

C6587572

MODEL 760™ M24

Model **545**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

MODEL 700™ H24

SERIAL NO.
C6587572

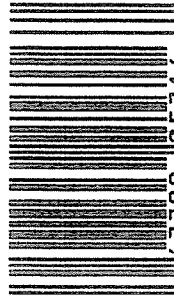
ORDER NO.
5716

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



5716 C6587572

UPC



0 47700 25716 7

OK - 1 Row 510007
OK - ET. P.W.

M-24

CONTRACT # DAAA21-87-C-0086

NEW BBL

GUN SERIAL # C 6587572

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/24/90	KH
600	Proof		10/24/90	KH
607	Check Headspace		10/24/90	KH
610	Dis-assemble Gun		10/24/90	KH
612	Magnaflux Barrel Action		10/30/90	KR
	Magnaflux Bolt		10/30/90	KR
615	Rollmark Caliber		11	LS
617	Drill and Tap Sight Holes		11/6/90	KB
618	Polish Barrel RB		11/7/90	WB
620	Apply Coatings (Barrel Action)		11-26-90	LS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		12/4/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		12/4/90	KS
	C) Inspect Ejector Hole for Chamfer		12/4/90	KS
	D) Oil Firing Pin Ass'y		12/4/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		12/5/90	JS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			12/4/90	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/5/90	WB
	H) Trigger Pull Test & Retainability						12/5/90	JL
	I) Firing Pin Indent	.024	.024	.024			12/5/90	WB
	J) Assemble Stock						12/9/90	KS
	K) Assemble Swivel Studs						12-8-90	JL
	L) Attach Front and Rear Sight Assemblies						12/5/90	KS
	M) Iron Sight Alignment						12/5/90	KS
	N) Detach Front & Rear Sights & place in numbered container						12/5/90	KS
	O) Attach Scope to Rifle						12/5/90	KS
	P) Detach & Attach Scope 20 Times						12/5/90	KS
640	Gallery Target & Test						12-6-90	AC
	A) Time						12-6-90	AC
	B) Malfunctions						12-6-90	AC
	C) Pierced Primers						12-6-90	AC
	D) Optical Clarity of Scope						12-6-90	AC
645	Inspect for Live Ammo						12-6-90	AC
655	Final Inspection						12-8-90	JL
	A) Headspace						12-8-90	JL
	B) Trigger Pull	295	271	265	2107	259	12-8-90	JL
	C) Function						12-8-90	JL
660	Pack						12/19/90	KS

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6587572

DATE 12/5/90

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.12	2.42	2.43	295	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.42	2.44	271	
PULL #3	2.41	2.45	2.42	265	
PULL #4	2.39	2.41	2.45	267	
PULL #5	2.42	2.41	2.46	259	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.42		
PULL #2	3.27	3.39		
PULL #3	3.19	3.39		
PULL #4	3.19	3.40		
PULL #5	3.47	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.30		4.40
PULL #2	4.16	4.39		4.41
PULL #3	4.33	4.38		4.41
PULL #4	4.39	4.33		4.41
PULL #5	4.33	4.37		4.25
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6587572
6 Dec 1990

CENTROIDAL DISTANCES

0 TO	1	.356732
1 TO	2	.306992
1 TO	3	.439056
1 TO	4	.698762
1 TO	5	.10373

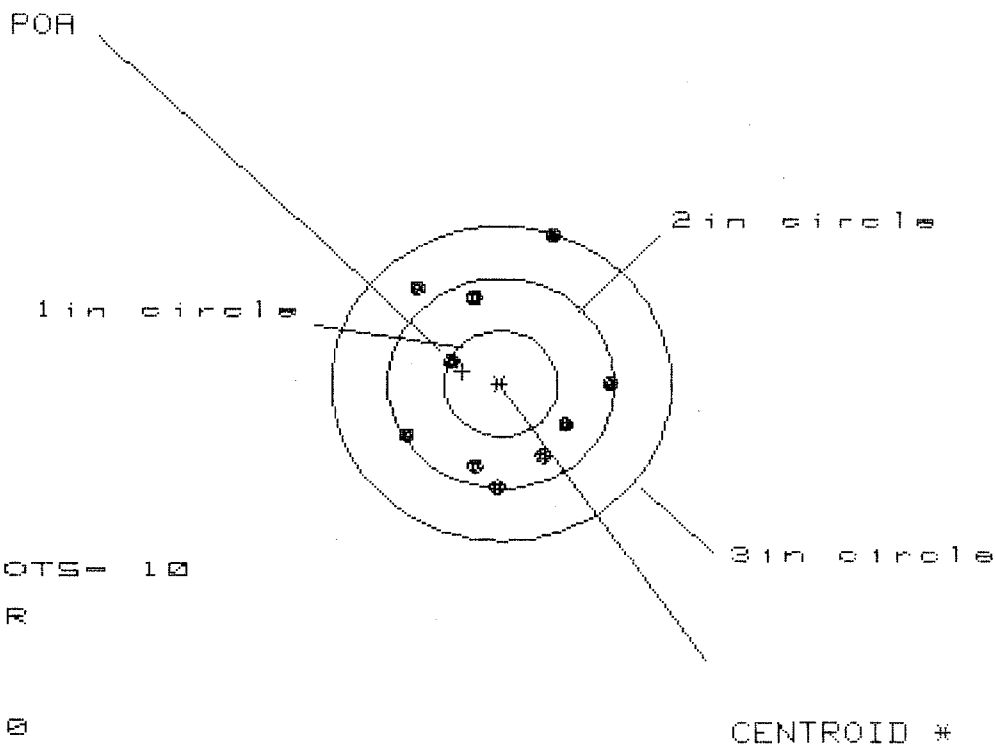
4.5 <----POA
2

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0576
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0762
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0955207
THE AMR FOR THIS RIFLE IS: .9112

6 Dec 1998

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CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 8

3 in = 10

HS= 1.847

VS= 2.376

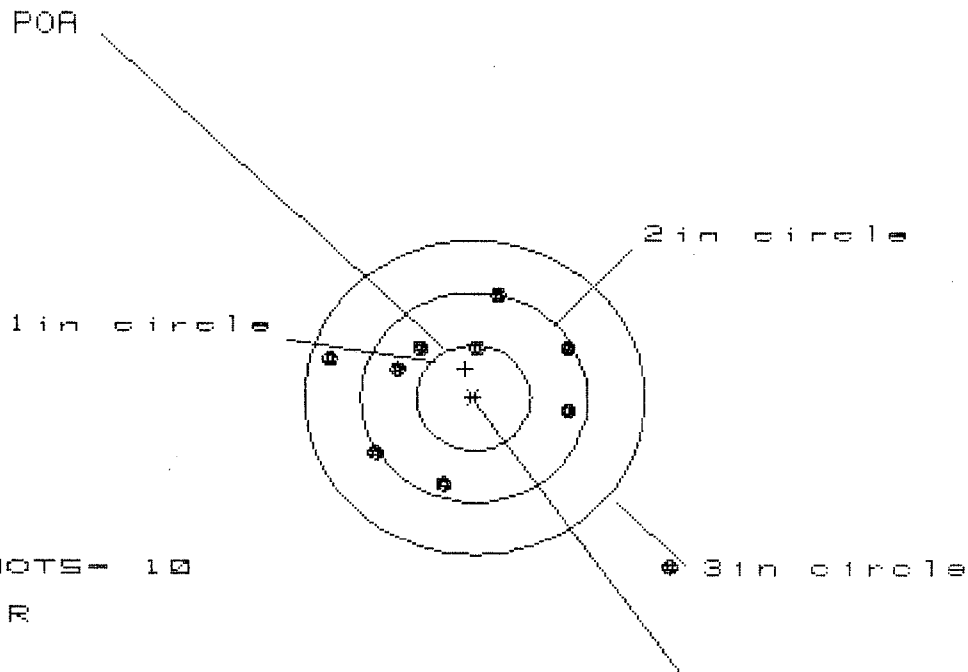
GS= 2.424

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.999	1.052	.971
MINIMUM X	-.848	-.795	-.876
MAXIMUM Y	1.384	1.071	1.075
MINIMUM Y	-.992	-.838	-.705
CENTROID X	.337	.284	.365
CENTROID Y	-.117	-.271	-.404
POA TO CENTROID in.	.357	.392	.545
MIN RADIUS	.458	.512	.531
MEAN RADIUS	.917	.834	.756
MAX RADIUS	1.464	1.252	1.115
HORIZONTAL SPREAD	1.847	1.847	1.847
VERTICAL SPREAD	2.376	1.909	1.779
EXTREME SPREAD	2.424	2.033	1.905
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 2

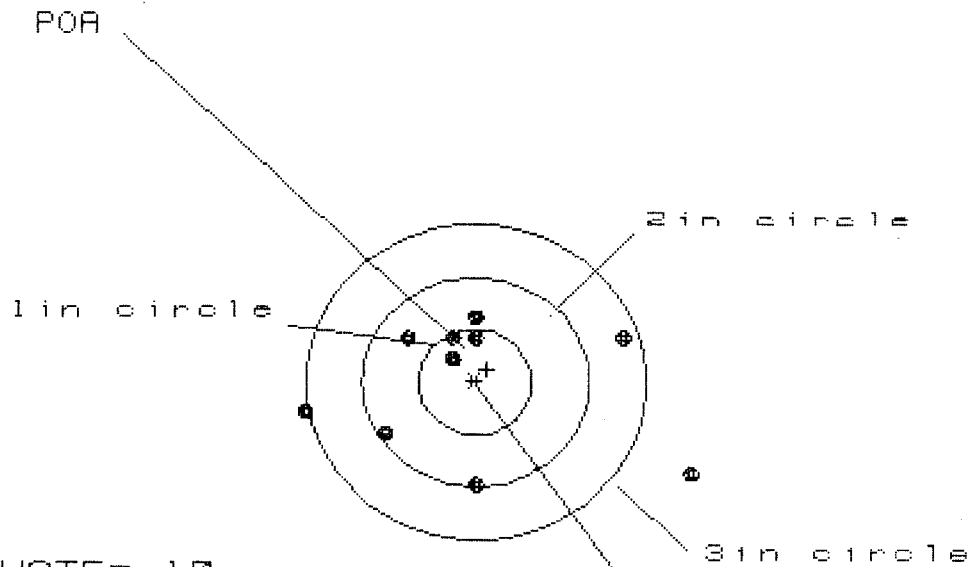


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.694	1.041	.909
MINIMUM X	:	-1.244	-1.056	-.834
MAXIMUM Y	:	.992	.814	.842
MINIMUM Y	:	-1.599	-.995	-.968
CENTROID X	:	.075	-.113	.019
CENTROID Y	:	-.277	-.099	-.127
POA TO CENTROID in.	:	.287	.151	.128
MIN RADIUS	:	.438	.309	.289
MEAN RADIUS	:	1.019	.814	.785
MAX RADIUS	:	2.329	1.096	1.067
HORIZONTAL SPREAD	:	2.938	2.097	1.743
VERTICAL SPREAD	:	2.591	1.809	1.809
EXTREME SPREAD	:	3.550	2.118	2.027
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

6 Dec 1990

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 3.331

VS= 1.523

GS= 3.398

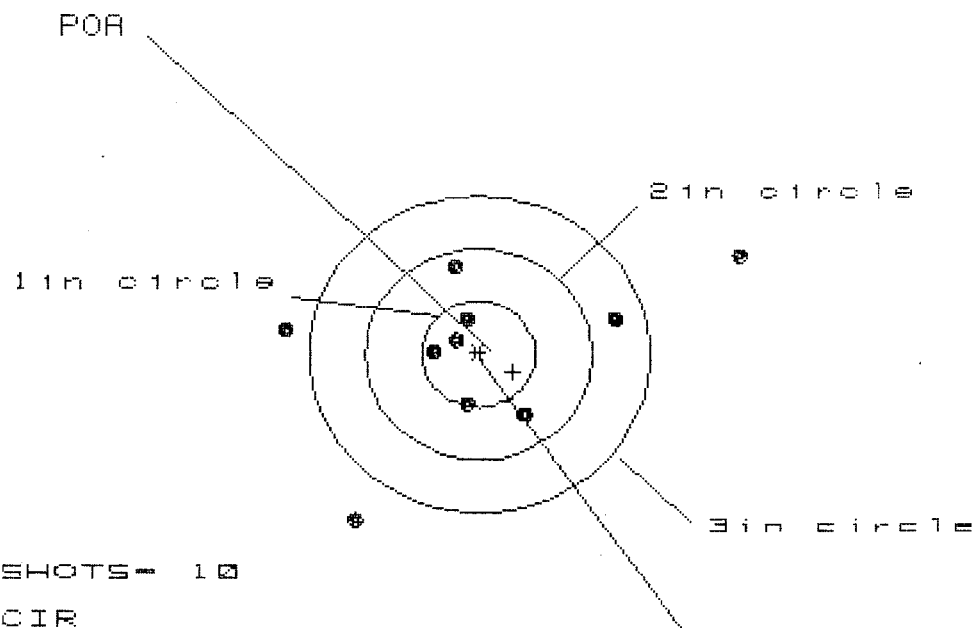
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.872	1.465	1.308
MINIMUM X	:	-1.459	-1.250	-.705
MAXIMUM Y	:	.590	.490	.449
MINIMUM Y	:	-.933	-1.033	-1.074
CENTROID X	:	-.102	-.310	-.153
CENTROID Y	:	-.124	-.024	.017
POA TO CENTROID in.	:	.160	.311	.154
MIN RADIUS	:	.309	.167	.166
MEAN RADIUS	:	.921	.729	.647
MAX RADIUS	:	2.076	1.506	1.344
HORIZONTAL SPREAD	:	3.331	2.715	2.013
VERTICAL SPREAD	:	1.523	1.523	1.523
EXTREME SPREAD	:	3.398	2.798	2.211
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 5

3in = 7

HS= 3.993

VS= 2.472

GS= 4.200

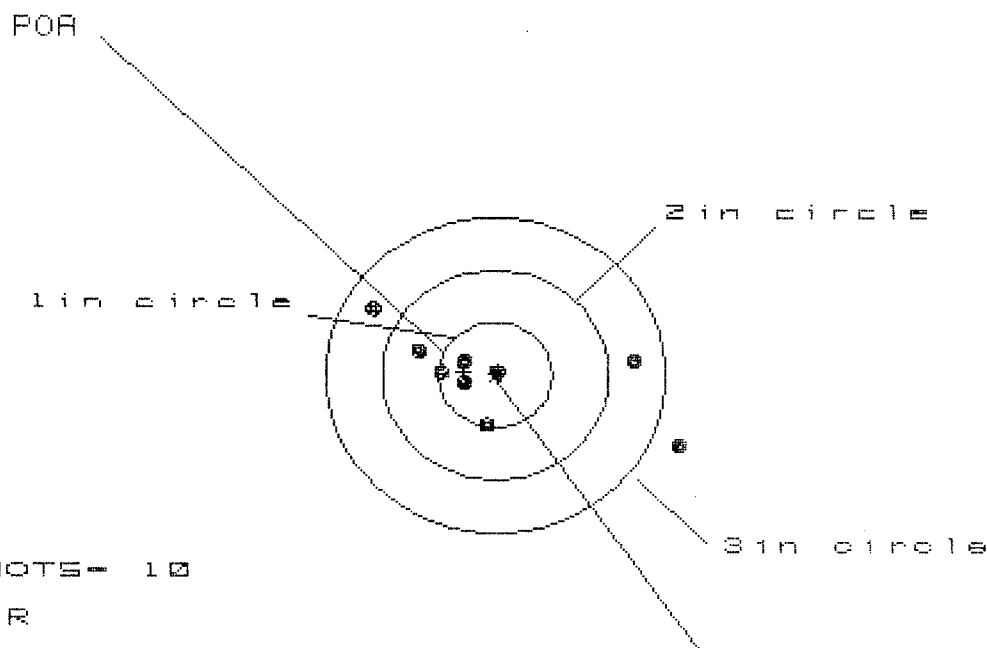
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.262	1.494	1.384
MINIMUM X	:	-1.731	-1.480	-1.590
MAXIMUM Y	:	.899	.900	.716
MINIMUM Y	:	-1.573	-1.473	-.674
CENTROID X	:	-.301	-.552	-.442
CENTROID Y	:	.168	.068	.253
POA TO CENTROID in.	:	.345	.557	.509
MIN RADIUS	:	.231	.189	.074
MEAN RADIUS	:	1.040	.855	.715
MAX RADIUS	:	2.434	1.718	1.601
HORIZONTAL SPREAD	:	3.993	2.974	2.974
VERTICAL SPREAD	:	2.472	2.373	1.390
EXTREME SPREAD	:	4.200	3.023	2.974
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 2.656

VS= 1.347

GS= 2.978

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.611	1.359	1.251
MINIMUM X	:	-1.045	-.866	-.631
MAXIMUM Y	:	.657	.580	.214
MINIMUM Y	:	-.690	-.582	-.510
CENTROID X	:	.279	.100	.208
CENTROID Y	:	-.031	.046	-.027
POA TO CENTROID in.	:	.280	.110	.210
MIN RADIUS	:	.023	.111	.094
MEAN RADIUS	:	.659	.507	.441
MAX RADIUS	:	1.753	1.359	1.255
HORIZONTAL SPREAD	:	2.656	2.225	1.882
VERTICAL SPREAD	:	1.347	1.162	.724
EXTREME SPREAD	:	2.978	2.293	1.886
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	