

G-63C 1030

DD FORM

M24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
- INSTRUCTION BOOK 5618



ORDER NO. **25716**
BARREL LENGTH 24"
CAPACITY 6
G6361030

NEW! IMPORTANT!
NEVER DISPOSE OF THIS
INSTRUCTION BOOK WITHOUT
THE REMINGTON RIFLE
IT IS THE KEY TO THE
RIFLE'S PROPER
USE AND MAINTENANCE

Remington®

M24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

ORDER NO. **G6361030**
25716
DD

96019699 9145

MADE IN U.S.A. BY REMINGTON-UMC, INC., HARTFORD, CT 06108

7/22/2004 3:19:29 PM

CRB

2

Original

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)



.MA25716

Shop Order: SWS628758



.ABSW628758

Start Date: 7/20/2004

Finish Date: 8/19/2004

0630

01PC001

Flat Black Powder Coat, Barrel and



0003338174

0640

89SWS1

Reassemble Action.



0003338175

0685

89SWS1

Attach Front and Rear Sight Assemblies



0003338180

0710

89SWS1

Pack Rifle & Stenell SWS Container



.OP0710

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 6636/030

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-6-04	RL
600	PROOF		4-6-04	RL
607	CHECK HEADSPACE		4-6-04	RL
610	DIS-ASSEMBLE GUN		4-6-04	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RL		
615	ROLLMARK CALIBER		4/8/04	RL
617	DRILL AND TAP SIGHT HOLES			
620	APPLY COATINGS (BARREL ACTION)		5-7	TA
	(BOLT)		5-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-14-04	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-14-04	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-14-04	RL
	D) OIL FIRING PIN ASSEMBLY		6-14-04	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP # OPERATION NAME			READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	50	50	50	6-21-04	RT
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	250	250	255	6-21-04	RT
	H) TRIGGER PULL TEST AND RETAINABILITY					6-21-04	RT
	I) FIRING PIN INDENT	.020 MIN	.022	.022	.022	6-21-04	RT
	J) ASSEMBLE STOCK					6-18-04	RT
	K) ASSEMBLE SWIVEL STUDS					6-28-04	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S						
	M) IRON SIGHT ALIGNMENT						
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER						
640	GALLERY TEST AND TARGET		PASS		FAIL	6-18-04	A
	MALFUNCTION		CORRECTION			6-18-04	A
	MALFUNCTION		CORRECTION			6-18-04	A
	MALFUNCTION		CORRECTION			6-18-04	A
	MALFUNCTION		CORRECTION			6-18-04	A
645	INSPECT FOR LIVE AMMO					6-18-04	A
655	FINAL INSPECTION A) HEADSPACE					6-28-04	RT
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	291	286	293 289 295	6-21-04	RT
	C) FUNCTION						
660	PACK					8-4-04	WA

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL **BARBER - M24 0082222**

2.50 LBS (plus or minus 0.50 LBS)

DATE 6-14-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.35		2.77	
PULL #2	2.62	2.46		2.73	
PULL #3	2.69	2.37		2.56	
PULL #4	2.80	2.36		2.49	
PULL #5	2.92	2.38		2.71	
TOTAL	13.60	11.92		13.26	
AVERAGE	2.72	2.38		2.65	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.28		
PULL #2	3.19	3.09		
PULL #3	3.16	3.13		
PULL #4	3.18	3.17		
PULL #5	3.13	3.17		
TOTAL	15.90	15.84		
AVERAGE	3.18	3.16		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.39	4.13		4.23
PULL #2	4.33	4.22		4.20
PULL #3	4.43	4.28		4.24
PULL #4	4.43	3.93		3.79
PULL #5	4.52	3.98		4.04
TOTAL	22.10	20.54		20.50
AVERAGE	4.42	4.10		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361030.___0
FILE DATE AND TIME: 06/18/2004 06:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.039
The Average Y Centroid of the Five Target Set:	0.130
The Average Point of Impact of the Five Target Set:	0.136
The Average Mean Radius of the Five Target Set:	0.782
The Distance from POA to Centroid Target #1:	0.301
The Distance from Centroid Target #2 to Centroid Target #1:	0.128
The Distance from Centroid Target #3 to Centroid Target #1:	0.405
The Distance from Centroid Target #4 to Centroid Target #1:	0.160
The Distance from Centroid Target #5 to Centroid Target #1:	0.145

SERIAL NUMBER: G6361030. __0

TARGET NUMBER: 1

FILE DATE: 06/18/2004

FILE TIME: 06:43

POINT#	X	Y
1:	-0.995	1.711
2:	-1.007	0.931
3:	-0.148	1.058
4:	-0.007	0.868
5:	0.574	0.870
6:	0.359	0.690
7:	0.665	-0.535
8:	0.445	-0.835
9:	-0.228	-0.436
10:	-0.389	-1.403

X CENTROID: -0.073

Y CENTROID: 0.292

POA TO CENTROID: 0.301

HORZ SPREAD: 1.672

VERT SPREAD: 3.114

GROUP SPREAD: 3.172

MIN RADIUS: 0.580

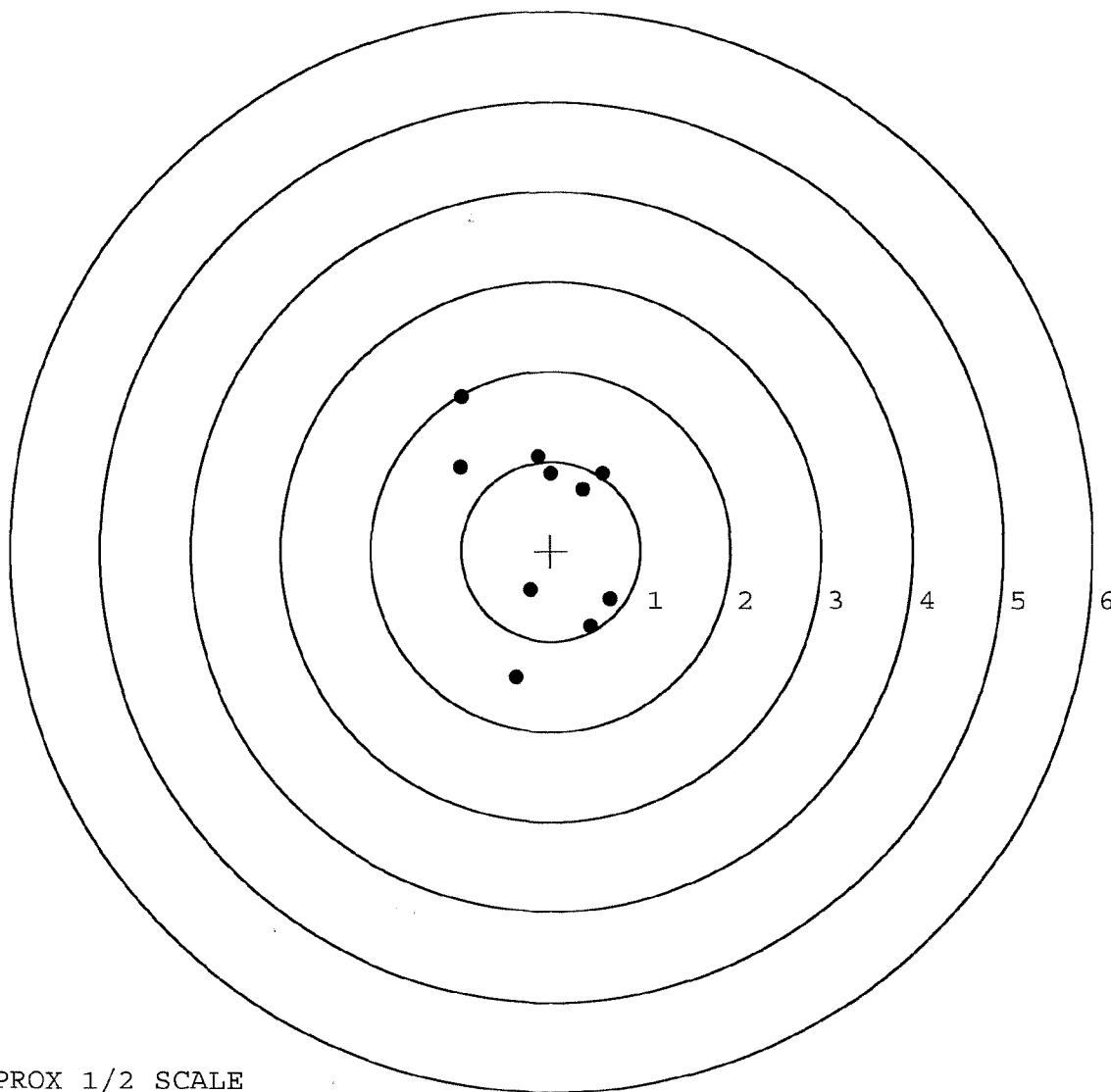
MAX RADIUS: 1.724

MEAN RADIUS: 1.045

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 2

FILE DATE: 06/18/2004

FILE TIME: 06:43

X CENTROID: -0.096

Y CENTROID: 0.165

POA TO CENTROID: 0.191

HORZ SPREAD: 1.725

VERT SPREAD: 2.393

GROUP SPREAD: 2.479

MIN RADIUS: 0.201

MAX RADIUS: 1.358

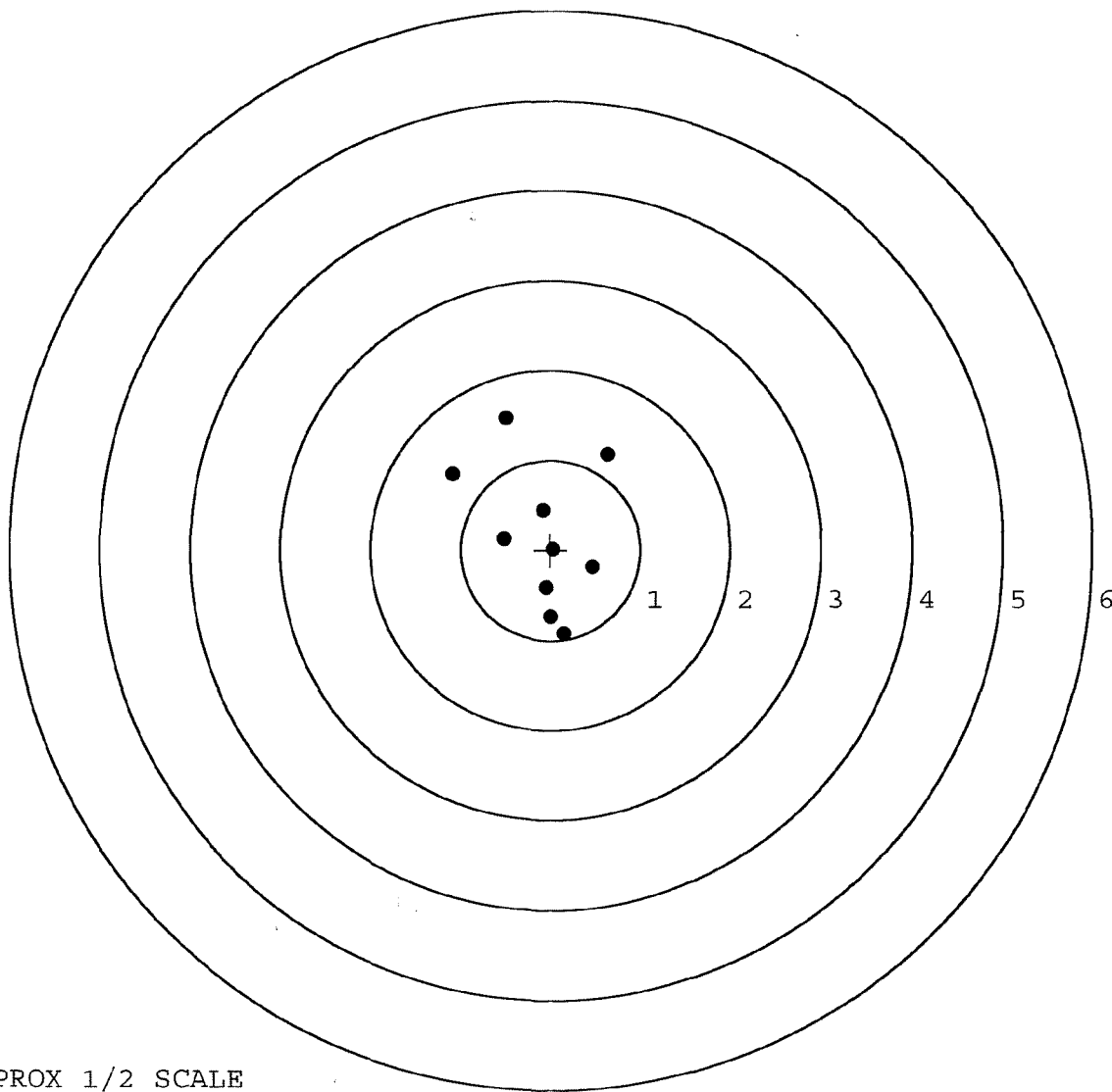
MEAN RADIUS: 0.792

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.495	1.463
2:	0.638	1.063
3:	-1.087	0.842
4:	-0.519	0.123
5:	-0.090	0.445
6:	0.470	-0.193
7:	0.030	0.009
8:	-0.052	-0.426
9:	-0.002	-0.742
10:	0.151	-0.930



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 3

FILE DATE: 06/18/2004

FILE TIME: 06:43

X CENTROID: 0.038

Y CENTROID: -0.097

POA TO CENTROID: 0.104

HORZ SPREAD: 2.433

VERT SPREAD: 1.735

GROUP SPREAD: 2.621

MIN RADIUS: 0.068

MAX RADIUS: 1.544

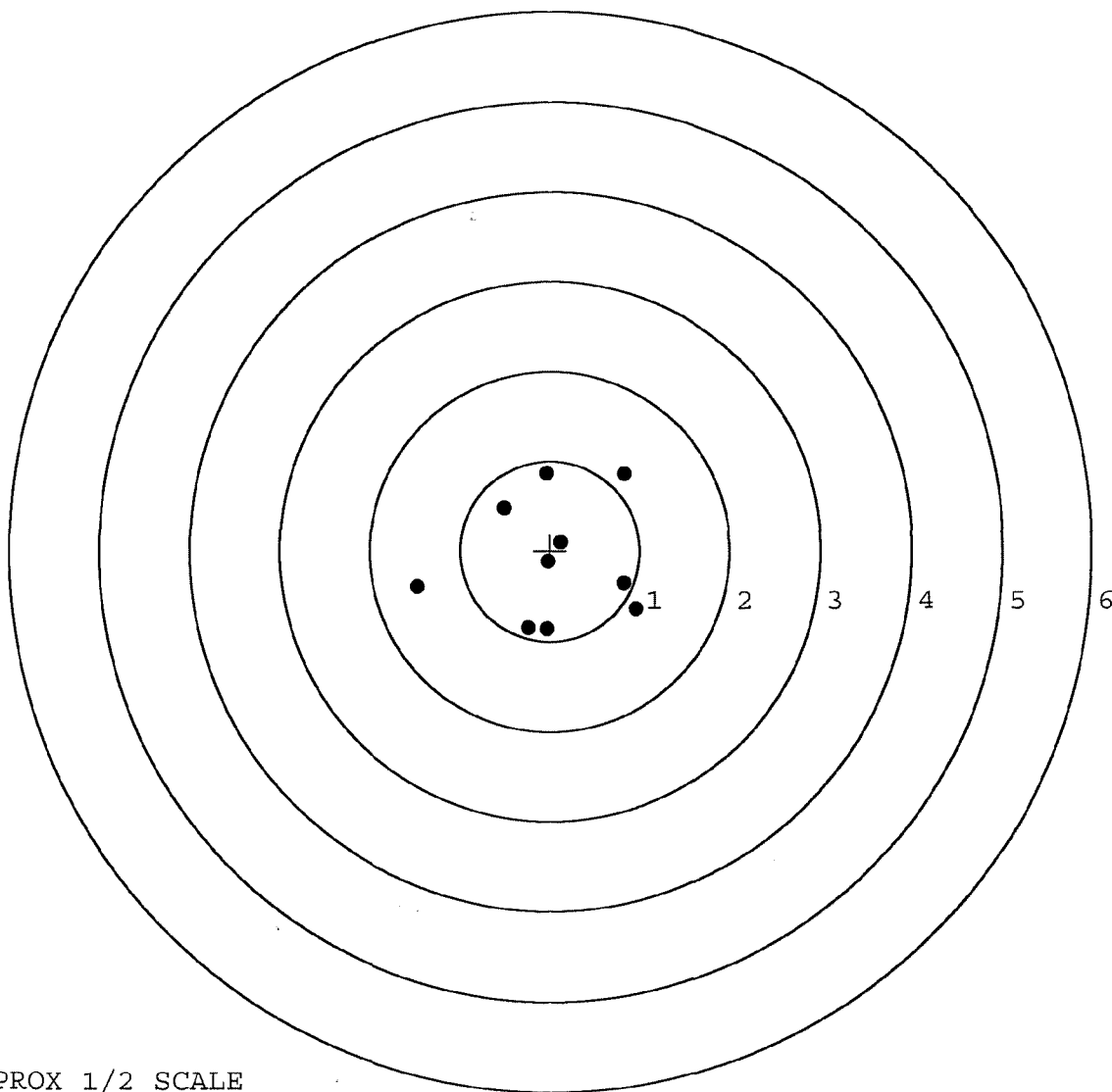
MEAN RADIUS: 0.832

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.823	0.859
2:	-0.042	0.866
3:	-0.515	0.475
4:	0.123	0.099
5:	-0.023	-0.126
6:	0.821	-0.362
7:	0.958	-0.652
8:	-0.039	-0.869
9:	-1.475	-0.402
10:	-0.250	-0.859



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 4

FILE DATE: 06/18/2004

FILE TIME: 06:43

X CENTROID: -0.024

Y CENTROID: 0.140

POA TO CENTROID: 0.142

HORZ SPREAD: 1.920

VERT SPREAD: 2.521

GROUP SPREAD: 2.613

MIN RADIUS: 0.221

MAX RADIUS: 1.661

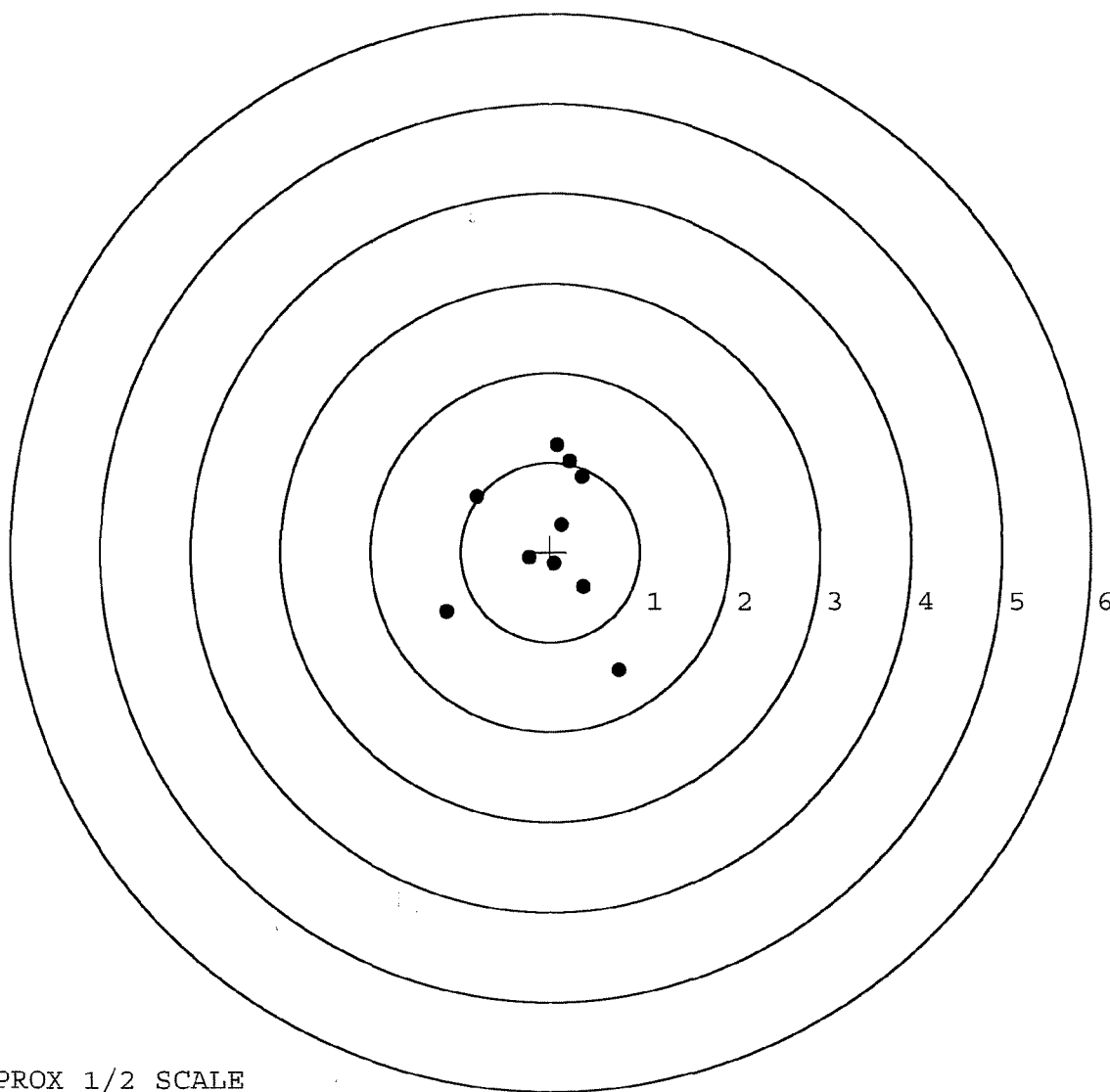
MEAN RADIUS: 0.819

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.077	1.199
2:	0.360	0.836
3:	-0.817	0.615
4:	0.123	0.305
5:	-0.236	-0.063
6:	0.044	-0.129
7:	0.372	-0.387
8:	-1.155	-0.665
9:	0.765	-1.322
10:	0.225	1.010



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 5

FILE DATE: 06/18/2004

FILE TIME: 06:43

POINT#	X	Y
1:	0.411	0.776
2:	-0.757	0.615
3:	-0.202	-0.543
4:	-0.268	0.349
5:	0.309	0.296
6:	0.115	0.010
7:	0.163	-0.245
8:	-0.116	-0.043
9:	-0.096	0.303
10:	0.055	-0.009

X CENTROID: -0.039

Y CENTROID: 0.151

POA TO CENTROID: 0.156

HORZ SPREAD: 1.168

VERT SPREAD: 1.319

GROUP SPREAD: 1.284

MIN RADIUS: 0.163

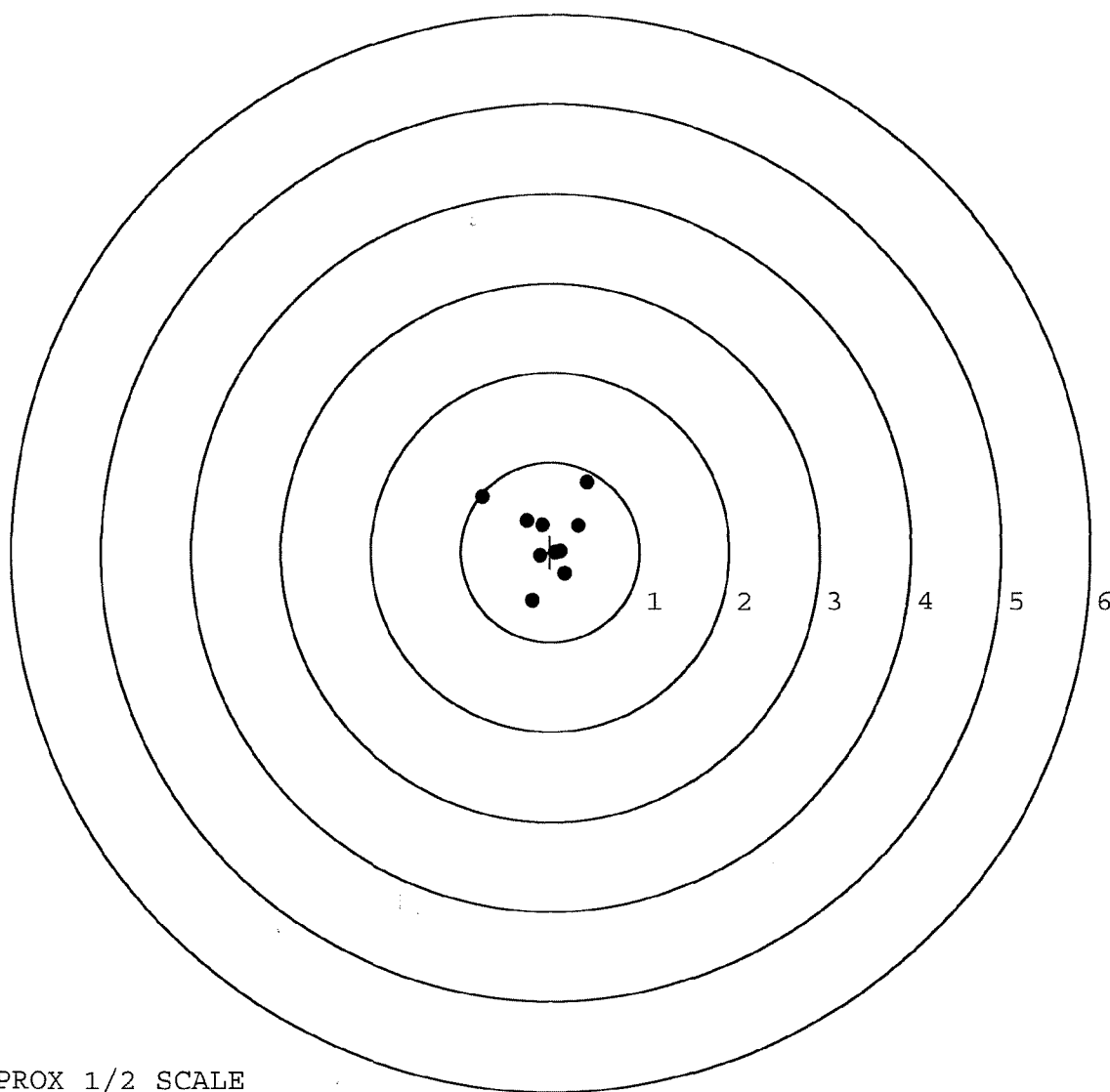
MAX RADIUS: 0.855

MEAN RADIUS: 0.423

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE