

66693302

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

- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6693302



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.



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400177496

M-24
INSPECTION CHECKLIST-NEW GUNS

M

GUN SERIAL # G6693302

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10/10/07	RPD
420	ASSEMBLE ACTION		10-9-07	SD
430	ASSEMBLE TO STOCK		10-10-07	SD
440	PROOF	MAGNA - FLUX	10/10/07	MSM
460	CHECK HEADSPACE		10/10/07	MSM
470	DIS-ASSEMBLE ACTION		10-10-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <i>mmms</i>	10/15/07	<i>mmms</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/20/07	CW
510	DRILL AND TAP SIGHT HOLES		10-11-07	SD
520	GOFF BLAST BBL / REC		10/15/07	PS
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/16/07	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/22/07	RP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/22/07	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/22/07	RP
	D) OIL FIRING PIN ASSEMBLY		10/23/07	RPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

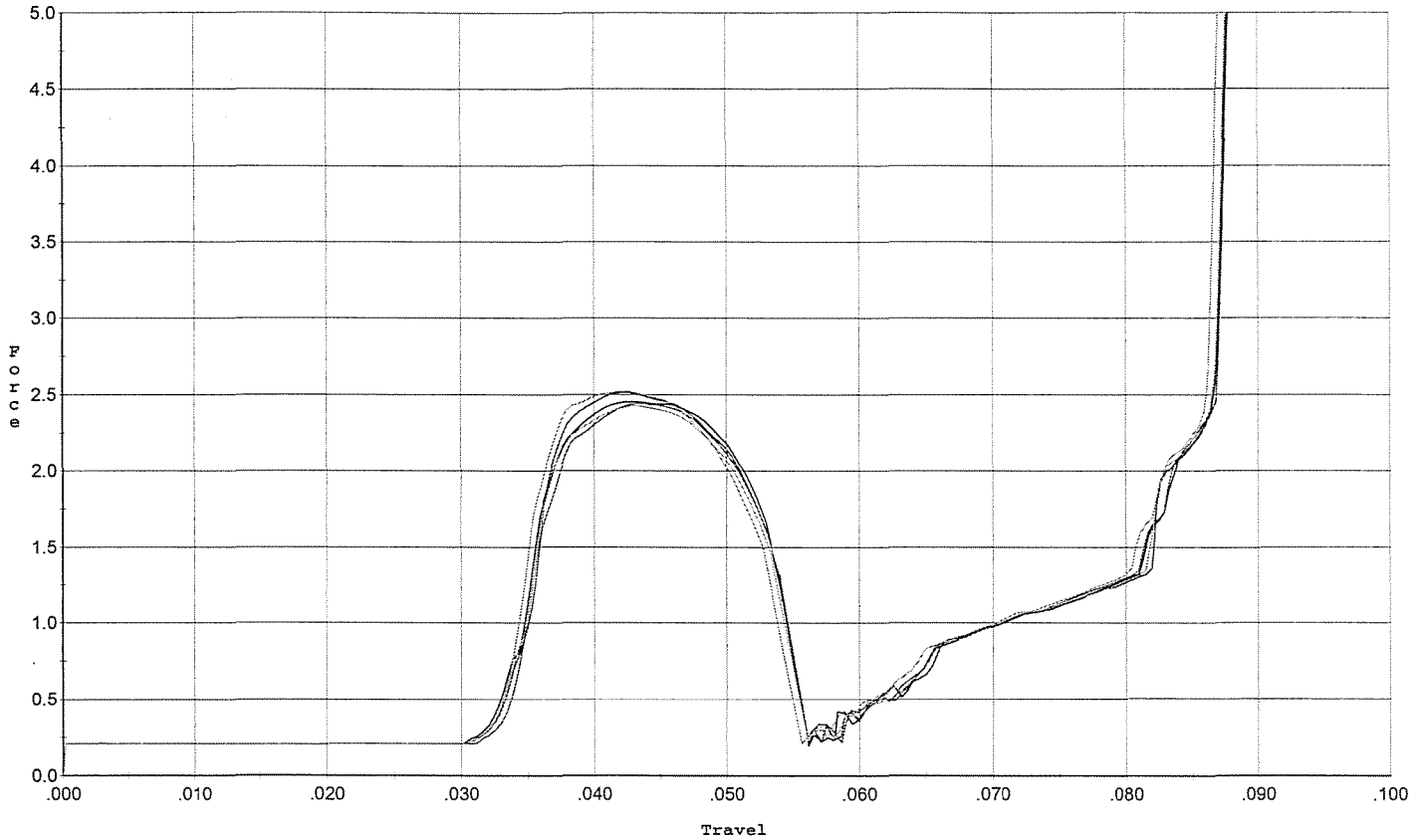
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.5</u> <u>5.25</u> <u>5.75</u>	10/23/07	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.25</u> <u>5.0</u> <u>5.25</u>	10/23/07	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		10/23/07	mm
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	10/23/07	mm
	J) ASSEMBLE STOCK		10/22/07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		10/23/07	RA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10/27/07	S.P.D.
	M) IRON SIGHT ALIGNMENT		10/27/07	S.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10/27/07	S.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-23-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-07	Fm
670	FINAL INSPECTION A) HEADSPACE		10/26/07	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>272</u> <u>227</u> <u>221</u> <u>218</u> <u>227</u>	10/23/07	mm
	C) FUNCTION		10/24/07	mm
690	PACK		10/29/07	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



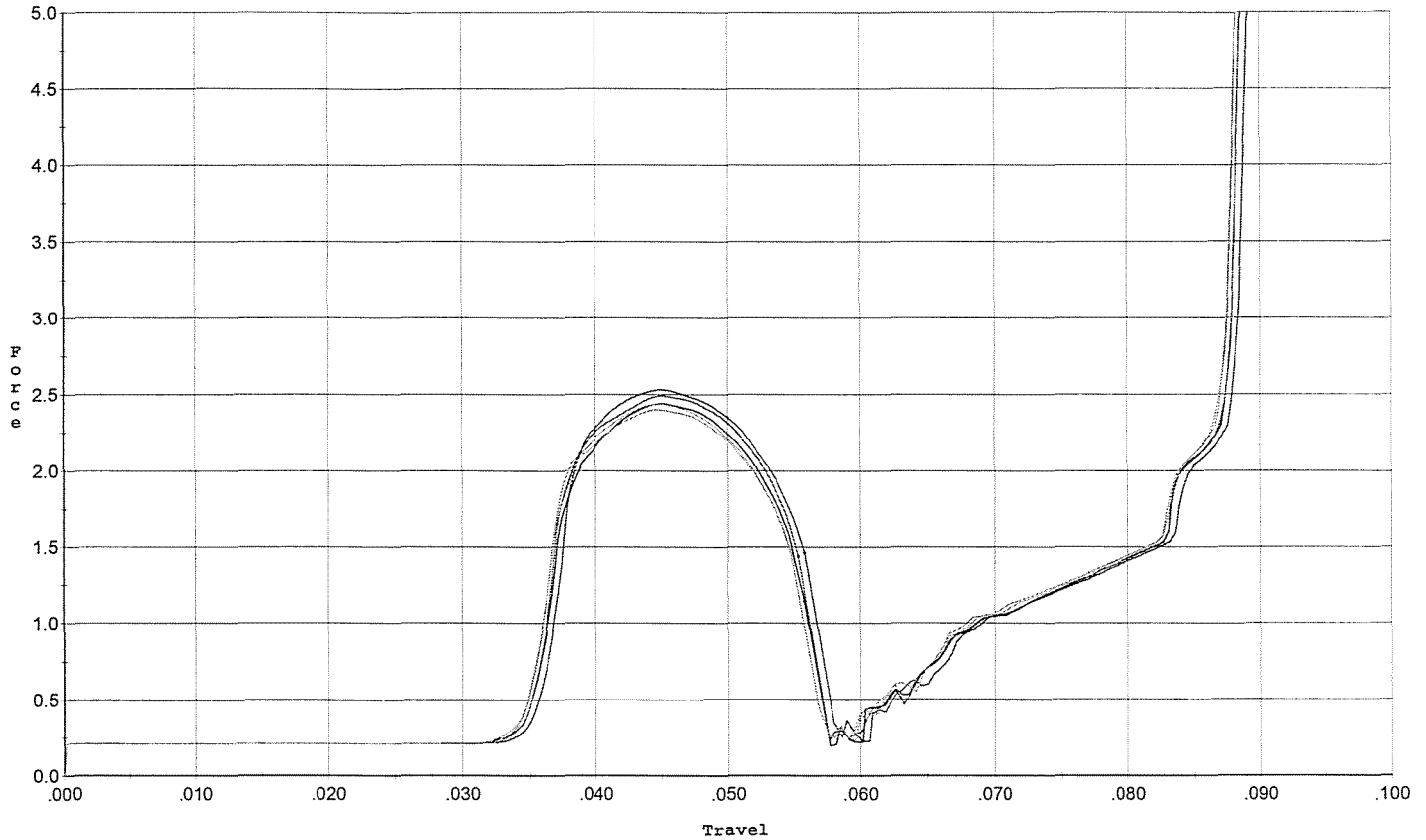
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.054	0.033	0.038	0.050		Set Trigger
2	2.453	0.054	0.032	0.038	0.050		Set Trigger
3	2.443	0.054	0.033	0.038	0.048		Set Trigger
4	2.428	0.055	0.033	0.038	0.049		Set Trigger
5	2.522	0.053	0.033	0.038	0.049		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



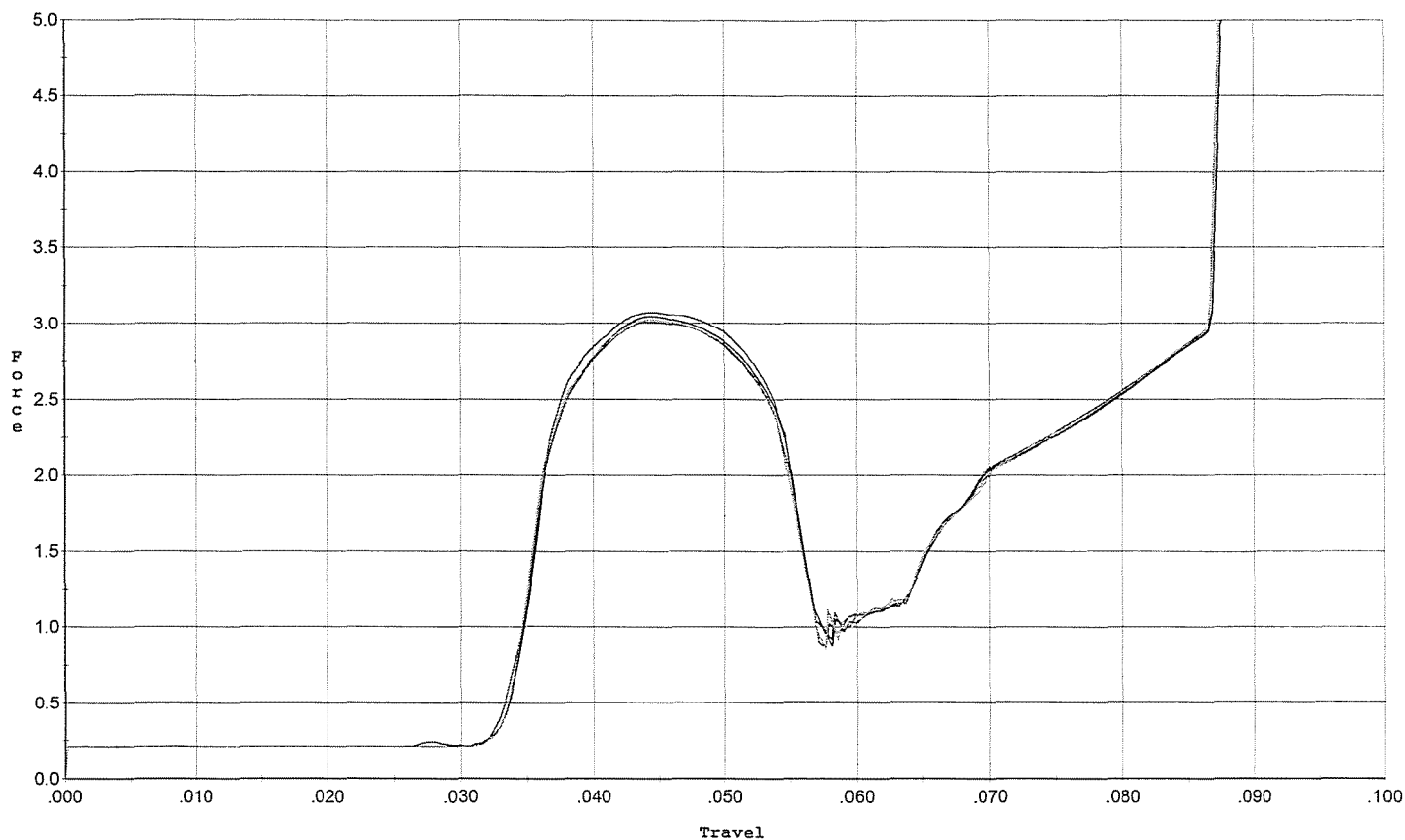
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.056	0.035	0.038	0.051		Set Trigger
2	2.439	0.056	0.035	0.038	0.049		Set Trigger
3	2.491	0.055	0.035	0.038	0.050		Set Trigger
4	2.436	0.055	0.034	0.038	0.048		Set Trigger
5	2.401	0.055	0.035	0.038	0.048		Set Trigger

AVg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



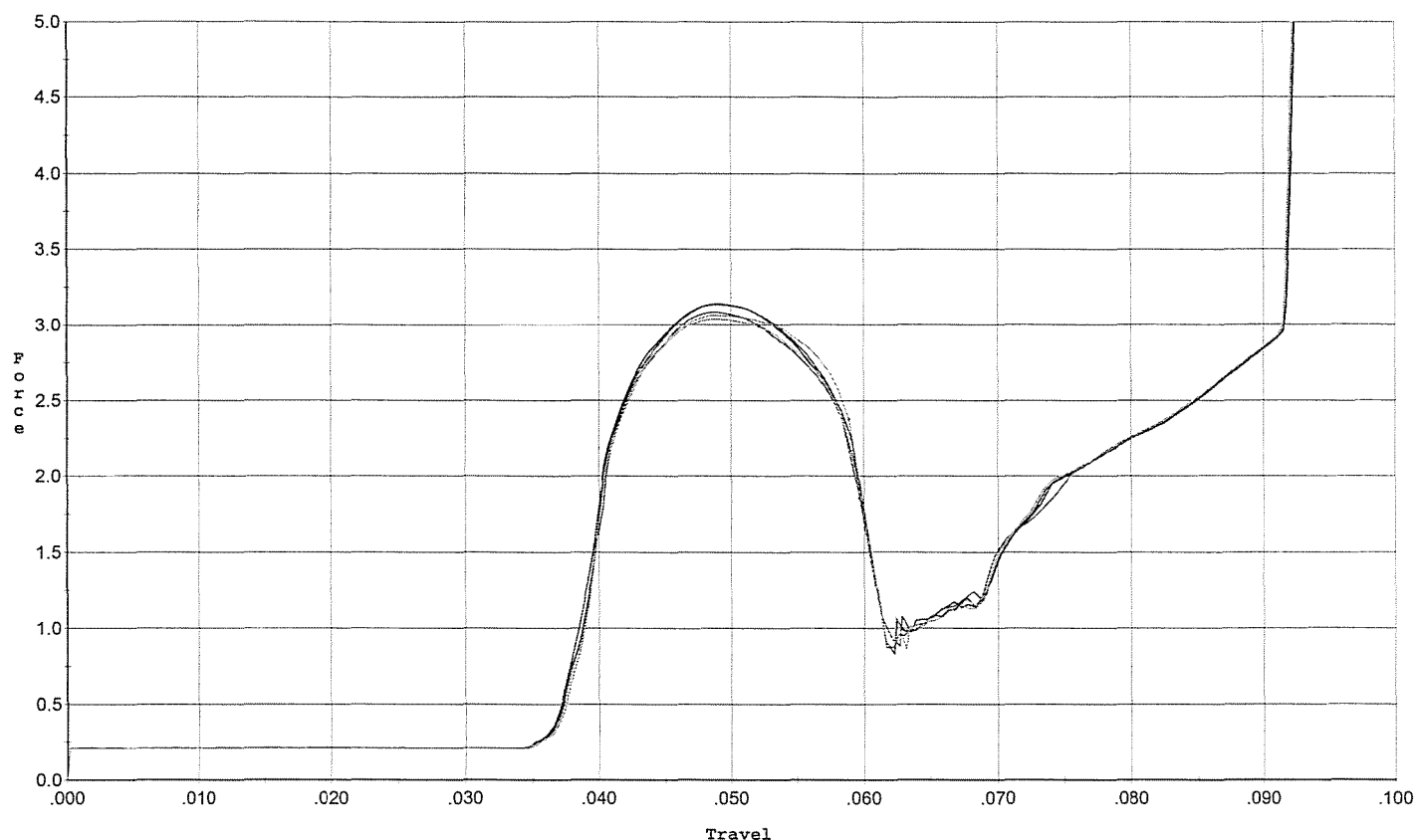
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.076	0.055	0.033	0.036	0.063		Set Trigger
2	3.045	0.055	0.033	0.036	0.062		Set Trigger
3	3.009	0.055	0.033	0.036	0.062		Set Trigger
4	3.023	0.055	0.033	0.036	0.062		Set Trigger
5	3.022	0.055	0.033	0.036	0.062		Set Trigger

AVG 3.03

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



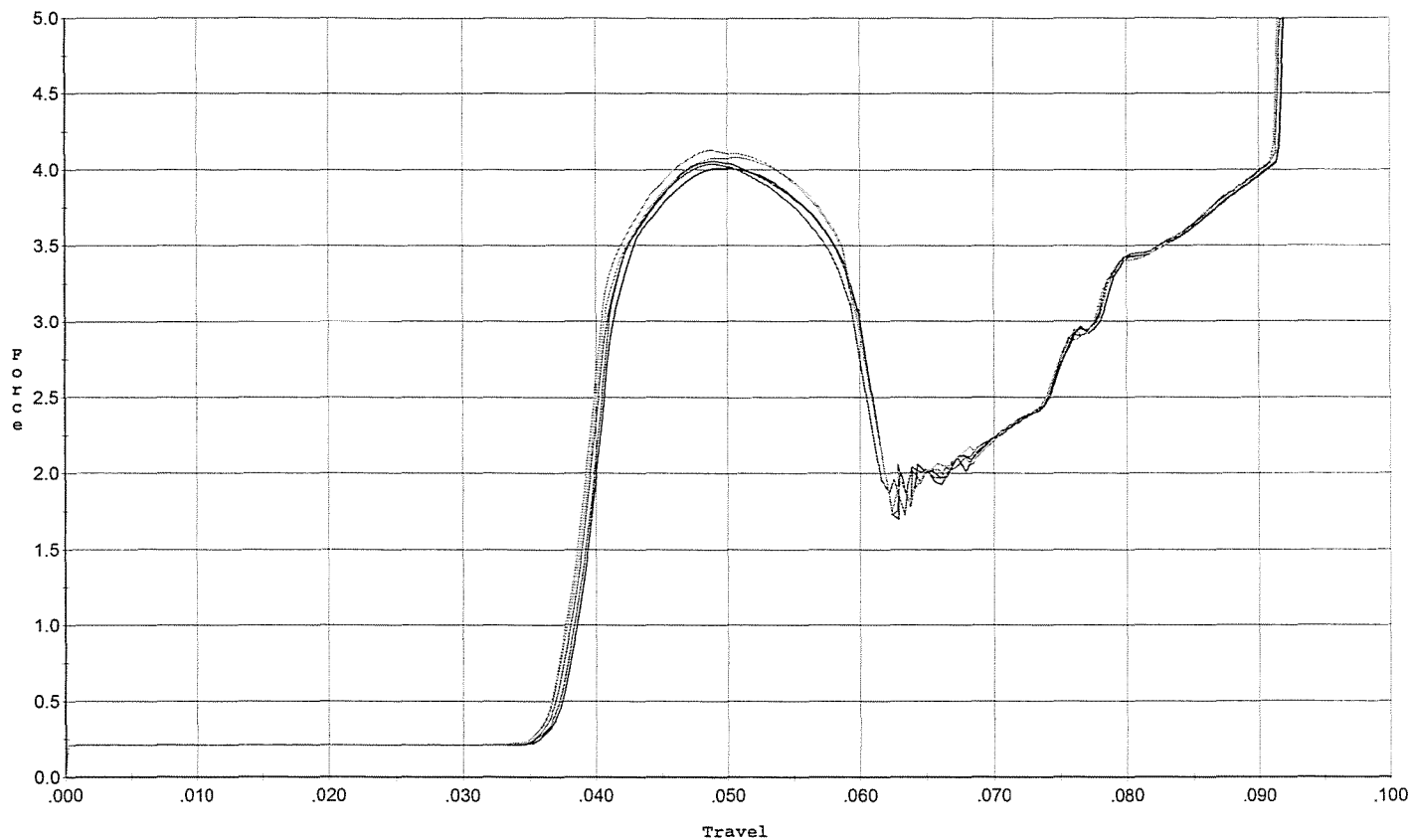
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.141	0.059	0.037	0.038	0.065		Set Trigger
2	3.138	0.060	0.037	0.038	0.066		Set Trigger
3	3.087	0.059	0.037	0.038	0.065		Set Trigger
4	3.041	0.060	0.037	0.038	0.065		Set Trigger
5	3.067	0.059	0.037	0.038	0.065		Set Trigger

AVG 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



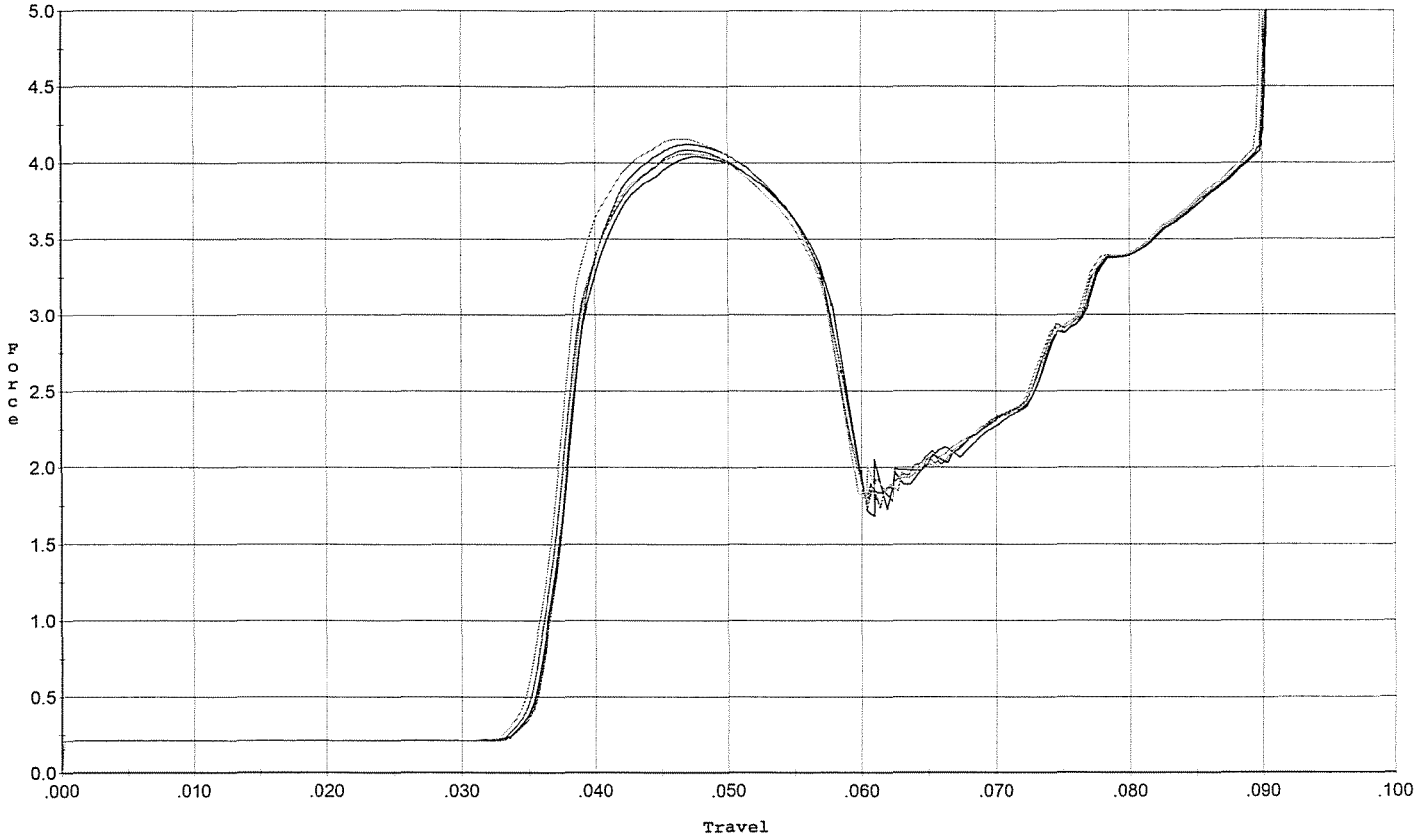
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.060	0.037	0.036	0.086		Set Trigger
2	4.011	0.060	0.037	0.037	0.085		Set Trigger
3	4.039	0.059	0.037	0.037	0.085		Set Trigger
4	4.080	0.060	0.036	0.036	0.089		Set Trigger
5	4.129	0.060	0.036	0.036	0.090		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



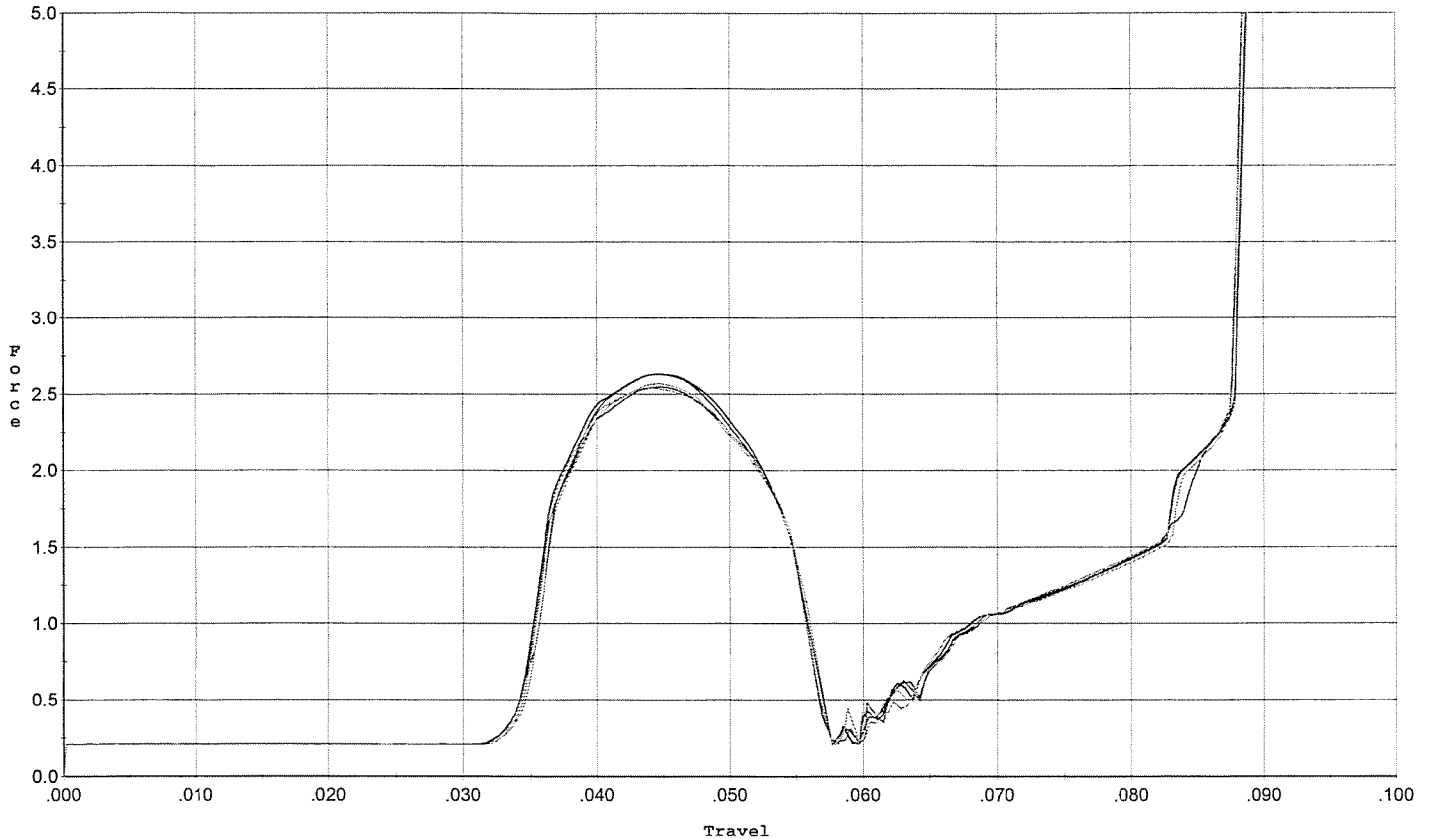
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.122	0.059	0.035	0.036	0.087		Set Trigger
2	4.041	0.058	0.035	0.036	0.085		Set Trigger
3	4.085	0.057	0.035	0.036	0.084		Set Trigger
4	4.159	0.057	0.034	0.036	0.087		Set Trigger
5	4.059	0.057	0.035	0.037	0.083		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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



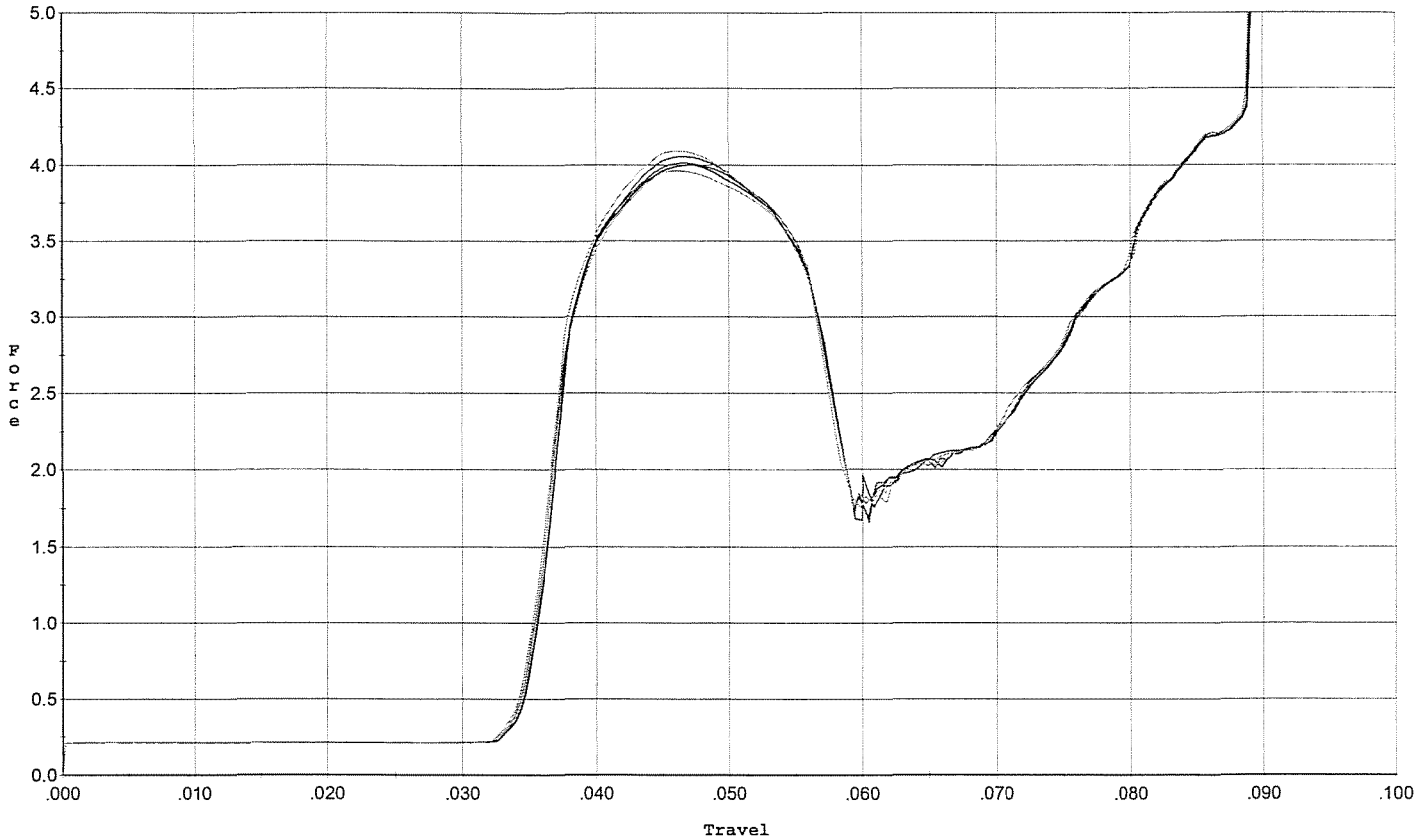
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.055	0.034	0.038	0.051		Set Trigger
2	2.632	0.055	0.034	0.038	0.052		Set Trigger
3	2.549	0.055	0.034	0.038	0.051		Set Trigger
4	2.570	0.056	0.034	0.038	0.051		Set Trigger
5	2.540	0.055	0.034	0.038	0.051		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/12/07

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	4.013	0.057	0.034	0.036	0.084		Set Trigger
2	3.999	0.058	0.034	0.036	0.085		Set Trigger
3	4.056	0.057	0.034	0.036	0.085		Set Trigger
4	4.092	0.056	0.034	0.036	0.083		Set Trigger
5	3.963	0.056	0.034	0.036	0.082		Set Trigger

AVG 4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693302.___0

FILE DATE AND TIME: 10/23/2007 20:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

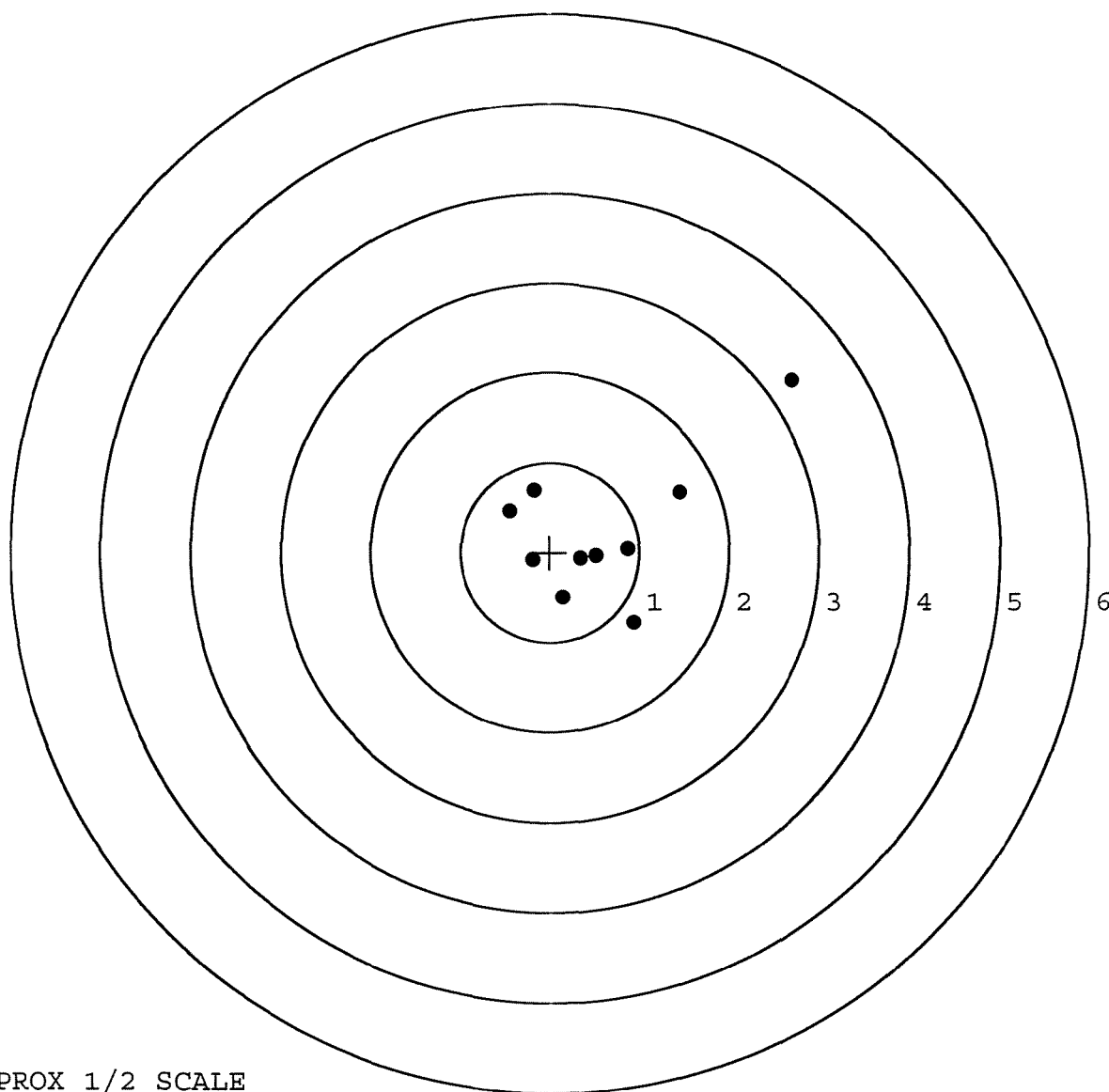
The Average X Centroid of the Five Target Set:	0.134
The Average Y Centroid of the Five Target Set:	0.090
The Average Point of Impact of the Five Target Set:	0.162
The Average Mean Radius of the Five Target Set:	0.677
The Distance from POA to Centroid Target #1:	0.658
The Distance from Centroid Target #2 to Centroid Target #1:	0.425
The Distance from Centroid Target #3 to Centroid Target #1:	0.680
The Distance from Centroid Target #4 to Centroid Target #1:	0.708
The Distance from Centroid Target #5 to Centroid Target #1:	0.722

SERIAL NUMBER: G6693302.____0
TARGET NUMBER: 1
FILE DATE: 10/23/2007
FILE TIME: 20:22

X CENTROID: 0.616
Y CENTROID: 0.231
POA TO CENTROID: 0.658
HORZ SPREAD: 3.149
VERT SPREAD: 2.689
GROUP SPREAD: 3.516
MIN RADIUS: 0.284
MAX RADIUS: 2.674
MEAN RADIUS: 0.942

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.176	0.689
2:	-0.450	0.465
3:	-0.190	-0.086
4:	0.141	-0.503
5:	0.352	-0.061
6:	0.526	-0.038
7:	0.875	0.046
8:	0.939	-0.780
9:	1.447	0.672
10:	2.699	1.909



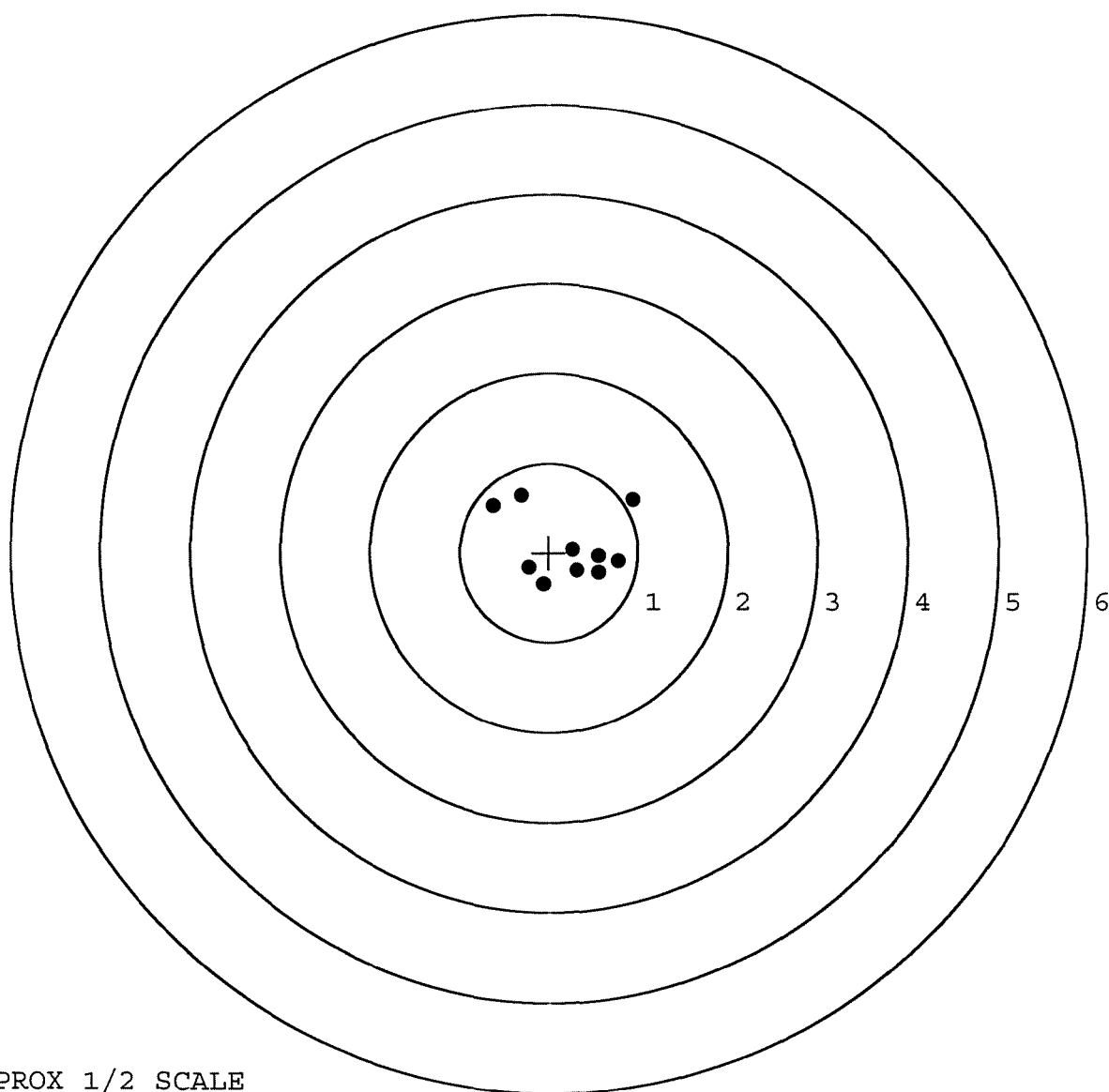
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693302.___0
TARGET NUMBER: 2
FILE DATE: 10/23/2007
FILE TIME: 20:22

X CENTROID: 0.223
Y CENTROID: 0.070
POA TO CENTROID: 0.233
HORZ SPREAD: 1.570
VERT SPREAD: 0.990
GROUP SPREAD: 1.571
MIN RADIUS: 0.056
MAX RADIUS: 0.961
MEAN RADIUS: 0.538

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.625	0.523
2:	-0.308	0.635
3:	-0.222	-0.173
4:	-0.063	-0.355
5:	0.945	0.589
6:	0.786	-0.094
7:	0.564	-0.223
8:	0.564	-0.035
9:	0.270	0.040
10:	0.315	-0.202

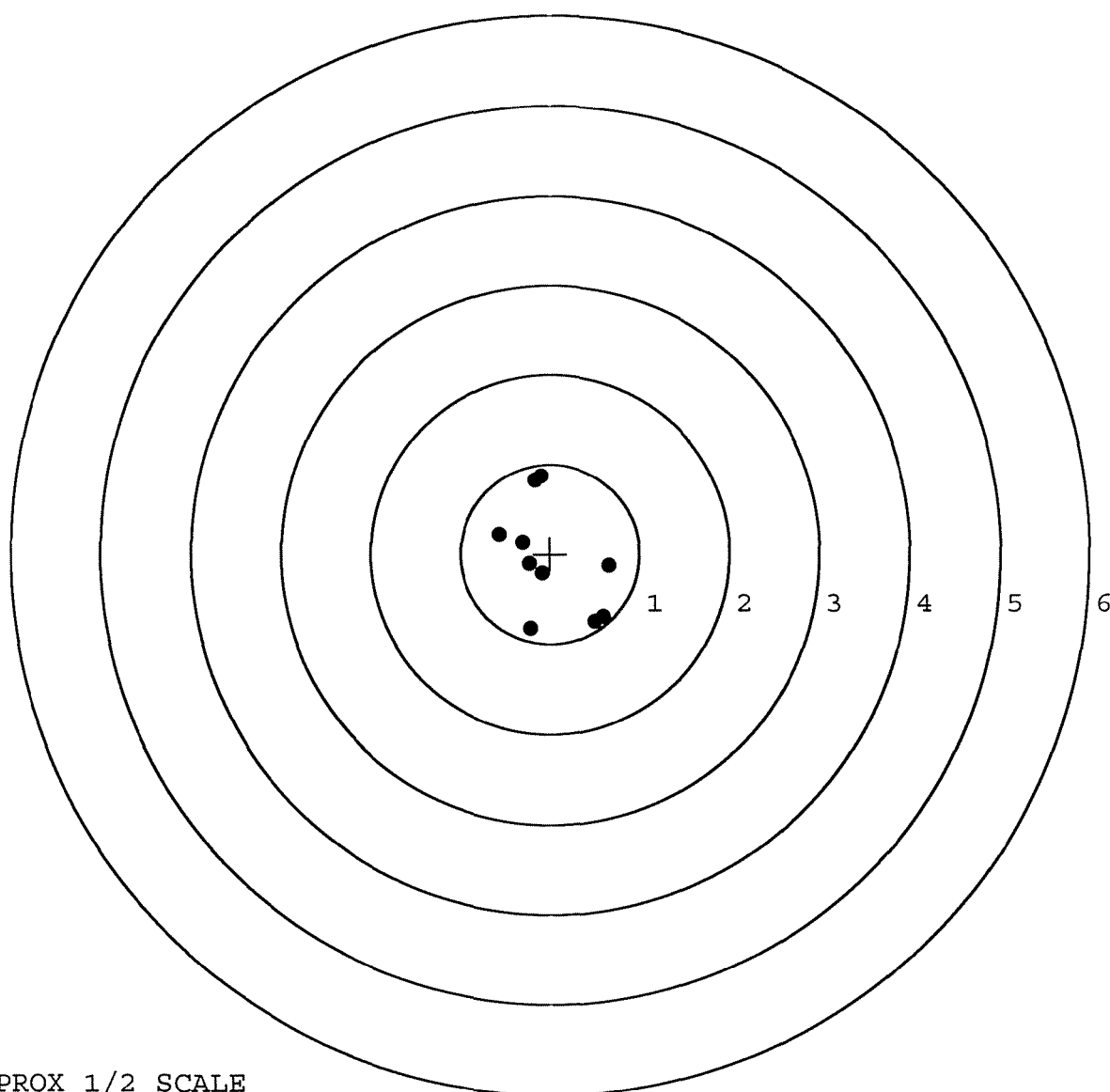


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693302. __0
 TARGET NUMBER: 3
 FILE DATE: 10/23/2007
 FILE TIME: 20:22

X CENTROID: 0.007
 Y CENTROID: -0.070
 POA TO CENTROID: 0.071
 HORZ SPREAD: 1.234
 VERT SPREAD: 1.708
 GROUP SPREAD: 1.737
 MIN RADIUS: 0.175
 MAX RADIUS: 0.950
 MEAN RADIUS: 0.646
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.170	0.821
2:	-0.105	0.873
3:	0.664	-0.130
4:	0.599	-0.701
5:	-0.226	-0.835
6:	-0.091	-0.215
7:	-0.229	-0.108
8:	-0.310	0.132
9:	-0.570	0.215
10:	0.504	-0.754

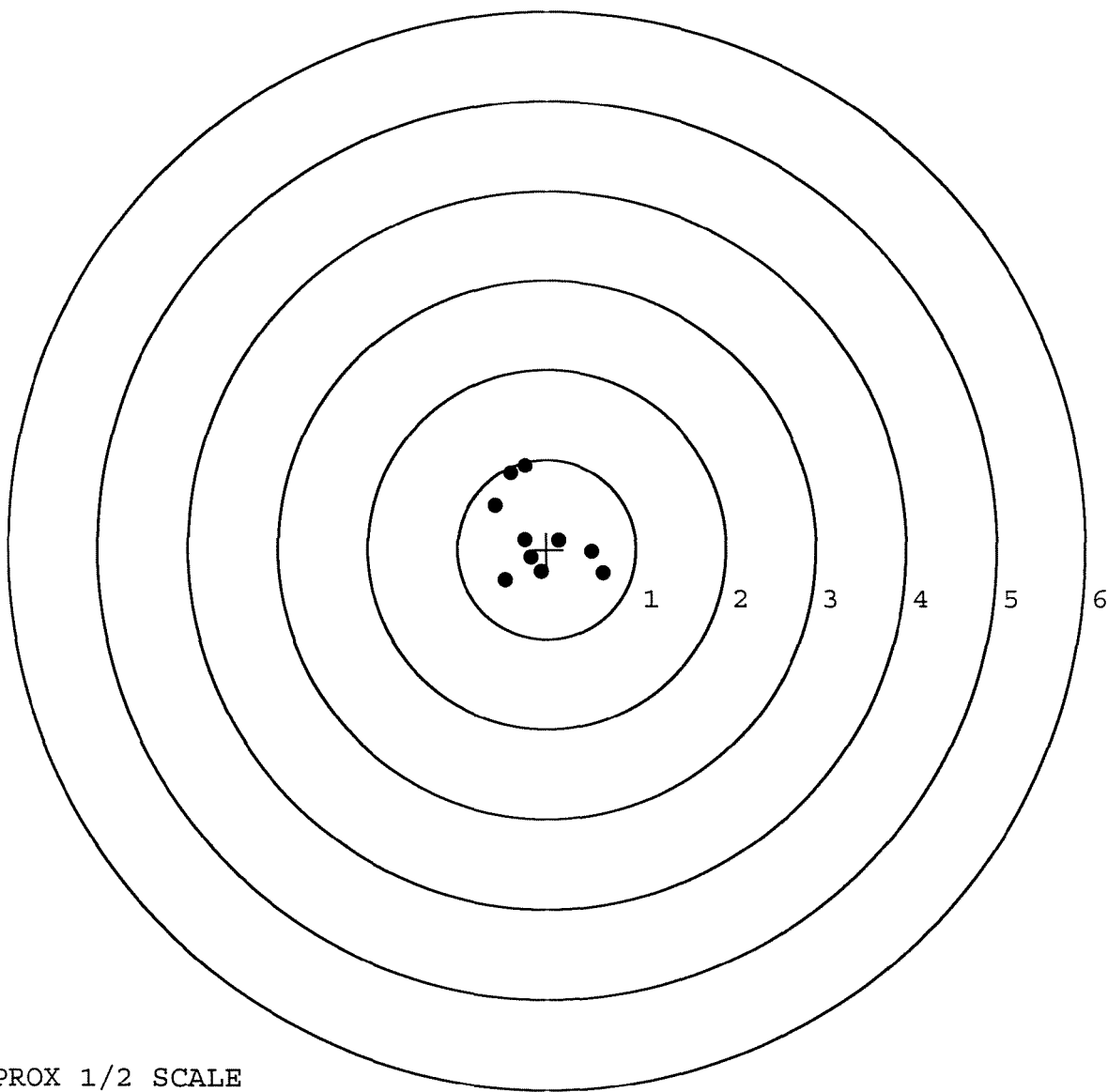


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693302.___0
TARGET NUMBER: 4
FILE DATE: 10/23/2007
FILE TIME: 20:22

X CENTROID: -0.087
Y CENTROID: 0.152
POA TO CENTROID: 0.175
HORZ SPREAD: 1.213
VERT SPREAD: 1.271
GROUP SPREAD: 1.521
MIN RADIUS: 0.159
MAX RADIUS: 0.834
MEAN RADIUS: 0.528
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.637	-0.261
2:	0.507	-0.021
3:	0.139	0.101
4:	-0.061	-0.250
5:	-0.241	0.109
6:	-0.462	-0.340
7:	-0.576	0.488
8:	-0.402	0.850
9:	-0.240	0.931
10:	-0.174	-0.091

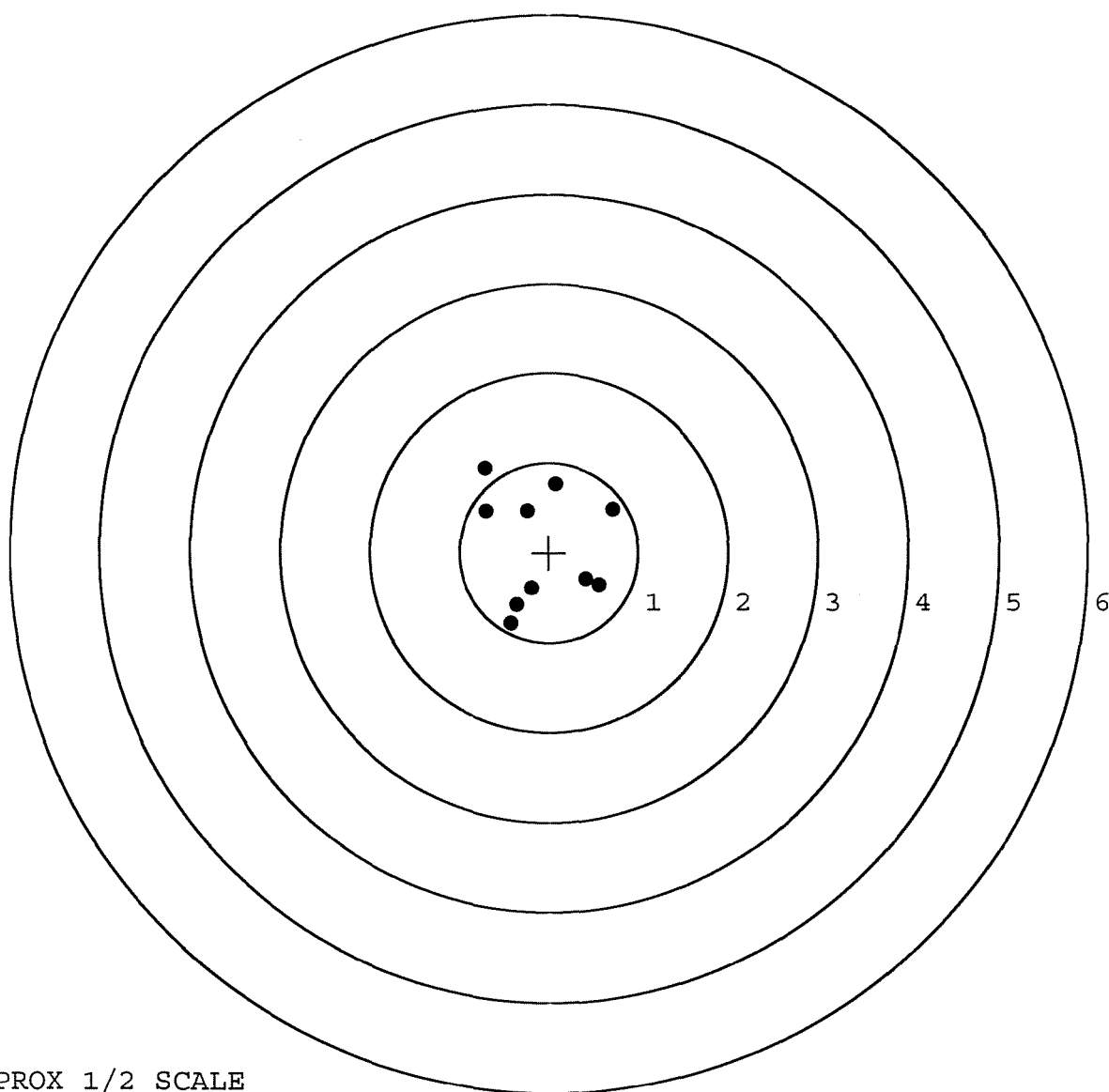


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693302. __0
TARGET NUMBER: 5
FILE DATE: 10/23/2007
FILE TIME: 20:22

X CENTROID: -0.087
Y CENTROID: 0.067
POA TO CENTROID: 0.110
HORZ SPREAD: 1.427
VERT SPREAD: 1.724
GROUP SPREAD: 1.816
MIN RADIUS: 0.422
MAX RADIUS: 1.069
MEAN RADIUS: 0.733
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.709	0.937
2:	-0.706	0.457
3:	-0.243	0.459
4:	0.076	0.760
5:	0.718	0.474
6:	0.564	-0.358
7:	0.418	-0.287
8:	-0.196	-0.396
9:	-0.362	-0.585
10:	-0.427	-0.787



TARGET APPROX 1/2 SCALE