ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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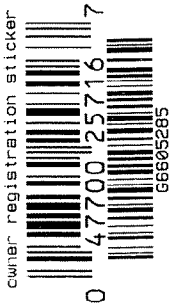
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

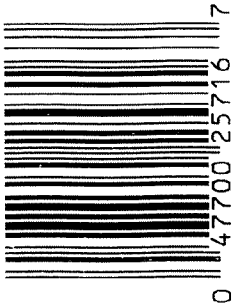
DD FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6605285



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6605285

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-13-06	RTC
420	ASSEMBLE ACTION		10-13-06	RTC
430	ASSEMBLE TO STOCK		10-16-06	WIR
440	PROOF		10-16-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-16-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 17 2006	10-16-06	RTC
480	MAGNAFLUX BBL ACTION	OPERATOR CPD	10-17-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-17-06	CW
510	DRILL AND TAP SIGHT HOLES		10-16-06	SD
520	GOFF BLAST BBL / REC		10-18-06	CB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/26/06	
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11-9-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-29-06	APD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

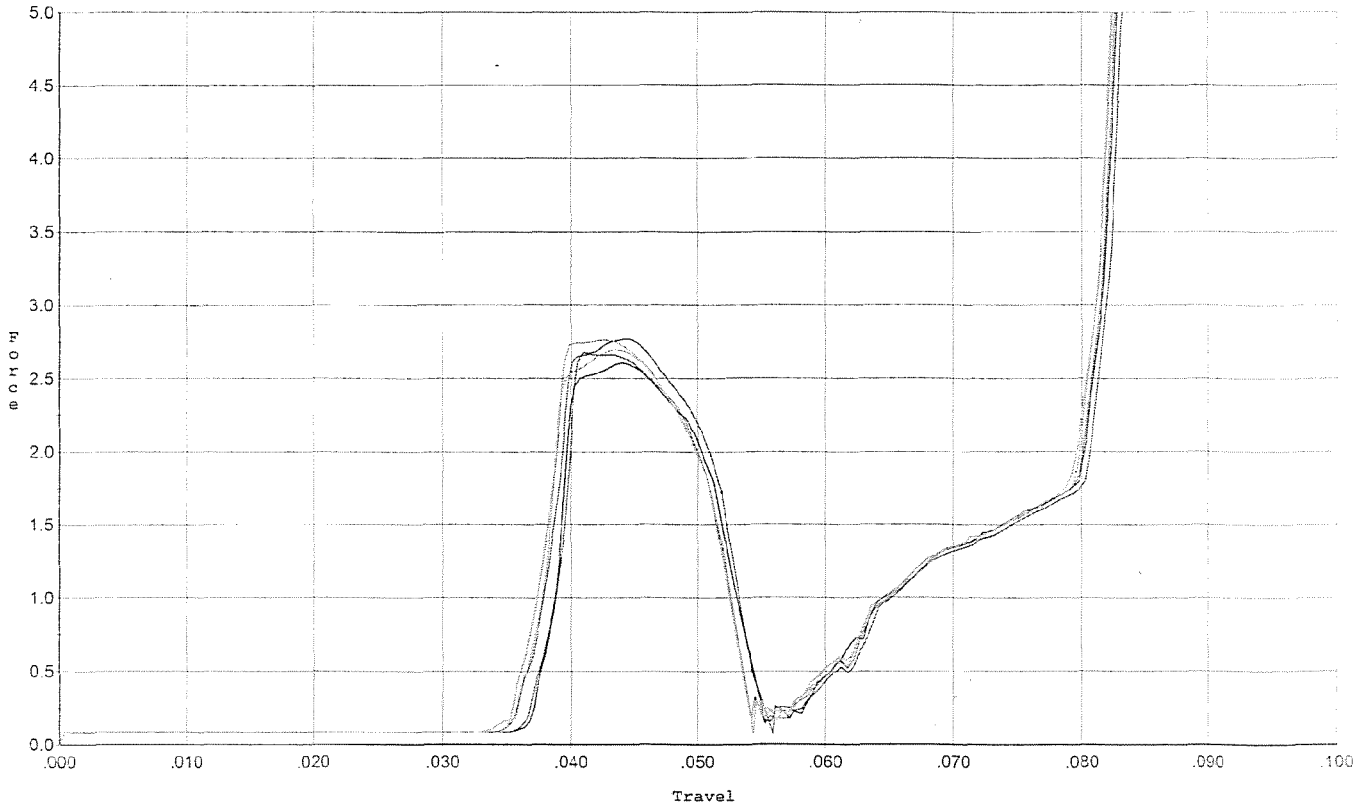
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
	~~BARBER - M24 0132389~~			
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	6.5 6.5 6.0	12-1-06	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 2.5 2.5	12-1-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.026 .026 .026	12-1-06	DA
	J) ASSEMBLE STOCK		11-29-06	LRW
	K) ASSEMBLE SWIVEL STUDS		12-12-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-12-06	BLG
	M) IRON SIGHT ALIGNMENT		12-12-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-12-06	BLG
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	11-30-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-30-06	DK
670	FINAL INSPECTION A) HEADSPACE		12-12-06	BLG
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.43 2.33 2.40 2.32 2.40	12-1-06	DA
	C) FUNCTION		12-12-06	BLG
690	PACK		1-28-07	DA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini.
Note:	R. Putch 11/07/06		

