

66611793

MODEL 760TM 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
rifle.




REG. U.S. PAT. & TM. OFF.

MODEL 700™ M24

SERIAL NO.
C6611793

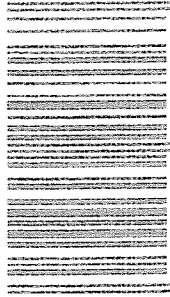
ORDER NO.
5716

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



5716 C6611793

UPC



0 4700 25716

7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

26611793

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		1/24/91	KS
600	Proof		1/24/91	KS
607	Check Headspace		1/24/91	KS
610	Dis-assemble Gun		1/24/91	KS
612	Magnaflux Barrel Action		1/29/91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	LL
617	Drill and Tap Sight Holes	2 2	91	FB
618	Polish Barrel RBB	2 2	91	WB
620	Apply Coatings (Barrel Action)		2-11-91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/14/91	KA
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/14/91	KA
	C) Inspect Ejector Hole for Chamfer		2/14/91	KA
	D) Oil Firing Pin Ass'y		2/14/91	KA
	E) Adjust Trigger Pull to Min Setting and Stake		2/15/91	KA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			2/16/91	WB
	G) Safety Off Force	3	3	3			2/16/91	WB
	H) Trigger Pull Test & Retainability						2/15/91	JU
	I) Firing Pin Indent	.0205	.020	.0205			2/16/91	WB
	J) Assemble Stock						2/18/91	KA
	K) Assemble Swivel Studs						2-22-91	A
	L) Attach Front and Rear Sight Assemblies						2/18/91	KA
	M) Iron Sight Alignment						2/18/91	KA
	N) Detach Front & Rear Sights & place in numbered container						2/18/91	KA
	O) Attach Scope to Rifle						2/18/91	KA
	P) Detach & Attach Scope 20 Times						2/18/91	KA
640	Gallery Target & Test						2/19/91	WB
	A) Time							10
	B) Malfunctions							10
	C) Pierced Primers							12
	D) Optical Clarity of Scope							12
645	Inspect for Live Ammo						2/19/91	12
655	Final Inspection							
	A) Headspace						2-22-91	A
	B) Trigger Pull	2.31	2.37	2.29	2.39	2.37	2/22/91	KA
	C) Function						2-22-91	AC
660	Pack						3-11-91	VF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611793

DATE 2/15/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.51	2.38	2.20	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.20	2.22	2.37	
PULL #3	2.19	2.41	2.38	2.29	
PULL #4	2.24	2.20	2.24	2.39	
PULL #5	2.44	2.27	2.25	2.37	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.58		
PULL #2	3.32	3.45		
PULL #3	3.50	3.38		
PULL #4	3.48	3.33		
PULL #5	3.35	3.46		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.46	4.15		4.30
PULL #2	4.45	4.22		4.39
PULL #3	4.39	4.44		4.18
PULL #4	4.31	4.31		4.15
PULL #5	4.15	4.42		4.46
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611793
20 Feb 1991

CENTROIDAL DISTANCES

0 TO	1	.0425441
1 TO	2	.227108
1 TO	3	.121458
1 TO	4	.150546
1 TO	5	.168772

 <----POA

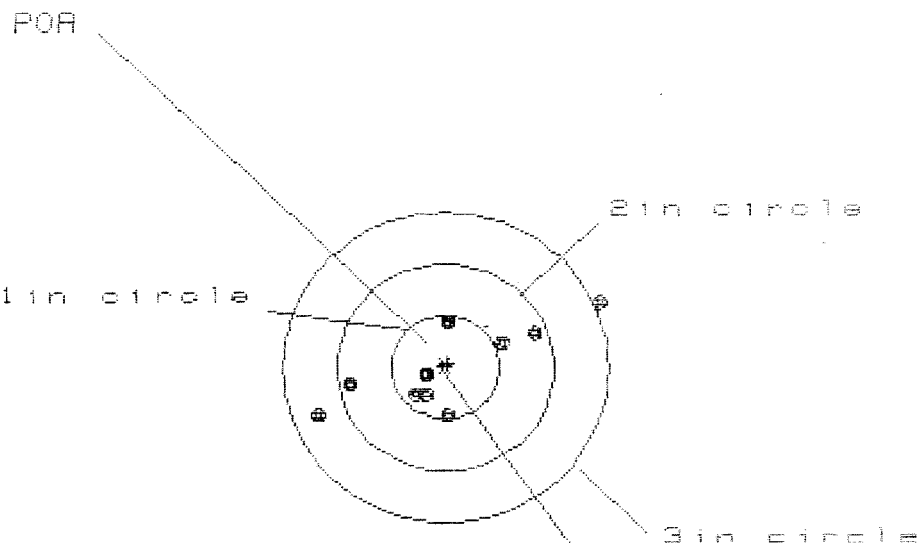
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0052
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0344
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0347908

THE AMR FOR THIS RIFLE IS: .9104

28 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811793

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 5

2in = 8

3in = 9

HS= 2.590

VS= 1.128

GS= 2.825

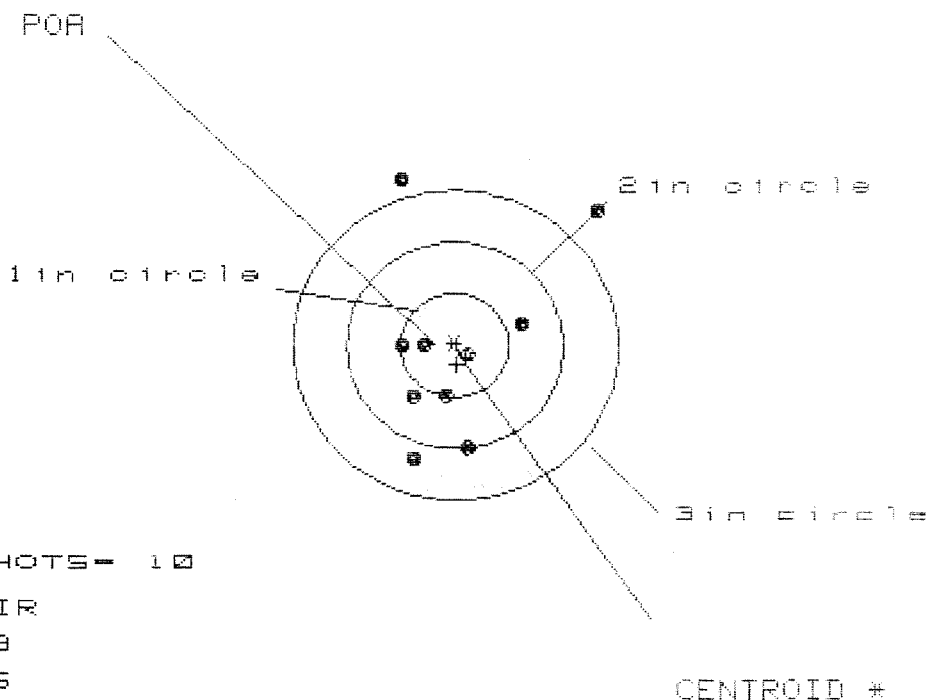
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.448	.936	.813
MINIMUM X	:	-1.142	-.981	-.833
MAXIMUM Y	:	.650	.491	.440
MINIMUM Y	:	-.478	-.405	-.414
CENTROID X	:	-.021	-.182	-.059
CENTROID Y	:	-.037	-.110	-.059
POA TO CENTROID in.	:	.043	.213	.084
MIN RADIUS	:	.234	.063	.191
MEAN RADIUS	:	.682	.536	.490
MAX RADIUS	:	1.587	1.061	.878
HORIZONTAL SPREAD	:	2.590	1.917	1.646
VERTICAL SPREAD	:	1.128	.896	.854
EXTREME SPREAD	:	2.825	2.072	1.700
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in - 3

2 in - 5

3 in - 8

HS - 1.779

VS - 2.667

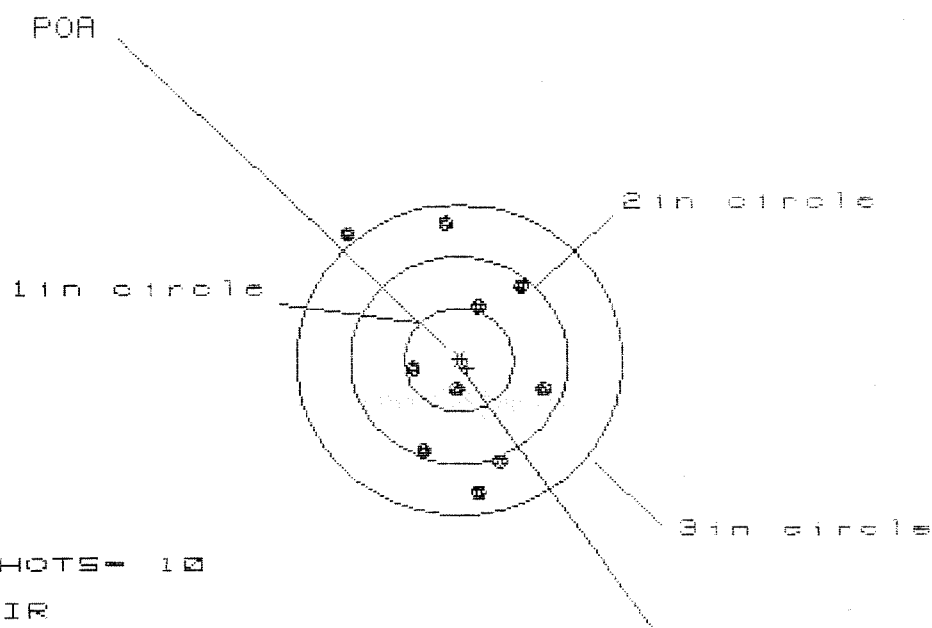
GS - 2.884

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.294	.738	.700
MINIMUM X	:	-.485	-.341	-.379
MAXIMUM Y	:	1.591	1.733	.605
MINIMUM Y	:	-1.076	-.934	-.718
CENTROID X	:	-.014	-.158	-.120
CENTROID Y	:	.190	.048	-.169
POA TO CENTROID in.	:	.190	.165	.207
MIN RADIUS	:	.090	.199	.158
MEAN RADIUS	:	.826	.672	.514
MAX RADIUS	:	1.816	1.759	.925
HORIZONTAL SPREAD	:	1.779	1.079	1.079
VERTICAL SPREAD	:	2.667	2.667	1.322
EXTREME SPREAD	:	2.884	2.668	1.641
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 8

HS = 1.777

VS = 2.599

GS = 2.795

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.744	.629	.630
MINIMUM X	:	-1.033	-.510	-.509
MAXIMUM Y	:	1.282	1.418	1.270
MINIMUM Y	:	-1.317	-1.191	-.955
CENTROID X	:	-.075	.040	.039
CENTROID Y	:	.079	-.057	.091
POA TO CENTROID in.	:	.109	.070	.098
MIN RADIUS	:	.288	.199	.325
MEAN RADIUS	:	.913	.816	.774
MAX RADIUS	:	1.603	1.437	1.292
HORIZONTAL SPREAD	:	1.777	1.139	1.139
VERTICAL SPREAD	:	2.599	2.599	2.225
EXTREME SPREAD	:	2.795	2.611	2.275
NUMBER IN ONE INCH CIRCLE =			2	

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CENTERFIRE PATTERNS

4

POR

1 in circle

2 in circle

3 in circle

OF SHOTS - 10

IN CIR

1 in - 3

2 in - 5

3 in - 8

HS = 1.754

VS = 2.762

GS = 2.815

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.852	.766
MINIMUM X	:	-.845	-.902	-.987
MAXIMUM Y	:	1.310	1.149	1.042
MINIMUM Y	:	-1.452	-1.093	-.950
CENTROID X	:	.029	.086	.172
CENTROID Y	:	.105	.266	.123
POR TO CENTROID in.	:	.109	.280	.211
MIN RADIUS	:	.280	.138	.191
MEAN RADIUS	:	.929	.835	.769
MAX RADIUS	:	1.540	1.417	1.370
HORIZONTAL SPREAD	:	1.754	1.754	1.754
VERTICAL SPREAD	:	2.762	2.242	1.992

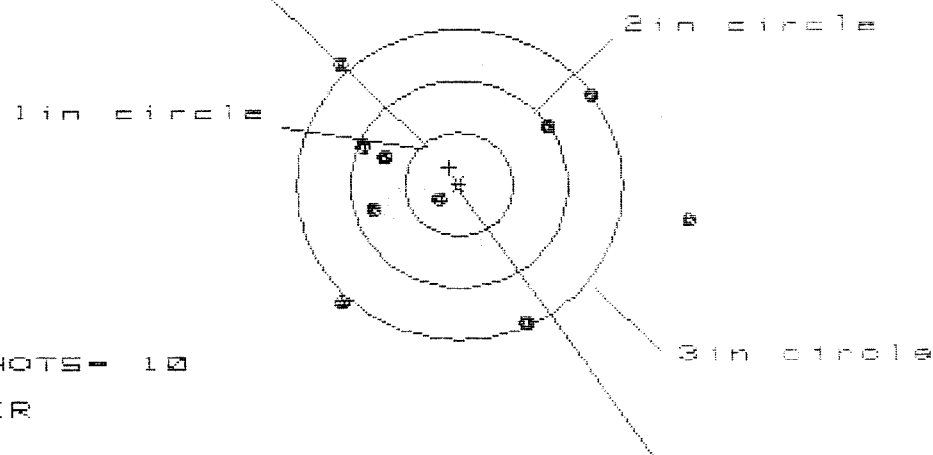
EXTREME	SPREAD :	2.815	2.592	2.592
NUMBER IN ONE	INCH CIRCLE =		3	
NUMBER IN TWO	INCH CIRCLE =		5	
NUMBER IN THREE	INCH CIRCLE =		9	

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 6

HS= 3.217

VS= 2.535

GS= 3.530

CENTROID *

PATTERN # : 5

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.126	1.443	1.336
MINIMUM X	:	-1.091	-.855	-.948
MAXIMUM Y	:	1.168	1.137	1.004
MINIMUM Y	:	-1.367	-1.398	-1.256
CENTROID X	:	.089	-.147	-.040
CENTROID Y	:	-.165	-.134	-.276
POA TO CENTROID in.	:	.188	.199	.279
MIN RADIUS	:	.220	.153	.059
MEAN RADIUS	:	1.202	1.037	.994

MAX RADIUS :	2.145	1.681	1.671
HORIZONTAL SPREAD :	3.217	2.298	2.284
VERTICAL SPREAD :	2.535	2.535	2.260
EXTREME SPREAD :	3.530	3.084	3.084
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		6	