

G-652/397
A2

ORDER 27246

M24A2 7.62 NATO COMPLETE SYSTEM

UPC



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M24A2 7.62 NATO COMPLETE SYSTEM

UPC



SERIAL NO.



M24A2 7.62 NATO COMPLETE SYSTEM
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

— INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	27246
BARREL LENGTH	24"
CAPACITY	6

G6521397



M-24
INSPECTION CHECKLIST-NEW GUNS

G 652 1397
GUN SERIAL # ~~6646~~ 1790

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-19-06	RTZ
440	PROOF		1-19-06	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-19-06	RTZ
470	DIS-ASSEMBLE ACTION	JAN 20 2006	1-19-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480 OPERATOR CPD	1-20-06	APD
500	ROLLMARK CALIBER		1-19-06	CW
510	DRILL AND TAP SIGHT HOLES	N/A		
520	GOFF BLAST BBL / REC		1-20-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/23	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-23-06	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-23-06	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-23-06	A
	D) OIL FIRING PIN ASSEMBLY		1-22-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

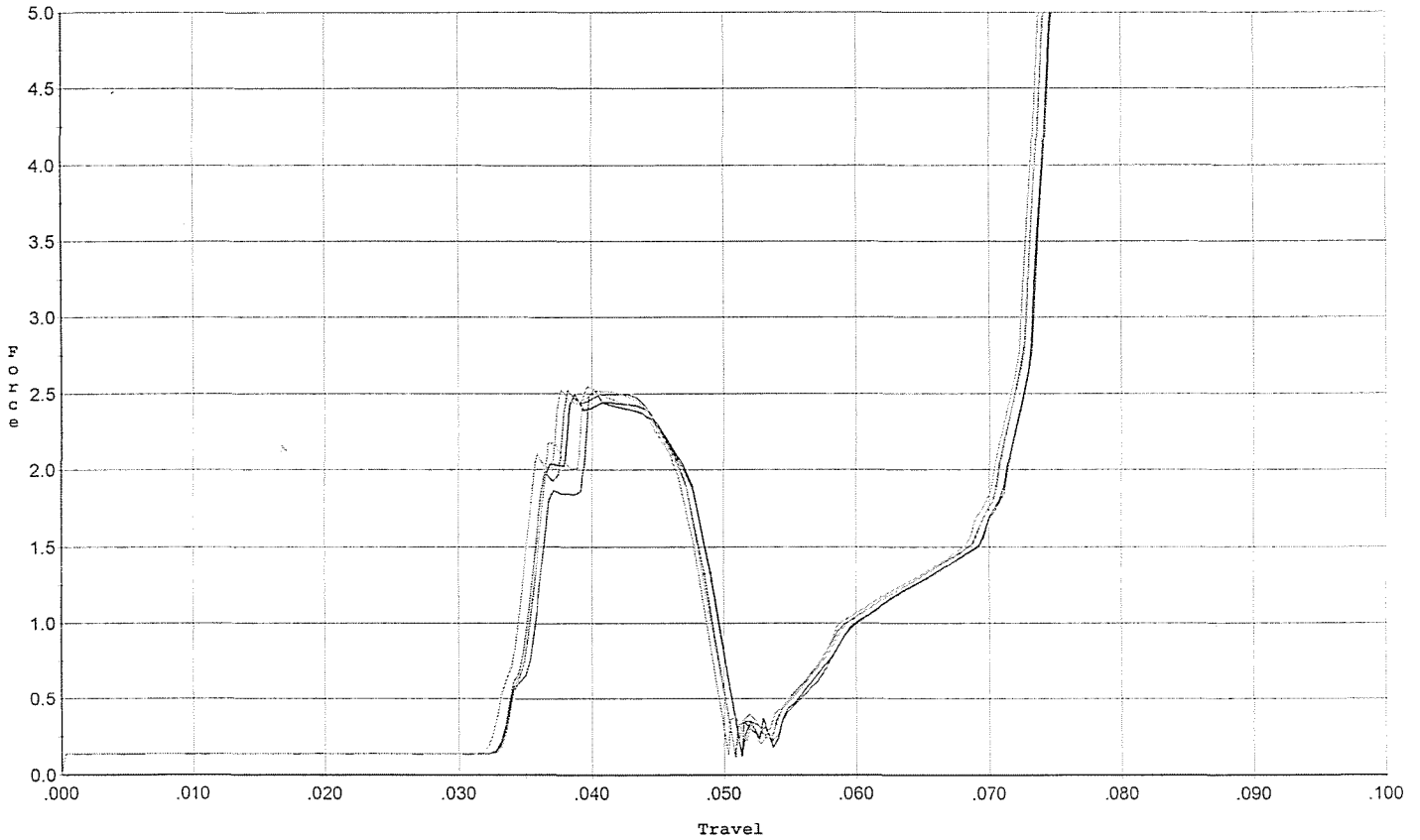
REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.2</u> <u>6.2</u>	8-22-07	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>4.0</u>	8-22-07	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.022</u>	8-22-07	RA
	J) ASSEMBLE STOCK		3-6-06	RTZ
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-6-06	RTZ
	M) IRON SIGHT ALIGNMENT		3-6-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-6-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-6-07 3-6-06	TRW TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO	8-6-07 Fr	3/6/06	RP
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.70</u> <u>2.65</u> <u>2.69</u> <u>2.67</u>	8-22-07	RA
	C) FUNCTION			
690	PACK		8-22-07	RA

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



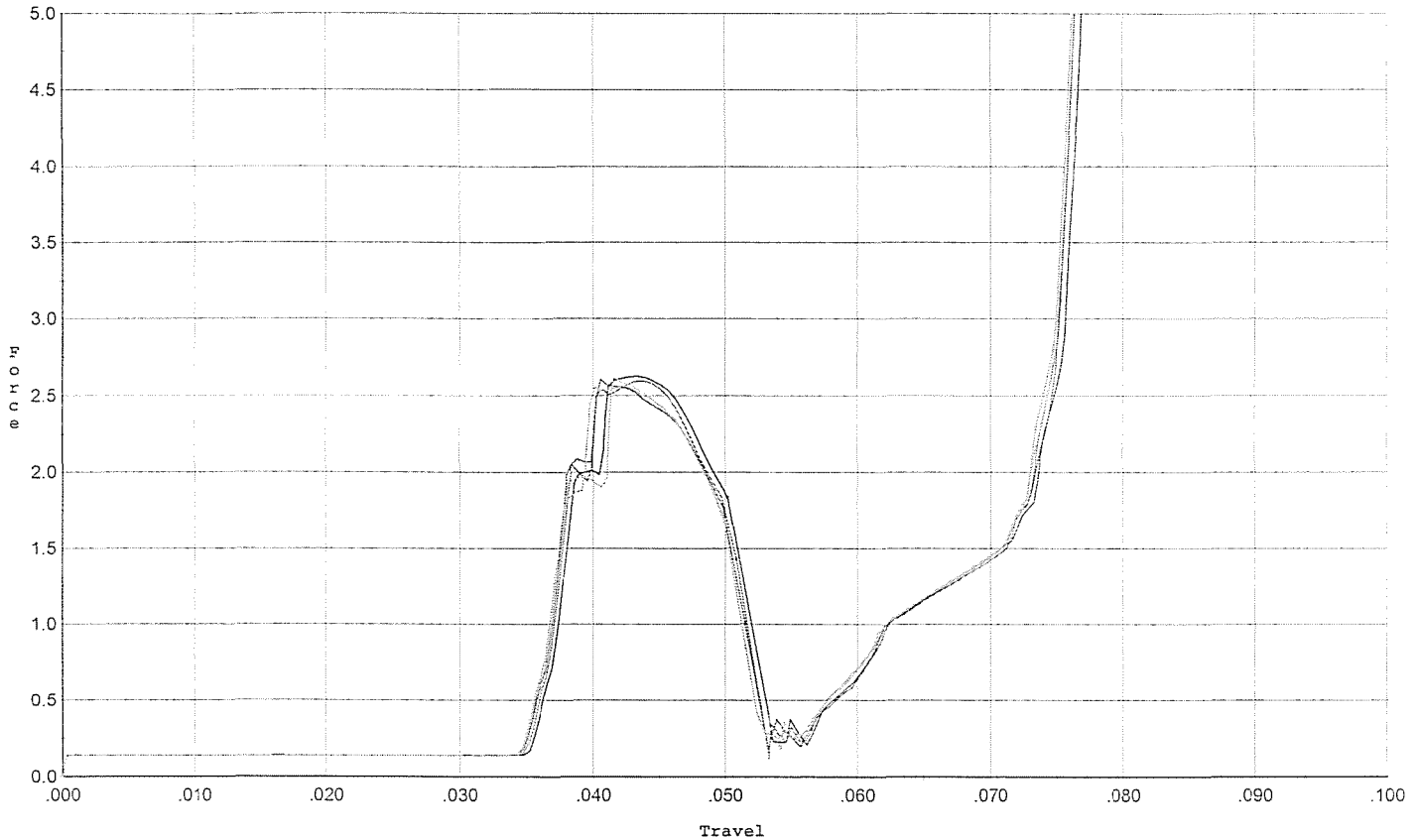
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.049	0.034	0.033	0.034		Set Trigger
2	2.498	0.049	0.033	0.033	0.035		Set Trigger
3	2.525	0.048	0.033	0.033	0.035		Set Trigger
4	2.553	0.049	0.034	0.033	0.034		Set Trigger
5	2.528	0.048	0.033	0.033	0.035		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



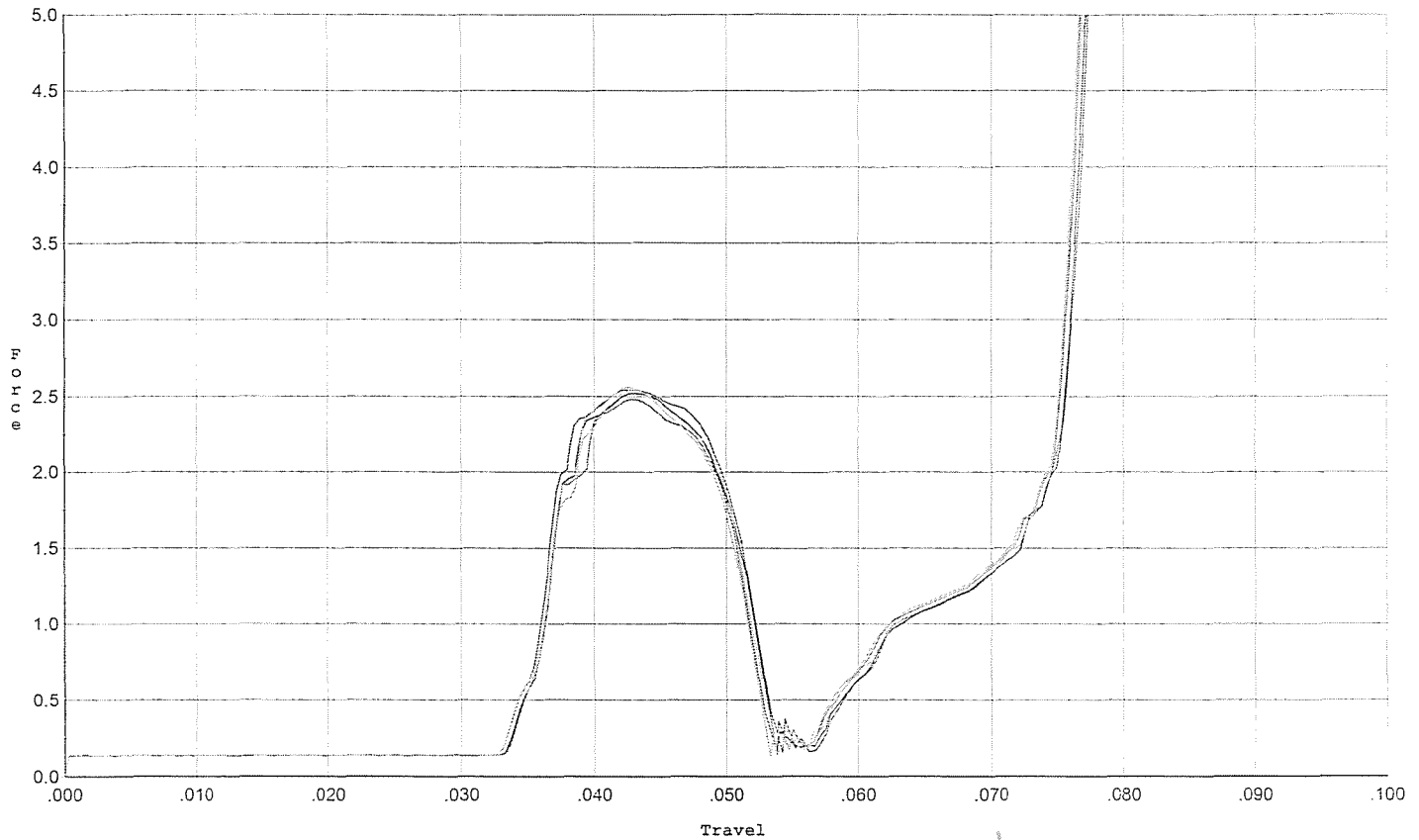
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.051	0.035	0.033	0.037		Set Trigger
2	2.623	0.050	0.036	0.033	0.036		Set Trigger
3	2.594	0.051	0.035	0.033	0.037		Set Trigger
4	2.620	0.050	0.035	0.033	0.035		Set Trigger
5	2.562	0.050	0.035	0.033	0.036		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



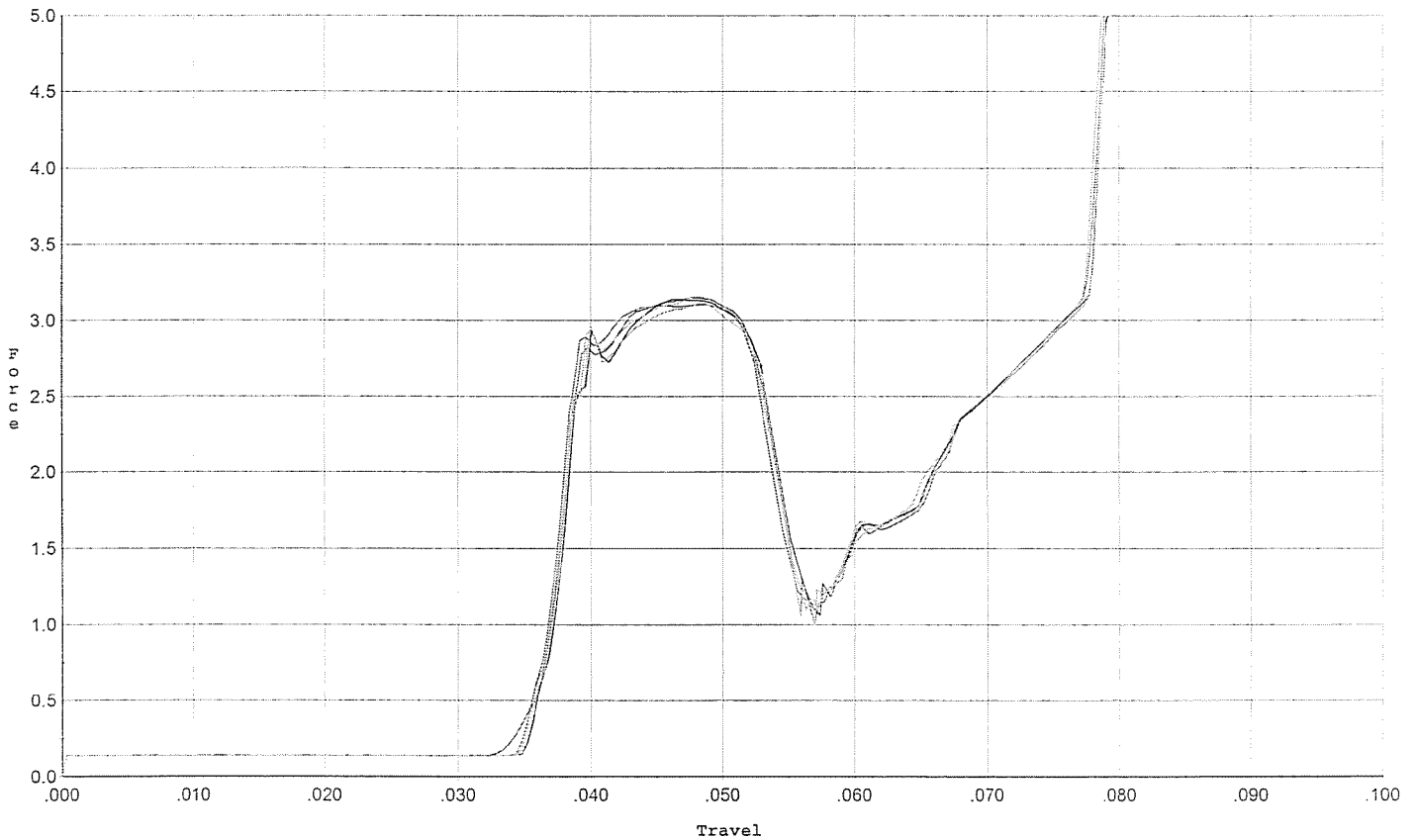
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.051	0.033	0.033	0.041		Set Trigger
2	2.519	0.051	0.034	0.033	0.039		Set Trigger
3	2.482	0.051	0.034	0.033	0.037		Set Trigger
4	2.560	0.051	0.033	0.033	0.039		Set Trigger
5	2.545	0.050	0.034	0.034	0.038		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



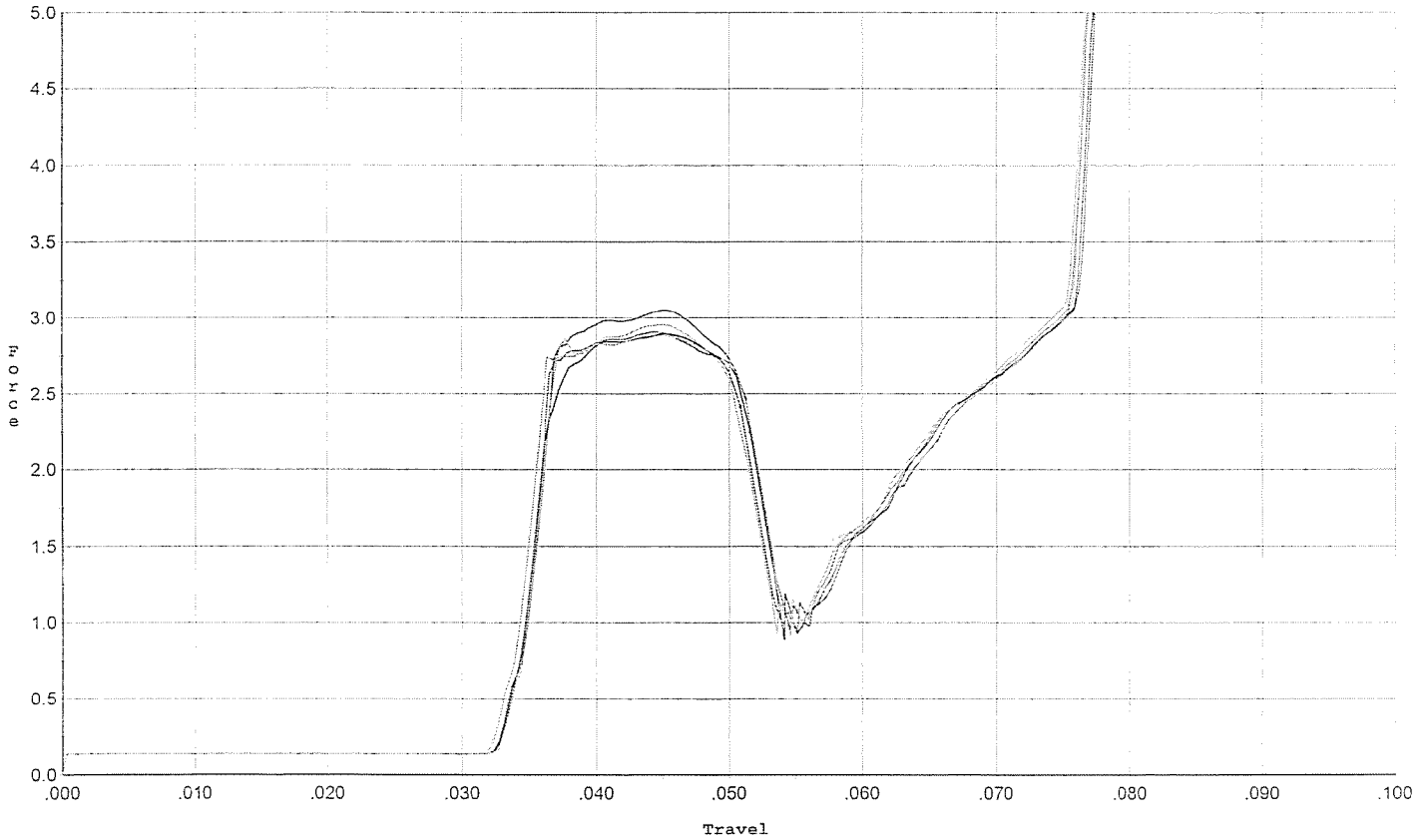
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.053	0.035	0.032	0.054		Set Trigger
2	3.142	0.053	0.035	0.032	0.053		Set Trigger
3	3.107	0.052	0.035	0.032	0.053		Set Trigger
4	3.118	0.053	0.035	0.032	0.053		Set Trigger
5	3.161	0.054	0.035	0.031	0.054		Set Trigger

AUG 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



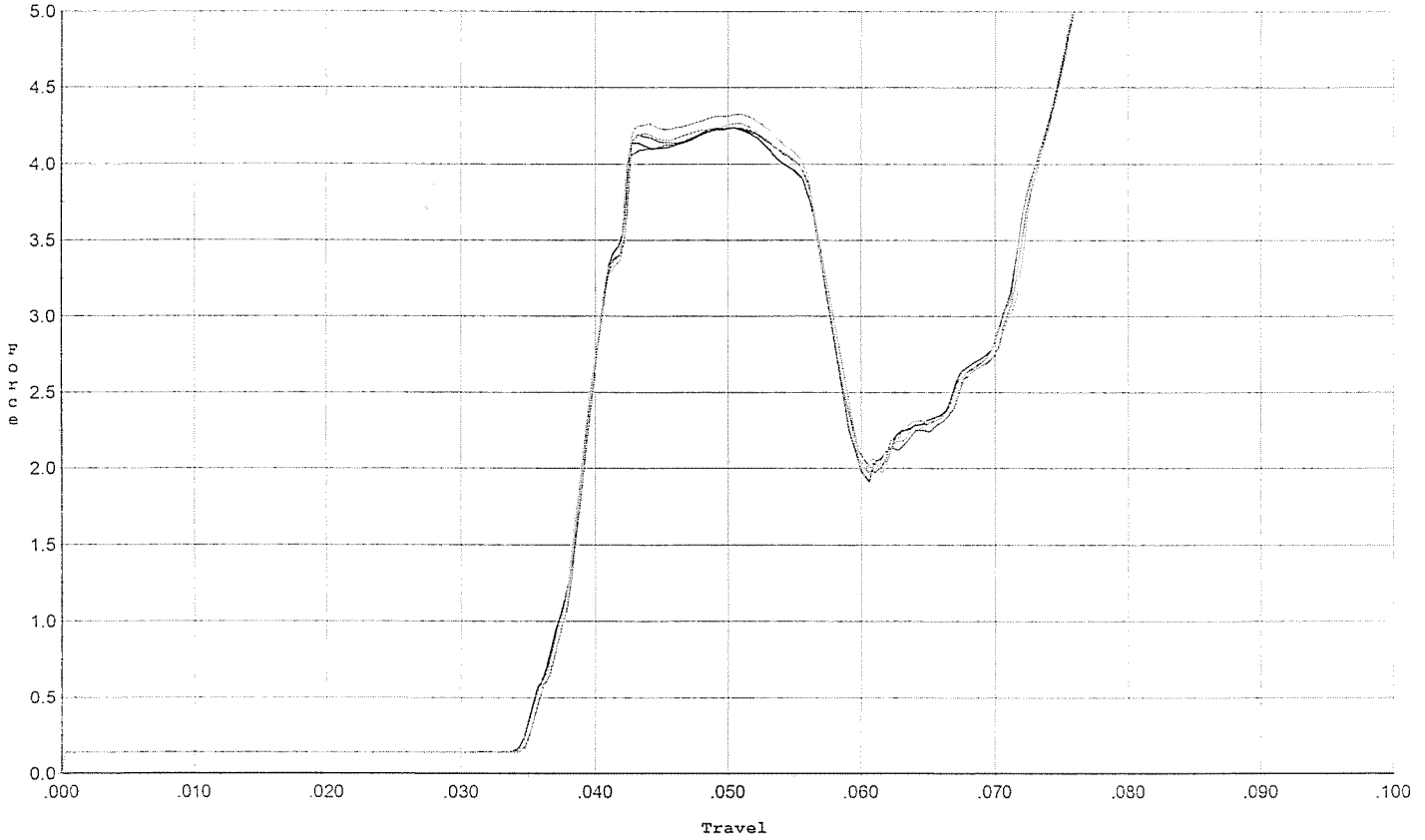
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.053	0.051	0.033	0.032	0.053		Set Trigger
2	2.896	0.052	0.033	0.032	0.051		Set Trigger
3	2.905	0.051	0.033	0.032	0.050		Set Trigger
4	2.955	0.051	0.033	0.032	0.051		Set Trigger
5	2.884	0.051	0.032	0.032	0.052		Set Trigger

AUG 2.93

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: -4.0 lbs. ini. +/- 1.0 lbs.



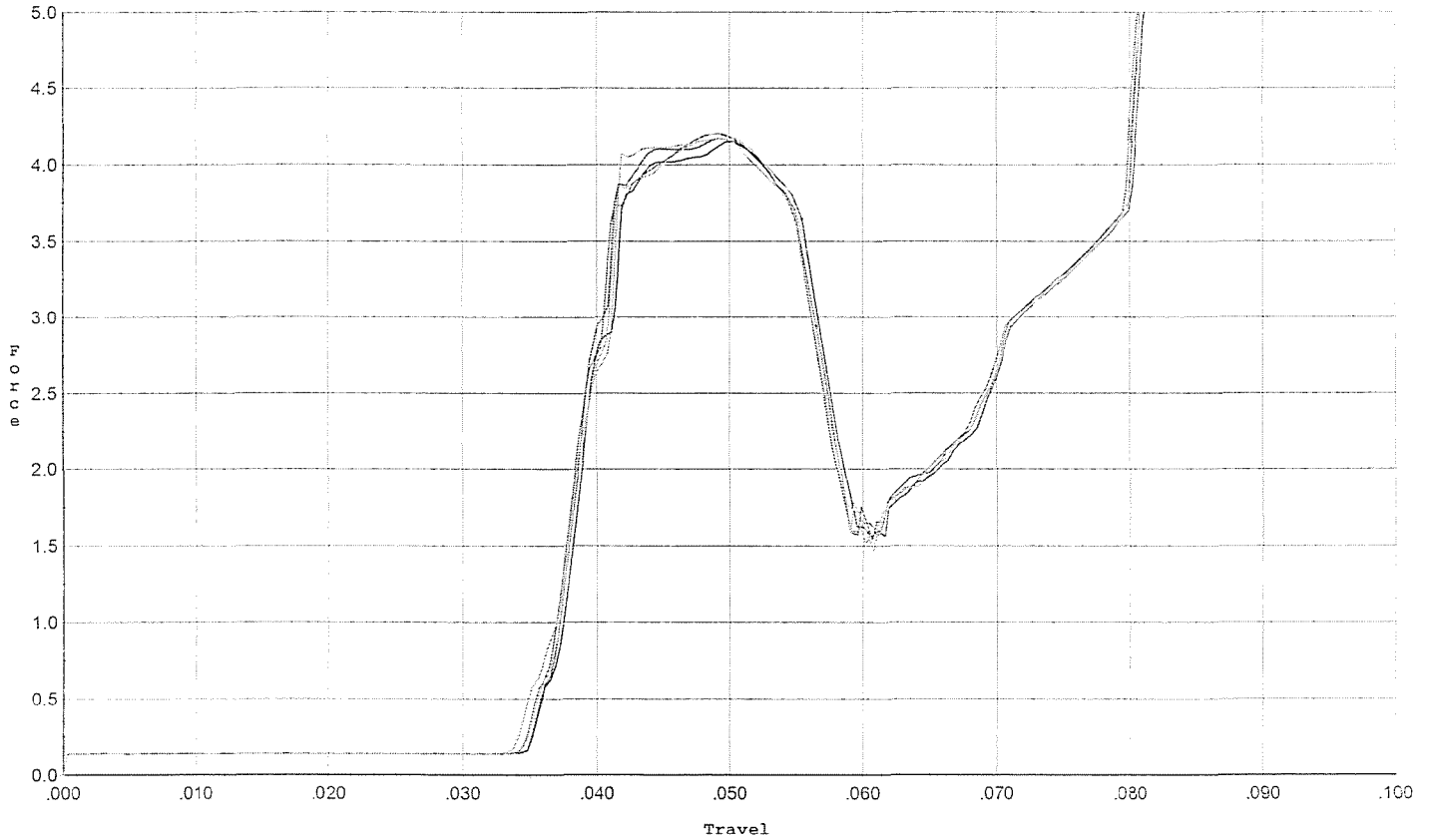
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.236	0.056	0.035	0.024	0.080		Set Trigger
2	4.233	0.056	0.035	0.024	0.080		Set Trigger
3	4.236	0.058	0.035	0.024	0.083		Set Trigger
4	4.266	0.056	0.035	0.024	0.080		Set Trigger
5	4.326	0.058	0.035	0.024	0.084		Set Trigger

Avg 4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: -4.0 lbs. after 20 cycles +/- 1.0 lbs.



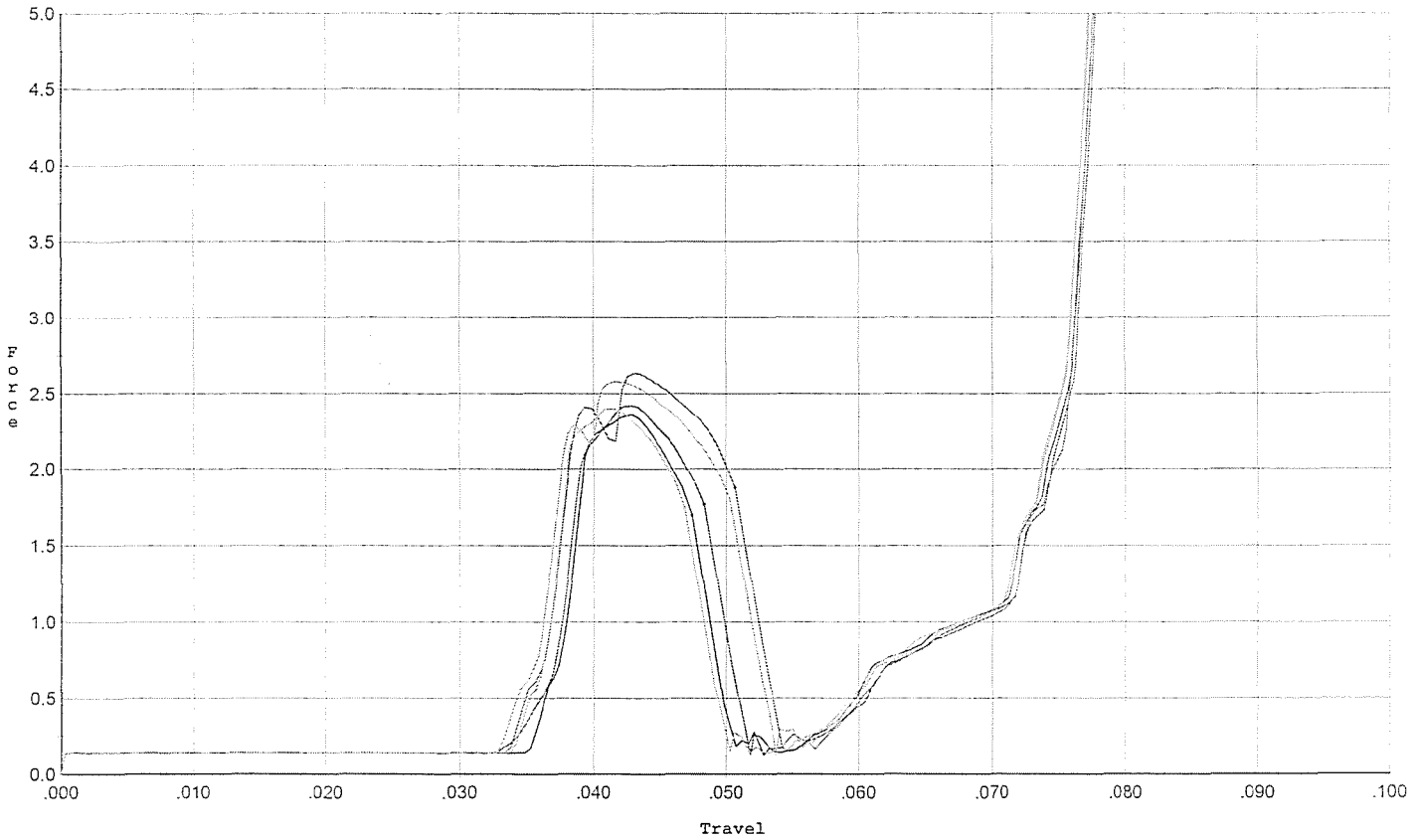
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.057	0.035	0.029	0.077		Set Trigger
2	4.149	0.055	0.035	0.030	0.075		Set Trigger
3	4.202	0.055	0.035	0.030	0.075		Set Trigger
4	4.204	0.056	0.035	0.029	0.076		Set Trigger
5	4.170	0.055	0.034	0.030	0.075		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



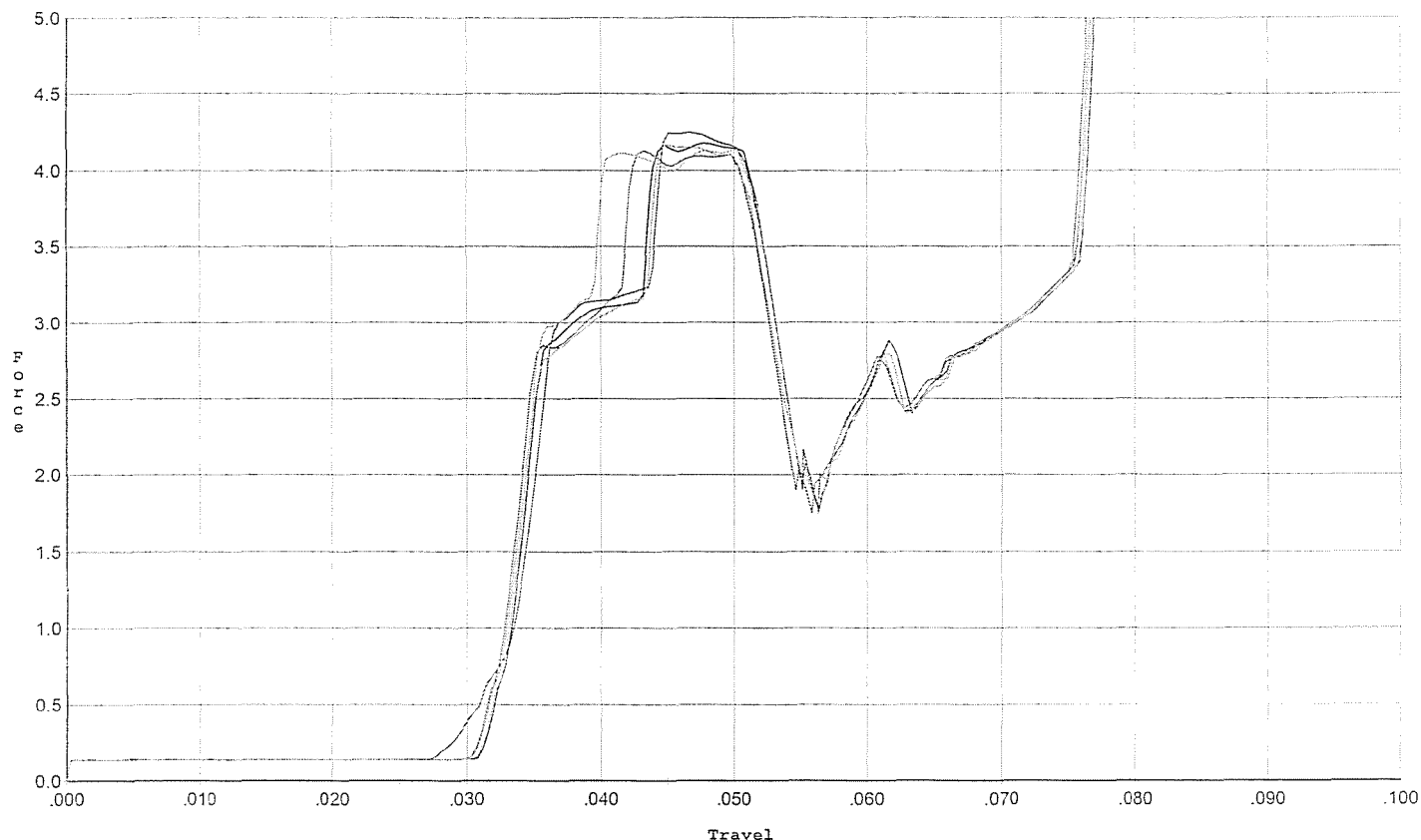
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.048	0.035	0.036	0.030		Set Trigger
2	2.364	0.047	0.036	0.037	0.027		Set Trigger
3	2.633	0.051	0.034	0.034	0.039		Set Trigger
4	2.403	0.047	0.034	0.036	0.029		Set Trigger
5	2.579	0.050	0.033	0.034	0.039		Set Trigger

Aug 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.052	0.030	0.029	0.072		Set Trigger
2	4.176	0.052	0.031	0.029	0.072		Set Trigger
3	4.129	0.051	0.031	0.029	0.072		Set Trigger
4	4.139	0.052	0.031	0.029	0.075		Set Trigger
5	4.169	0.051	0.031	0.029	0.070		Set Trigger

AUG 4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521397.___0
FILE DATE AND TIME: 08/06/2007 11:25

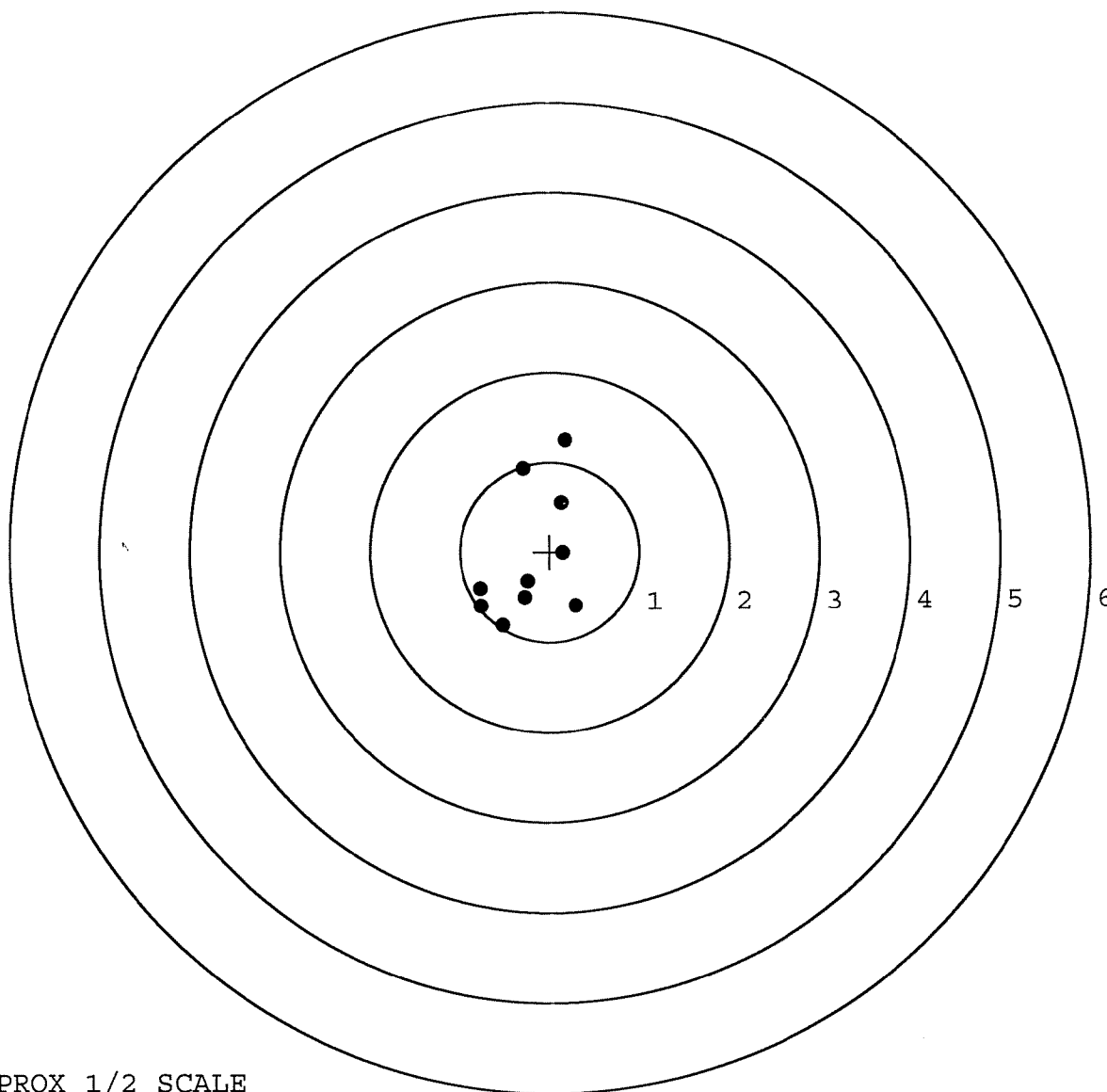
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.072
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.079
The Average Mean Radius of the Five Target Set:	0.690
The Distance from POA to Centroid Target #1:	0.224
The Distance from Centroid Target #2 to Centroid Target #1:	0.285
The Distance from Centroid Target #3 to Centroid Target #1:	0.191
The Distance from Centroid Target #4 to Centroid Target #1:	0.165
The Distance from Centroid Target #5 to Centroid Target #1:	0.302

SERIAL NUMBER: G6521397. __0
TARGET NUMBER: 1
FILE DATE: 08/06/2007
FILE TIME: 11:25

X CENTROID: -0.216
Y CENTROID: -0.057
POA TO CENTROID: 0.224
HORZ SPREAD: 1.065
VERT SPREAD: 2.063
GROUP SPREAD: 2.180
MIN RADIUS: 0.272
MAX RADIUS: 1.360
MEAN RADIUS: 0.714
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.127	0.542
2:	-0.296	0.930
3:	0.178	1.244
4:	0.289	-0.605
5:	0.145	-0.015
6:	-0.250	-0.327
7:	-0.283	-0.508
8:	-0.527	-0.819
9:	-0.768	-0.604
10:	-0.776	-0.410

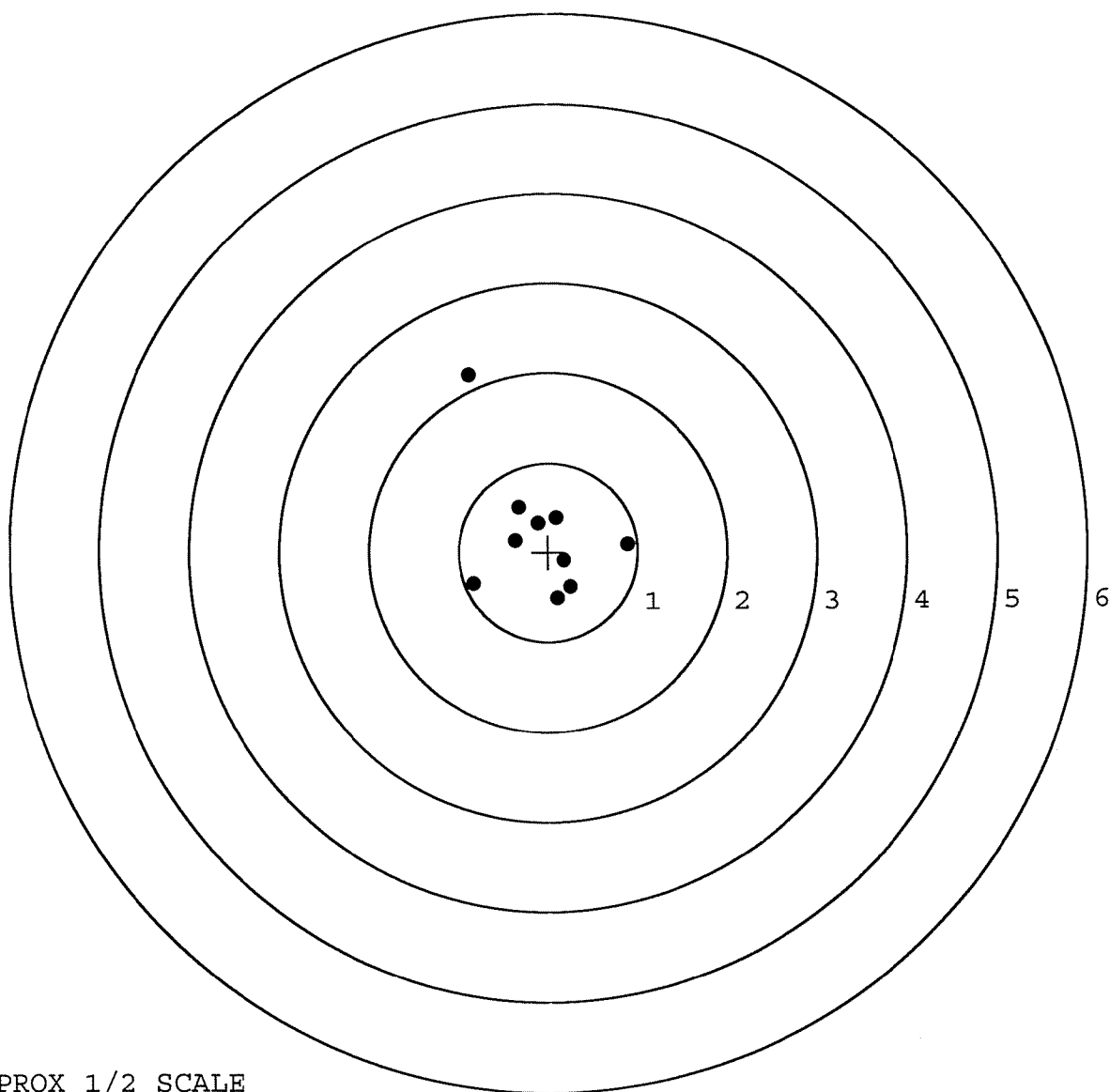


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521397. __0
TARGET NUMBER: 2
FILE DATE: 08/06/2007
FILE TIME: 11:25

X CENTROID: -0.102
Y CENTROID: 0.204
POA TO CENTROID: 0.228
HORZ SPREAD: 1.777
VERT SPREAD: 2.495
GROUP SPREAD: 2.683
MIN RADIUS: 0.121
MAX RADIUS: 1.937
MEAN RADIUS: 0.675
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.892	0.084
2:	0.250	-0.388
3:	0.103	-0.519
4:	0.176	-0.100
5:	-0.838	-0.351
6:	-0.370	0.132
7:	-0.327	0.500
8:	-0.116	0.324
9:	0.093	0.384
10:	-0.885	1.976

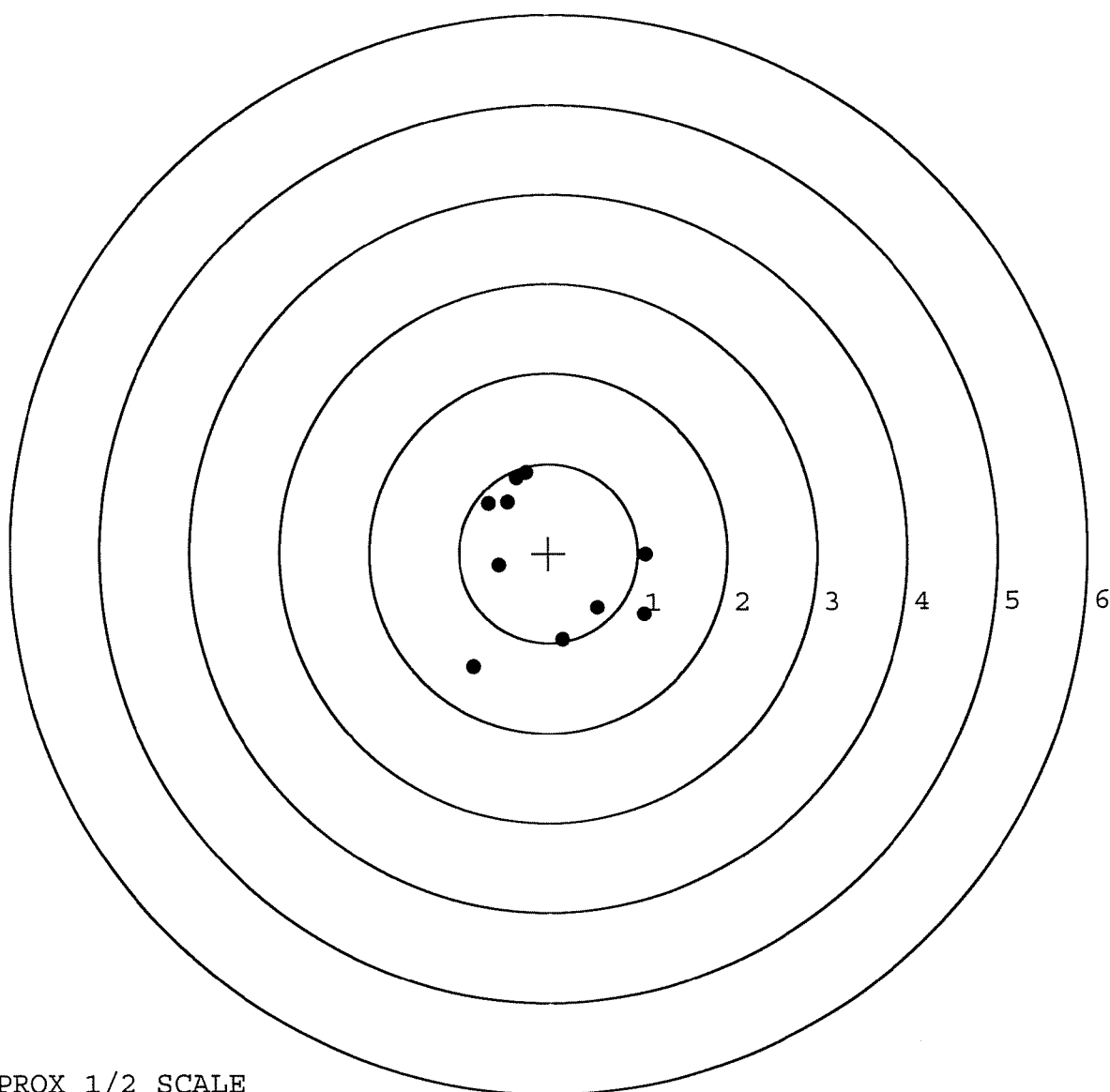


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521397. 0
TARGET NUMBER: 3
FILE DATE: 08/06/2007
FILE TIME: 11:25

X CENTROID: -0.027
Y CENTROID: -0.084
POA TO CENTROID: 0.088
HORZ SPREAD: 1.924
VERT SPREAD: 2.177
GROUP SPREAD: 2.292
MIN RADIUS: 0.534
MAX RADIUS: 1.440
MEAN RADIUS: 0.972
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.082	-0.025
2:	1.071	-0.693
3:	0.551	-0.616
4:	0.154	-0.971
5:	-0.842	-1.271
6:	-0.559	-0.134
7:	-0.667	0.554
8:	-0.459	0.569
9:	-0.354	0.843
10:	-0.250	0.906

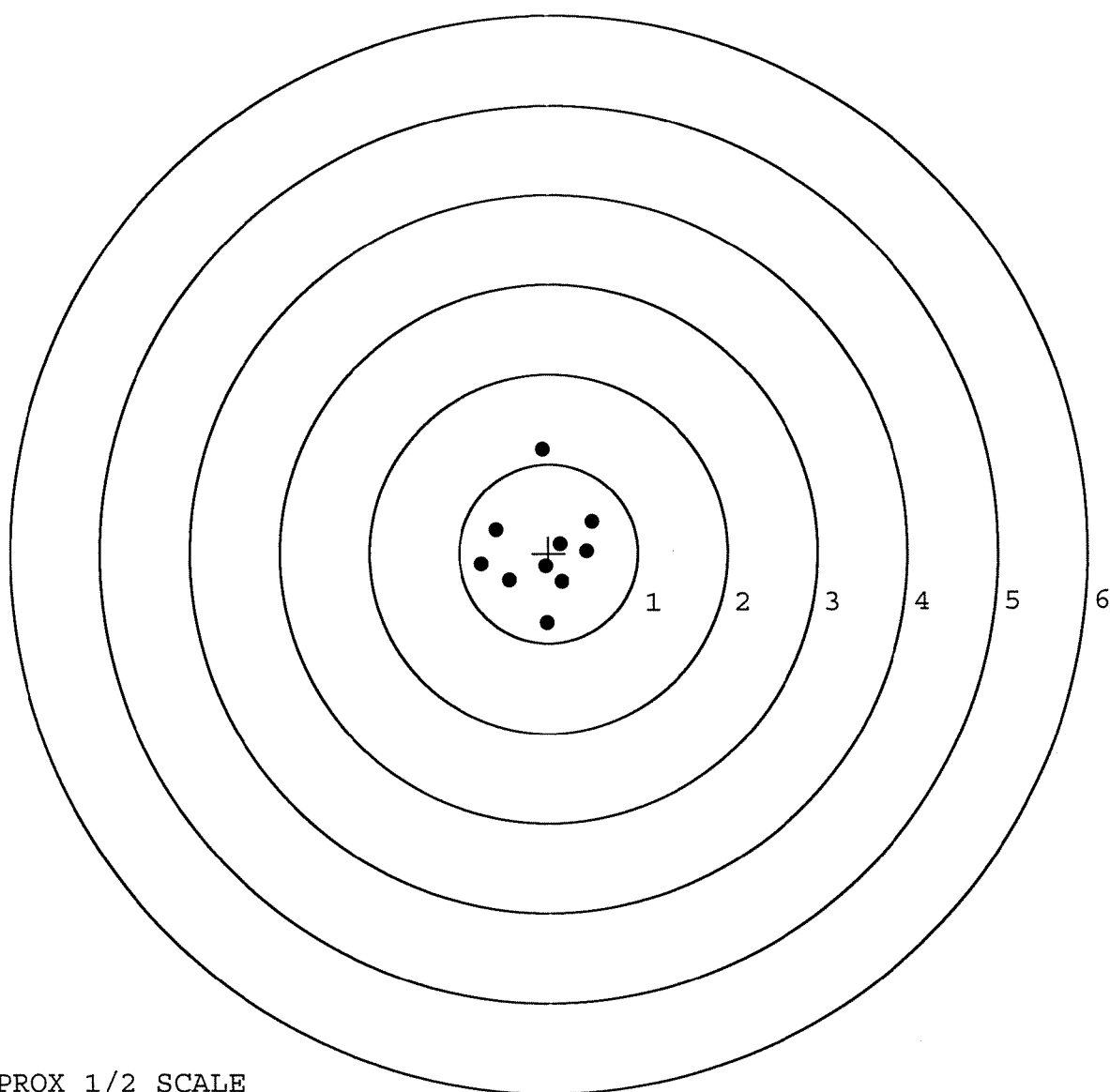


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521397. __0
 TARGET NUMBER: 4
 FILE DATE: 08/06/2007
 FILE TIME: 11:25

X CENTROID: -0.071
 Y CENTROID: 0.022
 POA TO CENTROID: 0.075
 HORZ SPREAD: 1.247
 VERT SPREAD: 1.947
 GROUP SPREAD: 1.948
 MIN RADIUS: 0.176
 MAX RADIUS: 1.143
 MEAN RADIUS: 0.567
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.021	-0.782
2:	0.148	-0.322
3:	0.431	0.025
4:	0.493	0.347
5:	0.128	0.106
6:	-0.039	-0.151
7:	-0.441	-0.303
8:	-0.754	-0.124
9:	-0.592	0.261
10:	-0.067	1.165

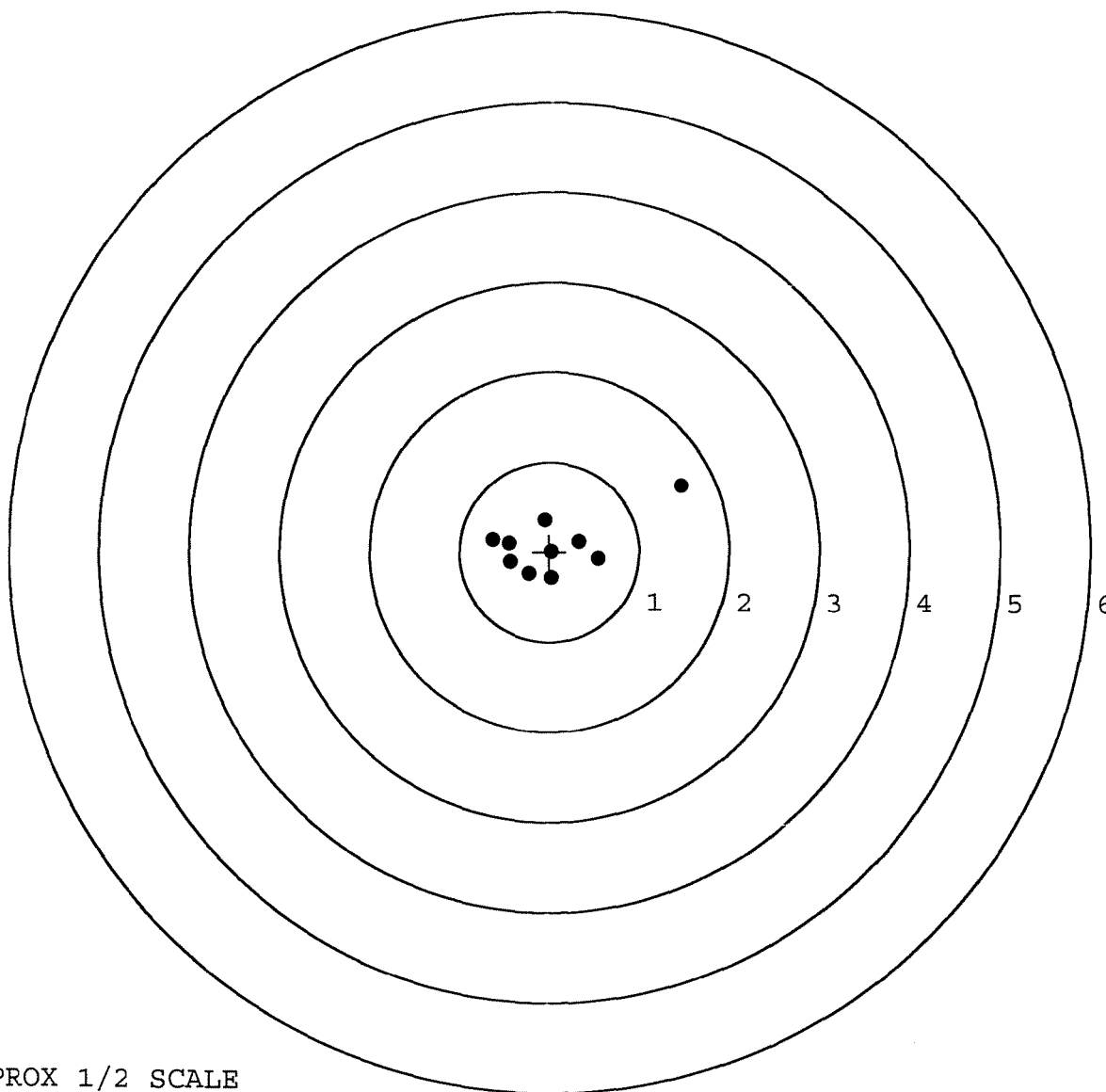


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521397.___0
TARGET NUMBER: 5
FILE DATE: 08/06/2007
FILE TIME: 11:25

X CENTROID: 0.057
Y CENTROID: 0.072
POA TO CENTROID: 0.091
HORZ SPREAD: 2.098
VERT SPREAD: 1.032
GROUP SPREAD: 2.187
MIN RADIUS: 0.076
MAX RADIUS: 1.556
MEAN RADIUS: 0.525
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.459	0.745
2:	-0.056	0.352
3:	0.332	0.119
4:	0.548	-0.076
5:	0.021	-0.287
6:	-0.230	-0.241
7:	-0.434	-0.116
8:	-0.639	0.127
9:	-0.456	0.089
10:	0.021	0.004



TARGET APPROX 1/2 SCALE