

06649240

MODEL 760™ M24

Model **SMS**™

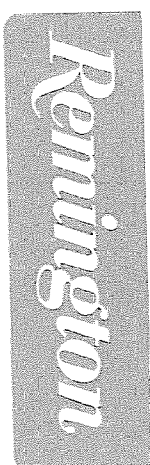
Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.






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

MODEL 700TM M24

SERIAL NO.

C6649240

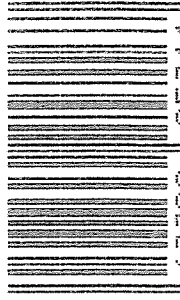
ORDER NO.

5716

20

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

UPC



0 47700 25716 7



5716 C6649240

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649240

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 2	9 1	RW
600	Proof	7 2	9 1	RW
607	Check Headspace	7 2	9 1	RW
610	Dis-assemble Gun	7 2	9 1	RW
612	Magnaflux Barrel Action		JUL 22 1991	GS
	Magnaflux Bolt		JUL 22 1991	GS
615	Rollmark Caliber		JUL 22 1991	GS
617	Drill and Tap Sight Holes		JUL 22 1991	FB
618	Polish Barrel		7/28/91	WB
620	Apply Coatings (Barrel Action)		8-2-91	FB
	Apply Coating (Bolt)		8-2-91	FB
625	Final Assembly A) Clean inside of Bolt Assembly		8/9/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/9/91	RW
	C) Inspect Ejector Hole for Chamfer		8/9/91	RW
	D) Oil Firing Pin Ass'y		8/9/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/21/91	JU

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			8/21/91	JM
	G) Safety Off Force	3	3	3			8/21/91	JM
	H) Trigger Pull Test & Retainability						8/21/91	JM
	I) Firing Pin Indent	.0205	.0205	.0205			8/21/91	JM
	J) Assemble Stock						8/21/91	RW
	K) Assemble Swivel Studs						8/22/91	JM
	L) Attach Front and Rear Sight Assemblies						8/21/91	RW
	M) Iron Sight Alignment						8/21/91	RW
	N) Detach Front & Rear Sights & place in numbered container						8/21/91	RW
	O) Attach Scope to Rifle						8/21/91	RW
	P) Detach & Attach Scope 20 Times						8/21/91	RW
640	Gallery Target & Test						8-22-91	DH
	A) Time						8-22-91	DH
	B) Malfunctions						8-22-91	DH
	C) Pierced Primers						8-22-91	DH
	D) Optical Clarity of Scope						8-22-91	DH
645	Inspect for Live Ammo						8-22-91	DH
655	Final Inspection						8-22-91	JM
	A) Headspace						8-22-91	JM
	B) Trigger Pull	2.56	2.59	2.62	2.67	2.69	8-22-91	JM
	C) Function						8-22-91	JM
660	Pack						9-17-91	DH

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C-6649240

DATE 8/21/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.56	2.43	2.56	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.46	2.48	2.59	
PULL #3	2.40	2.49	2.46	2.62	
PULL #4	2.36	2.44	2.48	2.67	
PULL #5	2.59	2.39	2.36	2.69	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.60	3.40		
PULL #2	3.61	3.39		
PULL #3	3.55	3.38		
PULL #4	3.58	3.35		
PULL #5	3.61	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.36		4.41
PULL #2	4.33	4.32		4.37
PULL #3	4.32	4.40		4.34
PULL #4	4.35	4.25		4.34
PULL #5	4.35	4.42		4.37
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649240
22 Aug 1991

CENTROIDAL DISTANCES

0 TO 1	.27184
1 TO 2	.68824
1 TO 3	.712058
1 TO 4	.592122
1 TO 5	.555828

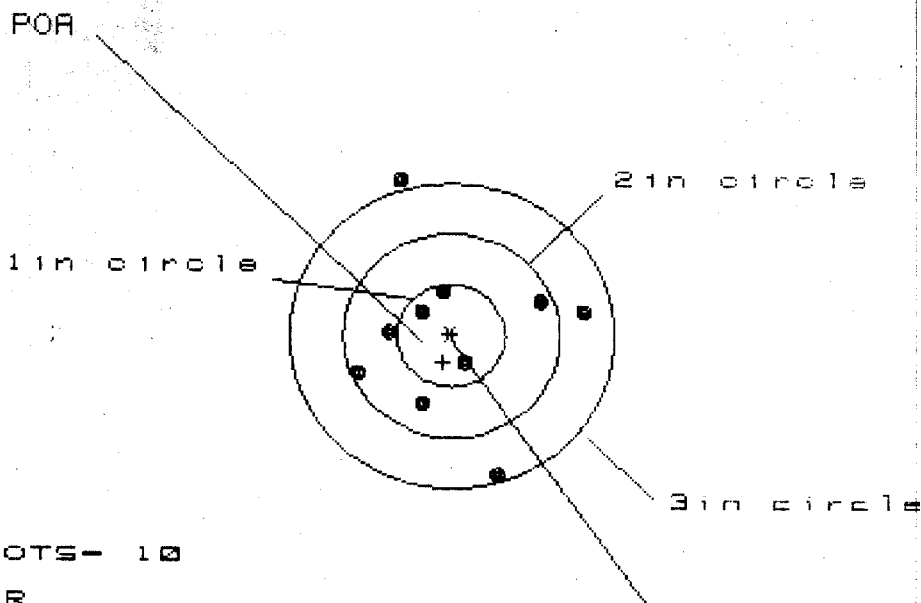
↑
* <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1906
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .257136
THE AMR FOR THIS RIFLE IS: .9242

22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649240

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS= 2.117

VS= 2.886

GS= 3.027

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.228	1.174	1.220
MINIMUM X	:	-.889	-.943	-.897
MAXIMUM Y	:	1.490	.633	.479
MINIMUM Y	:	-1.396	-1.230	-.668
CENTROID X	:	.076	.130	.084
CENTROID Y	:	.261	.095	.249
POA TO CENTROID in.	:	.271	.161	.263
MIN RADIUS	:	.304	.160	.314
MEAN RADIUS	:	.862	.779	.700
MAX RADIUS	:	1.569	1.284	1.249
HORIZONTAL SPREAD	:	2.117	2.117	2.117
VERTICAL SPREAD	:	2.886	1.863	1.147
EXTREME SPREAD	:	3.027	2.212	2.212
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

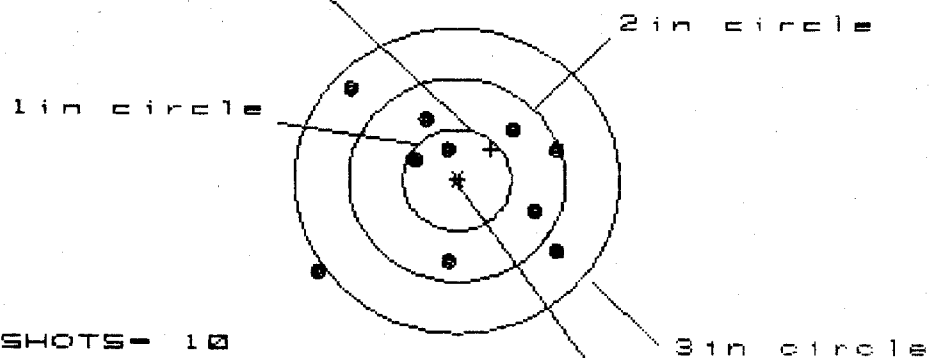
22 Aug 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CS649240

CENTERFIRE PATTERNS

2

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.186

VS= 1.746

GS= 2.474

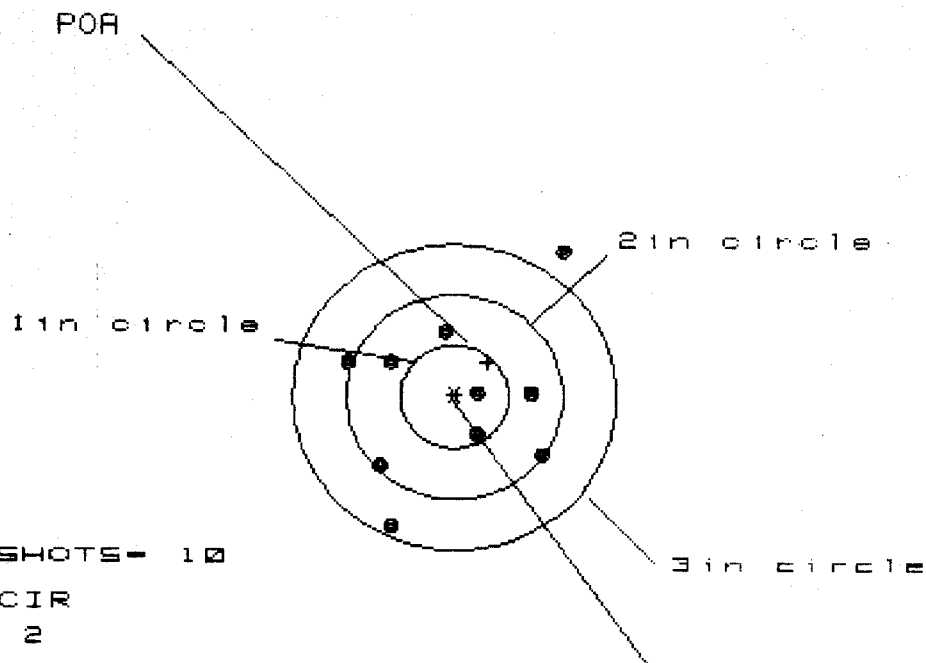
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.951	.814	.672
MINIMUM X	:	-1.235	-1.133	-.644
MAXIMUM Y	:	.883	.787	.568
MINIMUM Y	:	-.863	-.923	-.825
CENTROID X	:	-.317	-.180	-.038
CENTROID Y	:	-.304	-.208	-.306
POA TO CENTROID in.	:	.439	.275	.309
MIN RADIUS	:	.298	.308	.481
MEAN RADIUS	:	.868	.779	.705
MAX RADIUS	:	1.507	1.388	.933
HORIZONTAL SPREAD	:	2.186	1.947	1.316
VERTICAL SPREAD	:	1.746	1.710	1.392
EXTREME SPREAD	:	2.474	2.474	1.760
NUMBER IN ONE INCH CIRCLE *	:		2	
NUMBER IN TWO INCH CIRCLE *	:		7	
NUMBER IN THREE INCH CIRCLE *	:		9	

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CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 7

3in = 9

HS= 1.977

VS= 2.711

GS= 3.149

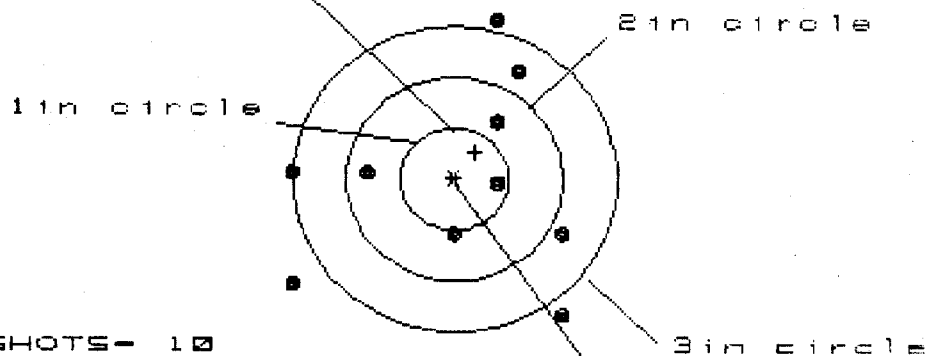
PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.007	.909	.849
MINIMUM X	-.970	-.858	-.918
MAXIMUM Y	1.423	.803	.662
MINIMUM Y	-1.288	-1.130	-.652
CENTROID X	-.309	-.421	-.361
CENTROID Y	-.338	-.496	-.355
POA TO CENTROID in.	.458	.651	.506
MIN RADIUS	.176	.355	.230
MEAN RADIUS	.874	.785	.703
MAX RADIUS	1.743	1.229	.989
HORIZONTAL SPREAD	1.977	1.767	1.767
VERTICAL SPREAD	2.711	1.933	1.314
EXTREME SPREAD	3.149	2.007	1.970
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

22 Aug 1991

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CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.552

VS= 2.967

GS= 3.255

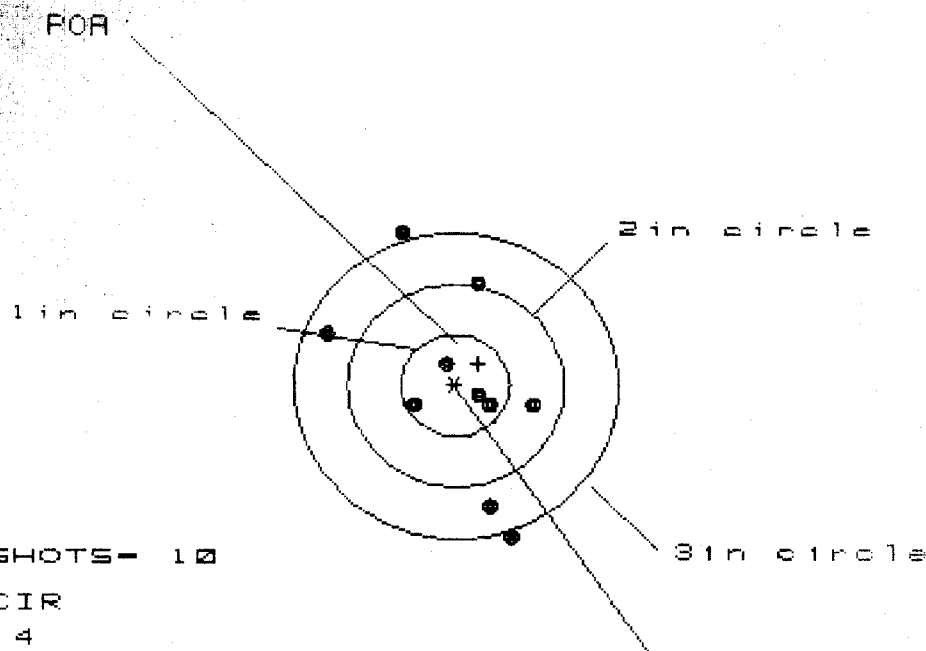
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	.831	.879
MINIMUM X	:	-1.549	-1.637	-1.533
MAXIMUM Y	:	1.604	1.491	1.306
MINIMUM Y	:	-1.363	-1.476	-.855
CENTROID X	:	-.192	-.020	-.124
CENTROID Y	:	-.267	-.154	.031
POA TO CENTROID in.	:	.329	.155	.128
MIN RADIUS	:	.437	.285	.456
MEAN RADIUS	:	1.143	1.037	.959
MAX RADIUS	:	1.851	1.694	1.546
HORIZONTAL SPREAD	:	2.552	2.468	2.412
VERTICAL SPREAD	:	2.967	2.967	2.161
EXTREME SPREAD	:	3.255	3.030	2.498
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

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CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 5

3 in = 8

HS= 1.946

VS= 3.000

GS= 3.161

CENTROID *

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.719	.663	.717
MINIMUM X	:	-1.227	-1.283	-1.229
MAXIMUM Y	:	1.525	1.209	1.045
MINIMUM Y	:	-1.475	-1.305	-1.198
CENTROID X	:	-.211	-.155	-.209
CENTROID Y	:	-.215	-.385	-.222
FOR TO CENTROID in.	:	.301	.415	.305
MIN RADIUS	:	.192	.138	.187
MEAN RADIUS	:	.874	.782	.697
MAX RADIUS	:	1.607	1.433	1.317
HORIZONTAL SPREAD	:	1.946	1.946	1.946
VERTICAL SPREAD	:	3.000	2.514	2.243
EXTREME SPREAD	:	3.161	2.593	2.272
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		