

G 6644507

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



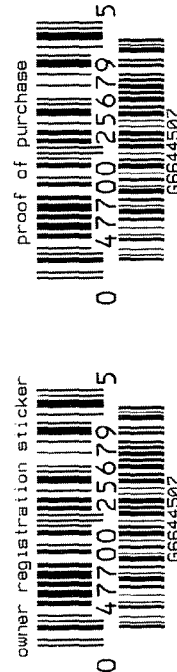
SERIAL NO.



**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
COMPLETE SYSTEM - LE/EXPORT**

98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
95117 - TRS BIPOD ASSB

DD FORM 96253

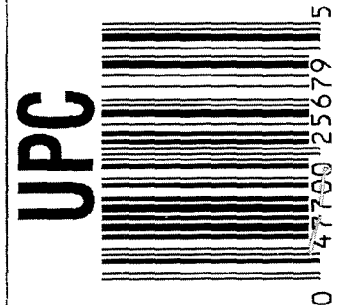


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6644507



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66644507

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-1-07	RTZ
420	ASSEMBLE ACTION		4/30/07	L.P.D.
430	ASSEMBLE TO STOCK		5-1-07	FM
440	PROOF	MAGNA - FLUX	5-1-07	TRW
460	CHECK HEADSPACE	JUN - 8 2008	5-1-07	TRW
470	DIS-ASSEMBLE ACTION		5-2-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	5/3/07	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-3-07	CW
510	DRILL AND TAP SIGHT HOLES		5-2-07	SD
520	GOFF BLAST BBL / REC		5-4-07	CB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/8/07	W
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-11-07	L.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-11-07	L.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-11-07	L.P.D.
	D) OIL FIRING PIN ASSEMBLY		5-11-07	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5/18/07	mm

F004 REV 5/2006

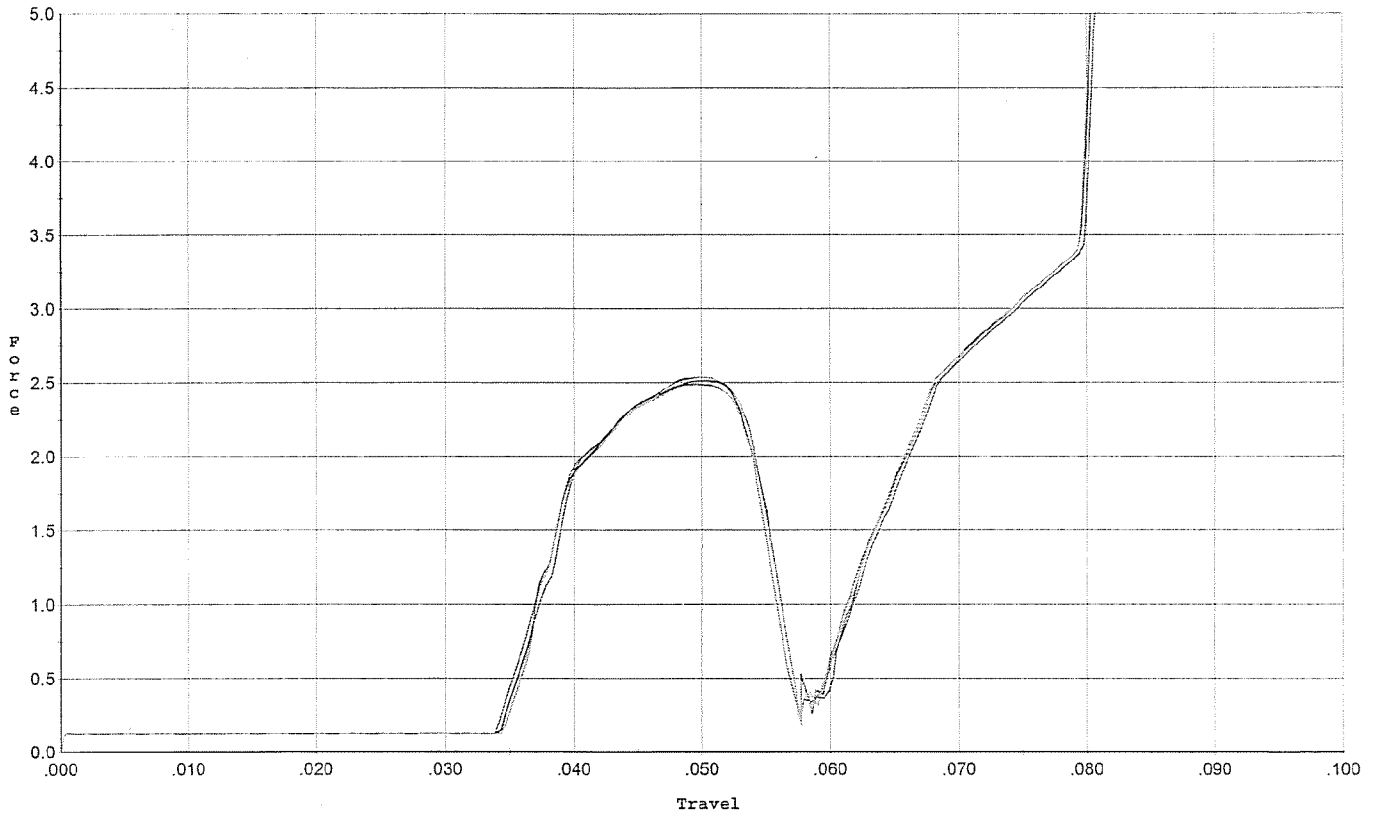
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.25</u> <u>8.0</u>	5-18-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.75</u> <u>2.5</u> <u>2.5</u>	5-18-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		5/18/07	TRW
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.0245</u> <u>.0235</u>	5-18-07	TRW
	J) ASSEMBLE STOCK		5-11-07	TRW
	K) ASSEMBLE SWIVEL STUDS		5/18/07	TRW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5/18/07	TRW
	M) IRON SIGHT ALIGNMENT		5/18/07	TRW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5/18/07	TRW
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	5/15/07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-15-07	TRW
670	FINAL INSPECTION A) HEADSPACE		5/18/07	TRW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.72</u> <u>2.70</u> <u>2.78</u> <u>2.71</u> <u>2.78</u>	5-18-07	TRW
	C) FUNCTION		5/18/07	TRW
690	PACK		5-23-07	TRW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



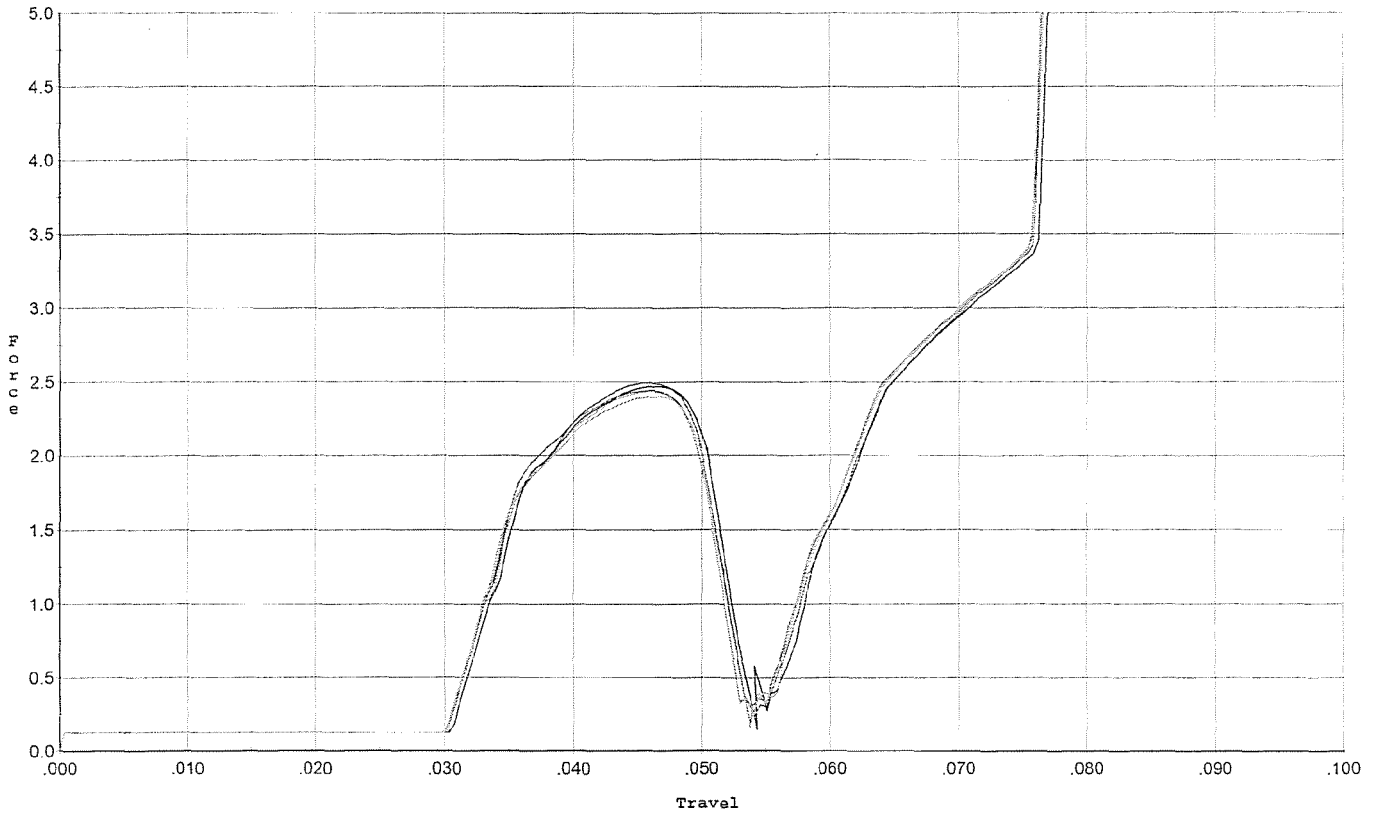
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.055	0.035	0.033	0.045		Set Trigger
2	2.535	0.054	0.035	0.033	0.044		Set Trigger
3	2.490	0.054	0.034	0.033	0.044		Set Trigger
4	2.536	0.055	0.035	0.032	0.045		Set Trigger
5	2.482	0.054	0.035	0.033	0.043		Set Trigger

AUG 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



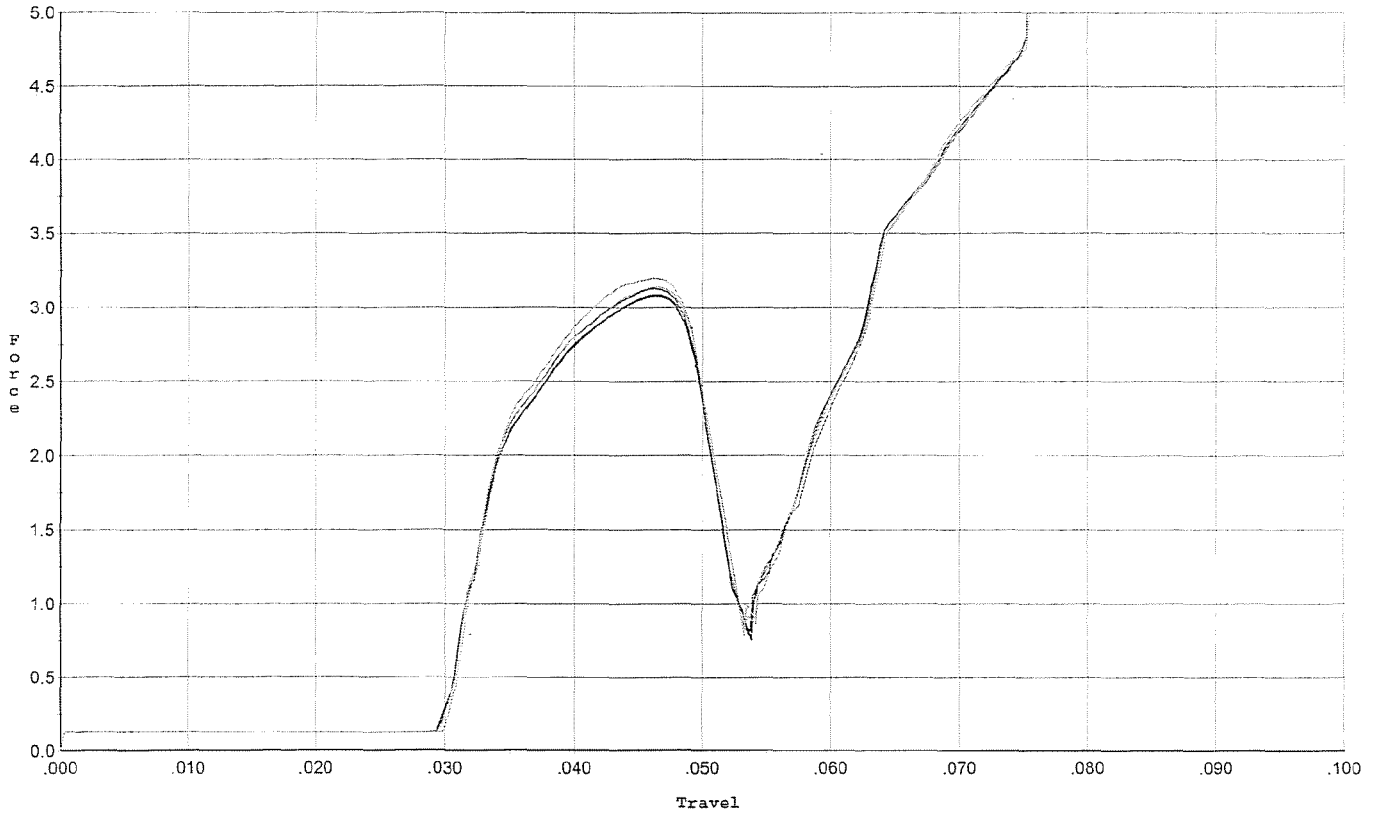
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.492	0.052	0.031	0.032	0.044		Set Trigger
2	2.468	0.050	0.031	0.032	0.043		Set Trigger
3	2.440	0.050	0.031	0.032	0.042		Set Trigger
4	2.400	0.050	0.031	0.032	0.041		Set Trigger
5	2.434	0.050	0.031	0.032	0.042		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



