

5676 4922

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

- INSTRUCTION BOOK 3518

BM FORM

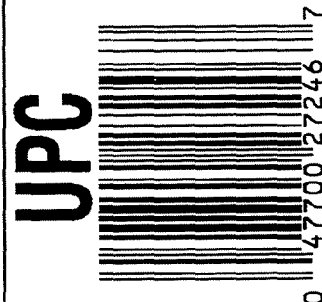


ORDER NO. **27246**

BARREL LENGTH **24"**

CAPACITY **6**

G6764922



SOP 6238

GUN SERIAL # C6764922

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-23-08	RTZ
430	ASSEMBLE TO STOCK		7-23-08	MED
440	PROOF		7-23-08	TRW
460	CHECK HEADSPACE		7-23-08	TRW
470	DIS-ASSEMBLE ACTION		7-23-08	RTZ
472	SERIALIZE BOLT HANDLE		7-24-08	RTZ
475	DRILL AND TAP SIGHT HOLES			
480	MAGNAFLUX BBL ACTION	Scrap	7-25-08	BT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/5/08	RT
520	GOFF BLAST BBL / REC		8/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		8/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8/21/08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-15-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-15-08	JP
	D) OIL FIRING PIN ASSEMBLY		8-21-08	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>3.0</u> <u>3.0</u> <u>3.0</u>	9.4.08	PSW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.5</u> <u>5.5</u>	9.4.08	PSW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	9.4.08	PSW
	J) ASSEMBLE STOCK		8-21-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		9.5.08	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT		N/A	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL <u>PASS</u> FAIL	9.3.08	FN
	MALFUNCTION <i>Bolt Binds</i>	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9.3.08	TRW
670	FINAL INSPECTION A) HEADSPACE		9.4.08	PSW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>263</u> <u>265</u> <u>258</u> <u>265</u> <u>265</u>	9.4.08	RTZ
	C) FUNCTION		9.4.08	PSW
690	PACK			

F004 REV 5/2006

M-24 INSPECTION CHECKLIST
 CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER

SERIAL NUMBER

66764922

LOG-IN DATE

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN		
505	RE-BARREL		
560	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	8-5-08	BTT
510	DRILL AND TAP		
615	ROLLMARK CALIBER	8/5/08	RT
618	ROTO-BLAST	8/6/08	DG
620	APPLY COATINGS	8/8	
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	PASS	FAIL
650	TARGET	PASS	FAIL
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION		
	A) HEADSPACE	PASS	FAIL
	B) TRIGGER PULL		
	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		
680	F) SAFETY ON FORCE		
	2 LBS MIN 10 LBS MAX		
	G) SAFETY OFF FORCE		
	2 LBS 0.015"		
	I) FIRING PIN INDENT		
	.020		
690	PACK		

MAGNA - FLUX

AUG 05 2008

OPERATOR BTT

8/5/08

RT

8/6/08

DG

8/8

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6764922.__0
FILE DATE AND TIME: 09/03/2008 10:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	-0.082
The Average Point of Impact of the Five Target Set:	0.091
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.359
The Distance from Centroid Target #2 to Centroid Target #1:	0.558
The Distance from Centroid Target #3 to Centroid Target #1:	0.527
The Distance from Centroid Target #4 to Centroid Target #1:	0.172
The Distance from Centroid Target #5 to Centroid Target #1:	0.184

SERIAL NUMBER: G6764922. __0

TARGET NUMBER: 1

FILE DATE: 09/03/2008

FILE TIME: 10:38

X CENTROID: 0.046

Y CENTROID: -0.356

POA TO CENTROID: 0.359

HORZ SPREAD: 3.552

VERT SPREAD: 1.996

GROUP SPREAD: 3.591

MIN RADIUS: 0.059

MAX RADIUS: 2.385

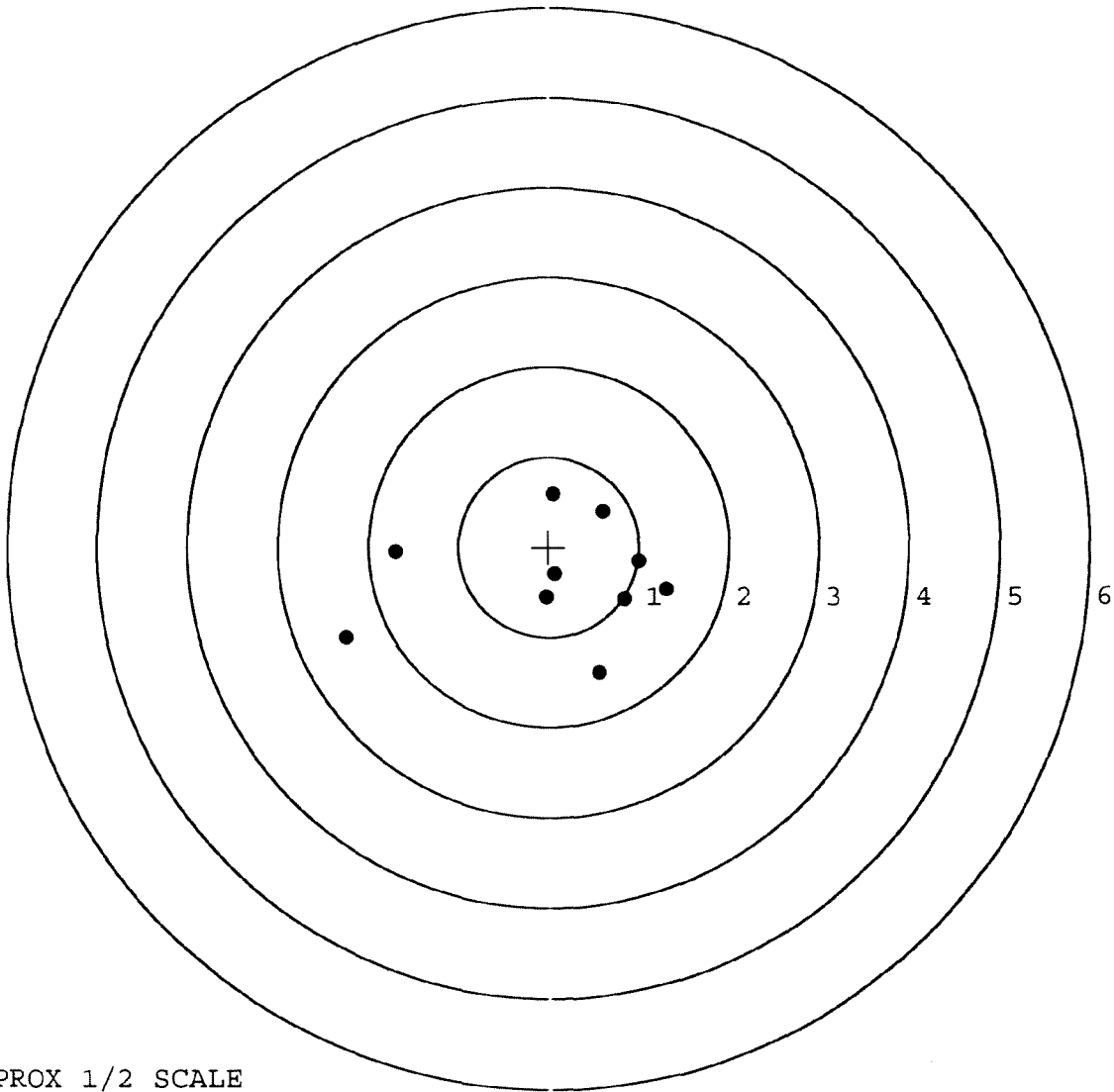
MEAN RADIUS: 1.056

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.566	-1.404
2:	-0.033	-0.563
3:	0.067	-0.301
4:	-2.247	-1.011
5:	-1.696	-0.047
6:	0.050	0.592
7:	0.603	0.399
8:	1.002	-0.166
9:	0.844	-0.584
10:	1.305	-0.480



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. __ 0

TARGET NUMBER: 2

FILE DATE: 09/03/2008

FILE TIME: 10:38

X CENTROID: 0.141

Y CENTROID: 0.193

POA TO CENTROID: 0.239

HORZ SPREAD: 2.440

VERT SPREAD: 2.133

GROUP SPREAD: 2.888

MIN RADIUS: 0.098

MAX RADIUS: 1.643

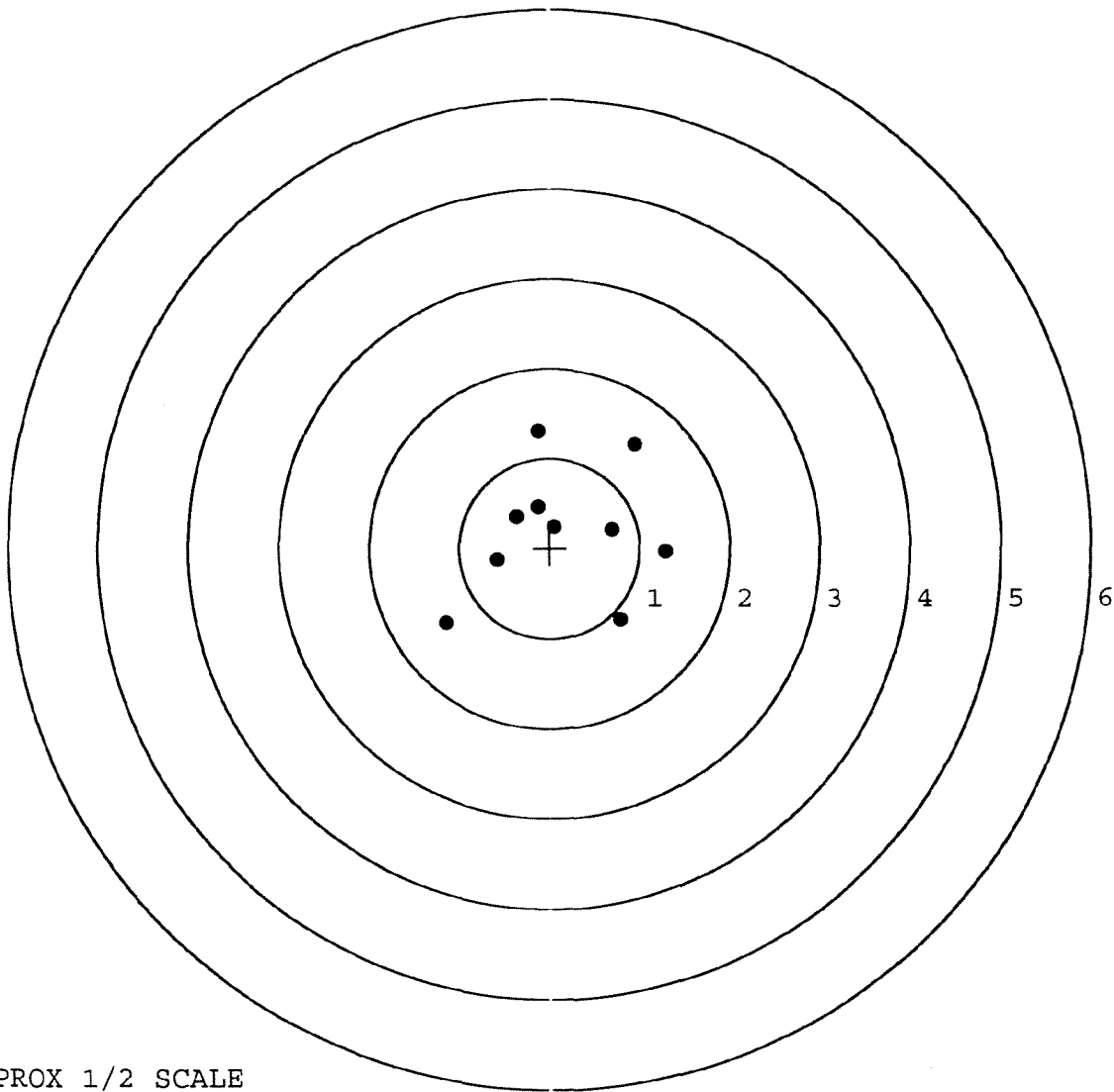
MEAN RADIUS: 0.874

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.147	-0.827
2:	-0.575	-0.127
3:	0.781	-0.788
4:	1.293	-0.042
5:	0.689	0.213
6:	0.953	1.156
7:	-0.131	1.306
8:	-0.132	0.457
9:	0.052	0.234
10:	-0.373	0.349



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. 0

TARGET NUMBER: 3

FILE DATE: 09/03/2008

FILE TIME: 10:38

X CENTROID: -0.084

Y CENTROID: 0.154

POA TO CENTROID: 0.176

HORZ SPREAD: 1.796

VERT SPREAD: 1.396

GROUP SPREAD: 2.070

MIN RADIUS: 0.089

MAX RADIUS: 1.110

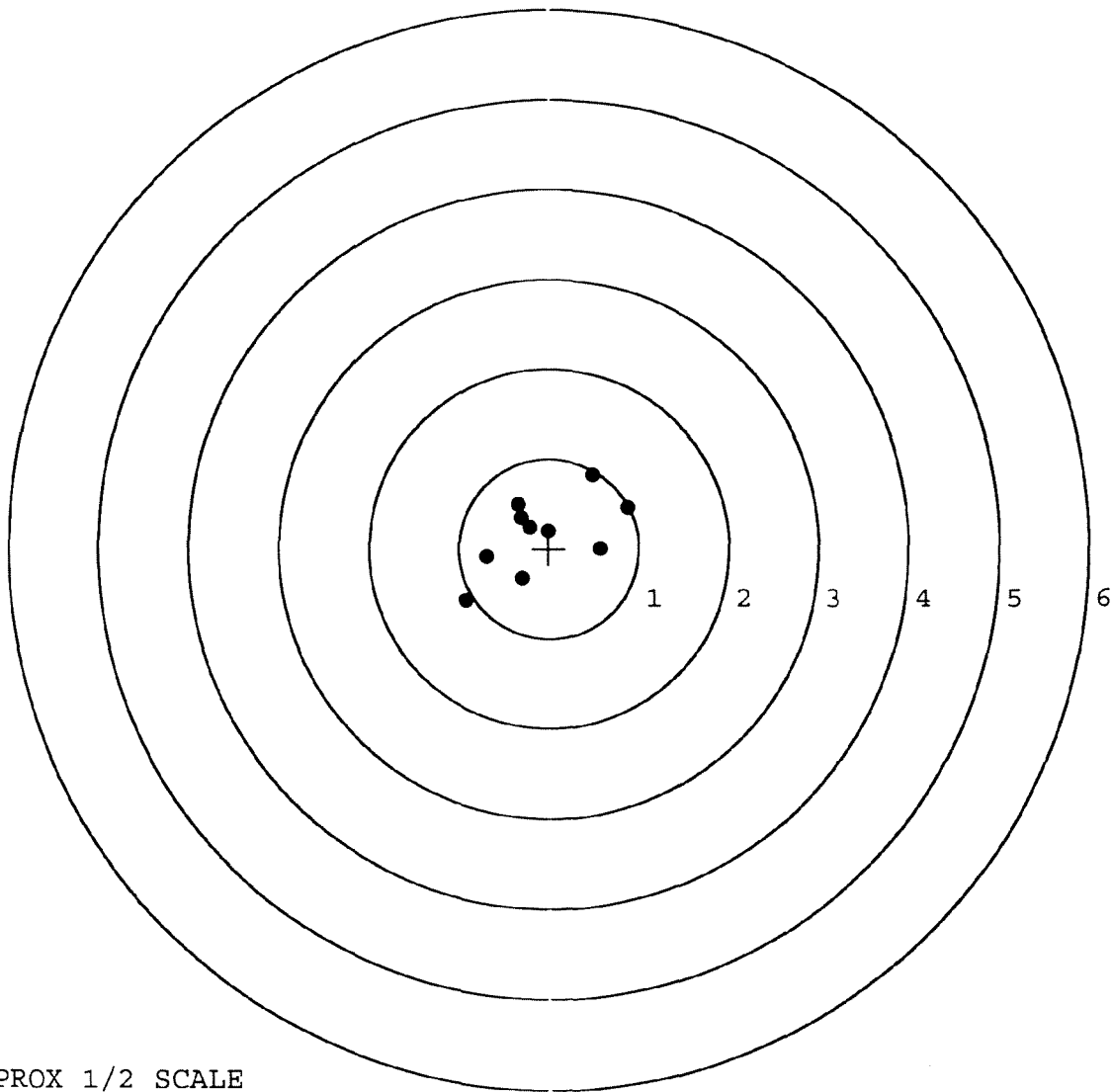
MEAN RADIUS: 0.582

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.922	-0.575
2:	-0.692	-0.089
3:	-0.296	-0.336
4:	-0.007	0.198
5:	-0.214	0.234
6:	-0.308	0.344
7:	-0.346	0.487
8:	0.578	0.001
9:	0.874	0.455
10:	0.488	0.821

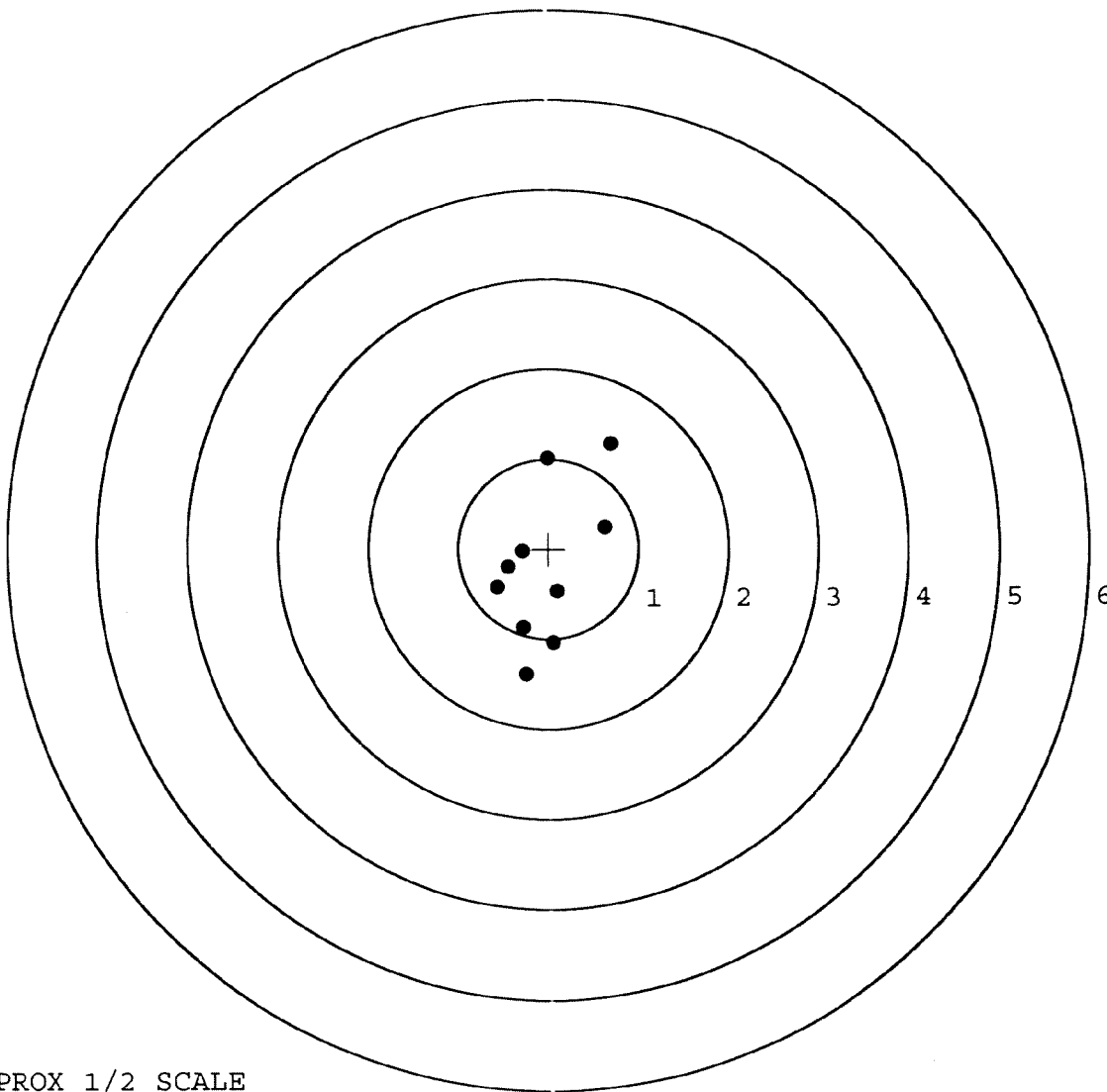


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. __0
 TARGET NUMBER: 4
 FILE DATE: 09/03/2008
 FILE TIME: 10:38

POINT#	X	Y
1:	-0.255	-1.405
2:	0.050	-1.047
3:	-0.281	-0.883
4:	-0.570	-0.431
5:	-0.447	-0.204
6:	-0.292	-0.032
7:	0.630	0.237
8:	0.695	1.166
9:	-0.013	1.011
10:	0.099	-0.476

X CENTROID: -0.038
 Y CENTROID: -0.206
 POA TO CENTROID: 0.210
 HORZ SPREAD: 1.265
 VERT SPREAD: 2.571
 GROUP SPREAD: 2.741
 MIN RADIUS: 0.303
 MAX RADIUS: 1.556
 MEAN RADIUS: 0.795
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. 0

TARGET NUMBER: 5

FILE DATE: 09/03/2008

FILE TIME: 10:38

X CENTROID: 0.134

Y CENTROID: -0.195

POA TO CENTROID: 0.236

HORZ SPREAD: 1.154

VERT SPREAD: 1.162

GROUP SPREAD: 1.343

MIN RADIUS: 0.305

MAX RADIUS: 0.723

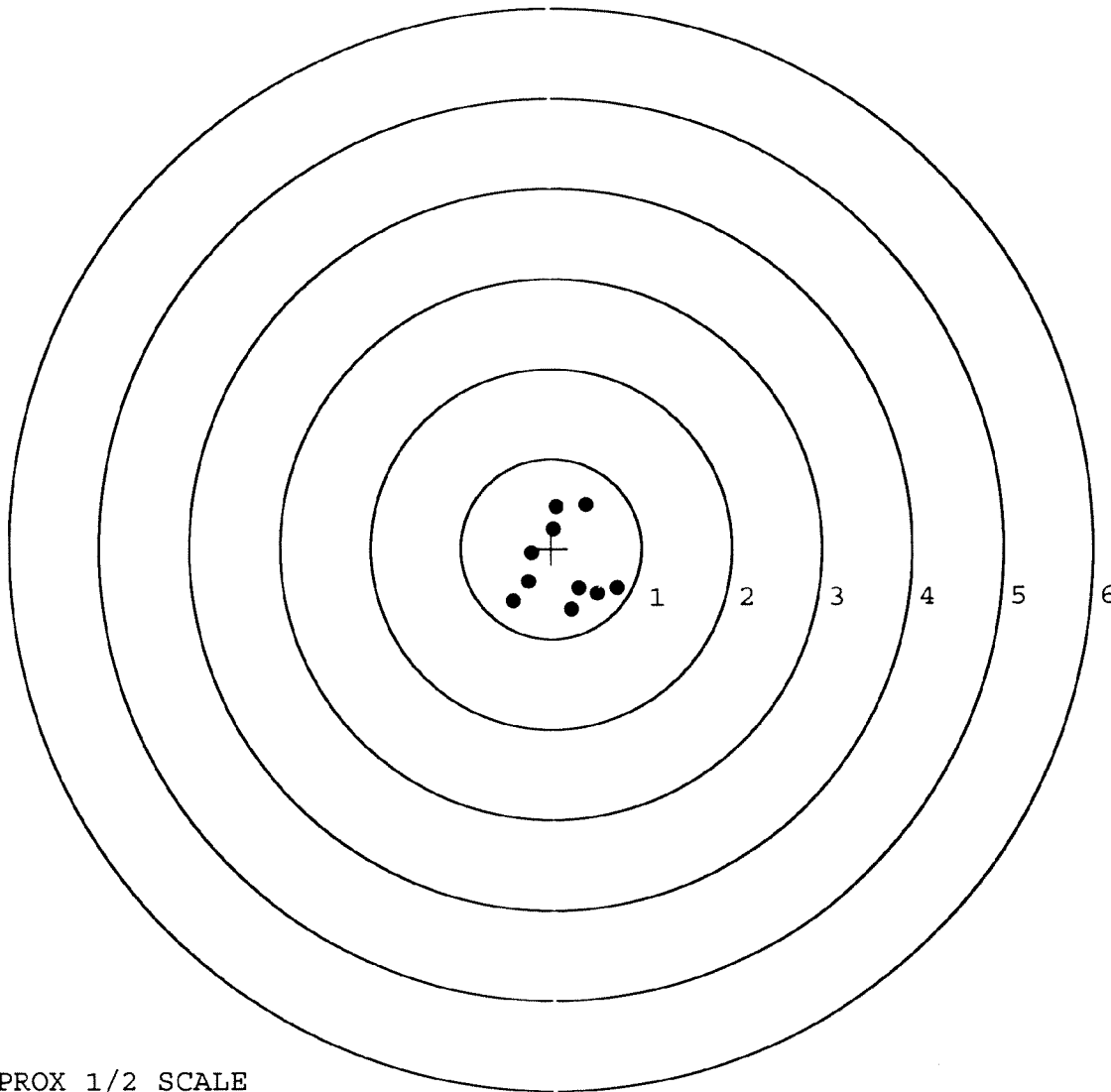
MEAN RADIUS: 0.524

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.223	-0.681
2:	0.305	-0.447
3:	0.511	-0.513
4:	0.730	-0.449
5:	-0.424	-0.588
6:	-0.256	-0.376
7:	-0.222	-0.056
8:	0.022	0.219
9:	0.389	0.481
10:	0.059	0.460

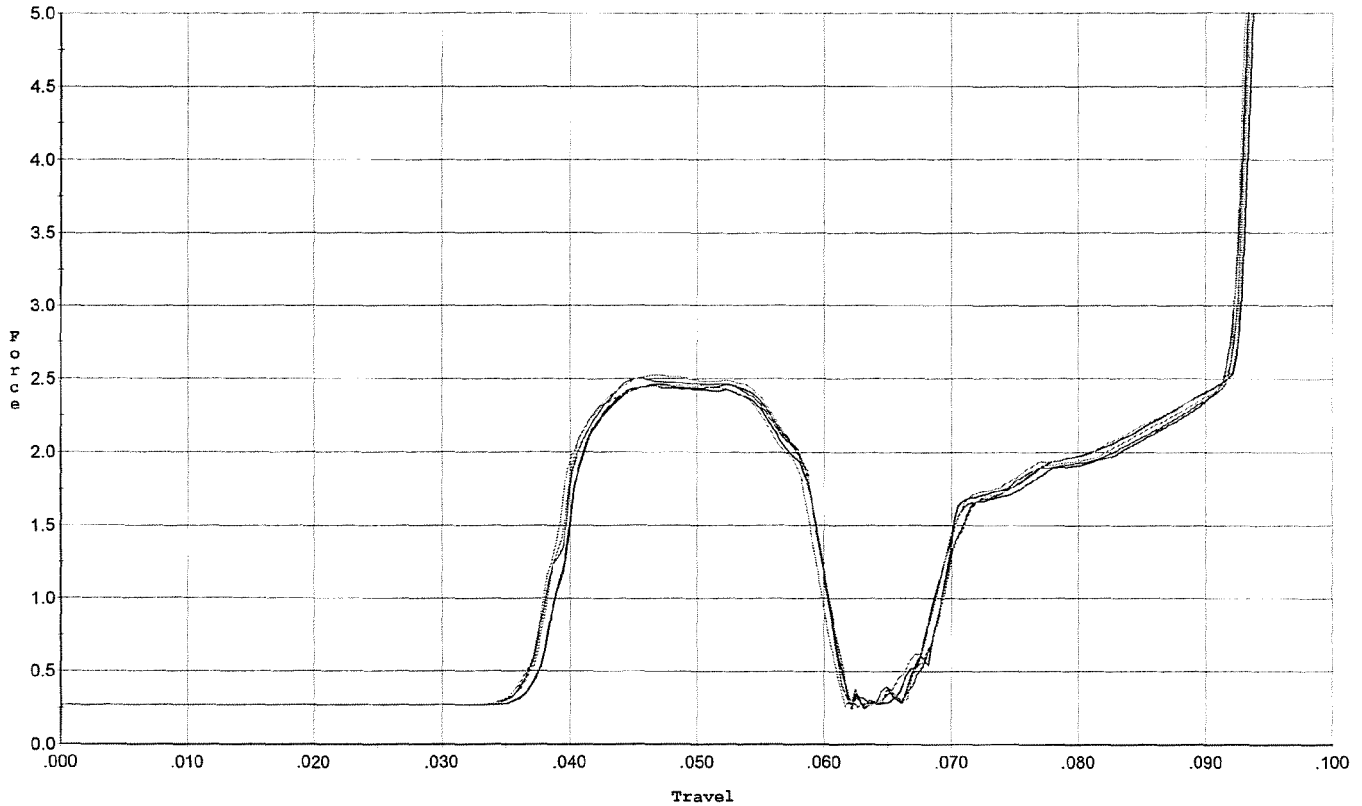


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



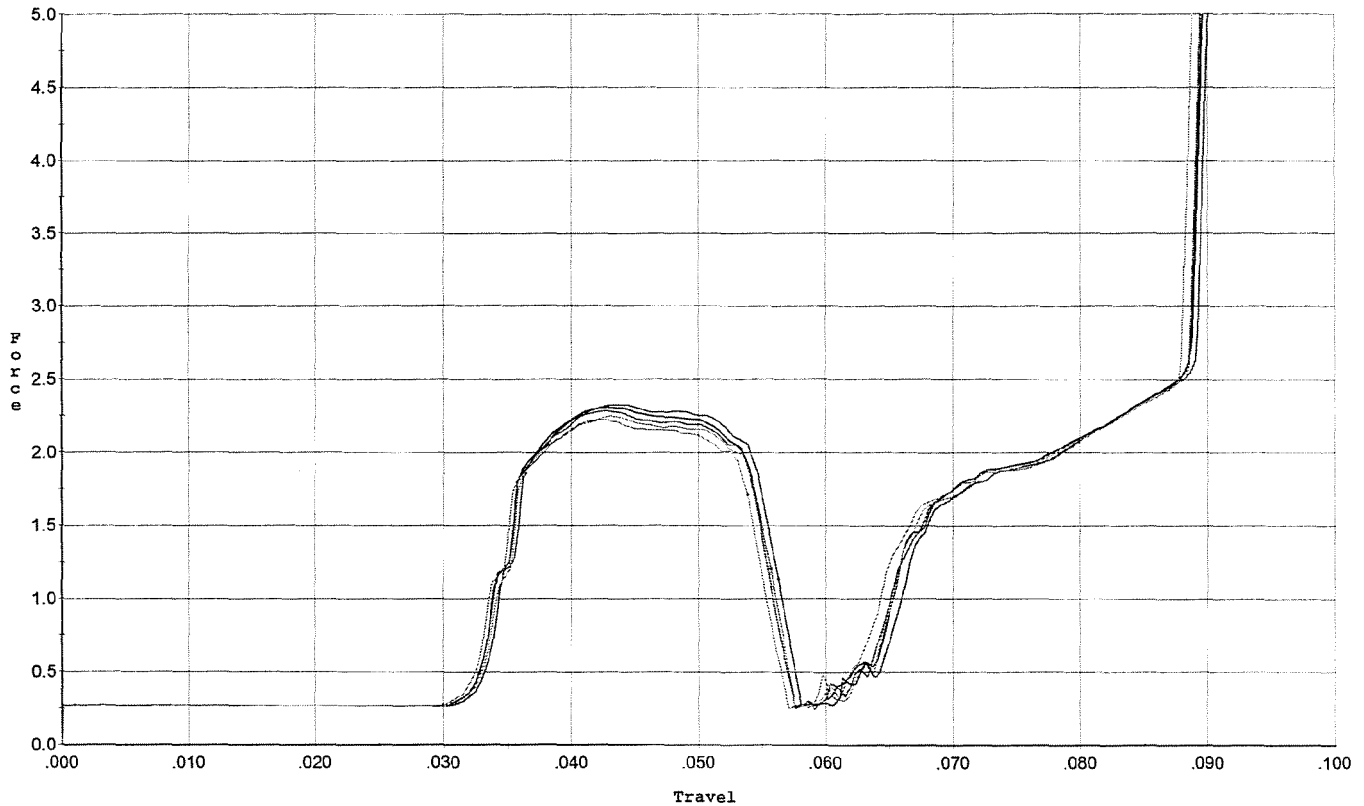
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.059	0.037	0.040	0.056		Set Trigger
2	2.460	0.059	0.037	0.040	0.056		Set Trigger
3	2.501	0.059	0.036	0.039	0.058		Set Trigger
4	2.526	0.059	0.036	0.040	0.058		Set Trigger
5	2.454	0.058	0.036	0.039	0.057		Set Trigger

Aug. 2.48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 08/04/2008

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



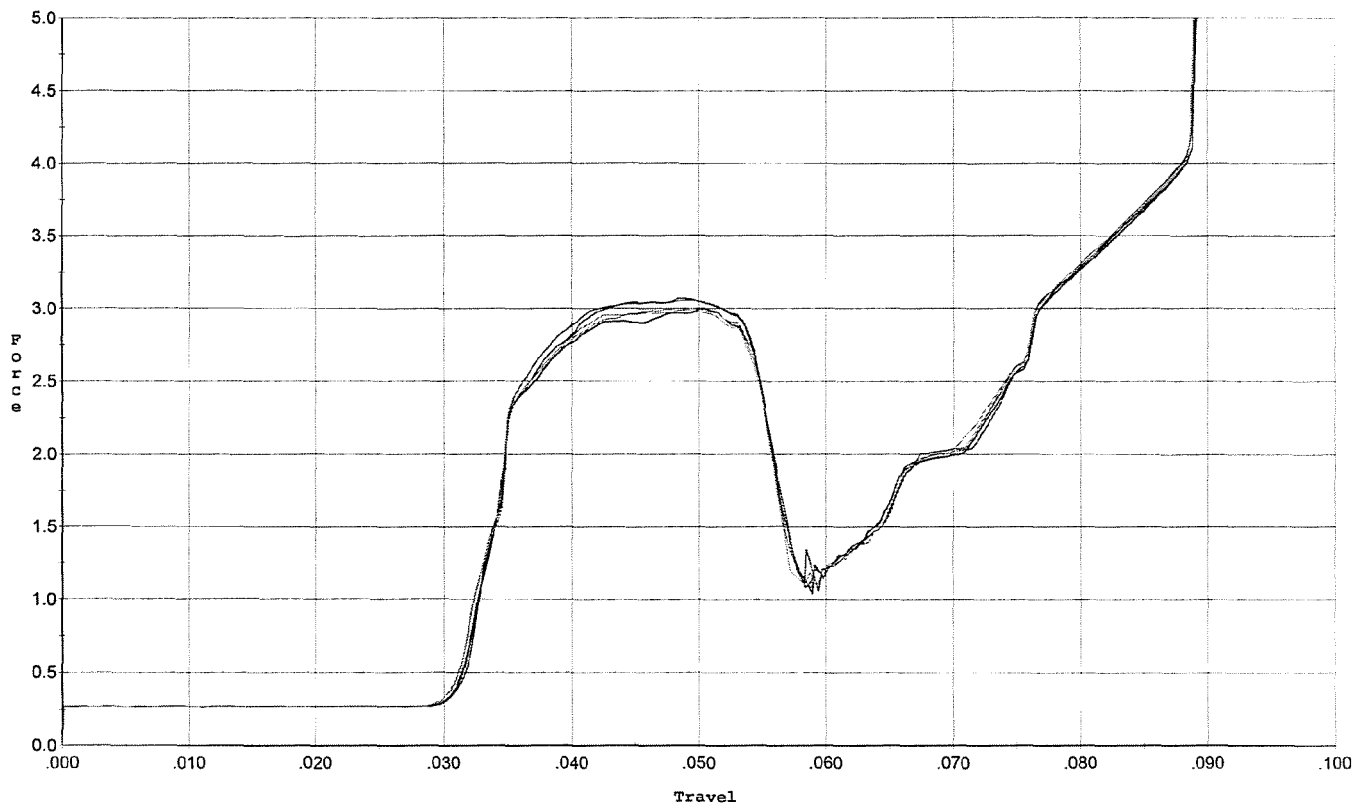
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.327	0.056	0.033	0.039	0.055		Set Trigger
2	2.312	0.056	0.032	0.039	0.054		Set Trigger
3	2.284	0.054	0.032	0.039	0.052		Set Trigger
4	2.250	0.056	0.033	0.039	0.053		Set Trigger
5	2.224	0.054	0.032	0.039	0.051		Set Trigger

Aug - 2.27

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 08/04/2008

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



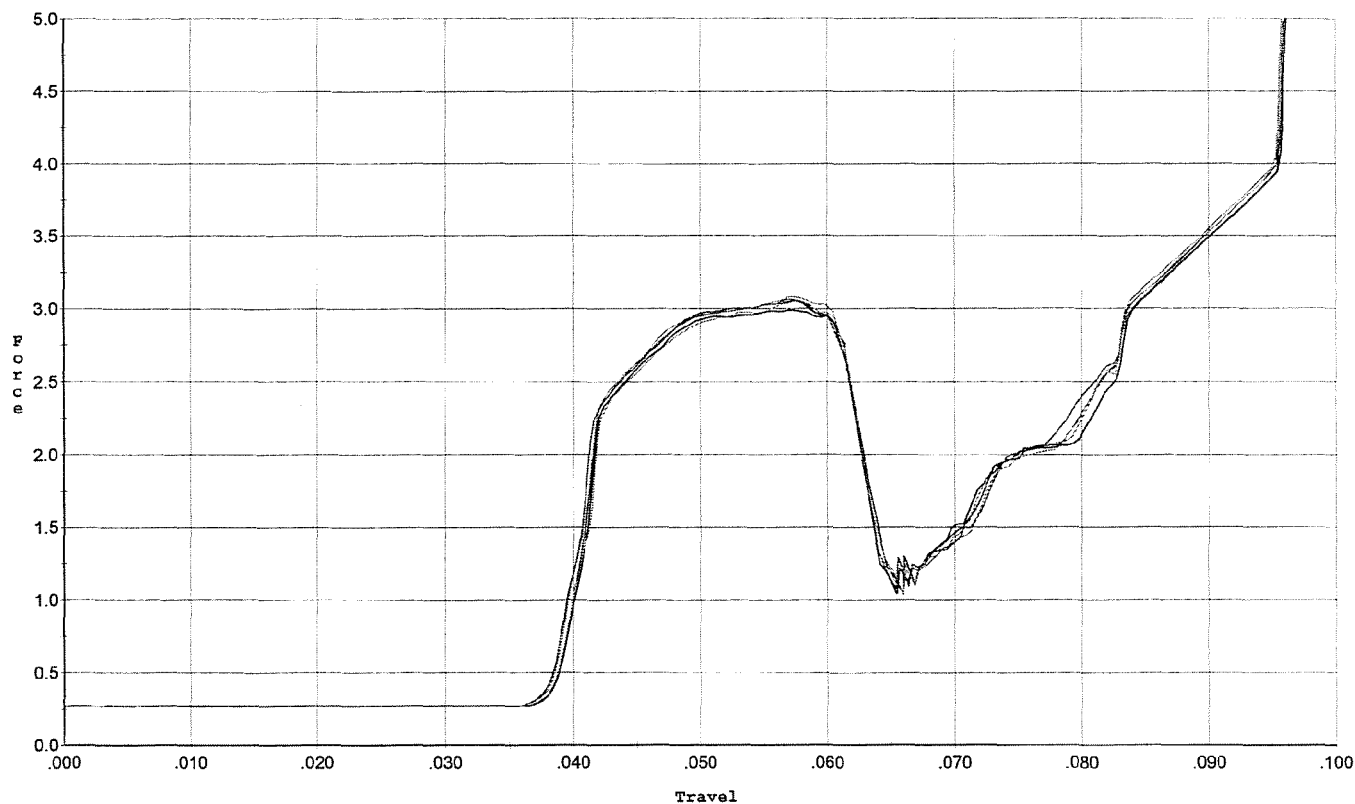
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.071	0.054	0.031	0.037	0.070		Set Trigger
2	2.997	0.055	0.031	0.037	0.069		Set Trigger
3	3.058	0.054	0.031	0.037	0.070		Set Trigger
4	2.985	0.055	0.031	0.036	0.070		Set Trigger
5	2.998	0.055	0.031	0.036	0.069		Set Trigger

Avg. 3.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 08/04/2008

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



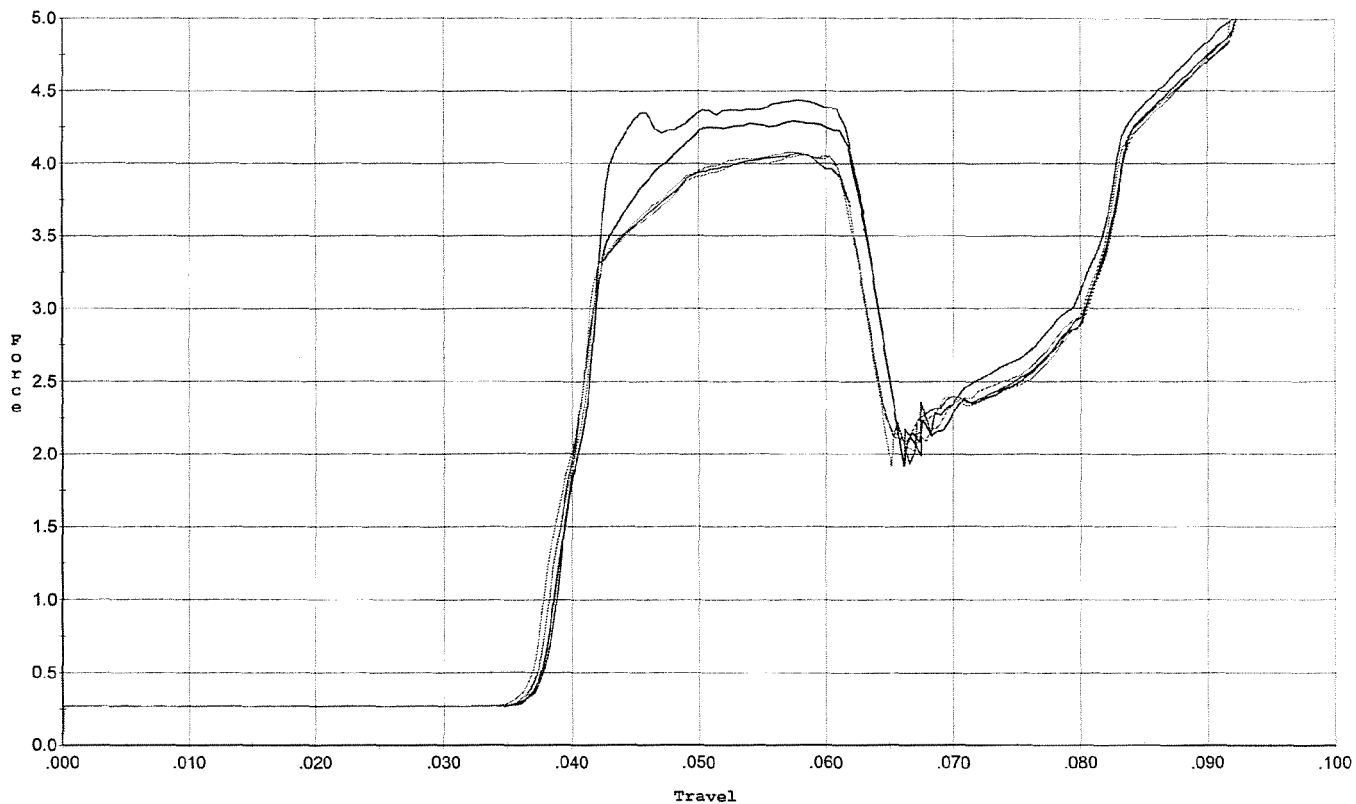
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.061	0.038	0.039	0.071		Set Trigger
2	2.990	0.062	0.038	0.039	0.071		Set Trigger
3	3.064	0.061	0.038	0.039	0.072		Set Trigger
4	3.054	0.061	0.039	0.039	0.071		Set Trigger
5	3.082	0.061	0.038	0.039	0.072		Set Trigger

Aug. 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



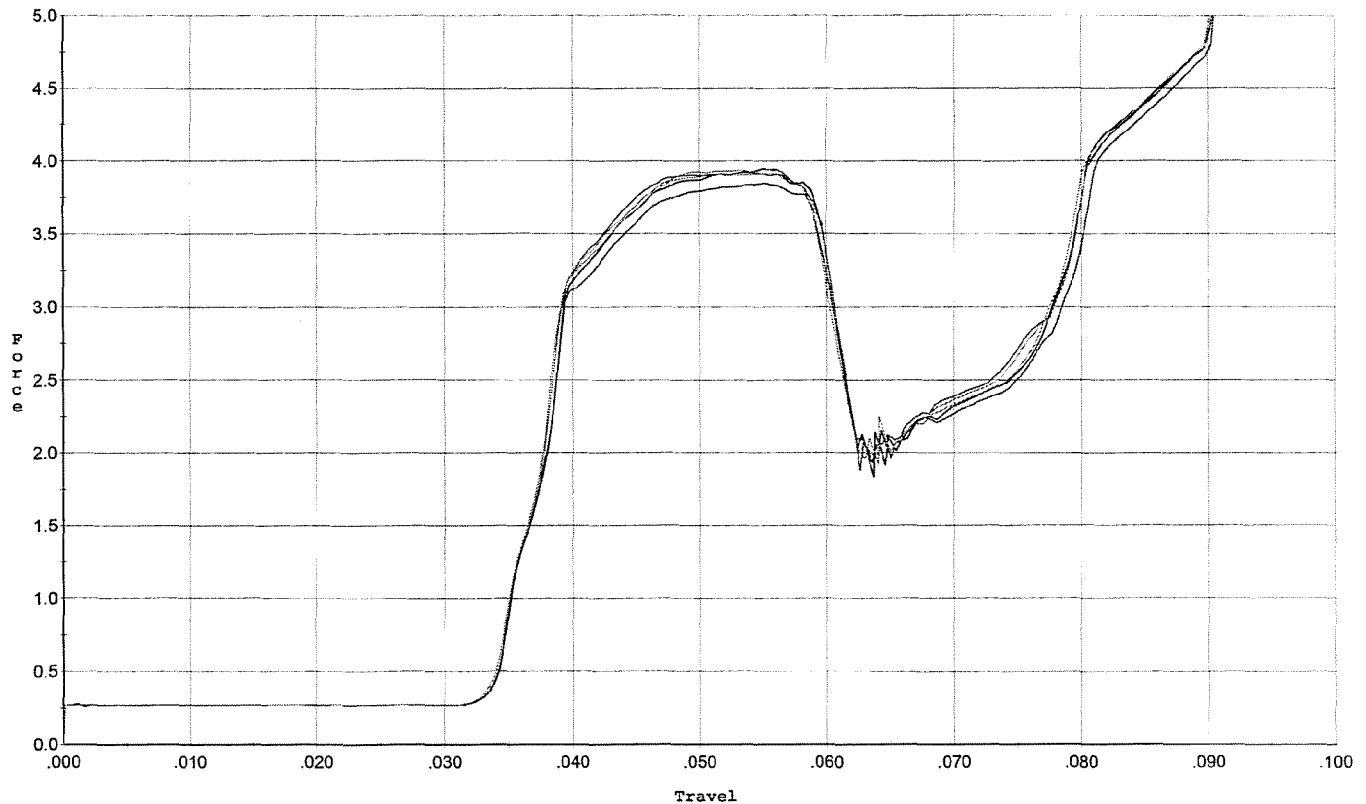
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.438	0.063	0.037	0.034	0.109		Set Trigger
2	4.291	0.063	0.037	0.034	0.105		Set Trigger
3	4.066	0.062	0.037	0.035	0.098		Set Trigger
4	4.056	0.062	0.037	0.035	0.097		Set Trigger
5	4.077	0.062	0.036	0.035	0.099		Set Trigger

Aug - 4-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



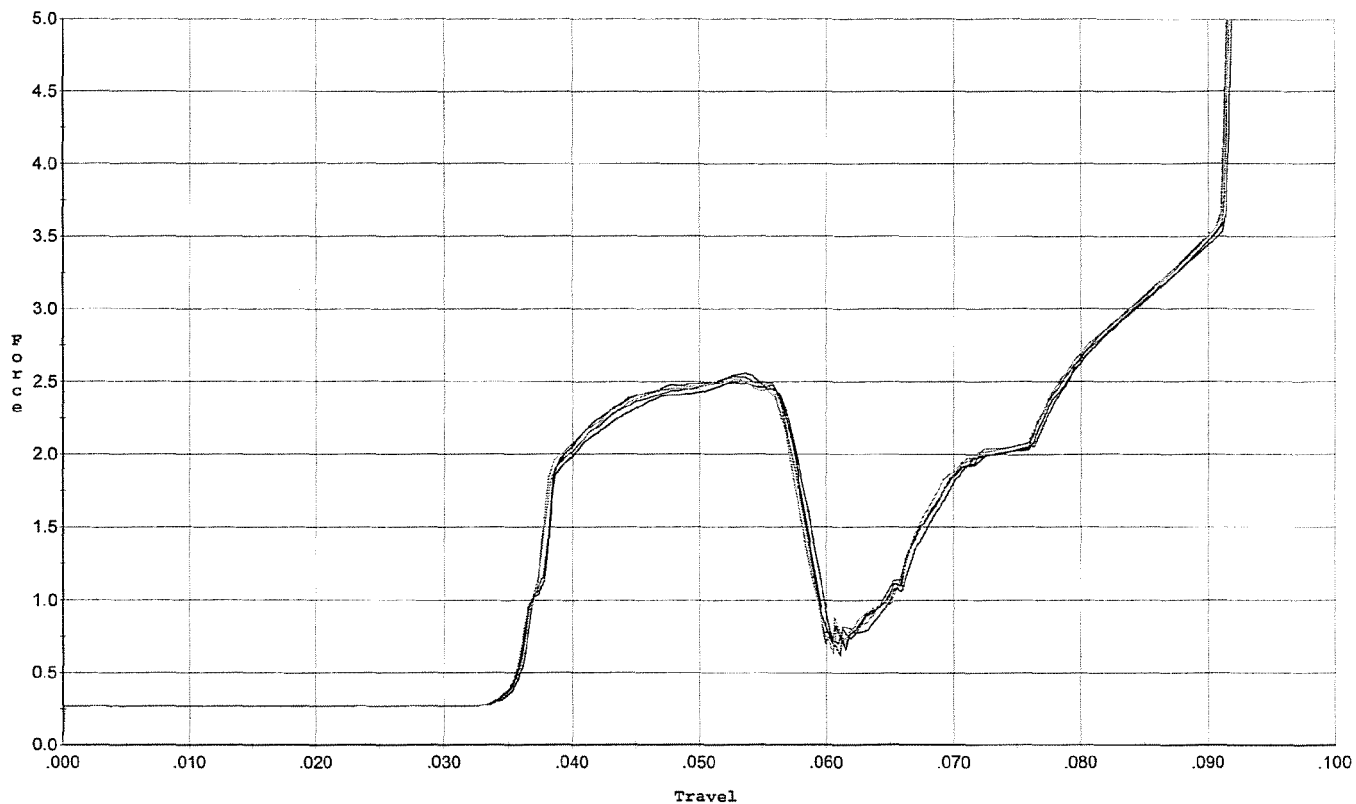
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.845	0.060	0.034	0.035	0.094		Set Trigger
2	3.920	0.060	0.034	0.035	0.095		Set Trigger
3	3.942	0.060	0.034	0.035	0.096		Set Trigger
4	3.912	0.059	0.034	0.035	0.094		Set Trigger
5	3.949	0.059	0.034	0.035	0.094		Set Trigger

Aug - 3.91

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 08/04/2008

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



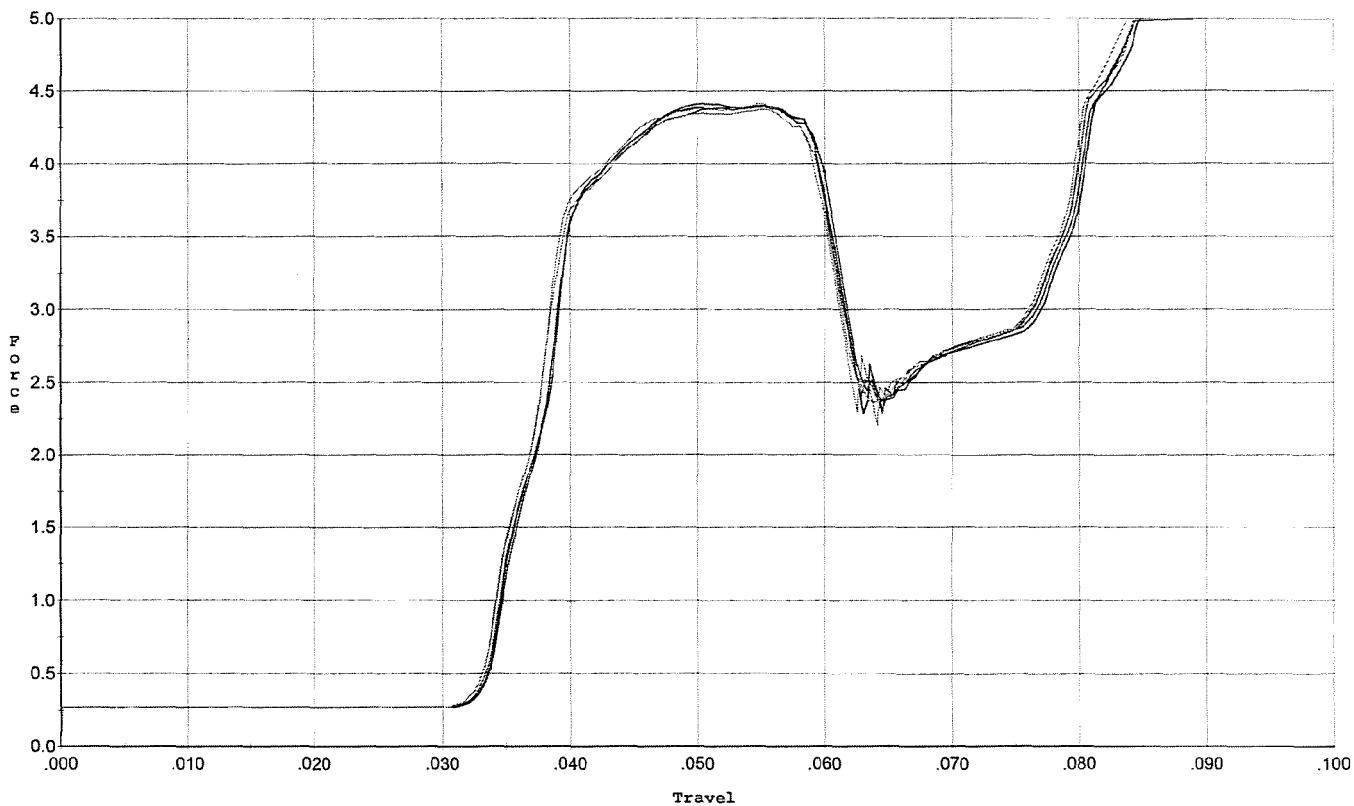
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.059	0.036	0.038	0.059		Set Trigger
2	2.496	0.057	0.036	0.038	0.057		Set Trigger
3	2.535	0.058	0.036	0.038	0.058		Set Trigger
4	2.512	0.057	0.036	0.039	0.056		Set Trigger
5	2.521	0.057	0.035	0.039	0.057		Set Trigger

Aug. 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. ini. +/- 1.0 lbs. for target&accur



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.394	0.060	0.033	0.031	0.108		Set Trigger
2	4.413	0.061	0.033	0.031	0.109		Set Trigger
3	4.393	0.059	0.033	0.031	0.106		Set Trigger
4	4.369	0.060	0.033	0.031	0.108		Set Trigger
5	4.413	0.059	0.033	0.031	0.108		Set Trigger

Avg. 4.39