

G 467 2608

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

- INSTRUCTION BOOK 3518



ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6672608



BM FORM

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6672608

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8/13/07	SPD
420	ASSEMBLE ACTION		8-15-07	SD
430	ASSEMBLE TO STOCK		8/16/07	WJ
440	PROOF	MAGNA - FLUX AUG 15 2007 OPERATOR <u>WJ</u>	8/16/07	WJ
460	CHECK HEADSPACE		8/16/07	WJ
470	DIS-ASSEMBLE ACTION		8/13/07	SPD
480	MAGNAFLUX BBL ACTION		8-15-07	WJ
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-14-07	CW
510	DRILL AND TAP SIGHT HOLES		8-14-07	TRW
520	GOFF BLAST BBL / REC		8-15-07	Ly
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/30/07	RB
560	RE-ASSEMBLE ACTION		8-22-07	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-22-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-22-07	SD
	D) OIL FIRING PIN ASSEMBLY		8/30/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

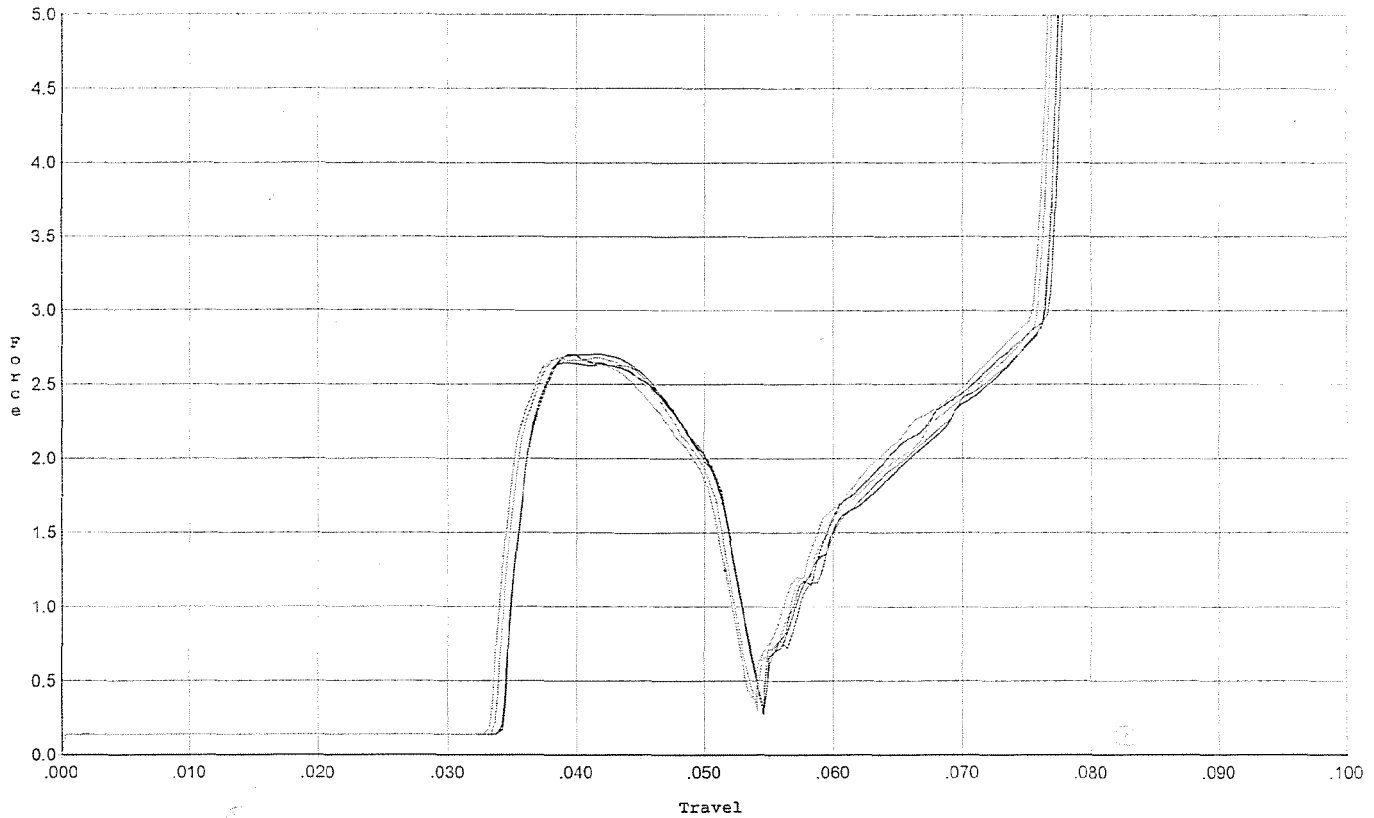
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>55</u> <u>55</u>	9-5-07	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>35</u>	9-5-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1022</u> <u>1023</u> <u>1023</u>	9-5-07	DA
	J) ASSEMBLE STOCK		8/30/07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		9-5-07	DA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-5-07	RTZ
	M) IRON SIGHT ALIGNMENT		9-5-07	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-5-07	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	8/31/07	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/31/07	RP
670	FINAL INSPECTION A) HEADSPACE		9-5-07	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.49</u> <u>2.34</u> <u>2.35</u> <u>2.30</u>	9/4/07	RP
	C) FUNCTION			
690	PACK		9-6-07	DA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



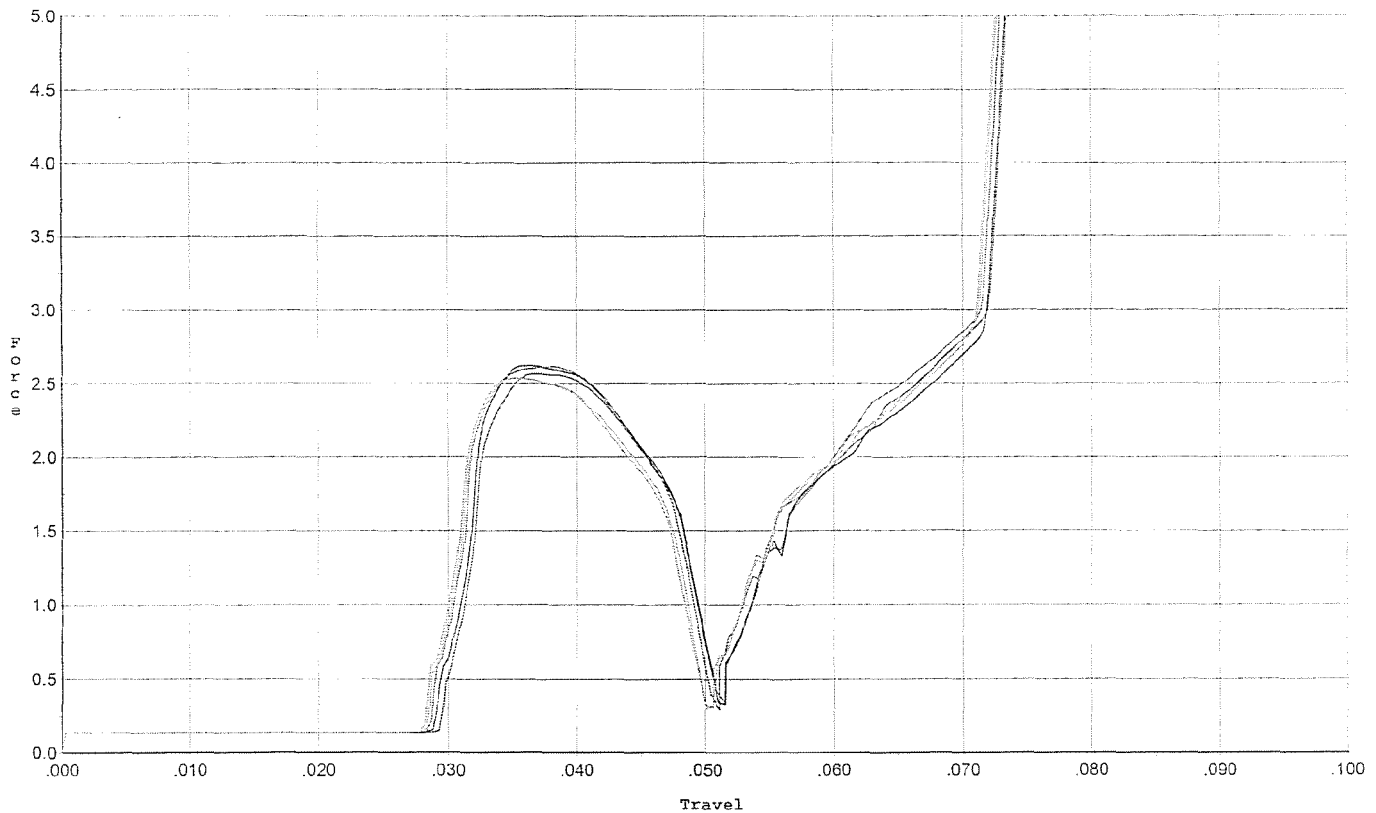
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.705	0.051	0.034	0.033	0.045		Set Trigger
2	2.701	0.051	0.034	0.033	0.044		Set Trigger
3	2.647	0.051	0.034	0.033	0.044		Set Trigger
4	2.687	0.051	0.034	0.033	0.045		Set Trigger
5	2.671	0.052	0.033	0.033	0.045		Set Trigger

2.68 Avg.

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



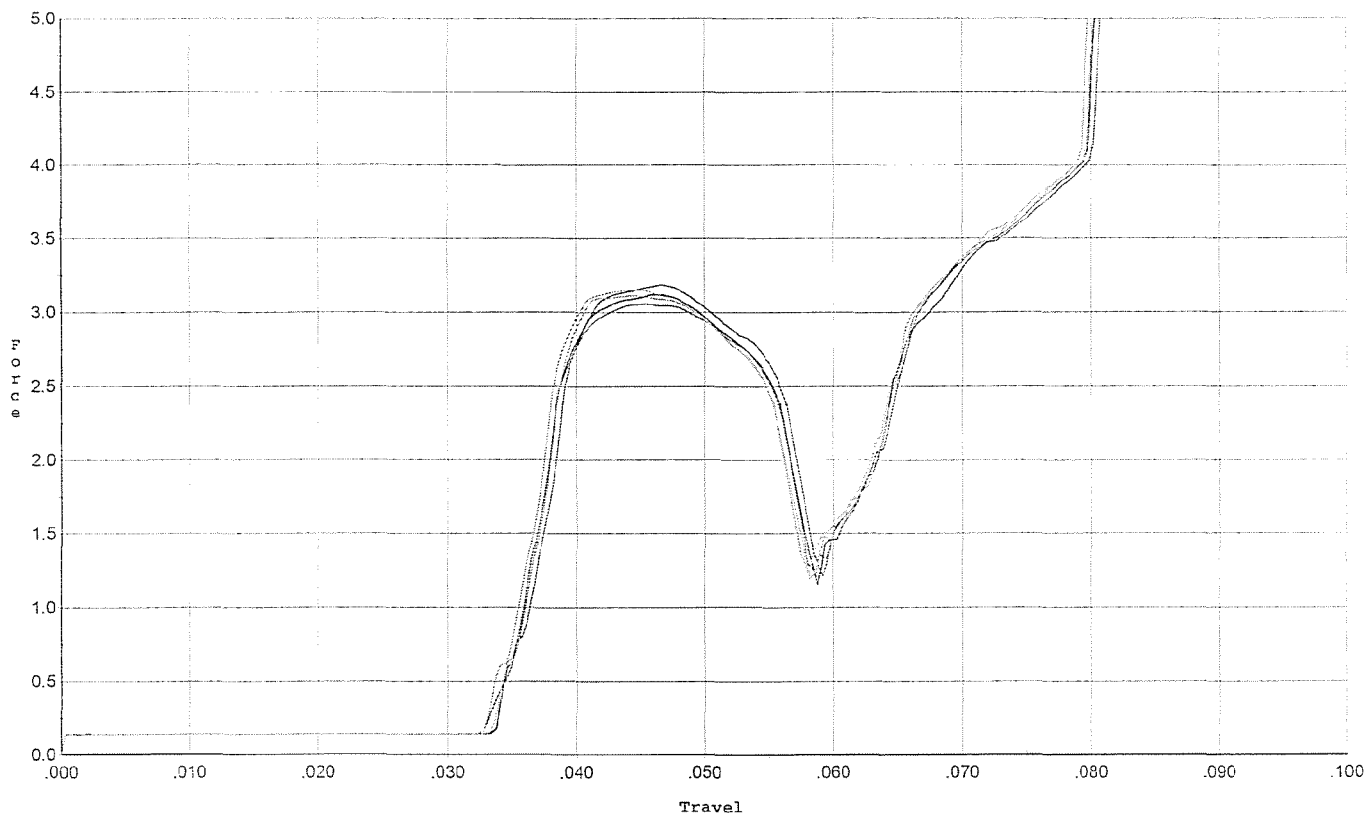
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.048	0.030	0.031	0.043		Set Trigger
2	2.621	0.048	0.029	0.031	0.044		Set Trigger
3	2.617	0.049	0.029	0.030	0.045		Set Trigger
4	2.540	0.048	0.029	0.031	0.043		Set Trigger
5	2.531	0.047	0.028	0.031	0.043		Set Trigger

2.58 Avg.

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



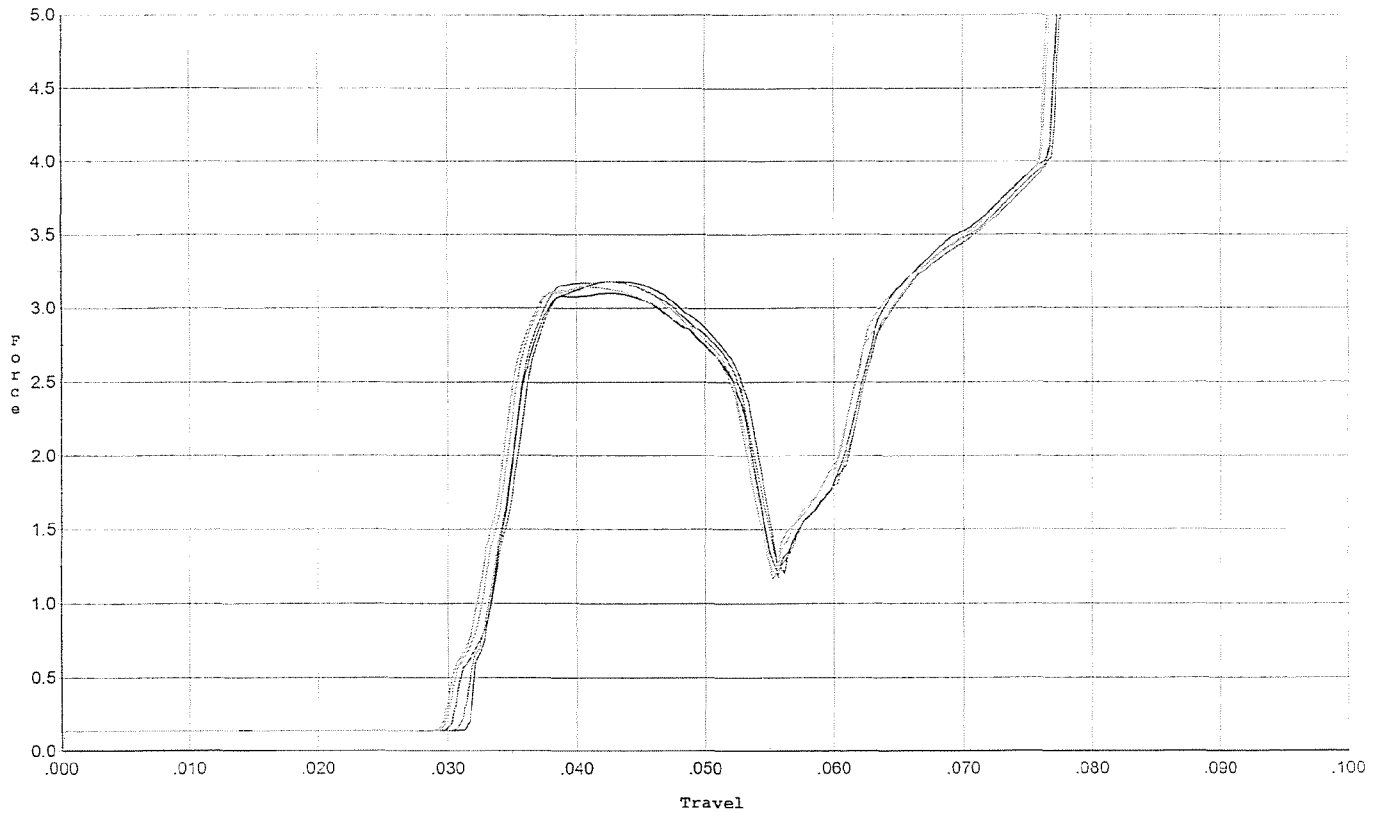
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.185	0.056	0.033	0.030	0.063		Set Trigger
2	3.118	0.056	0.034	0.030	0.061		Set Trigger
3	3.055	0.056	0.034	0.030	0.061		Set Trigger
4	3.112	0.055	0.034	0.031	0.060		Set Trigger
5	3.151	0.055	0.033	0.030	0.062		Set Trigger

3.12 Avg.

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



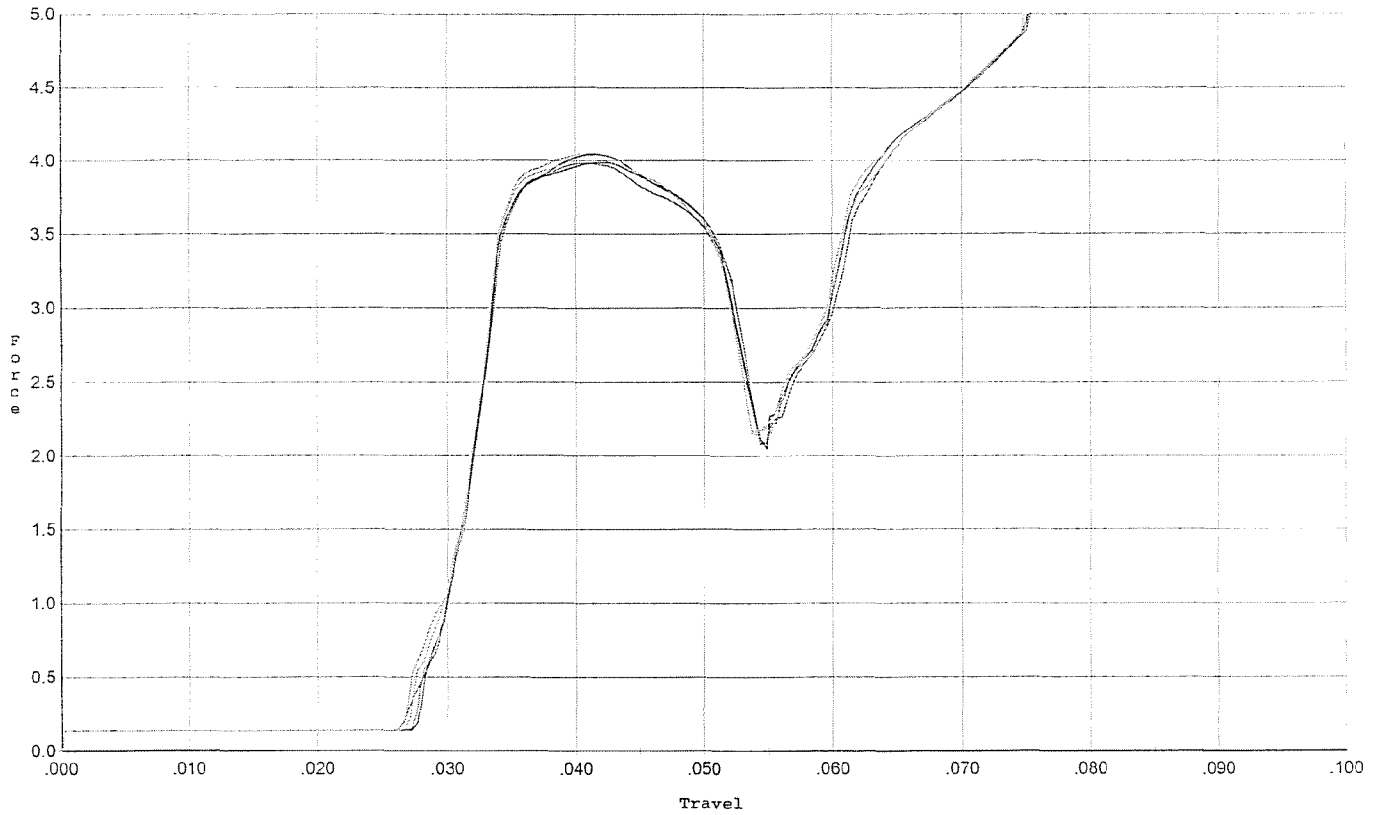
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.182	0.053	0.031	0.030	0.063		Set Trigger
2	3.102	0.053	0.032	0.030	0.060		Set Trigger
3	3.182	0.053	0.031	0.030	0.062		Set Trigger
4	3.183	0.053	0.030	0.030	0.064		Set Trigger
5	3.143	0.052	0.030	0.030	0.062		Set Trigger

3.16 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 6/20/07

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



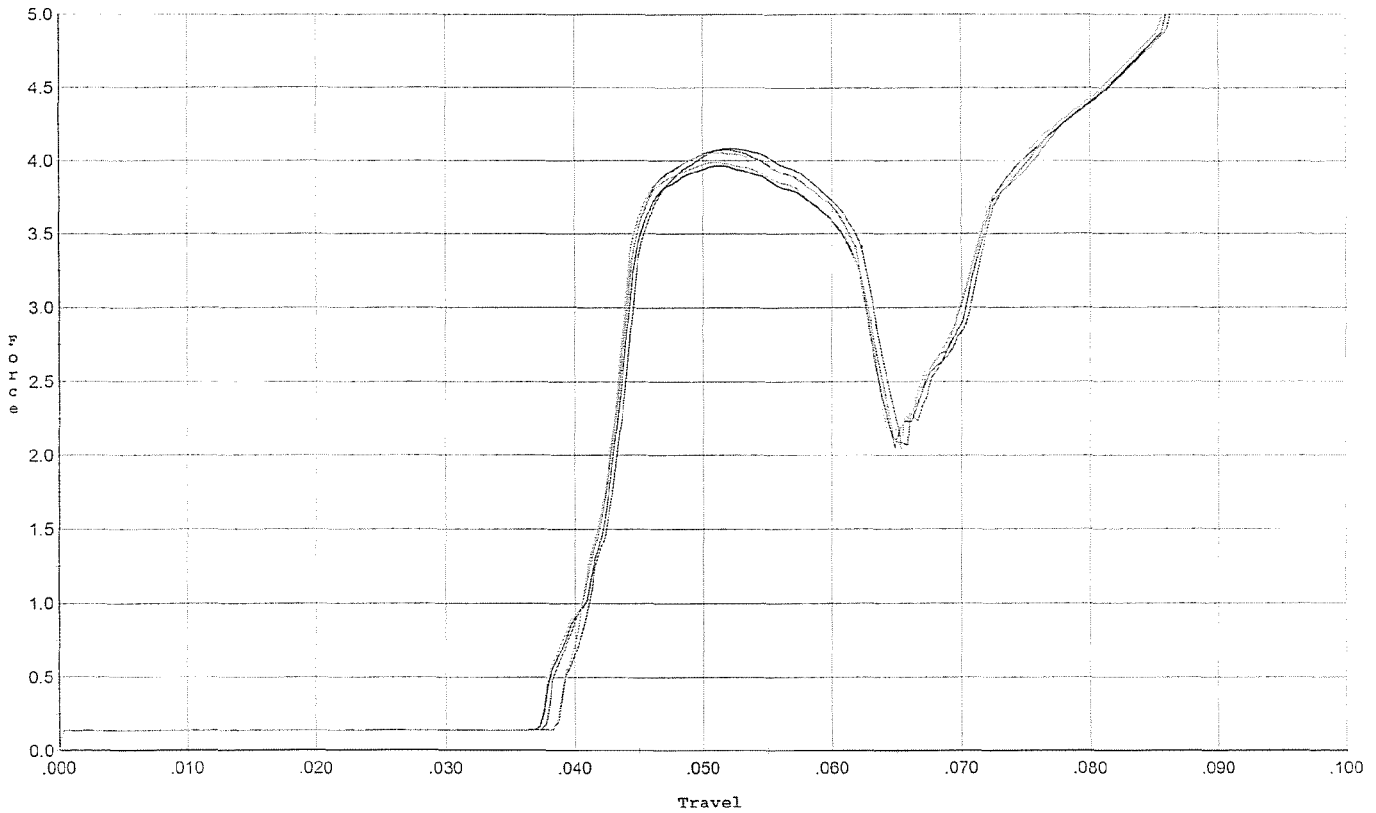
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.985	0.052	0.027	0.027	0.083		Set Trigger
2	4.042	0.051	0.028	0.028	0.082		Set Trigger
3	3.985	0.051	0.028	0.028	0.081		Set Trigger
4	4.001	0.052	0.027	0.027	0.083		Set Trigger
5	4.050	0.051	0.027	0.028	0.083		Set Trigger

4.01 Avg

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



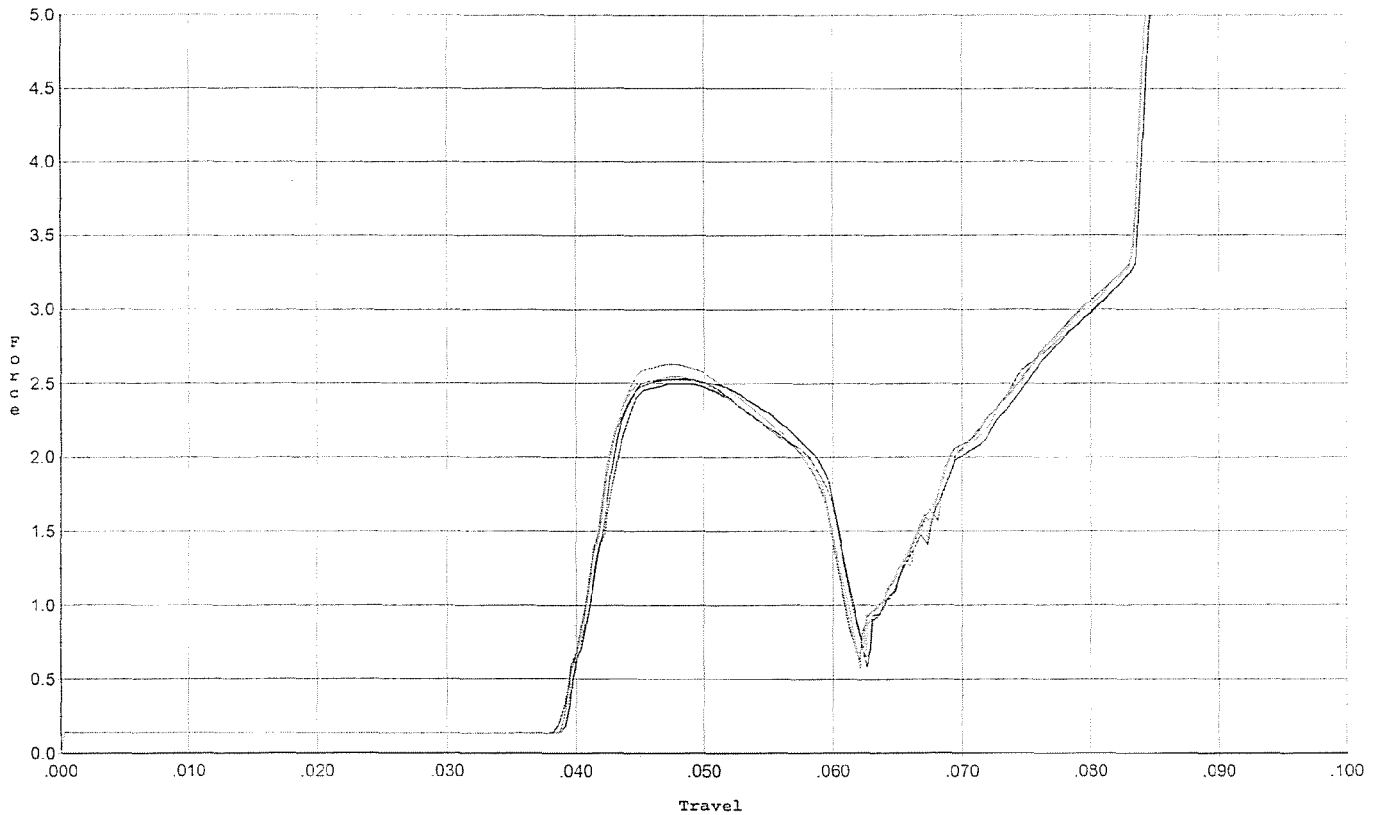
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.084	0.062	0.039	0.028	0.084		Set Trigger
2	3.967	0.062	0.038	0.028	0.083		Set Trigger
3	4.077	0.062	0.038	0.028	0.085		Set Trigger
4	4.058	0.062	0.039	0.028	0.084		Set Trigger
5	3.988	0.062	0.038	0.028	0.084		Set Trigger

4.04 Avg.

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/20/07

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



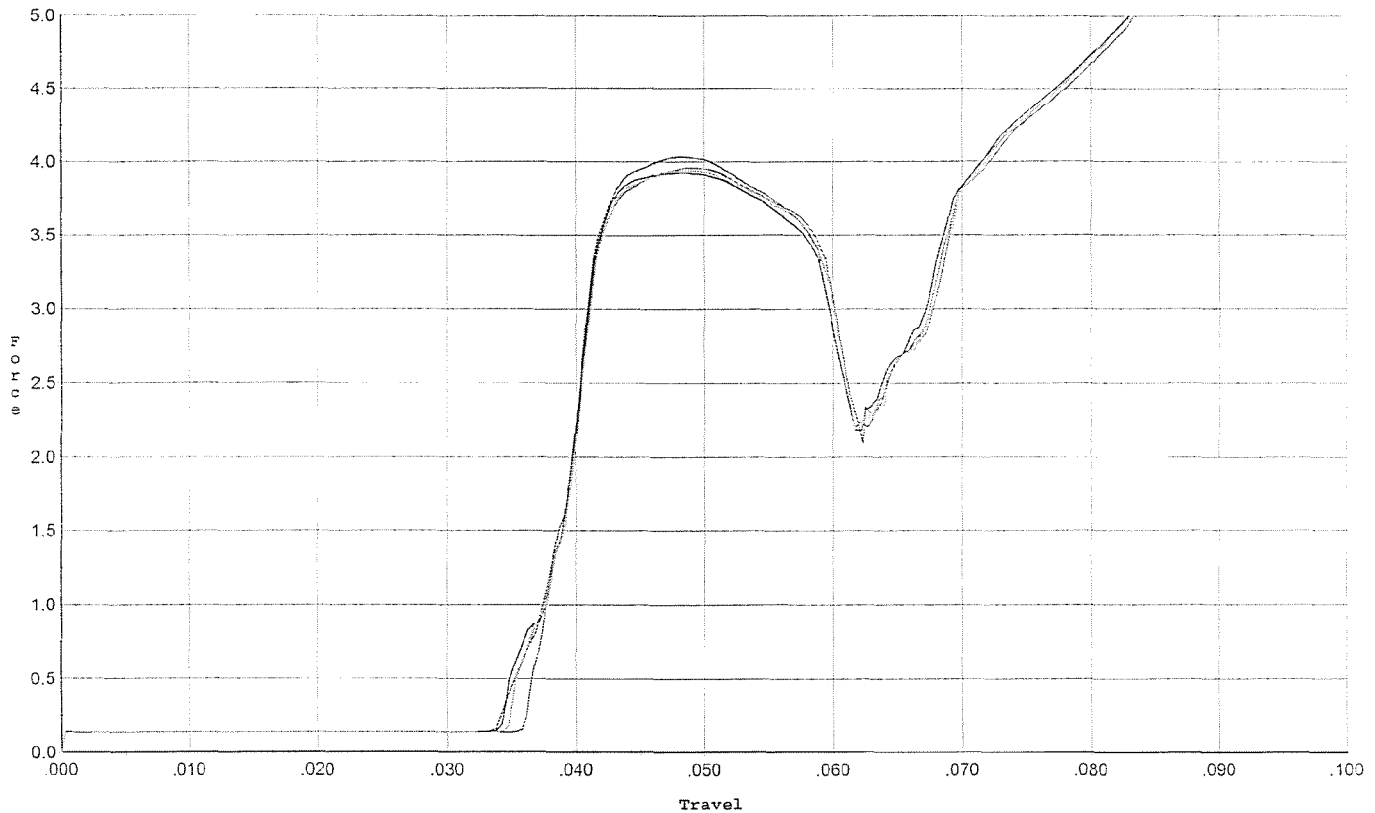
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.497	0.060	0.039	0.032	0.049		Set Trigger
2	2.534	0.060	0.040	0.032	0.049		Set Trigger
3	2.530	0.059	0.039	0.032	0.049		Set Trigger
4	2.634	0.059	0.039	0.032	0.049		Set Trigger
5	2.549	0.059	0.039	0.032	0.048		Set Trigger

2.55 Avg

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 6/20/07

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	4.036	0.060	0.034	0.028	0.086		Set Trigger
2	3.928	0.059	0.034	0.028	0.083		Set Trigger
3	3.959	0.059	0.036	0.028	0.084		Set Trigger
4	3.956	0.060	0.035	0.028	0.084		Set Trigger
5	3.939	0.060	0.035	0.028	0.084		Set Trigger

396 Avg

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6672608.___0
FILE DATE AND TIME: 09/04/2007 07:46

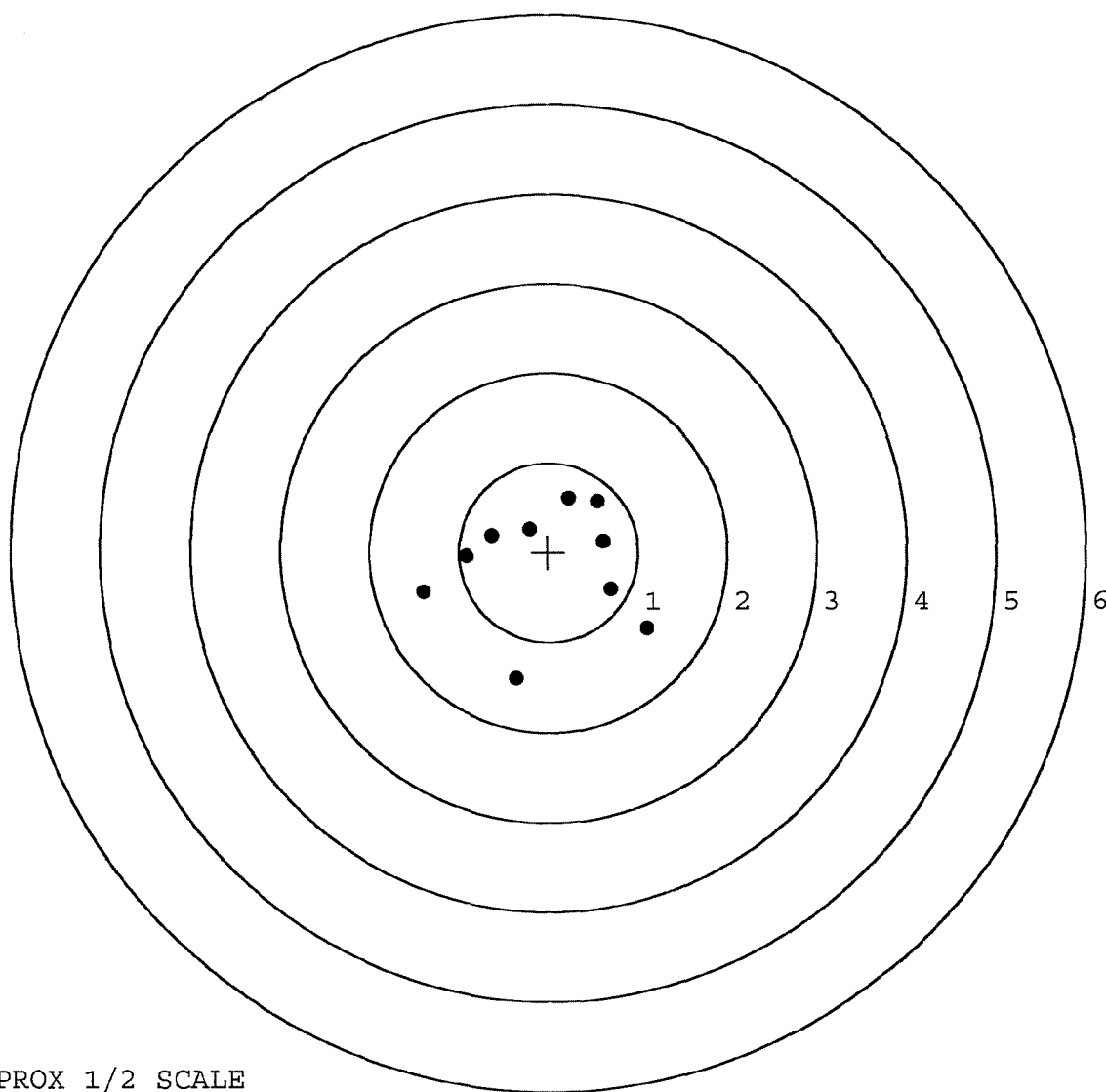
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.020
The Average Y Centroid of the Five Target Set:	-0.008
The Average Point of Impact of the Five Target Set:	0.022
The Average Mean Radius of the Five Target Set:	0.731
The Distance from POA to Centroid Target #1:	0.148
The Distance from Centroid Target #2 to Centroid Target #1:	0.188
The Distance from Centroid Target #3 to Centroid Target #1:	0.083
The Distance from Centroid Target #4 to Centroid Target #1:	0.278
The Distance from Centroid Target #5 to Centroid Target #1:	0.160

SERIAL NUMBER: G6672608.___0
TARGET NUMBER: 1
FILE DATE: 09/04/2007
FILE TIME: 07:46

X CENTROID: -0.035
Y CENTROID: -0.144
POA TO CENTROID: 0.148
HORZ SPREAD: 2.493
VERT SPREAD: 2.011
GROUP SPREAD: 2.525
MIN RADIUS: 0.436
MAX RADIUS: 1.398
MEAN RADIUS: 0.925
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.398	-0.453
2:	-0.364	-1.408
3:	1.095	-0.855
4:	0.699	-0.419
5:	0.609	0.122
6:	0.548	0.572
7:	0.228	0.603
8:	-0.211	0.255
9:	-0.640	0.190
10:	-0.916	-0.050

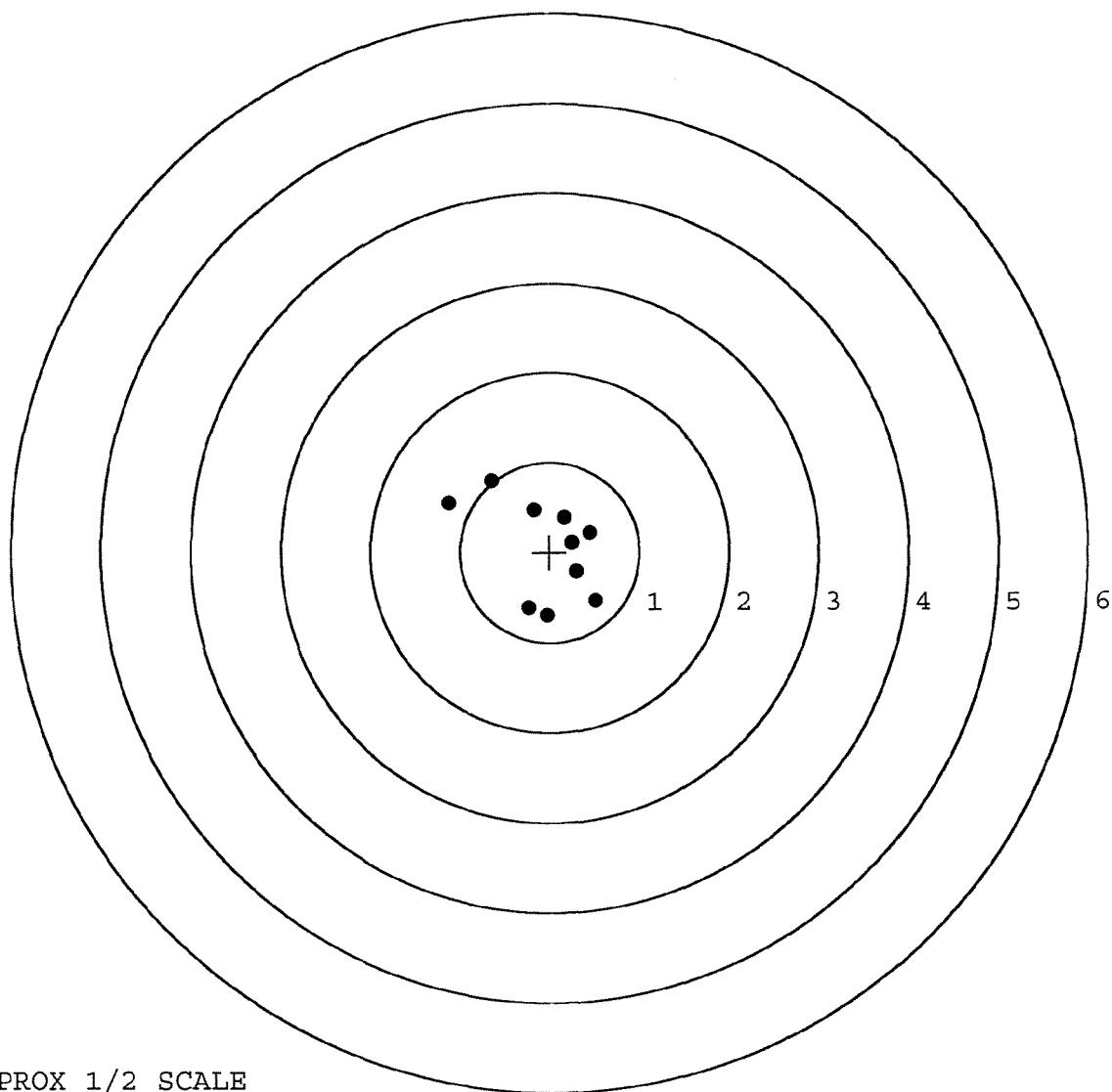


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6672608.___0
TARGET NUMBER: 2
FILE DATE: 09/04/2007
FILE TIME: 07:46

POINT#	X	Y
1:	-0.235	-0.619
2:	-0.039	-0.704
3:	0.512	-0.539
4:	0.295	-0.220
5:	0.441	0.219
6:	-0.176	0.473
7:	0.165	0.382
8:	-0.643	0.795
9:	-1.125	0.540
10:	0.243	0.103

X CENTROID: -0.056
Y CENTROID: 0.043
POA TO CENTROID: 0.071
HORZ SPREAD: 1.637
VERT SPREAD: 1.499
GROUP SPREAD: 1.961
MIN RADIUS: 0.305
MAX RADIUS: 1.179
MEAN RADIUS: 0.650
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

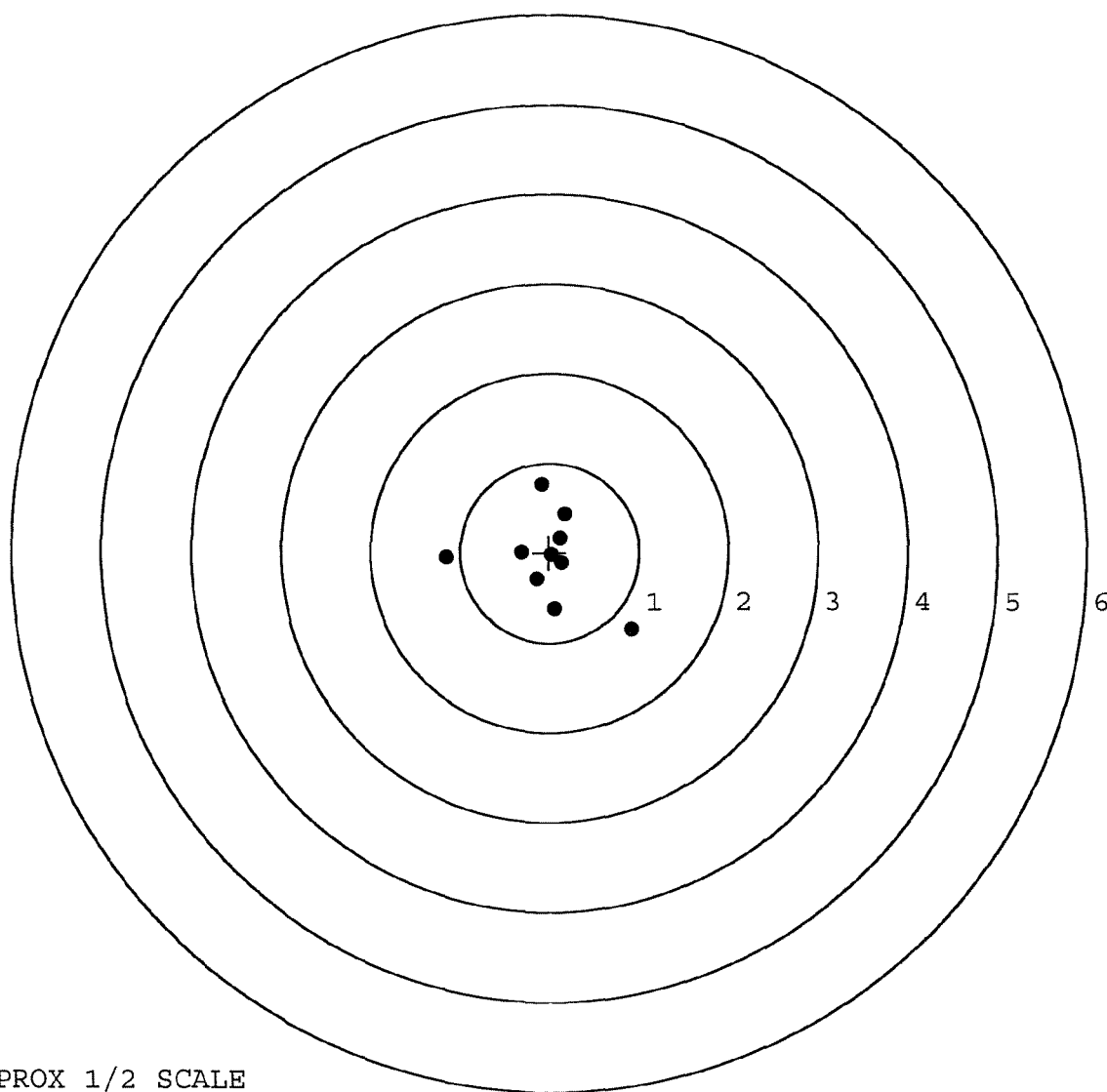


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6672608.___0
TARGET NUMBER: 3
FILE DATE: 09/04/2007
FILE TIME: 07:46

POINT#	X	Y
1:	0.915	-0.854
2:	0.058	-0.633
3:	-1.147	-0.054
4:	-0.084	0.765
5:	0.170	0.427
6:	0.114	0.165
7:	0.138	-0.114
8:	-0.141	-0.299
9:	-0.312	0.004
10:	0.022	-0.022

X CENTROID: -0.027
Y CENTROID: -0.061
POA TO CENTROID: 0.067
HORZ SPREAD: 2.062
VERT SPREAD: 1.619
GROUP SPREAD: 2.212
MIN RADIUS: 0.063
MAX RADIUS: 1.231
MEAN RADIUS: 0.534
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

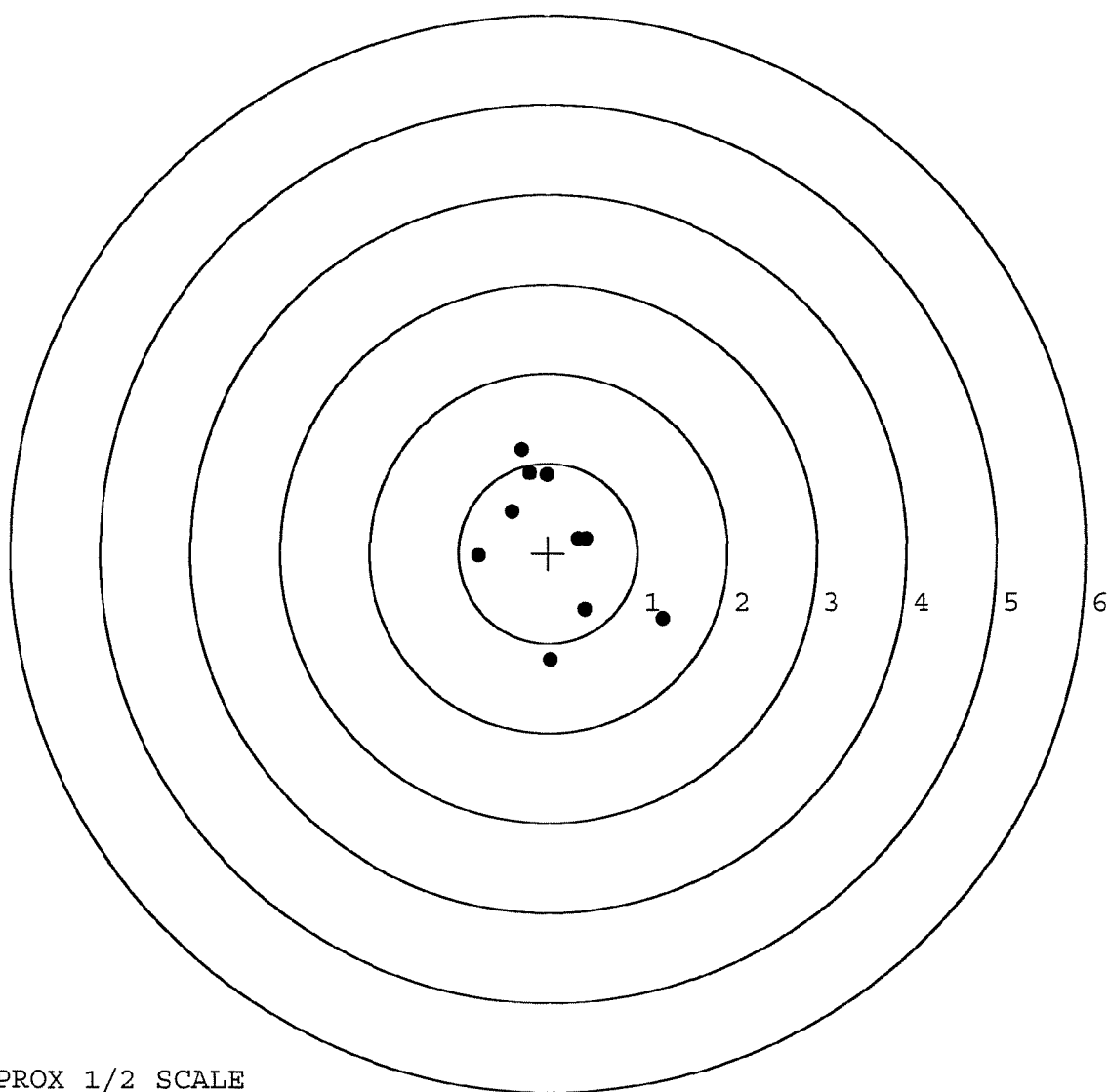


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6672608. __0
TARGET NUMBER: 4
FILE DATE: 09/04/2007
FILE TIME: 07:46

POINT#	X	Y
1:	0.020	-1.192
2:	0.409	-0.631
3:	1.278	-0.735
4:	0.417	0.162
5:	-0.775	-0.030
6:	-0.300	1.147
7:	-0.201	0.893
8:	-0.016	0.871
9:	-0.411	0.464
10:	0.329	0.163

X CENTROID: 0.075
Y CENTROID: 0.111
POA TO CENTROID: 0.134
HORZ SPREAD: 2.053
VERT SPREAD: 2.339
GROUP SPREAD: 2.456
MIN RADIUS: 0.259
MAX RADIUS: 1.471
MEAN RADIUS: 0.835
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

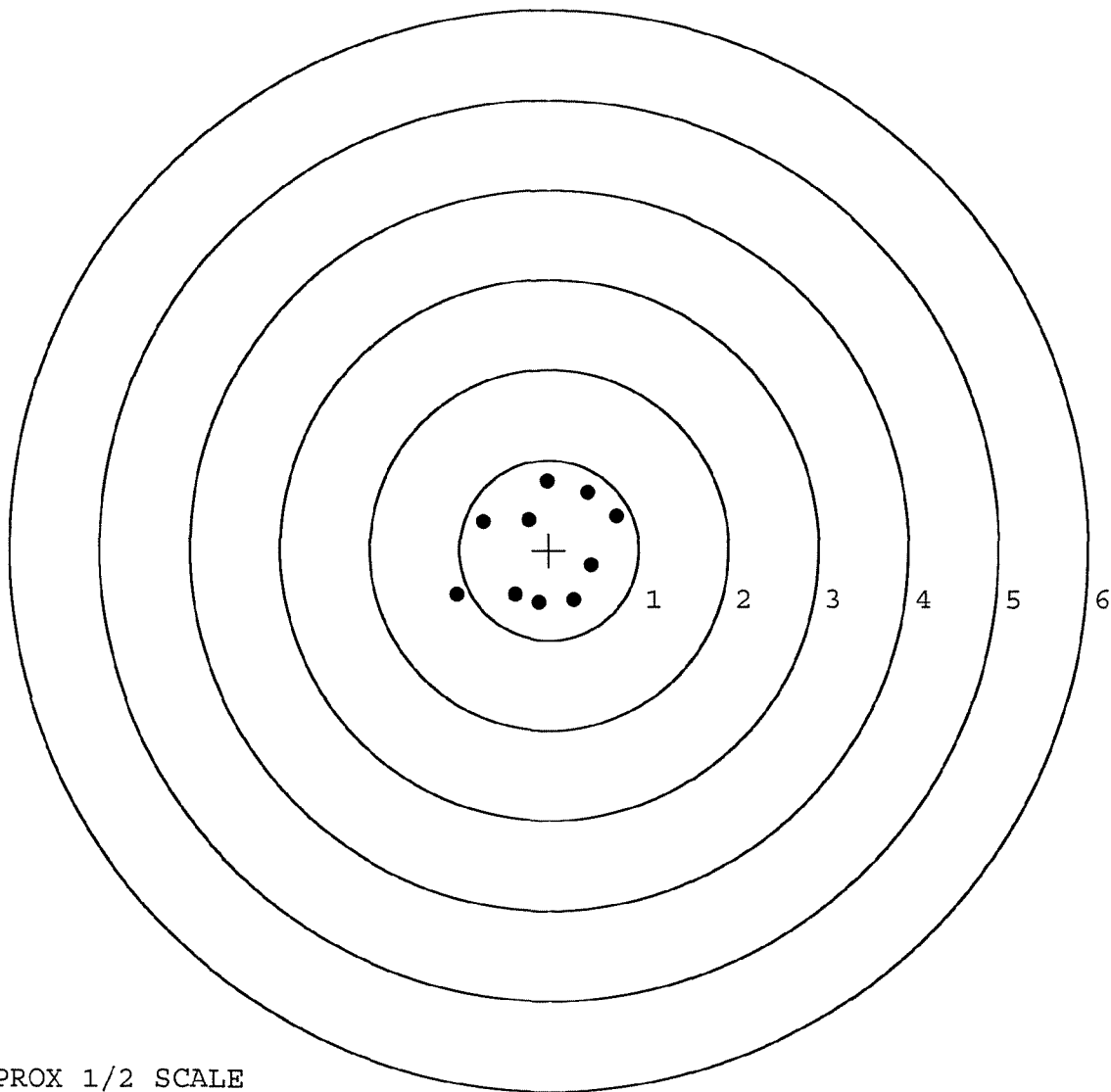


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6672608. __0
TARGET NUMBER: 5
FILE DATE: 09/04/2007
FILE TIME: 07:46

POINT#	X	Y
1:	-0.736	0.317
2:	-0.232	0.339
3:	-0.021	0.772
4:	0.433	0.642
5:	0.749	0.380
6:	0.470	-0.167
7:	0.276	-0.556
8:	-0.120	-0.584
9:	-0.375	-0.505
10:	-1.031	-0.502

X CENTROID: -0.059
Y CENTROID: 0.014
POA TO CENTROID: 0.060
HORZ SPREAD: 1.780
VERT SPREAD: 1.356
GROUP SPREAD: 1.987
MIN RADIUS: 0.369
MAX RADIUS: 1.101
MEAN RADIUS: 0.708
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE