

G 6645605

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348

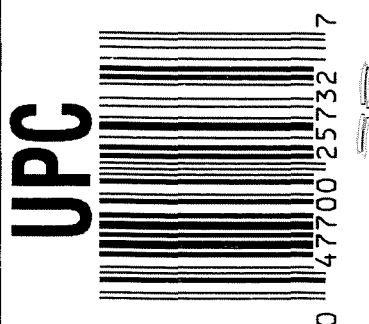


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6645605



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400172301

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66645605

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-18-07	RTZ
420	ASSEMBLE ACTION		5-16-07	P.P.D.
430	ASSEMBLE TO STOCK		5-17-07	FM
440	PROOF	MAGNA FLUX	5-17-07	TRW
460	CHECK HEADSPACE	MAY 21 2008	5-17-07	TRW
470	DIS-ASSEMBLE ACTION		5-18-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unus</u>	5/21/07	unus
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-21-07	C.W.
510	DRILL AND TAP SIGHT HOLES		5-21-07	TRW
520	GOFF BLAST BBL / REC		5-22-07	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/23/07	FS
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-29-07	P.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-29-07	P.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-29-07	P.P.D.
	D) OIL FIRING PIN ASSEMBLY		5-29-07	P.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

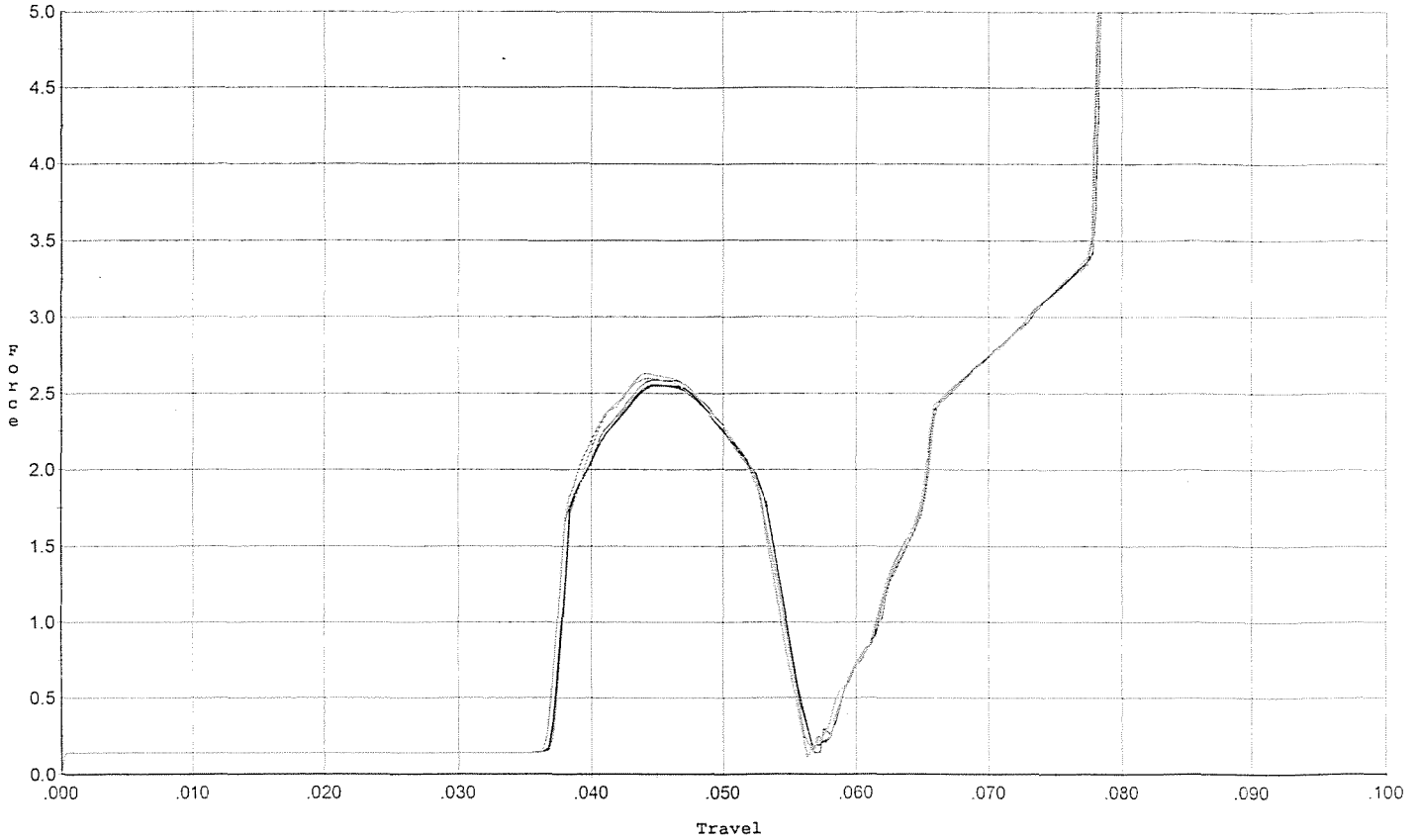
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>50</u> <u>50</u>	6-1-07	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>30</u> <u>30</u>	6-1-07	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	6-1-07	RA
	J) ASSEMBLE STOCK		5-29-07	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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	5/30/07	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-30-07	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	<u>246</u> <u>230</u> <u>233</u> <u>229</u> <u>235</u>	6-1-07	RA
	C) FUNCTION		6-6-07	L.P.D.
690	PACK		6-1-07	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

Model: M/24
Serial No: Form #F005
Trigger: 235 lbs. ini. +/- .50 lbs.



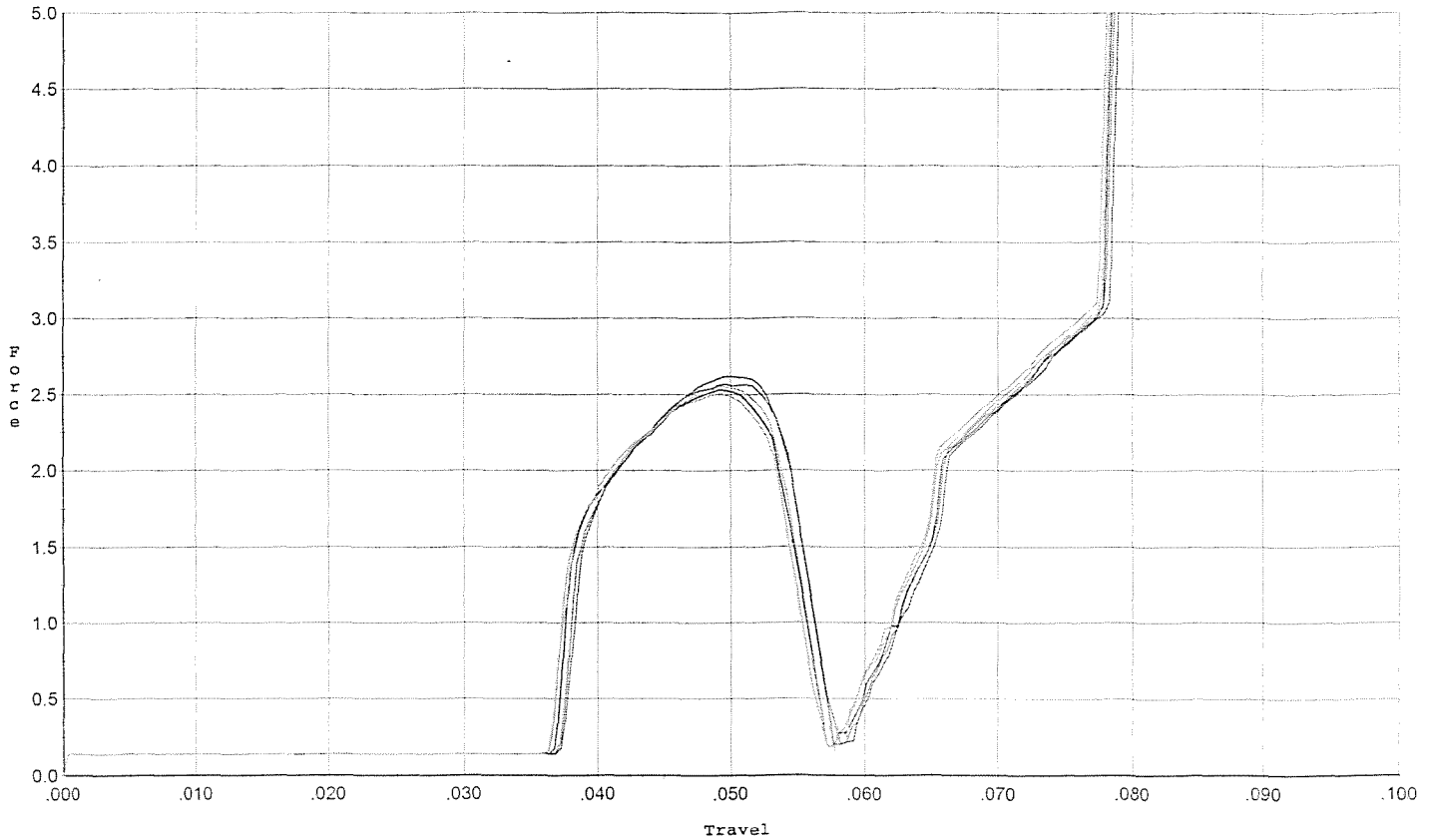
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.558	0.053	0.037	0.032	0.041		Set Trigger
2	2.550	0.053	0.037	0.032	0.041		Set Trigger
3	2.588	0.054	0.037	0.032	0.043		Set Trigger
4	2.629	0.054	0.037	0.032	0.042		Set Trigger
5	2.598	0.053	0.037	0.032	0.041		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

Model: M/24
Serial No: Form #F005
Trigger: 25 lbs. after 50 cycles +/- .50 lbs.



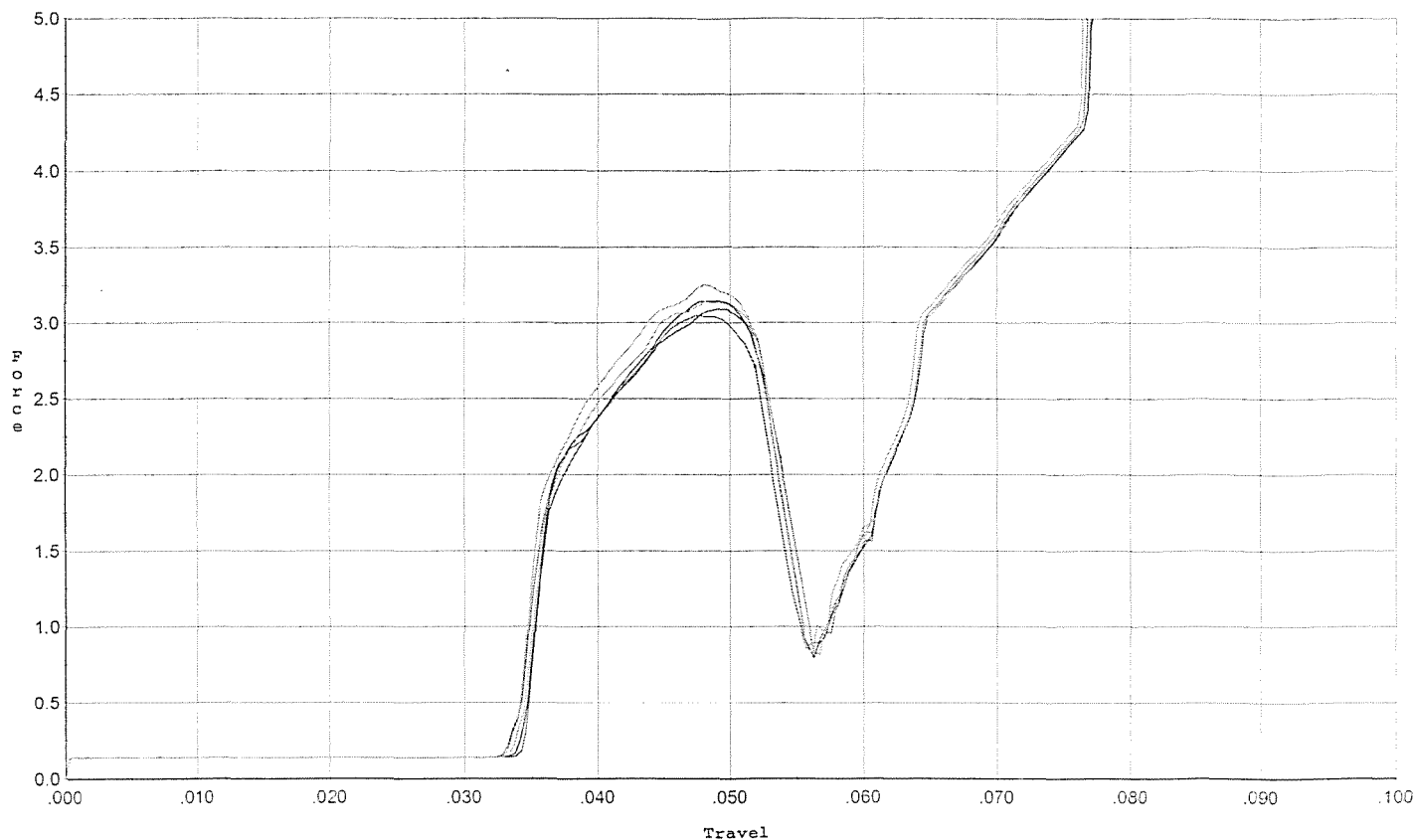
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.620	0.054	0.037	0.031	0.044		Set Trigger
2	2.533	0.055	0.037	0.031	0.043		Set Trigger
3	2.569	0.054	0.037	0.031	0.044		Set Trigger
4	2.555	0.054	0.037	0.031	0.043		Set Trigger
5	2.506	0.053	0.037	0.031	0.042		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

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



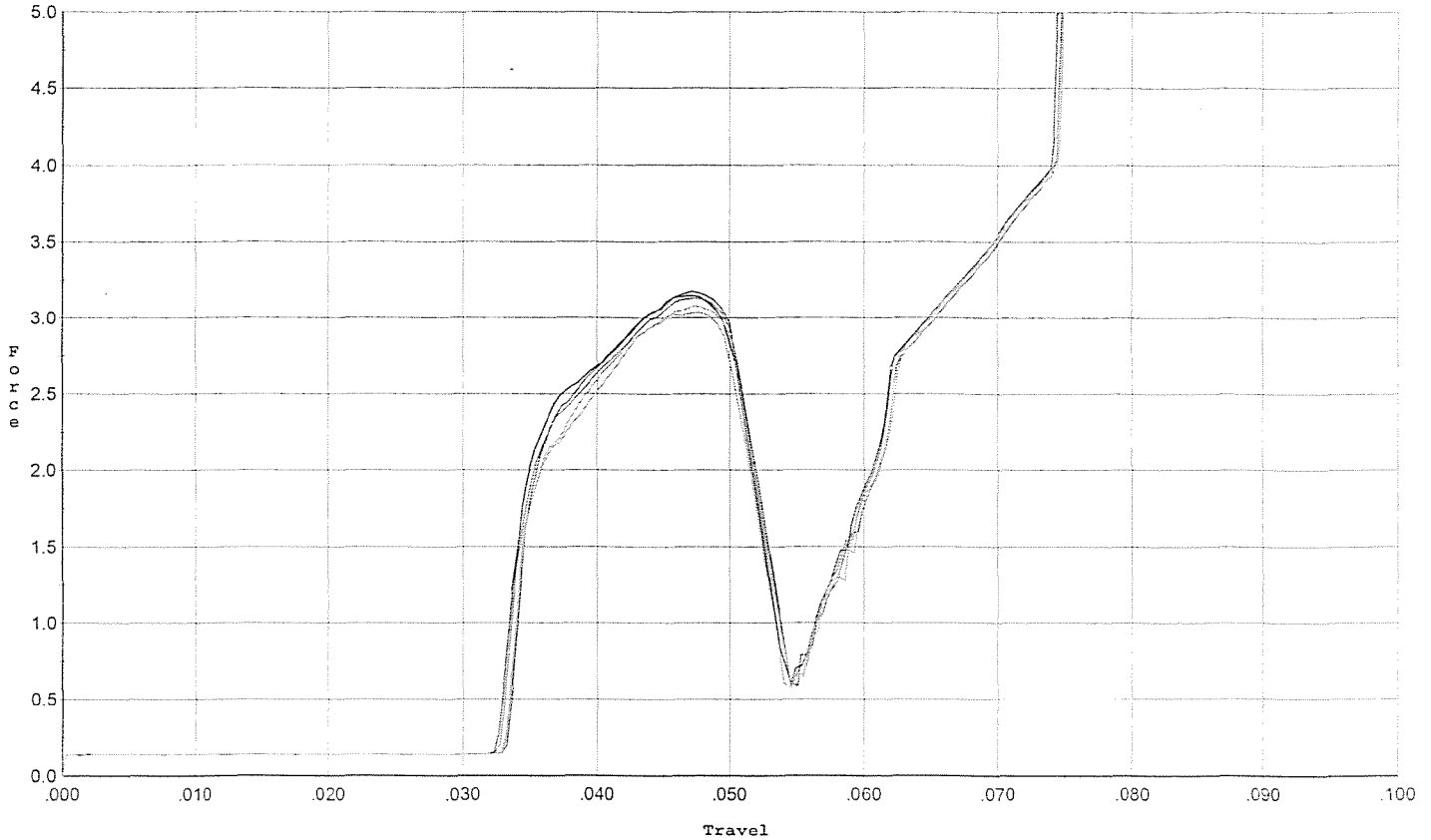
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.054	0.035	0.030	0.054		Set Trigger
2	3.144	0.052	0.034	0.030	0.053		Set Trigger
3	3.049	0.052	0.033	0.030	0.052		Set Trigger
4	3.151	0.054	0.034	0.029	0.056		Set Trigger
5	3.255	0.053	0.034	0.029	0.056		Set Trigger

Aug 3:13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

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



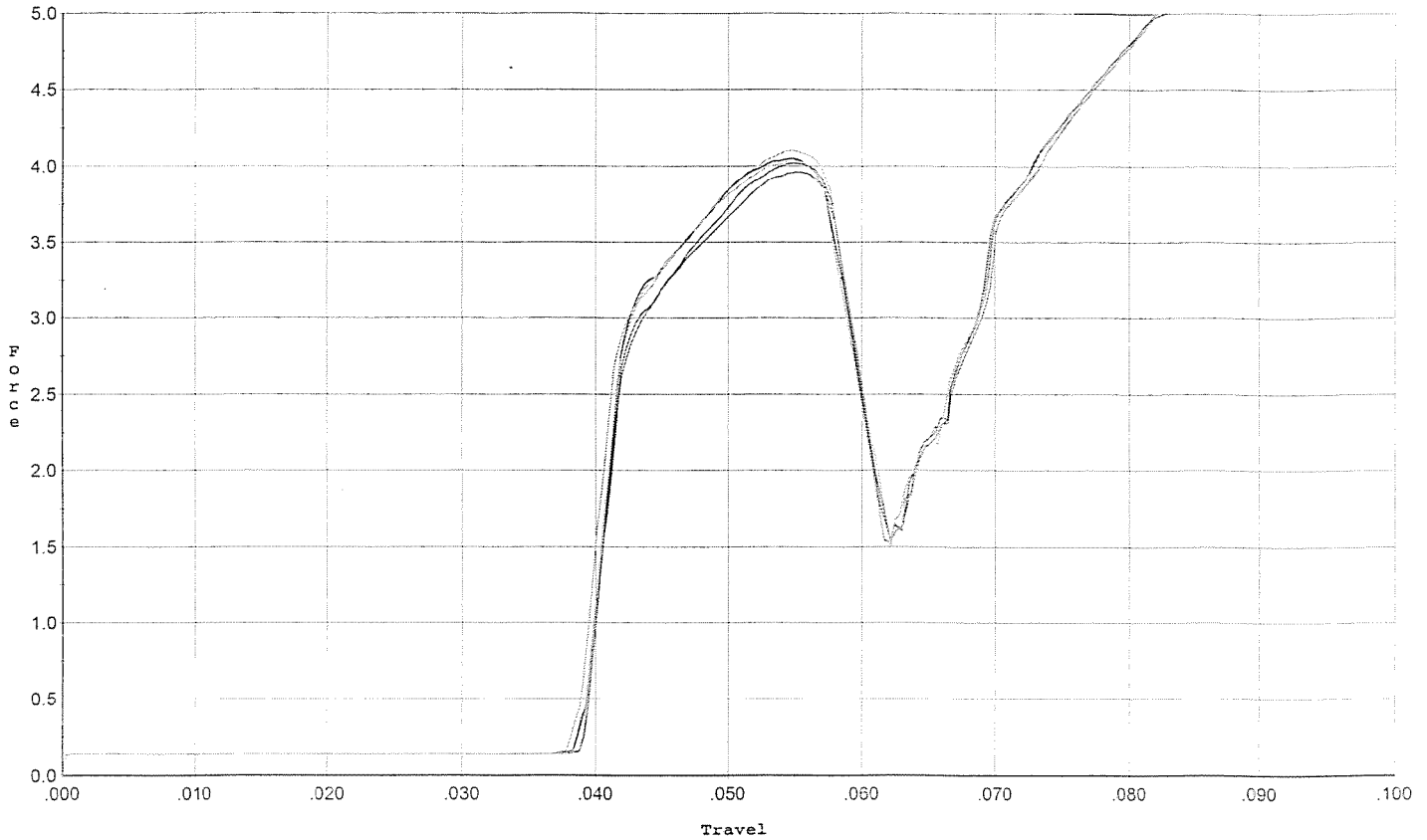
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.052	0.033	0.029	0.054		Set Trigger
2	3.147	0.050	0.033	0.030	0.053		Set Trigger
3	3.131	0.050	0.033	0.030	0.052		Set Trigger
4	3.034	0.051	0.033	0.030	0.051		Set Trigger
5	3.079	0.050	0.033	0.030	0.050		Set Trigger

AVG 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

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



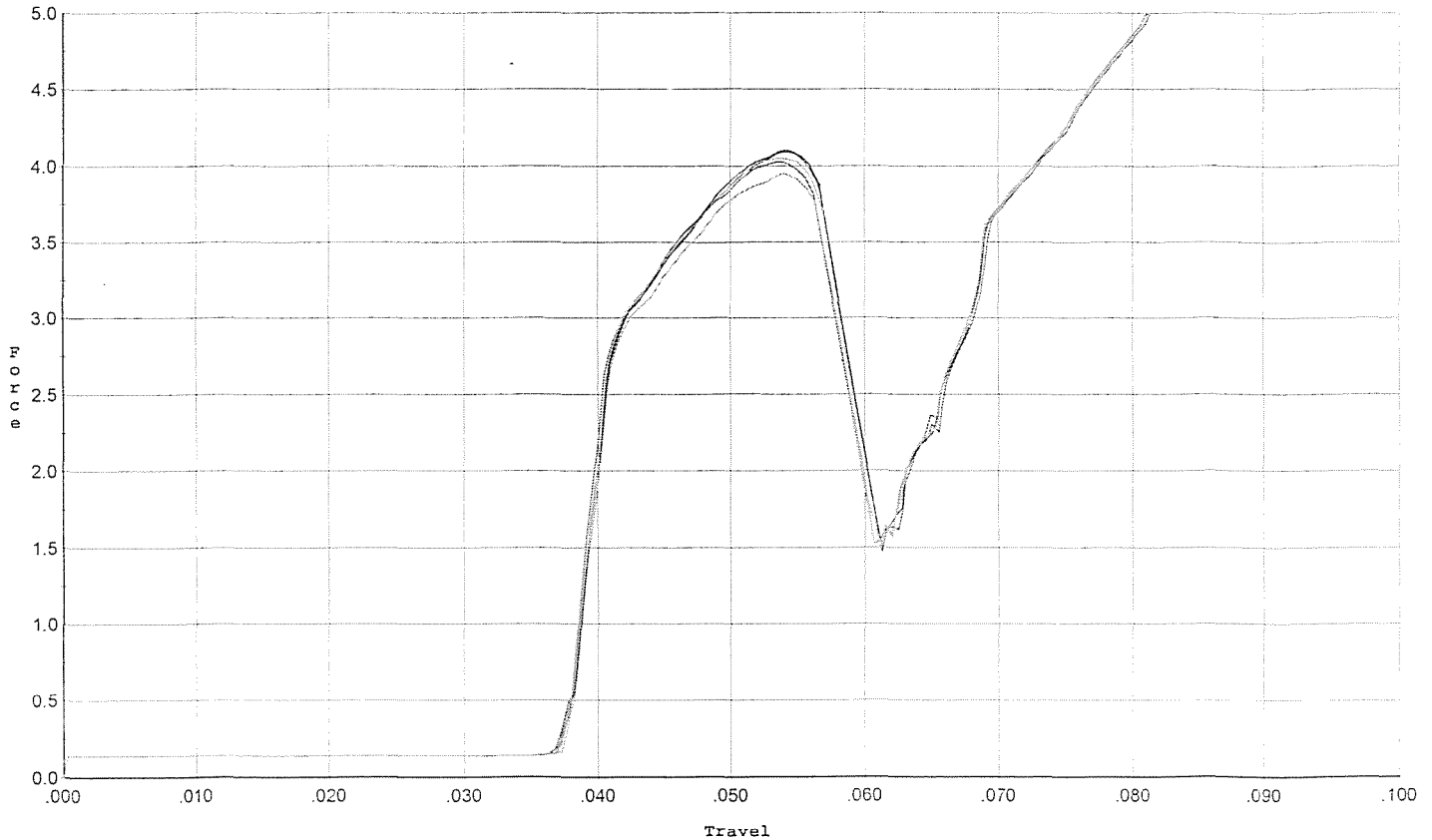
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.022	0.058	0.039	0.028	0.071		Set Trigger
2	4.053	0.059	0.039	0.028	0.074		Set Trigger
3	3.960	0.058	0.039	0.028	0.071		Set Trigger
4	4.105	0.058	0.039	0.028	0.073		Set Trigger
5	4.039	0.059	0.038	0.028	0.075		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 5/24

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



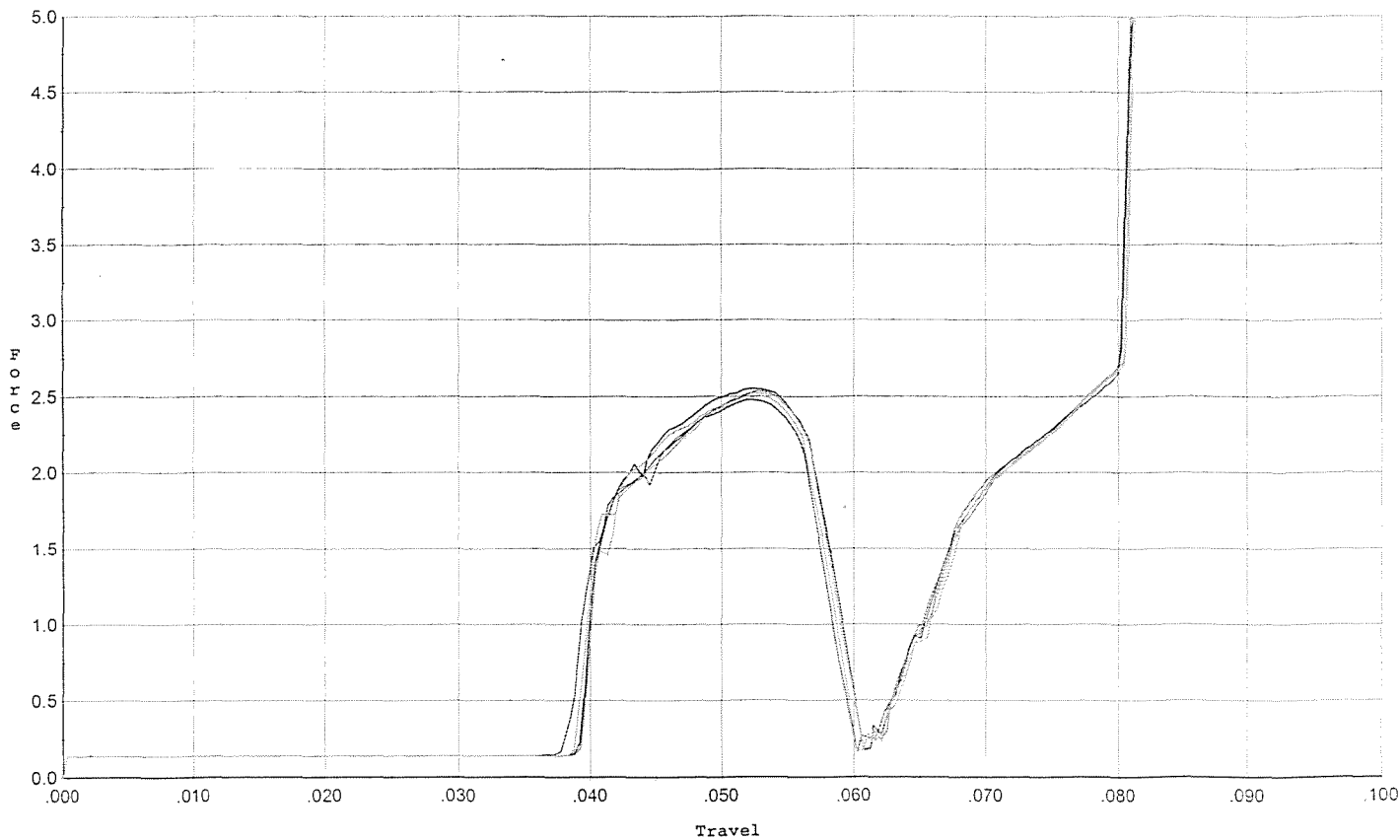
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.106	0.057	0.037	0.028	0.072		Set Trigger
2	4.095	0.057	0.037	0.028	0.072		Set Trigger
3	4.027	0.058	0.038	0.028	0.074		Set Trigger
4	4.053	0.057	0.037	0.028	0.073		Set Trigger
5	3.953	0.058	0.038	0.028	0.072		Set Trigger

AVG 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

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



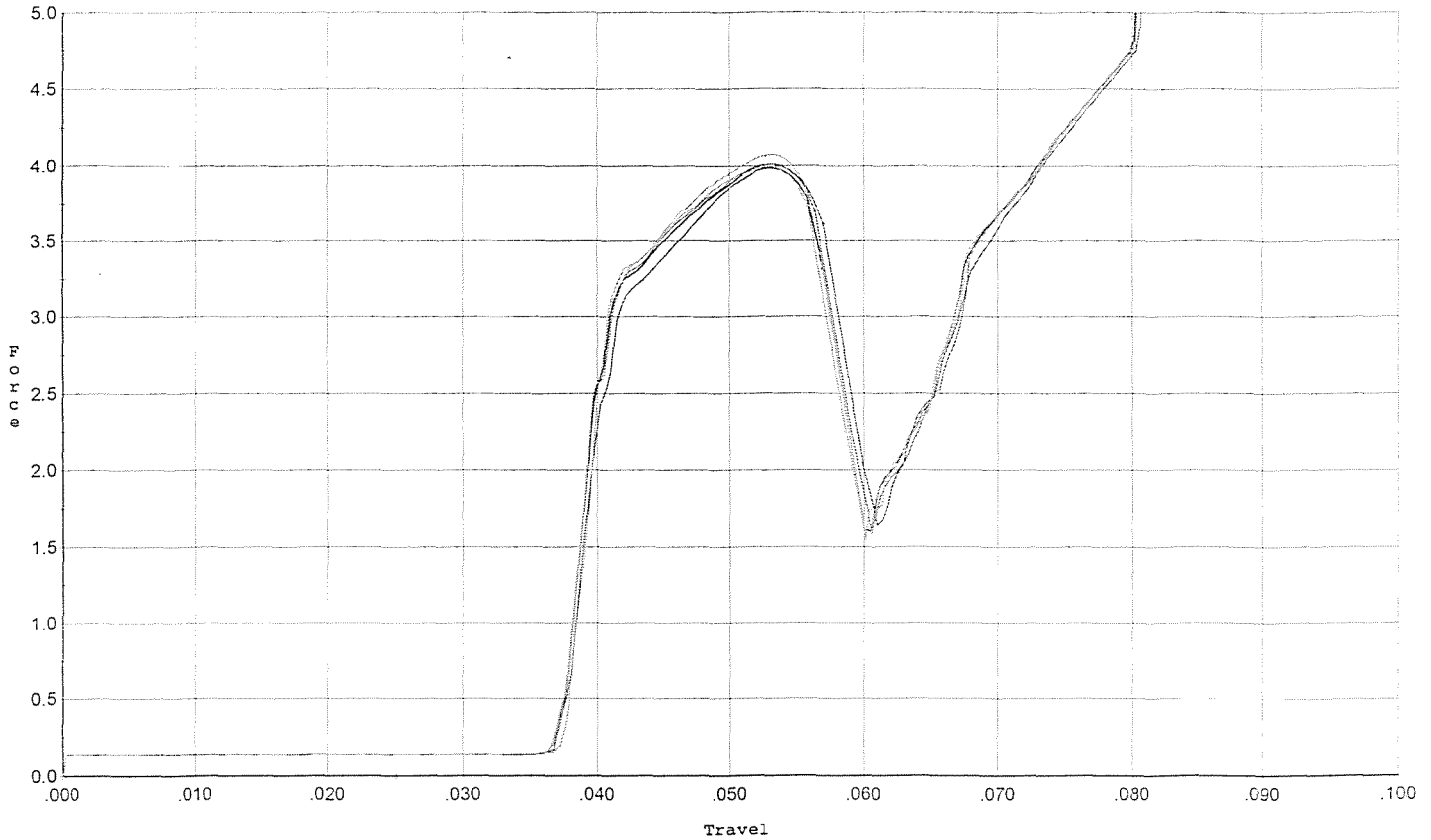
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.056	0.038	0.031	0.044		Set Trigger
2	2.550	0.058	0.039	0.030	0.047		Set Trigger
3	2.534	0.058	0.039	0.030	0.046		Set Trigger
4	2.501	0.058	0.039	0.031	0.045		Set Trigger
5	2.523	0.057	0.039	0.031	0.044		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/24

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.999	0.057	0.037	0.028	0.073		Set Trigger
2	3.993	0.057	0.037	0.028	0.073		Set Trigger
3	4.012	0.056	0.037	0.028	0.073		Set Trigger
4	4.072	0.057	0.038	0.028	0.073		Set Trigger
5	3.999	0.056	0.037	0.028	0.071		Set Trigger

Avg 4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645605.___0
FILE DATE AND TIME: 05/31/2007 01:13

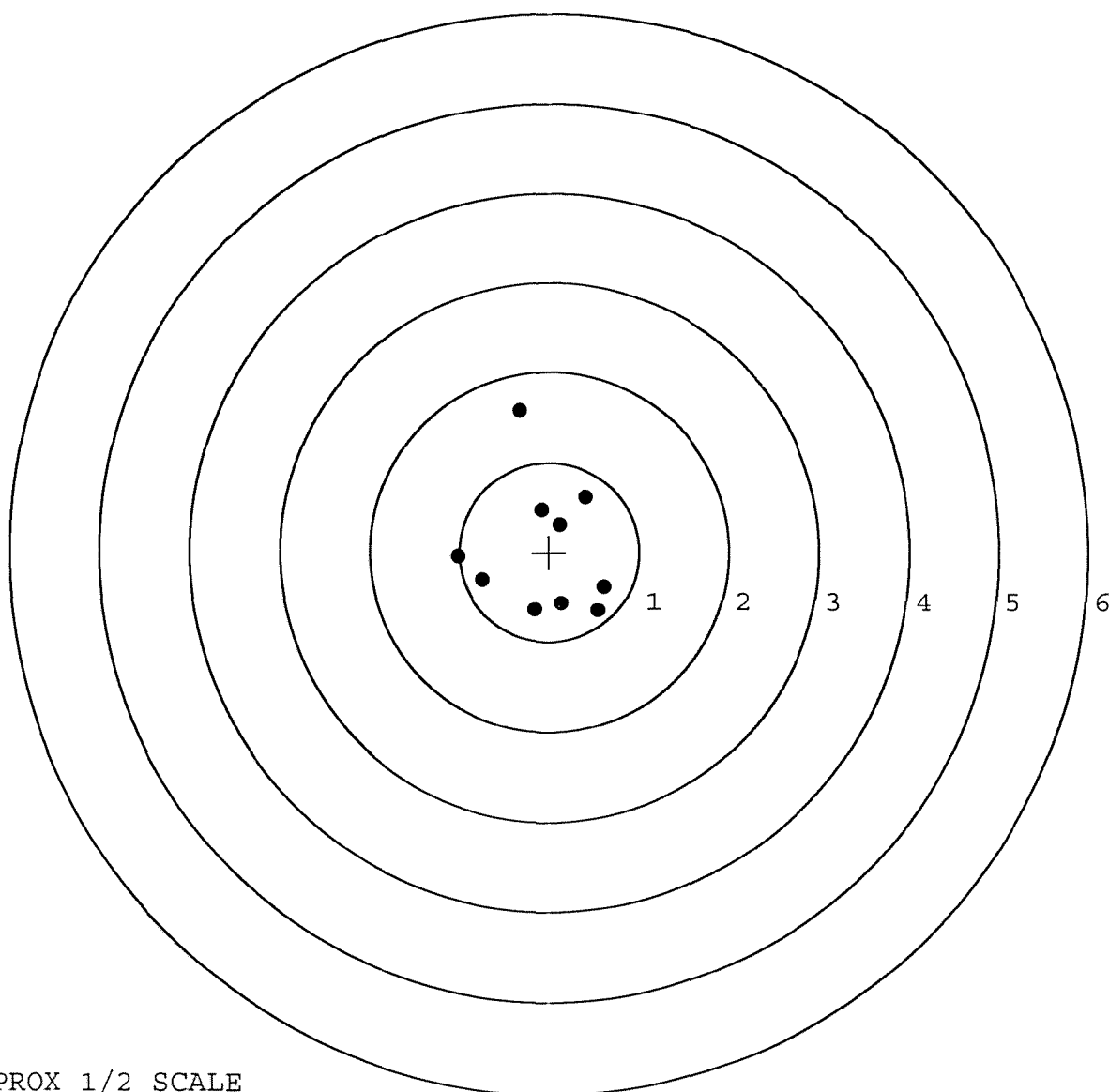
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.036
The Average Y Centroid of the Five Target Set:	-0.045
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.651
The Distance from POA to Centroid Target #1:	0.058
The Distance from Centroid Target #2 to Centroid Target #1:	0.187
The Distance from Centroid Target #3 to Centroid Target #1:	0.141
The Distance from Centroid Target #4 to Centroid Target #1:	0.277
The Distance from Centroid Target #5 to Centroid Target #1:	0.321

SERIAL NUMBER: G6645605. __0
TARGET NUMBER: 1
FILE DATE: 05/31/2007
FILE TIME: 01:13

X CENTROID: -0.049
Y CENTROID: 0.032
POA TO CENTROID: 0.058
HORZ SPREAD: 1.629
VERT SPREAD: 2.228
GROUP SPREAD: 2.395
MIN RADIUS: 0.322
MAX RADIUS: 1.566
MEAN RADIUS: 0.783
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.016	-0.047
2:	-0.743	-0.312
3:	-0.154	-0.648
4:	0.145	-0.579
5:	0.547	-0.656
6:	0.613	-0.391
7:	0.126	0.303
8:	-0.080	0.467
9:	0.407	0.610
10:	-0.331	1.572

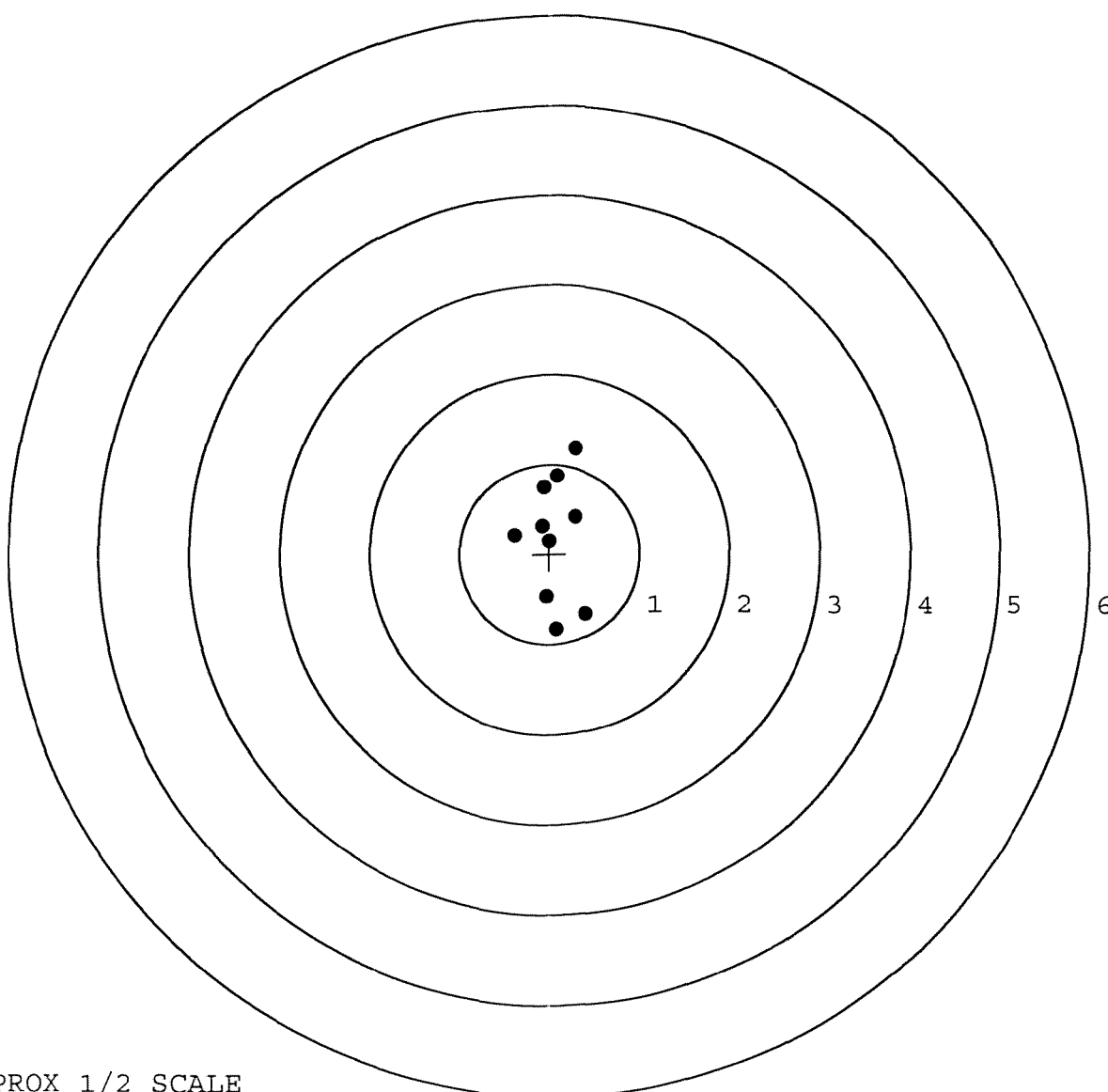


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645605. __0
TARGET NUMBER: 2
FILE DATE: 05/31/2007
FILE TIME: 01:13

	POINT#	X	Y
	1:	-0.066	0.743
	2:	0.091	0.868
	3:	0.300	1.174
	4:	0.290	0.407
	5:	0.000	0.142
	6:	-0.084	0.308
	7:	-0.392	0.211
	8:	-0.036	-0.476
	9:	0.077	-0.845
	10:	0.402	-0.673

X CENTROID: 0.058
Y CENTROID: 0.186
POA TO CENTROID: 0.195
HORZ SPREAD: 0.794
VERT SPREAD: 2.019
GROUP SPREAD: 2.031
MIN RADIUS: 0.073
MAX RADIUS: 1.031
MEAN RADIUS: 0.593
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

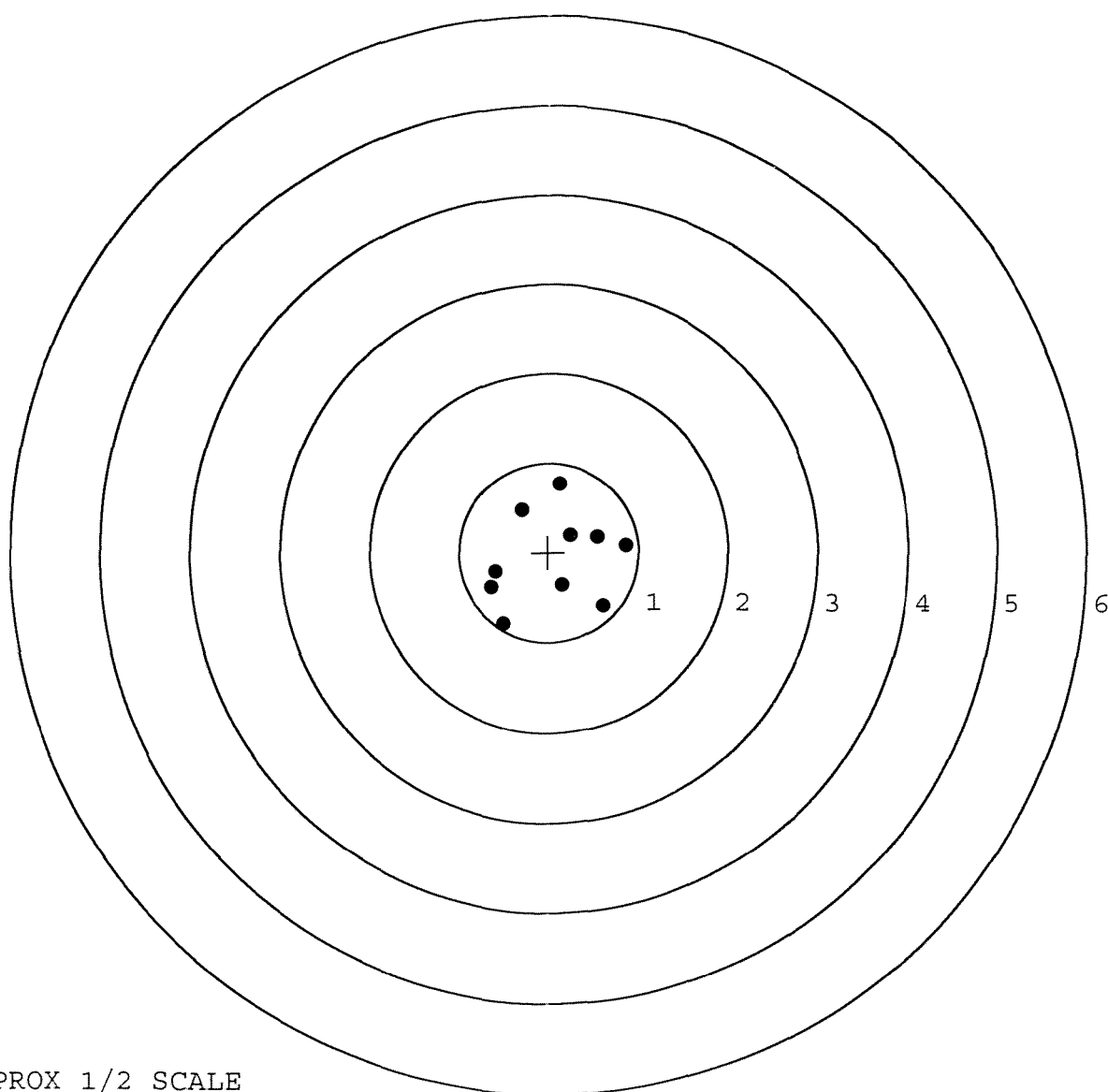


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645605.___0
TARGET NUMBER: 3
FILE DATE: 05/31/2007
FILE TIME: 01:13

X CENTROID: 0.050
Y CENTROID: -0.068
POA TO CENTROID: 0.085
HORZ SPREAD: 1.491
VERT SPREAD: 1.559
GROUP SPREAD: 1.683
MIN RADIUS: 0.319
MAX RADIUS: 0.916
MEAN RADIUS: 0.660
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.299	0.474
2:	0.130	0.762
3:	0.245	0.192
4:	0.545	0.175
5:	0.855	0.084
6:	0.608	-0.595
7:	0.154	-0.370
8:	-0.505	-0.797
9:	-0.636	-0.393
10:	-0.593	-0.217

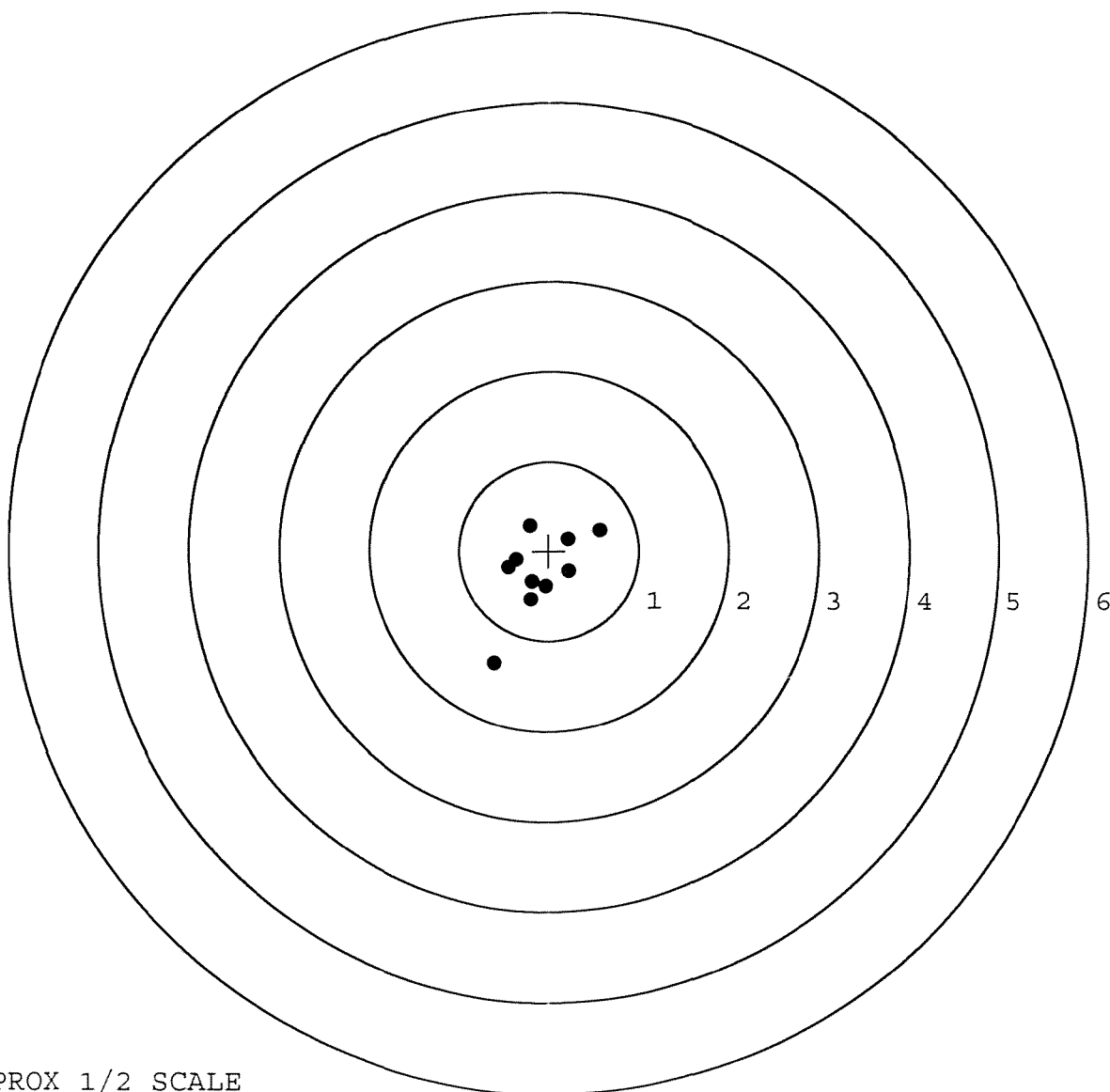


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645605. __0
TARGET NUMBER: 4
FILE DATE: 05/31/2007
FILE TIME: 01:13

X CENTROID: -0.104
Y CENTROID: -0.239
POA TO CENTROID: 0.261
HORZ SPREAD: 1.175
VERT SPREAD: 1.527
GROUP SPREAD: 1.886
MIN RADIUS: 0.135
MAX RADIUS: 1.122
MEAN RADIUS: 0.457
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.207	0.285
2:	0.217	0.133
3:	0.568	0.233
4:	0.226	-0.233
5:	-0.037	-0.396
6:	-0.204	-0.546
7:	-0.187	-0.346
8:	-0.449	-0.184
9:	-0.607	-1.242
10:	-0.364	-0.097

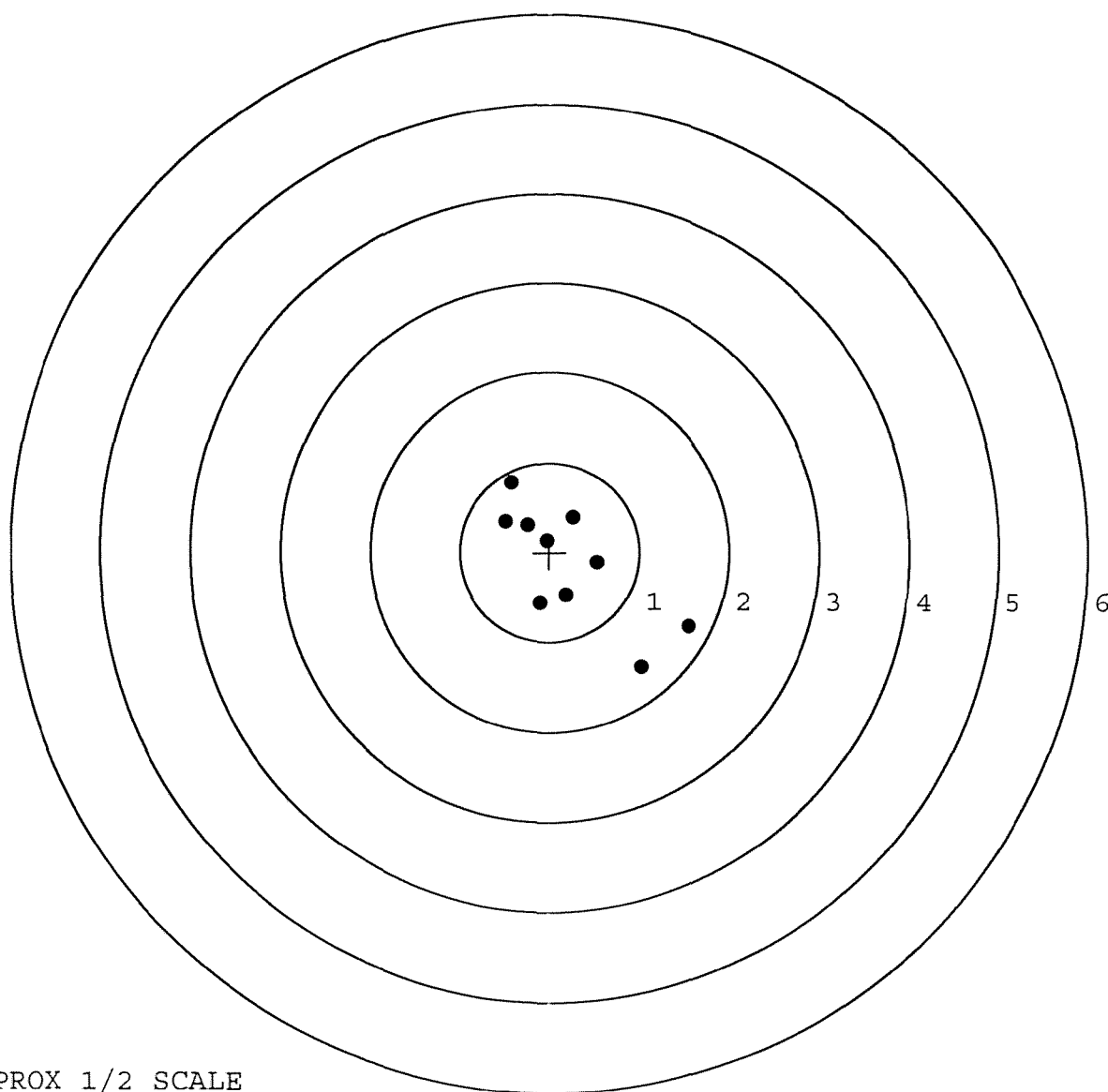


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645605. __0
TARGET NUMBER: 5
FILE DATE: 05/31/2007
FILE TIME: 01:13

X CENTROID: 0.226
Y CENTROID: -0.135
POA TO CENTROID: 0.263
HORZ SPREAD: 2.040
VERT SPREAD: 2.064
GROUP SPREAD: 2.548
MIN RADIUS: 0.306
MAX RADIUS: 1.498
MEAN RADIUS: 0.762
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.422	0.778
2:	-0.490	0.342
3:	-0.243	0.305
4:	-0.030	0.133
5:	0.261	0.389
6:	-0.106	-0.570
7:	0.186	-0.483
8:	0.532	-0.119
9:	1.023	-1.286
10:	1.550	-0.836



TARGET APPROX 1/2 SCALE