

05349104

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6349104

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10-9	89	RW
600	Proof	10-9	89	A
607	Check Headspace	10-9	89	RW
610	Dis-assemble Gun	10-9	89	RW
612	Magnaflux Barrel Action	10/31/89		KCR
	Magnaflux Bolt	10/31/89		KCR
615	Rollmark Caliber			
7	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)		11-3-89	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/6/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/6/89	RW
	C) Inspect Ejector Hole for Chamfer		11/6/89	RW
	D) Oil Firing Pin Ass'y		11/6/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		14/10/89	JS

BARBER - M24 0107870

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11-14-89	RM
	G) Safety Off Force	3	3	3			11-14-89	RM
	H) Trigger Pull Test & Retainability						14 Nov 89	JD
	I) Firing Pin Indent	.0215	.021	.021			11-14-89	RM
	J) Assemble Stock						11/15/89	RW
	K) Assemble Swivel Studs						11/15/89	JD
	L) Attach Front and Rear Sight Assemblies						11/15/89	RW
	M) Iron Sight Alignment						11/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container						11/15/89	RW
	O) Attach Scope to Rifle						15 Nov 89	JD
	P) Detach & Attach Scope 20 Times						15 Nov 89	JD
640	Gallery Target & Test						11-17-89	DH
	A) Time						11-17-89	DH
	B) Malfunctions						11-17-89	DH
	C) Pierced Primers						11-17-89	DH
	D) Optical Clarity of Scope						11-17-89	DH
645	Inspect for Live Ammo						11-17-89	DH
655	Final Inspection							
	A) Headspace						11 Dec 89	JD
	B) Trigger Pull	2.48	2.23	2.40	2.67	2.36	11 Dec 89	JD
	C) Function						11 Dec 89	JD
660	Pack						15 Dec 89	JD

SWS TRIGGER PULL TEST

BARBER - M24 0107871

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. C6349104

DATE 14 Mar 80

TESTER JS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.07	2.58		2.68	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.47	2.56		2.55	
PULL #3	2.50	2.58		2.71	
PULL #4	2.49	2.58		2.60	
PULL #5	2.56	2.48		2.36	
TOTAL	12.09	12.78			
AVG.	2.418	2.556			

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.42		
PULL #2	3.49	3.45		
PULL #3	3.35	3.41		
PULL #4	3.48	3.48		
PULL #5	3.39	3.50		
TOTAL	17.24	17.26		
AVG.	3.448	3.452		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	3.97	3.95		
PULL #2	3.92	3.92		
PULL #3	3.93	3.98		
PULL #4	3.91	3.97		
PULL #5	3.94	4.01		
TOTAL	19.67	19.73		
AVG.	3.934	3.946		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349104
17 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.561528
1 TO	2	.0610082
1 TO	3	1.14753
1 TO	4	.454634
1 TO	5	.899177

$\frac{5+4}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0318
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1866
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .18929
THE AMR FOR THIS RIFLE IS: .8924

17 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6349104

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 4

2in = 7

3in = 10

HS= 2.179

VS= 2.091

GS= 2.790

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.897	.754	.545
MINIMUM X	:	-1.282	-1.148	-1.053
MAXIMUM Y	:	1.097	1.025	.816
MINIMUM Y	:	-.994	-1.066	-.938
CENTROID X	:	.425	.568	.473
CENTROID Y	:	-.367	-.295	-.423
POA TO CENTROID in.	:	.561	.640	.635
MIN RADIUS	:	.047	.146	.040
MEAN RADIUS	:	.769	.680	.603
MAX RADIUS	:	1.436	1.272	1.054
HORIZONTAL SPREAD	:	2.179	1.902	1.598
VERTICAL SPREAD	:	2.091	2.091	1.754
EXTREME SPREAD	:	2.790	2.296	1.833
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

17 Nov 1989

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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 = 1

2 in = 5

3 in = 9

HS= 1.804

VS= 2.649

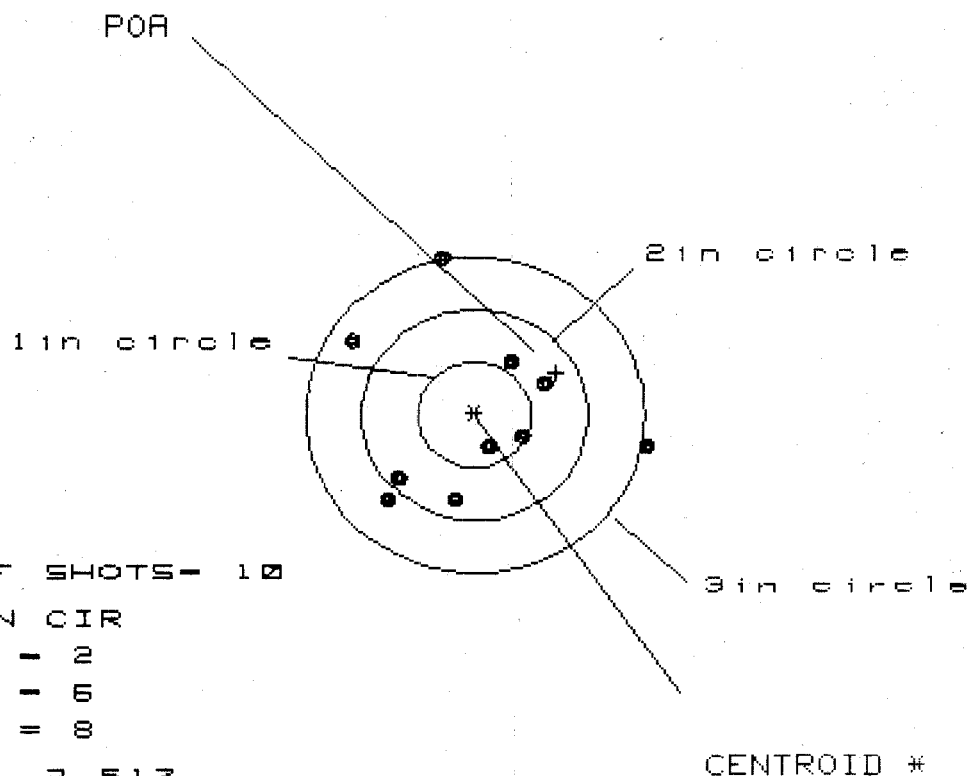
GS= 2.670

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.033	.984	.882
MINIMUM X	:	-.771	-.820	-.894
MAXIMUM Y	:	1.614	1.399	1.292
MINIMUM Y	:	-1.035	-.856	-.900
CENTROID X	:	.424	.473	.575
CENTROID Y	:	-.306	-.485	-.378
POA TO CENTROID in.	:	.523	.677	.688
MIN RADIUS	:	.193	.359	.263
MEAN RADIUS	:	.911	.806	.734
MAX RADIUS	:	1.672	1.431	1.353
HORIZONTAL SPREAD	:	1.804	1.804	1.776
VERTICAL SPREAD	:	2.649	2.255	2.192
EXTREME SPREAD	:	2.670	2.314	2.198
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Nov 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 2.517

VS= 2.380

GS= 2.680

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	1.459	.754
MINIMUM X	:	-1.029	-1.058	-.876
MAXIMUM Y	:	1.546	.831	.819
MINIMUM Y	:	-.834	-.662	-.674
CENTROID X	:	-.722	-.693	-.875
CENTROID Y	:	-.402	-.574	-.562
POA TO CENTROID in.	:	.826	.899	1.040
MIN RADIUS	:	.321	.150	.290
MEAN RADIUS	:	.916	.810	.743
MAX RADIUS	:	1.568	1.461	1.199
HORIZONTAL SPREAD	:	2.517	2.517	1.630
VERTICAL SPREAD	:	2.380	1.493	1.493
EXTREME SPREAD	:	2.680	2.680	1.735
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Nov 1989

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.423

VS= 2.792

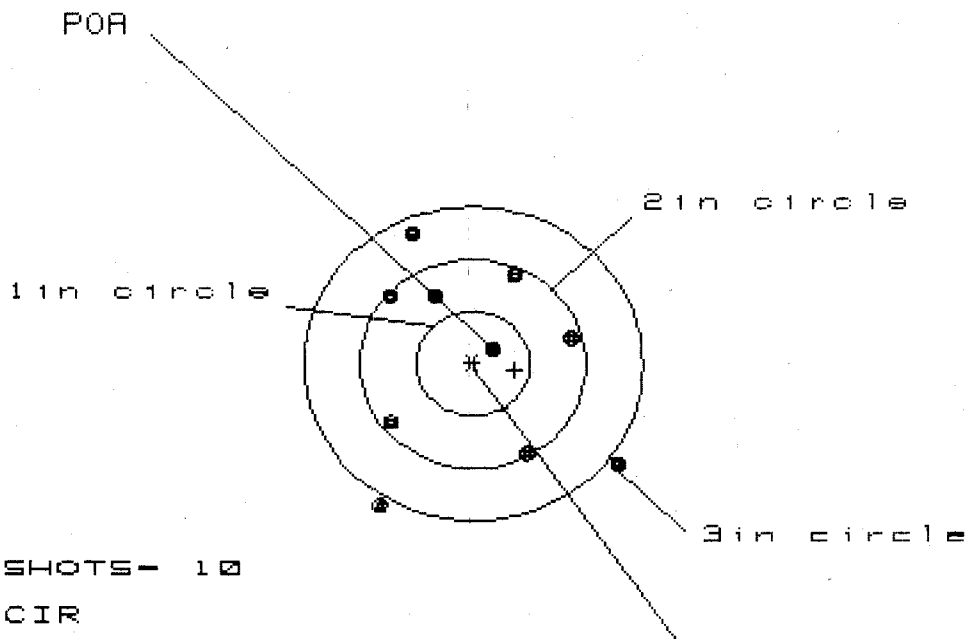
GS= 2.866

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.719	.720	.733
MINIMUM X	:	-.704	-.703	-.613
MAXIMUM Y	:	1.637	1.356	1.236
MINIMUM Y	:	-1.155	-.973	-1.093
CENTROID X	:	.401	.400	.309
CENTROID Y	:	.087	-.095	.025
POA TO CENTROID in.	:	.411	.411	.311
MIN RADIUS	:	.257	.160	.199
MEAN RADIUS	:	.853	.748	.683
MAX RADIUS	:	1.637	1.372	1.272
HORIZONTAL SPREAD	:	1.423	1.423	1.346
VERTICAL SPREAD	:	2.792	2.329	2.329
EXTREME SPREAD	:	2.866	2.444	2.444
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in - 8

HS- 2.053

VS- 2.649

GS- 2.784

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.127	.955
MINIMUM X	:	-.834	-.813	-.672
MAXIMUM Y	:	1.248	1.093	.957
MINIMUM Y	:	-1.401	-1.084	-1.136
CENTROID X	:	-.369	-.277	-.418
CENTROID Y	:	.055	.210	.346
POA TO CENTROID in.	:	.374	.348	.542
MIN RADIUS	:	.214	.102	.294
MEAN RADIUS	:	1.013	.911	.816
MAX RADIUS	:	1.630	1.564	1.266
HORIZONTAL SPREAD	:	2.053	1.940	1.627
VERTICAL SPREAD	:	2.649	2.177	2.093
EXTREME SPREAD	:	2.784	2.784	2.331
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

MOD.		GA. CAL.	GUN #	ASSEM. #
# TEST	DATE	MALFUNCTION/DEFECT		
	1st	shove brass & don't eject		
	11-17-89			
	2nd			
	3rd			
	4th			
		FUNCTION		RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF	Ream Ejector hole Polish Ejector 12/8/89	RW
TEST		
TGT		
PROOF	Shot OK	RW
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

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

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

MODEL 700TH M24

SERIAL NO.
C6349104

ORDER NO.
5716

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

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UPC

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