.473
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 1.742

VS= 2.477

GS= 2.592

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.864	.936	1.016
MINIMUM X	:	-.878	-.806	-.726
MAXIMUM Y	:	1.535	1.084	.987
MINIMUM Y	:	-.942	-.771	-.485
CENTROID X	:	.554	.482	.402
CENTROID Y	:	-.201	-.372	-.275
POA TO CENTROID in.	:	.589	.609	.488
MIN RADIUS	:	.483	.303	.396
MEAN RADIUS	:	.900	.783	.746
MAX RADIUS	:	1.667	1.084	1.097
HORIZONTAL SPREAD	:	1.742	1.742	1.742
VERTICAL SPREAD	:	2.477	1.855	1.472
EXTREME SPREAD	:	2.592	1.965	1.768
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

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS = 10

IN CIR

1in = 2

2in = 4

3in = 9

HS = 2.739

VS = 2.104

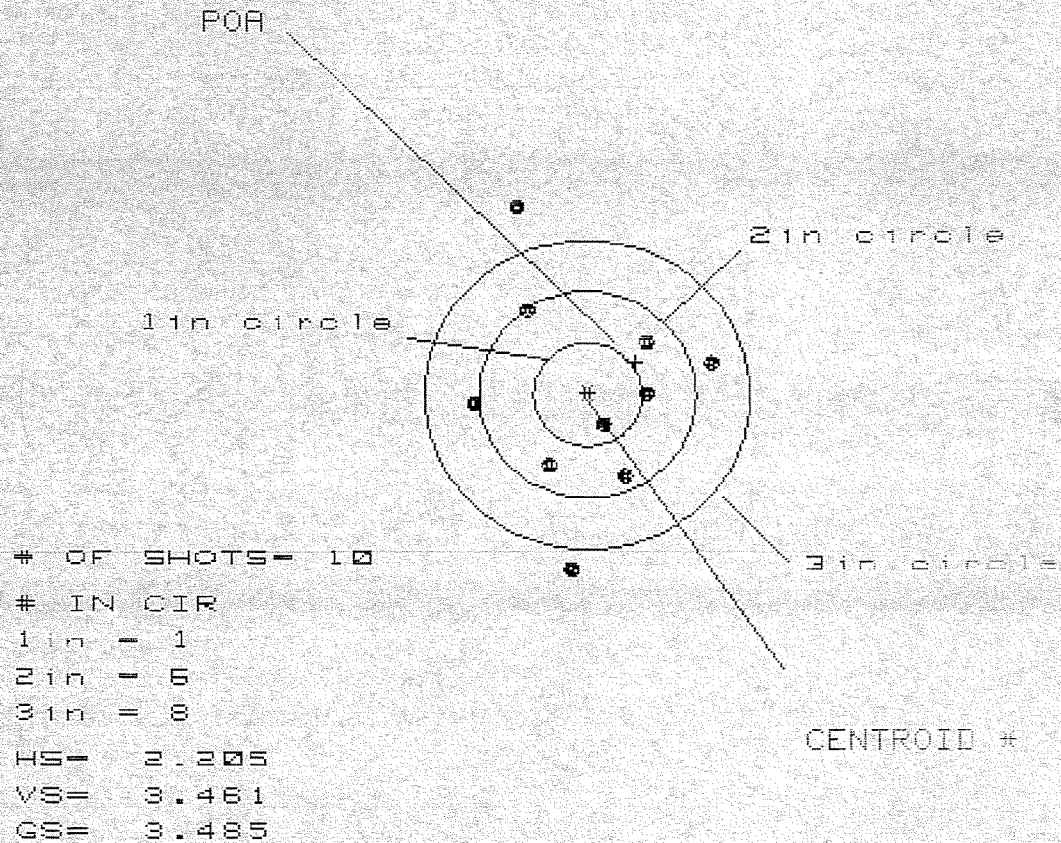
GS = 3.180

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.422	1.567	1.228
MINIMUM X	:	-1.317	-1.172	-.977
MAXIMUM Y	:	.815	.672	.616
MINIMUM Y	:	-1.289	-.457	-.513
CENTROID X	:	-.046	-.191	-.386
CENTROID Y	:	-.408	-.265	-.209
POA TO CENTROID in.	:	.411	.327	.439
MIN RADIUS	:	.085	.133	.312
MEAN RADIUS	:	.986	.894	.802
MAX RADIUS	:	1.830	1.630	1.270
HORIZONTAL SPREAD	:	2.739	2.739	2.205
VERTICAL SPREAD	:	2.104	1.129	1.129
EXTREME SPREAD	:	3.180	2.748	2.357
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.157	1.090	1.057
MINIMUM X	:	-1.048	-1.115	-1.148
MAXIMUM Y	:	1.817	1.017	.837
MINIMUM Y	:	-1.644	-1.442	-1.743
CENTROID X	:	-.445	-.378	-.345
CENTROID Y	:	-.317	-.519	-.339
POA TO CENTROID in.	:	.547	.642	.484
MIN RADIUS	:	.319	.115	.264
MEAN RADIUS	:	.998	.854	.783
MAX RADIUS	:	1.915	1.466	1.148
HORIZONTAL SPREAD	:	2.205	2.205	2.205
VERTICAL SPREAD	:	3.461	2.459	1.580
EXTREME SPREAD	:	3.485	2.482	2.239
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	