

G669 3293

**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL WITH MARS RAIL
COMPLETE SYSTEM - LE/EXPORT**

98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB
96082 SCOPE RING ASSEMBLY
400061 SCOPE RING ASSEMBLY 306-09

BM FORM 1692

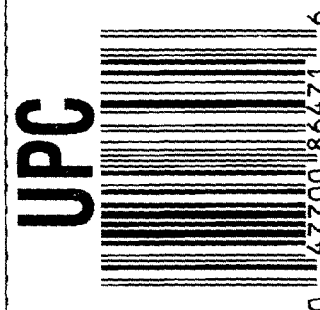


ORDER NO. 86471

BARREL LENGTH 24"

CAPACITY 6

G6693293



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6693293

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		12-5-07	RJZ
420	ASSEMBLE ACTION		12-5-07	RJZ
430	ASSEMBLE TO STOCK		12-5-07	RJZ
440	PROOF		12-6-07	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	12-6-07	TRW
470	DIS-ASSEMBLE ACTION		12-6-07	RJZ
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)		12/14/07	JB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-20-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-20-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-20-07	DA
	D) OIL FIRING PIN ASSEMBLY		1-8-08	RJZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1/16/08	
F004 REV 5/2006				

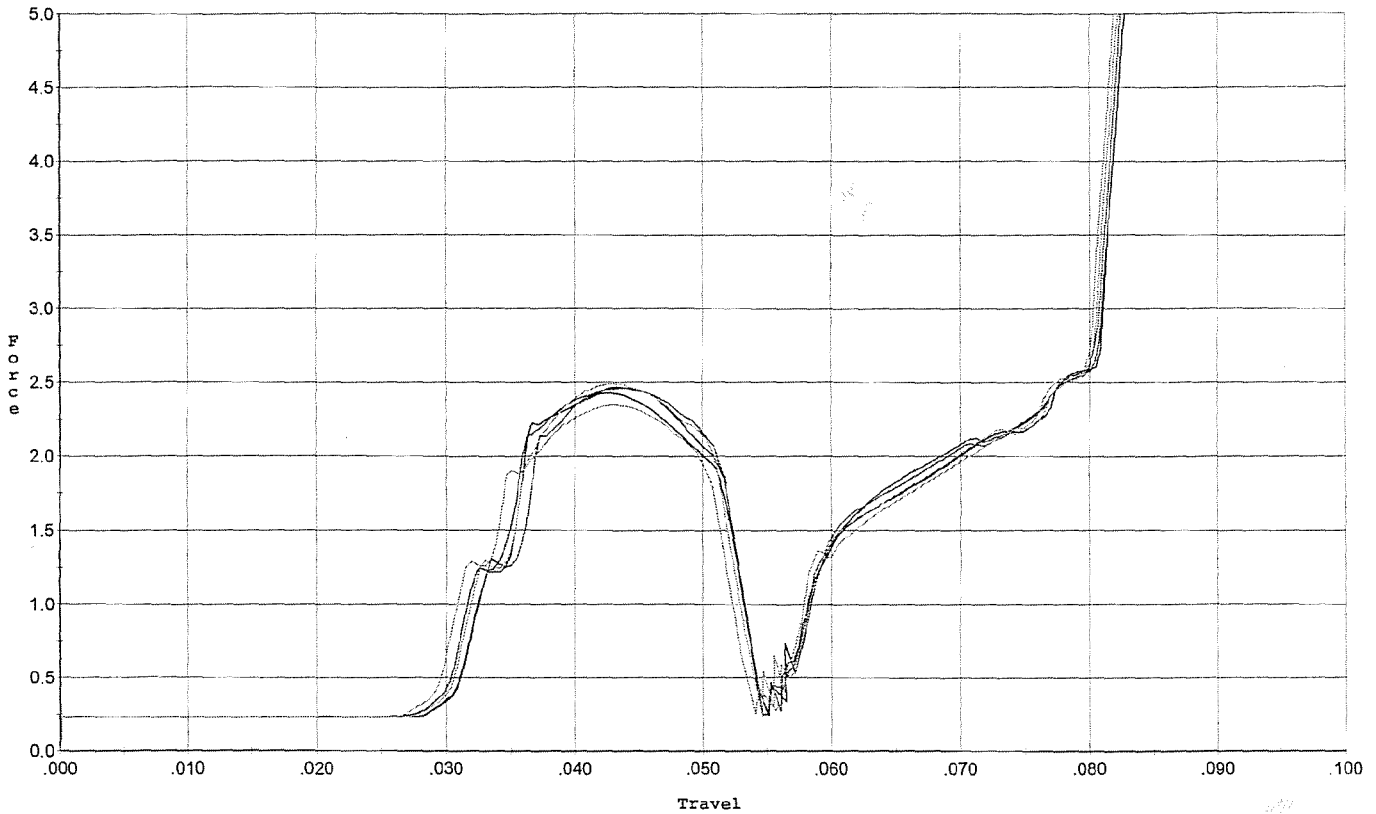
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.25</u>	1-10-08	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.25</u> <u>2.25</u>	1-10-08	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		1/16/08	am
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.0225</u> <u>.023</u>	1-10-08	TRW
	J) ASSEMBLE STOCK		1-9-08	RTW
	K) ASSEMBLE SWIVEL STUDS		1/16/08	am
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1/16/08	am
	M) IRON SIGHT ALIGNMENT		1/16/08	am
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1/16/08	am
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1/9/08	am
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-9-08	SD
670	FINAL INSPECTION A) HEADSPACE		1/16/08	am
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.31</u> <u>2.25</u> <u>2.26</u> <u>2.35</u>	1-10-08	TRW
	C) FUNCTION		1/16/08	am
690	PACK		4/24/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



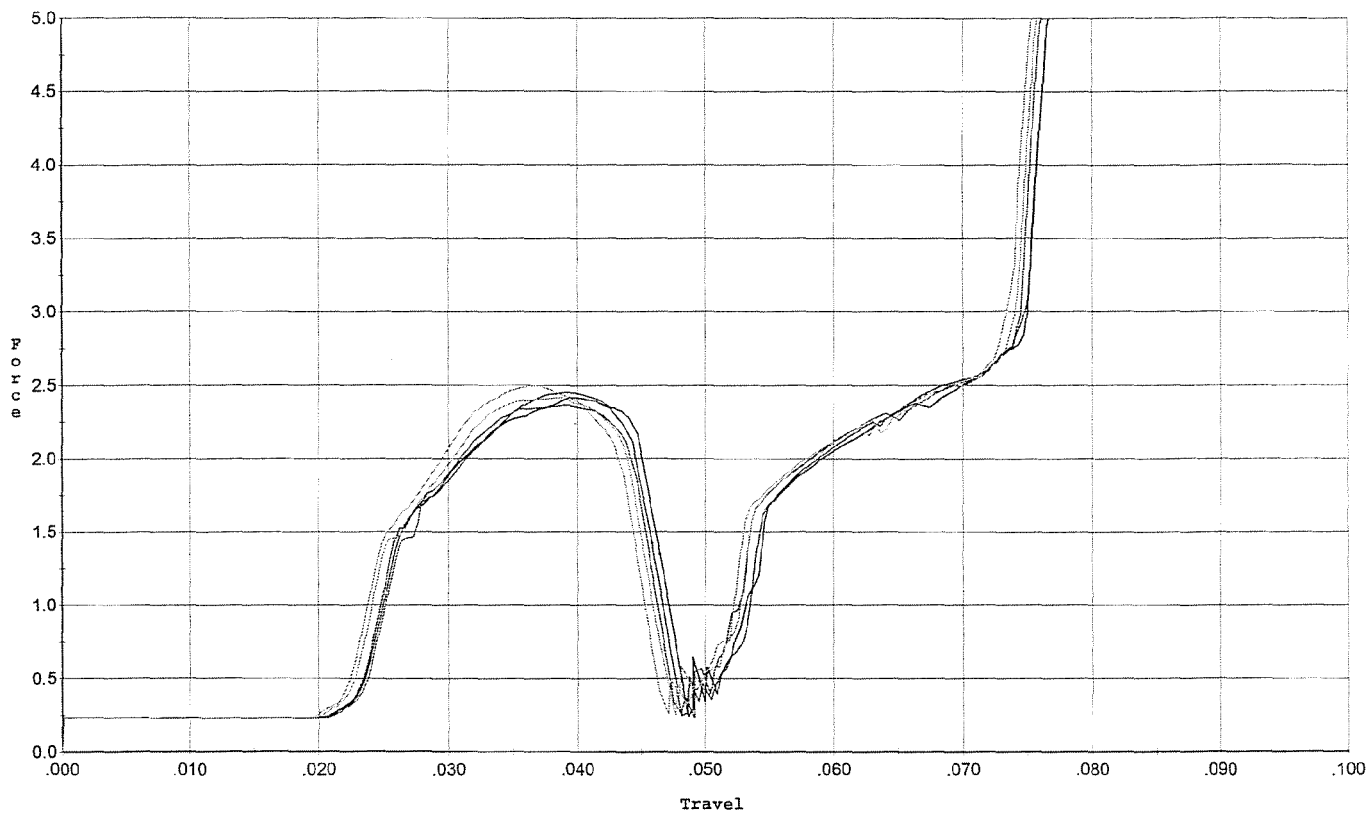
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.052	0.030	0.035	0.050		Set Trigger
2	2.428	0.052	0.031	0.036	0.049		Set Trigger
3	2.469	0.052	0.031	0.036	0.049		Set Trigger
4	2.489	0.051	0.030	0.036	0.049		Set Trigger
5	2.345	0.051	0.029	0.036	0.048		Set Trigger

2.44 Avg.

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 12/21/07

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



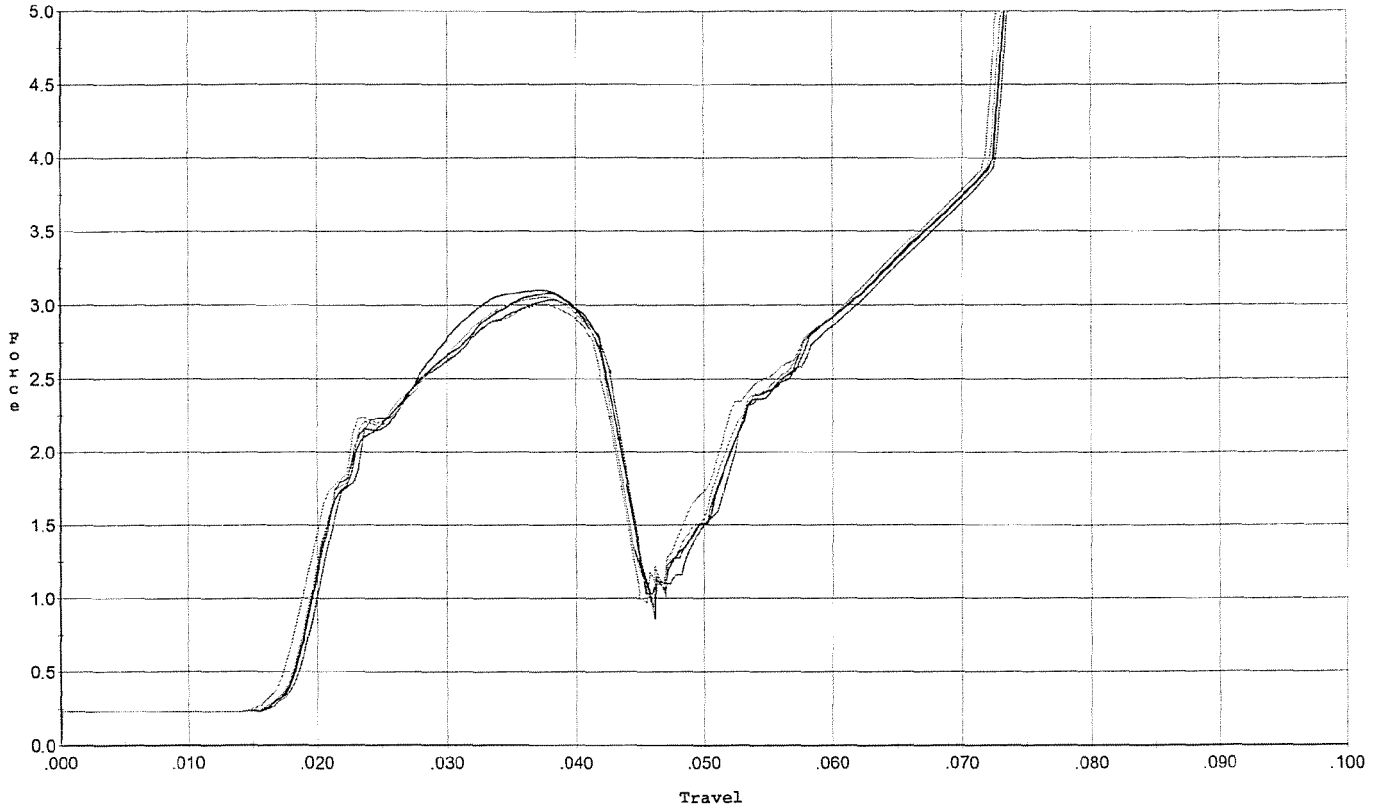
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.449	0.046	0.023	0.035	0.050		Set Trigger
2	2.414	0.046	0.023	0.035	0.051		Set Trigger
3	2.366	0.045	0.024	0.035	0.047		Set Trigger
4	2.415	0.044	0.022	0.035	0.048		Set Trigger
5	2.501	0.044	0.022	0.035	0.049		Set Trigger

2.43 Avg

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



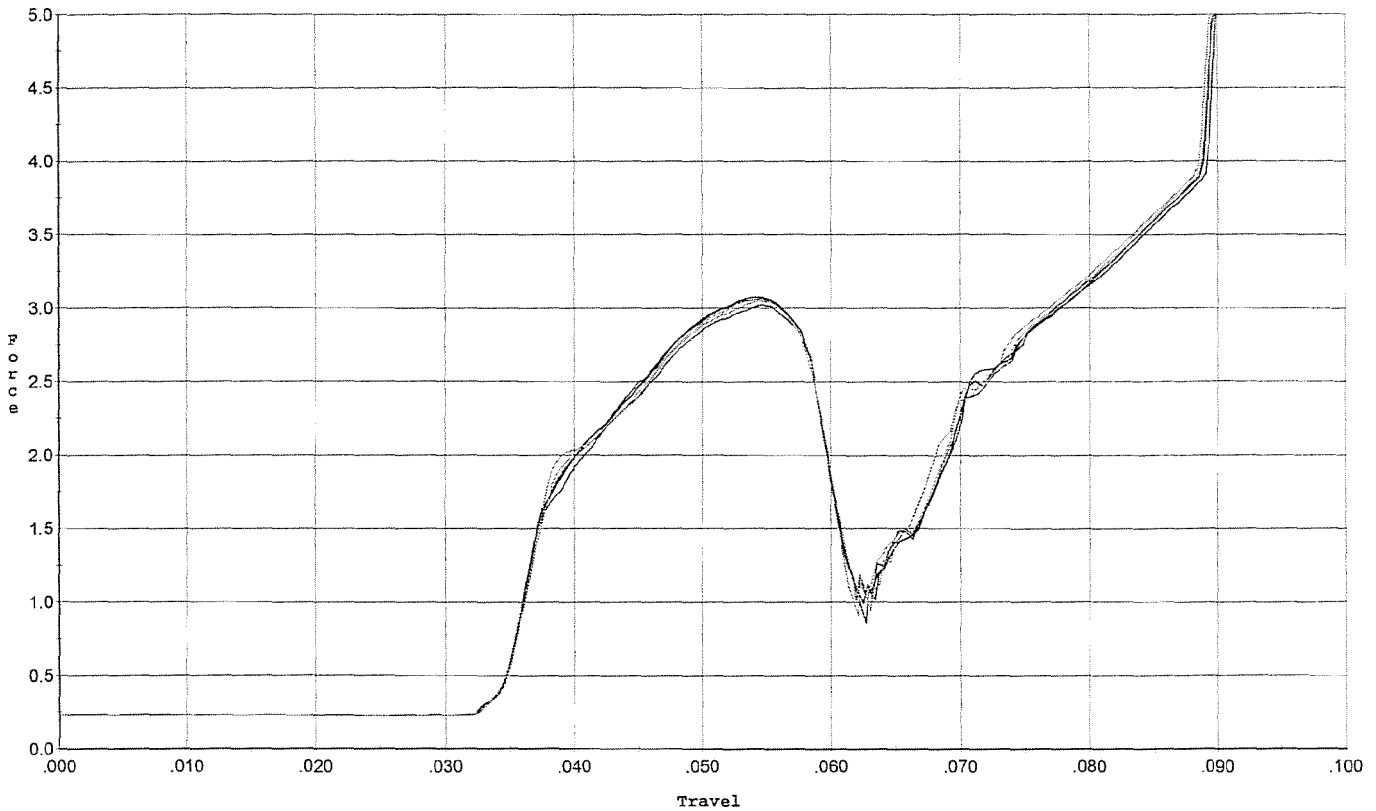
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.042	0.018	0.033	0.063		Set Trigger
2	3.083	0.043	0.018	0.033	0.065		Set Trigger
3	3.036	0.043	0.018	0.033	0.063		Set Trigger
4	3.054	0.042	0.018	0.033	0.063		Set Trigger
5	3.008	0.043	0.017	0.032	0.064		Set Trigger

3.06 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



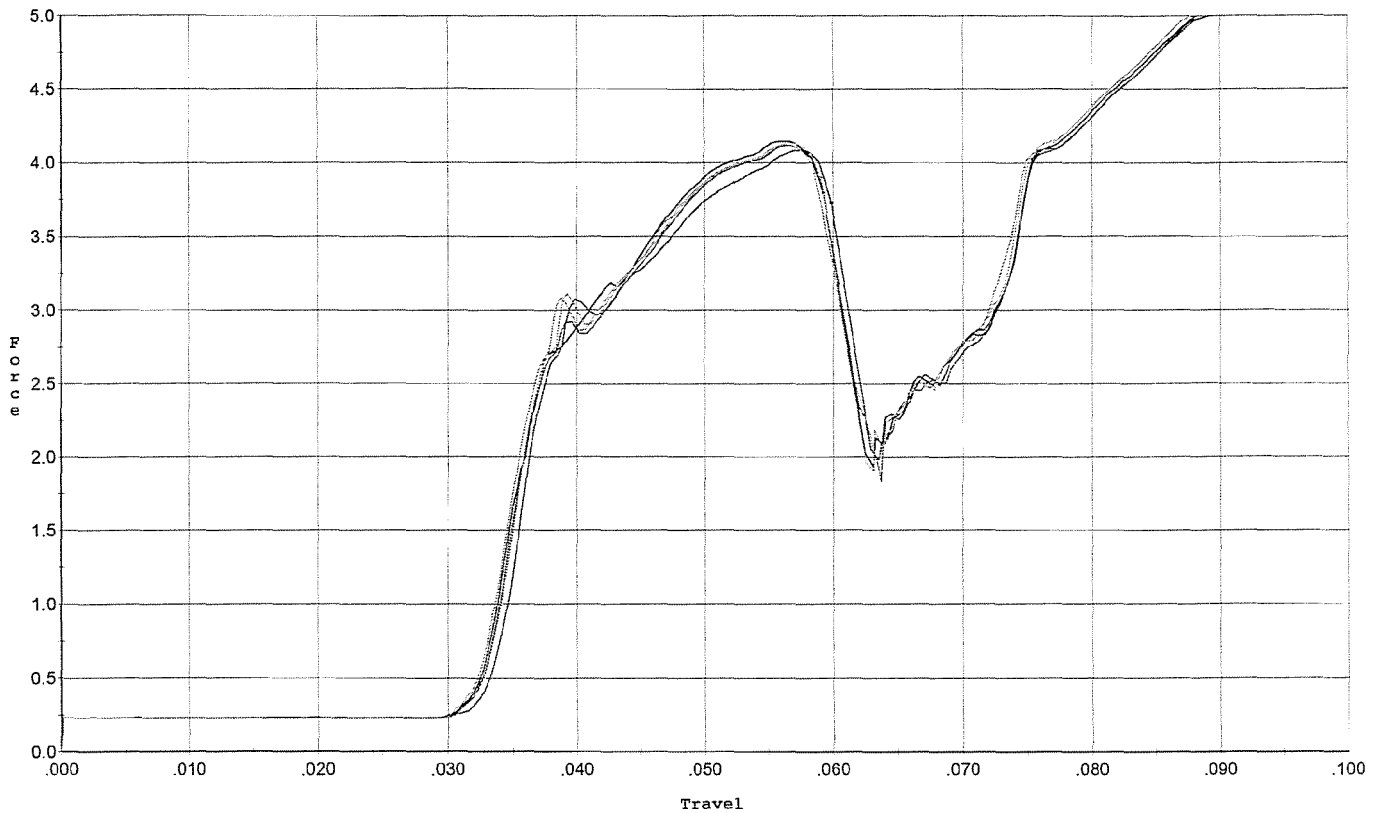
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.058	0.034	0.036	0.067		Set Trigger
2	3.074	0.058	0.034	0.036	0.067		Set Trigger
3	3.016	0.058	0.034	0.036	0.066		Set Trigger
4	3.046	0.058	0.034	0.036	0.066		Set Trigger
5	3.067	0.059	0.034	0.036	0.067		Set Trigger

3.05 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



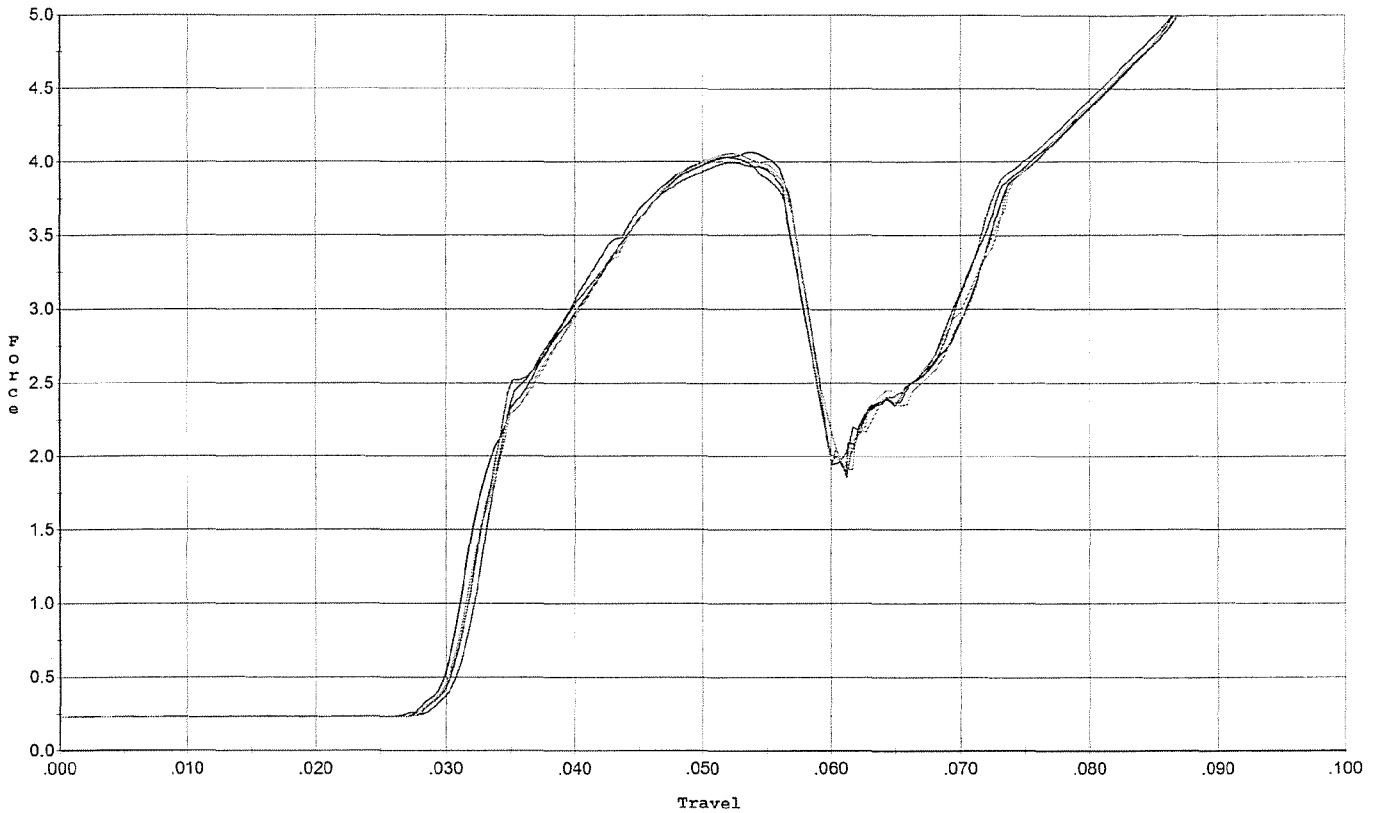
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.060	0.033	0.033	0.095		Set Trigger
2	4.146	0.059	0.032	0.033	0.096		Set Trigger
3	4.117	0.059	0.032	0.033	0.095		Set Trigger
4	4.136	0.059	0.032	0.033	0.096		Set Trigger
5	4.123	0.060	0.032	0.033	0.098		Set Trigger

4.12 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



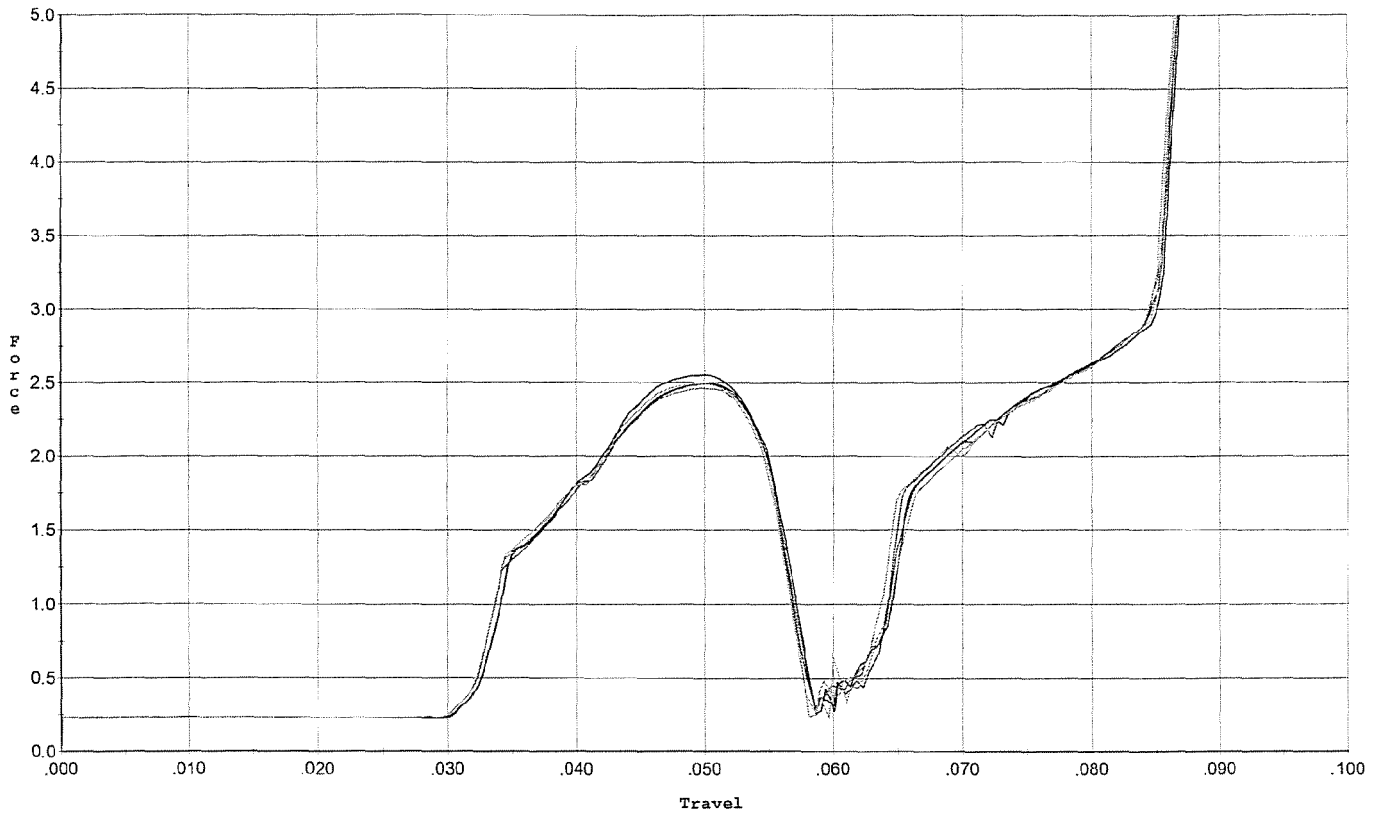
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.035	0.056	0.031	0.033	0.090		Set Trigger
2	4.069	0.057	0.030	0.032	0.094		Set Trigger
3	3.996	0.056	0.030	0.032	0.090		Set Trigger
4	4.062	0.057	0.030	0.032	0.093		Set Trigger
5	4.055	0.057	0.030	0.032	0.092		Set Trigger

4.04 Avg

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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



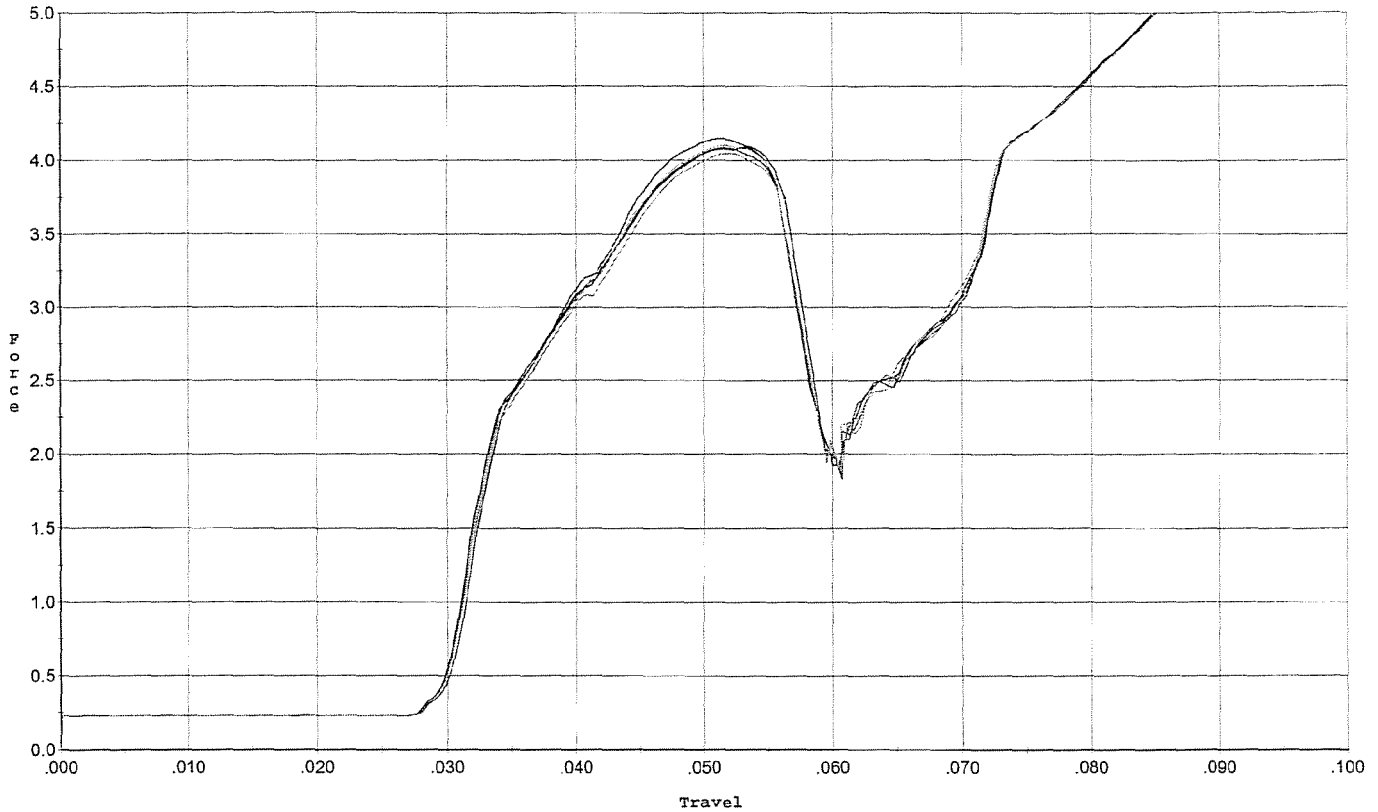
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.055	0.033	0.037	0.052		Set Trigger
2	2.555	0.056	0.032	0.036	0.055		Set Trigger
3	2.494	0.055	0.032	0.036	0.052		Set Trigger
4	2.500	0.055	0.032	0.036	0.053		Set Trigger
5	2.462	0.055	0.032	0.036	0.053		Set Trigger

2.50 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/21/07

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	4.148	0.056	0.030	0.032	0.093		Set Trigger
2	4.090	0.056	0.030	0.032	0.091		Set Trigger
3	4.087	0.056	0.030	0.032	0.091		Set Trigger
4	4.103	0.056	0.030	0.032	0.090		Set Trigger
5	4.050	0.056	0.030	0.032	0.089		Set Trigger

4.10 Avg.

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693293.___0

FILE DATE AND TIME: 01/10/2008 05:00

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:	-0.105
The Average Point of Impact of the Five Target Set:	0.107
The Average Mean Radius of the Five Target Set:	0.613
The Distance from POA to Centroid Target #1:	0.280
The Distance from Centroid Target #2 to Centroid Target #1:	0.361
The Distance from Centroid Target #3 to Centroid Target #1:	0.189
The Distance from Centroid Target #4 to Centroid Target #1:	0.260
The Distance from Centroid Target #5 to Centroid Target #1:	0.216

SERIAL NUMBER: G6693293. 0

TARGET NUMBER: 1

FILE DATE: 01/10/2008

FILE TIME: 05:00

POINT#	X	Y
1:	0.598	-0.990
2:	0.561	0.713
3:	-0.307	0.546
4:	-0.323	0.240
5:	0.099	-0.297
6:	-0.349	-0.632
7:	-0.242	-0.475
8:	-0.392	-0.297
9:	-0.605	-0.230
10:	-1.031	-0.547

X CENTROID: -0.199

Y CENTROID: -0.197

POA TO CENTROID: 0.280

HORZ SPREAD: 1.629

VERT SPREAD: 1.703

GROUP SPREAD: 2.030

MIN RADIUS: 0.217

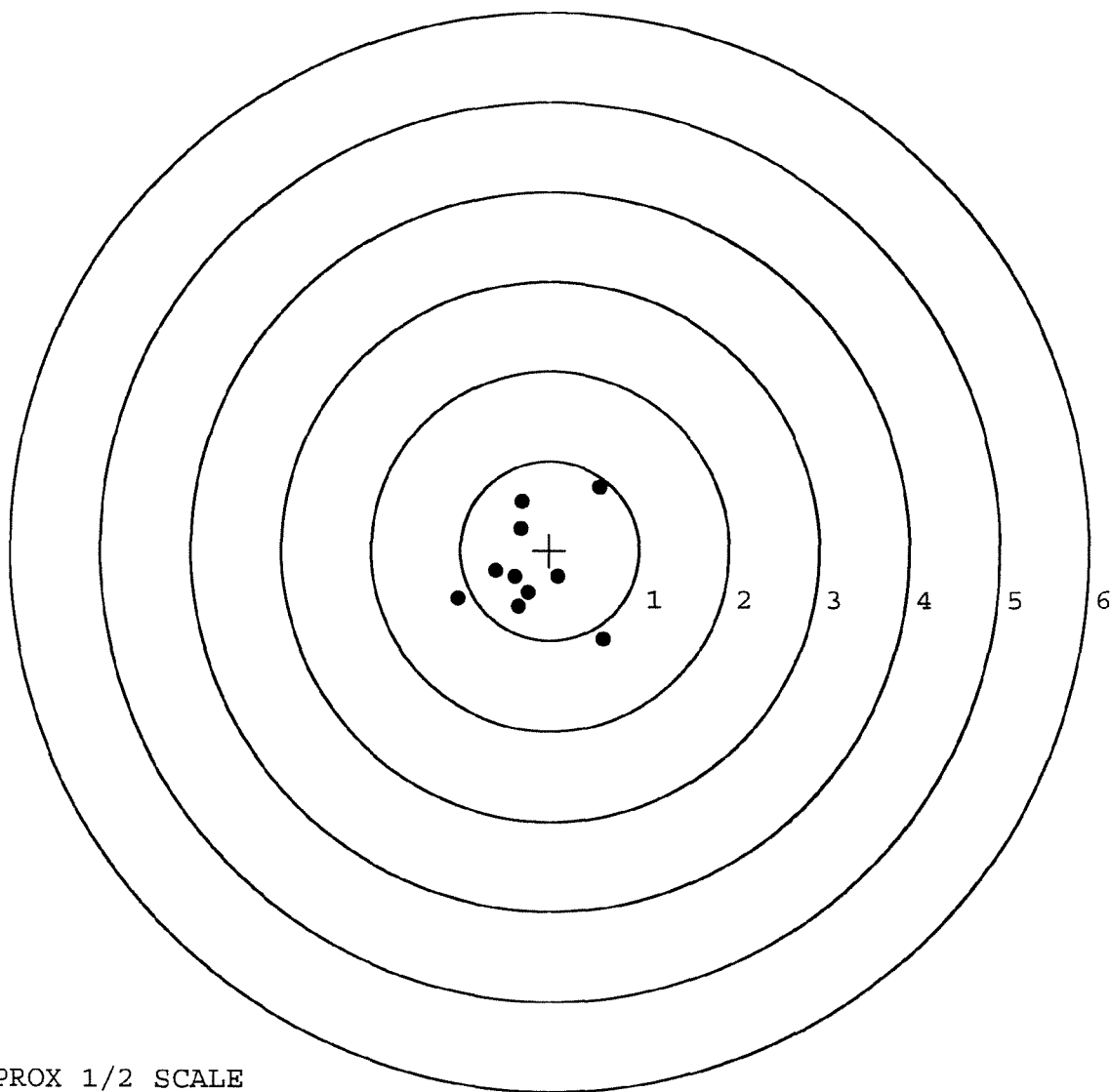
MAX RADIUS: 1.186

MEAN RADIUS: 0.610

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693293. __ 0

TARGET NUMBER: 2

FILE DATE: 01/10/2008

FILE TIME: 05:00

POINT#	X	Y
--------	---	---

1:	0.250	-1.204
----	-------	--------

2:	-0.109	-0.563
----	--------	--------

3:	0.504	0.316
----	-------	-------

4:	0.534	0.905
----	-------	-------

5:	0.029	0.709
----	-------	-------

6:	-0.431	0.385
----	--------	-------

7:	0.321	-0.413
----	-------	--------

8:	0.219	-0.230
----	-------	--------

9:	0.086	-0.012
----	-------	--------

10:	-0.197	-0.175
-----	--------	--------

X CENTROID: 0.121

Y CENTROID: -0.028

POA TO CENTROID: 0.124

HORZ SPREAD: 0.965

VERT SPREAD: 2.109

GROUP SPREAD: 2.128

MIN RADIUS: 0.038

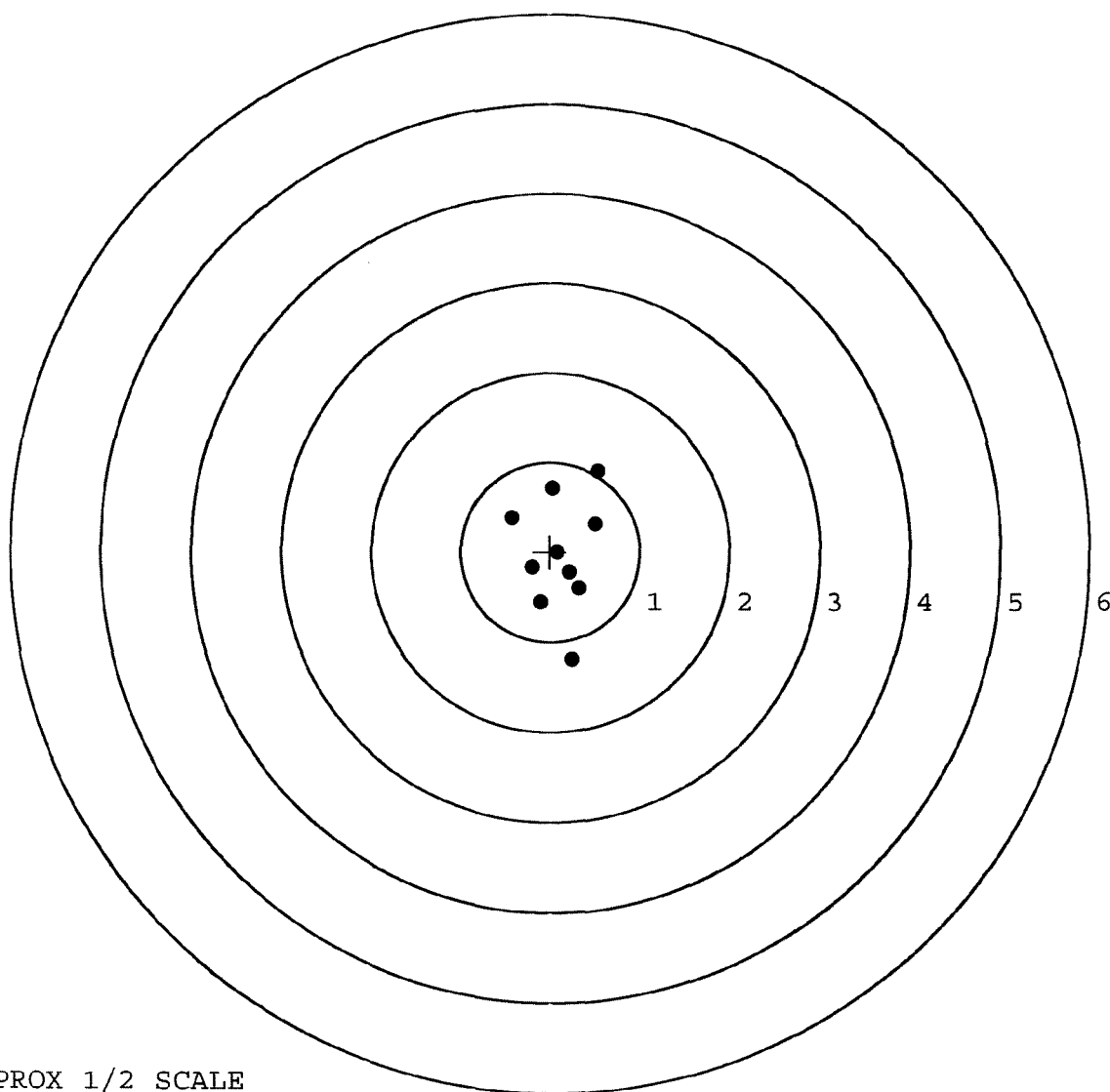
MAX RADIUS: 1.183

MEAN RADIUS: 0.578

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

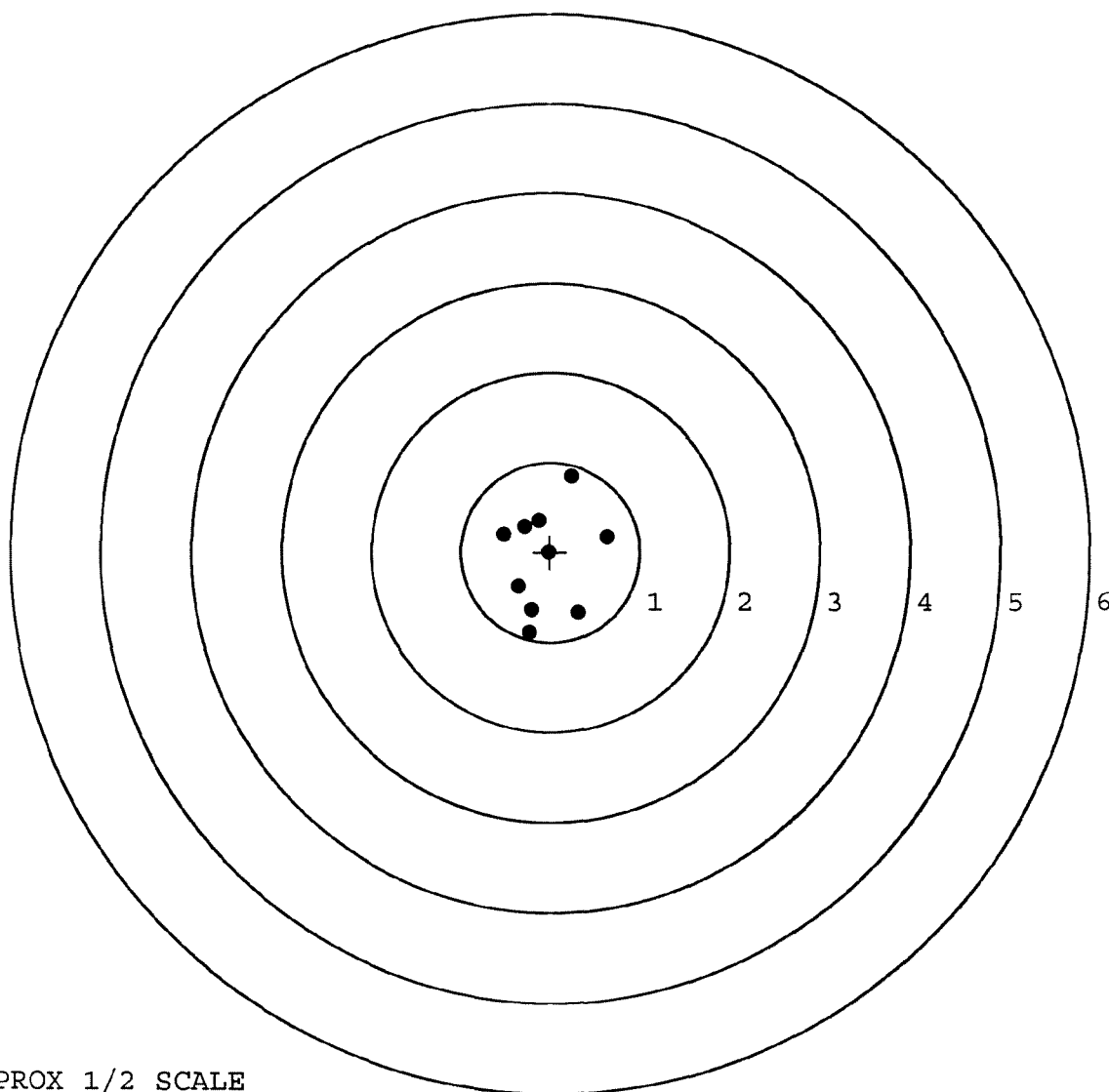


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693293. __0
TARGET NUMBER: 3
FILE DATE: 01/10/2008
FILE TIME: 05:00

POINT#	X	Y
1:	0.246	0.845
2:	0.631	0.178
3:	0.309	-0.676
4:	-0.236	-0.894
5:	-0.209	-0.642
6:	-0.357	-0.382
7:	-0.016	0.001
8:	-0.131	0.357
9:	-0.523	0.203
10:	-0.289	0.290

X CENTROID: -0.058
Y CENTROID: -0.072
POA TO CENTROID: 0.092
HORZ SPREAD: 1.154
VERT SPREAD: 1.739
GROUP SPREAD: 1.805
MIN RADIUS: 0.084
MAX RADIUS: 0.966
MEAN RADIUS: 0.576
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693293. __0

TARGET NUMBER: 4

FILE DATE: 01/10/2008

FILE TIME: 05:00

POINT#	X	Y
1:	1.405	-0.950
2:	0.180	-0.725
3:	-0.555	-0.587
4:	-0.606	-0.159
5:	0.030	0.604
6:	-0.025	0.372
7:	0.318	-0.003
8:	-0.038	-0.165
9:	-0.201	-0.024
10:	0.067	0.067

X CENTROID: 0.057

Y CENTROID: -0.157

POA TO CENTROID: 0.167

HORZ SPREAD: 2.011

VERT SPREAD: 1.554

GROUP SPREAD: 2.161

MIN RADIUS: 0.096

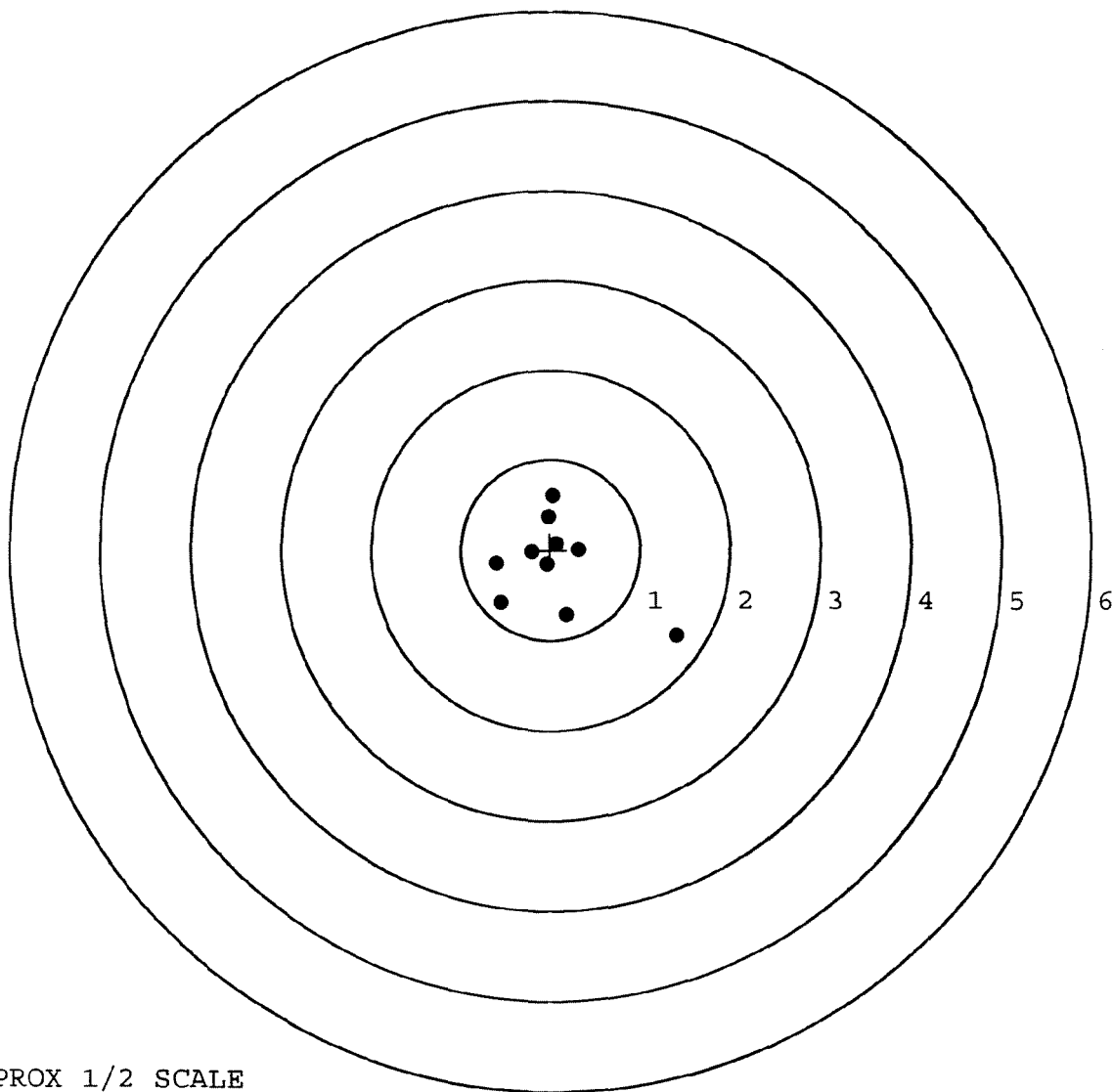
MAX RADIUS: 1.564

MEAN RADIUS: 0.577

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

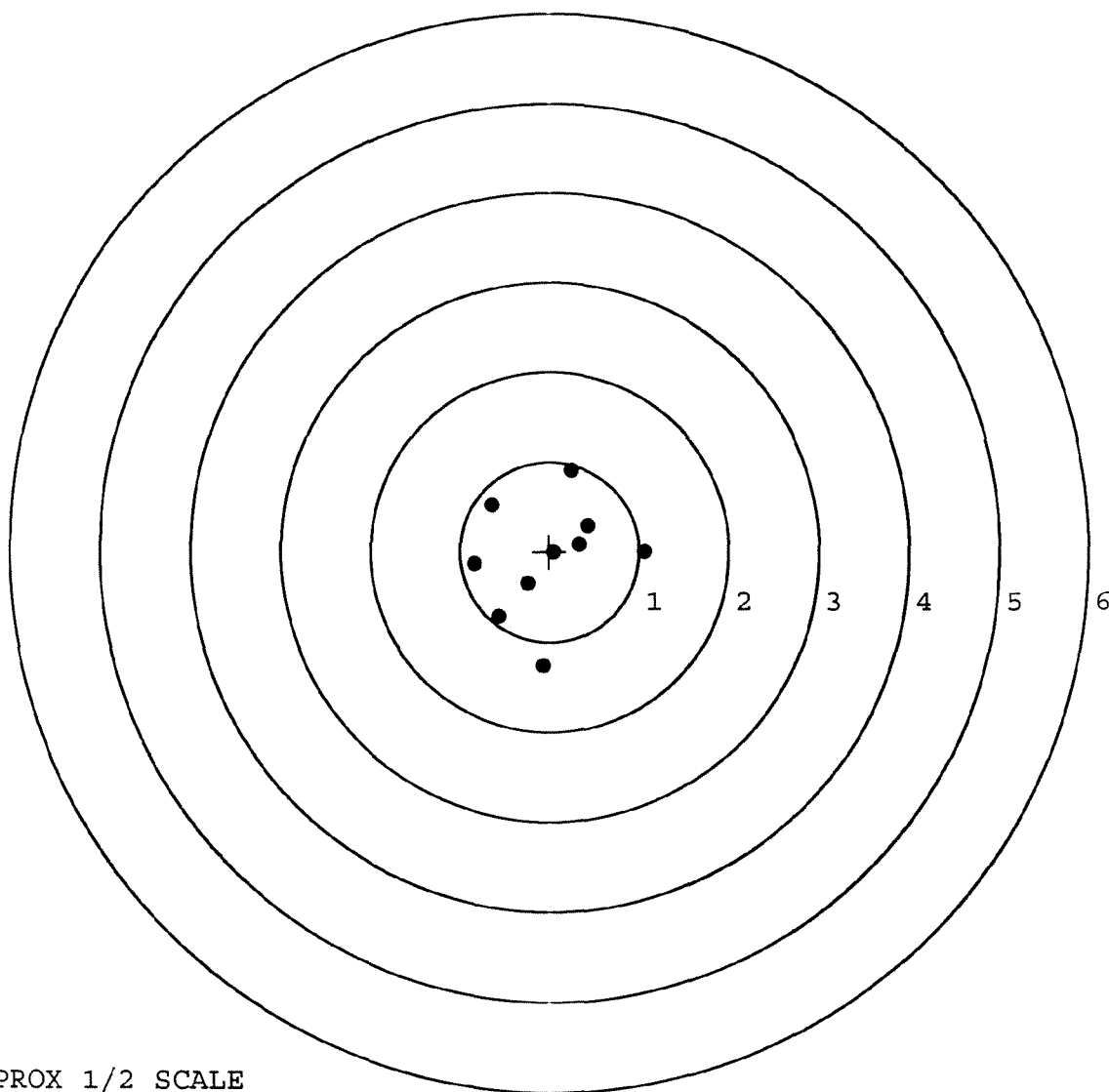


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693293. __0
TARGET NUMBER: 5
FILE DATE: 01/10/2008
FILE TIME: 05:00

POINT#	X	Y
1:	-0.069	-1.267
2:	-0.568	-0.726
3:	-0.241	-0.356
4:	-0.838	-0.143
5:	-0.646	0.519
6:	0.253	0.903
7:	1.065	-0.003
8:	0.430	0.290
9:	0.047	-0.011
10:	0.338	0.076

X CENTROID: -0.023
Y CENTROID: -0.072
POA TO CENTROID: 0.075
HORZ SPREAD: 1.903
VERT SPREAD: 2.170
GROUP SPREAD: 2.194
MIN RADIUS: 0.093
MAX RADIUS: 1.196
MEAN RADIUS: 0.725
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE