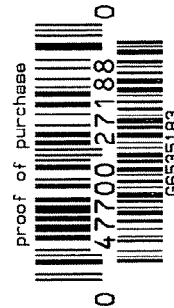


66535183

M24A2 SWS - RIFLE ONLY
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

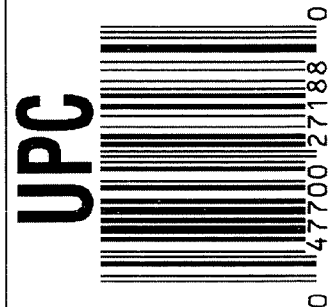


ORDER NO. **27188**

BARREL LENGTH 24"

CAPACITY 6

G6535183



A 2

GUN SERIAL # C653 5183

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-15-08	RTZ
430	ASSEMBLE TO STOCK		9-15-08	RTZ
440	PROOF		9-16-08	TRW
460	CHECK HEADSPACE		9-16-08	TRW
470	DIS-ASSEMBLE ACTION		9-16-08	RTZ
472	SERIALIZE BOLT HANDLE		9-16-08	RTZ
475	DRILL AND TAP SIGHT HOLES		N/A	
480	MAGNAFLUX BBL ACTION		9-17-08	BA
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/18/08	RT
520	GOFF BLAST BBL / REC		9/19/08	DG
542	APPLY COATINGS (BARREL ACTION)		9-24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-27-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

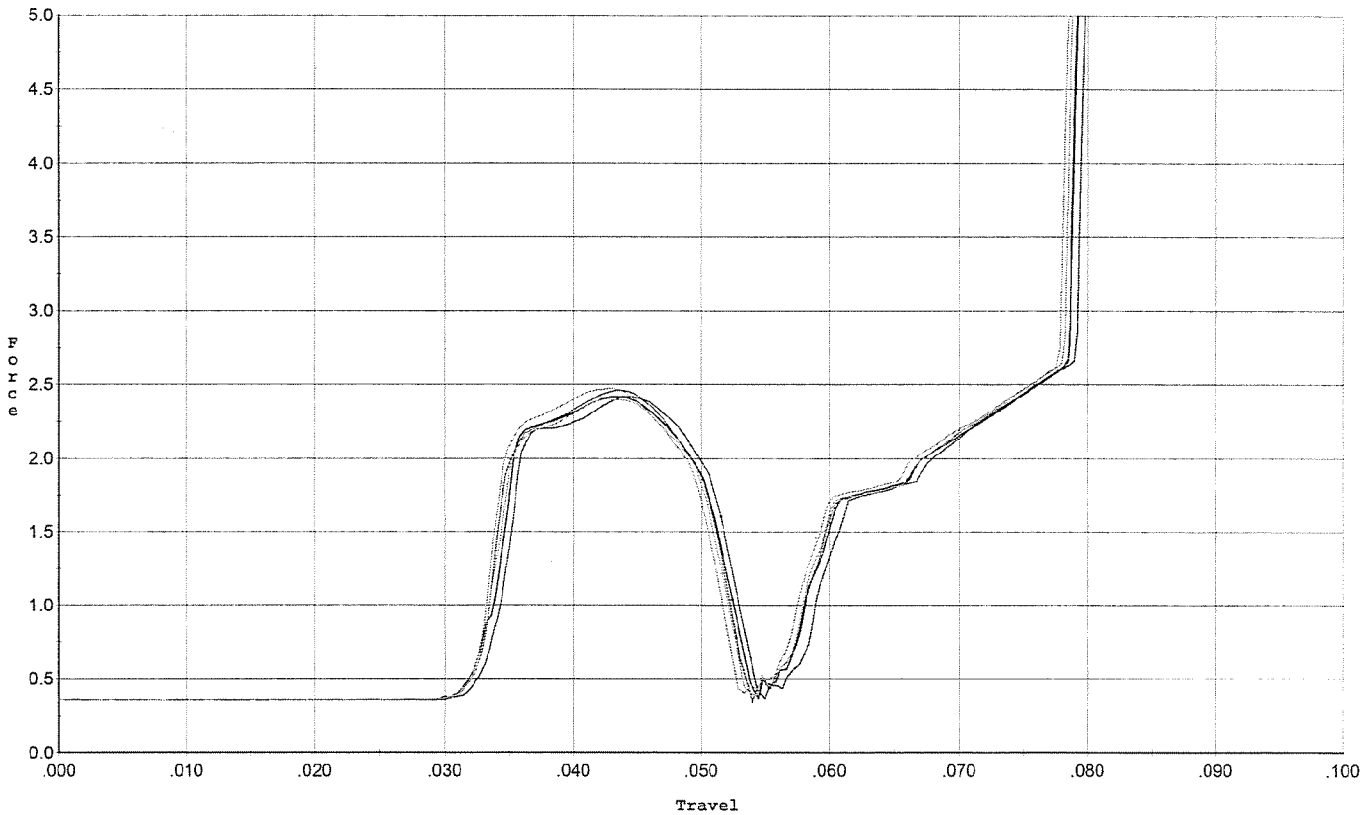
OP #	OPERATION NAME	READINGS	DATE	INITIAL
BARBER - M24 0089243				
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.0</u>	10-2-08	X J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10-2-08	X J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	10-2-08	X J.
	J) ASSEMBLE STOCK		9-27-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-2-08	X J.
	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	PASS FAIL PASS FAIL	9-27-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-27-08	X J.
670	FINAL INSPECTION A) HEADSPACE		10-2-08	X J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.19</u> <u>2.70</u> <u>2.23</u> <u>2.18</u> <u>2.25</u>	9-29-08	π
	C) FUNCTION		10-2-08	X J.
690	PACK		10/4/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/22/08

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



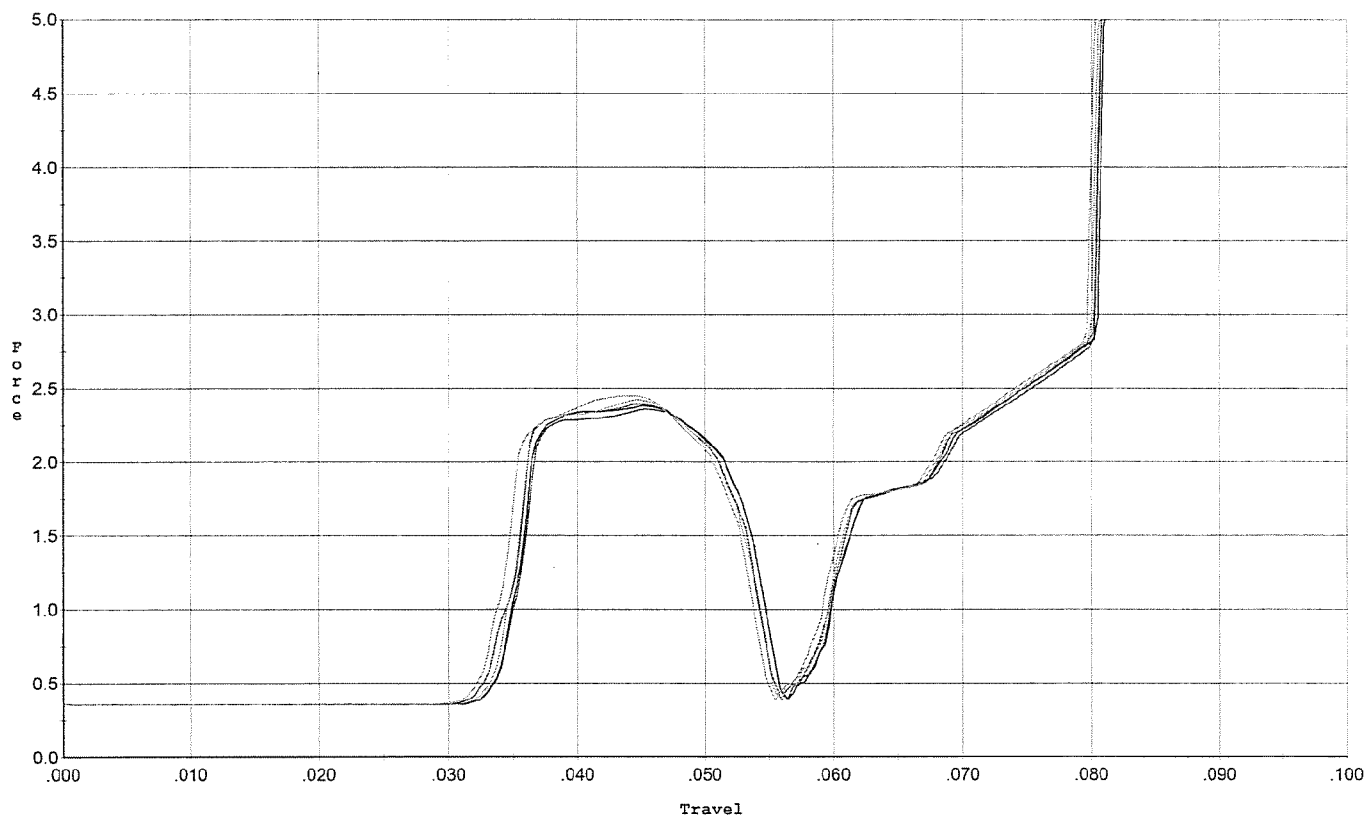
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.419	0.052	0.033	0.034	0.050		Set Trigger
2	2.418	0.052	0.032	0.034	0.052		Set Trigger
3	2.461	0.051	0.033	0.034	0.051		Set Trigger
4	2.401	0.052	0.033	0.033	0.051		Set Trigger
5	2.473	0.051	0.032	0.034	0.051		Set Trigger

Aug 2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



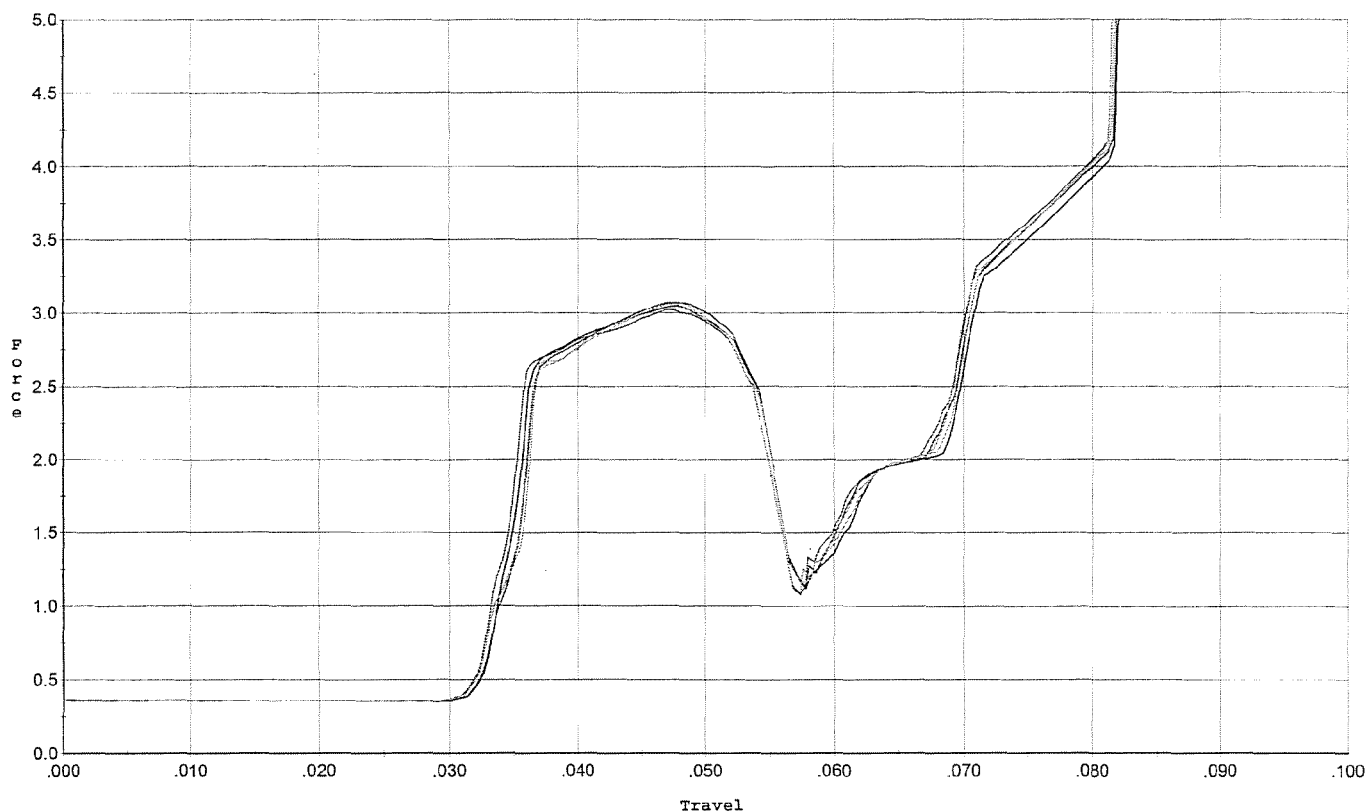
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.360	0.054	0.034	0.034	0.053		Set Trigger
2	2.382	0.054	0.034	0.034	0.054		Set Trigger
3	2.396	0.053	0.033	0.034	0.053		Set Trigger
4	2.423	0.053	0.034	0.034	0.053		Set Trigger
5	2.450	0.053	0.032	0.034	0.054		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/22/08

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



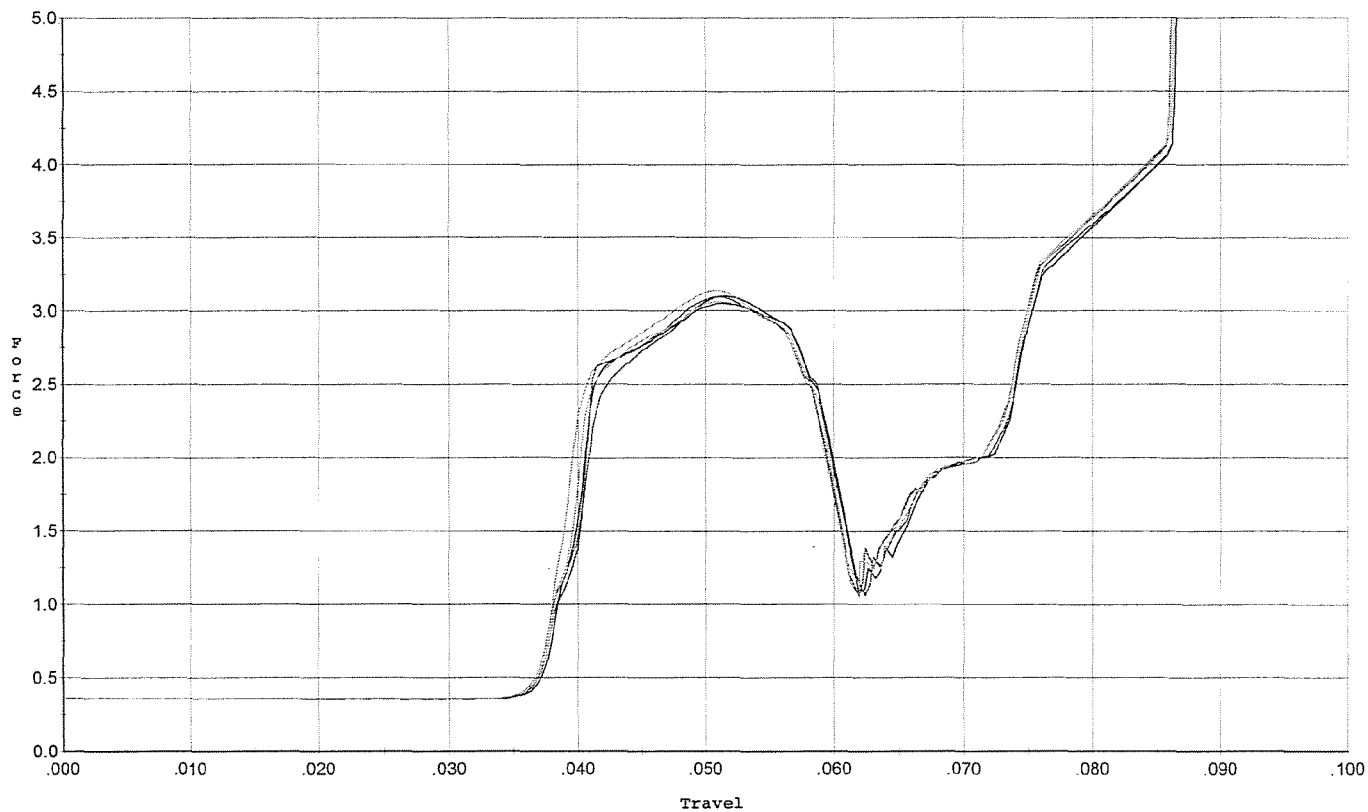
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.071	0.054	0.032	0.033	0.068		Set Trigger
2	3.047	0.054	0.033	0.033	0.069		Set Trigger
3	3.021	0.055	0.032	0.033	0.070		Set Trigger
4	3.077	0.054	0.032	0.033	0.068		Set Trigger
5	3.060	0.055	0.032	0.033	0.069		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/22/08

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



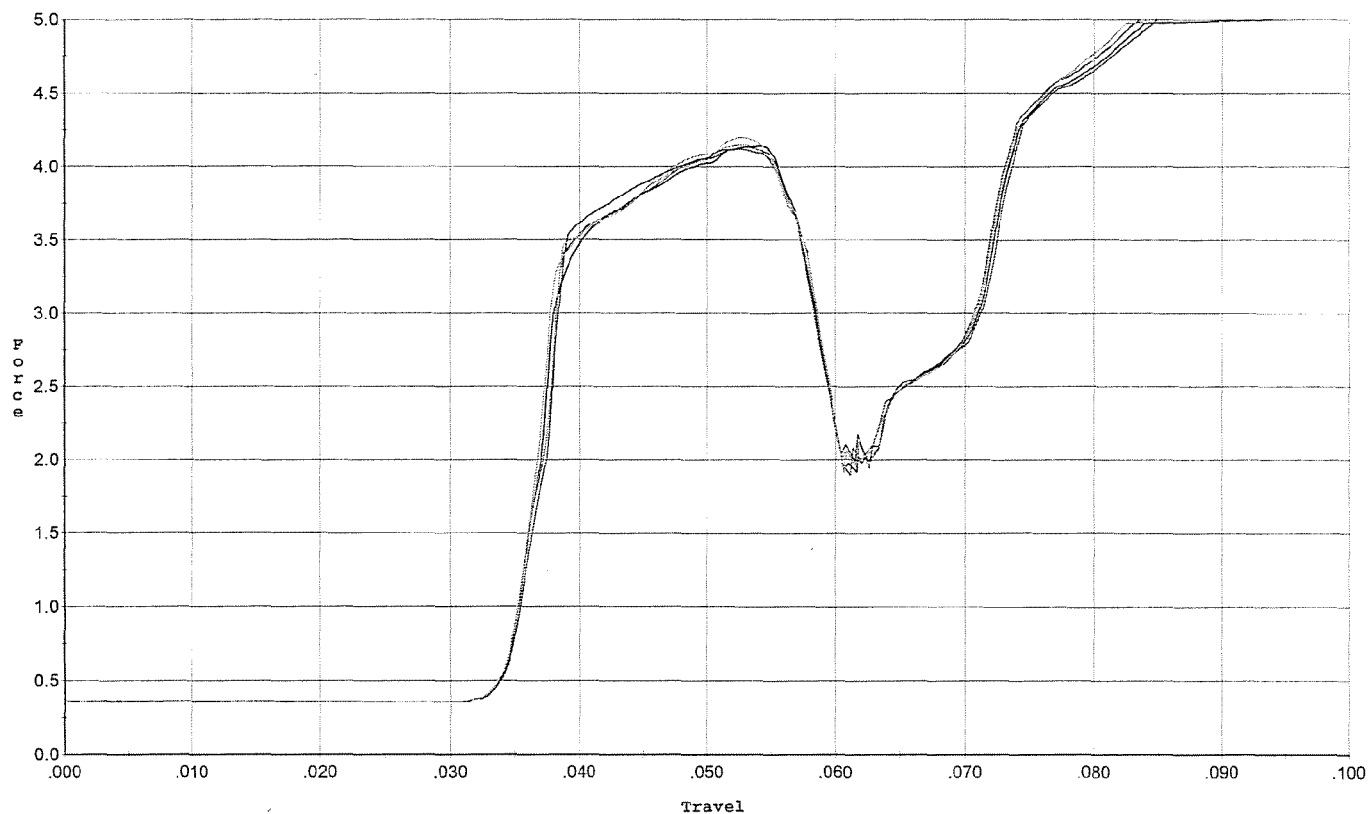
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.052	0.060	0.037	0.033	0.071		Set Trigger
2	3.101	0.060	0.037	0.033	0.072		Set Trigger
3	3.096	0.059	0.037	0.033	0.070		Set Trigger
4	3.061	0.059	0.037	0.033	0.070		Set Trigger
5	3.139	0.060	0.037	0.033	0.073		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



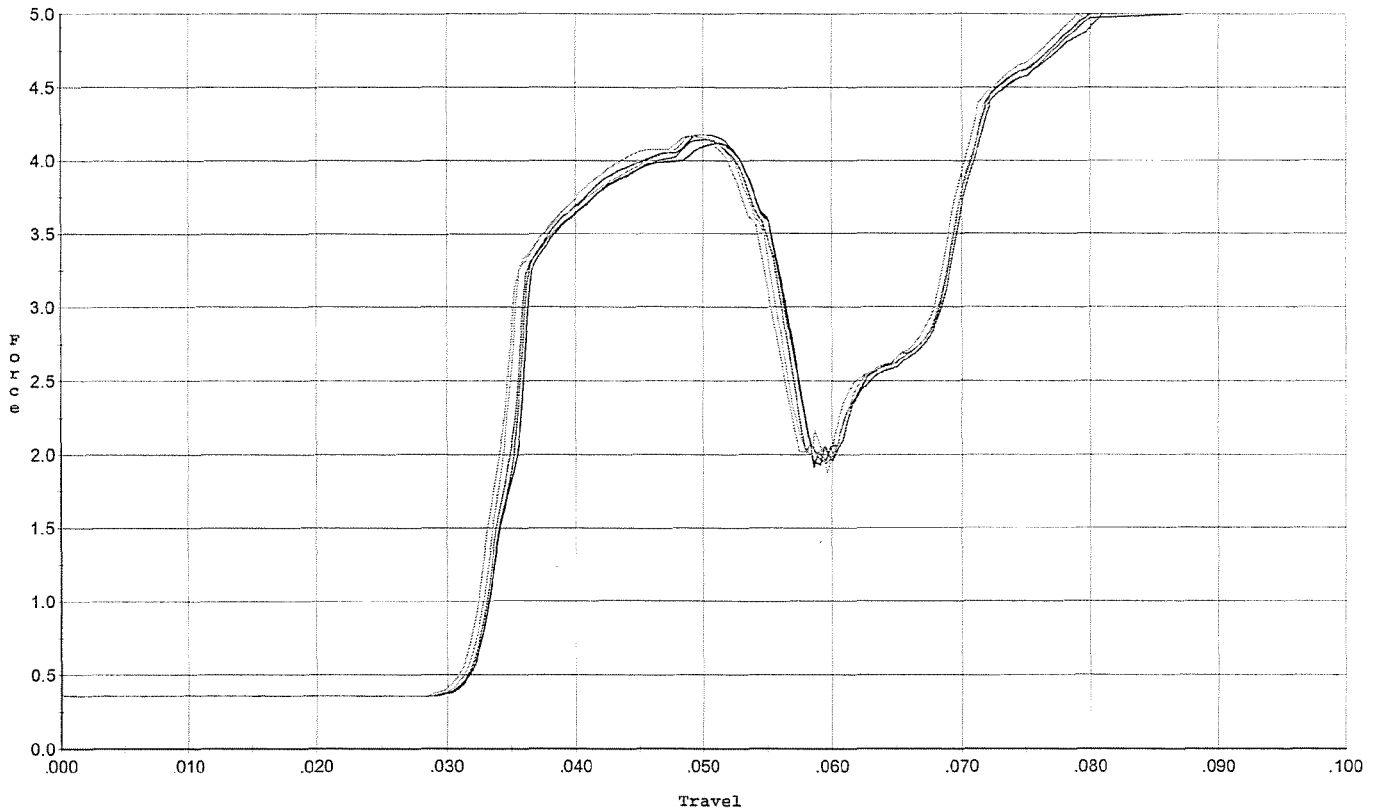
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.138	0.058	0.034	0.031	0.095		Set Trigger
2	4.142	0.058	0.034	0.031	0.096		Set Trigger
3	4.120	0.059	0.034	0.031	0.096		Set Trigger
4	4.203	0.058	0.034	0.031	0.096		Set Trigger
5	4.148	0.058	0.034	0.031	0.096		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



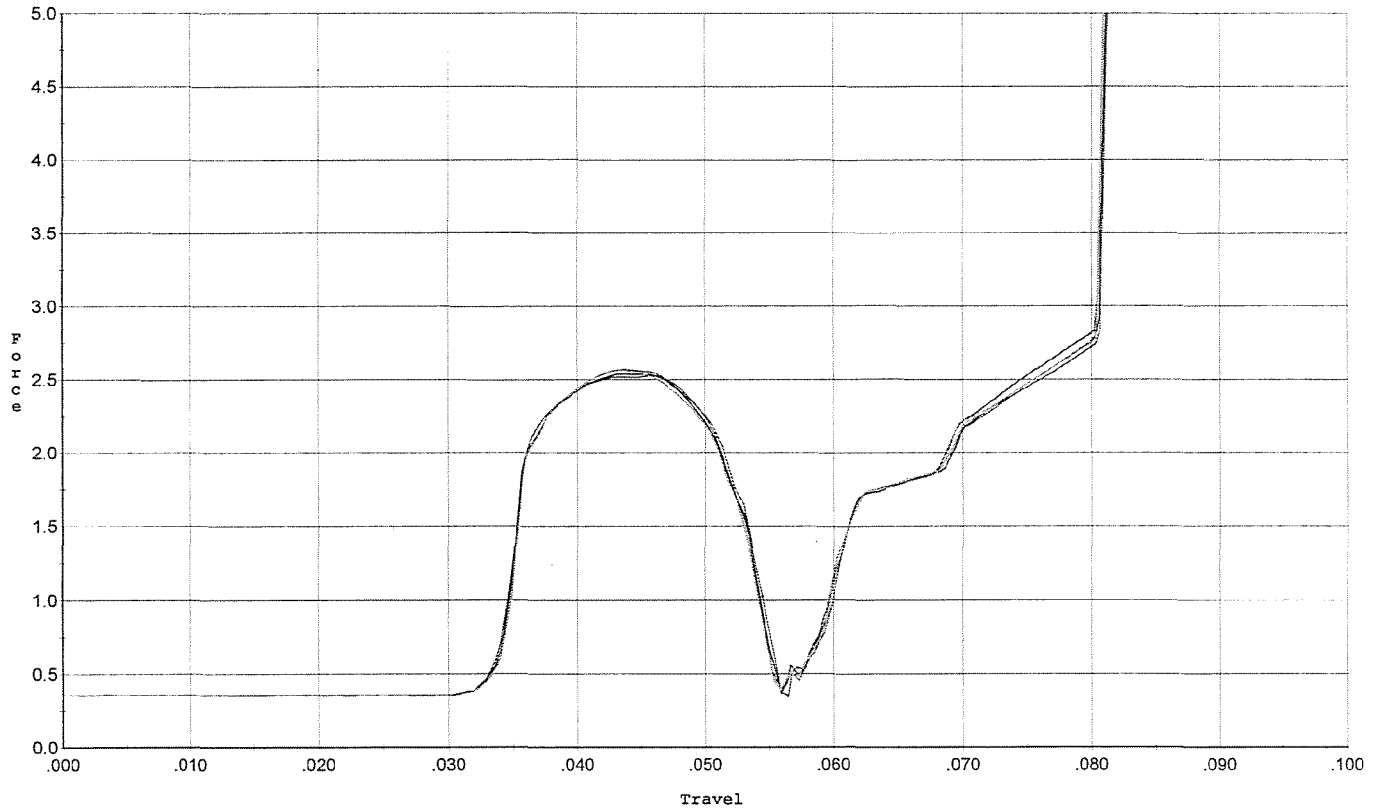
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.177	0.057	0.032	0.030	0.096		Set Trigger
2	4.120	0.056	0.032	0.030	0.094		Set Trigger
3	4.144	0.055	0.032	0.030	0.093		Set Trigger
4	4.178	0.055	0.032	0.031	0.092		Set Trigger
5	4.163	0.054	0.031	0.031	0.092		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



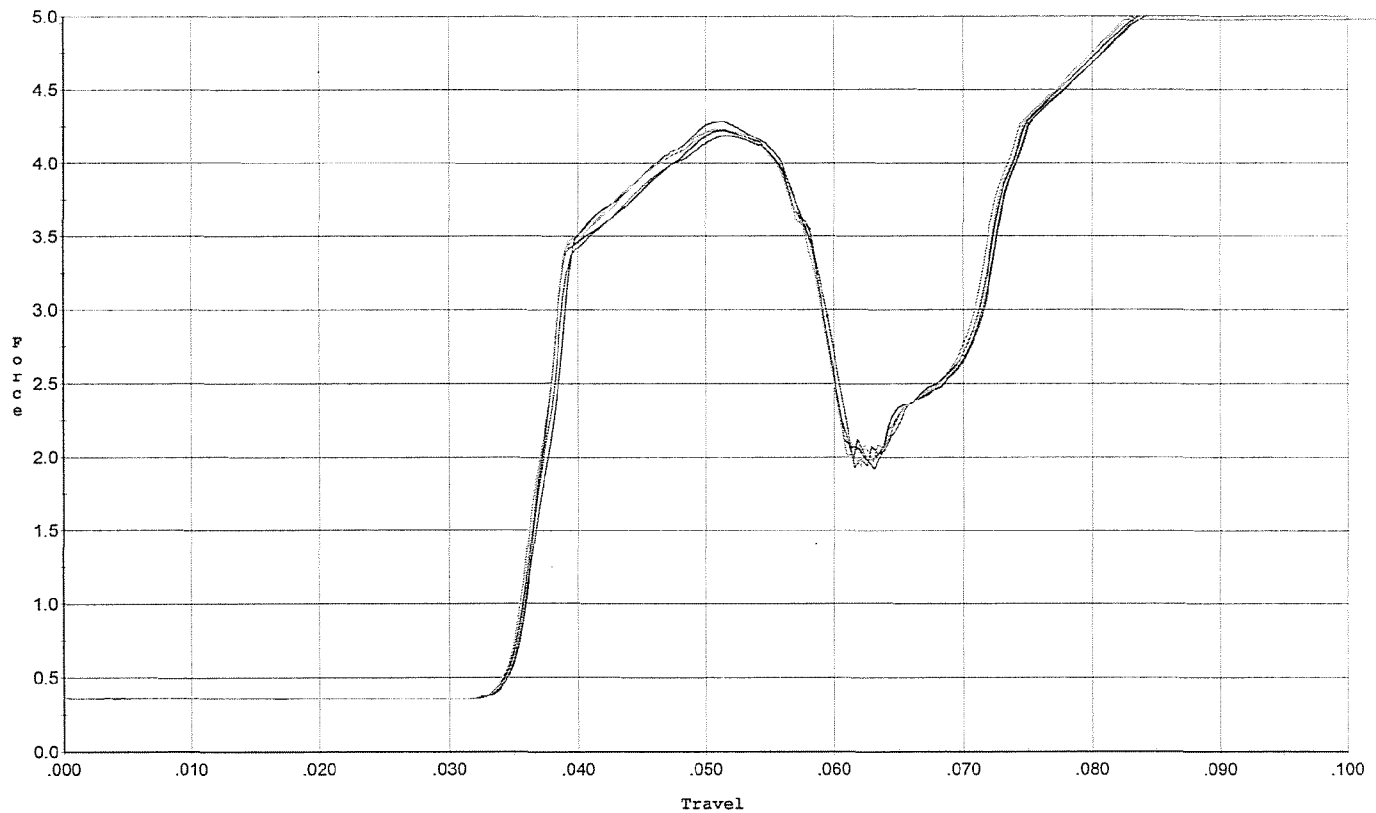
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.053	0.033	0.034	0.055		Set Trigger
2	2.539	0.053	0.034	0.034	0.054		Set Trigger
3	2.572	0.054	0.034	0.034	0.056		Set Trigger
4	2.565	0.053	0.034	0.034	0.054		Set Trigger
5	2.568	0.053	0.034	0.034	0.055		Set Trigger

AVG 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/22/08

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	4.282	0.058	0.035	0.031	0.096		Set Trigger
2	4.221	0.058	0.035	0.030	0.097		Set Trigger
3	4.187	0.059	0.035	0.030	0.099		Set Trigger
4	4.232	0.058	0.035	0.030	0.097		Set Trigger
5	4.232	0.059	0.034	0.030	0.098		Set Trigger

Avg 4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535183.___0
FILE DATE AND TIME: 09/27/2008 09:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.194
The Average Point of Impact of the Five Target Set:	0.194
The Average Mean Radius of the Five Target Set:	0.854
The Distance from POA to Centroid Target #1:	0.137
The Distance from Centroid Target #2 to Centroid Target #1:	0.228
The Distance from Centroid Target #3 to Centroid Target #1:	0.179
The Distance from Centroid Target #4 to Centroid Target #1:	0.418
The Distance from Centroid Target #5 to Centroid Target #1:	0.400

BARBER - M24 0089253

SERIAL NUMBER: G6535183. __0

TARGET NUMBER: 1

FILE DATE: 09/27/2008

FILE TIME: 09:04

POINT#	X	Y
1:	0.000	-1.292
2:	0.817	0.028
3:	0.480	0.349
4:	0.308	0.120
5:	0.145	-0.210
6:	-0.239	-0.485
7:	-0.153	-0.778
8:	-0.791	-0.380
9:	-0.563	-0.042
10:	-0.180	1.328

X CENTROID: -0.018

Y CENTROID: -0.136

POA TO CENTROID: 0.137

HORZ SPREAD: 1.608

VERT SPREAD: 2.620

GROUP SPREAD: 2.626

MIN RADIUS: 0.179

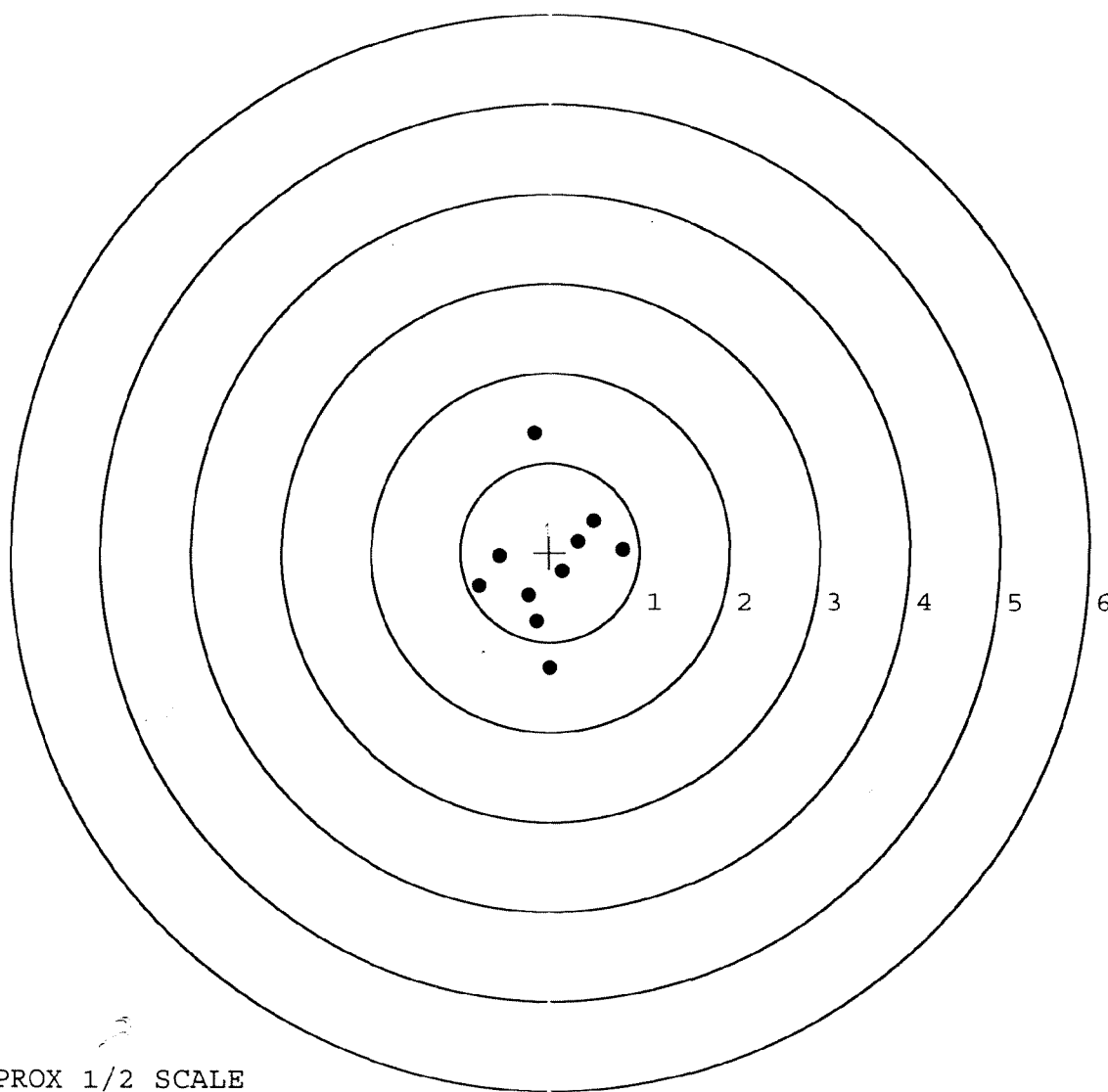
MAX RADIUS: 1.473

MEAN RADIUS: 0.720

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0089254

SERIAL NUMBER: G6535183. __0

TARGET NUMBER: 2

FILE DATE: 09/27/2008

FILE TIME: 09:04

POINT#	X	Y
1:	0.677	1.890
2:	-0.384	0.621
3:	0.241	0.434
4:	0.770	0.095
5:	0.007	0.159
6:	0.296	-0.590
7:	0.023	-0.438
8:	-0.499	-0.661
9:	-0.805	-0.495
10:	-0.803	-0.112

X CENTROID: -0.048

Y CENTROID: 0.090

POA TO CENTROID: 0.102

HORZ SPREAD: 1.575

VERT SPREAD: 2.551

GROUP SPREAD: 2.809

MIN RADIUS: 0.088

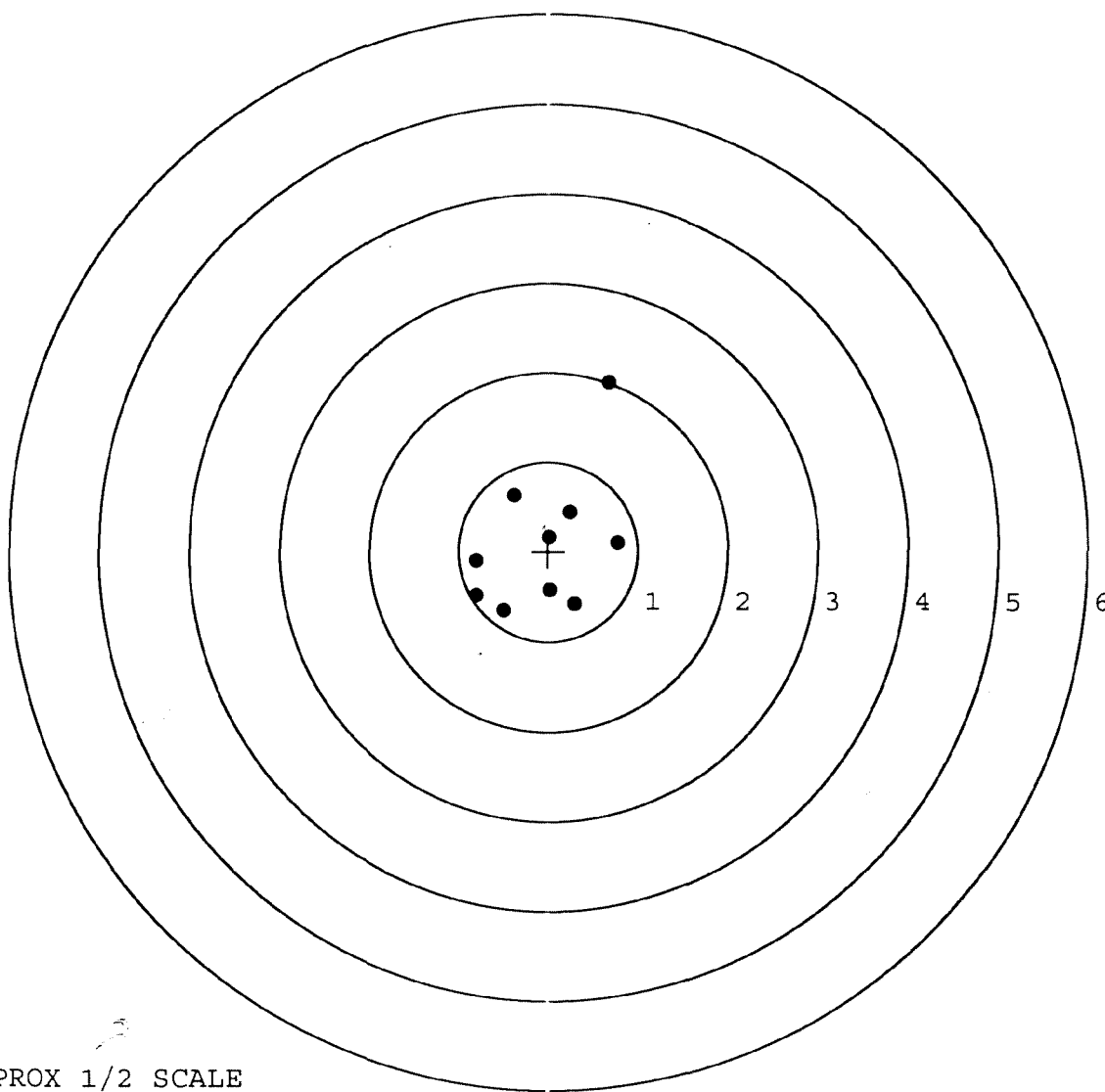
MAX RADIUS: 1.940

MEAN RADIUS: 0.783

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0089255

SERIAL NUMBER: G6535183. __0

TARGET NUMBER: 3

FILE DATE: 09/27/2008

FILE TIME: 09:04

POINT#	X	Y
1:	0.737	-0.183
2:	0.511	0.119
3:	0.123	-0.110
4:	0.232	-0.840
5:	-0.210	-0.765
6:	-0.430	-0.509
7:	-0.394	0.186
8:	0.015	0.592
9:	-1.130	0.387
10:	1.234	1.334

X CENTROID: 0.069

Y CENTROID: 0.021

POA TO CENTROID: 0.072

HORZ SPREAD: 2.364

VERT SPREAD: 2.174

GROUP SPREAD: 2.548

MIN RADIUS: 0.142

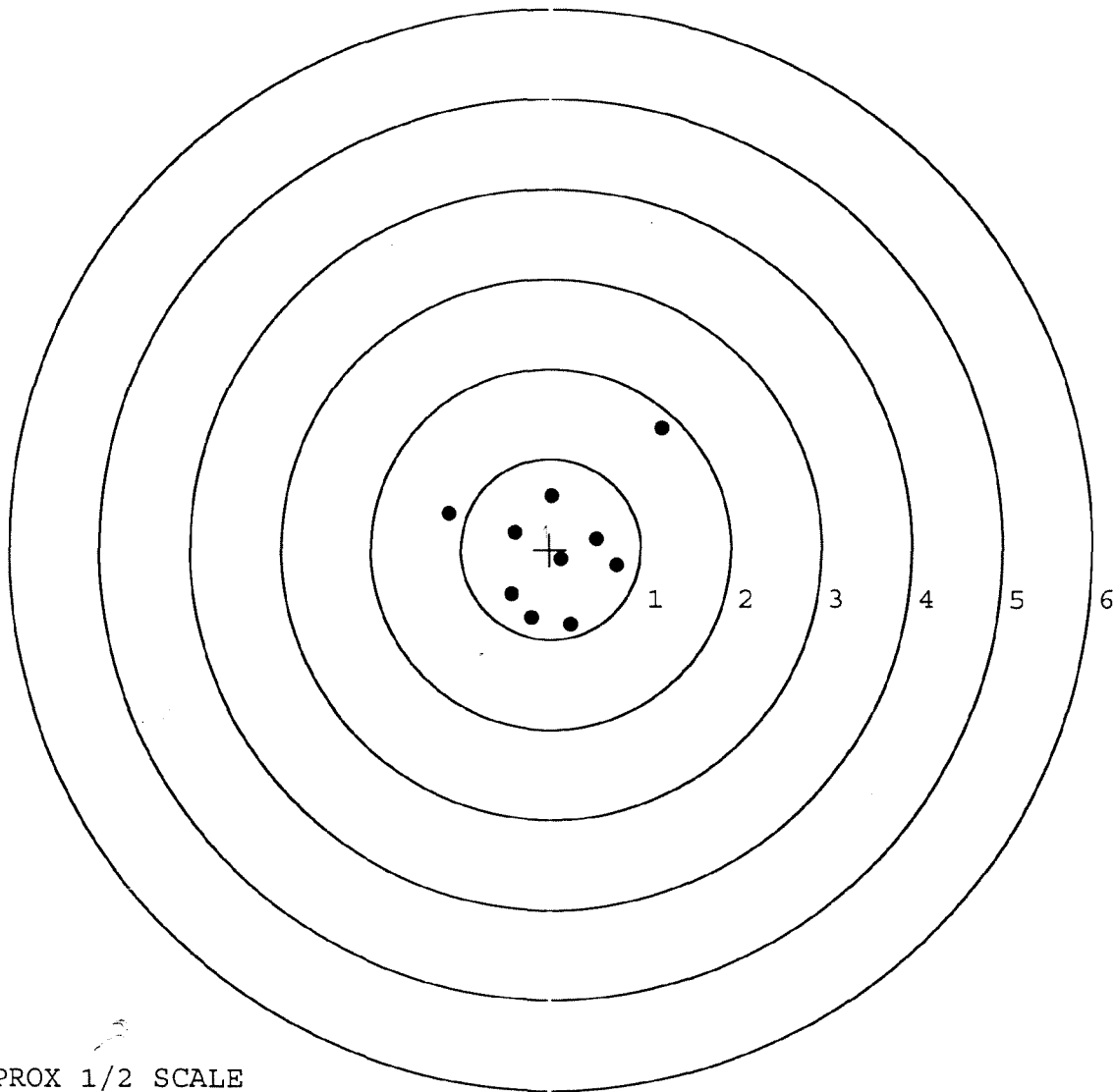
MAX RADIUS: 1.755

MEAN RADIUS: 0.781

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0089256

SERIAL NUMBER: G6535183. 0

TARGET NUMBER: 4

FILE DATE: 09/27/2008

FILE TIME: 09:04

POINT#	X	Y
1:	0.992	-0.513
2:	1.151	1.070
3:	1.187	-1.954
4:	0.116	-1.558
5:	-0.027	-1.676
6:	-0.084	0.715
7:	-0.107	-0.191
8:	-0.260	0.093
9:	-0.139	-0.499
10:	-0.574	-0.255

X CENTROID: 0.226

Y CENTROID: -0.477

POA TO CENTROID: 0.527

HORZ SPREAD: 1.761

VERT SPREAD: 3.024

GROUP SPREAD: 3.024

MIN RADIUS: 0.365

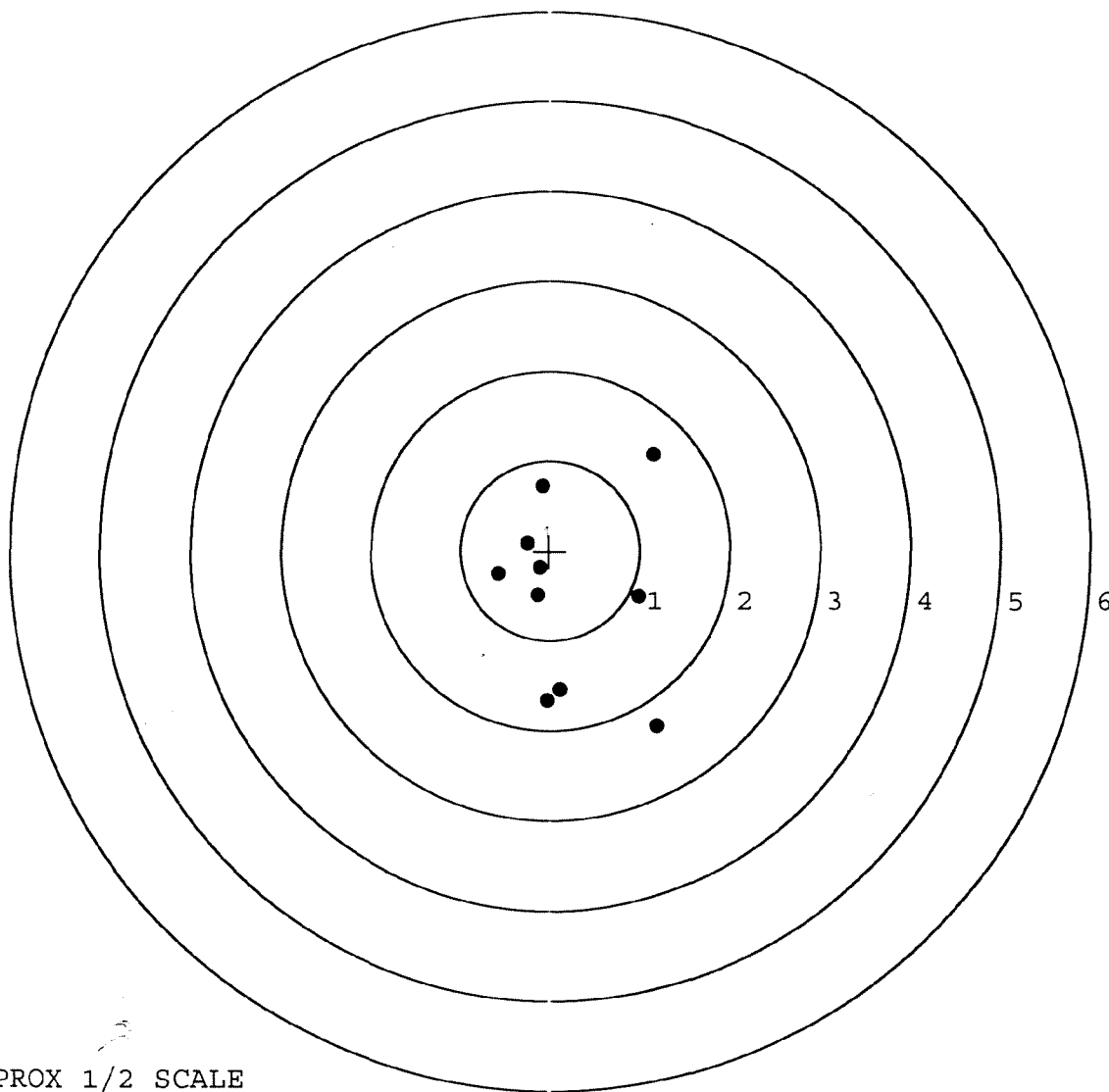
MAX RADIUS: 1.803

MEAN RADIUS: 1.026

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0089257

SERIAL NUMBER: G6535183. __0

TARGET NUMBER: 5

FILE DATE: 09/27/2008

FILE TIME: 09:04

POINT#	X	Y
1:	0.968	-0.142
2:	0.202	-0.455
3:	-0.103	-0.587
4:	-0.528	-0.389
5:	-0.609	-0.092
6:	-0.537	0.420
7:	-0.017	0.463
8:	-2.199	-0.091
9:	0.112	-1.371
10:	0.327	-2.455

X CENTROID: -0.238

Y CENTROID: -0.470

POA TO CENTROID: 0.527

HORZ SPREAD: 3.167

VERT SPREAD: 2.918

GROUP SPREAD: 3.460

MIN RADIUS: 0.179

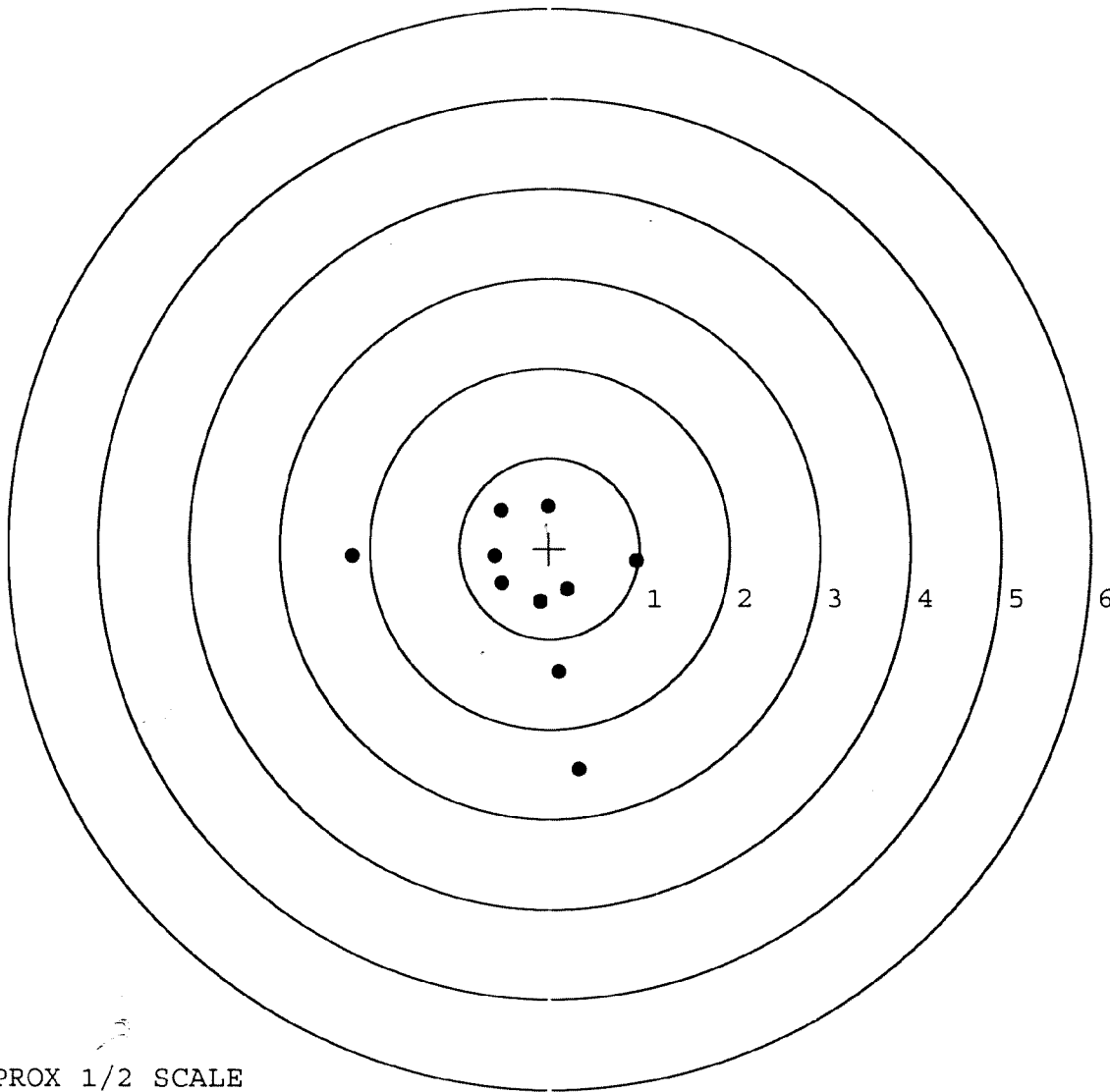
MAX RADIUS: 2.064

MEAN RADIUS: 0.963

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE