

C6611536

MODEL 760™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400078453

Remington		 REG. U.S. PAT. & TM. OFF.	VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
MODEL 700 TM M24		SERIAL NO. C6611536	ORDER NO. 5716
MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.			


5716 C6611536

UPC


0 47700 25716 7

INTERCHANGEABILITY

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6611536

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	QUALITY AUDIT	2 1 91	RW
600	Proof		2 1 91	RW
607	Check Headspace		2 1 91	RW
610	Dis-assemble Gun		2 1 91	RW
612	Magnaflux Barrel Action		2 1 1 91	Ked
	Magnaflux Bolt		2 1 1 91	Ked
615	Rollmark Caliber		2 1 1 91	GB
617	Drill and Tap Sight Holes		2 1 3 91	LB
618	Polish Barrel RBB		2 1 3 91	WB
620	Apply Coatings (Barrel Action)		2 1 2 91	
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		3/25/91	WB
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/25/91	WB
	C) Inspect Ejector Hole for Chamfer		3/25/91	WB
	D) Oil Firing Pin Ass'y		3/25/91	WB
	E) Adjust Trigger Pull to Min Setting and Stake		4/3/91	

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	4	4			4-3-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			4-3-91	DH
	H) Trigger Pull Test & Retainability						4/3/91	JH
	I) Firing Pin Indent	.020	.021	.020			4-3-91	DH
	J) Assemble Stock						4/4/91	RW
	K) Assemble Swivel Studs						4-8-91	DH
	L) Attach Front and Rear Sight Assemblies						4/4/91	RW
	M) Iron Sight Alignment						4/4/91	RW
	N) Detach Front & Rear Sights & place in numbered container						4/4/91	RW
	O) Attach Scope to Rifle						4/4/91	RW
	P) Detach & Attach Scope 20 Times						4/4/91	RW
640	Gallery Target & Test						4-5-91	AC
	A) Time						4-5-91	AC
	B) Malfunctions						4-5-91	AC
	C) Pierced Primers						4-5-91	AC
	D) Optical Clarity of Scope						4-5-91	AC
645	Inspect for Live Ammo						4-5-91	AC
655	Final Inspection							
	A) Headspace						4-8-91	DH
	B) Trigger Pull	2.18	2.15	2.14	2.25	2.20	4/8/91	JH
	C) Function						4-8-91	DH
660	Pack						6-19-91	NF

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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

SERIAL NO. C-6611536

DATE 4/3/81

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.27	2.27	2.18	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.28	2.31	2.27	2.15	
PULL #3	2.29	2.30	2.33	2.14	
PULL #4	2.28	2.29	2.26	2.25	
PULL #5	2.30	2.28	2.30	2.20	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.50	3.40		
PULL #2	3.48	3.46		
PULL #3	3.43	3.48		
PULL #4	3.48	3.40		
PULL #5	3.47	3.42		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.24		4.15
PULL #2	4.22	4.20		4.23
PULL #3	4.28	4.22		4.18
PULL #4	4.21	4.25		4.27
PULL #5	4.27	4.21		4.22
TOTAL				
AVG.				

INTERCHANGEABILITY

INTERPOLAL DISTANCE CALCULATIONS

FOR RIFLE # 06611536

20 May 1991

CENTROIDAL DISTANCES

0 TO	1	.408571
1 TO	2	.446919
1 TO	3	.744312
1 TO	4	.526186
1 TO	5	.429616

1
2
3 <----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.259

THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.134

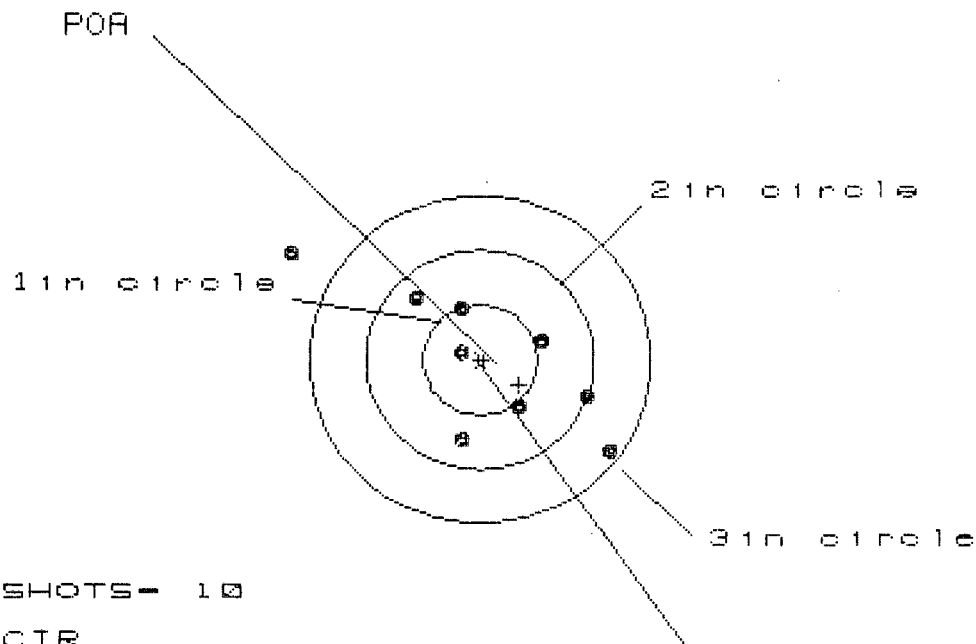
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .291611

THE AMR FOR THIS RIFLE IS: .9058

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11536.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 9

HS= 2.778

VS= 1.832

GS= 3.328

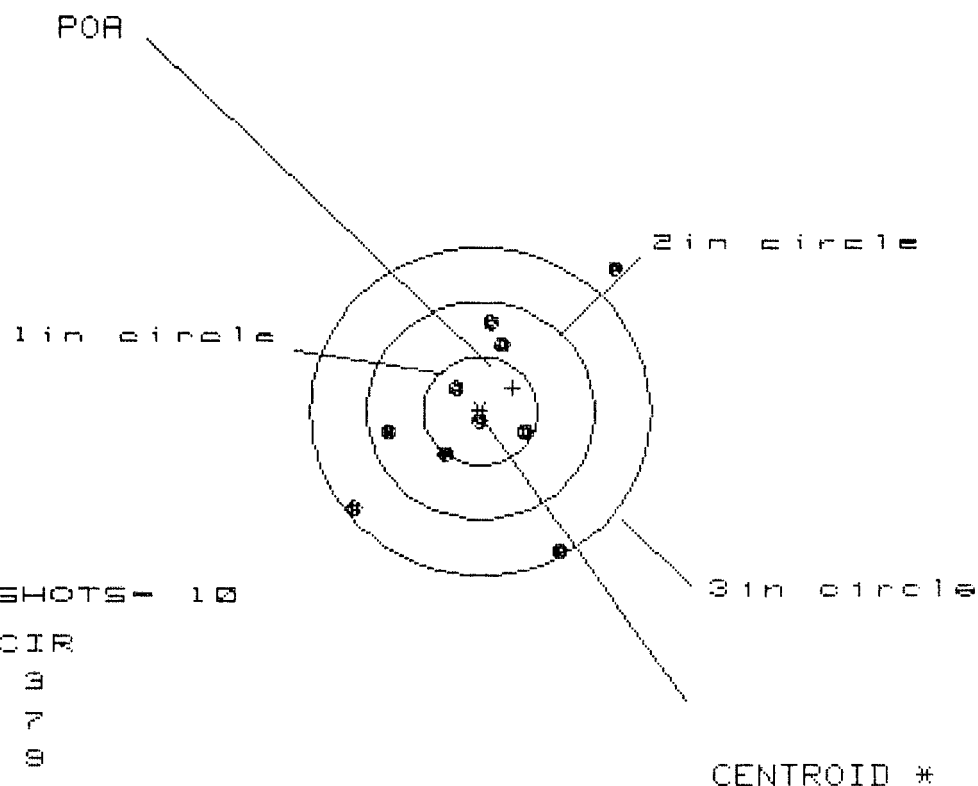
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.157	.977	.837
MINIMUM X	-1.621	-.756	-.633
MAXIMUM Y	.956	.715	.618
MINIMUM Y	-.876	-.769	-.682
CENTROID X	-.337	-.157	-.280
CENTROID Y	.231	.124	.221
POA TO CENTROID in.	.409	.201	.356
MIN RADIUS	.164	.317	.222
MEAN RADIUS	.774	.656	.557
MAX RADIUS	1.882	1.244	.894
HORIZONTAL SPREAD	2.778	1.733	1.470
VERTICAL SPREAD	1.832	1.484	1.301
EXTREME SPREAD	3.328	2.282	1.741
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	9		

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611536.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.271

VS= 2.669

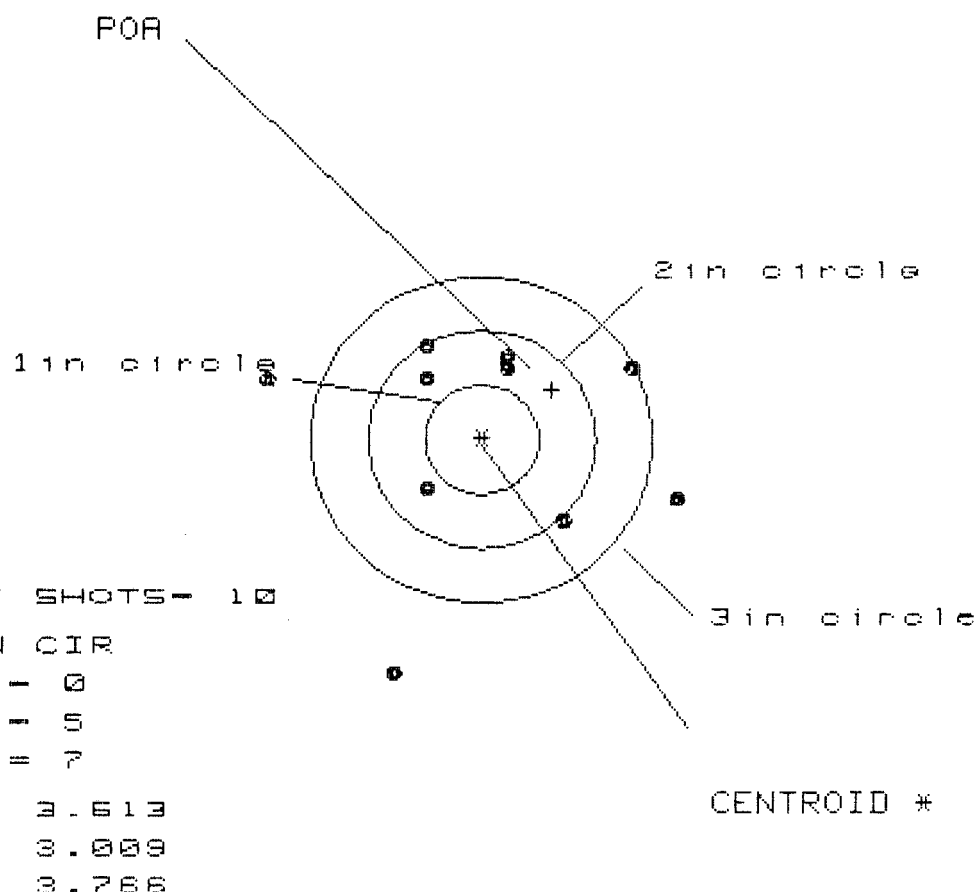
GS= 3.153

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.150	.810	.592
MINIMUM X	:	-1.121	-.993	-.892
MAXIMUM Y	:	1.347	.979	.833
MINIMUM Y	:	-1.321	-1.172	-.836
CENTROID X	:	-.286	-.414	-.515
CENTROID Y	:	-.213	-.363	-.217
POA TO CENTROID in.	:	.357	.551	.559
MIN RADIUS	:	.060	.157	.236
MEAN RADIUS	:	.833	.727	.629
MAX RADIUS	:	1.772	1.424	1.223
HORIZONTAL SPREAD	:	2.271	1.803	1.484
VERTICAL SPREAD	:	2.669	2.151	1.669
EXTREME SPREAD	:	3.153	2.235	2.053
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11536.1

CENTERFIRE PATTERNS # 3



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.687	1.595	1.343
MINIMUM X	:	-1.926	-2.018	-.835
MAXIMUM Y	:	.865	.626	.663
MINIMUM Y	:	-2.144	-1.014	-.977
CENTROID X	:	-.621	-.529	-.277
CENTROID Y	:	-.457	-.218	-.255
POA TO CENTROID in.	:	.770	.572	.376
MIN RADIUS	:	.675	.426	.457
MEAN RADIUS	:	1.233	1.059	.946
MAX RADIUS	:	2.297	2.039	1.530
HORIZONTAL SPREAD	:	3.613	3.613	2.178
VERTICAL SPREAD	:	3.009	1.640	1.640
EXTREME SPREAD	:	3.766	3.766	2.552
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11536.1

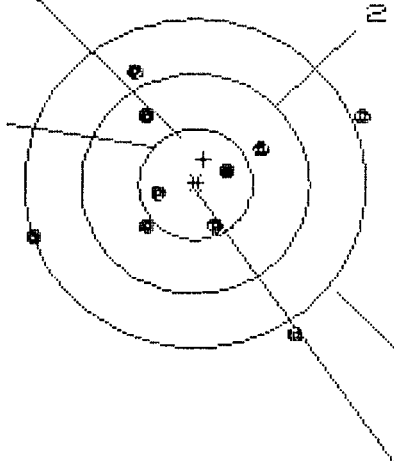
CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 6

3 in = 8

HS = 2.855

VS = 2.343

GS = 3.060

CENTROID #

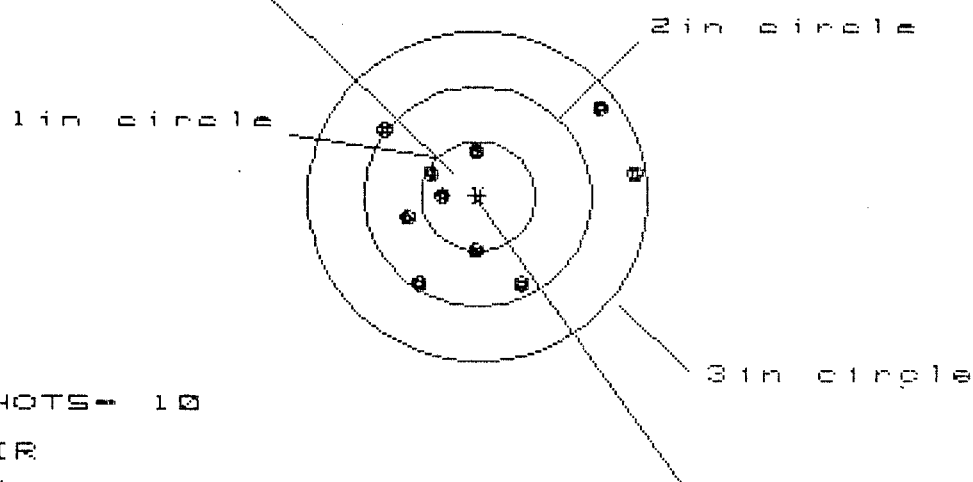
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.456	1.548	.839
MINIMUM X	:	-1.399	-1.307	-1.114
MAXIMUM Y	:	.982	.831	.885
MINIMUM Y	:	-1.361	-.672	-.618
CENTROID X	:	-.071	-.163	-.356
CENTROID Y	:	-.223	-.072	-.126
POA TO CENTROID in.	:	.235	.178	.378
MIN RADIUS	:	.295	.344	.215
MEAN RADIUS	:	.884	.802	.690
MAX RADIUS	:	1.589	1.606	1.274
HORIZONTAL SPREAD	:	2.855	2.855	1.953
VERTICAL SPREAD	:	2.343	1.503	1.503
EXTREME SPREAD	:	3.060	3.060	2.130
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

23 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611536.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.263

VS= 1.635

GS= 2.287

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.396	1.238	.699
MINIMUM X	:	-.867	-.712	-.557
MAXIMUM Y	:	.812	.838	.690
MINIMUM Y	:	-.823	-.797	-.692
CENTROID X	:	.020	-.135	-.290
CENTROID Y	:	-.008	-.034	-.139
POA TO CENTROID in.	:	.021	.140	.322
MIN RADIUS	:	.328	.174	.129
MEAN RADIUS	:	.805	.692	.559
MAX RADIUS	:	1.416	1.495	.984
HORIZONTAL SPREAD	:	2.263	1.950	1.256
VERTICAL SPREAD	:	1.635	1.635	1.382
EXTREME SPREAD	:	2.287	2.252	1.867
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611536
5 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0722011
1 TO	2	.152948
1 TO	3	.0859593
1 TO	4	.168048
1 TO	5	.434041

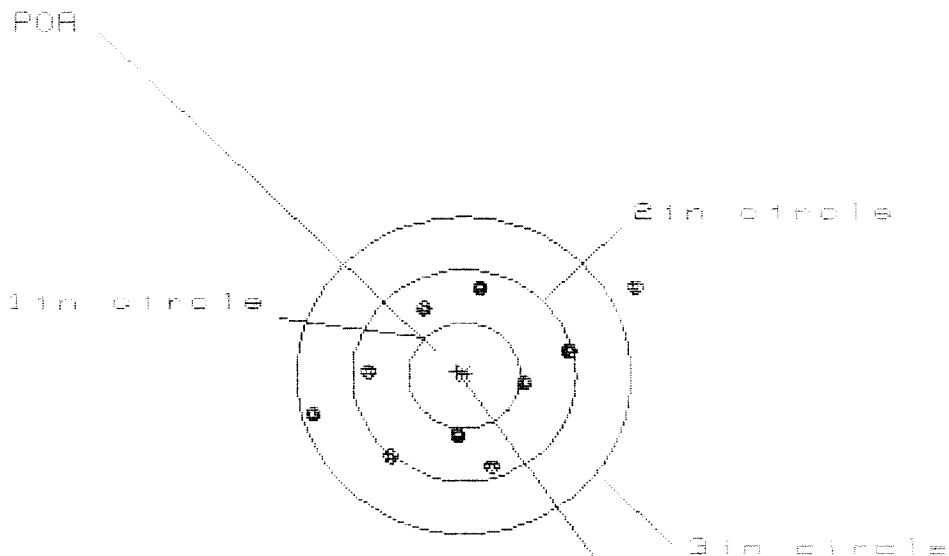
#45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1604
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179873
THE AMP FOR THIS RIFLE IS: .9692

5 Apr 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06B11536

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 0

3in = 9

HS= 2.914

VS= 1.667

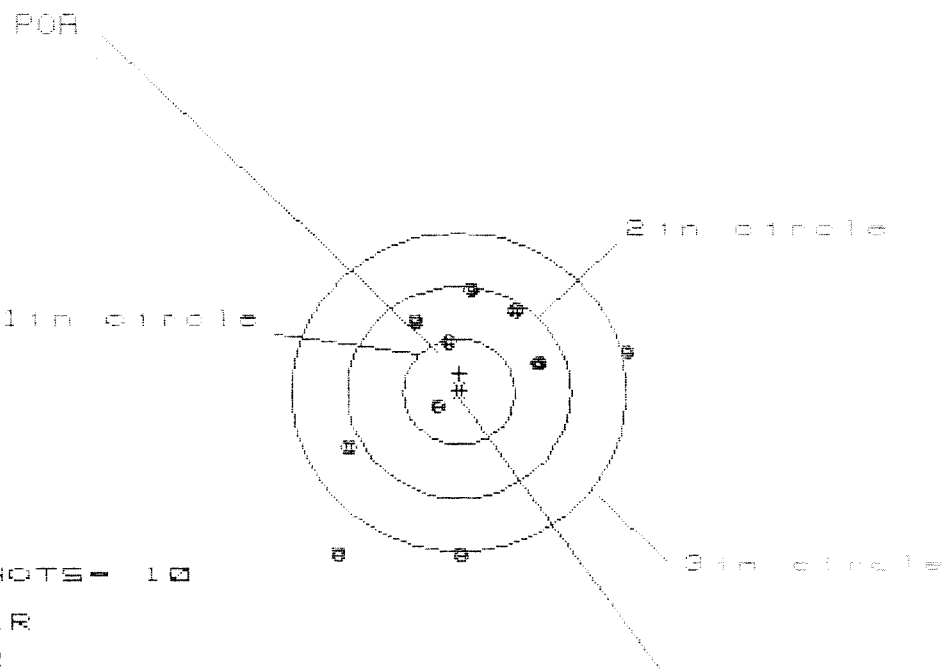
GS= 3.163

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.530	1.095	.944
MINIMUM X	-1.384	-1.214	-.848
MAXIMUM Y	.831	.914	.876
MINIMUM Y	-.836	-.743	-.781
CENTROID X	.062	-.108	.043
CENTROID Y	-.037	-.130	-.091
POA TO CENTROID in.	.072	.169	.101
MIN RADIUS	.535	.459	.500
MEAN RADIUS	.952	.850	.789
MAX RADIUS	1.742	1.252	.979
HORIZONTAL SPREAD	2.914	2.309	1.792
VERTICAL SPREAD	1.667	1.657	1.657
EXTREME SPREAD	3.163	2.387	1.846
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	0		
NUMBER IN THREE INCH CIRCLE =	9		

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/03611536

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.611

VS= 2.528

GS= 3.250

CENTROID *

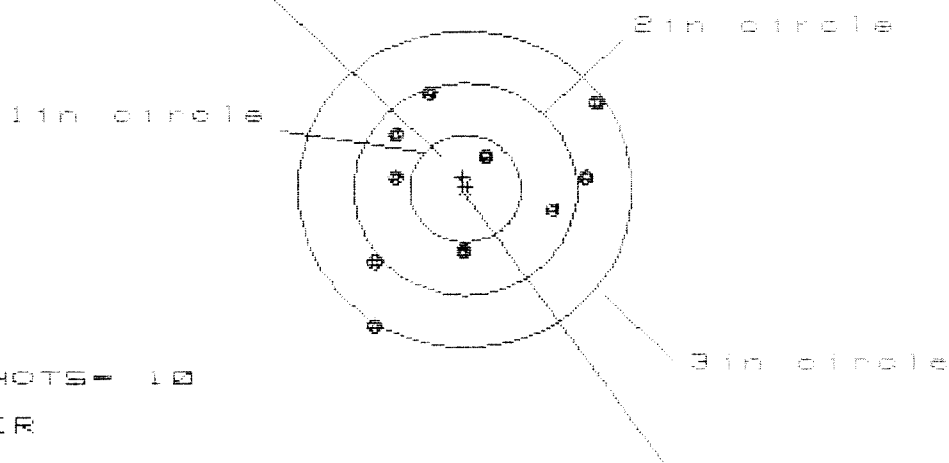
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.531	1.411	.759
MINIMUM X	-1.080	-1.152	-.975
MAXIMUM Y	1.008	.839	.869
MINIMUM Y	-1.520	-1.666	-1.635
CENTROID X	-.006	.114	-.063
CENTROID Y	-.174	-.005	-.035
POA TO CENTROID in.	.174	.114	.072
MIN RADIUS	.255	.363	.295
MEAN RADIUS	1.041	.912	.835
MAX RADIUS	1.865	1.670	1.637
HORIZONTAL SPREAD	2.611	2.563	1.734
VERTICAL SPREAD	2.528	2.505	2.505
EXTREME SPREAD	3.250	2.746	2.507
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611536

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 1.982

VS= 2.260

GS= 2.884

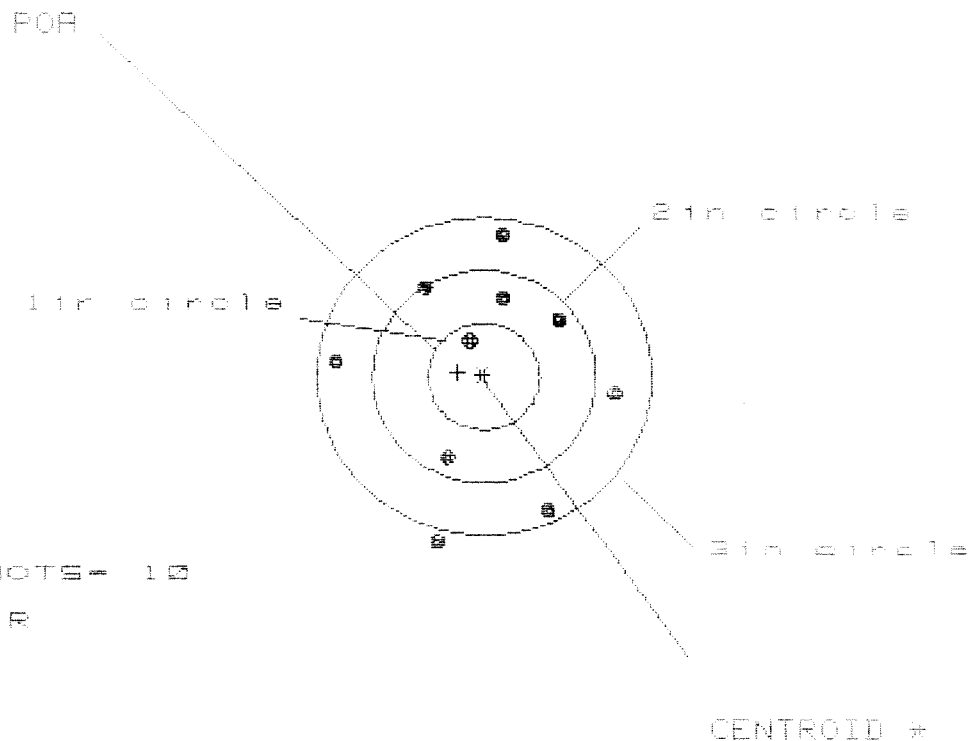
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.192	1.104	1.146
MINIMUM X	:	-1.790	-1.871	-1.733
MAXIMUM Y	:	.957	.812	.893
MINIMUM Y	:	-1.303	-1.798	-1.717
CENTROID X	:	.020	.108	-.030
CENTROID Y	:	-.112	.033	-.048
POA TO CENTROID in.	:	.114	.113	.057
MIN RADIUS	:	.379	.212	.348
MEAN RADIUS	:	.935	.853	.792
MAX RADIUS	:	1.524	1.280	1.146
HORIZONTAL SPREAD	:	1.982	1.975	1.879
VERTICAL SPREAD	:	2.260	1.610	1.610
EXTREME SPREAD	:	2.884	2.447	2.019
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611536

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.495

VS = 2.912

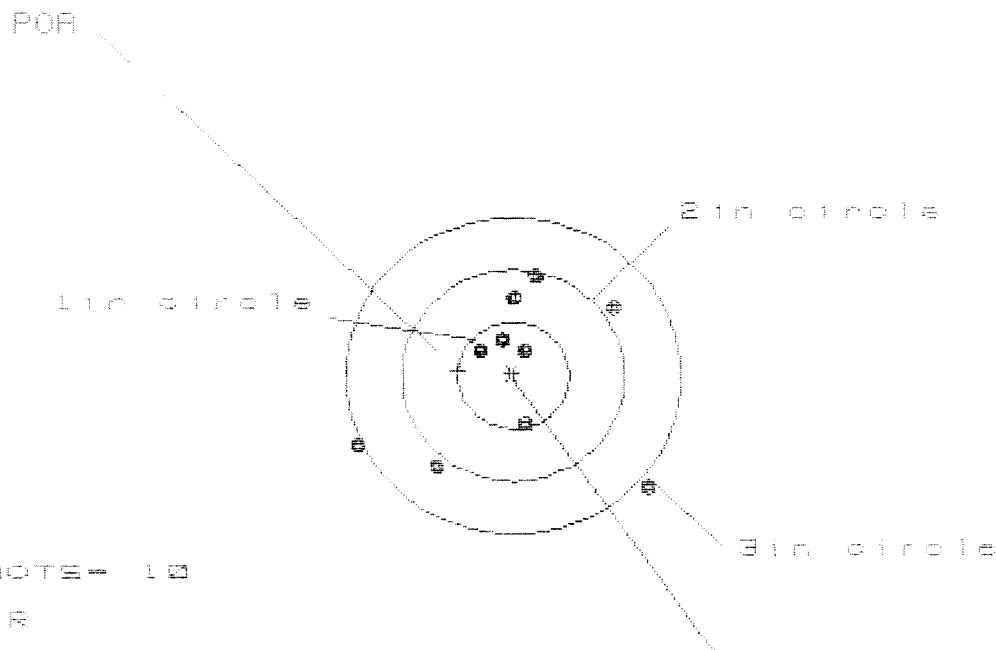
GS = 2.987

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.197	1.145	1.215
MINIMUM X	:	-1.298	-1.350	-1.280
MAXIMUM Y	:	1.306	1.127	.943
MINIMUM Y	:	-1.506	-1.477	-1.097
CENTROID X	:	.238	.282	.212
CENTROID Y	:	-.041	.138	.022
POA TO CENTROID in.	:	.234	.314	.386
MIN RADIUS	:	.343	.235	.133
MEAN RADIUS	:	1.064	.956	.830
MAX RADIUS	:	1.672	1.577	1.333
HORIZONTAL SPREAD	:	2.495	2.495	2.495
VERTICAL SPREAD	:	2.912	2.604	2.040
EXTREME SPREAD	:	2.987	2.635	2.512
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

5 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8B11536

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 6

3 in = 8

HS= 2.521

VS= 1.998

GS= 2.675

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.165	1.077	.924
MINIMUM X	:	-1.355	-1.226	-.723
MAXIMUM Y	:	.897	.774	.671
MINIMUM Y	:	-1.101	-.966	-1.069
CENTROID X	:	.496	.367	.520
CENTROID Y	:	-.043	.080	.189
POA TO CENTROID in.	:	.498	.376	.551
MIN RADIUS	:	.215	.219	.065
MEAN RADIUS	:	.849	.731	.597
MAX RADIUS	:	1.603	1.478	1.290
HORIZONTAL SPREAD	:	2.521	2.303	1.647
VERTICAL SPREAD	:	1.998	1.740	1.740
EXTREME SPREAD	:	2.675	2.675	2.228
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	