

06611423

MODEL 760™ M24

Model SMS™

Action

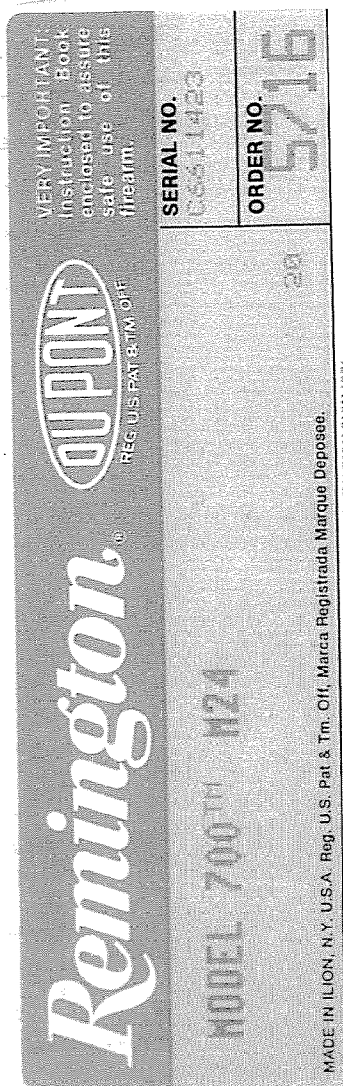
Barrel Length

Capacity

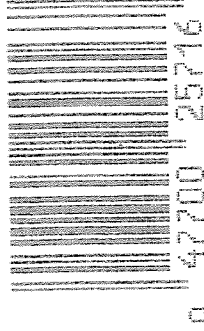
Order No. 5716

* Includes 1 in chamber.

Remington



UPC



GEM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611423

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 25	91	RW
600	Proof	1 25	91	RW
607	Check Headspace	1 25	91	RW
610	Dis-assemble Gun	1 25	91	RW
612	Magnaflux Barrel Action	1 25	91	KR
	Magnaflux Bolt	1 25	91	KR
615	Rollmark Caliber	1 25	91	GS
617	Drill and Tap Sight Holes	1 30	91	FB
618	Polish Barrel <i>RBB</i>	1 30	91	WB
620	Apply Coatings (Barrel Action)		2-10-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/11/91	RW
	C) Inspect Ejector Hole for Chamfer		2/11/91	RW
	D) Oil Firing Pin Ass'y		2/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/18/91	RL

op. #	BARBER M24 0076592	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4	4	4	2/18/91	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4	2 1/4	2 1/4	2/18/91	WB
	H) Trigger Pull Test & Retainability						2/18/91	WB
	I) Firing Pin Indent	.0225	.0225	.0225	.0225	.0225	2/18/91	WB
	J) Assemble Stock						2/19/91	RW
	K) Assemble Swivel Studs						2-22-91	R
	L) Attach Front and Rear Sight Assemblies						2/19/91	RW
	M) Iron Sight Alignment						2/19/91	RW
	N) Detach Front & Rear Sights & place in numbered container						2/19/91	RW
	O) Attach Scope to Rifle						2/19/91	RW
	P) Detach & Attach Scope 20 Times						2/19/91	RW
640	Gallery Target & Test						2-20-91	AC
	A) Time						2-20-91	AC
	B) Malfunctions						2-20-91	AC
	C) Pierced Primers						2-20-91	AC
	D) Optical Clarity of Scope						2-20-91	AC
645	Inspect for Live Ammo						2-20-91	AC
655	Final Inspection						2-22-91	A
	A) Headspace						2-22-91	AC
	B) Trigger Pull	2.59	2.48	2.51	2.51	2.54	2/21/91	WB
	C) Function						2-22-91	AC
660	Pack						3-12-91	VF

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

SERIAL NO. C6611423DATE 2/18/91TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.33	2.44	2.59	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.48	2.47	2.40	2.48	
PULL #3	2.30	2.47	2.46	2.51	
PULL #4	2.30	2.24	2.41	2.51	
PULL #5	2.18	2.53	2.40	2.59	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.22		
PULL #2	3.36	3.25		
PULL #3	3.31	3.21		
PULL #4	3.36	3.27		
PULL #5	3.49	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.31	4.28		4.53
PULL #2	4.44	4.50		4.52
PULL #3	4.22	4.42		4.34
PULL #4	4.40	4.45		4.44
PULL #5	4.36	4.47		4.50
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611423
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.349185
1 TO	2	.428441
1 TO	3	.161471
1 TO	4	.297121
1 TO	5	.718283

44 C----POA

5

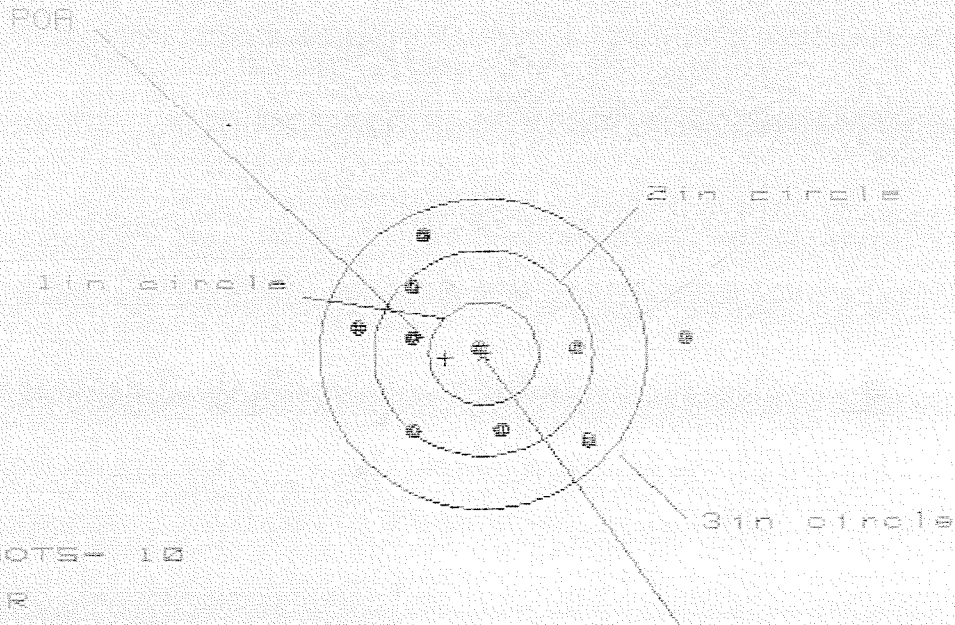
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2128
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2932
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .294235
THE RPF FOR THIS RIFLE IS: .924

20 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11423

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 3.023

VS= 2.062

GS= 3.025

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.930	1.163	1.151
MINIMUM X	-1.193	-0.990	-0.845
MAXIMUM Y	1.179	1.195	1.087
MINIMUM Y	-0.883	-0.867	-0.880
CENTROID X	.347	.144	-0.001
CENTROID Y	.039	.023	.131
POA TO CENTROID in.	.349	.146	.131
MIN RADIUS	.023	.188	.326
MEAN RADIUS	.987	.878	.789
MAX RADIUS	1.835	1.451	1.161
HORIZONTAL SPREAD	3.023	2.153	2.085
VERTICAL SPREAD	2.062	2.062	1.967
EXTREME SPREAD	3.025	2.558	2.038
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

20 Feb 1991

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CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS= 10

IN CIR

1 in = 0

2 in = 4

3 in = 10

HS= 2.078

VS= 2.401

GS= 2.643

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.084	1.127	.969
MINIMUM X	-.994	-.951	-.810
MAXIMUM Y	1.420	1.131	1.072
MINIMUM Y	-.981	-.824	-.883
CENTROID X	-.064	-.107	-.248
CENTROID Y	-.082	-.239	-.190
POA TO CENTROID (in)	.104	.262	.307
MIN RADIUS	.772	.606	.575
MEAN RADIUS	1.074	1.013	.980
MAX RADIUS	1.472	1.295	1.320
HORIZONTAL SPREAD	2.078	2.078	1.779
VERTICAL SPREAD	2.401	1.955	1.955
EXTREME SPREAD	2.643	2.439	2.349
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		10	

28 Feb 1991

FILE: \PATTERNING\CENTERFIRE_PATT\08611423

CENTERFIRE PATTERNS # 3

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 1.592

VS= 2.044

GS= 2.074

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.521	.402	.423
MINIMUM X	-1.071	-1.025	-1.004
MAXIMUM Y	.911	.811	.657
MINIMUM Y	-1.133	-1.233	-.380
CENTROID X	.254	.373	.352
CENTROID Y	-.093	.007	.161
POA TO CENTROID in.	.270	.373	.387
MIN RADIUS	.284	.135	.137
MEAN RADIUS	.694	.551	.450
MAX RADIUS	1.397	1.244	1.073
HORIZONTAL SPREAD	1.592	1.427	1.427
VERTICAL SPREAD	2.044	2.044	1.037
EXTREME SPREAD	2.074	2.074	1.456
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6511423

CENTERFIRE PATTERNS

4

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 0

2in = 4

3in = 10

HS= 2.481

VS= 2.093

CS= 2.487

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.036

.876

.965

MINIMUM X

-1.445

-.782

-.693

MAXIMUM Y

1.094

1.083

.985

MINIMUM Y

-.999

-1.010

-1.108

CENTROID X

.431

.591

.502

CENTROID Y

-.246

-.235

-.137

POR TO CENTROID in.

.496

.636

.520

MIN RADIUS

.683

.602

.731

MEAN RADIUS

1.012

.949

.928

MAX RADIUS

1.448

1.105

1.132

HORIZONTAL SPREAD

2.481

1.658

1.658

VERTICAL SPREAD

2.093

2.093

2.093

EXTREME SPREAD

2.487

2.167

2.134

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

4

NUMBER IN THREE INCH CIRCLE =

10

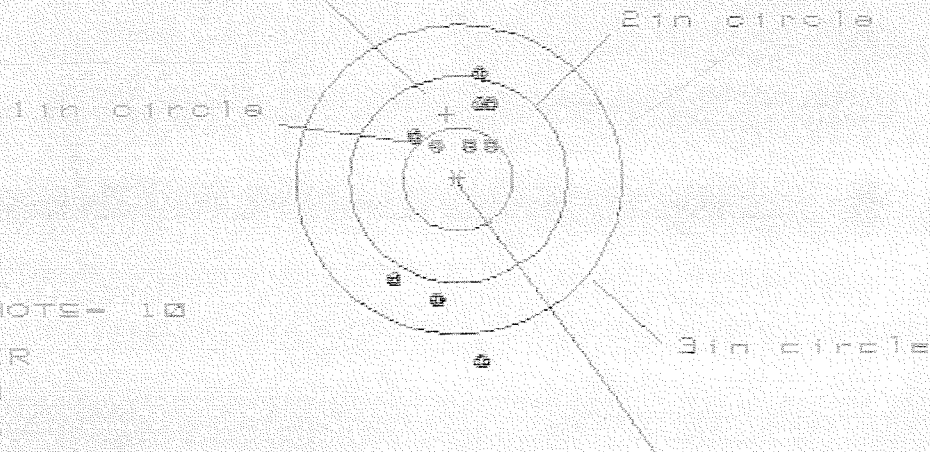
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FILE:/PATTERNING/CENTERFIRE_PATT/08511423

CENTERFIRE PATTERNS

5

POB



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= .876

VS= 2.766

GS= 2.766

CENTROID *

PATTERN #	1	5	9	8
SHOTS (BEST OF)	10	9	9	8
MAXIMUM X	.326	.347	.327	.327
MINIMUM X	-.550	-.529	-.549	-.549
MAXIMUM Y	.988	.790	.617	.617
MINIMUM Y	-1.779	-1.384	-1.345	-1.345
CENTROID X	.096	.074	.094	.094
CENTROID Y	-.634	-.436	-.263	-.263
POB TO CENTROID in.	.641	.442	.279	.279
MIN RADIUS	.347	.174	.091	.091
MEAN RADIUS	.853	.664	.586	.586
MAX RADIUS	1.788	1.393	1.453	1.453
HORIZONTAL SPREAD	.876	.876	.876	.876
VERTICAL SPREAD	2.766	2.174	1.962	1.962
EXTREME SPREAD	2.766	2.204	2.094	2.094
NUMBER IN ONE INCH CIRCLE =	3	3	3	3
NUMBER IN TWO INCH CIRCLE =	6	6	6	6
NUMBER IN THREE INCH CIRCLE =	9	9	9	9