

C6523358

MODEL 760™ M24

Model 5M5™

Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.






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

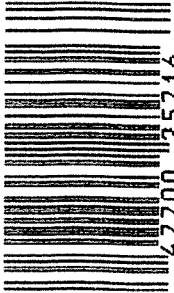
MODEL 700TM H24

SERIAL NO.
C6523358

ORDER NO.
5716

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

UPC



0 47700 25716 7



5716 C6523358

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6523358

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 25	90	RW
600	Proof	9 25	90	RW
607	Check Headspace	9 25	90	RW
610	Dis-assemble Gun	9 25	90	RW
612	Magnaflux Barrel Action		9-26-90	KR
	Magnaflux Bolt		9-26-90	K.R.
615	Rollmark Caliber		9-26-90	KR.
617	Drill and Tap Sight Holes		9/27/90	KB
618	Polish Barrel RB		10/1/90	WB
620	Apply Coatings (Barrel Action)		10-5-90	THA
	Apply Coating (Bolt)		10-5-90	THA
625	Final Assembly A) Clean inside of Bolt Assembly		10/8/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/8/90	RW
	C) Inspect Ejector Hole for Chamfer		10/8/90	RW
	D) Oil Firing Pin Ass'y		10/8/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		10/16/90	GM

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			10/18/90	WB
	G) Safety Off Force	2	2	2			10/18/90	WB
	H) Trigger Pull Test & Retainability						10/16/90	PL
	I) Firing Pin Indent	.0205	.0205	.0205			10/17/90	WB
	J) Assemble Stock						10/22/90	RW
	K) Assemble Swivel Studs						2/18/90	JSB
	L) Attach Front and Rear Sight Assemblies						10/22/90	RW
	M) Iron Sight Alignment						10/22/90	RW
	N) Detach Front & Rear Sights & place in numbered container						10/22/90	RW
	O) Attach Scope to Rifle						10/23/90	RW
	P) Detach & Attach Scope 20 Times						10/23/90	RW
640	Gallery Target & Test						10/25/90	NF
	A) Time						"	NF
	B) Malfunctions						"	NF
	C) Pierced Primers						"	NF
	D) Optical Clarity of Scope						"	NF
645	Inspect for Live Ammo						10/25/90	NF
655	Final Inspection							
	A) Headspace						2/18/90	JSB
	B) Trigger Pull	223	216	234	218	205	2/18/90	JSB
	C) Function						2/18/90	JSB
660	Pack						12-17-90	D/H

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C6523358

DATE 10/16/90

TESTER JJ

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.23	2.33	2.36	2.23	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.20	2.27	2.38	2.16	
PULL #3	2.22	2.31	2.40	2.34	
PULL #4	2.30	2.24	2.41	2.18	
PULL #5	2.36	2.27	2.44	2.05	
TOTAL	11.31	11.42	11.99		
AVG.	2.262	2.284	2.398		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.38		
PULL #2	3.39	3.25		
PULL #3	3.20	3.40		
PULL #4	3.39	3.35		
PULL #5	3.34	3.43		
TOTAL	16.54	16.81		
AVG.	3.308	3.362		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.21		4.37
PULL #2	4.21	4.17		4.36
PULL #3	4.17	4.15		4.33
PULL #4	4.15	4.37		4.42
PULL #5	4.22	4.39		4.42
TOTAL	21.02	21.29		21.9
AVG.	4.204	4.258		4.38

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523358
26 Oct 1990

CENTROIDAL DISTANCES

Ø TO	1	.135163
1 TO	2	.251921
1 TO	3	.385001
1 TO	4	.0899444
1 TO	5	.347023

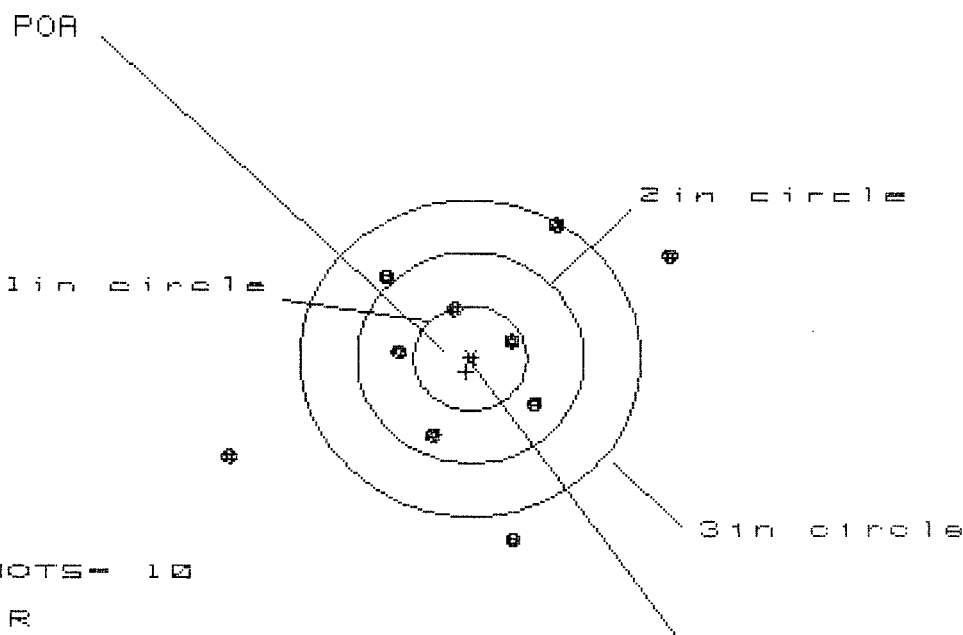
543 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0582
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0138
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0598137
THE AMR FOR THIS RIFLE IS: .9172

26 Oct 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523358

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 6

HS = 3.972

VS = 3.051

GS = 4.405

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.795	1.553	.726
MINIMUM X	:	-2.177	-.974	-.780
MAXIMUM Y	:	1.317	1.215	1.325
MINIMUM Y	:	-1.734	-1.836	-1.726
CENTROID X	:	.037	.279	.085
CENTROID Y	:	.130	.232	.122
POA TO CENTROID in.	:	.135	.363	.149
MIN RADIUS	:	.435	.174	.397
MEAN RADIUS	:	1.178	1.032	.923
MAX RADIUS	:	2.364	1.844	1.763
HORIZONTAL SPREAD	:	3.972	2.527	1.506
VERTICAL SPREAD	:	3.051	3.051	3.051
EXTREME SPREAD	:	4.405	3.073	3.073
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	6		

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CENTERFIRE PATTERNS

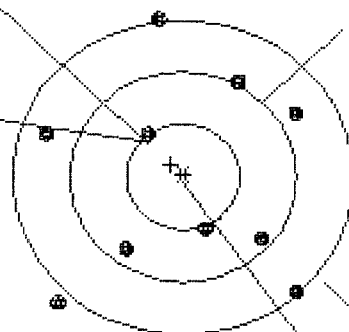
2

POA

1in circle

2in circle

3in circle



CENTROID #

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 2.241

VS= 2.704

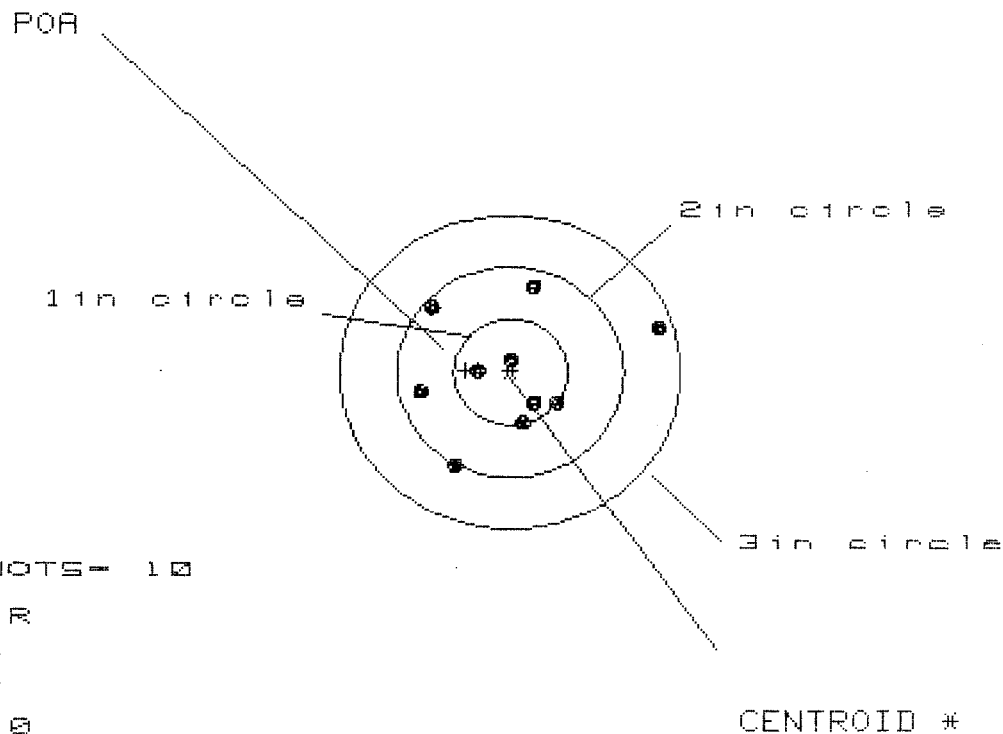
GS= 2.918

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	.908	.867
MINIMUM X	:	-1.211	-1.333	-1.375
MAXIMUM Y	:	1.557	1.430	.970
MINIMUM Y	:	-1.147	-1.226	-1.048
CENTROID X	:	.107	.229	.270
CENTROID Y	:	-.112	.015	-.163
POA TO CENTROID in.	:	.155	.230	.316
MIN RADIUS	:	.534	.564	.448
MEAN RADIUS	:	1.101	1.041	.969
MAX RADIUS	:	1.588	1.508	1.440
HORIZONTAL SPREAD	:	2.241	2.241	2.241
VERTICAL SPREAD	:	2.704	2.656	2.018
EXTREME SPREAD	:	2.918	2.918	2.659
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 4

2in = 8

3in = 10

HS= 2.090

VS= 1.766

GS= 2.269

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.303	.573	.527
MINIMUM X	:	-.787	-.642	-.688
MAXIMUM Y	:	.856	.906	.798
MINIMUM Y	:	-.910	-.860	-.580
CENTROID X	:	.392	.247	.293
CENTROID Y	:	-.019	-.069	.039
POA TO CENTROID in.	:	.392	.256	.295
MIN RADIUS	:	.139	.117	.131
MEAN RADIUS	:	.687	.603	.555
MAX RADIUS	:	1.379	.961	.875
HORIZONTAL SPREAD	:	2.090	1.215	1.215
VERTICAL SPREAD	:	1.766	1.766	1.378
EXTREME SPREAD	:	2.269	1.895	1.477
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

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CENTERFIRE PATTERNS

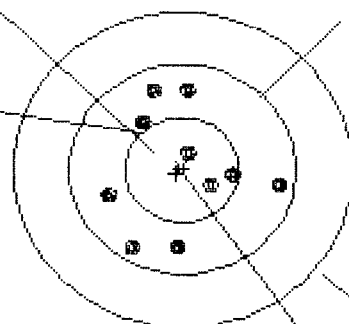
4

POA

1 in circle

2 in circle

3 in circle



CENTROID *

OF SHOTS- 10

IN CIR

1 in - 3

2 in - 10

3 in - 10

HS- 1.520

VS- 1.565

GS- 1.623

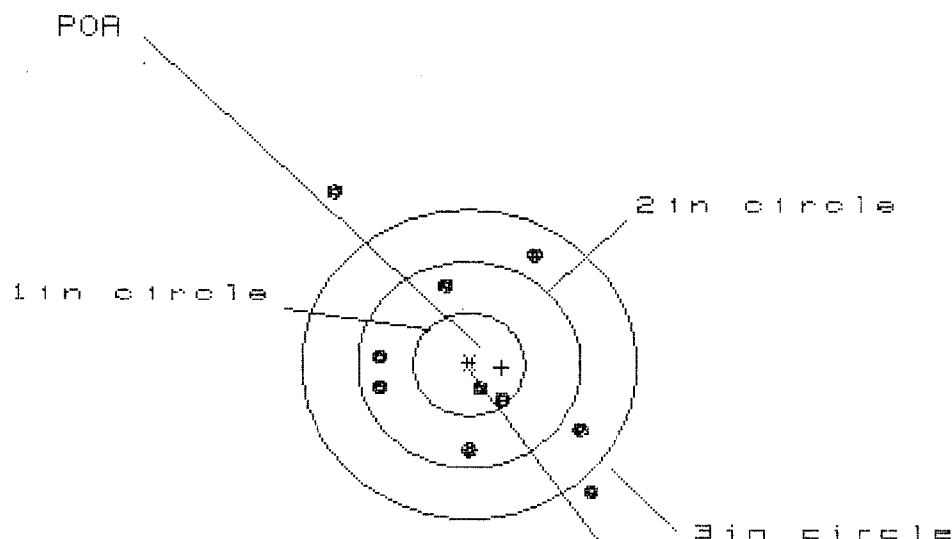
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.515	.466
MINIMUM X	:	-.621	-.522	-.571
MAXIMUM Y	:	.782	.762	.667
MINIMUM Y	:	-.783	-.803	-.898
CENTROID X	:	.050	-.049	-.000
CENTROID Y	:	.041	.061	.156
POA TO CENTROID in.	:	.065	.078	.156
MIN RADIUS	:	.144	.211	.140
MEAN RADIUS	:	.619	.593	.541
MAX RADIUS	:	.916	.860	.898
HORIZONTAL SPREAD	:	1.520	1.037	1.037
VERTICAL SPREAD	:	1.565	1.565	1.565
EXTREME SPREAD	:	1.623	1.623	1.569
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.278

VS= 2.943

GS= 3.722

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.089	.957	.941
MINIMUM X	:	-1.189	-.943	-.823
MAXIMUM Y	:	1.671	1.222	1.086
MINIMUM Y	:	-1.272	-1.086	-.755
CENTROID X	:	-.295	-.163	-.283
CENTROID Y	:	.029	-.157	-.021
POA TO CENTROID in.	:	.297	.226	.283
MIN RADIUS	:	.271	.075	.220
MEAN RADIUS	:	1.001	.837	.776
MAX RADIUS	:	2.051	1.448	1.210
HORIZONTAL SPREAD	:	2.278	1.900	1.764
VERTICAL SPREAD	:	2.943	2.308	1.841
EXTREME SPREAD	:	3.722	2.401	1.934
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		