

06587635

MODEL 760TM M24

Model **S&S**TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

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

Remington[®]

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

MODEL 700[™] M24

MADE IN U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

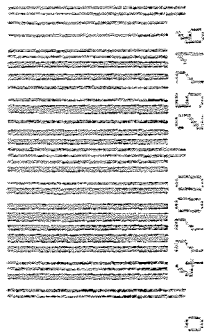
SERIAL NO.
06587605

ORDER NO.
5716

20

5716 06587605

LPC



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587635

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1024	90	RW
600	Proof	1024	90	RW
607	Check Headspace	1024	90	RW
610	Dis-assemble Gun	1024	90	RW
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes		11/5/90	LB
618	Polish Barrel AB		11/6/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	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		1-4-91	TH

op. #	BARBER M24 0024144	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3.50	3.50	3.25			1/3/91	KT
	G) Safety Off Force	2.50	2.50	2.50			1/3/91	KT
	H) Trigger Pull Test & Retainability						1-4-91	DH
	I) Firing Pin Indent	.021	.021	.020			1/3/91	KT
	J) Assemble Stock						1/8/91	RW
	K) Assemble Swivel Studs						1-11-91	JH
	L) Attach Front and Rear Sight Assemblies						1/8/91	RW
	M) Iron Sight Alignment						1/8/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/8/91	RW
	O) Attach Scope to Rifle						1/8/91	RW
	P) Detach & Attach Scope 20 Times						1/8/91	RW
640	Gallery Target & Test						1-10-91	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						1-10-91	NF
655	Final Inspection							
	A) Headspace						1-11-91	JH
	B) Trigger Pull	2.15	2.32	2.36	2.21	2.15	1-11-91	JH
	C) Function						1-11-91	JH
660	Pack						3/15/91	WB

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

SERIAL NO. CC587635DATE 1-4-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.46	2.46	2.50	2.15	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.48	2.50	2.32	
PULL #3	2.55	2.23	2.66	2.36	
PULL #4	2.52	2.44	2.45	2.21	
PULL #5	2.32	2.32	2.22	2.15	
TOTAL	12.32	11.93	12.33		
AVG.	2.46	2.38	2.46		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.28		
PULL #2	3.17	3.24		
PULL #3	3.17	3.38		
PULL #4	2.99	3.30		
PULL #5	3.09	3.28		
TOTAL	15.64	16.48		
AVG.	3.12	3.29		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.04	4.28		4.14
PULL #2	4.17	4.31		4.15
PULL #3	4.40	4.22		4.11
PULL #4	4.49	4.26		4.13
PULL #5	4.48	4.34		4.27
TOTAL	21.58	21.41		20.80
AVG.	4.31	4.28		4.16

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587635
11 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.10373
1 TO	2	.162086
1 TO	3	.305221
1 TO	4	.181342
1 TO	5	.128736

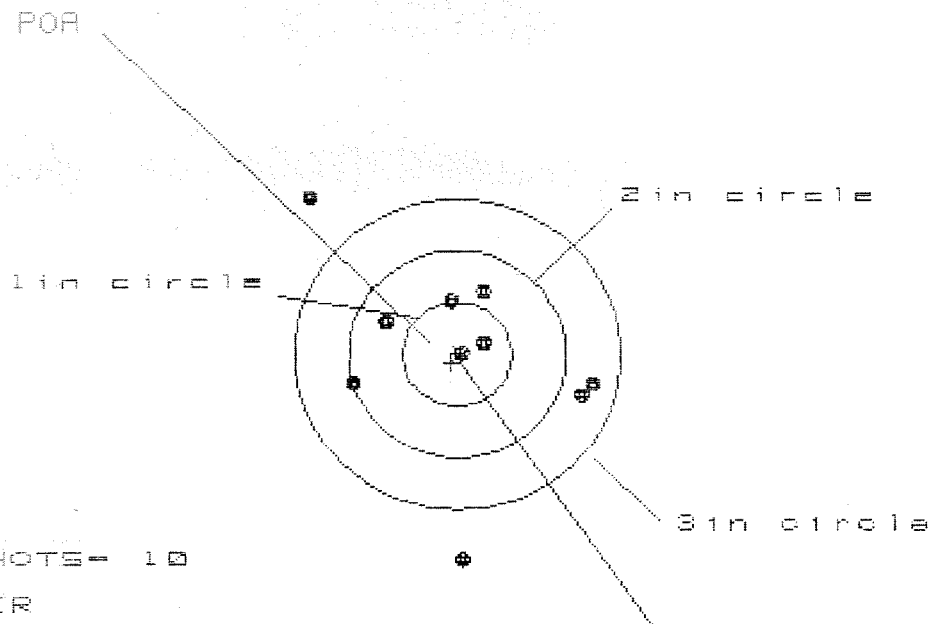
✱ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0866
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .045
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0975939
THE AMR FOR THIS RIFLE IS: 1.065

11 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/ C6587635

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 2.603

VS = 3.544

GS = 3.801

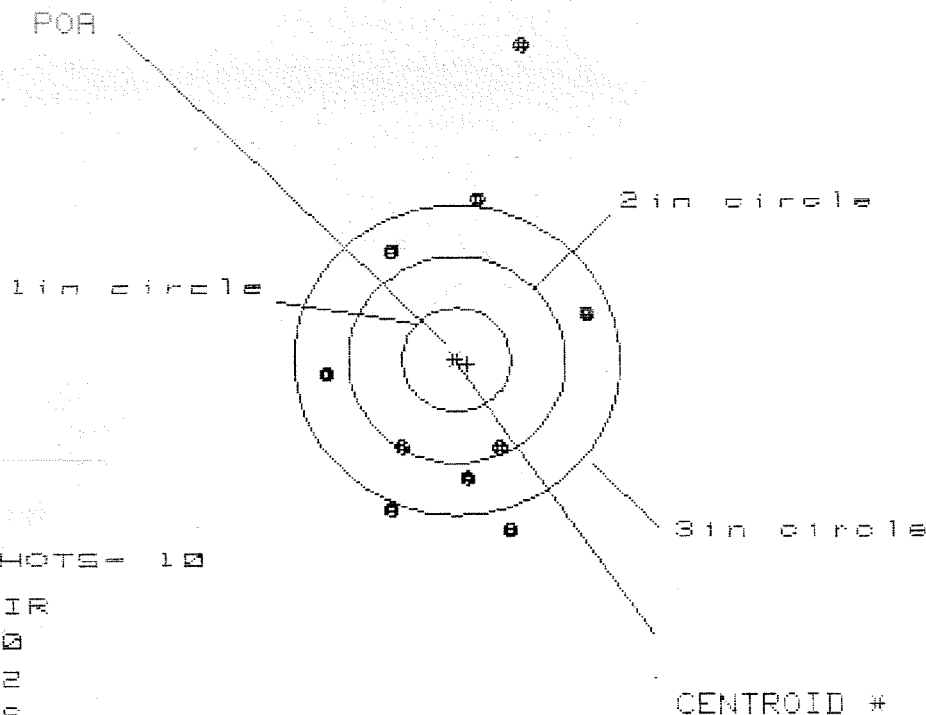
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.240	1.088	1.071
MINIMUM X	-1.363	-1.087	-1.104
MAXIMUM Y	1.535	.735	.505
MINIMUM Y	-2.009	-1.838	-1.486
CENTROID X	.058	.210	.227
CENTROID Y	.086	-.085	.145
POA TO CENTROID in.	.104	.226	.269
MIN RADIUS	.083	.160	.111
MEAN RADIUS	.978	.881	.688
MAX RADIUS	2.053	1.843	1.149
HORIZONTAL SPREAD	2.603	2.175	2.175
VERTICAL SPREAD	3.544	2.573	.991
EXTREME SPREAD	3.801	2.586	2.175
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

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CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 2

3 in = 6

HS= 2.387

VS= 4.634

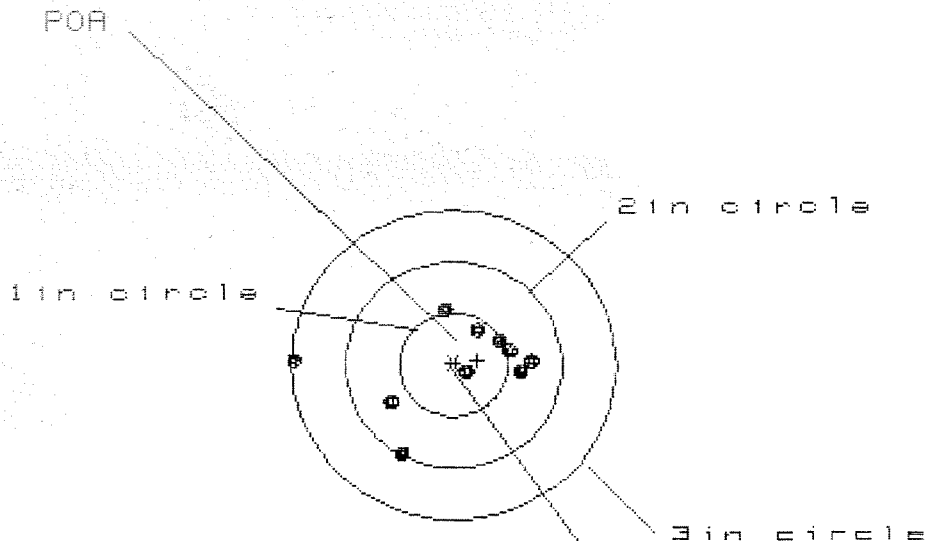
GS= 4.670

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.234	1.310
MINIMUM X	:	-1.217	-1.153	-1.077
MAXIMUM Y	:	3.025	1.859	1.700
MINIMUM Y	:	-1.609	-1.273	-1.309
CENTROID X	:	-.098	-.162	-.238
CENTROID Y	:	.042	-.294	-.135
POA TO CENTROID in.	:	.107	.336	.274
MIN RADIUS	:	.903	.656	.740
MEAN RADIUS	:	1.468	1.209	1.198
MAX RADIUS	:	3.079	1.876	1.732
HORIZONTAL SPREAD	:	2.387	2.387	2.387
VERTICAL SPREAD	:	4.634	3.132	3.009
EXTREME SPREAD	:	4.670	3.152	3.121
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 9

3 in = 9

HS= 2.201

VS= 1.393

GS= 2.201

CENTROID *

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.678	.508	.428
MINIMUM X	-1.523	-.715	-.795
MAXIMUM Y	.544	.551	.446
MINIMUM Y	-.849	-.842	-.416
CENTROID X	-.220	-.050	.030
CENTROID Y	-.040	-.047	.058
POA TO CENTROID in.	.223	.069	.065
MIN RADIUS	.149	.071	.201
MEAN RADIUS	.658	.509	.406
MAX RADIUS	1.525	1.058	.897
HORIZONTAL SPREAD	2.201	1.223	1.223
VERTICAL SPREAD	1.393	1.393	.862
EXTREME SPREAD	2.201	1.458	1.276
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
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 = 3

3in = 6

HS= 2.898

VS= 3.398

GS= 3.465

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.393	1.474	1.363
MINIMUM X	:	-1.505	-1.424	-1.240
MAXIMUM Y	:	1.592	1.391	1.469
MINIMUM Y	:	-1.806	-1.351	-1.273
CENTROID X	:	-.108	-.189	-.373
CENTROID Y	:	.013	.214	.136
POA TO CENTROID in.	:	.108	.285	.397
MIN RADIUS	:	.311	.359	.211
MEAN RADIUS	:	1.227	1.151	1.064
MAX RADIUS	:	1.947	1.599	1.581
HORIZONTAL SPREAD	:	2.898	2.898	2.603
VERTICAL SPREAD	:	3.398	2.742	2.742
EXTREME SPREAD	:	3.465	2.968	2.833
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.181

VS= 3.815

GS= 3.891

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.972	.922	.956
MINIMUM X	:	-1.209	-1.259	-1.225
MAXIMUM Y	:	1.845	1.626	1.871
MINIMUM Y	:	-1.970	-1.017	-.813
CENTROID X	:	-.065	-.015	-.049
CENTROID Y	:	.124	.343	.139
POA TO CENTROID in.	:	.140	.343	.148
MIN RADIUS	:	.202	.321	.217
MEAN RADIUS	:	.994	.907	.759
MAX RADIUS	:	2.020	1.649	1.225
HORIZONTAL SPREAD	:	2.181	2.181	2.181
VERTICAL SPREAD	:	3.815	2.643	1.884
EXTREME SPREAD	:	3.891	2.733	2.197
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	