

C6523524

MODEL 760™ M24

Model **SMS**™

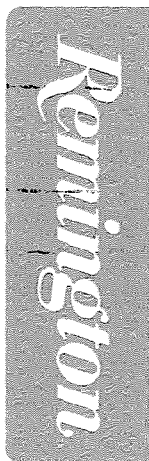
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

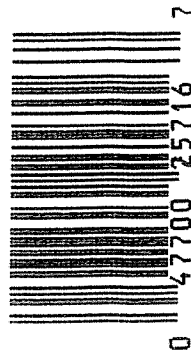
MODEL 700™ H2A

SERIAL NO.
C6523524

ORDER NO.
5716

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

UPC



5716 C6523524

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523524
12 Sep 1990

CENTROIDAL DISTANCES

Ø TO	1	.759234
1 TO	2	1.30848
1 TO	3	1.76936
1 TO	4	.338009
1 TO	5	.149375

4.5 + 2.3 <----POA

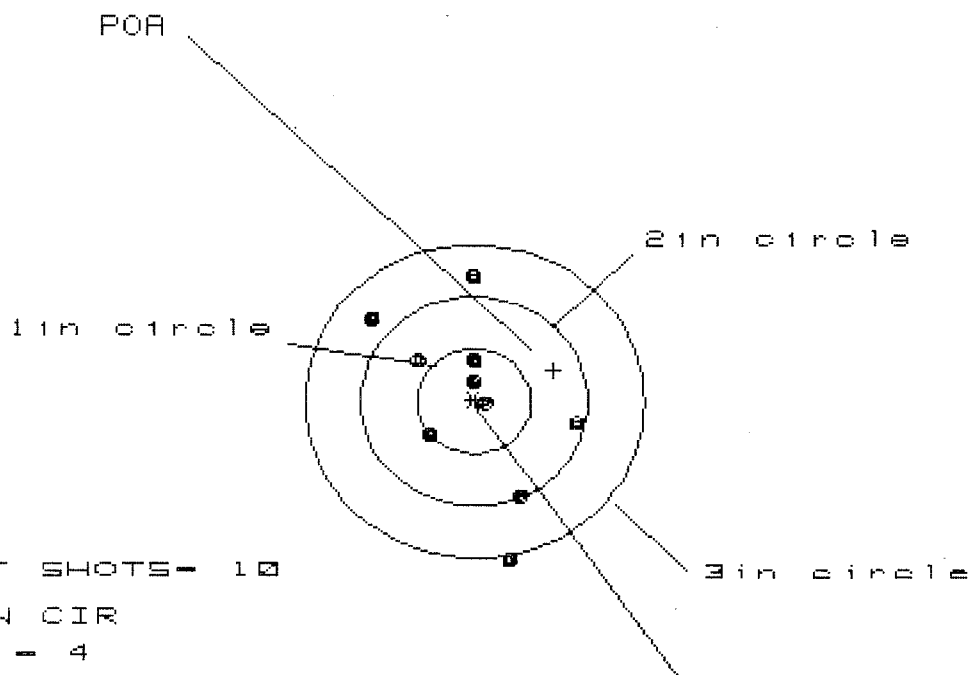
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1294
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1964
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .235196
THE AMR FOR THIS RIFLE IS: .8684

12 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6523524

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 1.840

VS= 2.735

GS= 2.757

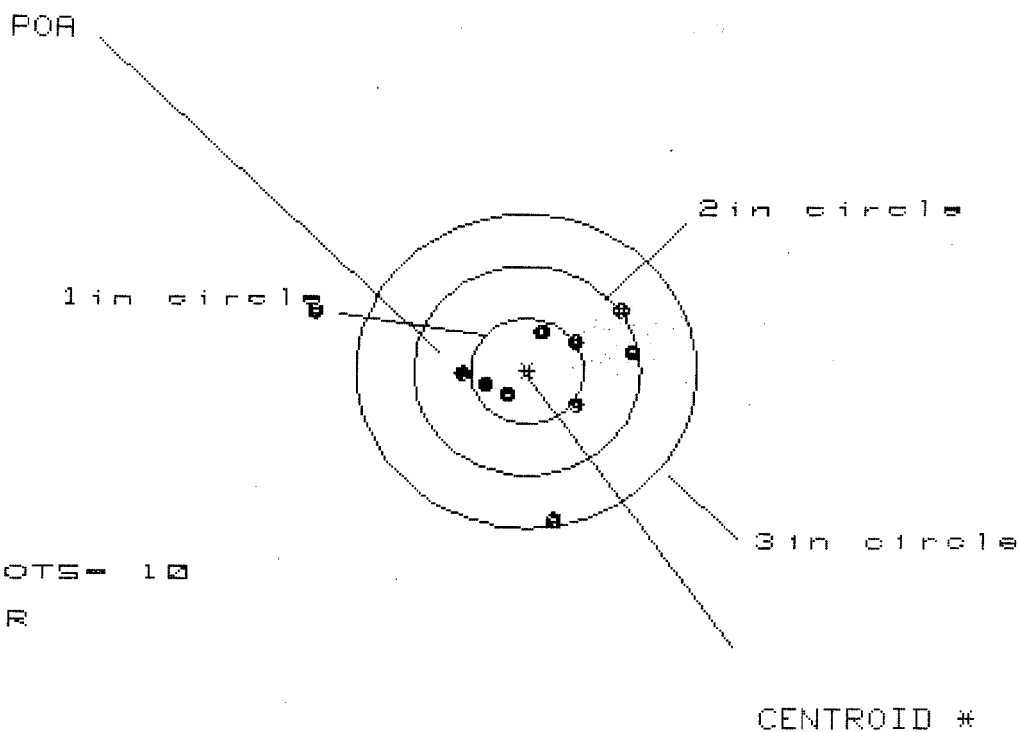
CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.937	.824
MINIMUM X	:	-.942	-.903	-.525
MAXIMUM Y	:	1.191	1.020	1.102
MINIMUM Y	:	-1.544	-1.079	-.997
CENTROID X	:	-.700	-.739	-.626
CENTROID Y	:	-.294	-.123	-.205
POA TO CENTROID in.	:	.759	.749	.659
MIN RADIUS	:	.091	.066	.061
MEAN RADIUS	:	.768	.647	.587
MAX RADIUS	:	1.583	1.156	1.105
HORIZONTAL SPREAD	:	1.840	1.840	1.349
VERTICAL SPREAD	:	2.735	2.099	2.099
EXTREME SPREAD	:	2.757	2.183	2.132
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS = 2.858

VS = 2.057

GS = 2.932

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.963	.752	.751
MINIMUM X	:	-1.905	-.771	-.772
MAXIMUM Y	:	.591	.655	.480
MINIMUM Y	:	-1.466	-1.402	-.424
CENTROID X	:	.570	.781	.782
CENTROID Y	:	.021	-.043	.132
POA TO CENTROID in.	:	.570	.782	.793
MIN RADIUS	:	.269	.303	.321
MEAN RADIUS	:	.818	.680	.569
MAX RADIUS	:	1.988	1.402	.805
HORIZONTAL SPREAD	:	2.868	1.523	1.523
VERTICAL SPREAD	:	2.057	2.057	.904
EXTREME SPREAD	:	2.932	2.159	1.534
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

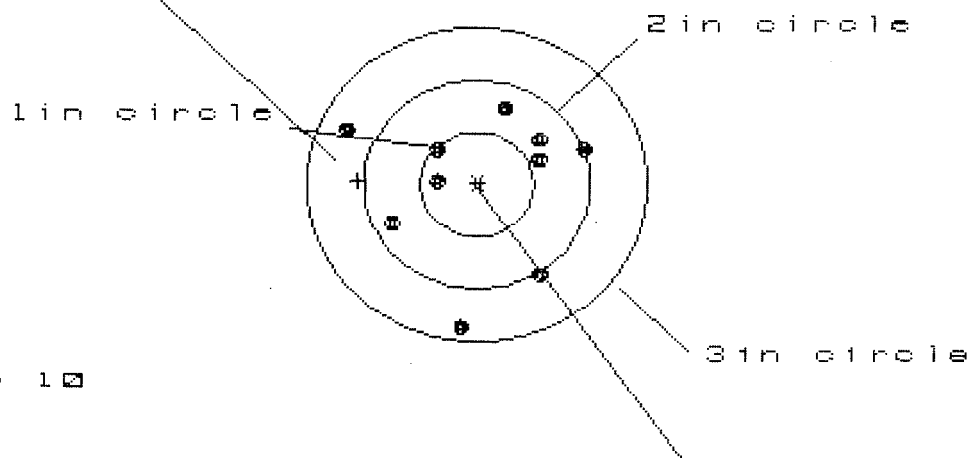
12 Sep 1990

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CENTERFIRE PATTERNS

3

FOR



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.146

VS= 2.123

GS= 2.233

CENTROID #

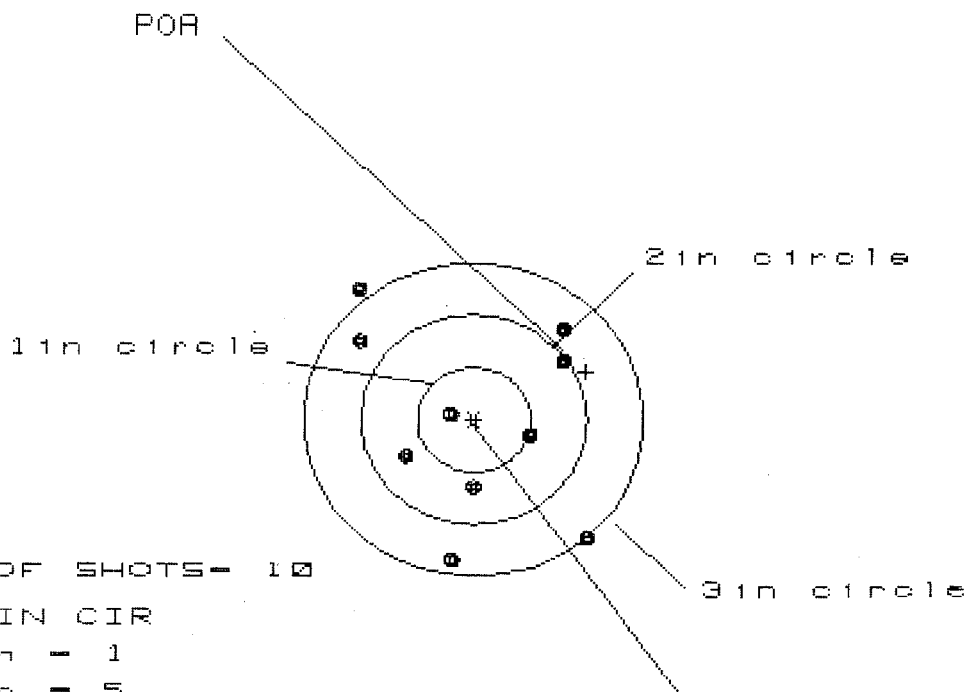
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.962	.943	.792
MINIMUM X	:	-1.184	-1.203	-.892
MAXIMUM Y	:	.723	.568	.618
MINIMUM Y	:	-1.400	-1.054	-1.004
CENTROID X	:	1.050	1.069	1.220
CENTROID Y	:	-.033	.122	.072
FOR TO CENTROID in.	:	1.050	1.076	1.222
MIN RADIUS	:	.373	.403	.372
MEAN RADIUS	:	.853	.766	.696
MAX RADIUS	:	1.411	1.269	1.060
HORIZONTAL SPREAD	:	2.146	2.146	1.684
VERTICAL SPREAD	:	2.123	1.622	1.622
EXTREME SPREAD	:	2.233	2.233	1.850
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

4



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.049

VS= 2.536

GS= 3.092

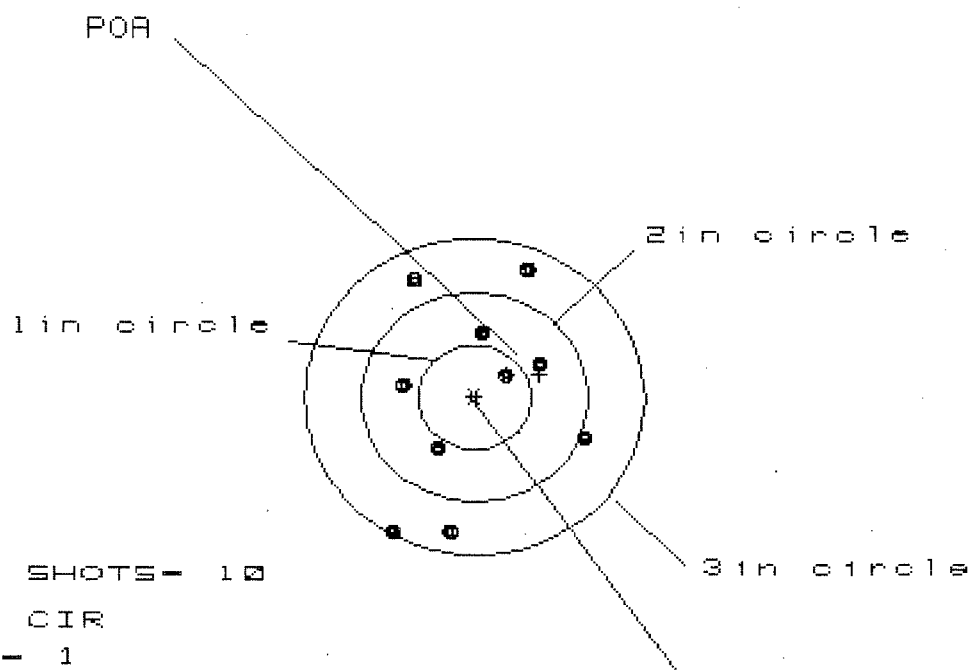
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	.887	.778
MINIMUM X	:	-1.046	-1.136	-1.026
MAXIMUM Y	:	1.222	.961	.841
MINIMUM Y	:	-1.314	-1.178	-1.298
CENTROID X	:	-.995	-.879	-.990
CENTROID Y	:	-.459	-.595	-.475
POA TO CENTROID in.	:	1.096	1.061	1.098
MIN RADIUS	:	.256	.380	.268
MEAN RADIUS	:	.982	.901	.841
MAX RADIUS	:	1.608	1.454	1.311
HORIZONTAL SPREAD	:	2.049	2.023	1.803
VERTICAL SPREAD	:	2.536	2.139	2.139
EXTREME SPREAD	:	3.092	2.751	2.342
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.685

VS= 2.574

GS= 2.841

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.961	.881	.930
MINIMUM X	:	-.724	-.669	-.620
MAXIMUM Y	:	1.249	1.102	1.064
MINIMUM Y	:	-1.325	-1.453	-1.316
CENTROID X	:	-.572	-.492	-.541
CENTROID Y	:	-.217	-.070	-.207
POA TO CENTROID in.	:	.612	.496	.580
MIN RADIUS	:	.359	.224	.328
MEAN RADIUS	:	.921	.824	.792
MAX RADIUS	:	1.510	1.486	1.341
HORIZONTAL SPREAD	:	1.685	1.550	1.550
VERTICAL SPREAD	:	2.574	2.555	2.380
EXTREME SPREAD	:	2.841	2.652	2.398
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

SWS TRIGGER PULL TEST

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

SERIAL NO. C6523524
DATE 9/8/90
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.33	2.37	2.25	2.27	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.36	2.41	2.10	2.31	
PULL #3	2.37	2.27	2.17	2.31	
PULL #4	2.22	2.40	2.17	2.32	
PULL #5	2.27	2.56	2.25	2.32	
TOTAL	11.55	12.01	10.94	11.53	
AVG.	2.31	2.40	2.19	2.306	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.19		
PULL #2	3.14	3.05		
PULL #3	3.01	3.00		
PULL #4	3.07	3.08		
PULL #5	3.08	3.07		
TOTAL	15.49	15.39		
AVG.	3.10	3.08		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.01	4.11		4.02
PULL #2	4.03	4.10		3.90
PULL #3	4.06	4.00		3.95
PULL #4	4.06	4.01		4.02
PULL #5	4.12	4.00		4.00
TOTAL	20.28	20.22		19.89
AVG.	4.06	4.04		3.98

CAD 700

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # 06523524

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	8-21-90	DM
600	Proof		8-21-90	DM
607	Check Headspace		8-21-90	DM
610	Dis-assemble Gun		8-21-90	DM
612	Magnaflux Barrel Action	New Barrel 8/22/90	8/23/90	KCK
	Magnaflux Bolt		8/22/90	KCK
615	Rollmark Caliber		8/23/90	GS
617	Drill and Tap Sight Holes		8/23/90	WLB
618	Polish Barrel <i>WLB</i>		8/23/90	WLB
620	Apply Coatings (Barrel Action)		8/28/90	WLB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9/8/90	WLB

op. #	OP. NAME	READINGS					DATE	INIT
35 Int.	F) Safety On Force	4	4	4			9/10/90	WB
	G) Safety Off Force	2	2	2			9/10/90	WB
	H) Trigger Pull Test & Retainability						9/8/90	WB
	I) Firing Pin Indent	.022	.0225	.0225			9/10/90	WB
	J) Assemble Stock						9/11/90	RW
	K) Assemble Swivel Studs						9/15/90	JS
	L) Attach Front and Rear Sight Assemblies						9/11/90	RW
	M) Iron Sight Alignment						9/11/90	RW
	N) Detach Front & Rear Sights & place in numbered container						9/11/90	RW
	O) Attach Scope to Rifle						9/11/90	RW
	P) Detach & Attach Scope 20 Times						9/11/90	RW
640	Gallery Target & Test						9-12-90	AC
	A) Time						9-12-90	AC
	B) Malfunctions						9-12-90	AC
	C) Pierced Primers						9-12-90	AC
	D) Optical Clarity of Scope						9-12-90	AC
645	Inspect for Live Ammo						9-12-90	AC
655	Final Inspection							
	A) Headspace						9/15/90	JS
	B) Trigger Pull	2.27	2.31	2.31	2.32	2.32	9-15-90	JS
	C) Function						9/15/90	JS
660	Pack						9/20/90	AF