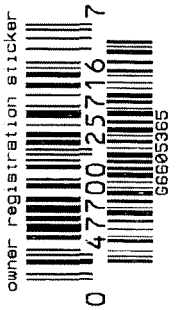
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

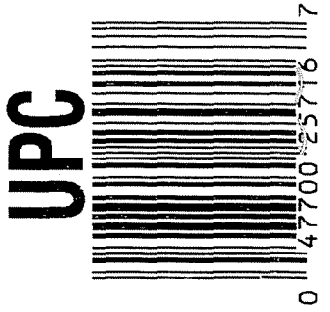
– INSTUCTION BOOK 3518



DD FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6605365



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC

SERIAL NO.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C-66053365

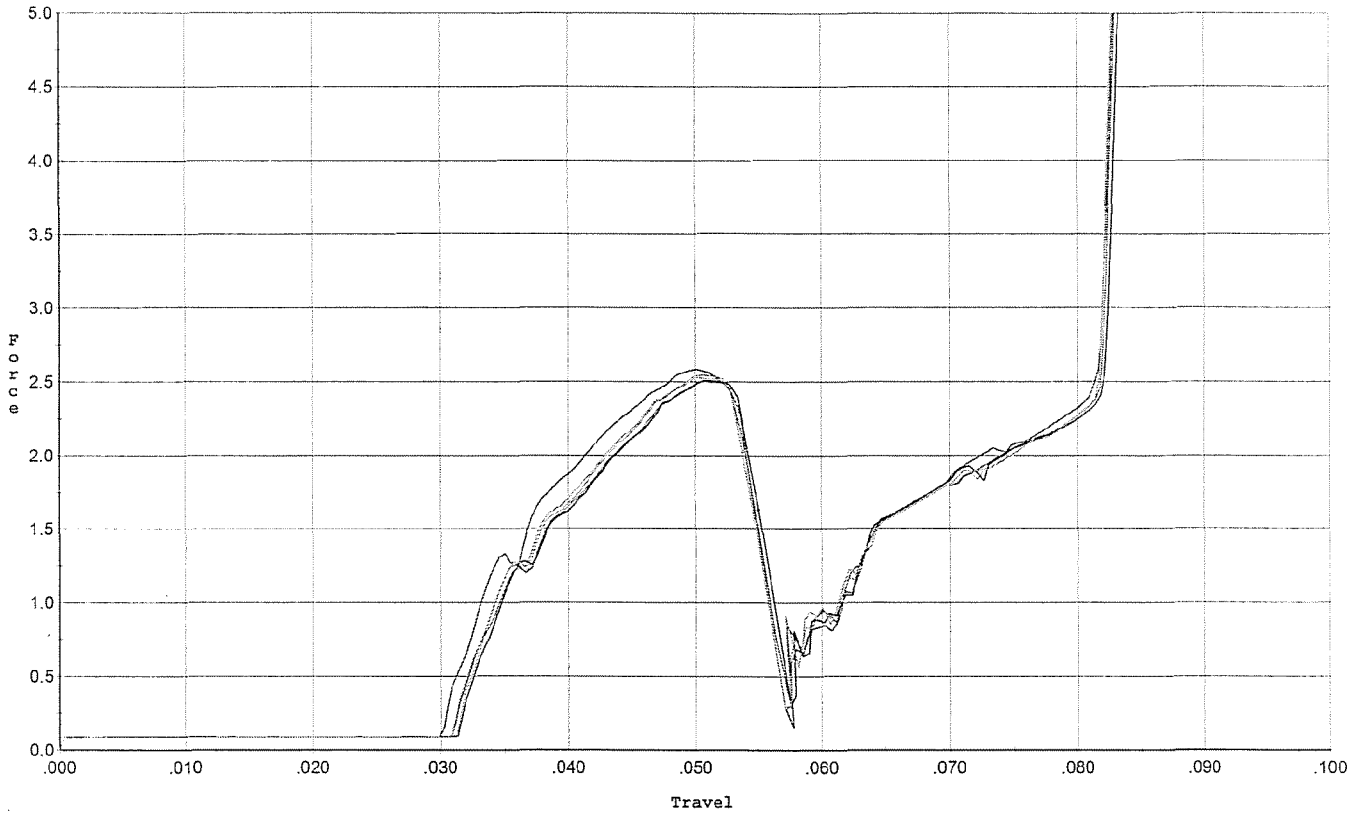
OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	BLC
420	ASSEMBLE ACTION		10-6-06	RTC
430	ASSEMBLE TO STOCK		10-6-06	WR
440	PROOF		10-6-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-6-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 10 2006	10-6-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR APD	10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-9-06	CW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-10-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION) (BOLT)		10/12	HP
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-19-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-19-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-19-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-1-06	RTC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	4# 4# 4#	11-1-06	SD
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	7# 6# 6#	11-1-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.024 .025 .024	11-1-06	SD
	J) ASSEMBLE STOCK		11-1-06	RTR
	K) ASSEMBLE SWIVEL STUDS		11-15-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-1-06	RTR
	M) IRON SIGHT ALIGNMENT		11-1-06	RTR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-1-06	RTR
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	11-2-06	TRW
	MALFUNCTION CH over live rds.	CORRECTION OK	11-7-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/2/06	WR
670	FINAL INSPECTION A) HEADSPACE		11-15-06	L.P.D.
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.48 2.64 2.44 2.53 2.38	11-13-06	SD
	C) FUNCTION		11-15-06	L.P.D.
690	PACK		11/17/06	QA

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 ini.
Note:	R. Putch 10/18/06		



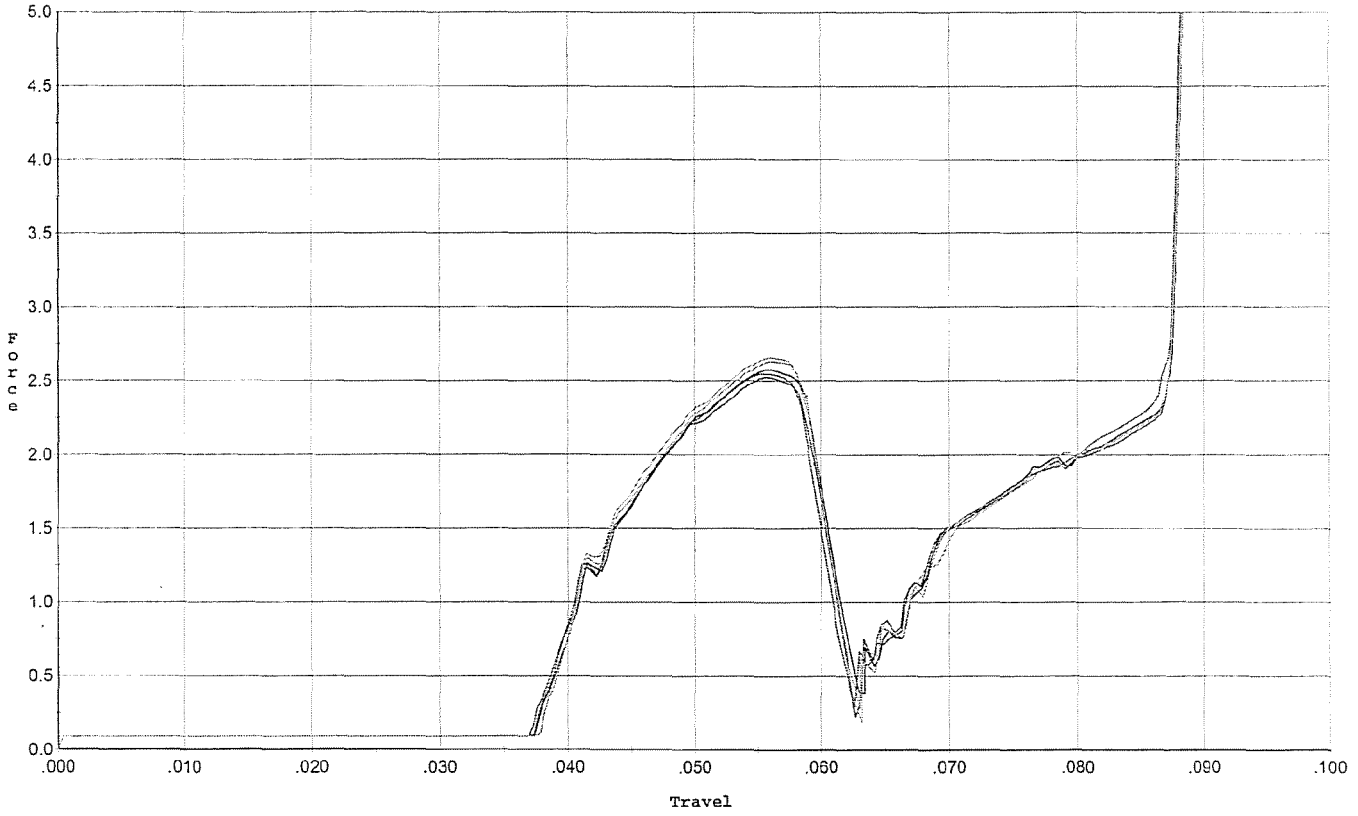
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.584	0.054	0.030	0.034	0.048		Set Trigger
2	2.508	0.055	0.032	0.034	0.045		Set Trigger
3	2.504	0.054	0.031	0.034	0.044		Set Trigger
4	2.530	0.054	0.031	0.034	0.045		Set Trigger
5	2.547	0.054	0.032	0.034	0.045		Set Trigger

AVG 2.53

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.: 10/18/2006 9:41:43 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 after 50 cycles
Note:	R. Putch 10/18/06		

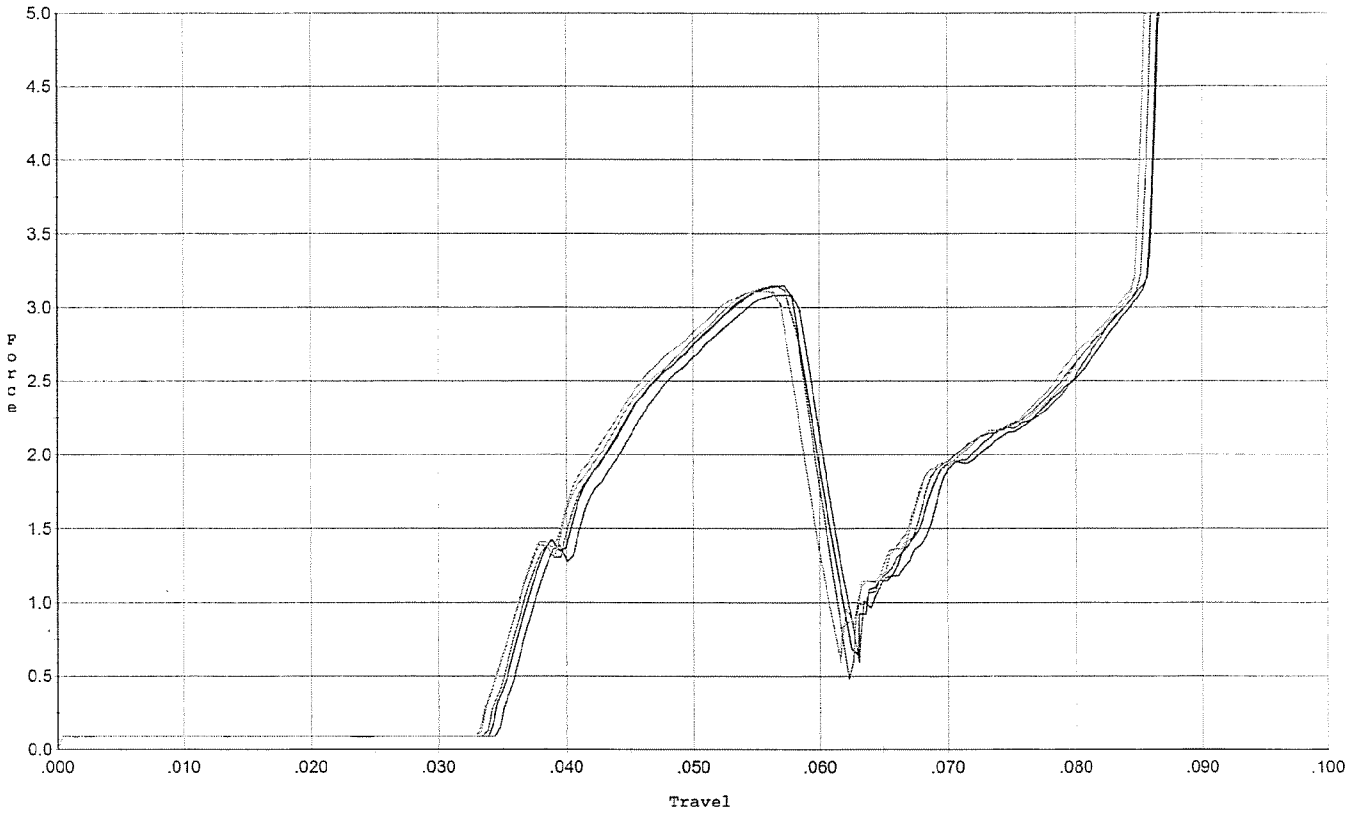


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.060	0.037	0.035	0.045		Set Trigger
2	2.577	0.059	0.038	0.035	0.045		Set Trigger
3	2.546	0.058	0.038	0.036	0.044		Set Trigger
4	2.655	0.059	0.038	0.035	0.046		Set Trigger
5	2.631	0.059	0.038	0.035	0.045		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 ini.
Note:	R. Putch 10/18/06		



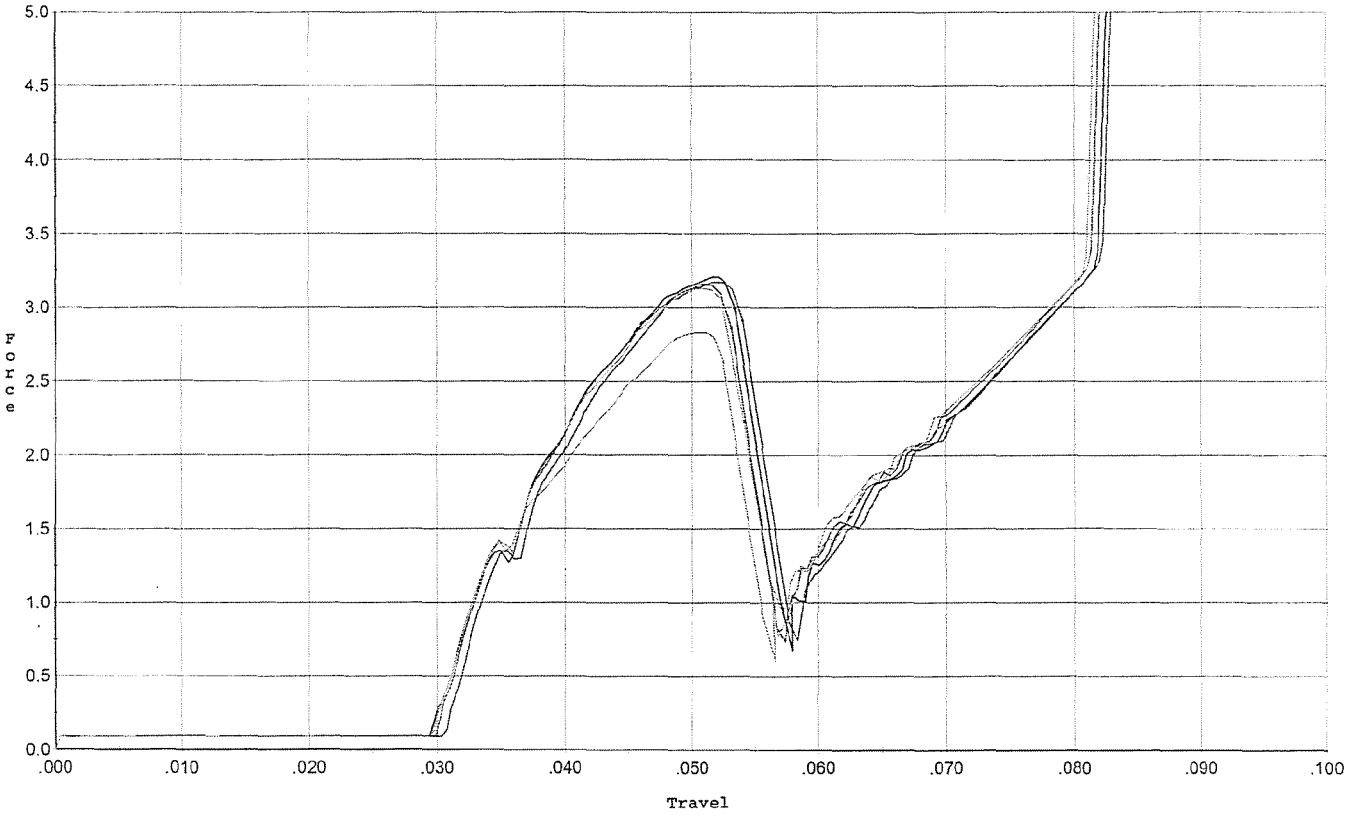
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.084	0.058	0.035	0.033	0.057		Set Trigger
2	3.147	0.058	0.034	0.034	0.058		Set Trigger
3	3.145	0.058	0.034	0.033	0.058		Set Trigger
4	3.108	0.057	0.033	0.033	0.057		Set Trigger
5	3.139	0.057	0.034	0.034	0.056		Set Trigger

AVG 3.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/18/2006 9:49:24 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 after 20 cycles
Note:	R. Putch 10/18/06		



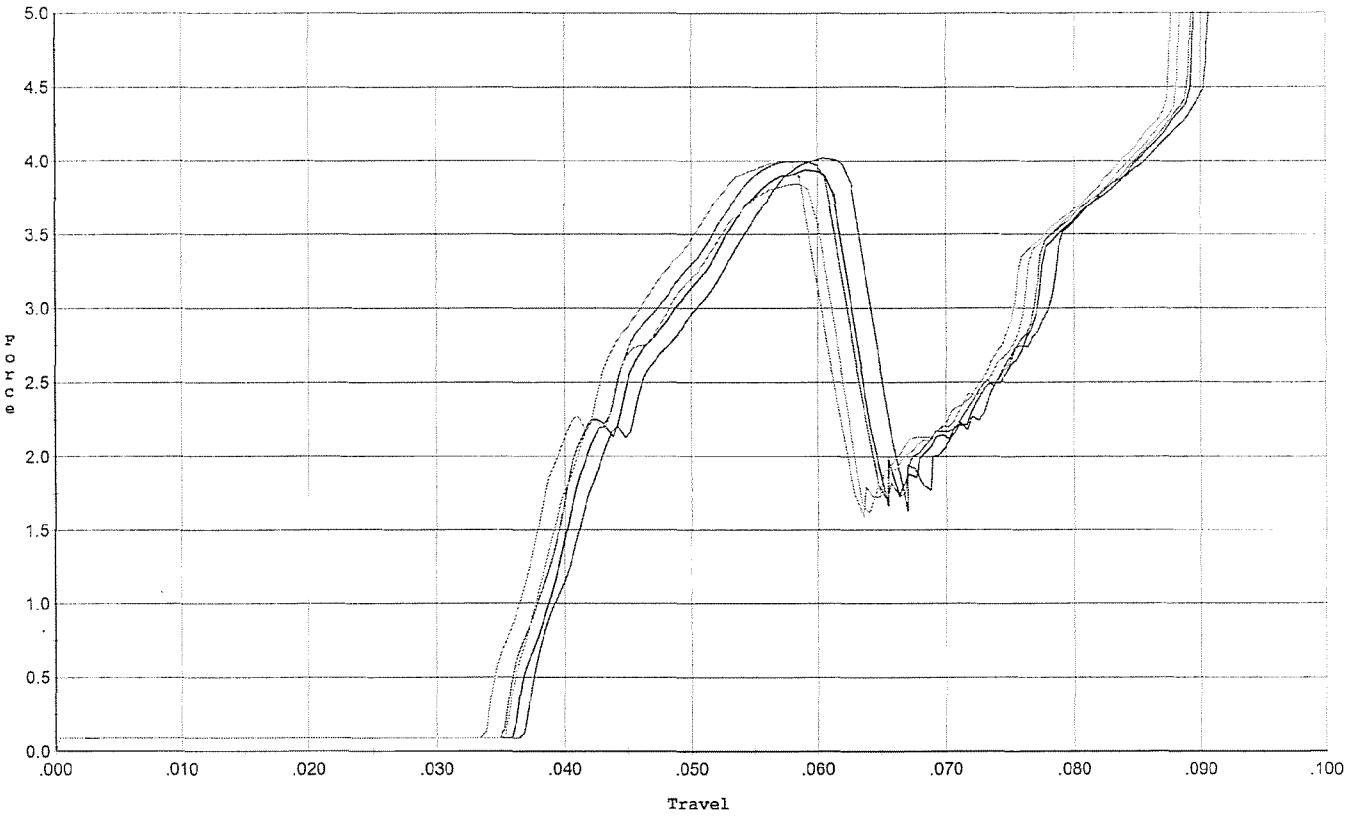
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.169	0.054	0.031	0.033	0.056		Set Trigger
2	3.204	0.053	0.030	0.033	0.057		Set Trigger
3	3.156	0.053	0.030	0.033	0.055		Set Trigger
4	3.128	0.054	0.030	0.033	0.056		Set Trigger
5	2.829	0.052	0.030	0.033	0.049		Set Trigger

AVG 3.09

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/18/2006 9:58:32 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 ini.
Note:	R. Putch 10/18/06		



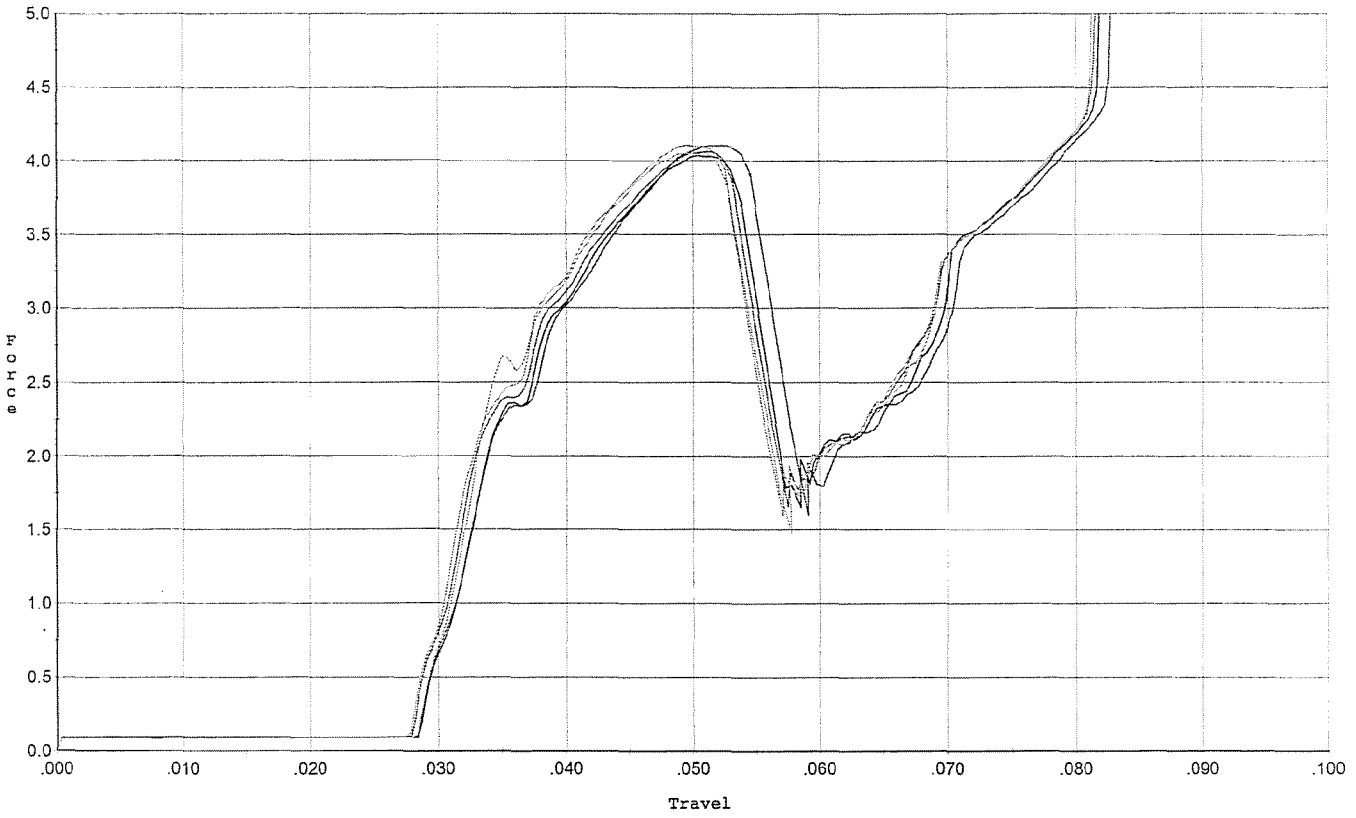
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.021	0.063	0.037	0.032	0.079		Set Trigger
2	3.939	0.061	0.036	0.032	0.077		Set Trigger
3	3.996	0.061	0.035	0.032	0.079		Set Trigger
4	3.843	0.060	0.036	0.032	0.074		Set Trigger
5	4.000	0.059	0.034	0.033	0.076		Set Trigger

AVG 3.96

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/18/2006 10:01:49 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 after 20 cycles
Note:	R. Putch 10/18/06		

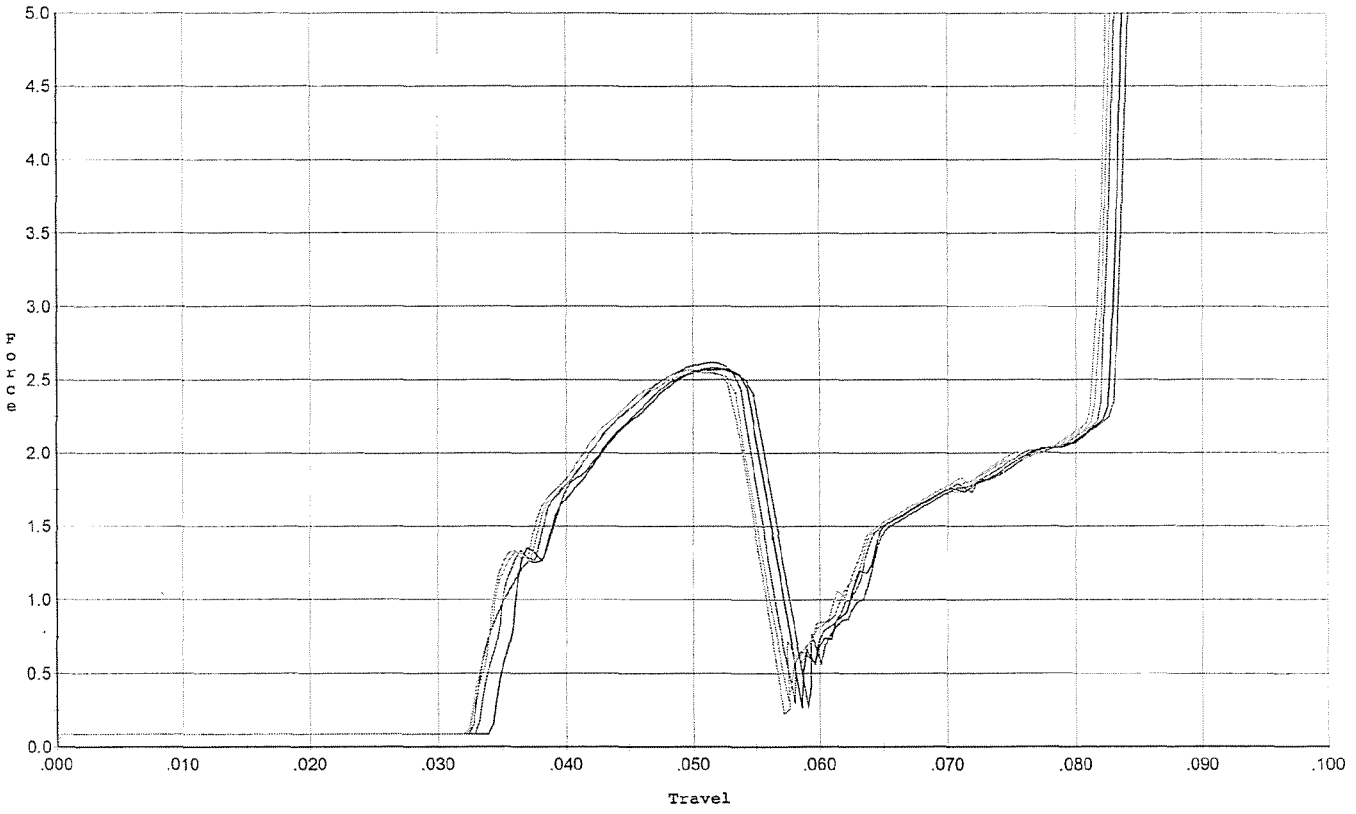


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.055	0.029	0.031	0.082		Set Trigger
2	4.035	0.054	0.029	0.031	0.078		Set Trigger
3	4.061	0.053	0.028	0.031	0.079		Set Trigger
4	4.102	0.052	0.029	0.031	0.078		Set Trigger
5	4.060	0.053	0.028	0.031	0.078		Set Trigger

AVG 4.07

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5
Note:	R. Putch 10/18/06		



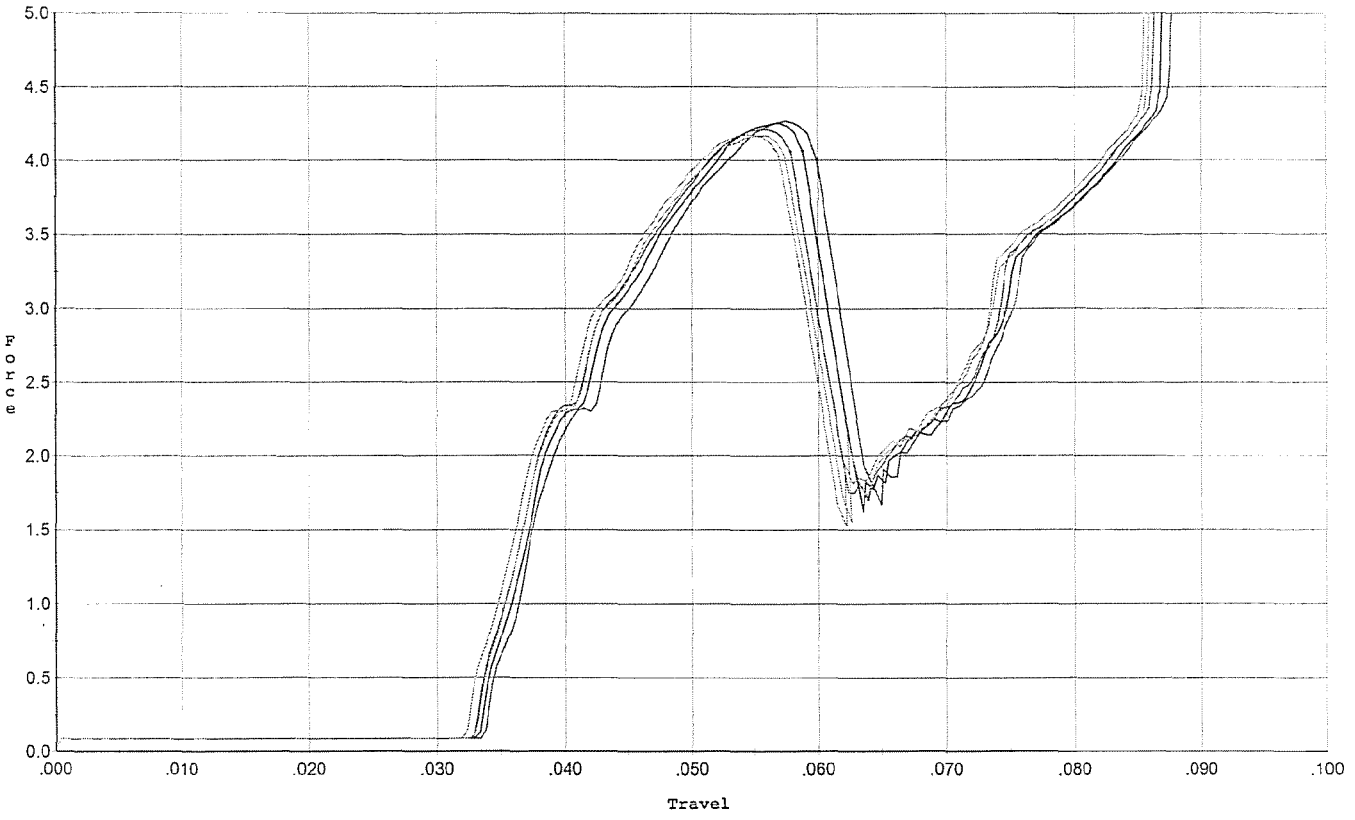
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.581	0.055	0.033	0.034	0.047		Set Trigger
2	2.572	0.056	0.034	0.035	0.046		Set Trigger
3	2.616	0.054	0.033	0.034	0.046		Set Trigger
4	2.553	0.053	0.033	0.034	0.045		Set Trigger
5	2.569	0.054	0.033	0.034	0.046		Set Trigger

AVG 2.57

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/18/2006 10:08:28 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 for target & accuracy
Note:	R. Putch 10/18/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.267	0.060	0.034	0.031	0.085		Set Trigger
2	4.250	0.059	0.034	0.031	0.084		Set Trigger
3	4.209	0.058	0.033	0.032	0.082		Set Trigger
4	4.166	0.059	0.033	0.031	0.083		Set Trigger
5	4.169	0.058	0.033	0.032	0.083		Set Trigger

AVG 4.21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605365.__0
FILE DATE AND TIME: 11/03/2006 05:35

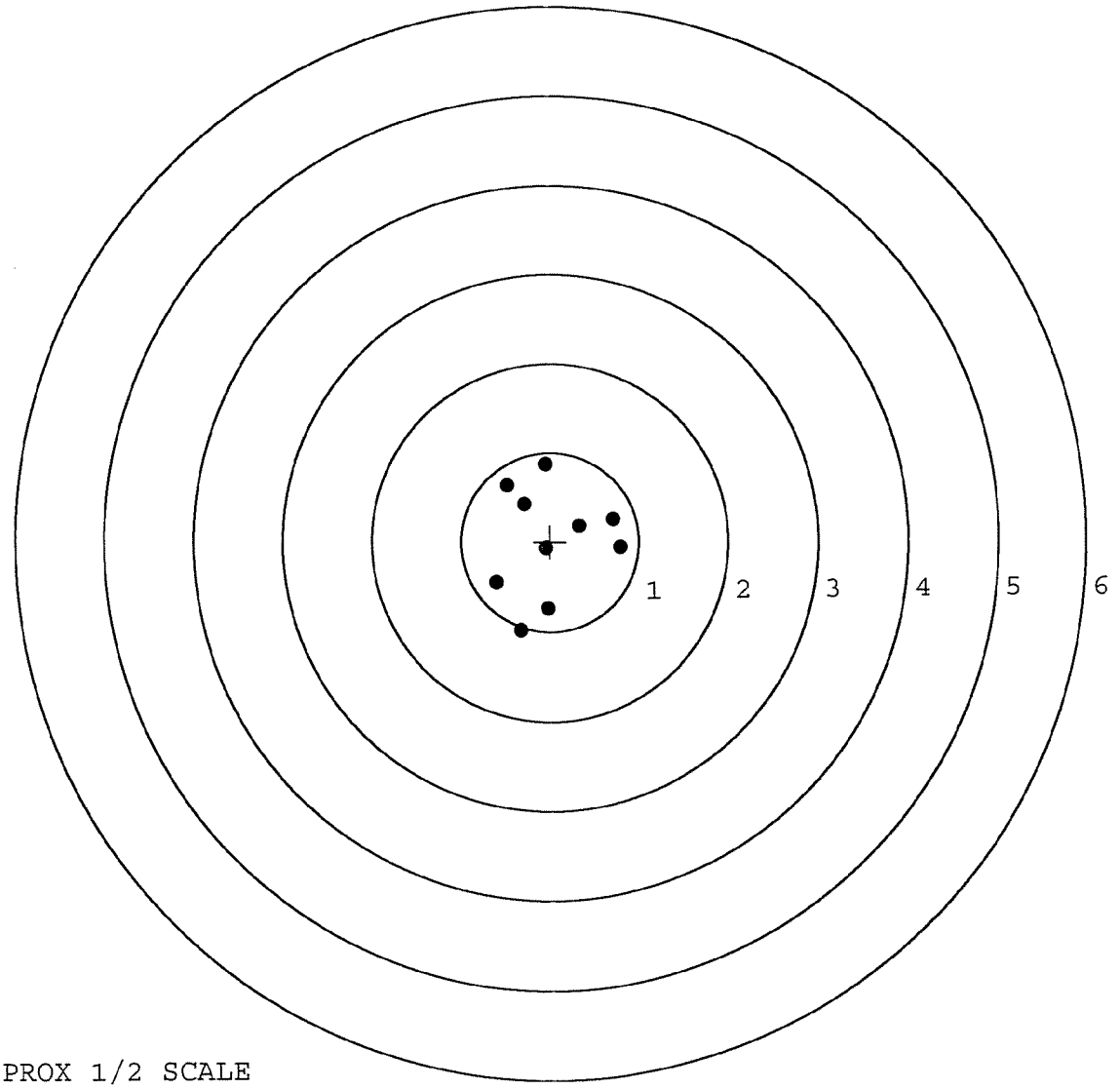
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.051
The Average Y Centroid of the Five Target Set:	0.038
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.758
The Distance from POA to Centroid Target #1:	0.003
The Distance from Centroid Target #2 to Centroid Target #1:	0.106
The Distance from Centroid Target #3 to Centroid Target #1:	0.136
The Distance from Centroid Target #4 to Centroid Target #1:	0.146
The Distance from Centroid Target #5 to Centroid Target #1:	0.151

SERIAL NUMBER: G6605365.__0
TARGET NUMBER: 1
FILE DATE: 11/03/2006
FILE TIME: 05:35

X CENTROID:	-0.003
Y CENTROID:	0.001
POA TO CENTROID:	0.003
HORZ SPREAD:	1.405
VERT SPREAD:	1.861
GROUP SPREAD:	1.883
MIN RADIUS:	0.092
MAX RADIUS:	1.048
MEAN RADIUS:	0.676
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.613	-0.457
2:	-0.338	-0.992
3:	-0.030	-0.752
4:	-0.053	-0.076
5:	0.792	-0.067
6:	0.713	0.249
7:	0.327	0.179
8:	-0.291	0.422
9:	-0.485	0.638
10:	-0.053	0.869

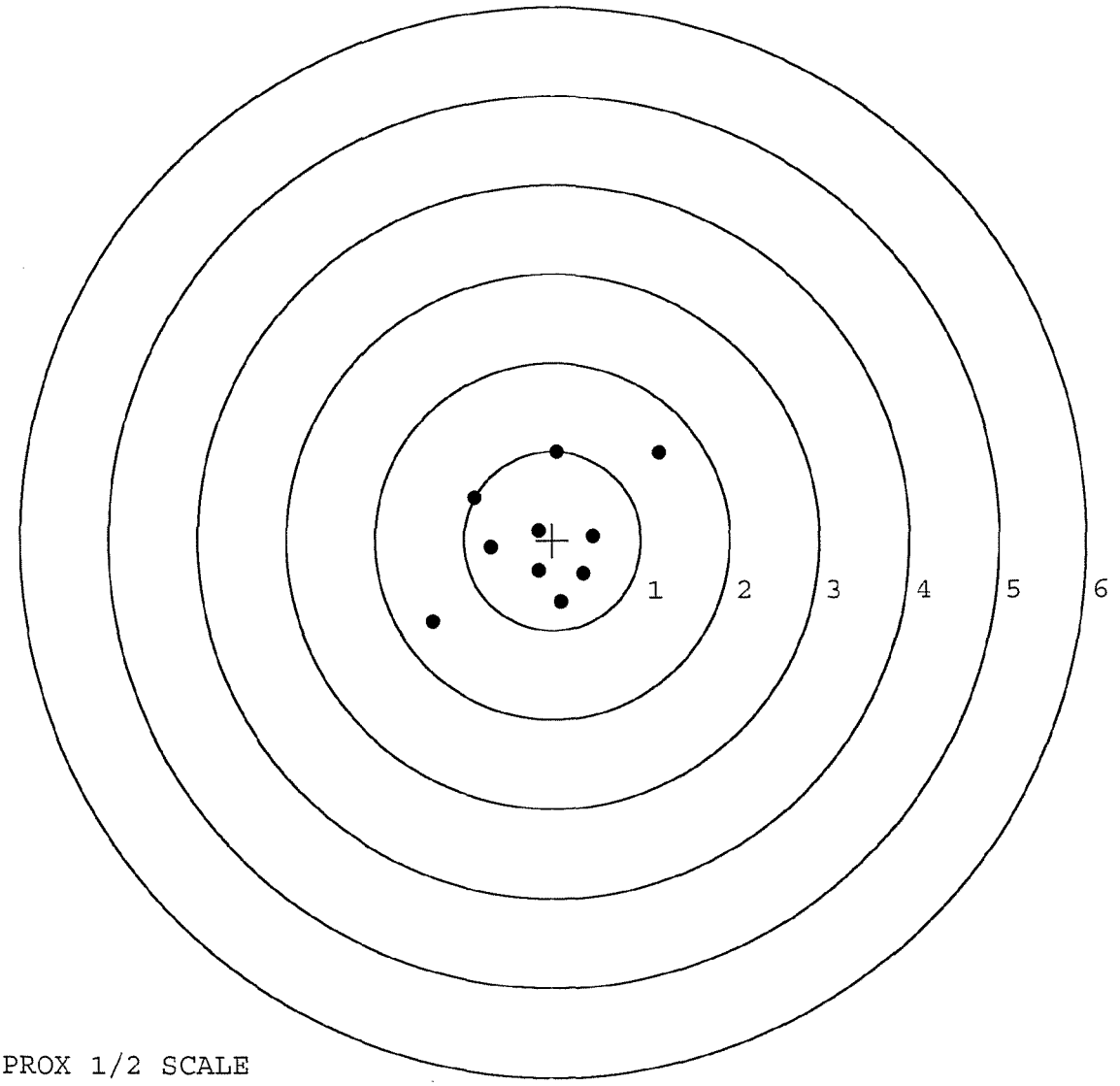


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605365.__0
TARGET NUMBER: 2
FILE DATE: 11/03/2006
FILE TIME: 05:35

X CENTROID:	-0.108
Y CENTROID:	0.020
POA TO CENTROID:	0.110
HORZ SPREAD:	2.556
VERT SPREAD:	1.909
GROUP SPREAD:	3.185
MIN RADIUS:	0.095
MAX RADIUS:	1.631
MEAN RADIUS:	0.804
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-1.347	-0.918
2:	0.095	-0.688
3:	0.350	-0.369
4:	-0.157	-0.345
5:	0.461	0.048
6:	-0.156	0.102
7:	-0.699	-0.083
8:	-0.886	0.476
9:	0.050	0.991
10:	1.209	0.982

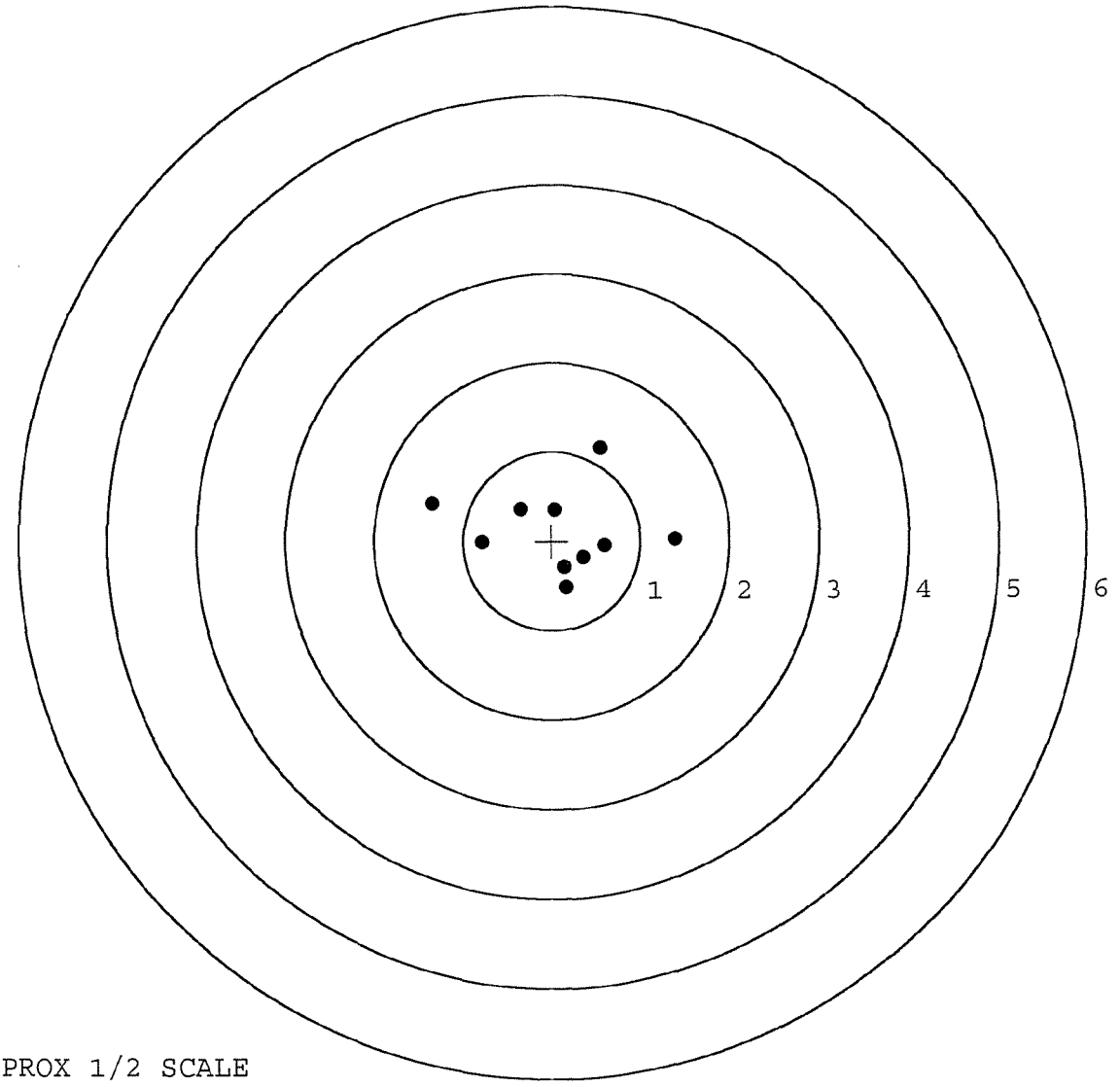


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605365.__0
TARGET NUMBER: 3
FILE DATE: 11/03/2006
FILE TIME: 05:35

X CENTROID:	0.074
Y CENTROID:	0.113
POA TO CENTROID:	0.135
HORZ SPREAD:	2.742
VERT SPREAD:	1.569
GROUP SPREAD:	2.770
MIN RADIUS:	0.244
MAX RADIUS:	1.457
MEAN RADIUS:	0.745
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.550	1.044
2:	1.391	0.026
3:	-1.351	0.418
4:	-0.785	-0.020
5:	-0.359	0.359
6:	0.033	0.353
7:	0.166	-0.525
8:	0.597	-0.048
9:	0.356	-0.184
10:	0.141	-0.294

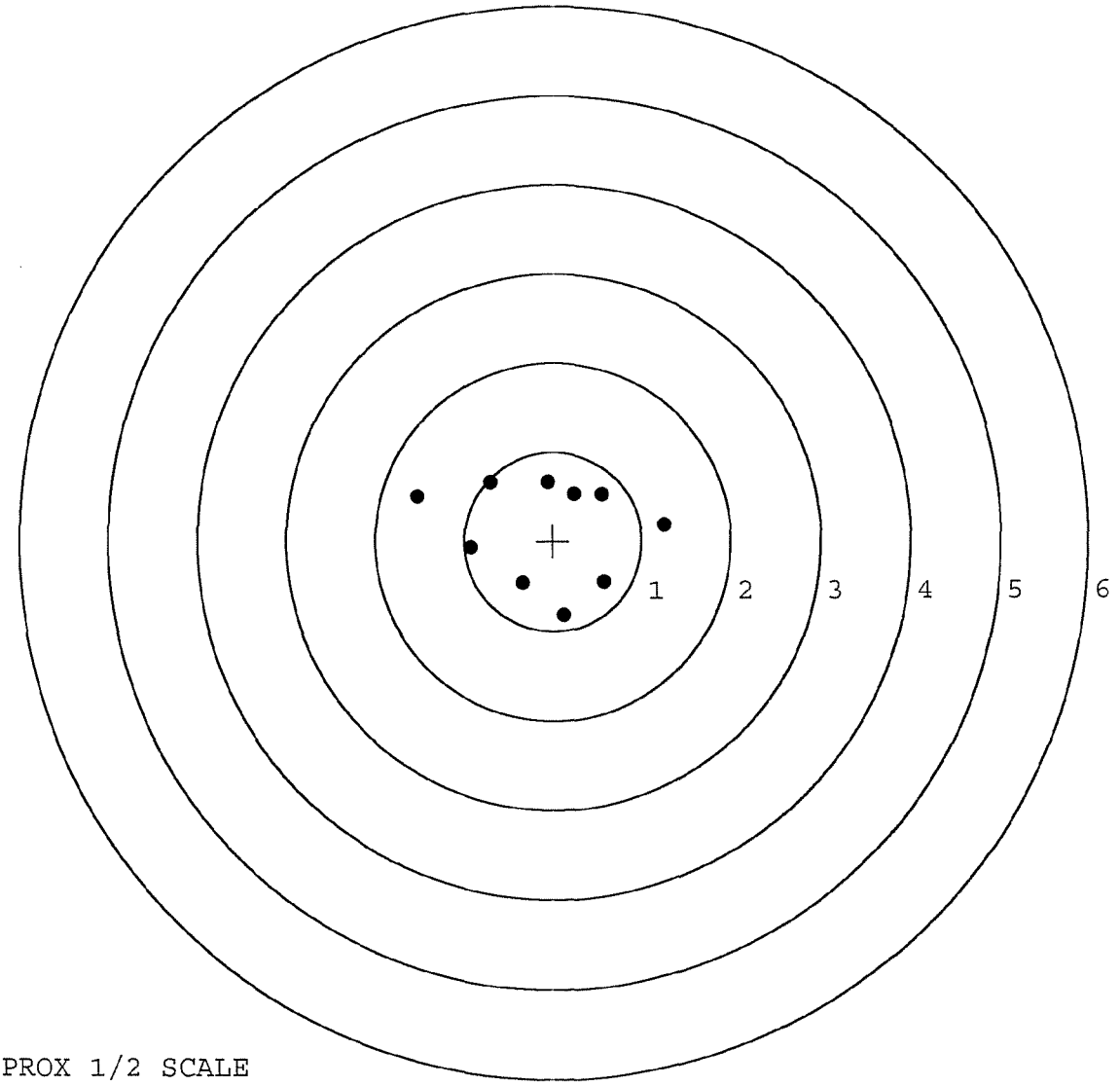


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605365.__0
TARGET NUMBER: 4
FILE DATE: 11/03/2006
FILE TIME: 05:35

X CENTROID:	-0.082
Y CENTROID:	0.124
POA TO CENTROID:	0.149
HORZ SPREAD:	2.781
VERT SPREAD:	1.493
GROUP SPREAD:	2.798
MIN RADIUS:	0.526
MAX RADIUS:	1.493
MEAN RADIUS:	0.884
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.253	0.183
2:	0.577	-0.454
3:	0.126	-0.828
4:	-0.343	-0.475
5:	-0.920	-0.075
6:	-1.528	0.494
7:	-0.712	0.661
8:	-0.064	0.665
9:	0.240	0.540
10:	0.550	0.528

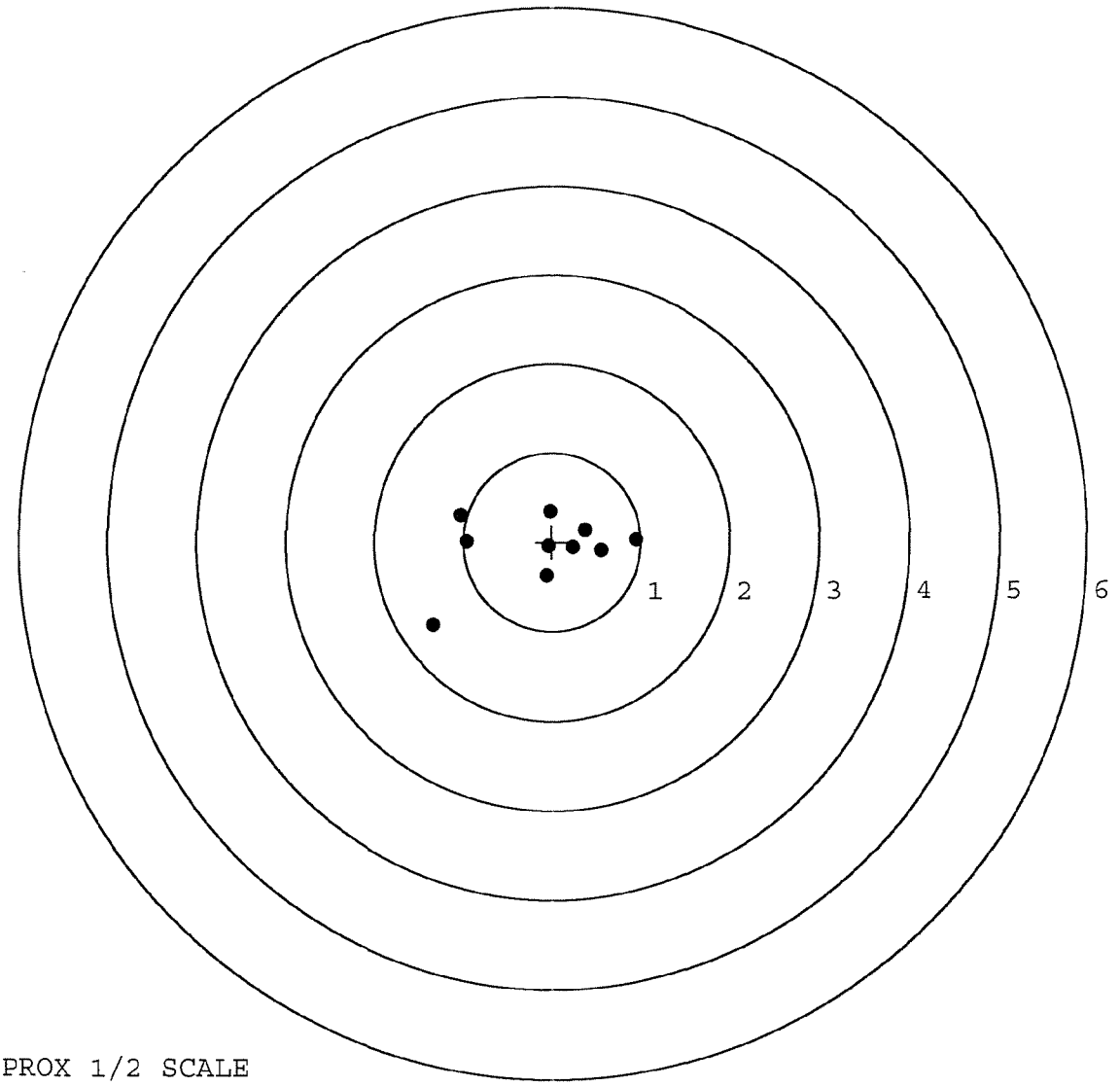


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605365.__0
TARGET NUMBER: 5
FILE DATE: 11/03/2006
FILE TIME: 05:35

X CENTROID:	-0.136
Y CENTROID:	-0.070
POA TO CENTROID:	0.153
HORZ SPREAD:	2.289
VERT SPREAD:	1.277
GROUP SPREAD:	2.486
MIN RADIUS:	0.092
MAX RADIUS:	1.480
MEAN RADIUS:	0.682
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.336	-0.936
2:	-0.965	0.012
3:	-1.028	0.306
4:	-0.032	0.341
5:	0.953	0.033
6:	0.555	-0.097
7:	0.369	0.139
8:	-0.062	-0.383
9:	-0.046	-0.052
10:	0.235	-0.064



TARGET APPROX 1/2 SCALE