

6674 9821

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM 200348

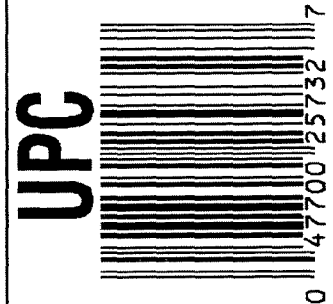


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6749821



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

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6749821

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		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	unms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/08	RT
520	GOFF BLAST BBL / REC		6/17/08	TL
542	APPLY COATINGS (BARREL ACTION)		6/18/08	LM
545	(BOLT)			
560	RE-ASSEMBLE ACTION		6/18/08	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	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	ESN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

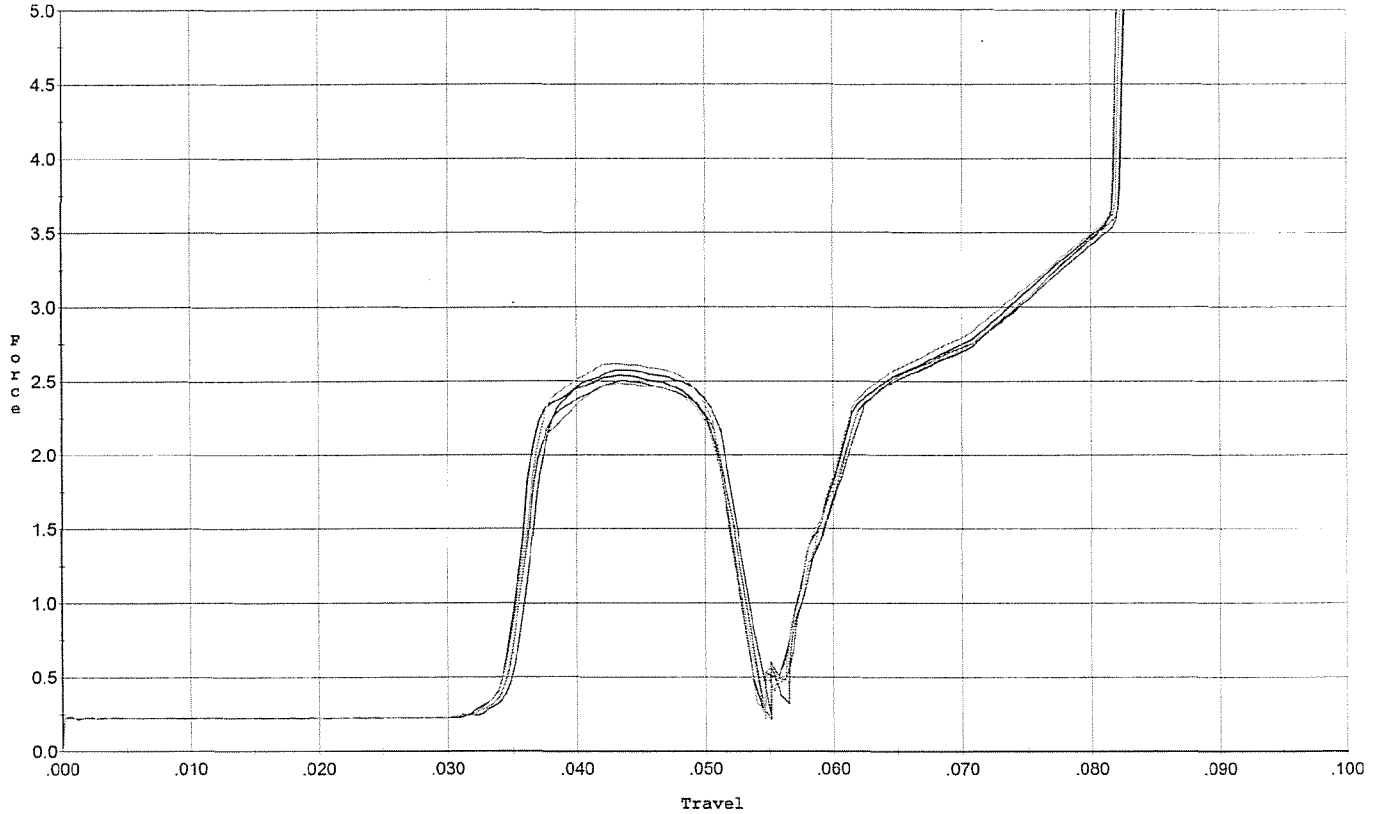
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁰</u> <u>7⁰</u> <u>7⁰</u>	6-26-08	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4⁰</u> <u>4⁰</u> <u>4⁰</u>	6-26-08	KTL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>022</u> <u>022</u> <u>022</u>	6-26-08	RTZ
	J) ASSEMBLE STOCK		6-19-08	ESW
	K) ASSEMBLE SWIVEL STUDS		6-27-08	ESW
	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	6-26-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-20-08	SP
670	FINAL INSPECTION A) HEADSPACE		6-27-08	ESW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>022</u> <u>022</u> <u>022</u> <u>022</u> <u>022</u>	6-26-08	RTZ
	C) FUNCTION			
690	PACK		6/30/08	RP

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 6/11/08

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



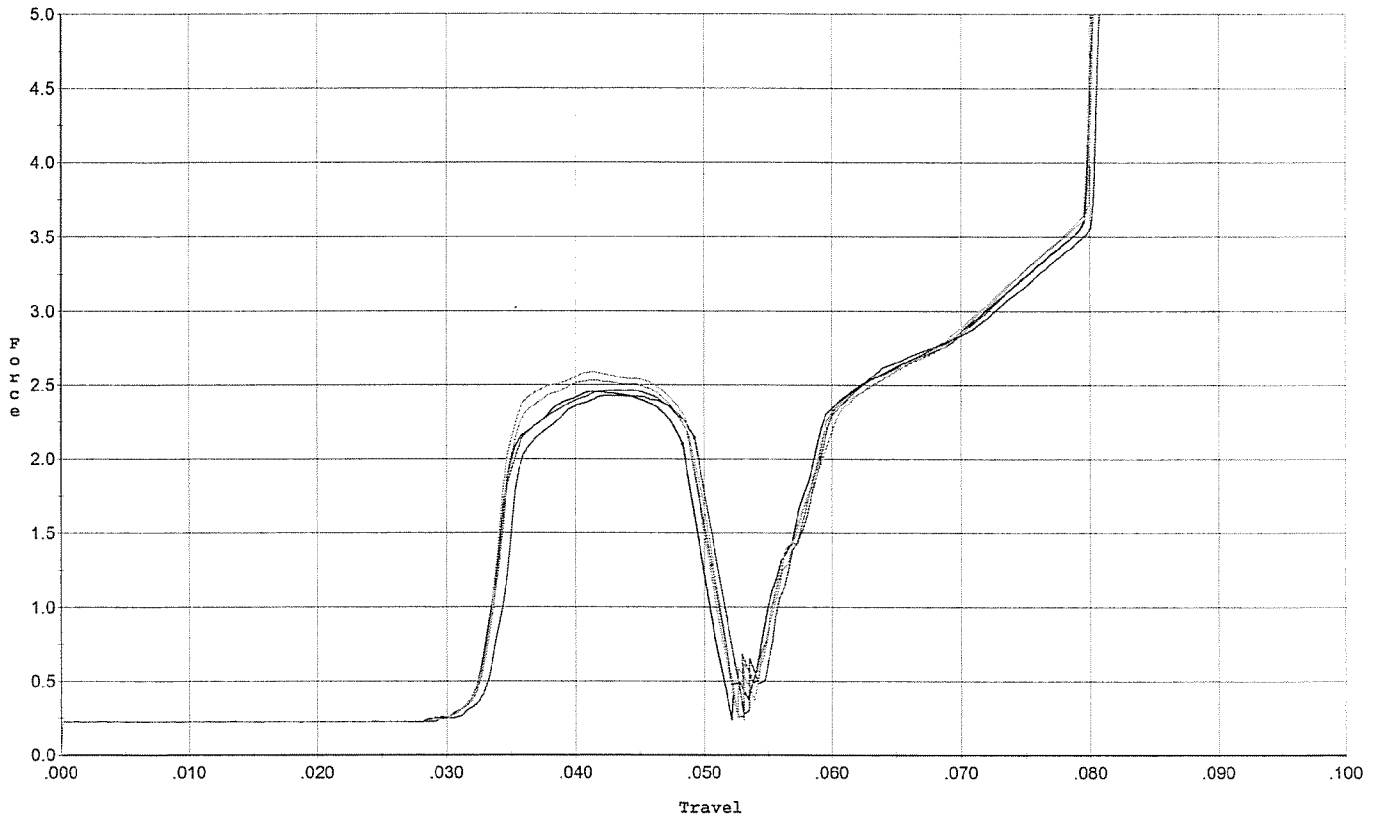
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.577	0.051	0.035	0.036	0.046		Set Trigger
2	2.538	0.051	0.034	0.036	0.046		Set Trigger
3	2.504	0.052	0.034	0.036	0.047		Set Trigger
4	2.618	0.051	0.034	0.036	0.046		Set Trigger
5	2.488	0.051	0.034	0.036	0.045		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/11/08

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



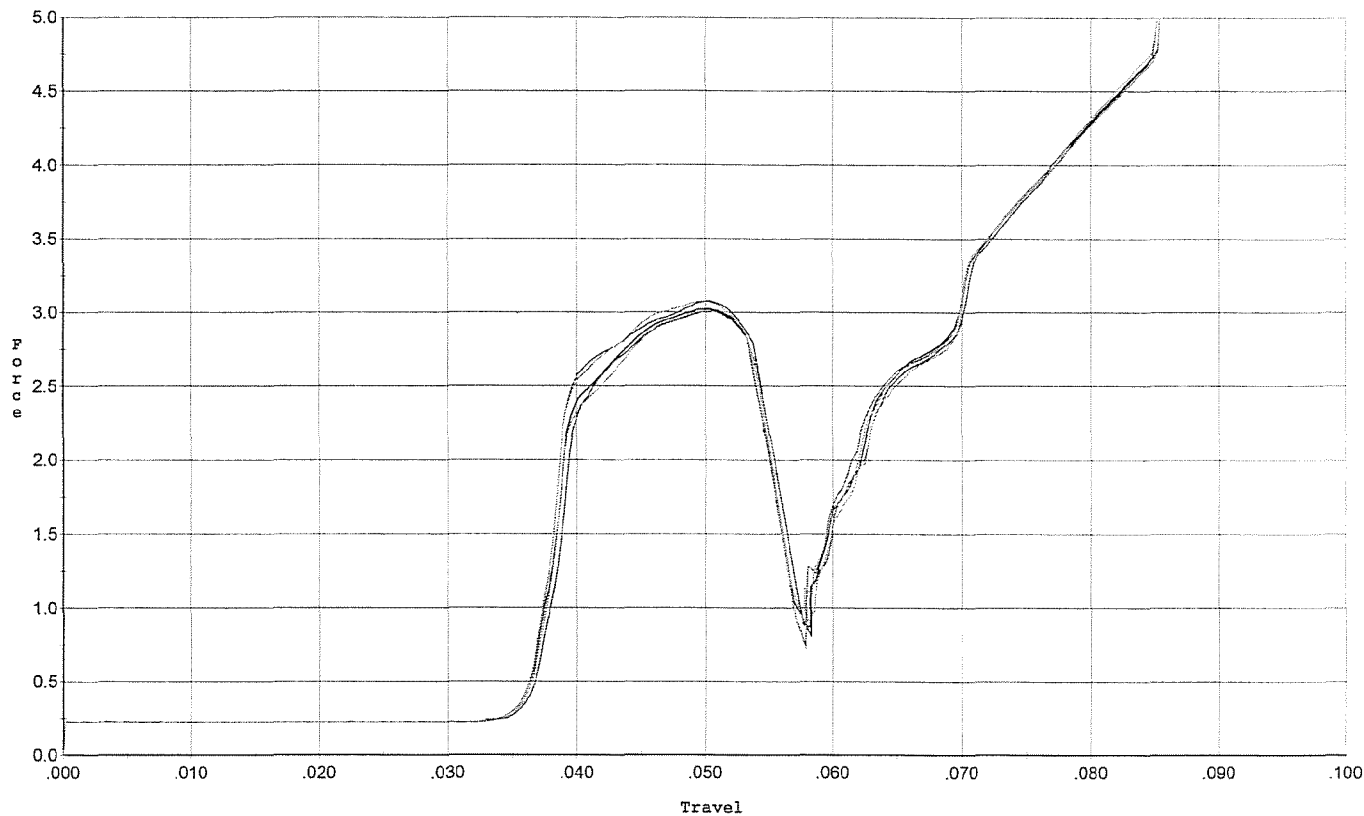
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.427	0.049	0.033	0.035	0.043		Set Trigger
2	2.456	0.048	0.032	0.035	0.043		Set Trigger
3	2.465	0.051	0.032	0.035	0.046		Set Trigger
4	2.586	0.050	0.032	0.035	0.047		Set Trigger
5	2.531	0.049	0.032	0.035	0.045		Set Trigger

AVG 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 6/11/08

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



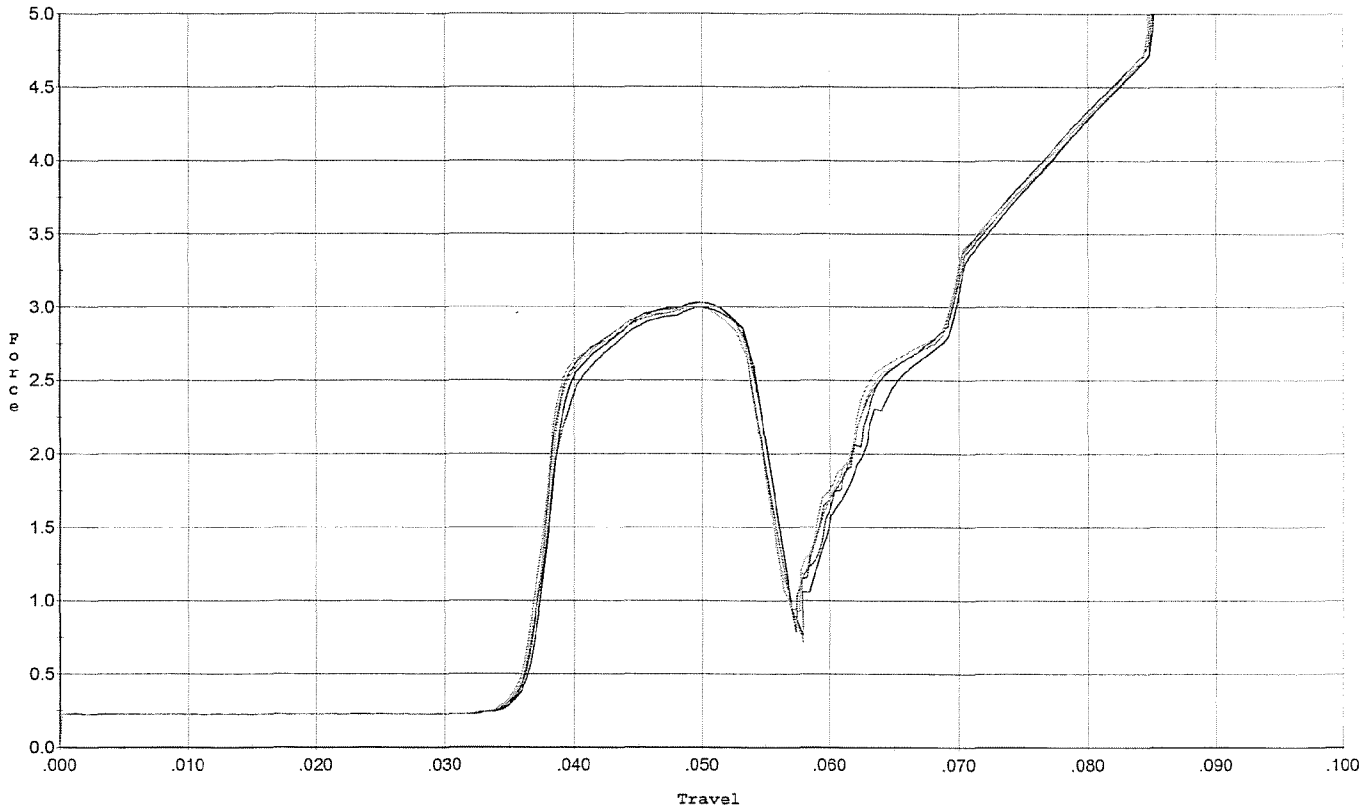
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.012	0.056	0.036	0.036	0.056		Set Trigger
2	3.021	0.054	0.036	0.036	0.055		Set Trigger
3	3.077	0.055	0.036	0.036	0.057		Set Trigger
4	3.074	0.054	0.036	0.036	0.057		Set Trigger
5	3.007	0.054	0.036	0.036	0.055		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/11/08

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



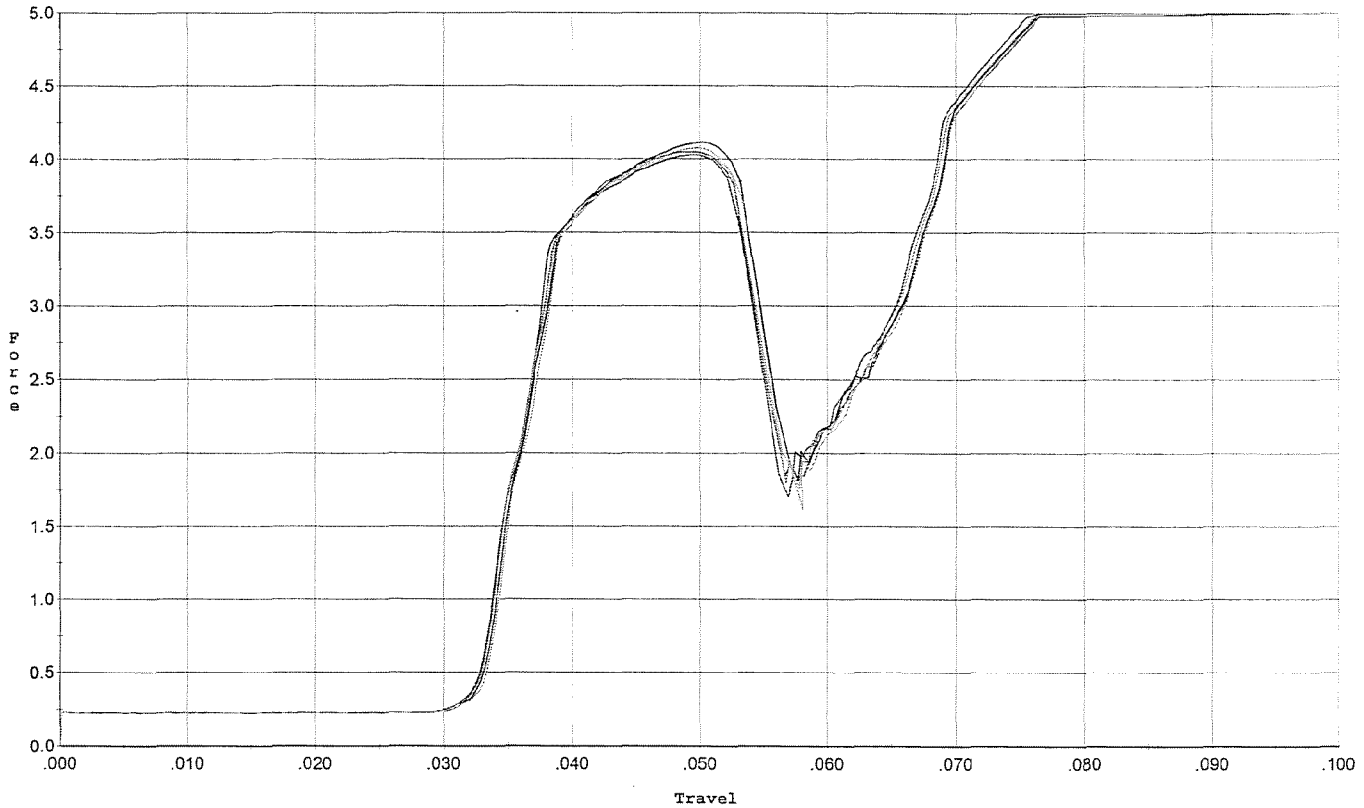
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.995	0.054	0.036	0.036	0.056		Set Trigger
2	3.026	0.054	0.036	0.036	0.056		Set Trigger
3	3.031	0.053	0.036	0.036	0.056		Set Trigger
4	2.996	0.053	0.036	0.036	0.055		Set Trigger
5	3.024	0.053	0.036	0.036	0.056		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/11/08

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



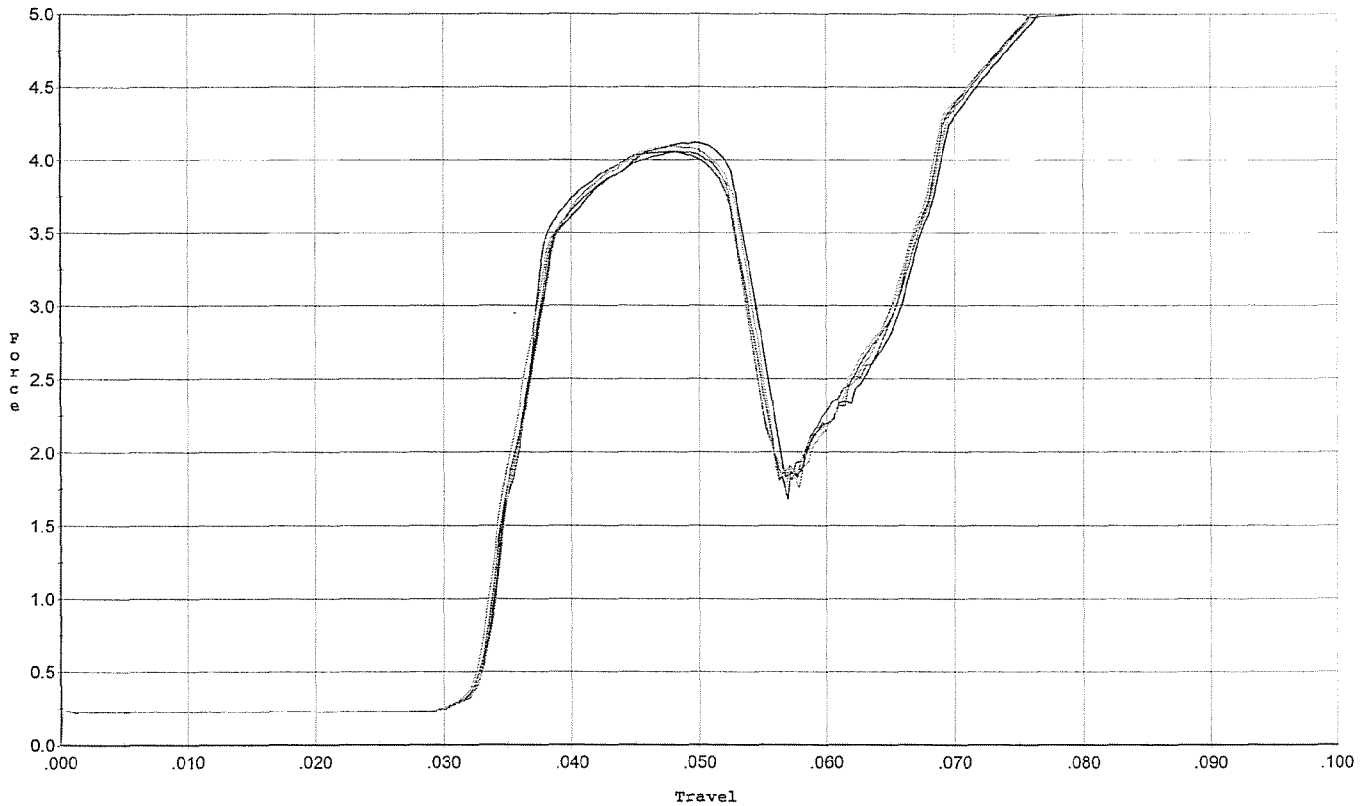
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.031	0.053	0.032	0.033	0.078		Set Trigger
2	4.116	0.053	0.033	0.033	0.079		Set Trigger
3	4.049	0.053	0.032	0.033	0.077		Set Trigger
4	4.034	0.053	0.033	0.034	0.078		Set Trigger
5	4.077	0.053	0.032	0.033	0.077		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/11/08

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



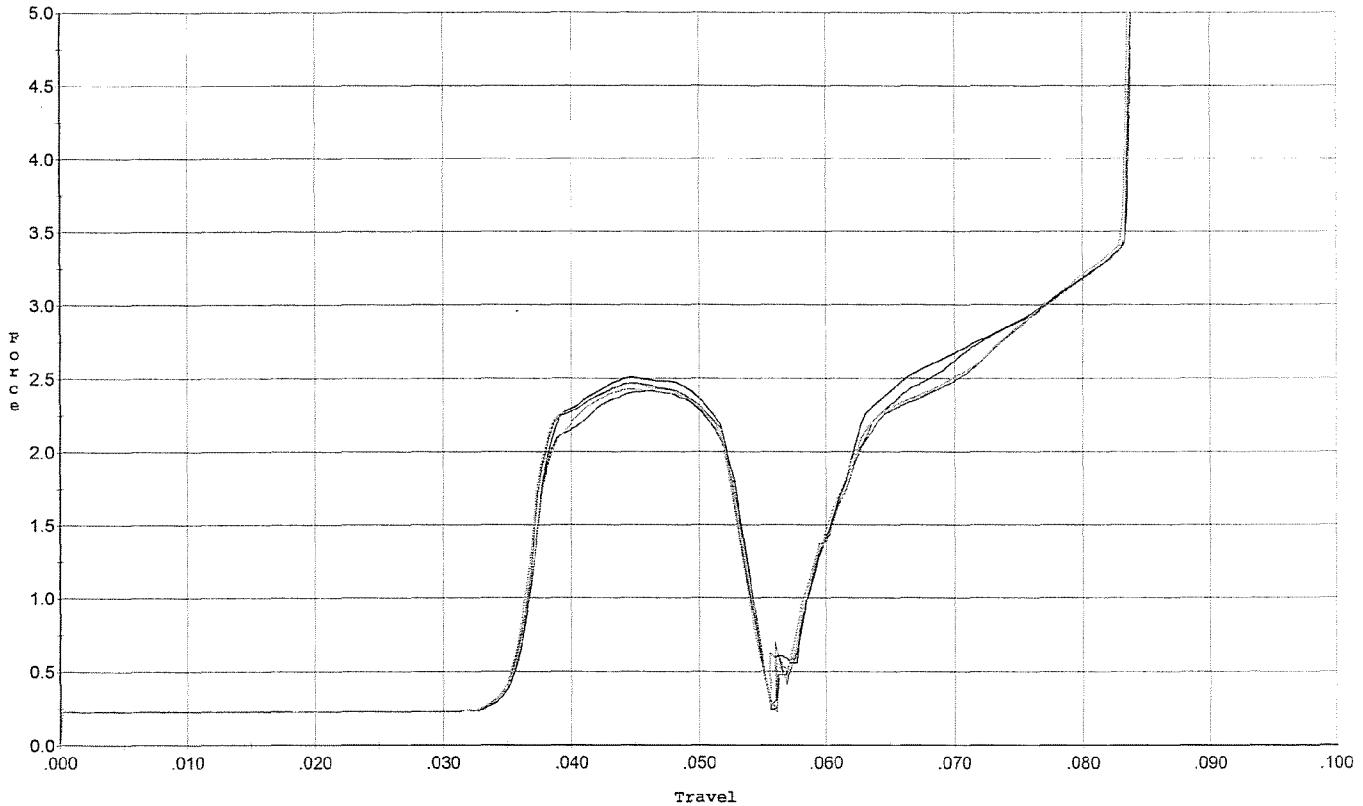
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.052	0.032	0.033	0.077		Set Trigger
2	4.118	0.054	0.033	0.033	0.081		Set Trigger
3	4.055	0.052	0.033	0.034	0.076		Set Trigger
4	4.098	0.053	0.033	0.033	0.078		Set Trigger
5	4.091	0.052	0.032	0.033	0.077		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/11/08

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



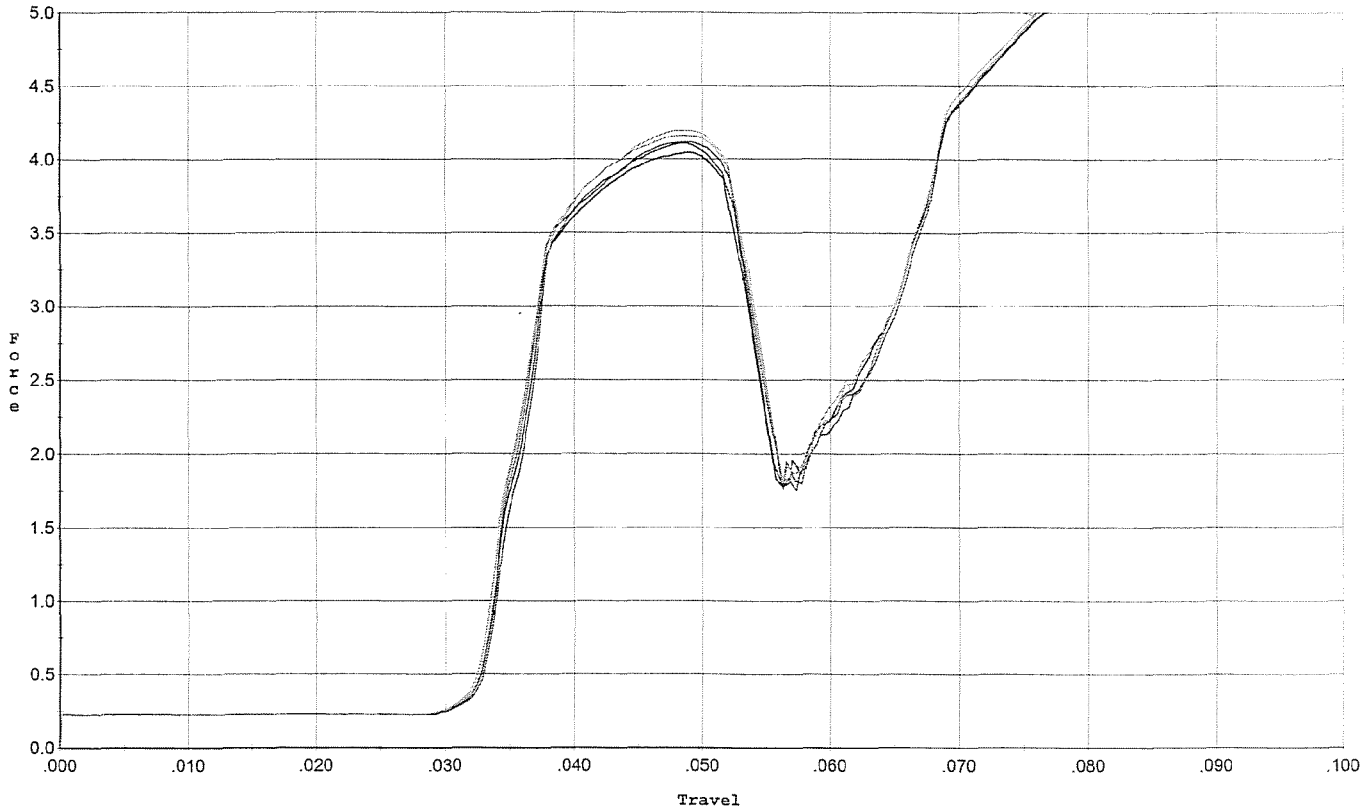
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.052	0.035	0.037	0.044		Set Trigger
2	2.509	0.053	0.035	0.037	0.046		Set Trigger
3	2.469	0.053	0.035	0.037	0.046		Set Trigger
4	2.467	0.052	0.035	0.036	0.045		Set Trigger
5	2.428	0.053	0.035	0.037	0.046		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/11/08

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	4.109	0.052	0.033	0.033	0.076		Set Trigger
2	4.047	0.053	0.032	0.033	0.077		Set Trigger
3	4.115	0.052	0.032	0.033	0.077		Set Trigger
4	4.159	0.052	0.032	0.033	0.078		Set Trigger
5	4.194	0.054	0.032	0.033	0.081		Set Trigger

AVG 4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6749821.___0

FILE DATE AND TIME: 06/23/2008 05:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

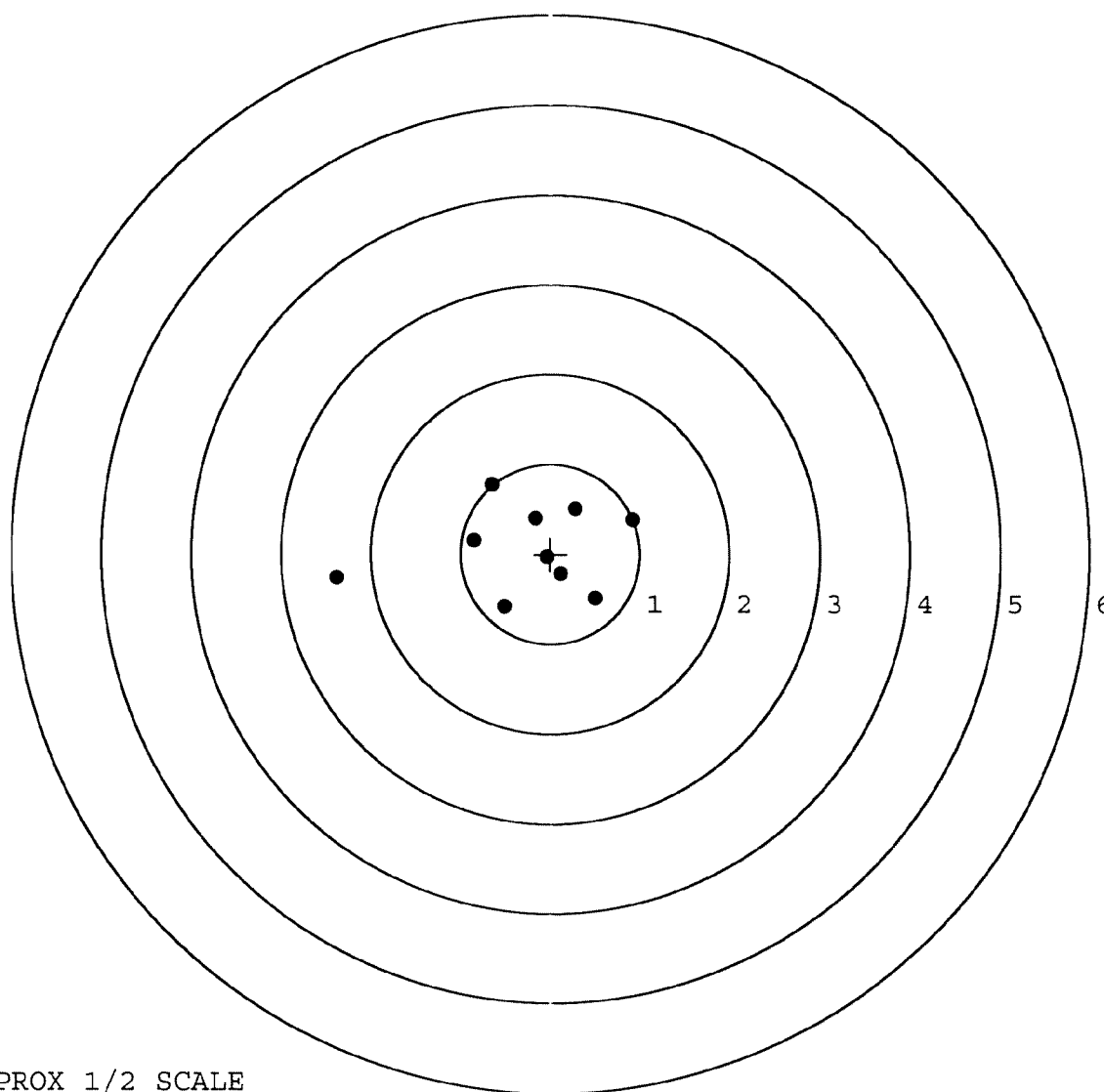
The Average X Centroid of the Five Target Set:	-0.131
The Average Y Centroid of the Five Target Set:	0.027
The Average Point of Impact of the Five Target Set:	0.133
The Average Mean Radius of the Five Target Set:	0.638
The Distance from POA to Centroid Target #1:	0.286
The Distance from Centroid Target #2 to Centroid Target #1:	0.177
The Distance from Centroid Target #3 to Centroid Target #1:	0.195
The Distance from Centroid Target #4 to Centroid Target #1:	0.301
The Distance from Centroid Target #5 to Centroid Target #1:	0.274

BARBER - M24 0139281

SERIAL NUMBER: G6749821. __0
 TARGET NUMBER: 1
 FILE DATE: 06/23/2008
 FILE TIME: 05:29

POINT#	X	Y
1:	0.501	-0.499
2:	0.921	0.386
3:	0.286	-0.502
4:	-0.045	-0.036
5:	0.119	-0.222
6:	-0.519	-0.590
7:	-0.168	0.398
8:	-0.658	0.771
9:	-0.854	0.153
10:	-2.381	-0.268

X CENTROID: -0.280
 Y CENTROID: 0.060
 POA TO CENTROID: 0.286
 HORZ SPREAD: 3.302
 VERT SPREAD: 1.361
 GROUP SPREAD: 3.366
 MIN RADIUS: 0.253
 MAX RADIUS: 2.127
 MEAN RADIUS: 0.823
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0139282

SERIAL NUMBER: G6749821. __0

TARGET NUMBER: 2

FILE DATE: 06/23/2008

FILE TIME: 05:29

POINT#	X	Y
1:	0.580	0.262
2:	0.512	0.038
3:	0.300	-0.106
4:	0.020	0.009
5:	-0.369	-0.065
6:	-0.367	0.278
7:	-0.568	0.130
8:	-0.867	0.542
9:	0.044	-0.640
10:	-0.380	-0.333

X CENTROID: -0.110

Y CENTROID: 0.012

POA TO CENTROID: 0.110

HORZ SPREAD: 1.447

VERT SPREAD: 1.182

GROUP SPREAD: 1.492

MIN RADIUS: 0.130

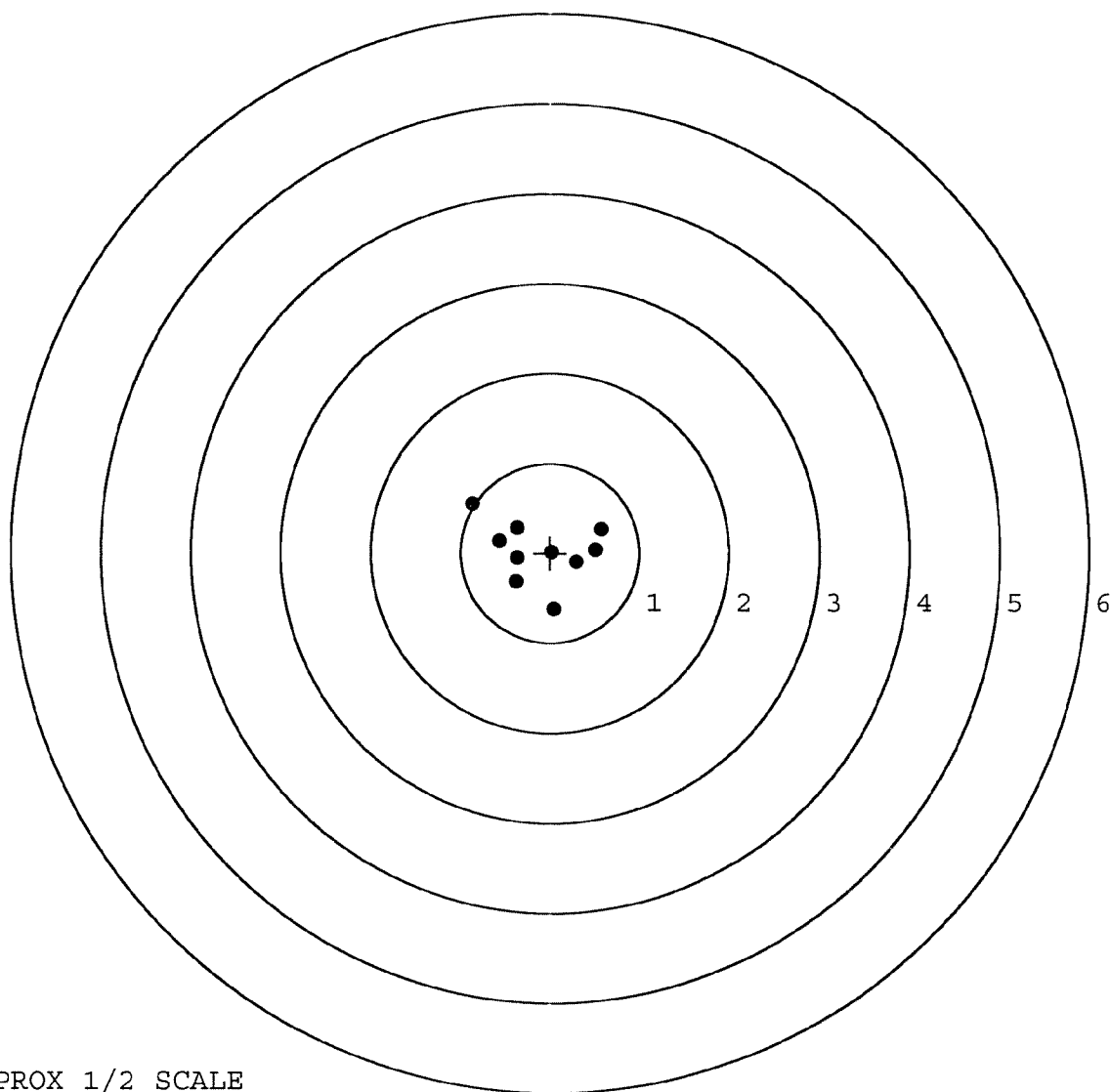
MAX RADIUS: 0.925

MEAN RADIUS: 0.506

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0139283

SERIAL NUMBER: G6749821. __ 0

TARGET NUMBER: 3

FILE DATE: 06/23/2008

FILE TIME: 05:29

POINT#	X	Y
1:	0.306	0.504
2:	-0.098	0.778
3:	-0.121	0.499
4:	0.434	-0.154
5:	0.030	-0.694
6:	-0.152	-0.508
7:	-0.344	-0.872
8:	-0.231	0.025
9:	-0.482	-0.010
10:	-0.373	0.214

X CENTROID: -0.103

Y CENTROID: -0.022

POA TO CENTROID: 0.105

HORZ SPREAD: 0.916

VERT SPREAD: 1.650

GROUP SPREAD: 1.668

MIN RADIUS: 0.136

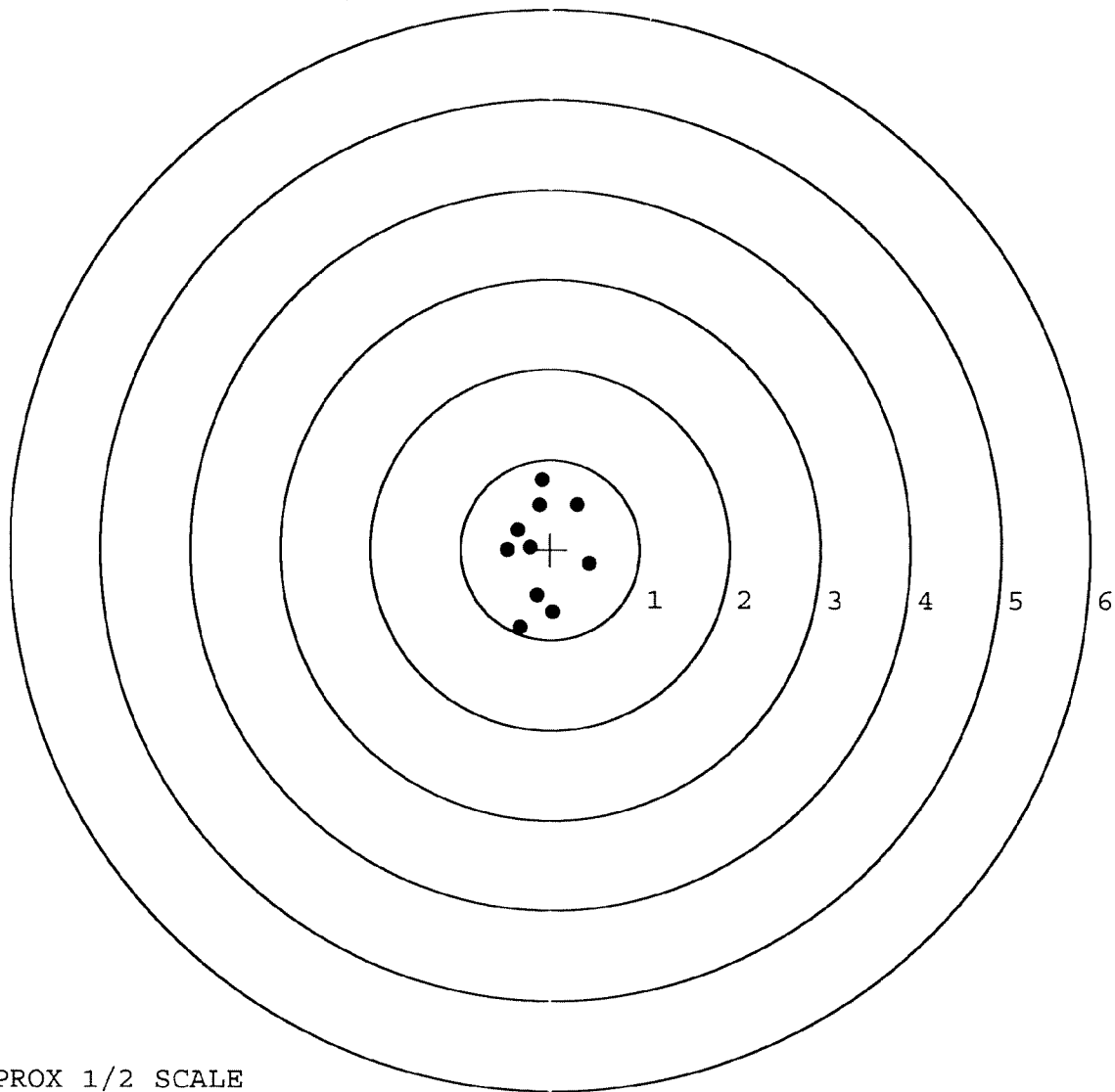
MAX RADIUS: 0.884

MEAN RADIUS: 0.547

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



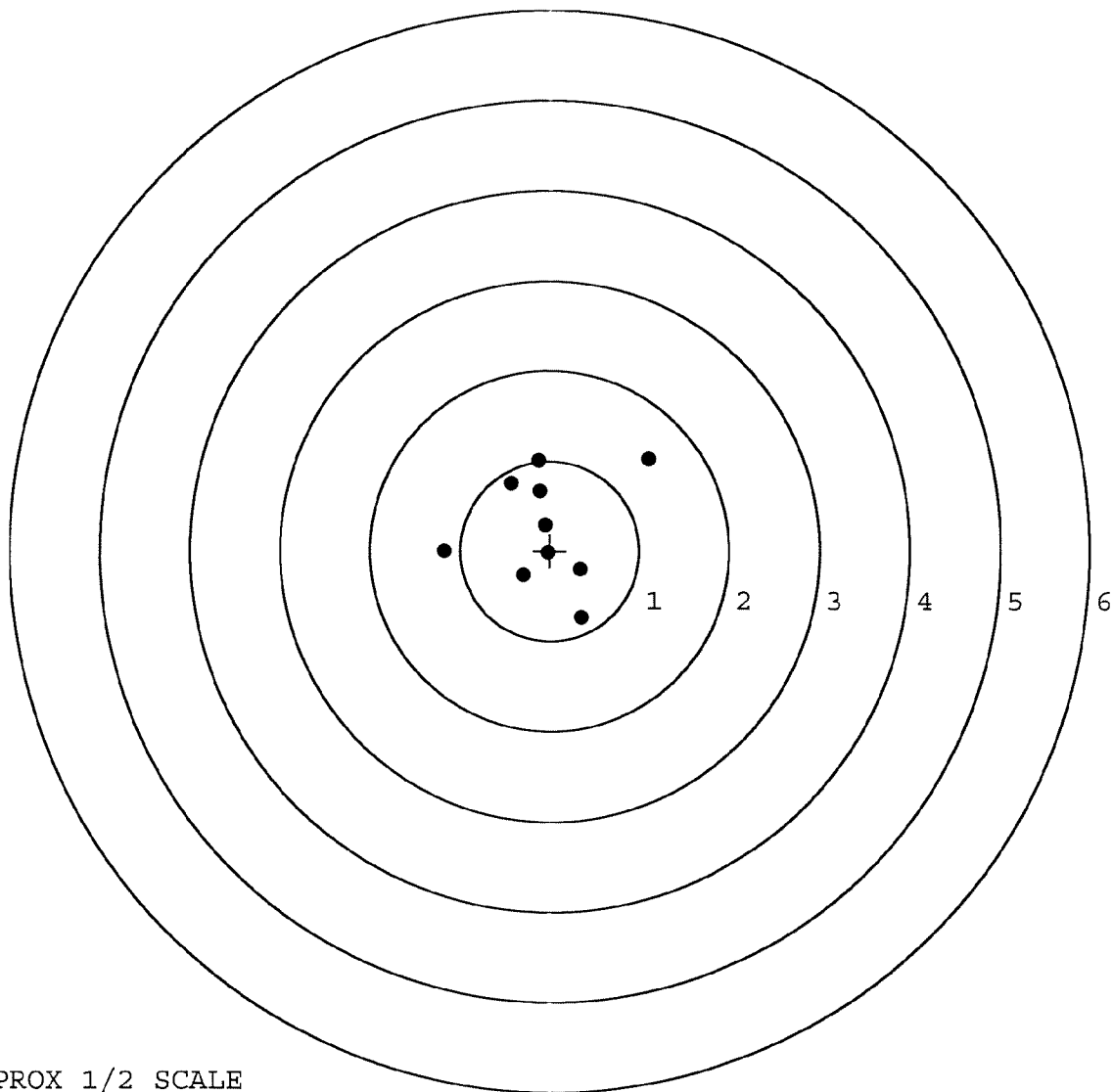
TARGET APPROX 1/2 SCALE

BARBER - M24 0139284

SERIAL NUMBER: G6749821. 0
 TARGET NUMBER: 4
 FILE DATE: 06/23/2008
 FILE TIME: 05:29

POINT#	X	Y
1:	1.106	1.026
2:	0.360	-0.741
3:	0.343	-0.212
4:	-0.299	-0.280
5:	-0.026	-0.022
6:	-0.057	0.293
7:	-1.179	-0.013
8:	-0.119	0.663
9:	-0.435	0.750
10:	-0.132	1.001

X CENTROID: -0.044
 Y CENTROID: 0.247
 POA TO CENTROID: 0.250
 HORZ SPREAD: 2.285
 VERT SPREAD: 1.767
 GROUP SPREAD: 2.510
 MIN RADIUS: 0.048
 MAX RADIUS: 1.389
 MEAN RADIUS: 0.694
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0139285

SERIAL NUMBER: G6749821. __0

TARGET NUMBER: 5

FILE DATE: 06/23/2008

FILE TIME: 05:29

POINT#	X	Y
1:	0.561	-1.013
2:	-0.021	-0.759
3:	0.201	-0.704
4:	0.335	-0.196
5:	0.320	0.504
6:	-0.228	0.285
7:	-0.209	-0.058
8:	-0.794	-0.138
9:	-0.784	0.315
10:	-0.551	0.159

X CENTROID: -0.117

Y CENTROID: -0.160

POA TO CENTROID: 0.199

HORZ SPREAD: 1.355

VERT SPREAD: 1.517

GROUP SPREAD: 1.890

MIN RADIUS: 0.138

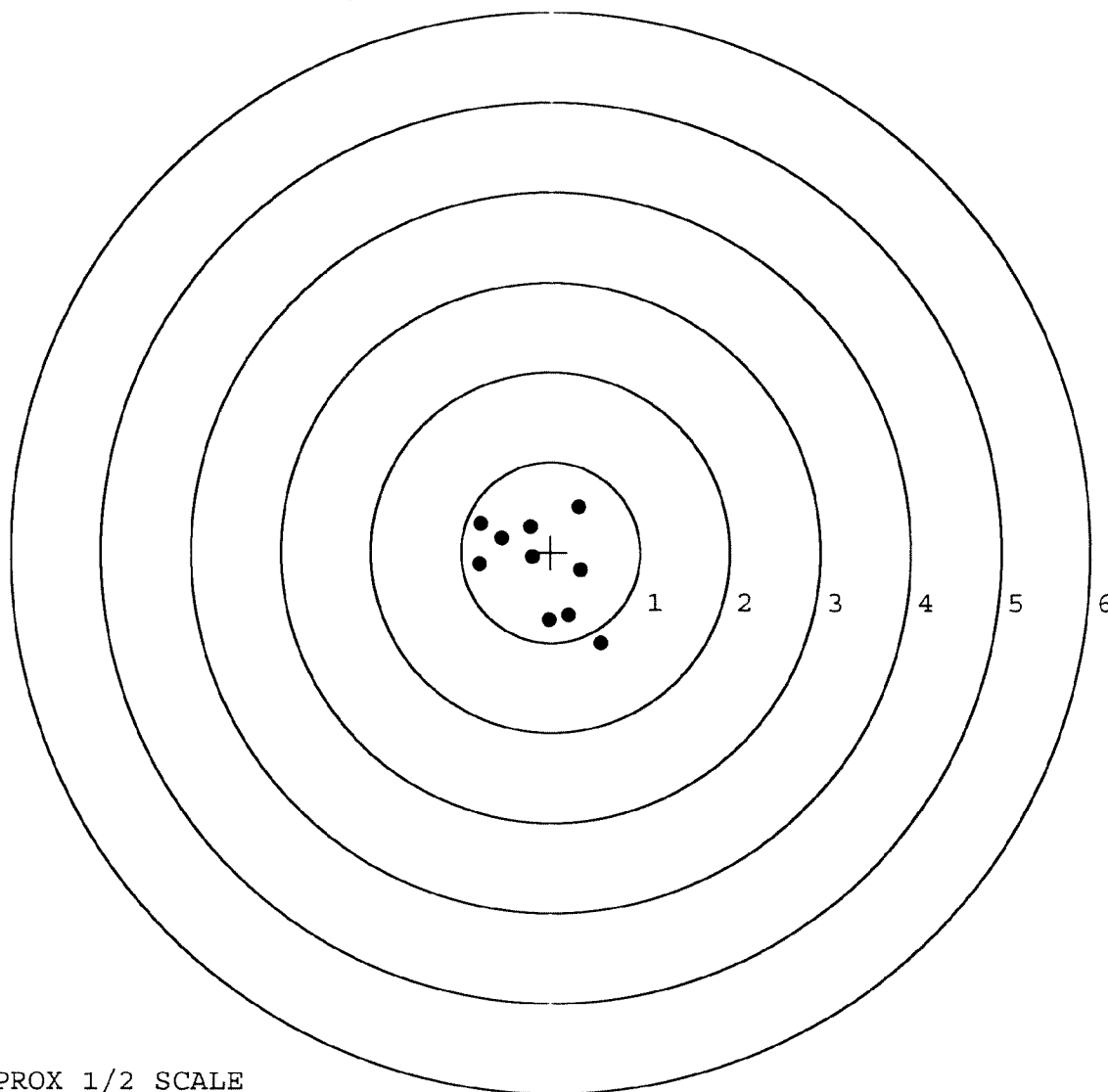
MAX RADIUS: 1.089

MEAN RADIUS: 0.621

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE