

C6636011

MODEL 760™ M24

Model **SMS**™

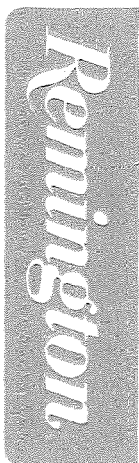
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

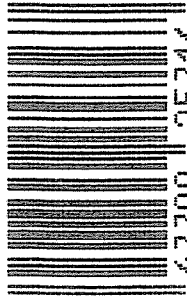
MODEL 700TM M24

SERIAL NO.
C6636011

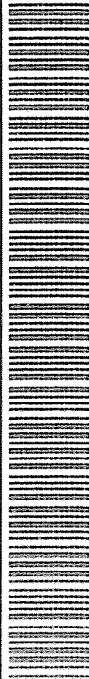
ORDER NO.
5716

MADE IN U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.

LPC



0 47700 25716 7



5716 C6636011

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6636011

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		5/1/91	KS
600	Proof		5/1/91	KS
607	Check Headspace		5/1/91	KS
610	Dis-assemble Gun		5/1/91	KS
612	Magnaflux Barrel Action	5 8 9 1		Ked
	Magnaflux Bolt	5 8 9 1		Ked
615	Rollmark Caliber	5 8 9 1		GS
617	Drill and Tap Sight Holes	5 15 9 1		KS
618	Polish Barrel	5 15 9 1		KS
620	Apply Coatings (Barrel Action)		5-31-91	KS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		6-6-91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		6-6-91	KS
	C) Inspect Ejector Hole for Chamfer		6-6-91	KS
	D) Oil Firing Pin Ass'y		6-6-91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		6-7-91	KS

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			6-7-91	JL
	G) Safety Off Force	4	4	4			6-7-91	JL
	H) Trigger Pull Test & Retainability						6-7-91	JL
	I) Firing Pin Indent	.0205	.0205	.0205			6-7-91	JL
	J) Assemble Stock						6-7-91	KS
	K) Assemble Swivel Studs						6-12-91	A
	L) Attach Front and Rear Sight Assemblies						6-7-91	KS
	M) Iron Sight Alignment						6-7-91	KS
	N) Detach Front & Rear Sights & place in numbered container						6-7-91	KS
	O) Attach Scope to Rifle						6-7-91	KS
	P) Detach & Attach Scope 20 Times						6-7-91	KS
640	Gallery Target & Test						6/10/91	KT
	A) Time							KT
	B) Malfunctions							KT
	C) Pierced Primers							KT
	D) Optical Clarity of Scope							KT
645	Inspect for Live Ammo						6/10/91	KT
655	Final Inspection							
	A) Headspace						6-12-91	A
	B) Trigger Pull	2.57	2.55	2.47	2.46	2.41	6-12-91	JL
	C) Function						6-12-91	AC
660	Pack						6-19-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. 0-6636011

DATE 6-7-91

TESTER J21

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.57	2.70	2.50	2.57	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.50	2.58	2.56	2.55	
PULL #3	2.58	2.59	2.55	2.47	
PULL #4	2.45	2.57	2.59	2.46	
PULL #5	2.55	2.55	2.55	2.41	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.33		
PULL #2	3.37	3.18		
PULL #3	3.28	3.29		
PULL #4	3.20	3.19		
PULL #5	3.28	3.30		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.39	4.54		4.14
PULL #2	4.19	4.69		4.57
PULL #3	4.58	4.26		4.69
PULL #4	4.23	4.48		4.25
PULL #5	4.48	4.67		4.23
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636011
10 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.307688
1 TO	2	.326339
1 TO	3	.390006
1 TO	4	.654426
1 TO	5	.485412

$\frac{4}{5} \frac{1}{2}$ <----FOR

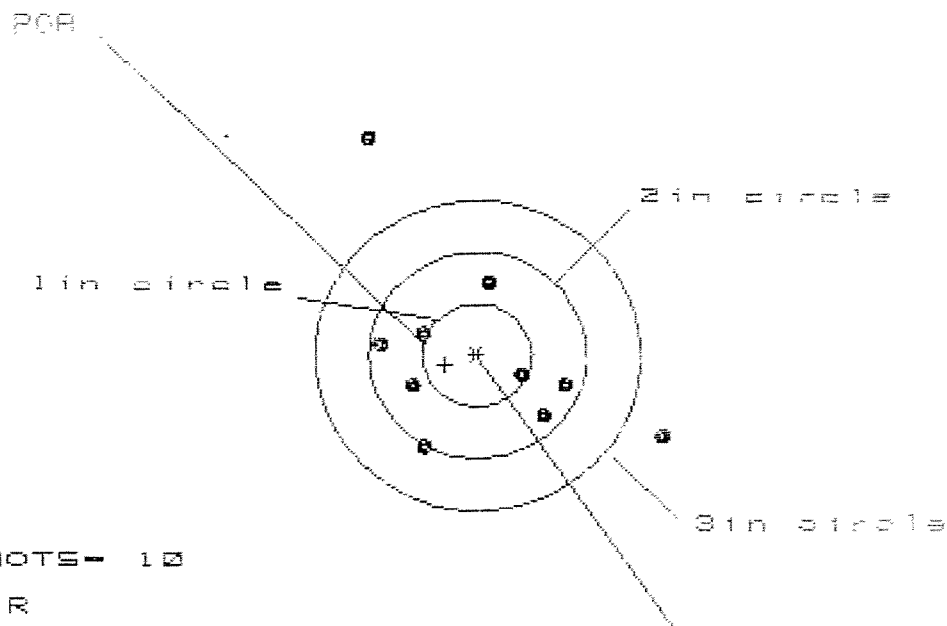
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0306
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0842
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0895879
THE AMR FOR THIS RIFLE IS: 1.011

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08689011

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1 in - 1

2 in - 7

3 in - 8

HS - 2.747

VS - 3.031

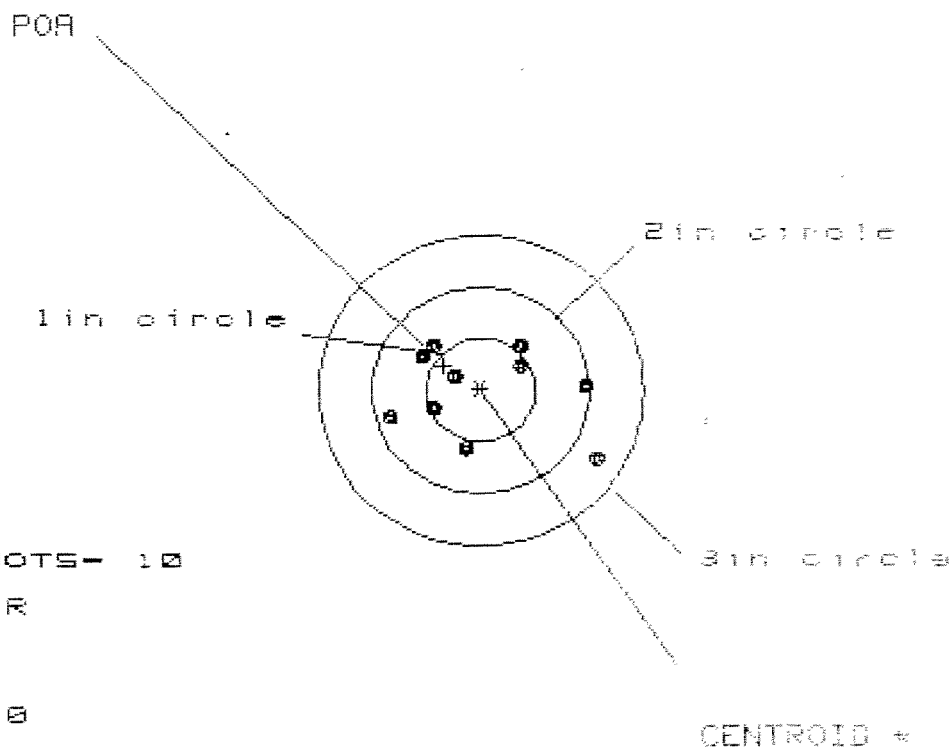
GS - 4.060

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.705	1.589	.853
MINIMUM X	:	-1.042	-.984	-.785
MAXIMUM Y	:	2.160	.928	.854
MINIMUM Y	:	-.871	-.631	-.705
CENTROID X	:	.296	.412	.213
CENTROID Y	:	.084	-.156	-.082
POA TO CENTROID in.	:	.308	.440	.228
MIN RADIUS	:	.475	.298	.501
MEAN RADIUS	:	1.025	.845	.726
MAX RADIUS	:	2.398	1.695	.890
HORIZONTAL SPREAD	:	2.747	2.573	1.638
VERTICAL SPREAD	:	3.031	1.559	1.559
EXTREME SPREAD	:	4.060	2.724	1.678
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

10 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6836011

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in - 3

2in - 9

3in - 10

HS= 1.930

VS= 1.140

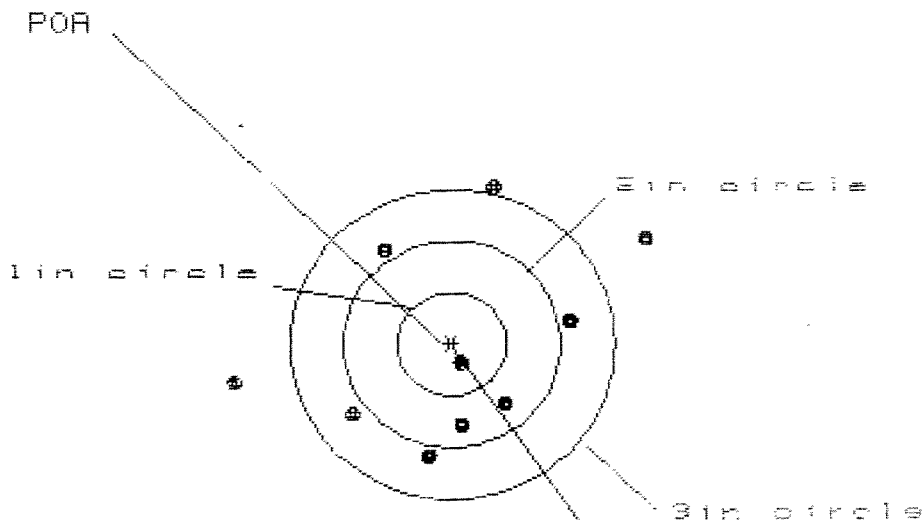
GS= 1.970

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.051	1.033	.937
MINIMUM X	:	-.879	-.762	-.536
MAXIMUM Y	:	.480	.407	.365
MINIMUM Y	:	-.660	-.667	-.709
CENTROID X	:	.335	.218	.314
CENTROID Y	:	-.240	-.167	-.125
POA TO CENTROID in.	:	.412	.275	.338
1IN RADIUS	:	.311	.173	.247
MEAN RADIUS	:	.671	.575	.548
MAX RADIUS	:	1.241	1.035	.944
HORIZONTAL SPREAD	:	1.930	1.795	1.473
VERTICAL SPREAD	:	1.140	1.074	1.074
EXTREME SPREAD	:	1.970	1.814	1.501
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			10	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8596011

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 7

HS = 3.768

VS = 2.619

GS = 4.016

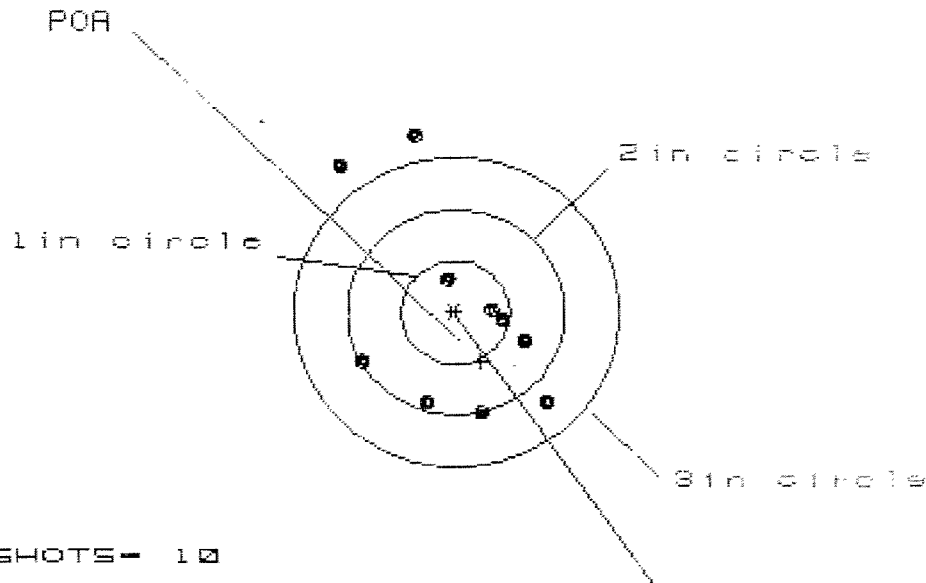
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.749
MINIMUM X	-2.019
MAXIMUM Y	1.555
MINIMUM Y	-1.064
CENTROID X	-.083
CENTROID Y	.176
POA TO CENTROID in.	.195
MIN RADIUS	.207
MEAN RADIUS	1.189
MAX RADIUS	2.058
HORIZONTAL SPREAD	3.768
VERTICAL SPREAD	2.619
EXTREME SPREAD	4.018
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	7

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C885601

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.870

VS= 2.685

GS= 2.962

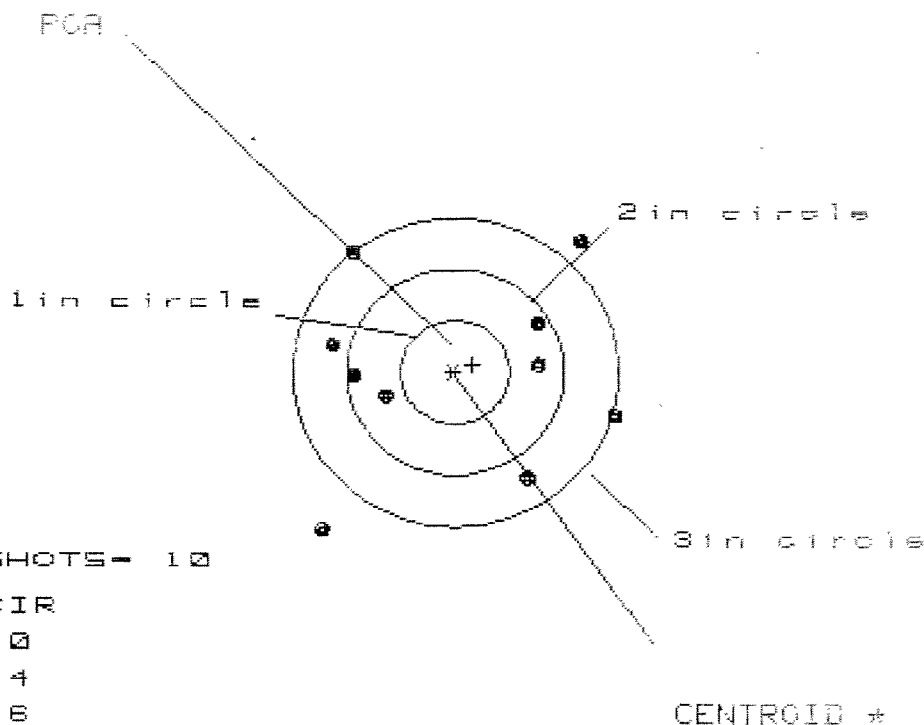
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.844	.801	.667
MINIMUM X	:	-1.026	-1.069	-.997
MAXIMUM Y	:	1.754	1.593	.742
MINIMUM Y	:	-.932	-.737	-.527
CENTROID X	:	-.231	-.188	-.054
CENTROID Y	:	.472	.277	.077
POA TO CENTROID in.	:	.525	.334	.094
MIN RADIUS	:	.350	.387	.418
MEAN RADIUS	:	.940	.809	.632
MAX RADIUS	:	1.797	1.919	1.800
HORIZONTAL SPREAD	:	1.870	1.870	1.664
VERTICAL SPREAD	:	2.685	2.330	1.200
EXTREME SPREAD	:	2.962	2.962	1.719
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8695811

CENTERFIRE PATTERNS

5



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 4

3 in - 6

HS- 2.663

VS- 2.740

GS- 3.640

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.460	1.327	1.459
MINIMUM X	:	-1.203	-1.270	-1.138
MAXIMUM Y	:	1.224	1.056	1.148
MINIMUM Y	:	-1.516	-1.176	-1.044
CENTROID X	:	-.164	-.031	-.163
CENTROID Y	:	-.071	.097	-.035
POA TO CENTROID in.	:	.179	.102	.167
MIN RADIUS	:	.672	.612	.685
MEAN RADIUS	:	1.232	1.142	1.085
MAX RADIUS	:	1.935	1.500	1.530
HORIZONTAL SPREAD	:	2.663	2.597	2.597
VERTICAL SPREAD	:	2.740	2.232	2.192
EXTREME SPREAD	:	3.640	2.914	2.914
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636011
17 Jun 1991

CENTROIDAL DISTANCES

0 TO	1	.332399
1 TO	2	.536196
1 TO	3	.390309
1 TO	4	.729079
1 TO	5	.488185

154 <----POA

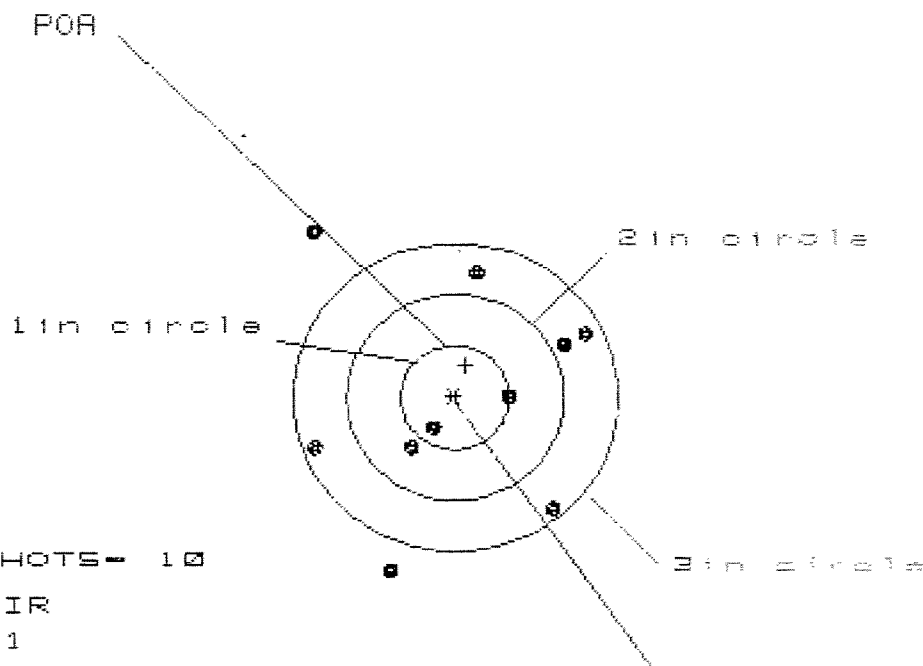
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .203
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0268
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .204761
THE AMR FOR THIS RIFLE IS: .9648

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8836011.1

CENTERFIRE PATTERNS

1



OF SHOTS - 10

IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.496

VS= 3.297

GS= 3.401

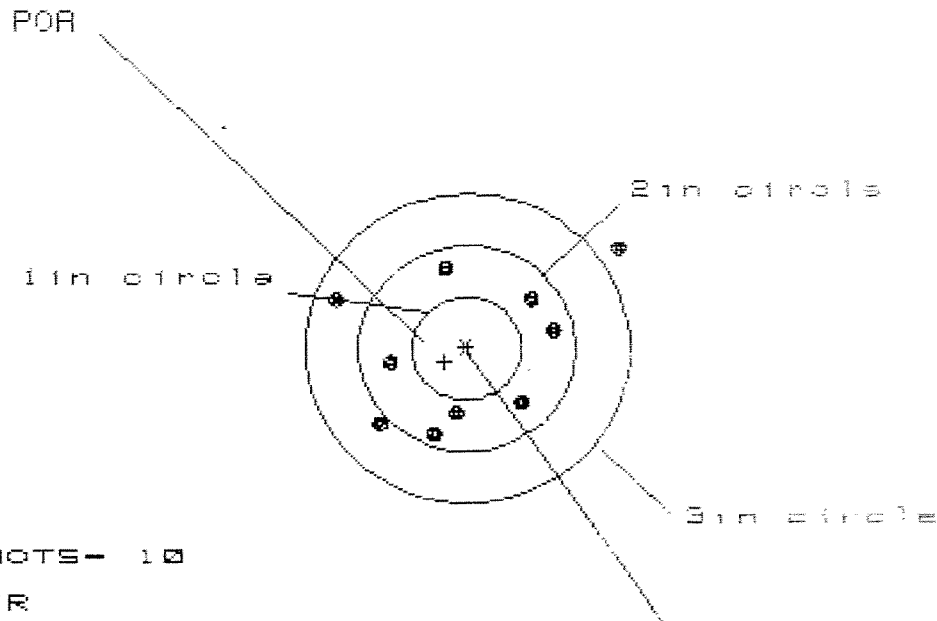
CENTROID +

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.202	1.058	.969
MINIMUM X	:	-1.294	-1.438	-1.527
MAXIMUM Y	:	1.603	1.348	1.159
MINIMUM Y	:	-1.694	-1.516	-1.853
CENTROID X	:	-.100	.044	.133
CENTROID Y	:	-.317	-.495	-.306
POA TO CENTROID in.	:	.332	.497	.333
MIN RADIUS	:	.353	.376	.296
MEAN RADIUS	:	1.170	1.050	.955
MAX RADIUS	:	2.057	1.677	1.520
HORIZONTAL SPREAD	:	2.496	2.496	2.496
VERTICAL SPREAD	:	3.297	2.864	2.212
EXTREME SPREAD	:	3.401	2.977	2.786
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			3	
NUMBER IN THREE INCH CIRCLE =			8	

17 Jun 1991

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 0

2 in - 7

3 in - 9

HS= 2.535

VS= 1.795

GS= 2.732

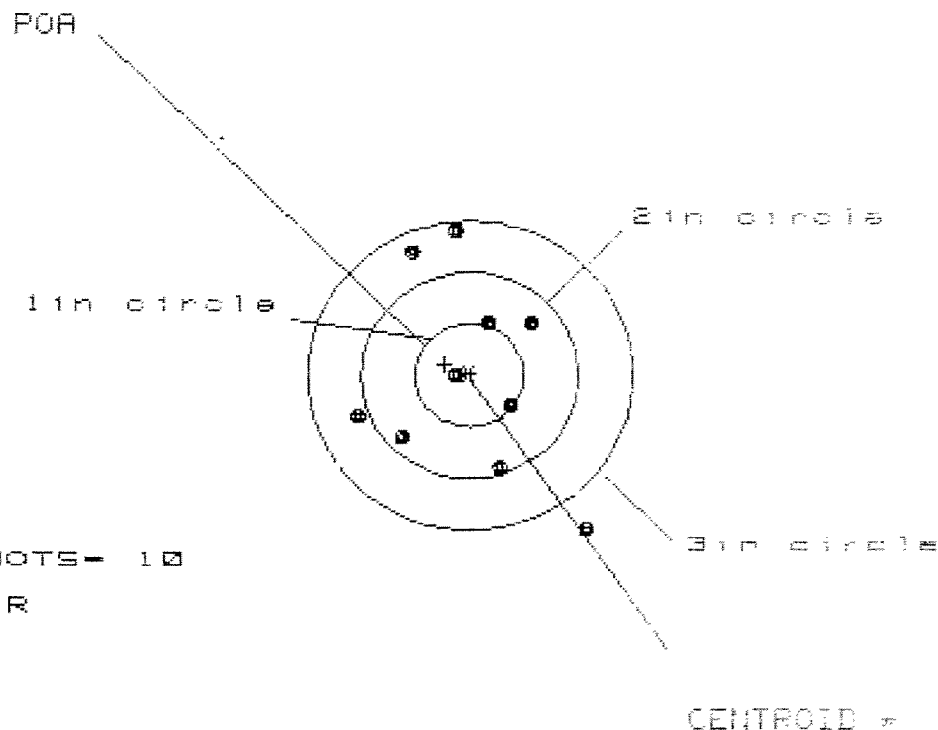
CENTROID *

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.364	.953	.826
MINIMUM X	-1.171	-1.020	-.752
MAXIMUM Y	.947	.895	.965
MINIMUM Y	-.848	-.742	-.672
CENTROID X	.205	.054	.181
CENTROID Y	.124	.018	-.052
POR TO CENTROID in.	.239	.057	.188
MIN RADIUS	.649	.543	.471
MEAN RADIUS	.940	.838	.781
MAX RADIUS	1.661	1.166	.979
HORIZONTAL SPREAD	2.535	1.973	1.578
VERTICAL SPREAD	1.795	1.637	1.637
EXTREME SPREAD	2.732	1.998	1.887
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C653601.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.069

VS= 2.909

GS= 3.143

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.050	.648	.645
MINIMUM X	:	-1.020	-.903	-.906
MAXIMUM Y	:	1.441	1.278	1.234
MINIMUM Y	:	-1.468	-1.036	-.876
CENTROID X	:	.229	.112	.115
CENTROID Y	:	-.107	.056	-.103
POA TO CENTROID in.	:	.252	.125	.155
MIN RADIUS	:	.102	.201	.045
MEAN RADIUS	:	.938	.848	.764
MAX RADIUS	:	1.805	1.278	1.302
HORIZONTAL SPREAD	:	2.069	1.551	1.551
VERTICAL SPREAD	:	2.909	2.314	2.111
EXTREME SPREAD	:	3.143	2.346	2.248
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C863601.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS= 2.535

VS= 2.509

GS= 2.910

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.348	1.389	1.245
MINIMUM X	:	-1.187	-1.146	-0.893
MAXIMUM Y	:	.964	.792	.885
MINIMUM Y	:	-1.545	-1.169	-1.075
CENTROID X	:	.516	.475	.619
CENTROID Y	:	.073	.245	.151
POA TO CENTROID in.	:	.521	.535	.637
MIN RADIUS	:	.115	.135	.209
MEAN RADIUS	:	.956	.879	.809
MAX RADIUS	:	1.587	1.405	1.352
HORIZONTAL SPREAD	:	2.535	2.535	2.138
VERTICAL SPREAD	:	2.509	1.961	1.961
EXTREME SPREAD	:	2.910	2.591	2.484
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

17 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C0835011.1

CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 5

2in = 6

3in = 9

HS= 2.239

VS= 2.357

GS= 3.022

CENTROID

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.942	1.018	.877
MINIMUM X	:	-1.298	-1.221	-1.062
MAXIMUM Y	:	.891	.728	.542
MINIMUM Y	:	-1.466	-1.170	-1.079
CENTROID X	:	.165	.088	.329
CENTROID Y	:	.093	.256	.105
POA TO CENTROID in.	:	.189	.271	.293
MIN RADIUS	:	.192	.154	.200
MEAN RADIUS	:	.800	.783	.608
MAX RADIUS	:	1.619	1.551	1.391
HORIZONTAL SPREAD	:	2.239	2.239	2.349
VERTICAL SPREAD	:	2.357	1.898	1.621
EXTREME SPREAD	:	3.022	2.866	2.549
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	