

G6695396

M24A2 7.62 NATO COMPLETE SYSTEM
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

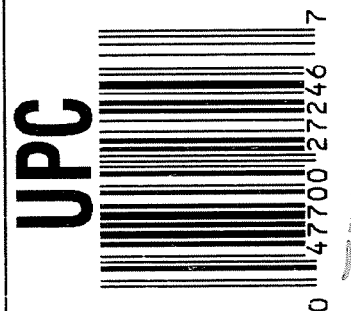


ORDER NO. **27246**

BARREL LENGTH 24"

CAPACITY 6

G6695390



ORDER 27246

M24A2 7.62 NATO COMPLETE SYSTEM

UPC



0 47700 27246 7

ORDER 27246

M24A2 7.62 NATO COMPLETE SYSTEM

UPC



0 47700 27246 7

SERIAL NO.



66695390

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6695390

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		1-14-08	RTZ
420	ASSEMBLE ACTION		1-14-08	RTZ
430	ASSEMBLE TO STOCK		1-14-08	RTZ
440	PROOF		1-14-08	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	1-14-08	TRW
470	DIS-ASSEMBLE ACTION	4 2008		
480	MAGNAFLUX BBL ACTION	OPERATOR <i>[Signature]</i>	1/14/08	<i>[Signature]</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		1/15/08	<i>[Signature]</i>
510	DRILL AND TAP SIGHT HOLES		1-15-08	<i>[Signature]</i>
520	GOFF BLAST BBL / REC			
530 & 540	APPLY COATINGS (BARREL ACTION)		1/15/08	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-16-08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-16-08	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-16-08	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-16-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

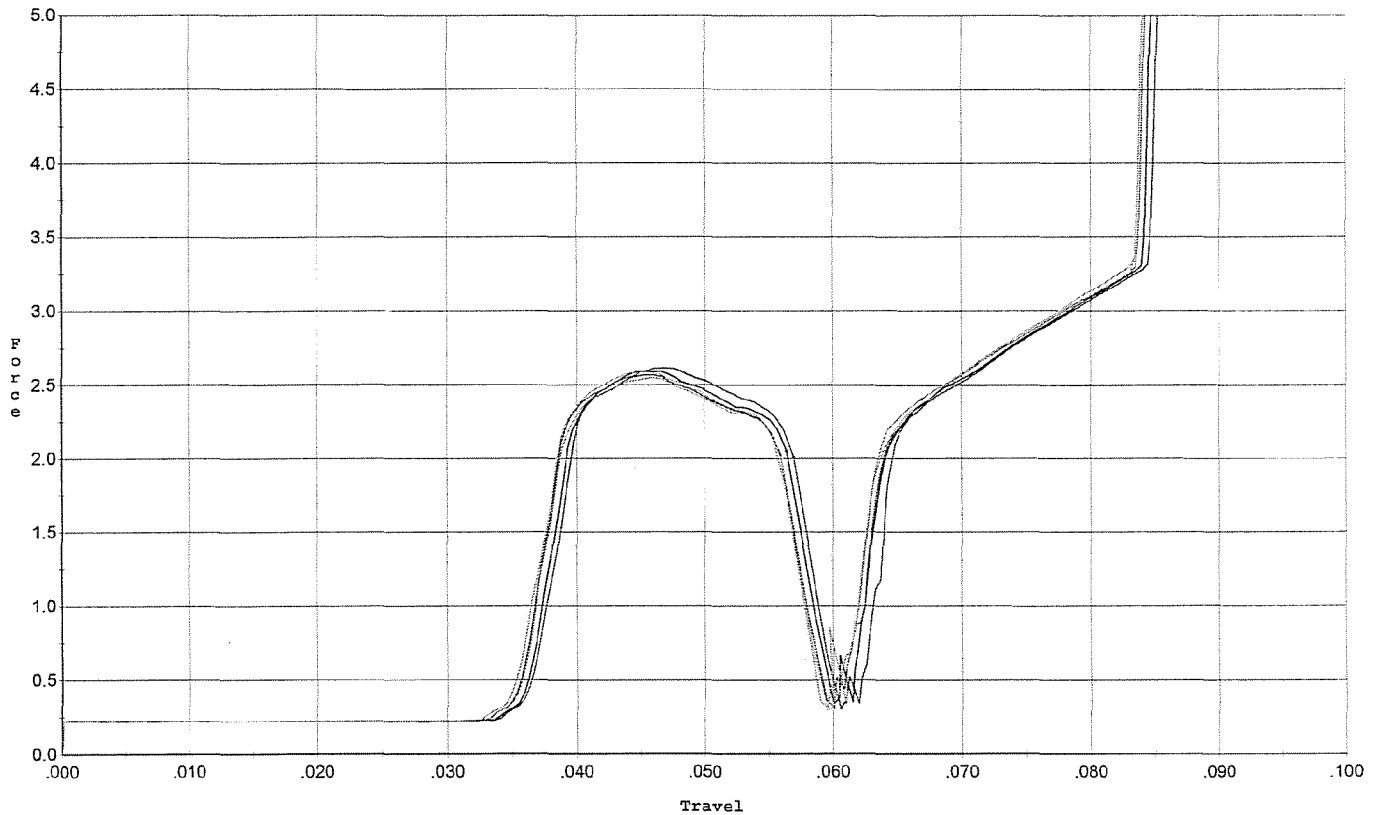
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>85</u> <u>85</u> <u>85</u>	1-18-08	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>35</u>	1-18-08	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	1-18-08	RA
	J) ASSEMBLE STOCK		1-16-08	RTL
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-17-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-17-08	Fm
670	FINAL INSPECTION A) HEADSPACE		1-18-08	PR
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>250</u> <u>245</u> <u>245</u> <u>255</u> <u>250</u>	1-18-08	RA
	C) FUNCTION		1-18-08	RTL
690	PACK		1-18-08	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



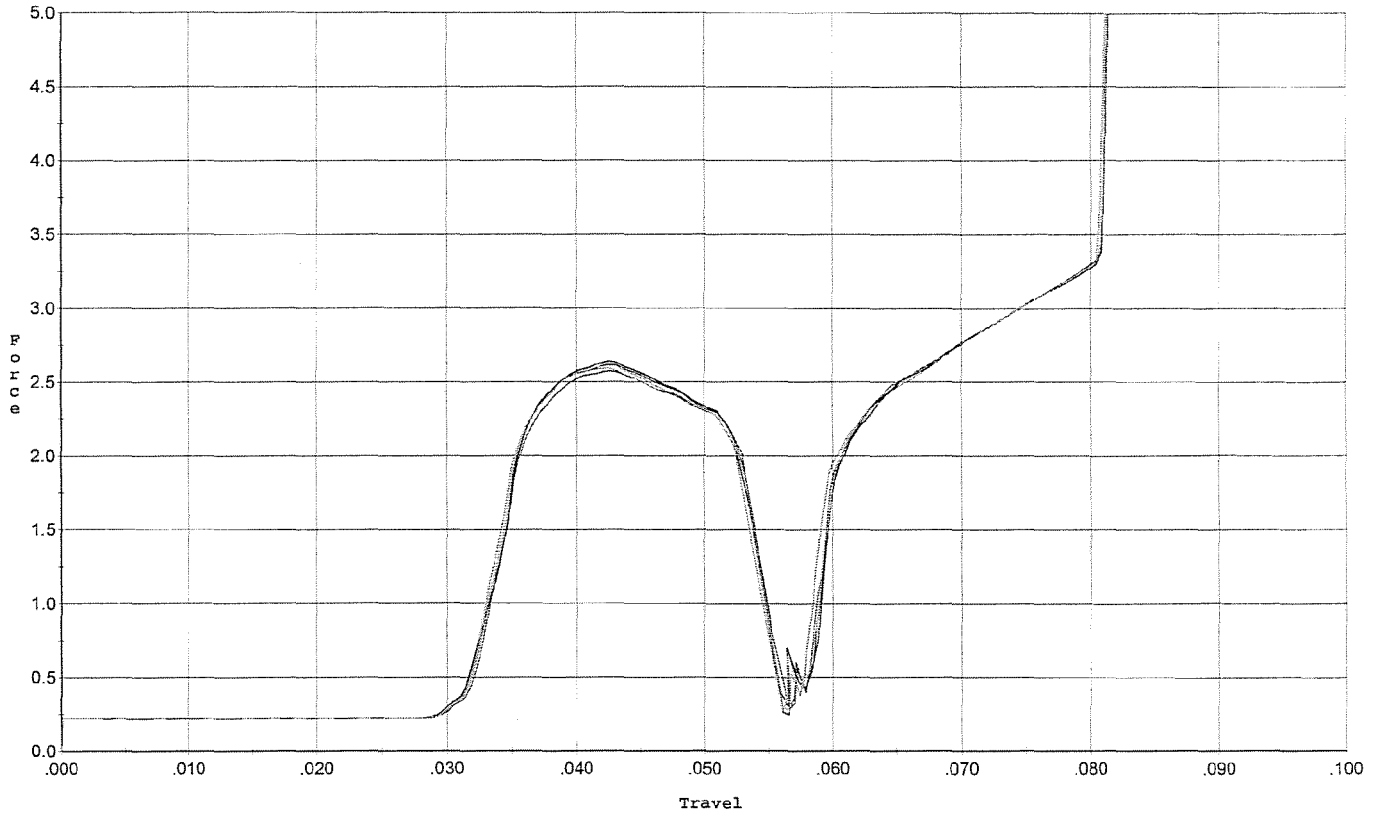
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.057	0.036	0.035	0.055		Set Trigger
2	2.591	0.056	0.036	0.035	0.054		Set Trigger
3	2.566	0.056	0.035	0.035	0.054		Set Trigger
4	2.546	0.056	0.035	0.035	0.054		Set Trigger
5	2.587	0.056	0.035	0.034	0.055		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



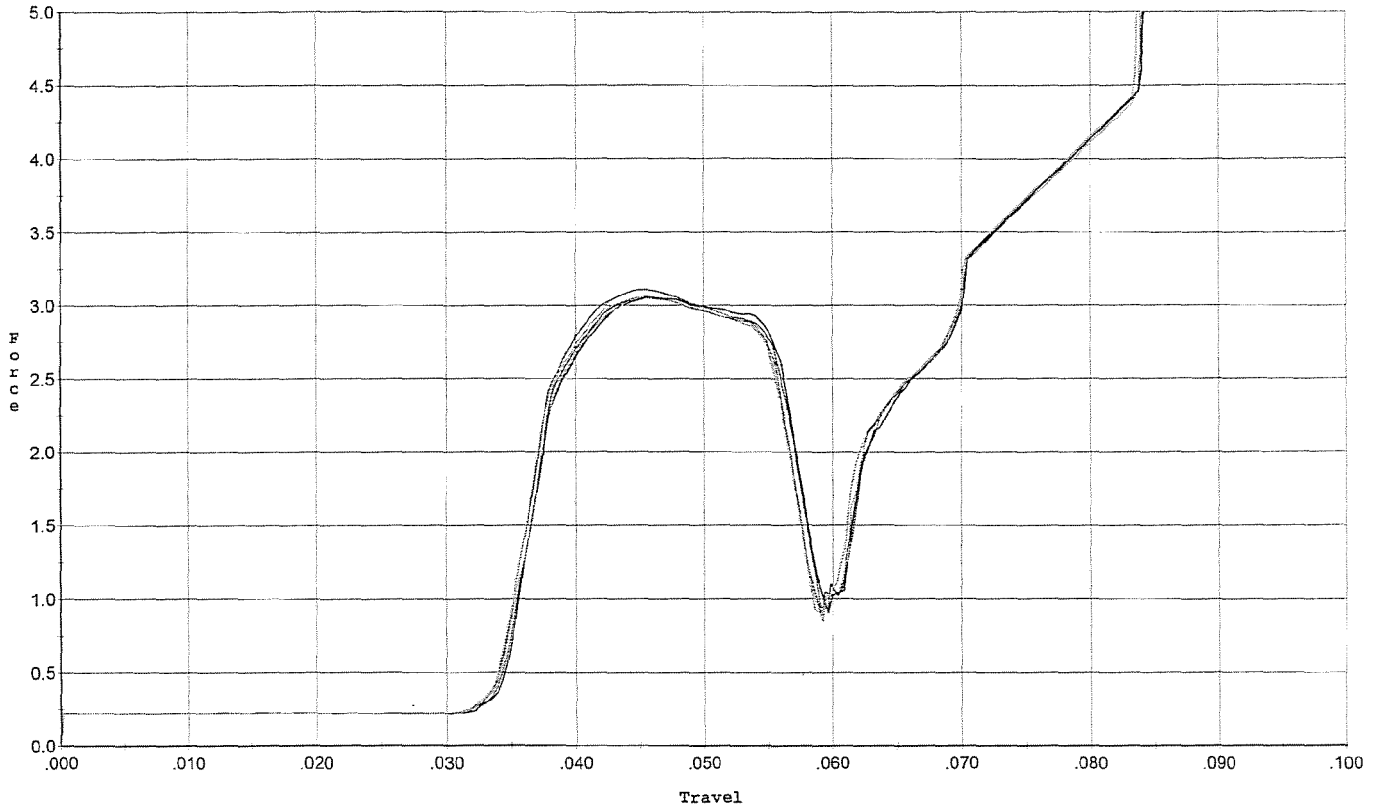
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.616	0.053	0.032	0.033	0.055		Set Trigger
2	2.639	0.053	0.031	0.033	0.055		Set Trigger
3	2.573	0.053	0.032	0.033	0.054		Set Trigger
4	2.610	0.053	0.032	0.033	0.055		Set Trigger
5	2.591	0.052	0.032	0.034	0.054		Set Trigger

AVG 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



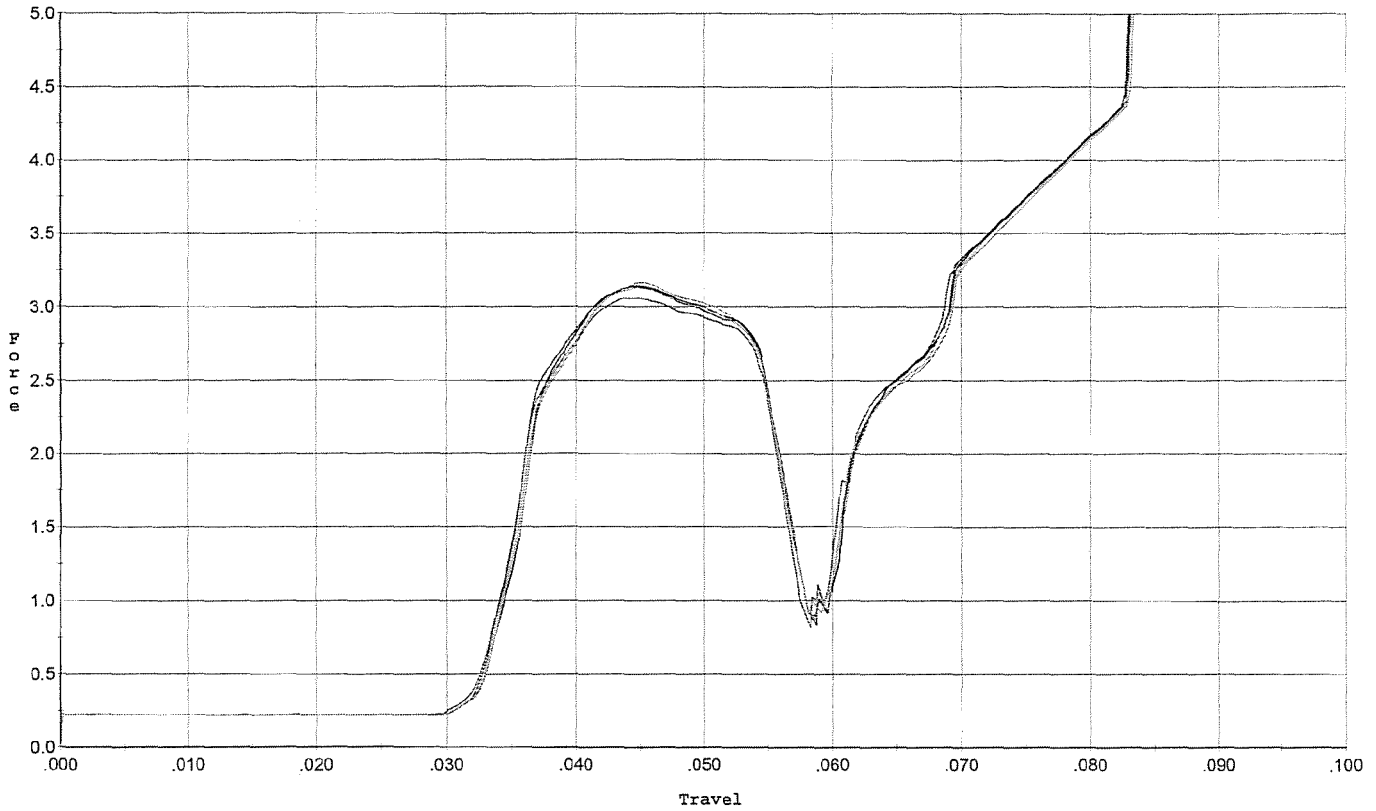
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.057	0.057	0.034	0.033	0.067		Set Trigger
2	3.054	0.056	0.034	0.034	0.066		Set Trigger
3	3.104	0.056	0.034	0.033	0.066		Set Trigger
4	3.055	0.056	0.034	0.033	0.066		Set Trigger
5	3.048	0.056	0.034	0.033	0.065		Set Trigger

AVG 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



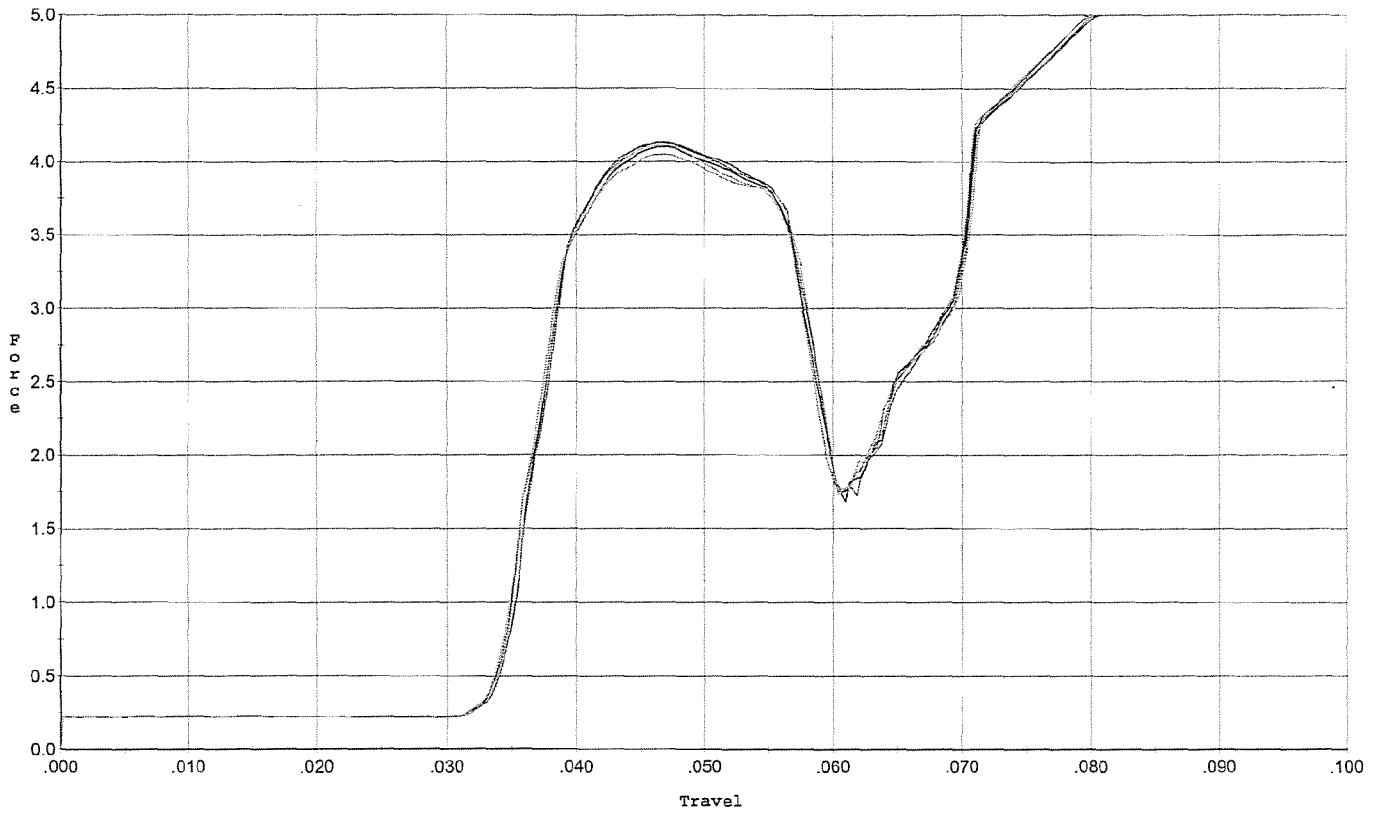
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.140	0.054	0.032	0.033	0.066		Set Trigger
2	3.136	0.056	0.033	0.033	0.068		Set Trigger
3	3.061	0.055	0.032	0.033	0.065		Set Trigger
4	3.131	0.056	0.033	0.033	0.067		Set Trigger
5	3.168	0.055	0.033	0.033	0.065		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/17/08

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



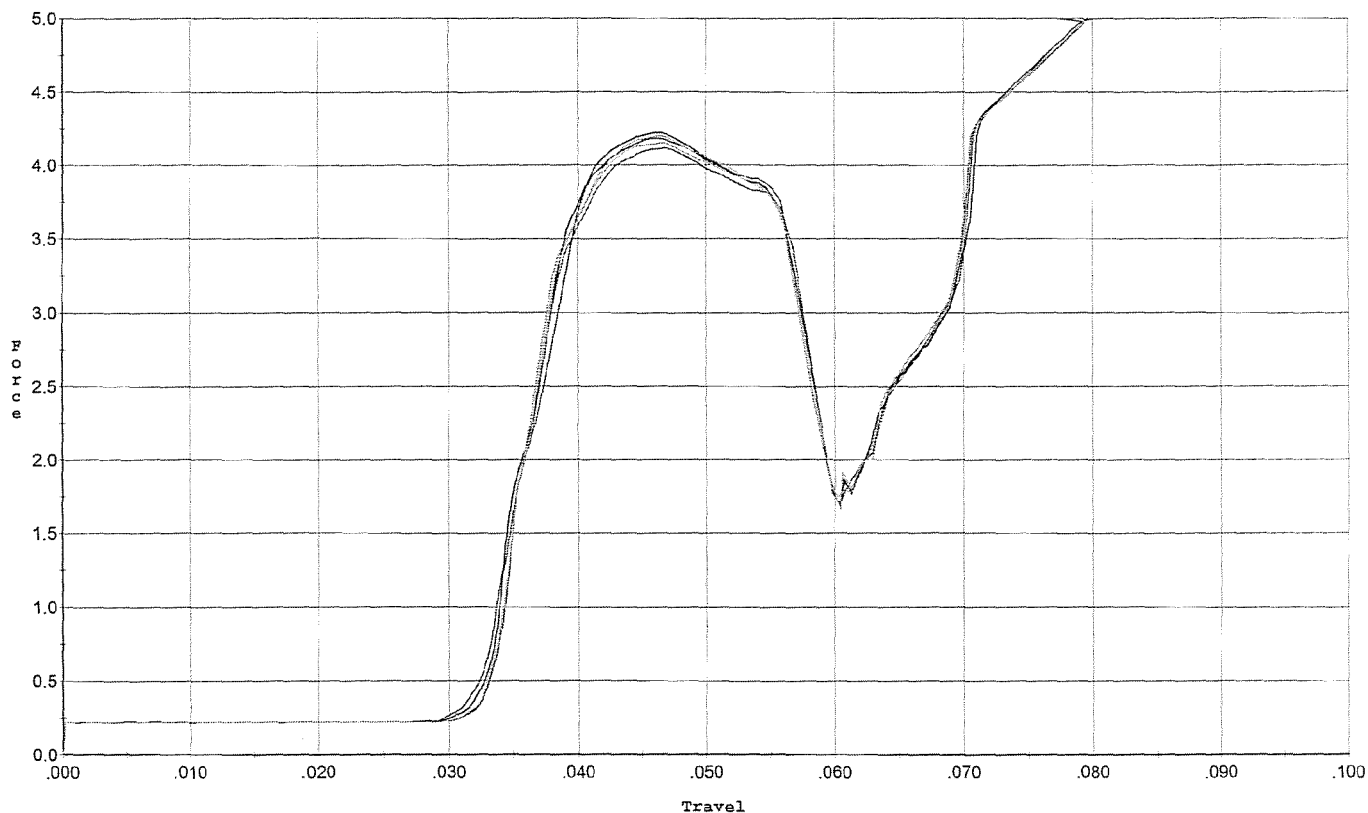
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.131	0.057	0.033	0.032	0.089		Set Trigger
2	4.099	0.057	0.034	0.032	0.088		Set Trigger
3	4.133	0.058	0.034	0.032	0.091		Set Trigger
4	4.050	0.057	0.033	0.032	0.088		Set Trigger
5	4.113	0.057	0.034	0.032	0.090		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



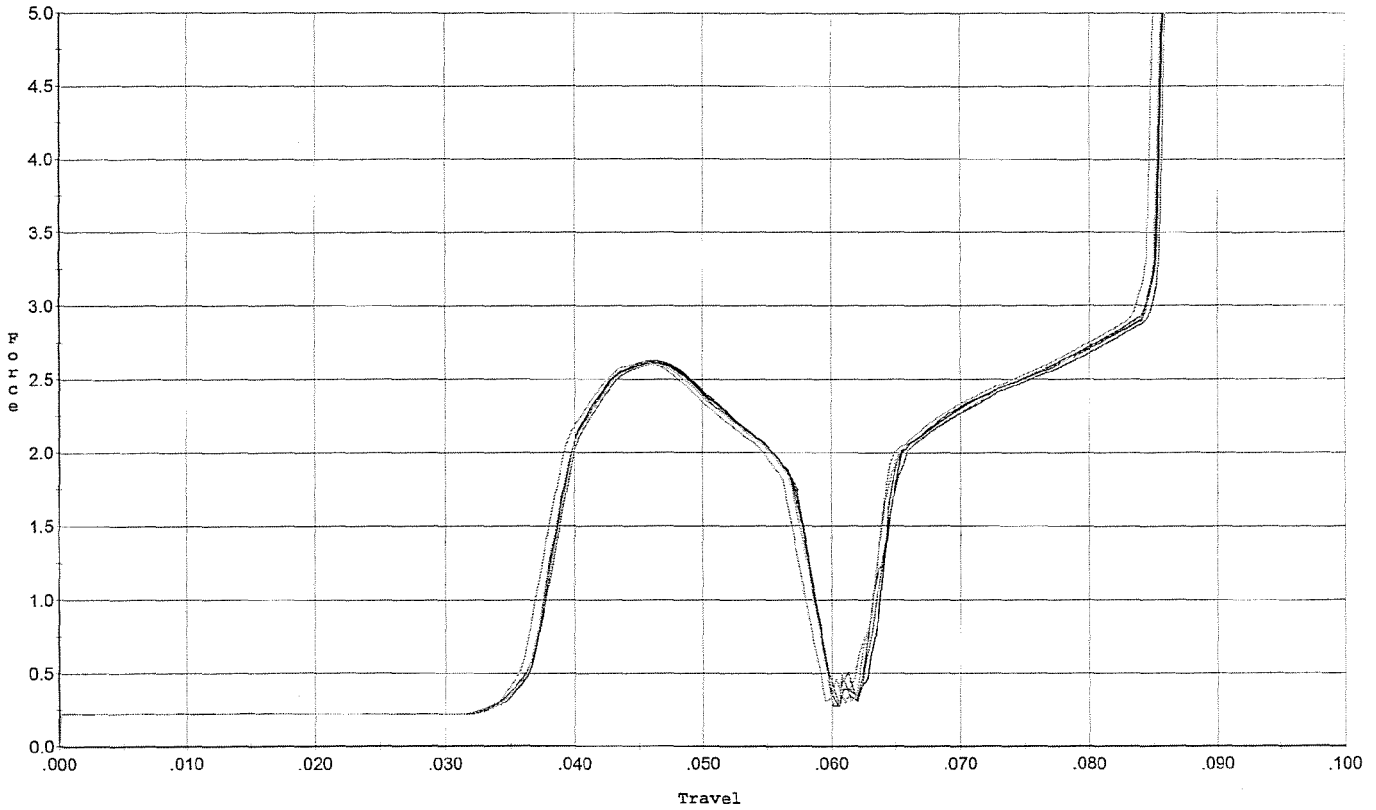
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.182	0.057	0.032	0.031	0.093		Set Trigger
2	4.220	0.056	0.032	0.032	0.090		Set Trigger
3	4.115	0.057	0.033	0.031	0.090		Set Trigger
4	4.149	0.056	0.033	0.032	0.089		Set Trigger
5	4.196	0.058	0.033	0.031	0.093		Set Trigger

Avg 4.17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/17/08

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



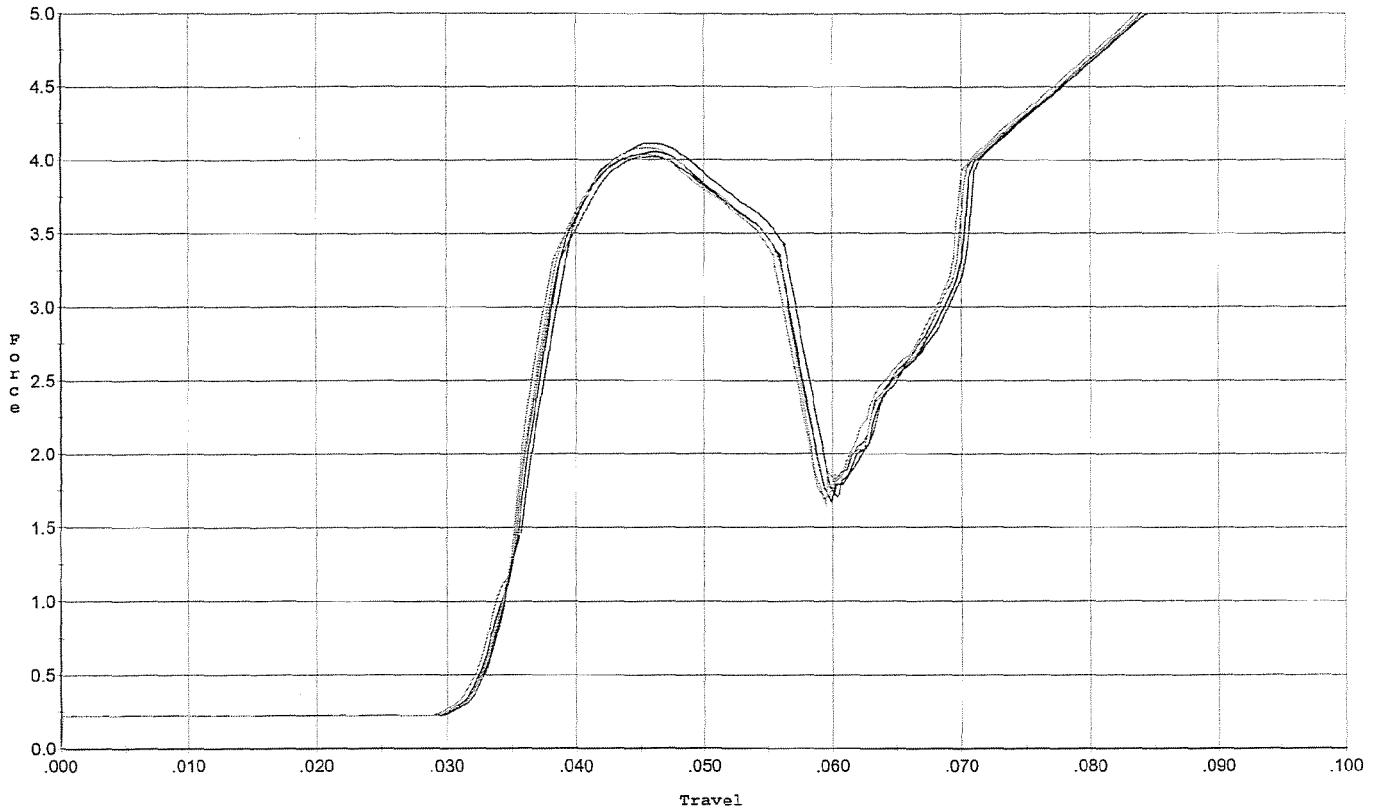
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.058	0.036	0.035	0.054		Set Trigger
2	2.614	0.057	0.036	0.035	0.054		Set Trigger
3	2.608	0.057	0.036	0.035	0.053		Set Trigger
4	2.602	0.058	0.036	0.035	0.054		Set Trigger
5	2.619	0.056	0.036	0.035	0.053		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/17/08

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	4.110	0.056	0.032	0.032	0.087		Set Trigger
2	4.056	0.056	0.032	0.032	0.085		Set Trigger
3	4.021	0.056	0.032	0.032	0.085		Set Trigger
4	4.080	0.056	0.032	0.032	0.086		Set Trigger
5	4.035	0.057	0.031	0.031	0.088		Set Trigger

AVG 4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695390.__0
FILE DATE AND TIME: 01/18/2008 12:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.025
The Average Y Centroid of the Five Target Set:	-0.068
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.703
The Distance from POA to Centroid Target #1:	0.075
The Distance from Centroid Target #2 to Centroid Target #1:	0.173
The Distance from Centroid Target #3 to Centroid Target #1:	0.336
The Distance from Centroid Target #4 to Centroid Target #1:	0.078
The Distance from Centroid Target #5 to Centroid Target #1:	0.044

SERIAL NUMBER: G6695390. __0

TARGET NUMBER: 1

FILE DATE: 01/18/2008

FILE TIME: 12:31

POINT#	X	Y
1:	-0.280	0.820
2:	-0.142	0.500
3:	0.180	0.203
4:	0.610	-0.083
5:	0.253	-0.237
6:	0.439	-0.741
7:	-0.433	-0.804
8:	-0.442	-0.119
9:	-1.518	-0.620
10:	0.586	1.167

X CENTROID: -0.075

Y CENTROID: 0.009

POA TO CENTROID: 0.075

HORZ SPREAD: 2.128

VERT SPREAD: 1.971

GROUP SPREAD: 2.760

MIN RADIUS: 0.320

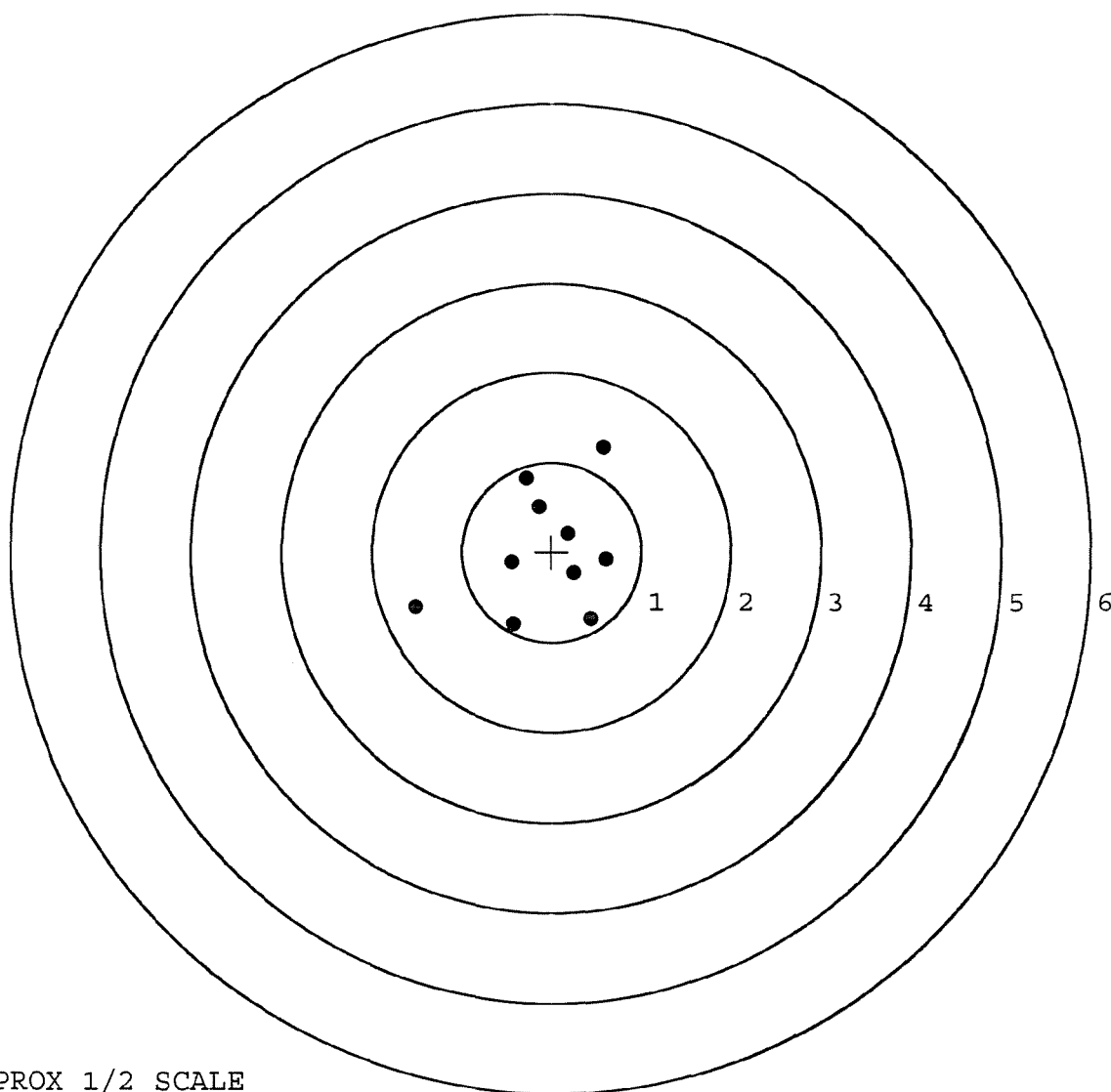
MAX RADIUS: 1.574

MEAN RADIUS: 0.785

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695390. __0

TARGET NUMBER: 2

FILE DATE: 01/18/2008

FILE TIME: 12:31

POINT#	X	Y
1:	0.489	-1.006
2:	0.814	0.129
3:	0.681	-0.146
4:	0.613	0.275
5:	0.361	0.170
6:	-0.387	0.307
7:	-0.552	0.059
8:	-0.408	-0.185
9:	-0.544	-0.463
10:	-0.984	-0.568

X CENTROID: 0.008

Y CENTROID: -0.143

POA TO CENTROID: 0.143

HORZ SPREAD: 1.798

VERT SPREAD: 1.313

GROUP SPREAD: 1.928

MIN RADIUS: 0.418

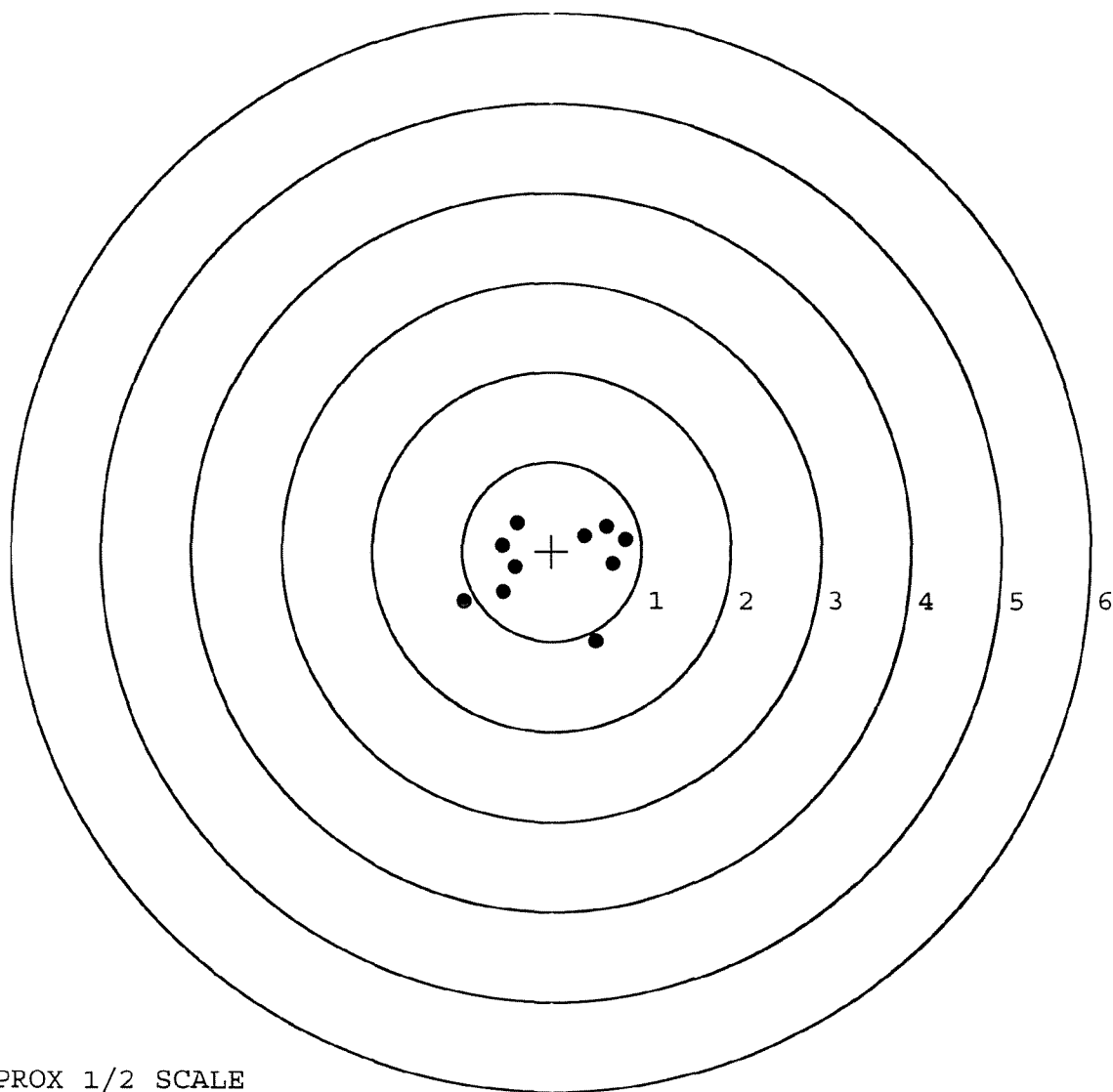
MAX RADIUS: 1.080

MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

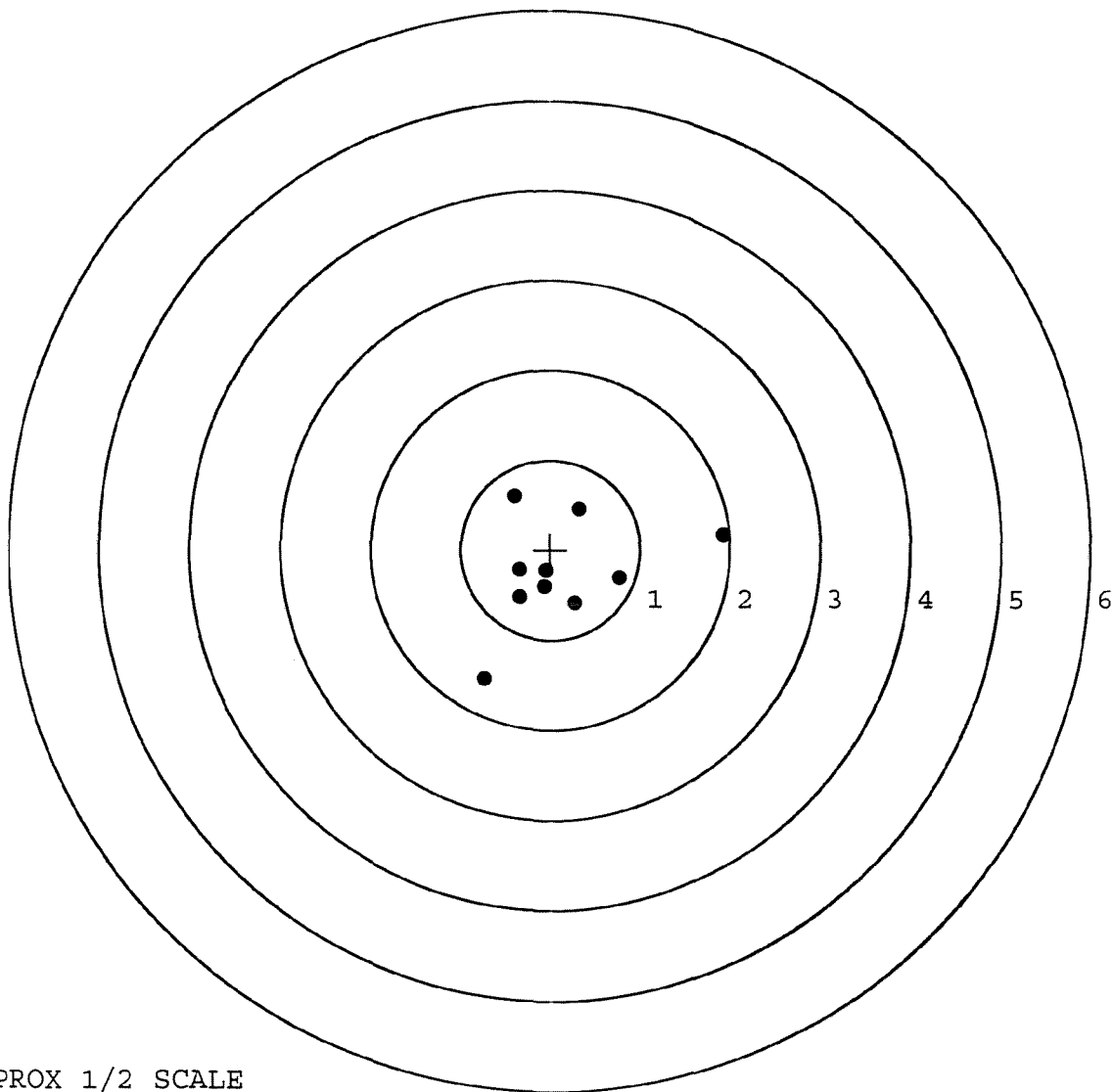


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695390. __0
TARGET NUMBER: 3
FILE DATE: 01/18/2008
FILE TIME: 12:31

POINT#	X	Y
1:	0.772	-0.315
2:	0.315	0.459
3:	-0.400	0.599
4:	0.270	-0.594
5:	-0.048	-0.240
6:	-0.073	-0.420
7:	-0.345	-0.540
8:	-0.342	-0.229
9:	-0.741	-1.445
10:	1.926	0.168

X CENTROID: 0.133
Y CENTROID: -0.256
POA TO CENTROID: 0.288
HORZ SPREAD: 2.667
VERT SPREAD: 2.044
GROUP SPREAD: 3.117
MIN RADIUS: 0.182
MAX RADIUS: 1.842
MEAN RADIUS: 0.755
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695390. __0

TARGET NUMBER: 4

FILE DATE: 01/18/2008

FILE TIME: 12:31

POINT#	X	Y
1:	0.936	-0.699
2:	0.067	-1.124
3:	-0.284	0.885
4:	-0.086	0.462
5:	-0.681	0.551
6:	-1.324	0.646
7:	0.074	0.169
8:	0.232	0.015
9:	0.071	-0.154
10:	-0.044	0.063

X CENTROID: -0.104

Y CENTROID: 0.081

POA TO CENTROID: 0.132

HORZ SPREAD: 2.260

VERT SPREAD: 2.009

GROUP SPREAD: 2.630

MIN RADIUS: 0.063

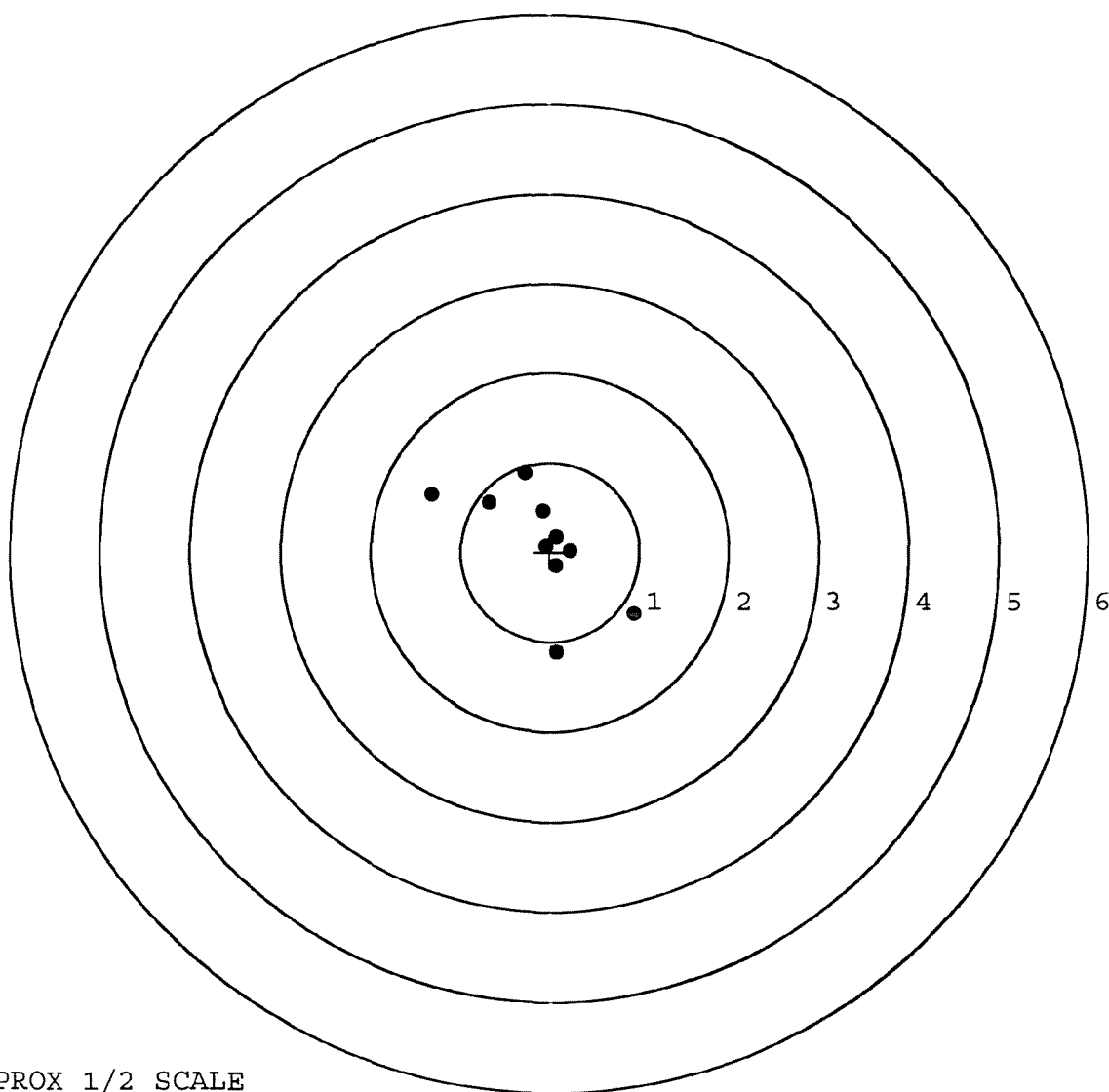
MAX RADIUS: 1.344

MEAN RADIUS: 0.671

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

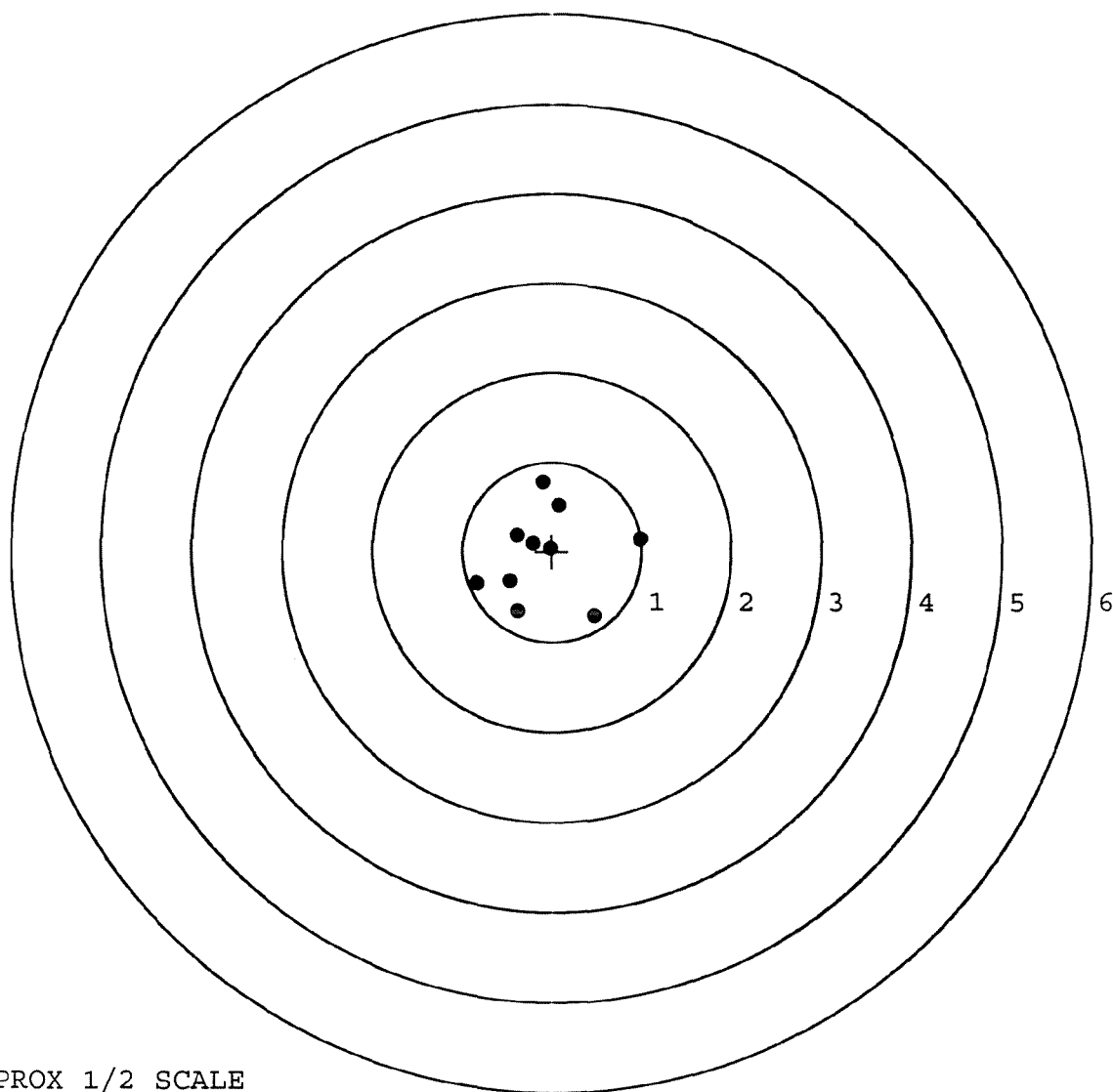


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695390. __0
TARGET NUMBER: 5
FILE DATE: 01/18/2008
FILE TIME: 12:31

POINT#	X	Y
1:	0.984	0.140
2:	0.473	-0.708
3:	-0.393	-0.664
4:	-0.469	-0.329
5:	-0.846	-0.359
6:	-0.104	0.778
7:	0.076	0.517
8:	-0.398	0.181
9:	-0.208	0.089
10:	-0.018	0.034

X CENTROID: -0.090
Y CENTROID: -0.032
POA TO CENTROID: 0.096
HORZ SPREAD: 1.830
VERT SPREAD: 1.486
GROUP SPREAD: 1.897
MIN RADIUS: 0.098
MAX RADIUS: 1.088
MEAN RADIUS: 0.600
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE