

06587608

MODEL 760™ M24

Model **S4S**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

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

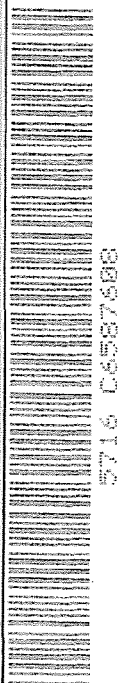
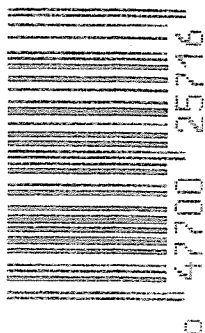
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6587608

ORDER NO.
5716

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

UPC



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6587608

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	50	RW
600	Proof	1019	50	RW
607	Check Headspace	1019	90	RW
610	Dis-assemble Gun	1019	90	RW
612	Magnaflux Barrel Action		10/23/90	KR
	Magnaflux Bolt		10/23/90	KR
615	Rollmark Caliber		10/23/90	GL
617	Drill and Tap Sight Holes		10/26/90	WB
618	Polish Barrel RB		10/27/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/12/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/12/90	RW
	C) Inspect Ejector Hole for Chamfer		12/12/90	RW
	D) Oil Firing Pin Ass'y		12/12/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-14-91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			1/15/91	JL
	G) Safety Off Force	3	3	3			1/15/91	JL
	H) Trigger Pull Test & Retainability						1-14-91	JL
	I) Firing Pin Indent	.0215	.0205	.020			1-15-91	JL
	J) Assemble Stock						1/16/91	RW
	K) Assemble Swivel Studs						1-17-91	JL
	L) Attach Front and Rear Sight Assemblies						1/16/91	RW
	M) Iron Sight Alignment						1/16/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/16/91	RW
	O) Attach Scope to Rifle						1/16/91	RW
	P) Detach & Attach Scope 20 Times						1/16/91	RW
640	Gallery Target & Test						1-16-91	DA
	A) Time						1-16-91	DA
	B) Malfunctions						1-16-91	DA
	C) Pierced Primers						1-16-91	DA
	D) Optical Clarity of Scope						1-16-91	DA
645	Inspect for Live Ammo						1-16-91	DA
655	Final Inspection							
	A) Headspace						1-17-91	JL
	B) Trigger Pull	2.33	2.32	2.33	2.29	2.32	1-17-91	JL
	C) Function						1-17-91	JL
660	Pack						3-19-91	NF

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

SERIAL NO. C6587608DATE 1-14-91TESTER JFL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.20	2.25	2.28	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.13	2.29	2.29	2.32	
PULL #3	2.21	2.29	2.27	2.33	
PULL #4	2.22	2.33	2.28	2.29	
PULL #5	2.20	2.31	2.29	2.32	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.44	3.38		
PULL #2	3.42	3.37		
PULL #3	3.36	3.32		
PULL #4	3.39	3.38		
PULL #5	3.34	3.36		
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	4.31		4.28
PULL #2	4.31	4.20		4.26
PULL #3	4.28	4.26		4.26
PULL #4	4.26	4.28		4.26
PULL #5	4.12	4.26		4.26
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C587608
17 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.497618
1 TO	2	.649765
1 TO	3	.257769
1 TO	4	.683143
1 TO	5	.38413

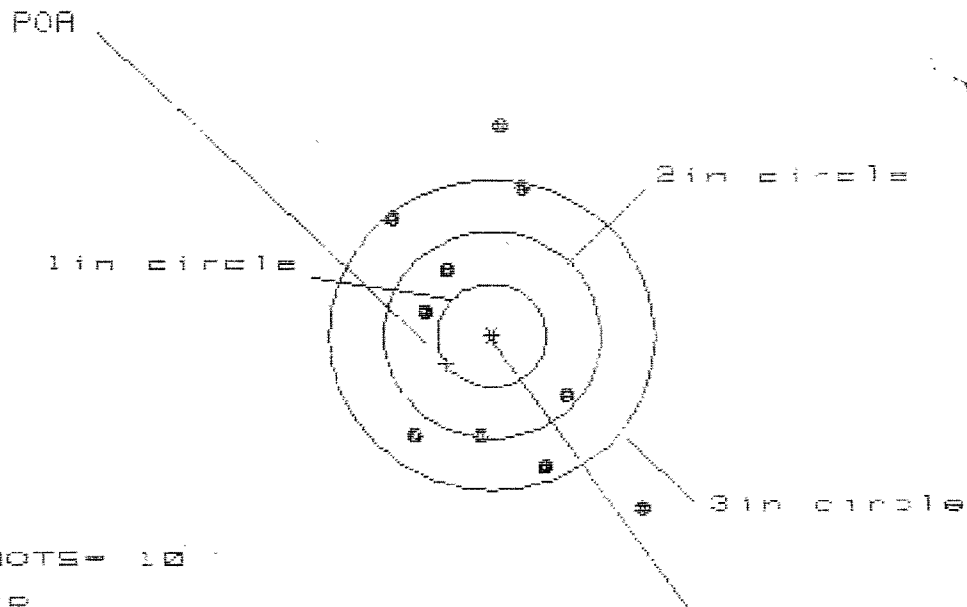
$\frac{S_1}{S_2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1418
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0406
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .147498
THE AMR FOR THIS RIFLE IS: 1.078

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08597688

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

ME = 2.289

VS = 3.743

CS = 3.660

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.370	.857	.885
MINIMUM X	-.929	-.777	-.749
MAXIMUM Y	2.045	1.856	1.441
MINIMUM Y	-1.698	-1.425	-1.193
CENTROID X	.418	.266	.238
CENTROID Y	.270	.459	.227
POA TO CENTROID in.	.498	.530	.328
MIN RADIUS	.689	.508	.537
MEAN RADIUS	1.302	1.176	1.073
MAX RADIUS	2.182	1.870	1.512
HORIZONTAL SPREAD	2.299	1.634	1.634
VERTICAL SPREAD	3.743	3.281	2.634
EXTREME SPREAD	3.960	3.304	2.777
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS587688

CENTERFIRE PATTERNS # 2

POR

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 8

HS= 2.302

VS= 3.405

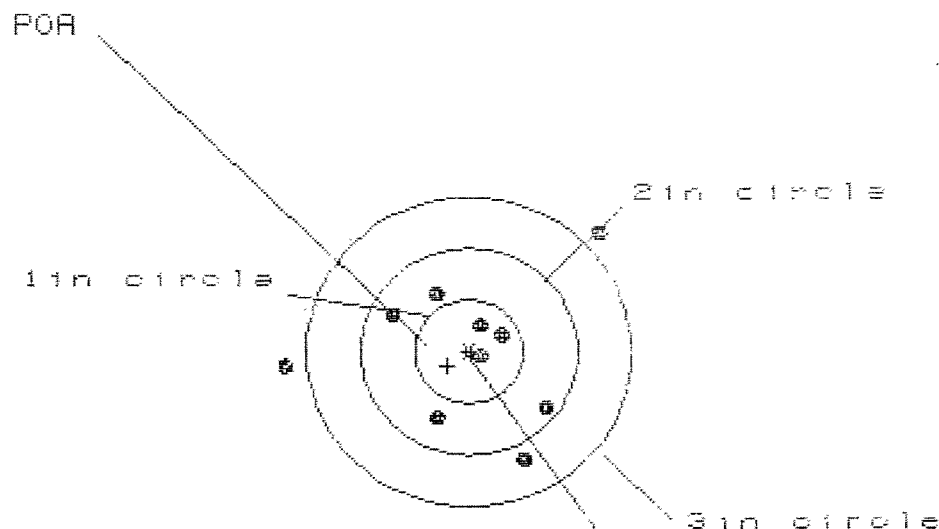
GS= 3.621

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.316	1.361	1.264
MINIMUM X	:	-.986	-.941	-1.038
MAXIMUM Y	:	1.616	1.418	.981
MINIMUM Y	:	-1.789	-1.144	-.967
CENTROID X	:	.181	.136	.233
CENTROID Y	:	-.335	-.137	-.314
POR TO CENTROID in.	:	.381	.193	.391
MIN RADIUS	:	.411	.390	.460
MEAN RADIUS	:	1.104	1.017	.928
MAX RADIUS	:	1.835	1.617	1.378
HORIZONTAL SPREAD	:	2.302	2.302	2.302
VERTICAL SPREAD	:	3.405	2.562	1.948
EXTREME SPREAD	:	3.621	3.128	2.554
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06587688

