

G6590210

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

- INSTRUCTION BOOK 3518

DD FORM



ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590210



ORDER 25716

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

UPC



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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590210

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-6-06	RTZ
420	ASSEMBLE ACTION		9-13-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		9-13-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED SEP 18 2006	9-13-06	TRW
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	CPD	9/15/06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-18-06	CLW
510	DRILL AND TAP SIGHT HOLES		9-15-06	TRW
520	GOFF BLAST BBL / REC		9-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/20/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-21-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-21-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-21-06	DA
	D) OIL FIRING PIN ASSEMBLY		9-22-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/10/06	WTH
F004 REV 5/2006				

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400166829

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁵</u> <u>7⁹</u> <u>7⁵</u>	10-2-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6⁹</u> <u>5⁹</u> <u>6⁹</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/10/06	noh
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.026</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-22-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/10/06	noh
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-26-06	BLG
	M) IRON SIGHT ALIGNMENT		9-22-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-22-06	BLG
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	9-22-06	noh
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-22-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		10/10/06	noh
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.74</u> <u>2.78</u> <u>2.73</u> <u>2.72</u>	9/25/06	DA
	C) FUNCTION		10/10/06	noh
690	PACK		10/31-06	DA

F004 REV 5/2006

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 9-21-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.58		2.51	
PULL #2	2.45	2.57		2.51	
PULL #3	2.52	2.59		2.55	
PULL #4	2.54	2.60		2.53	
PULL #5	2.43	2.59		2.48	
TOTAL	12.34	12.93		12.58	
AVERAGE	2.46	2.58		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.12		
PULL #2	3.01	3.12		
PULL #3	3.05	3.00		
PULL #4	3.07	3.04		
PULL #5	3.05	3.07		
TOTAL	15.19	15.35		
AVERAGE	3.03	3.07		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.07	4.20		4.13
PULL #2	4.08	4.20		4.15
PULL #3	4.10	4.18		4.14
PULL #4	4.10	4.16		4.14
PULL #5	4.10	4.17		4.16
TOTAL	20.45	20.91		20.72
AVERAGE	4.09	4.18		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590210.___0
FILE DATE AND TIME: 09/25/2006 05:30

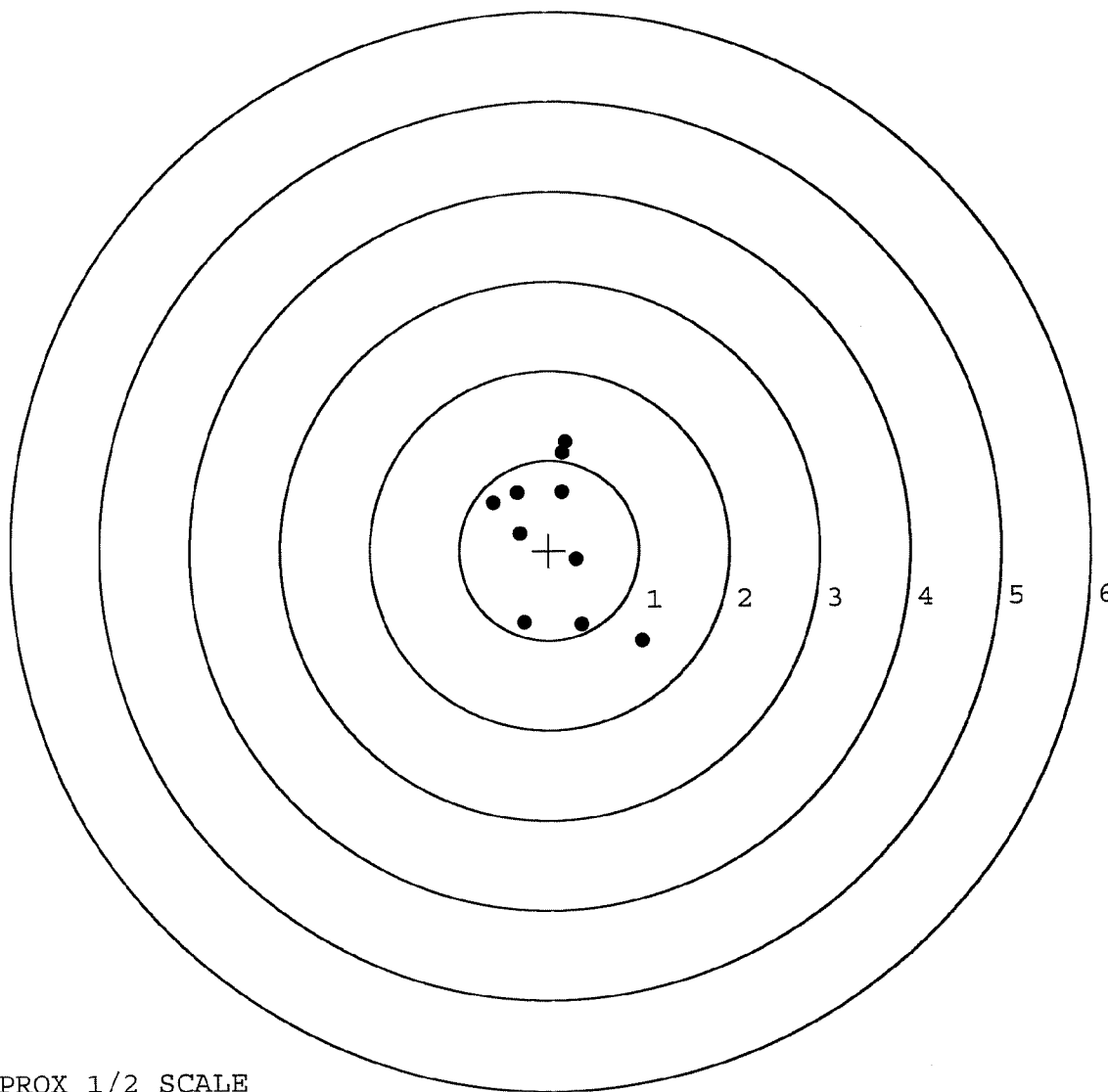
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.003
The Average Y Centroid of the Five Target Set:	0.049
The Average Point of Impact of the Five Target Set:	0.049
The Average Mean Radius of the Five Target Set:	0.761
The Distance from POA to Centroid Target #1:	0.167
The Distance from Centroid Target #2 to Centroid Target #1:	0.097
The Distance from Centroid Target #3 to Centroid Target #1:	0.168
The Distance from Centroid Target #4 to Centroid Target #1:	0.213
The Distance from Centroid Target #5 to Centroid Target #1:	0.190

SERIAL NUMBER: G6590210.___0
TARGET NUMBER: 1
FILE DATE: 09/25/2006
FILE TIME: 05:30

X CENTROID: 0.061
Y CENTROID: 0.156
POA TO CENTROID: 0.167
HORZ SPREAD: 1.647
VERT SPREAD: 2.220
GROUP SPREAD: 2.374
MIN RADIUS: 0.355
MAX RADIUS: 1.522
MEAN RADIUS: 0.822
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.188	1.202
2:	0.149	0.653
3:	-0.352	0.643
4:	-0.617	0.538
5:	-0.324	0.193
6:	0.304	-0.103
7:	-0.282	-0.804
8:	0.365	-0.827
9:	1.030	-1.018
10:	0.154	1.081

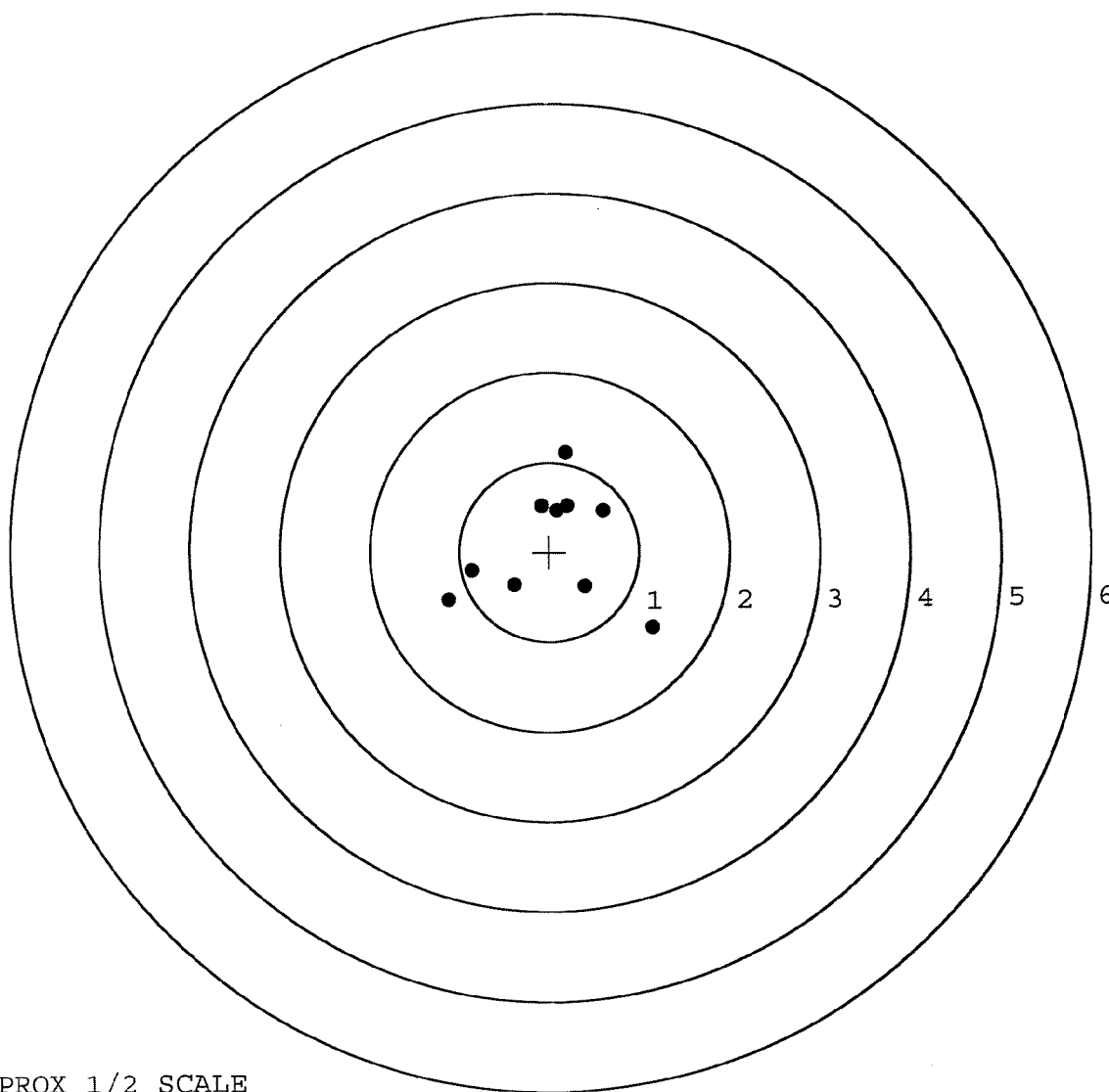


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590210. __0
TARGET NUMBER: 2
FILE DATE: 09/25/2006
FILE TIME: 05:30

POINT#	X	Y
1:	0.187	1.108
2:	0.605	0.455
3:	0.204	0.514
4:	-0.080	0.518
5:	-0.864	-0.203
6:	-1.126	-0.533
7:	-0.389	-0.371
8:	1.144	-0.859
9:	0.399	-0.389
10:	0.090	0.461

X CENTROID: 0.017
Y CENTROID: 0.070
POA TO CENTROID: 0.072
HORZ SPREAD: 2.270
VERT SPREAD: 1.967
GROUP SPREAD: 2.293
MIN RADIUS: 0.398
MAX RADIUS: 1.461
MEAN RADIUS: 0.796
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

