

06636332

MODEL 760™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.

Remington

Remington®
MODEL 700™ M24

DUPONT
REGISTERED TRADE MARK

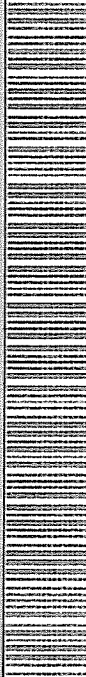
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

SERIAL NO.
C6606332

ORDER NO.
5716

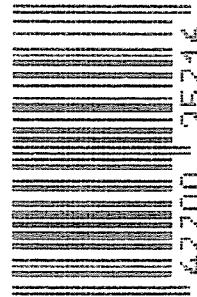
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada. Marque Deposee.

20



5716 C6606332

UPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636332

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5 6	91	KCK
	Magnaflux Bolt	5 6	91	KCK
615	Rollmark Caliber	5 6	91	GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-70-91	FB
	Apply Coating (Bolt)		5-70-91	FB
625	Final Assembly			
	A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-17-91	SH

op. #	BARBER M24 0033146	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	JH
	G) Safety Off Force	3	3	3			7-17-91	JH
	H) Trigger Pull Test & Retainability						7-17-91	JH
	I) Firing Pin Indent	.023	.023	.023			7-17-91	JH
	J) Assemble Stock						7/26/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						7/26/91	RW
	M) Iron Sight Alignment						7/26/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/26/91	RW
	O) Attach Scope to Rifle						7/26/91	RW
	P) Detach & Attach Scope 20 Times						7/26/91	RW
640	Gallery Target & Test						7-27-91	DH
	A) Time						7-27-91	DH
	B) Malfunctions						7-27-91	DH
	C) Pierced Primers						7-27-91	DH
	D) Optical Clarity of Scope						7-27-91	DH
645	Inspect for Live Ammo						7-27-91	DH
655	Final Inspection							
	A) Headspace						8-6-91	AC
	B) Trigger Pull	2.21	2.28	2.20	2.20	2.15	8-5-91	JH
	C) Function						8-6-91	AC
660	Pack						9-19-91	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 0-6636332

DATE 7-17-91

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.30	2.26	2.34	2.21	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.27	2.25	2.28	
PULL #3	2.26	2.26	2.30	2.20	
PULL #4	2.21	2.20	2.33	2.20	
PULL #5	2.26	2.16	2.35	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.32		
PULL #2	3.20	3.29		
PULL #3	3.32	3.14		
PULL #4	3.36	3.33		
PULL #5	3.21	3.39		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.48		4.36
PULL #2	4.26	4.48		4.51
PULL #3	4.26	4.40		4.19
PULL #4	4.22	4.48		4.51
PULL #5	4.17	4.50		4.19
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06636332
30 Jul 1991

CENTROIDAL DISTANCES

0 TO	1	.22205
1 TO	2	.440202
1 TO	3	.153847
1 TO	4	.196499
1 TO	5	.239253

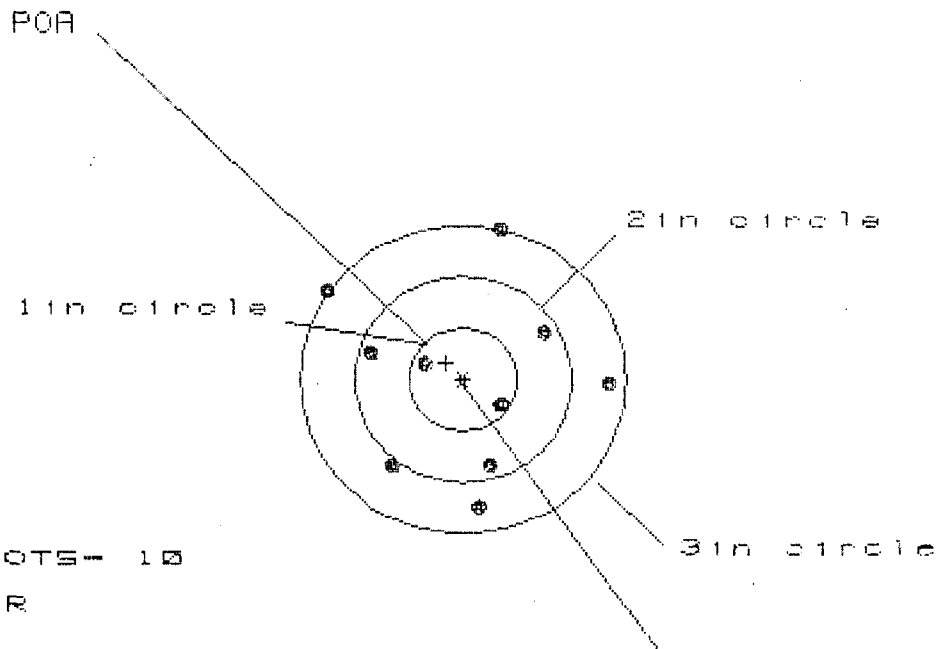
96 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .125
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .032
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129031
THE AMR FOR THIS RIFLE IS: 1.064

30 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6636332

CENTERFIRE PATTERNS, # 1



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 9

HS= 2.520

VS= 2.646

GS= 2.696

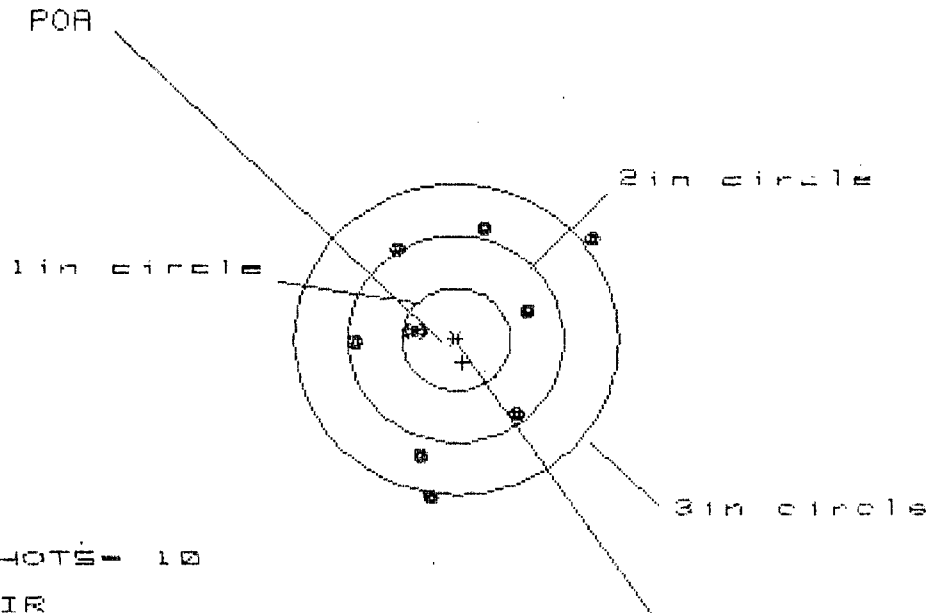
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.308	1.173	1.195
MINIMUM X	-1.212	-.957	-.935
MAXIMUM Y	1.435	1.535	.719
MINIMUM Y	-1.211	-1.111	-.919
CENTROID X	.155	.290	.268
CENTROID Y	-.159	-.259	-.451
POA TO CENTROID in.	.223	.389	.525
MIN RADIUS	.407	.240	.191
MEAN RADIUS	.995	.918	.813
MAX RADIUS	1.510	1.545	1.218
HORIZONTAL SPREAD	2.520	2.130	2.130
VERTICAL SPREAD	2.646	2.646	1.639
EXTREME SPREAD	2.696	2.649	2.149
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.276

VS= 2.646

GS= 2.949

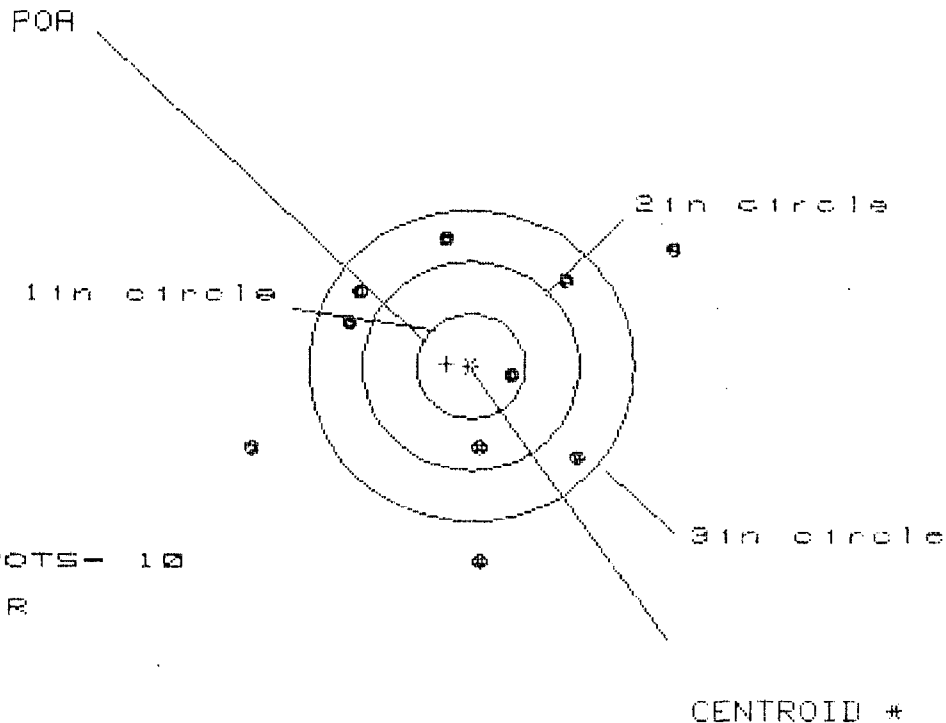
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	.839	.828
MINIMUM X	:	-.980	-.836	-.847
MAXIMUM Y	:	1.112	1.222	1.044
MINIMUM Y	:	-1.534	-1.424	-1.176
CENTROID X	:	-.062	-.206	-.195
CENTROID Y	:	.224	.114	.292
POA TO CENTROID in.	:	.232	.235	.351
MIN RADIUS	:	.375	.301	.231
MEAN RADIUS	:	1.001	.908	.820
MAX RADIUS	:	1.631	1.427	1.189
HORIZONTAL SPREAD	:	2.276	1.675	1.675
VERTICAL SPREAD	:	2.646	2.646	2.220
EXTREME SPREAD	:	2.949	2.697	2.299
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 2

3in = 7

HS= 3.960

VS= 3.036

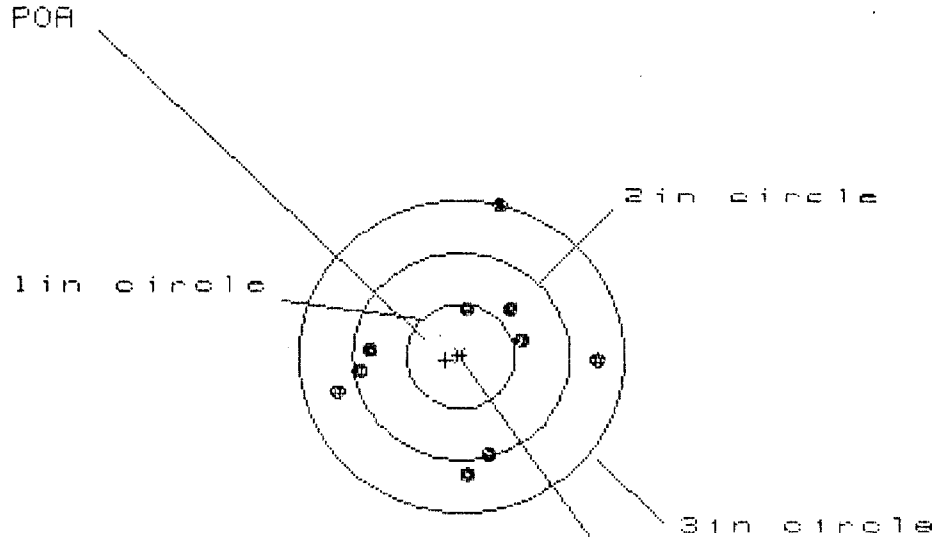
GS= 4.369

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.920
MINIMUM X	-2.040
MAXIMUM Y	1.197
MINIMUM Y	-1.839
CENTROID X	.225
CENTROID Y	-.022
POA TO CENTROID in.	.226
MIN RADIUS	.429
MEAN RADIUS	1.365
MAX RADIUS	2.214
HORIZONTAL SPREAD	3.960
VERTICAL SPREAD	3.036
EXTREME SPREAD	4.369
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	2
NUMBER IN THREE INCH CIRCLE =	7

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.426

VS= 2.568

GS= 2.586

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.300	1.336	.809
MINIMUM X	:	-1.126	-1.090	-.923
MAXIMUM Y	:	1.431	.671	.684
MINIMUM Y	:	-1.137	-.979	-.966
CENTROID X	:	.141	.105	-.062
CENTROID Y	:	.037	-.122	-.135
POA TO CENTROID in.	:	.146	.161	.149
MIN RADIUS	:	.420	.582	.637
MEAN RADIUS	:	.954	.898	.831
MAX RADIUS	:	1.468	1.340	.992
HORIZONTAL SPREAD	:	2.426	2.426	1.732
VERTICAL SPREAD	:	2.568	1.650	1.650
EXTREME SPREAD	:	2.586	2.437	1.790
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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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 = 2.929

VS = 2.374

GS = 2.930

CENTROID #

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.195	1.003	.813
MINIMUM X	-1.734	-1.515	-.722
MAXIMUM Y	.926	.891	.993
MINIMUM Y	-1.448	-1.483	-1.381
CENTROID X	.166	.358	.548
CENTROID Y	.080	.115	.013
POA TO CENTROID in.	.184	.376	.548
MIN RADIUS	.066	.151	.167
MEAN RADIUS	1.006	.899	.785
MAX RADIUS	1.763	1.721	1.384
HORIZONTAL SPREAD	2.929	2.518	1.535
VERTICAL SPREAD	2.374	2.374	2.374
EXTREME SPREAD	2.930	2.813	2.374
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	