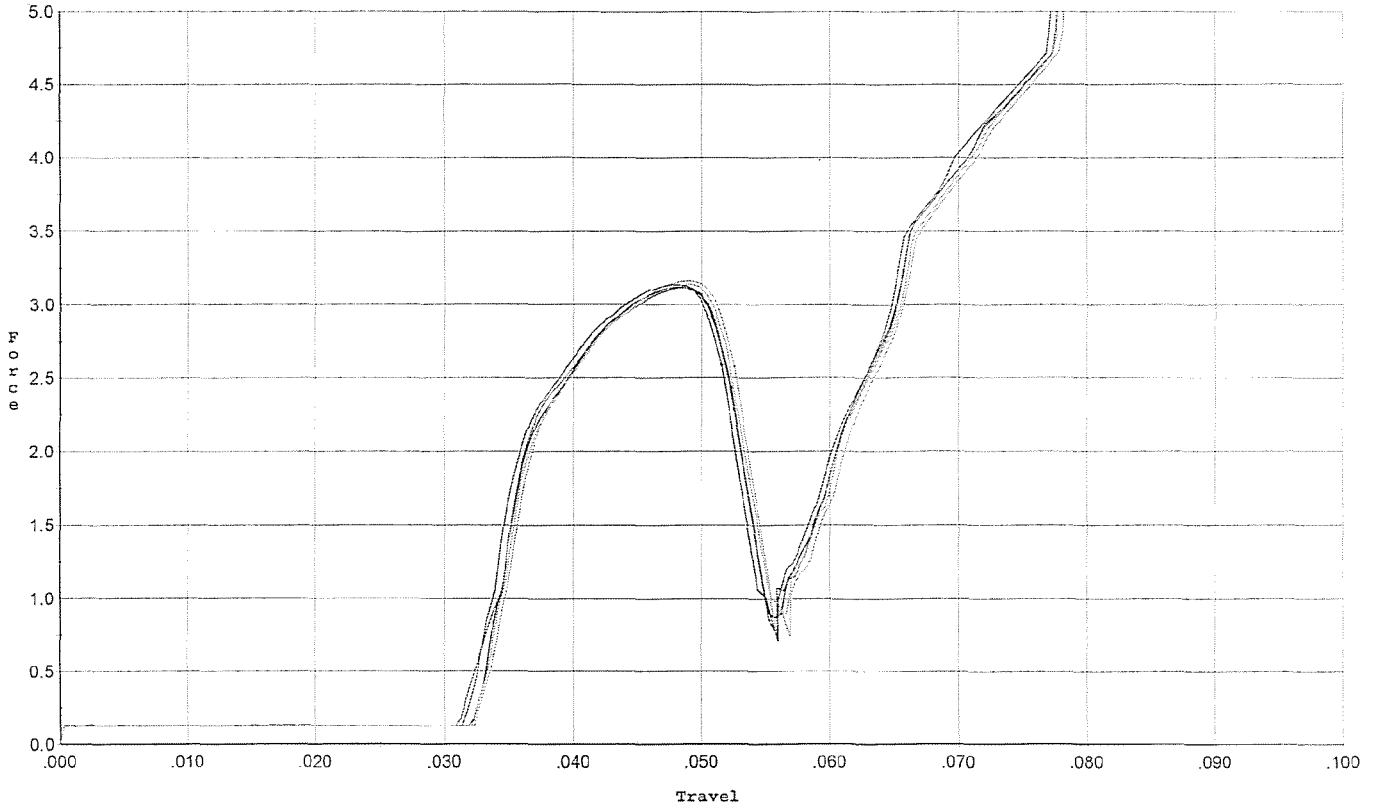
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.049	0.030	0.031	0.053		Set Trigger
2	3.086	0.050	0.030	0.031	0.053		Set Trigger
3	3.077	0.049	0.030	0.031	0.052		Set Trigger
4	3.137	0.051	0.030	0.031	0.055		Set Trigger
5	3.197	0.049	0.030	0.031	0.054		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 5/11/07

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



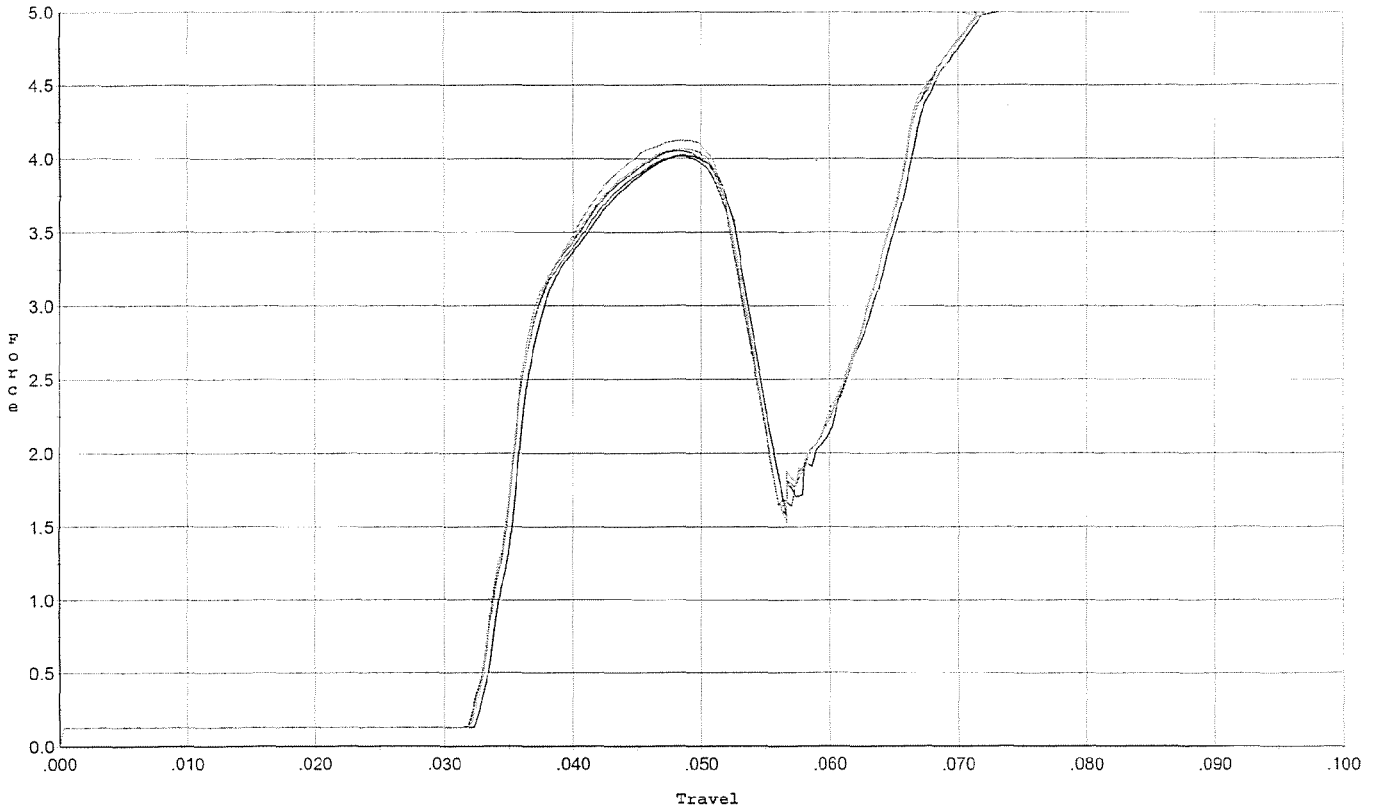
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.134	0.052	0.032	0.031	0.054		Set Trigger
2	3.116	0.052	0.033	0.031	0.054		Set Trigger
3	3.114	0.053	0.032	0.031	0.055		Set Trigger
4	3.136	0.054	0.033	0.031	0.056		Set Trigger
5	3.158	0.053	0.033	0.031	0.055		Set Trigger

Aug 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



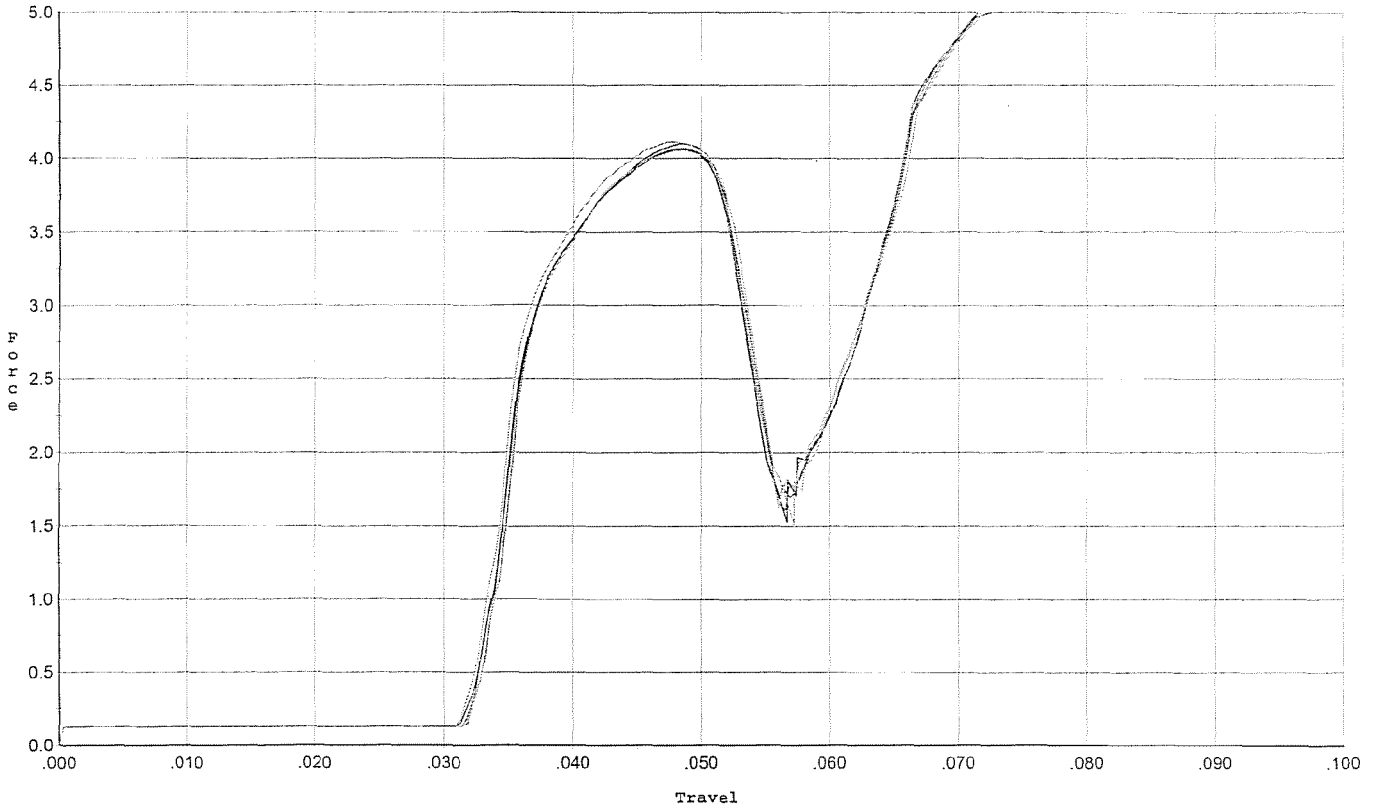
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.054	0.032	0.029	0.074		Set Trigger
2	4.022	0.053	0.033	0.030	0.071		Set Trigger
3	4.053	0.054	0.032	0.029	0.074		Set Trigger
4	4.120	0.053	0.032	0.029	0.074		Set Trigger
5	4.066	0.054	0.032	0.029	0.074		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



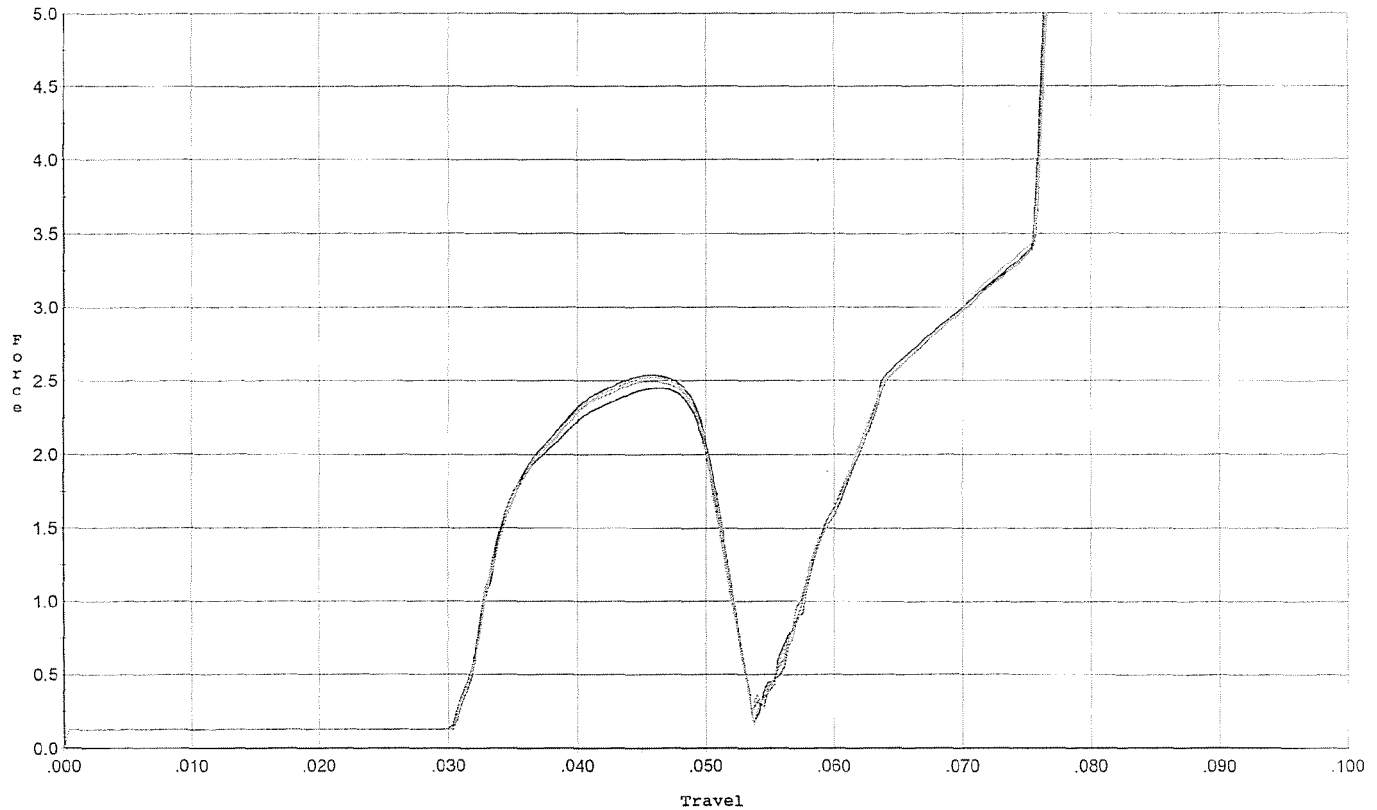
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.052	0.032	0.030	0.072		Set Trigger
2	4.062	0.052	0.032	0.029	0.072		Set Trigger
3	4.067	0.054	0.032	0.029	0.074		Set Trigger
4	4.053	0.053	0.032	0.029	0.073		Set Trigger
5	4.112	0.052	0.032	0.029	0.073		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



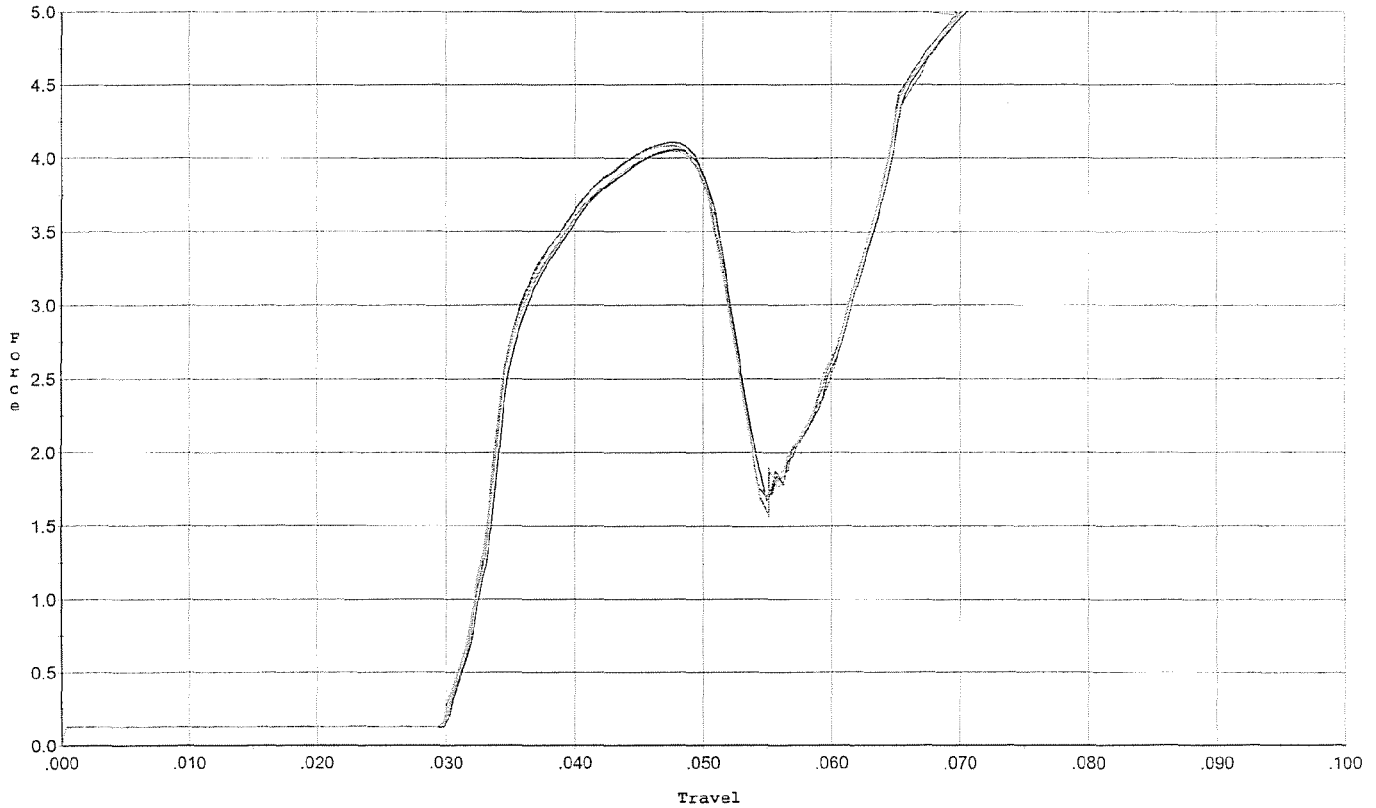
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.051	0.031	0.032	0.045		Set Trigger
2	2.450	0.050	0.031	0.032	0.043		Set Trigger
3	2.537	0.051	0.031	0.032	0.045		Set Trigger
4	2.495	0.051	0.031	0.032	0.045		Set Trigger
5	2.521	0.050	0.031	0.032	0.043		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/11/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.106	0.051	0.030	0.029	0.074		Set Trigger
2	4.058	0.051	0.030	0.030	0.071		Set Trigger
3	4.047	0.052	0.030	0.029	0.073		Set Trigger
4	4.055	0.052	0.030	0.029	0.073		Set Trigger
5	4.083	0.051	0.030	0.029	0.073		Set Trigger

Aug 4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6644507.__0
FILE DATE AND TIME: 05/16/2007 01:19

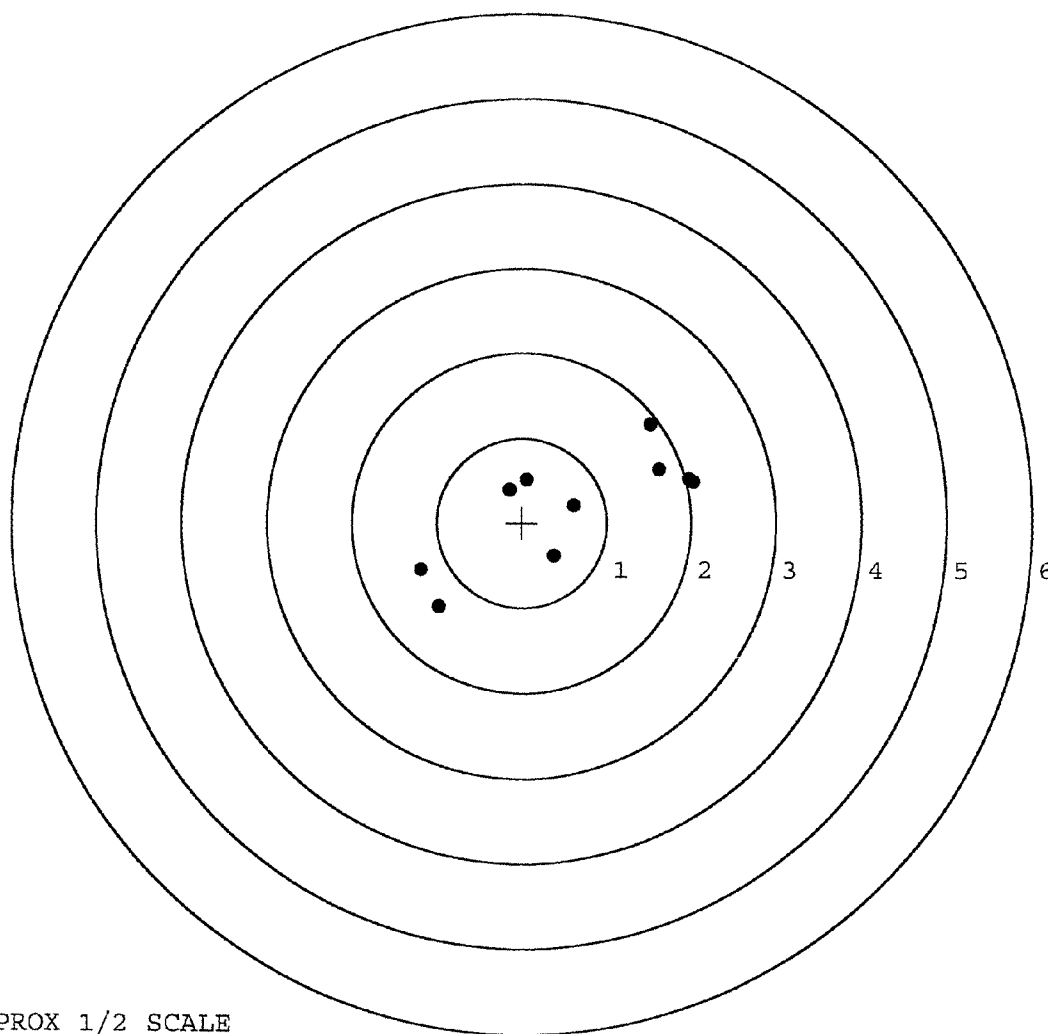
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.142
The Average Y Centroid of the Five Target Set:	-0.013
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.774
The Distance from POA to Centroid Target #1:	0.617
The Distance from Centroid Target #2 to Centroid Target #1:	0.665
The Distance from Centroid Target #3 to Centroid Target #1:	0.657
The Distance from Centroid Target #4 to Centroid Target #1:	0.487
The Distance from Centroid Target #5 to Centroid Target #1:	0.671

SERIAL NUMBER: G6644507.____0
TARGET NUMBER: 1
FILE DATE: 05/16/2007
FILE TIME: 01:19

X CENTROID: 0.585
Y CENTROID: 0.198
POA TO CENTROID: 0.617
HORZ SPREAD: 3.214
VERT SPREAD: 2.156
GROUP SPREAD: 3.343
MIN RADIUS: 0.028
MAX RADIUS: 1.961
MEAN RADIUS: 1.127
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.152	0.390
2:	0.055	0.507
3:	0.609	0.211
4:	1.619	0.637
5:	1.972	0.521
6:	2.023	0.488
7:	1.511	1.166
8:	0.375	-0.393
9:	-1.191	-0.554
10:	-0.976	-0.990

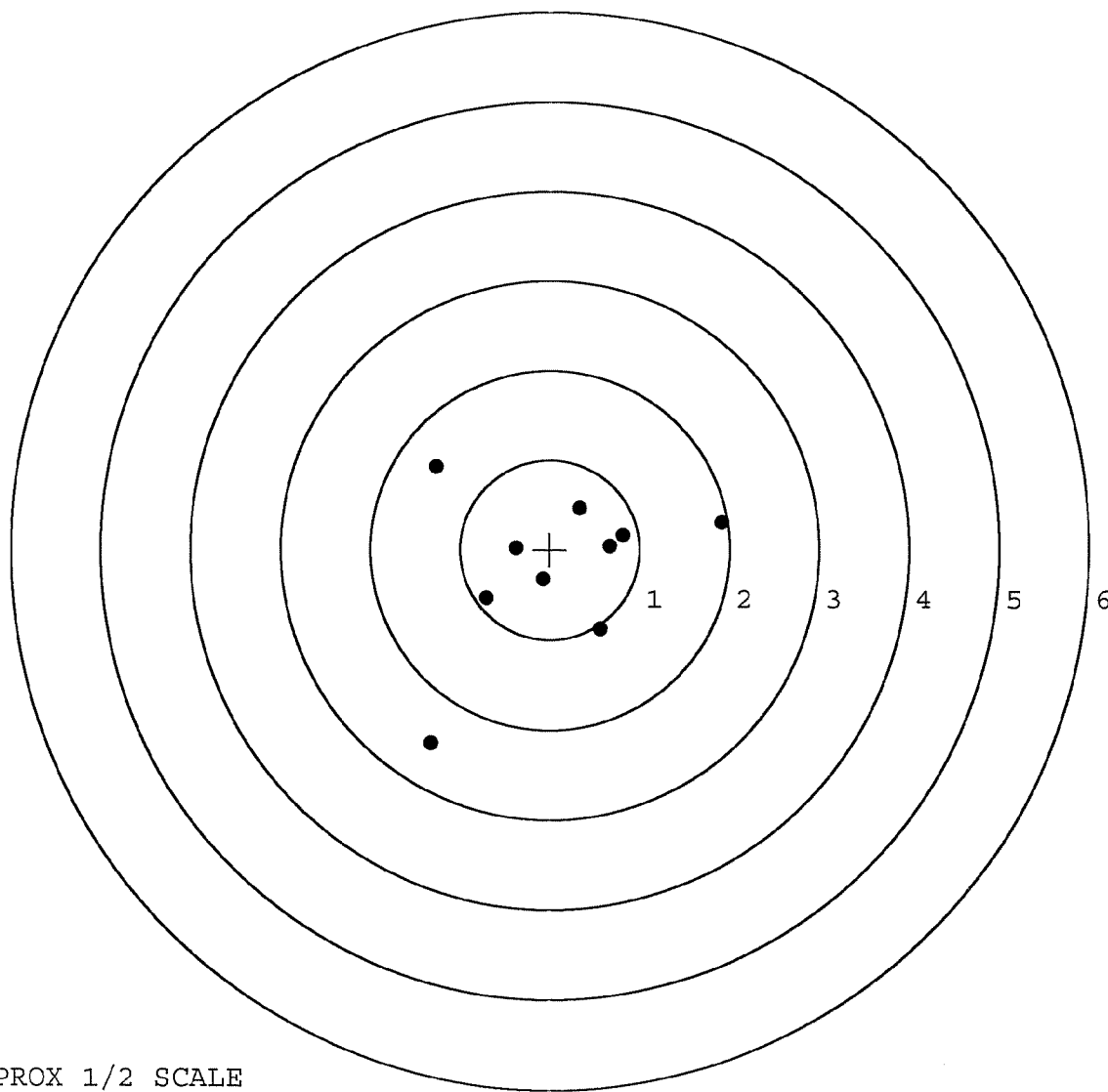


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644507. __0
 TARGET NUMBER: 2
 FILE DATE: 05/16/2007
 FILE TIME: 01:19

POINT#	X	Y
1:	0.335	0.465
2:	0.673	0.039
3:	0.814	0.155
4:	1.909	0.300
5:	0.561	-0.887
6:	-0.077	-0.335
7:	-0.379	0.018
8:	-0.709	-0.545
9:	-1.273	0.922
10:	-1.321	-2.157

X CENTROID: 0.053
 Y CENTROID: -0.202
 POA TO CENTROID: 0.209
 HORZ SPREAD: 3.230
 VERT SPREAD: 3.079
 GROUP SPREAD: 4.058
 MIN RADIUS: 0.186
 MAX RADIUS: 2.389
 MEAN RADIUS: 1.064
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644507. __0

TARGET NUMBER: 3

FILE DATE: 05/16/2007

FILE TIME: 01:19

POINT#	X	Y
1:	-0.008	0.253
2:	0.068	0.279
3:	0.484	0.074
4:	0.208	-0.101
5:	0.016	-0.247
6:	0.822	-0.351
7:	-0.006	-1.218
8:	-0.357	-0.234
9:	-0.730	0.038
10:	-0.434	0.374

X CENTROID: 0.006

Y CENTROID: -0.113

POA TO CENTROID: 0.113

HORZ SPREAD: 1.552

VERT SPREAD: 1.592

GROUP SPREAD: 1.649

MIN RADIUS: 0.134

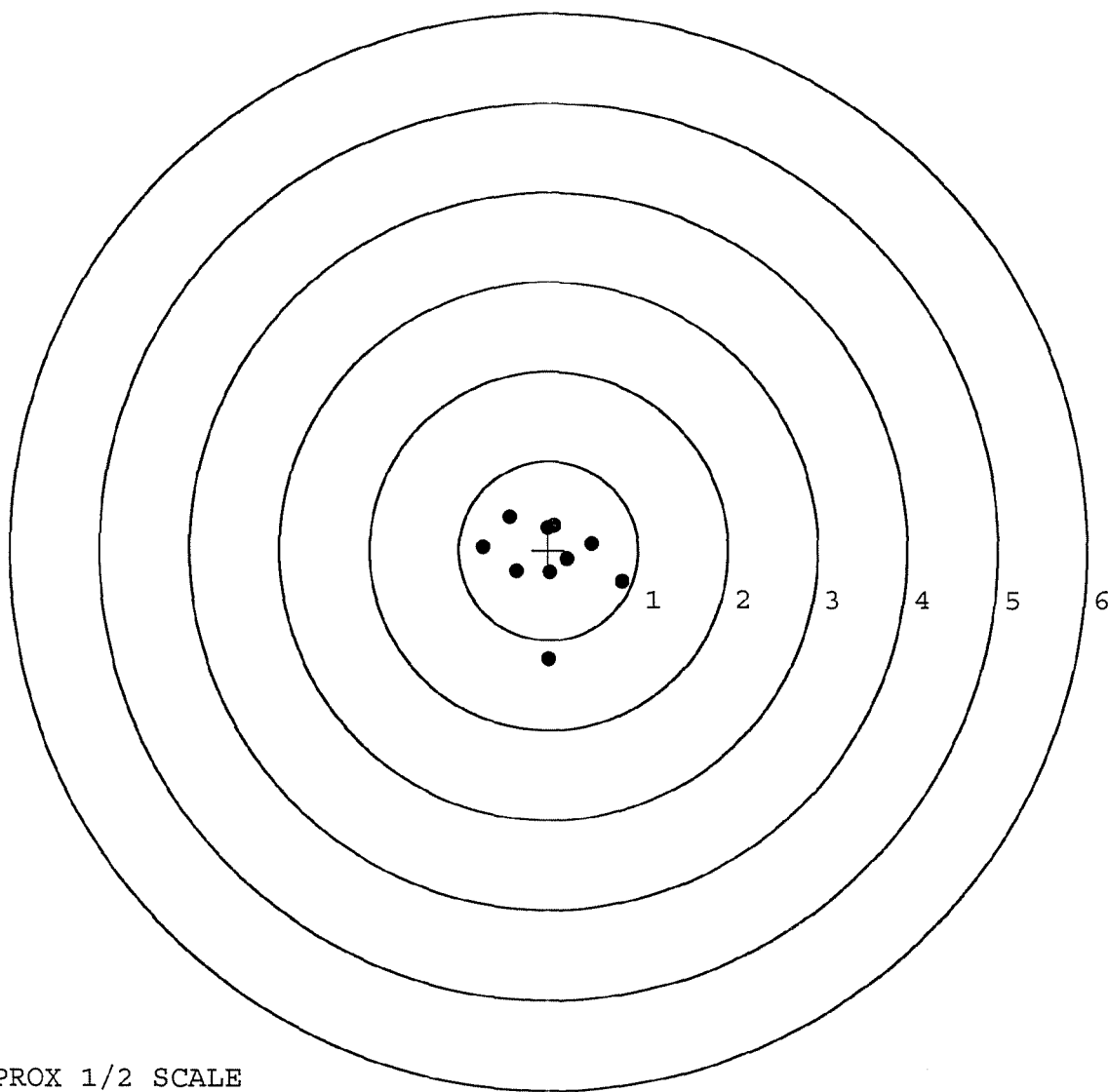
MAX RADIUS: 1.105

MEAN RADIUS: 0.536

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644507. __0

TARGET NUMBER: 4

FILE DATE: 05/16/2007

FILE TIME: 01:19

POINT#	X	Y
1:	-0.242	0.283
2:	-0.342	-0.326
3:	-0.697	-0.386
4:	-0.013	-0.525
5:	0.164	-0.415
6:	0.131	-0.219
7:	0.259	-0.123
8:	0.248	0.030
9:	0.485	0.822
10:	1.137	1.623

X CENTROID: 0.113

Y CENTROID: 0.076

POA TO CENTROID: 0.136

HORZ SPREAD: 1.834

VERT SPREAD: 2.148

GROUP SPREAD: 2.720

MIN RADIUS: 0.143

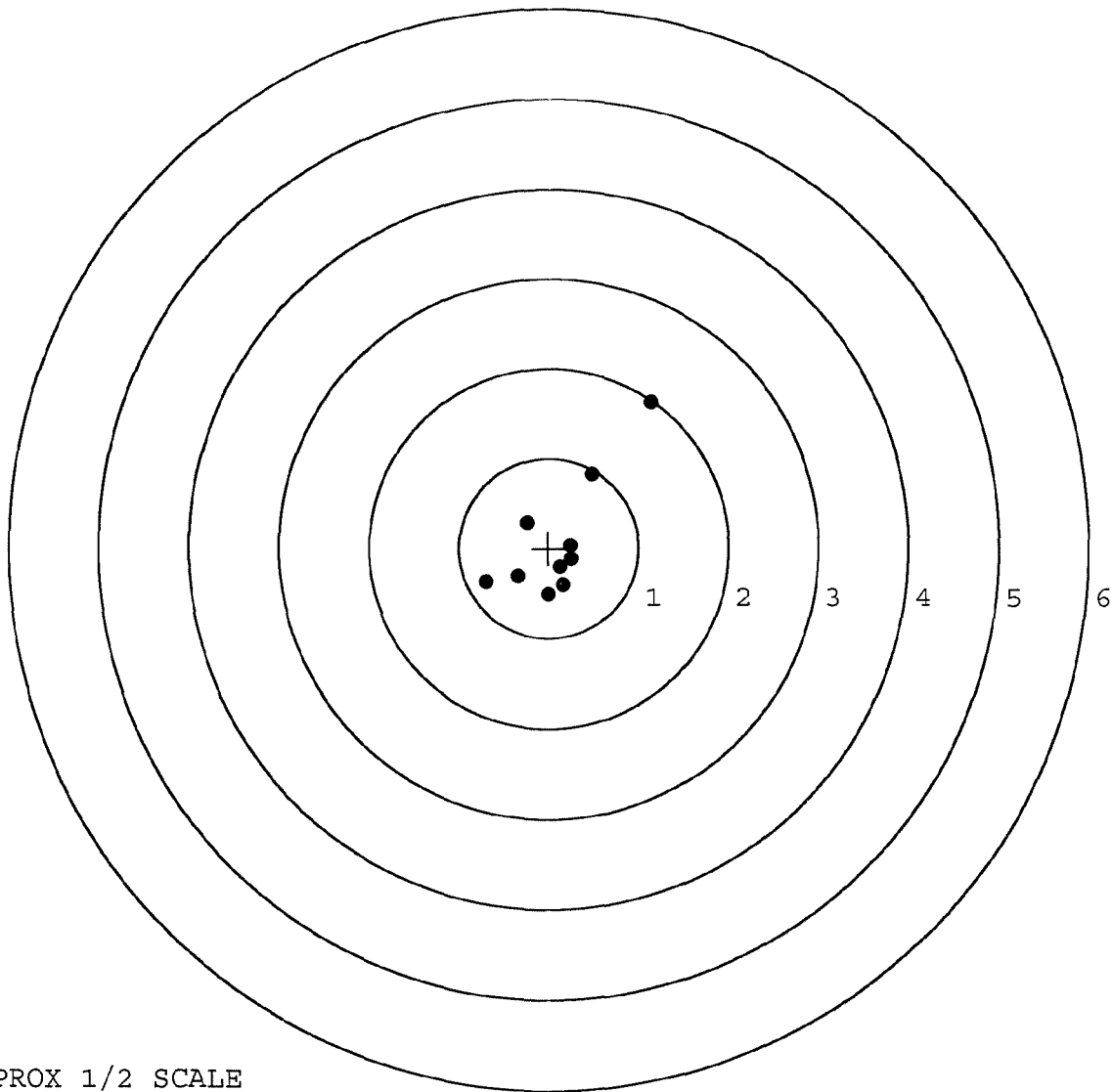
MAX RADIUS: 1.855

MEAN RADIUS: 0.643

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644507. __0

TARGET NUMBER: 5

FILE DATE: 05/16/2007

FILE TIME: 01:19

POINT#	X	Y
1:	-0.451	-0.138
2:	-0.711	-0.138
3:	-0.418	0.122
4:	0.067	0.723
5:	-0.294	0.185
6:	0.017	0.086
7:	0.118	-0.620
8:	0.095	-0.437
9:	0.467	-0.188
10:	0.623	0.167

X CENTROID: -0.049

Y CENTROID: -0.024

POA TO CENTROID: 0.054

HORZ SPREAD: 1.334

VERT SPREAD: 1.343

GROUP SPREAD: 1.344

MIN RADIUS: 0.128

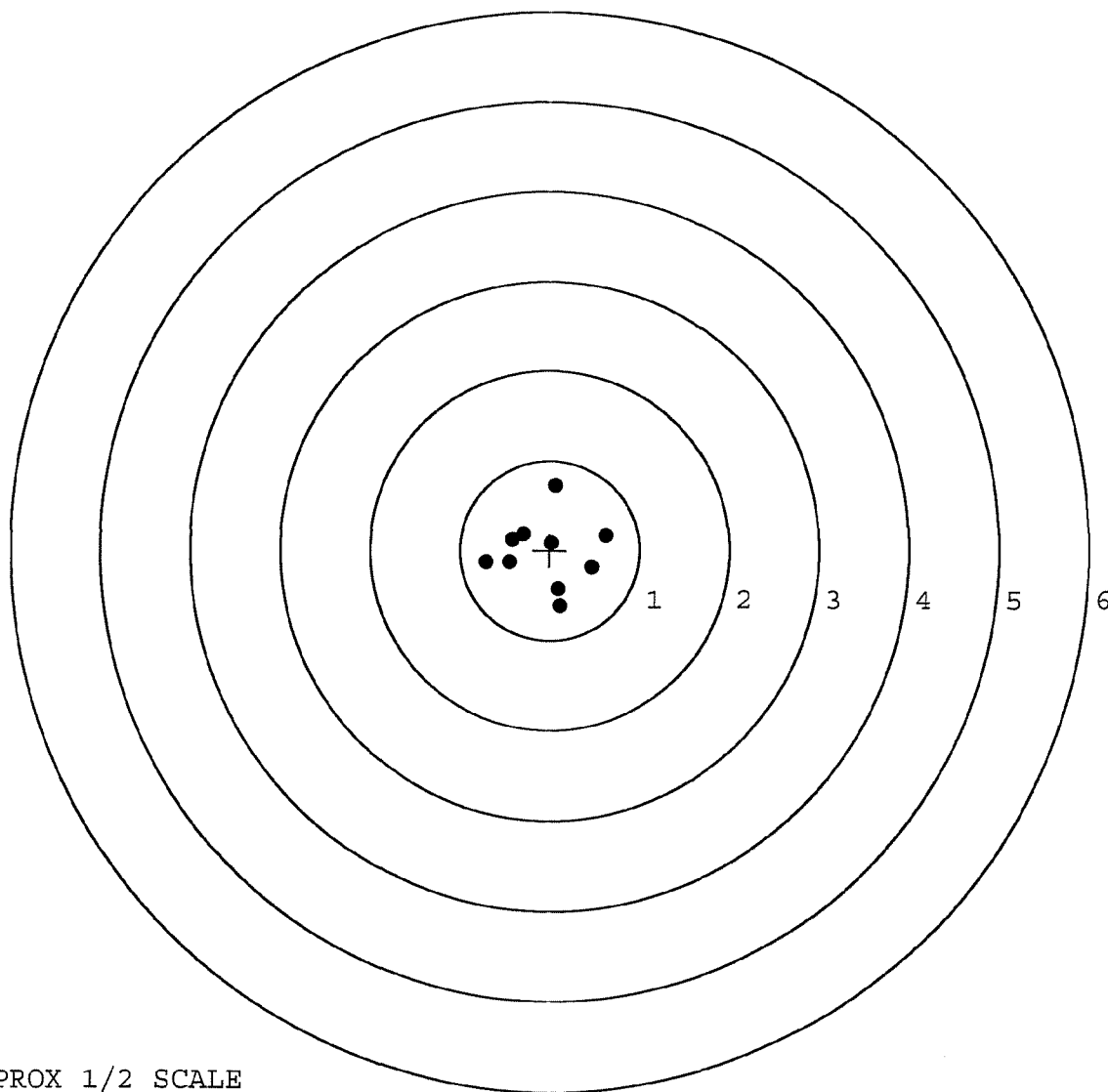
MAX RADIUS: 0.756

MEAN RADIUS: 0.499

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE