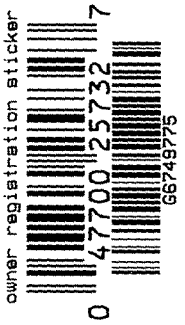
6674 9775

# M/24 7.62 NATO (RIFLE ONLY)

**BOLT ACTION CENTERFIRE RIFLE**
**24" BARREL 7.62 NATO**

– INSTUCTION BOOK 3518

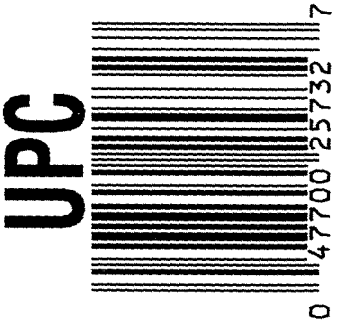
**BM FORM 200348**


**ORDER NO. 25732**

| | |
|---|---|
| BARREL LENGTH | 24" |
| CAPACITY | 5 |

**G6749775**



# INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6749775

| OP # | OPERATION NAME | READINGS | DATE | INITIAL |
|---|---|---|---|---|
| 420 | ASSEMBLE ACTION | | 6/11/08 | S.P.D. |
| 430 | ASSEMBLE TO STOCK | | 6/11/08 | SP |
| 440 | PROOF | | 6-11-08 | SD |
| 460 | CHECK HEADSPACE | | 6-11-08 | SD |
| 470 | DIS-ASSEMBLE ACTION | MAGNA FLUX JUN 13 2008 OPERATOR | 6/11/08 | S.P.D. |
| 472 | SERIALIZE BOLT HANDLE | | 6/12/08 | S.P.D. |
| 475 | DRILL AND TAP SIGHT HOLES | | 6-13-08 | TRW |
| 480 | MAGNAFLUX BBL ACTION | | 6/16/08 | |
| 490 | MAGNAFLUX BOLT | | | |
| 500 | ROLLMARK CALIBER | | 6/16/08 | RT |
| 520 | GOFF BLAST BBL / REC | | 6/17/08 | |
| 542 | APPLY COATINGS (BARREL ACTION) | | 6/18/08 | CM |
| 545 | (BOLT) | | | |
| 560 | RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY | | 6/18/08 | RP |
| | B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD | | 6/18/08 | RP |
| | C) INSPECT EJECTOR HOLE FOR CHAMFER | | 6/18/08 | RP |
| | D) OIL FIRING PIN ASSEMBLY | | 6/19/08 | |
| | E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS | | | |

F004 REV 5/2006

| | | | | | | |
|---|---|---|---|---|---|---|
| 560 | F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX] | 7.50 | 7.50 | 7.50 | 6.26.08 | RTR |
| CONT. | G) SAFETY OFF FORCE [2 LBS MIN] | 5# | 5# | 5# | 6-26-08 | RTR |
| | H) TRIGGER PULL TEST AND RETAINABILITY | | | | | |
| | I) FIRING PIN INDENT [.020 MIN] | .022 | .022 | .022 | 6.20.08 | RTR |
| | J) ASSEMBLE STOCK | | | | 6-19-08 | RTR |
| | K) ASSEMBLE SWIVEL STUDS | | | | 6-27-08 | RSN |
| | L) ATTACH FRONT AND REAR SIGHT ASSY'S | | | | | |
| | M) IRON SIGHT ALIGNMENT | | | | | |
| | N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER | | | | | |
| 640 & | FUNCTION TEST AND | ~~PASS~~ | FAIL | | | |
| 650 | TARGET | PASS | FAIL | | 6-30-08 | SD |
| | MALFUNCTION | CORRECTION | | | | |
| | MALFUNCTION | CORRECTION | NA | | | |
| | MALFUNCTION | CORRECTION | | | | |
| | MALFUNCTION | CORRECTION | | | | |
| 660 | INSPECT FOR LIVE AMMO | | | | 6-30-08 | SP |
| 670 | FINAL INSPECTION A) HEADSPACE | | | | 6-27-08 | RSN |
| | B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS] | 2.39 | 2.44 | 2.44 | 6.26.08 | RTR |
| | C) FUNCTION | | | | | |
| 690 | PACK | | | | 6/30/08 | RP |

Original 4 Crib

# 25732

M/24 7.62 NATO (RIFLE ONLY)

.MA25732

Shop Order: SW5732X

.ABSW5732X

Start Date: 6/4/2008
Finish Date: 6/26/2008

0520 78ROT01
Goff Blast Barrel & Rec Assembly.

0006554655

0547 01PC001
Gray Sandstrom Coat Bolt Assemblies

0006554673

0610 89SWS1
Assemble Action to Stock.

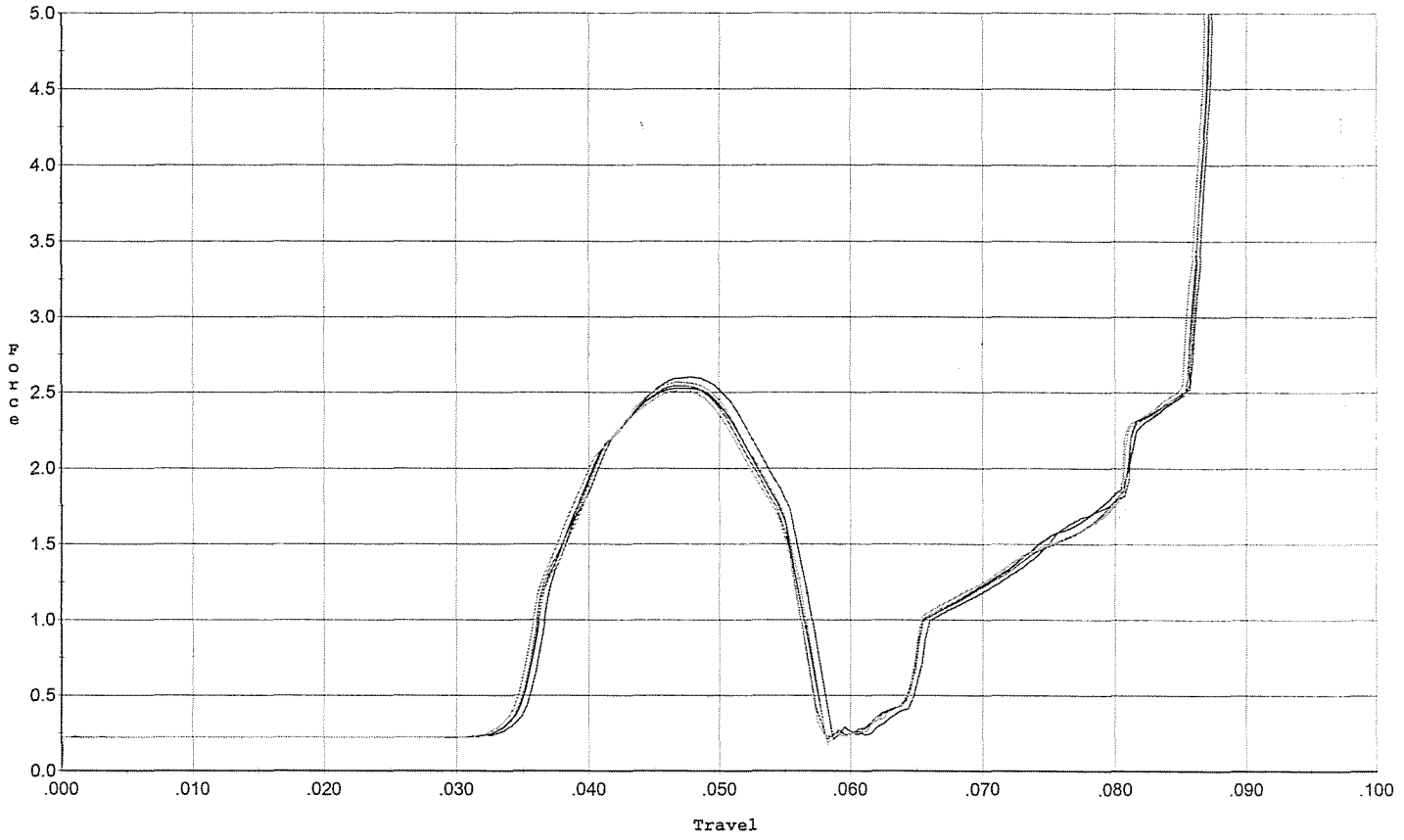
0006554662

0690 89SWS1
Pack Rifle & Stencil SWS Container

.OP0690

# Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 2.5 lbs. ini. +/- .50 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



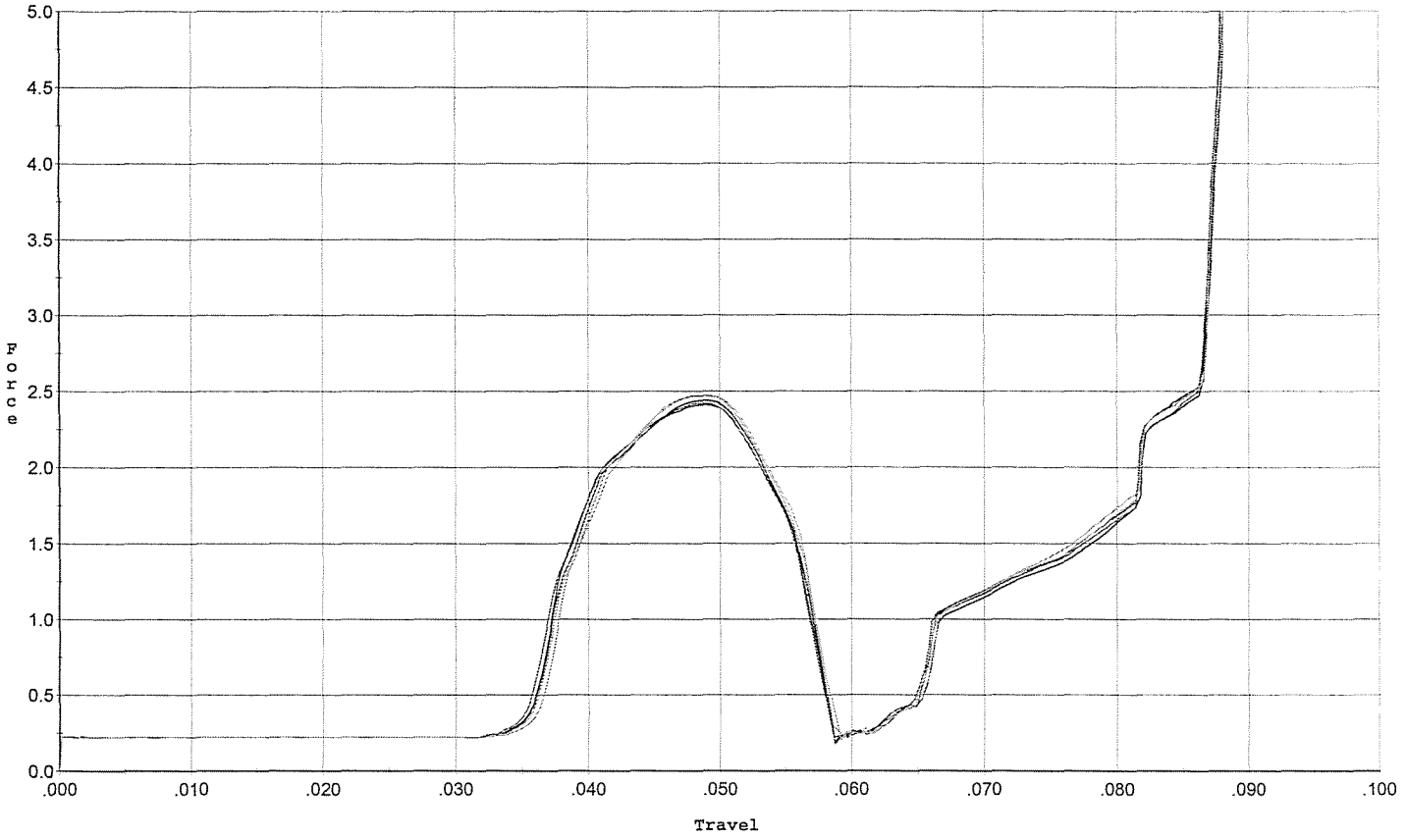

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.598 | 0.057 | 0.035 | 0.037 | 0.051 | | Set Trigger |
| 2 | 2.528 | 0.057 | 0.035 | 0.037 | 0.050 | | Set Trigger |
| 3 | 2.544 | 0.055 | 0.035 | 0.037 | 0.049 | | Set Trigger |
| 4 | 2.567 | 0.056 | 0.035 | 0.037 | 0.050 | | Set Trigger |
| 5 | 2.512 | 0.055 | 0.034 | 0.037 | 0.049 | | Set Trigger |

Avg 2.55

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:43:46 PM

## Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 2.5 lbs. after 50 cycles +/- .50 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



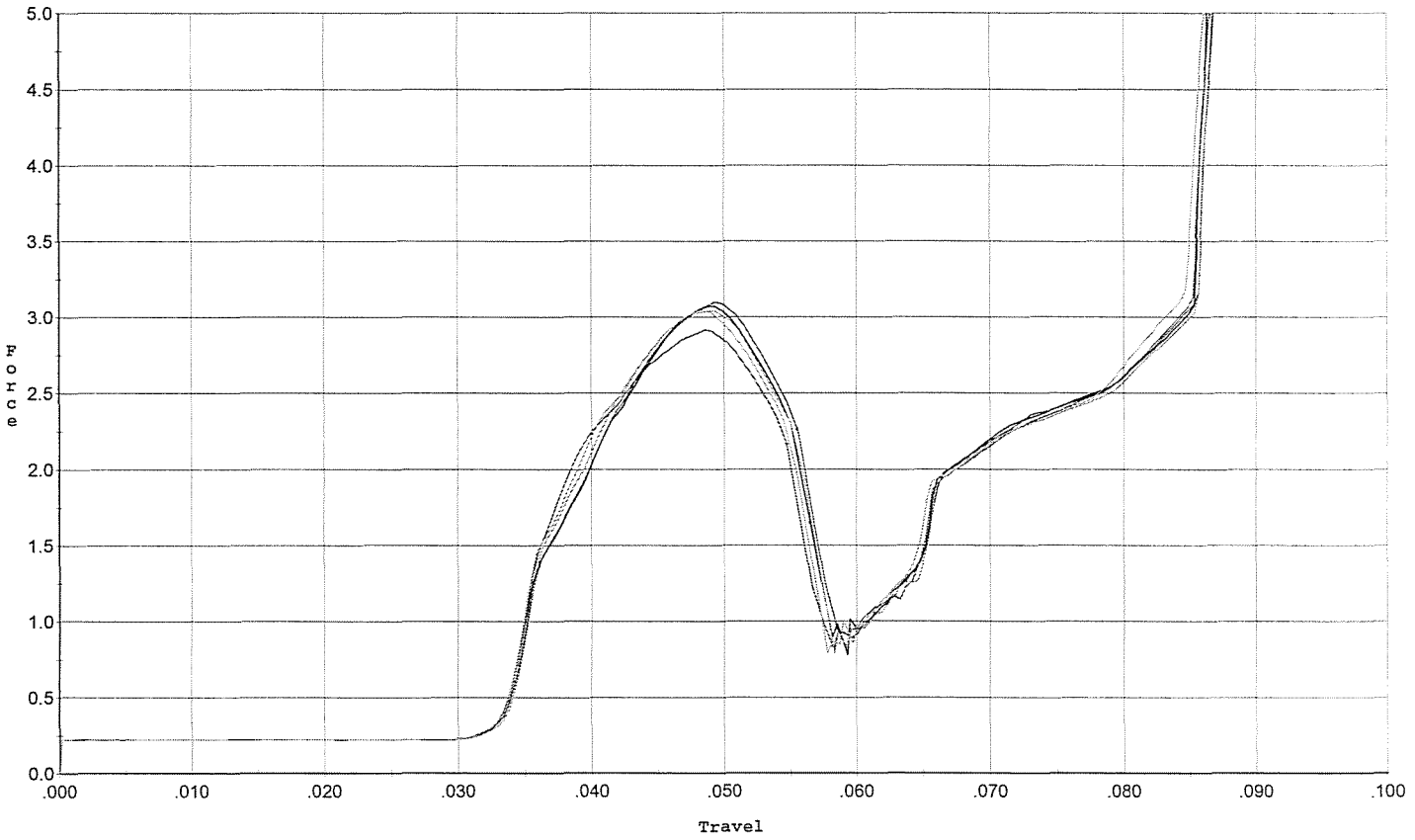

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.411 | 0.057 | 0.036 | 0.037 | 0.048 | | Set Trigger |
| 2 | 2.439 | 0.057 | 0.036 | 0.037 | 0.049 | | Set Trigger |
| 3 | 2.420 | 0.056 | 0.035 | 0.038 | 0.048 | | Set Trigger |
| 4 | 2.469 | 0.056 | 0.036 | 0.037 | 0.048 | | Set Trigger |
| 5 | 2.472 | 0.056 | 0.036 | 0.038 | 0.048 | | Set Trigger |

Avg 2.44

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:46:22 PM

## Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 3.0 lbs. ini. +/- .75 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



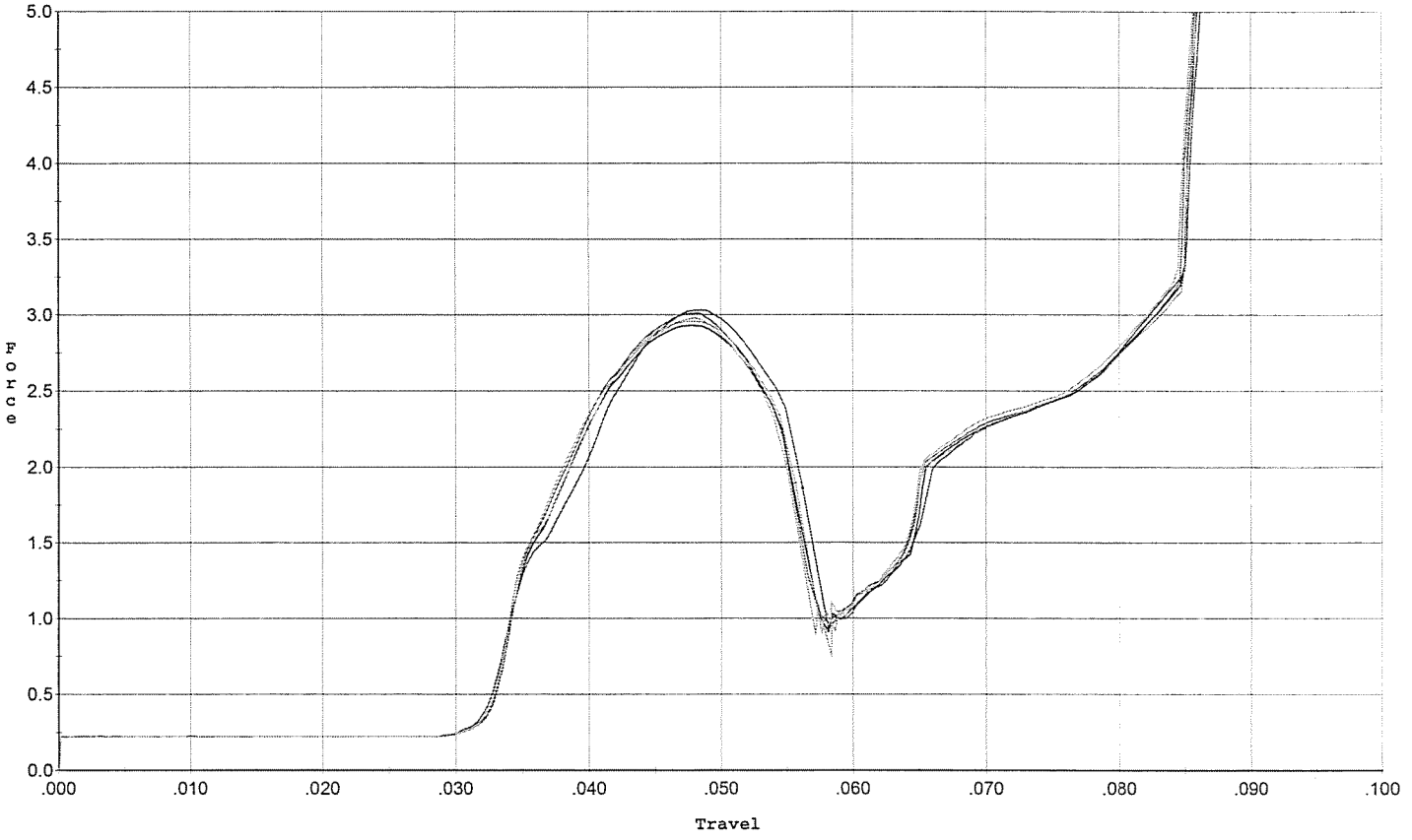

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 3.095 | 0.056 | 0.034 | 0.036 | 0.060 | | Set Trigger |
| 2 | 3.068 | 0.056 | 0.033 | 0.035 | 0.060 | | Set Trigger |
| 3 | 2.916 | 0.055 | 0.034 | 0.036 | 0.057 | | Set Trigger |
| 4 | 3.042 | 0.055 | 0.033 | 0.035 | 0.059 | | Set Trigger |
| 5 | 3.040 | 0.056 | 0.034 | 0.036 | 0.060 | | Set Trigger |

Avg 3.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:48:16 PM

# Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 3.0 lbs. after 20 cycles +/- .75 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



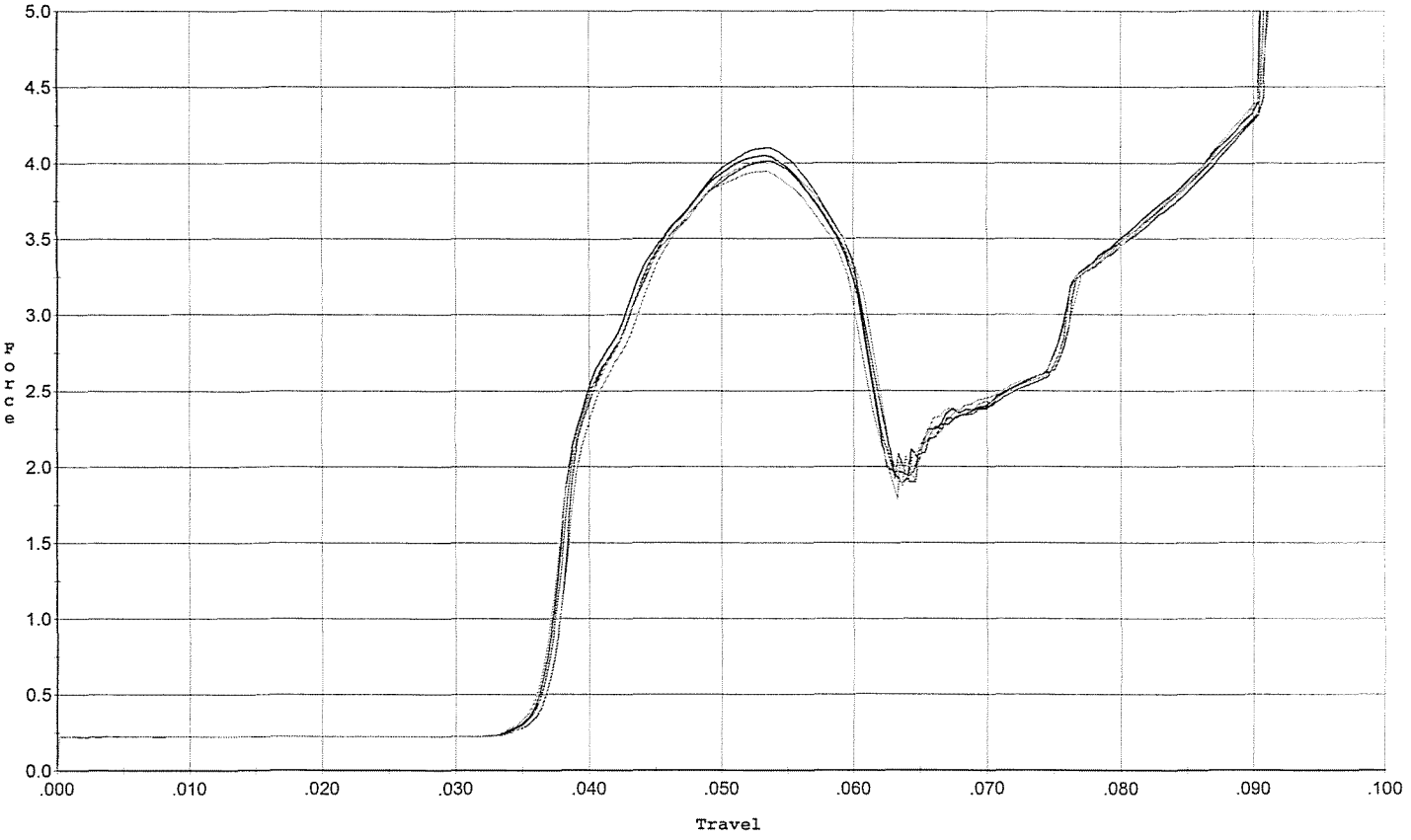

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 3.028 | 0.056 | 0.032 | 0.035 | 0.062 | | Set Trigger |
| 2 | 2.930 | 0.055 | 0.033 | 0.035 | 0.059 | | Set Trigger |
| 3 | 3.012 | 0.055 | 0.032 | 0.035 | 0.060 | | Set Trigger |
| 4 | 2.980 | 0.055 | 0.032 | 0.035 | 0.060 | | Set Trigger |
| 5 | 2.958 | 0.056 | 0.033 | 0.035 | 0.061 | | Set Trigger |

Avg 2.98

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:49:58 PM

# Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 4.0 lbs. ini. +/- 1.0 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



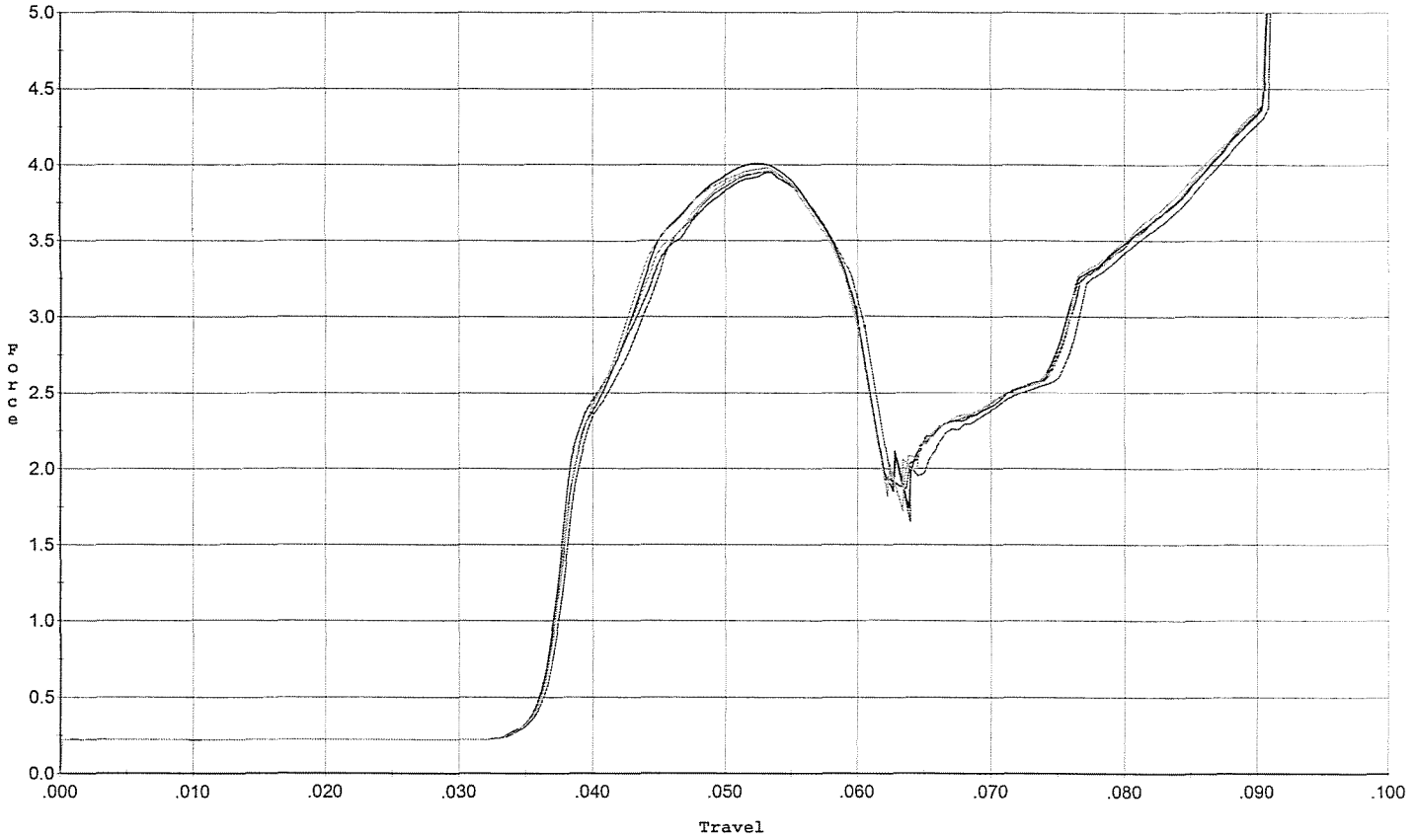

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 4.097 | 0.060 | 0.036 | 0.035 | 0.087 | | Set Trigger |
| 2 | 4.050 | 0.060 | 0.036 | 0.035 | 0.088 | | Set Trigger |
| 3 | 4.011 | 0.060 | 0.036 | 0.035 | 0.087 | | Set Trigger |
| 4 | 3.947 | 0.060 | 0.036 | 0.035 | 0.085 | | Set Trigger |
| 5 | 4.015 | 0.061 | 0.036 | 0.035 | 0.088 | | Set Trigger |

Avg 4.02

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:51:33 PM

## Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | 4.0 lbs. after 20 cycles +/- 1.0 lbs. |
| **Note:** | R. Putch 6/11/08 | | |



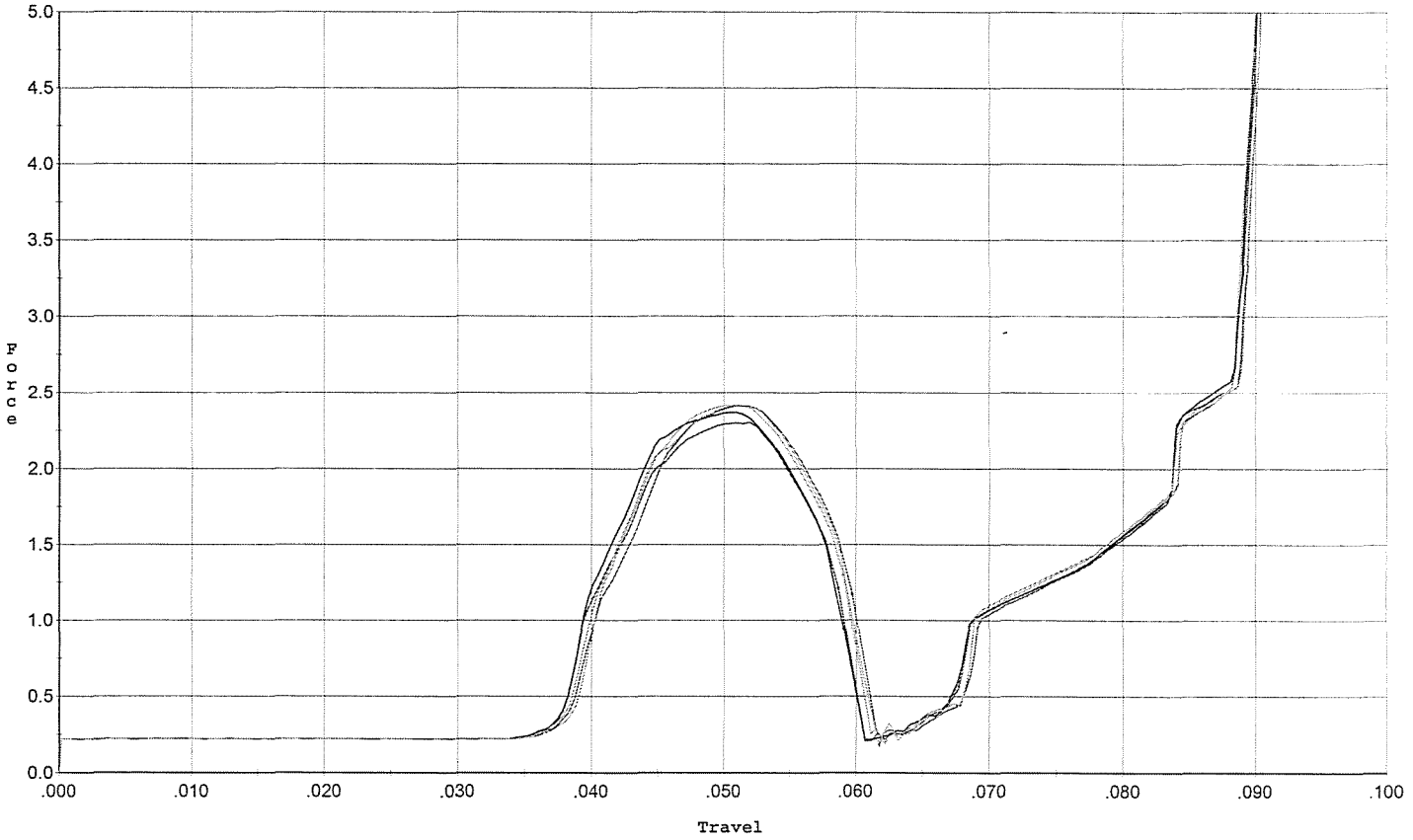

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 3.950 | 0.060 | 0.036 | 0.035 | 0.085 | | Set Trigger |
| 2 | 4.010 | 0.060 | 0.036 | 0.035 | 0.086 | | Set Trigger |
| 3 | 3.955 | 0.061 | 0.036 | 0.035 | 0.086 | | Set Trigger |
| 4 | 3.969 | 0.060 | 0.036 | 0.035 | 0.086 | | Set Trigger |
| 5 | 3.981 | 0.060 | 0.036 | 0.035 | 0.086 | | Set Trigger |

Avg 3.97

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:52:58 PM

# Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | reset to 2.5 lbs. +/- .50 lbs. for final test |
| **Note:** | R. Putch 6/11/08 | | |



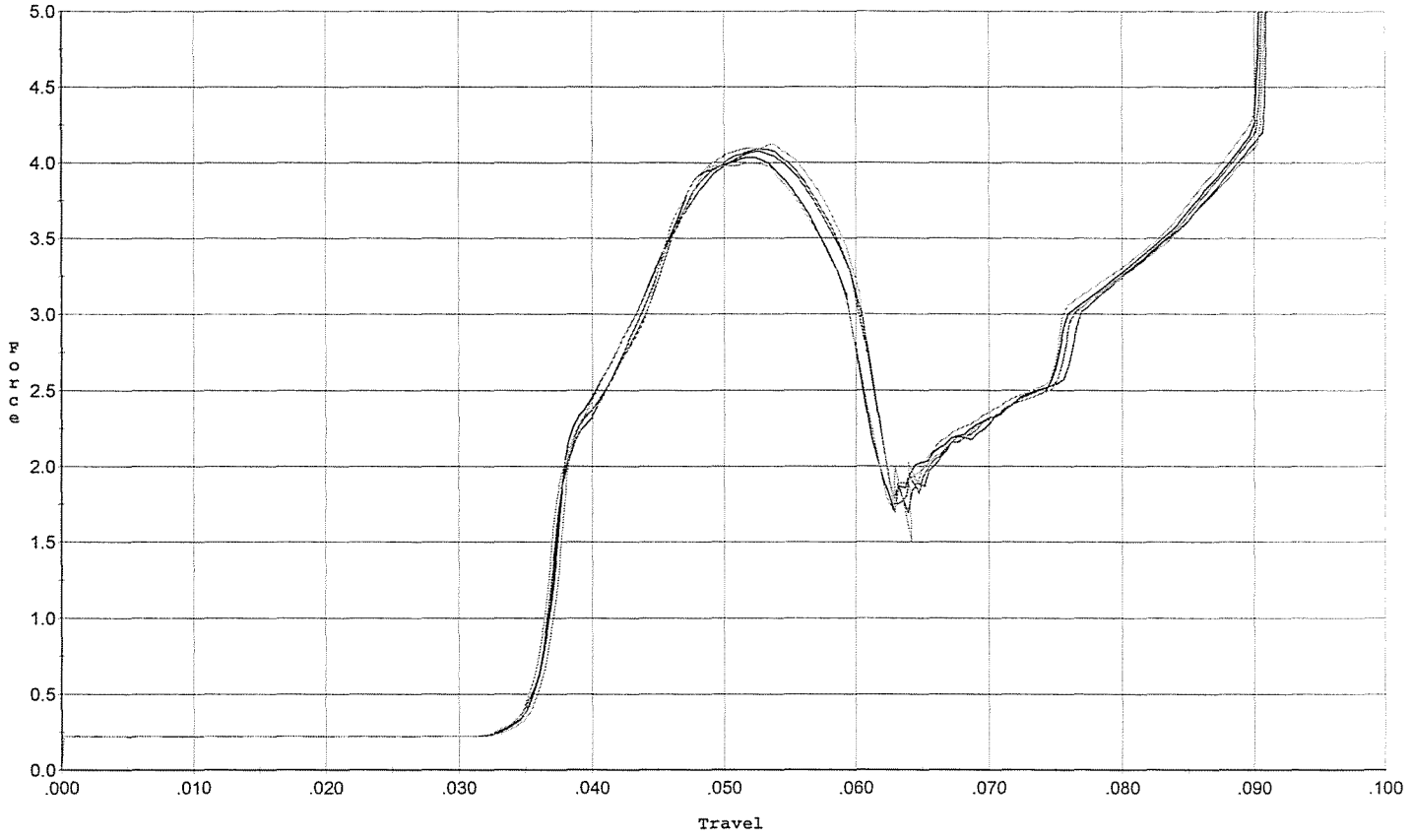

| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 2.304 | 0.059 | 0.038 | 0.038 | 0.046 | | Set Trigger |
| 2 | 2.369 | 0.059 | 0.038 | 0.038 | 0.048 | | Set Trigger |
| 3 | 2.413 | 0.060 | 0.039 | 0.038 | 0.048 | | Set Trigger |
| 4 | 2.418 | 0.059 | 0.038 | 0.038 | 0.048 | | Set Trigger |
| 5 | 2.410 | 0.059 | 0.039 | 0.038 | 0.048 | | Set Trigger |

Avg 2.38

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:54:49 PM

## Trigger Profile [ lbs,inch ]

| | | | |
|---|---|---|---|
| **Profile** | SWS | **Model:** | M/24 |
| **GunType:** | Rifle | **Serial No:** | Form #F005 |
| **Make:** | Remington | **Trigger:** | set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy |
| **Note:** | R. Putch 6/11/08 | | |




| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|---|---|---|---|---|---|---|
| 1 | 4.074 | 0.060 | 0.035 | 0.035 | 0.088 | | Set Trigger |
| 2 | 4.036 | 0.059 | 0.035 | 0.035 | 0.085 | | Set Trigger |
| 3 | 4.090 | 0.061 | 0.035 | 0.034 | 0.089 | | Set Trigger |
| 4 | 4.127 | 0.060 | 0.035 | 0.034 | 0.090 | | Set Trigger |
| 5 | 3.999 | 0.059 | 0.035 | 0.036 | 0.084 | | Set Trigger |

Avg 4.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 6/11/2008 11:56:32 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6749775.__0
FILE DATE AND TIME: 06/23/2008 05:46

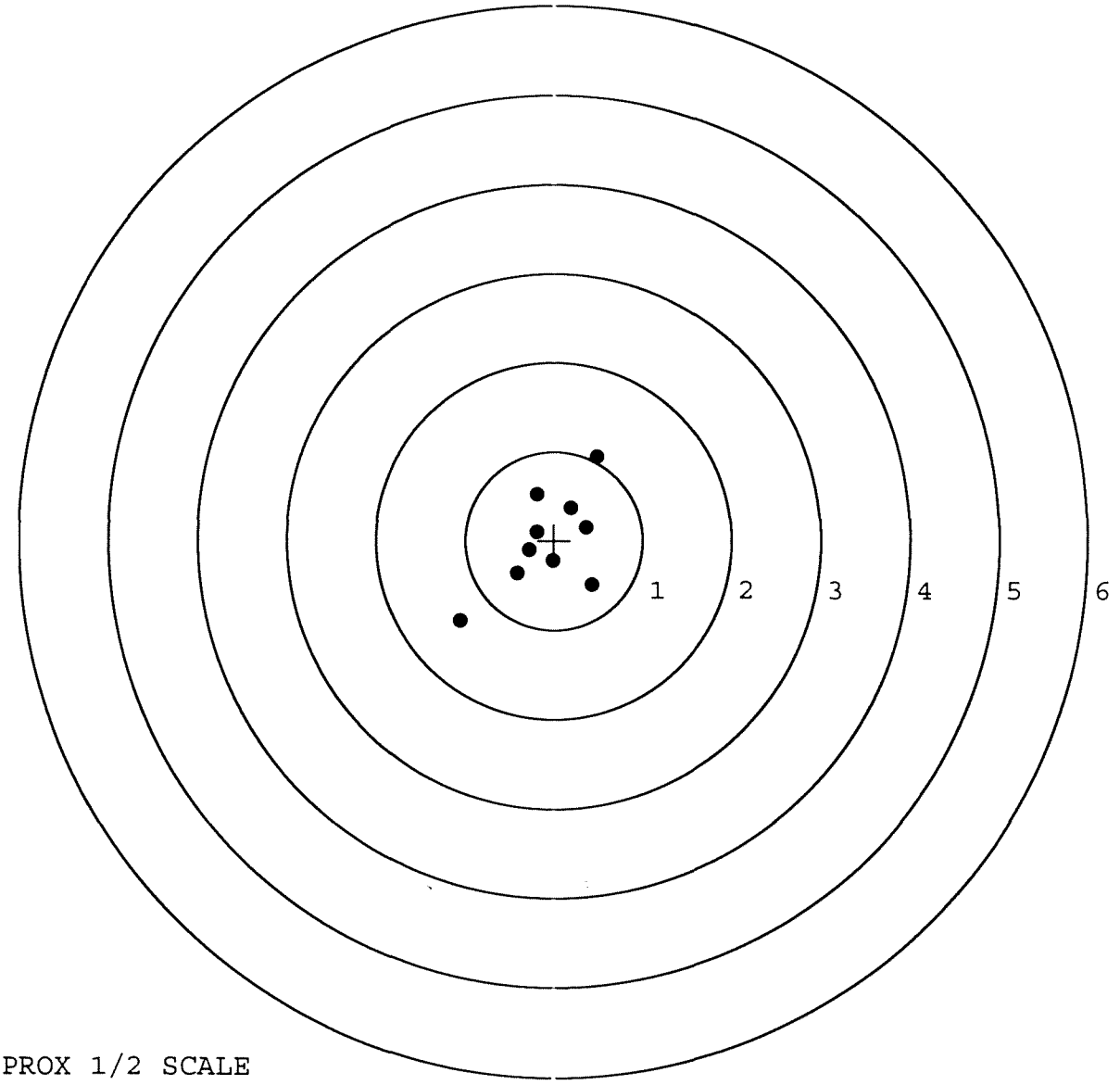
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

| | |
|---|---|
| The Average X Centroid of the Five Target Set: | -0.076 |
| The Average Y Centroid of the Five Target Set: | -0.045 |
| The Average Point of Impact of the Five Target Set: | 0.088 |
| The Average Mean Radius of the Five Target Set: | 0.572 |
| The Distance from POA to Centroid Target #1: | 0.068 |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.134 |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.145 |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.016 |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.040 |

SERIAL NUMBER: G6749775.__0
TARGET NUMBER: 1
FILE DATE: 06/23/2008
FILE TIME: 05:46

| | |
|---|---|
| X CENTROID: | -0.068 |
| Y CENTROID: | -0.003 |
| POA TO CENTROID: | 0.068 |
| HORZ SPREAD: | 1.540 |
| VERT SPREAD: | 1.844 |
| GROUP SPREAD: | 2.402 |
| MIN RADIUS: | 0.163 |
| MAX RADIUS: | 1.336 |
| MEAN RADIUS: | 0.573 |
| # IN 1 IN DIAMETER: | 5 |
| # IN 2 IN DIAMETER: | 8 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.431 | -0.498 |
| 2: | -1.055 | -0.904 |
| 3: | 0.485 | -0.940 |
| 4: | 0.364 | 0.150 |
| 5: | 0.197 | 0.367 |
| 6: | -0.189 | 0.523 |
| 7: | -0.197 | 0.096 |
| 8: | -0.286 | -0.107 |
| 9: | -0.417 | -0.372 |
| 10: | -0.015 | -0.229 |

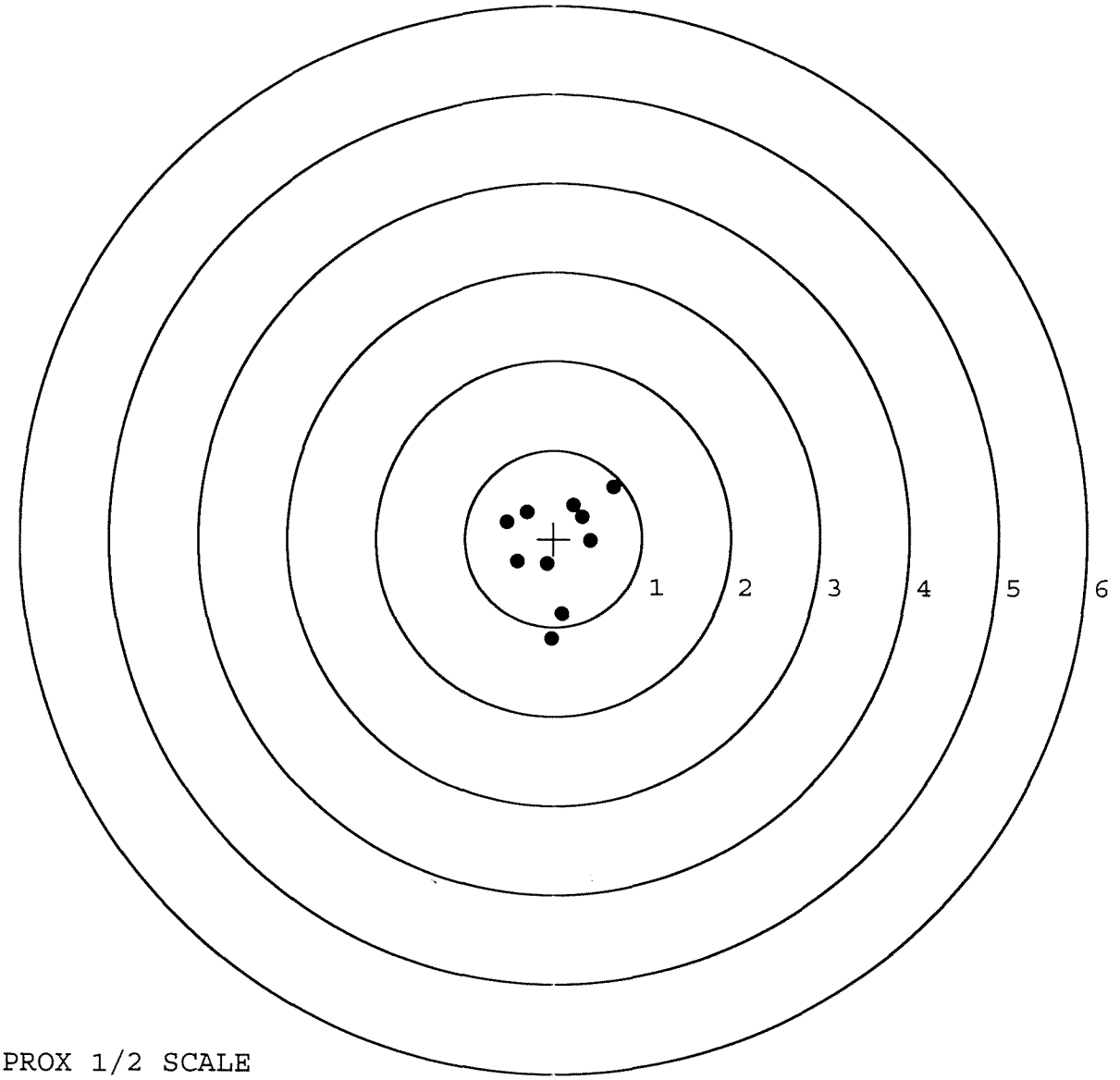



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749775.__0
TARGET NUMBER: 2
FILE DATE: 06/23/2008
FILE TIME: 05:46

| | |
|---|---|
| X CENTROID: | 0.038 |
| Y CENTROID: | -0.084 |
| POA TO CENTROID: | 0.093 |
| HORZ SPREAD: | 1.212 |
| VERT SPREAD: | 1.729 |
| GROUP SPREAD: | 1.870 |
| MIN RADIUS: | 0.233 |
| MAX RADIUS: | 1.058 |
| MEAN RADIUS: | 0.594 |
| # IN 1 IN DIAMETER: | 4 |
| # IN 2 IN DIAMETER: | 9 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.097 | -0.854 |
| 2: | -0.032 | -1.140 |
| 3: | -0.078 | -0.286 |
| 4: | -0.412 | -0.254 |
| 5: | -0.532 | 0.191 |
| 6: | -0.302 | 0.304 |
| 7: | 0.415 | -0.026 |
| 8: | 0.321 | 0.252 |
| 9: | 0.224 | 0.380 |
| 10: | 0.680 | 0.589 |

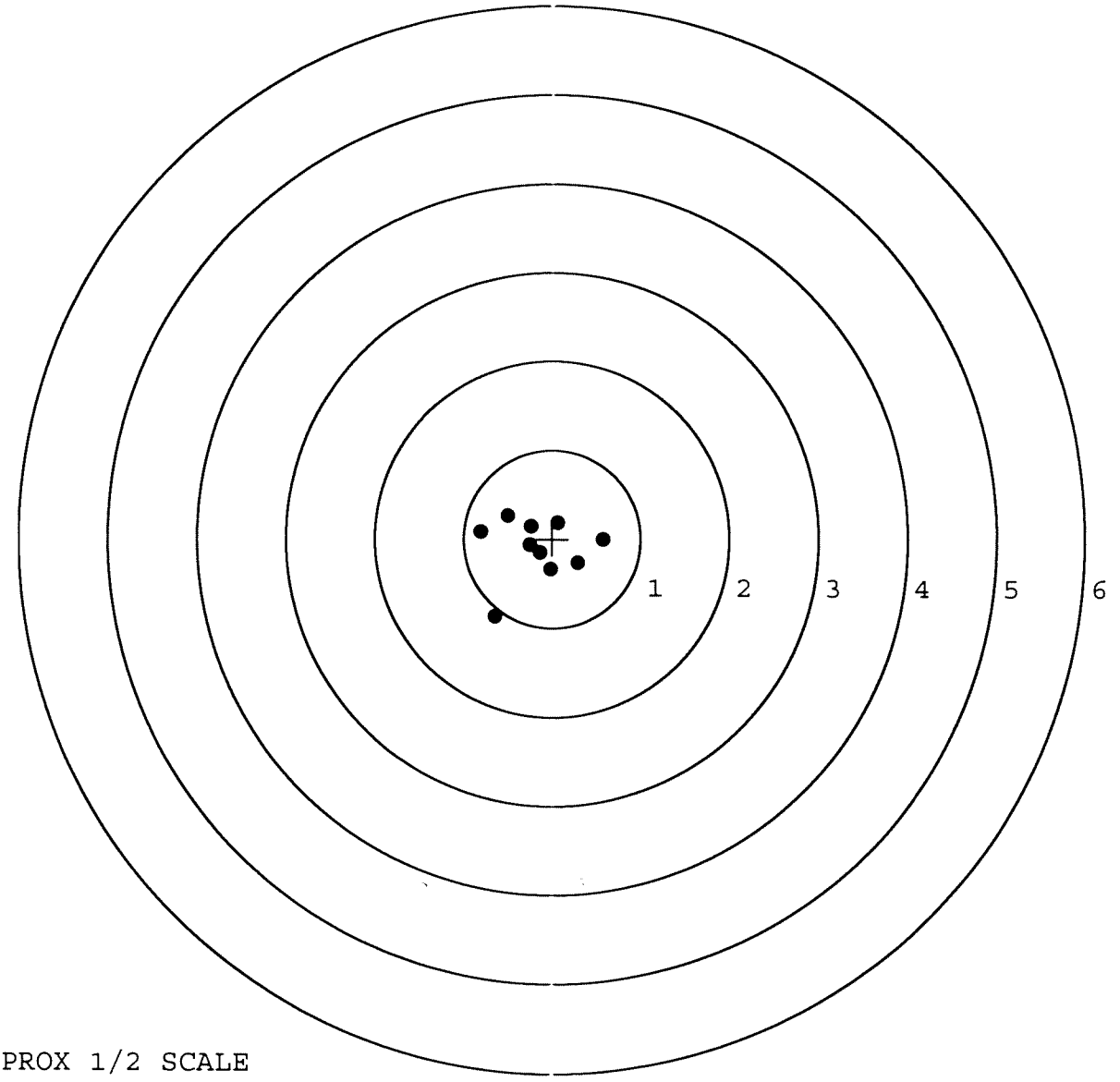



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749775.__0
TARGET NUMBER: 3
FILE DATE: 06/23/2008
FILE TIME: 05:46

| | |
|---|---|
| X CENTROID: | -0.171 |
| Y CENTROID: | -0.105 |
| POA TO CENTROID: | 0.201 |
| HORZ SPREAD: | 1.387 |
| VERT SPREAD: | 1.140 |
| GROUP SPREAD: | 1.504 |
| MIN RADIUS: | 0.062 |
| MAX RADIUS: | 0.910 |
| MEAN RADIUS: | 0.438 |
| # IN 1 IN DIAMETER: | 7 |
| # IN 2 IN DIAMETER: | 10 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 0.576 | -0.009 |
| 2: | 0.290 | -0.268 |
| 3: | -0.023 | -0.341 |
| 4: | -0.259 | -0.070 |
| 5: | 0.061 | 0.180 |
| 6: | -0.246 | 0.145 |
| 7: | -0.503 | 0.262 |
| 8: | -0.811 | 0.086 |
| 9: | -0.652 | -0.878 |
| 10: | -0.142 | -0.160 |

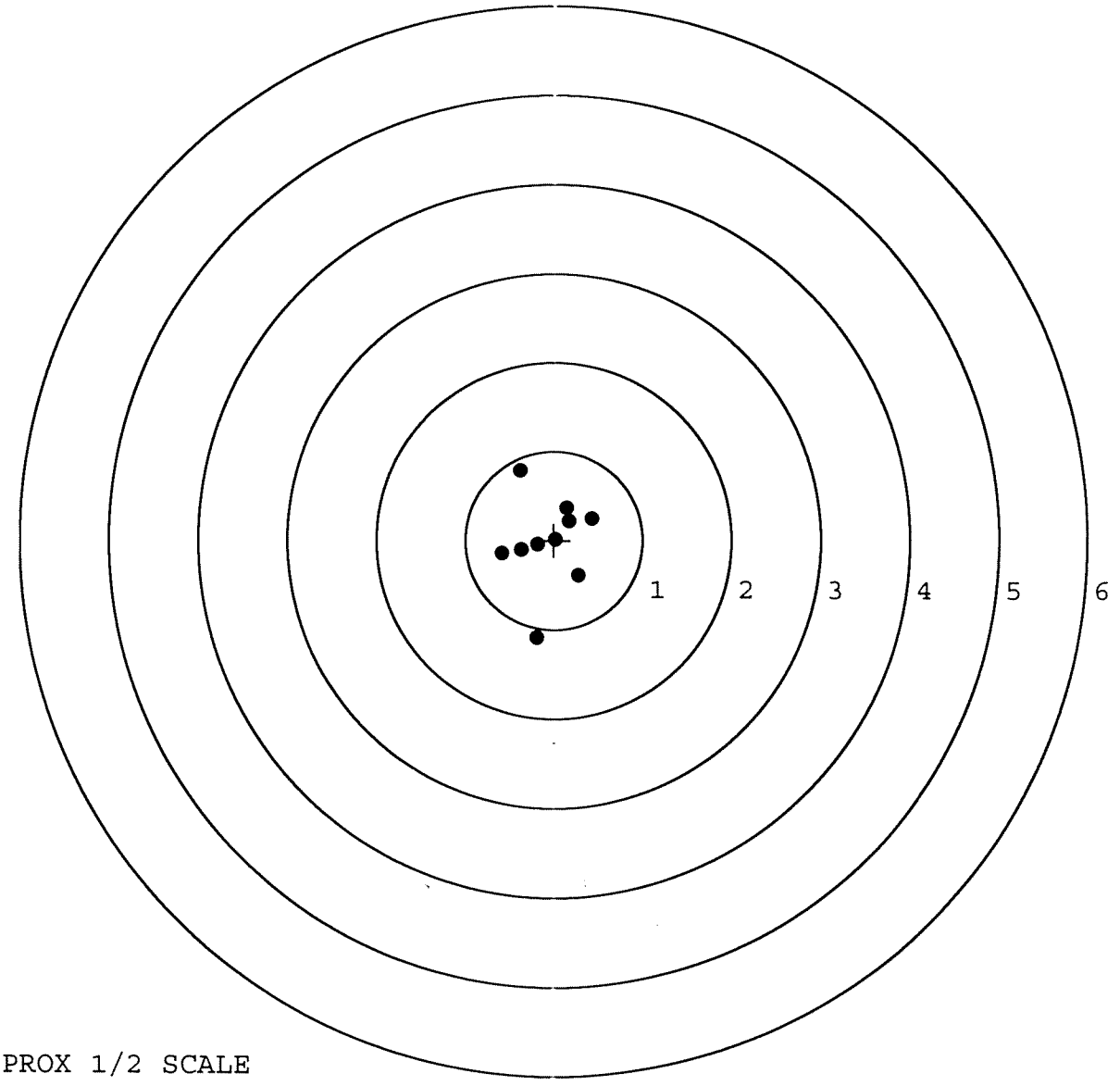



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749775.__0
TARGET NUMBER: 4
FILE DATE: 06/23/2008
FILE TIME: 05:46

| | |
|---|---|
| X CENTROID: | -0.069 |
| Y CENTROID: | -0.019 |
| POA TO CENTROID: | 0.072 |
| HORZ SPREAD: | 1.025 |
| VERT SPREAD: | 1.884 |
| GROUP SPREAD: | 1.893 |
| MIN RADIUS: | 0.088 |
| MAX RADIUS: | 1.087 |
| MEAN RADIUS: | 0.487 |
| # IN 1 IN DIAMETER: | 5 |
| # IN 2 IN DIAMETER: | 9 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | -0.194 | -1.099 |
| 2: | 0.278 | -0.400 |
| 3: | -0.383 | 0.785 |
| 4: | 0.145 | 0.366 |
| 5: | 0.433 | 0.244 |
| 6: | 0.167 | 0.214 |
| 7: | 0.015 | 0.007 |
| 8: | -0.190 | -0.051 |
| 9: | -0.372 | -0.112 |
| 10: | -0.592 | -0.149 |

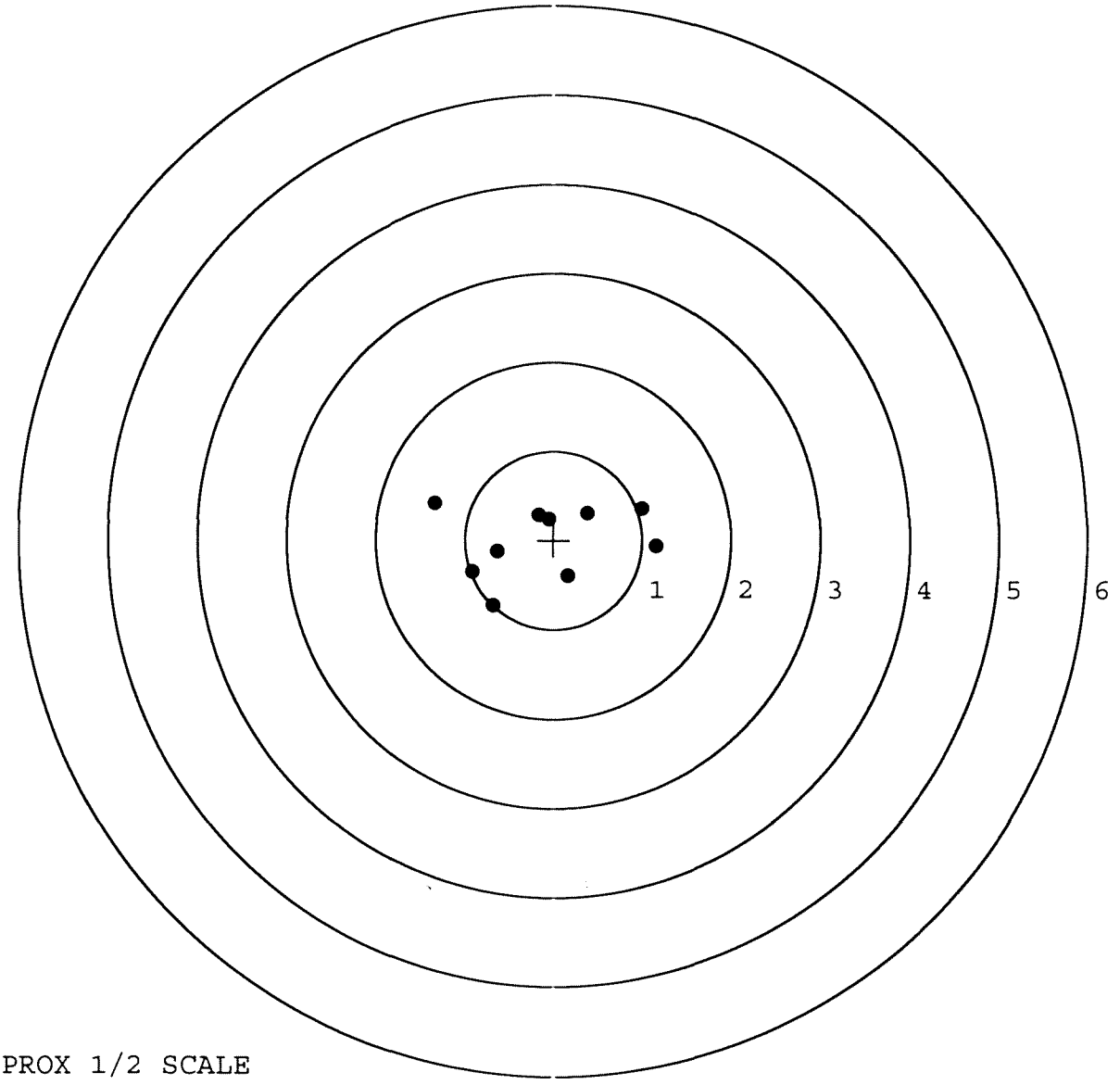



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749775.__0
TARGET NUMBER: 5
FILE DATE: 06/23/2008
FILE TIME: 05:46

| | |
|---|---|
| X CENTROID: | -0.108 |
| Y CENTROID: | -0.010 |
| POA TO CENTROID: | 0.108 |
| HORZ SPREAD: | 2.486 |
| VERT SPREAD: | 1.158 |
| GROUP SPREAD: | 2.534 |
| MIN RADIUS: | 0.254 |
| MAX RADIUS: | 1.293 |
| MEAN RADIUS: | 0.769 |
| # IN 1 IN DIAMETER: | 3 |
| # IN 2 IN DIAMETER: | 7 |
| # in 3 IN DIAMETER: | 10 |

| POINT# | X | Y |
|---|---|---|
| 1: | 1.159 | -0.070 |
| 2: | 0.998 | 0.357 |
| 3: | 0.390 | 0.301 |
| 4: | 0.162 | -0.406 |
| 5: | -0.055 | 0.238 |
| 6: | -0.169 | 0.281 |
| 7: | -0.637 | -0.129 |
| 8: | -0.915 | -0.357 |
| 9: | -0.685 | -0.739 |
| 10: | -1.327 | 0.419 |




TARGET APPROX 1/2 SCALE