

G-6635165

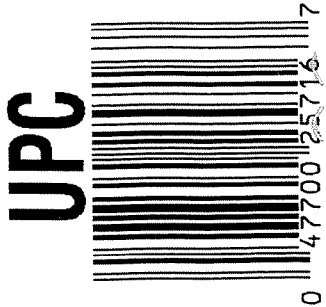
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6635165



DD FORM

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC



SERIAL NO.



GUN SERIAL # G 6635165

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-23-07	RTZ
420	ASSEMBLE ACTION		3-23-07	RTZ
430	ASSEMBLE TO STOCK		3-23-07	TRW
440	PROOF		3-23-07	Fm
460	CHECK HEADSPACE	INSPECTED	3-23-07	Fm
470	DIS-ASSEMBLE ACTION	MAR 26 2007	3-23-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	3-26-07	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-26-07	CW
510	DRILL AND TAP SIGHT HOLES		3-23-07	SD
520	GOFF BLAST BBL / REC		3/27/07	Le
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		3-30-07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/11/07	APD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/11/07	APD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/11/07	APD
	D) OIL FIRING PIN ASSEMBLY		4/17/07	APD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/18/07	man
F004 REV 5/2006				

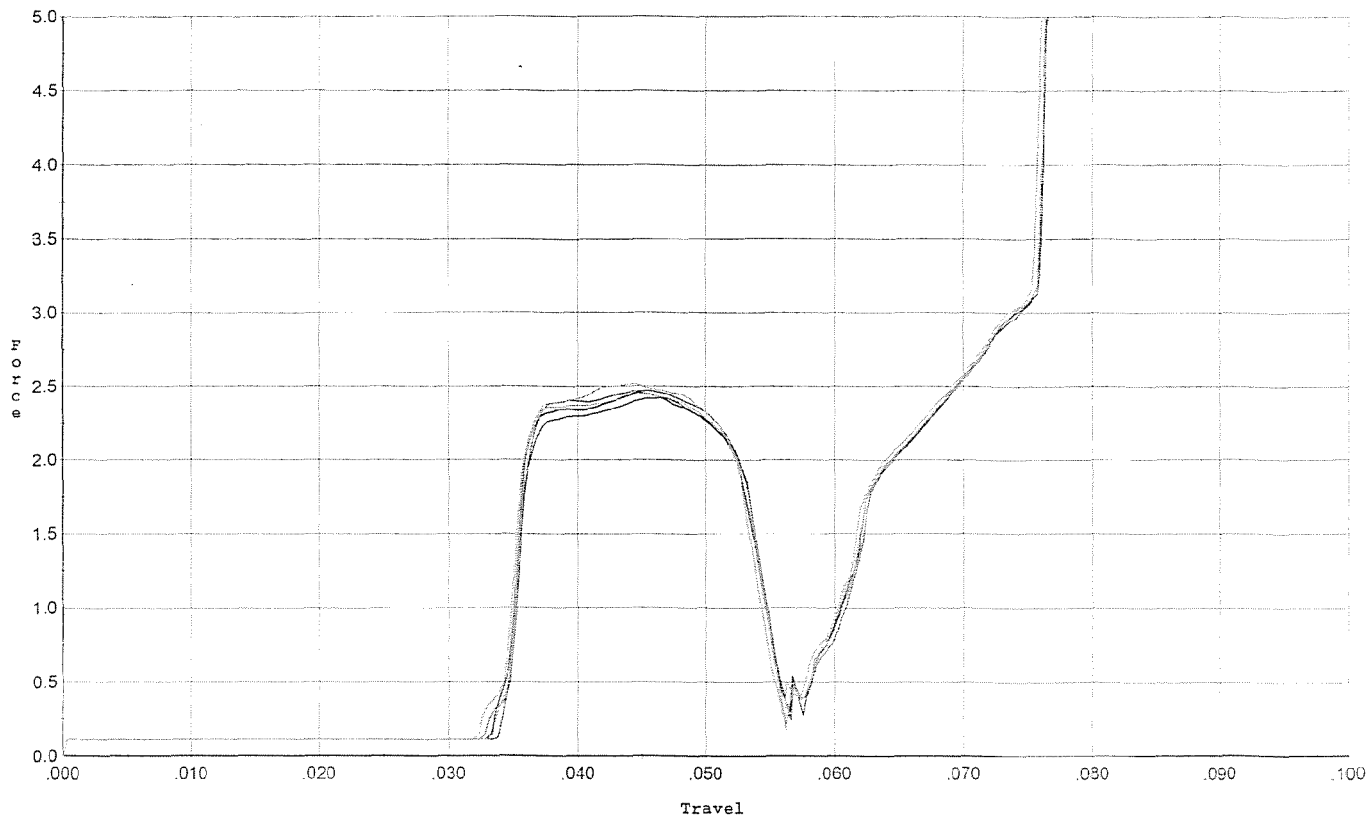
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9.0</u> <u>9.5</u> <u>8.75</u>	4-18-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.25</u> <u>3.5</u>	4-18-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		4/18/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.024</u> <u>.024</u>	4-18-07	TRW
	J) ASSEMBLE STOCK		4/17/07	PP.D.
	K) ASSEMBLE SWIVEL STUDS		4/18/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/18/07	non
	M) IRON SIGHT ALIGNMENT		4/18/07	non
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/18/07	non
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-18-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4/19/07	W.R.
670	FINAL INSPECTION A) HEADSPACE		4/18/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.43</u> <u>2.36</u> <u>2.36</u> <u>2.34</u>	4-18-07	TRW
	C) FUNCTION		4/18/07	non
690	PACK		4/20/07	OP

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



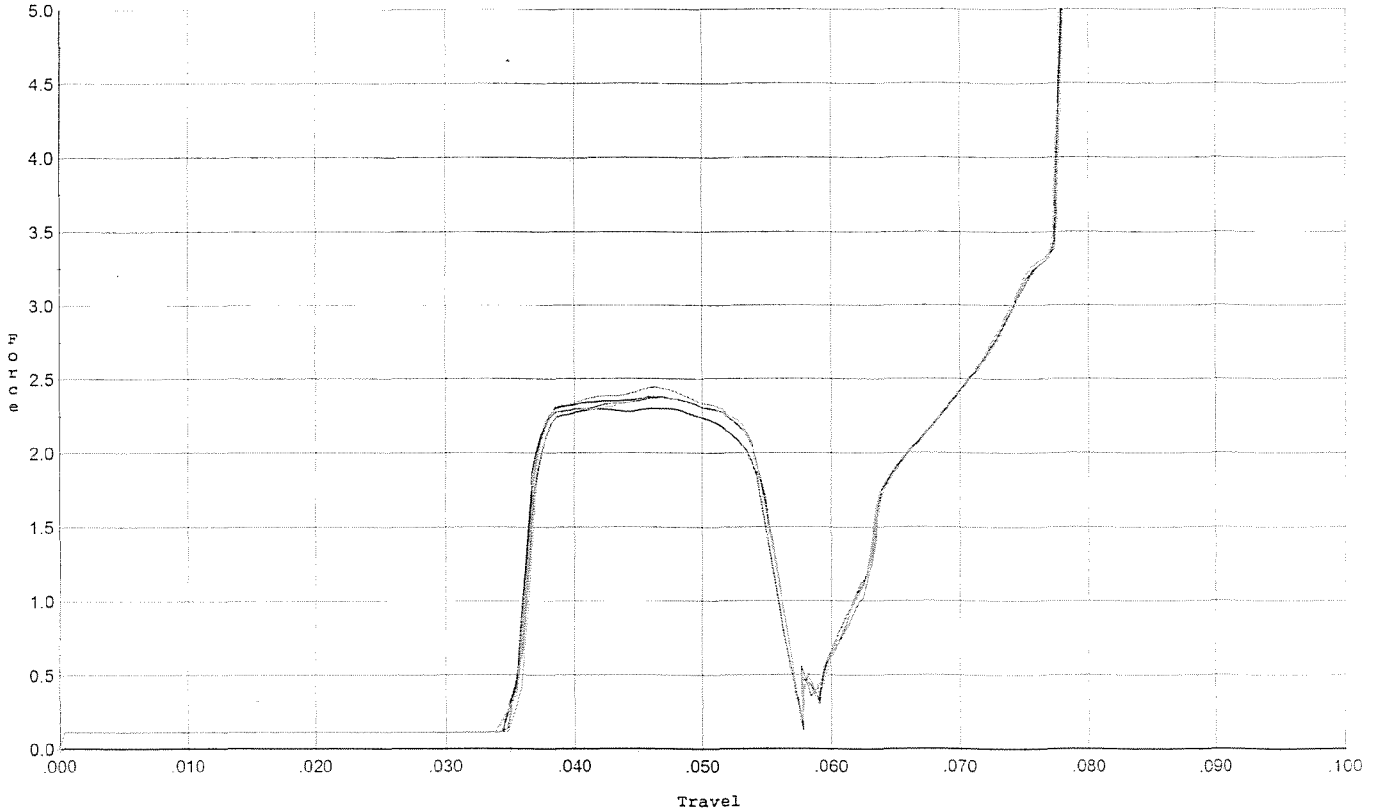
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.422	0.053	0.034	0.030	0.046		Set Trigger
2	2.458	0.054	0.034	0.030	0.047		Set Trigger
3	2.469	0.053	0.033	0.030	0.047		Set Trigger
4	2.451	0.054	0.034	0.030	0.047		Set Trigger
5	2.516	0.053	0.033	0.030	0.047		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



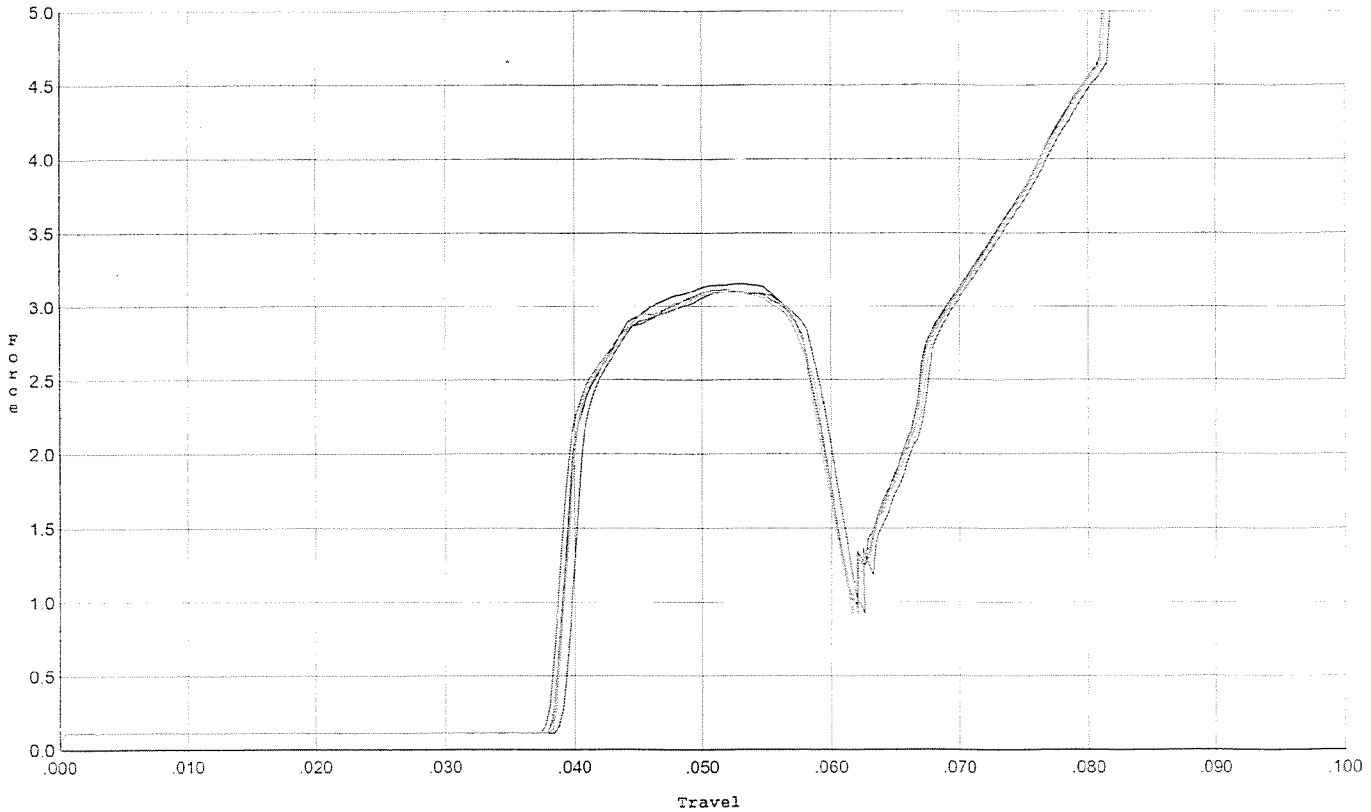
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.299	0.054	0.035	0.030	0.045		Set Trigger
2	2.380	0.055	0.035	0.030	0.047		Set Trigger
3	2.374	0.055	0.035	0.030	0.047		Set Trigger
4	2.377	0.055	0.035	0.030	0.046		Set Trigger
5	2.445	0.055	0.034	0.030	0.048		Set Trigger

Avg 2.37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 4/17/07

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



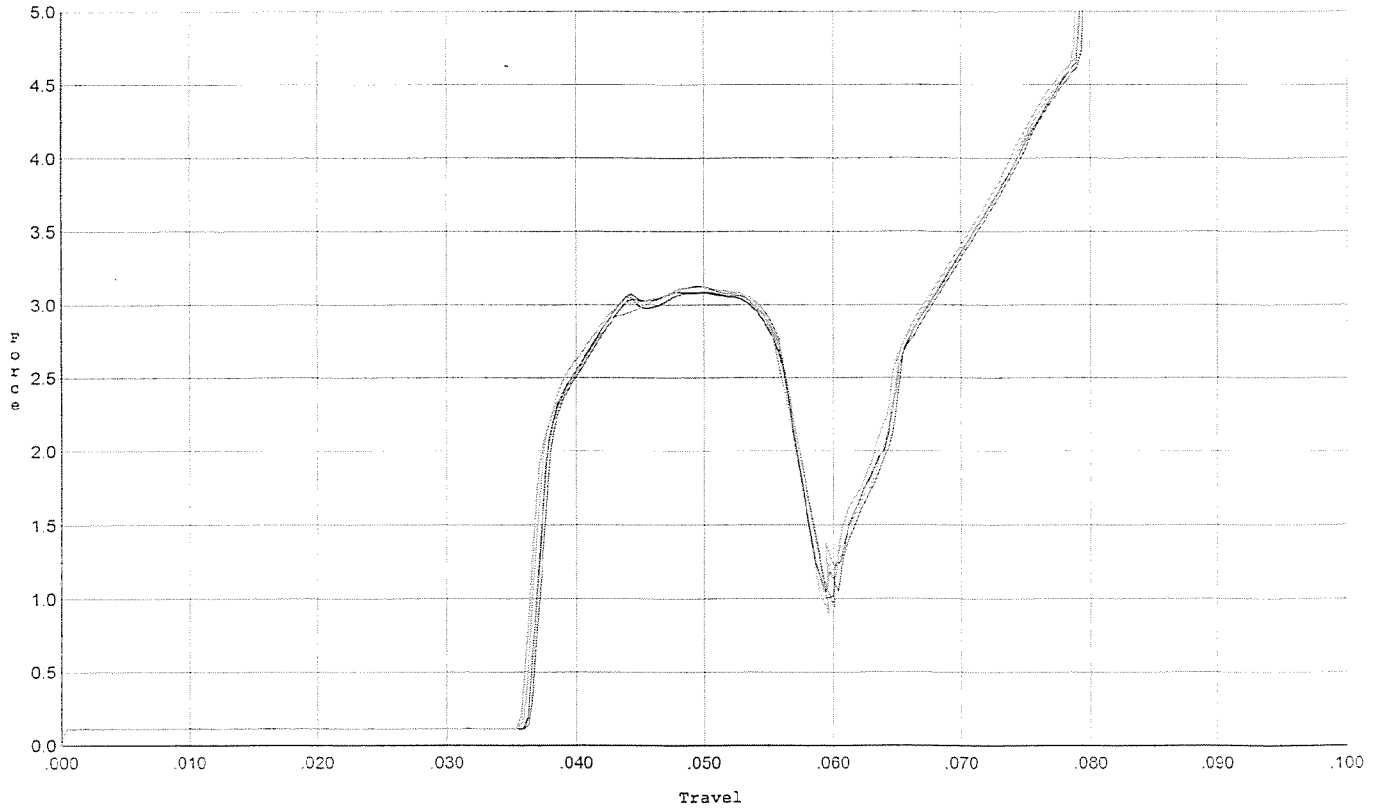
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.059	0.039	0.028	0.062		Set Trigger
2	3.154	0.059	0.038	0.028	0.063		Set Trigger
3	3.118	0.059	0.038	0.028	0.063		Set Trigger
4	3.097	0.059	0.039	0.028	0.062		Set Trigger
5	3.113	0.058	0.038	0.028	0.060		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



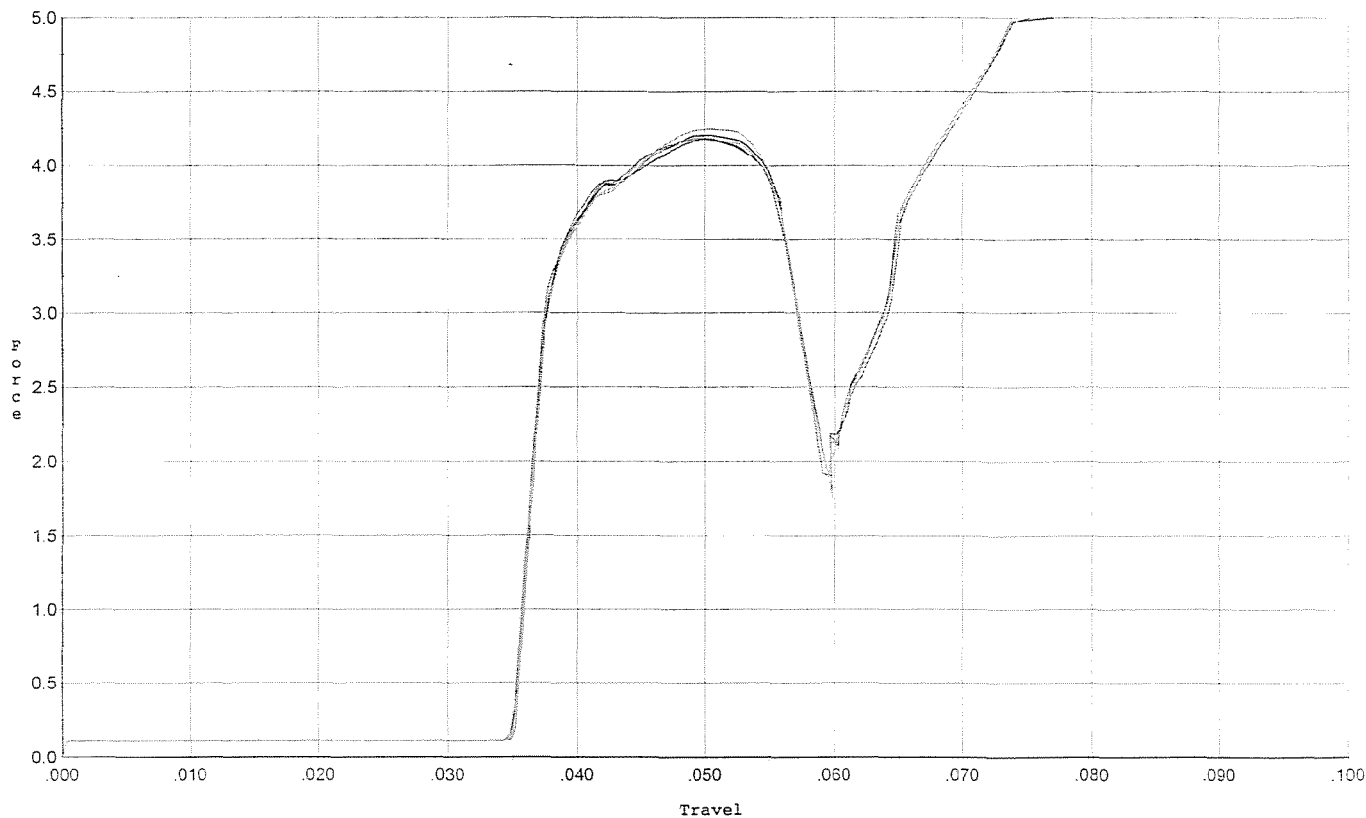
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.087	0.056	0.037	0.029	0.059		Set Trigger
2	3.085	0.056	0.036	0.029	0.060		Set Trigger
3	3.125	0.056	0.036	0.029	0.060		Set Trigger
4	3.121	0.056	0.036	0.029	0.061		Set Trigger
5	3.120	0.057	0.036	0.028	0.061		Set Trigger

