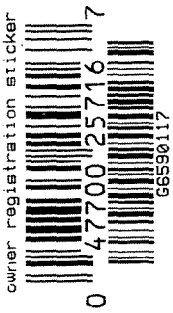
G659 0117

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

– INSTUCTION BOOK 3518

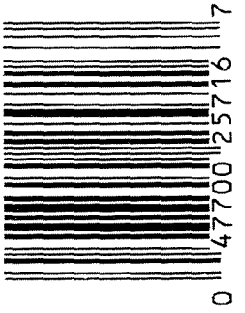
DD FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6590117



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC

SERIAL NO.

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 65 90 117

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-17-06	ETL
420	ASSEMBLE ACTION		10-17-06	ETL
430	ASSEMBLE TO STOCK		10-17-06	L.P.D.
440	PROOF		10-17-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-17-06	L.P.D.
470	DIS-ASSEMBLE ACTION	OCT 19 2006	10-18-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR GPD	10-19-06	GPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-2006	CW
510	DRILL AND TAP SIGHT HOLES		10.18.06	TRW
520	GOFF BLAST BBL / REC		10-23-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/27/06	TB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11/7/06	mdm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/17/06	mdm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/17/06	mdm
	D) OIL FIRING PIN ASSEMBLY		11-30-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12/22/06	mdm

F004 REV 5/2006

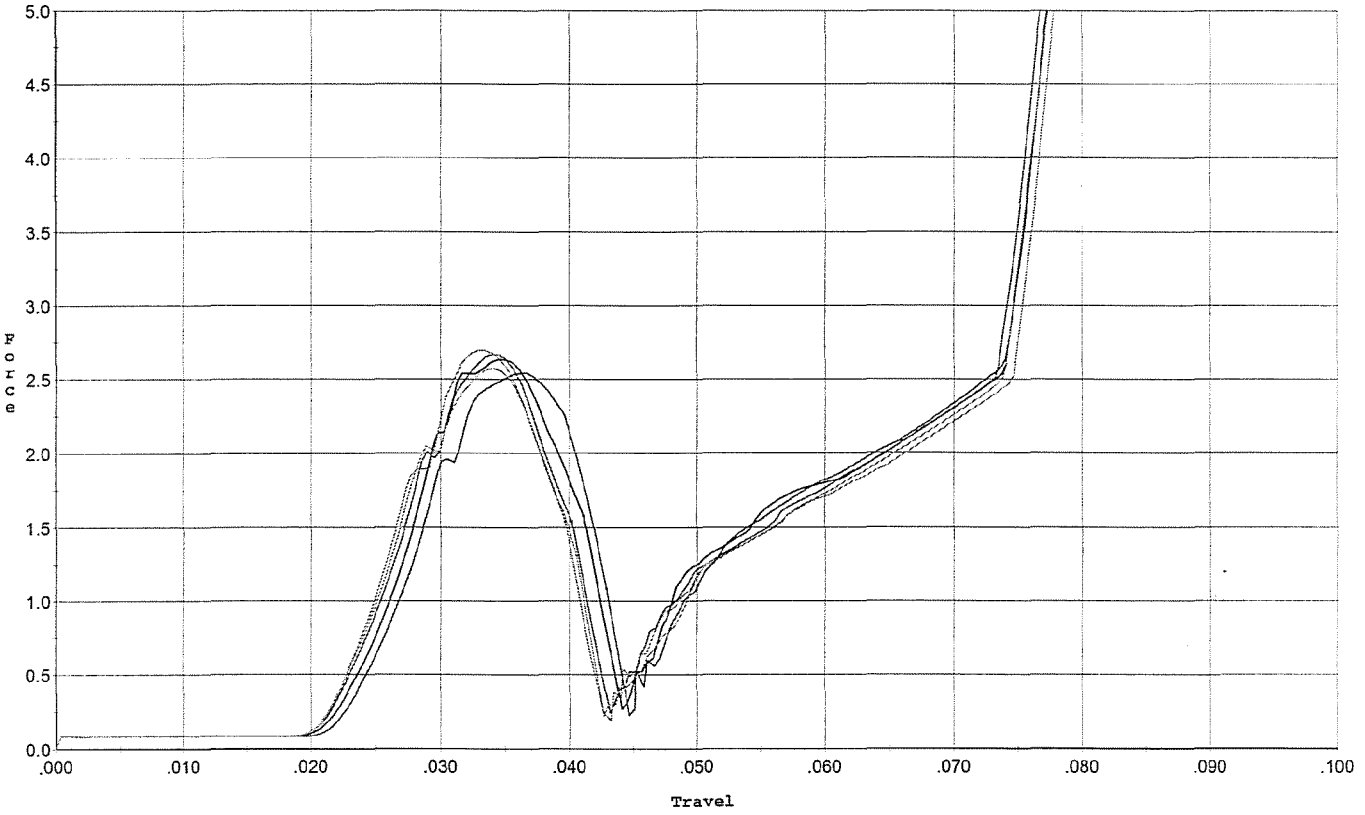
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5# 4# 5#	121306	SD
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	7# 7# 7#	121306	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		12/22/06	MDM
	I) FIRING PIN INDENT [.020 MIN]	.025 .024 .025	121306	SD
	J) ASSEMBLE STOCK		11-30-06	BLC
	K) ASSEMBLE SWIVEL STUDS		12/22/06	MDM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/22/06	MDM
	M) IRON SIGHT ALIGNMENT		12/22/06	MDM
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/22/06	MDM
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL / (PASS) FAIL	12-4-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-4-06	RP
670	FINAL INSPECTION A) HEADSPACE		12/22/06	MDM
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.40 2.22 2.43 2.30 2.04	12-12-06	BLC
	C) FUNCTION		12/22/06	MDM
690	PACK		12507	

N/A

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:	M. Mckinney 11/16/06		

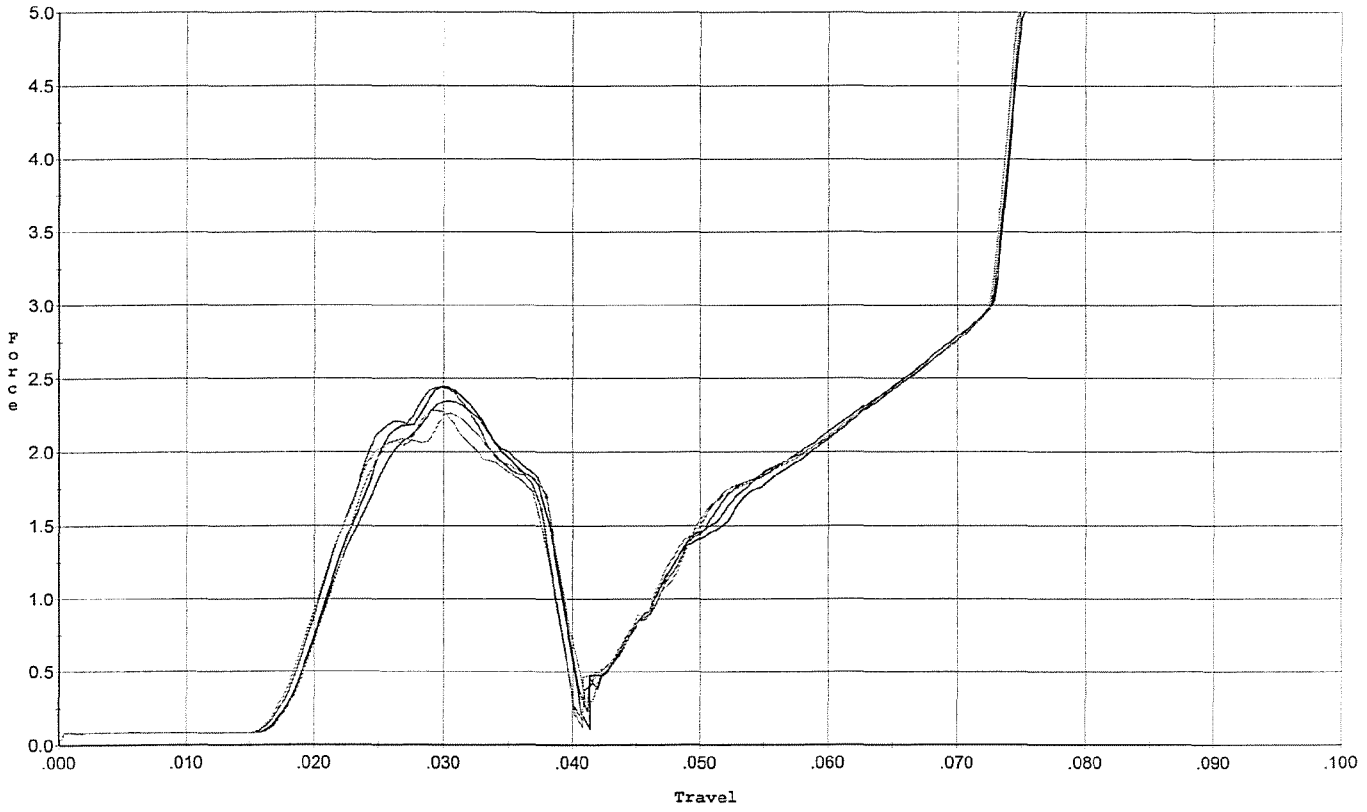


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.544	0.043	0.023	0.040	0.037		Set Trigger
2	2.634	0.041	0.023	0.043	0.037		Set Trigger
3	2.668	0.040	0.022	0.044	0.035		Set Trigger
4	2.572	0.041	0.022	0.045	0.035		Set Trigger
5	2.697	0.040	0.021	0.046	0.035		Set Trigger

2.62 Avg.

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:	M. Mckinney 11/16/06		



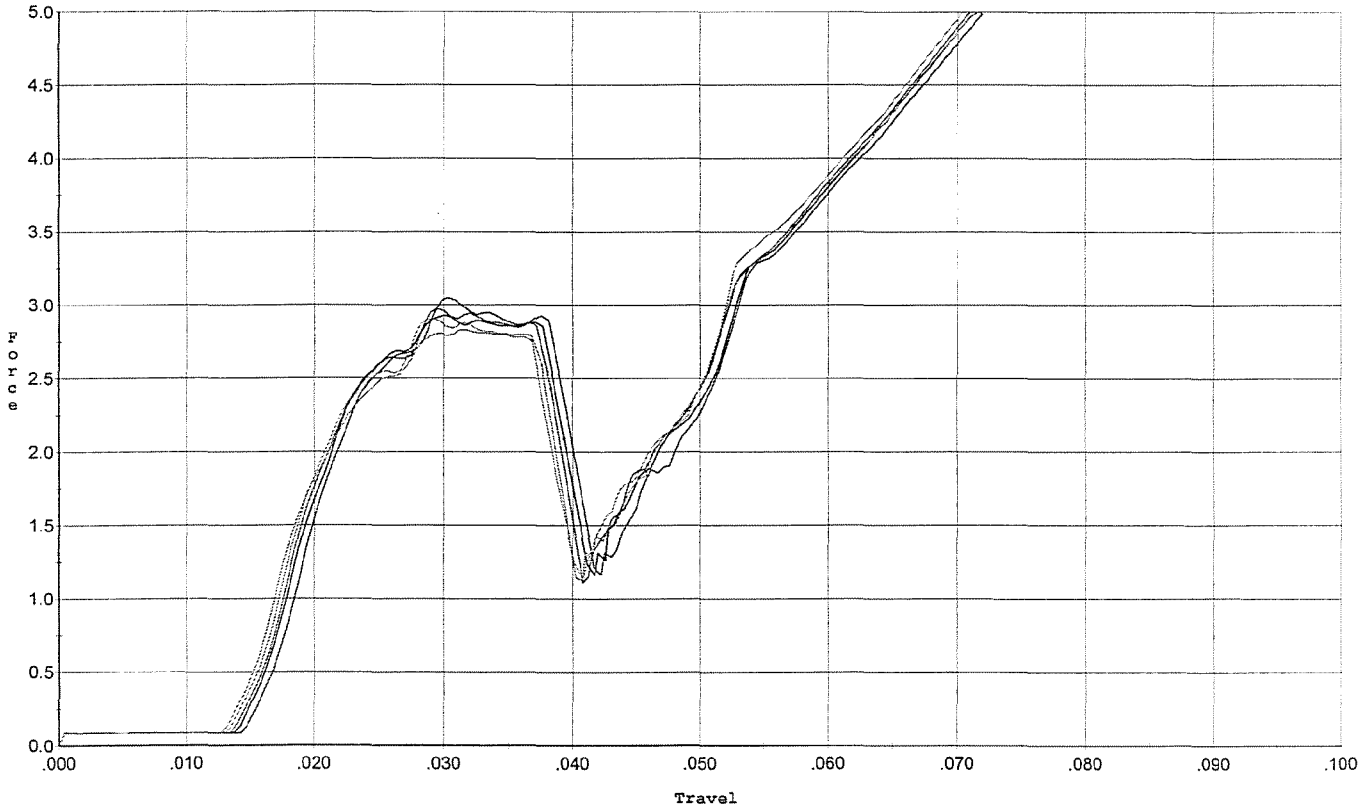
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.347	0.038	0.018	0.044	0.036		Set Trigger
2	2.445	0.038	0.018	0.044	0.038		Set Trigger
3	2.442	0.038	0.018	0.044	0.038		Set Trigger
4	2.265	0.038	0.018	0.044	0.036		Set Trigger
5	2.280	0.038	0.017	0.044	0.037		Set Trigger

2.36 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:02:08 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs ini.
Note:	M. Mckinney 11/16/06		



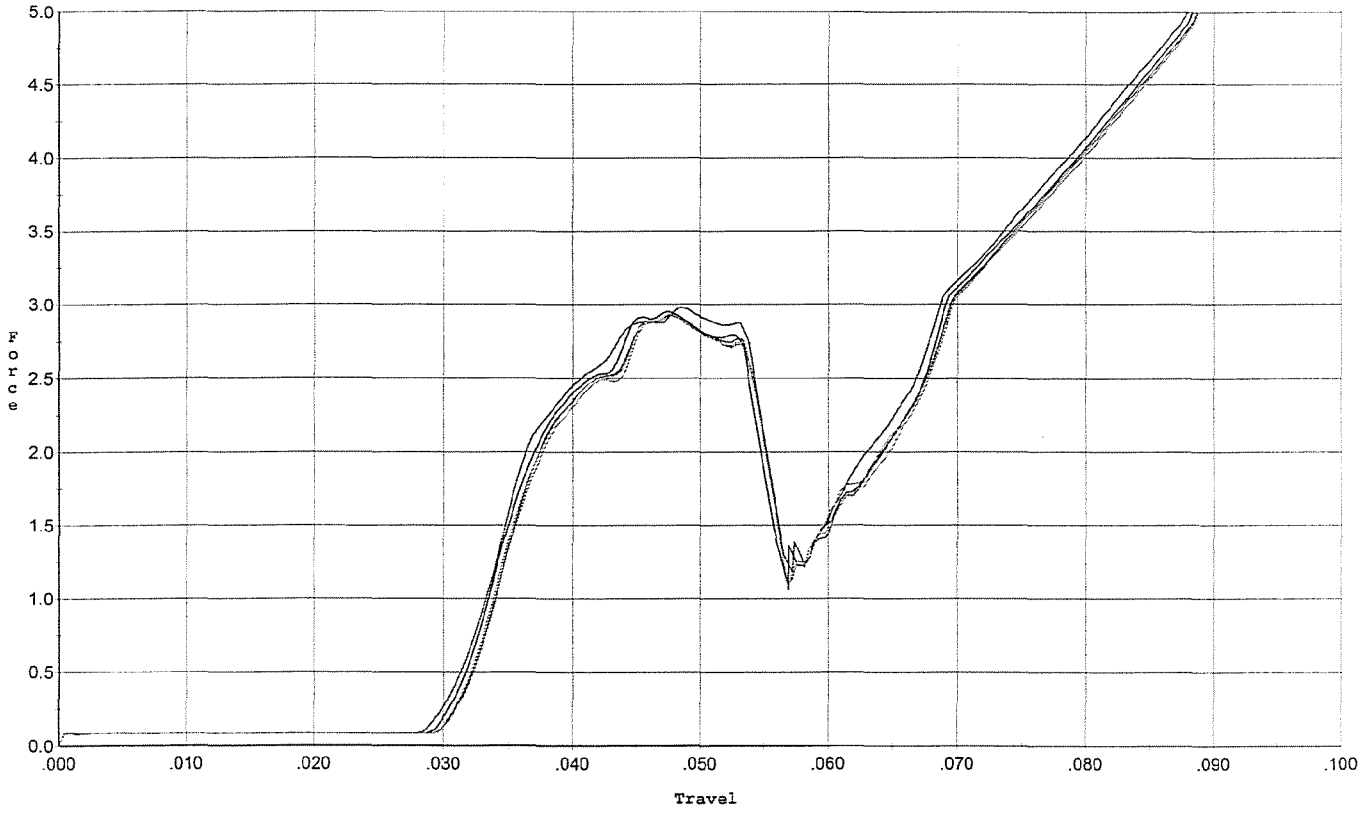
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.049	0.040	0.015	0.036	0.057		Set Trigger
2	2.928	0.039	0.015	0.036	0.056		Set Trigger
3	2.975	0.038	0.014	0.036	0.055		Set Trigger
4	2.904	0.037	0.014	0.037	0.052		Set Trigger
5	2.829	0.038	0.014	0.036	0.053		Set Trigger

2.94 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:05:09 PM

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:	M. Mckinney 11/16/06		



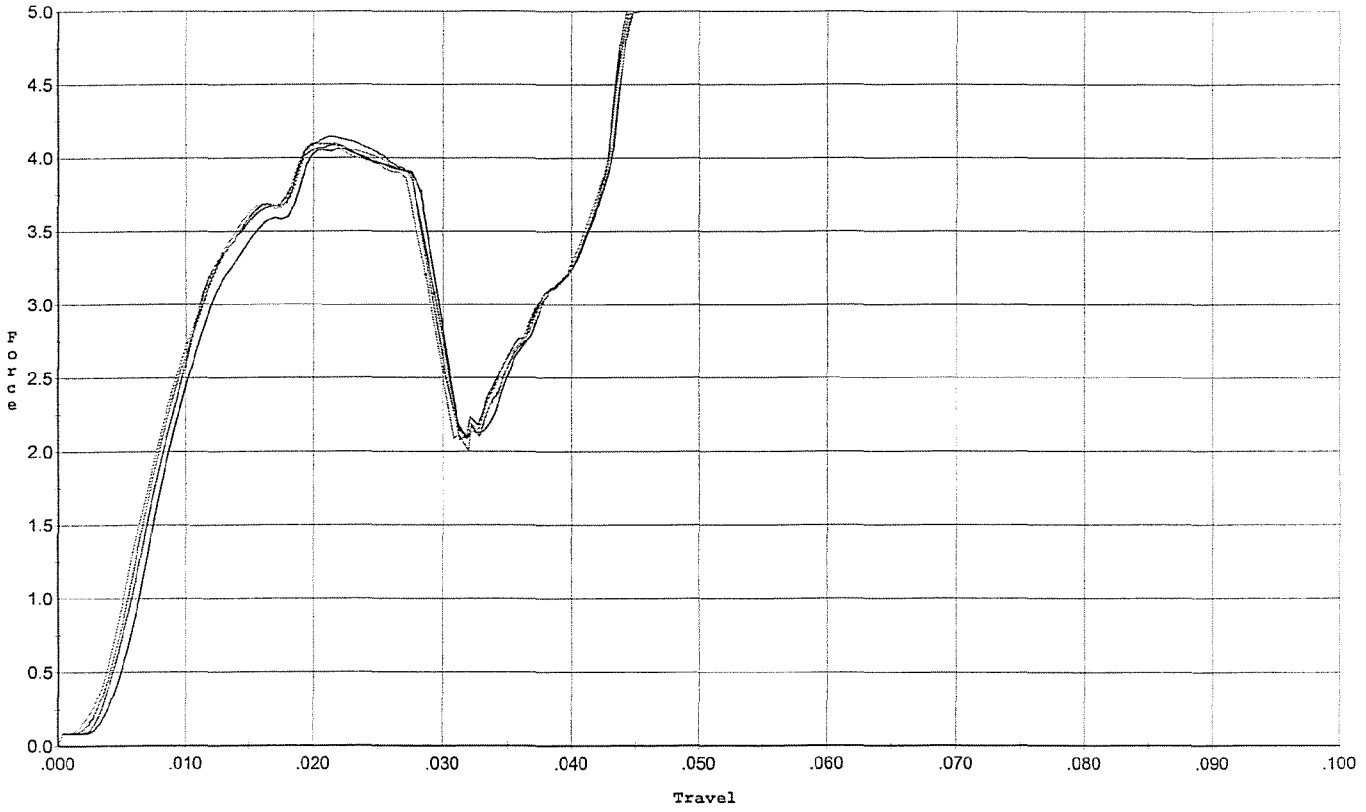
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.982	0.054	0.030	0.037	0.058		Set Trigger
2	2.951	0.053	0.030	0.038	0.055		Set Trigger
3	2.925	0.054	0.031	0.037	0.056		Set Trigger
4	2.933	0.054	0.031	0.038	0.056		Set Trigger
5	2.920	0.054	0.031	0.038	0.055		Set Trigger

2.944 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:06:09 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	M. Mckinney 11/16/06		



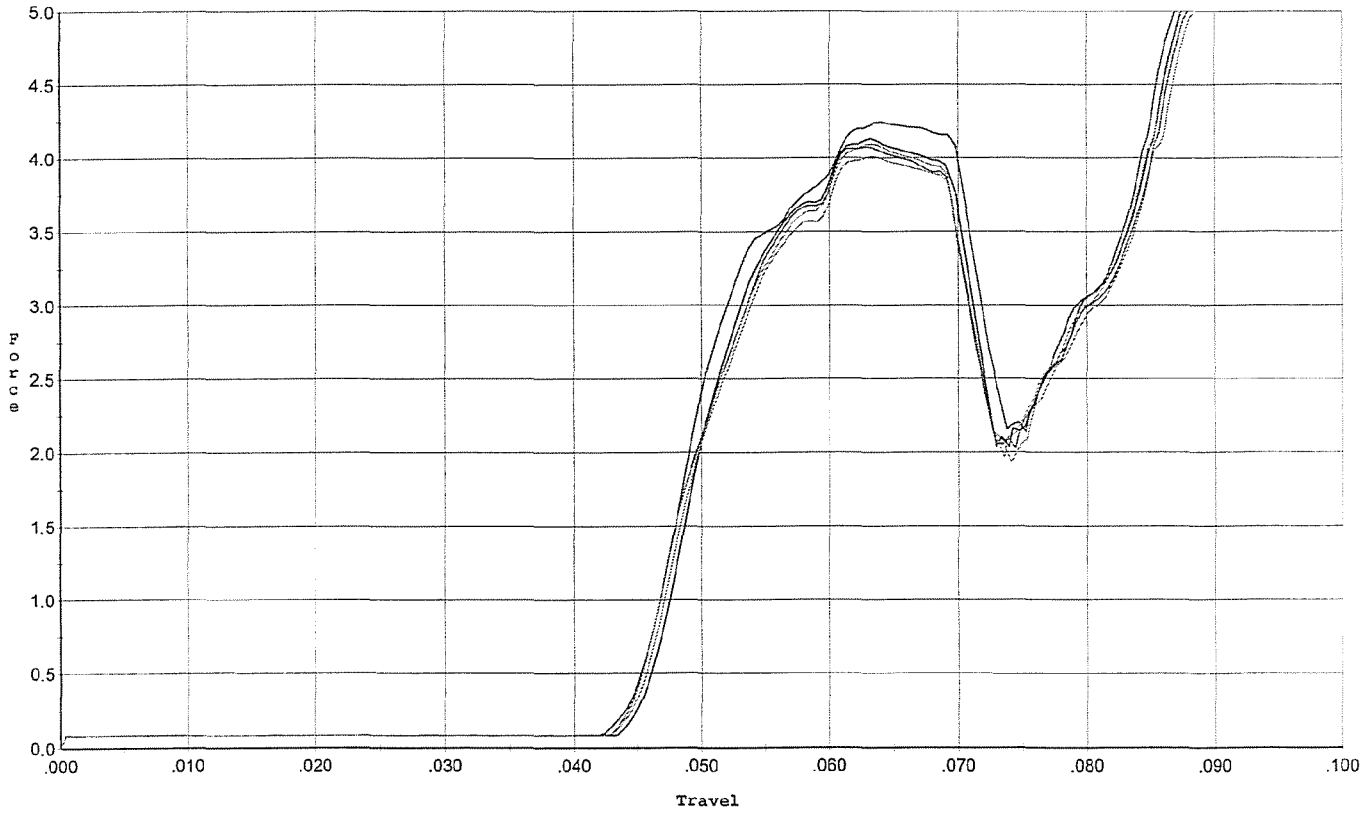
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.087	0.029	0.003	0.018	0.077		Set Trigger
2	4.060	0.028	0.004	0.018	0.072		Set Trigger
3	4.143	0.028	0.003	0.018	0.073		Set Trigger
4	4.100	0.028	0.003	0.018	0.073		Set Trigger
5	4.107	0.029	0.00	0.018	0.076		Set Trigger

4.10

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:07:15 PM

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:	M. Mckinney 11/16/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.246	0.070	0.045	0.024	0.091		Set Trigger
2	4.131	0.070	0.045	0.025	0.085		Set Trigger
3	4.074	0.069	0.045	0.026	0.084		Set Trigger
4	4.095	0.069	0.045	0.026	0.083		Set Trigger
5	4.012	0.069	0.044	0.026	0.083		Set Trigger

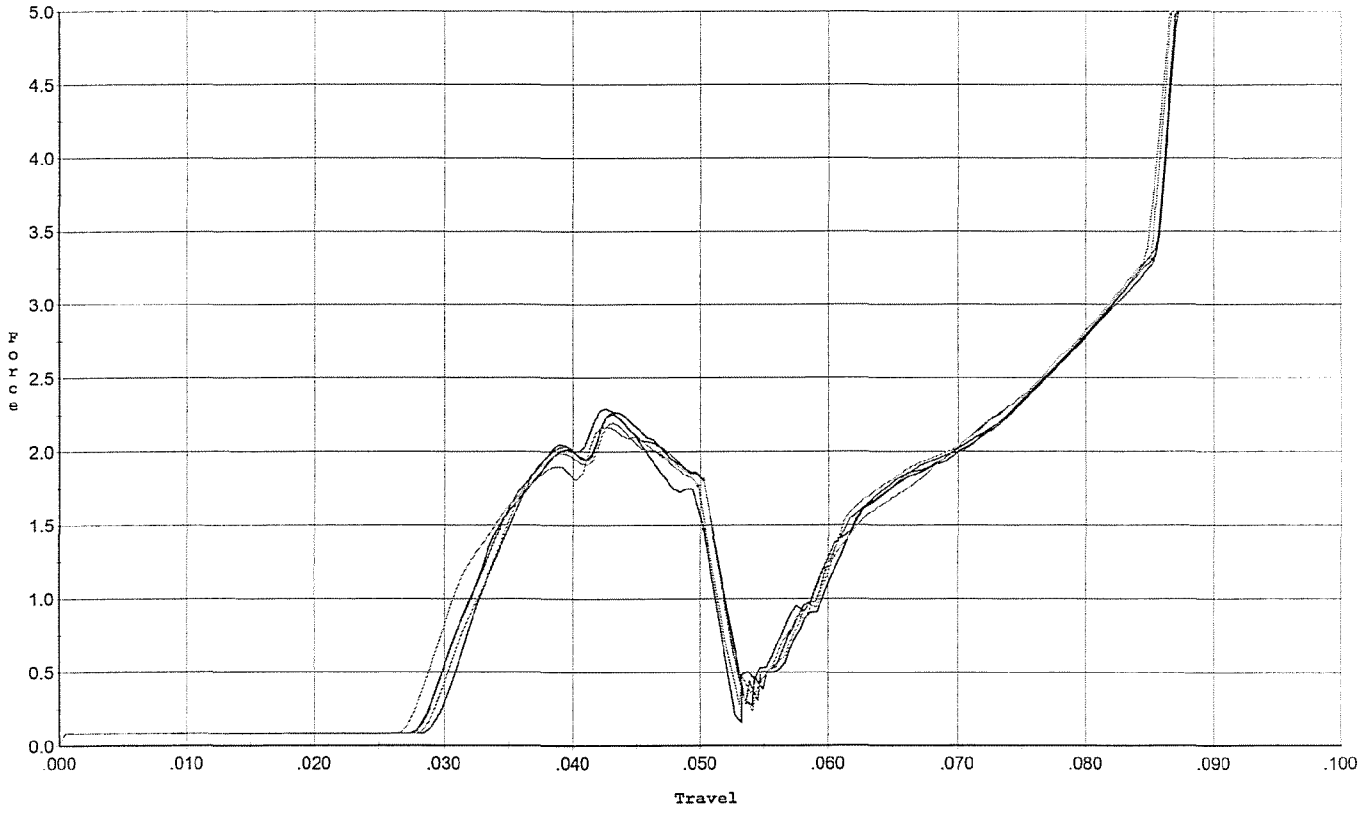
4.11 Avg.

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400164947

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	Final Test & To Reset 2.5 lbs.
Note:	M. Mckinney 11/16/06		



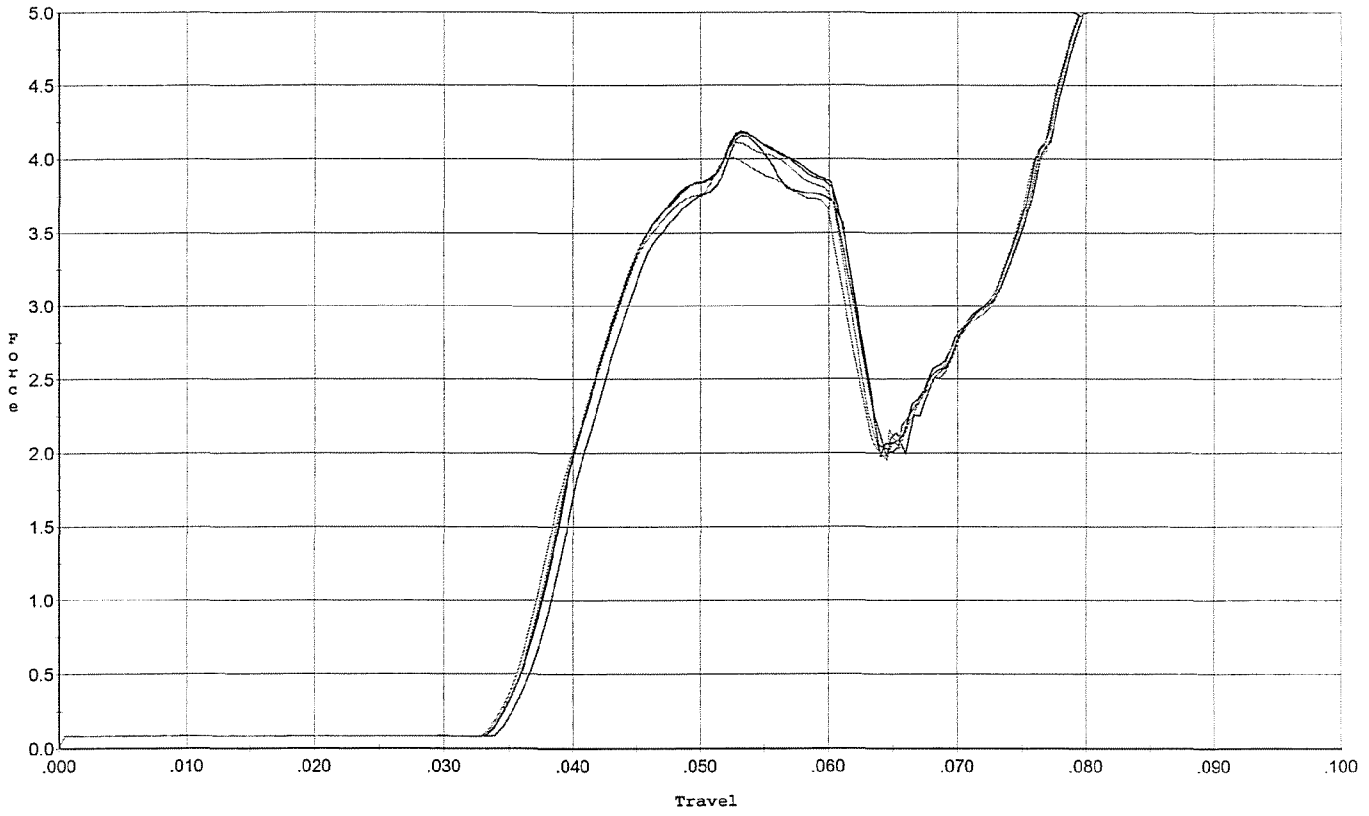
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.293	0.050	0.030	0.042	0.037		Set Trigger
2	2.266	0.050	0.029	0.041	0.039		Set Trigger
3	2.253	0.050	0.029	0.042	0.039		Set Trigger
4	2.196	0.050	0.029	0.041	0.038		Set Trigger
5	2.169	0.050	0.028	0.041	0.039		Set Trigger

2.24 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:09:24 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	Reset to 4.0 lbs. For Target & Accuracy
Note:	M. Mckinney 11/16/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.158	0.061	0.035	0.029	0.083		Set Trigger
2	4.176	0.061	0.035	0.029	0.087		Set Trigger
3	4.187	0.062	0.034	0.029	0.088		Set Trigger
4	4.110	0.060	0.034	0.029	0.085		Set Trigger
5	4.012	0.060	0.034	0.030	0.082		Set Trigger

4.13 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:10:52 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590117.__0
FILE DATE AND TIME: 12/05/2006 05:52

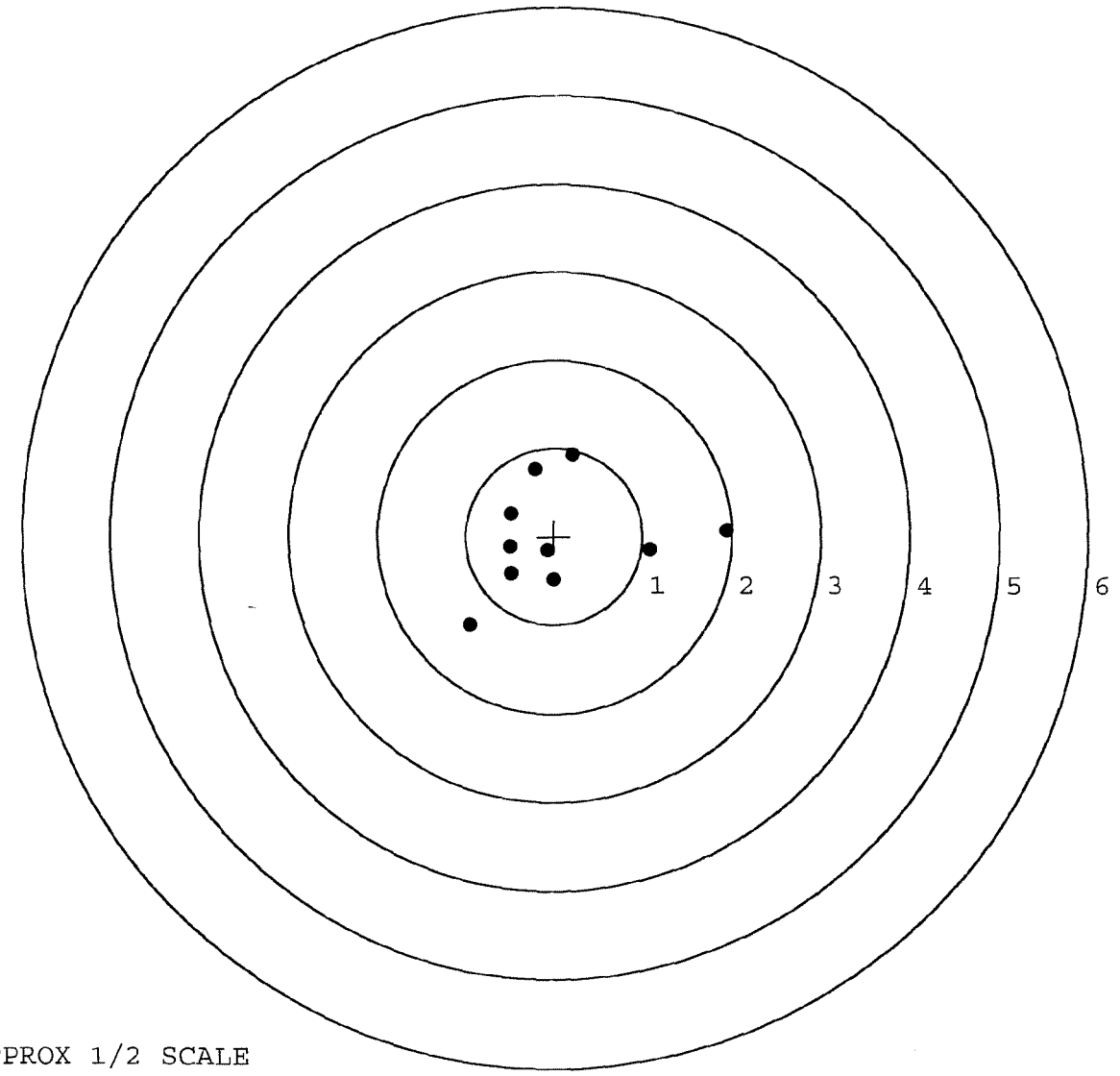
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.041
The Average Y Centroid of the Five Target Set:	-0.046
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.797
The Distance from POA to Centroid Target #1:	0.061
The Distance from Centroid Target #2 to Centroid Target #1:	0.099
The Distance from Centroid Target #3 to Centroid Target #1:	0.057
The Distance from Centroid Target #4 to Centroid Target #1:	0.074
The Distance from Centroid Target #5 to Centroid Target #1:	0.029

SERIAL NUMBER: G6590117.__0
TARGET NUMBER: 1
FILE DATE: 12/05/2006
FILE TIME: 05:52

X CENTROID:	0.051
Y CENTROID:	-0.034
POA TO CENTROID:	0.061
HORZ SPREAD:	2.892
VERT SPREAD:	1.935
GROUP SPREAD:	3.085
MIN RADIUS:	0.183
MAX RADIUS:	1.894
MEAN RADIUS:	0.864
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.942	0.068
2:	1.083	-0.150
3:	0.208	0.930
4:	-0.219	0.766
5:	-0.487	0.261
6:	-0.079	-0.163
7:	-0.001	-0.500
8:	-0.486	-0.425
9:	-0.500	-0.118
10:	-0.950	-1.005

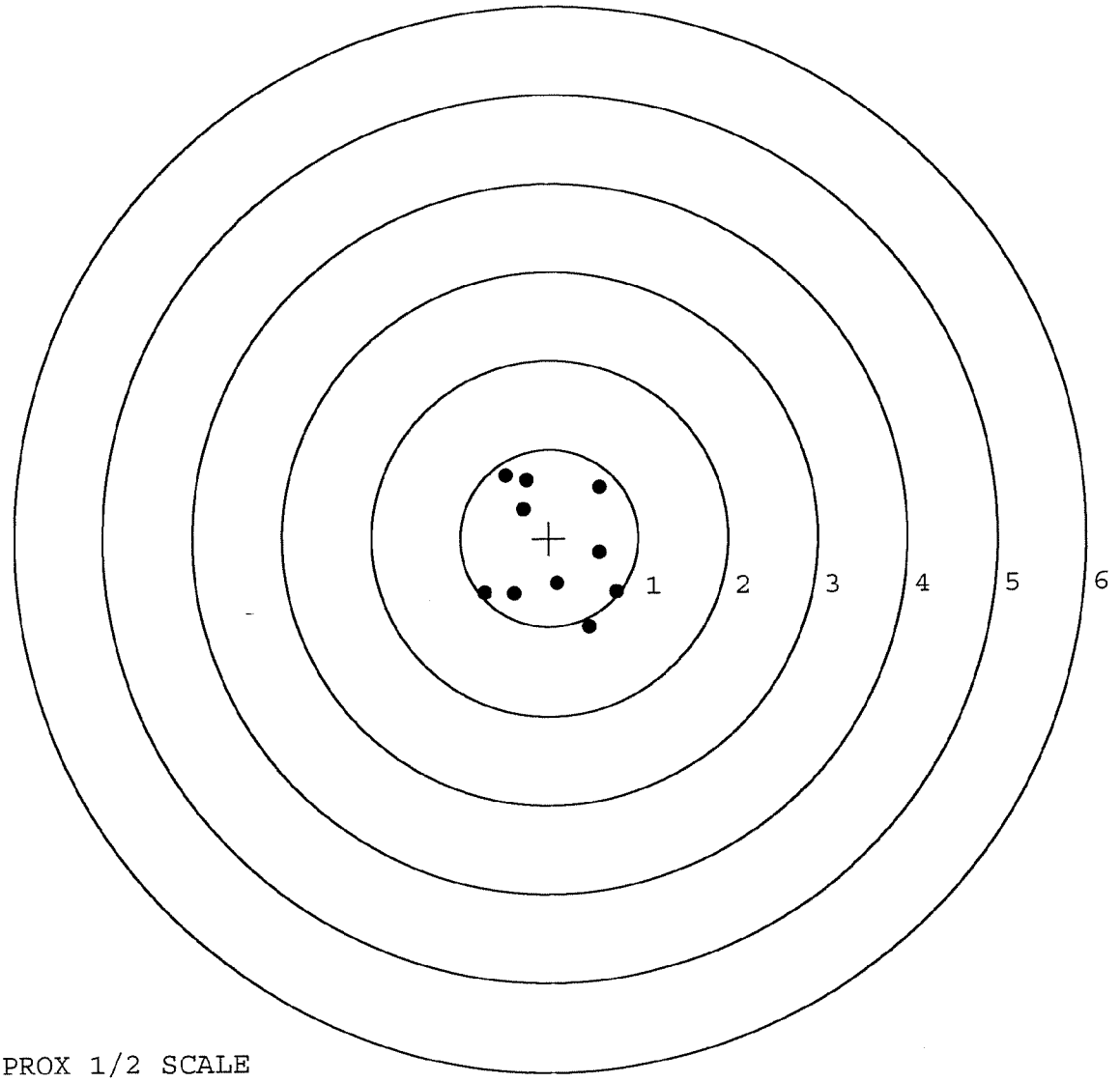


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590117.__0
TARGET NUMBER: 2
FILE DATE: 12/05/2006
FILE TIME: 05:52

X CENTROID:	0.026
Y CENTROID:	-0.129
POA TO CENTROID:	0.132
HORZ SPREAD:	1.478
VERT SPREAD:	1.714
GROUP SPREAD:	1.949
MIN RADIUS:	0.389
MAX RADIUS:	0.980
MEAN RADIUS:	0.758
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.485	0.707
2:	-0.251	0.655
3:	-0.288	0.331
4:	0.570	0.572
5:	0.561	-0.170
6:	0.087	-0.514
7:	0.750	-0.620
8:	0.442	-1.007
9:	-0.394	-0.631
10:	-0.728	-0.616

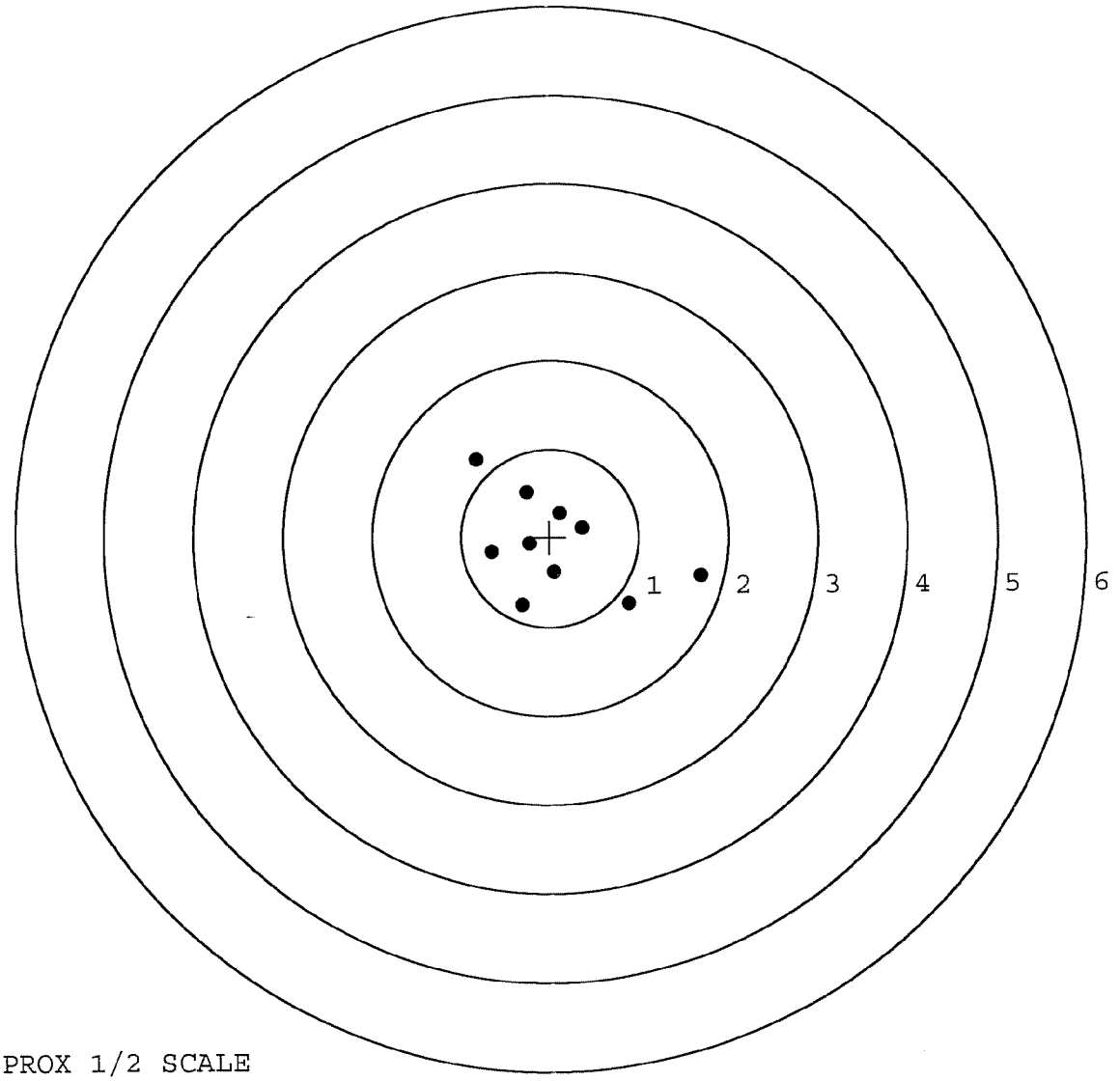


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590117.__0
TARGET NUMBER: 3
FILE DATE: 12/05/2006
FILE TIME: 05:52

X CENTROID:	0.082
Y CENTROID:	-0.082
POA TO CENTROID:	0.116
HORZ SPREAD:	2.510
VERT SPREAD:	1.647
GROUP SPREAD:	2.844
MIN RADIUS:	0.313
MAX RADIUS:	1.647
MEAN RADIUS:	0.755
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.822	0.890
2:	-0.257	0.508
3:	0.114	0.273
4:	0.367	0.101
5:	0.053	-0.395
6:	-0.231	-0.076
7:	-0.655	-0.165
8:	-0.317	-0.757
9:	0.884	-0.748
10:	1.688	-0.447

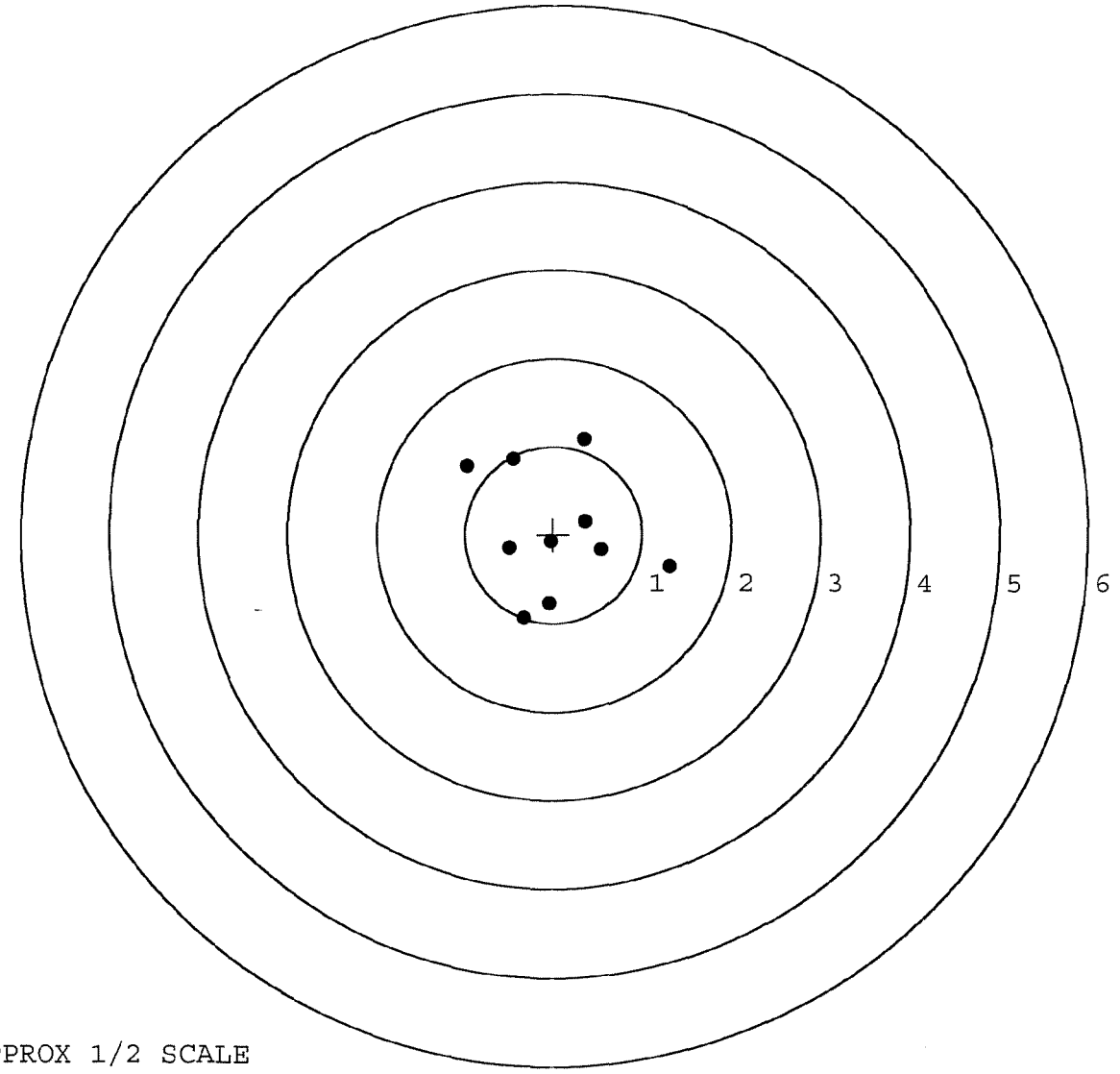


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590117.__0
TARGET NUMBER: 4
FILE DATE: 12/05/2006
FILE TIME: 05:52

X CENTROID:	0.023
Y CENTROID:	0.035
POA TO CENTROID:	0.041
HORZ SPREAD:	2.283
VERT SPREAD:	2.034
GROUP SPREAD:	2.558
MIN RADIUS:	0.127
MAX RADIUS:	1.349
MEAN RADIUS:	0.810
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.345	1.081
2:	-0.454	0.858
3:	-0.974	0.781
4:	-0.332	-0.953
5:	-0.040	-0.785
6:	1.309	-0.373
7:	0.543	-0.177
8:	0.355	0.150
9:	-0.030	-0.081
10:	-0.496	-0.154

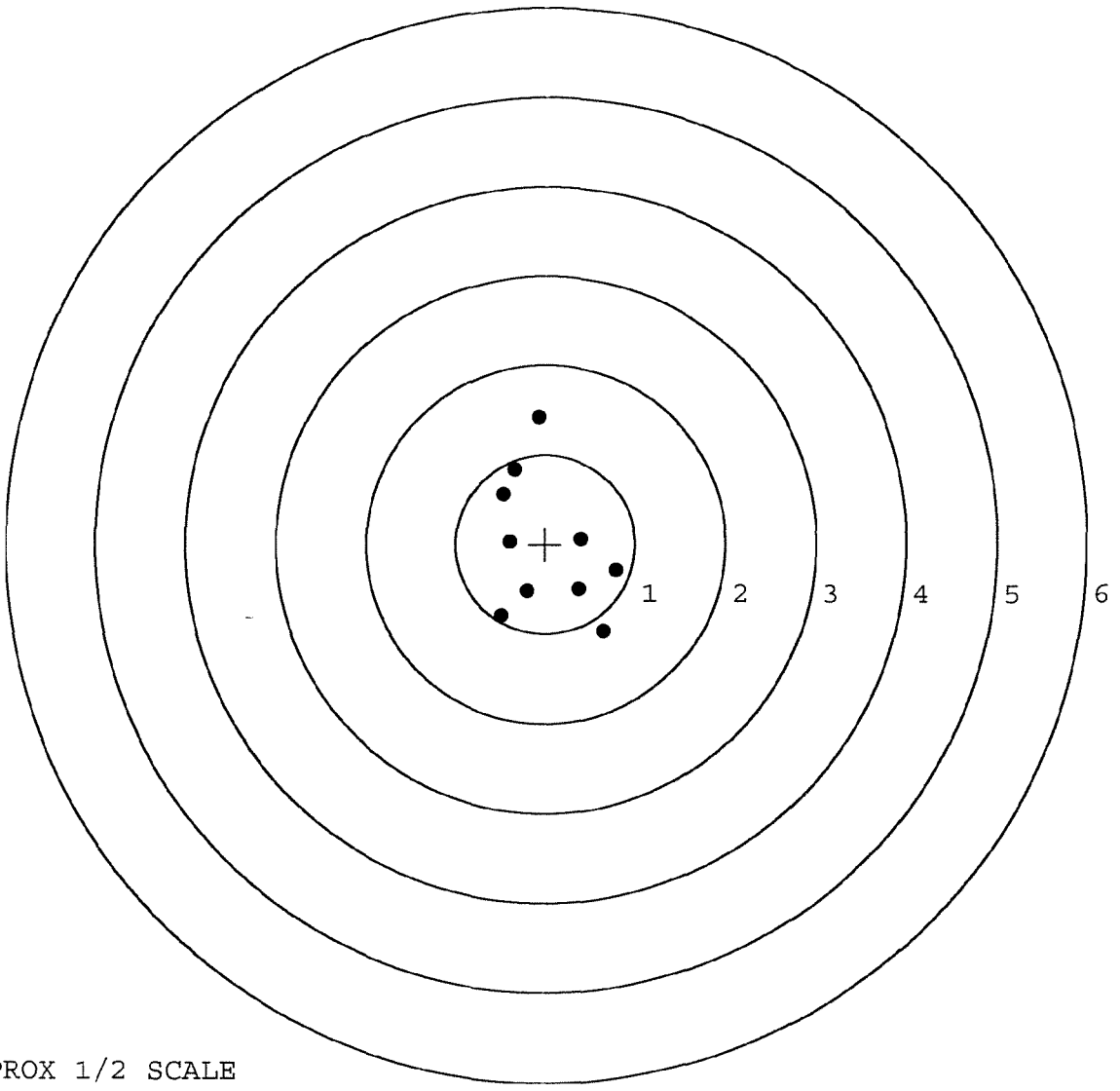


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590117.__0
TARGET NUMBER: 5
FILE DATE: 12/05/2006
FILE TIME: 05:52

X CENTROID:	0.025
Y CENTROID:	-0.021
POA TO CENTROID:	0.032
HORZ SPREAD:	1.279
VERT SPREAD:	2.396
GROUP SPREAD:	2.506
MIN RADIUS:	0.390
MAX RADIUS:	1.444
MEAN RADIUS:	0.800
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.652	-0.977
2:	0.378	-0.508
3:	0.788	-0.294
4:	0.406	0.062
5:	-0.491	-0.803
6:	-0.200	-0.532
7:	-0.399	0.029
8:	-0.467	0.562
9:	-0.340	0.834
10:	-0.081	1.419



TARGET APPROX 1/2 SCALE