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.887

VS= 2.180

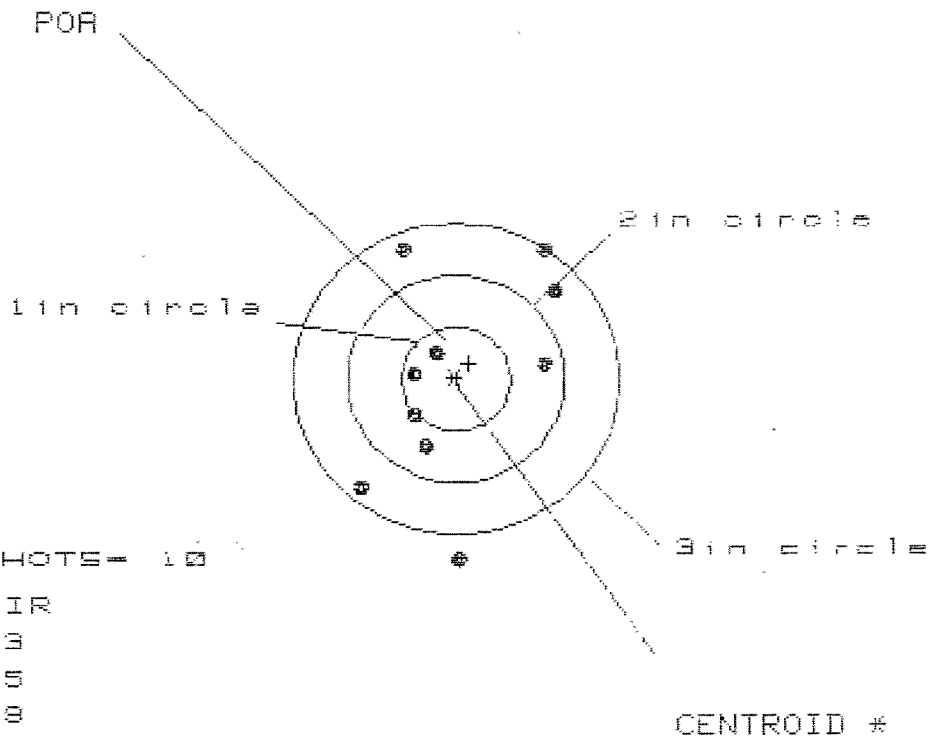
GS= 3.147

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.194	1.005	.638
MINIMUM X	-1.693	-.869	-.743
MAXIMUM Y	1.127	1.113	.650
MINIMUM Y	-1.053	-1.067	-.927
CENTROID X	.196	.385	.259
CENTROID Y	.139	.153	.014
POA TO CENTROID in.	.240	.414	.259
MIN RADIUS	.120	.083	.111
MEAN RADIUS	.821	.706	.614
MAX RADIUS	1.698	1.500	1.027
HORIZONTAL SPREAD	2.887	1.874	1.381
VERTICAL SPREAD	2.180	2.180	1.577
EXTREME SPREAD	3.147	2.301	1.827
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 1.832

VS = 2.970

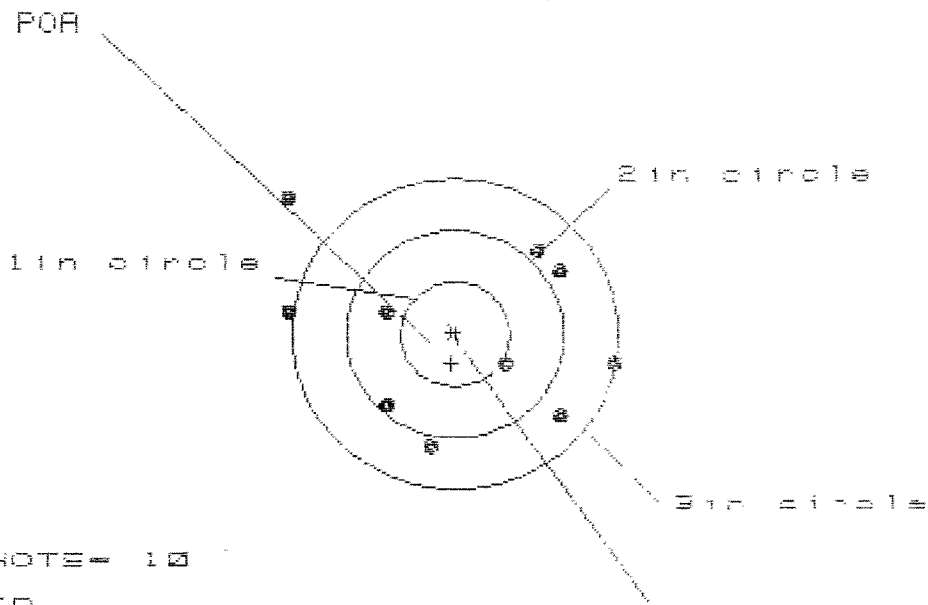
GS = 3.068

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.927	.930	1.031
MINIMUM X	-.905	-.902	-.801
MAXIMUM Y	1.243	1.051	1.182
MINIMUM Y	-1.727	-1.285	-1.154
CENTROID X	-.120	-.123	-.224
CENTROID Y	-.151	.041	-.090
FOR TO CENTROID in.	.193	.129	.241
MIN RADIUS	.316	.193	.211
MEAN RADIUS	.984	.893	.807
MAX RADIUS	1.727	1.570	1.405
HORIZONTAL SPREAD	1.832	1.832	1.832
VERTICAL SPREAD	2.970	2.336	2.336
EXTREME SPREAD	3.068	2.894	2.695
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

17 Jan 1991

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CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS = 2.995

VS = 2.335

GS = 3.322

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.424
MINIMUM X	-1.561
MAXIMUM Y	1.272
MINIMUM Y	-1.063
CENTROID X	.034
CENTROID Y	.280
POA TO CENTROID in.	.282
MIN RADIUS	.561
MEAN RADIUS	1.178
MAX RADIUS	1.978
HORIZONTAL SPREAD	2.985
VERTICAL SPREAD	2.335
EXTREME SPREAD	3.322
NUMBER IN ONE INCH CIRCLE =	0
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	8