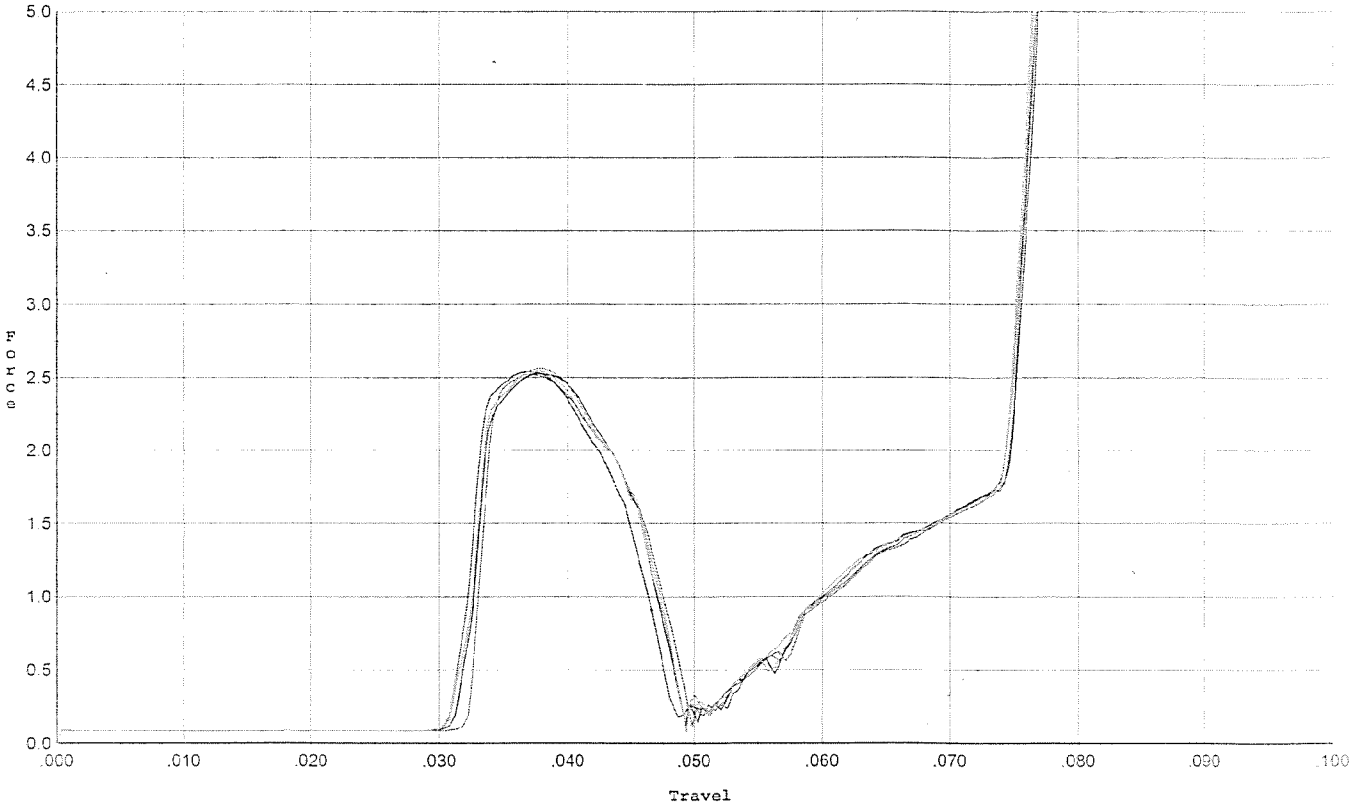


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.769	0.052	0.037	0.038	0.037		Set Trigger
2	2.607	0.051	0.037	0.038	0.034		Set Trigger
3	2.664	0.052	0.036	0.037	0.037		Set Trigger
4	2.695	0.052	0.036	0.037	0.037		Set Trigger
5	2.761	0.052	0.035	0.037	0.038		Set Trigger

Avg 2.69

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	2.5 lbs. after 50 cycles
Note:	R. Putch 11/07/06		



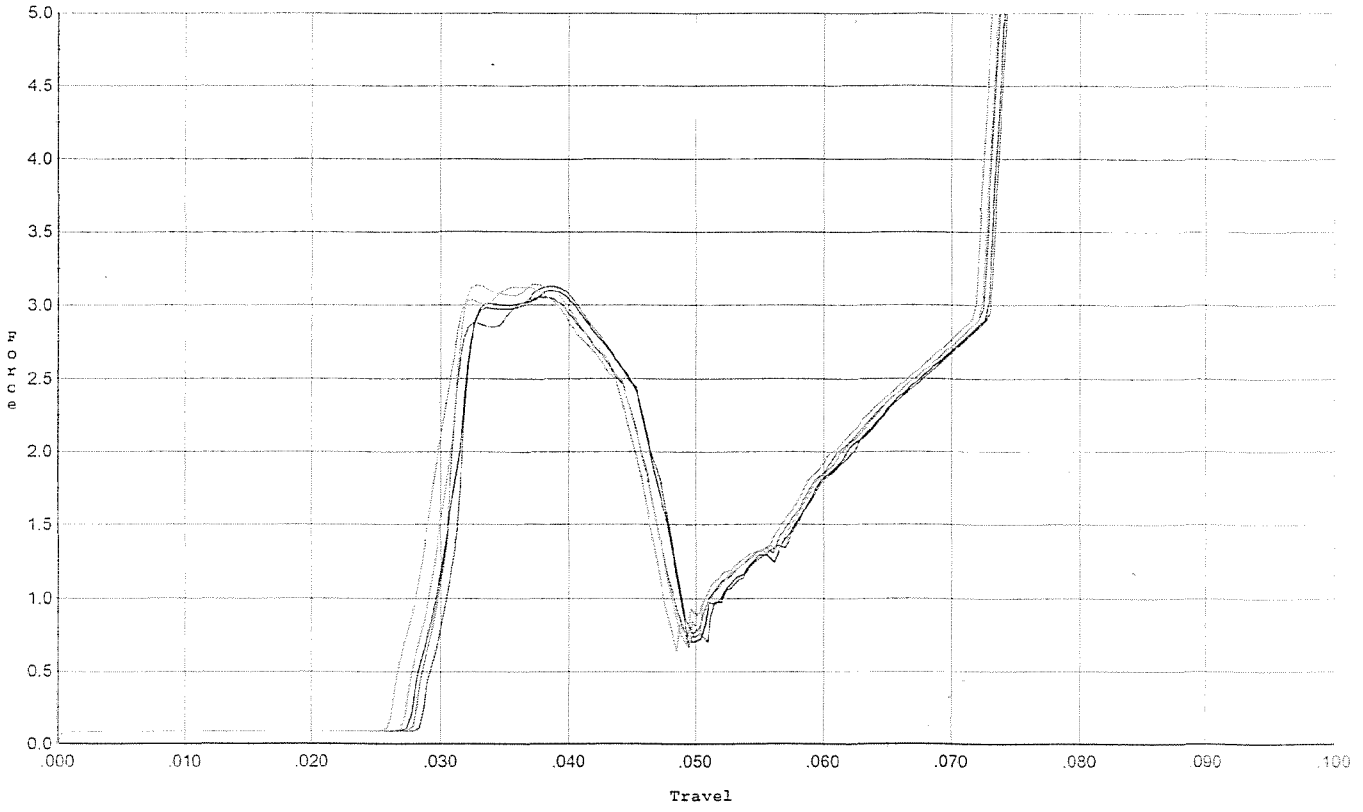
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.540	0.047	0.031	0.035	0.033		Set Trigger
2	2.529	0.046	0.031	0.035	0.033		Set Trigger
3	2.522	0.048	0.032	0.034	0.034		Set Trigger
4	2.547	0.048	0.031	0.034	0.035		Set Trigger
5	2.564	0.048	0.031	0.034	0.035		Set Trigger

Avg 2.54

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc. 11/7/2006 11:25:55 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini.
Note:	R. Putch 11/07/06		



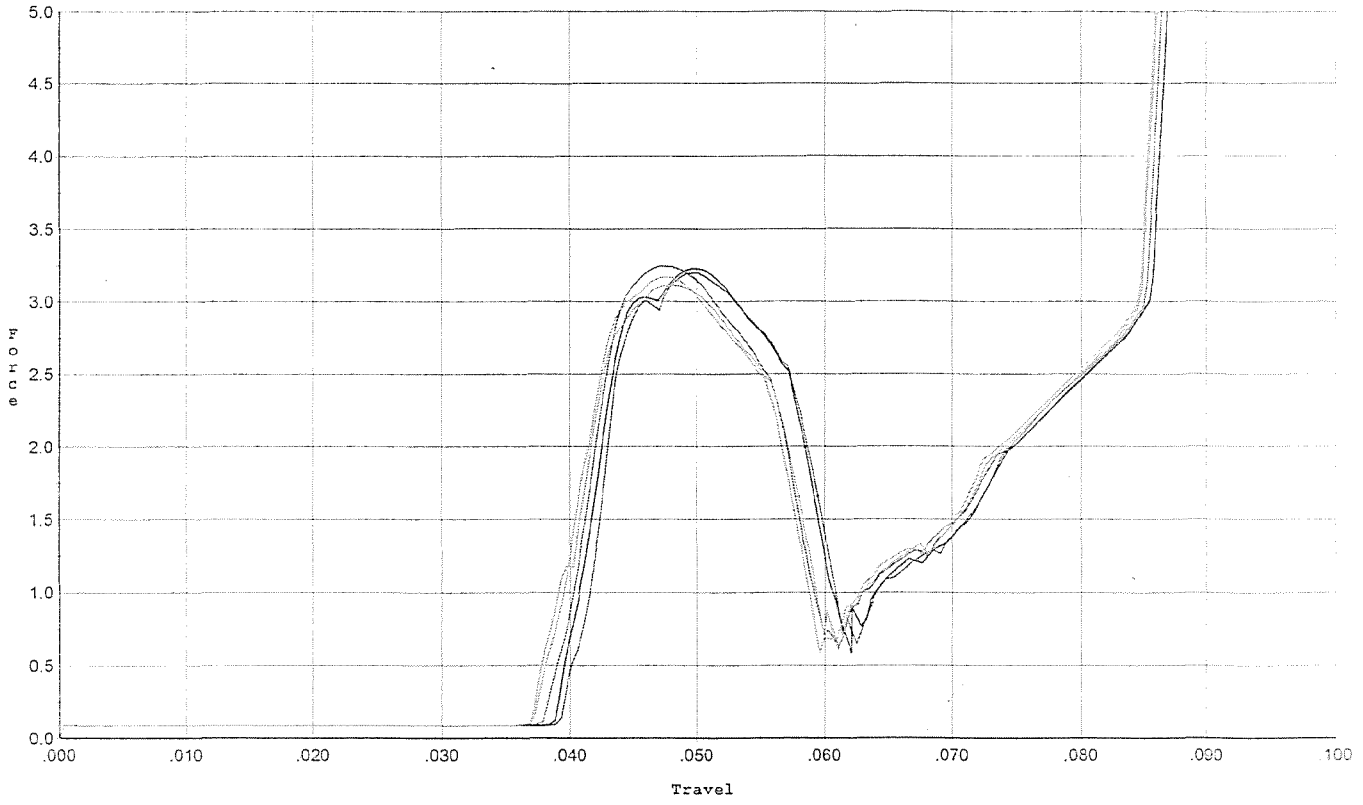
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.130	0.047	0.029	0.031	0.049		Set Trigger
2	3.100	0.048	0.028	0.031	0.051		Set Trigger
3	3.058	0.046	0.028	0.031	0.047		Set Trigger
4	3.142	0.046	0.027	0.031	0.050		Set Trigger
5	3.124	0.046	0.026	0.031	0.050		Set Trigger

Avg 3.11

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc., 11/7/2006 11:29:22 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles
Note:	R. Putch 11/07/06		



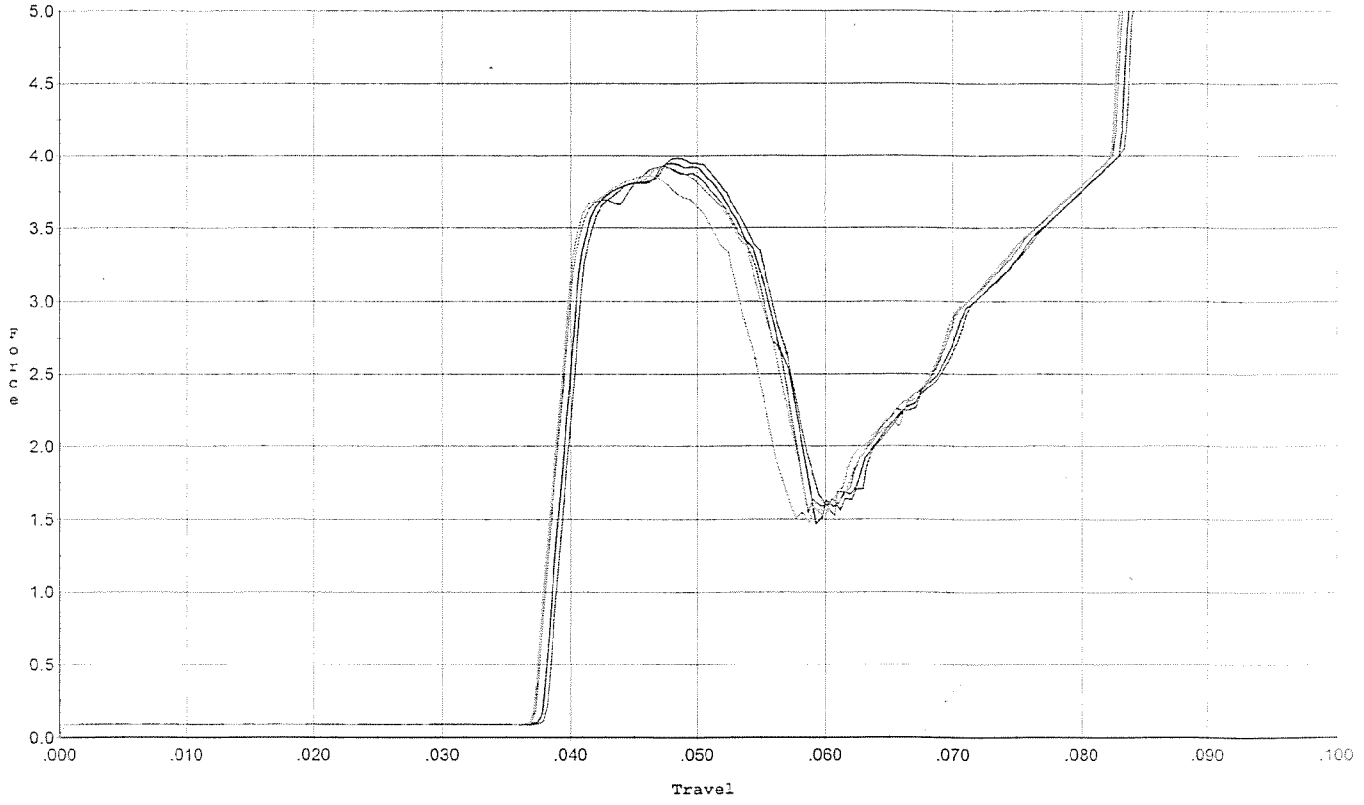
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.059	0.040	0.034	0.053		Set Trigger
2	3.228	0.058	0.039	0.035	0.054		Set Trigger
3	3.246	0.057	0.038	0.036	0.051		Set Trigger
4	3.167	0.058	0.037	0.035	0.052		Set Trigger
5	3.109	0.058	0.037	0.035	0.053		Set Trigger

Aug 318

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/7/2006 11:31:09 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	R. Putch 11/07/06		



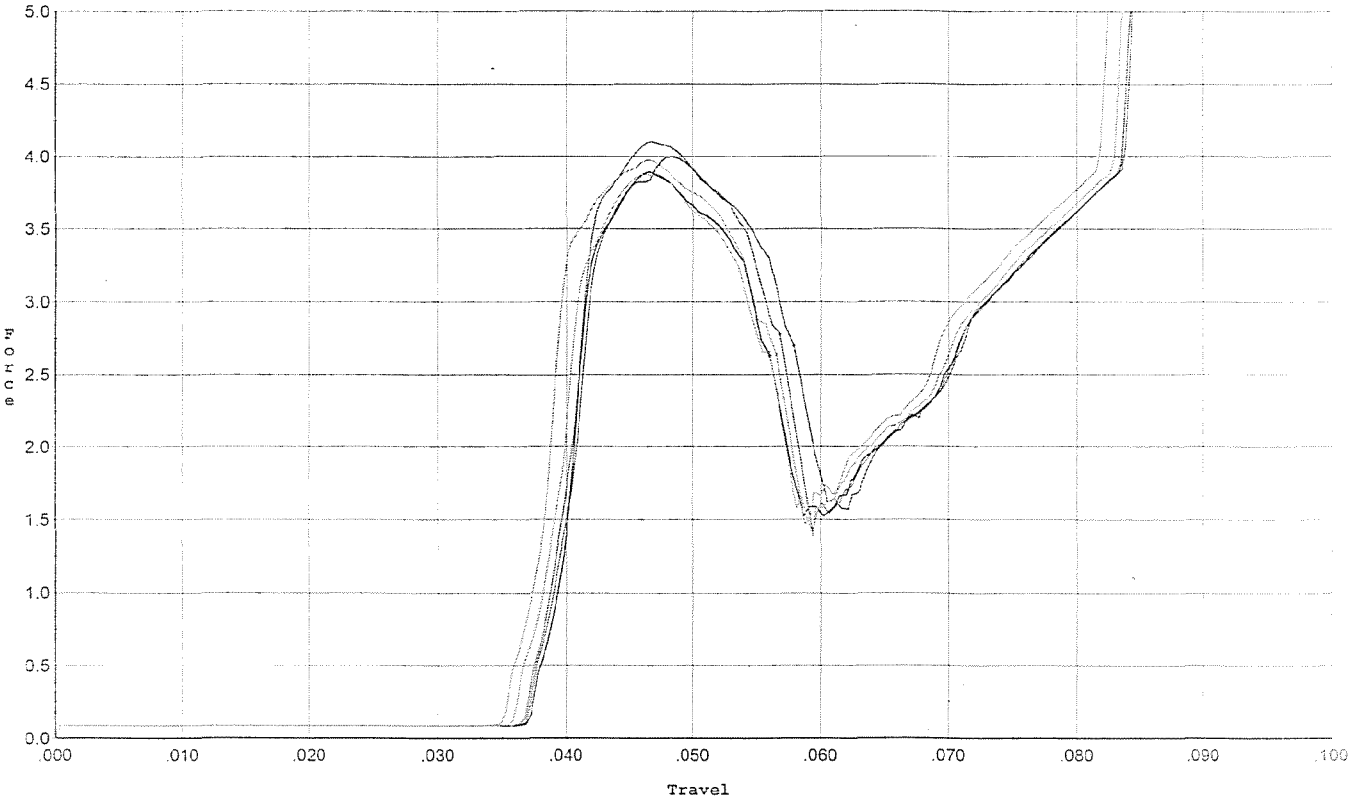
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.982	0.057	0.038	0.033	0.068		Set Trigger
2	3.948	0.057	0.038	0.032	0.069		Set Trigger
3	3.926	0.056	0.037	0.032	0.068		Set Trigger
4	3.860	0.055	0.037	0.034	0.061		Set Trigger
5	3.918	0.057	0.037	0.032	0.069		Set Trigger

Avg 3.92

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/7/2006 11:35:09 AM

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	4.0 lbs. after 20 cycles
Note:	R. Putch 11/07/06		



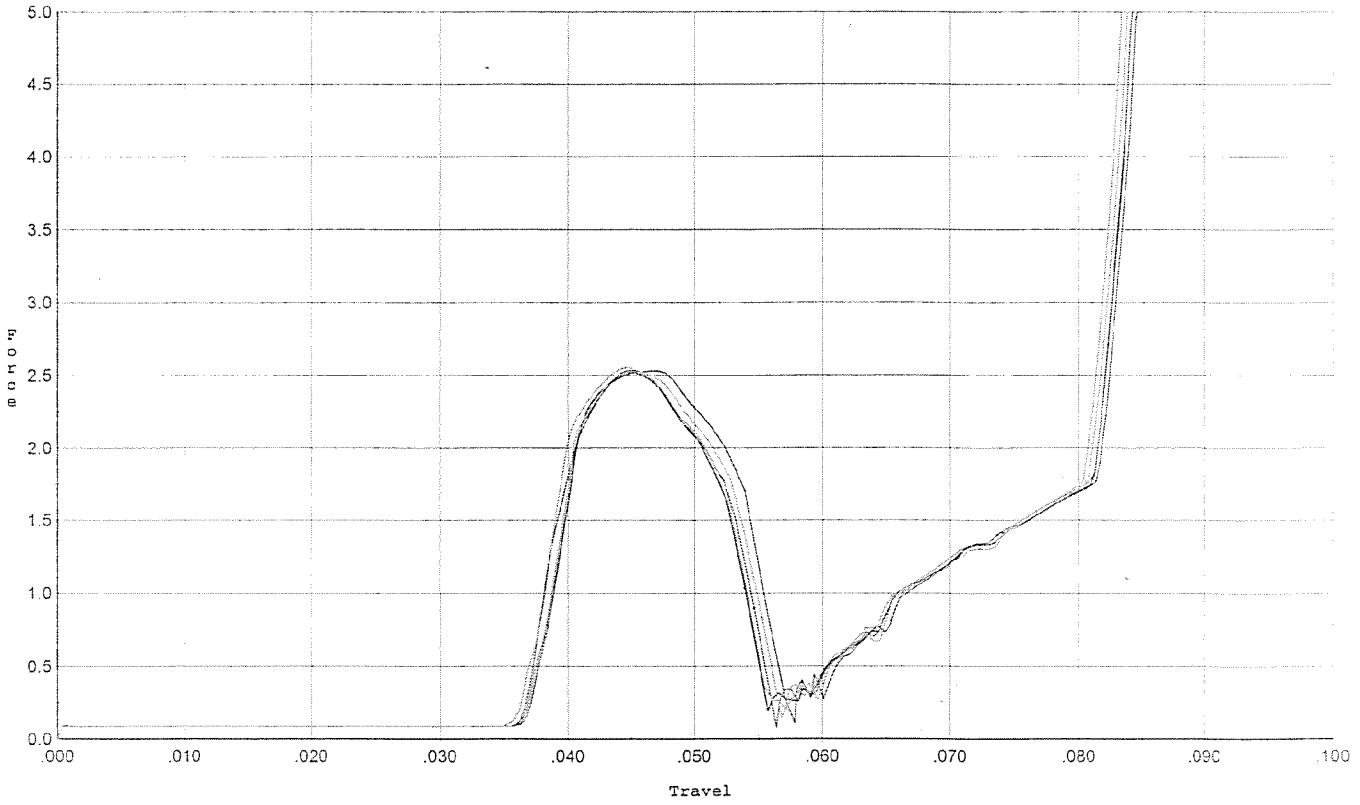
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.001	0.058	0.037	0.032	0.069		Set Trigger
2	3.895	0.056	0.037	0.034	0.061		Set Trigger
3	4.105	0.057	0.037	0.033	0.068		Set Trigger
4	3.877	0.056	0.036	0.033	0.064		Set Trigger
5	3.977	0.056	0.035	0.032	0.070		Set Trigger

Avg 3.97

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc., 11/7/2006 11:39:08 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. for final test
Note:	R. Putch 11/07/06		



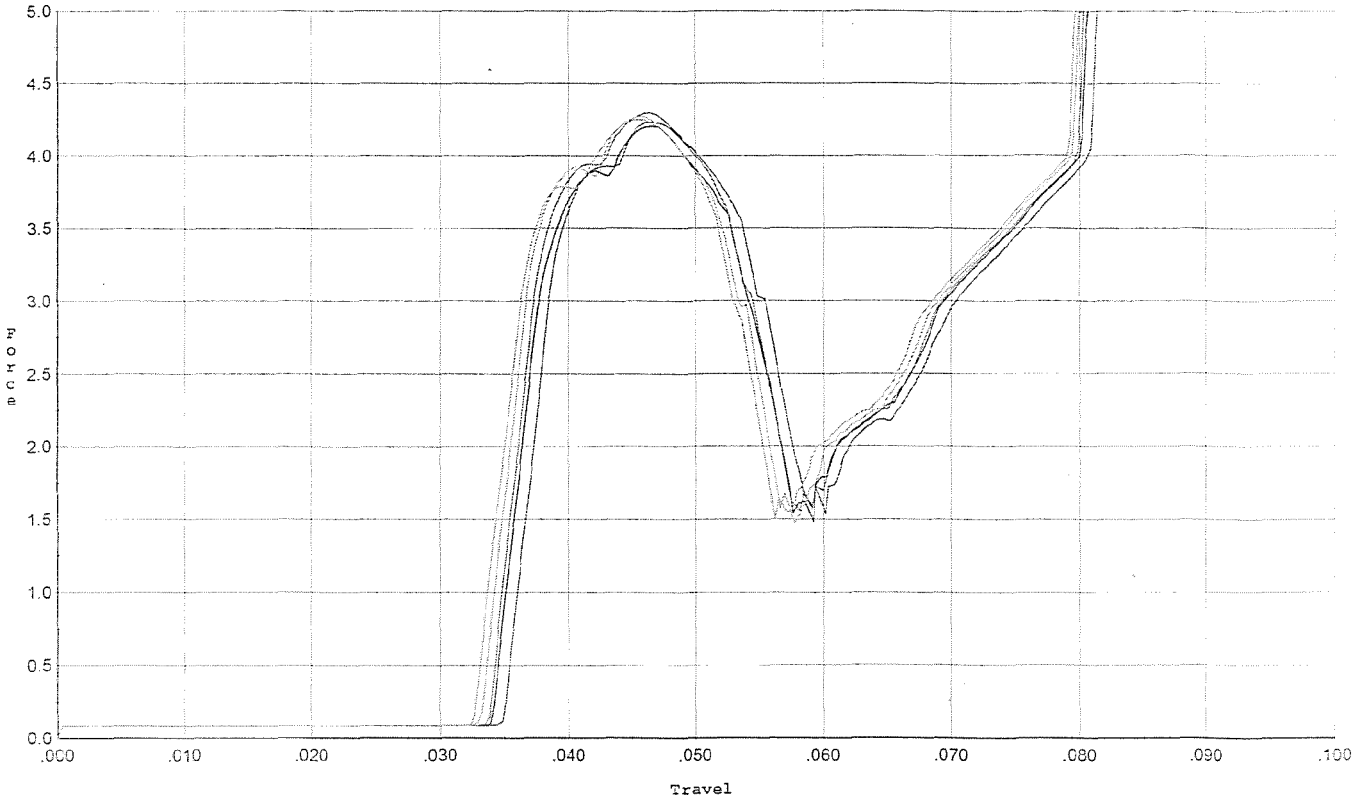
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.054	0.037	0.037	0.039		Set Trigger
2	2.531	0.054	0.037	0.038	0.036		Set Trigger
3	2.520	0.055	0.037	0.037	0.037		Set Trigger
4	2.524	0.055	0.037	0.037	0.038		Set Trigger
5	2.555	0.054	0.036	0.037	0.038		Set Trigger

Avg 2.53

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc. 11/7/2006 11:42:08 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. for target & accuracy
Note:	R. Putch 11/07/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.055	0.035	0.031	0.075		Set Trigger
2	4.204	0.056	0.034	0.031	0.076		Set Trigger
3	4.295	0.056	0.034	0.031	0.079		Set Trigger
4	4.269	0.054	0.033	0.031	0.076		Set Trigger
5	4.249	0.054	0.033	0.031	0.076		Set Trigger

Avg 4.25

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/7/2006 11:45:18 AM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605285.__0
FILE DATE AND TIME: 11/30/2006 21:09

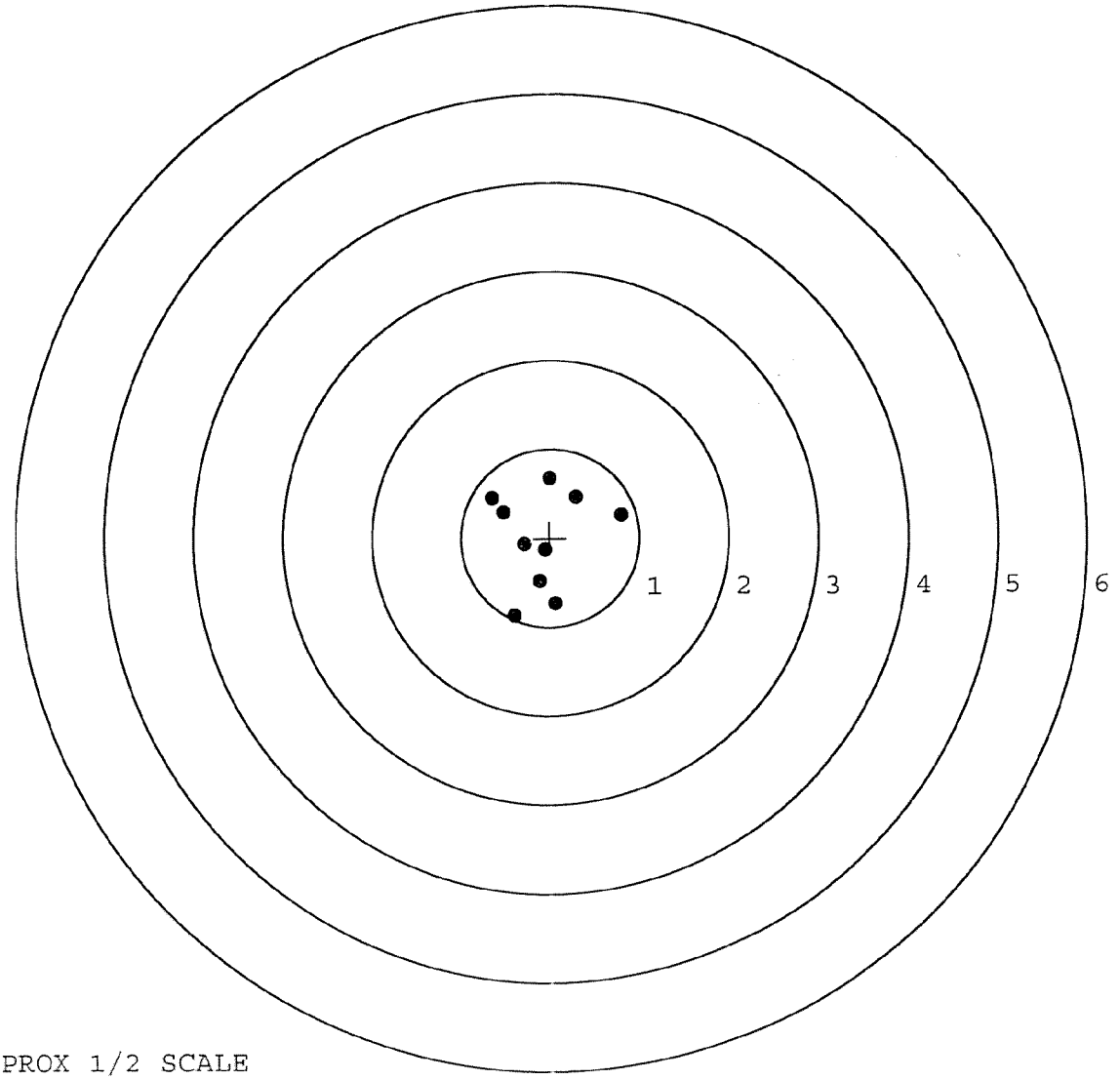
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.005
The Average Y Centroid of the Five Target Set:	-0.059
The Average Point of Impact of the Five Target Set:	0.059
The Average Mean Radius of the Five Target Set:	0.534
The Distance from POA to Centroid Target #1:	0.092
The Distance from Centroid Target #2 to Centroid Target #1:	0.199
The Distance from Centroid Target #3 to Centroid Target #1:	0.148
The Distance from Centroid Target #4 to Centroid Target #1:	0.167
The Distance from Centroid Target #5 to Centroid Target #1:	0.028

SERIAL NUMBER: G6605285.__0
TARGET NUMBER: 1
FILE DATE: 11/30/2006
FILE TIME: 21:09

X CENTROID:	-0.089
Y CENTROID:	-0.020
POA TO CENTROID:	0.092
HORZ SPREAD:	1.448
VERT SPREAD:	1.546
GROUP SPREAD:	1.646
MIN RADIUS:	0.123
MAX RADIUS:	0.926
MEAN RADIUS:	0.595
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.796	0.249
2:	0.065	-0.742
3:	-0.404	-0.877
4:	-0.119	-0.493
5:	-0.058	-0.139
6:	-0.288	-0.067
7:	-0.523	0.289
8:	-0.652	0.449
9:	-0.006	0.669
10:	0.295	0.457

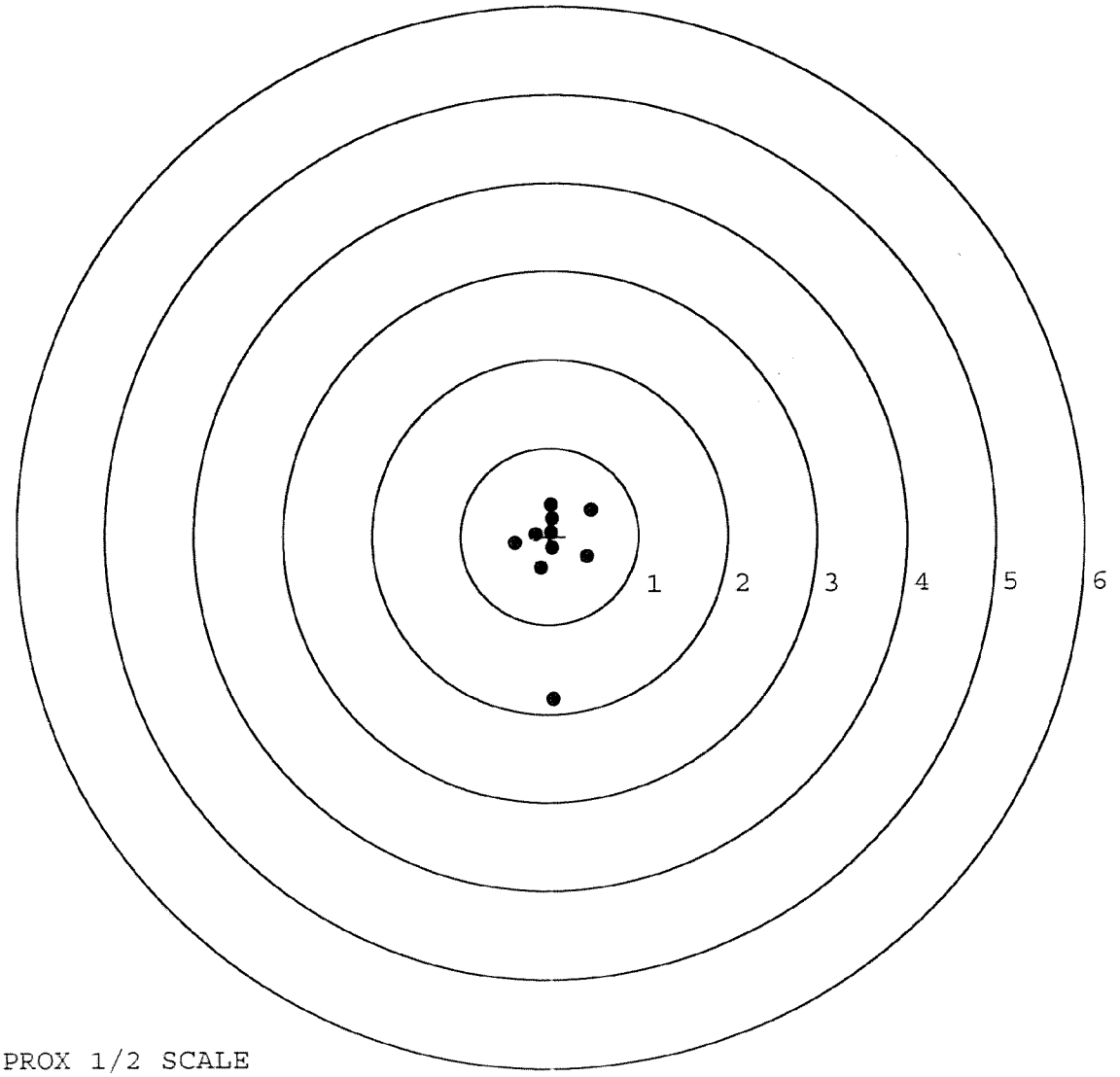


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605285.__0
TARGET NUMBER: 2
FILE DATE: 11/30/2006
FILE TIME: 21:09

X CENTROID:	0.040
Y CENTROID:	-0.172
POA TO CENTROID:	0.177
HORZ SPREAD:	0.864
VERT SPREAD:	2.197
GROUP SPREAD:	2.197
MIN RADIUS:	0.038
MAX RADIUS:	1.667
MEAN RADIUS:	0.481
# IN 1 IN DIAMETER:	7
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.472	0.294
2:	0.420	-0.237
3:	0.044	-1.839
4:	-0.099	-0.365
5:	-0.392	-0.074
6:	0.034	-0.135
7:	-0.160	0.023
8:	0.022	0.046
9:	0.034	0.205
10:	0.024	0.358



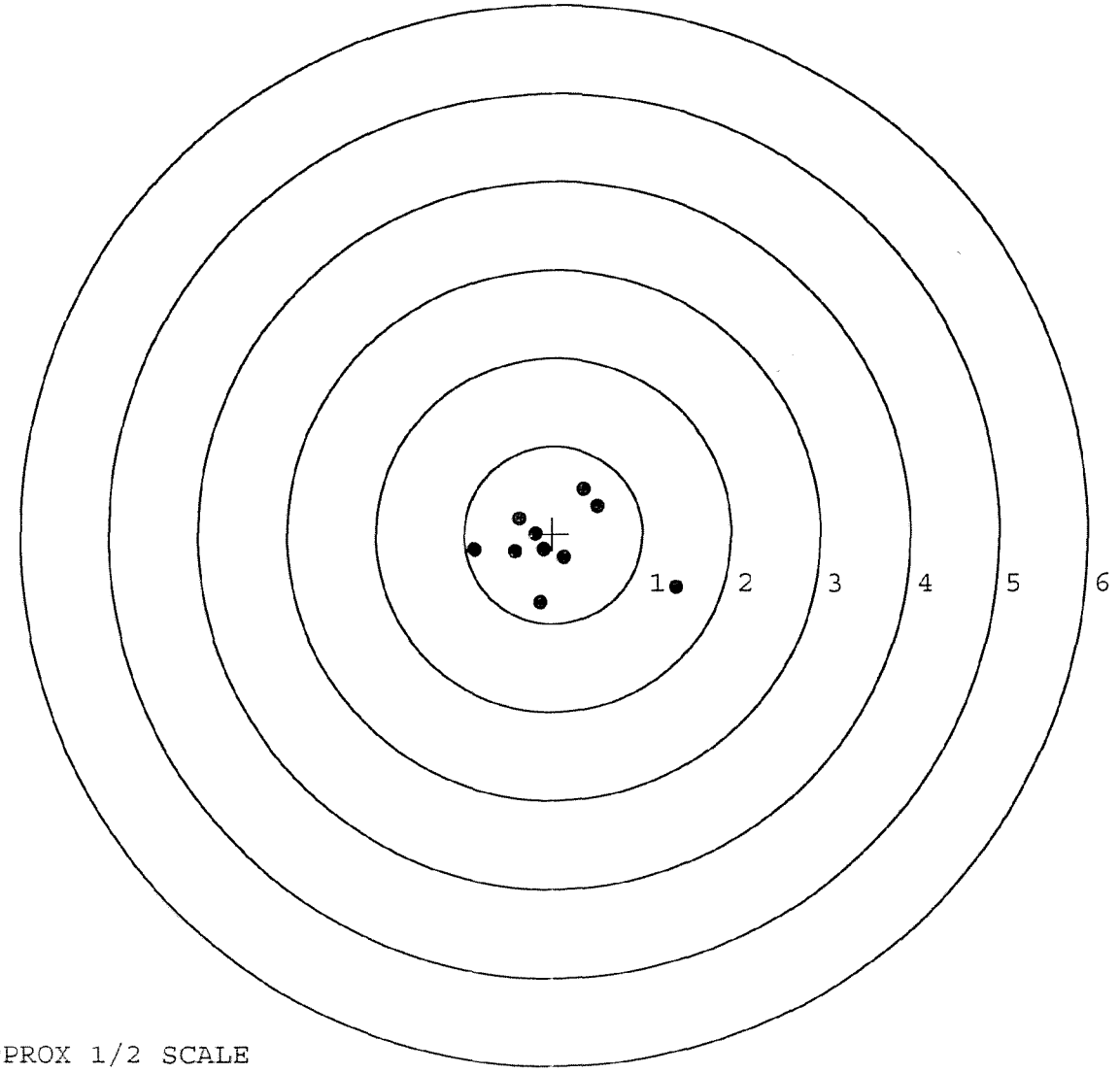
TARGET APPROX 1/2 SCALE

BARBER - M24 0132401

SERIAL NUMBER: G6605285.__0
TARGET NUMBER: 3
FILE DATE: 11/30/2006
FILE TIME: 21:09

X CENTROID:	0.020
Y CENTROID:	-0.120
POA TO CENTROID:	0.122
HORZ SPREAD:	2.258
VERT SPREAD:	1.285
GROUP SPREAD:	2.300
MIN RADIUS:	0.135
MAX RADIUS:	1.440
MEAN RADIUS:	0.590
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.343	0.513
2:	0.500	0.315
3:	1.374	-0.611
4:	-0.144	-0.772
5:	-0.884	-0.175
6:	-0.382	0.175
7:	-0.432	-0.197
8:	-0.196	-0.005
9:	-0.104	-0.174
10:	0.128	-0.273



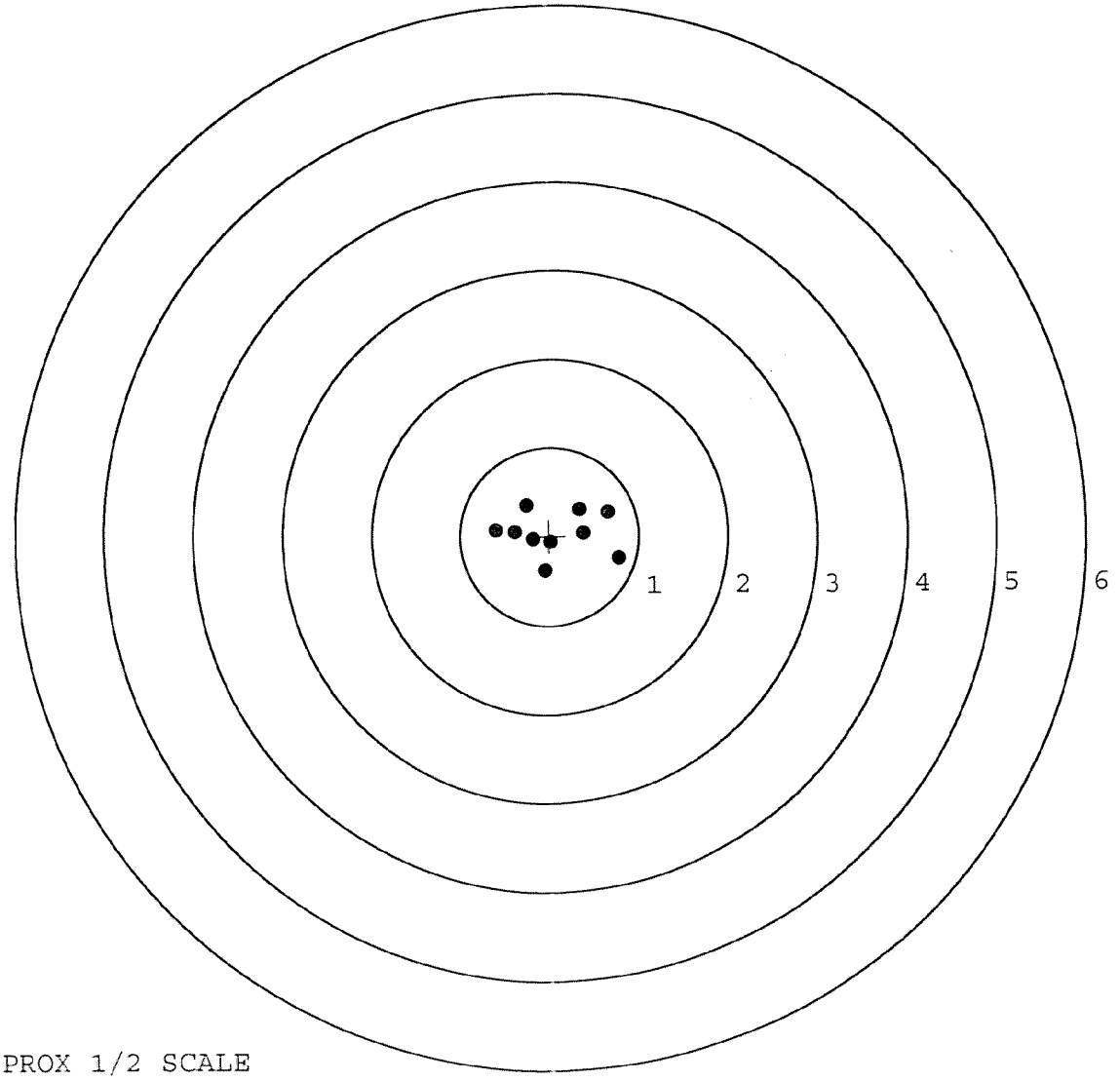
TARGET APPROX 1/2 SCALE

BARBER - M24 0132402

SERIAL NUMBER: G6605285.__0
TARGET NUMBER: 4
FILE DATE: 11/30/2006
FILE TIME: 21:09

X CENTROID:	0.070
Y CENTROID:	0.031
POA TO CENTROID:	0.076
HORZ SPREAD:	1.380
VERT SPREAD:	0.745
GROUP SPREAD:	1.418
MIN RADIUS:	0.111
MAX RADIUS:	0.766
MEAN RADIUS:	0.450
# IN 1 IN DIAMETER:	7
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.344	0.296
2:	0.384	0.033
3:	0.658	0.264
4:	0.779	-0.258
5:	-0.052	-0.392
6:	-0.601	0.067
7:	-0.256	0.353
8:	-0.390	0.050
9:	-0.186	-0.034
10:	0.017	-0.067



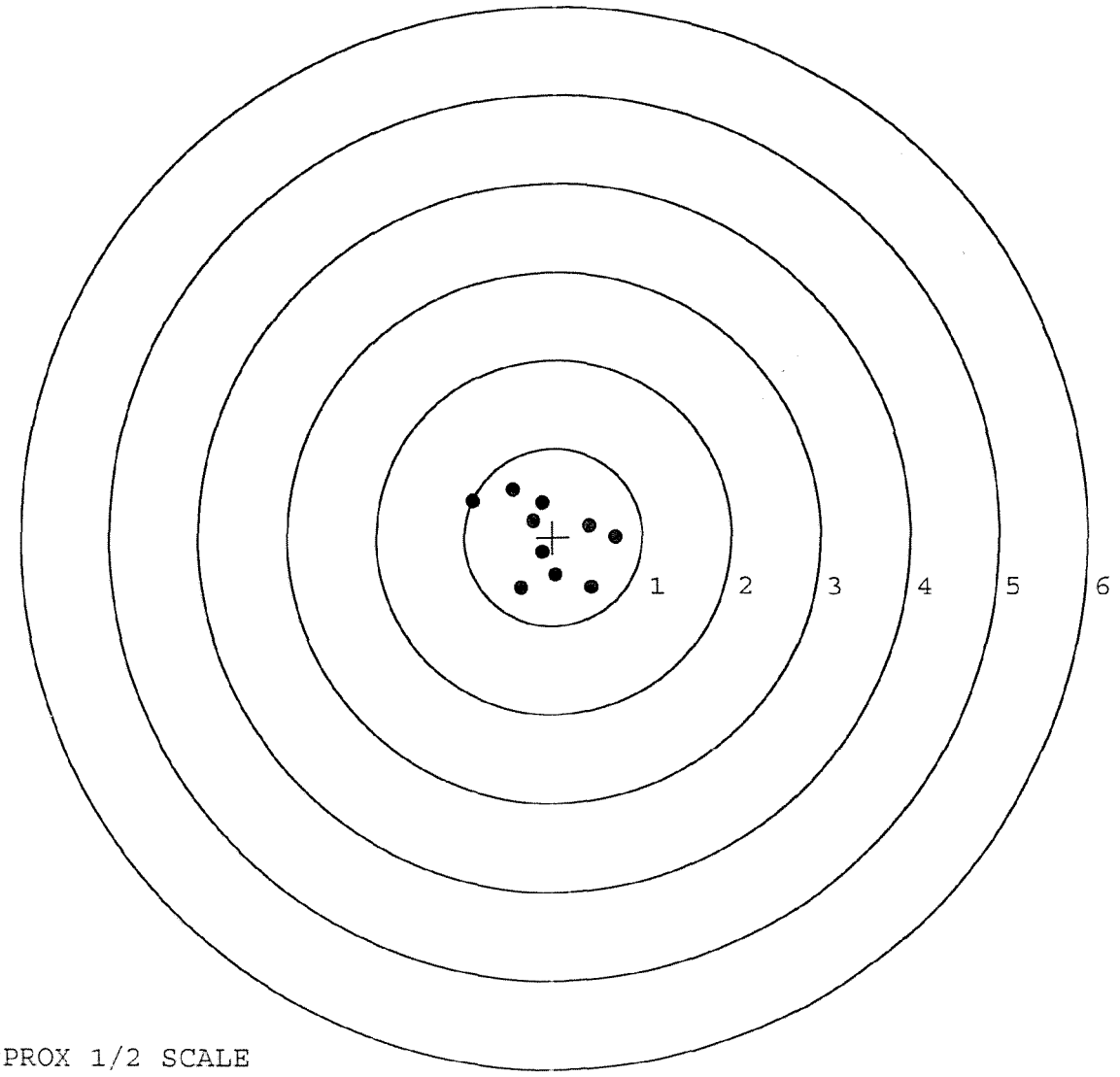
TARGET APPROX 1/2 SCALE

BARBER - M24 0132403

SERIAL NUMBER: G6605285.__0
TARGET NUMBER: 5
FILE DATE: 11/30/2006
FILE TIME: 21:09

X CENTROID:	-0.064
Y CENTROID:	-0.011
POA TO CENTROID:	0.064
HORZ SPREAD:	1.614
VERT SPREAD:	1.116
GROUP SPREAD:	1.663
MIN RADIUS:	0.168
MAX RADIUS:	0.945
MEAN RADIUS:	0.552
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.912	0.405
2:	-0.455	0.537
3:	-0.127	0.387
4:	-0.228	0.183
5:	0.405	0.130
6:	0.702	0.004
7:	0.434	-0.572
8:	-0.121	-0.168
9:	0.027	-0.432
10:	-0.360	-0.579



TARGET APPROX 1/2 SCALE