84101459

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

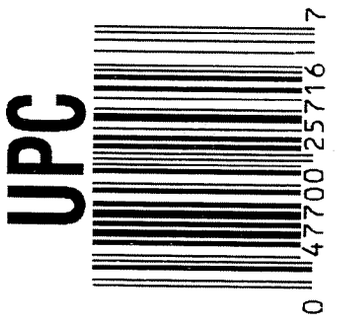
– INSTUCTION BOOK 3518

DD FORM

ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6590148



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.

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590148

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-17-06	RTZ
420	ASSEMBLE ACTION		10-17-06	RTZ
430	ASSEMBLE TO STOCK		10-17-06	S.P.D.
440	PROOF	MAGNA-FLUX INSPECTED OCT 19 2006 OPERATOR APD	10-17-06	S.P.D.
460	CHECK HEADSPACE		10-17-06	S.P.D.
470	DIS-ASSEMBLE ACTION		10-18-06	BLG
480	MAGNAFLUX BBL ACTION		10-19-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-20-06	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	MDH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/7/06	MDH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/7/06	MDH
	D) OIL FIRING PIN ASSEMBLY		11-29-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

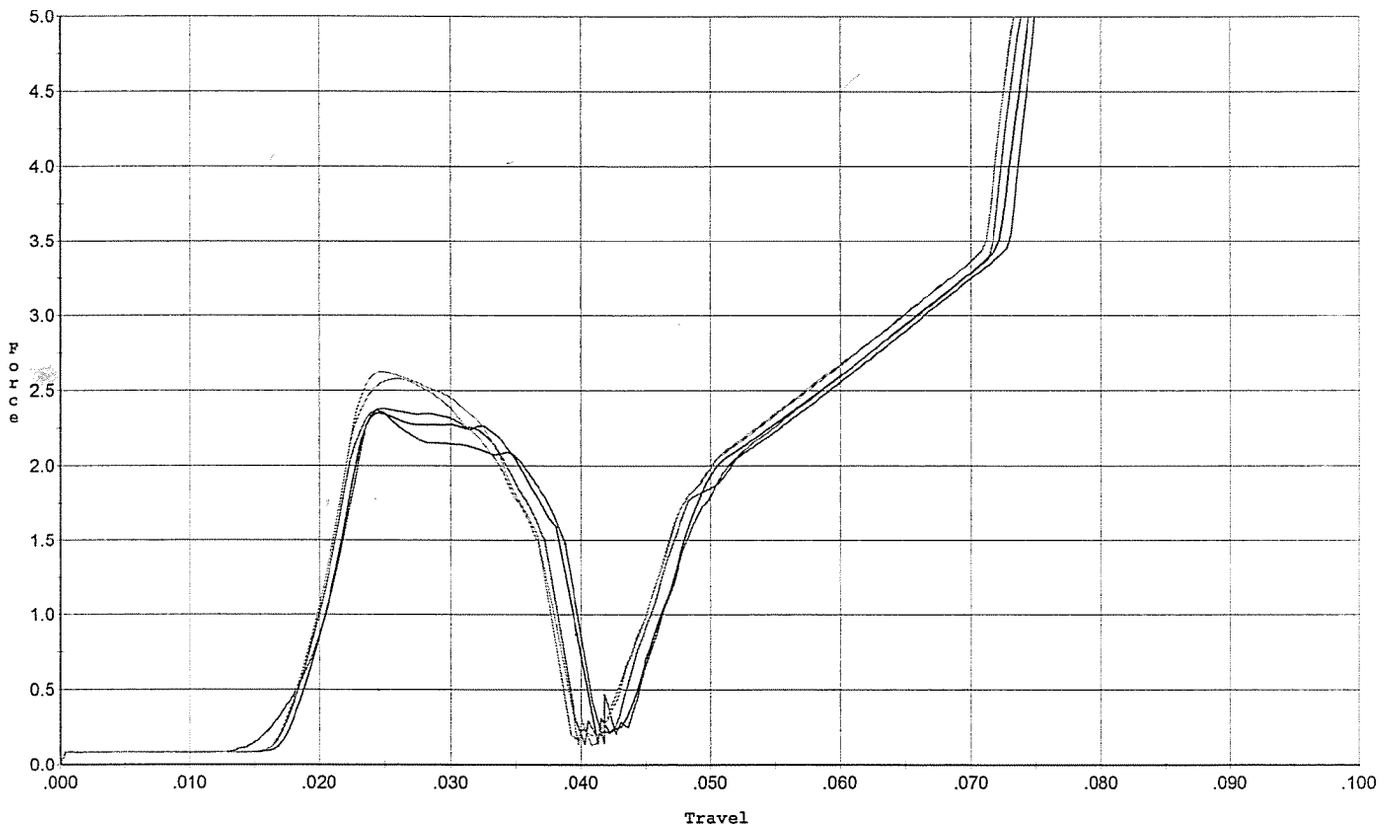
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	6# 6# 5#	12-13-06	SD
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	8# 8# 7#	12-13-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.025 .025 .025	12-13-06	SD
	J) ASSEMBLE STOCK		11-30-06	BLC
	K) ASSEMBLE SWIVEL STUDS		1-3-07	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-3-07	L.P.D.
	M) IRON SIGHT ALIGNMENT		1-3-07	L.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-3-07	L.P.D.
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL / PASS FAIL	12-8-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-8-06	WR
670	FINAL INSPECTION A) HEADSPACE		1-3-07	L.P.D.
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.66 2.51 2.79 2.80 2.50	12-13-06	BLC
	C) FUNCTION		1-3-07	L.P.D.
690	PACK		1-23-07	DA

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		



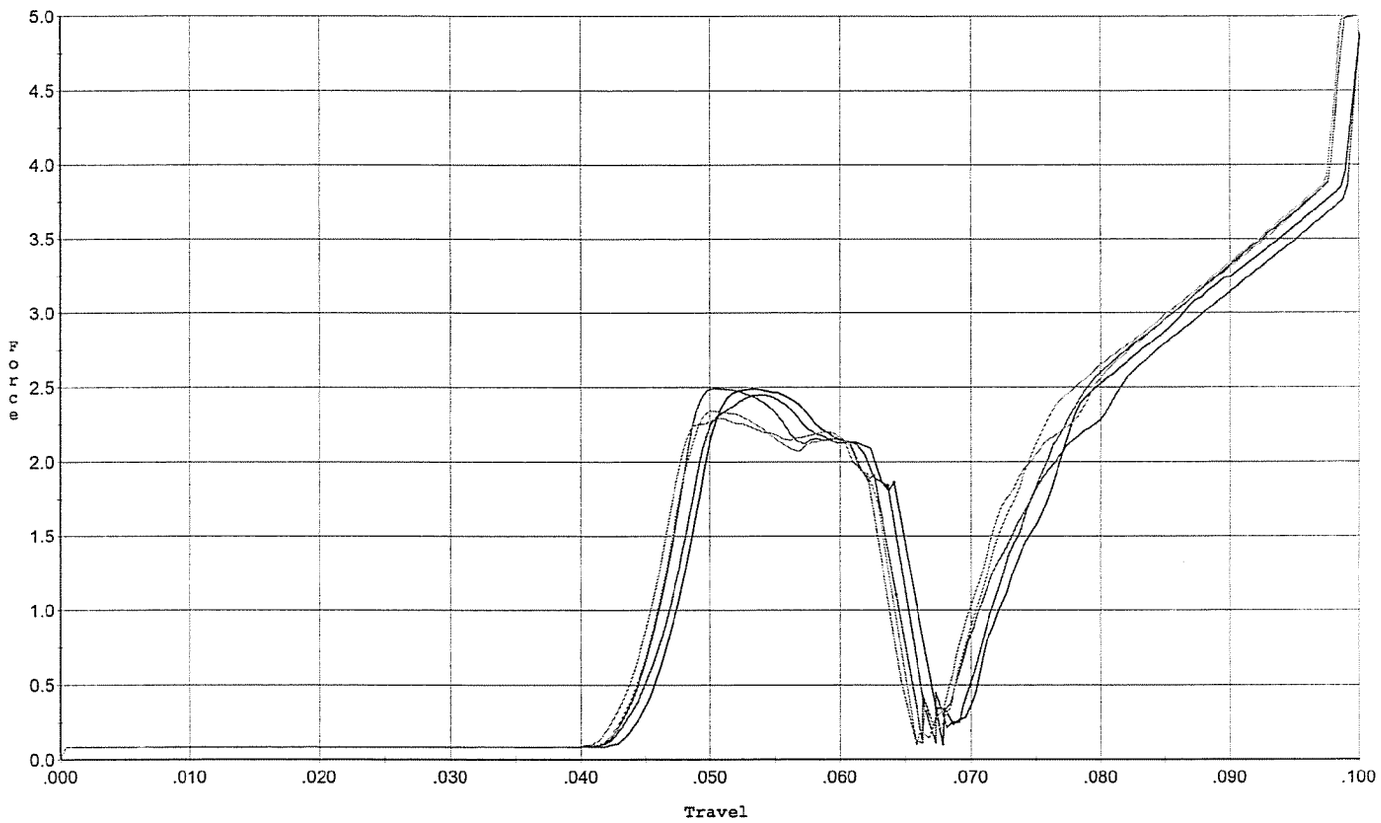
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.366	0.039	0.017	0.044	0.040		Set Trigger
2	2.350	0.040	0.018	0.044	0.041		Set Trigger
3	2.377	0.037	0.017	0.044	0.039		Set Trigger
4	2.625	0.038	0.017	0.044	0.041		Set Trigger
5	2.579	0.037	0.017	0.043	0.039		Set Trigger

2.46 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:23:29 PM

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		



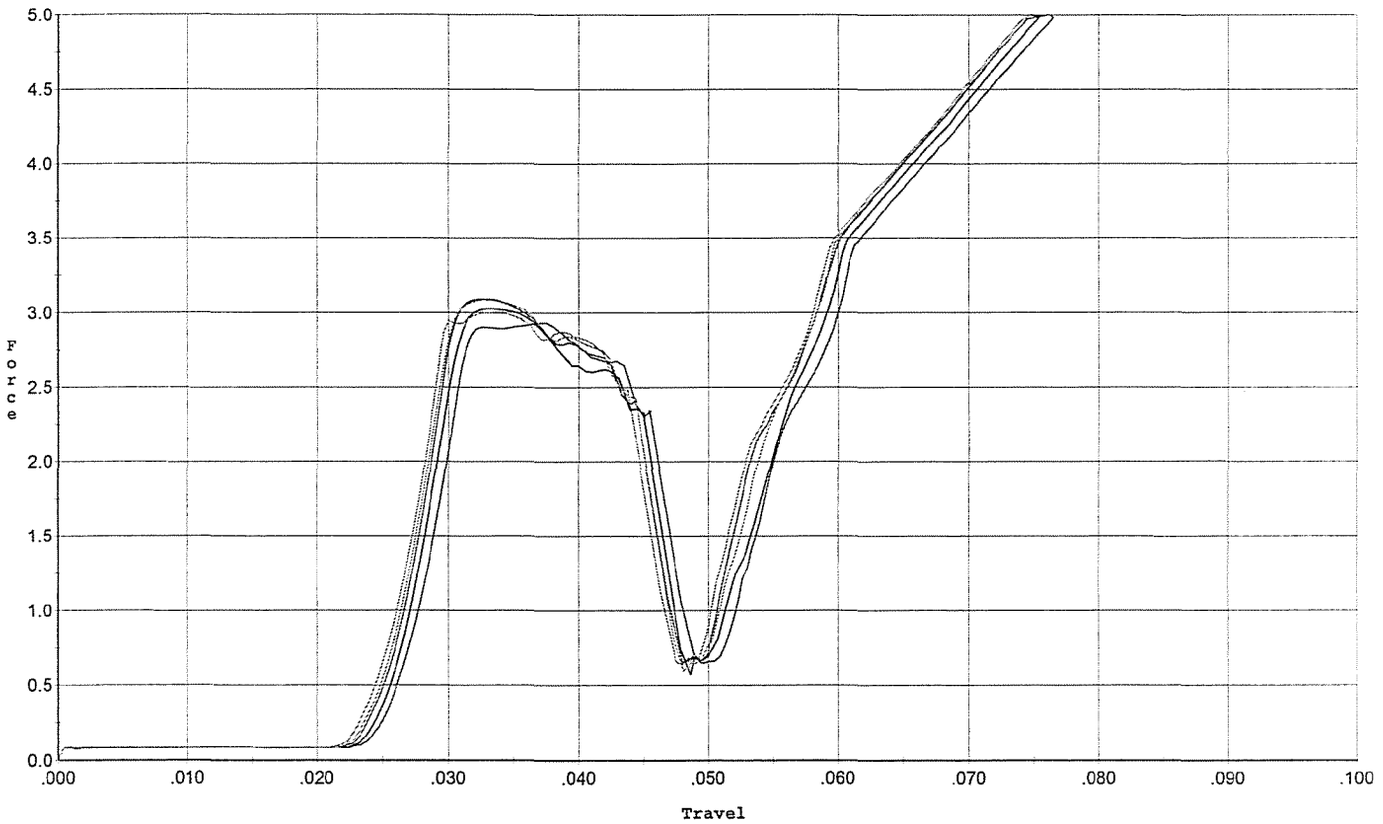
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.449	0.064	0.044	0.044	0.043		Set Trigger
2	2.488	0.064	0.045	0.044	0.043		Set Trigger
3	2.490	0.064	0.043	0.043	0.044		Set Trigger
4	2.339	0.063	0.043	0.043	0.041		Set Trigger
5	2.291	0.062	0.042	0.043	0.042		Set Trigger

2.41 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:25:12 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		



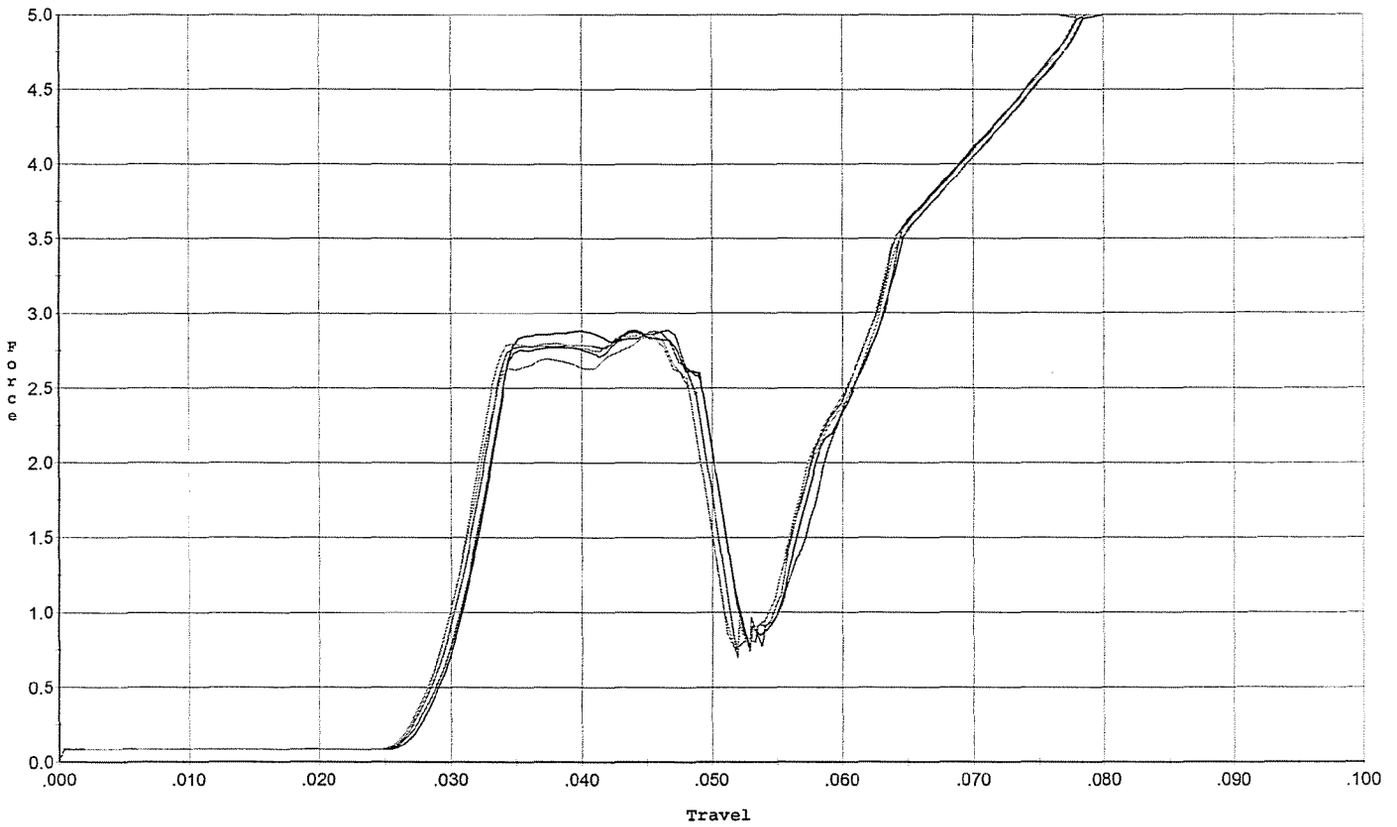
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.931	0.045	0.025	0.038	0.050		Set Trigger
2	3.027	0.045	0.025	0.038	0.051		Set Trigger
3	3.089	0.044	0.024	0.038	0.052		Set Trigger
4	3.092	0.044	0.024	0.037	0.052		Set Trigger
5	2.999	0.044	0.023	0.038	0.051		Set Trigger

3.03 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:26:20 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		



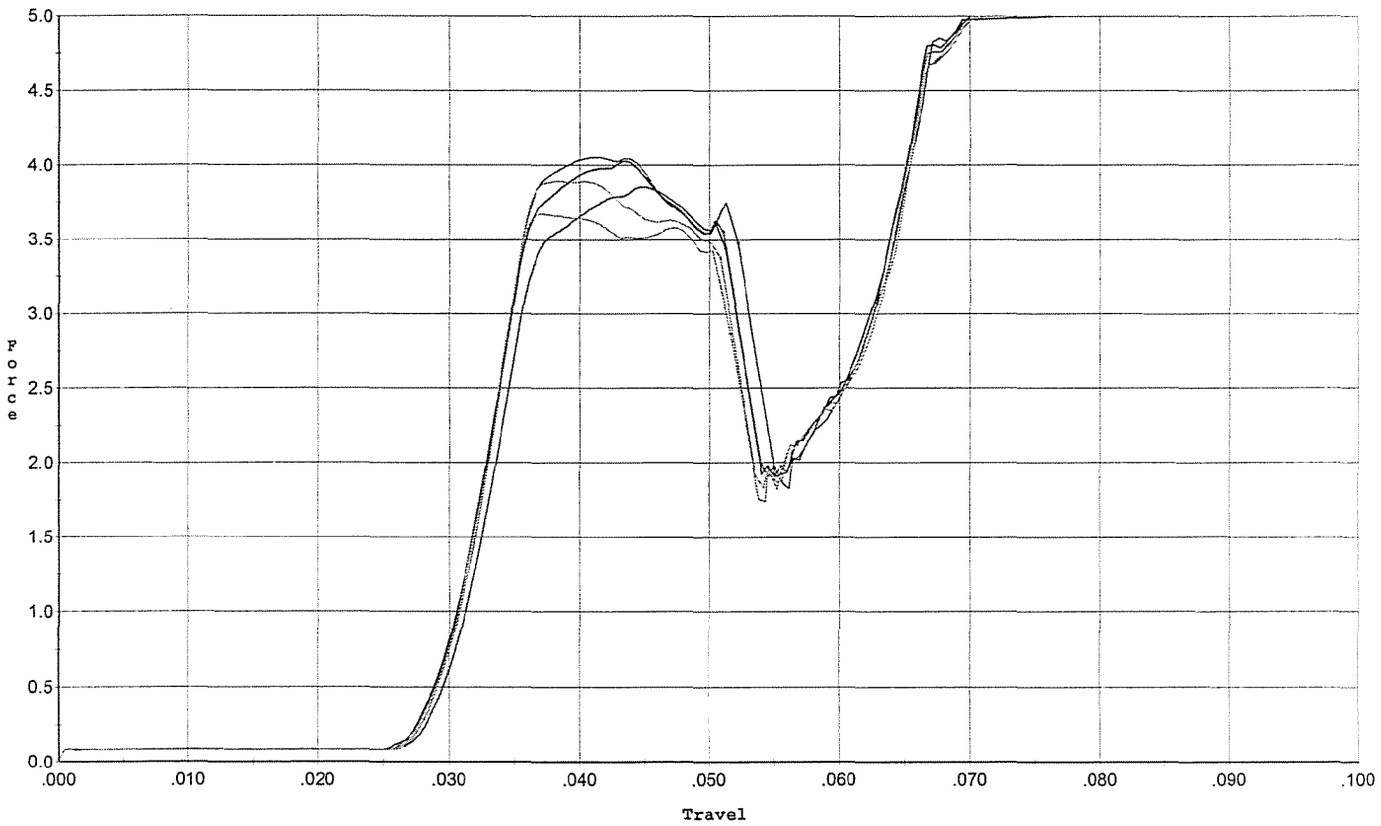
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.890	0.049	0.028	0.037	0.053		Set Trigger
2	2.882	0.049	0.028	0.037	0.053		Set Trigger
3	2.881	0.049	0.027	0.037	0.053		Set Trigger
4	2.869	0.048	0.027	0.037	0.053		Set Trigger
5	2.845	0.048	0.027	0.037	0.051		Set Trigger

2.87 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:27:54 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		



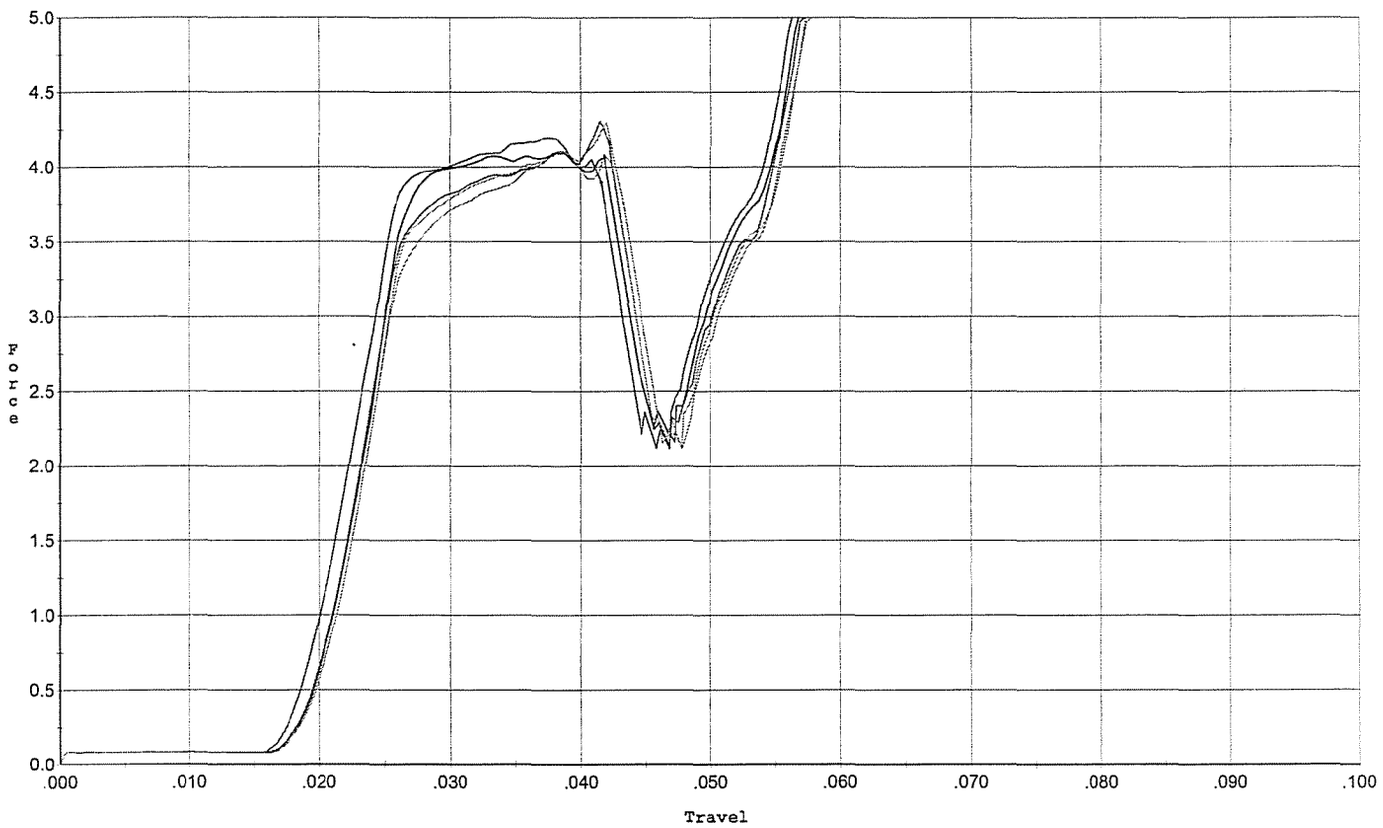
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.853	0.052	0.028	0.031	0.076		Set Trigger
2	4.027	0.051	0.028	0.031	0.076		Set Trigger
3	4.051	0.051	0.028	0.031	0.077		Set Trigger
4	3.888	0.051	0.028	0.032	0.073		Set Trigger
5	3.672	0.052	0.028	0.032	0.072		Set Trigger

3.90 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 5:29:12 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		



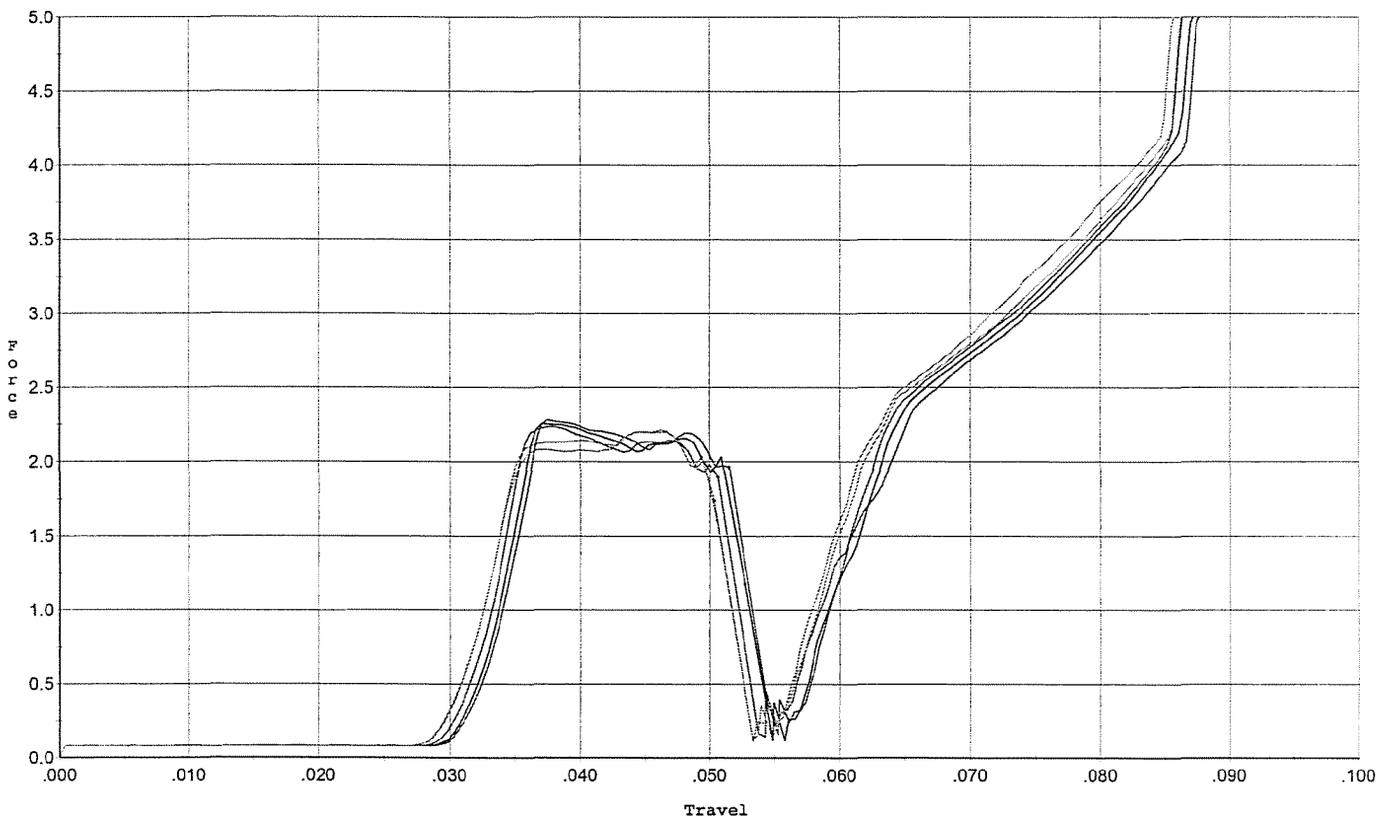
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.196	0.042	0.017	0.019	0.081		Set Trigger
2	4.092	0.042	0.019	0.019	0.079		Set Trigger
3	4.306	0.042	0.019	0.019	0.080		Set Trigger
4	4.101	0.042	0.019	0.019	0.079		Set Trigger
5	4.297	0.043	0.019	0.025	0.081		Set Trigger

4.20 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 6:33:08 PM

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		



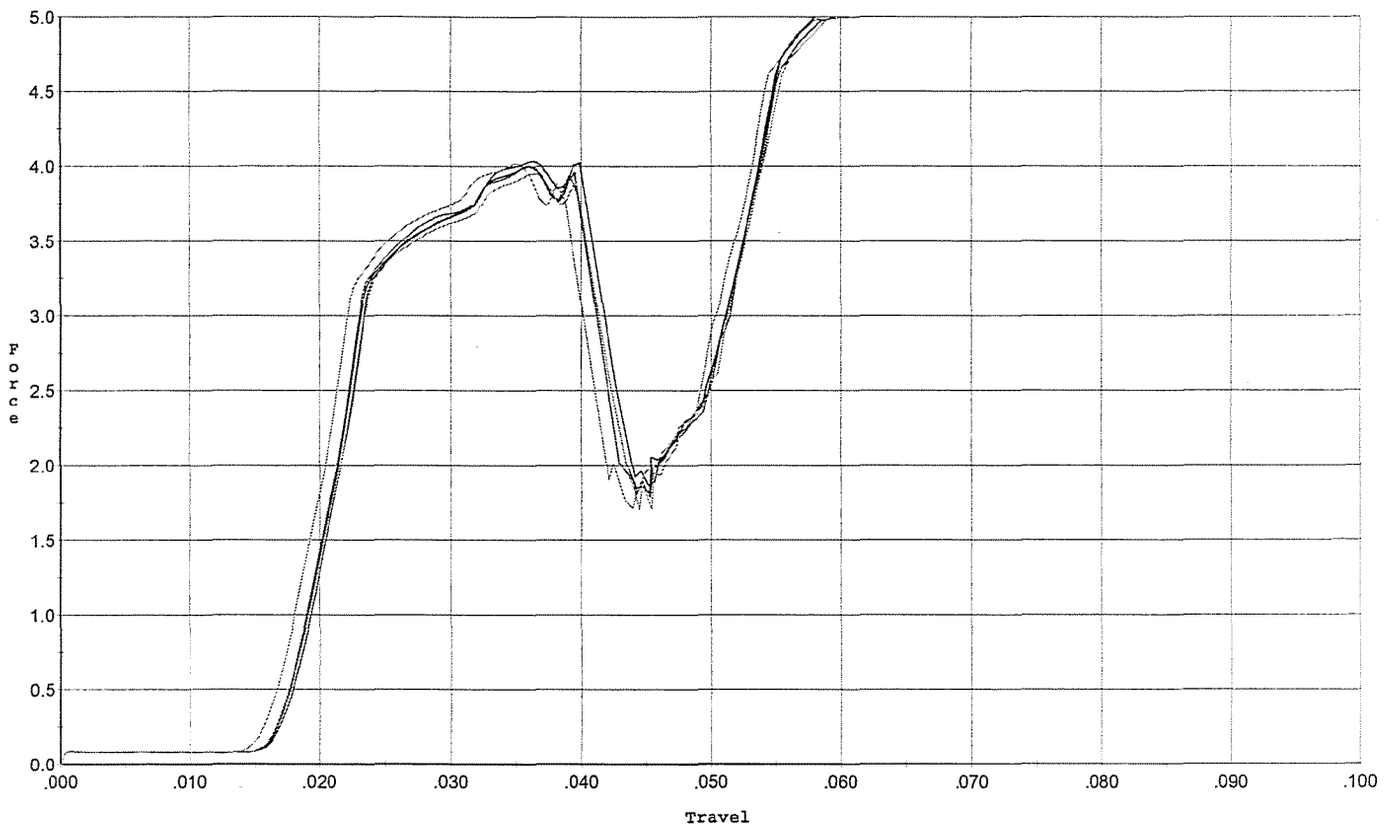
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.282	0.052	0.031	0.040	0.042		Set Trigger
2	2.256	0.053	0.031	0.040	0.042		Set Trigger
3	2.236	0.051	0.030	0.040	0.041		Set Trigger
4	2.203	0.050	0.030	0.040	0.041		Set Trigger
5	2.213	0.051	0.030	0.040	0.041		Set Trigger

2.24 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 6:34:24 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	4.036	0.040	0.017	0.026	0.074		Set Trigger
2	4.001	0.039	0.017	0.026	0.073		Set Trigger
3	4.005	0.040	0.017	0.027	0.073		Set Trigger
4	3.951	0.040	0.017	0.027	0.072		Set Trigger
5	4.017	0.039	0.016	0.027	0.073		Set Trigger

4.00 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/16/2006 6:37:31 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590148.__0
FILE DATE AND TIME: 12/09/2006 05:44

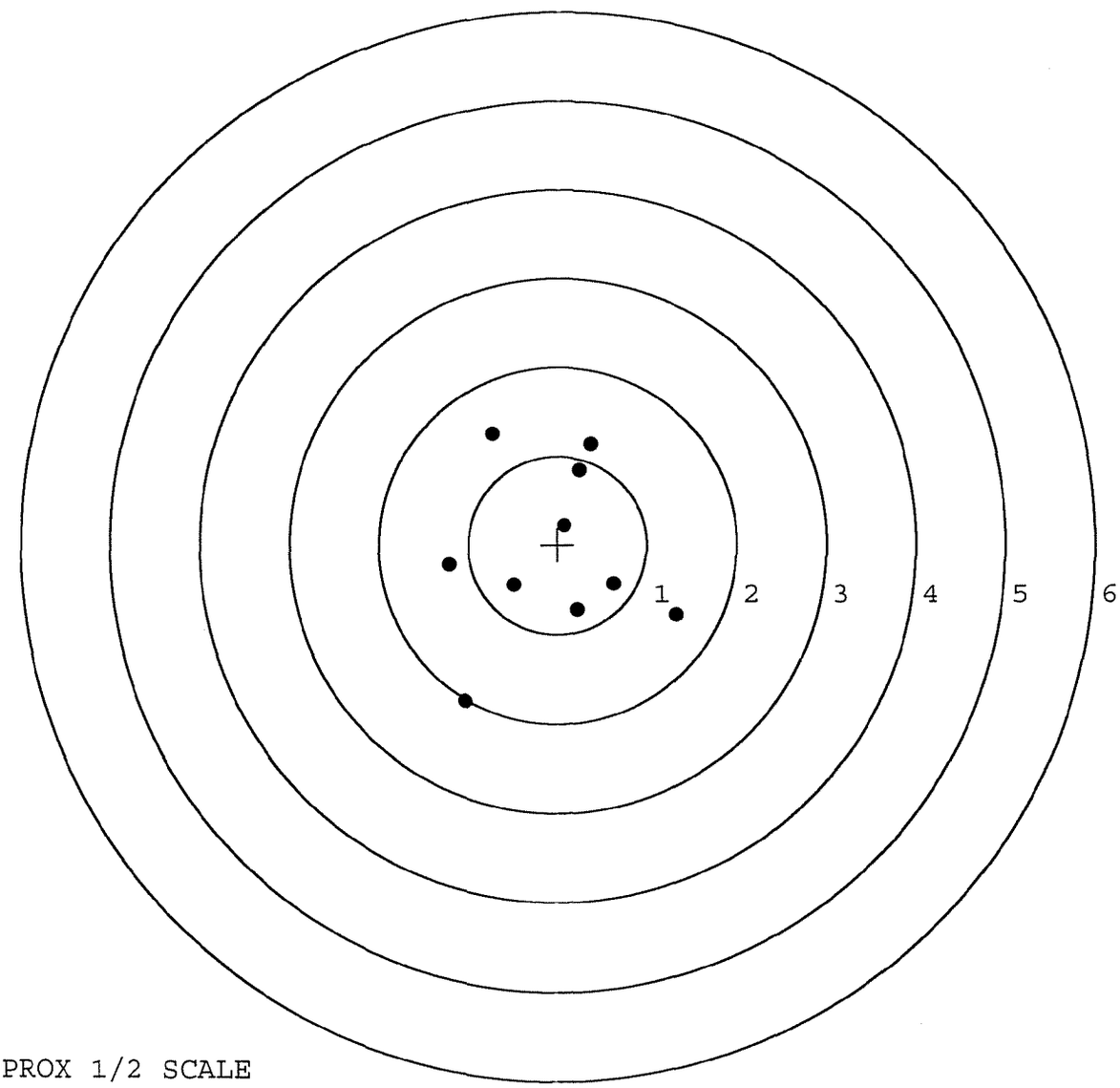
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.077
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.918
The Distance from POA to Centroid Target #1:	0.110
The Distance from Centroid Target #2 to Centroid Target #1:	0.144
The Distance from Centroid Target #3 to Centroid Target #1:	0.259
The Distance from Centroid Target #4 to Centroid Target #1:	0.105
The Distance from Centroid Target #5 to Centroid Target #1:	0.200

SERIAL NUMBER: G6590148.__0
TARGET NUMBER: 1
FILE DATE: 12/09/2006
FILE TIME: 05:44

X CENTROID:	-0.057
Y CENTROID:	-0.095
POA TO CENTROID:	0.110
HORZ SPREAD:	2.537
VERT SPREAD:	2.999
GROUP SPREAD:	3.204
MIN RADIUS:	0.341
MAX RADIUS:	1.919
MEAN RADIUS:	1.079
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	-0.737	1.249
2:	0.367	1.134
3:	0.252	0.844
4:	0.078	0.219
5:	1.328	-0.782
6:	0.634	-0.444
7:	0.230	-0.732
8:	-1.028	-1.750
9:	-0.481	-0.457
10:	-1.209	-0.229

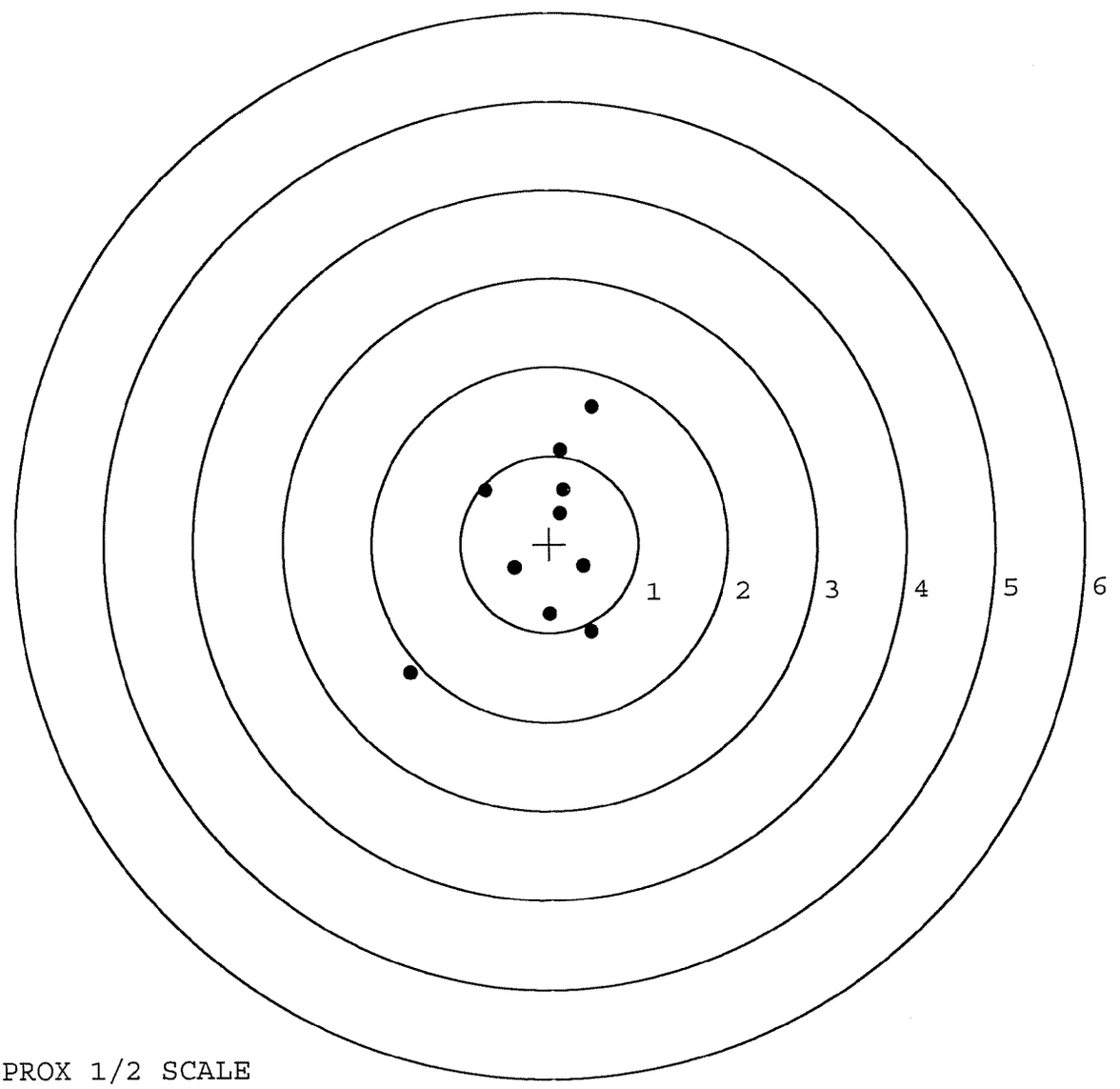


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590148.__0
TARGET NUMBER: 2
FILE DATE: 12/09/2006
FILE TIME: 05:44

X CENTROID:	-0.094
Y CENTROID:	0.044
POA TO CENTROID:	0.104
HORZ SPREAD:	2.068
VERT SPREAD:	2.976
GROUP SPREAD:	3.624
MIN RADIUS:	0.376
MAX RADIUS:	2.096
MEAN RADIUS:	0.962
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.489	1.541
2:	0.133	1.063
3:	0.166	0.618
4:	0.124	0.351
5:	-0.719	0.616
6:	0.381	-0.256
7:	-0.396	-0.267
8:	0.467	-0.994
9:	-0.004	-0.797
10:	-1.579	-1.435

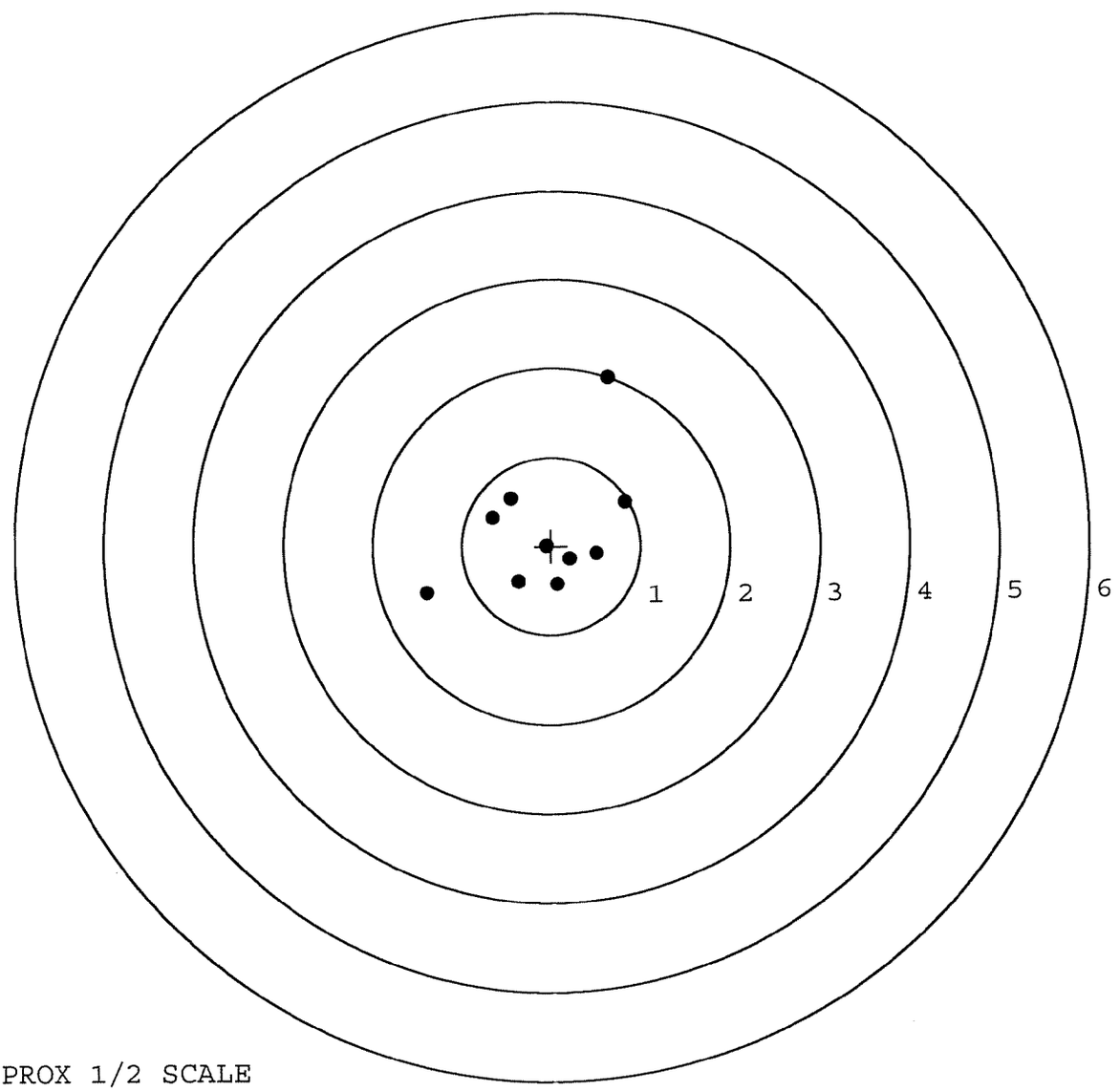


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590148.__0
TARGET NUMBER: 3
FILE DATE: 12/09/2006
FILE TIME: 05:44

X CENTROID:	-0.067
Y CENTROID:	0.164
POA TO CENTROID:	0.177
HORZ SPREAD:	2.230
VERT SPREAD:	2.415
GROUP SPREAD:	3.166
MIN RADIUS:	0.168
MAX RADIUS:	1.872
MEAN RADIUS:	0.794
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-1.397	-0.522
2:	-0.658	0.322
3:	-0.452	0.537
4:	0.833	0.489
5:	0.507	-0.090
6:	-0.059	-0.004
7:	0.211	-0.151
8:	0.068	-0.434
9:	-0.373	-0.401
10:	0.651	1.893

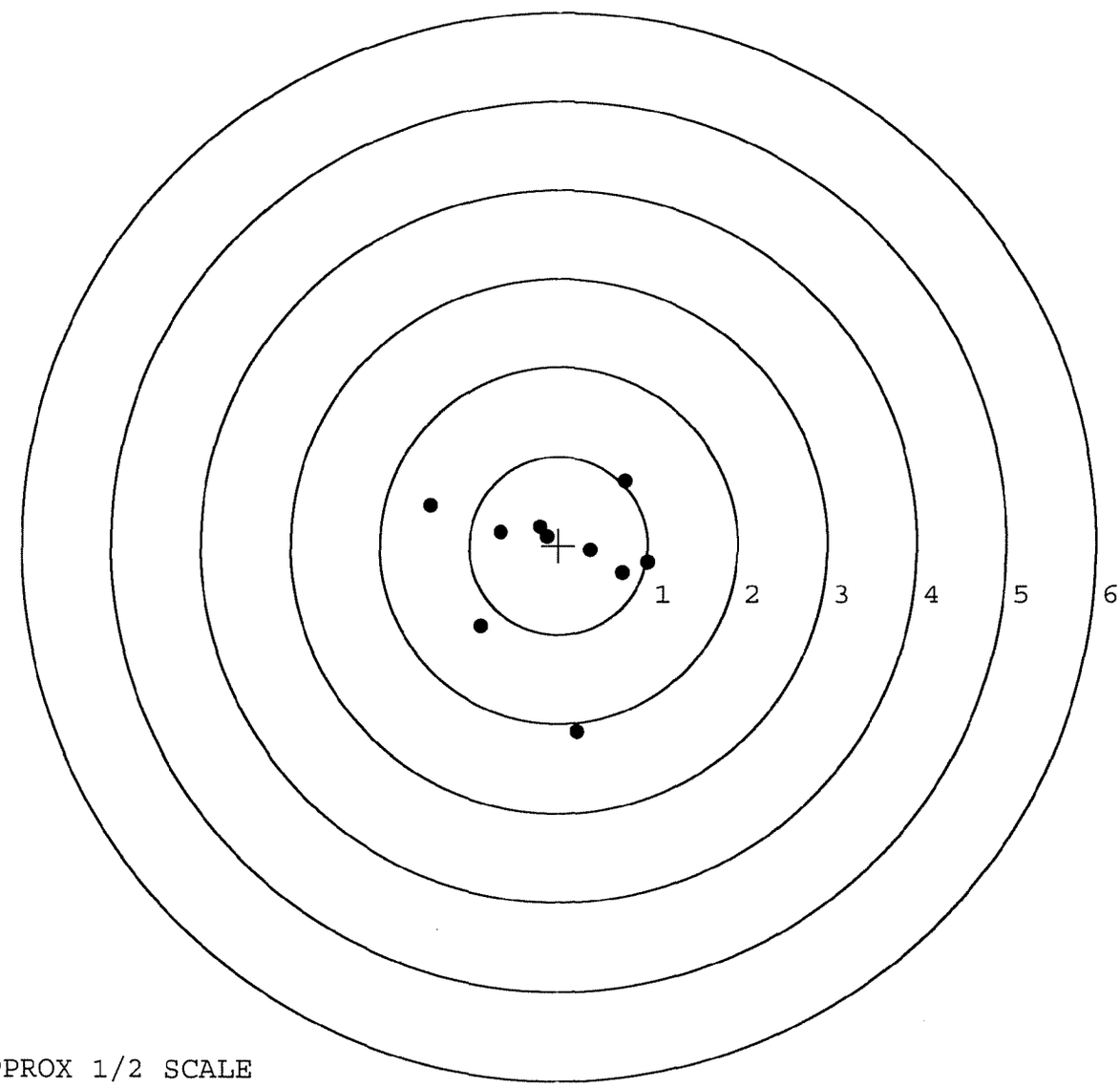


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590148.__0
TARGET NUMBER: 4
FILE DATE: 12/09/2006
FILE TIME: 05:44

X CENTROID:	-0.024
Y CENTROID:	-0.194
POA TO CENTROID:	0.196
HORZ SPREAD:	2.441
VERT SPREAD:	2.819
GROUP SPREAD:	3.038
MIN RADIUS:	0.309
MAX RADIUS:	1.917
MEAN RADIUS:	0.943
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.219	-2.096
2:	-0.871	-0.908
3:	-1.435	0.452
4:	-0.651	0.153
5:	-0.207	0.207
6:	-0.129	0.096
7:	0.354	-0.060
8:	0.725	-0.311
9:	1.006	-0.200
10:	0.748	0.723

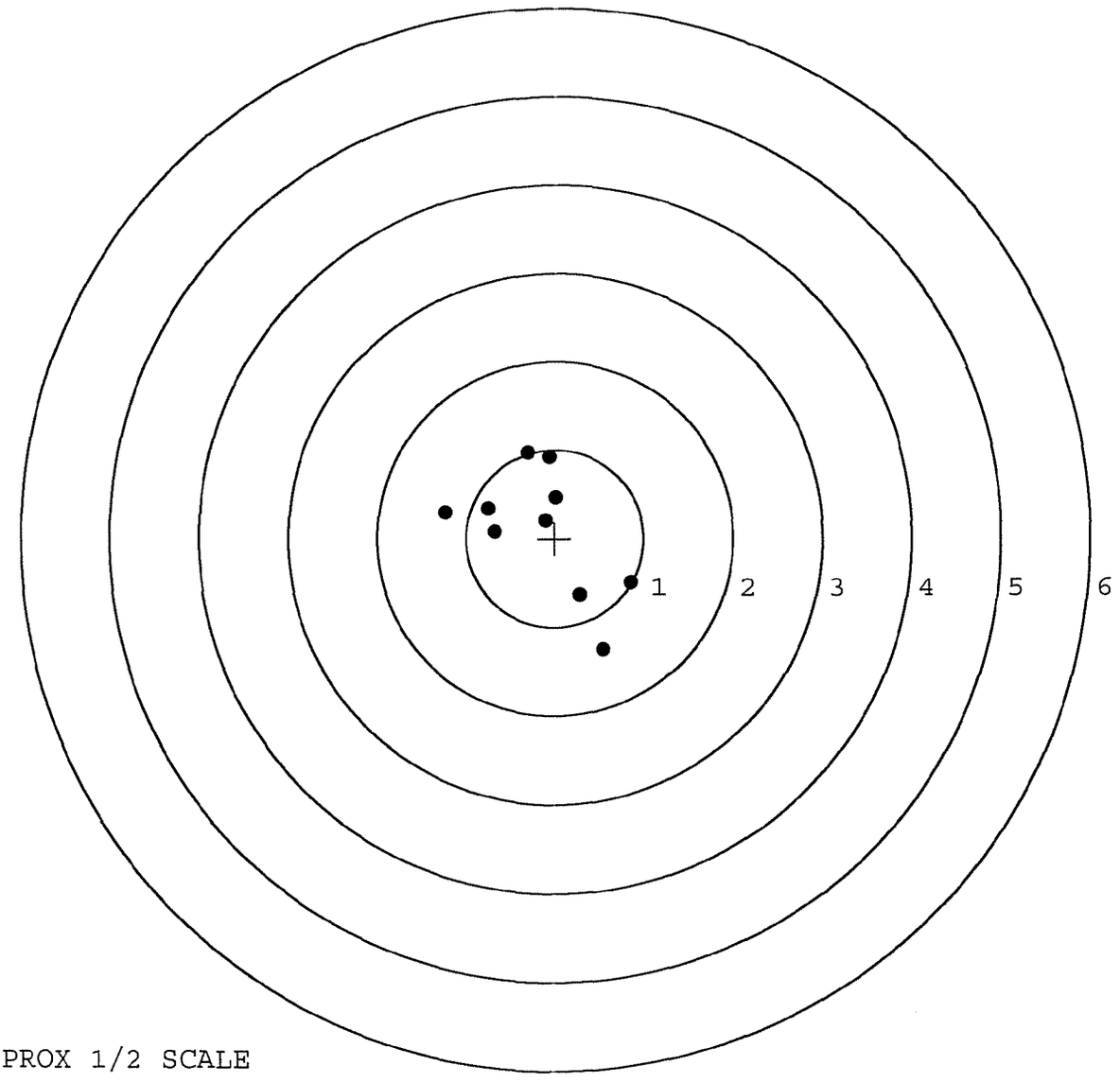


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590148.__0
TARGET NUMBER: 5
FILE DATE: 12/09/2006
FILE TIME: 05:44

X CENTROID:	-0.143
Y CENTROID:	0.086
POA TO CENTROID:	0.166
HORZ SPREAD:	2.098
VERT SPREAD:	2.222
GROUP SPREAD:	2.378
MIN RADIUS:	0.122
MAX RADIUS:	1.507
MEAN RADIUS:	0.809
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.547	-1.254
2:	0.292	-0.643
3:	0.858	-0.503
4:	-1.240	0.298
5:	-0.674	0.075
6:	-0.754	0.338
7:	-0.104	0.202
8:	0.013	0.464
9:	-0.063	0.914
10:	-0.301	0.968



TARGET APPROX 1/2 SCALE