

65648973

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

Remington

Remington[®]

MODEL 700TM M24

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

DU PONT
REG. U.S. PAT. & TM. OFF.

SERIAL NO.
C6648973

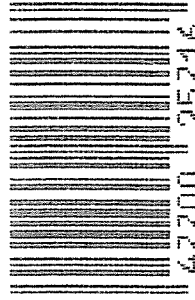
ORDER NO.
5716

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



5716 C6648973

UPC



0 47700 25716 2

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648973

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	YS
	Magnaflux Bolt		JUL 22 1991	YS
615	Rollmark Caliber		JUL 22 1991	YS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7-22-91	SA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	BARBER - M24 0030161 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5 1/4	6	6			9-6-91	DH
	G) Safety Off Force	3	2 1/4	2 1/4			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	.022	.023	.022			9-6-91	DH
	J) Assemble Stock						9/7/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/7/91	RW
	M) Iron Sight Alignment						9/7/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/7/91	RW
	O) Attach Scope to Rifle						9/7/91	RW
	P) Detach & Attach Scope 20 Times						9/8/91	RW
640	Gallery Target & Test						9-9-91	AC
	A) Time						9-9-91	AC
	B) Malfunctions						9-9-91	AC
	C) Pierced Primers						9-9-91	AC
	D) Optical Clarity of Scope						9-9-91	AC
645	Inspect for Live Ammo						9-9-91	AC
655	Final Inspection							
	A) Headspace						9-10-91	DH
	B) Trigger Pull	271	271	261	268	280	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-17-91	DH

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

SERIAL NO. C6648973DATE 9-6-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.50	2.41	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.37	2.38	2.71	
PULL #3	2.41	2.33	2.27	2.61	
PULL #4	2.43	2.34	2.25	2.68	
PULL #5	2.42	2.30	2.33	2.80	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.35		
PULL #2	3.31	3.31		
PULL #3	3.38	3.15		
PULL #4	3.39	3.26		
PULL #5	3.37	3.33		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.58		4.23
PULL #2	4.56	4.64		4.29
PULL #3	4.54	4.53		4.13
PULL #4	4.70	4.54		4.35
PULL #5	4.67	4.40		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS

FOR RIFLE # 06648973

9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.203686
1 TO	2	.139014
1 TO	3	.245524
1 TO	4	.296071
1 TO	5	.440438

542 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .024
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .024891

THE AMR FOR THIS RIFLE IS: .8242

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648973

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 9

HS= 2.328

VS= 2.629

GS= 3.119

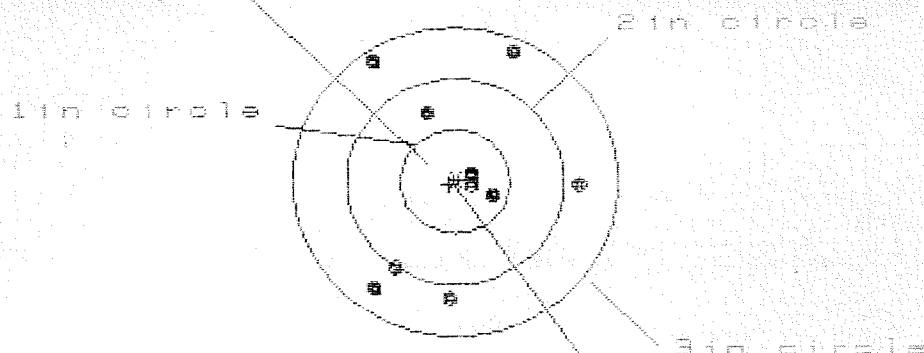
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.396	.974	1.067
MINIMUM X	-.932	-.777	-.684
MAXIMUM Y	1.411	1.391	1.258
MINIMUM Y	-1.218	-1.061	-.640
CENTROID X	.192	.037	-.056
CENTROID Y	.068	-.089	.044
POA TO CENTROID in.	.204	.096	.071
MIN RADIUS	.289	.404	.296
MEAN RADIUS	.963	.811	.742
MAX RADIUS	1.985	1.423	1.275
HORIZONTAL SPREAD	2.328	1.751	1.751
VERTICAL SPREAD	2.629	2.452	1.898
EXTREME SPREAD	3.119	2.665	2.072
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6648973

CENTERFIRE PATTERNS # 2

POR



OF SHOTS- 10

IN CIR

1in = 3

2in = 5

3in = 10

HS= 1.936

VS= 2.420

GS= 2.675

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.136	1.198	1.113
MINIMUM X	-.790	-.728	-.813
MAXIMUM Y	1.271	1.278	1.957
MINIMUM Y	-1.149	-1.008	-.848
CENTROID X	.058	-.004	.081
CENTROID Y	.031	-.110	-.270
POR TO CENTROID in.	.066	.110	.282
MIN RADIUS	.098	.193	.282
MEAN RADIUS	.872	.825	.744
MAX RADIUS	1.388	1.448	1.153
HORIZONTAL SPREAD	1.926	1.926	1.926
VERTICAL SPREAD	2.420	2.286	1.805
EXTREME SPREAD	2.675	2.396	2.189
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		10	

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FILE:/PATTERNING/CENTERFIRE_PATT/C6648973

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS= 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 1.383

VS= 2.312

GS= 2.320

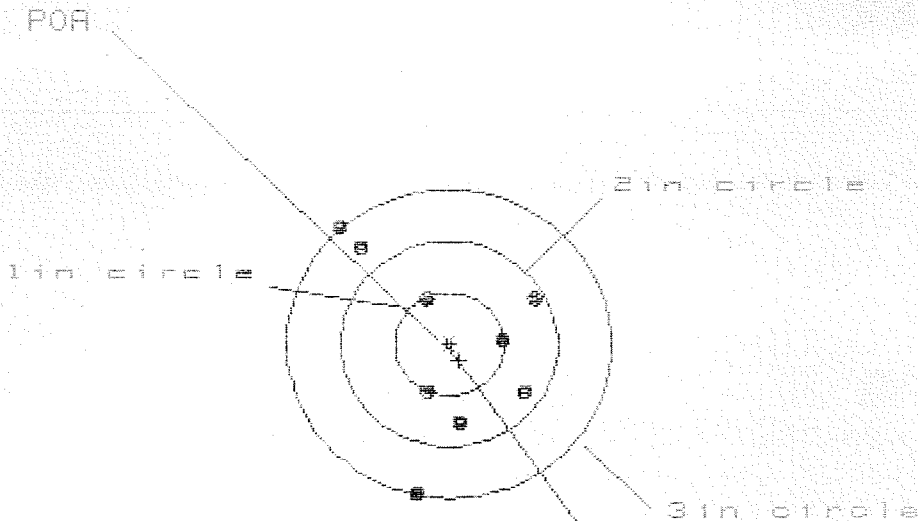
CENTROID #

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.716	.752	.821
MINIMUM X	-.667	-.631	-.562
MAXIMUM Y	1.065	.927	.554
MINIMUM Y	-1.247	-.793	-.677
CENTROID X	.051	.015	-.054
CENTROID Y	-.133	.005	-.111
POA TO CENTROID in.	.143	.016	.123
MIN RADIUS	.272	.307	.195
MEAN RADIUS	.710	.636	.554
MAX RADIUS	1.289	1.093	1.064
HORIZONTAL SPREAD	1.383	1.383	1.383
VERTICAL SPREAD	2.312	1.720	1.232
EXTREME SPREAD	2.320	1.732	1.729
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

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CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 1.785

VS = 2.582

GS = 2.665

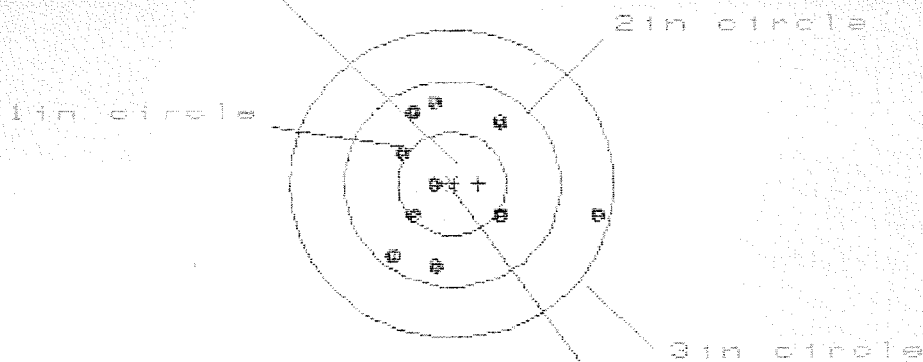
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.778	.666	.609
MINIMUM X	:	-1.007	-.940	-1.997
MAXIMUM Y	:	1.167	1.026	.865
MINIMUM Y	:	-1.415	-1.285	-.738
CENTROID X	:	-.091	.021	.078
CENTROID Y	:	.155	.025	.186
POA TO CENTROID in.	:	.179	.033	.201
MIN RADIUS	:	.447	.365	.278
MEAN RADIUS	:	.870	.765	.672
MAX RADIUS	:	1.542	1.392	1.320
HORIZONTAL SPREAD	:	1.785	1.606	1.606
VERTICAL SPREAD	:	2.582	2.311	1.603
EXTREME SPREAD	:	2.665	2.361	2.078
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

5 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C884B373

CENTERFIRE PATTERNS # 5

FOR



OF SHOTS - 10

IN CIR

1in = 2

2in = 9

3in = 10

HS = 1.907

VS = 1.580

GS = 2.043

CENTROID *

PATTERN #	1	5	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.369	.576	.520
MINIMUM X	-.538	-.386	-.391
MAXIMUM Y	.794	.757	.670
MINIMUM Y	-.786	-.823	-.910
CENTROID X	-.243	-.395	-.347
CENTROID Y	-.001	.036	.123
POA TO CENTROID in.	.243	.397	.368
MIN RADIUS	.121	.041	.078
MEAN RADIUS	.706	.598	.573
MAX RADIUS	1.409	.824	.913
HORIZONTAL SPREAD	1.907	.962	.919
VERTICAL SPREAD	1.580	1.580	1.580
EXTREME SPREAD	2.043	1.581	1.581
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	