

C6636313

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st		
7-18-91		after hits stuck	KS
	2nd		
7/18/91		FILED STOCK <u>REP'D</u>	<u>KS</u>
	3rd		
	4th		

FUNCTION _____ RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

Remington®
REG. U.S. PAT. & TM. OFF.

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

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

MODEL 700™ M24

SERIAL NO.
C6636313

ORDER NO.
5716

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

20

5716 C6636313

UPC
0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6636313

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	5/3/91	KS
600	Proof		5/3/91	KS
607	Check Headspace		5/3/91	KS
610	Dis-assemble Gun		5/3/91	KS
612	Magnaflux Barrel Action	5 8 9 1		KCK
	Magnaflux Bolt	5 8 9 1		KCK
615	Rollmark Caliber	5 8 9 1		GB.
617	Drill and Tap Sight Holes	5 15 9 1		LB
618	Polish Barrel	5 15 9 1		WB
620	Apply Coatings (Barrel Action)		5-25-91	JA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/4/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/4/91	KS
	C) Inspect Ejector Hole for Chamfer		6/4/91	KS
	D) Oil Firing Pin Ass'y		6/4/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-5-91	GM

~~REAR SEAT~~

op. #	BARBER - M24 0032926	READINGS			DATE	INIT
625 cont.	F) Safety On Force	6	6	6	6/5/91	JH
	G) Safety Off Force	4	4	4	6-5-91	JH
	H) Trigger Pull Test & Retainability				6-5-91	JH
	I) Firing Pin Indent	.022	.022	.022	6-5-91	JH
	J) Assemble Stock				7/16/91	KS
	K) Assemble Swivel Studs				7-23-91	DH
	L) Attach Front and Rear Sight Assemblies				7/16/91	KS
	M) Iron Sight Alignment				7/16/91	KS
	N) Detach Front & Rear Sights & place in numbered container				7/16/91	KS
	O) Attach Scope to Rifle				7/16/91	KS
	P) Detach & Attach Scope 20 Times				7/16/91	KS
640	Gallery Target & Test				7-18-91	DH
	A) Time				7-18-91	DH
	B) Malfunctions				7-18-91	DH
	C) Pierced Primers				7-18-91	DH
	D) Optical Clarity of Scope				7-18-91	DH
645	Inspect for Live Ammo				7-18-91	DH
655	Final Inspection				7-23-91	DH
	A) Headspace				7-23-91	DH
	B) Trigger Pull	2.57	2.52	2.35	7-23-91	JH
	C) Function				7-23-91	DH
660	Pack				7-17-91	DH

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

SERIAL NO. C6636313DATE 6-17-91TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.45	2.46	2.74	2.51	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.27	2.72	2.52	
PULL #3	2.39	2.47	2.70	2.35	
PULL #4	2.44	2.45	2.71	2.43	
PULL #5	2.45	2.57	2.72	2.40	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.38		
PULL #2	3.38	3.48		
PULL #3	3.25	3.42		
PULL #4	3.32	3.33		
PULL #5	3.35	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.27		4.36
PULL #2	4.19	4.28		4.20
PULL #3	4.16	4.27		4.24
PULL #4	4.20	4.28		4.26
PULL #5	4.24	4.23		4.11
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636313
18 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.241748
1 TO 2	.639088
1 TO 3	.202872
1 TO 4	.0922008
1 TO 5	.56978

24 -> FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0436
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0450156

THE AMR FOR THIS RIFLE IS: .9058

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE PATT/C8696313

CENTERFIRE PATTERNS

1

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 7

2in = 8

3in = 10

HS= 1.868

VS= 1.214

GS= 2.019

CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.951	.999	.898
MINIMUM X	-.917	-.812	-.201
MAXIMUM Y	.815	.584	.186
MINIMUM Y	-.400	-.309	-.236
CENTROID X	.241	.136	.237
CENTROID Y	.019	-.072	-.145
POB TO CENTROID in.	.242	.154	.278
MIN RADIUS	.091	.031	.117
MEAN RADIUS	.475	.330	.278
MAX RADIUS	1.252	1.046	.928
HORIZONTAL SPREAD	1.868	1.811	1.099
VERTICAL SPREAD	1.214	.893	.422
EXTREME SPREAD	2.019	2.019	1.161
NUMBER IN ONE INCH CIRCLE =	7		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C866313

CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 5

HS= 3.296

VS= 2.381

CS= 3.859

CENTROID #

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.615	1.428	1.386
MINIMUM X	-1.681	-1.822	-1.643
MAXIMUM Y	.927	.807	.783
MINIMUM Y	-1.454	-1.574	-1.473
CENTROID X	-.392	-.205	-.384
CENTROID Y	-.069	.051	-.050
POA TO CENTROID in.	.398	.211	.387
MIN RADIUS	.369	.263	.349
MEAN RADIUS	1.330	1.220	1.177
MAX RADIUS	1.998	1.983	1.722
HORIZONTAL SPREAD	3.296	3.250	3.029
VERTICAL SPREAD	2.381	2.381	2.176
EXTREME SPREAD	3.859	3.452	3.098
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	5		

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B3B313

CENTERFIRE PATTERNS

3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS = 2.401

VS = 2.366

GS = 2.602

PATTERN #

3

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.091

.970

.932

MINIMUM X

-1.310

-1.431

-1.469

MAXIMUM Y

1.401

1.293

.710

MINIMUM Y

-.965

-.948

-.786

CENTROID X

.082

.203

.241

CENTROID Y

-.107

.001

-.161

POA TO CENTROID in.

.135

.203

.290

MIN RADIUS

.355

.298

.359

MEAN RADIUS

.919

.833

.769

MAX RADIUS

1.457

1.443

1.508

HORIZONTAL SPREAD

2.401

2.401

2.401

VERTICAL SPREAD

2.366

2.241

1.504

EXTREME SPREAD

2.602

2.602

2.602

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

6

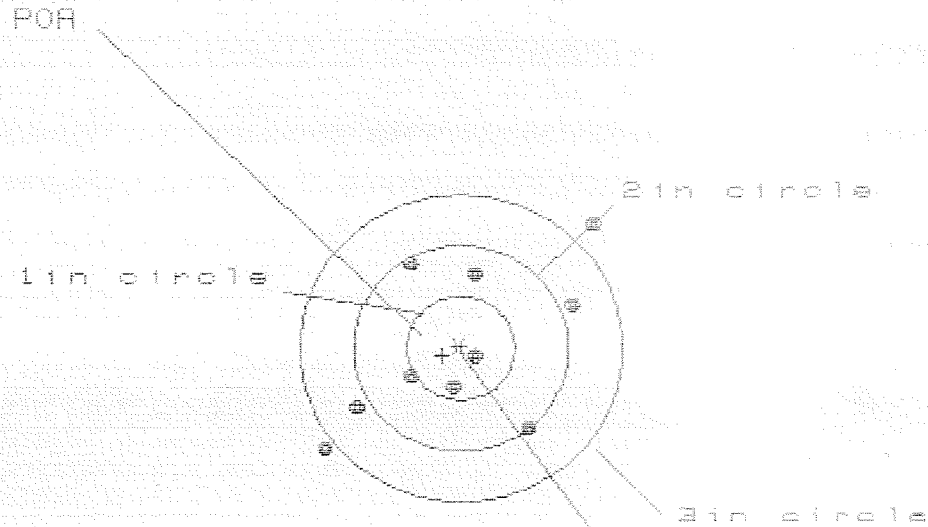
NUMBER IN THREE INCH CIRCLE =

10

18 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CAB36313

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.515

VS= 2.160

GS= 3.315

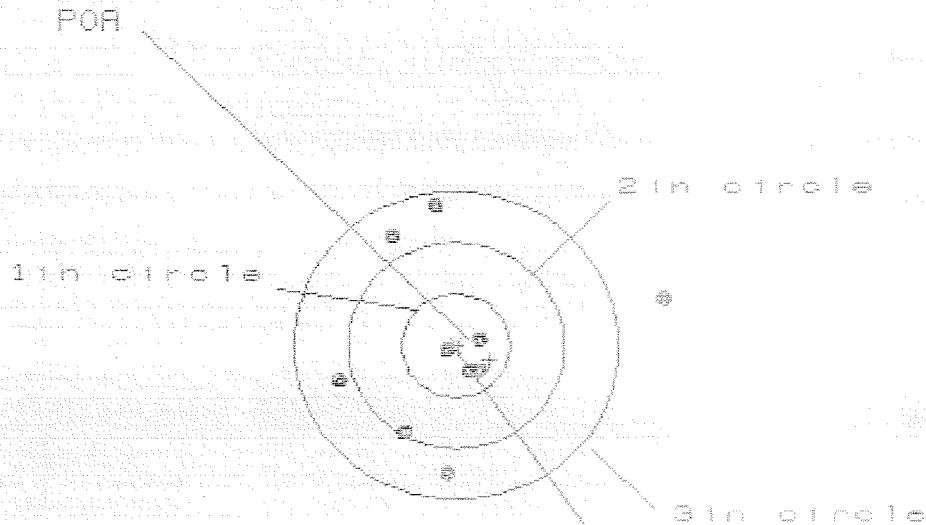
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.235	1.196	1.053
MINIMUM X	-1.280	-1.143	-.991
MAXIMUM Y	1.184	.941	.835
MINIMUM Y	-.976	-.844	-.794
CENTROID X	.167	.030	.173
CENTROID Y	.074	-.058	.048
POA TO CENTROID in.	.183	.065	.179
MIN RADIUS	.180	.285	.168
MEAN RADIUS	.933	.830	.749
MAX RADIUS	1.711	1.421	1.134
HORIZONTAL SPREAD	2.515	2.339	2.044
VERTICAL SPREAD	2.160	1.785	1.629
EXTREME SPREAD	3.315	2.711	2.253
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

18 Jul 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C6636313

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 9

HS= 2.995

VS= 2.622

CS= 3.109

PATTERN #

5

	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.914	.420	.424
MINIMUM X	-1.080	-.068	-.064
MAXIMUM Y	1.370	1.424	1.260
MINIMUM Y	-1.252	-1.198	-1.020
CENTROID X	-.316	-.528	-.532
CENTROID Y	.139	.085	-.093
POA TO CENTROID in.	.345	.535	.541
MIN RADIUS	.112	.116	.213
MEAN RADIUS	.872	.761	.664
MAX RADIUS	1.976	1.425	1.300
HORIZONTAL SPREAD	2.995	1.288	1.288
VERTICAL SPREAD	2.622	2.622	2.280
EXTREME SPREAD	3.109	2.622	2.316
NUMBER IN ONE INCH CIRCLE	=	4	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	9	