

G 6695357

M/24 .300 WIN MAG (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL .300 WIN MAG

- INSTRUCTION BOOK 3518

BM FORM 200348



UPC

G6695357

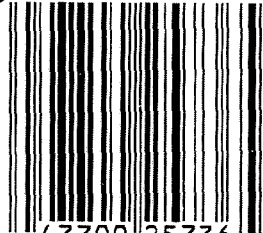
ORDER NO.	25736
BARREL LENGTH	24"
CAPACITY	5



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC

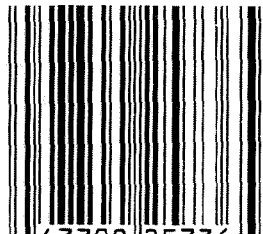


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ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



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SERIAL NO.



66695357

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6695357

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		1-3-08	RTZ
420	ASSEMBLE ACTION		1-3-08	RTZ
430	ASSEMBLE TO STOCK		1-3-08	RTZ
440	PROOF	MAGNA - FLUX JAN 4 2008 OPERATOR <u>JB</u>	1-3-08	TRW
460	CHECK HEADSPACE		1-3-08	TRW
470	DIS-ASSEMBLE ACTION		1-4-08	JB
480	MAGNAFLUX BBL ACTION			
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		1-4-08	CW
510	DRILL AND TAP SIGHT HOLES		1-7-08	LY
520	GOFF BLAST BBL / REC			
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		1/9/08	JB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-11-08	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-11-08	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-11-08	DA
	D) OIL FIRING PIN ASSEMBLY		1-11-08	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>70</u> <u>75</u> <u>75</u>	1-14-08	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>35</u>	1-14-08	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0215</u> <u>.022</u> <u>.022</u>	1-14-08	RA
	J) ASSEMBLE STOCK		1-11-08	RT
	K) ASSEMBLE SWIVEL STUDS		1-14-08	RA
	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	1-11-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-11-08	FM
670	FINAL INSPECTION A) HEADSPACE		1-15-08	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.83</u> <u>2.62</u> <u>2.48</u> <u>2.57</u> <u>2.81</u>	1-14-08	RA
	C) FUNCTION		1-15-08	RT
690	PACK		1-16-07	RA

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695357.__0
FILE DATE AND TIME: 01/15/2008 09:03

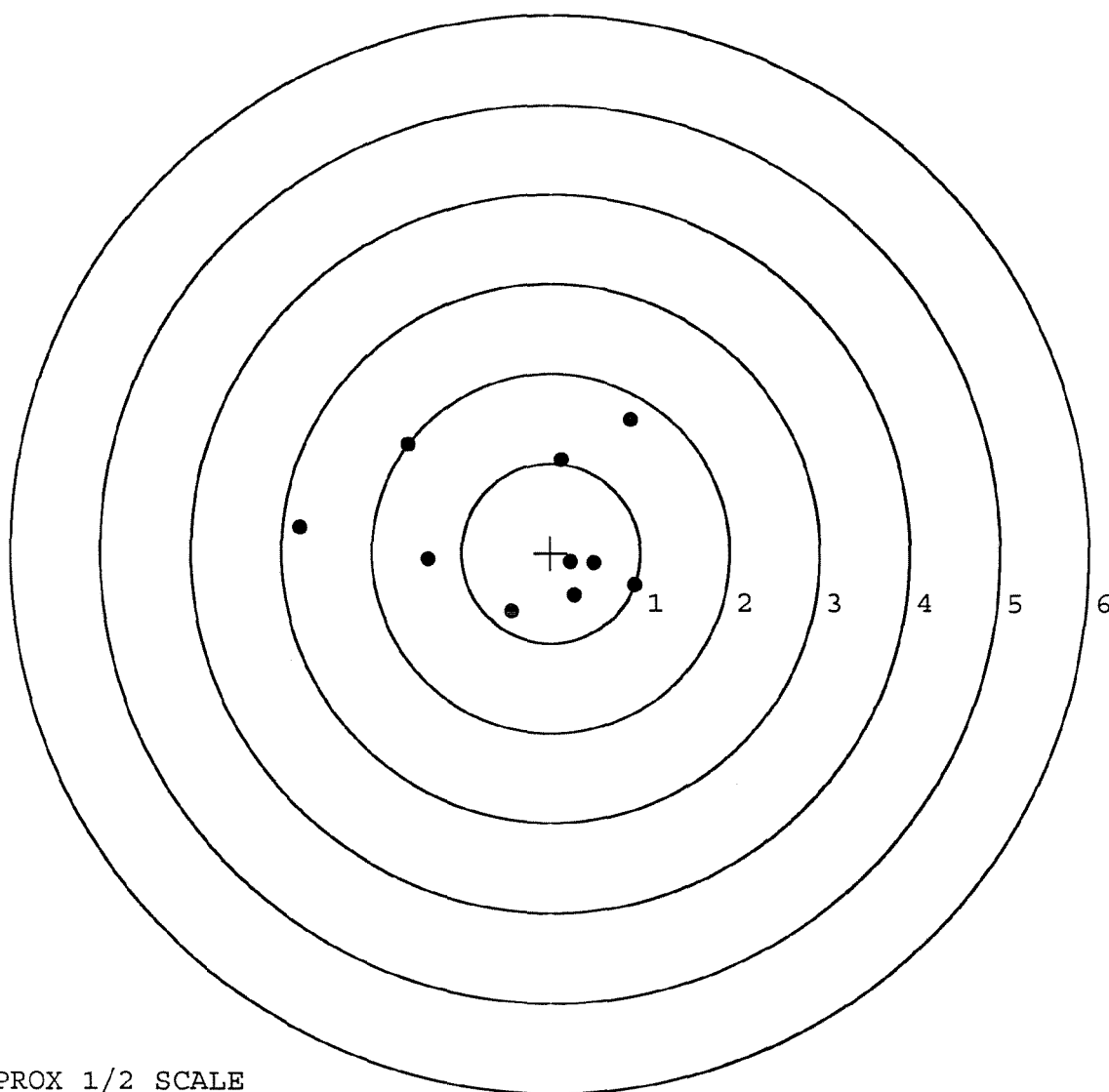
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.024
The Average Y Centroid of the Five Target Set:	0.149
The Average Point of Impact of the Five Target Set:	0.151
The Average Mean Radius of the Five Target Set:	1.048
The Distance from POA to Centroid Target #1:	0.396
The Distance from Centroid Target #2 to Centroid Target #1:	0.472
The Distance from Centroid Target #3 to Centroid Target #1:	0.577
The Distance from Centroid Target #4 to Centroid Target #1:	0.102
The Distance from Centroid Target #5 to Centroid Target #1:	0.783

SERIAL NUMBER: G6695357.___0
TARGET NUMBER: 1
FILE DATE: 01/15/2008
FILE TIME: 09:03

POINT#	X	Y
1:	0.888	1.487
2:	0.114	1.037
3:	-1.597	1.202
4:	-2.795	0.278
5:	-1.367	-0.086
6:	-0.441	-0.655
7:	0.224	-0.105
8:	0.483	-0.119
9:	0.266	-0.470
10:	0.936	-0.360

X CENTROID: -0.329
Y CENTROID: 0.221
POA TO CENTROID: 0.396
HORZ SPREAD: 3.731
VERT SPREAD: 2.142
GROUP SPREAD: 3.876
MIN RADIUS: 0.642
MAX RADIUS: 2.467
MEAN RADIUS: 1.255
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695357. 0

TARGET NUMBER: 2

FILE DATE: 01/15/2008

FILE TIME: 09:03

POINT#	X	Y
1:	-1.572	0.284
2:	-0.852	-0.074
3:	-0.297	-0.981
4:	1.419	-0.392
5:	1.073	0.006
6:	0.532	0.951
7:	0.453	-0.331
8:	0.118	-0.127
9:	-0.221	0.148
10:	0.106	0.292

X CENTROID: 0.076

Y CENTROID: -0.022

POA TO CENTROID: 0.079

HORZ SPREAD: 2.991

VERT SPREAD: 1.932

GROUP SPREAD: 3.066

MIN RADIUS: 0.113

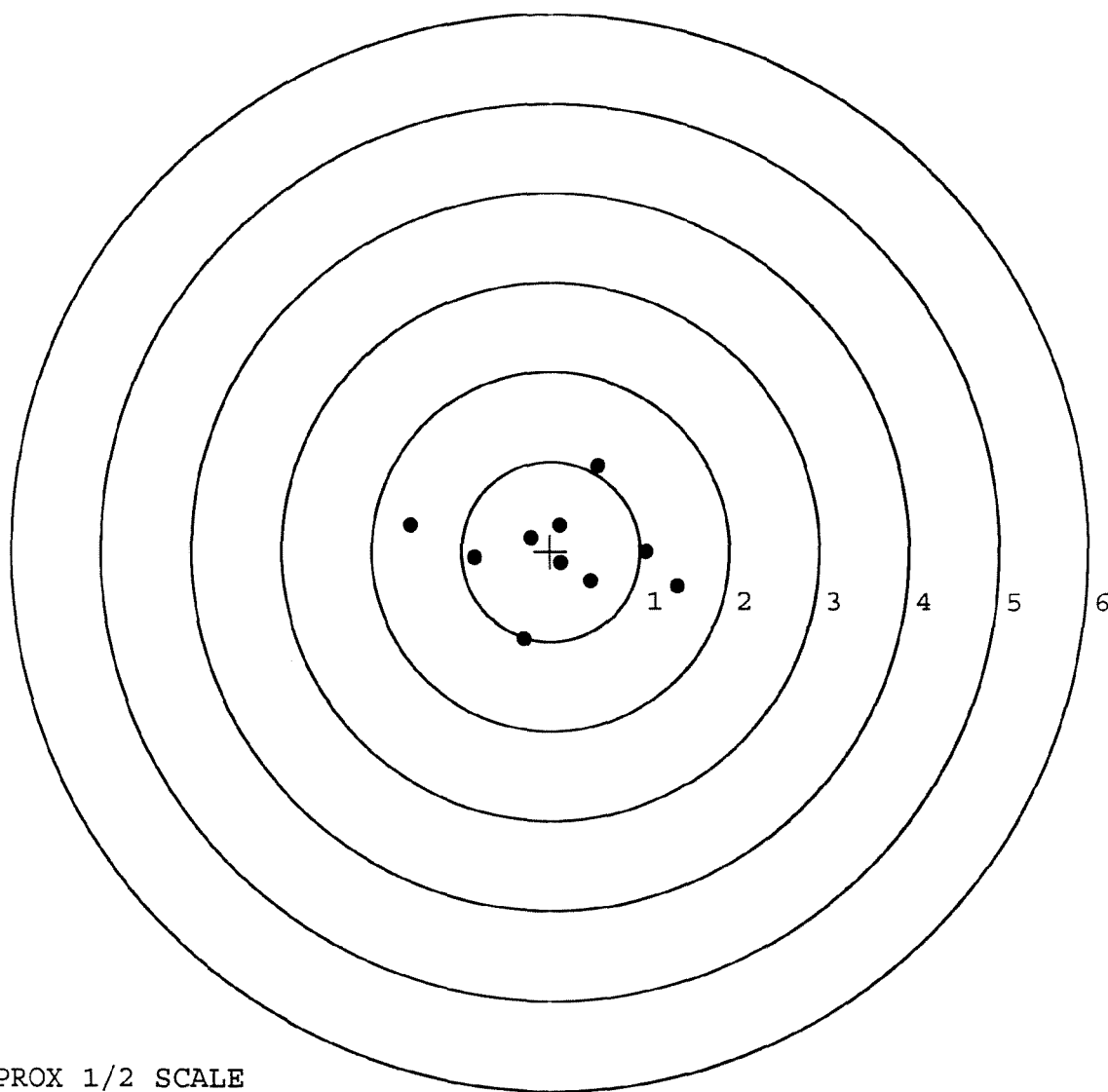
MAX RADIUS: 1.676

MEAN RADIUS: 0.836

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

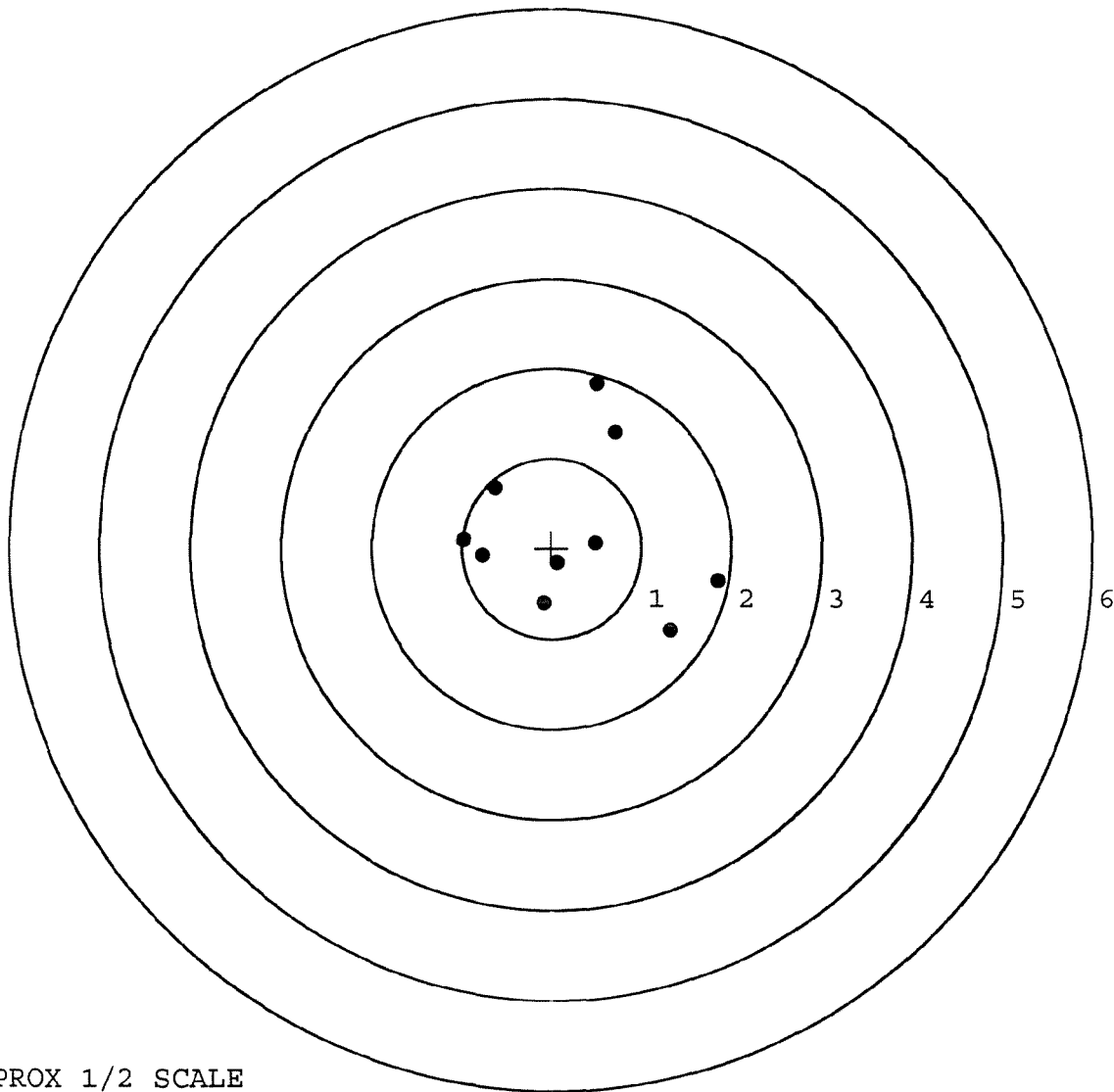


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695357. __0
TARGET NUMBER: 3
FILE DATE: 01/15/2008
FILE TIME: 09:03

POINT#	X	Y
1:	0.506	1.834
2:	0.708	1.288
3:	1.852	-0.354
4:	1.319	-0.908
5:	0.493	0.064
6:	0.063	-0.164
7:	-0.092	-0.613
8:	-0.771	-0.086
9:	-0.981	0.090
10:	-0.630	0.672

X CENTROID: 0.247
Y CENTROID: 0.182
POA TO CENTROID: 0.307
HORZ SPREAD: 2.833
VERT SPREAD: 2.742
GROUP SPREAD: 2.868
MIN RADIUS: 0.273
MAX RADIUS: 1.693
MEAN RADIUS: 1.091
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 7

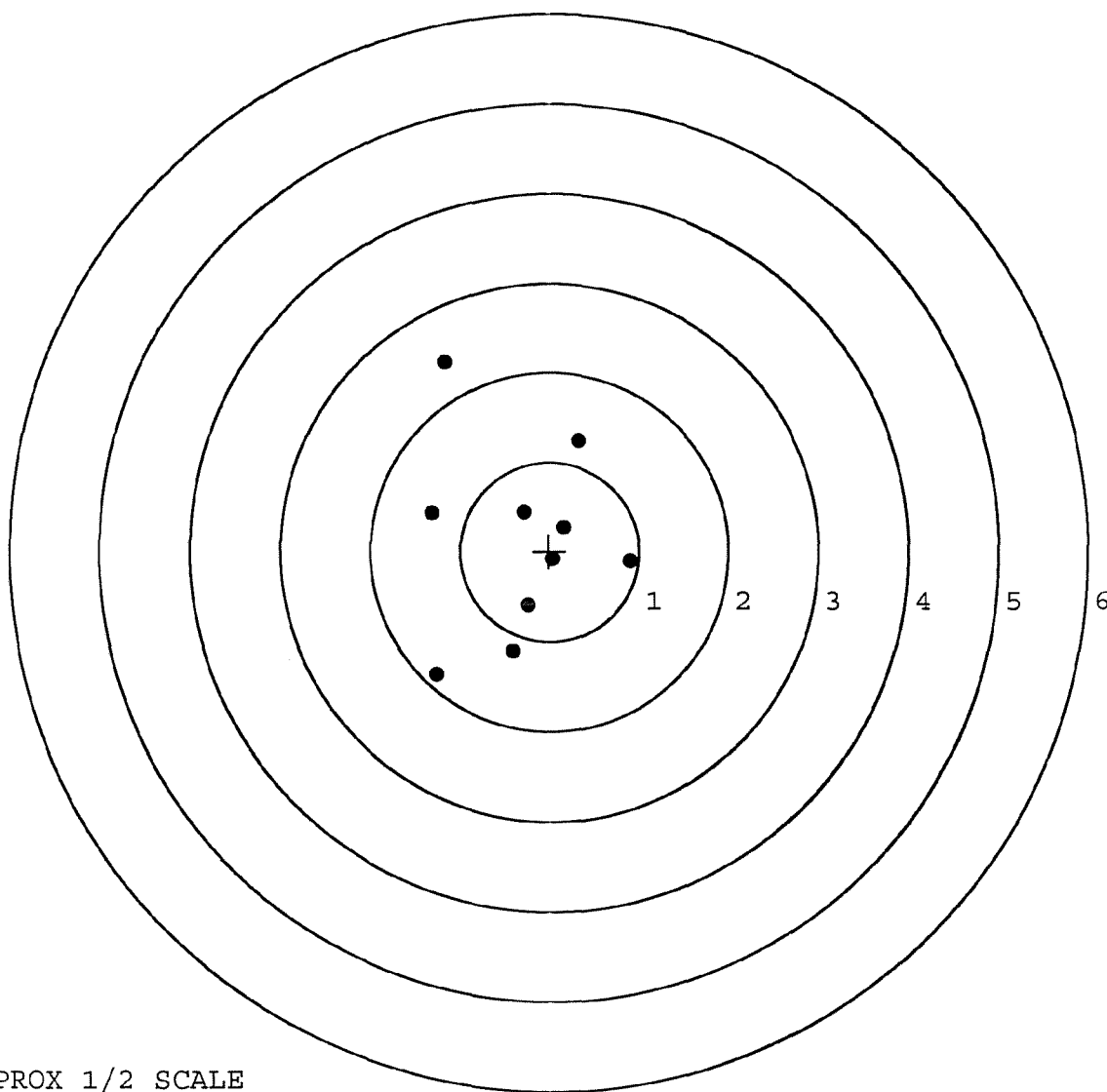


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695357. __0
TARGET NUMBER: 4
FILE DATE: 01/15/2008
FILE TIME: 09:03

POINT#	X	Y
1:	-1.170	2.111
2:	0.330	1.236
3:	-1.316	0.433
4:	-0.289	0.443
5:	0.155	0.268
6:	0.902	-0.112
7:	0.039	-0.087
8:	-0.246	-0.606
9:	-0.413	-1.117
10:	-1.261	-1.378

X CENTROID: -0.327
Y CENTROID: 0.119
POA TO CENTROID: 0.348
HORZ SPREAD: 2.218
VERT SPREAD: 3.489
GROUP SPREAD: 3.490
MIN RADIUS: 0.326
MAX RADIUS: 2.163
MEAN RADIUS: 1.073
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

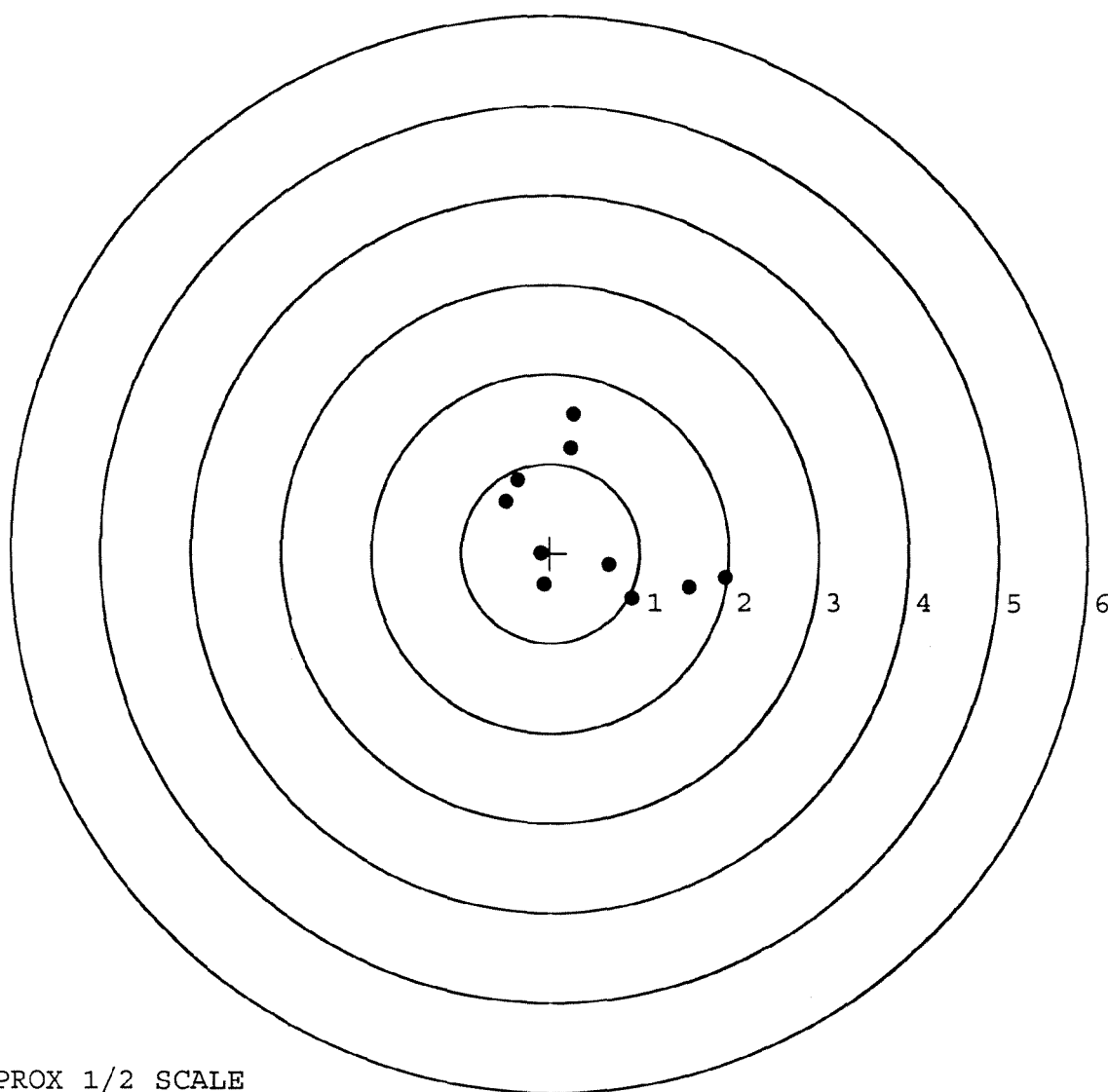


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695357.___0
TARGET NUMBER: 5
FILE DATE: 01/15/2008
FILE TIME: 09:03

POINT#	X	Y
1:	1.956	-0.277
2:	1.551	-0.383
3:	0.909	-0.512
4:	0.660	-0.127
5:	-0.067	-0.355
6:	-0.106	-0.003
7:	-0.497	0.567
8:	-0.361	0.812
9:	0.228	1.177
10:	0.265	1.557

X CENTROID: 0.454
Y CENTROID: 0.246
POA TO CENTROID: 0.516
HORZ SPREAD: 2.453
VERT SPREAD: 2.069
GROUP SPREAD: 2.594
MIN RADIUS: 0.426
MAX RADIUS: 1.591
MEAN RADIUS: 0.985
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

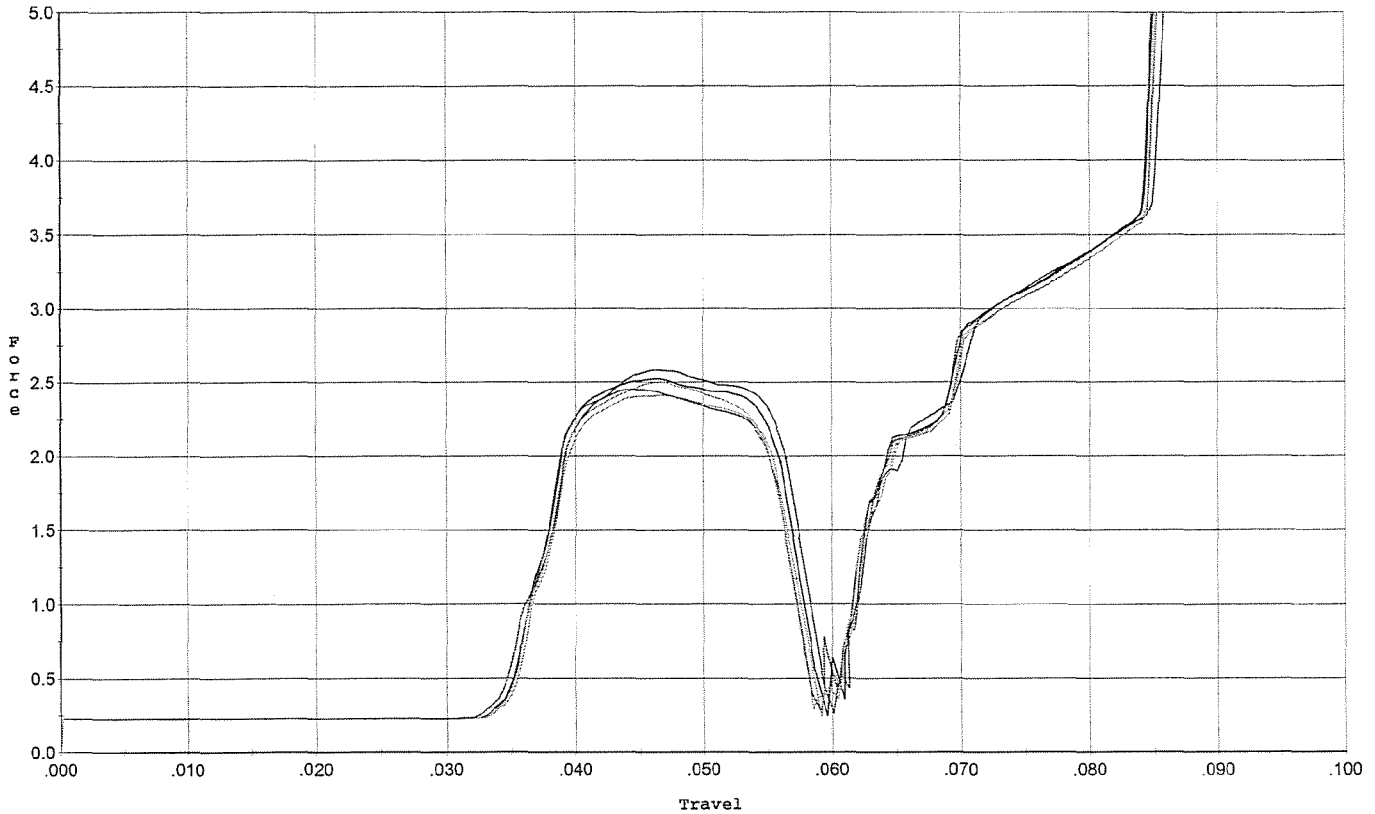


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



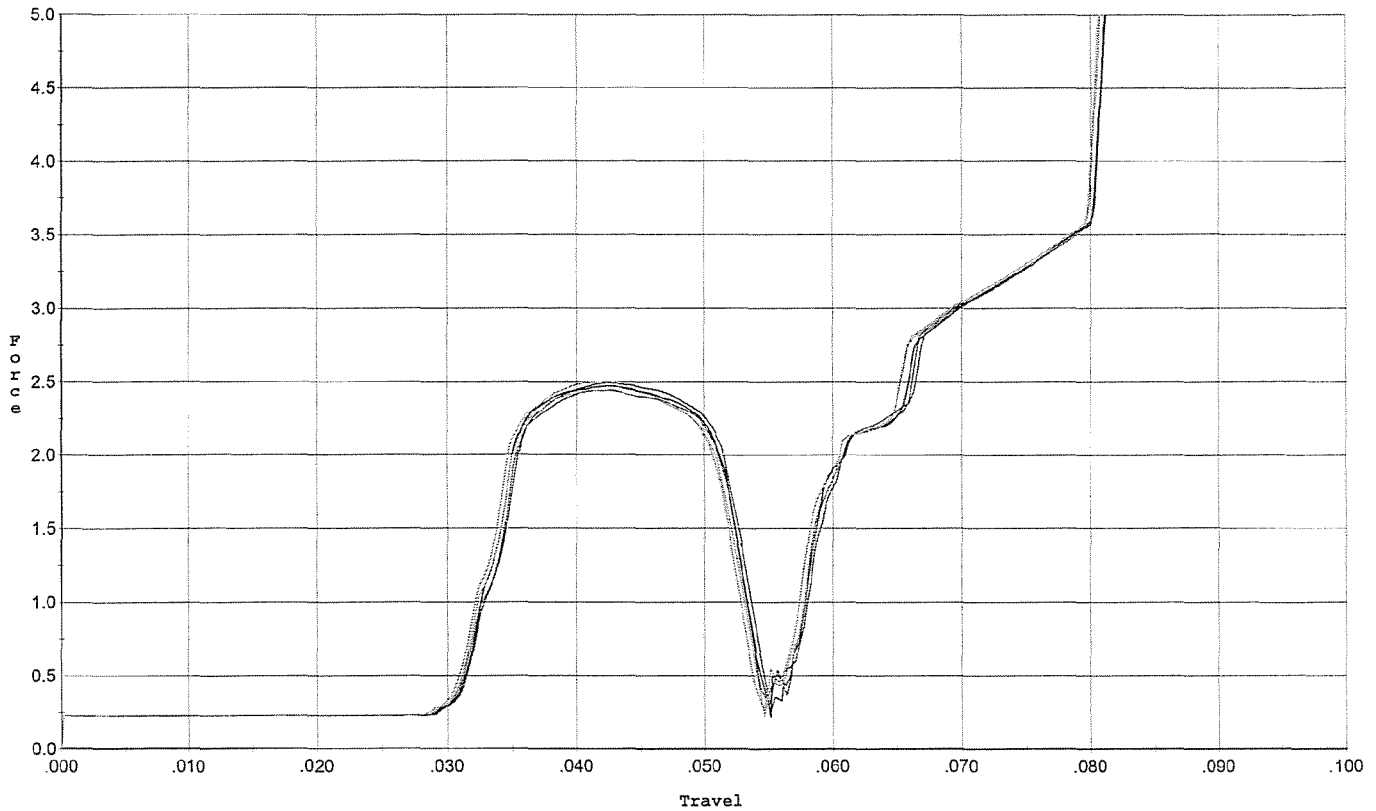
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.056	0.035	0.035	0.056		Set Trigger
2	2.523	0.056	0.035	0.035	0.054		Set Trigger
3	2.449	0.056	0.034	0.035	0.053		Set Trigger
4	2.412	0.057	0.035	0.035	0.053		Set Trigger
5	2.501	0.056	0.035	0.036	0.052		Set Trigger

AVG 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



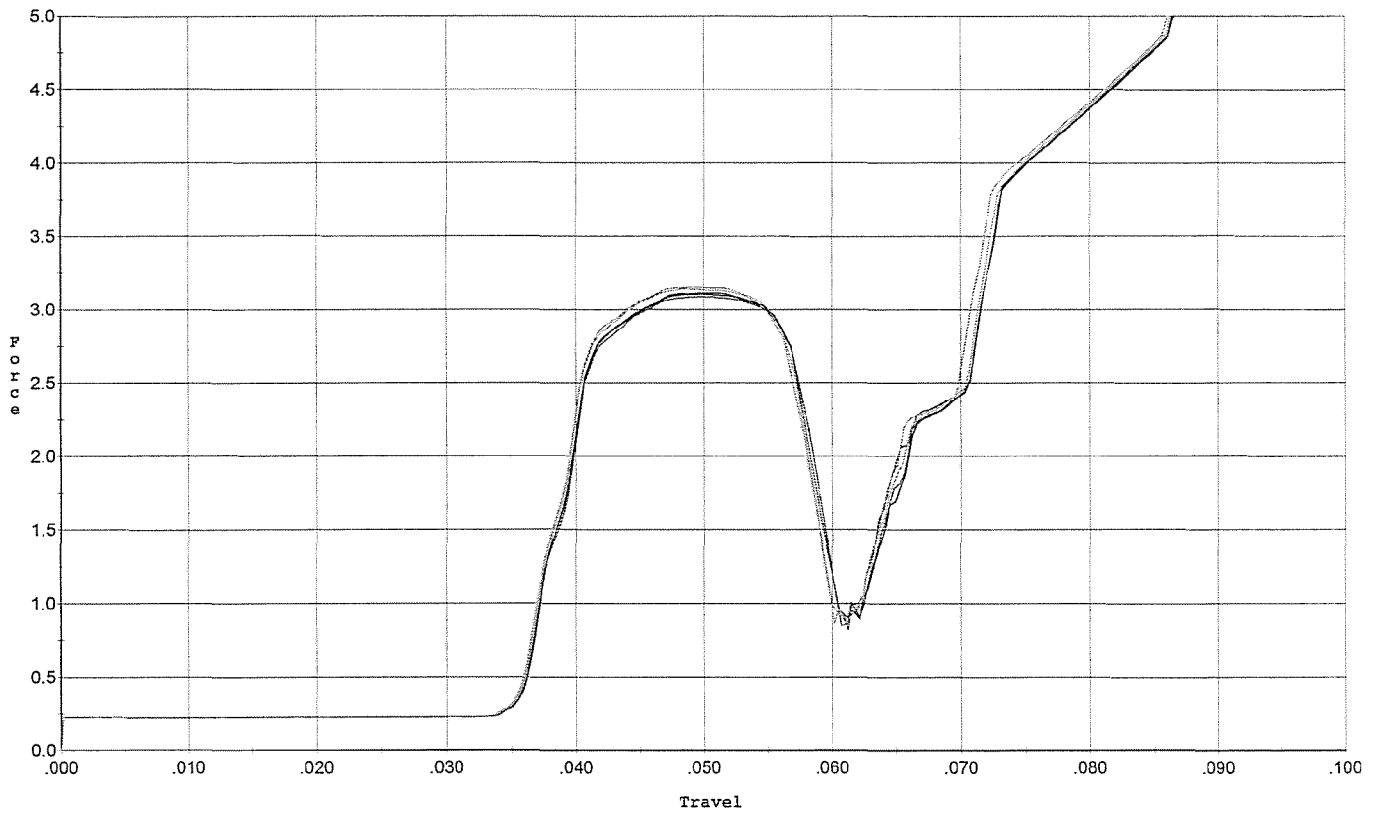
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.053	0.031	0.034	0.052		Set Trigger
2	2.470	0.052	0.031	0.034	0.051		Set Trigger
3	2.441	0.052	0.031	0.034	0.050		Set Trigger
4	2.499	0.051	0.030	0.034	0.051		Set Trigger
5	2.441	0.053	0.031	0.034	0.051		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



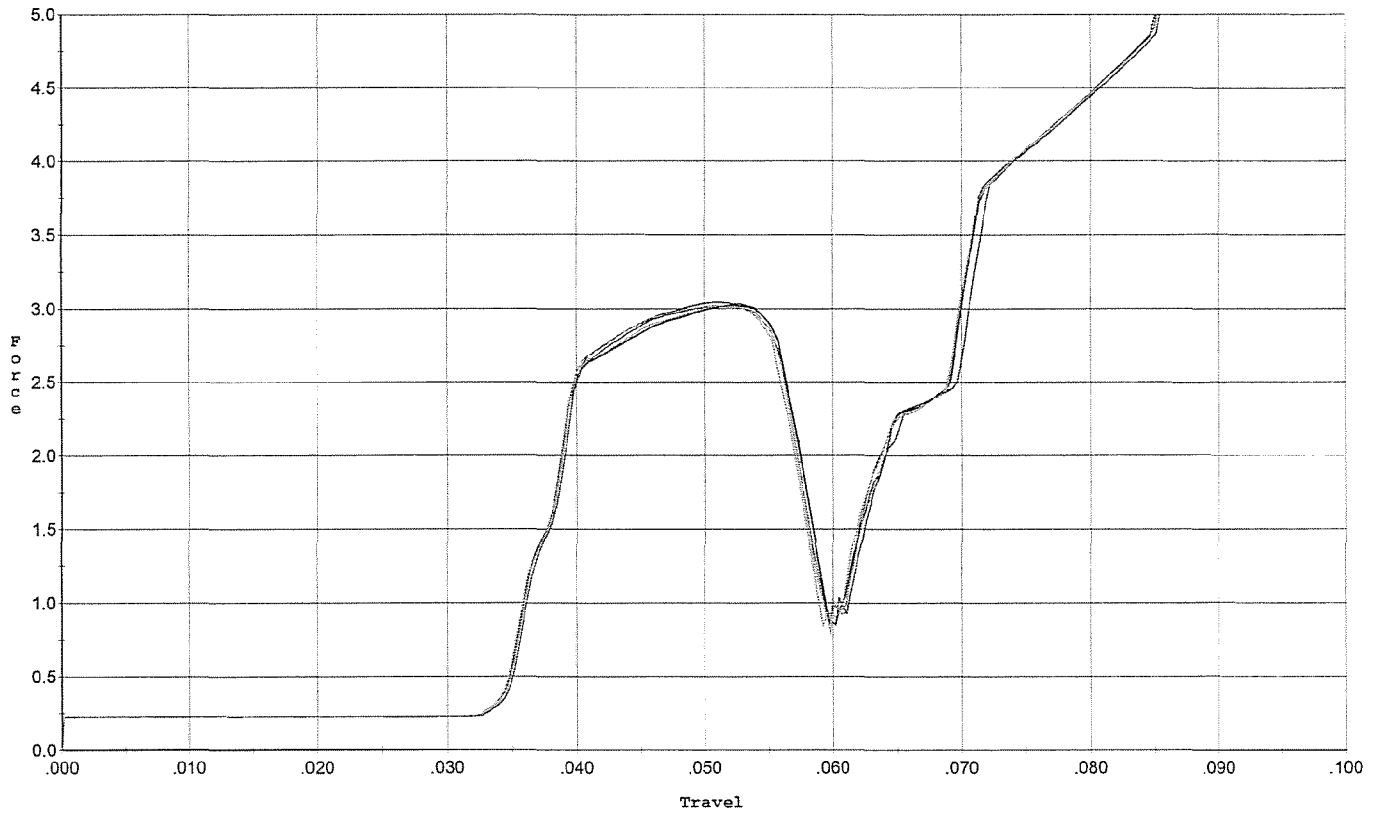
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.113	0.058	0.036	0.035	0.067		Set Trigger
2	3.108	0.057	0.036	0.035	0.065		Set Trigger
3	3.087	0.057	0.036	0.035	0.065		Set Trigger
4	3.138	0.058	0.036	0.035	0.067		Set Trigger
5	3.151	0.057	0.036	0.035	0.066		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



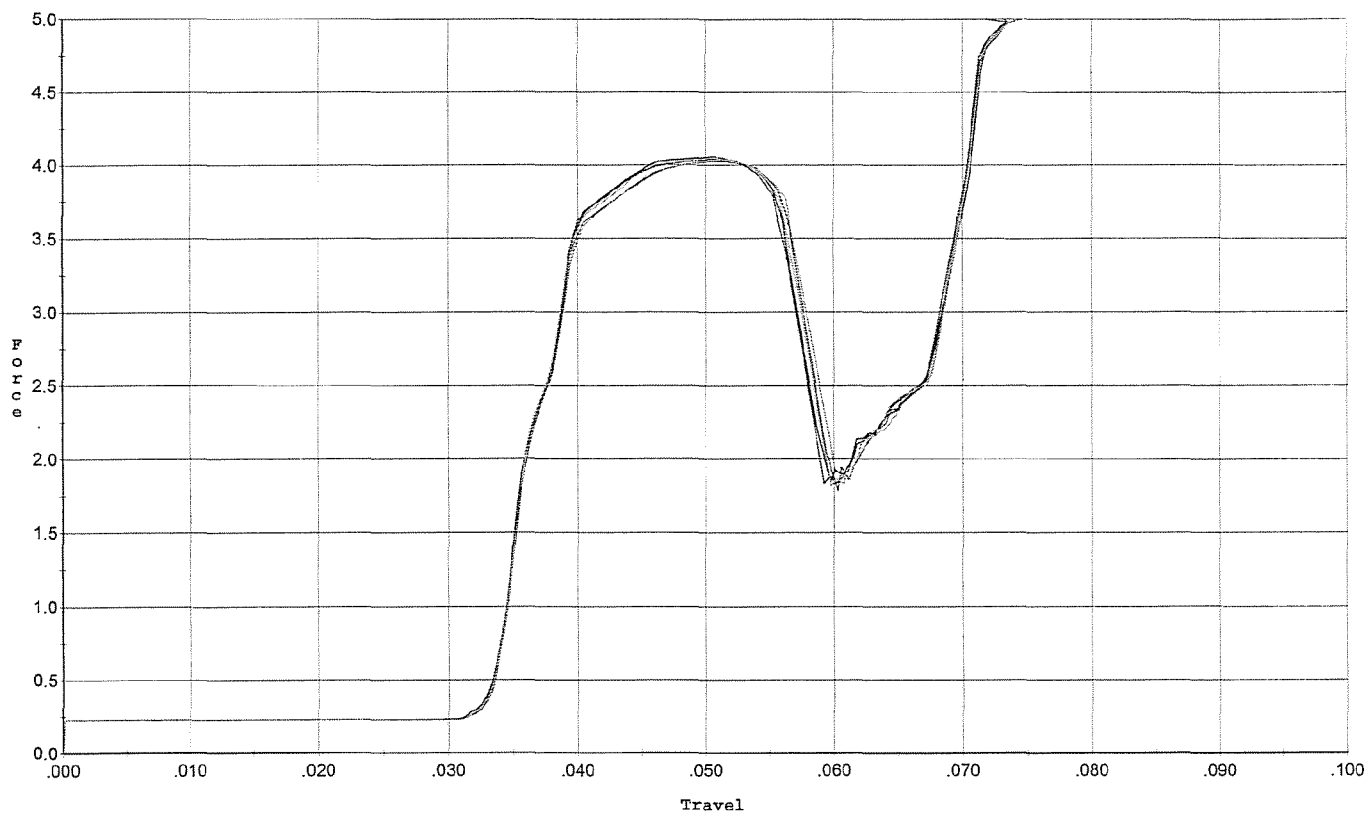
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.058	0.035	0.034	0.066		Set Trigger
2	3.023	0.057	0.034	0.034	0.065		Set Trigger
3	3.016	0.056	0.034	0.034	0.064		Set Trigger
4	3.023	0.057	0.034	0.034	0.064		Set Trigger
5	3.017	0.056	0.035	0.034	0.063		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



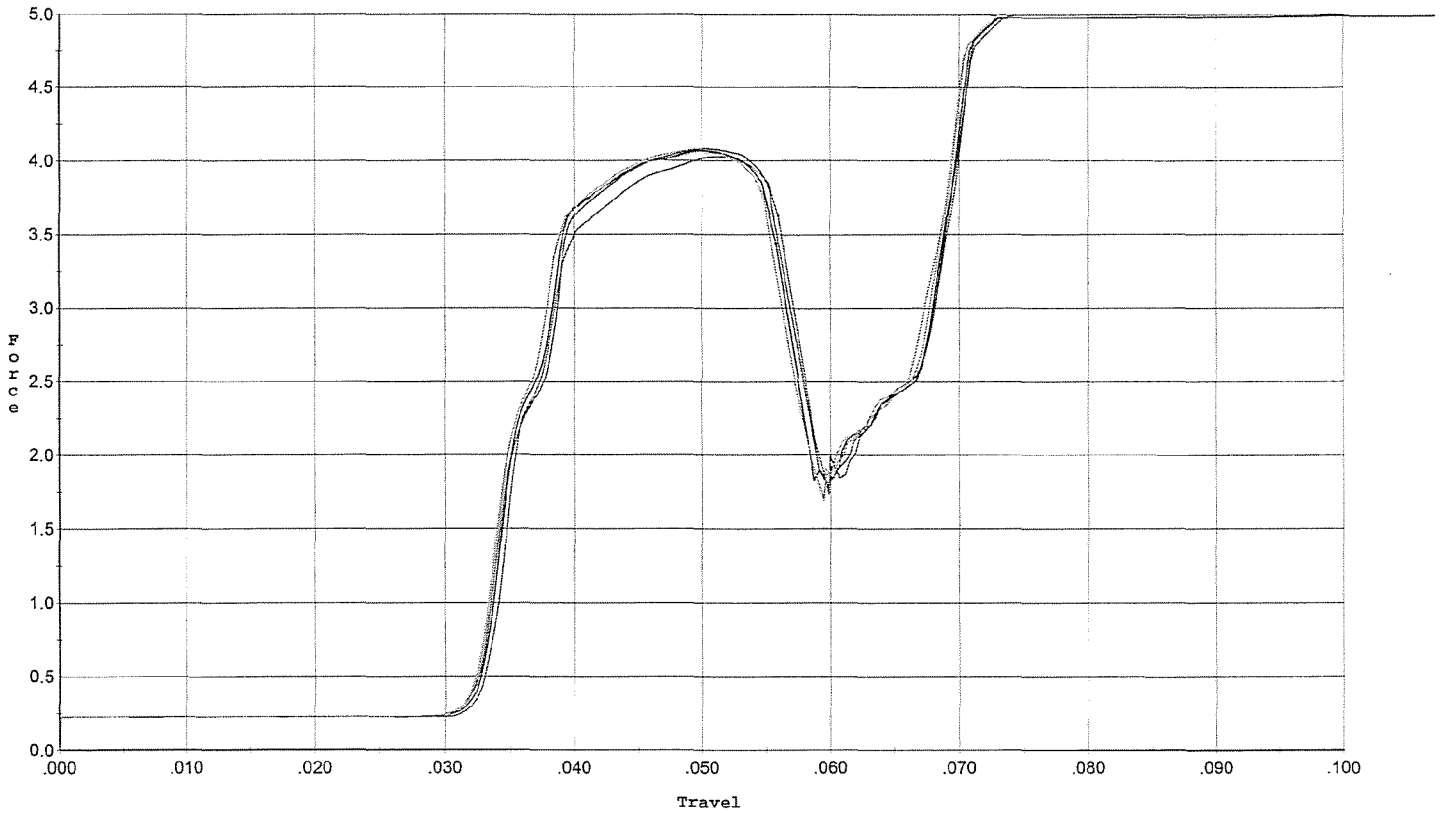
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.042	0.056	0.033	0.032	0.088		Set Trigger
2	4.057	0.056	0.033	0.033	0.087		Set Trigger
3	4.028	0.057	0.033	0.032	0.088		Set Trigger
4	4.055	0.057	0.033	0.032	0.090		Set Trigger
5	4.039	0.058	0.033	0.032	0.091		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



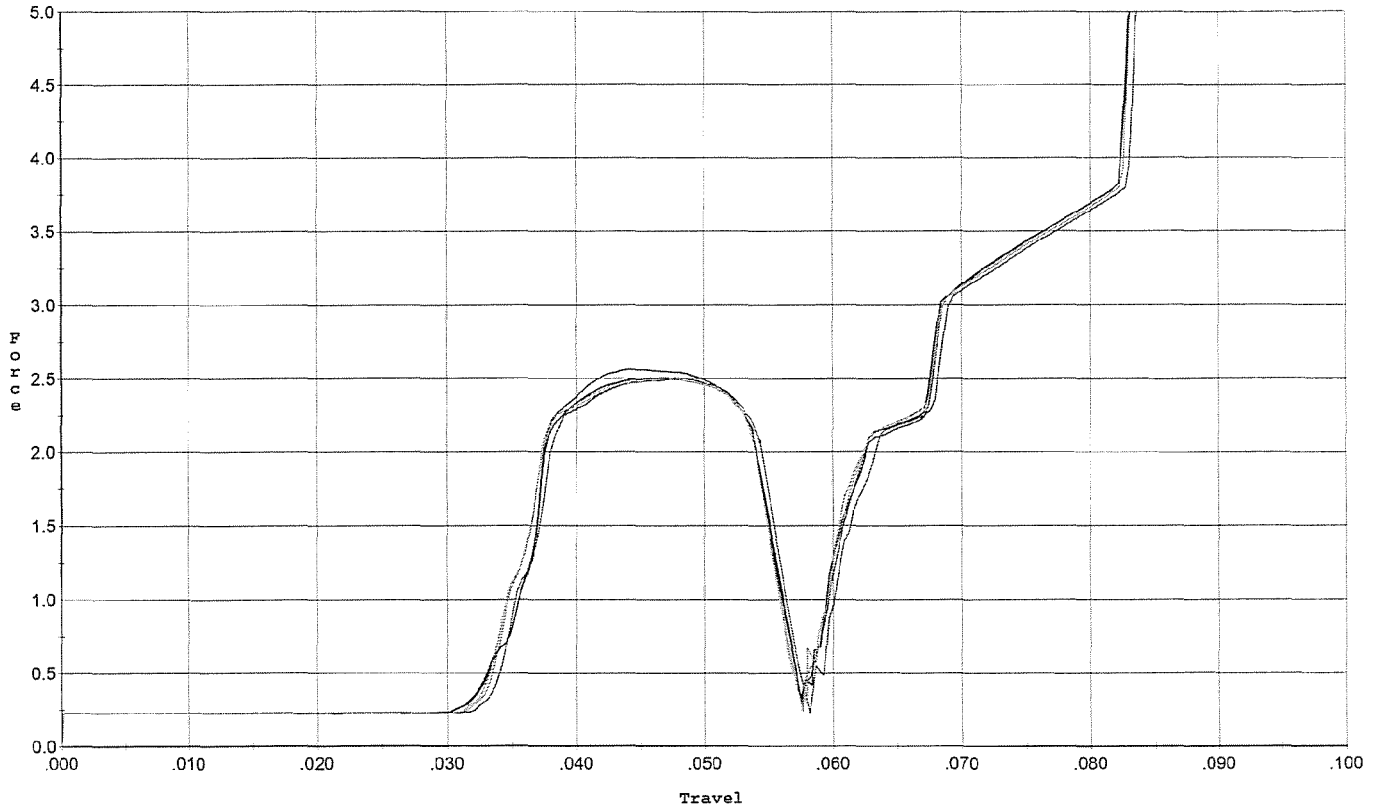
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.081	0.055	0.032	0.032	0.087		Set Trigger
2	4.067	0.056	0.032	0.032	0.088		Set Trigger
3	4.026	0.056	0.033	0.032	0.087		Set Trigger
4	4.080	0.055	0.032	0.032	0.087		Set Trigger
5	4.055	0.055	0.032	0.032	0.086		Set Trigger

AVG 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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



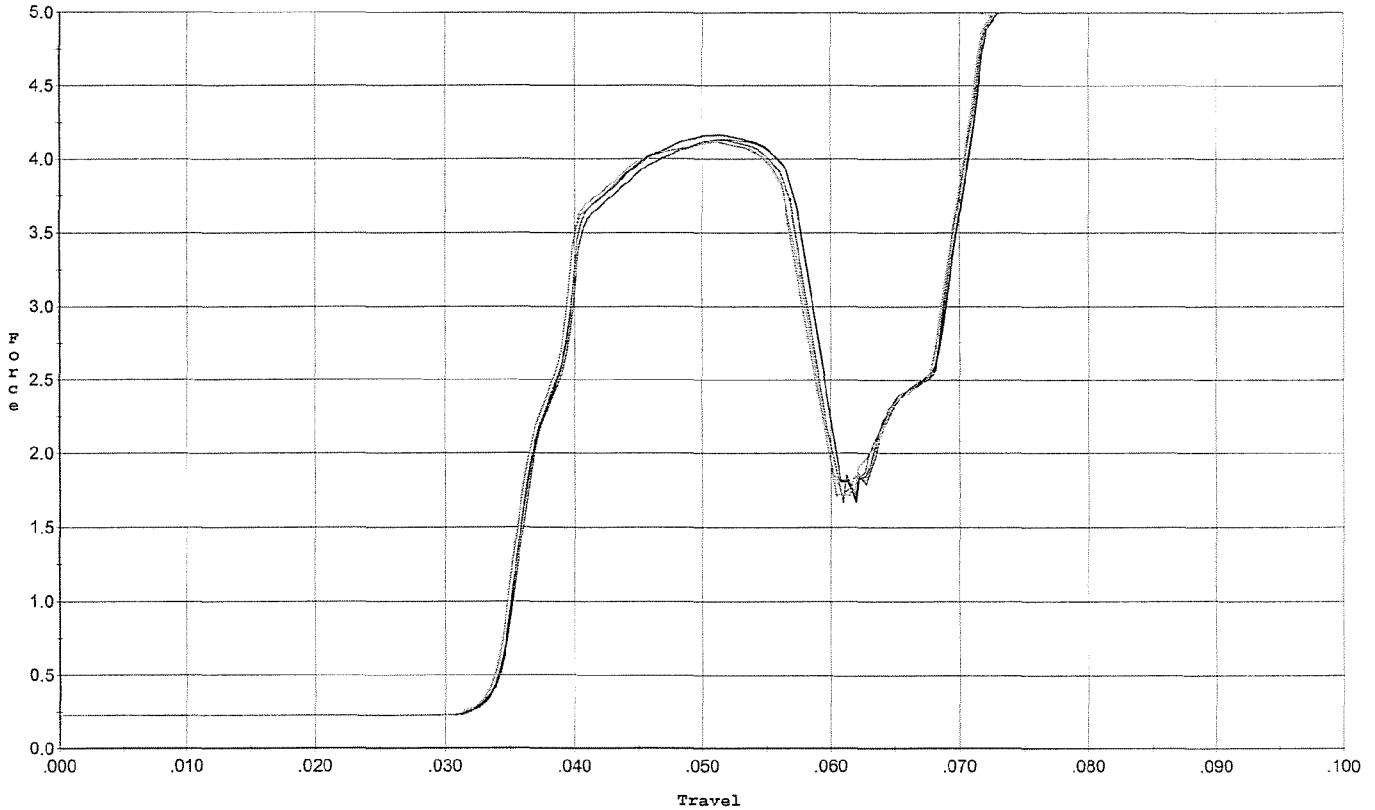
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.054	0.033	0.035	0.053		Set Trigger
2	2.505	0.056	0.033	0.034	0.054		Set Trigger
3	2.499	0.054	0.034	0.035	0.052		Set Trigger
4	2.504	0.054	0.033	0.035	0.053		Set Trigger
5	2.493	0.054	0.033	0.035	0.053		Set Trigger

AVG 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/09/08

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	4.135	0.058	0.034	0.032	0.090		Set Trigger
2	4.164	0.057	0.034	0.032	0.091		Set Trigger
3	4.134	0.057	0.034	0.032	0.089		Set Trigger
4	4.112	0.058	0.033	0.032	0.090		Set Trigger
5	4.117	0.056	0.033	0.033	0.088		Set Trigger

Avg 4.13