

C6587653

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



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

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

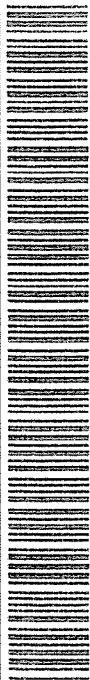
MODEL 700TM M24

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

SERIAL NO.
C6587653

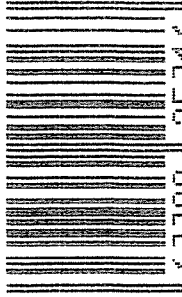
ORDER NO.
5716

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



5716 C6587653

UPC



0 47700 25716 7

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6587653

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1019	90	RW
600	Proof	1019	90	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	FB
618	Polish Barrel <i>R/B</i>		10/29/90	WB
620	Apply Coatings (Barrel Action)		11-7-90	TA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		12/2/90	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		1-9-91	ML

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4.0	4.25	4.25			1/18/91	RJ
	G) Safety Off Force	2.75	2.75	2.75			1/18/91	122
	H) Trigger Pull Test & Retainability						1-9-91	JP
	I) Firing Pin Indent	.020	.020	.020			1/18/91	128
	J) Assemble Stock						1/18/91	Rw
	K) Assemble Swivel Studs						2-1-91	AC
	L) Attach Front and Rear Sight Assemblies						1/18/91	Rw
	M) Iron Sight Alignment						1/18/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						1/18/91	Rw
	O) Attach Scope to Rifle						1/18/91	Rw
	P) Detach & Attach Scope 20 Times						1/18/91	Rw
640	Gallery Target & Test						1-20-91	DH
	A) Time						1-20-91	DH
	B) Malfunctions						1-20-91	DH
	C) Pierced Primers						1-20-91	DH
	D) Optical Clarity of Scope						1-20-91	DH
645	Inspect for Live Ammo						1-20-91	DH
655	Final Inspection							
	A) Headspace						2-1-91	AC
	B) Trigger Pull	2.37	2.27	2.25	2.21	2.19	1-22-91	JP
	C) Function						2-1-91	AC
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. C6587653

DATE 1-9-91

TESTER JEL.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.32	2.31	2.38	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.33	2.35	2.27	
PULL #3	2.32	2.30	2.30	2.25	
PULL #4	2.36	2.32	2.32	2.21	
PULL #5	2.36	2.36	2.32	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.34		
PULL #2	3.28	3.17		
PULL #3	3.19	3.24		
PULL #4	3.28	3.23		
PULL #5	3.34	3.32		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.13		4.43
PULL #2	4.18	4.14		4.38
PULL #3	4.23	4.39		4.45
PULL #4	4.34	4.39		4.47
PULL #5	4.29	4.47		4.43
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587653
21 Jan 1991

CENTROIDAL DISTANCES

0 TO	1	.30098
1 TO	2	.406768
1 TO	3	.413392
1 TO	4	.366191
1 TO	5	.165738

$\frac{E_1}{E_3}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1002
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.022
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .102587

THE AMR FOR THIS RIFLE IS: .9808

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/G6587653

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS = 2.442

VS = 2.490

GS = 2.696

CENTROID *

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.357	1.286	1.310
MINIMUM X	:	-1.085	-1.156	-1.132
MAXIMUM Y	:	1.556	1.608	.885
MINIMUM Y	:	-.934	-.761	-.560
CENTROID X	:	.258	.328	.304
CENTROID Y	:	.155	-.018	-.218
POA TO CENTROID in.	:	.301	.328	.375
MIN RADIUS	:	.384	.243	.294
MEAN RADIUS	:	1.034	.912	.779
MAX RADIUS	:	1.680	1.619	1.437
HORIZONTAL SPREAD	:	2.442	2.442	2.442
VERTICAL SPREAD	:	2.490	2.369	1.445
EXTREME SPREAD	:	2.696	2.562	2.562
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587853

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.411

VS= 3.114

GS= 3.129

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.665	.583	.518
MINIMUM X	:	-.746	-.828	-.893
MAXIMUM Y	:	1.456	1.272	.719
MINIMUM Y	:	-1.658	-.917	-.758
CENTROID X	:	-.010	.072	.137
CENTROID Y	:	-.151	.033	-.126
POA TO CENTROID in.	:	.151	.079	.186
MIN RADIUS	:	.273	.316	.286
MEAN RADIUS	:	.838	.706	.591
MAX RADIUS	:	1.815	1.373	1.171
HORIZONTAL SPREAD	:	1.411	1.411	1.411
VERTICAL SPREAD	:	3.114	2.189	1.477
EXTREME SPREAD	:	3.129	2.211	1.827
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6587653

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 3

3in = 10

HS= 2.413

VS= 2.123

GS= 2.505

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.092	.945	.812
MINIMUM X	:	-1.321	-1.129	-1.262
MAXIMUM Y	:	1.056	1.113	1.238
MINIMUM Y	:	-1.067	-1.010	-.885
CENTROID X	:	.240	.387	.520
CENTROID Y	:	-.258	-.315	-.440
POA TO CENTROID in.	:	.352	.499	.681
MIN RADIUS	:	.308	.321	.461
MEAN RADIUS	:	1.047	.986	.905
MAX RADIUS	:	1.420	1.456	1.286
HORIZONTAL SPREAD	:	2.413	2.074	2.074
VERTICAL SPREAD	:	2.123	2.123	2.123
EXTREME SPREAD	:	2.505	2.391	2.178
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		10	

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8587653

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 1.928

VS = 4.102

GS = 4.105

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.005	.945	.851
MINIMUM X	-.923	-.983	-1.077
MAXIMUM Y	1.952	1.713	.793
MINIMUM Y	-2.150	-.710	-.496
CENTROID X	-.082	-.022	.072
CENTROID Y	.019	.258	.044
POA TO CENTROID in.	.084	.259	.084
MIN RADIUS	.220	.339	.106
MEAN RADIUS	.989	.873	.669
MAX RADIUS	2.218	1.870	1.163
HORIZONTAL SPREAD	1.928	1.928	1.928
VERTICAL SPREAD	4.102	2.423	1.289
EXTREME SPREAD	4.105	2.462	2.157
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

21 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08587653

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS = 1.552

VS = 2.708

GS = 2.853

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.738	.695	.714
MINIMUM X	-.814	-.857	-.770
MAXIMUM Y	1.578	1.080	.972
MINIMUM Y	-1.130	-.954	-1.062
CENTROID X	.095	.138	.052
CENTROID Y	.125	-.051	.057
POA TO CENTROID in.	.156	.147	.077
MIN RADIUS	.680	.561	.666
MEAN RADIUS	.996	.900	.878
MAX RADIUS	1.627	1.337	1.198
HORIZONTAL SPREAD	1.552	1.552	1.484
VERTICAL SPREAD	2.708	2.034	2.034
EXTREME SPREAD	2.853	2.446	2.050
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	