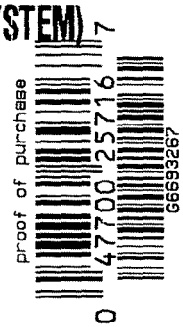
G669267

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

**BOLT ACTION CENTERFIRE RIFLE**
**24" BARREL 7.62 NATO**

– INSTUCTION BOOK 3518

BM FORM

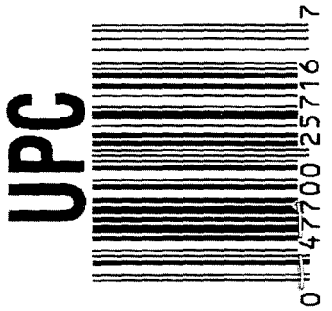




ORDER NO. **25716**

| | |
|---|---|
| BARREL LENGTH | 24" |
| CAPACITY | 6 |

**G6693267**



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 # G6693267

| OP # | OPERATION NAME | READINGS | DATE | INITIAL |
|---|---|---|---|---|
| 410 | SERIALIZE BOLT HANDLE | | 12-6-07 | RTZ |
| 420 | ASSEMBLE ACTION | | 12-6-07 | RTZ |
| 430 | ASSEMBLE TO STOCK | | 12-7-07 | TRW |
| 440 | PROOF | | 12-7-07 | TRW |
| 460 | CHECK HEADSPACE | | 12-7-07 | TRW |
| 470 | DIS-ASSEMBLE ACTION | | 12-7-07 | RTZ |
| 480 | MAGNAFLUX BBL ACTION | | 12-10-07 | JB |
| 490 | MAGNAFLUX BOLT | | | |
| 500 | ROLLMARK CALIBER | | 12-7-07 | CW |
| 510 | DRILL AND TAP SIGHT HOLES | | 12-7-07 | FM |
| 520 | GOFF BLAST BBL / REC | | 12-11-07 | JY |
| 530 & 540 | APPLY COATINGS (BARREL ACTION) | | | |
| | (BOLT) | | 12/11/07 | |
| 560 | RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY | | 12-18-07 | DA |
| | B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD | | 12-18-07 | DA |
| | C) INSPECT EJECTOR HOLE FOR CHAMFER | | 12-18-07 | DA |
| | D) OIL FIRING PIN ASSEMBLY | | 12-19-07 | RTZ |
| | E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS | | 1/8/08 | |

MAGNA - FLUX 2008 OPERATOR JL

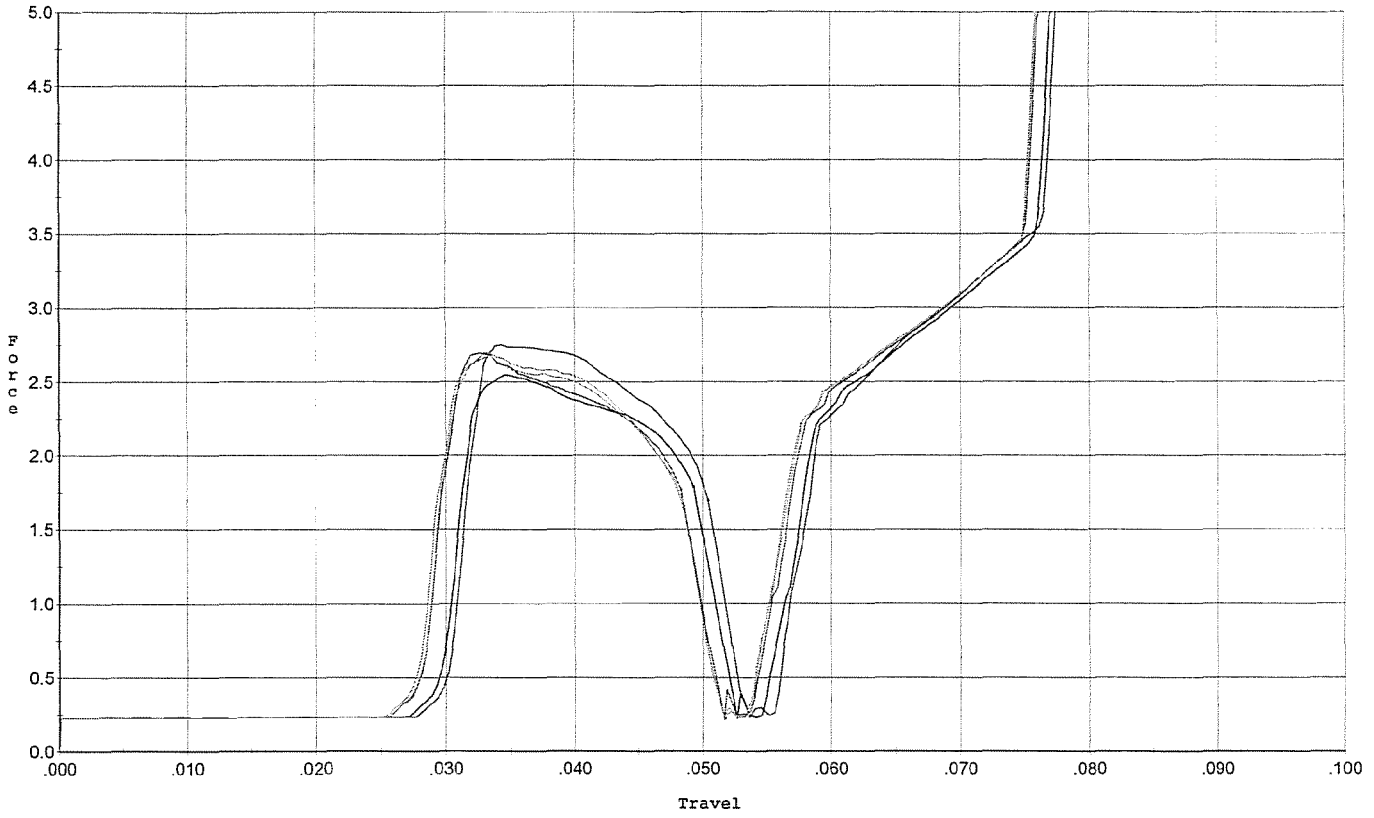
F004 REV 5/2006

| OP # | OPERATION NAME | READINGS | DATE | INITIAL |
|---|---|---|---|---|
| 560 | F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX) | 6.5 6.5 6.0 | 1/4/08 | |
| CONT. | G) SAFETY OFF FORCE (2 LBS MIN) | 4.25 4.0 3.5 | 1/4/08 | |
| | H) TRIGGER PULL TEST AND RETAINABILITY | | 1/8/08 | |
| | I) FIRING PIN INDENT (.020 MIN) | .022 .023 .022 | 1/4/08 | |
| | J) ASSEMBLE STOCK | | 12-19-07 | RTZ |
| | K) ASSEMBLE SWIVEL STUDS | | 1/8/08 | |
| | L) ATTACH FRONT AND REAR SIGHT ASSY'S | | 1/8/08 | |
| | M) IRON SIGHT ALIGNMENT | | 1/8/08 | |
| | N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER | | 1/8/08 | |
| 640 & 650 | FUNCTION TEST AND TARGET | PASS FAIL / PASS FAIL | 2 1/8/08 | |
| | MALFUNCTION | CORRECTION | | |
| | MALFUNCTION | CORRECTION N/A | | |
| | MALFUNCTION | CORRECTION | | |
| | MALFUNCTION | CORRECTION | | |
| 660 | INSPECT FOR LIVE AMMO | | 1-2-08 | |
| 670 | FINAL INSPECTION A) HEADSPACE | | 1/8/08 | |
| | B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS) | 2.38 2.37 2.41 2.42 2.41 | 1/4/08 | |
| | C) FUNCTION | | 1/8/08 | |
| 690 | PACK | | 1-9-08 | |

F004 REV 5/2006

## 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:** | 12/18/07 M. Mckinney | | |



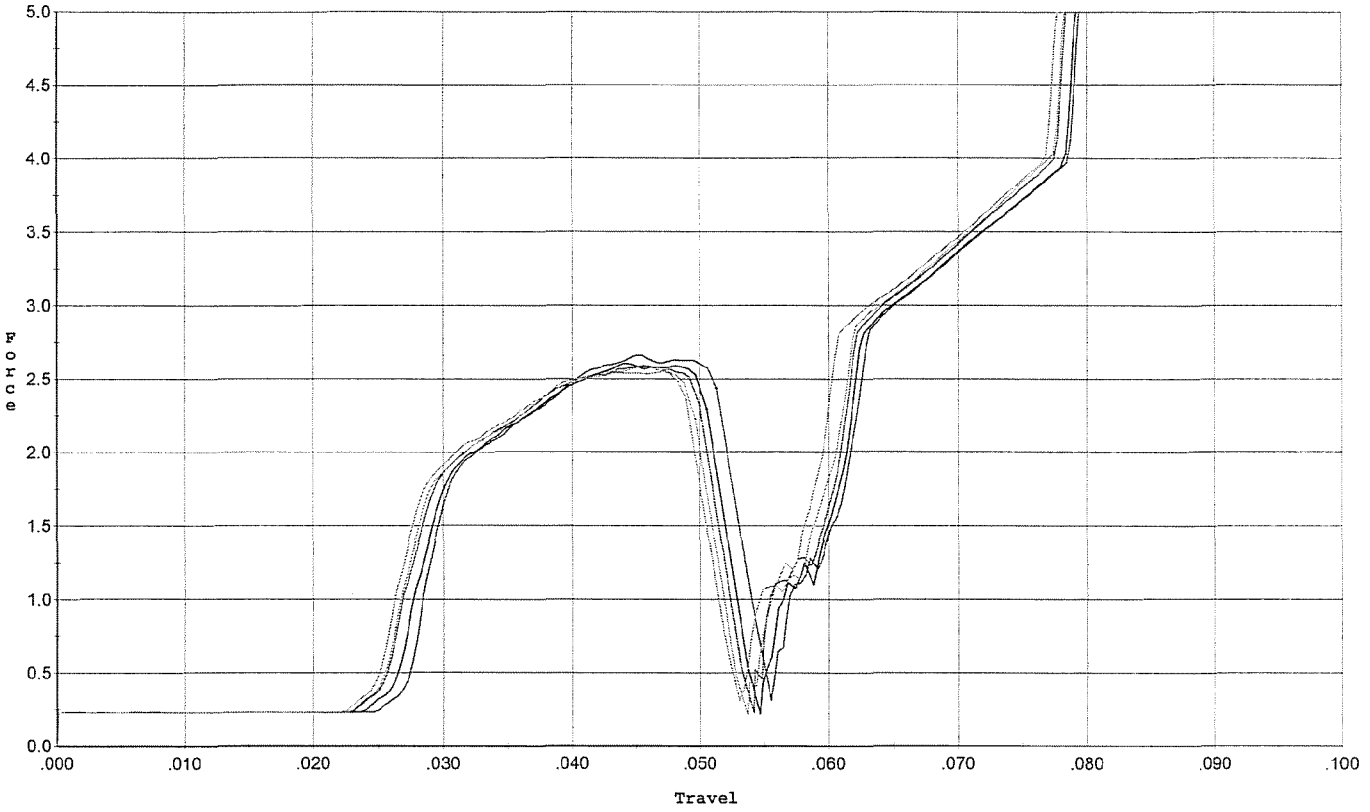

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.753 | 0.050 | 0.030 | 0.032 | 0.055 | | Set Trigger |
| 2 | 2.547 | 0.049 | 0.029 | 0.032 | 0.051 | | Set Trigger |
| 3 | 2.690 | 0.048 | 0.028 | 0.031 | 0.052 | | Set Trigger |
| 4 | 2.693 | 0.048 | 0.028 | 0.031 | 0.053 | | Set Trigger |
| 5 | 2.677 | 0.048 | 0.027 | 0.031 | 0.053 | | Set Trigger |

2.67 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:10:19 PM

# 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:** | 12/18/07 M. Mckinney | | |



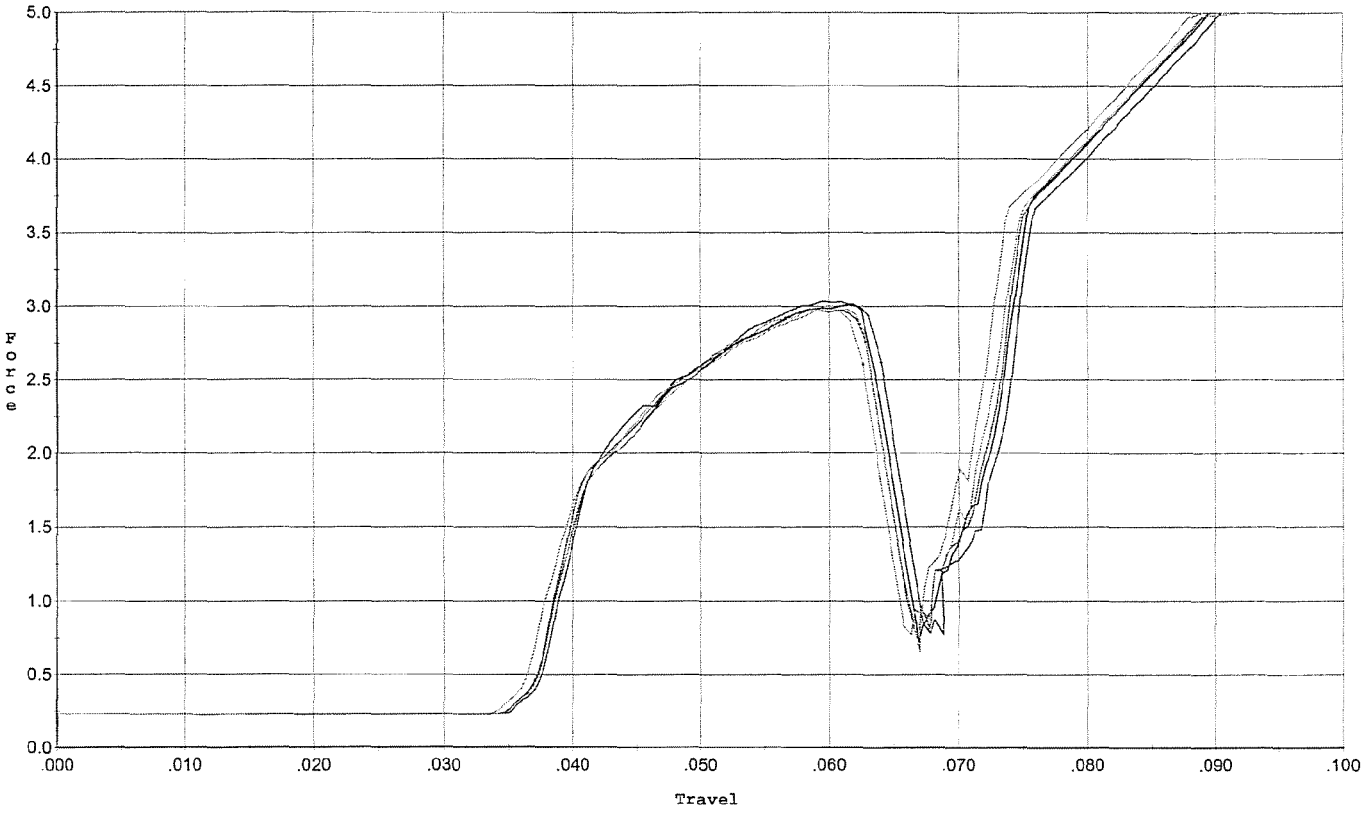

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.658 | 0.051 | 0.027 | 0.032 | 0.061 | | Set Trigger |
| 2 | 2.604 | 0.051 | 0.026 | 0.032 | 0.059 | | Set Trigger |
| 3 | 2.589 | 0.050 | 0.025 | 0.032 | 0.059 | | Set Trigger |
| 4 | 2.547 | 0.050 | 0.025 | 0.032 | 0.058 | | Set Trigger |
| 5 | 2.579 | 0.049 | 0.025 | 0.032 | 0.058 | | Set Trigger |

2.60 Avg

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:11:57 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:** | 12/18/07 M. Mckinney | | |



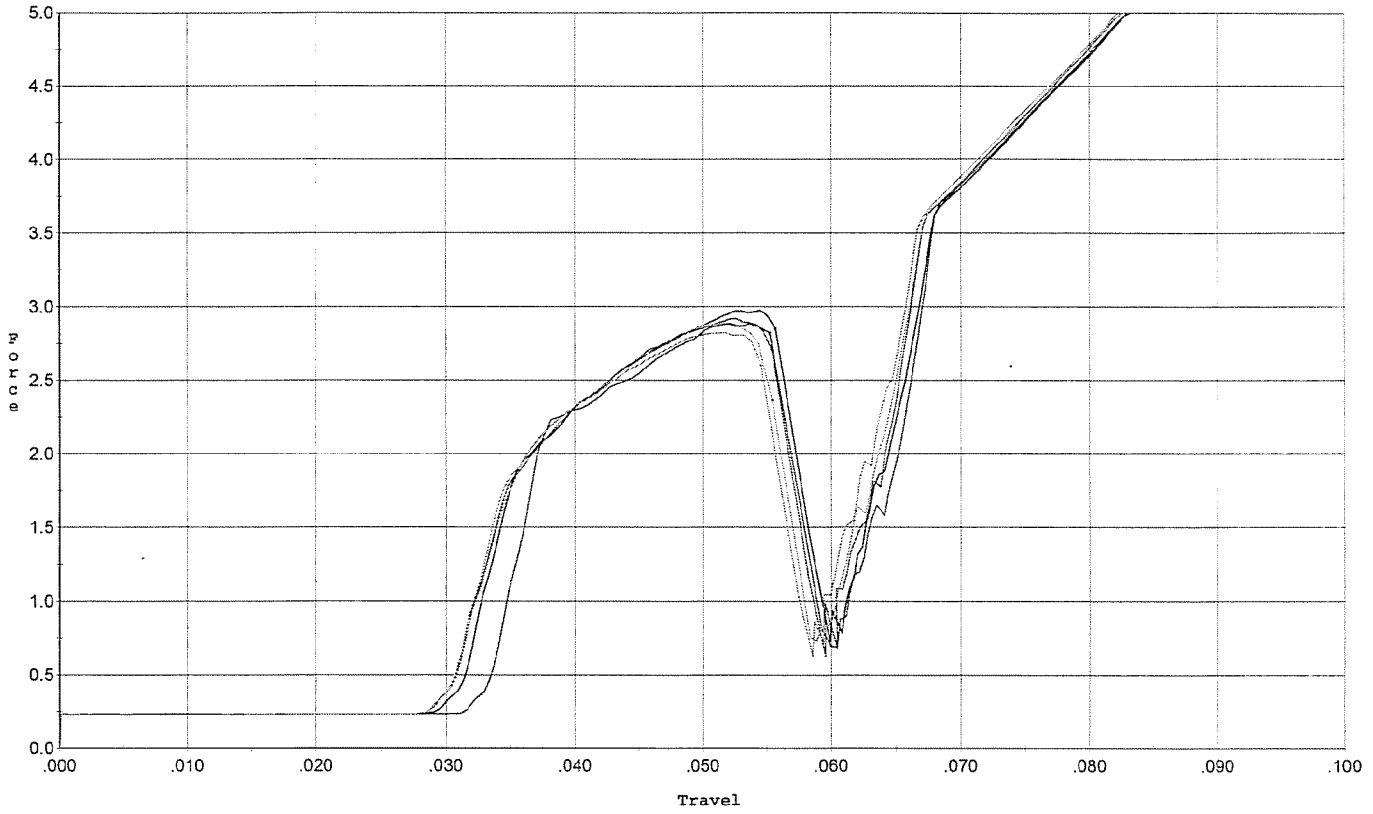

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 3.032 | 0.064 | 0.037 | 0.033 | 0.075 | | Set Trigger |
| 2 | 3.016 | 0.064 | 0.037 | 0.033 | 0.073 | | Set Trigger |
| 3 | 2.981 | 0.063 | 0.037 | 0.033 | 0.072 | | Set Trigger |
| 4 | 2.980 | 0.063 | 0.037 | 0.033 | 0.071 | | Set Trigger |
| 5 | 2.980 | 0.063 | 0.036 | 0.032 | 0.072 | | Set Trigger |

3.00

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:13:12 PM

# Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 After 20 cycles +/- .75 lbs. |
| **Make:** | Remington | **Trigger:** | 3.0 lbs. ~~ini. +/- .75 lbs~~. |
| **Note:** | 12/18/07 M. Mckinney | | |



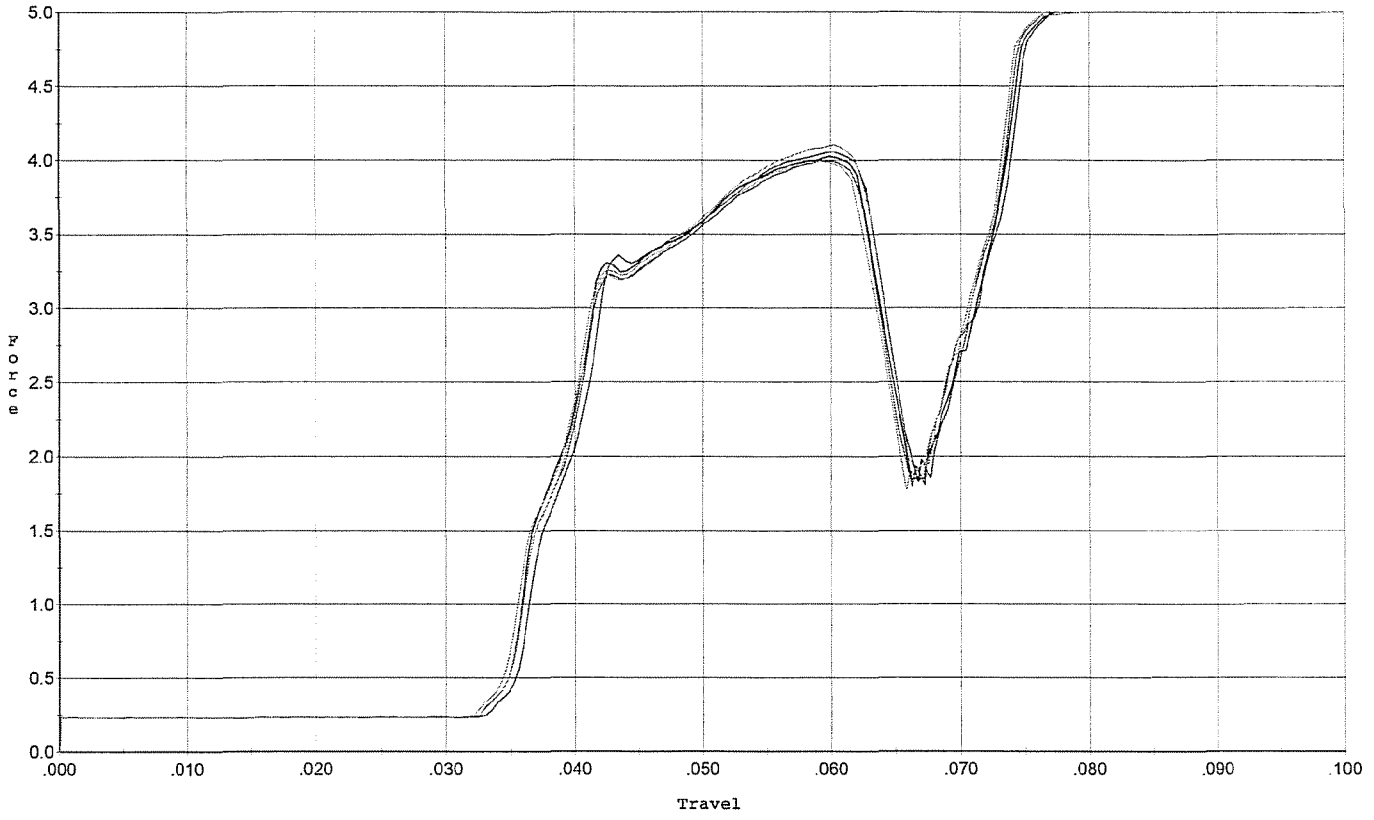

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.882 | 0.055 | 0.033 | 0.033 | 0.061 | | Set Trigger |
| 2 | 2.975 | 0.056 | 0.031 | 0.032 | 0.067 | | Set Trigger |
| 3 | 2.920 | 0.055 | 0.031 | 0.032 | 0.066 | | Set Trigger |
| 4 | 2.892 | 0.055 | 0.030 | 0.032 | 0.065 | | Set Trigger |
| 5 | 2.825 | 0.055 | 0.029 | 0.032 | 0.063 | | Set Trigger |

2.90 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:14:06 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:** | 12/18/07 M. Mckinney | | |



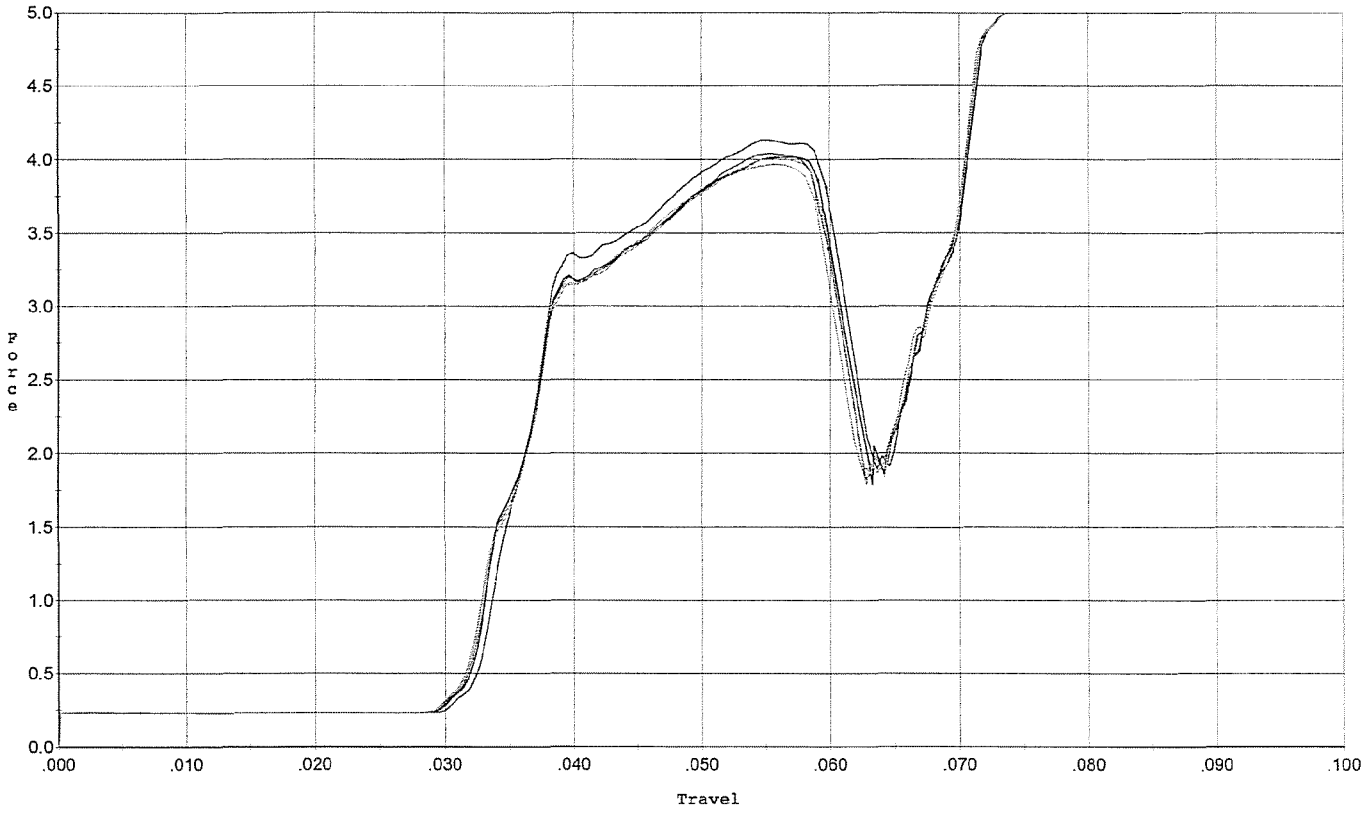

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 4.056 | 0.063 | 0.035 | 0.029 | 0.099 | | Set Trigger |
| 2 | 4.026 | 0.062 | 0.035 | 0.029 | 0.099 | | Set Trigger |
| 3 | 3.996 | 0.062 | 0.035 | 0.029 | 0.098 | | Set Trigger |
| 4 | 3.993 | 0.063 | 0.035 | 0.028 | 0.100 | | Set Trigger |
| 5 | 4.103 | 0.063 | 0.034 | 0.028 | 0.102 | | Set Trigger |

4.04 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:30:36 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:** | 12/18/07 M. Mckinney | | |



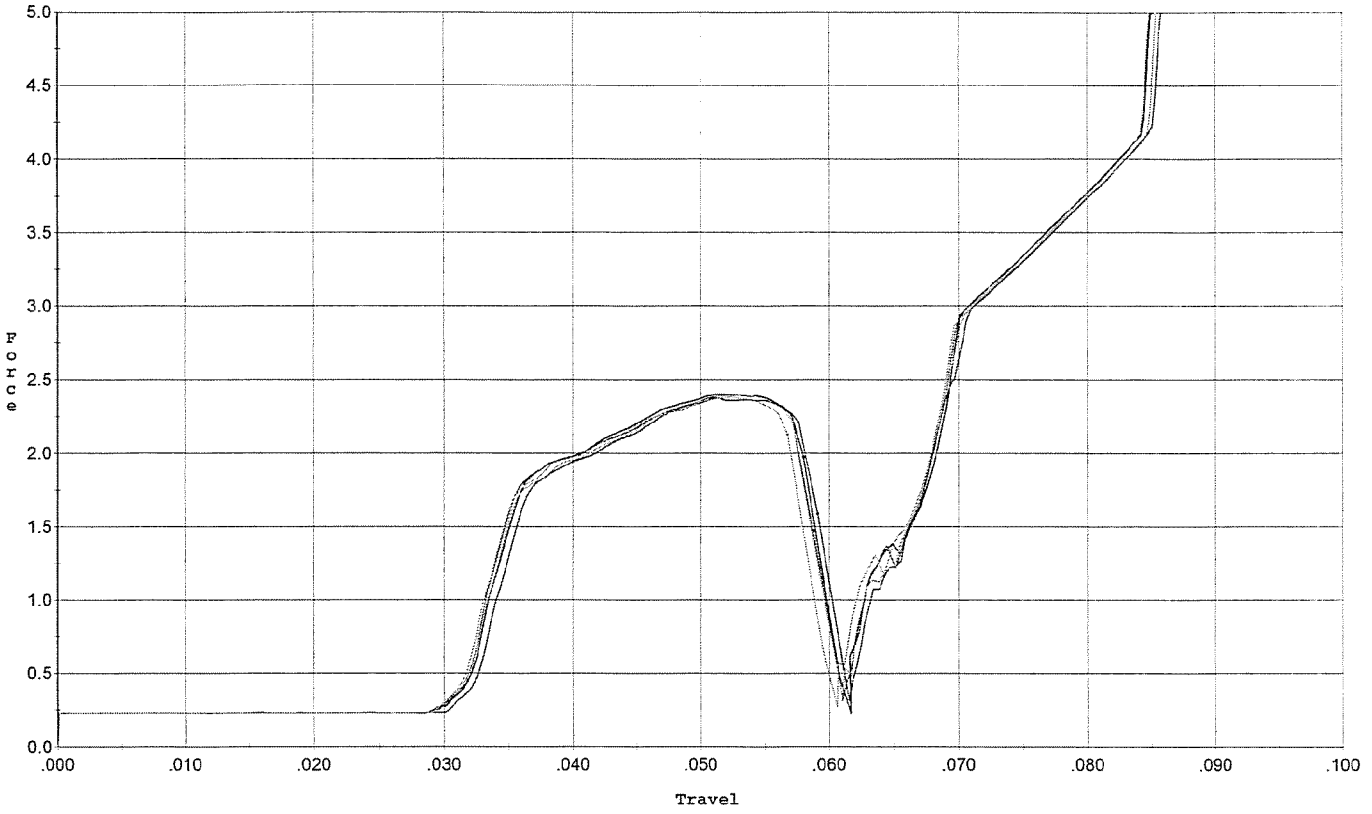

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 4.133 | 0.060 | 0.032 | 0.028 | 0.101 | | Set Trigger |
| 2 | 4.017 | 0.059 | 0.032 | 0.029 | 0.097 | | Set Trigger |
| 3 | 4.042 | 0.060 | 0.032 | 0.029 | 0.098 | | Set Trigger |
| 4 | 3.967 | 0.059 | 0.031 | 0.029 | 0.095 | | Set Trigger |
| 5 | 4.022 | 0.059 | 0.031 | 0.029 | 0.097 | | Set Trigger |

4.04 Avg

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:31:35 PM

# 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:** | 12/18/07 M. Mckinney | | |



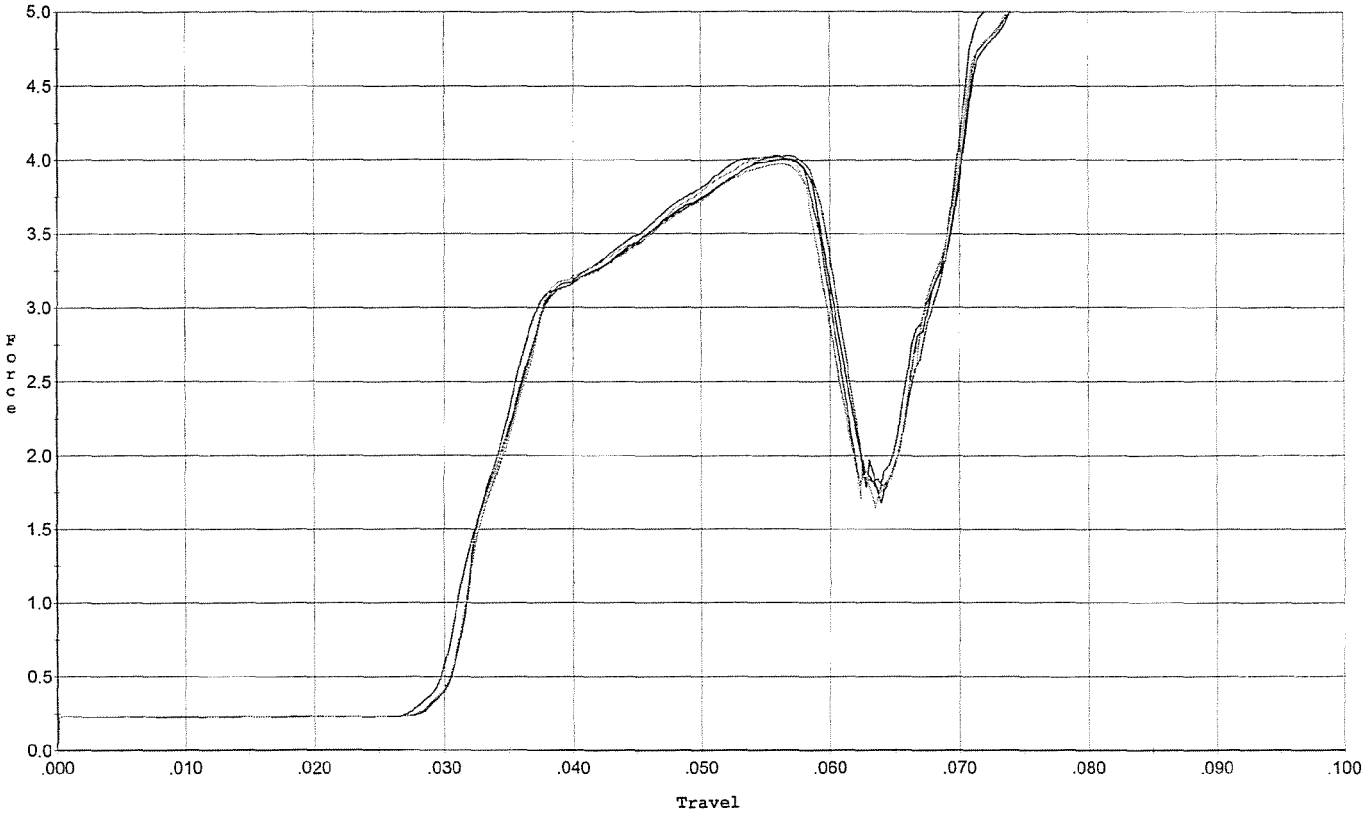

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.377 | 0.059 | 0.032 | 0.033 | 0.061 | | Set Trigger |
| 2 | 2.403 | 0.058 | 0.032 | 0.033 | 0.061 | | Set Trigger |
| 3 | 2.398 | 0.059 | 0.032 | 0.033 | 0.062 | | Set Trigger |
| 4 | 2.388 | 0.057 | 0.031 | 0.033 | 0.059 | | Set Trigger |
| 5 | 2.395 | 0.057 | 0.032 | 0.033 | 0.059 | | Set Trigger |

2.39 AVG.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/18/2007 1:32:46 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:** | 12/18/07 M. Mckinney | | |




| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 4.025 | 0.059 | 0.029 | 0.024 | 0.101 | | Set Trigger |
| 2 | 4.007 | 0.059 | 0.030 | 0.026 | 0.099 | | Set Trigger |
| 3 | 4.029 | 0.059 | 0.030 | 0.025 | 0.101 | | Set Trigger |
| 4 | 4.036 | 0.058 | 0.030 | 0.027 | 0.097 | | Set Trigger |
| 5 | 3.972 | 0.058 | 0.030 | 0.027 | 0.096 | | Set Trigger |

4.01 Avg.

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693267.__0
FILE DATE AND TIME: 01/02/2008 22:59

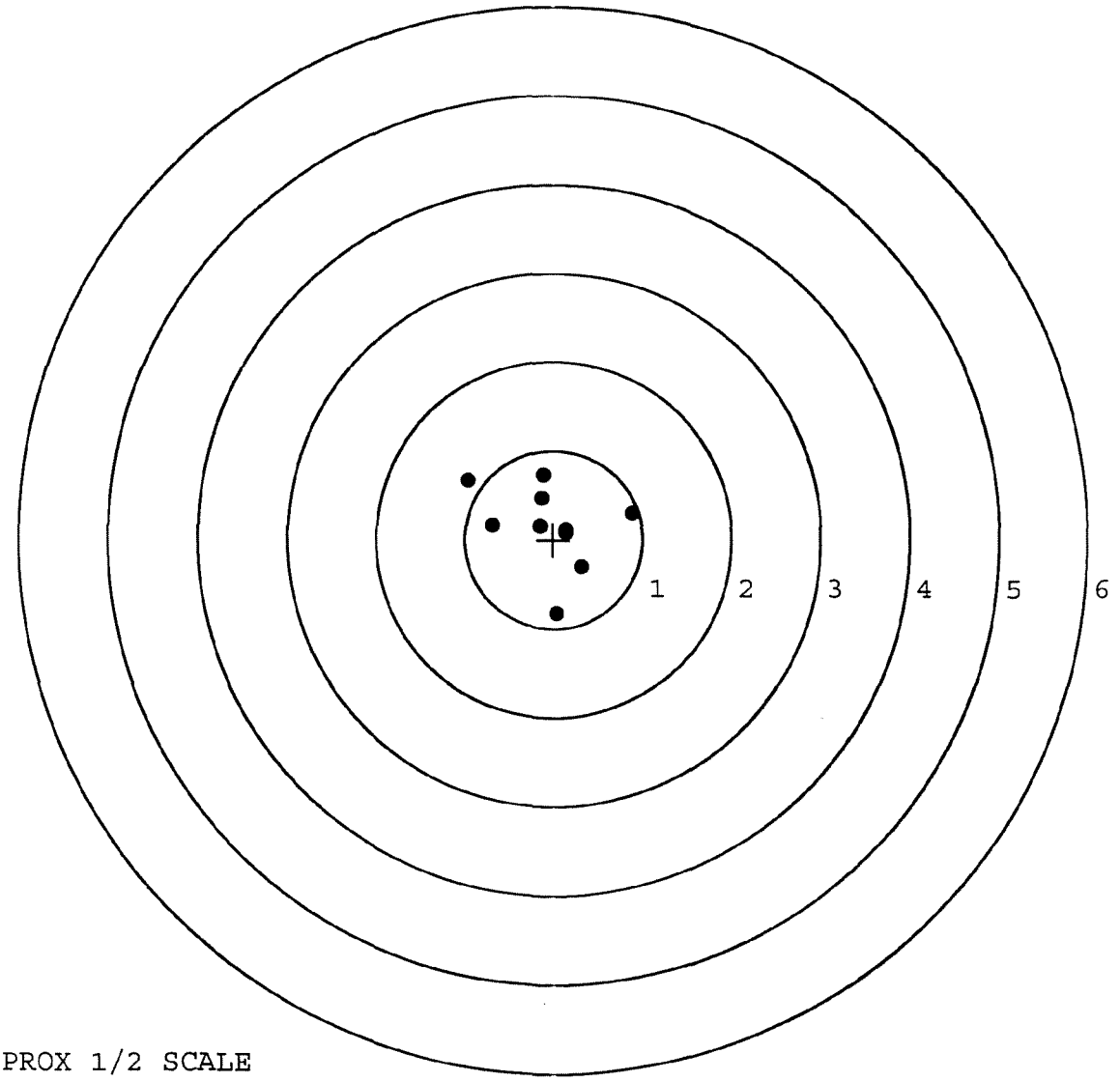
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

| | |
|---|---|
| The Average X Centroid of the Five Target Set: | 0.057 |
| The Average Y Centroid of the Five Target Set: | -0.019 |
| The Average Point of Impact of the Five Target Set: | 0.060 |
| The Average Mean Radius of the Five Target Set: | 0.640 |
| The Distance from POA to Centroid Target #1: | 0.159 |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.142 |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.381 |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.214 |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.412 |

SERIAL NUMBER: G6693267.__0
TARGET NUMBER: 1
FILE DATE: 01/02/2008
FILE TIME: 22:59

| | |
|---|---|
| X CENTROID: | -0.053 |
| Y CENTROID: | 0.150 |
| POA TO CENTROID: | 0.159 |
| HORZ SPREAD: | 1.847 |
| VERT SPREAD: | 1.560 |
| GROUP SPREAD: | 1.883 |
| MIN RADIUS: | 0.103 |
| MAX RADIUS: | 1.041 |
| MEAN RADIUS: | 0.562 |
| # IN 1 IN DIAMETER: | 4 |
| # IN 2 IN DIAMETER: | 9 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -0.961 | 0.660 |
| 2: | -0.687 | 0.157 |
| 3: | -0.119 | 0.725 |
| 4: | -0.135 | 0.466 |
| 5: | 0.141 | 0.077 |
| 6: | -0.156 | 0.153 |
| 7: | 0.314 | -0.310 |
| 8: | 0.886 | 0.293 |
| 9: | 0.038 | -0.835 |
| 10: | 0.146 | 0.110 |

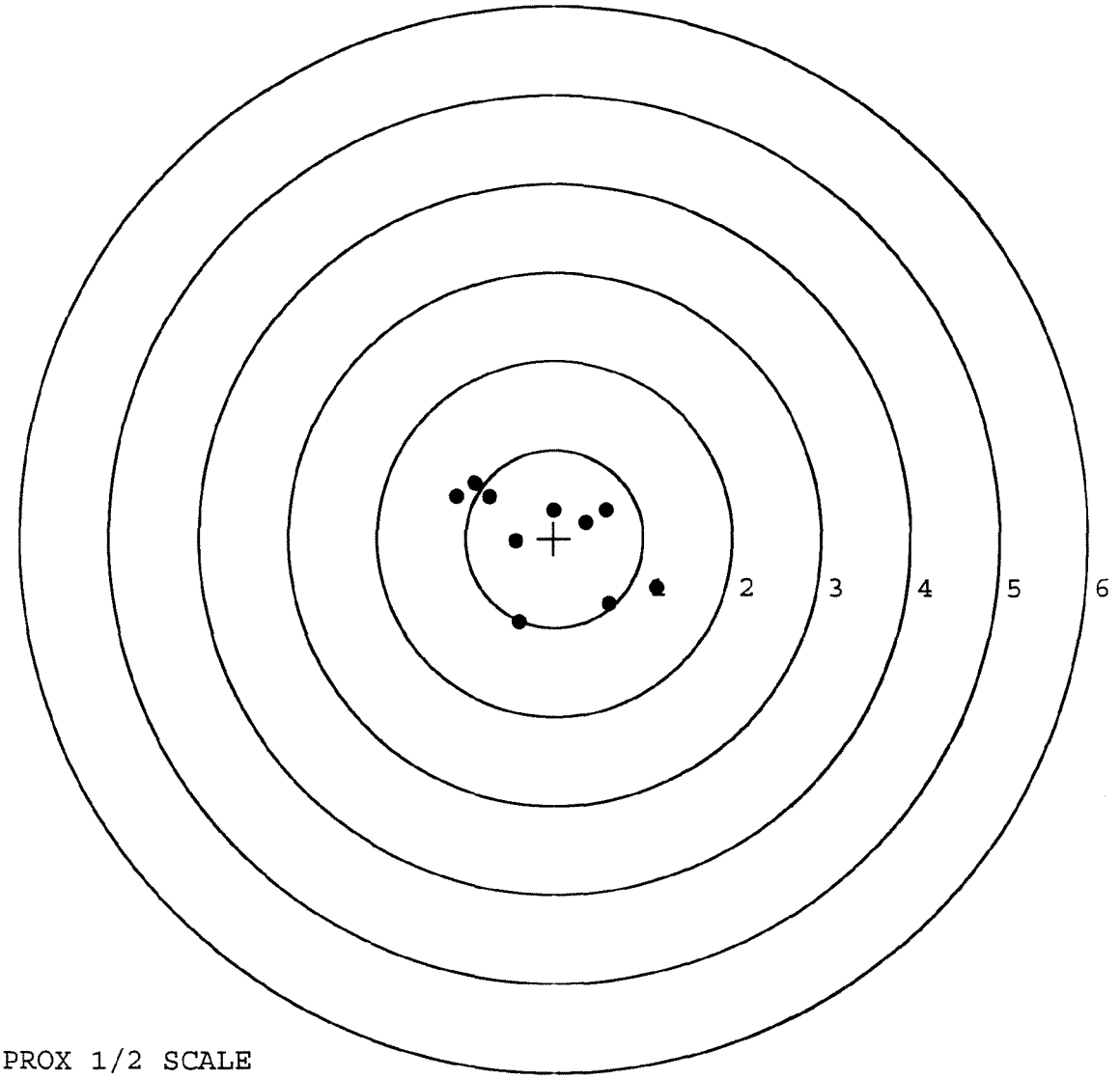



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693267.__0
TARGET NUMBER: 2
FILE DATE: 01/02/2008
FILE TIME: 22:59

| | |
|---|---|
| X CENTROID: | -0.085 |
| Y CENTROID: | 0.011 |
| POA TO CENTROID: | 0.086 |
| HORZ SPREAD: | 2.255 |
| VERT SPREAD: | 1.572 |
| GROUP SPREAD: | 2.479 |
| MIN RADIUS: | 0.314 |
| MAX RADIUS: | 1.361 |
| MEAN RADIUS: | 0.819 |
| # IN 1 IN DIAMETER: | 3 |
| # IN 2 IN DIAMETER: | 5 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -0.398 | -0.946 |
| 2: | 0.618 | -0.736 |
| 3: | 1.149 | -0.563 |
| 4: | 0.584 | 0.322 |
| 5: | 0.359 | 0.182 |
| 6: | -0.010 | 0.316 |
| 7: | -0.429 | -0.029 |
| 8: | -0.727 | 0.472 |
| 9: | -0.894 | 0.626 |
| 10: | -1.106 | 0.467 |

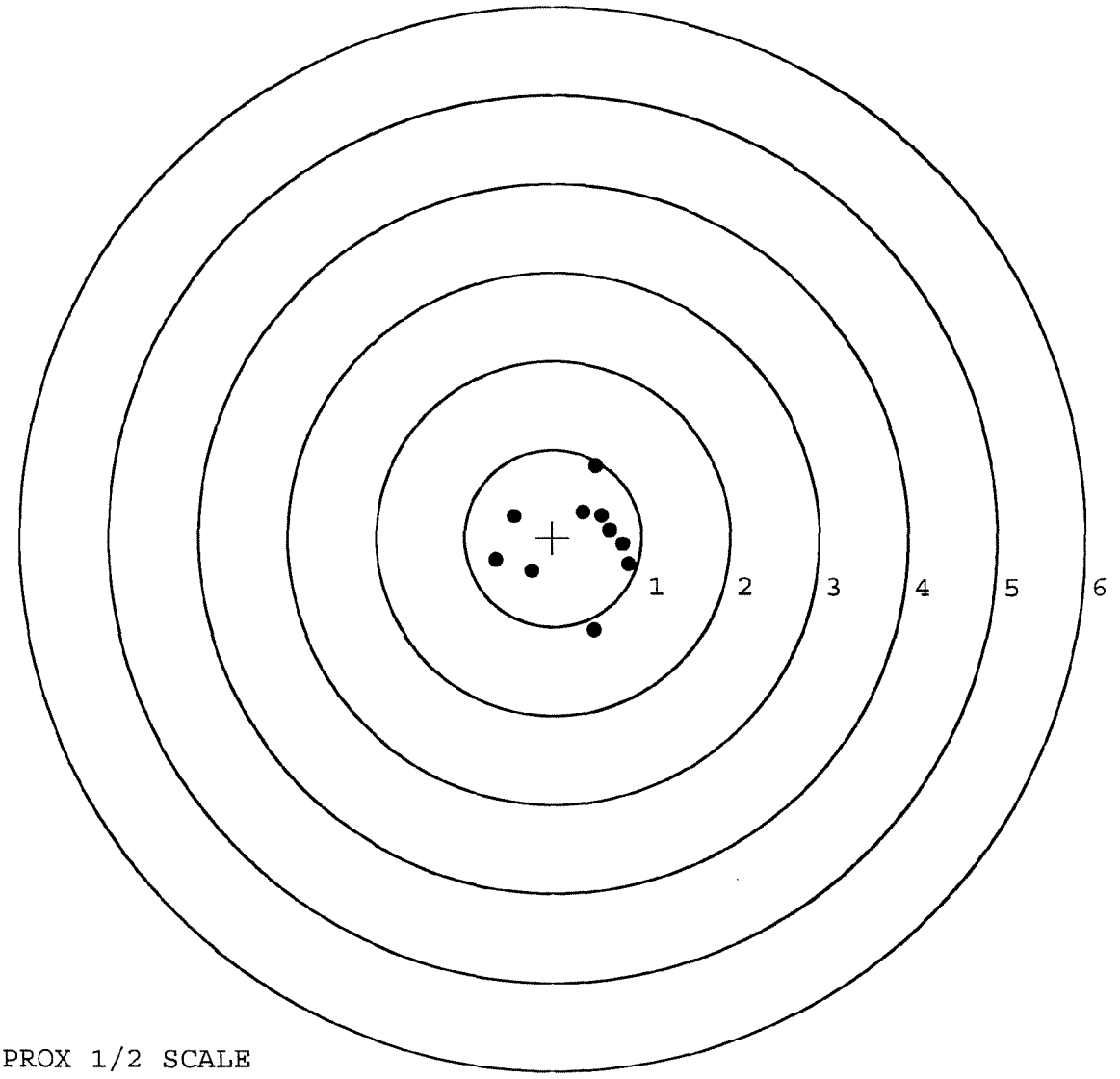



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693267.__0
TARGET NUMBER: 3
FILE DATE: 01/02/2008
FILE TIME: 22:59

| | |
|---|---|
| X CENTROID: | 0.279 |
| Y CENTROID: | -0.036 |
| POA TO CENTROID: | 0.282 |
| HORZ SPREAD: | 1.501 |
| VERT SPREAD: | 1.861 |
| GROUP SPREAD: | 1.861 |
| MIN RADIUS: | 0.331 |
| MAX RADIUS: | 1.024 |
| MEAN RADIUS: | 0.650 |
| # IN 1 IN DIAMETER: | 3 |
| # IN 2 IN DIAMETER: | 9 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -0.441 | 0.244 |
| 2: | -0.645 | -0.255 |
| 3: | -0.235 | -0.380 |
| 4: | 0.485 | 0.818 |
| 5: | 0.334 | 0.290 |
| 6: | 0.548 | 0.255 |
| 7: | 0.634 | 0.092 |
| 8: | 0.792 | -0.076 |
| 9: | 0.856 | -0.306 |
| 10: | 0.465 | -1.043 |

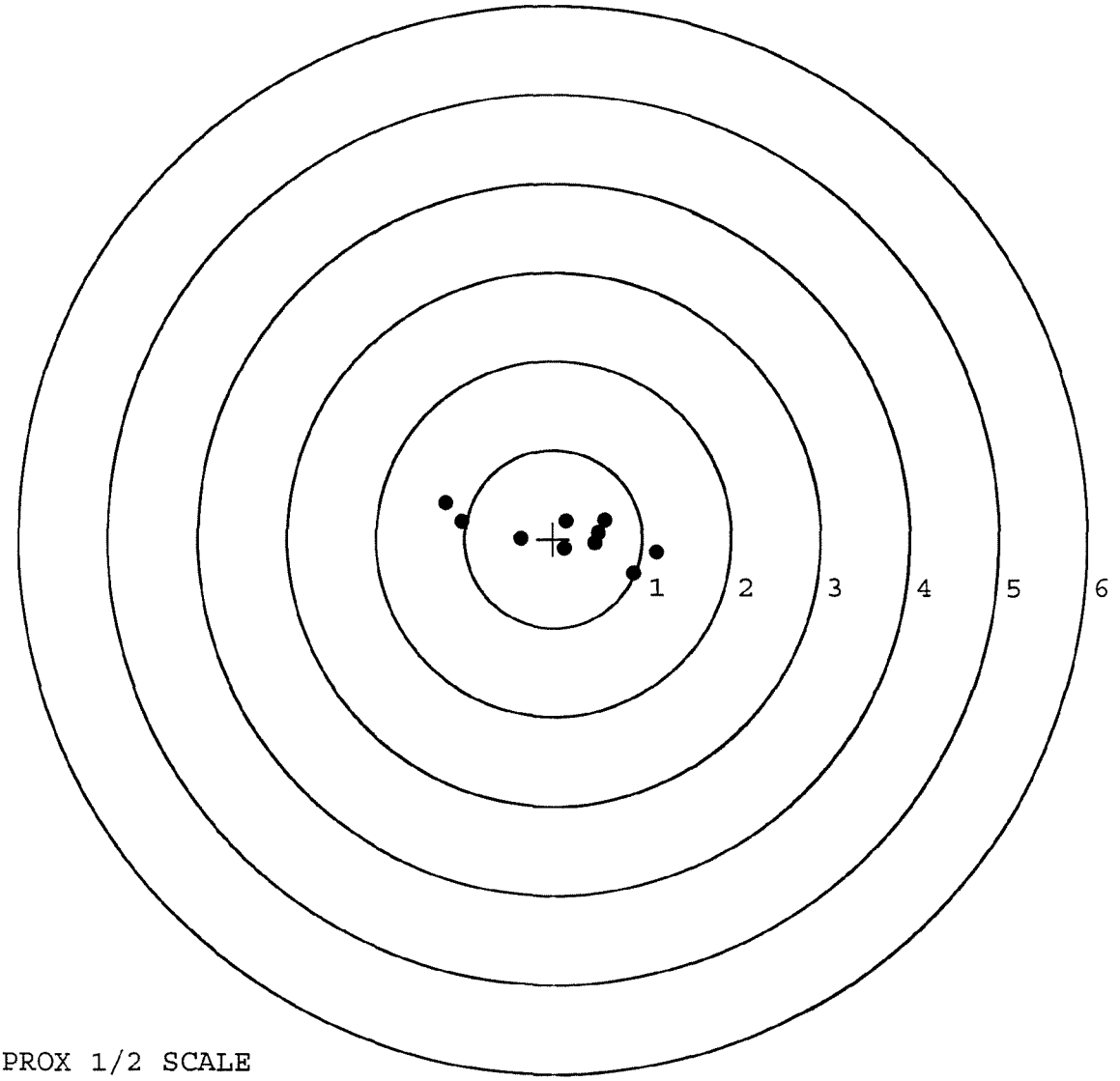



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693267.__0
TARGET NUMBER: 4
FILE DATE: 01/02/2008
FILE TIME: 22:59

| | |
|---|---|
| X CENTROID: | 0.129 |
| Y CENTROID: | 0.037 |
| POA TO CENTROID: | 0.134 |
| HORZ SPREAD: | 2.379 |
| VERT SPREAD: | 0.799 |
| GROUP SPREAD: | 2.444 |
| MIN RADIUS: | 0.144 |
| MAX RADIUS: | 1.392 |
| MEAN RADIUS: | 0.654 |
| # IN 1 IN DIAMETER: | 6 |
| # IN 2 IN DIAMETER: | 7 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -1.214 | 0.402 |
| 2: | -1.037 | 0.199 |
| 3: | -0.365 | -0.005 |
| 4: | 0.141 | 0.200 |
| 5: | 0.130 | -0.107 |
| 6: | 0.472 | -0.051 |
| 7: | 0.586 | 0.211 |
| 8: | 1.165 | -0.159 |
| 9: | 0.903 | -0.397 |
| 10: | 0.508 | 0.073 |

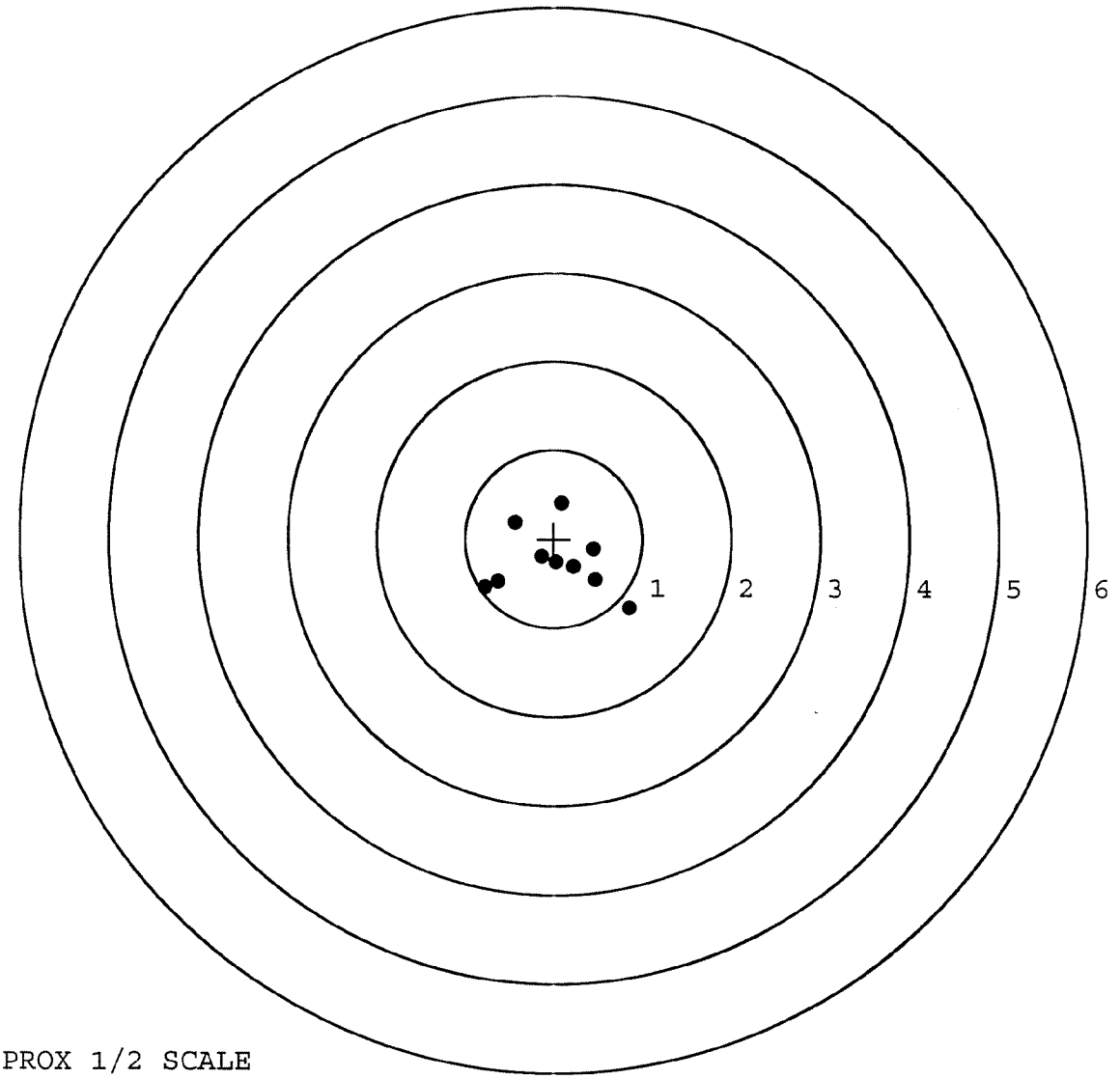



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693267.__0
TARGET NUMBER: 5
FILE DATE: 01/02/2008
FILE TIME: 22:59

| | |
|---|---|
| X CENTROID: | 0.013 |
| Y CENTROID: | -0.257 |
| POA TO CENTROID: | 0.258 |
| HORZ SPREAD: | 1.624 |
| VERT SPREAD: | 1.185 |
| GROUP SPREAD: | 1.641 |
| MIN RADIUS: | 0.019 |
| MAX RADIUS: | 0.985 |
| MEAN RADIUS: | 0.516 |
| # IN 1 IN DIAMETER: | 5 |
| # IN 2 IN DIAMETER: | 10 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -0.435 | 0.193 |
| 2: | 0.090 | 0.404 |
| 3: | -0.628 | -0.481 |
| 4: | -0.135 | -0.202 |
| 5: | 0.031 | -0.264 |
| 6: | 0.447 | -0.114 |
| 7: | 0.224 | -0.318 |
| 8: | 0.467 | -0.466 |
| 9: | 0.847 | -0.781 |
| 10: | -0.777 | -0.544 |




TARGET APPROX 1/2 SCALE