

G-659/1580

ORDER 25716

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

UPC



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ORDER 25716

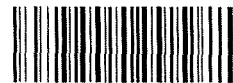
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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SERIAL NO.

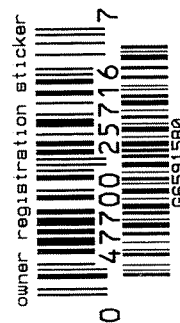


66591580

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

G6591580



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591580

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-16-06	RTZ
420	ASSEMBLE ACTION		8-16-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		8-16-06	L.P.D.
460	CHECK HEADSPACE		8-16-06	L.P.D.
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION		8-17-06	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-17-06	TRW
520	GOFF BLAST BBL / REC		8-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8-24-06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-30-06	WMS
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-30-06	WMS
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-30-06	WMS
	D) OIL FIRING PIN ASSEMBLY		9-7-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/16/06	WMS

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>5.0</u>	9-9-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	9-9-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	mm
	I) FIRING PIN INDENT .020 MIN	<u>1.025</u> <u>1.025</u> <u>1.024</u>	9-9-06	RA
	J) ASSEMBLE STOCK		9-7-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/16/06	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-7-06	BLC
	M) IRON SIGHT ALIGNMENT		9-7-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-7-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-7-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/7/06	mm
670	FINAL INSPECTION A) HEADSPACE		10/16/06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.67</u> <u>2.35</u> <u>2.52</u> <u>2.41</u>	9-9-06	RA
	C) FUNCTION		10/16/06	mm
690	PACK		11/4/06	RA

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 9-6-06

TESTER MJM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.57		2.50	
PULL #2	2.57	2.50		2.47	
PULL #3	2.60	2.49		2.51	
PULL #4	2.70	2.46		2.48	
PULL #5	2.64	2.42		2.55	
TOTAL	13.13	12.44		12.51	
AVERAGE	2.63	2.49		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.09		
PULL #2	3.08	3.10		
PULL #3	3.14	3.06		
PULL #4	3.14	3.06		
PULL #5	3.05	3.07		
TOTAL	15.52	15.38		
AVERAGE	3.10	3.08		

	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	4.00	4.04		4.10
PULL #2	4.17	3.83		4.12
PULL #3	4.13	3.98		4.08
PULL #4	4.14	3.94		4.11
PULL #5	4.14	4.00		4.14
TOTAL	20.63	19.79		20.55
AVERAGE	4.13	3.96		4.11

EVALUATION RECORD - M-24 TRIGGER ASSEMBLY

F005 REV 5/2006

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

M2400168246

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591580.___0
FILE DATE AND TIME: 09/07/2006 06:08

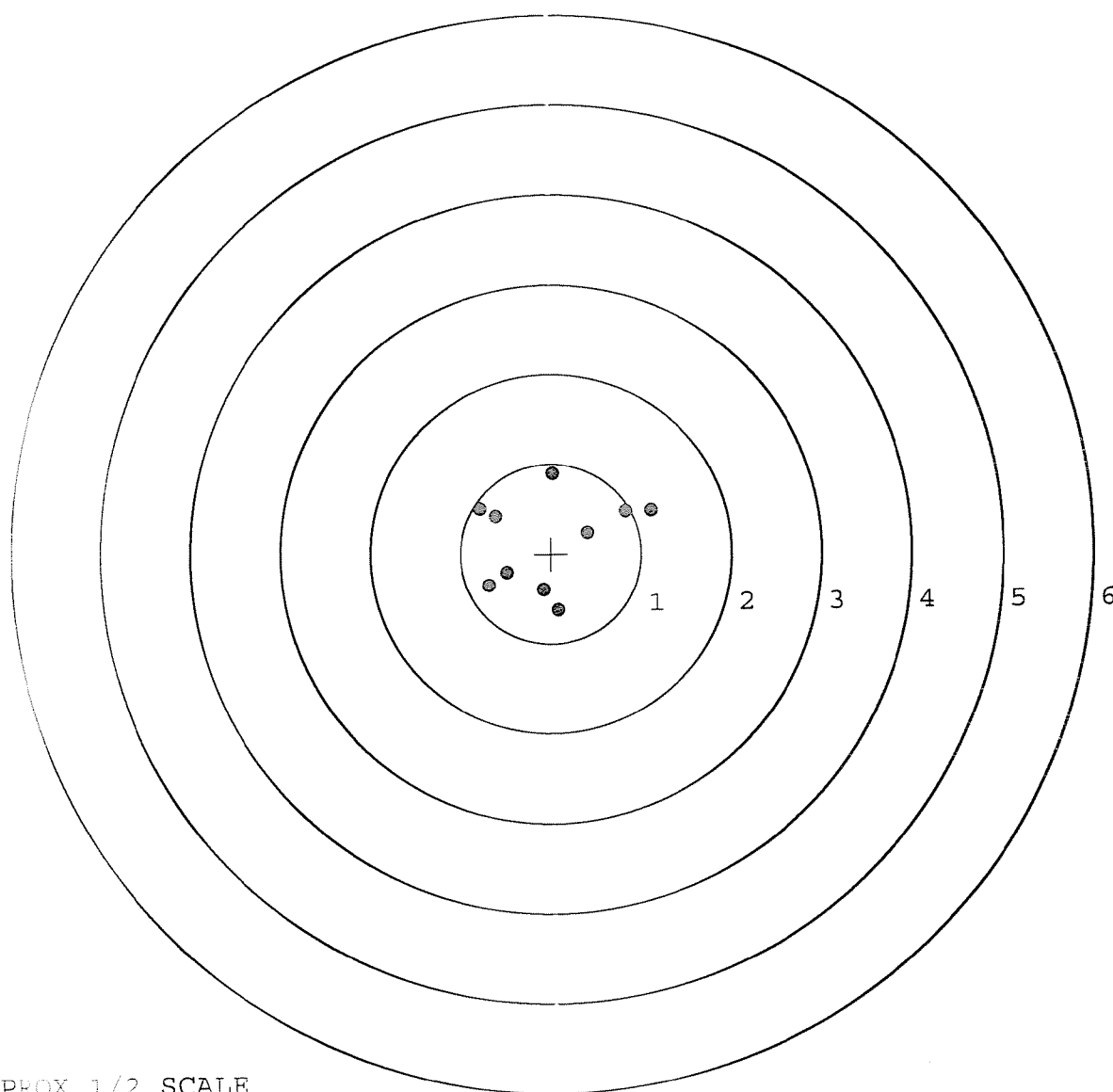
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.070
The Average Y Centroid of the Five Target Set:	0.087
The Average Point of Impact of the Five Target Set:	0.112
The Average Mean Radius of the Five Target Set:	0.884
The Distance from POA to Centroid Target #1:	0.139
The Distance from Centroid Target #2 to Centroid Target #1:	0.158
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.159
The Distance from Centroid Target #5 to Centroid Target #1:	0.186

SERIAL NUMBER: G6591580. 0
TARGET NUMBER: 1
FILE DATE: 09/07/2006
FILE TIME: 06:08

X CENTROID: -0.021
Y CENTROID: 0.137
POA TO CENTROID: 0.139
HORZ SPREAD: 1.891
VERT SPREAD: 1.519
GROUP SPREAD: 1.976
MIN RADIUS: 0.442
MAX RADIUS: 1.178
MEAN RADIUS: 0.751
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.110	0.467
2:	0.828	0.461
3:	0.411	0.229
4:	0.022	0.888
5:	0.080	-0.631
6:	-0.091	-0.402
7:	-0.781	0.501
8:	-0.611	0.419
9:	-0.493	-0.210
10:	-0.689	-0.350

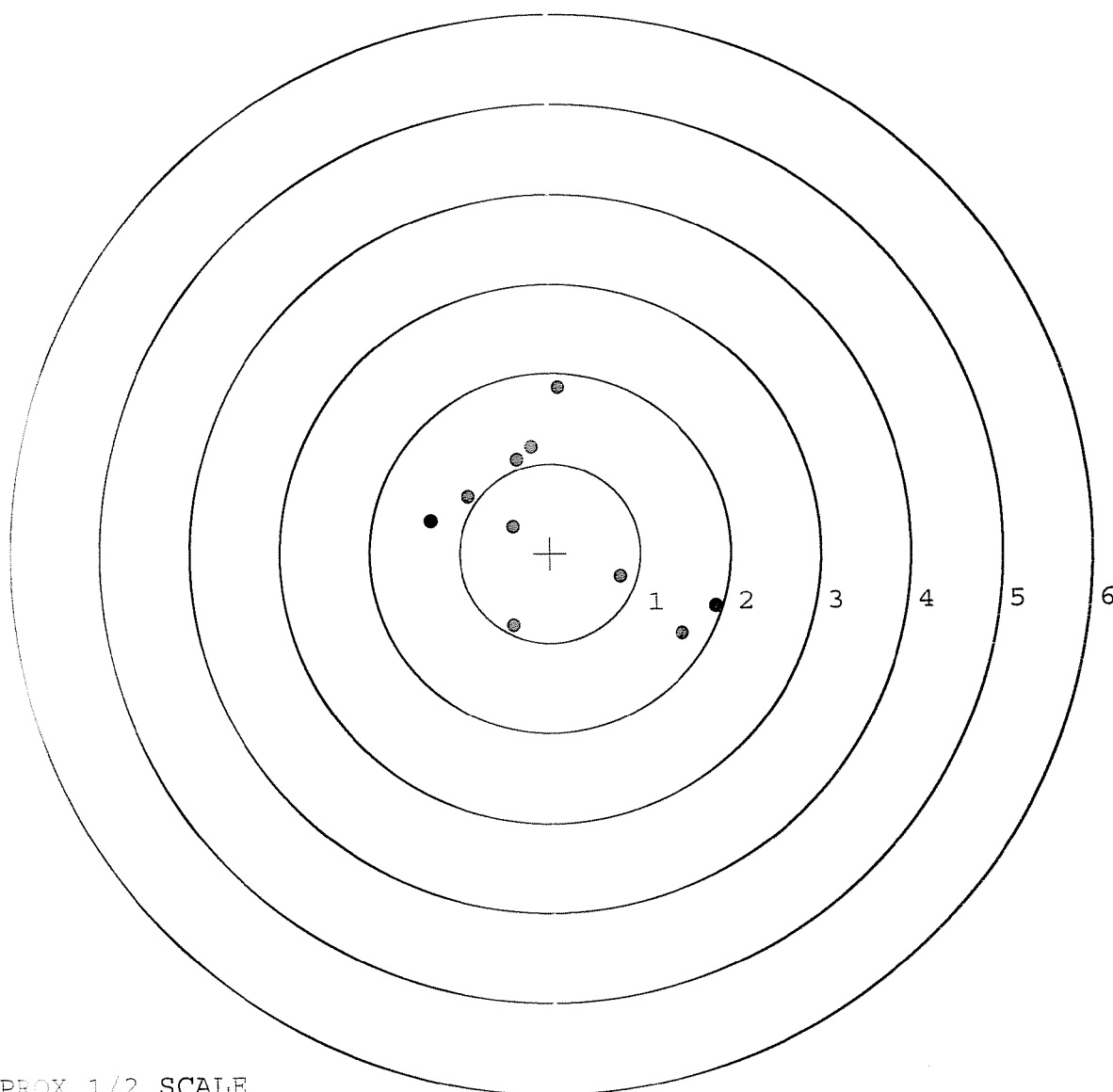


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591580. 0
TARGET NUMBER: 2
FILE DATE: 09/07/2006
FILE TIME: 06:08

X CENTROID: 0.055
Y CENTROID: 0.276
POA TO CENTROID: 0.281
HORZ SPREAD: 3.148
VERT SPREAD: 2.744
GROUP SPREAD: 3.295
MIN RADIUS: 0.462
MAX RADIUS: 1.980
MEAN RADIUS: 1.213
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.097	1.835
2:	-0.201	1.180
3:	-0.363	1.040
4:	-1.321	0.367
5:	-0.903	0.636
6:	-0.407	0.298
7:	0.779	-0.272
8:	-0.408	-0.812
9:	1.448	-0.909
10:	1.827	-0.607

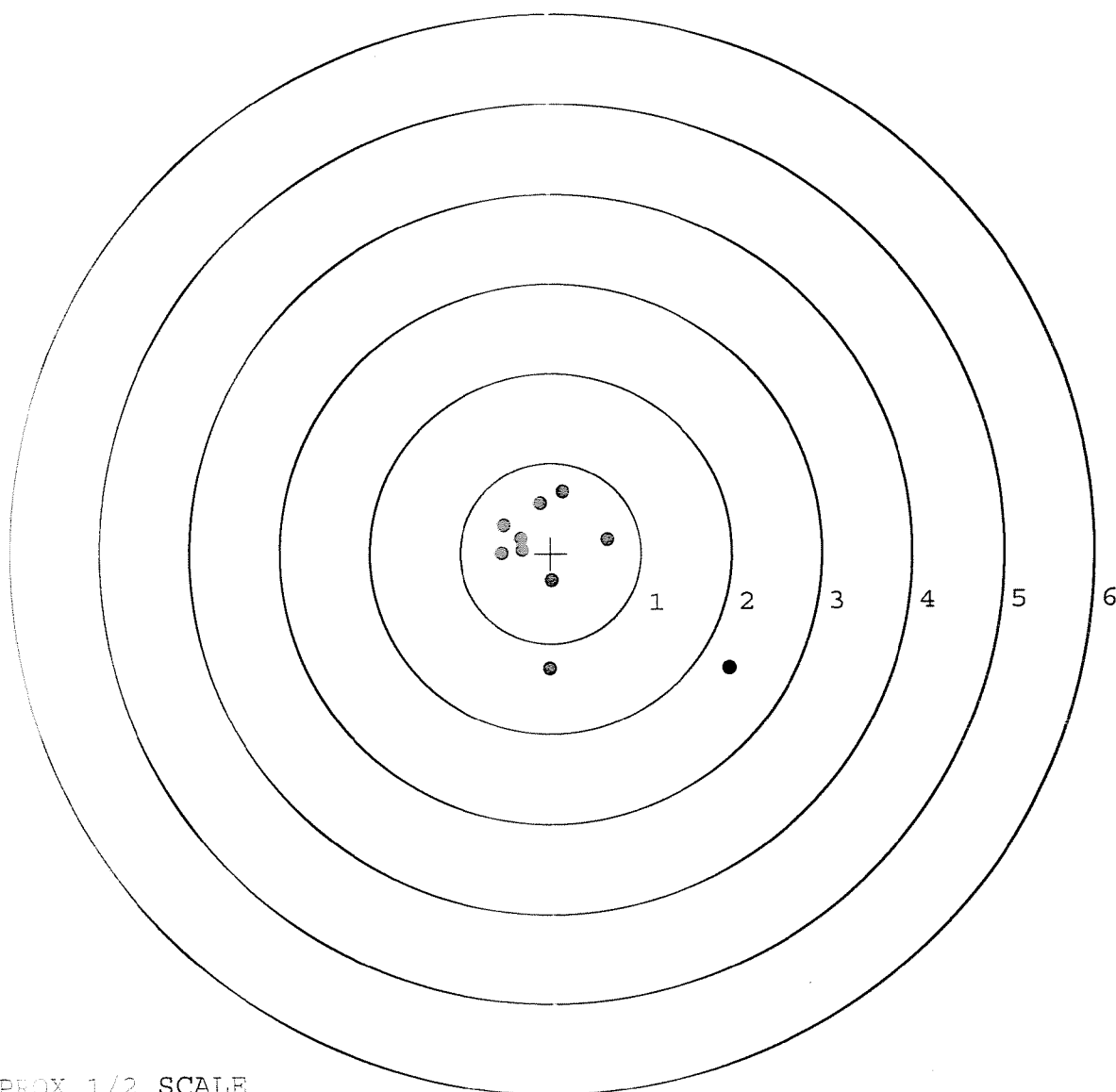


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591580. __0
TARGET NUMBER: 3
FILE DATE: 09/07/2006
FILE TIME: 06:08

X CENTROID: 0.090
Y CENTROID: -0.098
POA TO CENTROID: 0.133
HORZ SPREAD: 2.510
VERT SPREAD: 1.964
GROUP SPREAD: 2.950
MIN RADIUS: 0.217
MAX RADIUS: 2.221
MEAN RADIUS: 0.798
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.966	-1.287
2:	-0.026	-1.281
3:	0.011	-0.300
4:	0.632	0.148
5:	-0.320	0.038
6:	-0.544	0.005
7:	-0.327	0.162
8:	-0.516	0.308
9:	0.138	0.677
10:	-0.115	0.553

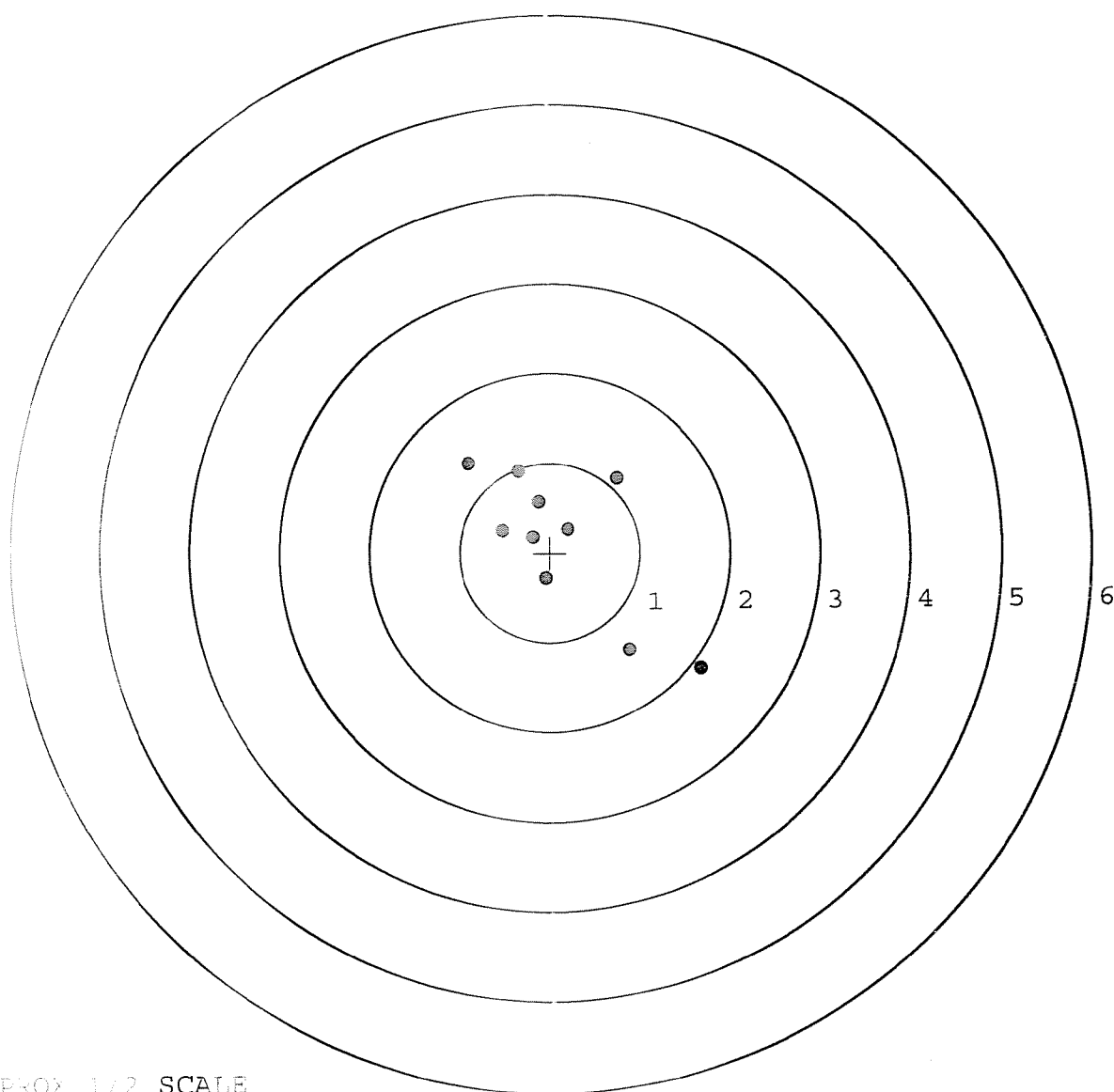


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591580. 0
TARGET NUMBER: 4
FILE DATE: 09/07/2006
FILE TIME: 06:08

X CENTROID: 0.137
Y CENTROID: 0.130
POA TO CENTROID: 0.189
HORZ SPREAD: 2.564
VERT SPREAD: 2.305
GROUP SPREAD: 3.448
MIN RADIUS: 0.148
MAX RADIUS: 2.095
MEAN RADIUS: 0.883
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.665	-1.303
2:	0.879	-1.095
3:	0.749	0.823
4:	-0.049	-0.286
5:	0.204	0.262
6:	-0.899	1.002
7:	-0.345	0.907
8:	-0.121	0.568
9:	-0.526	0.249
10:	-0.187	0.174

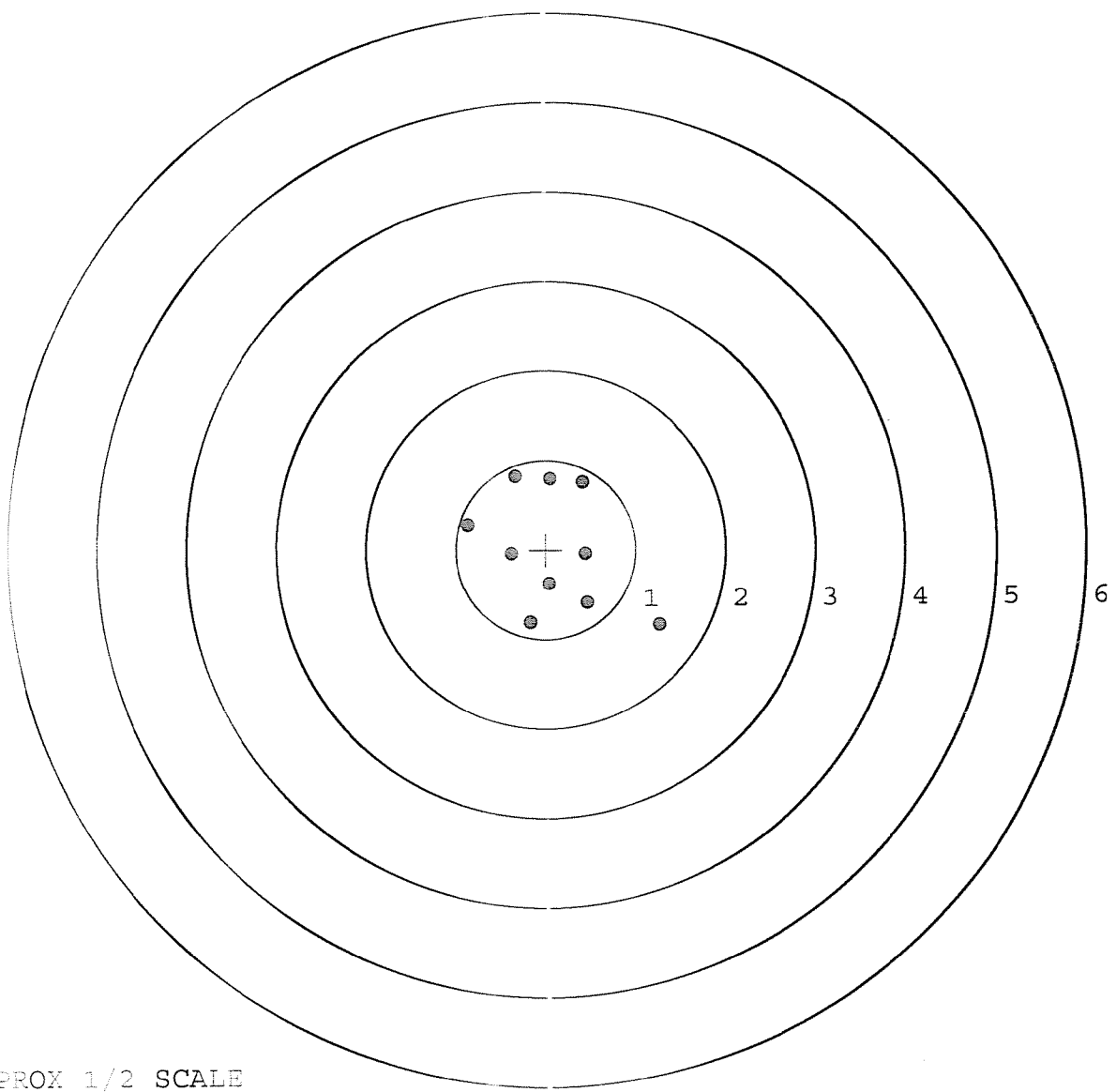


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591580. __0
 TARGET NUMBER: 5
 FILE DATE: 09/07/2006
 FILE TIME: 06:08

X CENTROID: 0.091
 Y CENTROID: -0.011
 POA TO CENTROID: 0.091
 HORZ SPREAD: 2.120
 VERT SPREAD: 1.662
 GROUP SPREAD: 2.400
 MIN RADIUS: 0.356
 MAX RADIUS: 1.434
 MEAN RADIUS: 0.774
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.255	-0.848
2:	0.464	-0.594
3:	0.444	-0.052
4:	-0.177	-0.814
5:	0.037	-0.380
6:	-0.383	-0.051
7:	-0.865	0.277
8:	0.419	0.750
9:	0.047	0.791
10:	-0.335	0.814



TARGET APPROX 1/2 SCALE