

C6649241

MODEL 760™ M24

Model **SMS**™

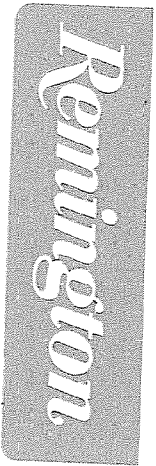
Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.






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

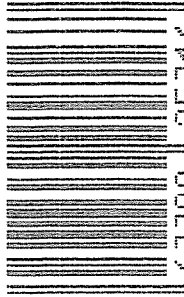
MODEL 700TM M24

SERIAL NO.
C6649241

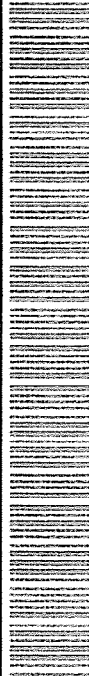
ORDER NO.
5716

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

UPC



0 4700 25716 7



5716 C6649241

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649241

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 25	9 1	RW
600	Proof	6 25	9 1	RW
607	Check Headspace	6 25	9 1	RW
610	Dis-assemble Gun	6 25	9 1	RW
612	Magnaflux Barrel Action		JUL 1 1991	KR
	Magnaflux Bolt		JUL 1 1991	KR
615	Rollmark Caliber		JUL 1 1991	GL
617	Drill and Tap Sight Holes		JUL 1 1991	WB
618	Polish Barrel		JUL 2 1991	WB
620	Apply Coatings (Barrel Action)			
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		8/28/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/28/91	RW
	C) Inspect Ejector Hole for Chamfer		8/28/91	RW
	D) Oil Firing Pin Ass'y		8/28/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		7-6-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6 1/4	6			9-6-91	DH
	G) Safety Off Force	2 1/2	3	3			9-6-91	DH
	H) Trigger Pull Test & Retainability						9-6-91	DH
	I) Firing Pin Indent	.022	.022	.023			9-6-91	DH
	J) Assemble Stock						9/6/91	RW
	K) Assemble Swivel Studs						9-10-91	DH
	L) Attach Front and Rear Sight Assemblies						9/6/91	RW
	M) Iron Sight Alignment						9/6/91	RW
	N) Detach Front & Rear Sights & place in numbered container						9/6/91	RW
	O) Attach Scope to Rifle						9/6/91	RW
	P) Detach & Attach Scope 20 Times						9/6/91	RW
640	Gallery Target & Test						9-9-91	DH
	A) Time						9-9-91	DH
	B) Malfunctions						9-9-91	DH
	C) Pierced Primers						9-9-91	DH
	D) Optical Clarity of Scope						9-9-91	DH
645	Inspect for Live Ammo						9-9-91	DH
655	Final Inspection						9-10-91	DH
	A) Headspace						9-9-91	DH
	B) Trigger Pull	2.43	2.41	2.32	2.26	2.15	9-9-91	DH
	C) Function						9-10-91	DH
660	Pack						9-12-91	DH

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649241DATE 9-6-91TESTER DLH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.18	2.55	2.43	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.18	2.56	2.41	
PULL #3	2.40	2.23	2.52	2.32	
PULL #4	2.58	2.21	2.54	2.26	
PULL #5	2.49	2.28	2.48	2.15	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.54	3.39		
PULL #2	3.40	3.27		
PULL #3	3.48	3.43		
PULL #4	3.47	3.42		
PULL #5	3.44	3.37		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.28	4.30		4.15
PULL #2	4.34	4.29		4.23
PULL #3	4.11	4.37		4.20
PULL #4	4.29	4.00		4.09
PULL #5	4.26	4.30		4.18
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649241
9 Sep 1991

CENTROIDAL DISTANCES

0 TO	1	.221382
1 TO	2	.549084
1 TO	3	.161617
1 TO	4	.524619
1 TO	5	.597452

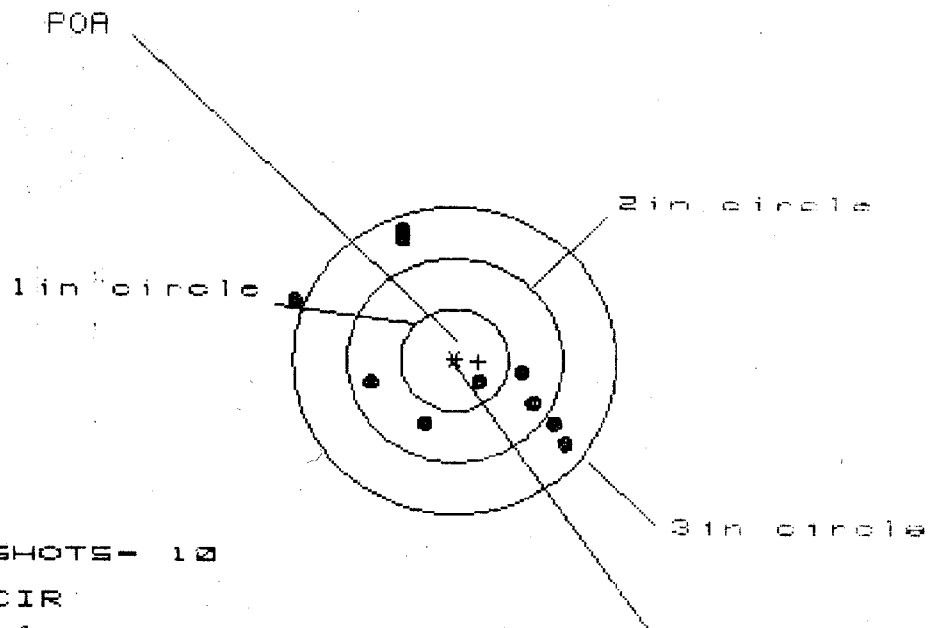
$\frac{y^4}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .08
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .148071
THE POI FOR THIS RIFLE IS: 1.046

9 Sep 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8645241

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.509

VS= 2.043

GS= 2.834

CENTROID *

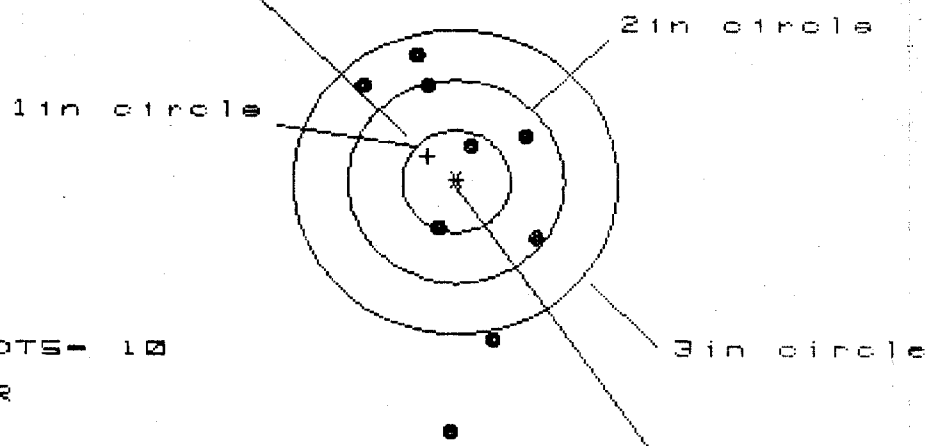
PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.015	.849	.767
MINIMUM X	:	-1.494	-.938	-1.020
MAXIMUM Y	:	1.267	1.327	1.458
MINIMUM Y	:	-.776	-.716	-.550
CENTROID X	:	-.221	-.055	.027
CENTROID Y	:	.013	-.047	-.213
POA TO CENTROID in.	:	.221	.072	.214
MIN RADIUS	:	.314	.199	.078
MEAN RADIUS	:	.997	.890	.758
MAX RADIUS	:	1.590	1.477	1.624
HORIZONTAL SPREAD	:	2.509	1.787	1.787
VERTICAL SPREAD	:	2.043	2.043	2.008
EXTREME SPREAD	:	2.834	2.533	2.496
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.578

VS= 3.692

GS= 3.701

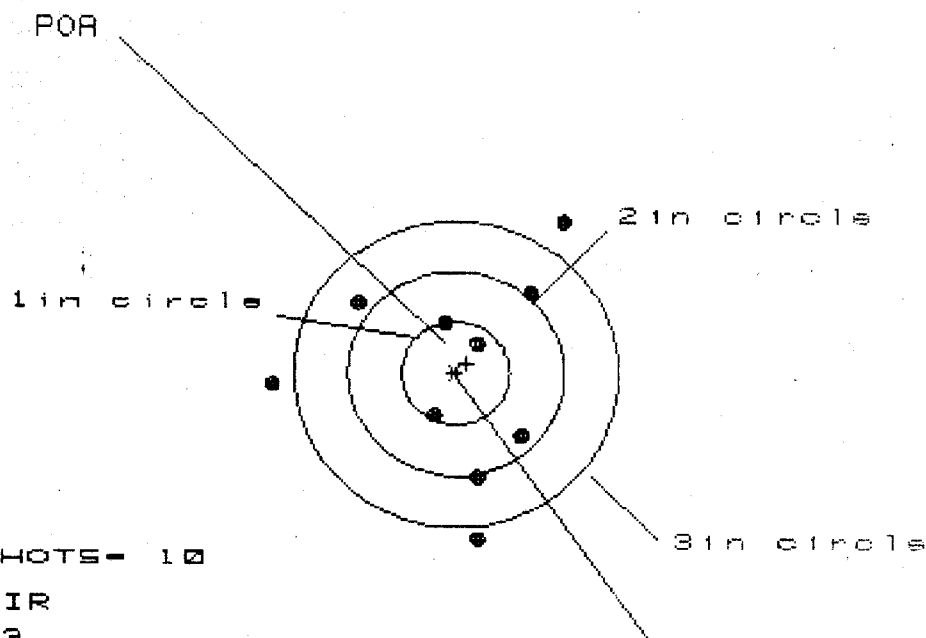
CENTROID +

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.738	.730	.777
MINIMUM X	-.840	-.848	-.801
MAXIMUM Y	1.268	.999	.774
MINIMUM Y	-2.424	-1.803	-1.058
CENTROID X	.261	.269	.222
CENTROID Y	-.250	.019	.244
POA TO CENTROID in.	.361	.269	.330
MIN RADIUS	.399	.151	.182
MEAN RADIUS	1.107	.890	.723
MAX RADIUS	2.425	1.842	1.313
HORIZONTAL SPREAD	1.578	1.578	1.578
VERTICAL SPREAD	3.692	2.802	1.832
EXTREME SPREAD	3.701	2.892	2.207
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

9 Sep 1991

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1in = 3

2in = 5

3in = 7

HS= 2.586

VS= 3.193

GS= 3.298

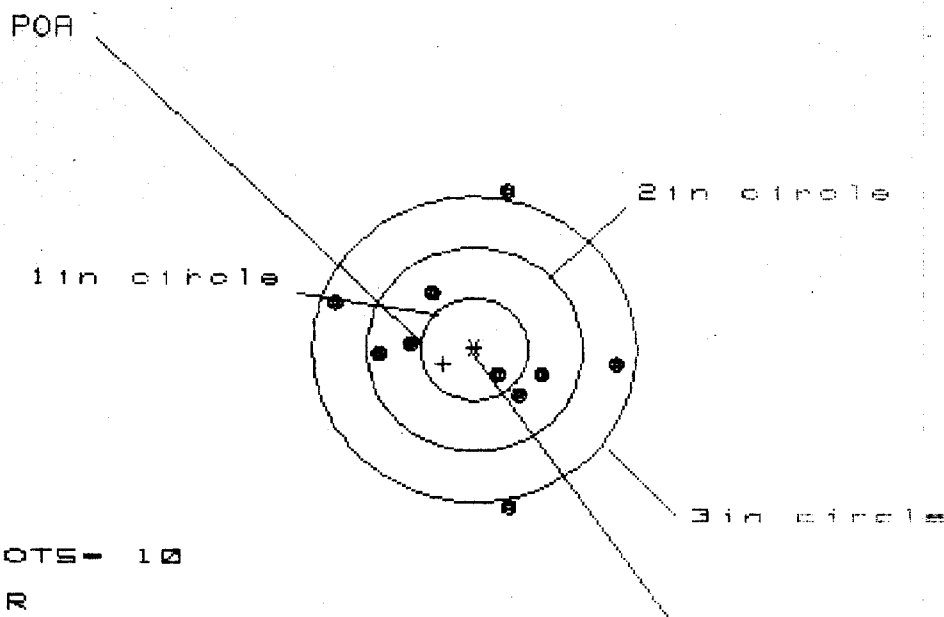
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.008	.800	.605
MINIMUM X	:	-1.678	-1.566	-1.019
MAXIMUM Y	:	1.538	.954	.964
MINIMUM Y	:	-1.655	-1.485	-1.475
CENTROID X	:	-.099	-.211	-.016
CENTROID Y	:	-.093	-.263	-.273
POA TO CENTROID in.	:	.136	.338	.273
MIN RADIUS	:	.373	.286	.387
MEAN RADIUS	:	1.053	.964	.869
MAX RADIUS	:	1.839	1.567	1.478
HORIZONTAL SPREAD	:	2.686	2.366	1.624
VERTICAL SPREAD	:	3.193	2.439	2.439
EXTREME SPREAD	:	3.298	2.562	2.562
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

9 Sep 1991

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CENTERFIRE PATTERNS # 4



OF SHOTS - 10

IN CIR

1in = 1

2in = 6

3in = 8

HS = 2.636

VS = 3.110

GS = 3.110

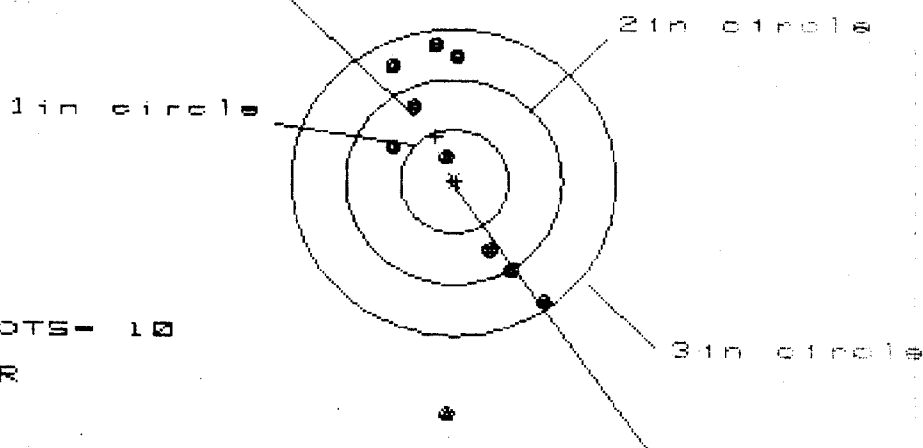
PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.308	1.347	1.397
MINIMUM X	:	-1.328	-1.289	-1.239
MAXIMUM Y	:	1.560	.767	.595
MINIMUM Y	:	-1.550	-1.376	-.469
CENTROID X	:	.287	.248	.198
CENTROID Y	:	.144	-.030	.142
POA TO CENTROID in.	:	.321	.250	.244
MIN RADIUS	:	.290	.213	.347
MEAN RADIUS	:	.966	.879	.807
MAX RADIUS	:	1.599	1.433	1.400
HORIZONTAL SPREAD	:	2.636	2.636	2.636
VERTICAL SPREAD	:	3.110	2.143	1.064
EXTREME SPREAD	:	3.110	2.688	2.688
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	8		

2 Sep 1981

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CENTERFIRE PATTERNS # 5

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 9

HS = 1.362

VS = 3.637

GS = 3.638

CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.791	.786	.621
MINIMUM X	:	-.571	-.576	-.478
MAXIMUM Y	:	1.363	1.110	.933
MINIMUM Y	:	-2.274	-1.419	-1.339
CENTROID X	:	.172	.177	.079
CENTROID Y	:	-.437	-.184	-.007
POA TO CENTROID in.	:	.469	.256	.079
MIN RADIUS	:	.226	.040	.216
MEAN RADIUS	:	1.105	.917	.796
MAX RADIUS	:	2.275	1.622	1.476
HORIZONTAL SPREAD	:	1.362	1.362	1.099
VERTICAL SPREAD	:	3.637	2.529	2.272
EXTREME SPREAD	:	3.638	2.691	2.365
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	