

05523436

MODEL 760TH M24

Model **SMS** TM

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington



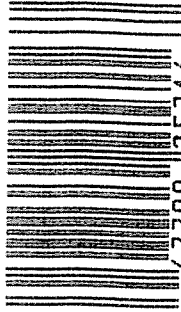

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ H24

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

SERIAL NO.
C6523436

ORDER NO.
5716



0 47700 25716 7



5716 C6523436

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523436

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 3 90		RW
600	Proof	10 3 90		RW
607	Check Headspace	10 3 90		RW
610	Dis-assemble Gun	10 3 90		RW
612	Magnaflux Barrel Action		10/11/90	KR
	Magnaflux Bolt		10/11/90	KR
615	Rollmark Caliber		10/11/90	LL
617	Drill and Tap Sight Holes		10/11/90	LB
618	Polish Barrel <i>RB</i>		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-12-90	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		10/22/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/22/90	RW
	C) Inspect Ejector Hole for Chamfer		10/22/90	RW
	D) Oil Firing Pin Ass'y		10/22/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11-8-90	JL

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			11/9/90	WB
	G) Safety Off Force	3	3	3			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-8-90	JH
	I) Firing Pin Indent	.021	.021	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	RW
	K) Assemble Swivel Studs						11-9-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	RW
	M) Iron Sight Alignment						11/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	RW
	O) Attach Scope to Rifle						11/9/90	RW
	P) Detach & Attach Scope 20 Times						11/9/90	RW
640	Gallery Target & Test						11-9-90	KT
	A) Time						11-9-90	KT
	B) Malfunctions						11-9-90	KT
	C) Pierced Primers						11-9-90	KT
	D) Optical Clarity of Scope						11-9-90	KT
645	Inspect for Live Ammo						11-9-90	KT
655	Final Inspection							
	A) Headspace						11-9-90	DH
	B) Trigger Pull	276	283	281	284	279	11-9-90	DH
	C) Function						11-9-90	DH
660	Pack						12-7-90	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. 06523436

DATE 11-8-90

TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.43	2.50	2.76	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.44	2.46	2.83	
PULL #3	2.36	2.41	2.52	2.81	
PULL #4	2.38	2.48	2.45	2.84	
PULL #5	2.37	2.40	2.51	2.79	
TOTAL	11.87	12.16	12.44		
AVG.	2.374	2.432	2.488		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.22		
PULL #2	3.34	3.49		
PULL #3	3.35	3.48		
PULL #4	3.34	3.23		
PULL #5	3.19	3.48		
TOTAL	16.68	16.90		
AVG.	3.336	3.38		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.32		4.19
PULL #2	4.31	4.31		4.28
PULL #3	4.02	4.36		4.39
PULL #4	4.27	4.37		4.45
PULL #5	4.32	4.36		4.37
TOTAL	21.27	21.72		21.68
AVG.	4.254	4.344		4.336

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523436
9 Nov 1990

CENTROIDAL DISTANCES

0	TO	1	.181618
1	TO	2	.085703
1	TO	3	.383788
1	TO	4	.0968762
1	TO	5	.175285

$\frac{3}{45}$ <----POA

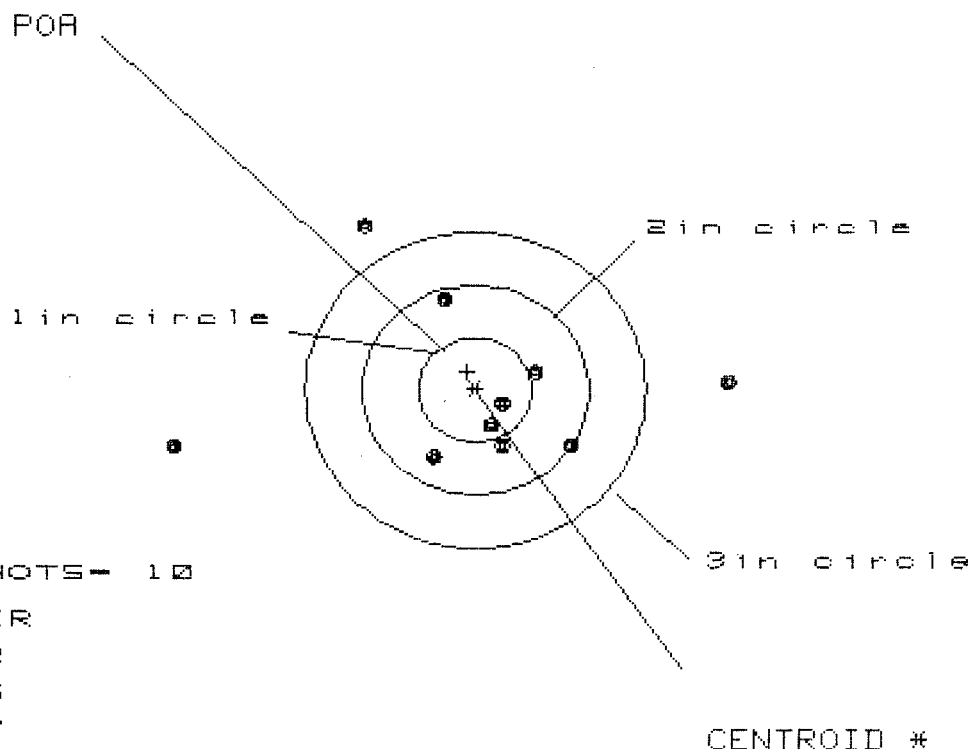
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0884
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1118
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .142526

THE AMR FOR THIS RIFLE IS: 1.261

9 Nov 1990

FILE:/PATTERNING/CENTERFIRE_PATT/06523436

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in - 2

2 in - 6

3 in - 7

HS - 4.876

VS - 2.184

GS - 4.917

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.248	1.956	.886
MINIMUM X	:	-2.628	-1.266	-1.022
MAXIMUM Y	:	1.521	1.463	1.469
MINIMUM Y	:	-.663	-.721	-.715
CENTROID X	:	.069	.361	.117
CENTROID Y	:	-.168	-.111	-.117
POA TO CENTROID in.	:	.182	.378	.165
MIN RADIUS	:	.255	.203	.250
MEAN RADIUS	:	1.110	.897	.771
MAX RADIUS	:	2.679	1.957	1.790
HORIZONTAL SPREAD	:	4.876	3.222	1.828
VERTICAL SPREAD	:	2.184	2.184	2.184
EXTREME SPREAD	:	4.917	3.517	2.773
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

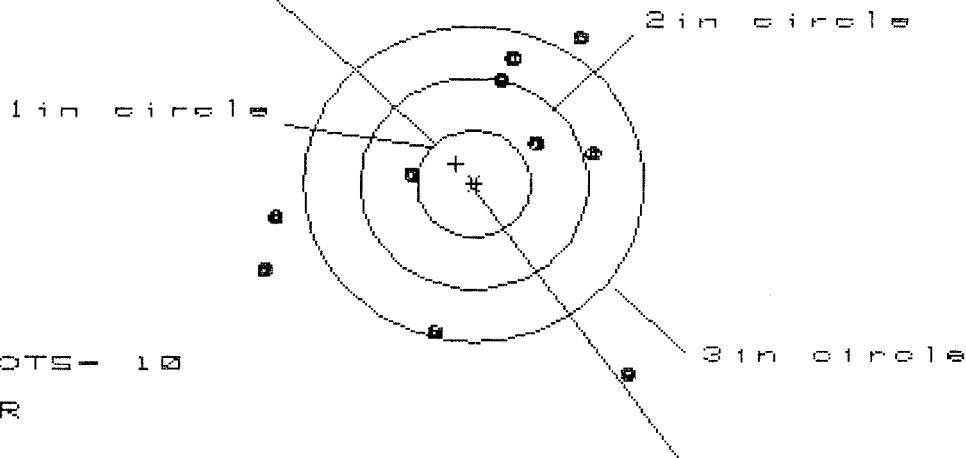
9 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523436

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 6

HS= 3.268

VS= 3.210

GS= 3.528

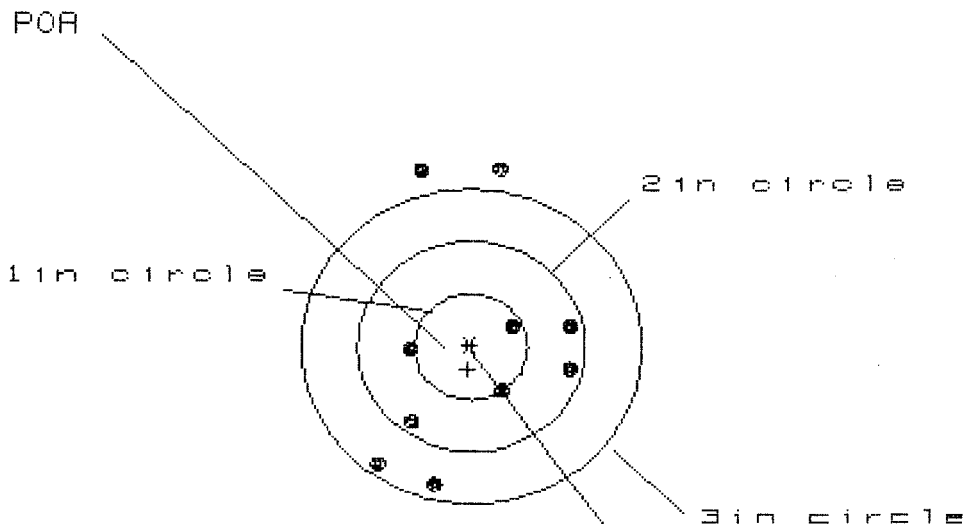
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.377	1.239	1.022
MINIMUM X	:	-1.891	-1.738	-1.820
MAXIMUM Y	:	1.358	1.152	1.030
MINIMUM Y	:	-1.852	-1.619	-1.741
CENTROID X	:	.153	-.000	.217
CENTROID Y	:	-.185	.021	.143
POA TO CENTROID in.	:	.240	.021	.260
MIN RADIUS	:	.532	.397	.504
MEAN RADIUS	:	1.384	1.251	1.106
MAX RADIUS	:	2.308	1.994	1.917
HORIZONTAL SPREAD	:	3.268	2.977	2.842
VERTICAL SPREAD	:	3.210	2.771	2.771
EXTREME SPREAD	:	3.528	3.528	3.136
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		2	
NUMBER IN THREE INCH CIRCLE	=		6	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.710

VS = 3.076

GS = 3.134

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.899	.933	.882
MINIMUM X	-.811	-.777	-.828
MAXIMUM Y	1.717	1.847	.638
MINIMUM Y	-1.359	-1.168	-.937
CENTROID X	.032	-.002	.049
CENTROID Y	.214	.023	-.208
POA TO CENTROID in.	.216	.023	.214
MIN RADIUS	.420	.323	.221
MEAN RADIUS	1.032	.926	.781
MAX RADIUS	1.744	1.891	1.088
HORIZONTAL SPREAD	1.710	1.710	1.710
VERTICAL SPREAD	3.076	3.015	1.575
EXTREME SPREAD	3.134	3.019	2.164
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

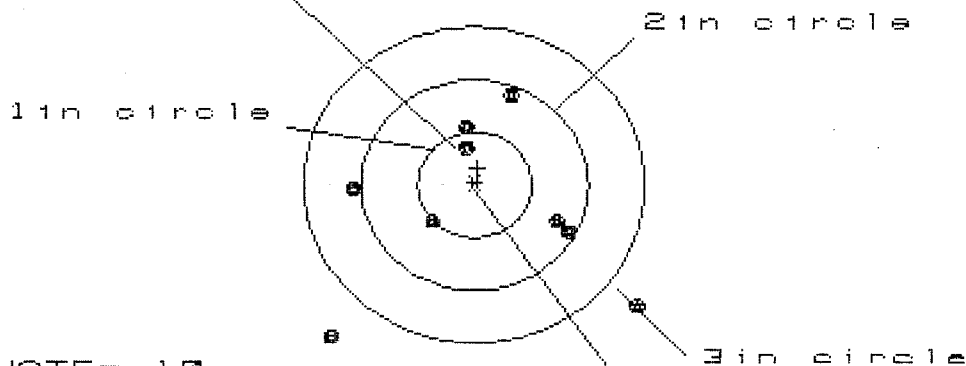
9 May 1998

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CENTERFIRE PATTERNS

4

POA



OF SHOTS- 10

IN CIR

1in - 2

2in - 6

3in - 7

HS- 2.664

VS= 3.426

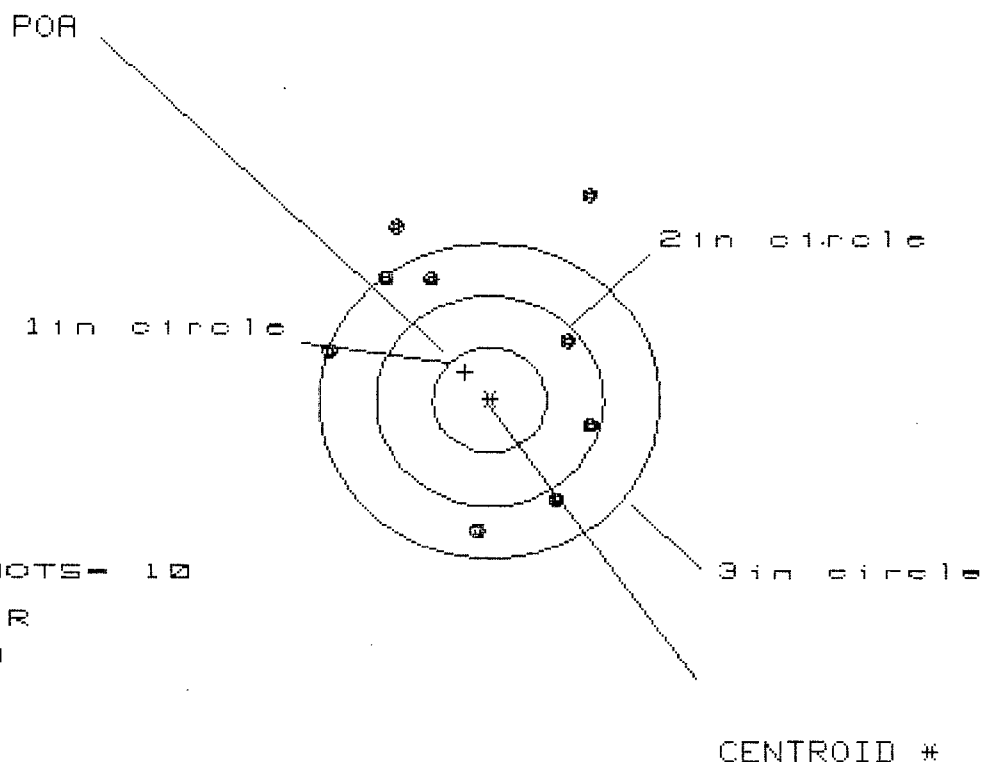
GS= 3.731

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.431	1.368	1.205
MINIMUM X	:	-1.233	-1.296	-1.296
MAXIMUM Y	:	1.965	1.072	.917
MINIMUM Y	:	-1.461	-1.243	-1.122
CENTROID X	:	-.027	.036	.199
CENTROID Y	:	-.155	-.373	-.218
POA TO CENTROID in.	:	.157	.375	.295
MIN RADIUS	:	.358	.406	.530
MEAN RADIUS	:	1.096	1.003	.875
MAX RADIUS	:	2.046	1.796	1.647
HORIZONTAL SPREAD	:	2.664	2.664	2.502
VERTICAL SPREAD	:	3.426	2.315	2.039
EXTREME SPREAD	:	3.731	2.780	2.767
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	7		

9 Nov 1998

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 0

2in = 2

3in = 7

HS= 2.302

VS= 6.399

GS= 6.400

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.894	.978	1.100
MINIMUM X	-1.408	-1.324	-1.202
MAXIMUM Y	1.922	1.424	1.359
MINIMUM Y	-4.477	-1.690	-1.512
CENTROID X	.215	.131	.009
CENTROID Y	-.265	.233	.054
POA TO CENTROID in.	.341	.267	.055
MIN RADIUS	.894	.778	.875
MEAN RADIUS	1.682	1.282	1.226
MAX RADIUS	4.541	1.725	1.513
HORIZONTAL SPREAD	2.302	2.302	2.302
VERTICAL SPREAD	6.399	3.114	2.871
EXTREME SPREAD	6.400	3.282	2.962
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	7		