AVG 3.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 4/17/07

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



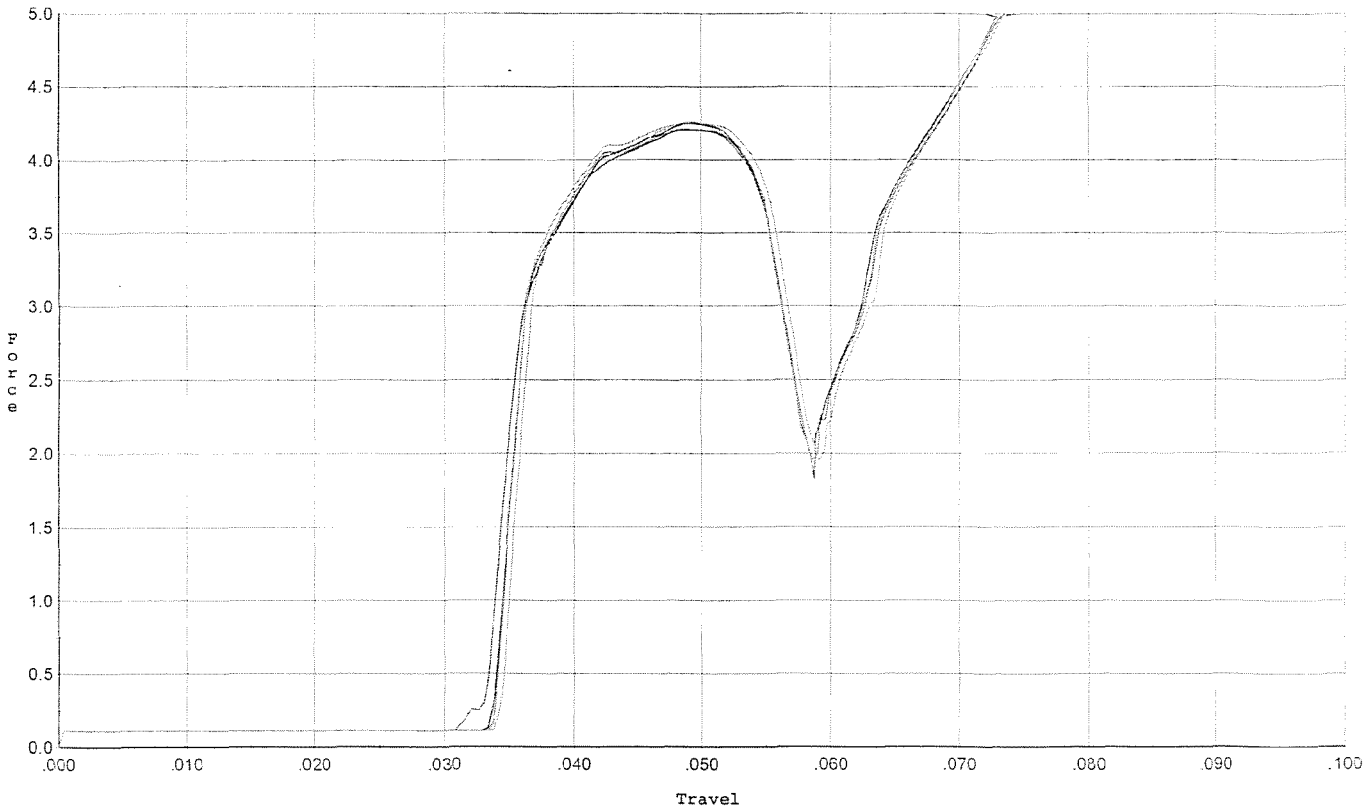
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.175	0.056	0.035	0.027	0.083		Set Trigger
2	4.204	0.056	0.035	0.027	0.083		Set Trigger
3	4.184	0.056	0.035	0.026	0.084		Set Trigger
4	4.247	0.056	0.035	0.027	0.083		Set Trigger
5	4.196	0.056	0.035	0.026	0.083		Set Trigger

Avg 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/17/07

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



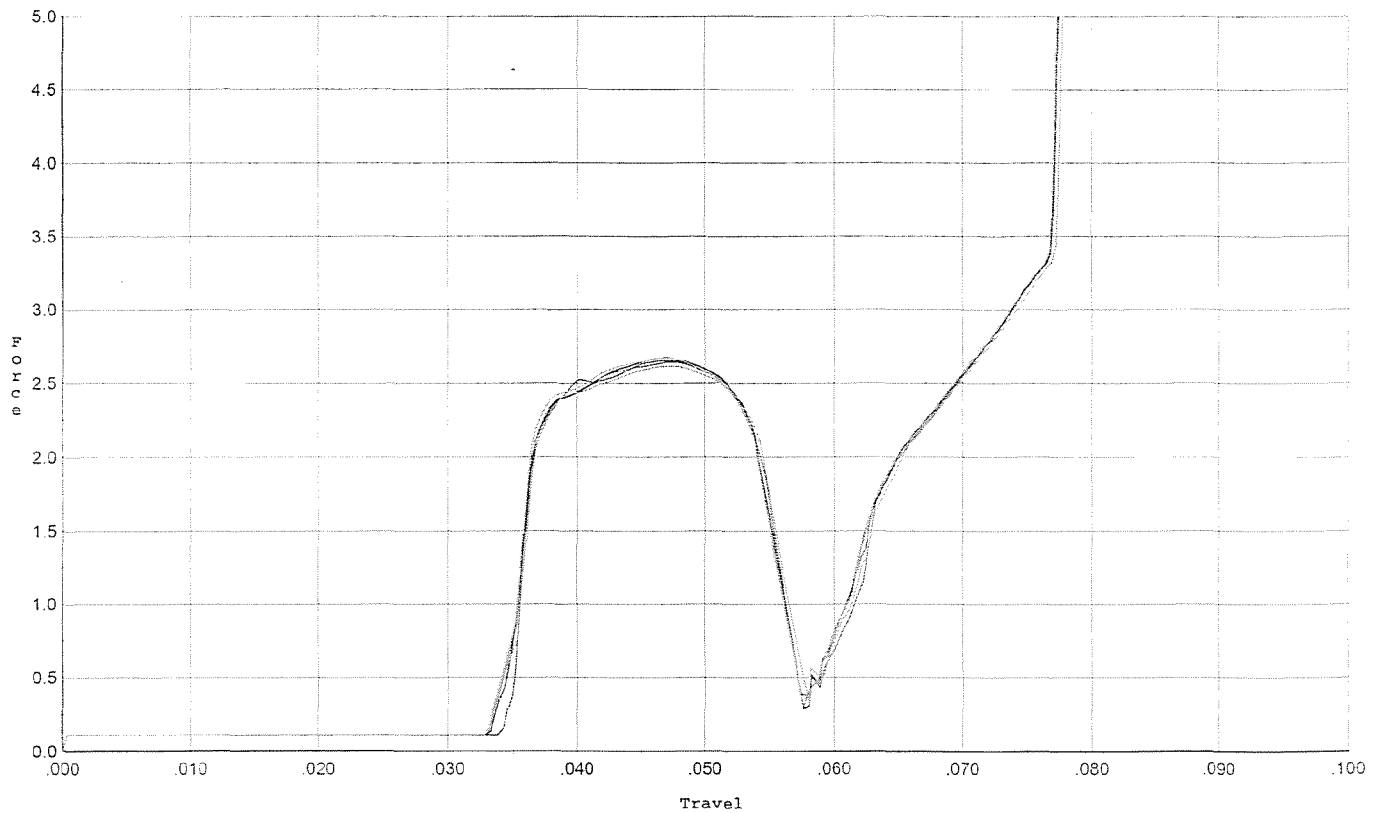
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.214	0.055	0.032	0.027	0.085		Set Trigger
2	4.251	0.055	0.034	0.026	0.084		Set Trigger
3	4.204	0.055	0.034	0.026	0.084		Set Trigger
4	4.251	0.055	0.034	0.026	0.085		Set Trigger
5	4.259	0.055	0.034	0.026	0.085		Set Trigger

Avg 4.23

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 4/17/07

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



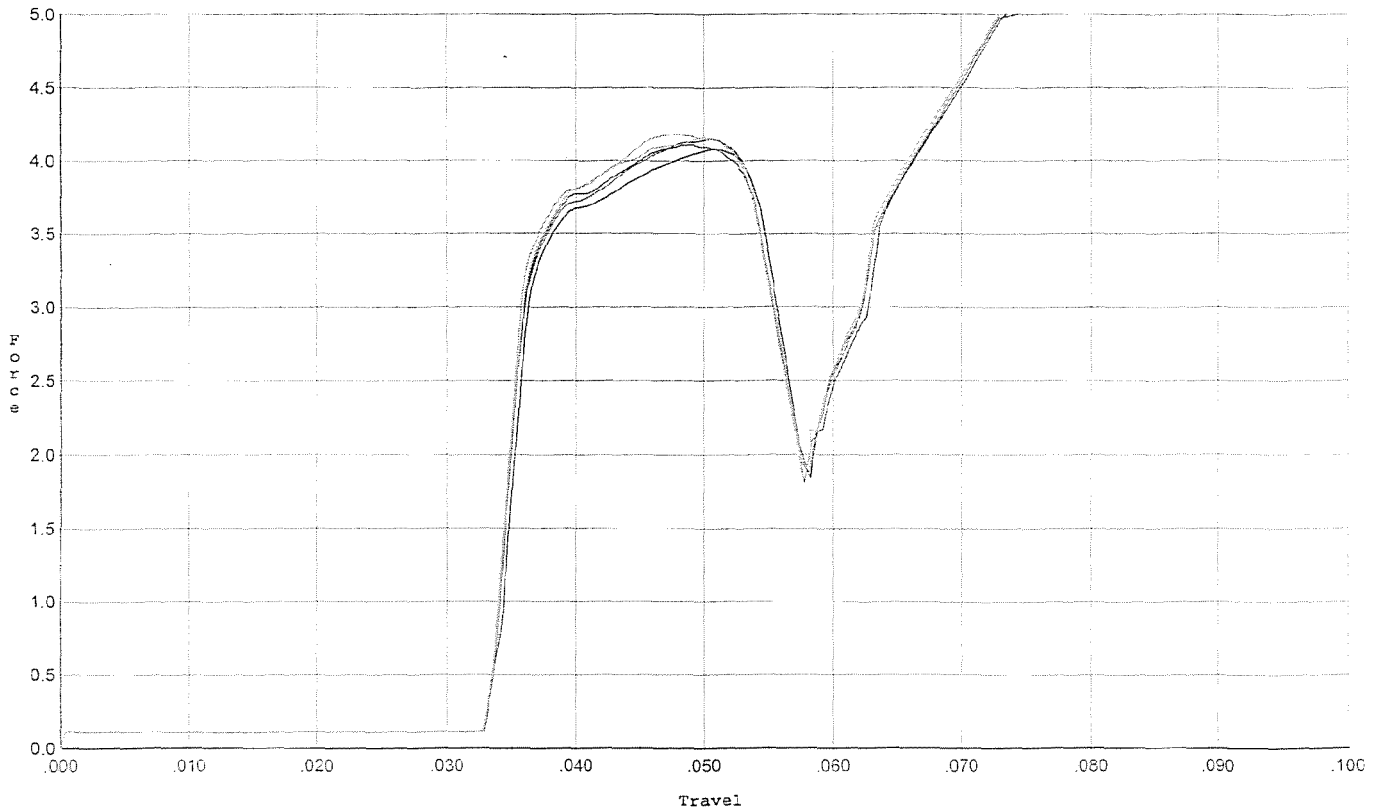
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.653	0.054	0.035	0.030	0.050		Set Trigger
2	2.670	0.055	0.034	0.029	0.052		Set Trigger
3	2.643	0.055	0.034	0.029	0.052		Set Trigger
4	2.668	0.055	0.033	0.029	0.053		Set Trigger
5	2.615	0.054	0.034	0.030	0.051		Set Trigger

AVG 2.65

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/17/07

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	4.150	0.054	0.033	0.027	0.080		Set Trigger
2	4.082	0.054	0.033	0.027	0.080		Set Trigger
3	4.109	0.054	0.033	0.027	0.080		Set Trigger
4	4.180	0.054	0.033	0.027	0.081		Set Trigger
5	4.161	0.055	0.033	0.026	0.085		Set Trigger

AVG 4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6635165.__0

FILE DATE AND TIME: 04/18/2007 11:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

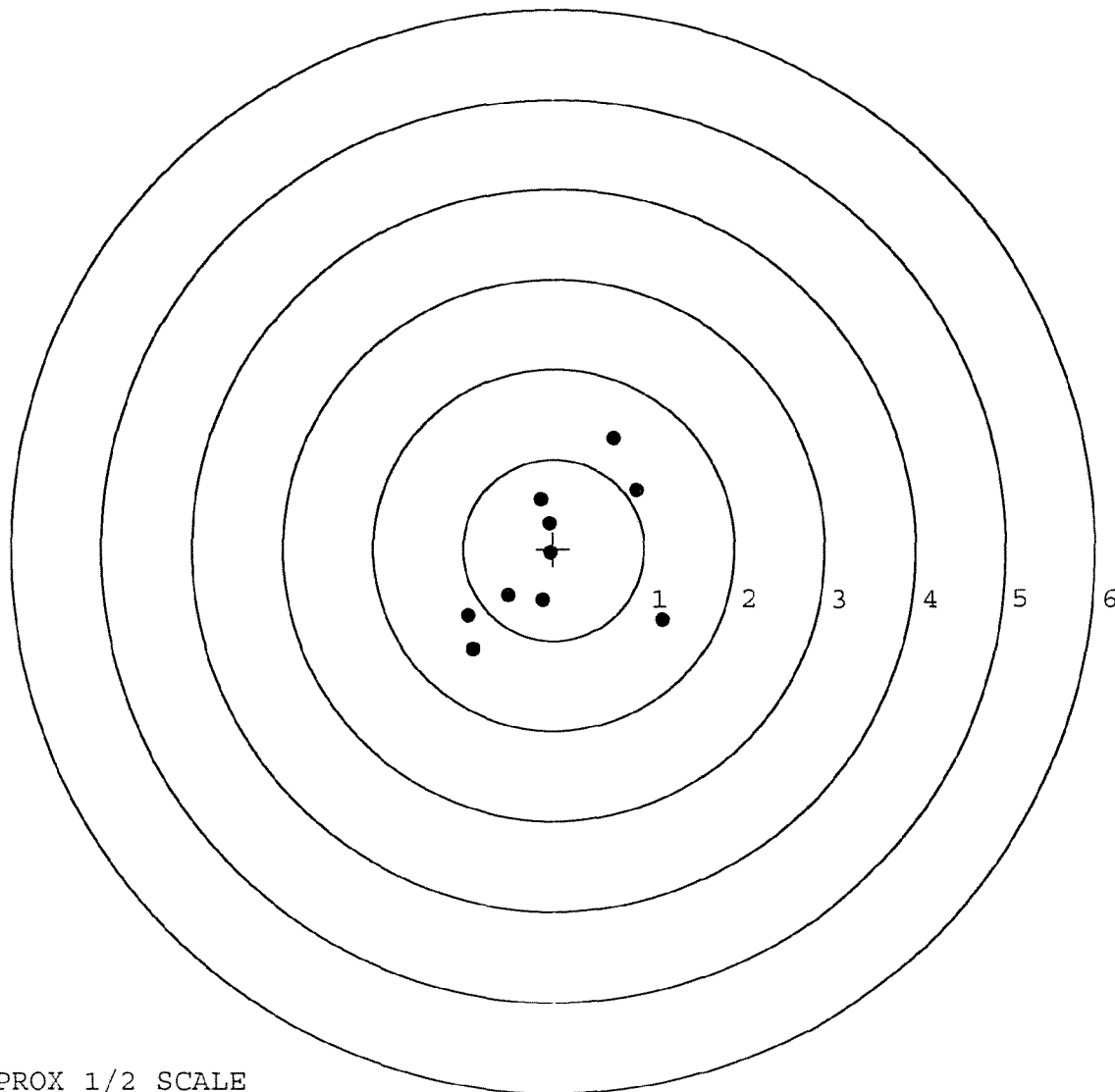
The Average X Centroid of the Five Target Set:	0.020
The Average Y Centroid of the Five Target Set:	0.008
The Average Point of Impact of the Five Target Set:	0.021
The Average Mean Radius of the Five Target Set:	0.631
The Distance from POA to Centroid Target #1:	0.102
The Distance from Centroid Target #2 to Centroid Target #1:	0.294
The Distance from Centroid Target #3 to Centroid Target #1:	0.164
The Distance from Centroid Target #4 to Centroid Target #1:	0.154
The Distance from Centroid Target #5 to Centroid Target #1:	0.099

BARBER - M24 0142881

SERIAL NUMBER: G6635165. __0
 TARGET NUMBER: 1
 FILE DATE: 04/18/2007
 FILE TIME: 11:22

POINT#	X	Y
1:	1.196	-0.781
2:	0.914	0.653
3:	0.668	1.233
4:	-0.144	0.548
5:	-0.047	0.281
6:	-0.036	-0.044
7:	-0.123	-0.563
8:	-0.500	-0.508
9:	-0.949	-0.737
10:	-0.887	-1.102

X CENTROID: 0.009
 Y CENTROID: -0.102
 POA TO CENTROID: 0.102
 HORZ SPREAD: 2.145
 VERT SPREAD: 2.335
 GROUP SPREAD: 2.805
 MIN RADIUS: 0.074
 MAX RADIUS: 1.489
 MEAN RADIUS: 0.879
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0142882

SERIAL NUMBER: G6635165. __ 0

TARGET NUMBER: 2

FILE DATE: 04/18/2007

FILE TIME: 11:22

POINT#	X	Y
1:	1.547	0.370
2:	0.938	0.312
3:	0.102	-0.790
4:	-0.092	-0.580
5:	-0.685	-0.442
6:	0.343	0.102
7:	0.020	0.248
8:	-0.556	0.637
9:	-0.241	0.851
10:	-0.848	1.182

X CENTROID: 0.053

Y CENTROID: 0.189

POA TO CENTROID: 0.196

HORZ SPREAD: 2.395

VERT SPREAD: 1.972

GROUP SPREAD: 2.529

MIN RADIUS: 0.068

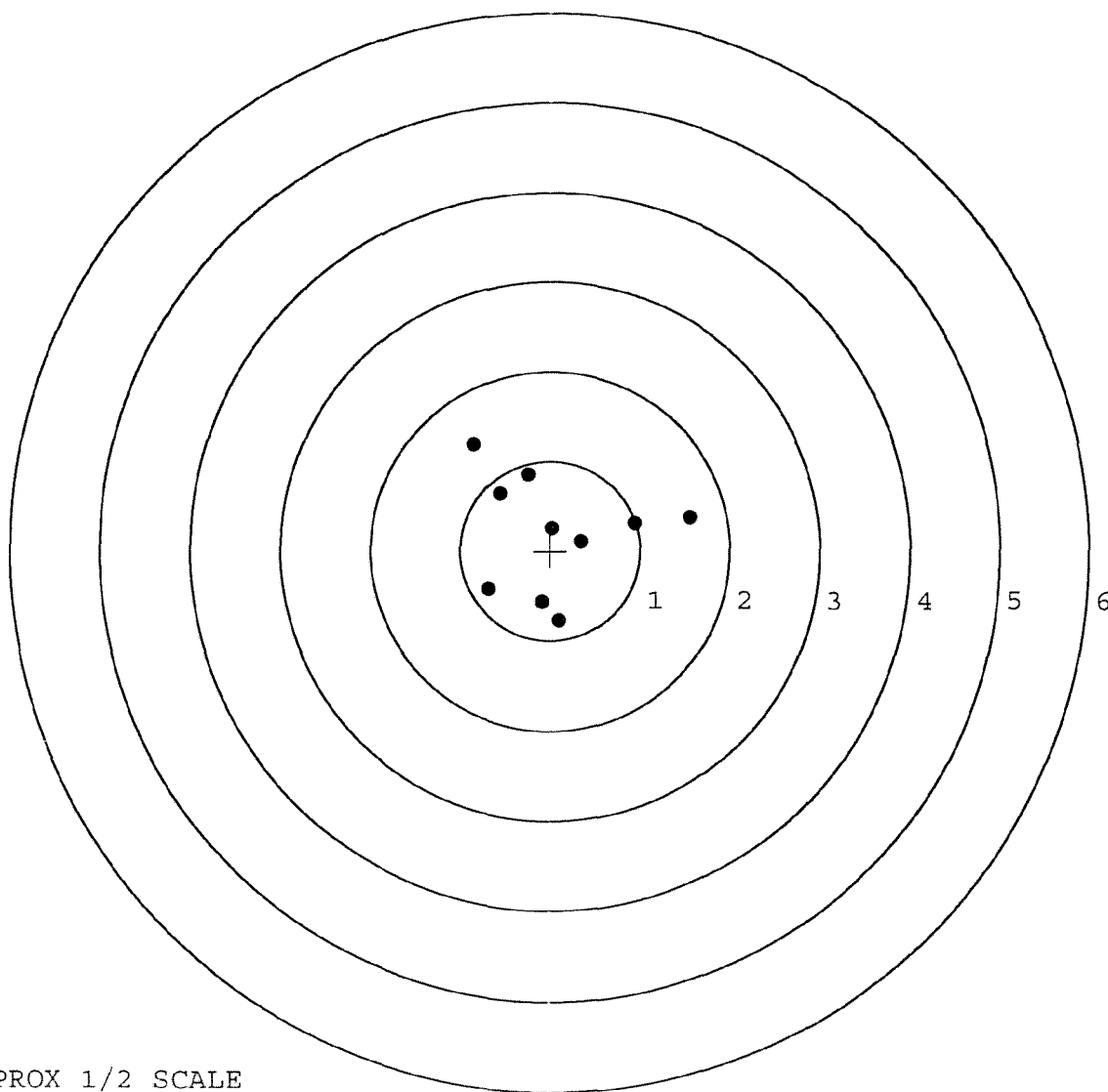
MAX RADIUS: 1.505

MEAN RADIUS: 0.832

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0142883

SERIAL NUMBER: G6635165. __0

TARGET NUMBER: 3

FILE DATE: 04/18/2007

FILE TIME: 11:22

POINT#	X	Y
1:	0.603	1.101
2:	0.436	-0.261
3:	0.035	-0.501
4:	-0.118	-0.313
5:	0.168	-0.073
6:	-0.204	-0.052
7:	0.129	0.116
8:	-0.135	0.306
9:	-0.435	0.158
10:	-0.071	0.107

X CENTROID: 0.041

Y CENTROID: 0.059

POA TO CENTROID: 0.072

HORZ SPREAD: 1.038

VERT SPREAD: 1.602

GROUP SPREAD: 1.700

MIN RADIUS: 0.105

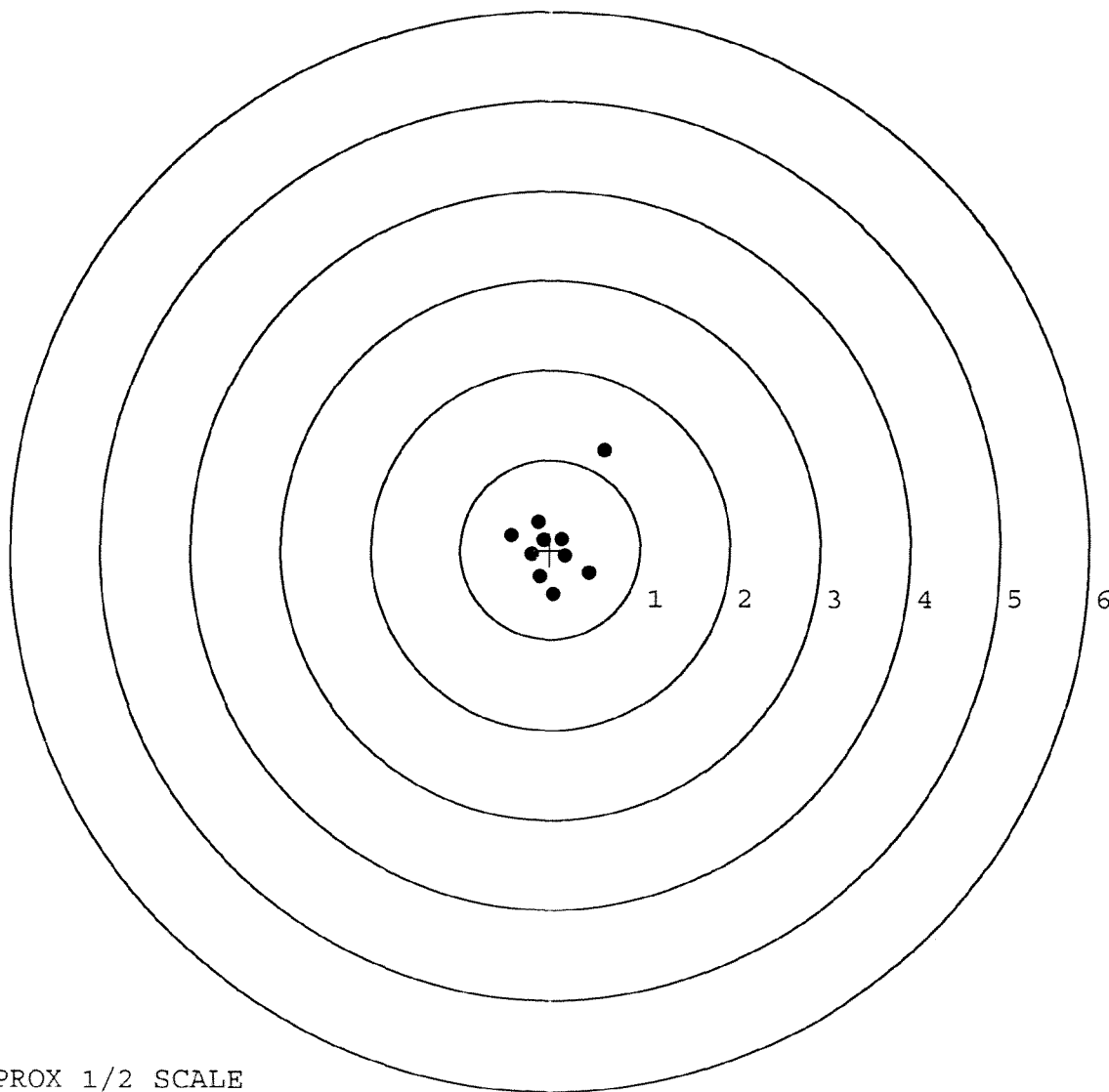
MAX RADIUS: 1.184

MEAN RADIUS: 0.412

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635165. __0

TARGET NUMBER: 4

FILE DATE: 04/18/2007

FILE TIME: 11:22

POINT#	X	Y
1:	-0.089	-1.056
2:	-0.018	-0.635
3:	0.140	-0.293
4:	0.568	0.022
5:	0.296	0.541
6:	-0.561	1.065
7:	-0.265	0.219
8:	-0.323	-0.007
9:	-0.440	-0.118
10:	-0.436	0.189

X CENTROID: -0.113

Y CENTROID: -0.007

POA TO CENTROID: 0.113

HORZ SPREAD: 1.129

VERT SPREAD: 2.121

GROUP SPREAD: 2.173

MIN RADIUS: 0.210

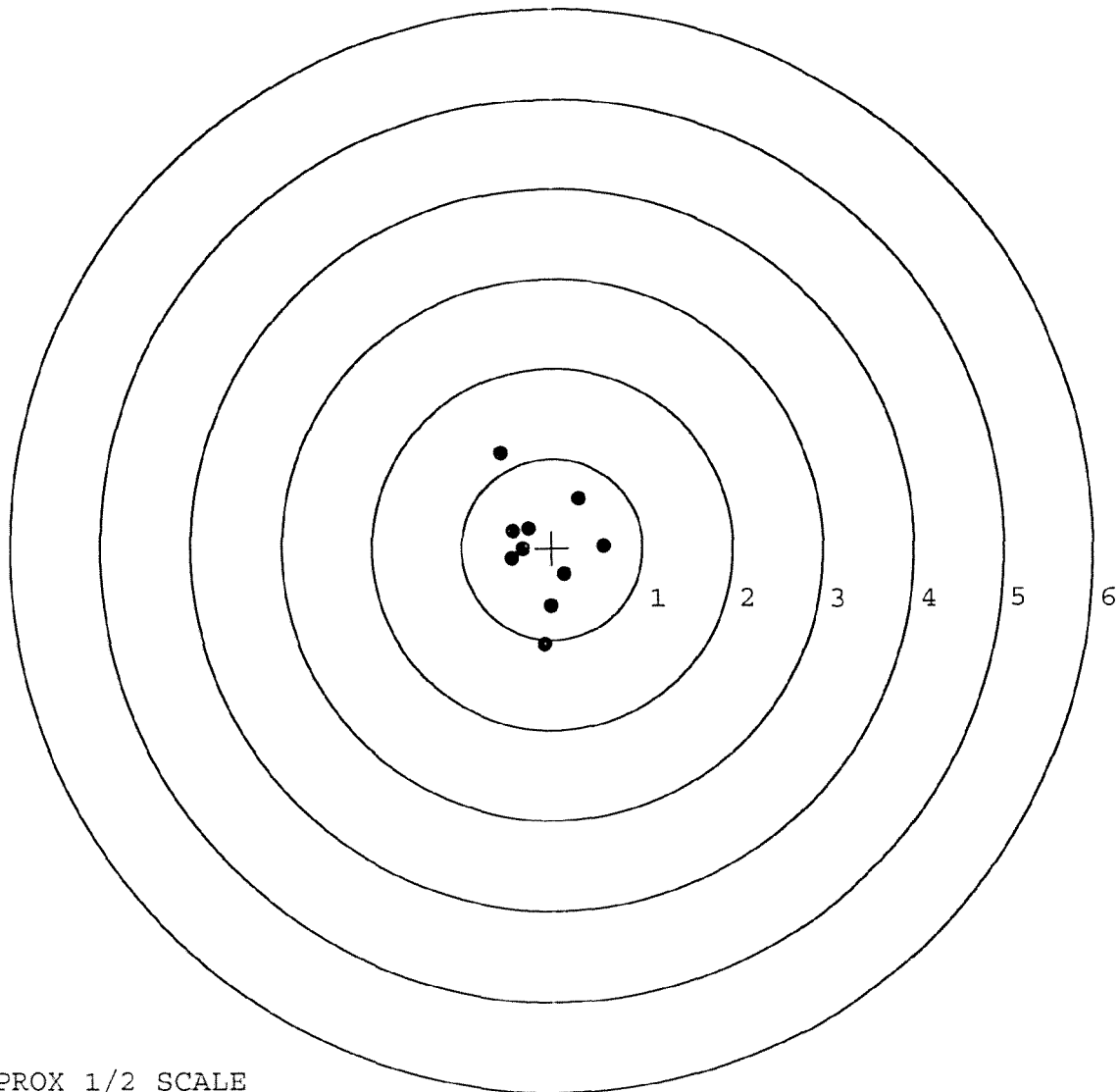
MAX RADIUS: 1.162

MEAN RADIUS: 0.580

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0142885

SERIAL NUMBER: G6635165. 0

TARGET NUMBER: 5

FILE DATE: 04/18/2007

FILE TIME: 11:22

POINT#	X	Y
1:	-0.039	-0.909
2:	0.056	-0.589
3:	0.513	0.848
4:	-0.433	0.366
5:	0.556	-0.219
6:	0.283	-0.017
7:	0.042	0.043
8:	-0.267	-0.182
9:	0.064	-0.157
10:	0.302	-0.150

X CENTROID: 0.108

Y CENTROID: -0.097

POA TO CENTROID: 0.145

HORZ SPREAD: 0.989

VERT SPREAD: 1.757

GROUP SPREAD: 1.842

MIN RADIUS: 0.075

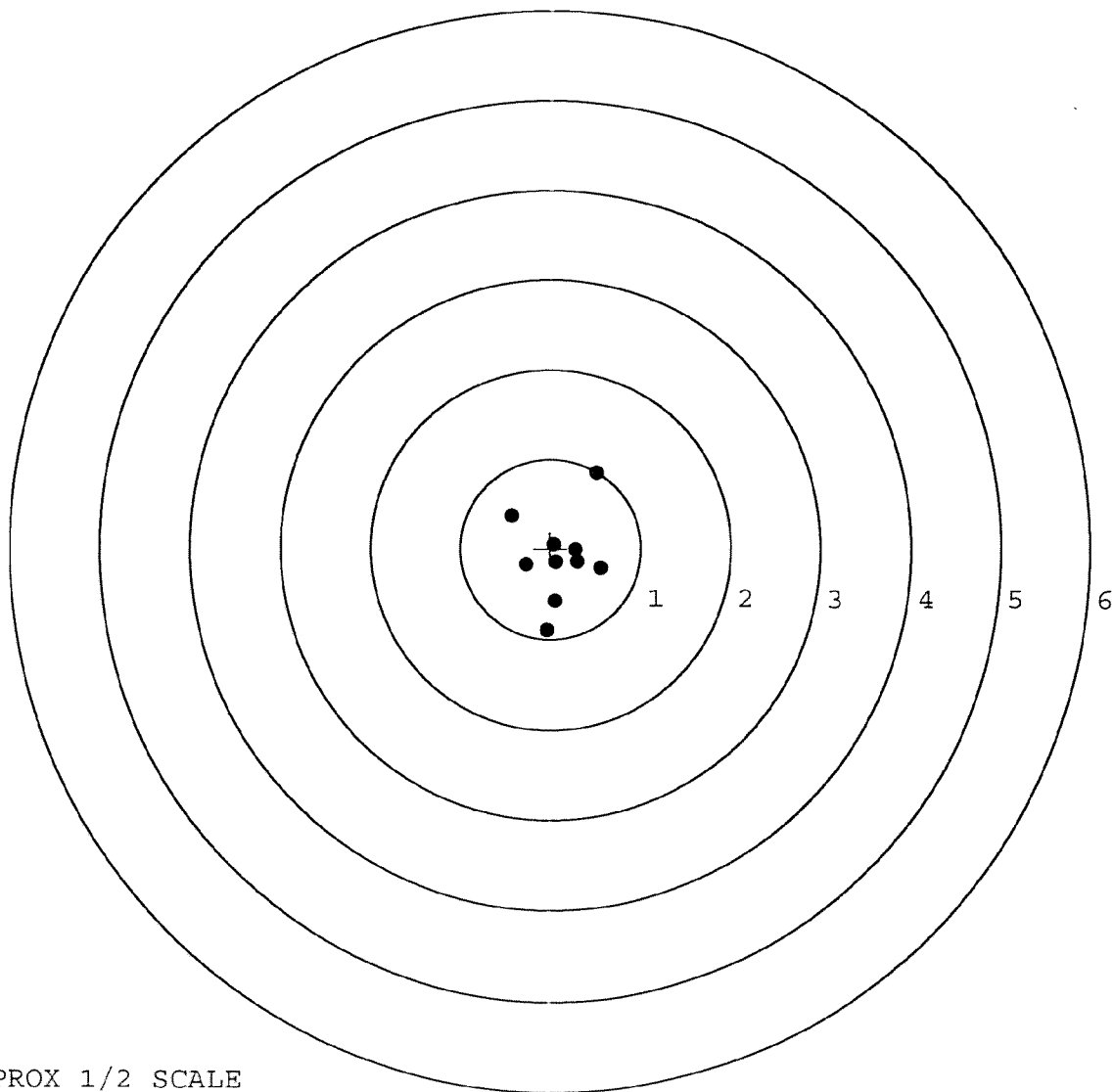
MAX RADIUS: 1.028

MEAN RADIUS: 0.453

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE