

9669 9808

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

- INSTRUCTION BOOK 3518

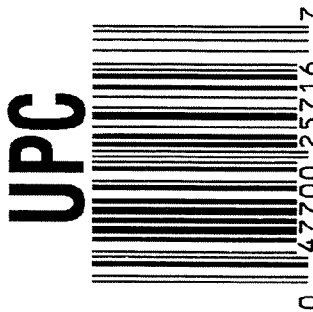


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6699808



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66699808

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-5-08	RTZ
420	ASSEMBLE ACTION		3-5-08	S.P.D.
430	ASSEMBLE TO STOCK		3-5-08	TRW
440	PROOF	MAGNA - FLUX	3-5-08	TRW
460	CHECK HEADSPACE		3-5-08	TRW
470	DIS-ASSEMBLE ACTION		3-6-08	S.P.D.
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unus</u>	3/7/08	unus
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-6-08	CW
510	DRILL AND TAP SIGHT HOLES		3-6-08	TRW
520	GOFF BLAST BBL / REC		3-10-08	TL
530 & 540	APPLY COATINGS (BARREL ACTION)		3/12/08	cm
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-17-08	S.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-17-08	S.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-17-08	S.P.D.
	D) OIL FIRING PIN ASSEMBLY		3-18-08	S.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

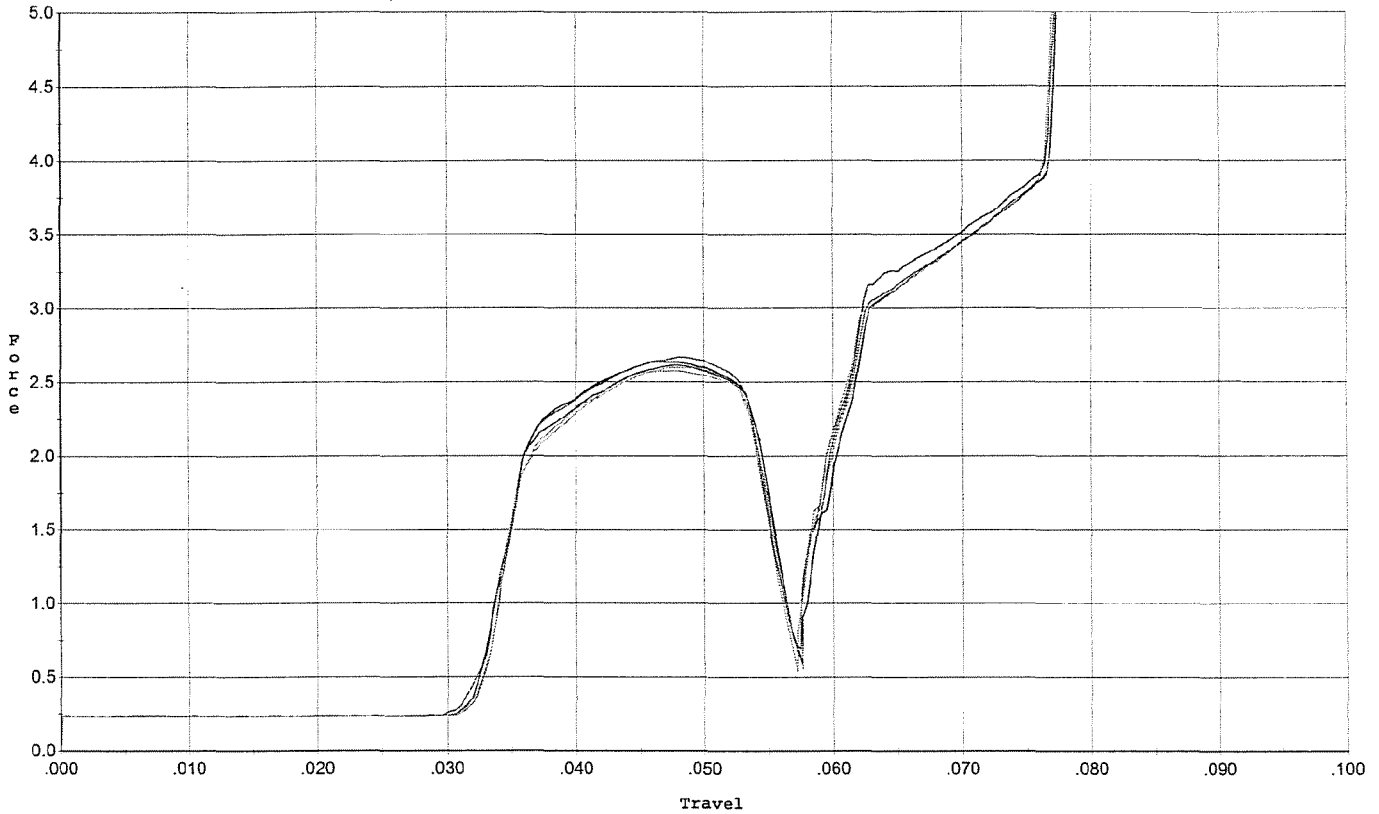
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8</u> <u>8</u> <u>8</u>	4-1-08	Fm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5</u> <u>4.5</u> <u>4.5</u>	4-1-08	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.023</u> <u>.023</u>	4-1-08	Fm
	J) ASSEMBLE STOCK		3-18-08	TRW
	K) ASSEMBLE SWIVEL STUDS		4-1-08	Fm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-9-08	TRW
	M) IRON SIGHT ALIGNMENT		4-9-08	TRW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-9-08	TRW
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-26-08	TRW
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-08	RP
670	FINAL INSPECTION A) HEADSPACE		4-9-08	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>290</u> <u>286</u> <u>287</u> <u>296</u> <u>296</u>	4-9-08	RTL
	C) FUNCTION		4-9-08	RTL
690	PACK		4/14/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/22/08

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



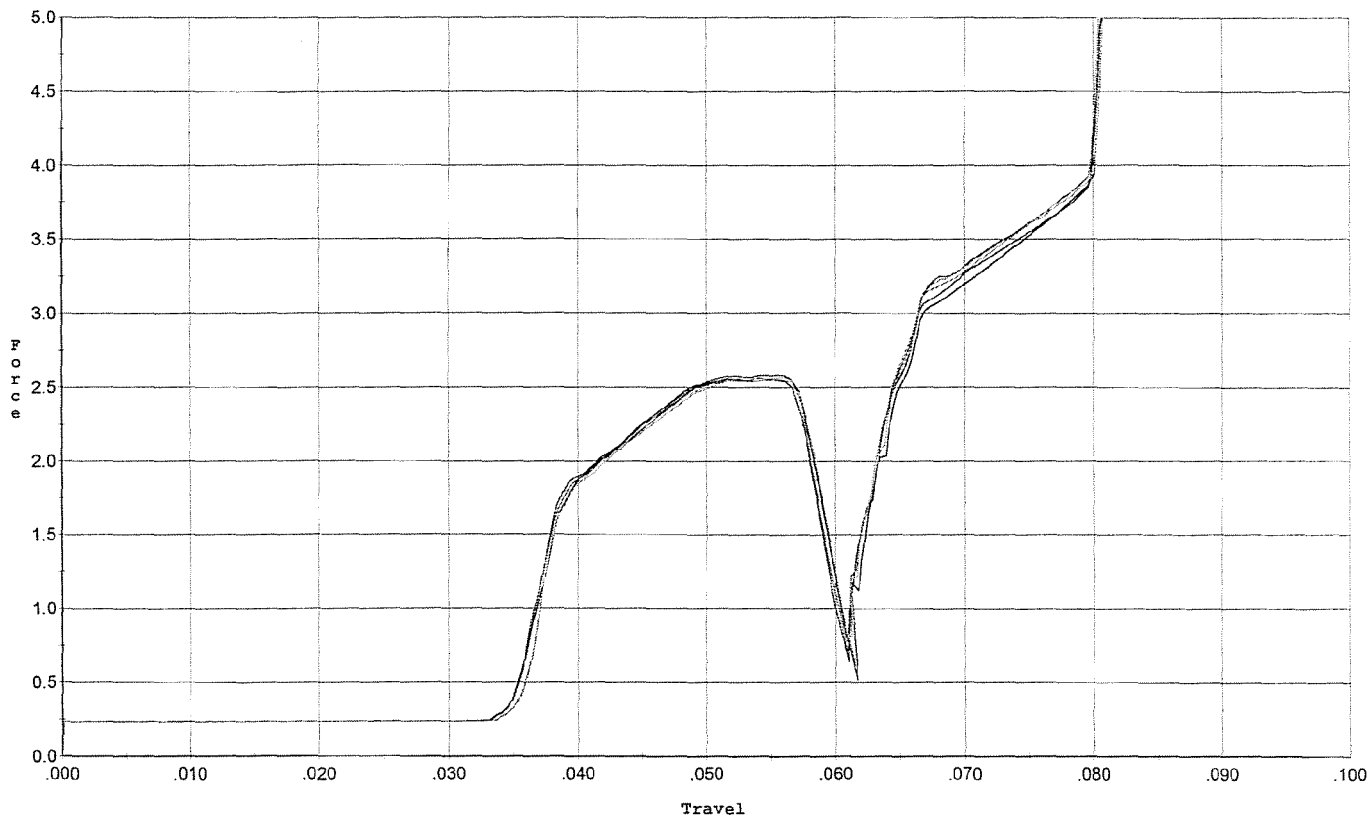
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.613	0.053	0.032	0.030	0.056		Set Trigger
2	2.637	0.054	0.032	0.029	0.058		Set Trigger
3	2.667	0.055	0.031	0.029	0.059		Set Trigger
4	2.576	0.055	0.032	0.029	0.057		Set Trigger
5	2.600	0.054	0.032	0.030	0.055		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/22/08

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



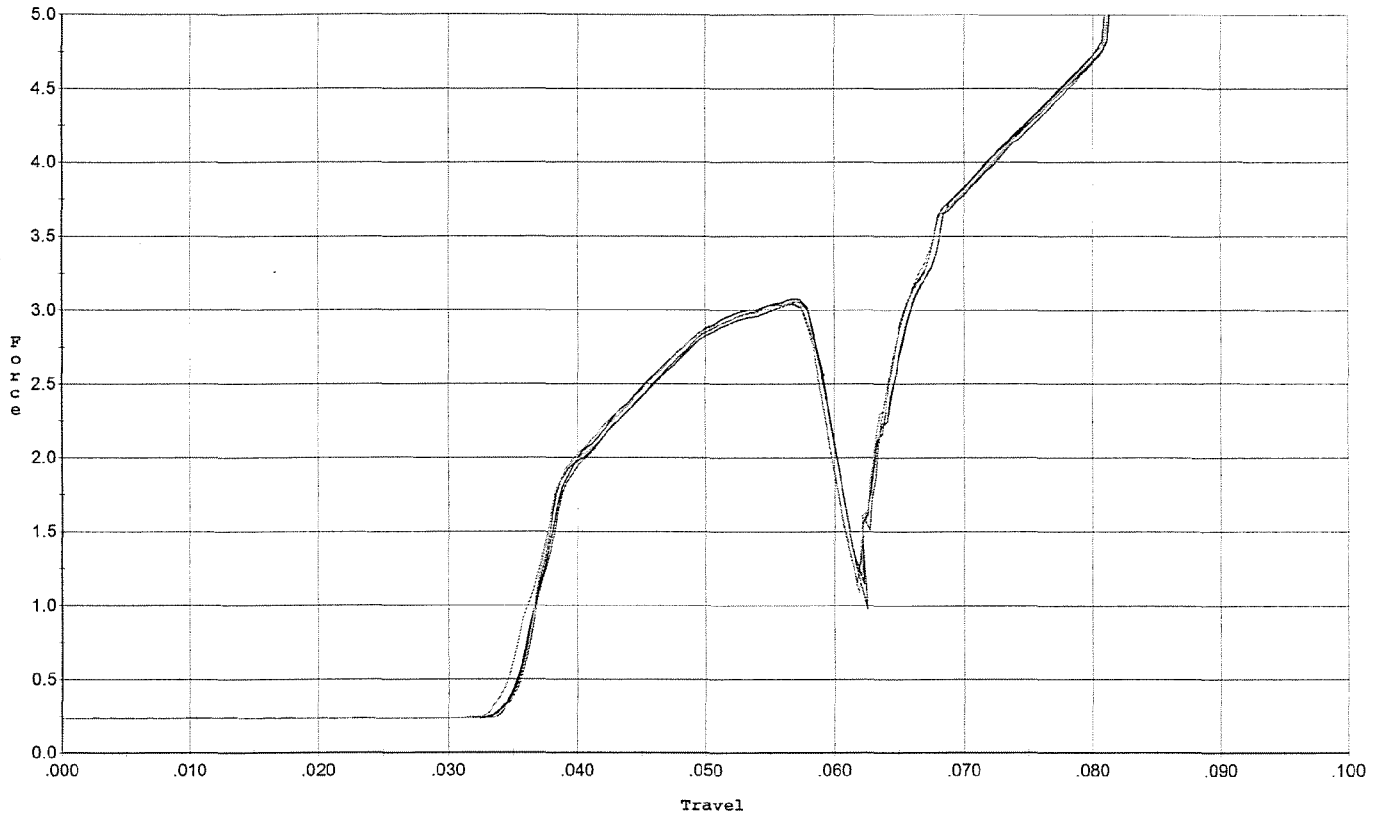
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.058	0.035	0.029	0.057		Set Trigger
2	2.551	0.059	0.035	0.029	0.058		Set Trigger
3	2.585	0.057	0.035	0.029	0.057		Set Trigger
4	2.570	0.058	0.035	0.029	0.058		Set Trigger
5	2.557	0.057	0.036	0.029	0.056		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/22/08

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



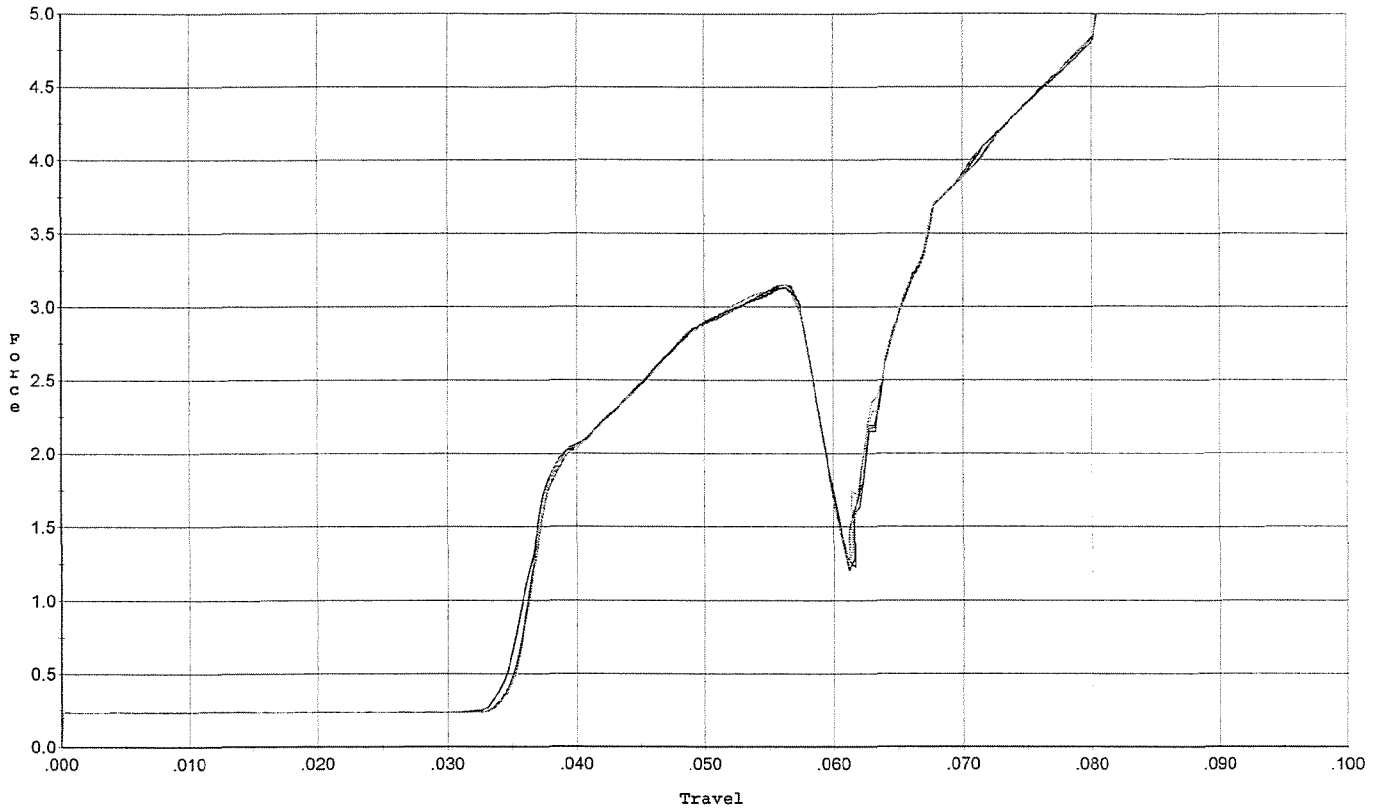
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.038	0.058	0.034	0.028	0.065		Set Trigger
2	3.074	0.059	0.035	0.028	0.068		Set Trigger
3	3.058	0.059	0.035	0.028	0.067		Set Trigger
4	3.060	0.058	0.035	0.028	0.066		Set Trigger
5	3.049	0.058	0.034	0.028	0.066		Set Trigger

AVG 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/22/08

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



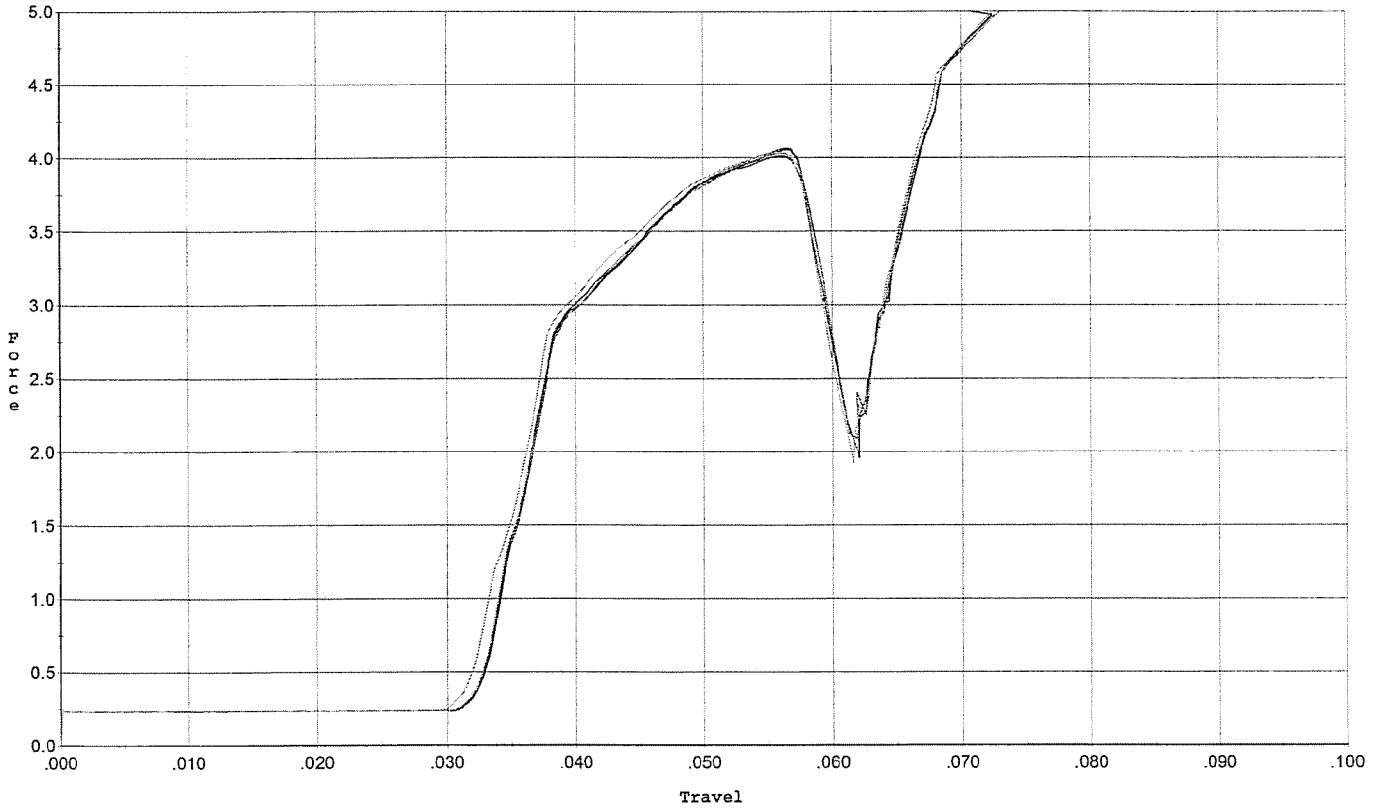
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.057	0.034	0.028	0.065		Set Trigger
2	3.130	0.058	0.034	0.028	0.066		Set Trigger
3	3.150	0.057	0.034	0.028	0.066		Set Trigger
4	3.123	0.058	0.035	0.028	0.065		Set Trigger
5	3.152	0.058	0.035	0.028	0.066		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/22/08

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



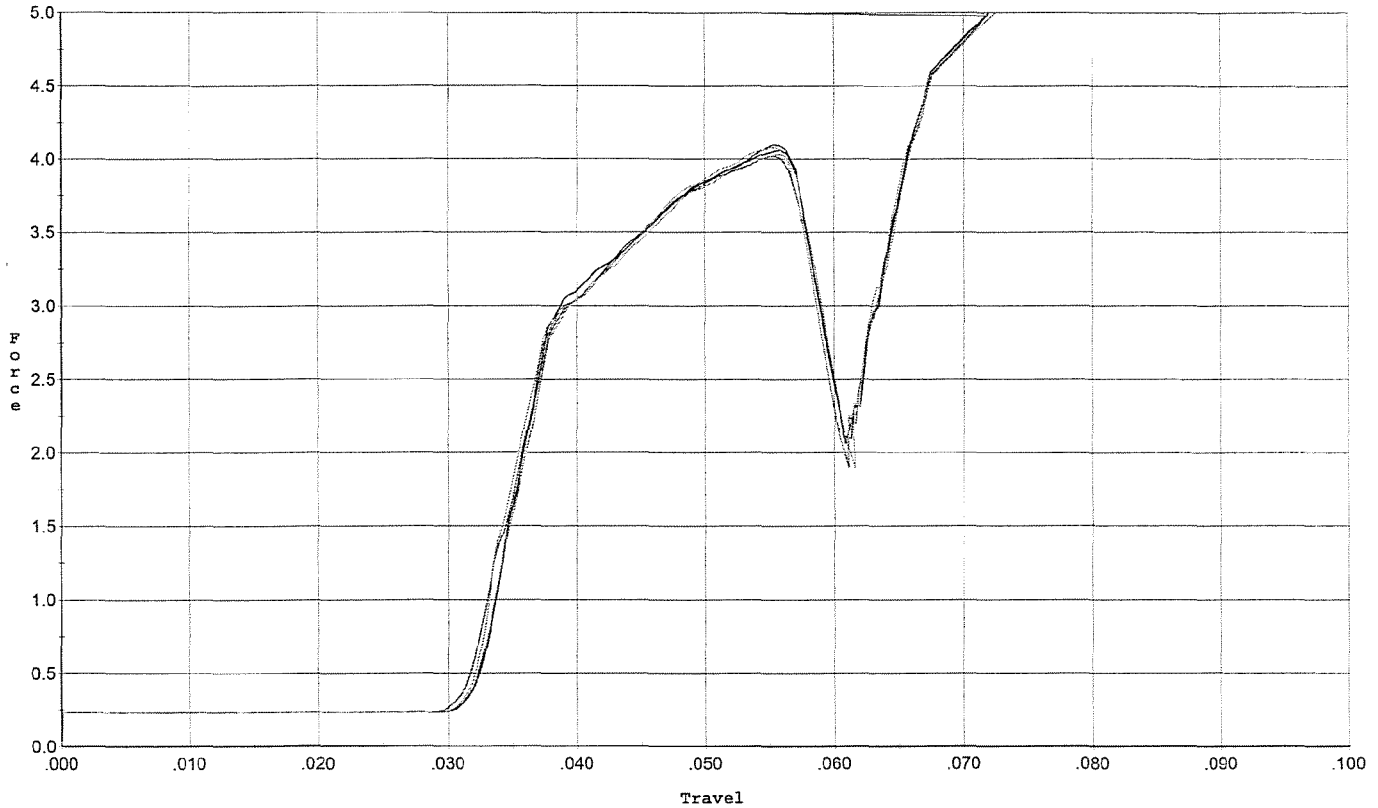
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.012	0.059	0.032	0.026	0.093		Set Trigger
2	4.056	0.059	0.032	0.026	0.092		Set Trigger
3	4.067	0.059	0.032	0.026	0.092		Set Trigger
4	4.039	0.058	0.031	0.026	0.092		Set Trigger
5	4.030	0.059	0.032	0.026	0.092		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/22/08

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



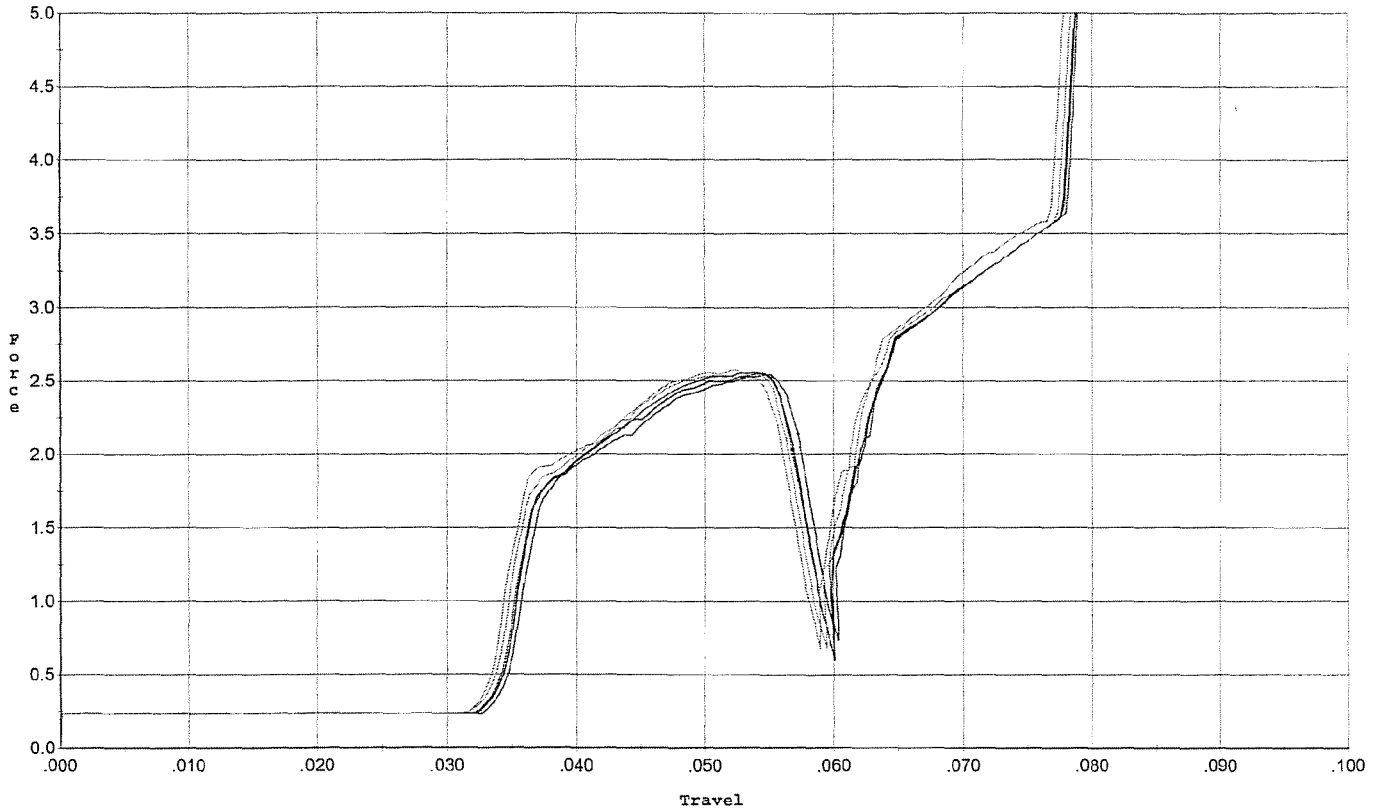
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.057	0.032	0.026	0.089		Set Trigger
2	4.064	0.057	0.032	0.026	0.090		Set Trigger
3	4.020	0.058	0.031	0.026	0.091		Set Trigger
4	4.081	0.058	0.032	0.026	0.091		Set Trigger
5	4.035	0.059	0.032	0.026	0.092		Set Trigger

AVG 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/22/08

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



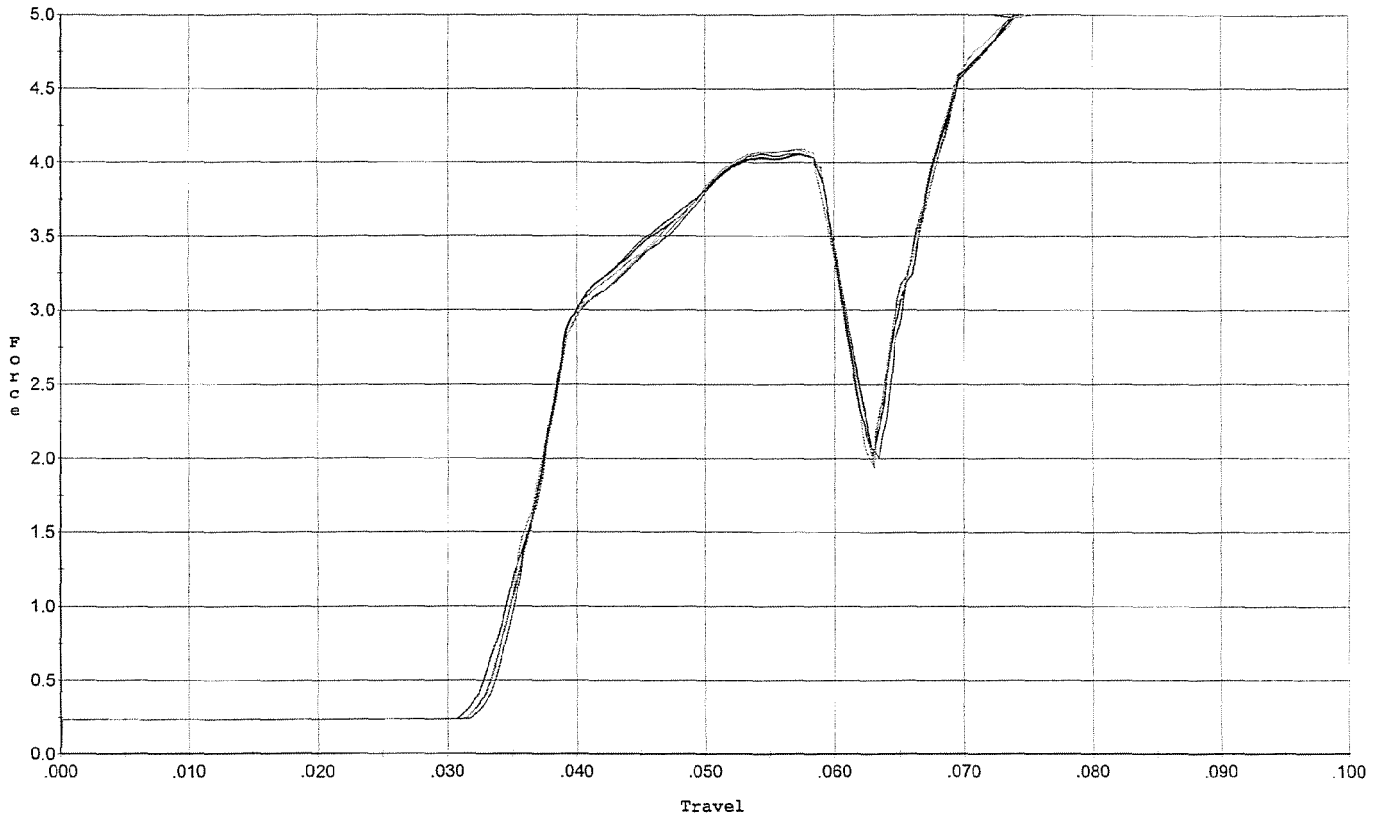
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.546	0.057	0.034	0.028	0.057		Set Trigger
2	2.554	0.057	0.034	0.028	0.057		Set Trigger
3	2.556	0.057	0.034	0.028	0.058		Set Trigger
4	2.576	0.056	0.033	0.029	0.057		Set Trigger
5	2.539	0.056	0.033	0.029	0.057		Set Trigger

AVG 2.55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/22/08

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	4.058	0.059	0.032	0.027	0.094		Set Trigger
2	4.053	0.059	0.033	0.026	0.093		Set Trigger
3	4.050	0.059	0.033	0.026	0.092		Set Trigger
4	4.091	0.059	0.033	0.026	0.093		Set Trigger
5	4.087	0.060	0.033	0.026	0.094		Set Trigger

AVG 4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6699808.__0

FILE DATE AND TIME: 03/28/2008 05:39

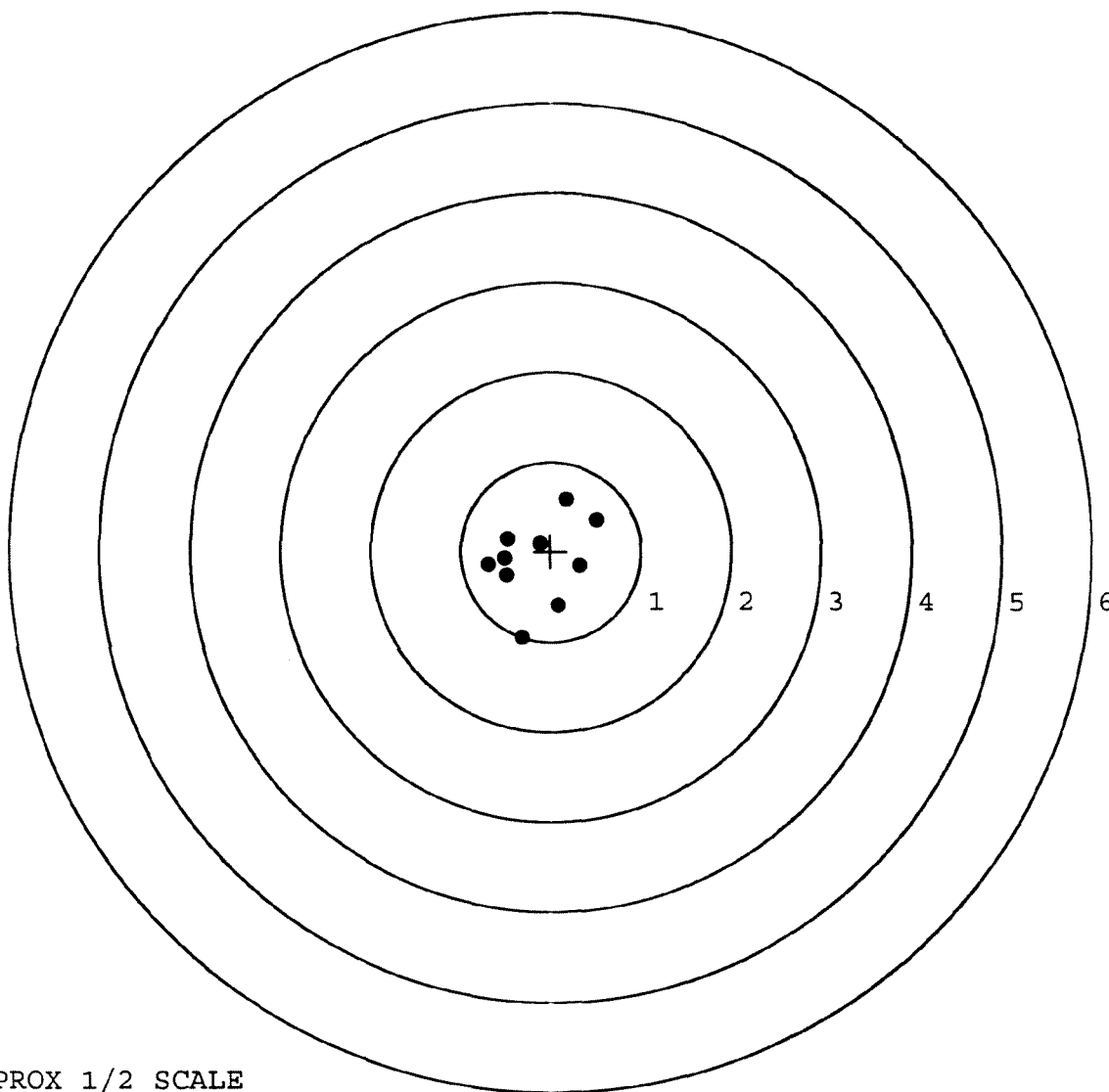
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.017
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.063
The Average Mean Radius of the Five Target Set:	0.760
The Distance from POA to Centroid Target #1:	0.186
The Distance from Centroid Target #2 to Centroid Target #1:	0.139
The Distance from Centroid Target #3 to Centroid Target #1:	0.184
The Distance from Centroid Target #4 to Centroid Target #1:	0.176
The Distance from Centroid Target #5 to Centroid Target #1:	0.288

SERIAL NUMBER: G6699808.___0
TARGET NUMBER: 1
FILE DATE: 03/28/2008
FILE TIME: 05:39

POINT#	X	Y
1:	-0.321	-0.955
2:	0.083	-0.606
3:	0.324	-0.163
4:	0.508	0.358
5:	0.170	0.582
6:	-0.119	0.088
7:	-0.486	0.142
8:	-0.688	-0.149
9:	-0.489	-0.269
10:	-0.511	-0.083

X CENTROID: -0.153
Y CENTROID: -0.106
POA TO CENTROID: 0.186
HORZ SPREAD: 1.196
VERT SPREAD: 1.537
GROUP SPREAD: 1.614
MIN RADIUS: 0.196
MAX RADIUS: 0.866
MEAN RADIUS: 0.535
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699808. 0

TARGET NUMBER: 2

FILE DATE: 03/28/2008

FILE TIME: 05:39

POINT#	X	Y
1:	1.039	0.206
2:	0.511	0.773
3:	-0.488	0.843
4:	-0.459	0.445
5:	-0.695	-0.082
6:	-0.235	-0.265
7:	0.417	-0.178
8:	0.295	-0.714
9:	0.007	-0.694
10:	-0.687	-0.747

X CENTROID: -0.030

Y CENTROID: -0.041

POA TO CENTROID: 0.051

HORZ SPREAD: 1.734

VERT SPREAD: 1.590

GROUP SPREAD: 1.972

MIN RADIUS: 0.304

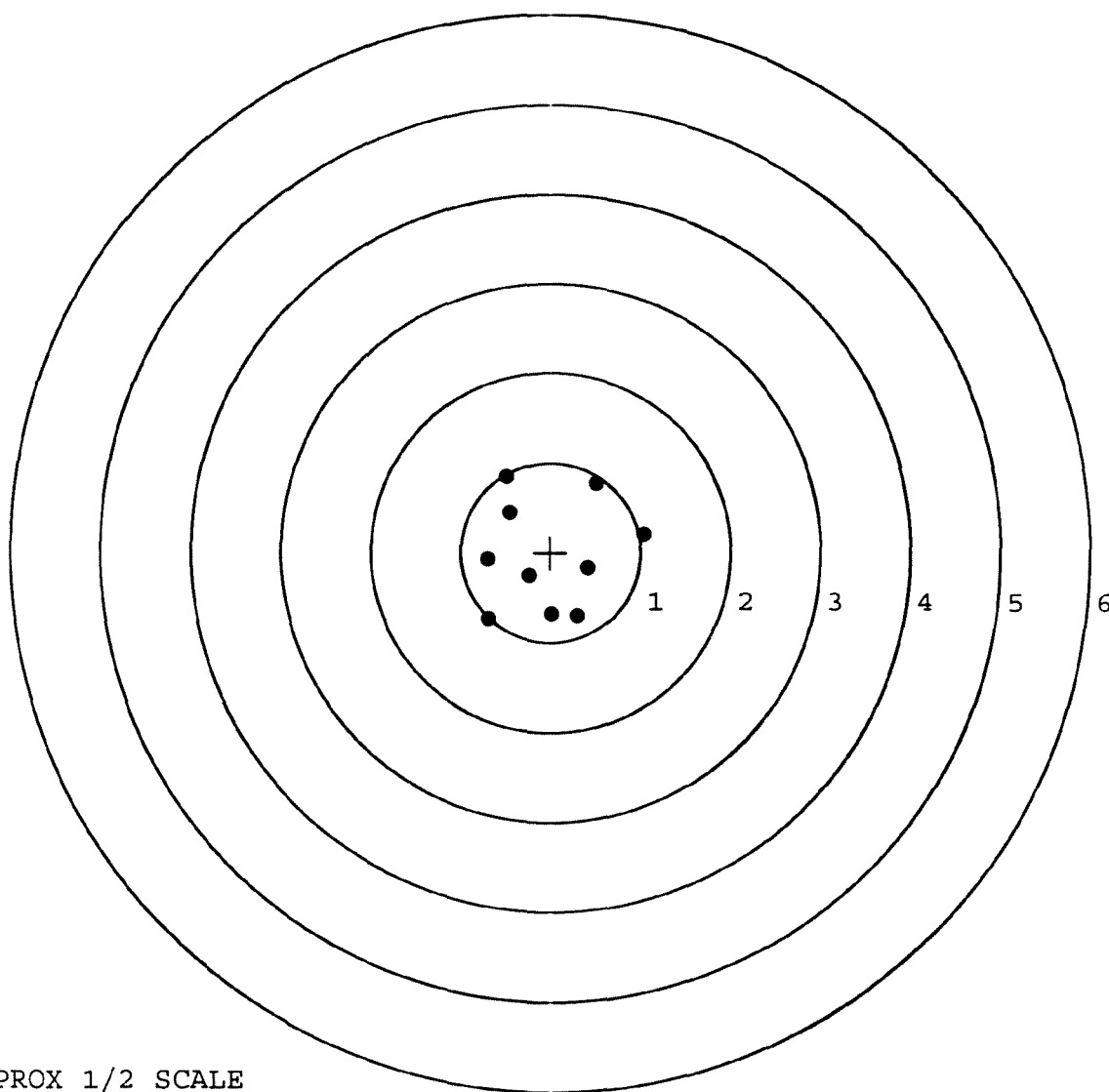
MAX RADIUS: 1.097

MEAN RADIUS: 0.752

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

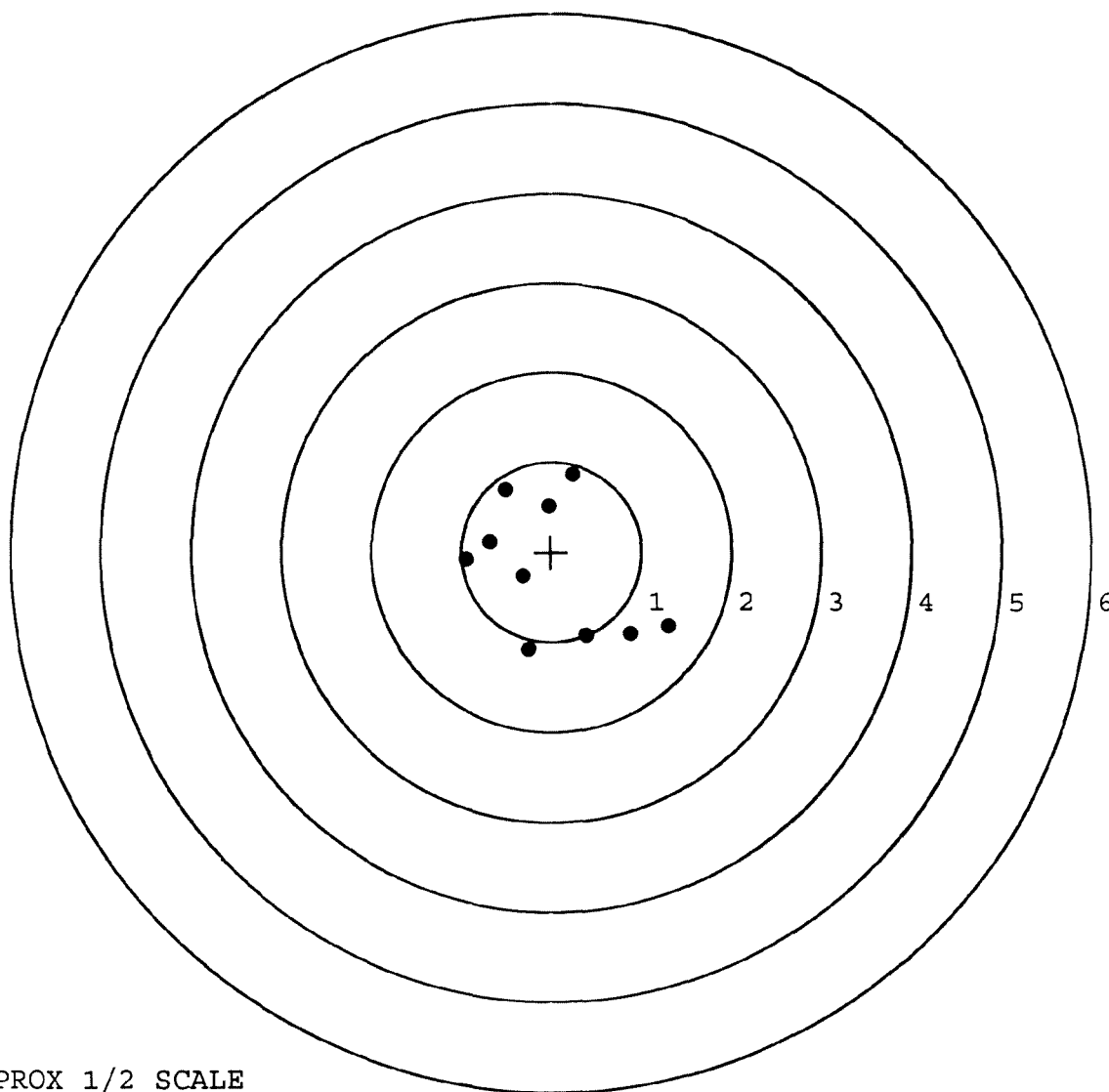


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699808.___0
TARGET NUMBER: 3
FILE DATE: 03/28/2008
FILE TIME: 05:39

POINT#	X	Y
1:	1.296	-0.830
2:	0.878	-0.908
3:	0.387	-0.929
4:	-0.248	-1.088
5:	-0.315	-0.271
6:	-0.942	-0.090
7:	-0.674	0.119
8:	-0.513	0.688
9:	-0.029	0.510
10:	0.245	0.860

X CENTROID: 0.009
Y CENTROID: -0.194
POA TO CENTROID: 0.194
HORZ SPREAD: 2.238
VERT SPREAD: 1.948
GROUP SPREAD: 2.362
MIN RADIUS: 0.333
MAX RADIUS: 1.436
MEAN RADIUS: 0.917
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

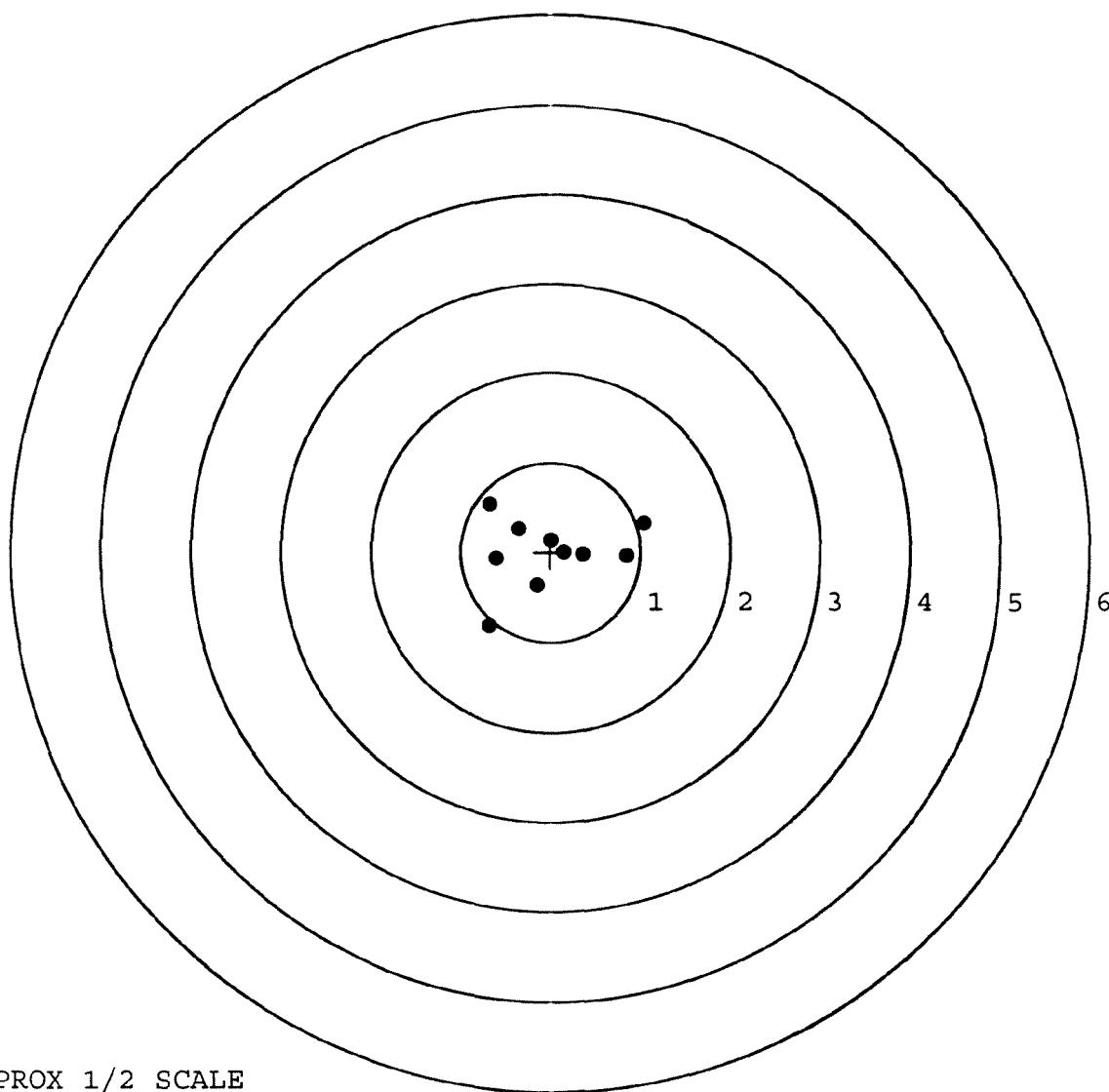


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699808.___0
TARGET NUMBER: 4
FILE DATE: 03/28/2008
FILE TIME: 05:39

POINT#	X	Y
1:	1.038	0.329
2:	0.850	-0.043
3:	0.362	-0.028
4:	0.013	0.136
5:	-0.359	0.264
6:	-0.680	0.536
7:	-0.603	-0.075
8:	-0.152	-0.378
9:	-0.683	-0.824
10:	0.151	0.004

X CENTROID: -0.006
Y CENTROID: -0.008
POA TO CENTROID: 0.010
HORZ SPREAD: 1.721
VERT SPREAD: 1.360
GROUP SPREAD: 2.072
MIN RADIUS: 0.145
MAX RADIUS: 1.097
MEAN RADIUS: 0.600
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699808. __0

TARGET NUMBER: 5

FILE DATE: 03/28/2008

FILE TIME: 05:39

POINT#	X	Y
1:	0.544	-1.140
2:	-0.445	-1.219
3:	-0.786	-0.220
4:	0.873	-0.382
5:	0.809	0.048
6:	0.506	0.134
7:	0.178	0.117
8:	-1.016	0.360
9:	-0.658	0.952
10:	0.937	1.781

X CENTROID: 0.094

Y CENTROID: 0.043

POA TO CENTROID: 0.104

HORZ SPREAD: 1.953

VERT SPREAD: 3.000

GROUP SPREAD: 3.303

MIN RADIUS: 0.112

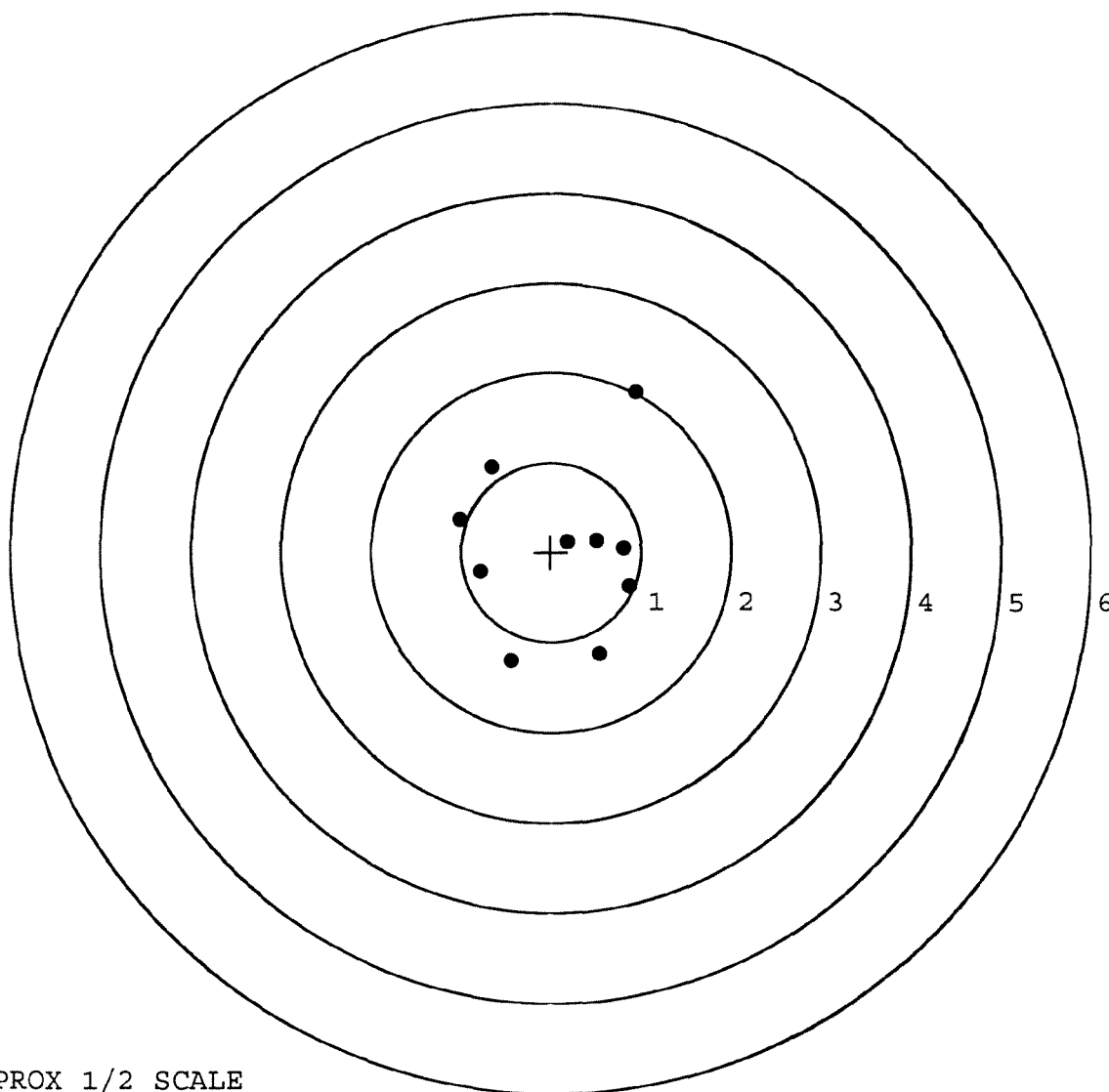
MAX RADIUS: 1.931

MEAN RADIUS: 0.996

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE