

G667 7050

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.52 NATO

- INSTRUCTION BOOK 3518



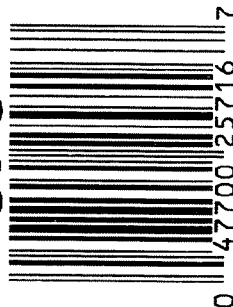
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6677050

UPC

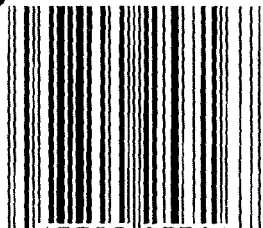


BM FORM

ORDER 25716

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

UPC

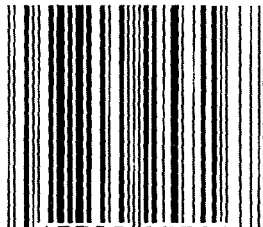


0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



66677050

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6677050

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8/11/07	SPD
420	ASSEMBLE ACTION		8-10-07	SD
430	ASSEMBLE TO STOCK		8/10/07	nm
440	PROOF	MAGNA - FLUX	8/10/07	nm
460	CHECK HEADSPACE	AUG 15 2007	8/10/07	nm
470	DIS-ASSEMBLE ACTION		8-10-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>NRD</u>	8-15-07	NRD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-14-07	CLD
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)		8/22/07	RZ
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		8/27/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

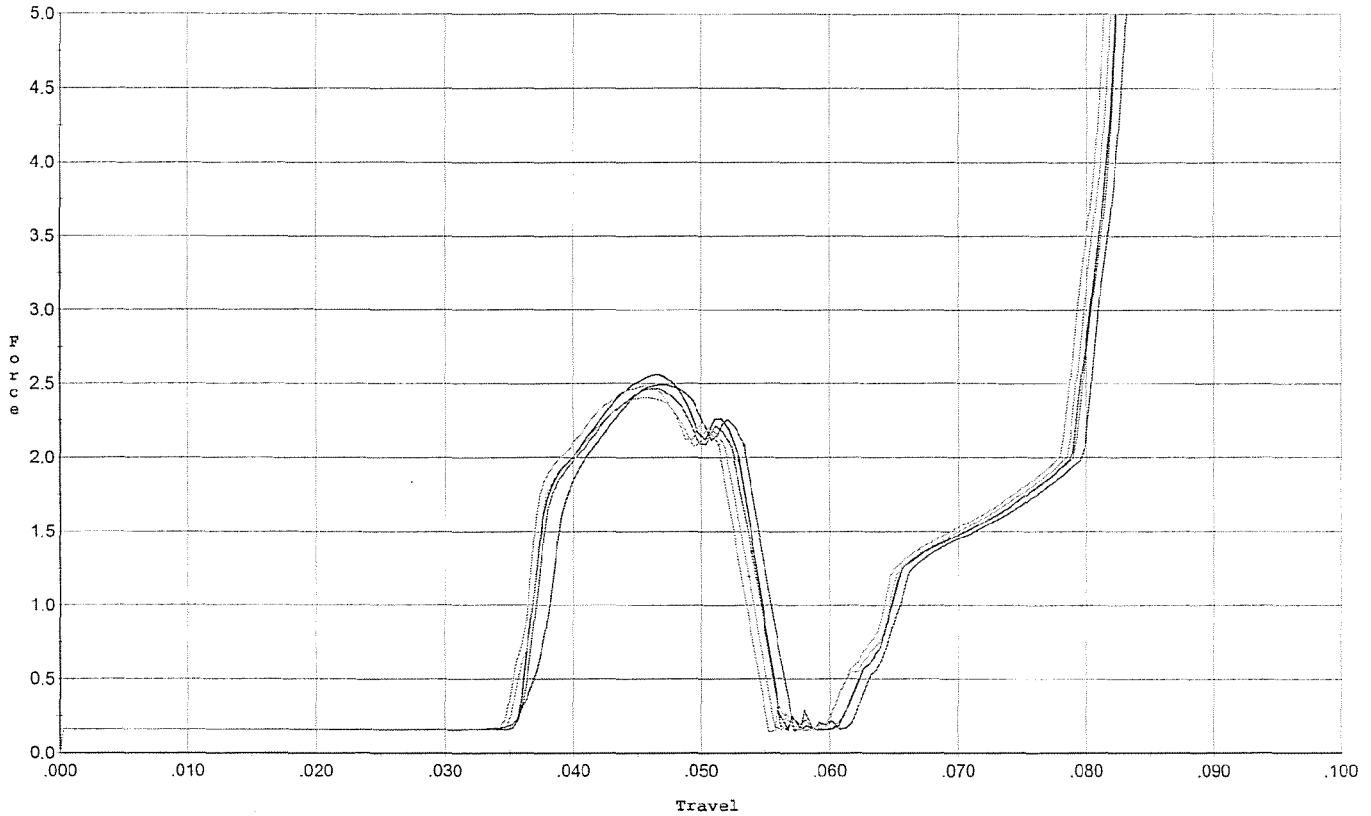
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.6</u> <u>5.6</u> <u>5.4</u>	8/28/07	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.8</u> <u>4.8</u> <u>4.8</u>	8/29/07	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8/29/07	RP
	J) ASSEMBLE STOCK		8/27/07	RP
	K) ASSEMBLE SWIVEL STUDS		8-29-07	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-4-07	RTZ
	M) IRON SIGHT ALIGNMENT		9-4-07	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-4-07	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8/28/07	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-28-07	SD
670	FINAL INSPECTION A) HEADSPACE		9-4-07	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.35</u> <u>2.53</u> <u>2.55</u> <u>2.40</u>	8/29/07	RP
	C) FUNCTION			
690	PACK		9-4-07	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 8/16/07

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



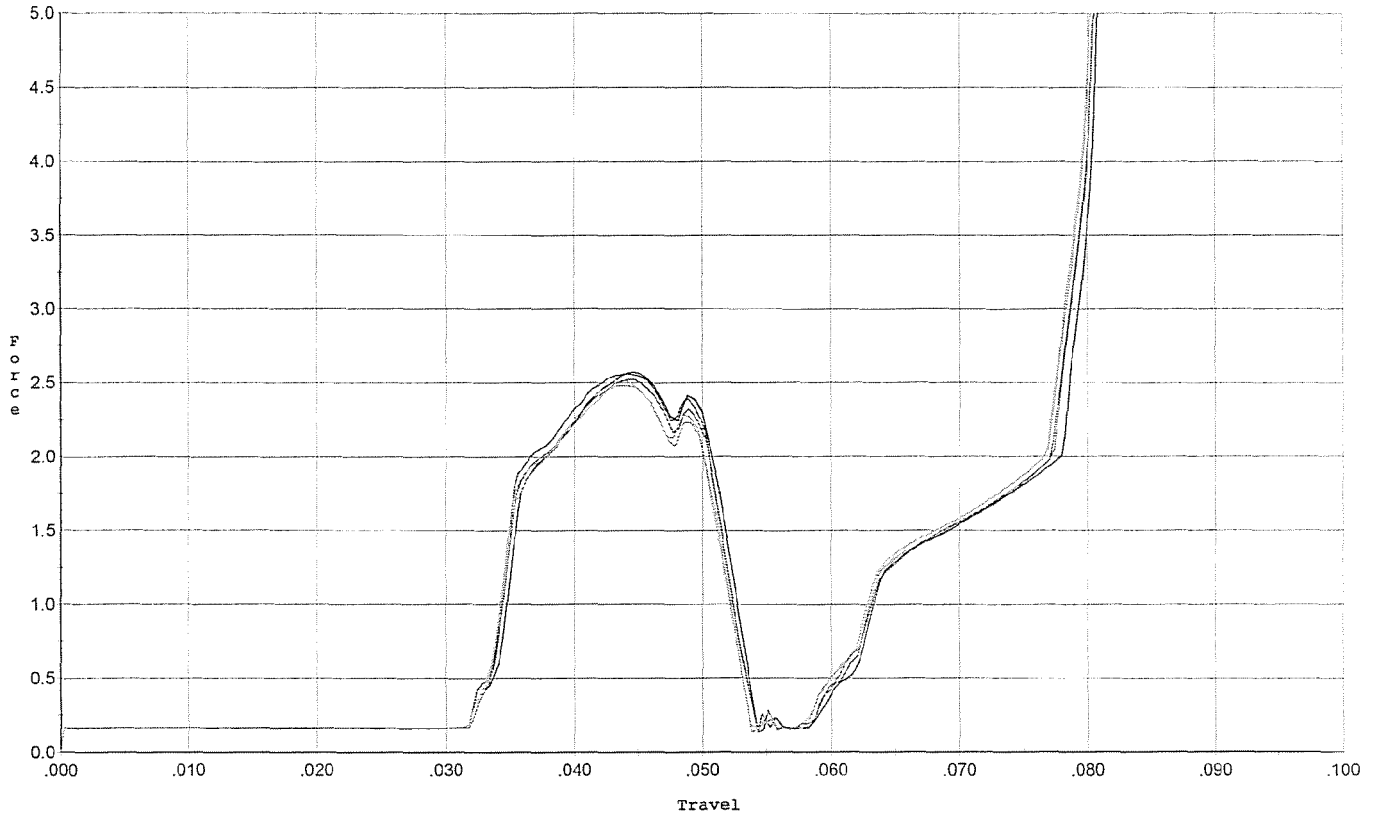
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.491	0.053	0.036	0.036	0.042		Set Trigger
2	2.562	0.053	0.036	0.036	0.043		Set Trigger
3	2.466	0.054	0.036	0.036	0.042		Set Trigger
4	2.404	0.054	0.035	0.035	0.042		Set Trigger
5	2.487	0.051	0.035	0.036	0.041		Set Trigger

AVG 2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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



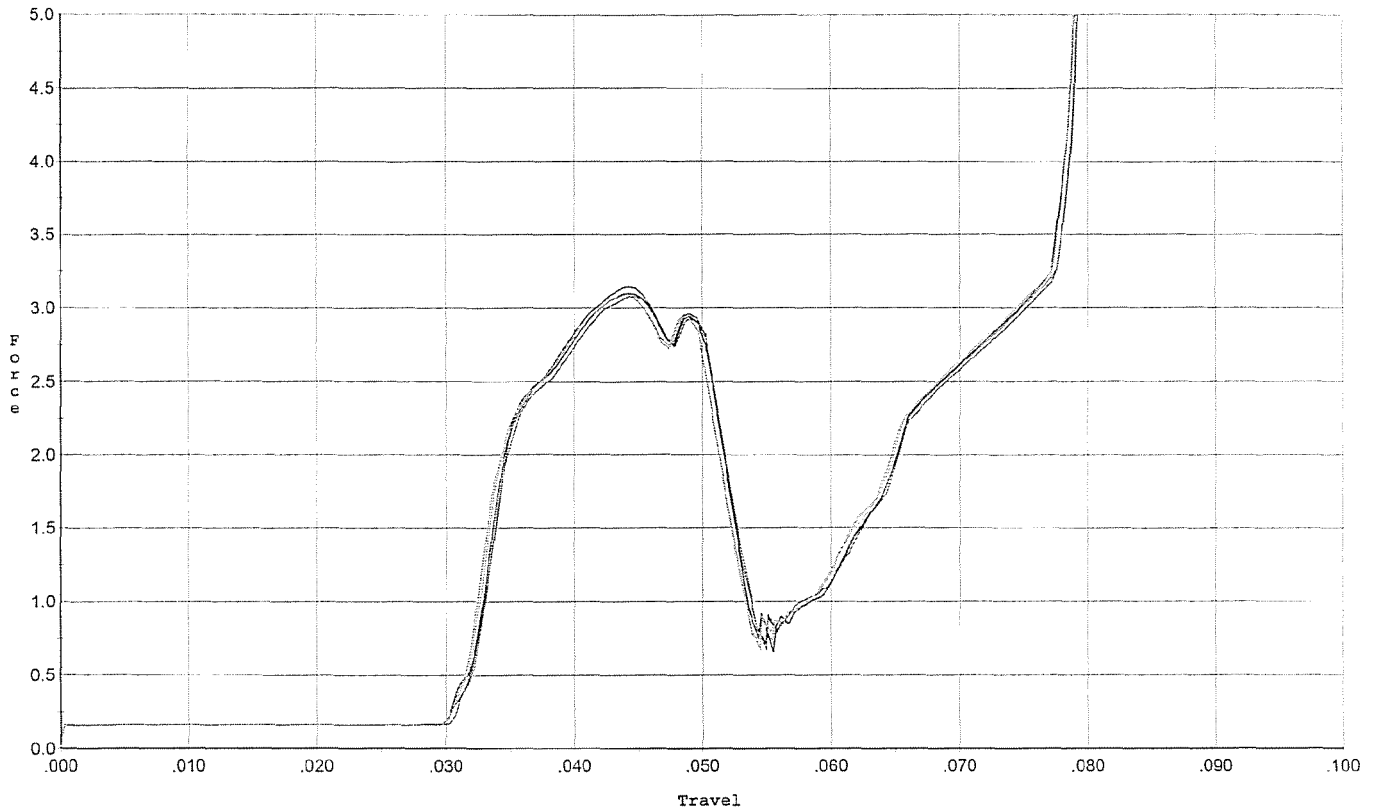
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.050	0.032	0.035	0.044		Set Trigger
2	2.570	0.051	0.032	0.035	0.044		Set Trigger
3	2.523	0.050	0.032	0.035	0.043		Set Trigger
4	2.520	0.051	0.032	0.035	0.043		Set Trigger
5	2.481	0.051	0.032	0.035	0.042		Set Trigger

AVG 2.53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/16/07

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



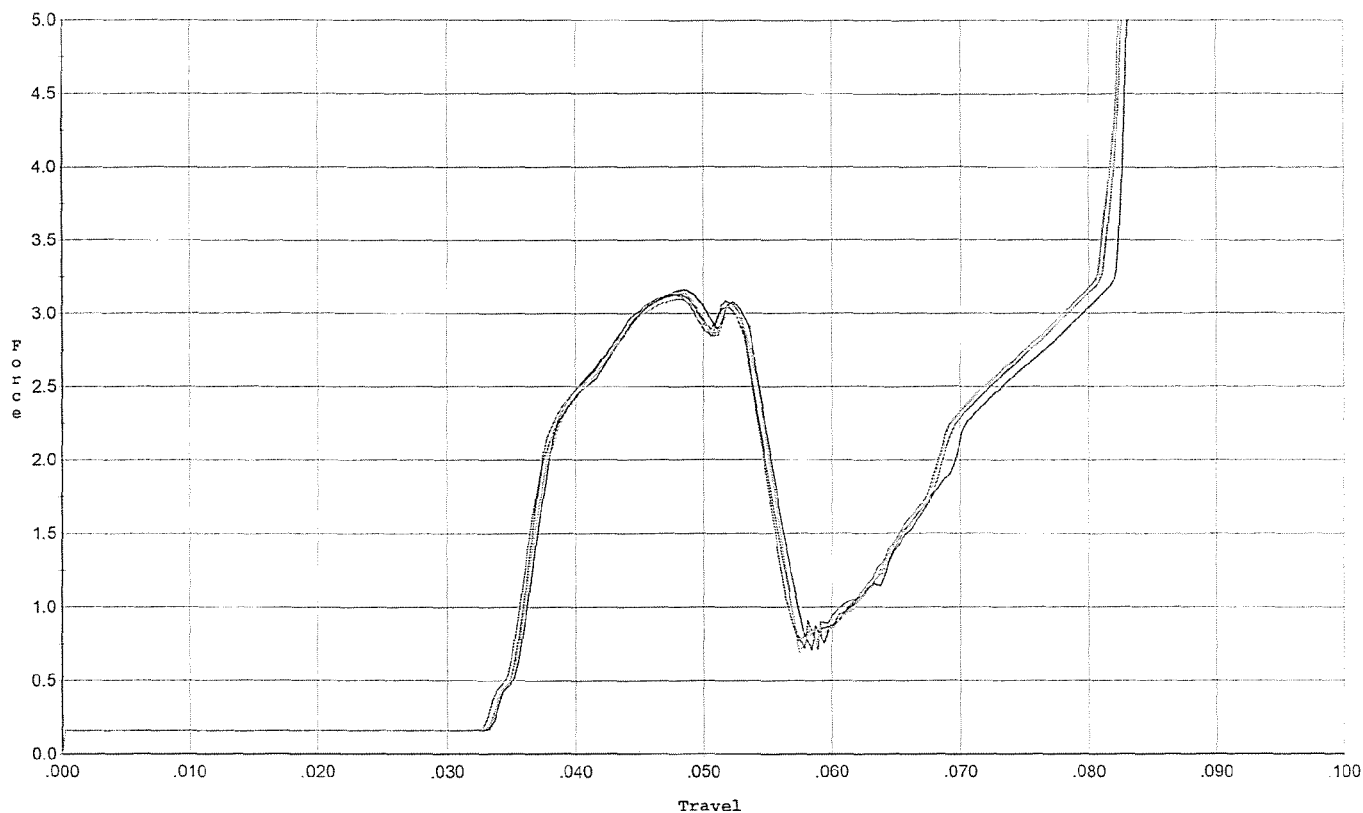
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.144	0.050	0.031	0.033	0.055		Set Trigger
2	3.099	0.050	0.031	0.033	0.055		Set Trigger
3	3.078	0.050	0.031	0.033	0.054		Set Trigger
4	3.083	0.050	0.031	0.033	0.053		Set Trigger
5	3.085	0.050	0.031	0.033	0.054		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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



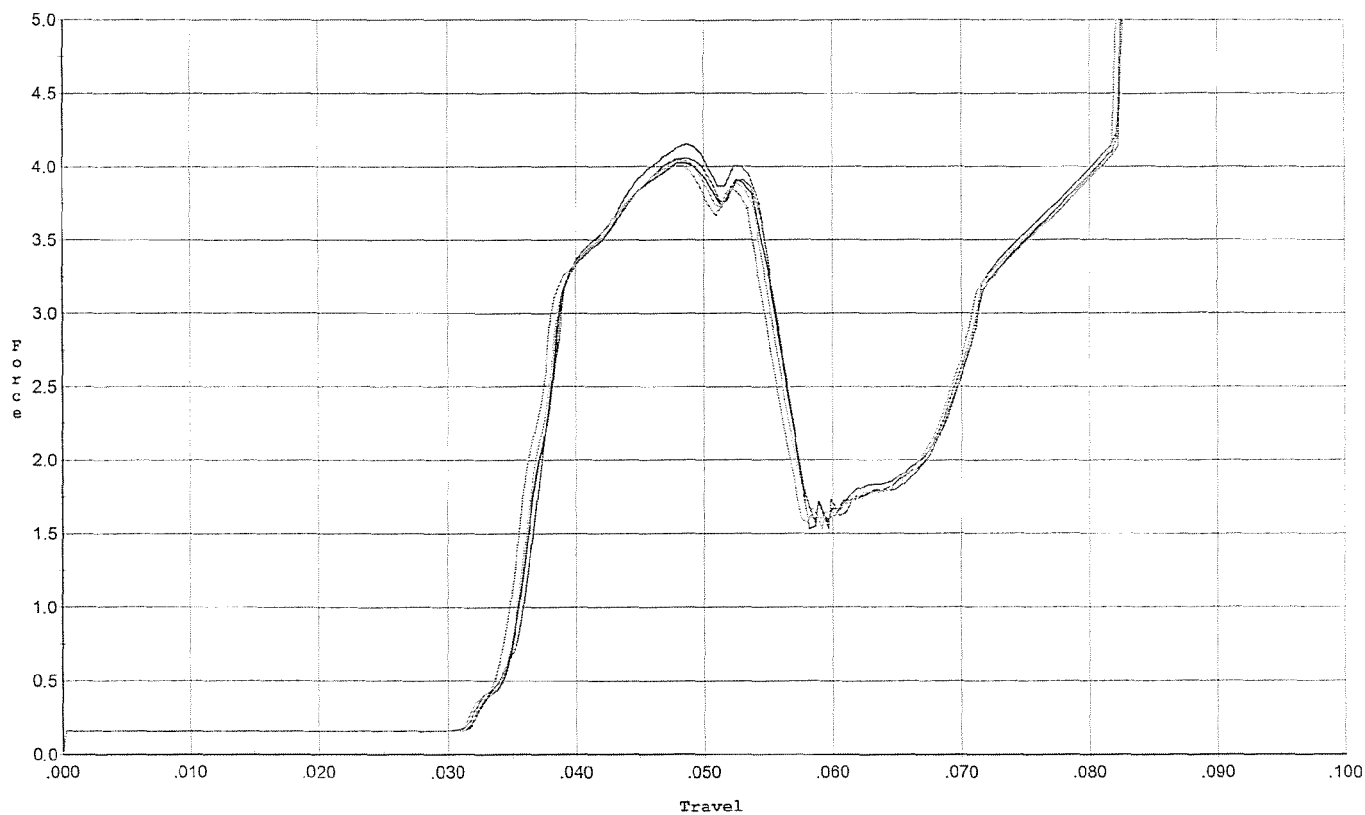
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.053	0.034	0.034	0.056		Set Trigger
2	3.155	0.054	0.034	0.034	0.056		Set Trigger
3	3.129	0.053	0.033	0.034	0.056		Set Trigger
4	3.145	0.054	0.034	0.034	0.057		Set Trigger
5	3.094	0.054	0.034	0.034	0.056		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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



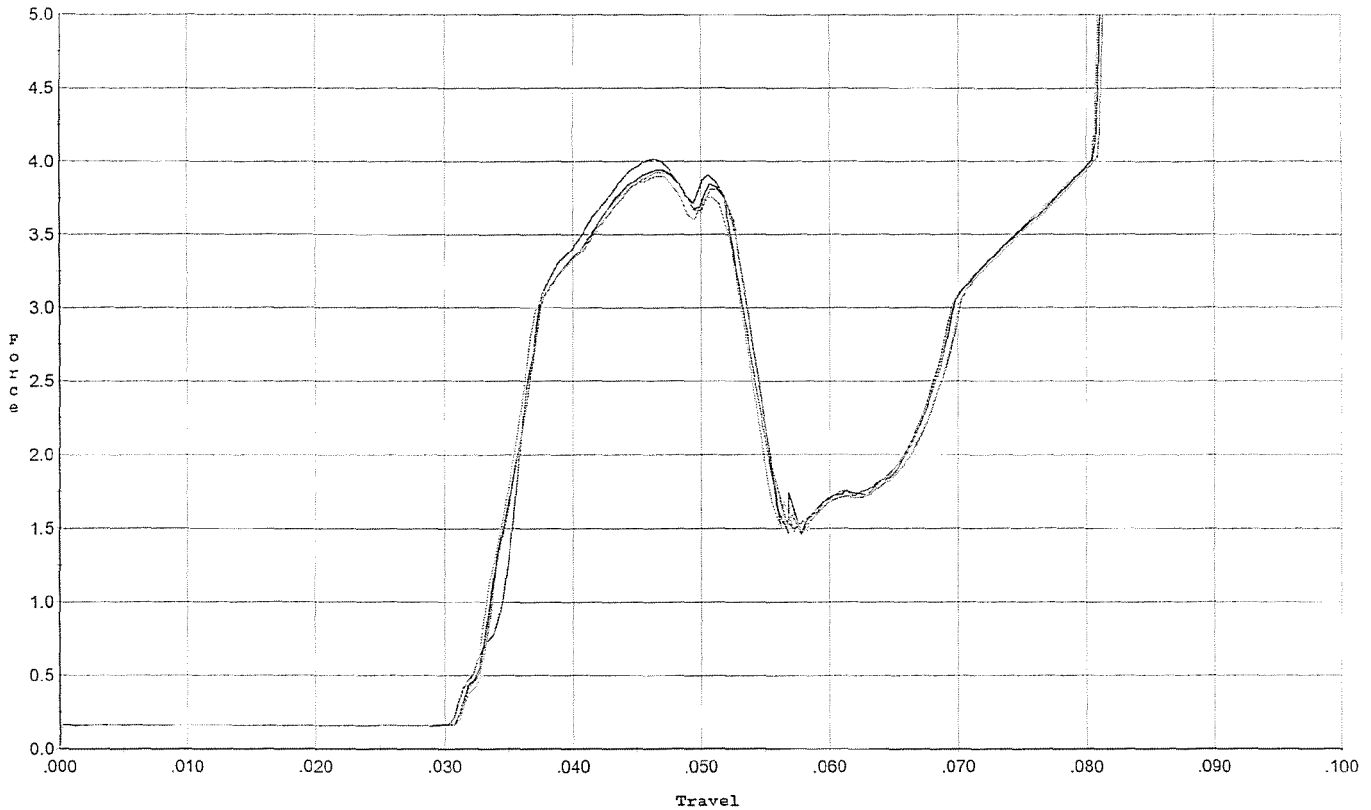
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.156	0.054	0.032	0.032	0.076		Set Trigger
2	4.025	0.055	0.032	0.032	0.076		Set Trigger
3	4.059	0.054	0.032	0.032	0.076		Set Trigger
4	4.045	0.054	0.032	0.032	0.074		Set Trigger
5	4.007	0.053	0.032	0.032	0.074		Set Trigger

AVG 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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



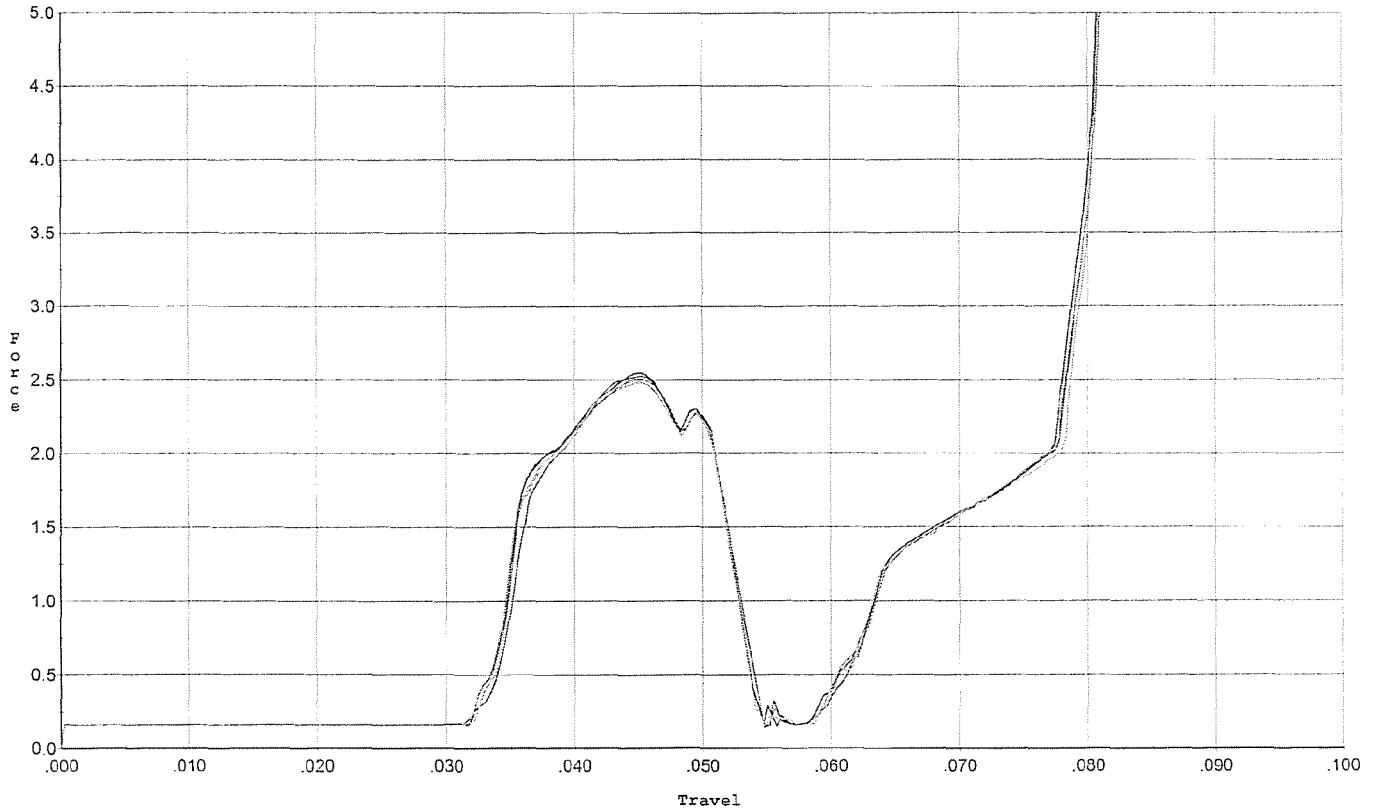
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.052	0.031	0.032	0.071		Set Trigger
2	3.940	0.053	0.031	0.032	0.072		Set Trigger
3	3.924	0.053	0.032	0.032	0.072		Set Trigger
4	3.921	0.053	0.032	0.032	0.072		Set Trigger
5	3.901	0.052	0.031	0.032	0.071		Set Trigger

Avg 3.94

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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



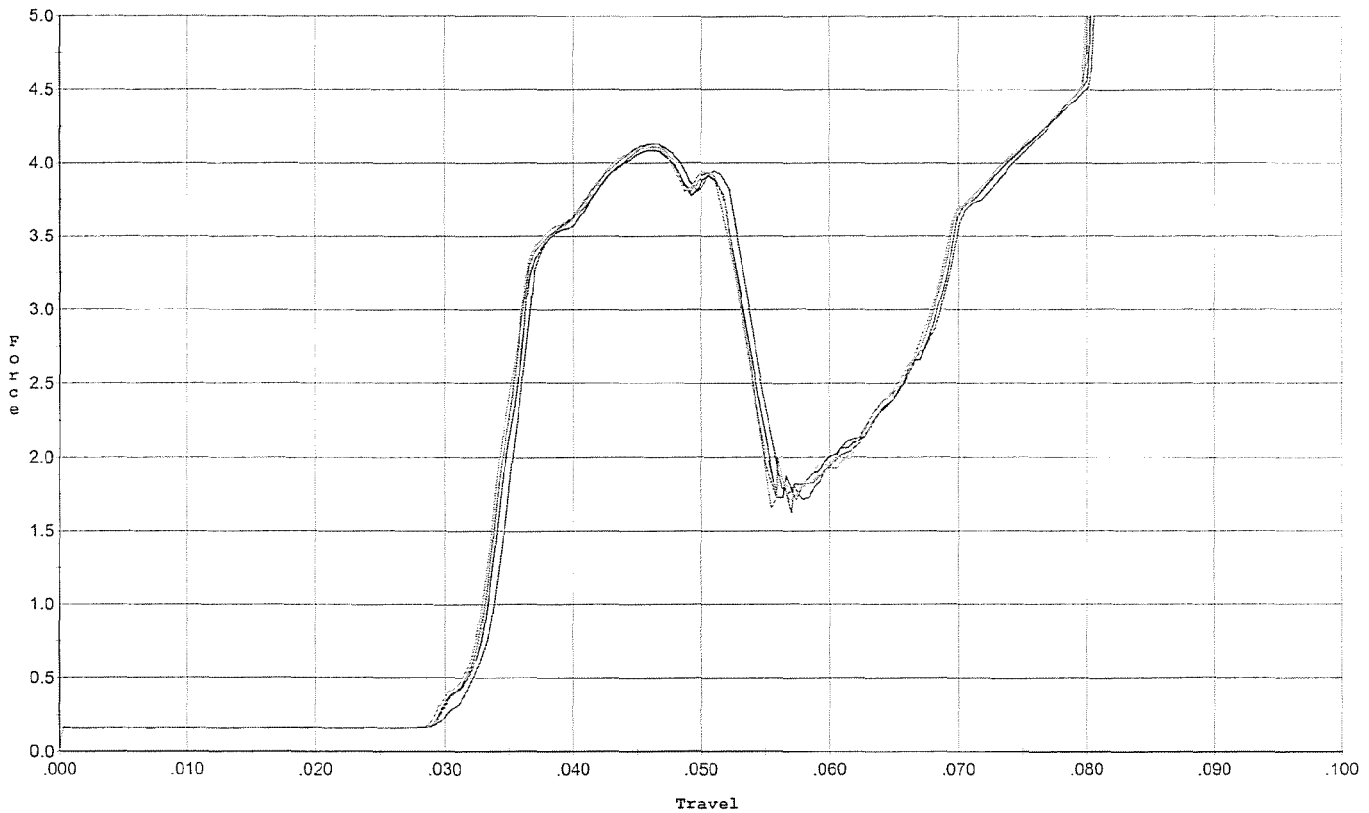
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.527	0.051	0.033	0.035	0.042		Set Trigger
2	2.550	0.051	0.032	0.035	0.043		Set Trigger
3	2.509	0.051	0.032	0.035	0.043		Set Trigger
4	2.481	0.051	0.033	0.035	0.042		Set Trigger
5	2.491	0.051	0.032	0.035	0.043		Set Trigger

AVG 2.51

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/07

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	4.129	0.052	0.032	0.032	0.076		Set Trigger
2	4.088	0.052	0.030	0.032	0.075		Set Trigger
3	4.134	0.052	0.030	0.032	0.076		Set Trigger
4	4.108	0.052	0.030	0.032	0.075		Set Trigger
5	4.112	0.052	0.030	0.031	0.077		Set Trigger

Avg 4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6677050.__0
FILE DATE AND TIME: 08/28/2007 23:06

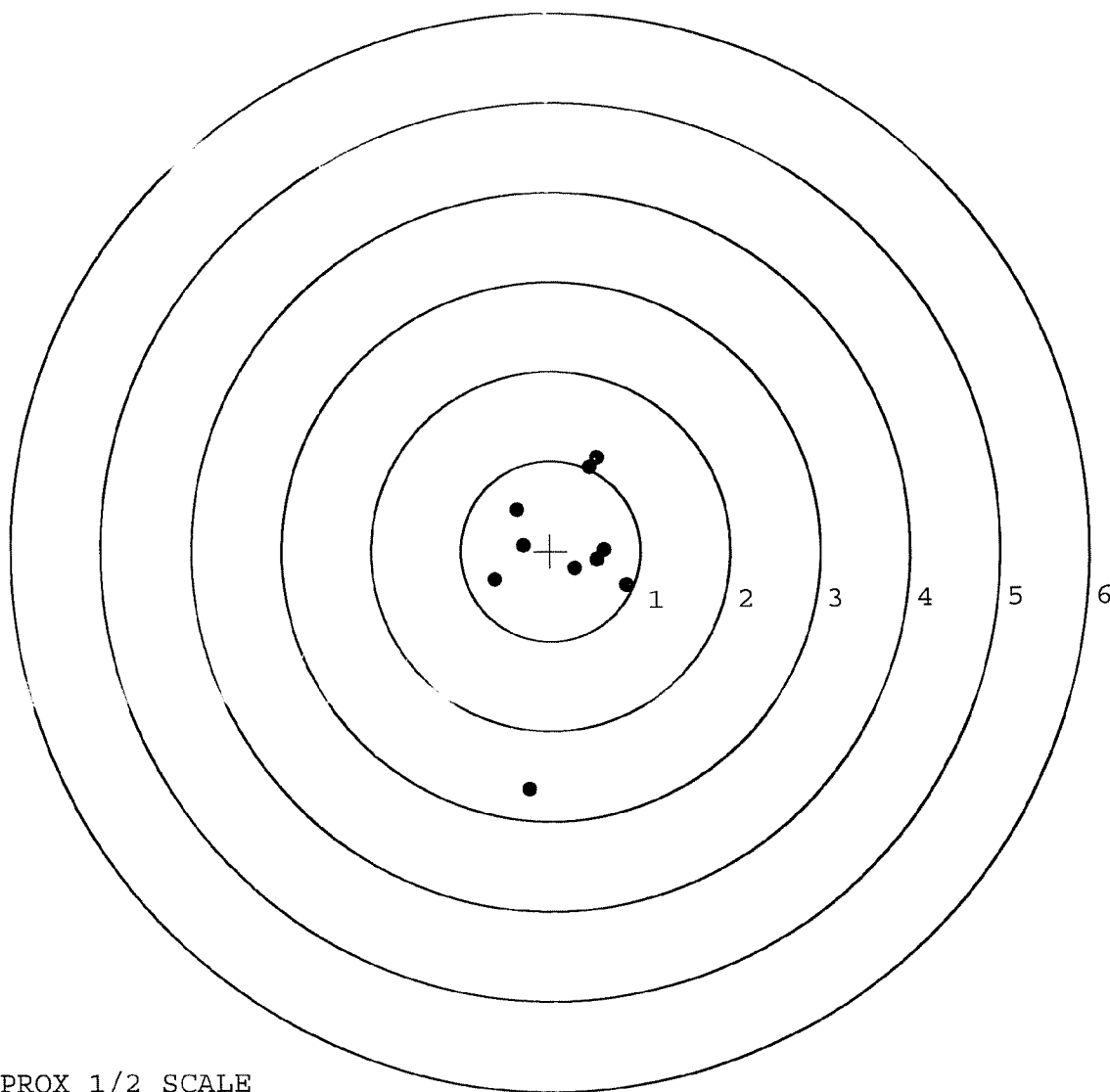
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.044
The Average Y Centroid of the Five Target Set:	-0.007
The Average Point of Impact of the Five Target Set:	0.044
The Average Mean Radius of the Five Target Set:	0.770
The Distance from POA to Centroid Target #1:	0.201
The Distance from Centroid Target #2 to Centroid Target #1:	0.036
The Distance from Centroid Target #3 to Centroid Target #1:	0.330
The Distance from Centroid Target #4 to Centroid Target #1:	0.172
The Distance from Centroid Target #5 to Centroid Target #1:	0.388

SERIAL NUMBER: G6677050. __0
TARGET NUMBER: 1
FILE DATE: 08/28/2007
FILE TIME: 23:06

POINT#	X	Y
1:	0.444	0.925
2:	0.522	1.027
3:	0.598	0.010
4:	0.269	-0.198
5:	0.840	-0.388
6:	-0.373	0.459
7:	-0.305	0.061
8:	-0.621	-0.317
9:	-0.265	-2.656
10:	0.516	-0.101

X CENTROID: 0.163
Y CENTROID: -0.118
POA TO CENTROID: 0.201
HORZ SPREAD: 1.461
VERT SPREAD: 3.683
GROUP SPREAD: 3.766
MIN RADIUS: 0.133
MAX RADIUS: 2.574
MEAN RADIUS: 0.862
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

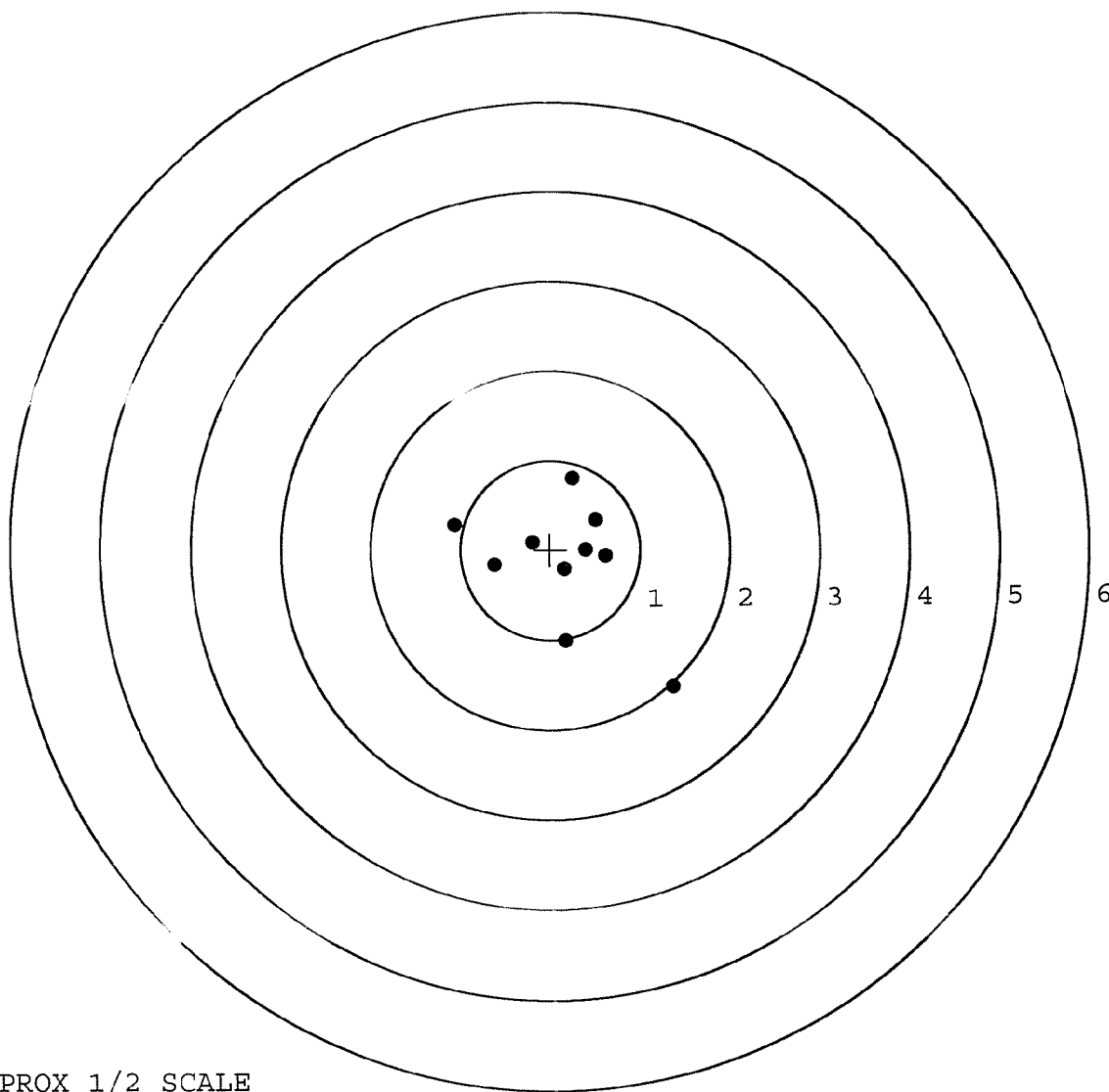


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6677050. __0
TARGET NUMBER: 2
FILE DATE: 08/28/2007
FILE TIME: 23:06

POINT#	X	Y
1:	-1.060	0.291
2:	-0.624	-0.167
3:	0.166	-1.019
4:	1.351	-1.535
5:	-0.199	0.083
6:	0.154	-0.224
7:	0.618	-0.079
8:	0.394	-0.011
9:	0.510	0.333
10:	0.257	0.795

X CENTROID: 0.157
Y CENTROID: -0.153
POA TO CENTROID: 0.219
HORZ SPREAD: 2.411
VERT SPREAD: 2.330
GROUP SPREAD: 3.024
MIN RADIUS: 0.071
MAX RADIUS: 1.826
MEAN RADIUS: 0.756
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

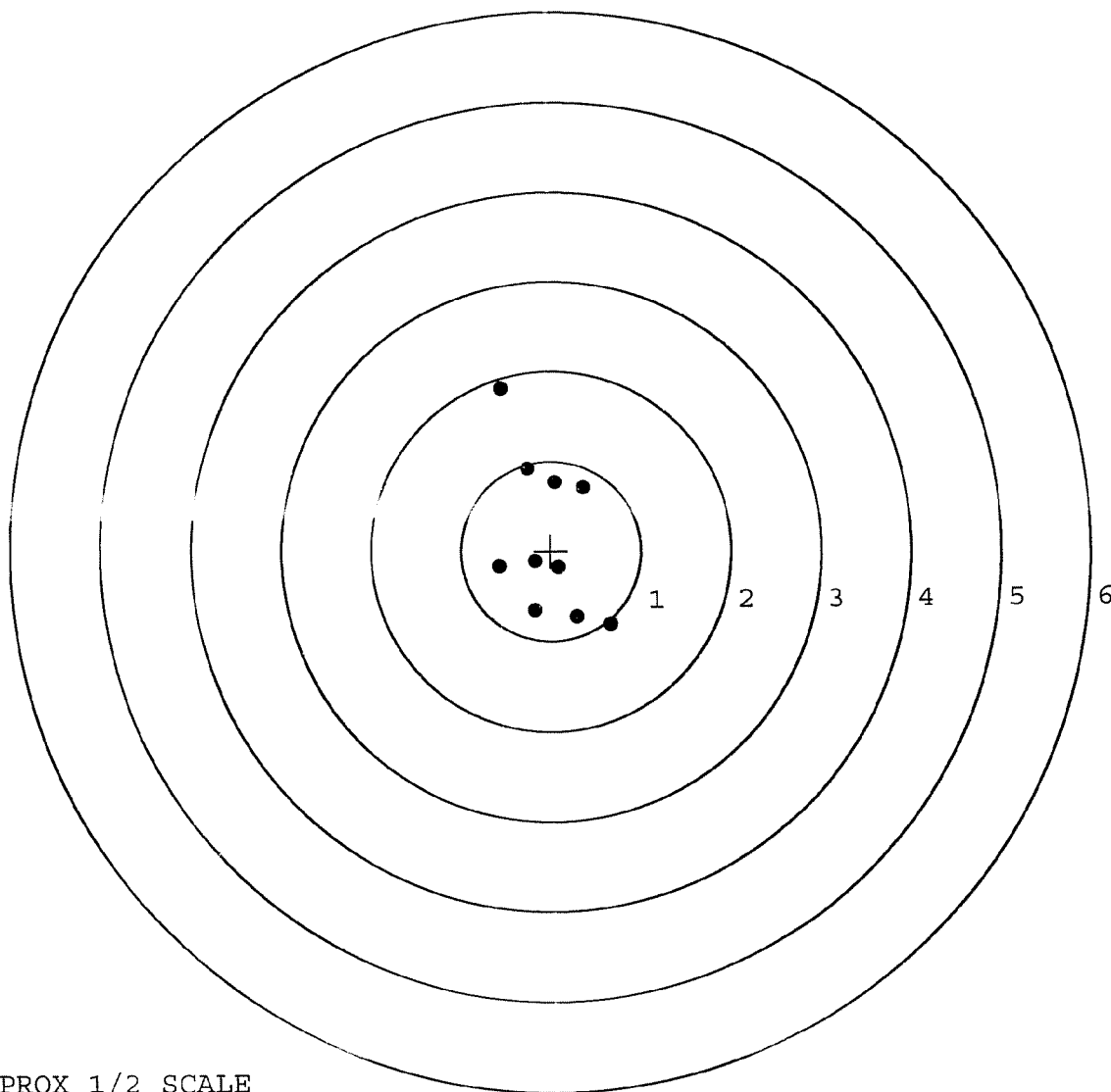


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6677050. __0
 TARGET NUMBER: 3
 FILE DATE: 08/28/2007
 FILE TIME: 23:06

POINT#	X	Y
1:	-0.256	0.919
2:	0.050	0.761
3:	0.361	0.704
4:	-0.541	1.809
5:	-0.578	-0.170
6:	-0.174	-0.115
7:	0.080	-0.186
8:	-0.182	-0.665
9:	0.282	-0.738
10:	0.655	-0.824

X CENTROID: -0.030
 Y CENTROID: 0.150
 POA TO CENTROID: 0.153
 HORZ SPREAD: 1.233
 VERT SPREAD: 2.633
 GROUP SPREAD: 2.892
 MIN RADIUS: 0.301
 MAX RADIUS: 1.736
 MEAN RADIUS: 0.808
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

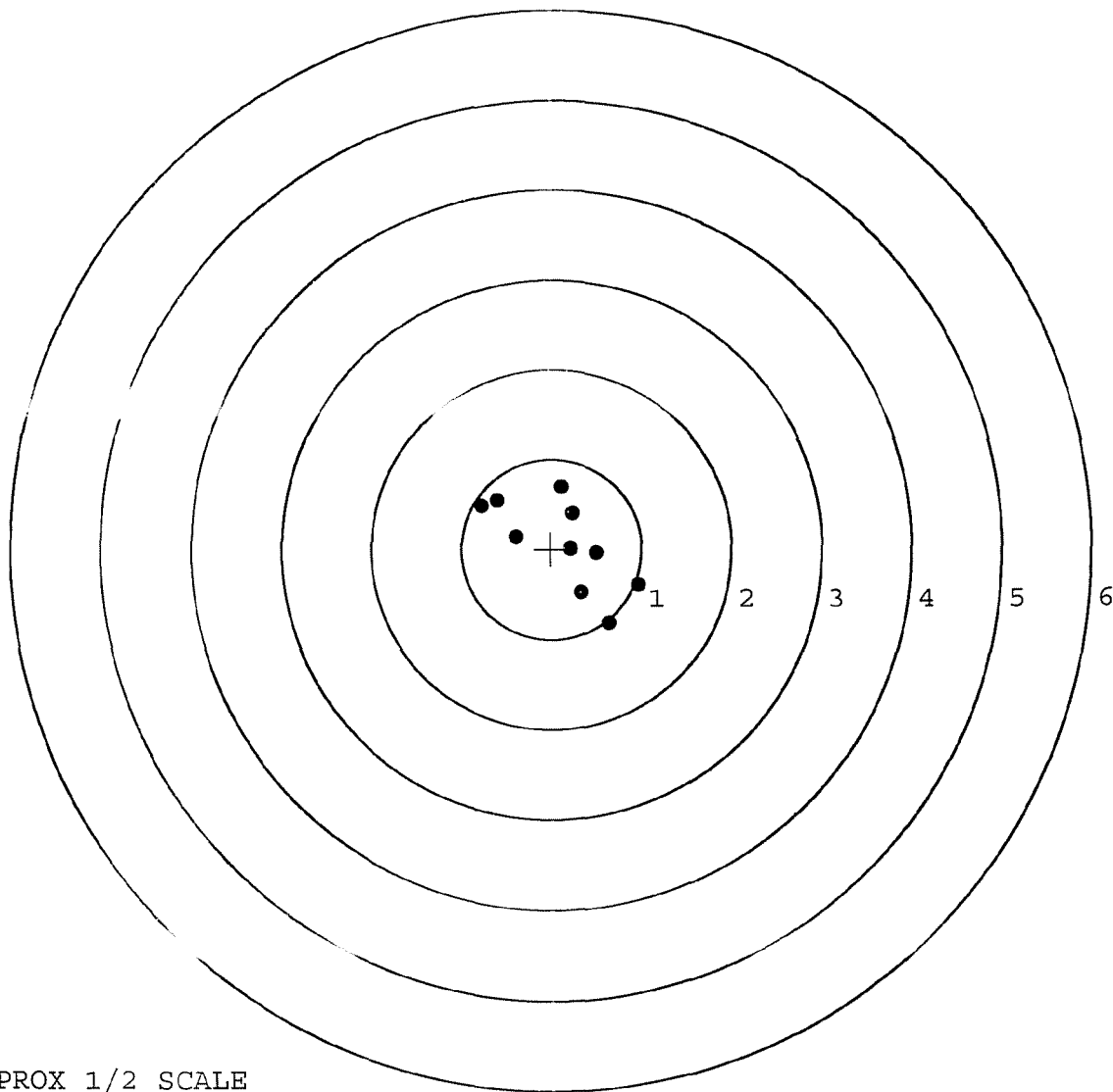


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6677050. 0
TARGET NUMBER: 4
FILE DATE: 08/28/2007
FILE TIME: 23:06

POINT#	X	Y
1:	-0.601	0.544
2:	-0.774	0.485
3:	-0.394	0.134
4:	0.119	0.693
5:	0.234	0.394
6:	0.219	-0.004
7:	0.504	-0.046
8:	0.327	-0.484
9:	0.638	-0.820
10:	0.961	-0.402

X CENTROID: 0.123
Y CENTROID: 0.049
POA TO CENTROID: 0.133
HORZ SPREAD: 1.735
VERT SPREAD: 1.513
GROUP SPREAD: 1.923
MIN RADIUS: 0.110
MAX RADIUS: 1.010
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

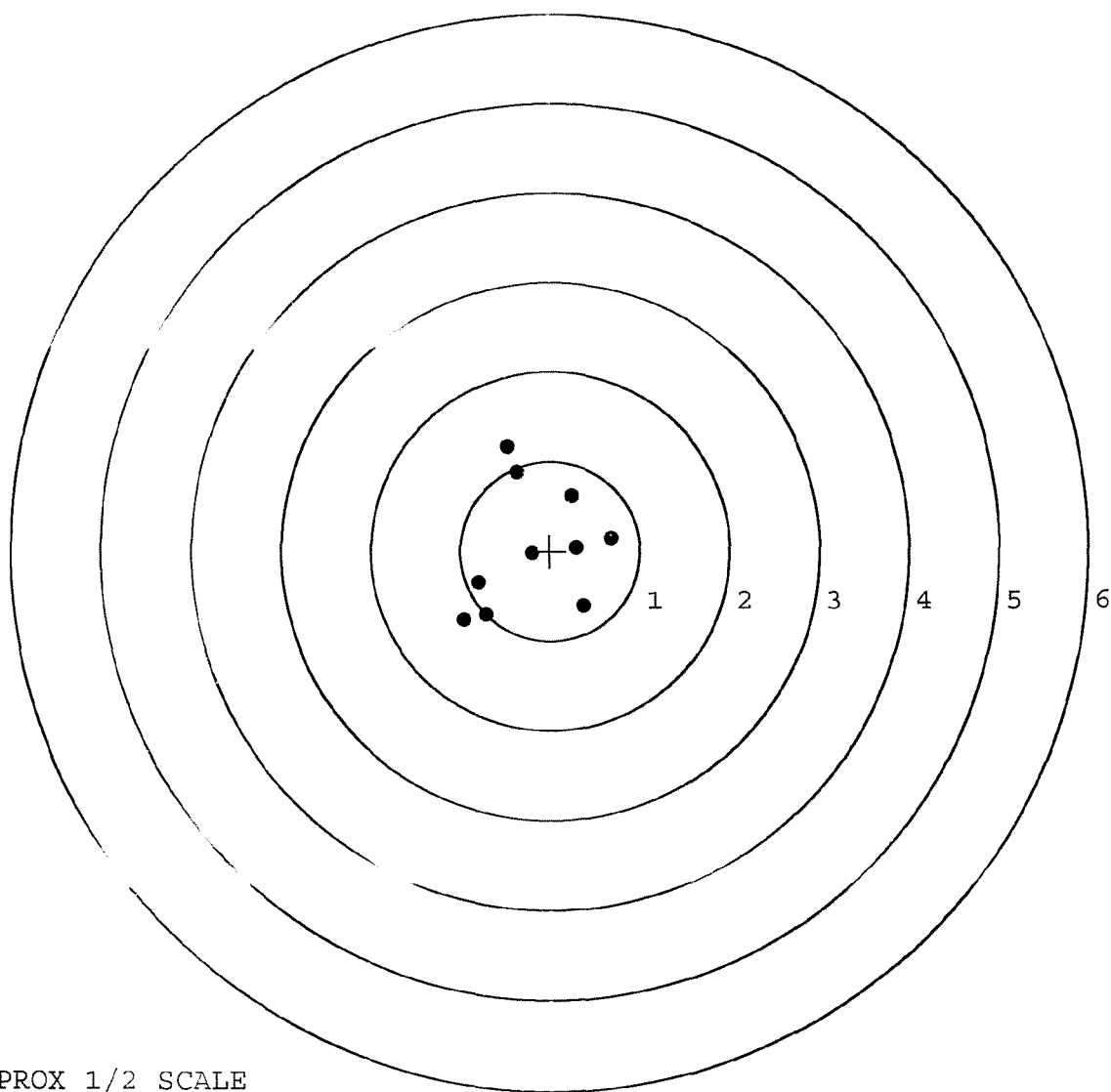


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6677050. __0
TARGET NUMBER: 5
FILE DATE: 08/28/2007
FILE TIME: 23:06

POINT#	X	Y
1:	-0.469	1.164
2:	-0.373	0.882
3:	0.243	0.620
4:	0.674	0.144
5:	0.296	0.039
6:	-0.194	-0.022
7:	-0.796	-0.346
8:	-0.715	-0.707
9:	-0.963	-0.769
10:	0.372	-0.614

X CENTROID: -0.193
Y CENTROID: 0.039
POA TO CENTROID: 0.196
HORZ SPREAD: 1.637
VERT SPREAD: 1.933
GROUP SPREAD: 1.995
MIN RADIUS: 0.061
MAX RADIUS: 1.158
MEAN RADIUS: 0.778
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE