

C6636092

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.



M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6636092

Stock
Repaired

REPAIR 02/27/91

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 4 8 9 1		Rw
600	Proof	1 4 8 9 1		Rw
607	Check Headspace	1 4 8 9 1		Rw
610	Dis-assemble Gun	1 4 8 9 1		Rw
612	Magnaflux Barrel Action		APR 9 1991	KR
	Magnaflux Bolt		APR 9 1991	Y
615	Rollmark Caliber		APR 9 1991	JS
617	Drill and Tap Sight Holes		APR 19 1991	LB
618	Polish Barrel		APR 19 1991	LB
620	Apply Coatings (Barrel Action)		5/10/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/91	Rw
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	Rw
	C) Inspect Ejector Hole for Chamfer		5/10/91	Rw
	D) Oil Firing Pin Ass'y		5/10/91	Rw
	E) Adjust Trigger Pull to Min Setting and Stake		5/24/91	Y

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	5	3		5-24-91	D/H
	G) Safety Off Force	4	3	3	3		5-24-91	D/H
	H) Trigger Pull Test & Retainability						5/24/91	JH
	I) Firing Pin Indent	.020	.020	.021			5-24-91	D/H
	J) Assemble Stock						5/25/91	Rw
	K) Assemble Swivel Studs						6-1-91	D/H
	L) Attach Front and Rear Sight Assemblies						5/25/91	Rw
	M) Iron Sight Alignment						5/25/91	Rw
	N) Detach Front & Rear Sights & place in numbered container						5/25/91	Rw
	O) Attach Scope to Rifle						5/25/91	Rw
	P) Detach & Attach Scope 20 Times						5/25/91	Rw
640	Gallery Target & Test						5-29-91	AC
	A) Time						5-29-91	AC
	B) Malfunctions						5-29-91	AC
	C) Pierced Primers						5-29-91	AC
	D) Optical Clarity of Scope						5-29-91	AC
645	Inspect for Live Ammo						5-29-91	AC
655	Final Inspection							
	A) Headspace						6-1-91	D/H
	B) Trigger Pull	2.48	2.25	2.20	2.18	2.15	6/1/91	D/H
	C) Function						6-1-91	D/H
660	Pack						6-20-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6636092

DATE 5/24/91

TESTER JP

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.37	2.70	2.40	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.31	2.48	2.25	
PULL #3	2.39	2.34	2.41	2.20	
PULL #4	2.32	2.41	2.35	2.18	
PULL #5	2.30	2.45	2.48	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.55		
PULL #2	3.36	3.52		
PULL #3	3.44	3.60		
PULL #4	3.55	3.50		
PULL #5	3.39	3.28		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.41	4.55		4.30
PULL #2	4.37	4.37		4.33
PULL #3	4.13	4.37		4.33
PULL #4	4.28	4.25		4.20
PULL #5	4.18	4.26		4.33
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6636092
29 May 1991

CENTROIDAL DISTANCES

Ø TO	1	.0595399
1 TO	2	.332866
1 TO	3	.196023
1 TO	4	.282816
1 TO	5	.212002

←----POA

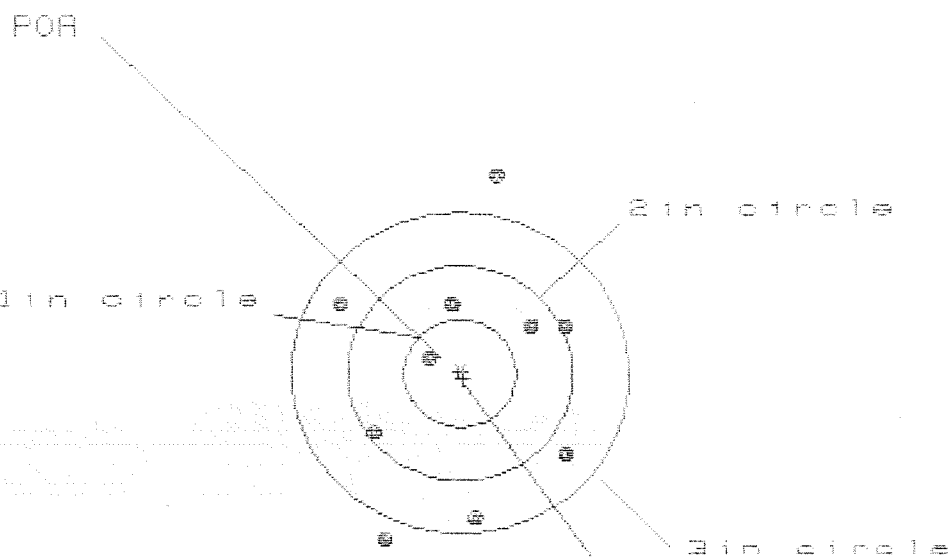
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0912
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0376
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0986468

THE AMR FOR THIS RIFLE IS: .6588

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08636092

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 4

3in = 5

HS= 1.988

VS= 3.366

GS= 3.511

CENTROID #

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.940	.971	.886
MINIMUM X	:	-1.048	-1.017	-1.102
MAXIMUM Y	:	1.849	.874	.710
MINIMUM Y	:	-1.517	-1.311	-1.265
CENTROID X	:	-.029	-.060	.025
CENTROID Y	:	.052	-.154	.010
POA TO CENTROID in.	:	.059	.165	.027
MIN RADIUS	:	.272	.385	.338
MEAN RADIUS	:	1.091	1.011	.926
MAX RADIUS	:	1.871	1.477	1.299
HORIZONTAL SPREAD	:	1.988	1.988	1.988
VERTICAL SPREAD	:	3.366	2.185	1.975
EXTREME SPREAD	:	3.511	2.543	2.378
NUMBER IN ONE INCH CIRCLE	=	1	4	5
NUMBER IN TWO INCH CIRCLE	=	4	4	5
NUMBER IN THREE INCH CIRCLE	=	5	4	5

29 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8636092

CENTERFIRE PATTERNS

2

POA

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 5

2in = 5

3in = 8

HS= 2.314

VS= 1.945

GS= 2.807

CENTROID *

PATTERN # : 2

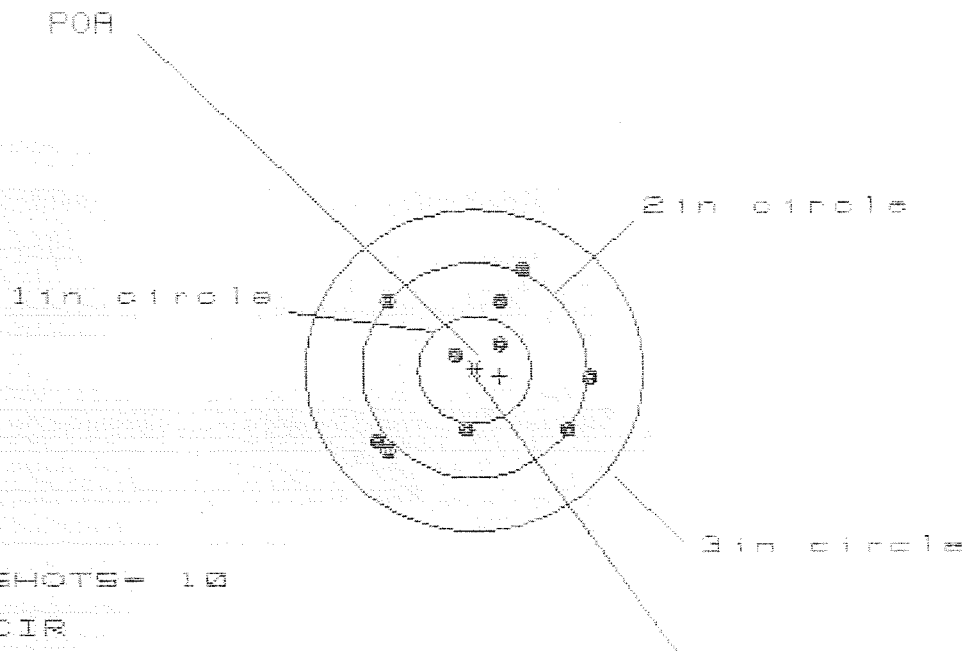
	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.274	.950	.853
MINIMUM X	-1.040	-.899	-.996
MAXIMUM Y	1.017	.914	1.005
MINIMUM Y	-.928	-.835	-.744
CENTROID X	.151	.010	.107
CENTROID Y	.332	.435	.344
POA TO CENTROID in.	.365	.435	.360
MIN RADIUS	.047	.221	.093
MEAN RADIUS	.724	.648	.560
MAX RADIUS	1.576	1.265	1.132
HORIZONTAL SPREAD	2.314	1.849	1.849
VERTICAL SPREAD	1.945	1.749	1.749
EXTREME SPREAD	2.807	2.326	2.823
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =		9	

29 May 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C8B35092

CENTERFIRE PATTERNS

3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 1.872

VS= 1.718

GS= 2.069

CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.985	.886	.778
MINIMUM X	:	-.887	-.912	-1.020
MAXIMUM Y	:	.965	.894	.791
MINIMUM Y	:	-.753	-.824	-.758
CENTROID X	:	-.225	-.126	-.018
CENTROID Y	:	.055	.126	.229
POA TO CENTROID in.	:	.232	.179	.230
MIN RADIUS	:	.196	.231	.086
MEAN RADIUS	:	.801	.754	.674
MAX RADIUS	:	1.092	1.196	1.113
HORIZONTAL SPREAD	:	1.872	1.798	1.798
VERTICAL SPREAD	:	1.718	1.718	1.549
EXTREME SPREAD	:	2.069	2.069	2.022
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

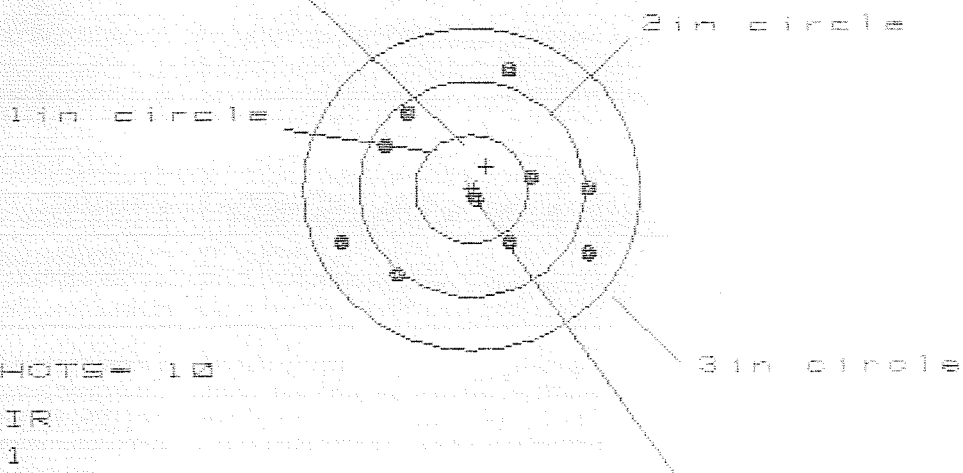
29 May 1991

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CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.203

VS= 1.917

GS= 2.249

PATTERN # : 4

SHOTS (BEST OF) : 10

MAXIMUM X : 1.061

MINIMUM X : -1.142

MAXIMUM Y : 1.086

MINIMUM Y : -.831

CENTROID X : -.133

CENTROID Y : -.211

POA TO CENTROID in: .250

MIN RADIUS : .092

MEAN RADIUS : .874

MAX RADIUS : 1.225

HORIZONTAL SPREAD : 2.203

VERTICAL SPREAD : 1.917

EXTREME SPREAD : 2.249

NUMBER IN ONE INCH CIRCLE = 1

NUMBER IN TWO INCH CIRCLE = 5

NUMBER IN THREE INCH CIRCLE = 10

9

.934

-.908

1.037

-.880

-.006

-.162

.162

.198

.827

1.212

1.842

1.917

2.176

1

5

10

8

1.043

-.799

.963

-.954

-.115

-.088

.145

.216

.803

1.198

1.842

1.917

2.176

1

5

10

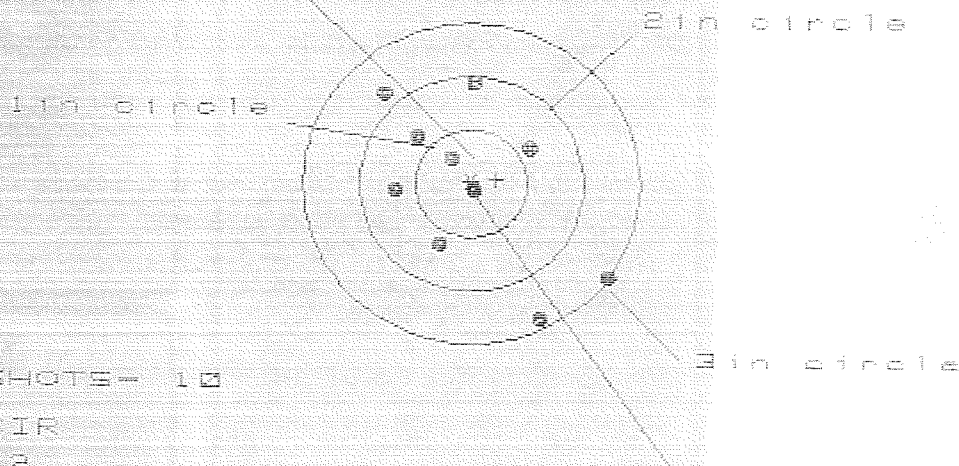
29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8636092

CENTERFIRE PATTERNS

5

POA



OF SHOTS= 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 2.005

VS= 2.221

CS= 2.638

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.261	.787	.753
MINIMUM X	:	-.744	-.604	-.506
MAXIMUM Y	:	.956	.858	.688
MINIMUM Y	:	-1.265	-1.363	-.823
CENTROID X	:	-.220	-.360	-.458
CENTROID Y	:	-.040	.058	.228
POA TO CENTROID in.	:	.223	.364	.512
MIN RADIUS	:	.089	.135	.068
MEAN RADIUS	:	.804	.692	.557
MAX RADIUS	:	1.539	1.573	.825
HORIZONTAL SPREAD	:	2.005	1.391	1.259
VERTICAL SPREAD	:	2.221	2.221	1.511
EXTREME SPREAD	:	2.638	2.516	1.535
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	



MODEL 700™ **H24**

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



REG. U.S. PAT. & T.M. OFF.

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

SERIAL NO. C6636092	ORDER NO. 5716
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UPC



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