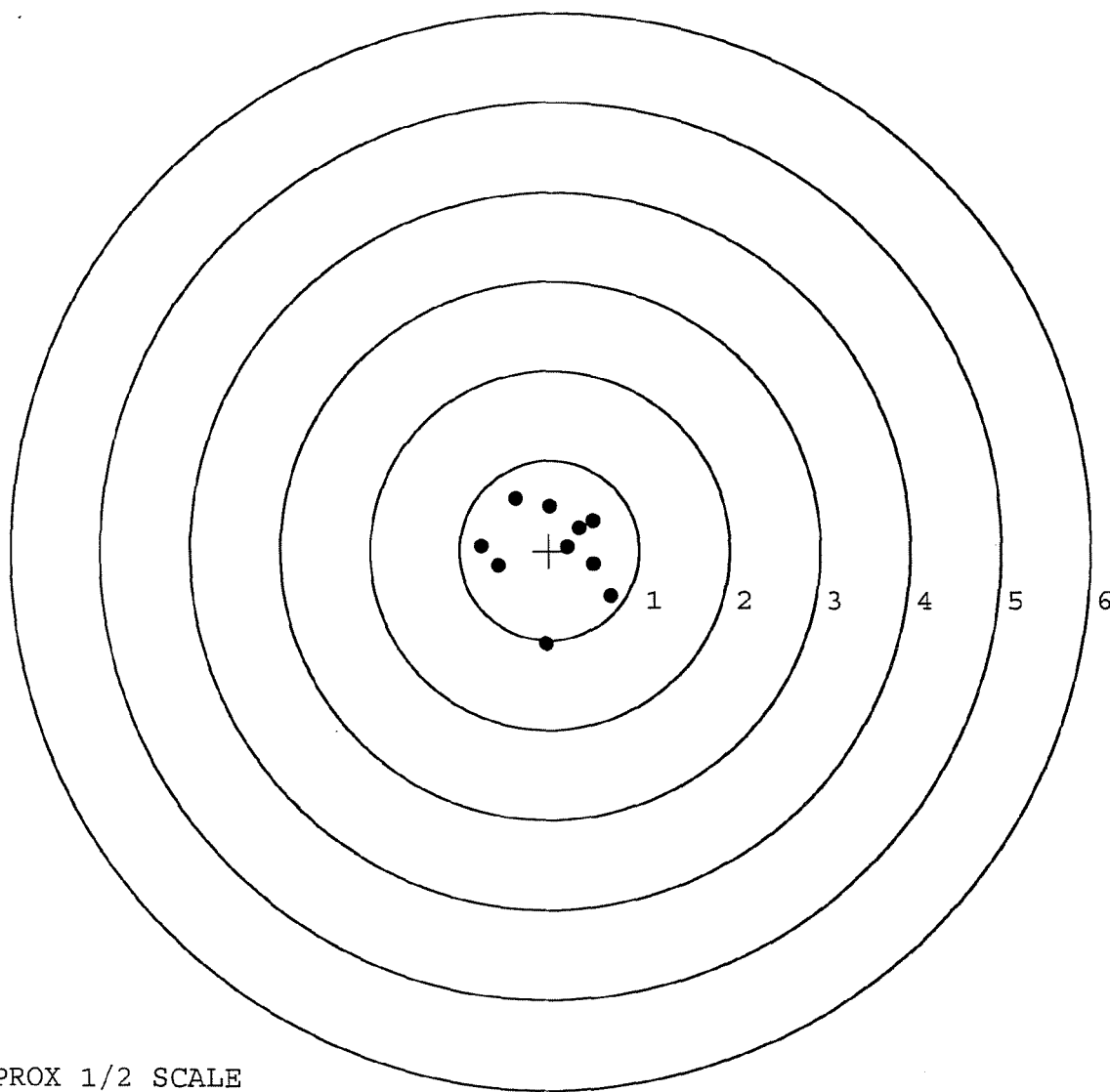


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590210. __ 0
TARGET NUMBER: 3
FILE DATE: 09/25/2006
FILE TIME: 05:30

POINT#	X	Y
1:	-0.030	-1.046
2:	-0.572	-0.168
3:	-0.760	0.050
4:	-0.379	0.579
5:	0.001	0.494
6:	0.481	0.333
7:	0.330	0.253
8:	0.206	0.045
9:	0.490	-0.148
10:	0.692	-0.511

X CENTROID: 0.046
Y CENTROID: -0.012
POA TO CENTROID: 0.047
HORZ SPREAD: 1.452
VERT SPREAD: 1.625
GROUP SPREAD: 1.662
MIN RADIUS: 0.170
MAX RADIUS: 1.037
MEAN RADIUS: 0.611
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

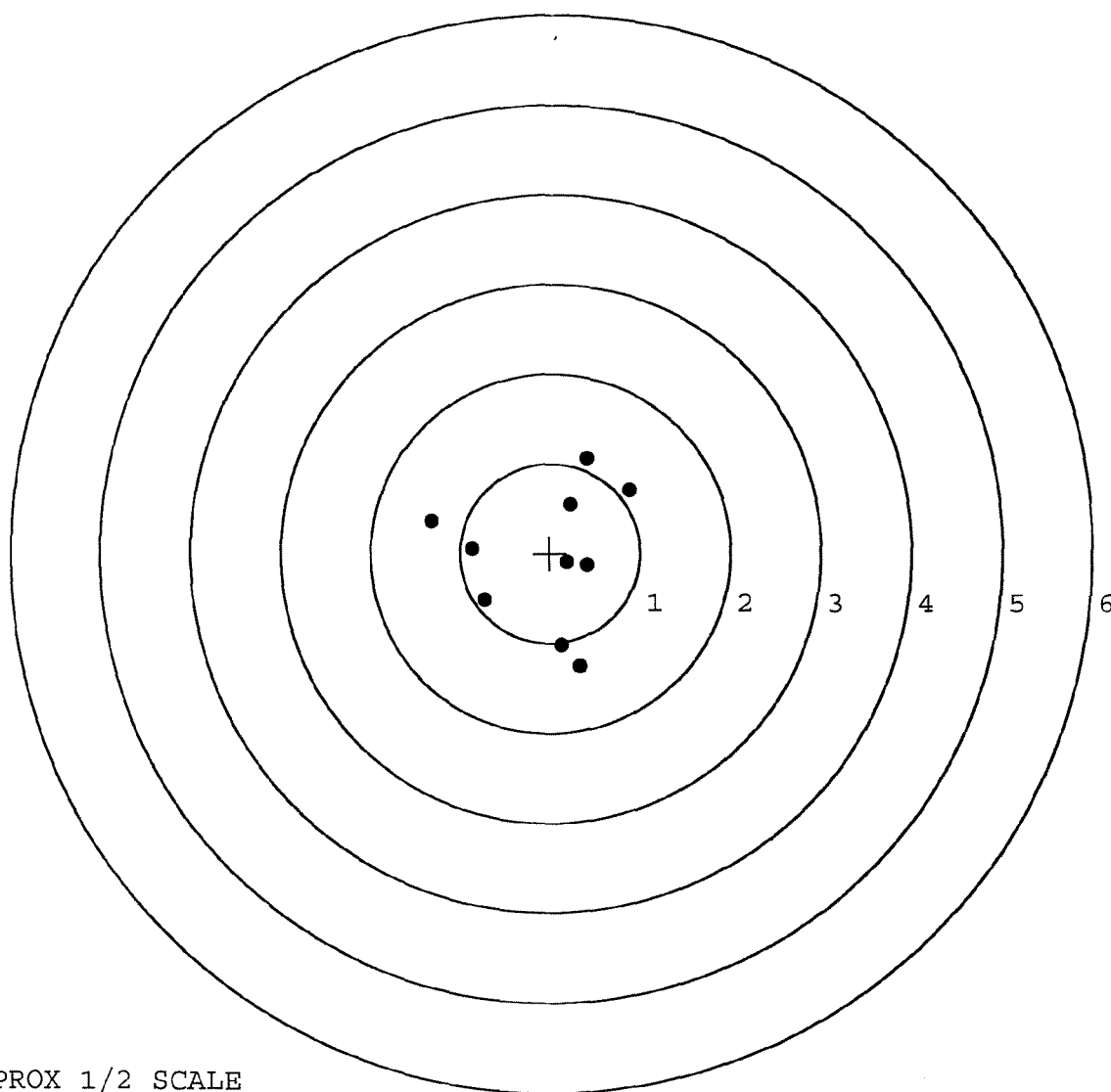


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590210. __0
TARGET NUMBER: 4
FILE DATE: 09/25/2006
FILE TIME: 05:30

X CENTROID: -0.031
Y CENTROID: -0.036
POA TO CENTROID: 0.047
HORZ SPREAD: 2.195
VERT SPREAD: 2.321
GROUP SPREAD: 2.324
MIN RADIUS: 0.232
MAX RADIUS: 1.349
MEAN RADIUS: 0.900
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.321	0.359
2:	-0.863	0.050
3:	-0.724	-0.527
4:	0.139	-1.033
5:	0.341	-1.266
6:	0.408	1.055
7:	0.874	0.701
8:	0.228	0.543
9:	0.420	-0.137
10:	0.190	-0.106

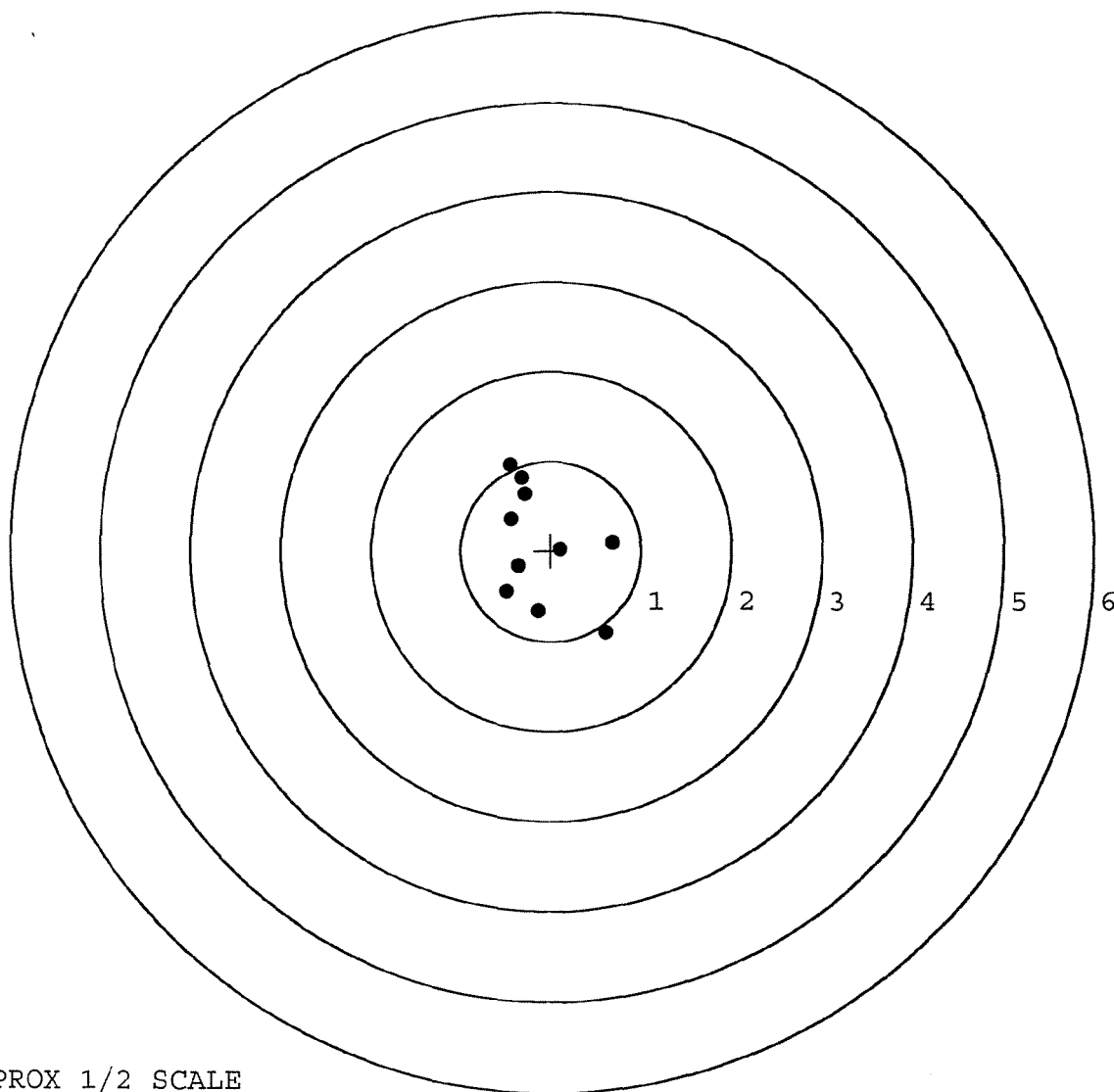


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590210. __0
TARGET NUMBER: 5
FILE DATE: 09/25/2006
FILE TIME: 05:30

POINT#	X	Y
1:	0.620	-0.900
2:	0.688	0.092
3:	-0.138	-0.668
4:	0.112	0.015
5:	-0.488	-0.449
6:	-0.359	-0.169
7:	-0.441	0.356
8:	-0.458	0.963
9:	-0.322	0.814
10:	-0.293	0.635

X CENTROID: -0.108
Y CENTROID: 0.069
POA TO CENTROID: 0.128
HORZ SPREAD: 1.176
VERT SPREAD: 1.863
GROUP SPREAD: 2.152
MIN RADIUS: 0.226
MAX RADIUS: 1.212
MEAN RADIUS: 0.673
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE