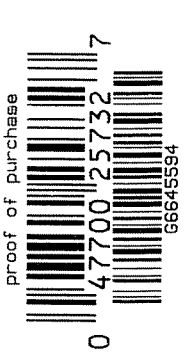
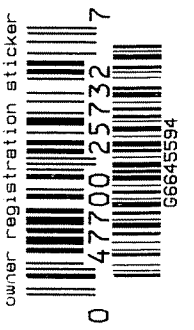
M/24 7.62 NATO (RIFLE ONLY)

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

DD FORM 200348

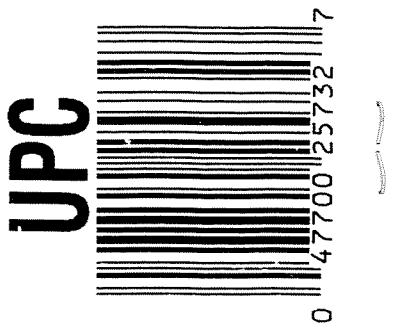




ORDER NO. **25732**

BARREL LENGTH	24"
CAPACITY	5

G6645594



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

SERIAL NO.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6645594

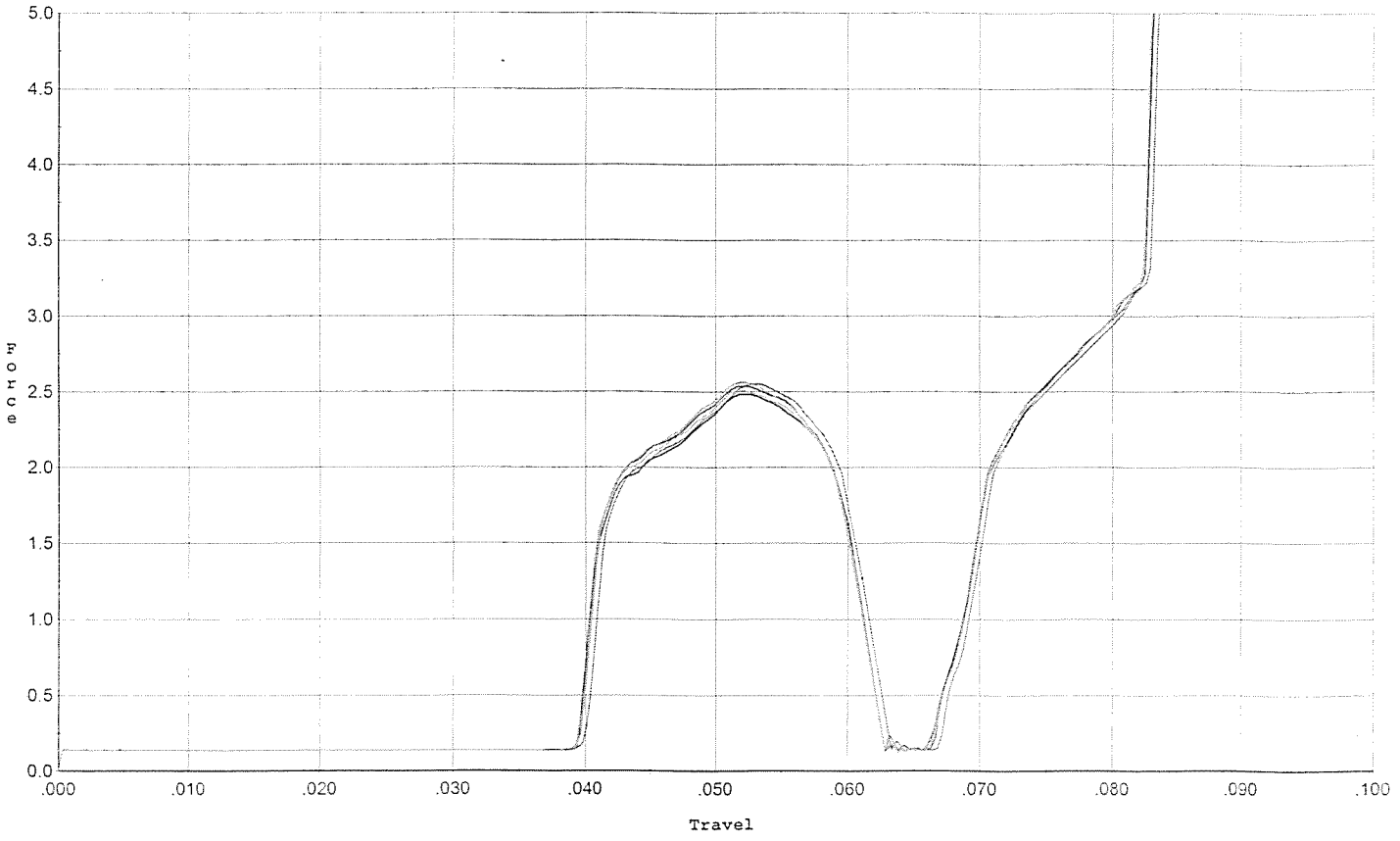
OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-18-07	KTL
420	ASSEMBLE ACTION		5-18-07	KTL
430	ASSEMBLE TO STOCK		5-17-07	FM
440	PROOF	MAGNA - FLUX MAY 21 2007 OPERATOR	5-17-07	TRW
460	CHECK HEADSPACE		5-17-07	TRW
470	DIS-ASSEMBLE ACTION		5-18-07	KTL
480	MAGNAFLUX BBL ACTION		5/21/07	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-21-07	CW
510	DRILL AND TAP SIGHT HOLES		5-21-07	TRW
520	GOFF BLAST BBL / REC		5-22-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/23/07	PB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		5-25-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-25-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-25-07	SD
	D) OIL FIRING PIN ASSEMBLY		5-30-07	SDD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	7.0	7.0	7.0	6-6-07	DA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	3.5	3.0	3.0	6-6-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	.023	.0235	.0235	6-6-07	DA
	J) ASSEMBLE STOCK					5-30-07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS					6-6-07	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S						
	M) IRON SIGHT ALIGNMENT						
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER						
640 &	FUNCTION TEST AND		(PASS)	FAIL			
650	TARGET		(PASS)	FAIL		6/4/07	
	MALFUNCTION	CORRECTION					
	MALFUNCTION	CORRECTION	N/A				
	MALFUNCTION	CORRECTION					
	MALFUNCTION	CORRECTION					
660	INSPECT FOR LIVE AMMO					6-4-07	SD
670	FINAL INSPECTION A) HEADSPACE					6-6-07	L.P.D.
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.72	2.66	2.68	2.74 2.82	6-6-07 DA
	C) FUNCTION					6-6-07	L.P.D.
690	PACK					6/1/07	DA

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini. +/- .50 lbs.
Note:	R. Putch 5/30/07		

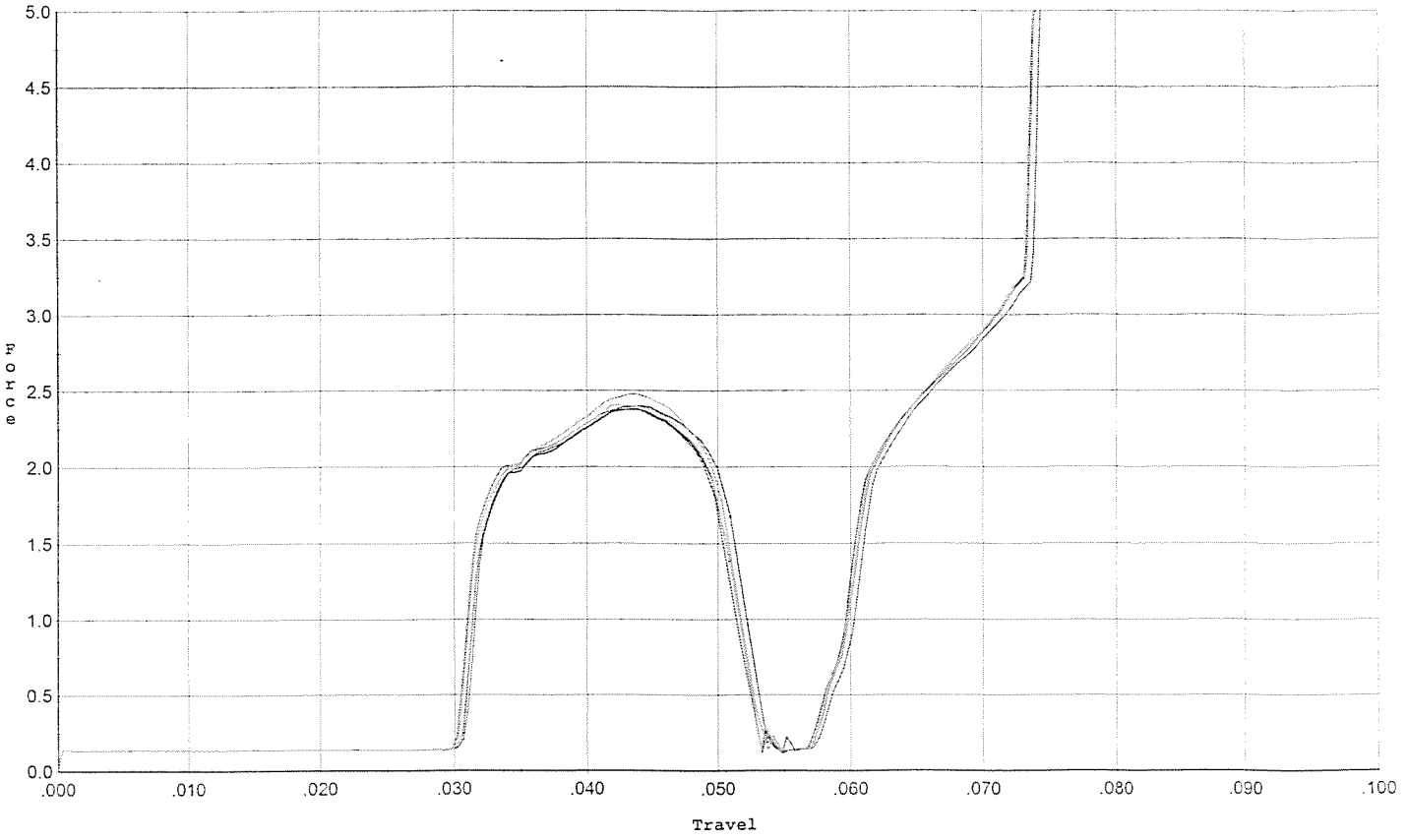


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.538	0.060	0.040	0.030	0.050		Set Trigger
2	2.485	0.060	0.040	0.030	0.049		Set Trigger
3	2.553	0.061	0.040	0.030	0.050		Set Trigger
4	2.511	0.061	0.040	0.030	0.049		Set Trigger
5	2.563	0.060	0.040	0.030	0.050		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 5/30/07		

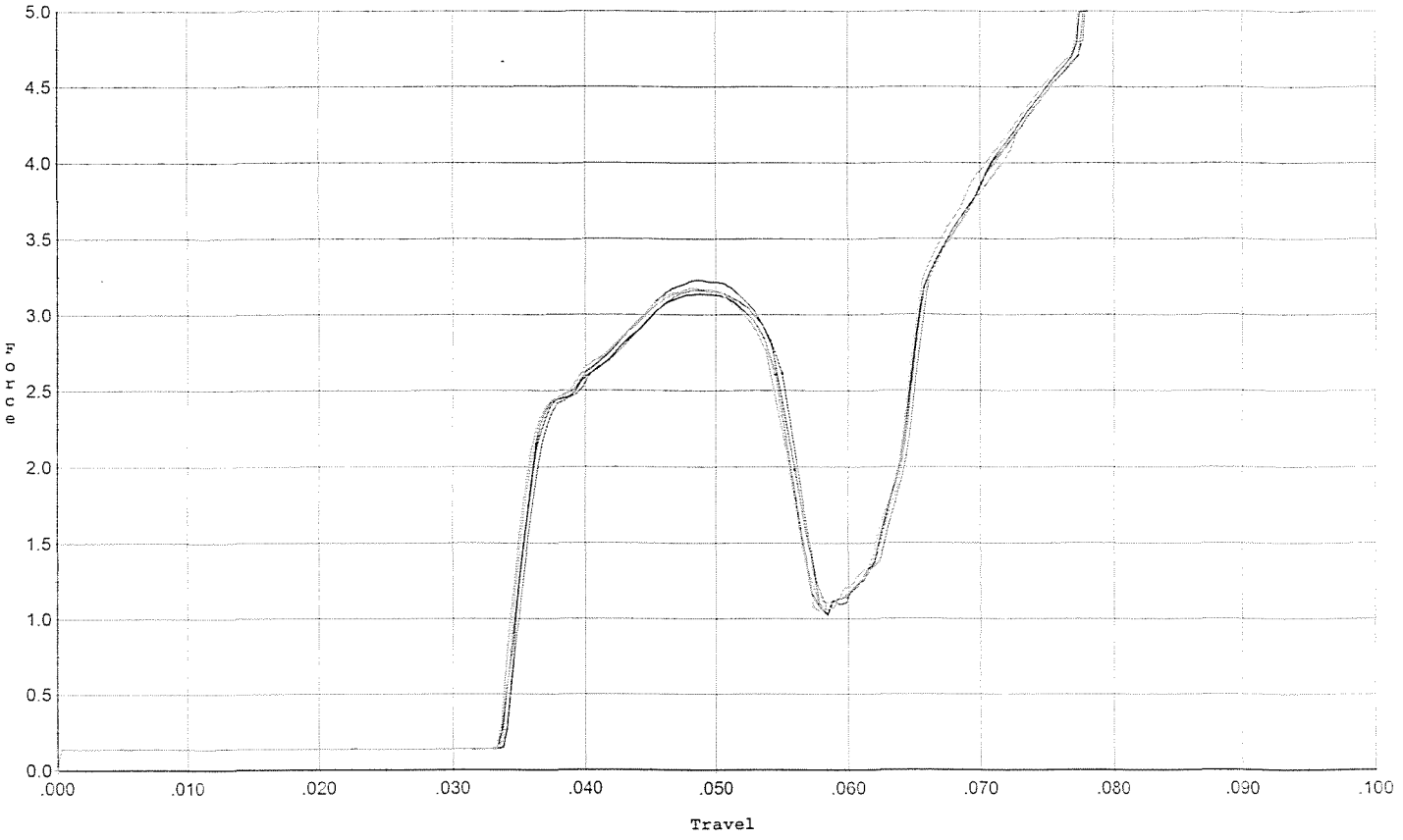


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.397	0.051	0.031	0.030	0.046		Set Trigger
2	2.376	0.051	0.031	0.030	0.045		Set Trigger
3	2.380	0.050	0.030	0.030	0.045		Set Trigger
4	2.404	0.051	0.030	0.030	0.046		Set Trigger
5	2.477	0.050	0.031	0.030	0.046		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 5/30/07		

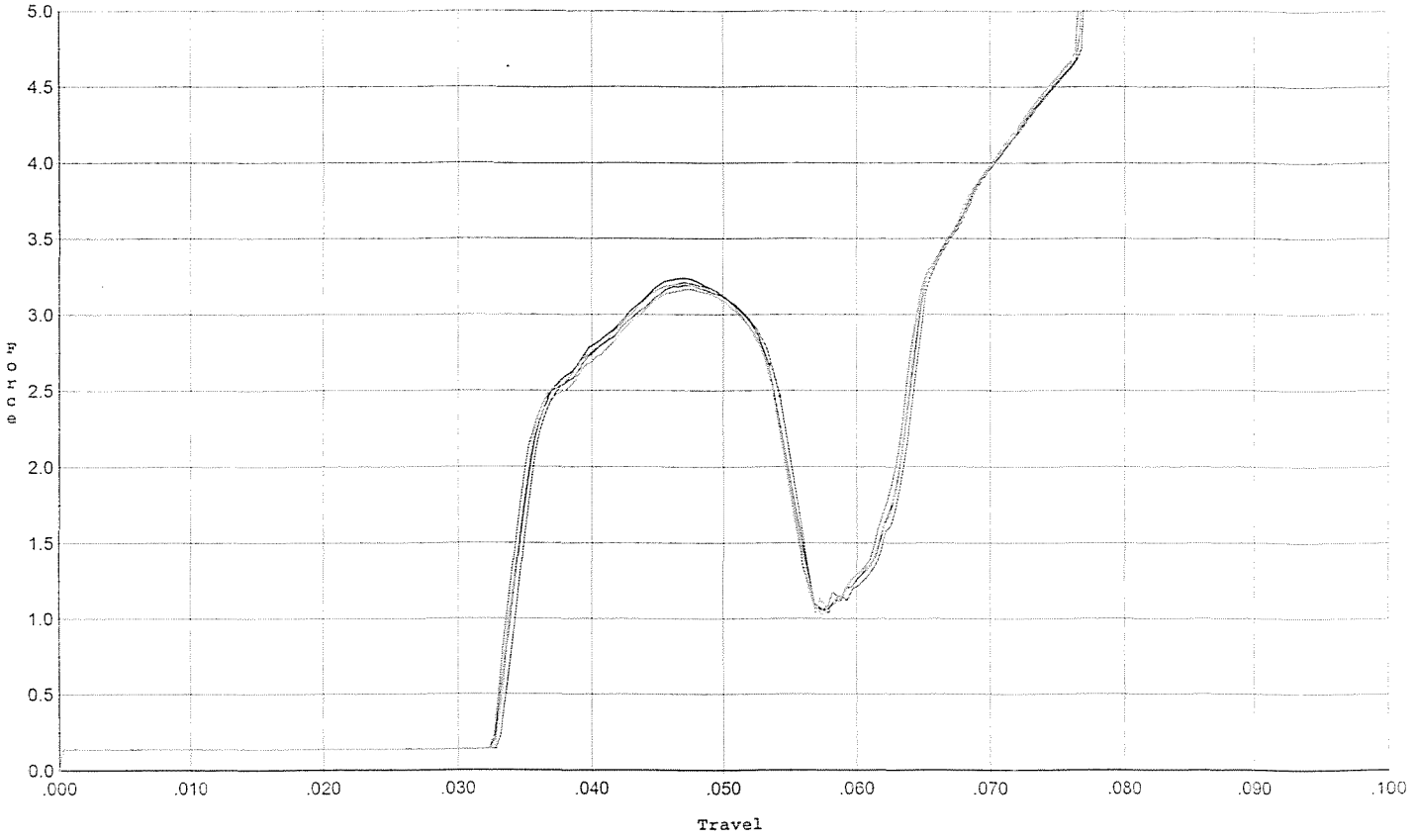


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.229	0.056	0.034	0.028	0.064		Set Trigger
2	3.138	0.055	0.034	0.028	0.061		Set Trigger
3	3.165	0.055	0.034	0.028	0.062		Set Trigger
4	3.160	0.055	0.034	0.028	0.063		Set Trigger
5	3.174	0.055	0.034	0.029	0.062		Set Trigger

Avg 3.17

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 5/30/07		

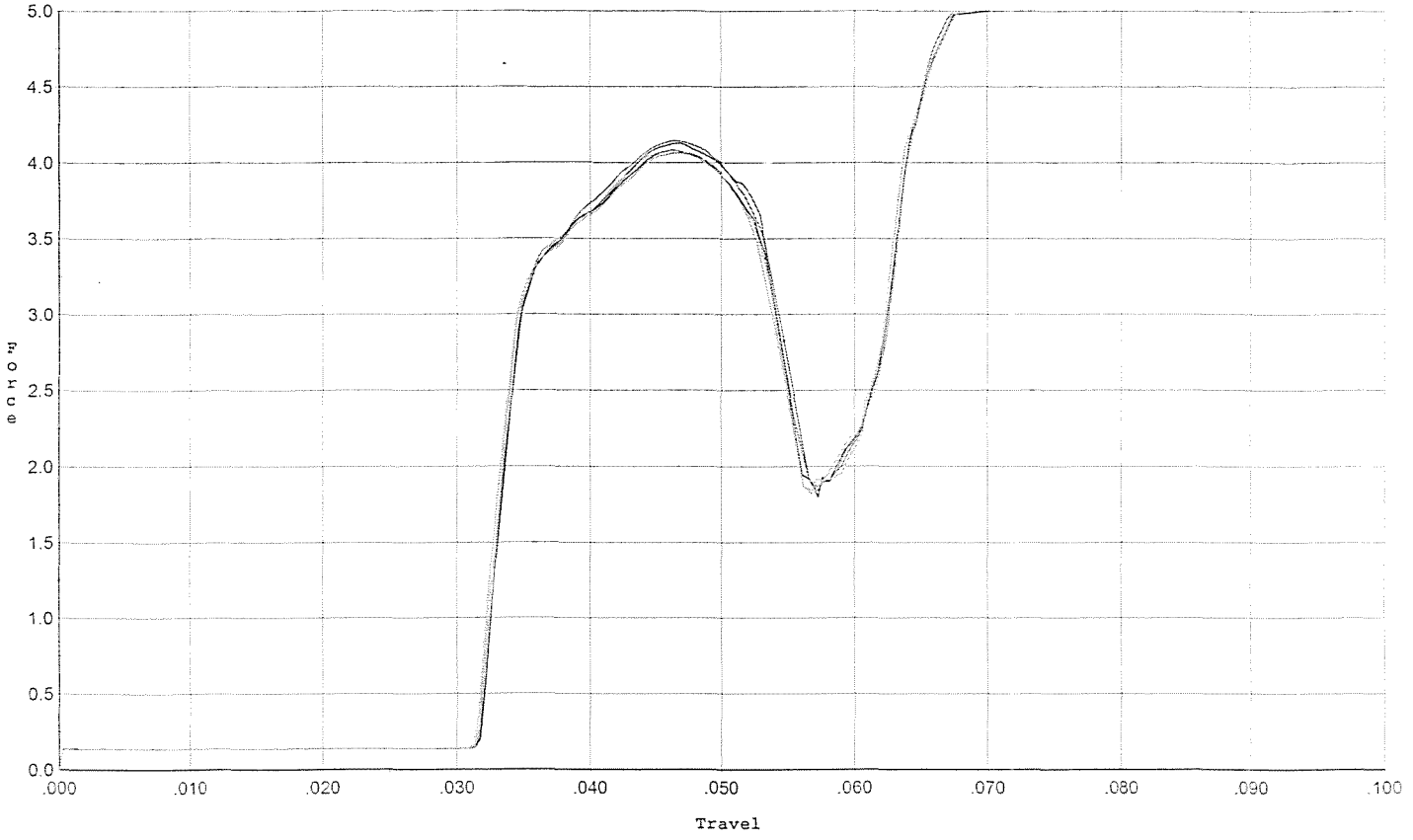


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.192	0.054	0.033	0.028	0.062		Set Trigger
2	3.239	0.053	0.033	0.029	0.062		Set Trigger
3	3.210	0.054	0.033	0.029	0.062		Set Trigger
4	3.201	0.054	0.033	0.029	0.061		Set Trigger
5	3.165	0.053	0.033	0.029	0.061		Set Trigger

Avg 3.20

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 5/30/07		

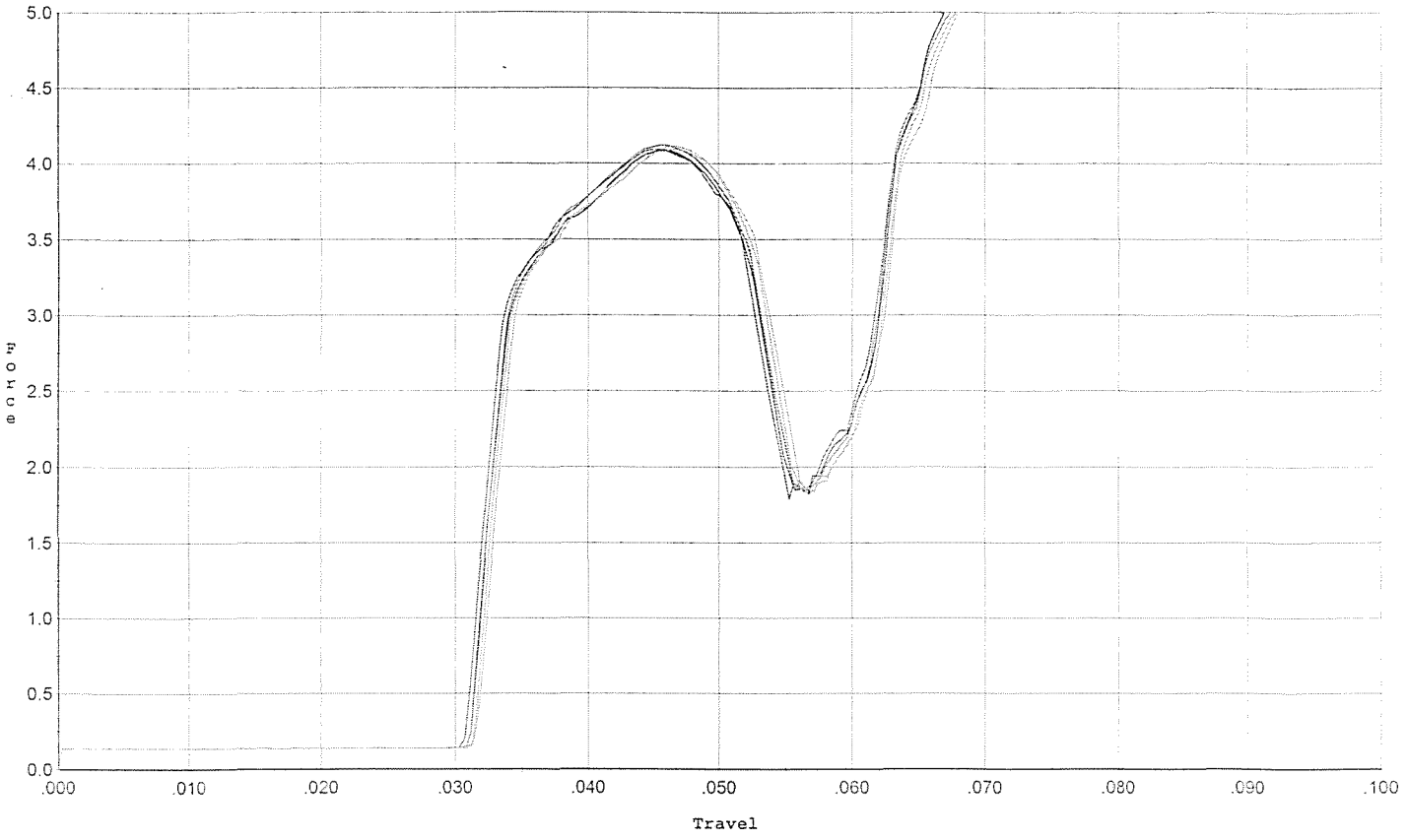


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.055	0.032	0.026	0.085		Set Trigger
2	4.081	0.053	0.032	0.027	0.081		Set Trigger
3	4.142	0.053	0.032	0.027	0.082		Set Trigger
4	4.080	0.054	0.032	0.027	0.083		Set Trigger
5	4.064	0.054	0.032	0.027	0.082		Set Trigger

AVG 4.09

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 5/30/07		

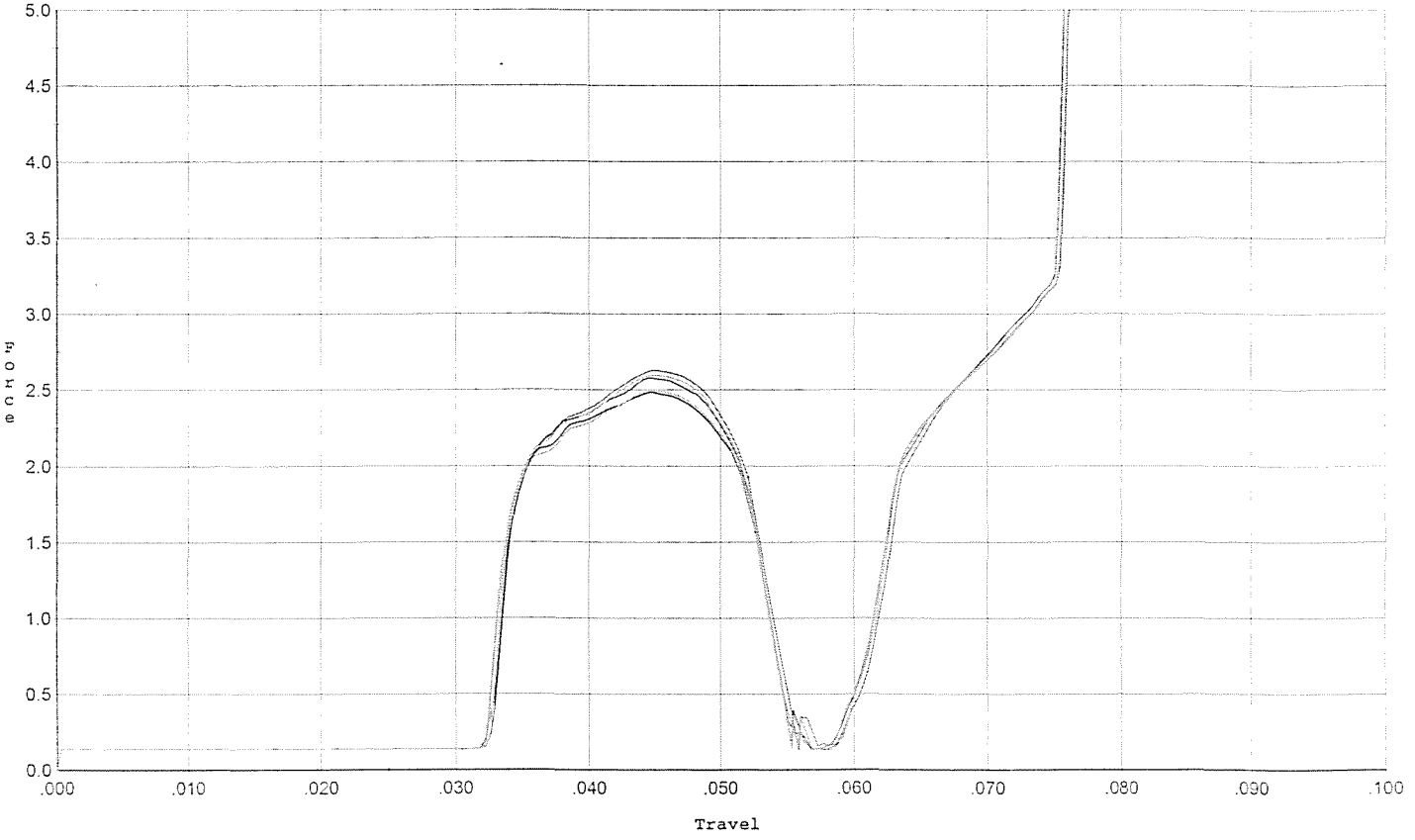


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.052	0.031	0.027	0.079		Set Trigger
2	4.090	0.053	0.031	0.027	0.080		Set Trigger
3	4.123	0.052	0.031	0.027	0.080		Set Trigger
4	4.114	0.053	0.031	0.027	0.081		Set Trigger
5	4.093	0.054	0.032	0.027	0.083		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 5/30/07		



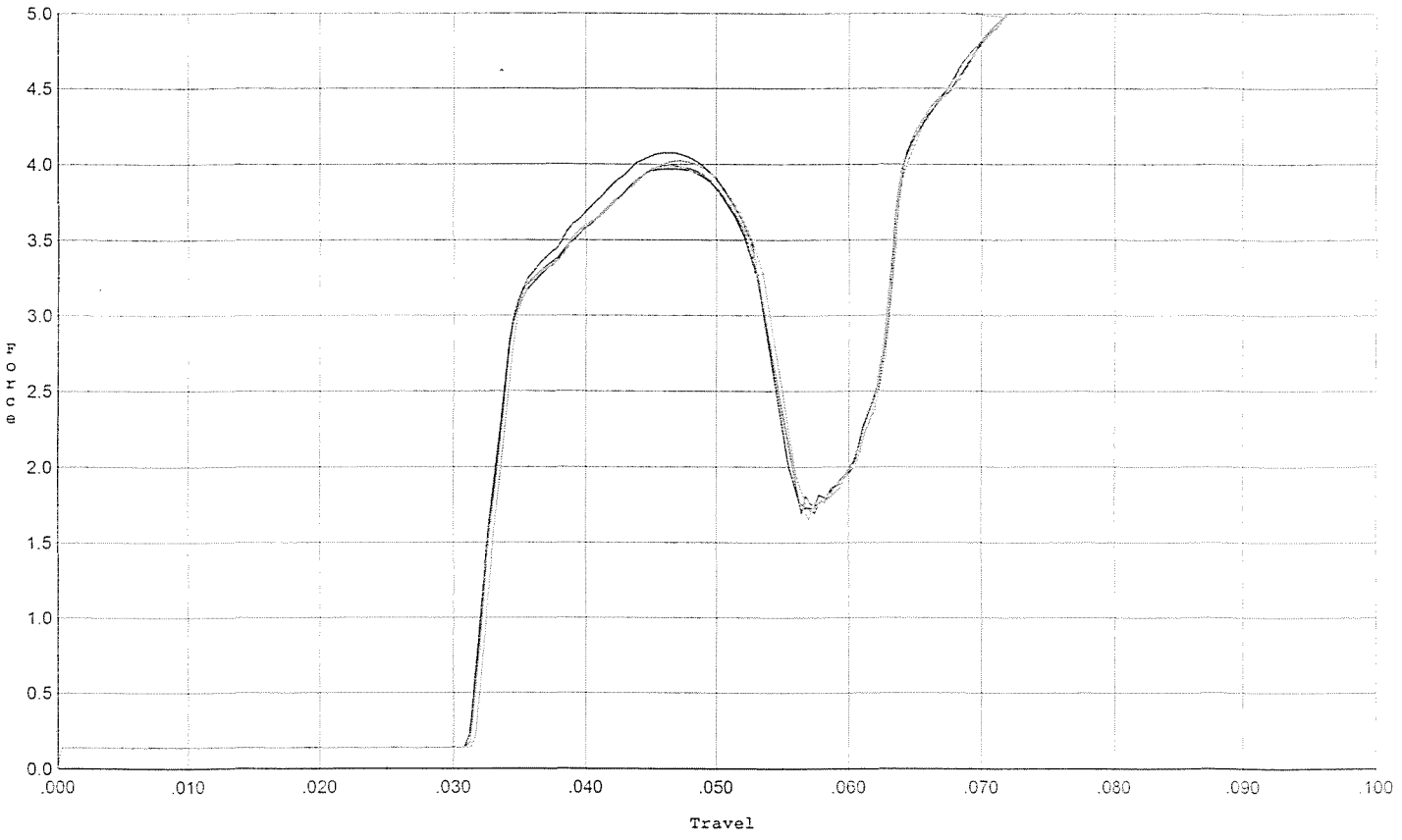
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.579	0.052	0.032	0.031	0.049		Set Trigger
2	2.485	0.053	0.033	0.030	0.047		Set Trigger
3	2.628	0.052	0.032	0.030	0.049		Set Trigger
4	2.596	0.052	0.032	0.030	0.049		Set Trigger
5	2.492	0.053	0.033	0.031	0.048		Set Trigger

AVG 2.55

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/30/2007 6:24:18 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 5/30/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.075	0.053	0.031	0.027	0.080		Set Trigger
2	3.969	0.053	0.031	0.027	0.079		Set Trigger
3	3.992	0.053	0.031	0.027	0.079		Set Trigger
4	3.994	0.055	0.031	0.027	0.082		Set Trigger
5	4.022	0.054	0.032	0.027	0.080		Set Trigger

Avg 4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645594.__0
FILE DATE AND TIME: 06/04/2007 23:19

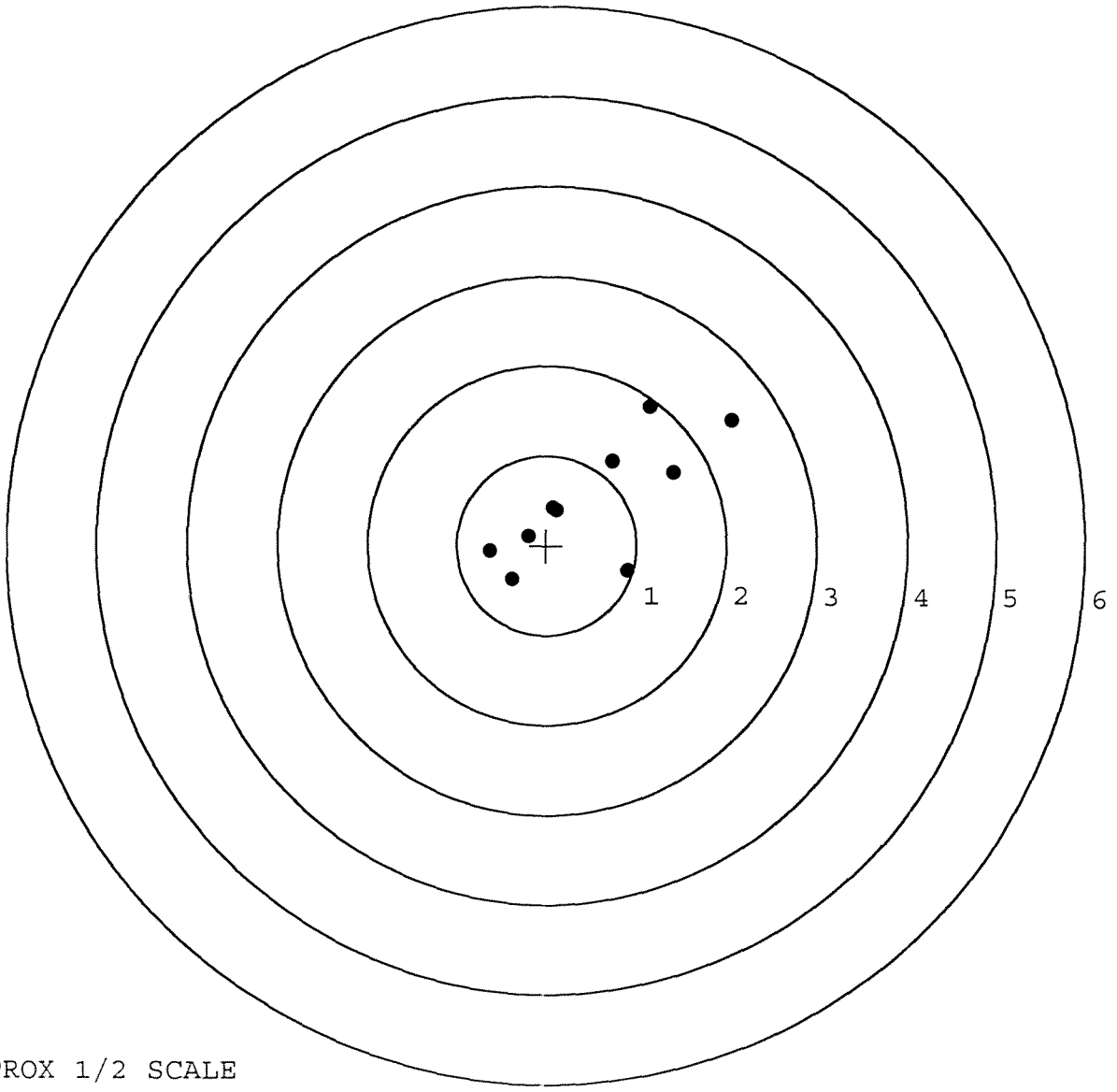
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.173
The Average Y Centroid of the Five Target Set:	0.151
The Average Point of Impact of the Five Target Set:	0.230
The Average Mean Radius of the Five Target Set:	0.778
The Distance from POA to Centroid Target #1:	0.715
The Distance from Centroid Target #2 to Centroid Target #1:	0.603
The Distance from Centroid Target #3 to Centroid Target #1:	0.737
The Distance from Centroid Target #4 to Centroid Target #1:	0.625
The Distance from Centroid Target #5 to Centroid Target #1:	0.498

SERIAL NUMBER: G6645594.__0
TARGET NUMBER: 1
FILE DATE: 06/04/2007
FILE TIME: 23:19

X CENTROID:	0.521
Y CENTROID:	0.491
POA TO CENTROID:	0.715
HORZ SPREAD:	2.672
VERT SPREAD:	1.929
GROUP SPREAD:	3.048
MIN RADIUS:	0.412
MAX RADIUS:	1.772
MEAN RADIUS:	0.950
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.630	-0.067
2:	-0.376	-0.376
3:	-0.197	0.100
4:	0.119	0.399
5:	0.905	-0.279
6:	0.726	0.944
7:	1.401	0.814
8:	1.139	1.553
9:	2.042	1.400
10:	0.077	0.420

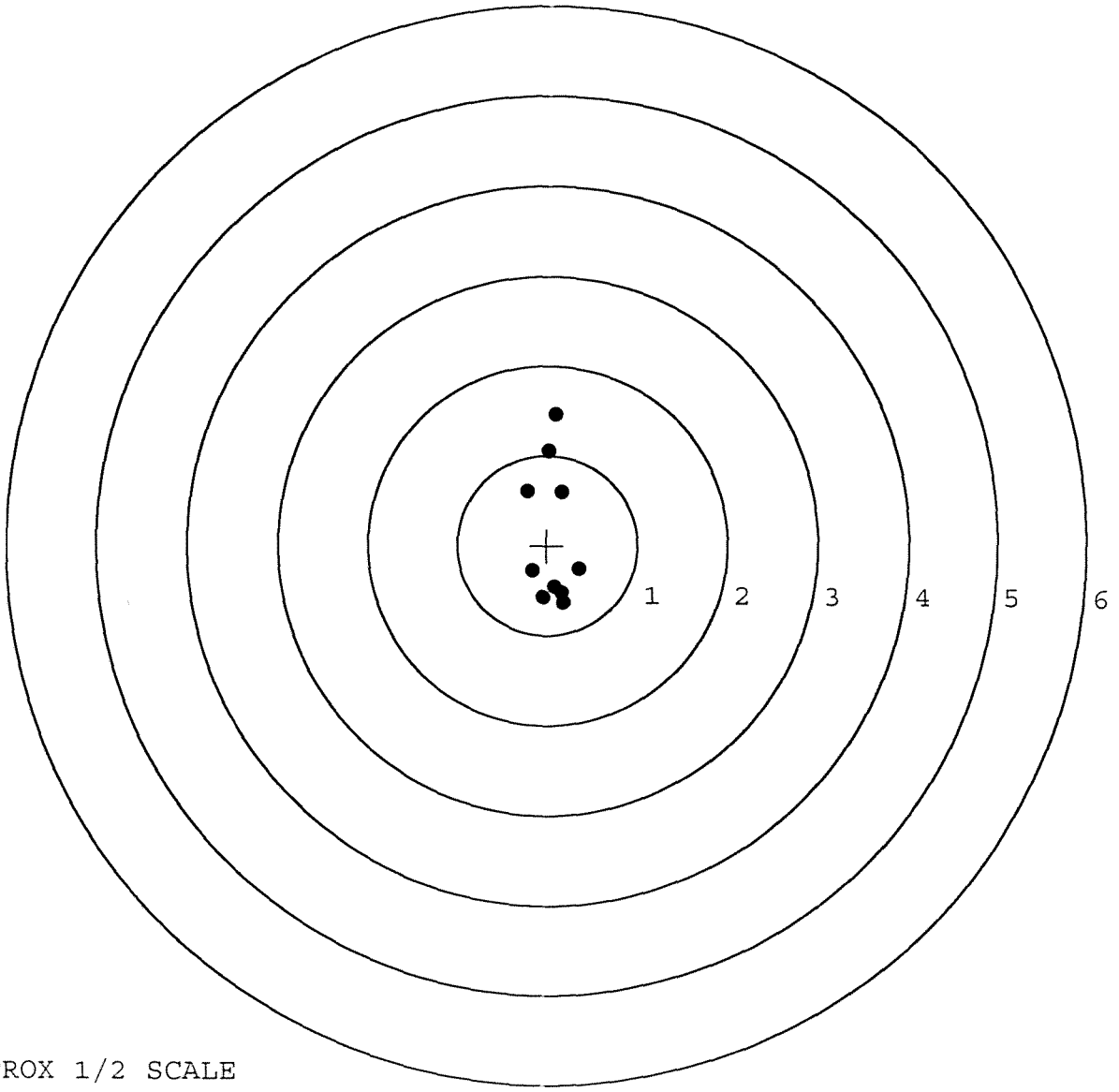


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645594.__0
TARGET NUMBER: 2
FILE DATE: 06/04/2007
FILE TIME: 23:19

X CENTROID:	0.065
Y CENTROID:	0.096
POA TO CENTROID:	0.116
HORZ SPREAD:	0.579
VERT SPREAD:	2.100
GROUP SPREAD:	2.102
MIN RADIUS:	0.444
MAX RADIUS:	1.364
MEAN RADIUS:	0.694
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.093	1.460
2:	0.015	1.051
3:	-0.225	0.605
4:	0.164	0.598
5:	-0.163	-0.285
6:	-0.043	-0.582
7:	0.169	-0.532
8:	0.354	-0.254
9:	0.091	-0.460
10:	0.193	-0.640

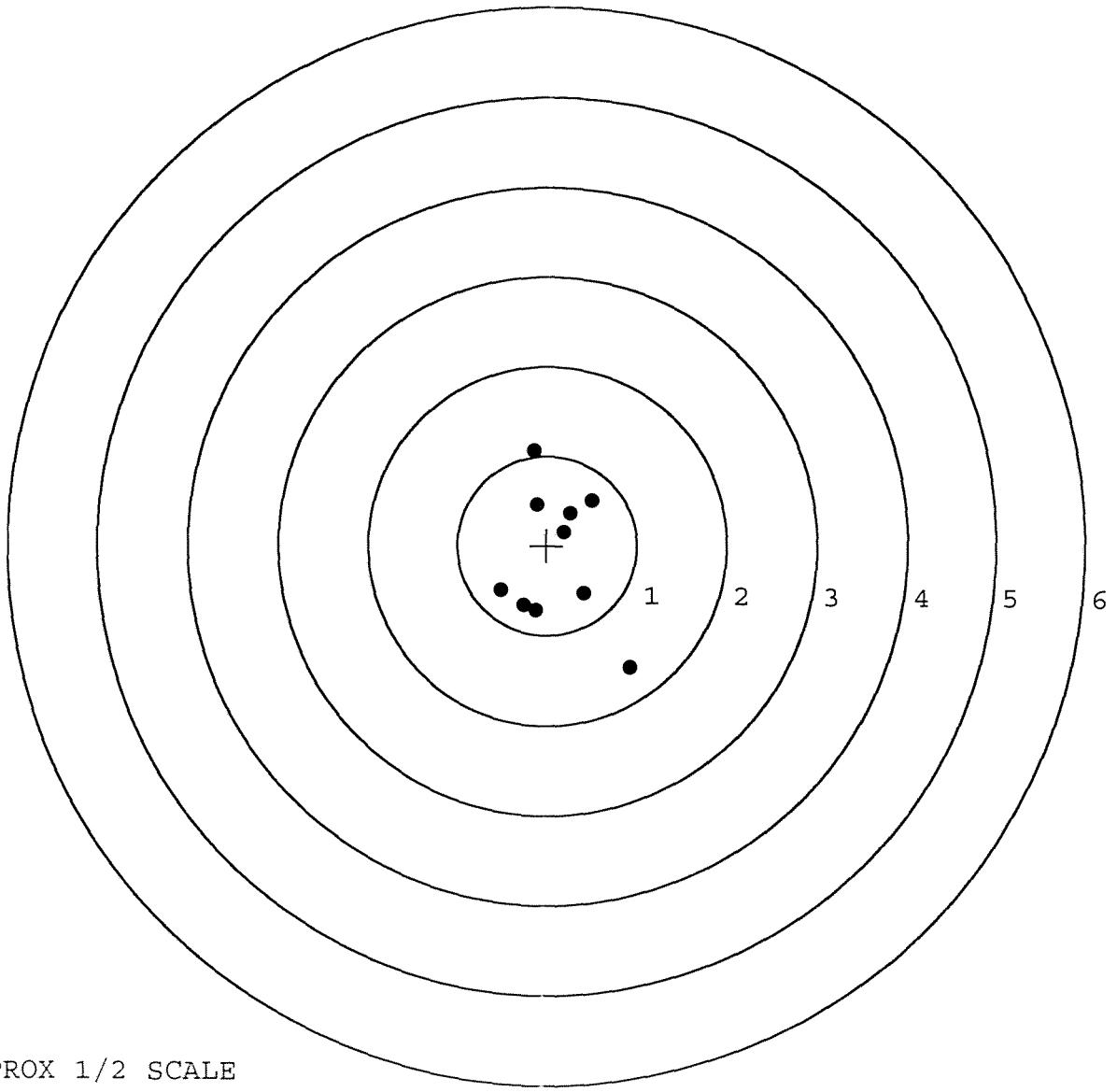


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645594.__0
TARGET NUMBER: 3
FILE DATE: 06/04/2007
FILE TIME: 23:19

X CENTROID:	0.117
Y CENTROID:	-0.126
POA TO CENTROID:	0.171
HORZ SPREAD:	1.450
VERT SPREAD:	2.417
GROUP SPREAD:	2.652
MIN RADIUS:	0.286
MAX RADIUS:	1.481
MEAN RADIUS:	0.740
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.153	1.060
2:	-0.108	0.457
3:	-0.511	-0.504
4:	-0.250	-0.672
5:	-0.116	-0.730
6:	0.416	-0.530
7:	0.939	-1.357
8:	0.193	0.150
9:	0.262	0.362
10:	0.495	0.509

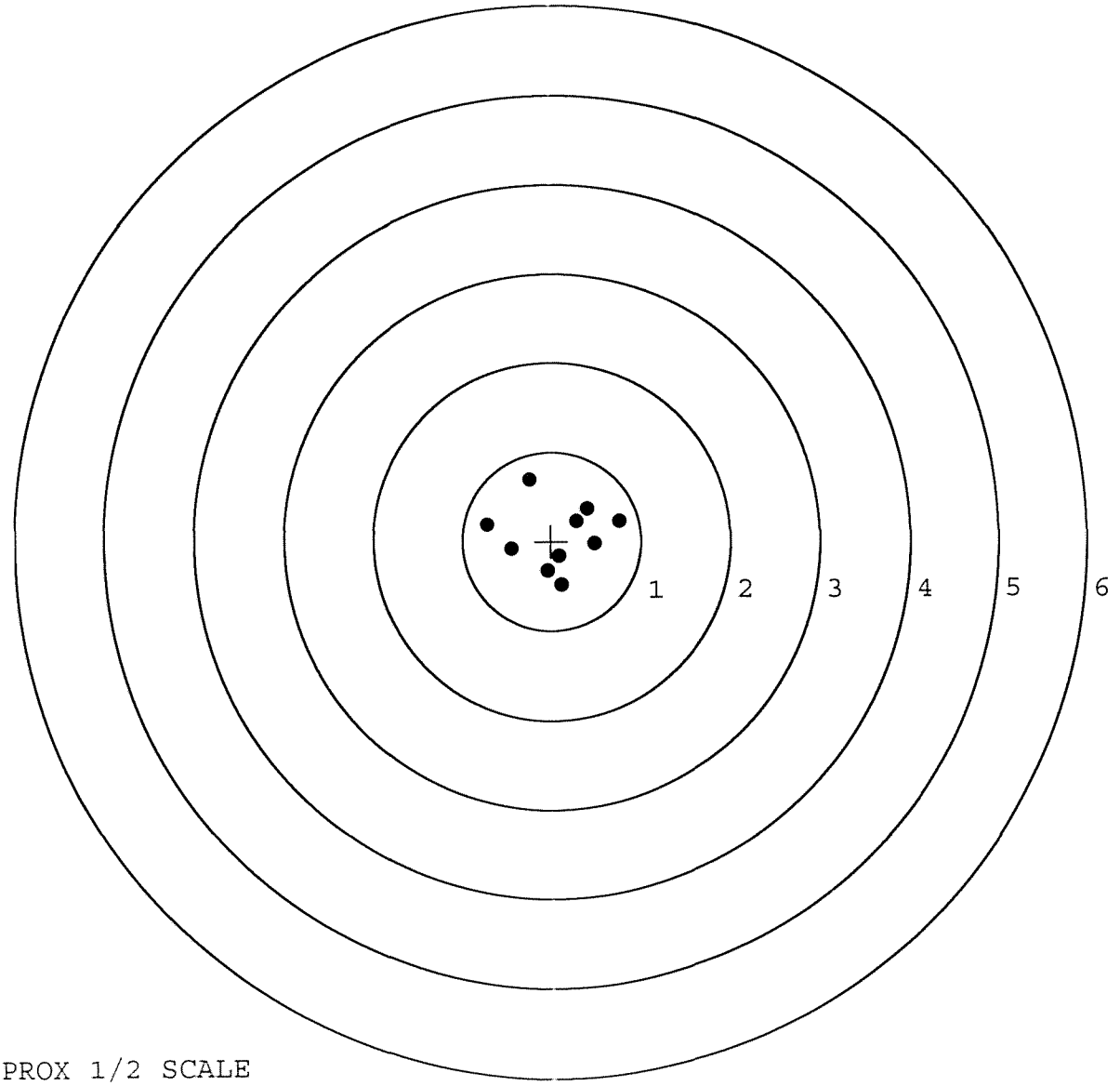


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645594.__0
TARGET NUMBER: 4
FILE DATE: 06/04/2007
FILE TIME: 23:19

X CENTROID:	0.071
Y CENTROID:	0.056
POA TO CENTROID:	0.090
HORZ SPREAD:	1.480
VERT SPREAD:	1.187
GROUP SPREAD:	1.480
MIN RADIUS:	0.227
MAX RADIUS:	0.800
MEAN RADIUS:	0.509
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.234	0.691
2:	-0.719	0.186
3:	-0.447	-0.089
4:	-0.041	-0.337
5:	0.117	-0.496
6:	0.088	-0.170
7:	0.289	0.220
8:	0.411	0.363
9:	0.483	-0.028
10:	0.761	0.223

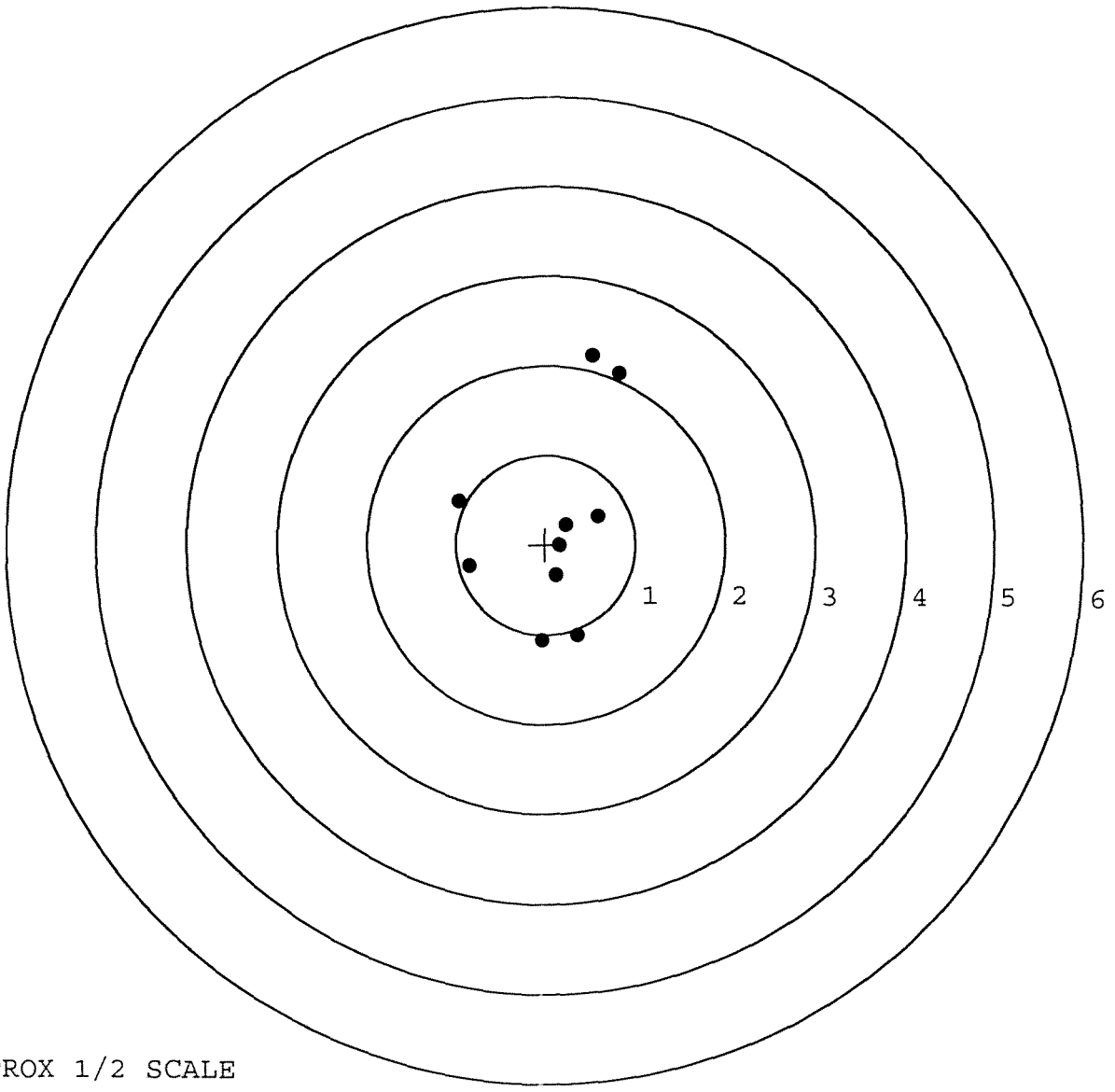


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645594.__0
TARGET NUMBER: 5
FILE DATE: 06/04/2007
FILE TIME: 23:19

X CENTROID:	0.093
Y CENTROID:	0.236
POA TO CENTROID:	0.254
HORZ SPREAD:	1.778
VERT SPREAD:	3.182
GROUP SPREAD:	3.228
MIN RADIUS:	0.135
MAX RADIUS:	1.922
MEAN RADIUS:	0.996
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.973	0.477
2:	-0.850	-0.250
3:	-0.032	-1.069
4:	0.367	-1.011
5:	0.127	-0.345
6:	0.165	-0.009
7:	0.227	0.225
8:	0.583	0.315
9:	0.805	1.918
10:	0.510	2.113



TARGET APPROX 1/2 SCALE