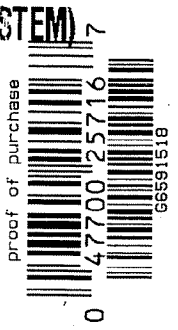
6/5/15

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

– INSTUCTION BOOK 3518

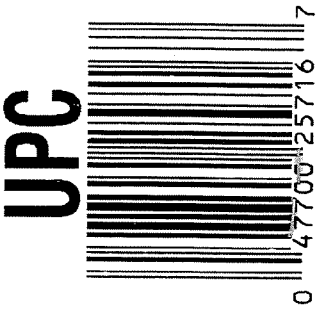
DD FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6591518



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 659151 8

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-17-06	RTL
420	ASSEMBLE ACTION		10-17-06	RTL
430	ASSEMBLE TO STOCK		10-17-06	L.P.D.
440	PROOF		10-17-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED OCT 19 2006	10-17-06	L.P.D.
470	DIS-ASSEMBLE ACTION		10-18-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR APD	10-19-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-20-06	CW
510	DRILL AND TAP SIGHT HOLES		10-18-06	MW
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		11/17/06	MOH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/17/06	MOH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/17/06	MOH
	D) OIL FIRING PIN ASSEMBLY		11-30-06	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

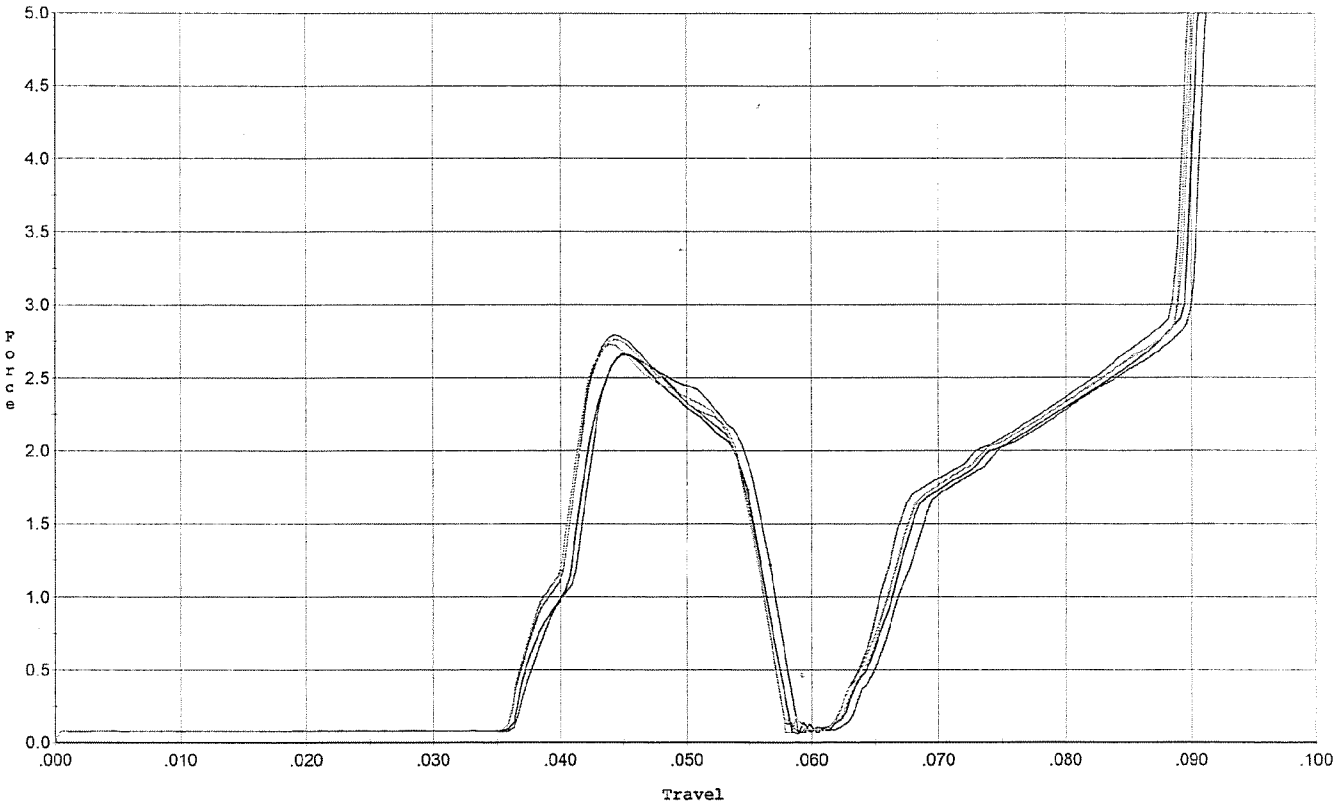
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5# 5# 5#	12-13-06	SD
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	8# 9# 8#	12-13-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.024 .025 .025	12-13-06	SD
	J) ASSEMBLE STOCK		11-30-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		12-18-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-18-06	L.P.D.
	M) IRON SIGHT ALIGNMENT		12-18-06	L.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-18-06	L.P.D.
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	12/4/06	[illegible]
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12/4/06	MJD
670	FINAL INSPECTION A) HEADSPACE		12-18-06	L.P.D.
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.61 2.49 2.37 2.43 2.40	12-12-06	BLG
	C) FUNCTION		12-18-06	L.P.D.
690	PACK		2.6.07	DA

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:	R. Putch 11/09/06		



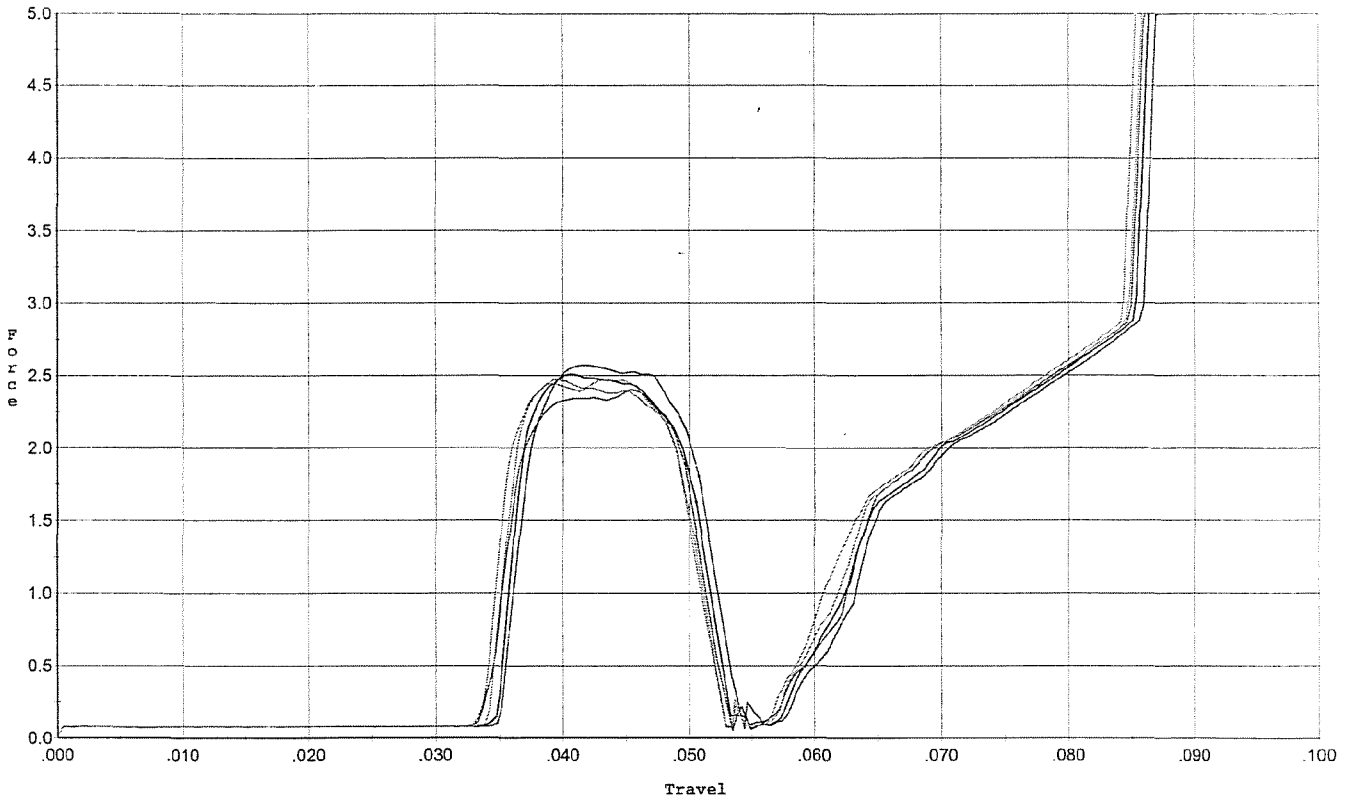
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.667	0.057	0.037	0.041	0.041		Set Trigger
2	2.660	0.055	0.037	0.041	0.039		Set Trigger
3	2.794	0.055	0.036	0.040	0.041		Set Trigger
4	2.728	0.055	0.036	0.040	0.041		Set Trigger
5	2.766	0.055	0.036	0.040	0.041		Set Trigger

Avg 2.72

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:03:37 AM

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:	R. Putch 11/09/06		



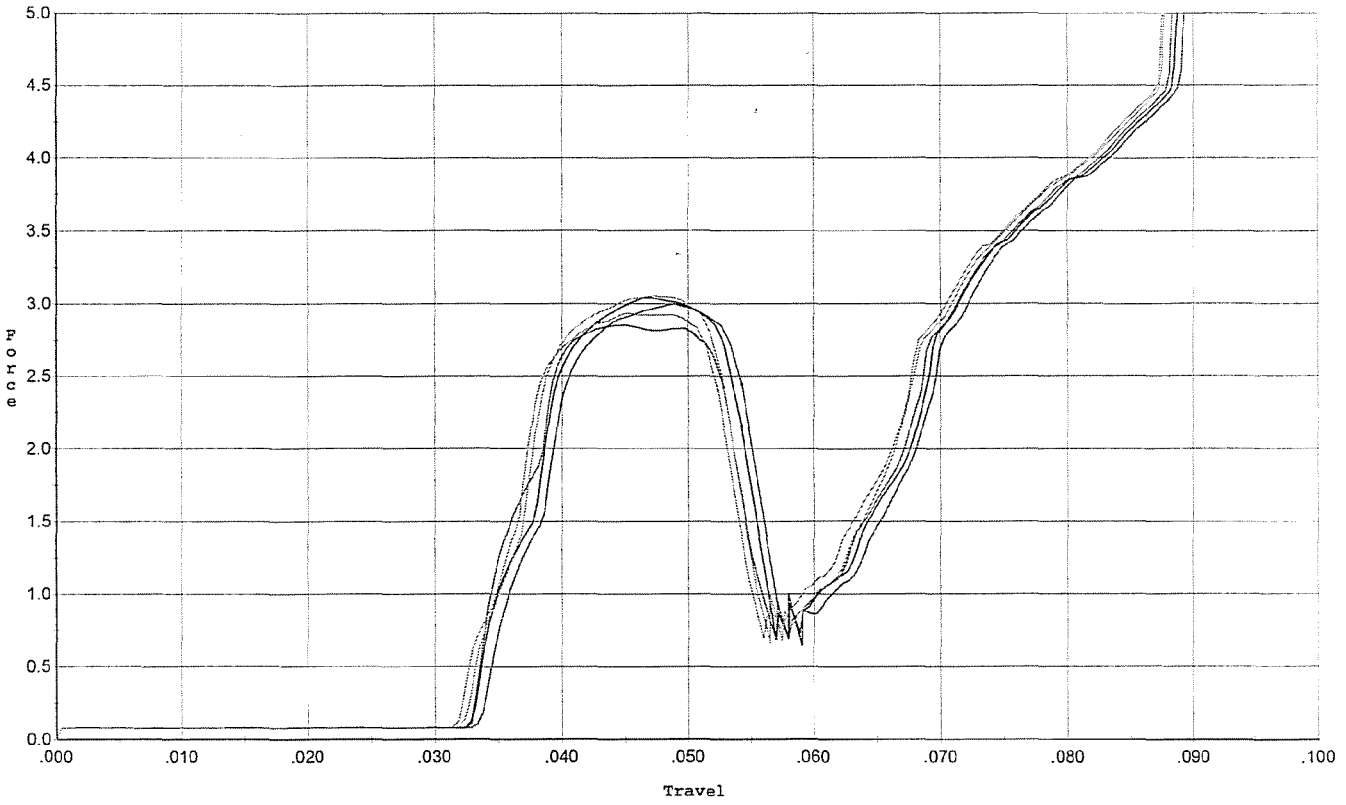
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.570	0.051	0.035	0.040	0.038		Set Trigger
2	2.509	0.051	0.035	0.040	0.037		Set Trigger
3	2.404	0.050	0.034	0.040	0.036		Set Trigger
4	2.469	0.050	0.034	0.039	0.038		Set Trigger
5	2.472	0.049	0.034	0.039	0.037		Set Trigger

Avg 2.48

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:05:55 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini.
Note:	R. Putch 11/09/06		



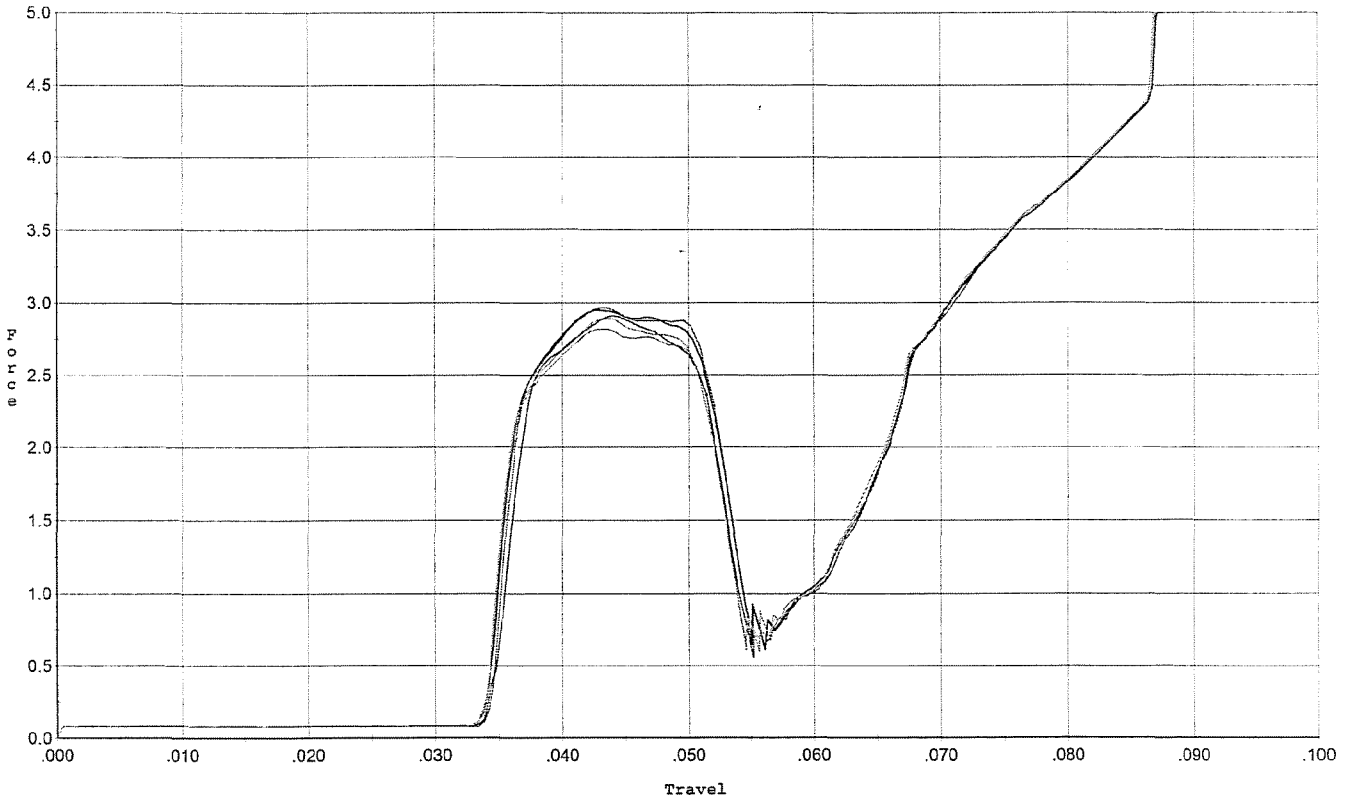
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.997	0.054	0.034	0.039	0.052		Set Trigger
2	3.045	0.054	0.033	0.038	0.054		Set Trigger
3	2.853	0.053	0.033	0.038	0.051		Set Trigger
4	3.054	0.053	0.033	0.038	0.052		Set Trigger
5	2.935	0.052	0.032	0.038	0.051		Set Trigger

Avg 2.97

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:09:07 AM

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:	R. Putch 11/09/06		



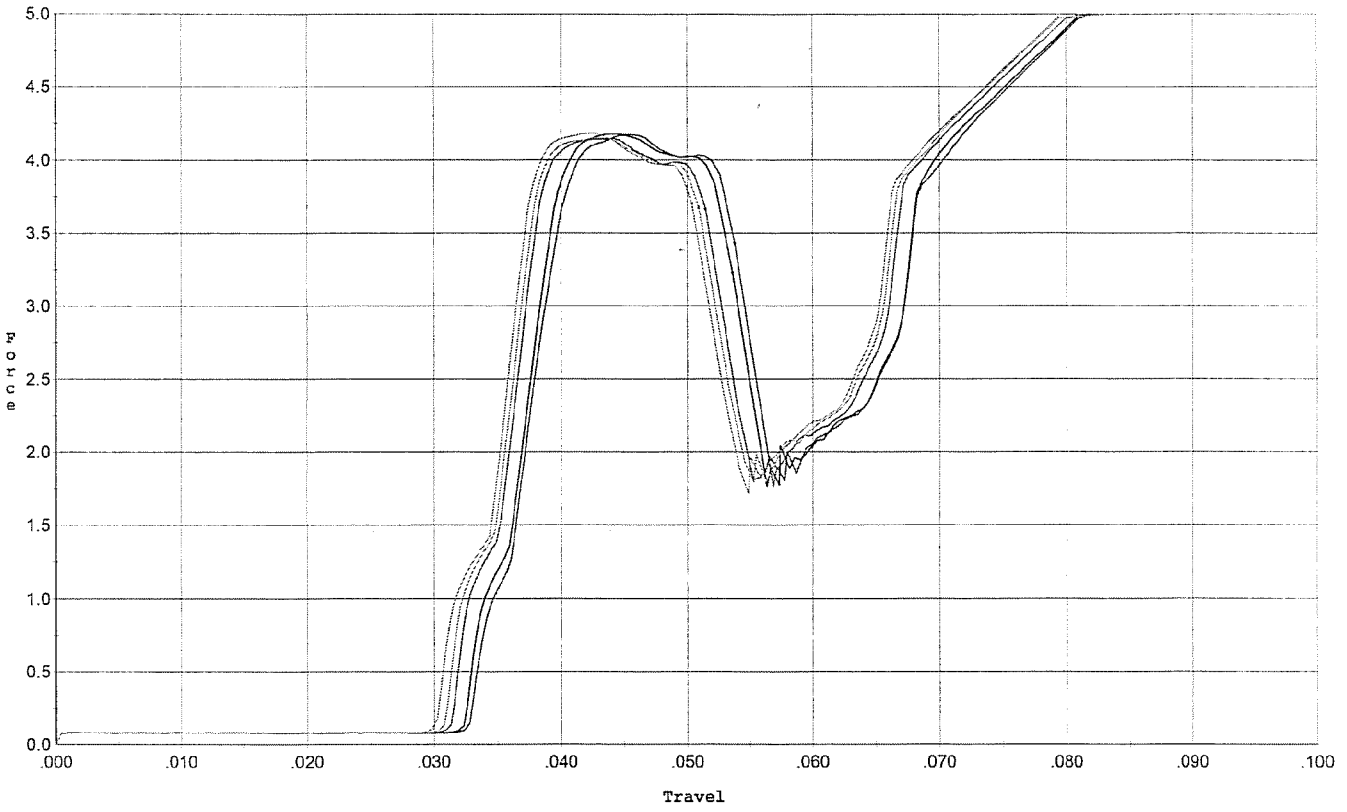
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.912	0.051	0.034	0.038	0.047		Set Trigger
2	2.948	0.052	0.034	0.038	0.050		Set Trigger
3	2.964	0.052	0.034	0.038	0.050		Set Trigger
4	2.892	0.052	0.034	0.038	0.048		Set Trigger
5	2.820	0.052	0.034	0.038	0.047		Set Trigger

Avg 2.90

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:11:46 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	R. Putch 11/09/06		



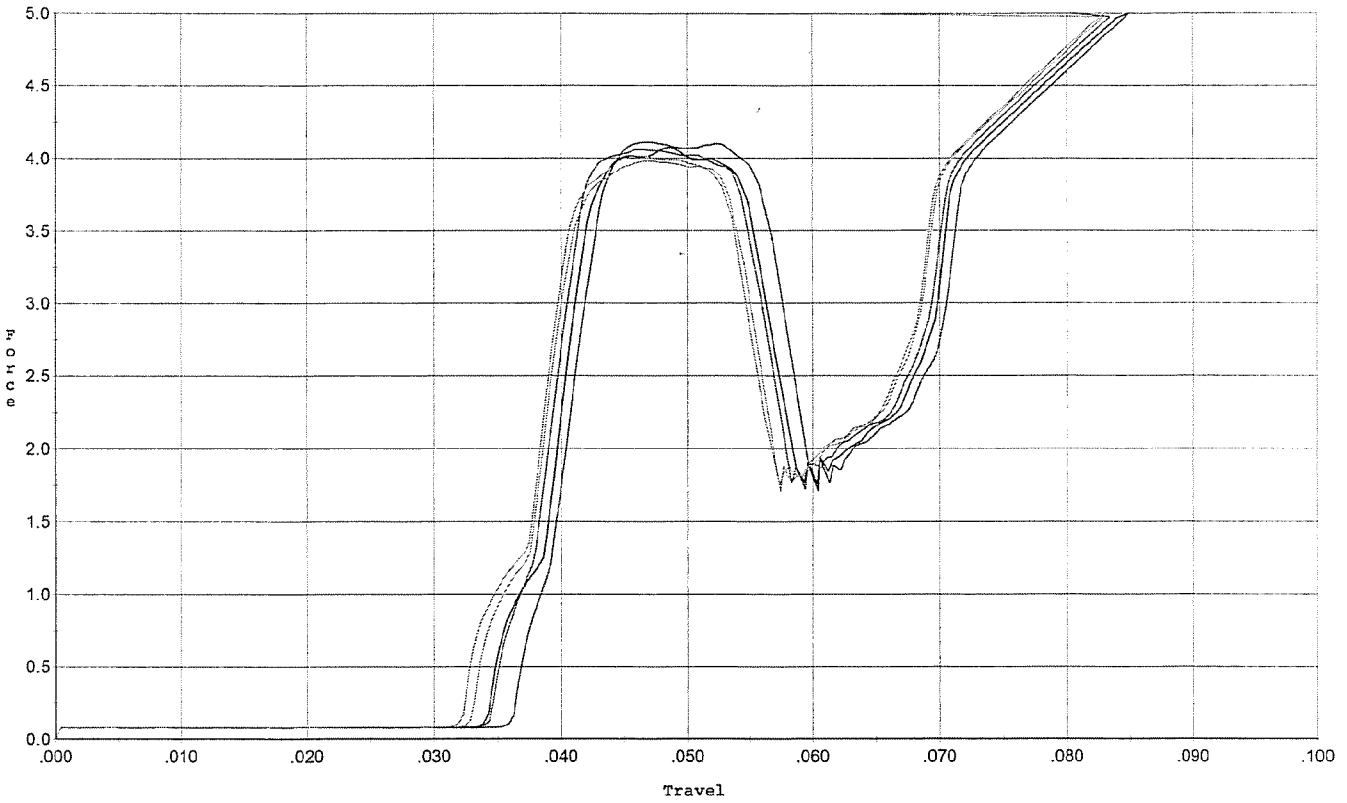
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.173	0.054	0.033	0.036	0.073		Set Trigger
2	4.177	0.054	0.033	0.036	0.074		Set Trigger
3	4.145	0.051	0.032	0.036	0.071		Set Trigger
4	4.151	0.051	0.031	0.036	0.070		Set Trigger
5	4.182	0.050	0.030	0.036	0.070		Set Trigger

Avg 4.16

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:17:55 AM

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:	R. Putch 11/09/06		



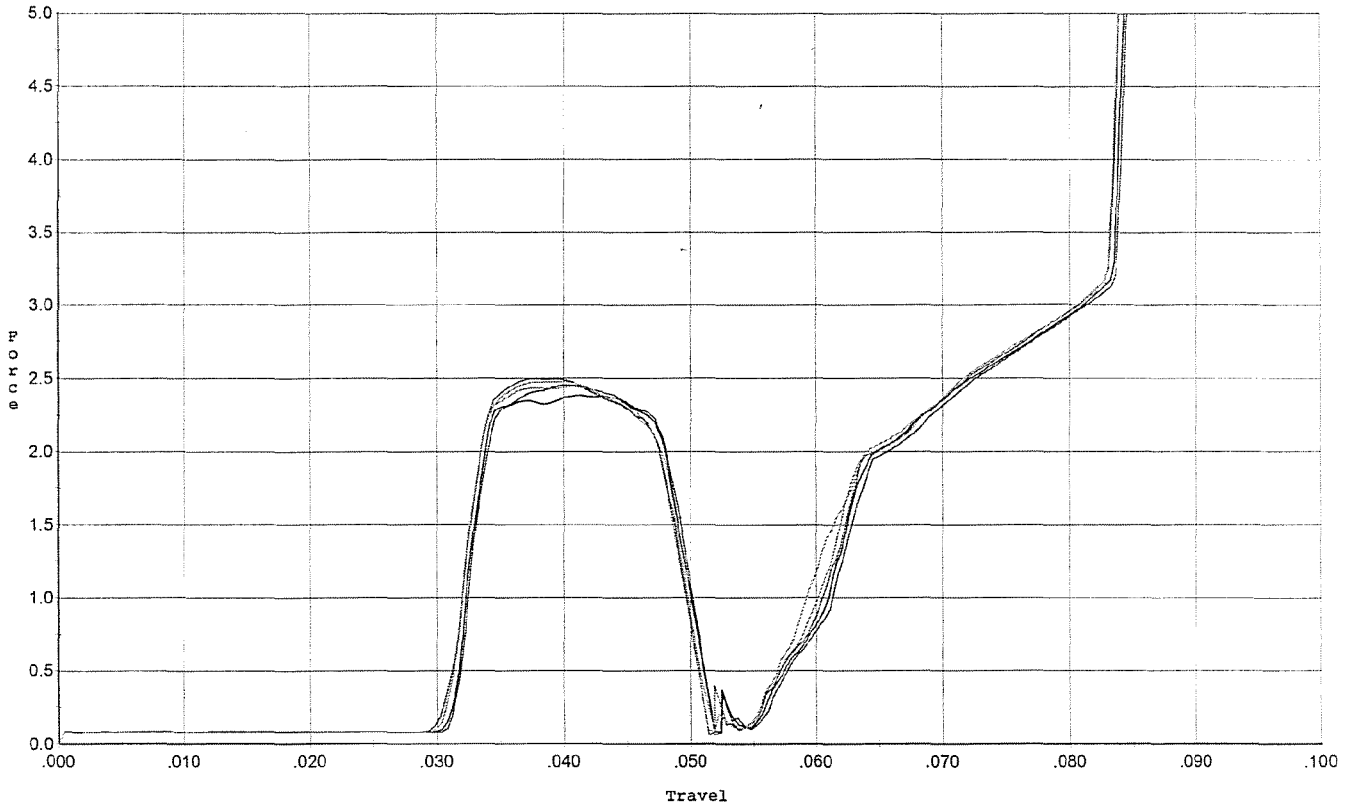
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.113	0.057	0.036	0.037	0.073		Set Trigger
2	4.074	0.055	0.034	0.037	0.070		Set Trigger
3	4.064	0.056	0.035	0.037	0.073		Set Trigger
4	3.982	0.055	0.033	0.037	0.070		Set Trigger
5	4.015	0.054	0.032	0.037	0.069		Set Trigger

Avg 4.05

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:20:20 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 for final test
Note:	R. Putch 11/09/06		



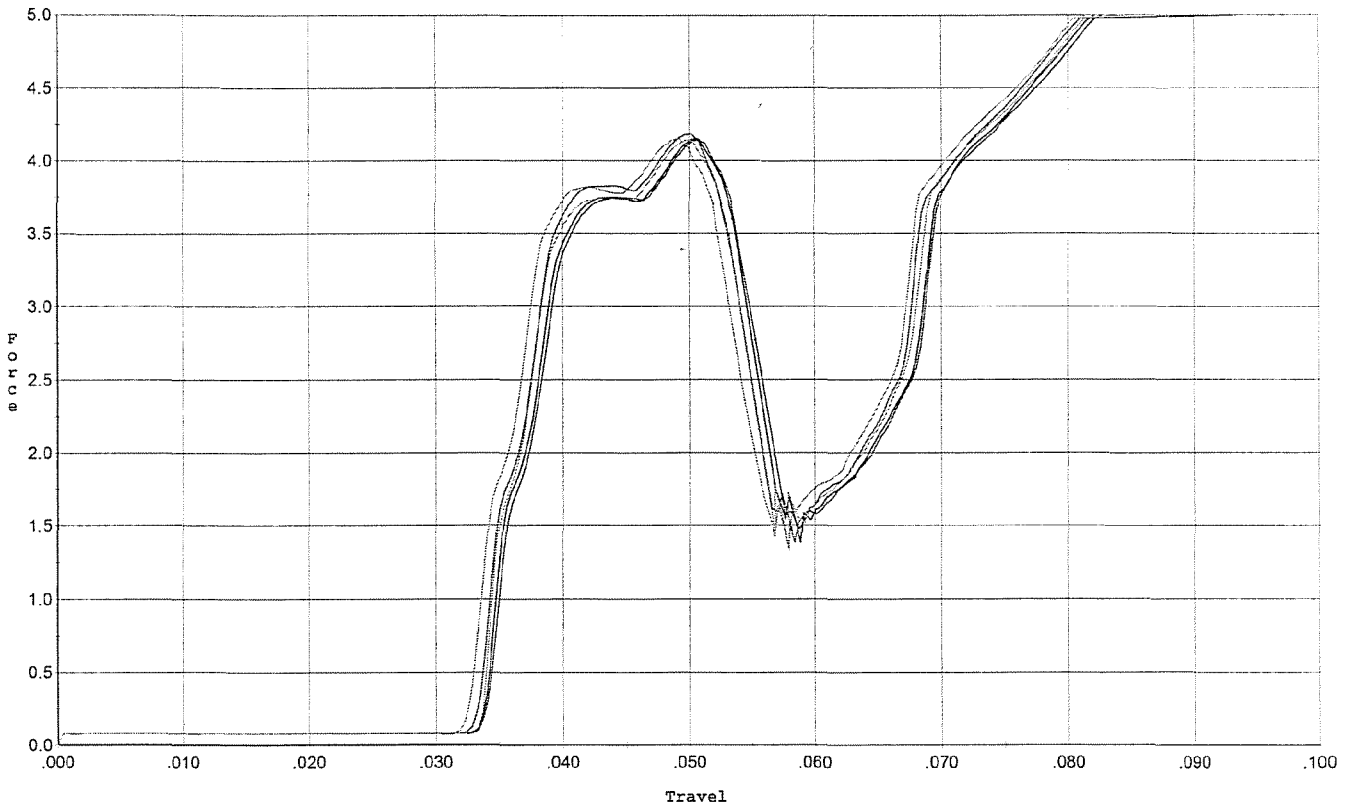
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.455	0.049	0.031	0.039	0.041		Set Trigger
2	2.383	0.048	0.031	0.039	0.039		Set Trigger
3	2.499	0.049	0.030	0.039	0.041		Set Trigger
4	2.477	0.048	0.031	0.039	0.041		Set Trigger
5	2.445	0.049	0.031	0.039	0.041		Set Trigger

AVG 2.45

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:32:08 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. for target & accuracy
Note:	R. Putch 11/09/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.144	0.055	0.034	0.036	0.073		Set Trigger
2	4.150	0.054	0.034	0.036	0.071		Set Trigger
3	4.182	0.053	0.033	0.036	0.072		Set Trigger
4	4.139	0.053	0.034	0.036	0.070		Set Trigger
5	4.151	0.052	0.032	0.036	0.070		Set Trigger

Avg 4.15

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/9/2006 8:43:43 AM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591518.__0
FILE DATE AND TIME: 12/05/2006 06:02

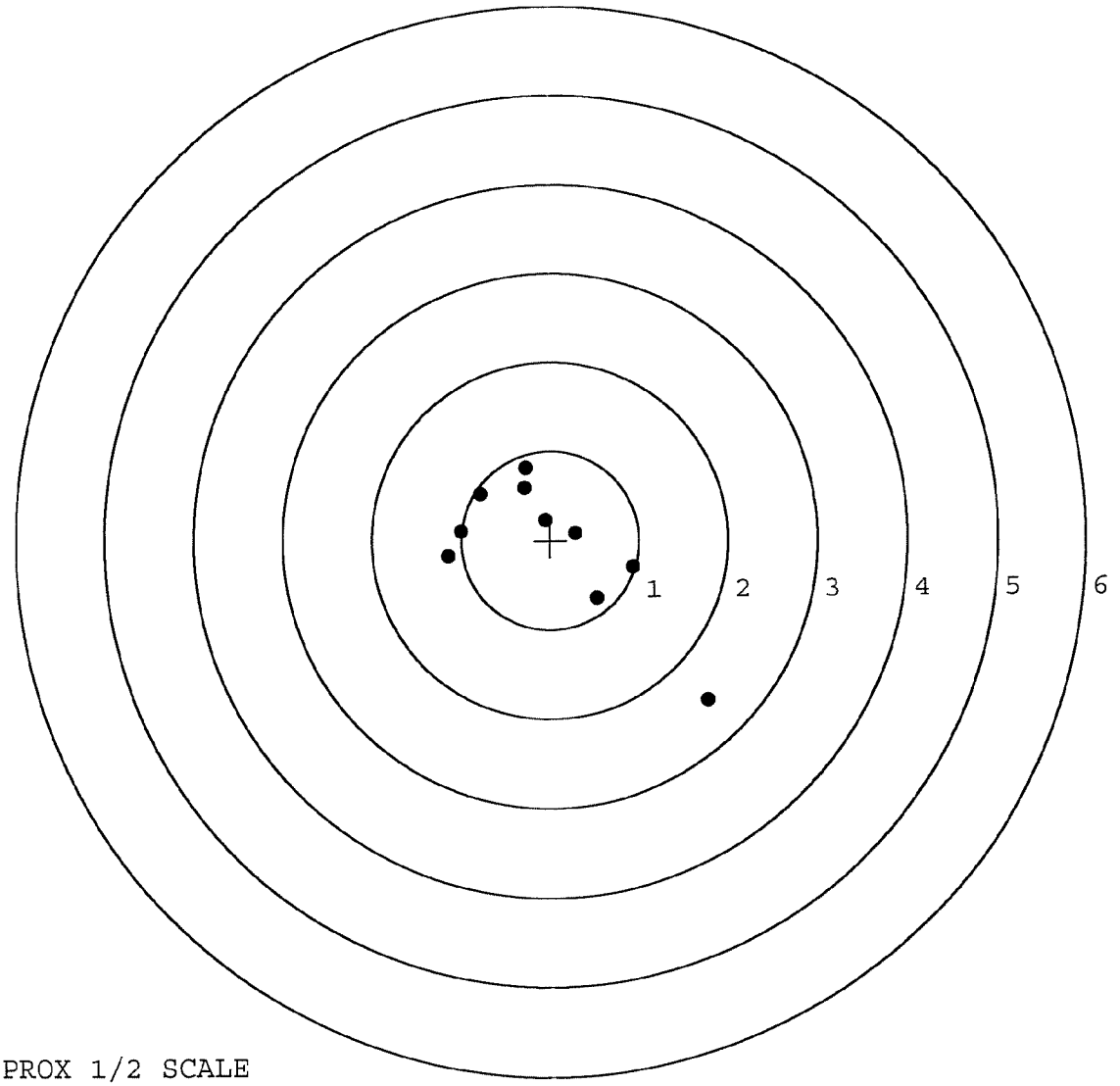
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	0.055
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.759
The Distance from POA to Centroid Target #1:	0.058
The Distance from Centroid Target #2 to Centroid Target #1:	0.159
The Distance from Centroid Target #3 to Centroid Target #1:	0.170
The Distance from Centroid Target #4 to Centroid Target #1:	0.143
The Distance from Centroid Target #5 to Centroid Target #1:	0.151

SERIAL NUMBER: G6591518.__0
TARGET NUMBER: 1
FILE DATE: 12/05/2006
FILE TIME: 06:02

X CENTROID:	-0.006
Y CENTROID:	-0.058
POA TO CENTROID:	0.058
HORZ SPREAD:	2.923
VERT SPREAD:	2.610
GROUP SPREAD:	3.454
MIN RADIUS:	0.293
MAX RADIUS:	2.489
MEAN RADIUS:	0.961
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.770	-1.802
2:	0.523	-0.647
3:	0.927	-0.302
4:	0.284	0.084
5:	-0.057	0.230
6:	-0.292	0.590
7:	-0.274	0.808
8:	-0.783	0.524
9:	-1.003	0.112
10:	-1.153	-0.177

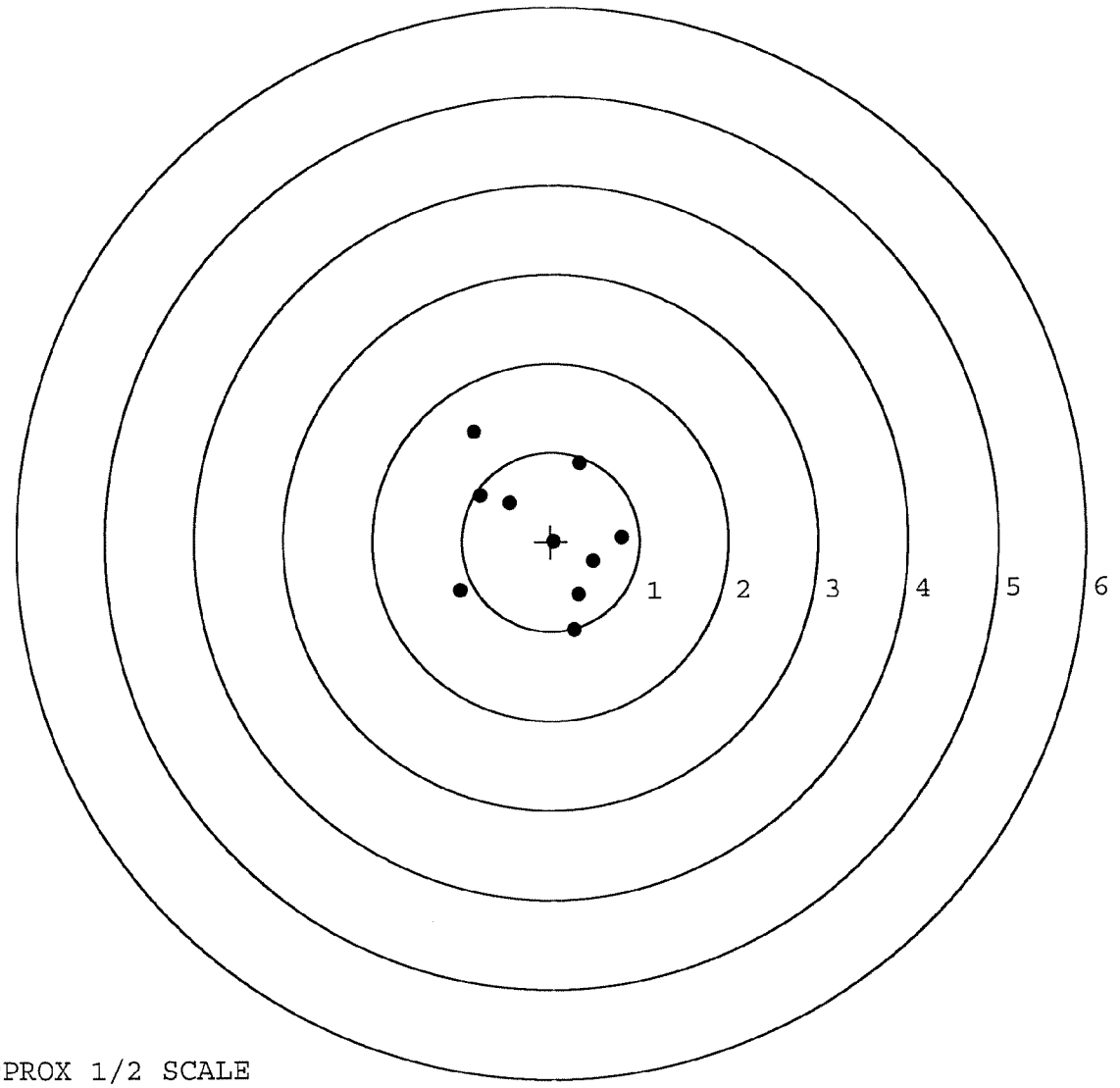


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591518.__0
TARGET NUMBER: 2
FILE DATE: 12/05/2006
FILE TIME: 06:02

X CENTROID:	-0.093
Y CENTROID:	0.074
POA TO CENTROID:	0.119
HORZ SPREAD:	1.823
VERT SPREAD:	2.226
GROUP SPREAD:	2.488
MIN RADIUS:	0.141
MAX RADIUS:	1.388
MEAN RADIUS:	0.832
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.856	1.234
2:	-0.788	0.514
3:	-0.462	0.427
4:	0.329	0.875
5:	-1.026	-0.541
6:	0.255	-0.992
7:	0.309	-0.597
8:	0.479	-0.223
9:	0.797	0.041
10:	0.030	0.005

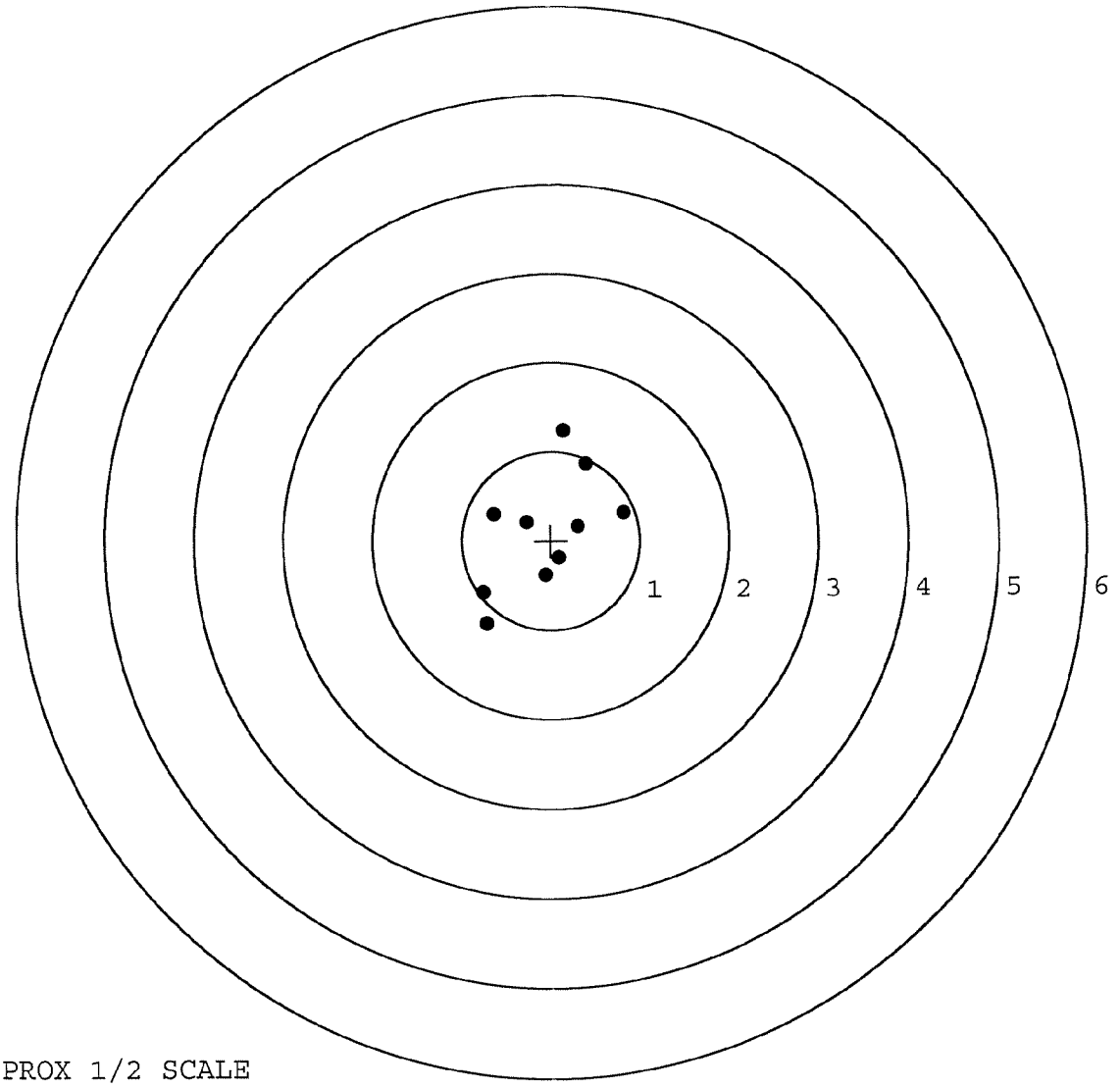


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591518.__0
TARGET NUMBER: 3
FILE DATE: 12/05/2006
FILE TIME: 06:02

X CENTROID:	-0.071
Y CENTROID:	0.099
POA TO CENTROID:	0.122
HORZ SPREAD:	1.580
VERT SPREAD:	2.159
GROUP SPREAD:	2.327
MIN RADIUS:	0.234
MAX RADIUS:	1.215
MEAN RADIUS:	0.720
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.722	-0.927
2:	-0.762	-0.585
3:	-0.642	0.305
4:	-0.278	0.208
5:	-0.062	-0.393
6:	0.089	-0.194
7:	0.306	0.163
8:	0.818	0.315
9:	0.395	0.863
10:	0.146	1.232

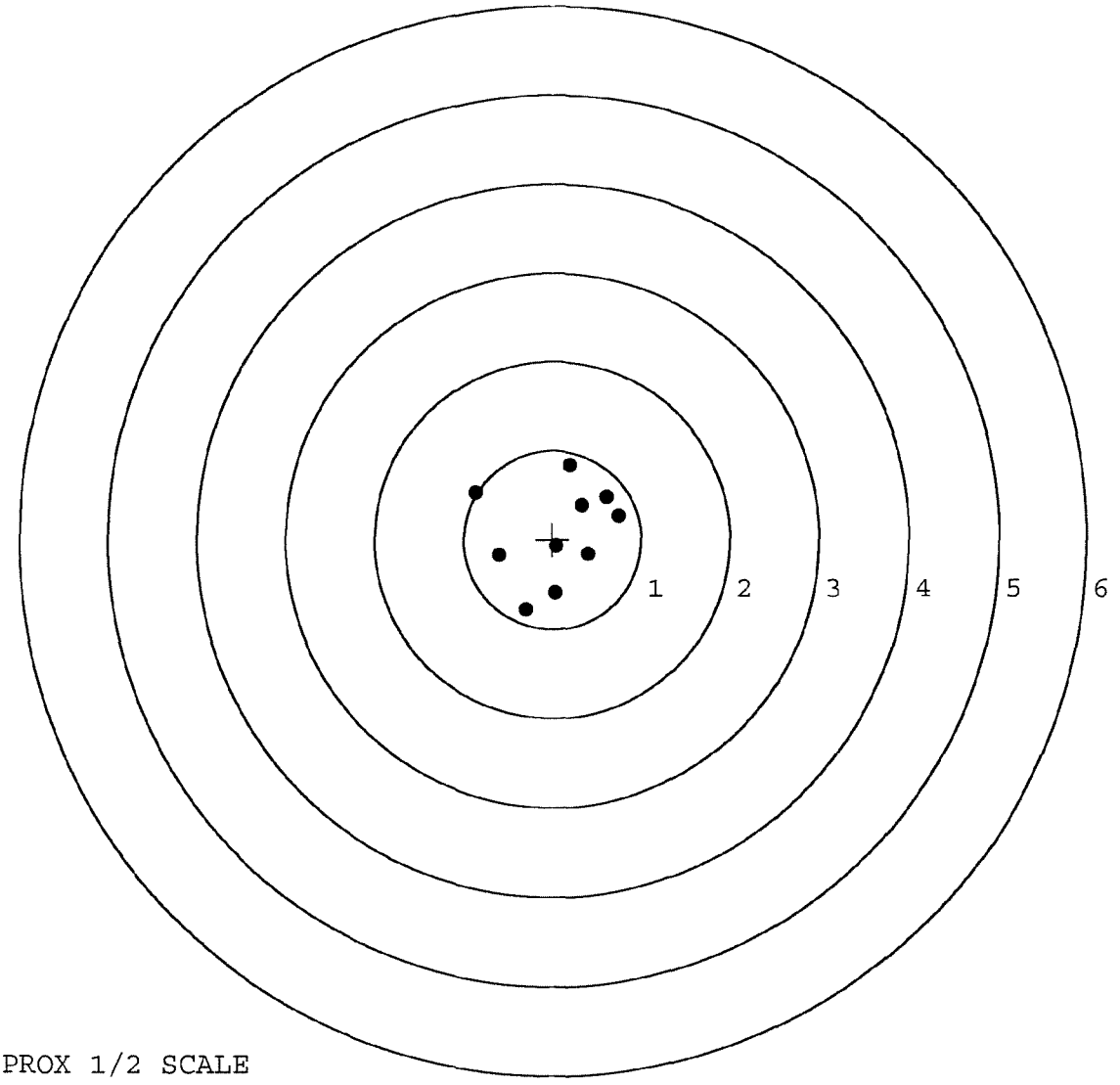


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591518.__0
TARGET NUMBER: 4
FILE DATE: 12/05/2006
FILE TIME: 06:02

X CENTROID:	0.059
Y CENTROID:	0.069
POA TO CENTROID:	0.091
HORZ SPREAD:	1.613
VERT SPREAD:	1.627
GROUP SPREAD:	1.634
MIN RADIUS:	0.149
MAX RADIUS:	1.033
MEAN RADIUS:	0.651
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.867	0.527
2:	0.195	0.834
3:	0.333	0.391
4:	0.608	0.485
5:	0.746	0.267
6:	0.405	-0.161
7:	0.041	-0.079
8:	-0.602	-0.179
9:	0.029	-0.600
10:	-0.302	-0.793

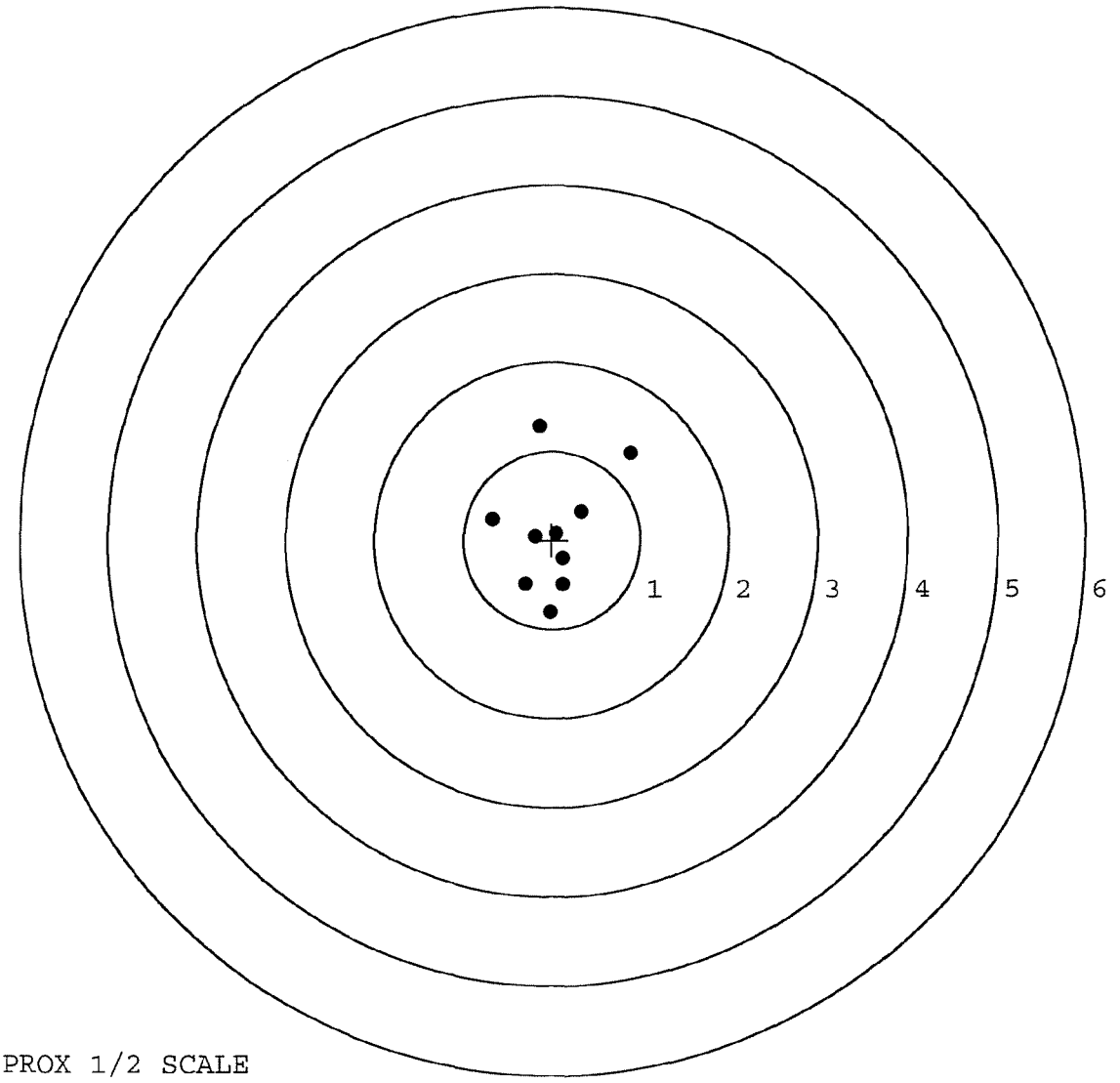


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591518.__0
TARGET NUMBER: 5
FILE DATE: 12/05/2006
FILE TIME: 06:02

X CENTROID:	0.018
Y CENTROID:	0.091
POA TO CENTROID:	0.093
HORZ SPREAD:	1.562
VERT SPREAD:	2.092
GROUP SPREAD:	2.011
MIN RADIUS:	0.038
MAX RADIUS:	1.243
MEAN RADIUS:	0.629
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.149	1.278
2:	0.888	0.979
3:	-0.023	-0.814
4:	-0.306	-0.499
5:	0.125	-0.505
6:	0.126	-0.207
7:	0.329	0.326
8:	-0.191	0.041
9:	-0.674	0.236
10:	0.053	0.077



TARGET APPROX 1/2 SCALE