

G 6644519

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

- INSTRUCTION BOOK 3518

BM FORM

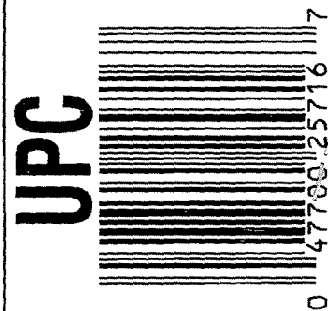


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6644517



ORDER 25716

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

UPC

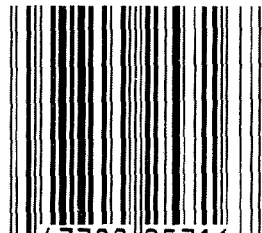


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ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



66644517

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6644517

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		4-4-07	RTZ
420	ASSEMBLE ACTION		4-4-07	RTZ
430	ASSEMBLE TO STOCK		4-4-07	TRW
440	PROOF		4-4-07	TRW
460	CHECK HEADSPACE	INSPECTED	4-4-07	TRW
470	DIS-ASSEMBLE ACTION	APR 09 2007	4-5-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	4-9-07	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-9-07	CW
510	DRILL AND TAP SIGHT HOLES		4-5-07	SD
520	GOFF BLAST BBL / REC		4/9/07	(KS)
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		4/13/07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/18/07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/18/07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/18/07	SPD
	D) OIL FIRING PIN ASSEMBLY		4/18/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/19/07	WJ

F004 REV 5/2006

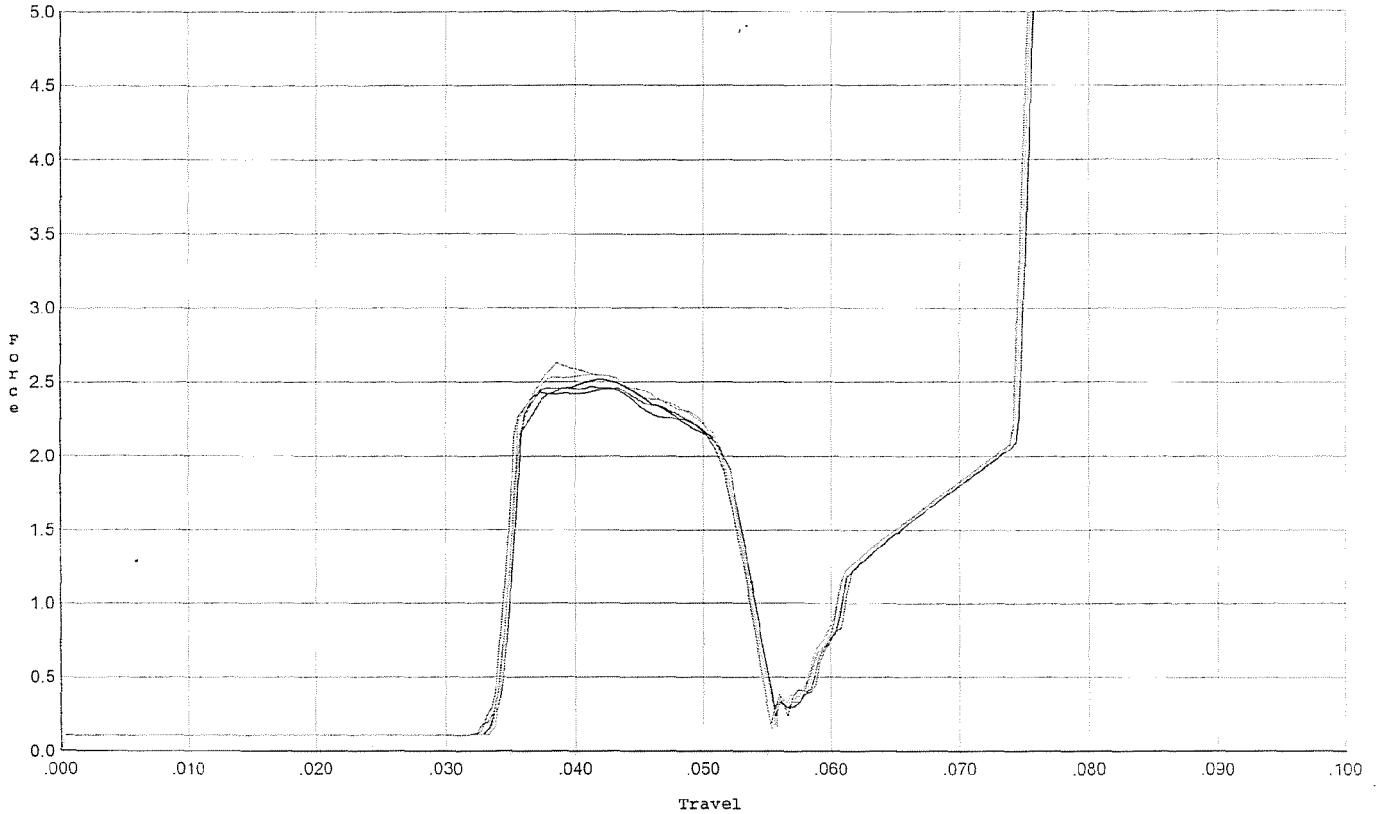
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.25</u> <u>7.0</u> <u>7.75</u>	^{TRW} 4-19-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.0</u> <u>3.25</u>	4-19-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		4/19/07	mon
	I) FIRING PIN INDENT .020 MIN	<u>.0255</u> <u>.0245</u> <u>.0245</u>	4-19-07	TRW
	J) ASSEMBLE STOCK		4/18/07	TRW
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/19/07	mon
	M) IRON SIGHT ALIGNMENT		4/19/07	mon
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/19/07	mon
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-19-07	TRW
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-19-07	TRW
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.12</u> <u>2.31</u> <u>2.22</u> <u>2.44</u> <u>2.49</u>	4-19-07	TRW
	C) FUNCTION			
690	PACK		9/8/07	TRW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



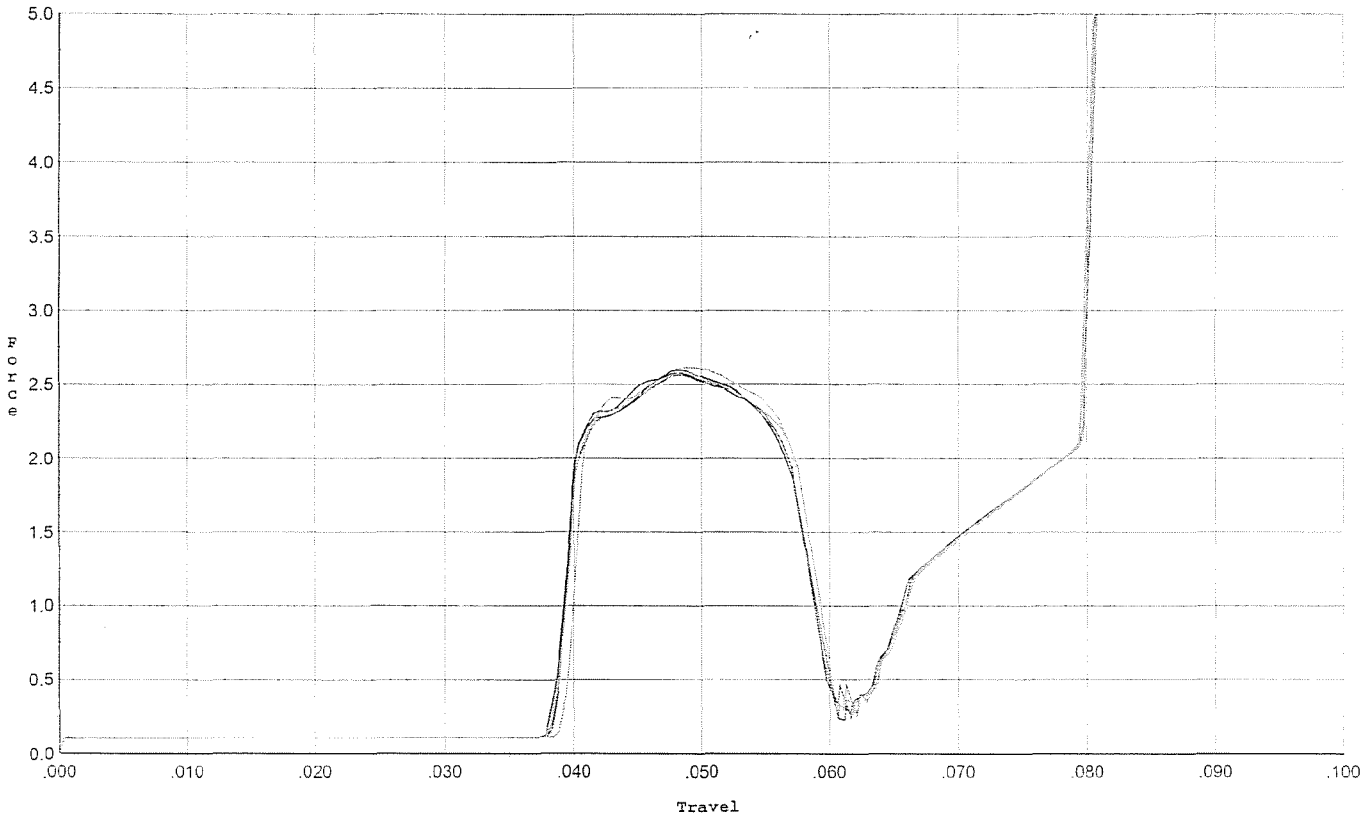
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.471	0.054	0.033	0.030	0.046		Set Trigger
2	2.515	0.054	0.034	0.030	0.046		Set Trigger
3	2.458	0.053	0.033	0.030	0.046		Set Trigger
4	2.553	0.052	0.034	0.030	0.046		Set Trigger
5	2.628	0.052	0.034	0.030	0.046		Set Trigger

AVG 2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/17/07

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



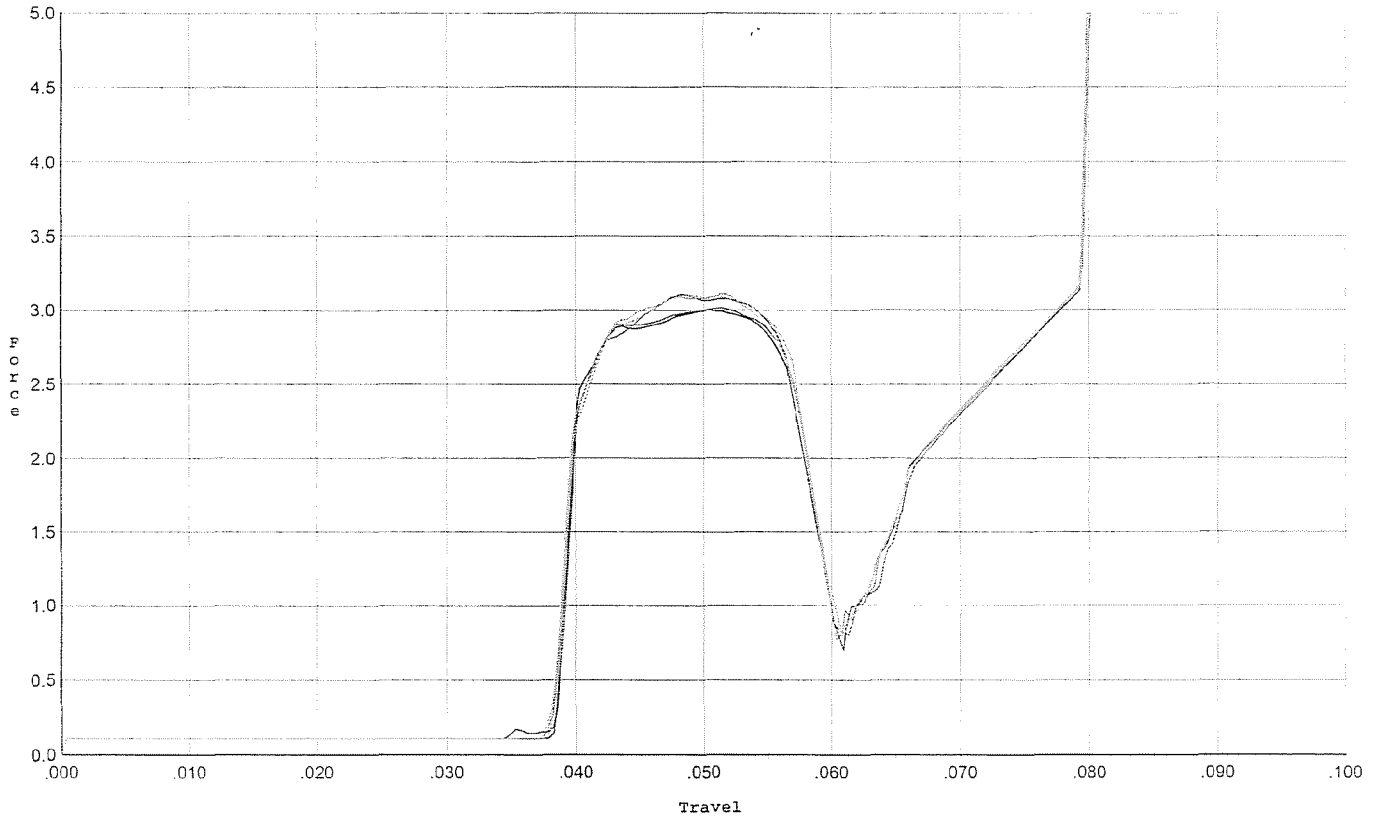
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.575	0.057	0.038	0.030	0.047		Set Trigger
2	2.599	0.057	0.038	0.030	0.048		Set Trigger
3	2.564	0.057	0.038	0.030	0.047		Set Trigger
4	2.613	0.058	0.038	0.030	0.049		Set Trigger
5	2.585	0.058	0.039	0.030	0.047		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/17/07

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



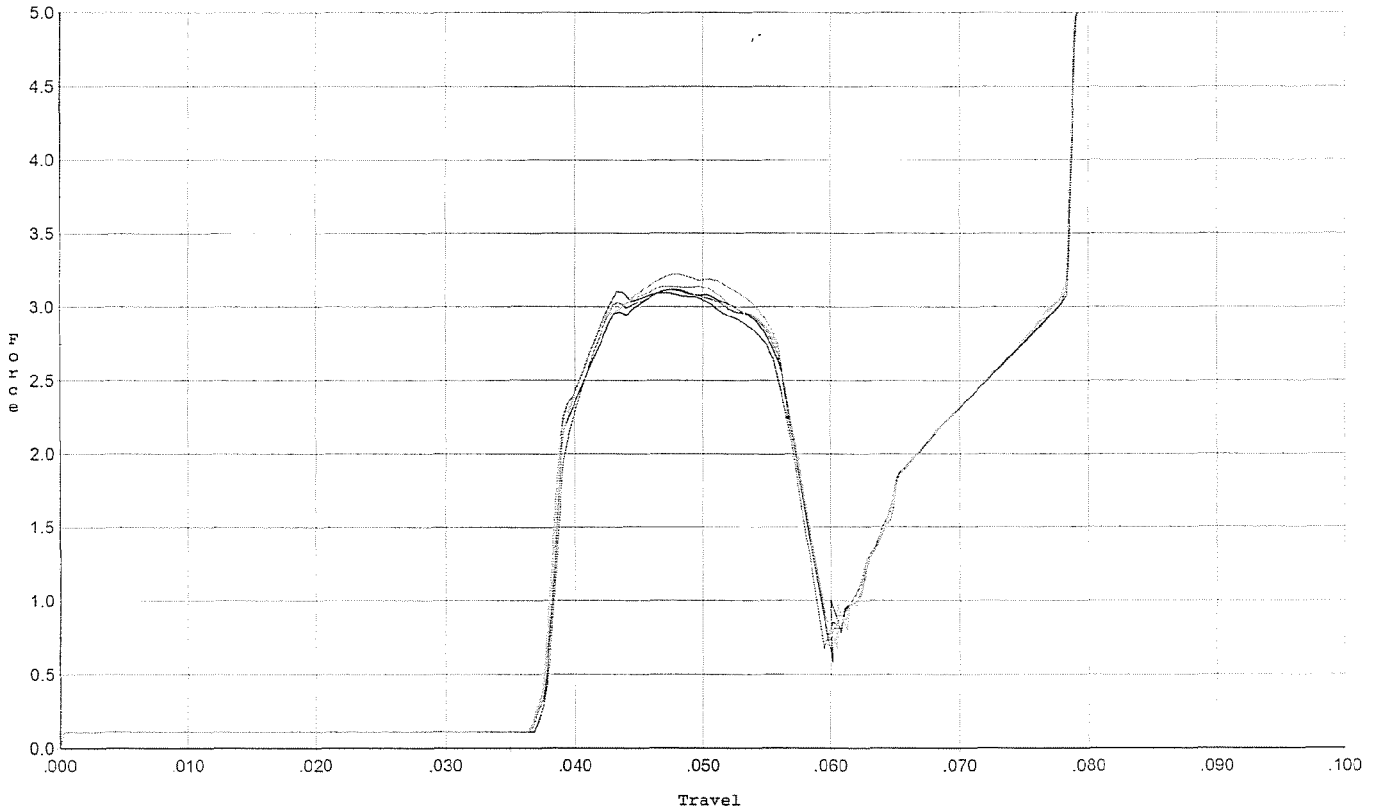
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.015	0.057	0.039	0.029	0.057		Set Trigger
2	3.000	0.058	0.038	0.029	0.058		Set Trigger
3	3.107	0.057	0.038	0.028	0.058		Set Trigger
4	3.109	0.057	0.038	0.029	0.059		Set Trigger
5	3.092	0.057	0.038	0.029	0.058		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



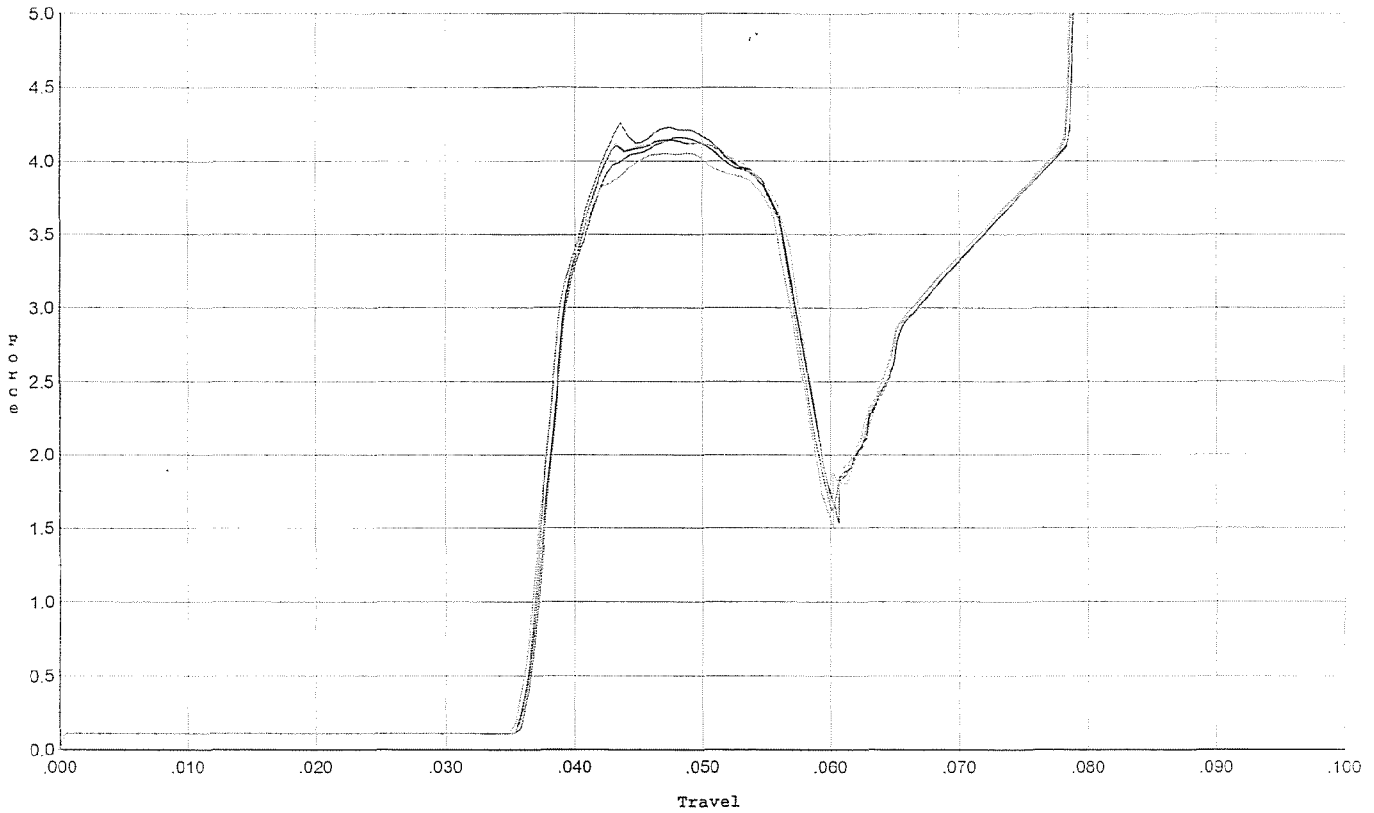
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.104	0.057	0.037	0.028	0.058		Set Trigger
2	3.115	0.056	0.037	0.029	0.057		Set Trigger
3	3.120	0.056	0.037	0.029	0.057		Set Trigger
4	3.139	0.058	0.037	0.028	0.060		Set Trigger
5	3.220	0.058	0.037	0.028	0.061		Set Trigger

AVG 3.14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 4/17/07

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



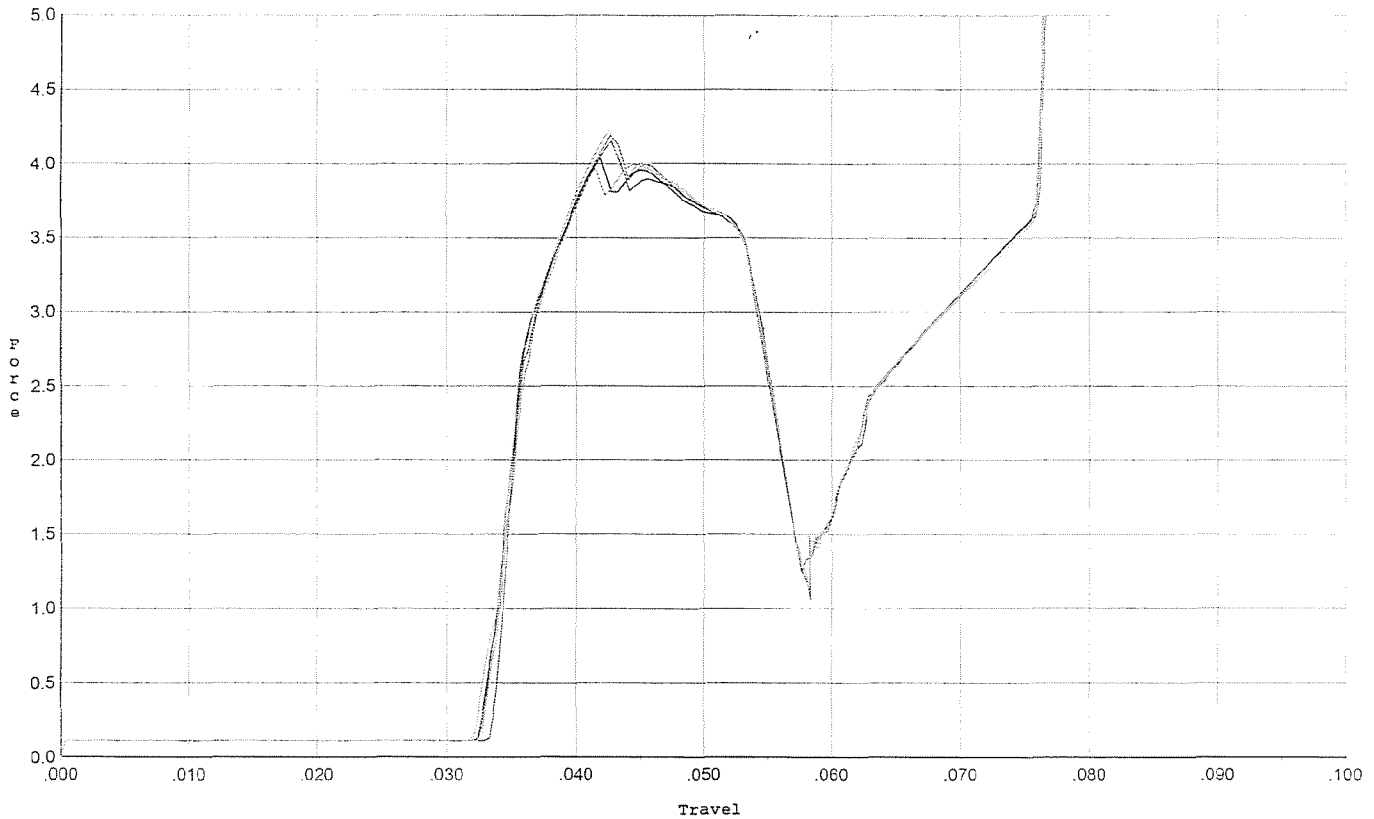
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.162	0.056	0.036	0.027	0.078		Set Trigger
2	4.146	0.058	0.036	0.026	0.082		Set Trigger
3	4.261	0.056	0.036	0.027	0.080		Set Trigger
4	4.139	0.057	0.036	0.026	0.080		Set Trigger
5	4.056	0.057	0.036	0.027	0.079		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



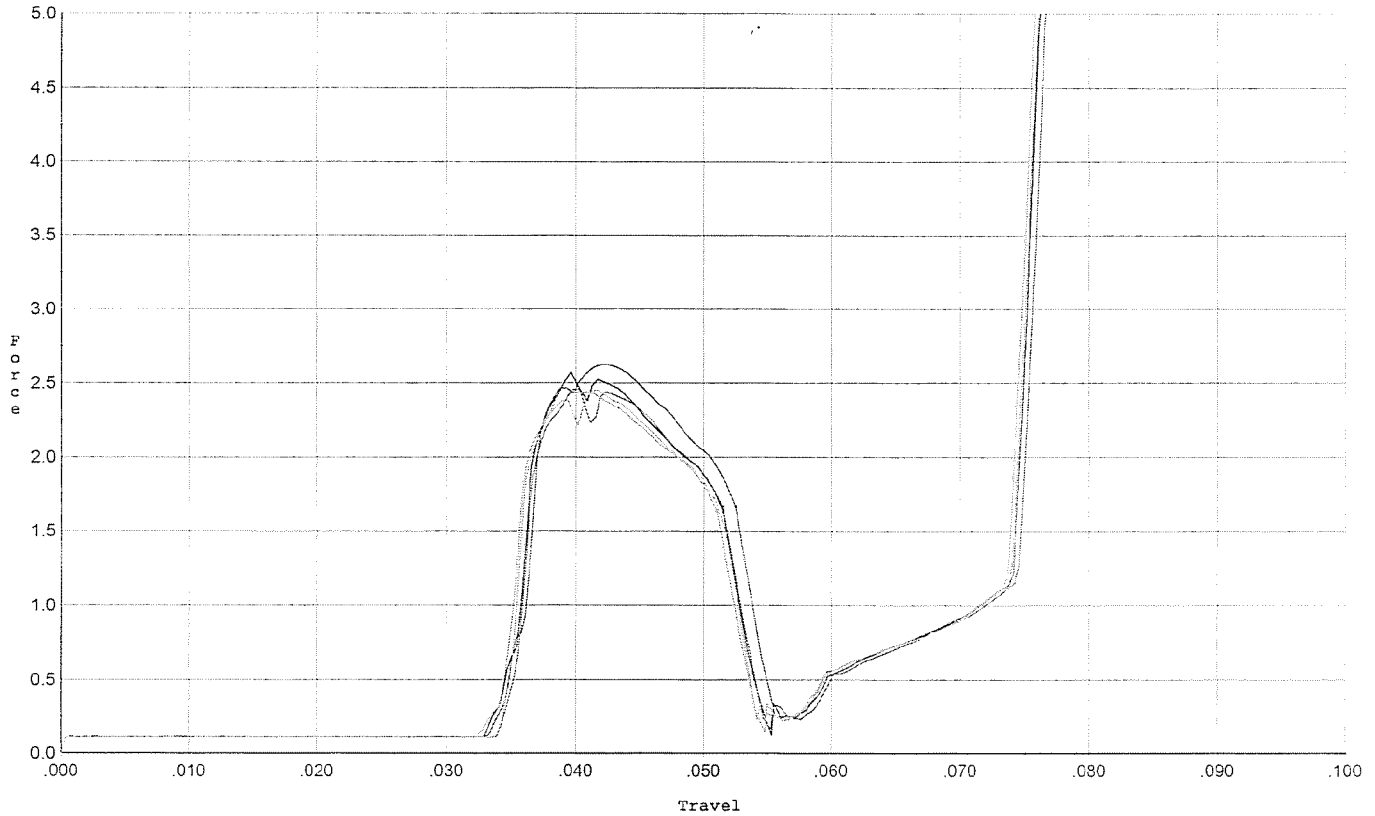
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.055	0.034	0.027	0.077		Set Trigger
2	4.042	0.053	0.033	0.027	0.075		Set Trigger
3	4.191	0.055	0.033	0.027	0.078		Set Trigger
4	4.228	0.053	0.033	0.027	0.075		Set Trigger
5	3.996	0.055	0.032	0.027	0.077		Set Trigger

Avg 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/17/07

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



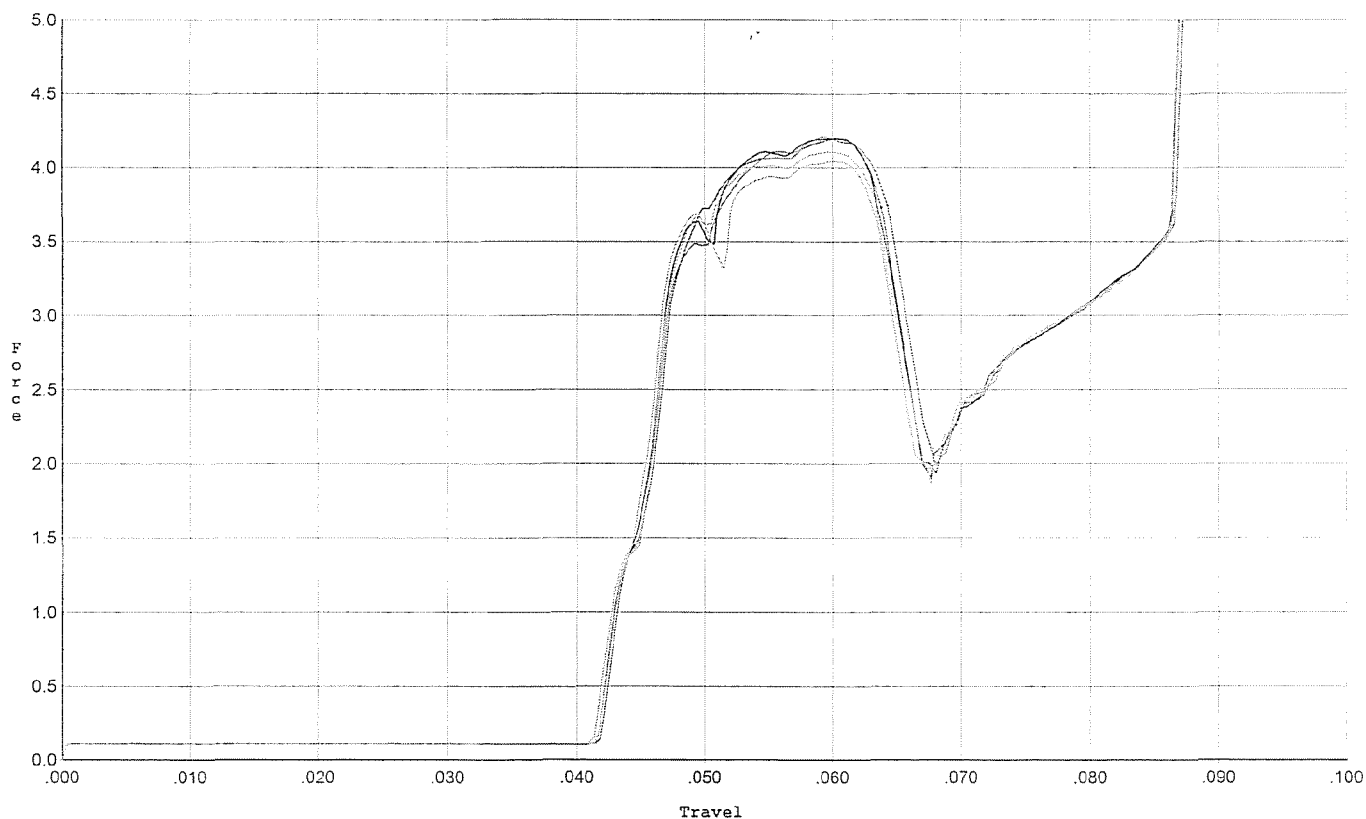
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.052	0.034	0.031	0.043		Set Trigger
2	2.573	0.052	0.033	0.032	0.040		Set Trigger
3	2.458	0.051	0.034	0.032	0.039		Set Trigger
4	2.451	0.052	0.034	0.032	0.039		Set Trigger
5	2.472	0.051	0.033	0.032	0.039		Set Trigger

AVG 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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	4.201	0.064	0.042	0.027	0.082		Set Trigger
2	4.198	0.064	0.042	0.027	0.084		Set Trigger
3	4.207	0.064	0.042	0.027	0.084		Set Trigger
4	4.107	0.063	0.042	0.028	0.080		Set Trigger
5	4.042	0.063	0.042	0.027	0.080		Set Trigger

Aug 4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6644517.___0
FILE DATE AND TIME: 04/19/2007 10:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	-0.049
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.622
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.151
The Distance from Centroid Target #3 to Centroid Target #1:	0.273
The Distance from Centroid Target #4 to Centroid Target #1:	0.092
The Distance from Centroid Target #5 to Centroid Target #1:	0.038

SERIAL NUMBER: G6644517. __0

TARGET NUMBER: 1

FILE DATE: 04/19/2007

FILE TIME: 10:10

POINT#	X	Y
1:	1.632	-0.490
2:	0.469	0.730
3:	0.152	0.445
4:	-0.006	0.076
5:	0.221	-0.263
6:	-0.255	-0.201
7:	-0.255	-0.580
8:	-0.206	-0.818
9:	-0.882	-0.018
10:	-1.161	-0.104

X CENTROID: -0.029

Y CENTROID: -0.122

POA TO CENTROID: 0.126

HORZ SPREAD: 2.793

VERT SPREAD: 1.548

GROUP SPREAD: 2.820

MIN RADIUS: 0.200

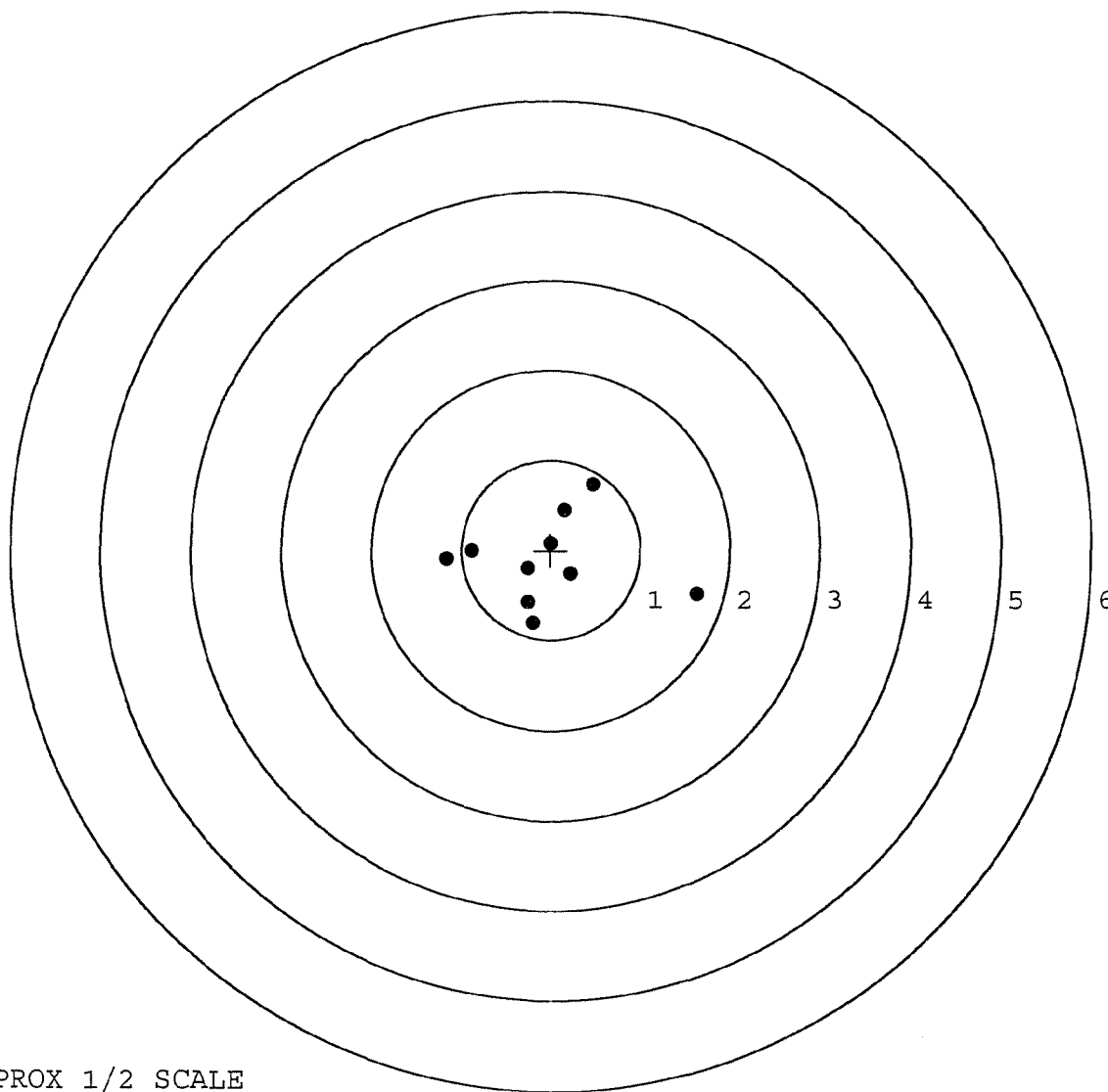
MAX RADIUS: 1.701

MEAN RADIUS: 0.723

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

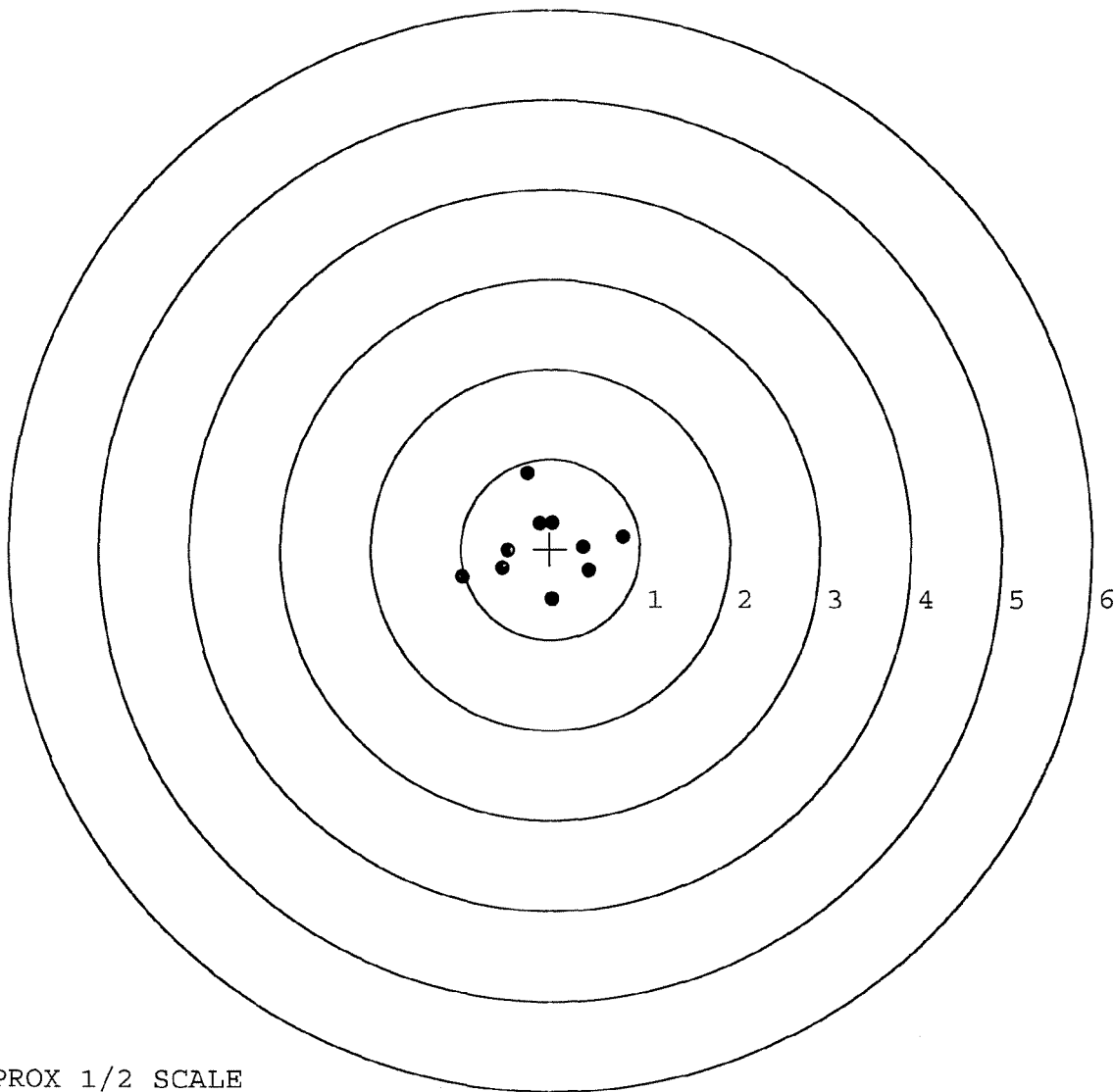


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644517. __0
TARGET NUMBER: 2
FILE DATE: 04/19/2007
FILE TIME: 10:10

POINT#	X	Y
1:	0.811	0.134
2:	-0.258	0.840
3:	-0.122	0.282
4:	0.024	0.291
5:	0.368	0.025
6:	0.433	-0.239
7:	0.023	-0.556
8:	-0.535	-0.215
9:	-0.478	-0.025
10:	-0.983	-0.316

X CENTROID: -0.072
Y CENTROID: 0.022
POA TO CENTROID: 0.075
HORZ SPREAD: 1.794
VERT SPREAD: 1.396
GROUP SPREAD: 1.850
MIN RADIUS: 0.265
MAX RADIUS: 0.972
MEAN RADIUS: 0.577
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644517. __0

TARGET NUMBER: 3

FILE DATE: 04/19/2007

FILE TIME: 10:10

POINT#	X	Y
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1:	-0.467	0.977
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2:	-0.708	0.046
----	--------	-------

3:	-0.503	-0.338
----	--------	--------

4:	-0.355	-0.948
----	--------	--------

5:	0.277	-0.341
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6:	0.819	-0.136
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7:	0.782	0.030
----	-------	-------

8:	0.404	0.239
----	-------	-------

9:	0.995	0.490
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10:	0.748	0.248
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X CENTROID: 0.199

Y CENTROID: 0.027

POA TO CENTROID: 0.201

HORZ SPREAD: 1.703

VERT SPREAD: 1.925

GROUP SPREAD: 1.928

MIN RADIUS: 0.295

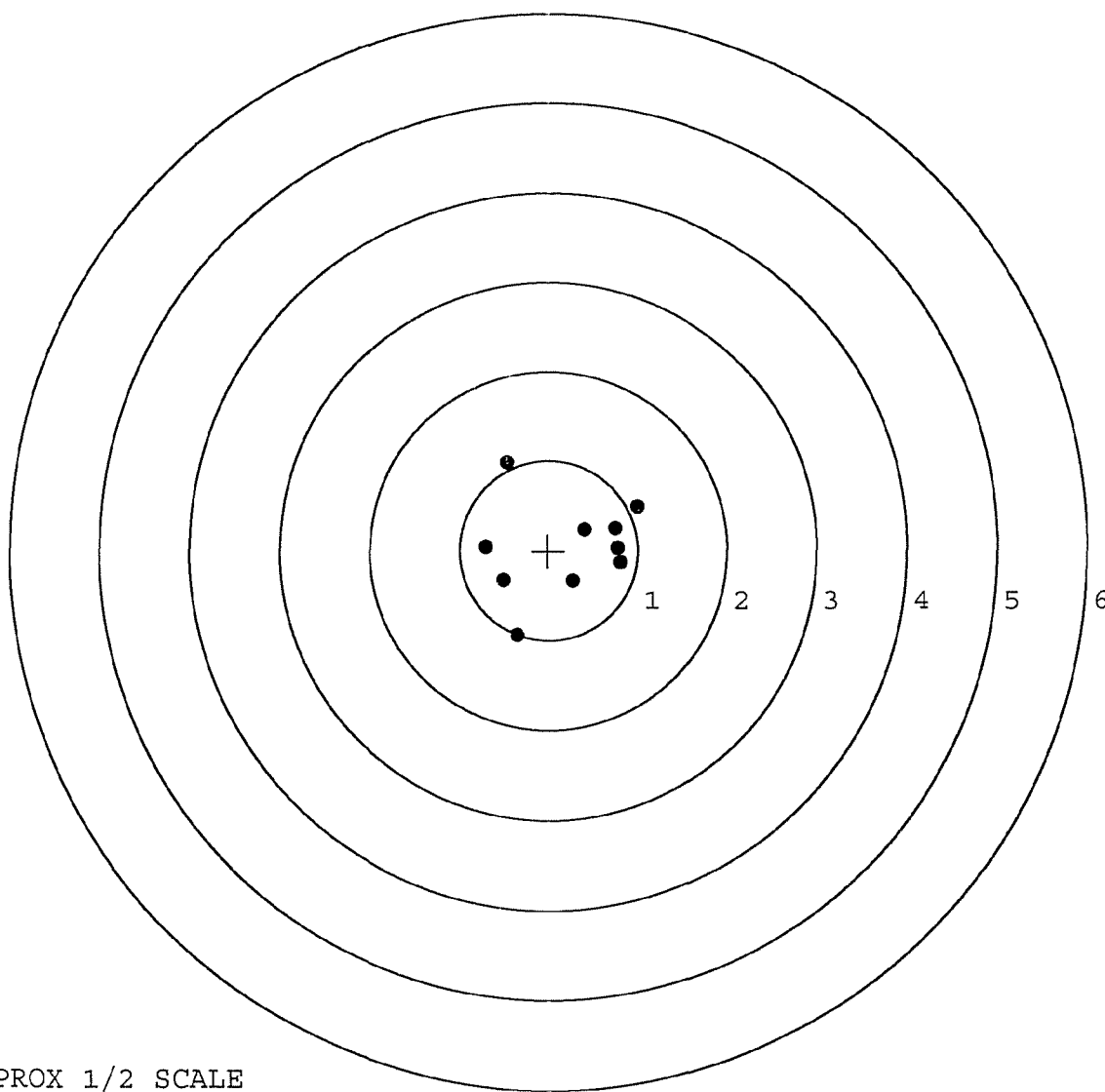
MAX RADIUS: 1.161

MEAN RADIUS: 0.739

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644517. __0

TARGET NUMBER: 4

FILE DATE: 04/19/2007

FILE TIME: 10:10

POINT#	X	Y
1:	-0.301	-0.912
2:	-0.374	-0.681
3:	-0.301	-0.332
4:	0.653	0.447
5:	-0.185	0.833
6:	-0.473	0.616
7:	0.341	-0.114
8:	0.190	0.150
9:	0.059	-0.304
10:	-0.186	-0.054

X CENTROID: -0.058

Y CENTROID: -0.035

POA TO CENTROID: 0.068

HORZ SPREAD: 1.126

VERT SPREAD: 1.745

GROUP SPREAD: 1.749

MIN RADIUS: 0.130

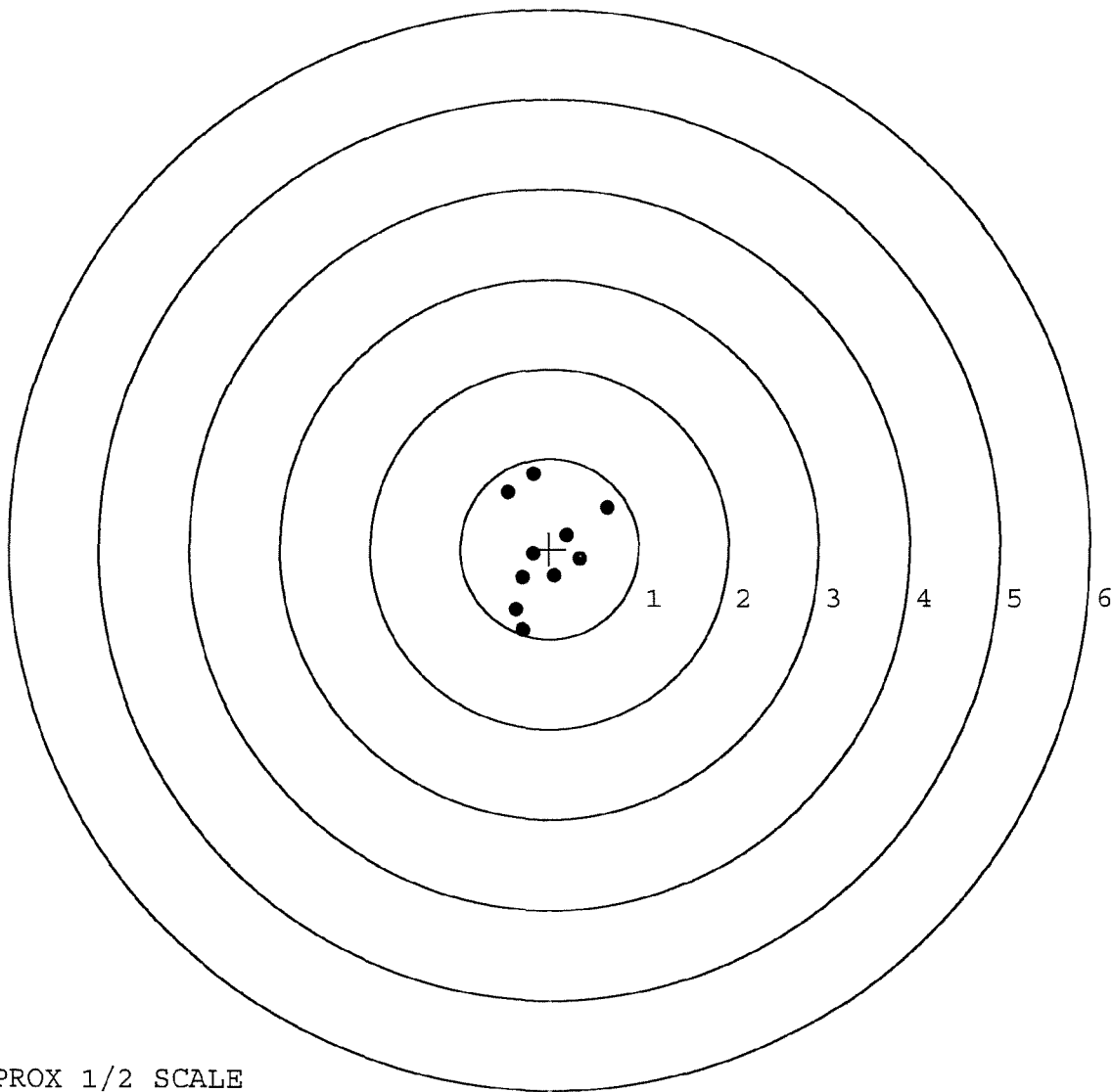
MAX RADIUS: 0.910

MEAN RADIUS: 0.566

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

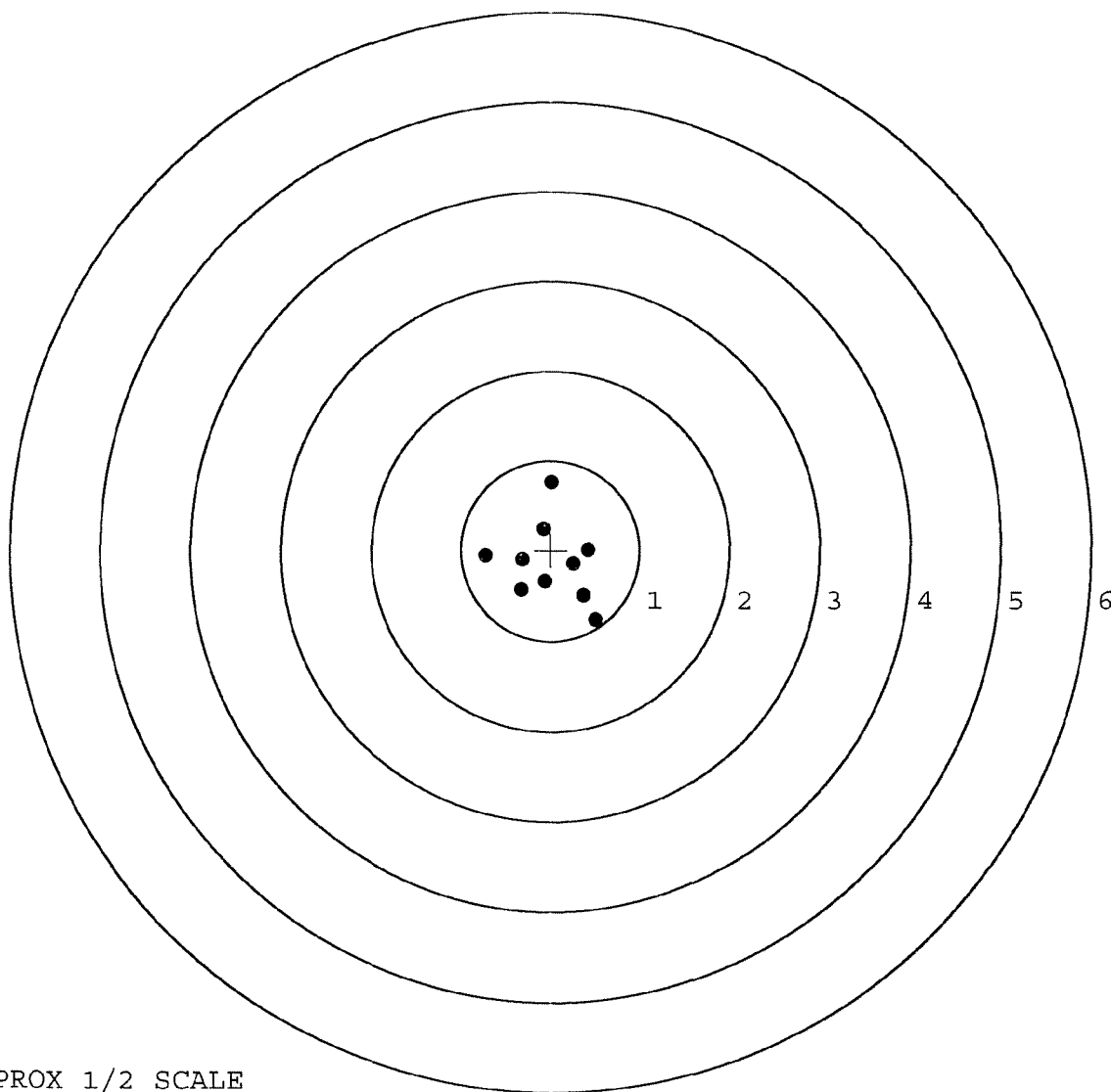


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644517. __0
TARGET NUMBER: 5
FILE DATE: 04/19/2007
FILE TIME: 10:10

POINT#	X	Y
1:	0.506	-0.769
2:	0.367	-0.503
3:	0.426	-0.001
4:	0.257	-0.156
5:	-0.062	-0.347
6:	-0.331	-0.440
7:	-0.314	-0.110
8:	-0.081	0.239
9:	-0.727	-0.060
10:	0.011	0.760

X CENTROID: 0.005
Y CENTROID: -0.139
POA TO CENTROID: 0.139
HORZ SPREAD: 1.233
VERT SPREAD: 1.529
GROUP SPREAD: 1.607
MIN RADIUS: 0.219
MAX RADIUS: 0.899
MEAN RADIUS: 0.503
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE