

C6648930

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Remington
MODEL 700™ M24

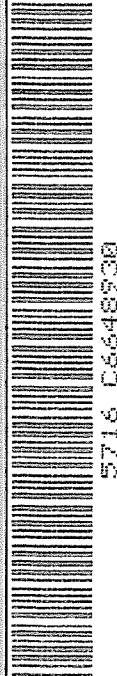
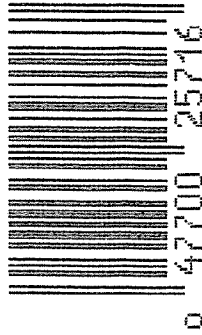
VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

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

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

SERIAL NO. C6648930	20
ORDER NO. 5716	

LPC



5716 C6648930

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648930

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	LS
	Magnaflux Bolt		JUL 22 1991	LS
615	Rollmark Caliber		JUL 22 1991	LS
617	Drill and Tap Sight Holes		JUL 22 1991	LB
618	Polish Barrel		7/22/91	WB
620	Apply Coatings (Barrel Action)		7/22/91	LS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-15-91	JH

op. #	BARBER, M24 0033456 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8-15-91	JH
	G) Safety Off Force	2	2	2			8-15-91	JH
	H) Trigger Pull Test & Retainability						8-15-91	JH
	I) Firing Pin Indent	.0215	.021	.021			8-15-91	JH
	J) Assemble Stock						8-16-91	RW
	K) Assemble Swivel Studs						8-17-91	D/H
	L) Attach Front and Rear Sight Assemblies						8-16-91	RW
	M) Iron Sight Alignment						8-16-91	RW
	N) Detach Front & Rear Sights & place in numbered container						8-16-91	RW
	O) Attach Scope to Rifle						8-16-91	RW
	P) Detach & Attach Scope 20 Times						8-16-91	RW
640	Gallery Target & Test						8-16-91	AC
	A) Time						8-16-91	AC
	B) Malfunctions						8-16-91	AC
	C) Pierced Primers						8-16-91	AC
	D) Optical Clarity of Scope						8-16-91	AC
645	Inspect for Live Ammo						8-16-91	AC
655	Final Inspection						8-17-91	D/H
	A) Headspace							
	B) Trigger Pull	272	268	277	277	280	8-17-91	D/H
	C) Function						8-17-91	D/H
660	Pack						9-19-91	AF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C 6648930DATE 8-15-91TESTER JLL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.60	2.15	2.40	2.72	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.32	2.39	2.44	2.68	
PULL #3	2.42	2.49	2.39	2.77	
PULL #4	2.32	2.44	2.20	2.77	
PULL #5	2.45	2.39	2.41	2.80	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.58	3.22		
PULL #2	3.54	3.20		
PULL #3	3.54	3.18		
PULL #4	3.29	3.20		
PULL #5	3.60	3.19		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.29	4.45		4.48
PULL #2	4.52	4.47		4.49
PULL #3	4.44	4.48		4.44
PULL #4	4.49	4.43		4.15
PULL #5	4.49	4.44		4.53
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648930
22 Aug 1991

CENTROIDAL DISTANCES

0 TO	1	.285007
1 TO	2	.310105
1 TO	3	.445892
1 TO	4	.355844
1 TO	5	.448657

1
95 <----POR

THIS RIFLE IS: -.044
THIS RIFLE IS: -.0064
RIS FOR THIS RIFLE IS: .044463
..7842

22 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C864B930

CENTERFIRE PATTERNS # 1

POR

1 in circle

2 in circle

3 in circle

* OF SHOTS = 10

IN CIR

1 1

2 3

3 6

X = 6.830

Y = 6.820

Z = 6.780

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POR TO CENTROID in.

4 in RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

DIAGN. SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

10

9

8

.948

.771

.655

-1.590

-1.044

-.948

.556

.585

.492

-.772

-.744

-.767

.002

.179

.083

.285

.256

.349

.285

.313

.359

.315

.309

.224

.811

.690

.638

1.611

1.072

.948

2.538

1.815

1.603

1.329

1.329

1.259

2.738

1.999

1.656

1

8

9

22 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8646930

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HSE = 2.155

VSE = 1.988

CE = 2.238

CENTROID #

PATTERN #

2

SHOTS (BEST OF)

10

9

8

MAXIMUM X

.907

.809

.641

MINIMUM X

-1.249

-1.347

-.521

MAXIMUM Y

1.212

.685

.649

MINIMUM Y

-.776

-.641

-.677

CENTROID X

-.127

-.029

.139

CENTROID Y

.003

-.132

-.096

POA TO CENTROID in.

.127

.135

.169

MIN RADIUS

.268

.258

.086

MEAN RADIUS

.755

.645

.517

MAX RADIUS

1.498

1.377

.767

HORIZONTAL SPREAD

2.156

2.156

1.162

VERTICAL SPREAD

1.988

1.326

1.326

EXTREME SPREAD

2.238

2.175

1.457

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

8

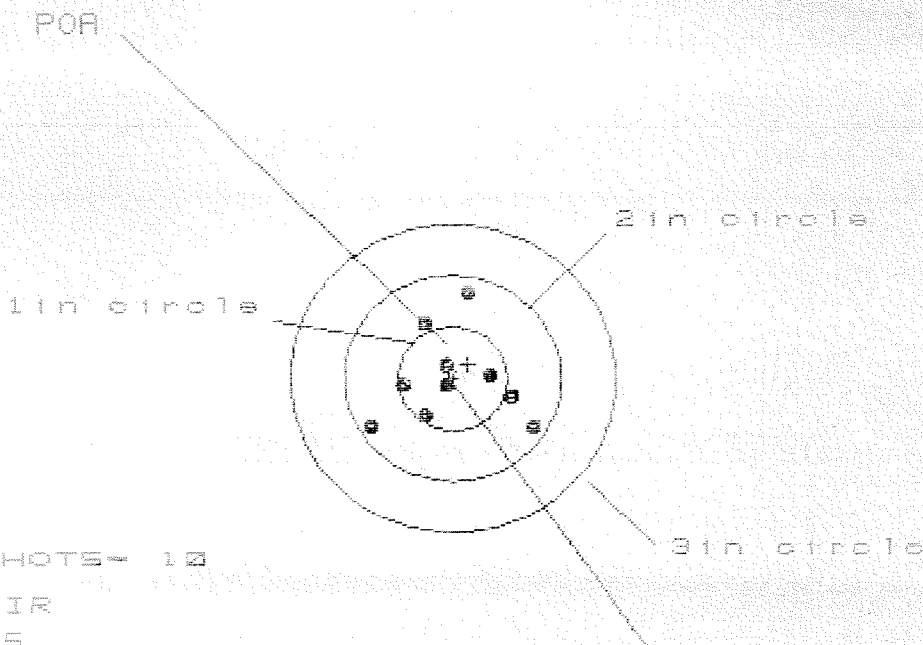
NUMBER IN THREE INCH CIRCLE =

10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B4B930

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 10

3in = 10

HS= 1.475

VS= 1.244

GS= 1.536

CENTROID *

PATTERN #

SHOTS (BEST OF)

MAXIMUM X

MINIMUM X

MAXIMUM Y

MINIMUM Y

CENTROID X

CENTROID Y

POA TO CENTROID in.

MIN RADIUS

MEAN RADIUS

MAX RADIUS

HORIZONTAL SPREAD

VERTICAL SPREAD

EXTREME SPREAD

NUMBER IN ONE INCH CIRCLE =

NUMBER IN TWO INCH CIRCLE =

NUMBER IN THREE INCH CIRCLE =

3

10

9

8

.727

.644

.492

-.748

-.502

-.421

.794

.747

.685

-.450

-.497

-.442

-.142

-.059

-.140

-.137

-.090

-.028

.197

.108

.142

.122

.209

.111

.523

.489

.438

.860

.814

.709

1.475

1.146

.913

1.244

1.244

1.127

1.536

1.411

1.206

5

10

10

22 Aug 1931

FILE:/PATTERNING/CENTERFIRE_PATT/C8848930

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS = 2.713

VS = 1.899

GS = 2.713

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.363

.925

.775

MINIMUM X

-1.350

-1.199

-.890

MAXIMUM Y

.873

.855

.838

MINIMUM Y

-1.026

-1.044

-1.060

CENTROID X

-.118

-.269

-.119

CENTROID Y

-.050

-.032

-.016

POA TO CENTROID in.

.128

.271

.120

MIN RADIUS

.033

.137

.015

MEAN RADIUS

.878

.832

.754

MAX RADIUS

1.373

1.206

1.171

HORIZONTAL SPREAD

2.713

2.124

1.665

VERTICAL SPREAD

1.899

1.899

1.899

EXTREME SPREAD

2.713

2.235

2.051

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

7

NUMBER IN THREE INCH CIRCLE =

10

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8848930

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 9

HS = 2.136

VS = 2.751

GS = 2.754

CENTROID #

PATTERN #

5

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.130

1.103

.986

MINIMUM X

-1.006

-1.033

-1.149

MAXIMUM Y

1.209

1.037

1.142

MINIMUM Y

-1.542

-.945

-.840

CENTROID X

.165

.192

.308

CENTROID Y

-.133

.039

-.066

POA TO CENTROID in.

.212

.196

.315

MIN RADIUS

.185

.035

.135

MEAN RADIUS

.954

.859

.803

MAX RADIUS

1.561

1.382

1.234

HORIZONTAL SPREAD

2.136

2.136

2.136

VERTICAL SPREAD

2.751

1.982

1.982

EXTREME SPREAD

2.754

2.630

2.439

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

9