

C6636322

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



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




REGISTERED PAT. & TM. OFF.

MODEL 700™ M24

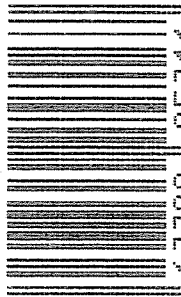
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MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee

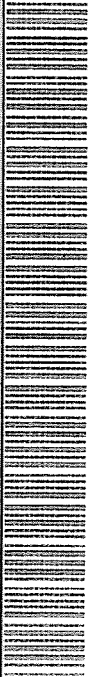
SERIAL NO.
C6636322

ORDER NO.
5716

UPC



0 47700 25716 7



5716 C6636322

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636322

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	4 30	91	RW
600	Proof	4 30	91	RW
607	Check Headspace	4 30	91	RW
610	Dis-assemble Gun	4 30	91	RW
612	Magnaflux Barrel Action	5	6 9 1	KCH
	Magnaflux Bolt	5	6 9 1	KCH
615	Rollmark Caliber	5	6 9 1	GB
617	Drill and Tap Sight Holes	5 10	91	FB
618	Polish Barrel	5 10	91	WB
620	Apply Coatings (Barrel Action)		5-30-91	DA
	Apply Coating (Bolt)			DA
625	Final Assembly A) Clean inside of Bolt Assembly		6/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6/19/91	RW
	C) Inspect Ejector Hole for Chamfer		6/19/91	RW
	D) Oil Firing Pin Ass'y		6/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-16-91	DA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			7-17-91	SH
	G) Safety Off Force	4	4	4			7-17-91	SH
	H) Trigger Pull Test & Retainability						7-16-91	SH
	I) Firing Pin Indent	.022	.022	.022			7-17-91	SH
	J) Assemble Stock						7/18/91	RW
	K) Assemble Swivel Studs						7-23-91	DH
	L) Attach Front and Rear Sight Assemblies						7/18/91	RW
	M) Iron Sight Alignment						7/18/91	RW
	N) Detach Front & Rear Sights & place in numbered container						7/18/91	RW
	O) Attach Scope to Rifle						7/18/91	RW
	P) Detach & Attach Scope 20 Times						7/18/91	RW
640	Gallery Target & Test						7-22-91	DH
	A) Time						7-22-91	DH
	B) Malfunctions						7-22-91	DH
	C) Pierced Primers						7-22-91	DH
	D) Optical Clarity of Scope						7-22-91	DH
645	Inspect for Live Ammo						7-22-91	DH
655	Final Inspection							
	A) Headspace						7-23-91	DH
	B) Trigger Pull	2.20	2.19	2.25	2.23	2.21	7-23-91	SH
	C) Function						7-23-91	DH
660	Pack						9-18-91	RW

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6636322
DATE 7-16-91
TESTER RM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.34	2.19	2.20	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.22	2.30	2.20	2.19	
PULL #3	2.66	2.24	2.15	2.25	
PULL #4	2.56	2.18	2.19	2.23	
PULL #5	2.79	2.29	2.17	2.21	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.40		
PULL #2	3.21	3.38		
PULL #3	3.30	3.47		
PULL #4	3.37	3.41		
PULL #5	3.34	3.38		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.25		4.47
PULL #2	4.20	4.27		4.67
PULL #3	4.33	4.29		4.38
PULL #4	4.34	3.92		4.71
PULL #5	4.35	4.32		4.74
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636322
23 Jul 1991

CENTROIDAL DISTANCES

0 TO 1	.320975
1 TO 2	.539796
1 TO 3	.546469
1 TO 4	.2791
1 TO 5	.162225

51

<----POA

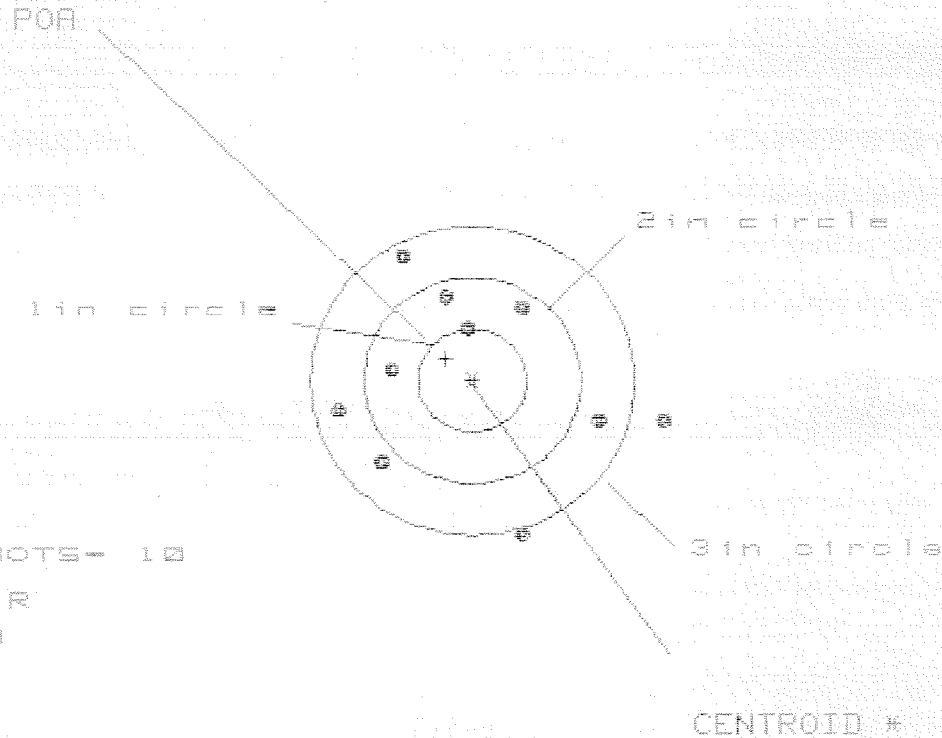
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0252
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0034
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0254283

THE AMR FOR THIS RIFLE IS: .9462

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6E36322

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

MS= 2.951

VS= 2.659

GS= 2.954

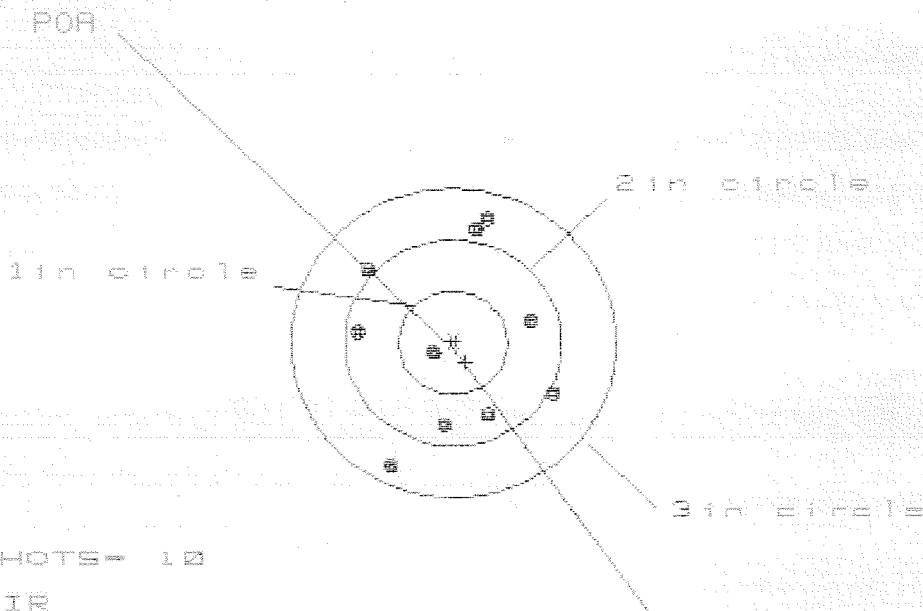
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.719	1.383	1.462
MINIMUM X	-1.232	-1.041	-.962
MAXIMUM Y	1.218	1.172	.986
MINIMUM Y	-1.441	-1.487	-1.015
CENTROID X	.241	.050	-.029
CENTROID Y	-.212	-.166	.020
POA TO CENTROID in.	.321	.173	.035
MIN RADIUS	.502	.483	.362
MEAN RADIUS	1.125	1.020	.896
MAX RADIUS	1.767	1.617	1.535
HORIZONTAL SPREAD	2.951	2.424	2.424
VERTICAL SPREAD	2.659	2.659	2.001
EXTREME SPREAD	2.954	2.873	2.433
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

23 Jul 1991

FILE:/PATTERNS/CENTERFIRE_PATT/C6636322

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 1.817

VS= 2.376

GS= 2.551

CENTROID *

PATTERN #

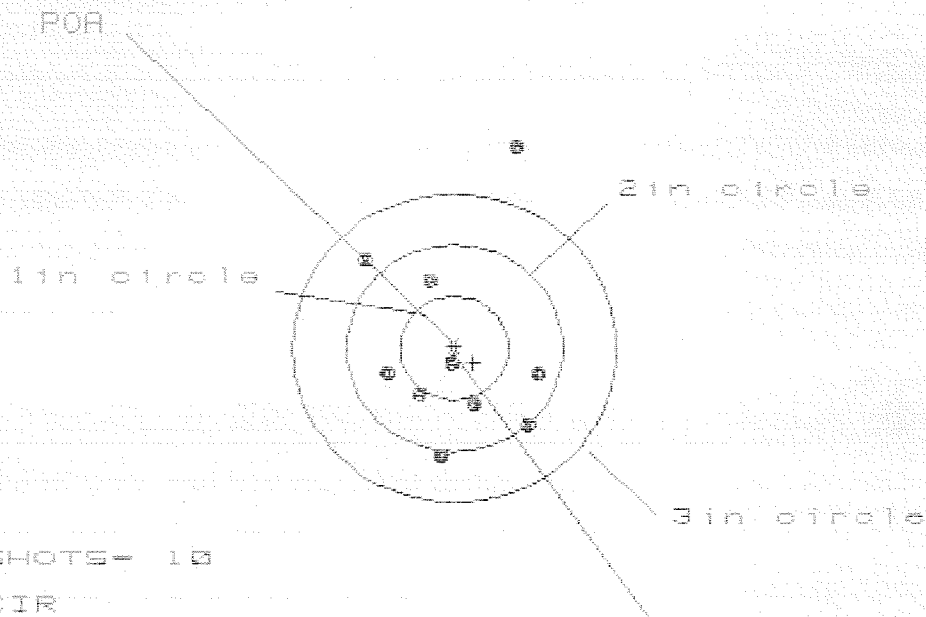
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SHOTS (BEST OF)	10	9	9
MAXIMUM X	.935	.865	.894
MINIMUM X	-.882	-.952	-.923
MAXIMUM Y	1.168	1.034	1.055
MINIMUM Y	-1.208	-.922	-.793
CENTROID X	-.117	-.047	-.076
CENTROID Y	.192	.326	.197
POA TO CENTROID in.	.225	.330	.212
MIN RADIUS	.213	.357	.249
MEAN RADIUS	.916	.871	.826
MAX RADIUS	1.362	1.089	1.075
HORIZONTAL SPREAD	1.817	1.817	1.817
VERTICAL SPREAD	2.376	1.956	1.848
EXTREME SPREAD	2.551	2.099	2.099
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636322

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

CENTROID *

HS= 1.555

VS= 3.032

GS= 3.113

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	.742	.805	.711
MINIMUM X	-.813	-.750	-.610
MAXIMUM Y	1.957	1.101	1.031
MINIMUM Y	-1.075	-.858	-.720
CENTROID X	-.177	-.240	-.146
CENTROID Y	.140	-.077	-.215
POA TO CENTROID in.	.226	.252	.260
MIN RADIUS	.131	.099	.226
MEAN RADIUS	.876	.691	.598
MAX RADIUS	2.038	1.333	1.053
HORIZONTAL SPREAD	1.555	1.555	1.321
VERTICAL SPREAD	3.032	1.959	1.751
EXTREME SPREAD	3.113	2.235	1.752
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

23 Jul 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6635322

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.612

VS= 1.989

GS= 2.870

CENTROID #

PATTERN #

:

4

SHOTS (BEST OF)

:

10

9

8

MAXIMUM X

:

1.262

1.112

.928

MINIMUM X

:

-1.350

-1.016

-.877

MAXIMUM Y

:

1.132

1.037

.963

MINIMUM Y

:

-.857

-.723

-.797

CENTROID X

:

.092

.242

.102

CENTROID Y

:

.024

.119

.193

POA TO CENTROID in.

:

.095

.269

.219

MIN RADIUS

:

.349

.265

.182

MEAN RADIUS

:

.892

.811

.723

MAX RADIUS

:

1.599

1.260

1.224

HORIZONTAL SPREAD

:

2.612

2.120

1.805

VERTICAL SPREAD

:

1.989

1.760

1.760

EXTREME SPREAD

:

2.870

2.150

2.062

NUMBER IN ONE INCH CIRCLE =

3

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

8

23 JUL 1981

FILE: \PATTERNING\CENTERFIRE_PATT\C8B36322

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 2.491

VS= 2.877

GS= 2.878

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.132	1.146	.978
MINIMUM X	:	-1.359	-1.345	-.866
MAXIMUM Y	:	.881	.659	.631
MINIMUM Y	:	-1.996	-.898	-.926
CENTROID X	:	.087	.073	.241
CENTROID Y	:	-.161	.061	.089
POA TO CENTROID in.	:	.183	.095	.257
MIN RADIUS	:	.291	.298	.172
MEAN RADIUS	:	.922	.751	.657
MAX RADIUS	:	2.000	1.363	1.090
HORIZONTAL SPREAD	:	2.491	2.491	1.844
VERTICAL SPREAD	:	2.877	1.557	1.557
EXTREME SPREAD	:	2.878	2.502	1.912
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	