G 0091400

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

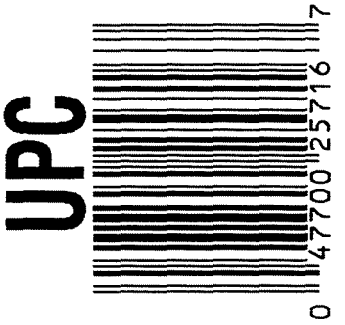
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

BM FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6691400



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.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6691400

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-24-07	RTL
420	ASSEMBLE ACTION		9-24-07	RTL
430	ASSEMBLE TO STOCK		9-24-07	SD
440	PROOF	MAGNA-FLUX SEP 25 2007 OPERATOR	9/24/07	
460	CHECK HEADSPACE		9/24/07	
470	DIS-ASSEMBLE ACTION		9-24-07	SD
480	MAGNAFLUX BBL ACTION		9/25/07	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-25-07	CW
510	DRILL AND TAP SIGHT HOLES		9-25-07	
520	GOFF BLAST BBL / REC		9.25.07	
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/25/07	
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-2-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-2-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-2-07	SD
	D) OIL FIRING PIN ASSEMBLY		10/3/07	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/12/07	

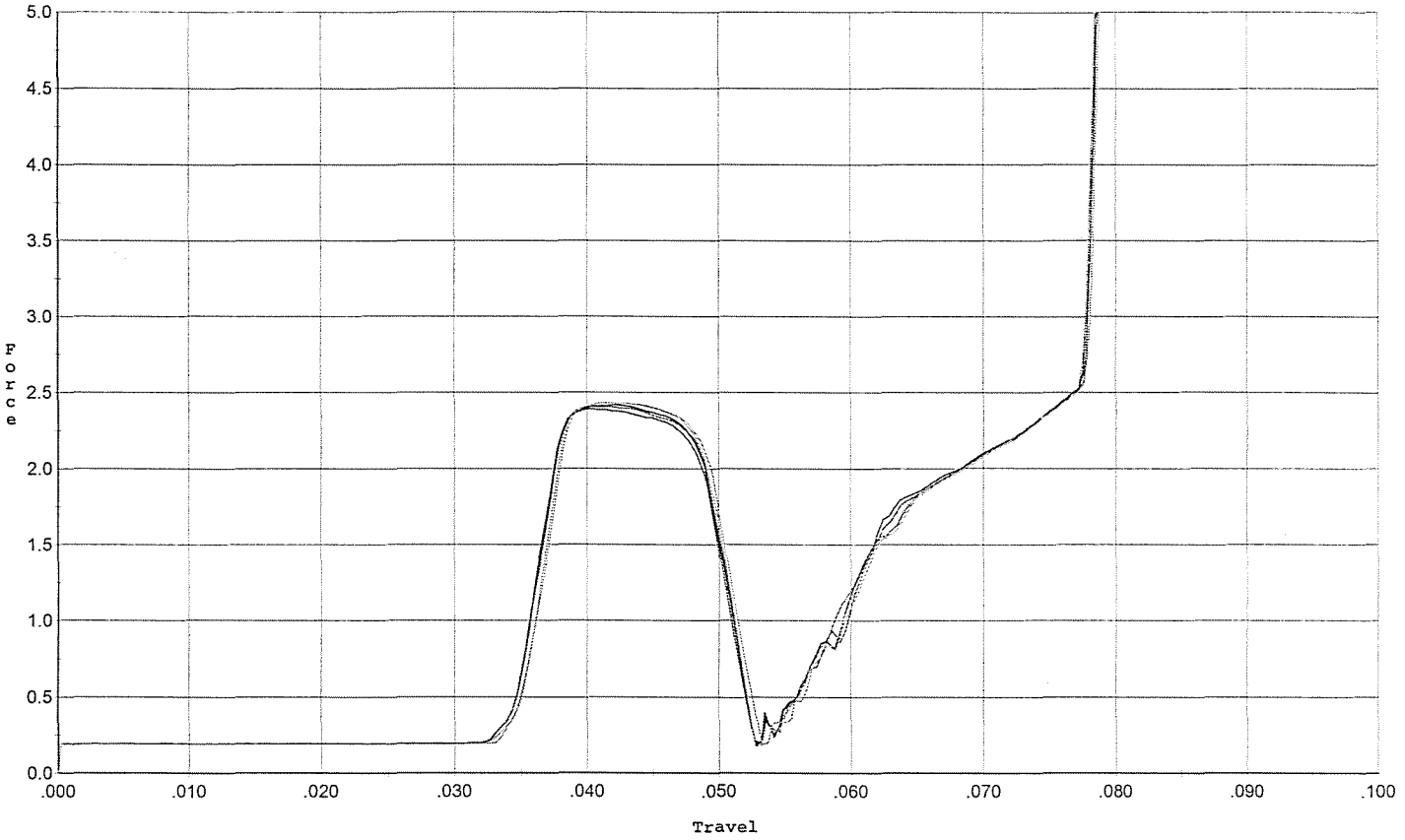
F004 REV 5/2006

560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	7.5	7.5	7.0	10.5.07	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	4.5	4.5	4.5	10.5.07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY				10/12/07	
	I) FIRING PIN INDENT [.020 MIN]	.023	.023	.024	10.5.07	DA
	J) ASSEMBLE STOCK				10/3/07	
	K) ASSEMBLE SWIVEL STUDS				10.5.07	DA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10/12/07	
	M) IRON SIGHT ALIGNMENT				10/12/07	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10/12/07	
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL (PASS) FAIL			10-4-07	TRW
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
660	INSPECT FOR LIVE AMMO				10.4.07	BWD
670	FINAL INSPECTION A) HEADSPACE				10/12/07	
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.31	2.53	2.46 2.39 2.33	10-5-07	DA
	C) FUNCTION				10/12/07	
690	PACK				10/13/07	DA

N/A

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 9/18/07		

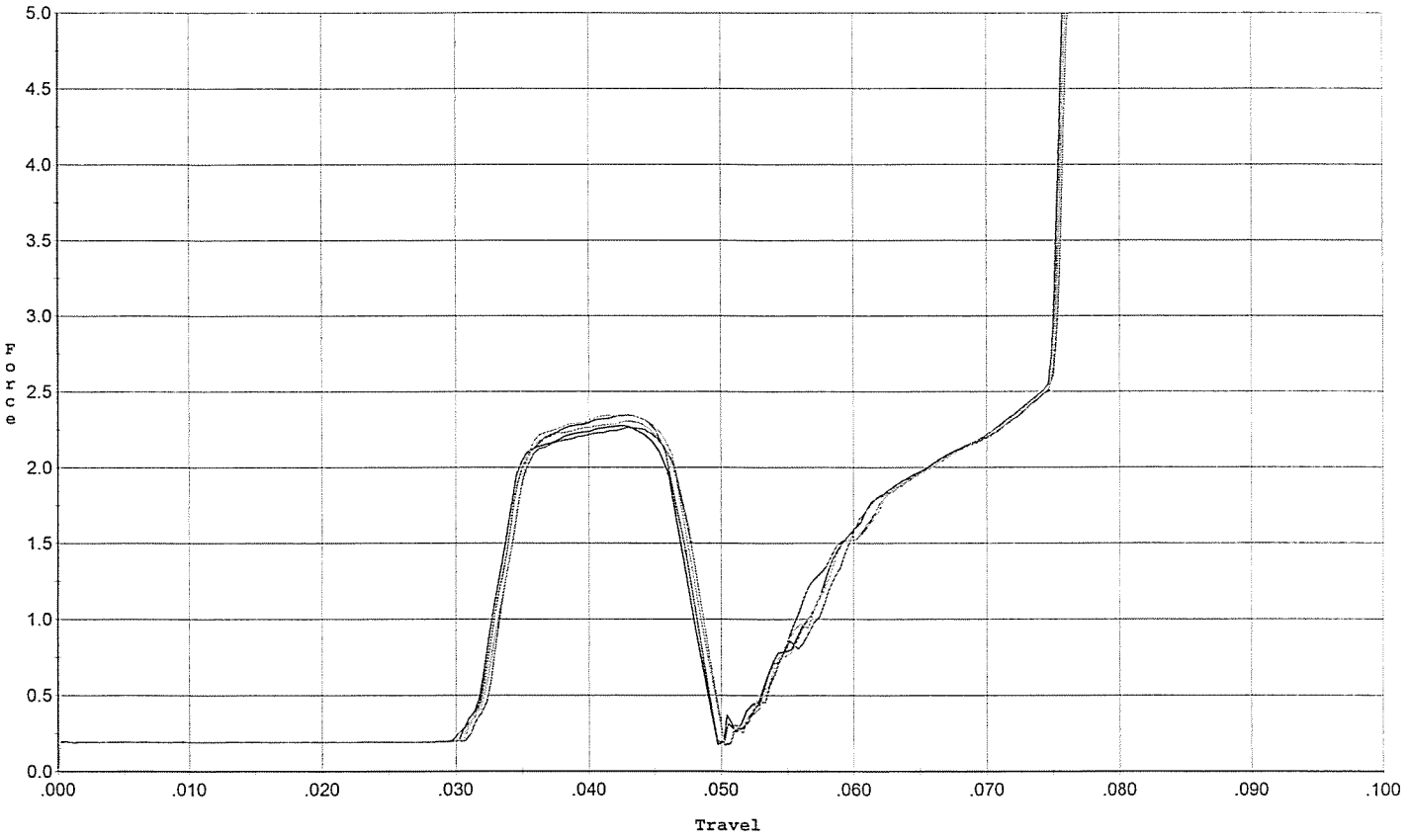


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.392	0.049	0.034	0.035	0.038		Set Trigger
2	2.417	0.051	0.034	0.035	0.040		Set Trigger
3	2.406	0.050	0.034	0.035	0.040		Set Trigger
4	2.432	0.049	0.035	0.035	0.039		Set Trigger
5	2.427	0.050	0.034	0.035	0.039		Set Trigger

Avg 2.41

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 9/18/07		



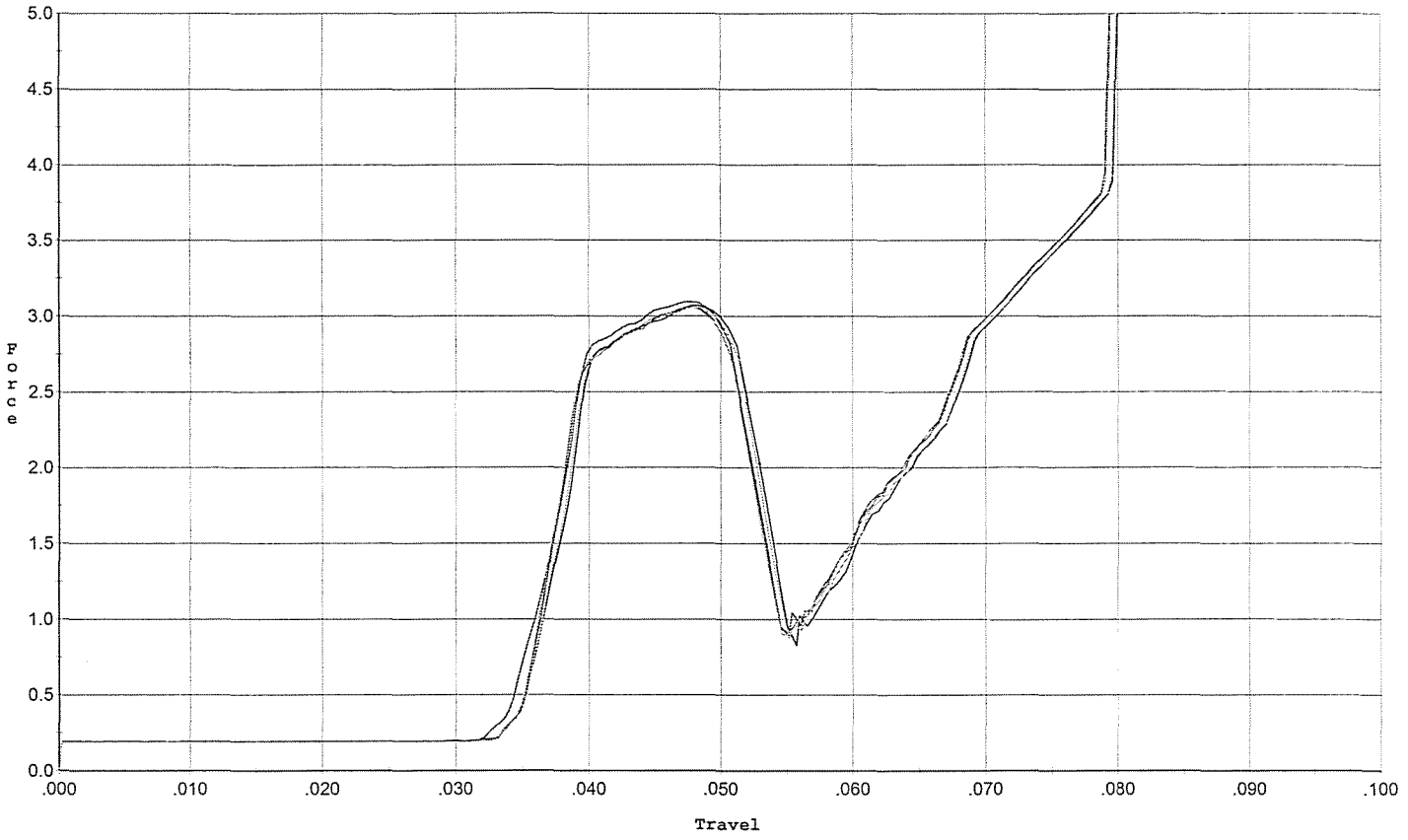
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.346	0.047	0.032	0.034	0.038		Set Trigger
2	2.274	0.046	0.031	0.034	0.036		Set Trigger
3	2.264	0.048	0.031	0.034	0.037		Set Trigger
4	2.305	0.046	0.031	0.034	0.036		Set Trigger
5	2.344	0.048	0.031	0.034	0.038		Set Trigger

AVG 2.30

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:42:29 PM

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 9/18/07		



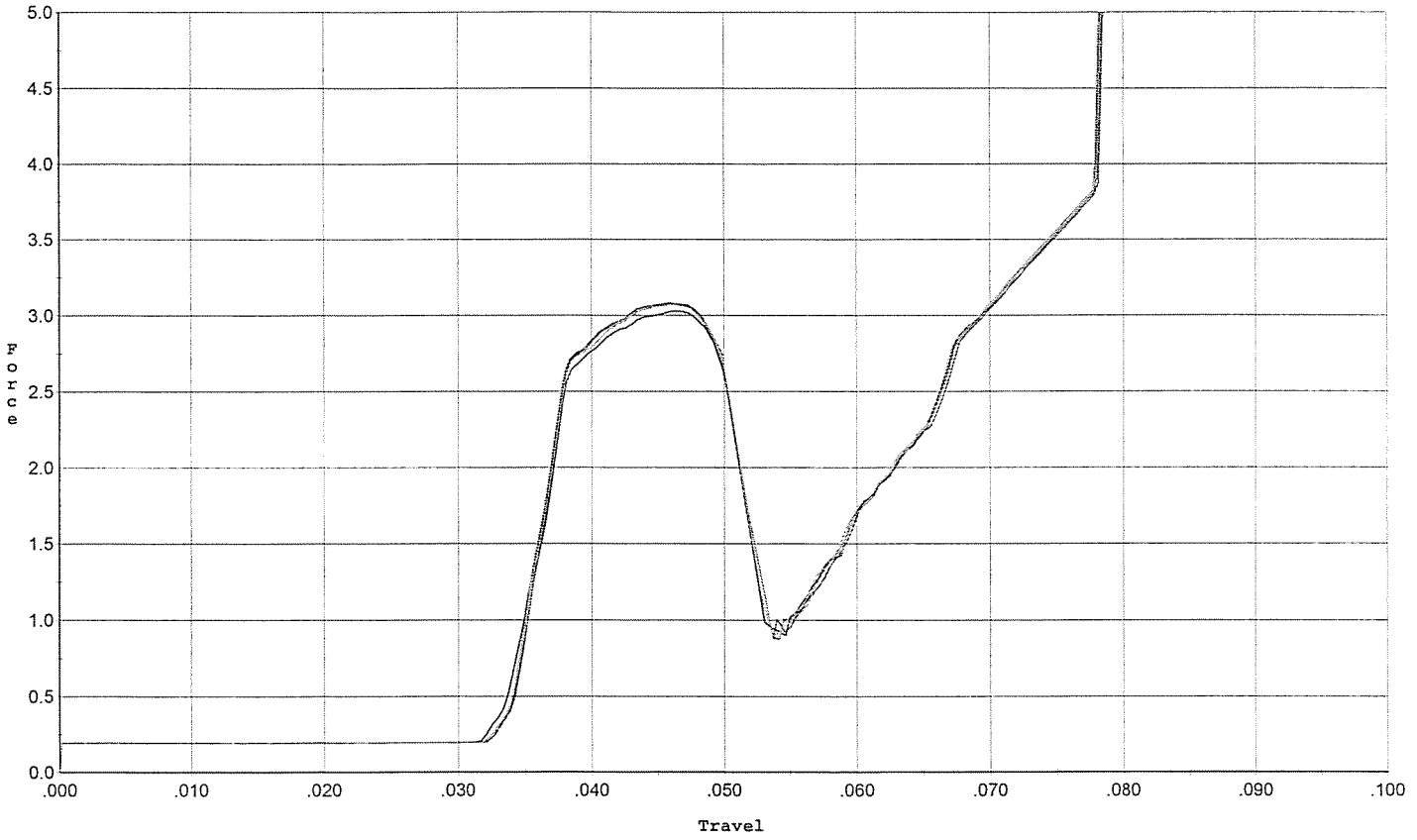
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.094	0.053	0.034	0.033	0.052		Set Trigger
2	3.069	0.053	0.035	0.033	0.052		Set Trigger
3	3.059	0.051	0.035	0.034	0.049		Set Trigger
4	3.061	0.051	0.035	0.034	0.050		Set Trigger
5	3.060	0.051	0.035	0.034	0.049		Set Trigger

Avg 3.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:44:18 PM

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 9/18/07		



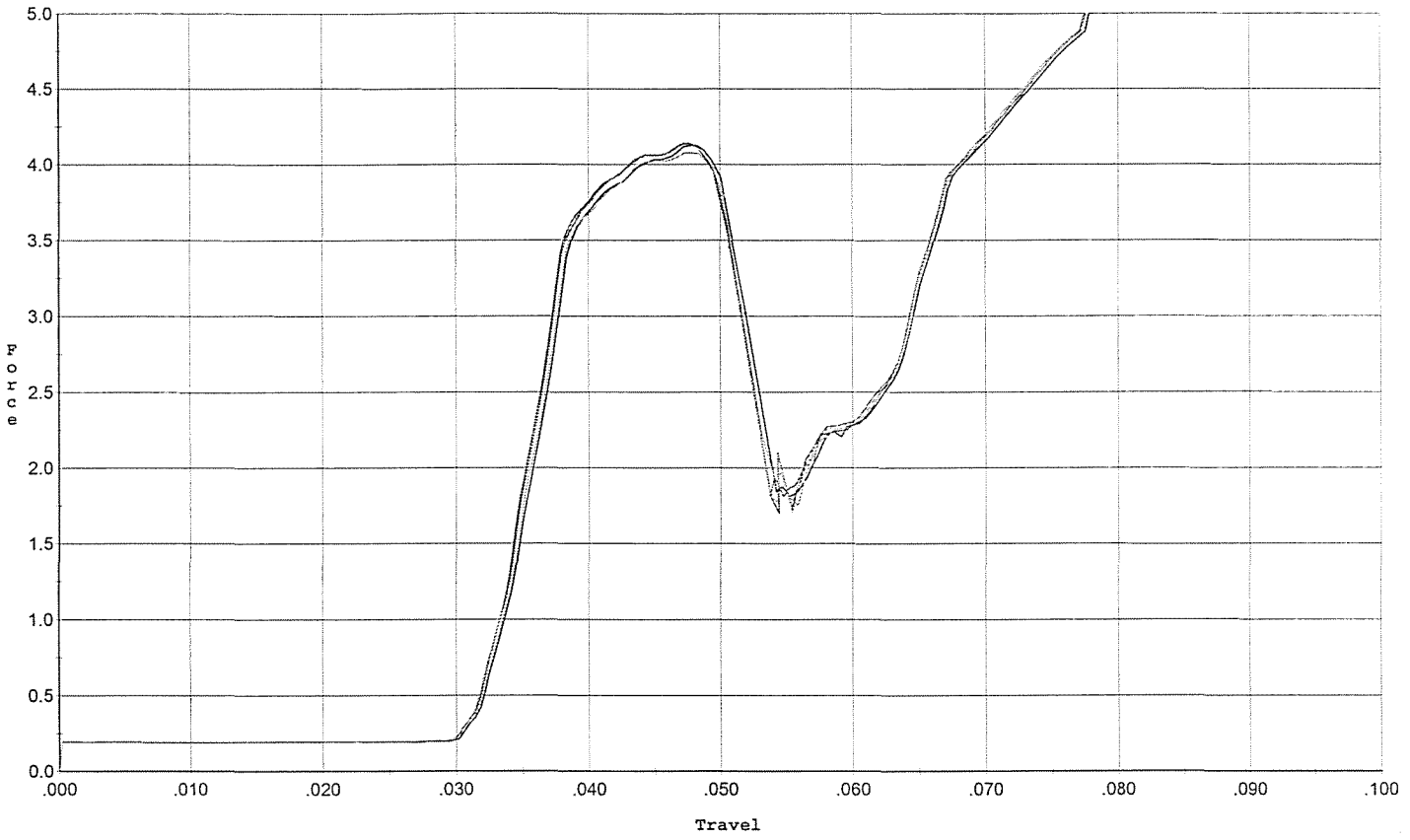
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.028	0.050	0.033	0.033	0.049		Set Trigger
2	3.081	0.050	0.033	0.033	0.050		Set Trigger
3	3.079	0.050	0.033	0.033	0.050		Set Trigger
4	3.074	0.050	0.033	0.033	0.050		Set Trigger
5	3.072	0.050	0.034	0.033	0.050		Set Trigger

Avg 3.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:45:58 PM

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 9/18/07		



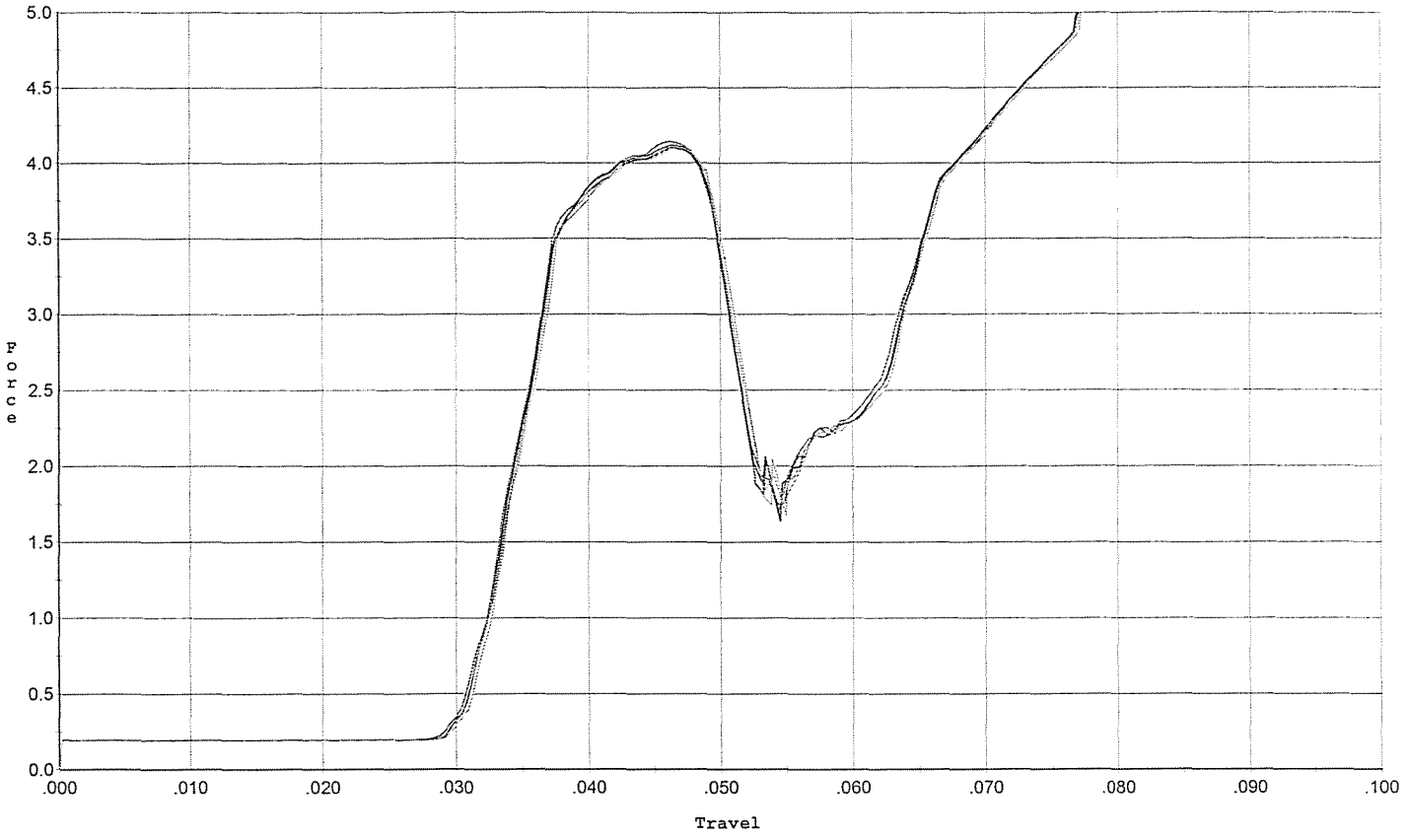
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.141	0.051	0.031	0.031	0.070		Set Trigger
2	4.124	0.052	0.032	0.031	0.071		Set Trigger
3	4.136	0.051	0.031	0.031	0.071		Set Trigger
4	4.077	0.050	0.031	0.031	0.068		Set Trigger
5	4.131	0.050	0.031	0.031	0.070		Set Trigger

AVG 4.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:48:52 PM

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 9/18/07		

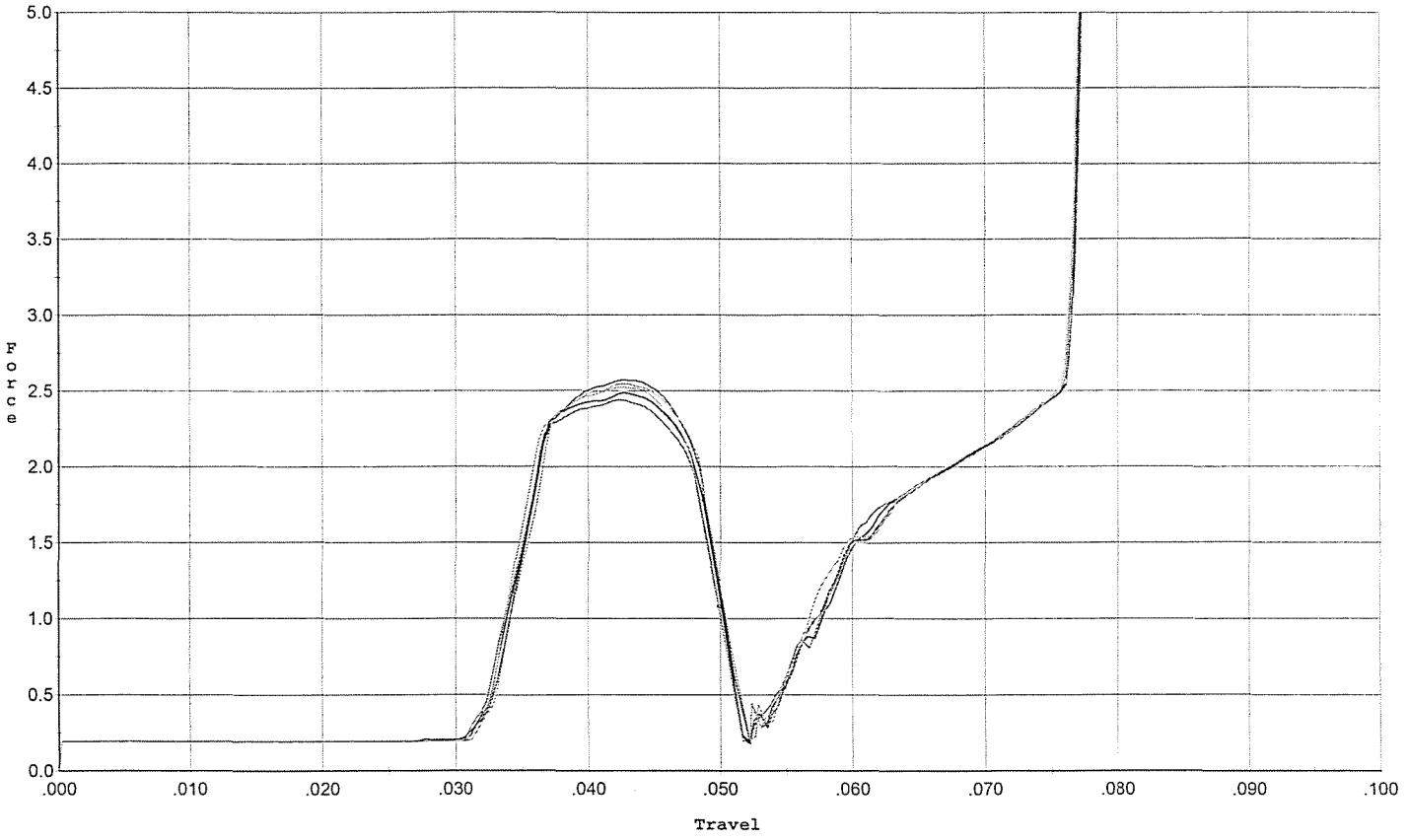


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.049	0.030	0.031	0.069		Set Trigger
2	4.107	0.049	0.031	0.031	0.069		Set Trigger
3	4.144	0.049	0.030	0.031	0.069		Set Trigger
4	4.103	0.050	0.030	0.031	0.070		Set Trigger
5	4.110	0.049	0.030	0.031	0.068		Set Trigger

Avg 4.11

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 9/18/07		



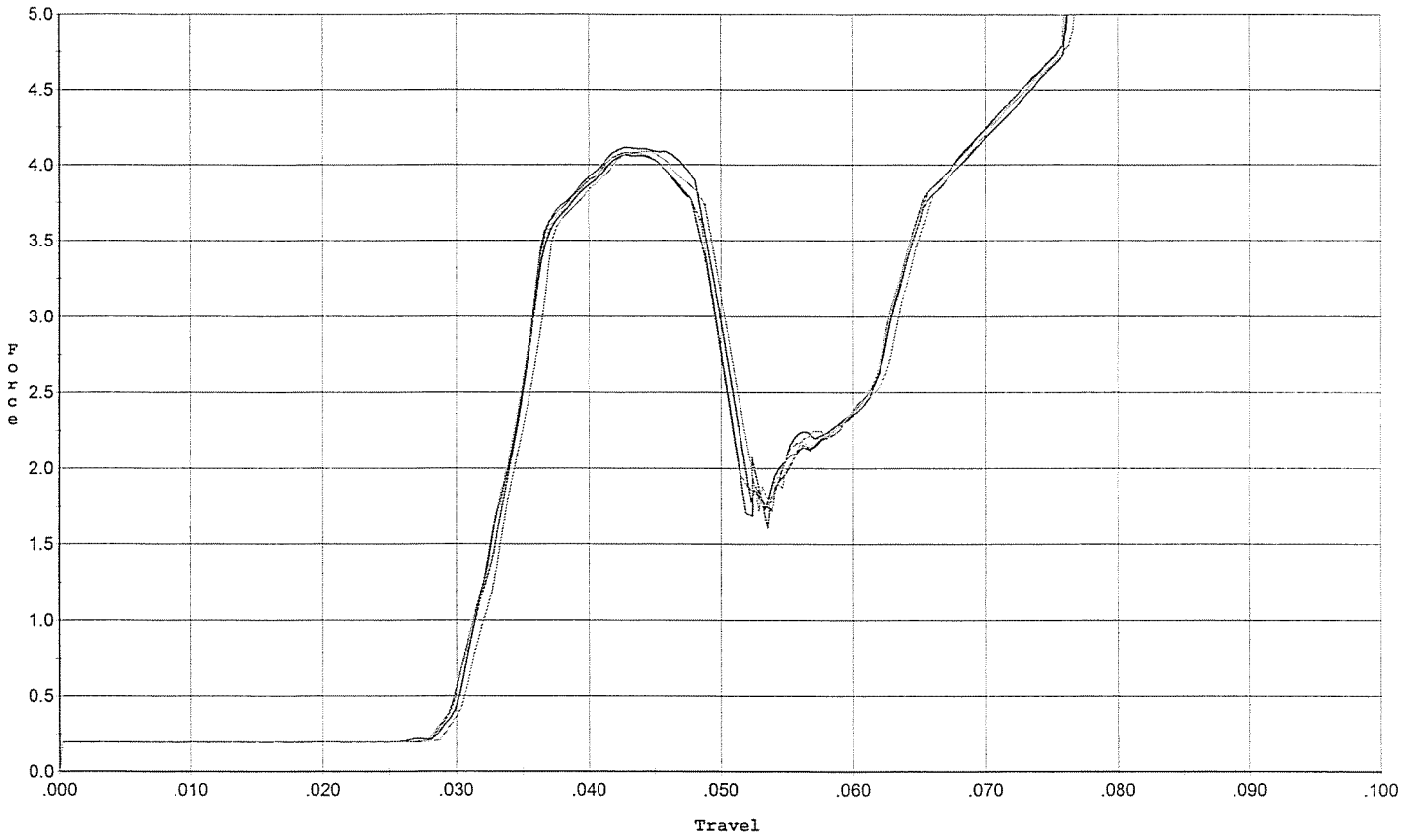
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.048	0.032	0.034	0.041		Set Trigger
2	2.488	0.049	0.032	0.034	0.041		Set Trigger
3	2.442	0.050	0.031	0.034	0.041		Set Trigger
4	2.525	0.050	0.032	0.034	0.042		Set Trigger
5	2.545	0.048	0.032	0.034	0.041		Set Trigger

Avg 2.51

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:51:48 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 9/18/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.050	0.029	0.030	0.071		Set Trigger
2	4.067	0.048	0.029	0.031	0.067		Set Trigger
3	4.084	0.049	0.030	0.030	0.069		Set Trigger
4	4.074	0.048	0.030	0.030	0.068		Set Trigger
5	4.087	0.049	0.030	0.031	0.067		Set Trigger

Avg 4.08

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/18/2007 6:53:40 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6691400.__0
FILE DATE AND TIME: 10/05/2007 10:21

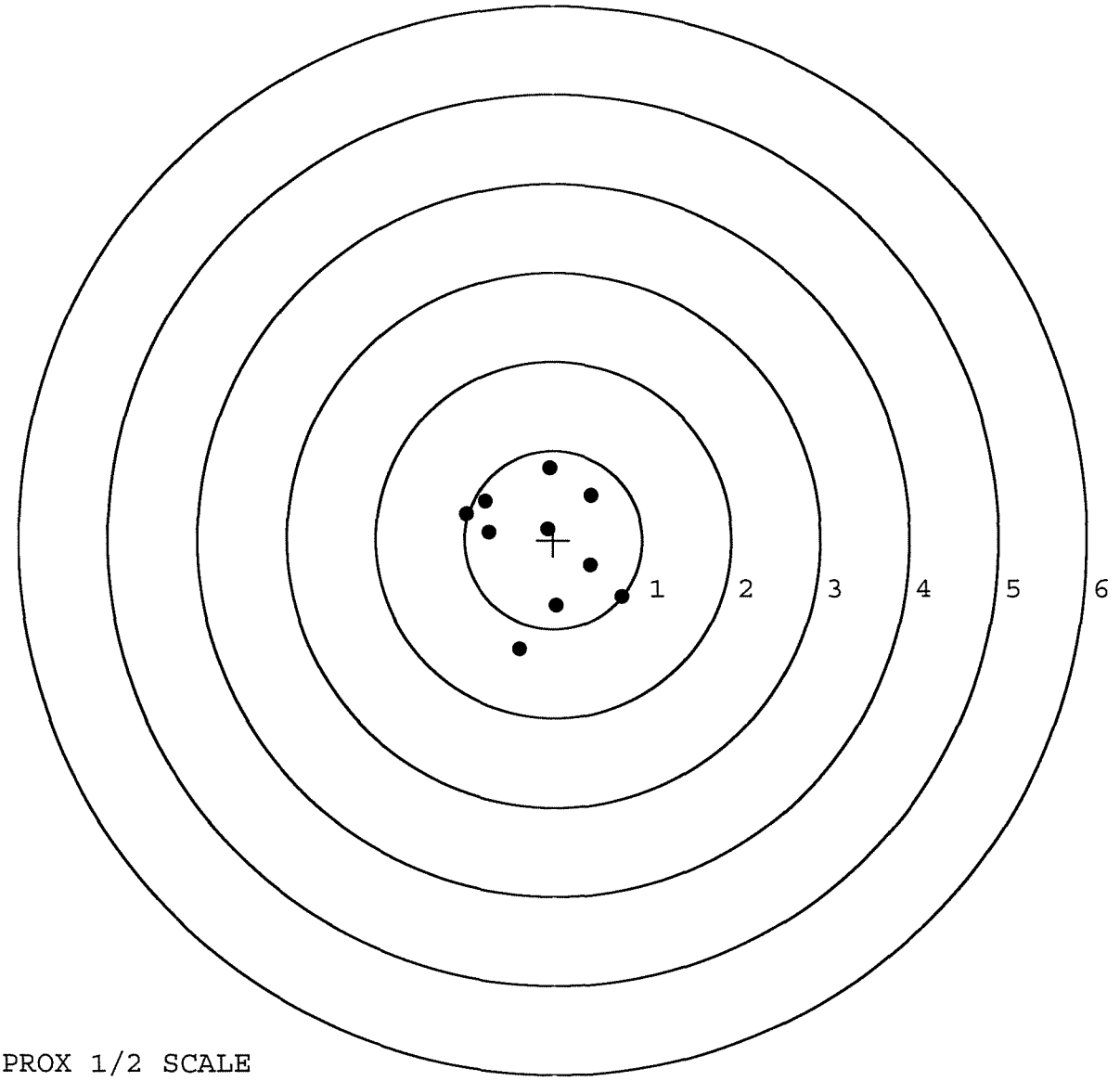
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	-0.052
The Average Point of Impact of the Five Target Set:	0.081
The Average Mean Radius of the Five Target Set:	0.660
The Distance from POA to Centroid Target #1:	0.148
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.053
The Distance from Centroid Target #4 to Centroid Target #1:	0.089
The Distance from Centroid Target #5 to Centroid Target #1:	0.125

SERIAL NUMBER: G6691400.__0
TARGET NUMBER: 1
FILE DATE: 10/05/2007
FILE TIME: 10:21

X CENTROID:	-0.132
Y CENTROID:	-0.067
POA TO CENTROID:	0.148
HORZ SPREAD:	1.753
VERT SPREAD:	2.041
GROUP SPREAD:	2.068
MIN RADIUS:	0.202
MAX RADIUS:	1.197
MEAN RADIUS:	0.777
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.380	-1.238
2:	0.033	-0.744
3:	0.772	-0.645
4:	0.414	-0.285
5:	-0.066	0.124
6:	0.422	0.500
7:	-0.044	0.803
8:	-0.767	0.434
9:	-0.981	0.288
10:	-0.724	0.090

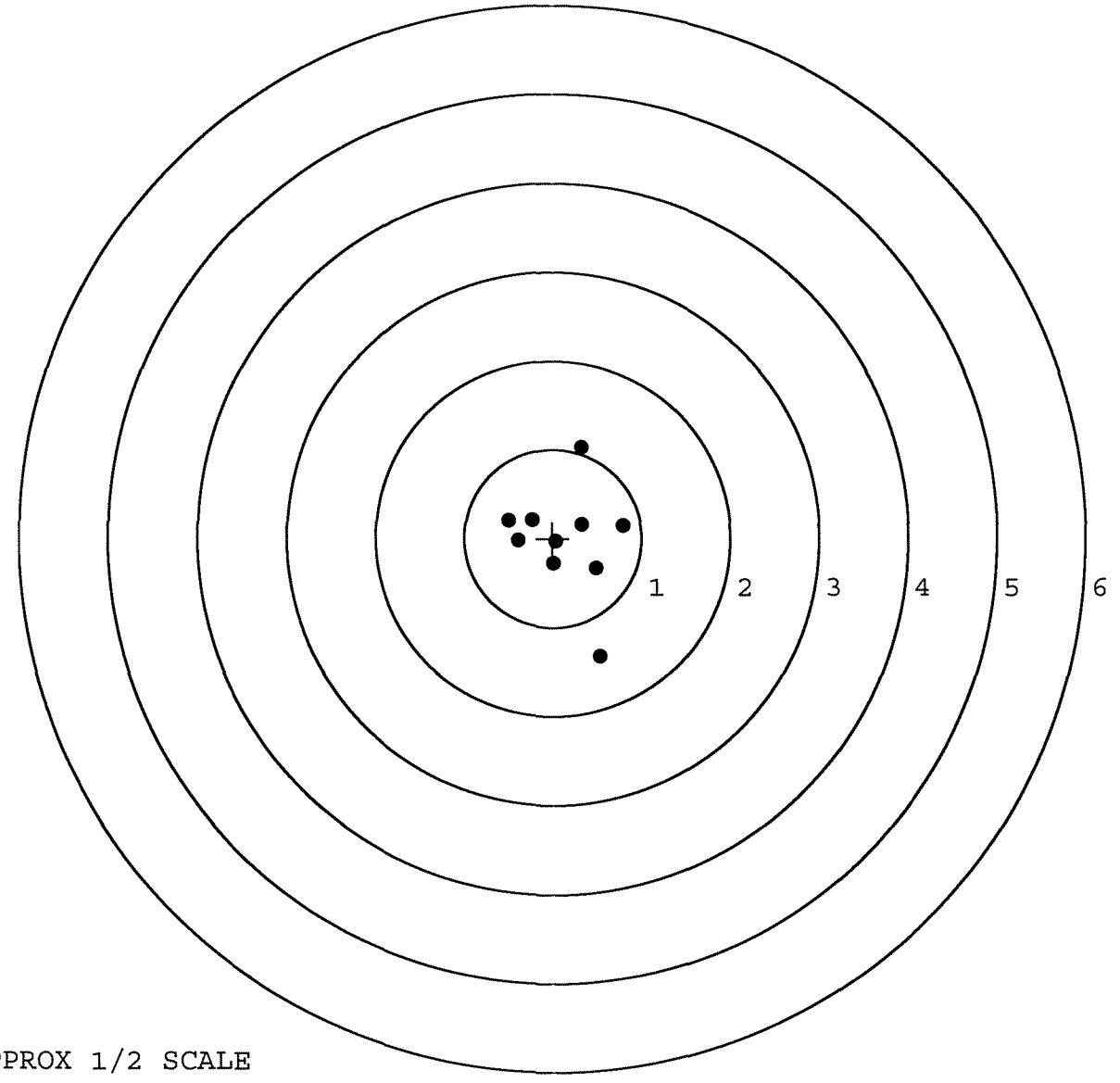


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6691400.__0
TARGET NUMBER: 2
FILE DATE: 10/05/2007
FILE TIME: 10:21

X CENTROID:	0.139
Y CENTROID:	-0.029
POA TO CENTROID:	0.141
HORZ SPREAD:	1.303
VERT SPREAD:	2.349
GROUP SPREAD:	2.358
MIN RADIUS:	0.105
MAX RADIUS:	1.357
MEAN RADIUS:	0.588
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.321	1.021
2:	0.798	0.146
3:	0.531	-1.328
4:	0.492	-0.337
5:	0.333	0.159
6:	0.010	-0.281
7:	0.034	-0.034
8:	-0.390	-0.032
9:	-0.238	0.202
10:	-0.505	0.199

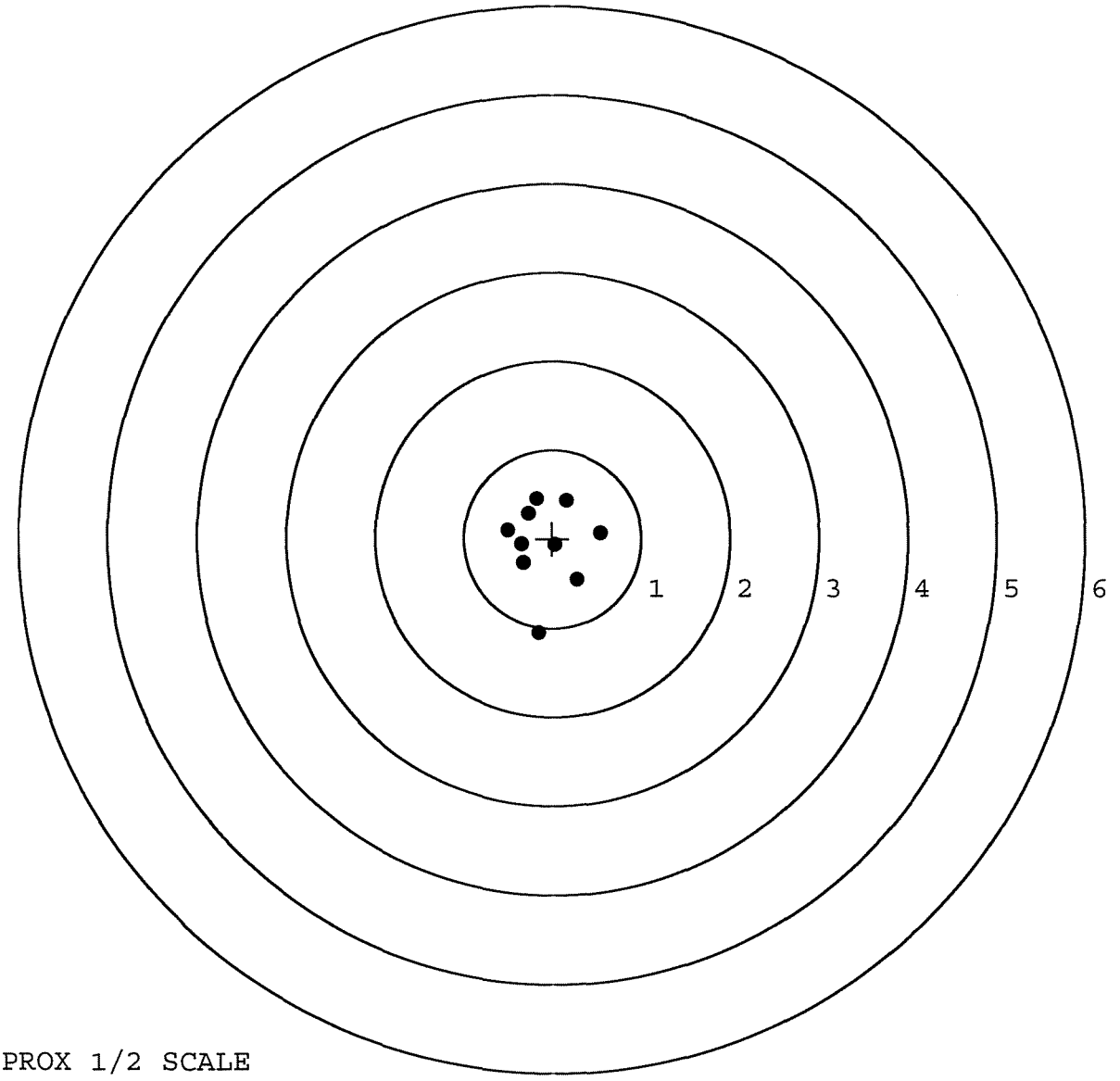


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6691400.__0
TARGET NUMBER: 3
FILE DATE: 10/05/2007
FILE TIME: 10:21

X CENTROID:	-0.080
Y CENTROID:	-0.059
POA TO CENTROID:	0.099
HORZ SPREAD:	1.047
VERT SPREAD:	1.510
GROUP SPREAD:	1.517
MIN RADIUS:	0.107
MAX RADIUS:	1.001
MEAN RADIUS:	0.478
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.158	0.427
2:	-0.185	0.453
3:	-0.274	0.281
4:	-0.505	0.097
5:	-0.349	-0.066
6:	-0.330	-0.268
7:	0.027	-0.069
8:	0.542	0.068
9:	0.275	-0.455
10:	-0.158	-1.057

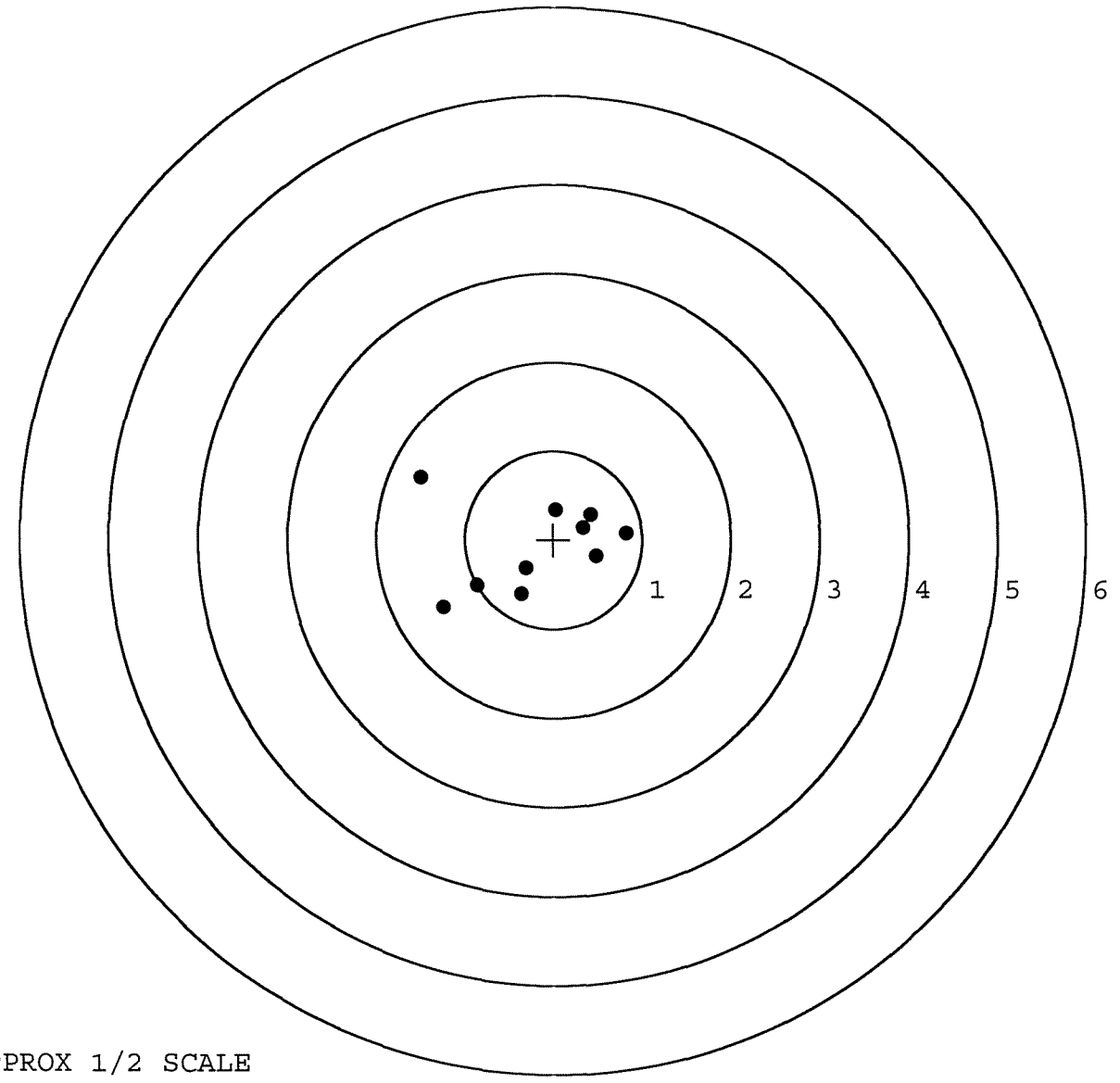


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6691400.__0
TARGET NUMBER: 4
FILE DATE: 10/05/2007
FILE TIME: 10:21

X CENTROID:	-0.220
Y CENTROID:	-0.085
POA TO CENTROID:	0.235
HORZ SPREAD:	2.318
VERT SPREAD:	1.456
GROUP SPREAD:	2.398
MIN RADIUS:	0.257
MAX RADIUS:	1.495
MEAN RADIUS:	0.789
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-1.495	0.695
2:	-1.244	-0.761
3:	-0.864	-0.518
4:	-0.364	-0.607
5:	-0.310	-0.326
6:	0.823	0.079
7:	0.485	-0.180
8:	0.416	0.289
9:	0.333	0.143
10:	0.024	0.337

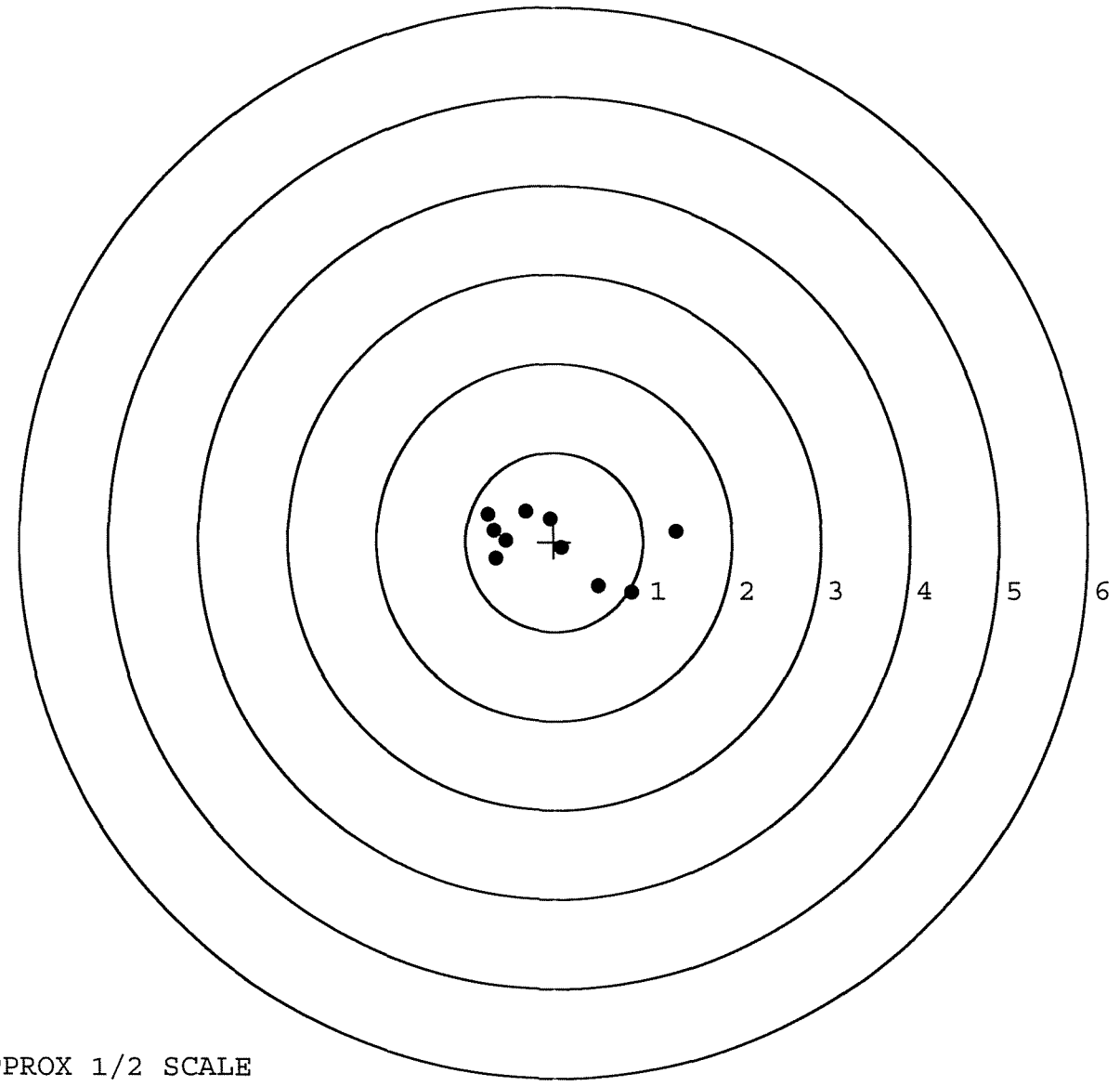


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6691400.__0
TARGET NUMBER: 5
FILE DATE: 10/05/2007
FILE TIME: 10:21

X CENTROID:	-0.017
Y CENTROID:	-0.018
POA TO CENTROID:	0.025
HORZ SPREAD:	2.118
VERT SPREAD:	0.907
GROUP SPREAD:	2.126
MIN RADIUS:	0.112
MAX RADIUS:	1.394
MEAN RADIUS:	0.666
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.370	0.118
2:	0.868	-0.568
3:	0.499	-0.499
4:	0.083	-0.068
5:	-0.042	0.255
6:	-0.325	0.339
7:	-0.748	0.306
8:	-0.675	0.124
9:	-0.543	0.008
10:	-0.657	-0.196



TARGET APPROX 1/2 SCALE