

C6648939

MODEL 760TM M24

Model **SMS**TM

Action

Barrel Length

Capacity

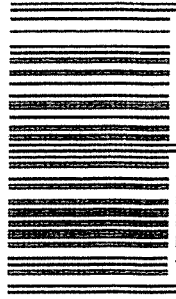
Order No. **5716**

*Includes 1 in chamber.

Remington

Remington REG. U.S. PAT. & TM. OFF.		DU PONT REG. U.S. PAT. & TM. OFF.		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.	
MODEL 700™ M24		SERIAL NO. C6648939		ORDER NO. 5716	
MADE IN LILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.					

UPC



0 47700 25716 7



5716 C6648939

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6648939

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	2 0 1		Rw
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
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	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/29/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/29/91	Rw
	C) Inspect Ejector Hole for Chamfer		9/29/91	Rw
	D) Oil Firing Pin Ass'y		9/29/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		9/11/91	SM

op. #	BARBER M24 0033557	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			9/11/91	JH
	G) Safety Off Force	3	3	3			9/11/91	JH
	H) Trigger Pull Test & Retainability						9/11/91	JH
	I) Firing Pin Indent	.0215	.0215	.021			9/11/91	JH
	J) Assemble Stock						9/13/91	Rev
	K) Assemble Swivel Studs						9-14-91	DH
	L) Attach Front and Rear Sight Assemblies						9/13/91	Rev
	M) Iron Sight Alignment						9/15/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						9/13/91	Rev
	O) Attach Scope to Rifle						9/13/91	Rev
	P) Detach & Attach Scope 20 Times						9/13/91	Rev
640	Gallery Target & Test						9/13/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						9/13/91	KT
655	Final Inspection							
	A) Headspace						9-14-91	DH
	B) Trigger Pull	2.45	2.55	2.44	2.58	2.46	9-14-91	JH
	C) Function						9-14-91	DH
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. C6648939DATE 9-11-91TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.31	2.42	2.40	2.45	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.27	2.40	2.42	2.55	
PULL #3	2.23	2.36	2.44	2.44	
PULL #4	2.20	2.34	2.39	2.58	
PULL #5	2.26	2.36	2.36	2.66	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.32		
PULL #2	3.60	3.57		
PULL #3	3.24	3.39		
PULL #4	3.38	3.44		
PULL #5	3.44	3.61		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.67		4.50
PULL #2	4.32	4.63		4.50
PULL #3	4.43	4.64		4.41
PULL #4	4.63	4.69		4.34
PULL #5	4.49	4.56		4.62
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6648939
13 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.577848
1 TO	2	.547537
1 TO	3	.150881
1 TO	4	.173925
1 TO	5	.439606

5.4
f 3) <----POR

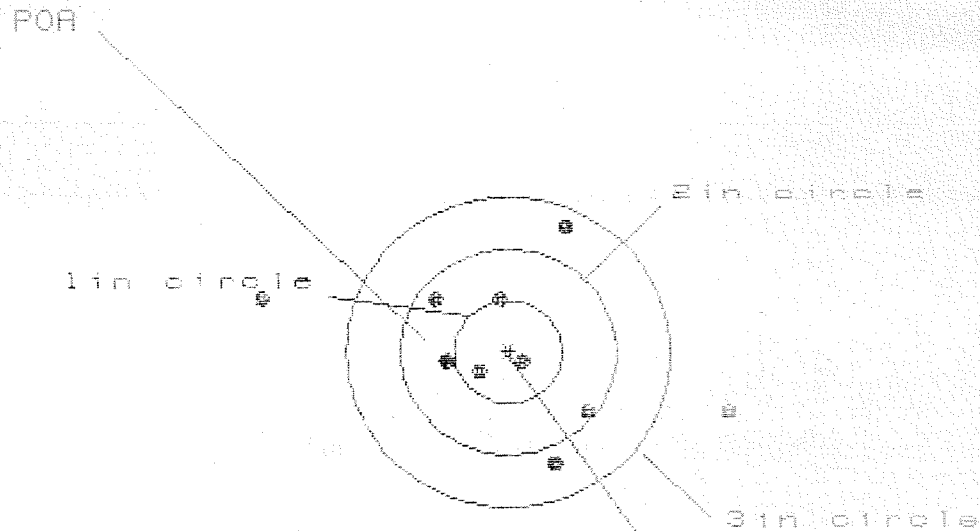
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3426
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .19
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .391759

THE AMR FOR THIS RIFLE IS: 1.047

13 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08648939

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 4.364

VS= 2.273

GS= 4.488

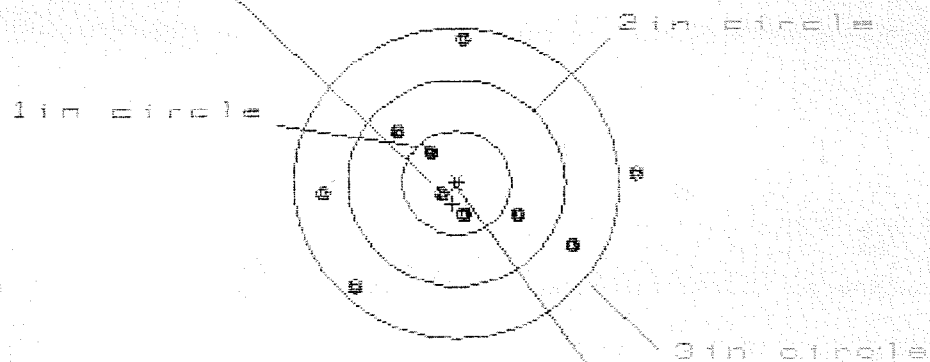
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.066	1.811	.661
MINIMUM X	-2.298	-.951	-.725
MAXIMUM Y	1.212	1.265	1.200
MINIMUM Y	-1.061	-1.008	-1.073
CENTROID X	.572	.827	.601
CENTROID Y	.082	.029	.094
POA TO CENTROID in.	.578	.827	.608
MIN RADIUS	.144	.166	.135
MEAN RADIUS	1.829	1.907	.728
MAX RADIUS	2.348	1.884	1.299
HORIZONTAL SPREAD	4.364	2.762	1.386
VERTICAL SPREAD	2.273	2.273	2.273
EXTREME SPREAD	4.490	2.962	2.274
NUMBER IN ONE INCH CIRCLE	=	2	
NUMBER IN TWO INCH CIRCLE	=	6	
NUMBER IN THREE INCH CIRCLE	=	8	

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FILE:/PATTERNING/CENTERFIRE_PATT/C864B333

CENTERFIRE PATTERNS # 2

POA



OF SHOTS = 10

IN CIR

1in = 3

2in = 5

3in = 9

CENTROID *

HS= 2.884

VS= 2.436

GS= 2.892

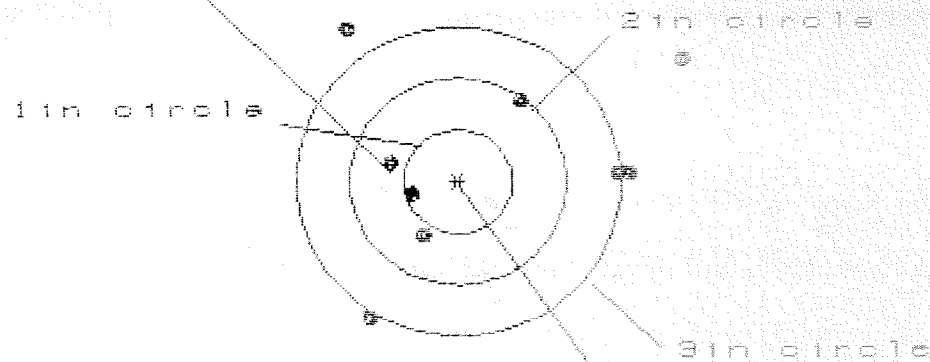
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.623	1.222	1.125
MINIMUM X	-1.261	-1.080	-1.177
MAXIMUM Y	1.398	1.408	1.280
MINIMUM Y	-1.038	-1.028	-0.680
CENTROID X	.038	-.143	-.046
CENTROID Y	.203	.193	.321
POA TO CENTROID in.	.205	.240	.325
MIN RADIUS	.187	.085	.226
MEAN RADIUS	.913	.812	.758
MAX RADIUS	1.626	1.422	1.315
HORIZONTAL SPREAD	2.884	2.302	2.302
VERTICAL SPREAD	2.436	2.436	1.960
EXTREME SPREAD	2.892	2.621	2.343
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 3

FOR



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 4.473

VS= 3.376

GS= 5.483

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.039	1.769	1.514
MINIMUM X	-2.434	-1.280	-1.059
MAXIMUM Y	1.492	1.282	1.399
MINIMUM Y	-1.884	-1.481	-1.364
CENTROID X	.425	.695	.474
CENTROID Y	.116	.325	.208
FOR TO CENTROID in.	.440	.767	.518
MIN RADIUS	.452	.631	.528
MEAN RADIUS	1.443	1.268	1.135
MAX RADIUS	3.078	2.002	1.755
HORIZONTAL SPREAD	4.473	3.049	2.573
VERTICAL SPREAD	3.376	2.763	2.763
EXTREME SPREAD	5.483	3.723	2.935
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

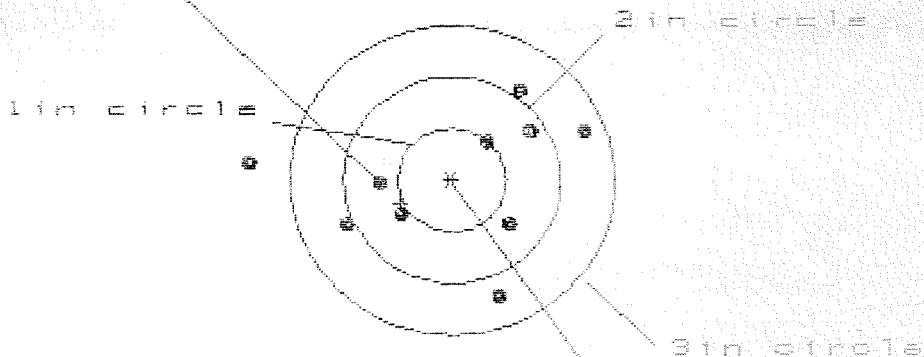
[8 Sep 1991]

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 5

3 in = 9

HS= 3.113

VS= 1.918

GS= 3.130

CENTROID *

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.219	1.008	.672
MINIMUM X	-1.894	-1.174	-1.047
MAXIMUM Y	.829	.845	.905
MINIMUM Y	-1.089	-1.073	-1.014
CENTROID X	.473	.684	.557
CENTROID Y	.225	.209	.149
POA TO CENTROID in.	.524	.715	.577
MIN RADIUS	.516	.425	.530
MEAN RADIUS	.976	.850	.814
MAX RADIUS	1.899	1.254	1.115
HORIZONTAL SPREAD	3.113	2.182	1.720
VERTICAL SPREAD	1.918	1.918	1.918
EXTREME SPREAD	3.130	2.368	2.073
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

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FILE:/PATTERNING/CENTERFIRE_PATT/C864B933

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.124

VS= 2.074

GS= 2.889

CENTROID #

PATTERN #	1	5	9
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.868	.728	.814
MINIMUM X	-1.257	-.745	-.659
MAXIMUM Y	1.267	.989	.915
MINIMUM Y	-.807	-.666	-.740
CENTROID X	.205	.344	.258
CENTROID Y	.324	.183	.257
POA TO CENTROID in.	.383	.396	.364
MIN RADIUS	.268	.415	.318
MEAN RADIUS	.875	.759	.733
MAX RADIUS	1.785	1.016	.990
HORIZONTAL SPREAD	2.124	1.473	1.473
VERTICAL SPREAD	2.074	1.655	1.655
EXTREME SPREAD	2.889	1.828	1.733
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	