

C6611543

MODEL 760™ M24

Model **SMS**™

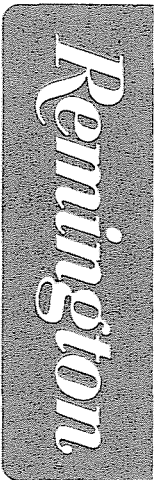
Action

Barrel Length

Capacity

Order No. **5716**

* Includes 1 in chamber.





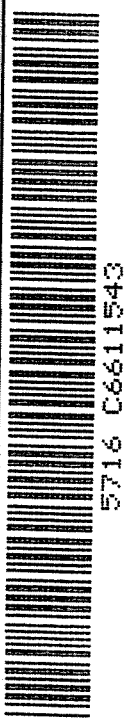

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

MODEL 700™ H24

SERIAL NO. C6611543

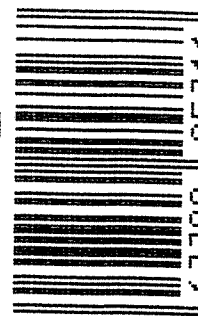
ORDER NO. 5716

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



5716 C6611543

UPC



0 47700 25716 7

GUN SERIAL #

C6611543

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		3/19/91	K.S.
600	Proof		3/19/91	K.S.
607	Check Headspace		3/19/91	K.S.
610	Dis-assemble Gun		3/19/91	K.S.
612	Magnaflux Barrel Action		3/28/91	KR
	Magnaflux Bolt		"	KR
615	Rollmark Caliber		"	LS
617	Drill and Tap Sight Holes	APR	3 1991	FB
618	Polish Barrel	APR	3 1991	WB
620	Apply Coatings (Barrel Action)		4/19/91	JS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/24/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/24/91	KS
	C) Inspect Ejector Hole for Chamfer		4/24/91	KS
	D) Oil Firing Pin Ass'y		4/24/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		4/25/91	JS

Op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			4/25/91	JK
	G) Safety Off Force	2	2	2			4/25/91	JK
	H) Trigger Pull Test & Retainability						4/25/91	JK
	I) Firing Pin Indent	.0225	.0225	.0225			4/25/91	JK
	J) Assemble Stock						4/24/91	KX
	K) Assemble Swivel Studs						5-16-91	D/H
	L) Attach Front and Rear Sight Assemblies						4/26/91	KX
	M) Iron Sight Alignment						4/26/91	KX
	N) Detach Front & Rear Sights & place in numbered container						4/26/91	KX
	O) Attach Scope to Rifle						4/26/91	KX
	P) Detach & Attach Scope 20 Times						4/26/91	KX
640	Gallery Target & Test						4-29-91	D/H
	A) Time						4-29-91	D/H
	B) Malfunctions						4-29-91	D/H
	C) Pierced Primers						4-29-91	D/H
	D) Optical Clarity of Scope						4-29-91	D/H
645	Inspect for Live Ammo						4-29-91	D/H
655	Final Inspection							
	A) Headspace						5-16-91	D/H
	B) Trigger Pull	2.19	2.22	2.26	2.26	2.31	5/10/91	JK
	C) Function						5-16-91	D/H
660	Pack						6-17-91	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-6611343

DATE 4/25/91

TESTER [Signature]

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.33	2.46	2.19	MIN. SETTING
PULL #2	2.33	2.33	2.40	2.22	NO AVG. OF 5
PULL #3	2.23	2.32	2.38	2.26	READINGS ACCEPT-
PULL #4	2.35	2.41	2.48	2.26	ABLE LESS THAN 2#
PULL #5	2.37	2.44	2.44	2.31	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.21		
PULL #2	3.15	3.35		
PULL #3	3.18	3.24		
PULL #4	3.24	3.33		
PULL #5	3.20	3.31		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.58	4.37		4.53
PULL #2	4.38	4.49		4.58
PULL #3	4.20	4.50		4.54
PULL #4	4.43	4.46		4.56
PULL #5	4.45	4.27		4.39
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611543
29 Apr 1991

CENTROIDAL DISTANCES

Ø TO	1	.195133
1 TO	2	.432558
1 TO	3	.127035
1 TO	4	.337617
1 TO	5	.234361

$\frac{2}{15}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0162
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0177279
THE AMR FOR THIS RIFLE IS: .8858

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611543

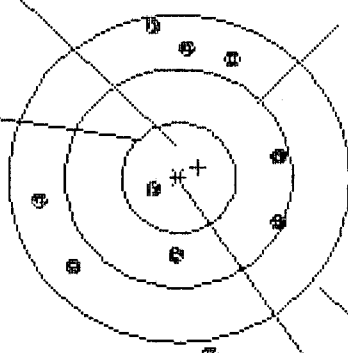
CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle



CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.175

VS= 2.982

GS= 3.022

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.919	.947	.920
MINIMUM X	:	-1.256	-1.228	-1.255
MAXIMUM Y	:	1.396	1.220	1.145
MINIMUM Y	:	-1.586	-1.019	-.866
CENTROID X	:	-.171	-.199	-.172
CENTROID Y	:	-.094	.082	-.071
POA TO CENTROID in.	:	.196	.215	.186
MIN RADIUS	:	.208	.314	.219
MEAN RADIUS	:	1.060	1.003	.950
MAX RADIUS	:	1.605	1.335	1.272
HORIZONTAL SPREAD	:	2.175	2.175	2.175
VERTICAL SPREAD	:	2.982	2.239	2.011
EXTREME SPREAD	:	3.022	2.331	2.328
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611543

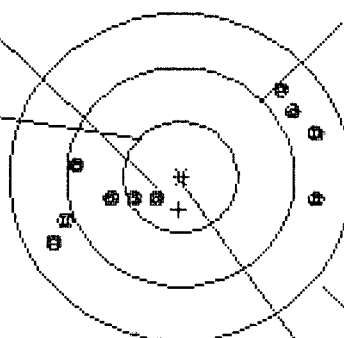
CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle



CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 4

3 in = 10

HS= 2.316

VS= 1.434

GS= 2.535

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.220	1.353	1.233
MINIMUM X	:	-1.096	-.963	-.977
MAXIMUM Y	:	.789	.836	.761
MINIMUM Y	:	-.645	-.598	-.445
CENTROID X	:	.014	-.119	.001
CENTROID Y	:	.297	.250	.325
POA TO CENTROID in.	:	.297	.277	.325
MIN RADIUS	:	.319	.198	.330
MEAN RADIUS	:	.964	.883	.886
MAX RADIUS	:	1.275	1.365	1.259
HORIZONTAL SPREAD	:	2.316	2.316	2.210
VERTICAL SPREAD	:	1.434	1.434	1.206
EXTREME SPREAD	:	2.535	2.461	2.256
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	10		

29 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611543

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 4

2 in = 8

3 in = 10

HS= 2.333

VS= 1.043

GS= 2.334

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.374
MINIMUM X	-.959
MAXIMUM Y	.626
MINIMUM Y	-.417
CENTROID X	-.044
CENTROID Y	-.097
POA TO CENTROID in.	.107
MIN RADIUS	.205
MEAN RADIUS	.669
MAX RADIUS	1.407
HORIZONTAL SPREAD	2.333
VERTICAL SPREAD	1.043
EXTREME SPREAD	2.334
NUMBER IN ONE INCH CIRCLE	4
NUMBER IN TWO INCH CIRCLE	8
NUMBER IN THREE INCH CIRCLE	10

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FILE:/PATTERNING/CENTERFIRE_PATT/C6611543

CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.819

VS= 1.809

GS= 2.353

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.929	.735	.672
MINIMUM X	:	-.890	-.787	-.850
MAXIMUM Y	:	.994	.904	1.013
MINIMUM Y	:	-.815	-.905	-.796
CENTROID X	:	.141	.038	.101
CENTROID Y	:	-.223	-.133	-.242
POA TO CENTROID in.	:	.264	.138	.263
MIN RADIUS	:	.175	.241	.183
MEAN RADIUS	:	.791	.742	.688
MAX RADIUS	:	1.234	1.013	1.015
HORIZONTAL SPREAD	:	1.819	1.522	1.522
VERTICAL SPREAD	:	1.809	1.809	1.809
EXTREME SPREAD	:	2.353	1.864	1.811
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

29 Apr 1991

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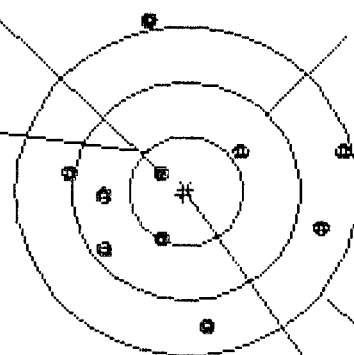
CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle



CENTROID *

OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 9

HS = 2.313

VS = 2.826

GS = 2.883

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.330	1.288	1.322
MINIMUM X	:	-.983	-1.025	-.864
MAXIMUM Y	:	1.554	.568	.637
MINIMUM Y	:	-1.272	-1.099	-1.030
CENTROID X	:	.024	.066	-.095
CENTROID Y	:	.036	-.137	-.206
POA TO CENTROID in.	:	.043	.152	.227
MIN RADIUS	:	.308	.347	.191
MEAN RADIUS	:	.945	.869	.760
MAX RADIUS	:	1.598	1.401	1.328
HORIZONTAL SPREAD	:	2.313	2.313	2.186
VERTICAL SPREAD	:	2.826	1.667	1.667
EXTREME SPREAD	:	2.883	2.326	2.241
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	6		
NUMBER IN THREE INCH CIRCLE	=	9		