

G 663 5213

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

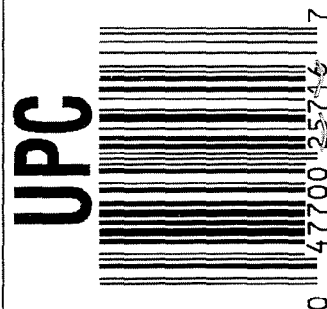
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6635213



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



SERIAL NO.



GUN SERIAL # G6635213

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		3-12-07	SPD
430	ASSEMBLE TO STOCK		3-12-07	SPD
440	PROOF		3-14-07	Fm
460	CHECK HEADSPACE	INSPECTED	3-14-07	Fm
470	DIS-ASSEMBLE ACTION	MAR 16 2007	3-15-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <i>mmg</i>	3/16/07	<i>mmg</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-16-07	CW
510	DRILL AND TAP SIGHT HOLES		3-16-07	TRW
520	GOFF BLAST BBL / REC		3-17-07	JB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		3-29-07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/4/07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/4/07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/4/07	SPD
	D) OIL FIRING PIN ASSEMBLY		4/4/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/4/07	<i>mmg</i>
F004 REV 5/2006				

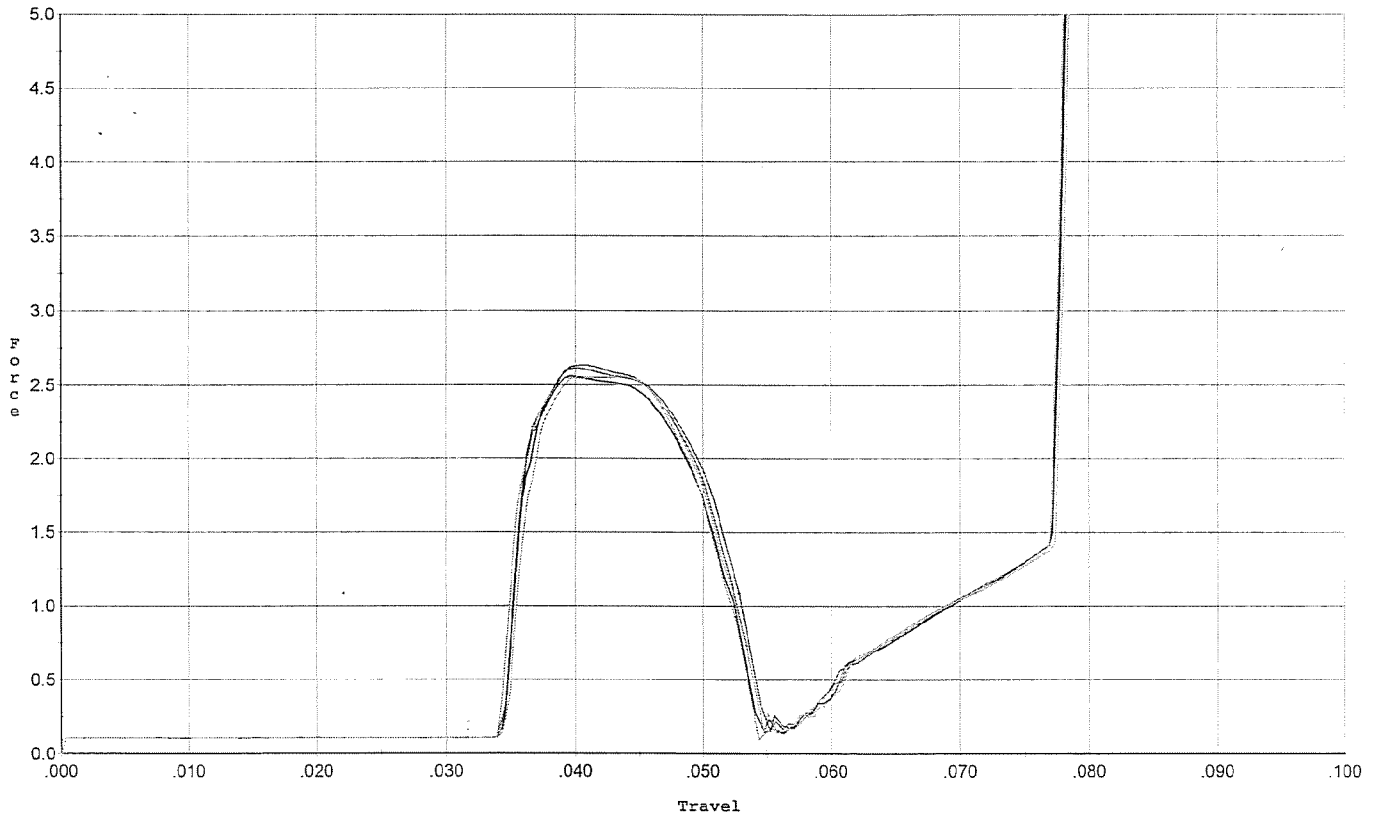
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.0</u> <u>8.25</u>	4-9-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.25</u> <u>3.5</u> <u>3.25</u>	4-9-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		4/9/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.024</u> <u>.0245</u>	4-9-07	TRW
	J) ASSEMBLE STOCK		4/4/07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4/9/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/9/07	non
	M) IRON SIGHT ALIGNMENT		4/9/07	non
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/9/07	non
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	4-9-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-9-07	Fm
670	FINAL INSPECTION A) HEADSPACE		4/9/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.09</u> <u>2.63</u> <u>2.63</u> <u>2.21</u>	4-9-07	TRW
	C) FUNCTION		4/9/07	non
690	PACK		4-12-07	DA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/03/07

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



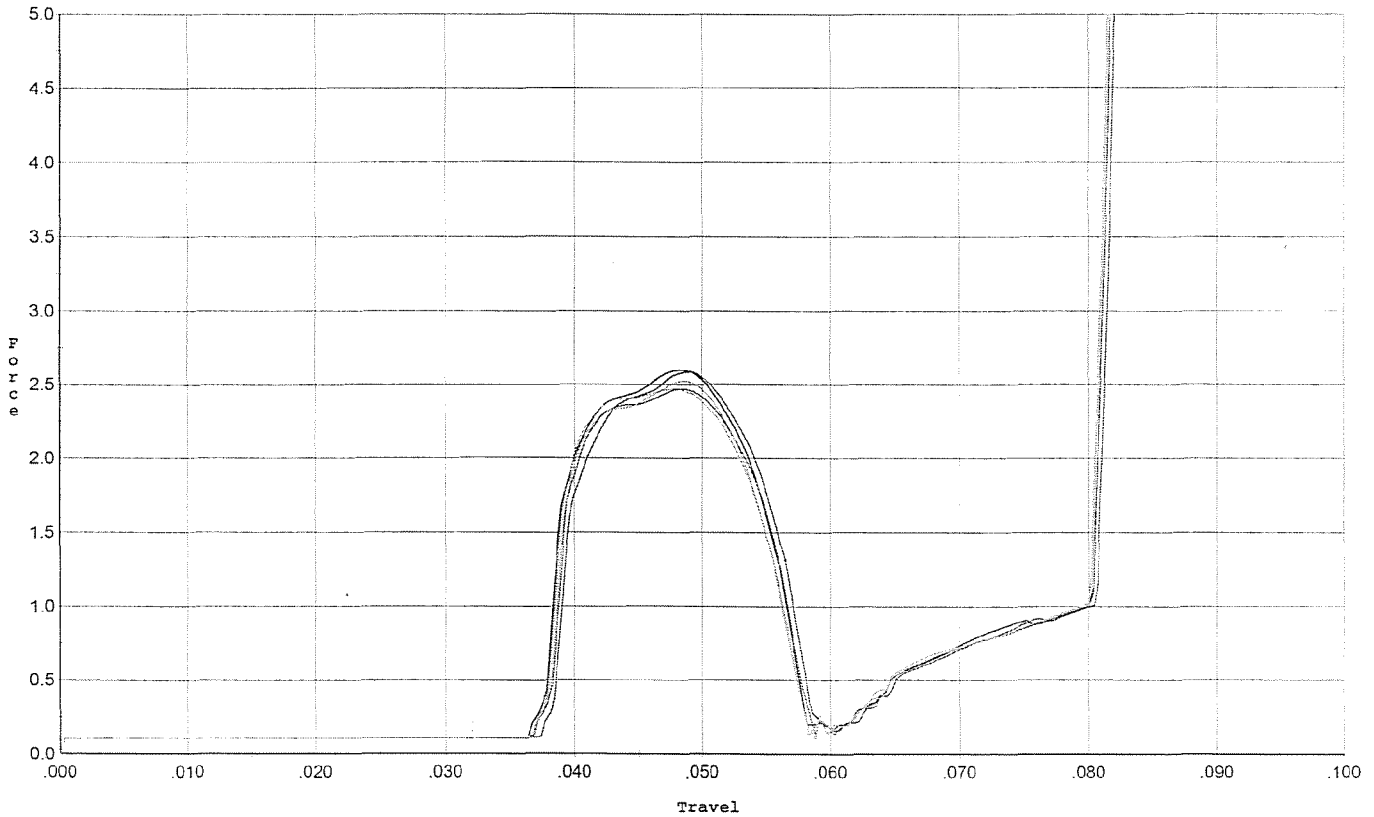
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.633	0.053	0.034	0.033	0.043		Set Trigger
2	2.561	0.052	0.035	0.034	0.041		Set Trigger
3	2.615	0.053	0.034	0.033	0.043		Set Trigger
4	2.559	0.053	0.035	0.033	0.042		Set Trigger
5	2.564	0.053	0.034	0.033	0.042		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/03/07

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



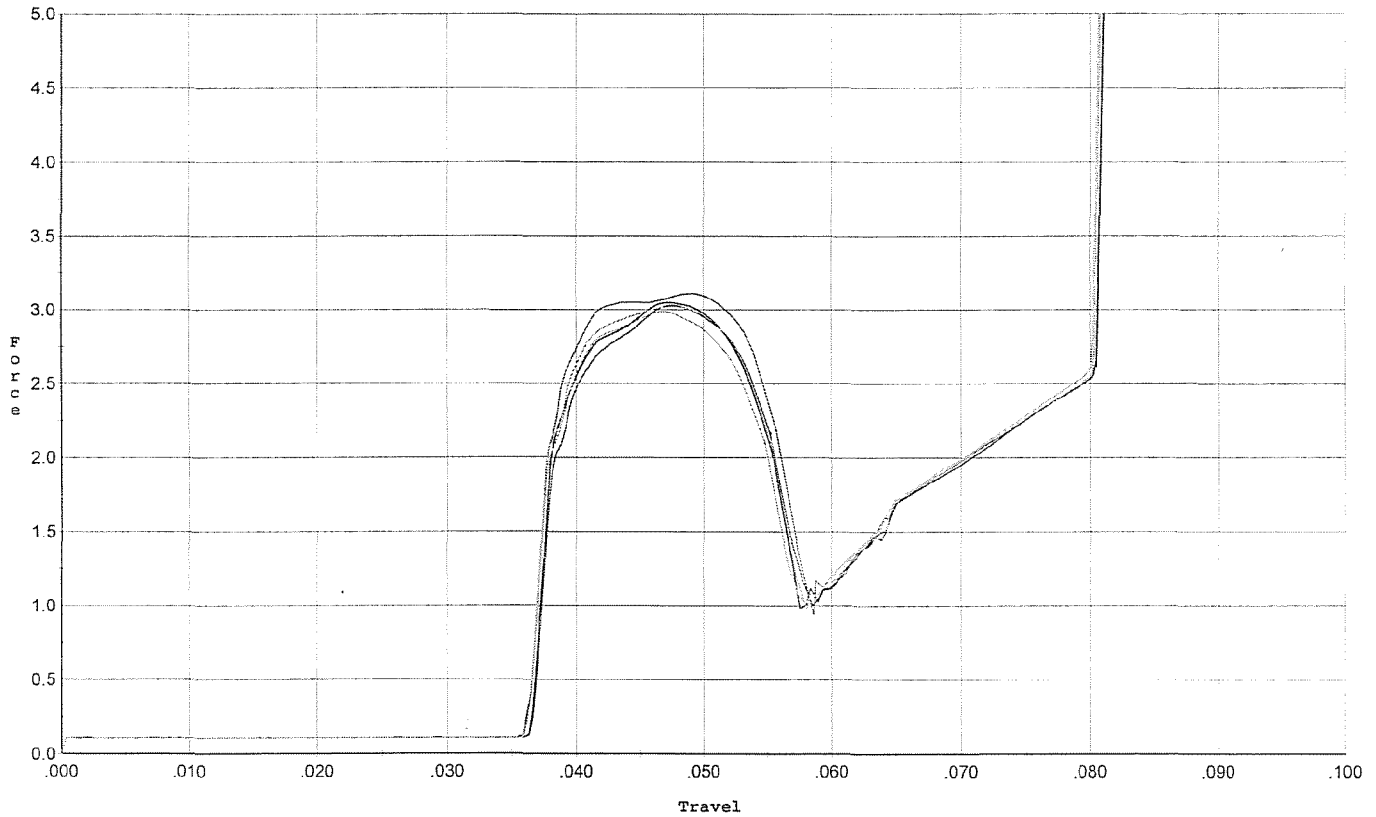
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.056	0.038	0.033	0.043		Set Trigger
2	2.599	0.056	0.037	0.033	0.044		Set Trigger
3	2.472	0.056	0.037	0.033	0.042		Set Trigger
4	2.524	0.055	0.037	0.034	0.042		Set Trigger
5	2.472	0.057	0.037	0.033	0.043		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Puch 4/03/07

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



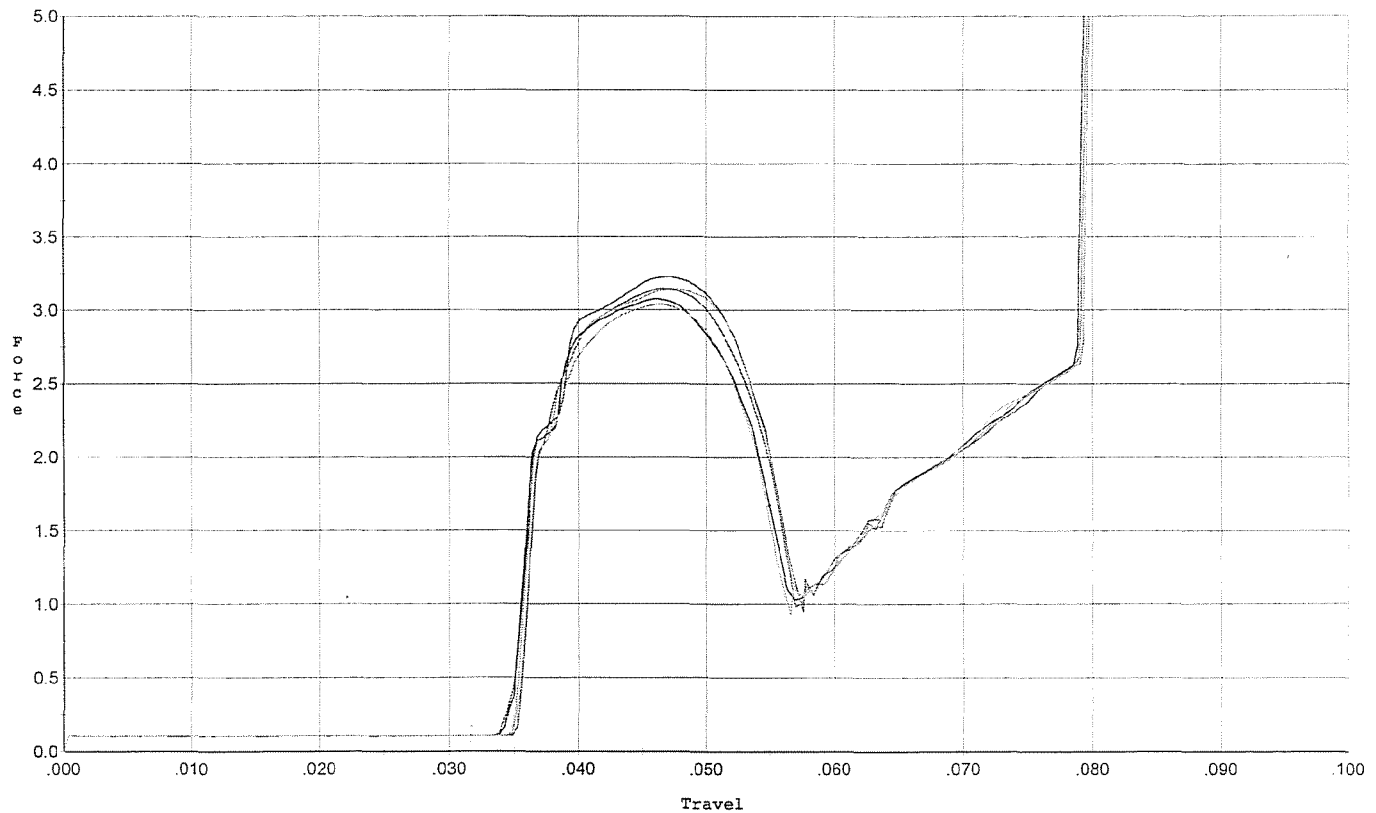
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.055	0.037	0.032	0.053		Set Trigger
2	3.050	0.055	0.037	0.032	0.054		Set Trigger
3	3.111	0.056	0.036	0.031	0.058		Set Trigger
4	3.020	0.055	0.036	0.032	0.055		Set Trigger
5	2.988	0.055	0.036	0.032	0.052		Set Trigger

AVG 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/03/07

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



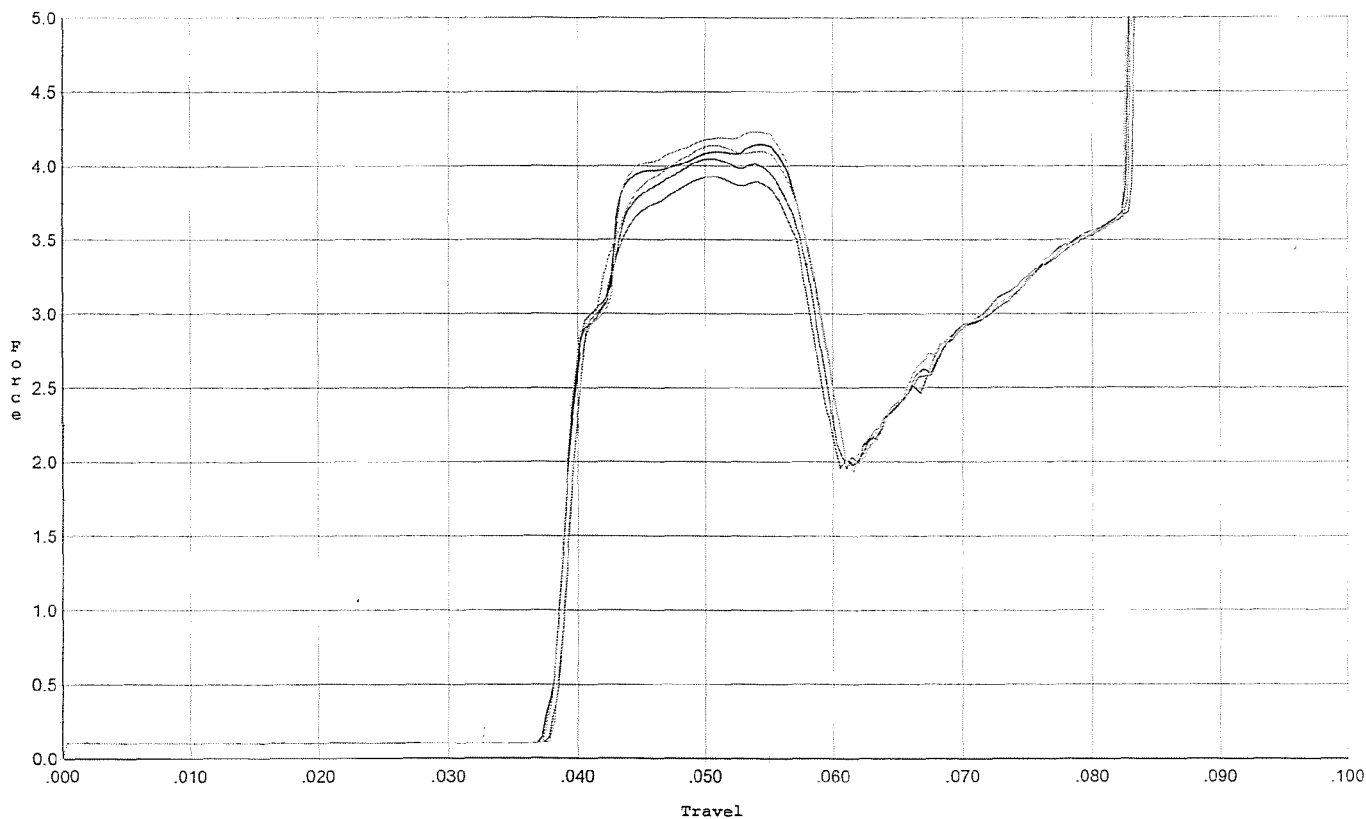
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.055	0.034	0.031	0.059		Set Trigger
2	3.074	0.055	0.034	0.031	0.056		Set Trigger
3	3.145	0.055	0.035	0.031	0.057		Set Trigger
4	3.039	0.054	0.035	0.032	0.053		Set Trigger
5	3.143	0.055	0.035	0.031	0.057		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/03/07

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



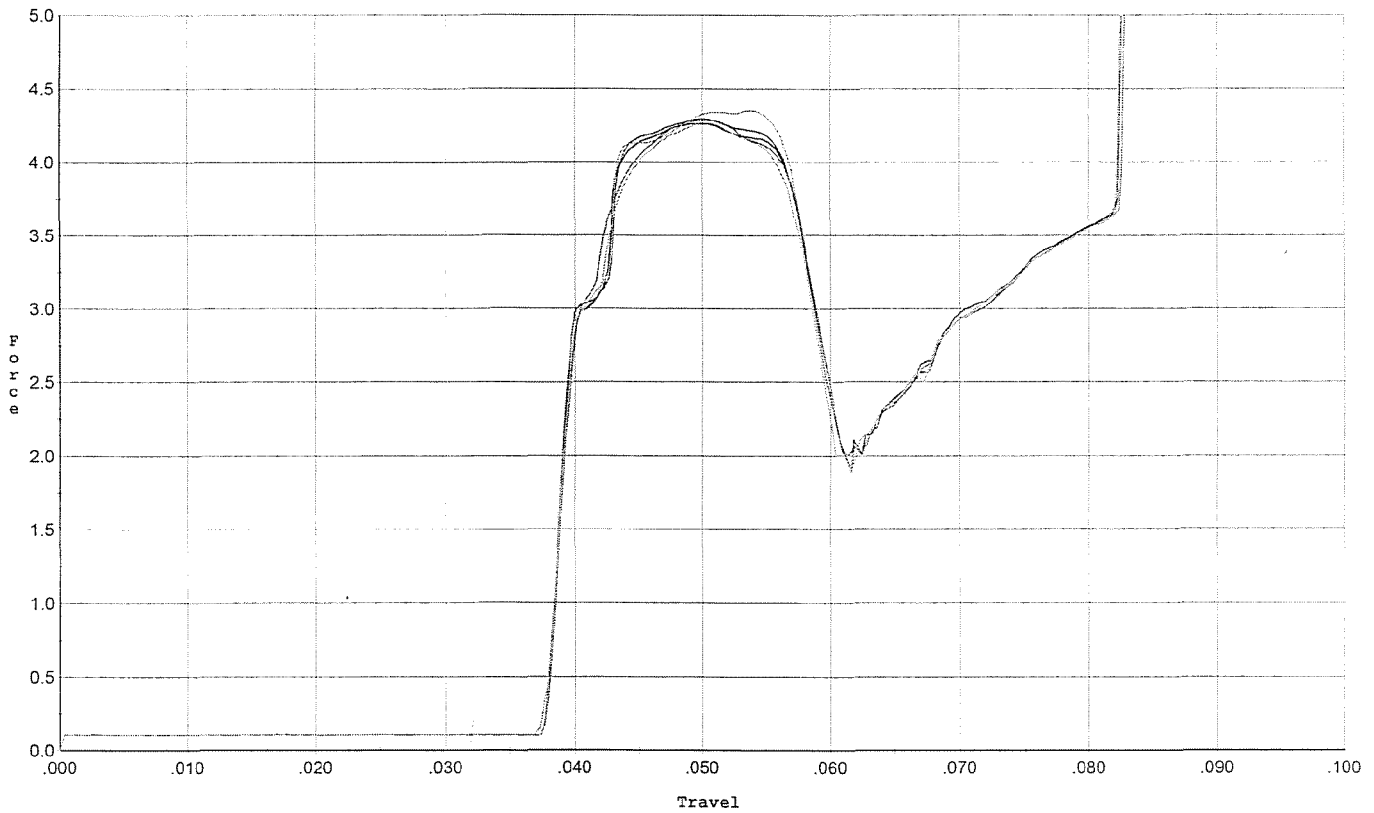
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.048	0.058	0.038	0.029	0.077		Set Trigger
2	4.148	0.059	0.038	0.029	0.081		Set Trigger
3	3.927	0.057	0.038	0.030	0.072		Set Trigger
4	4.233	0.059	0.038	0.029	0.082		Set Trigger
5	4.139	0.059	0.038	0.029	0.079		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Patch 4/03/07

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



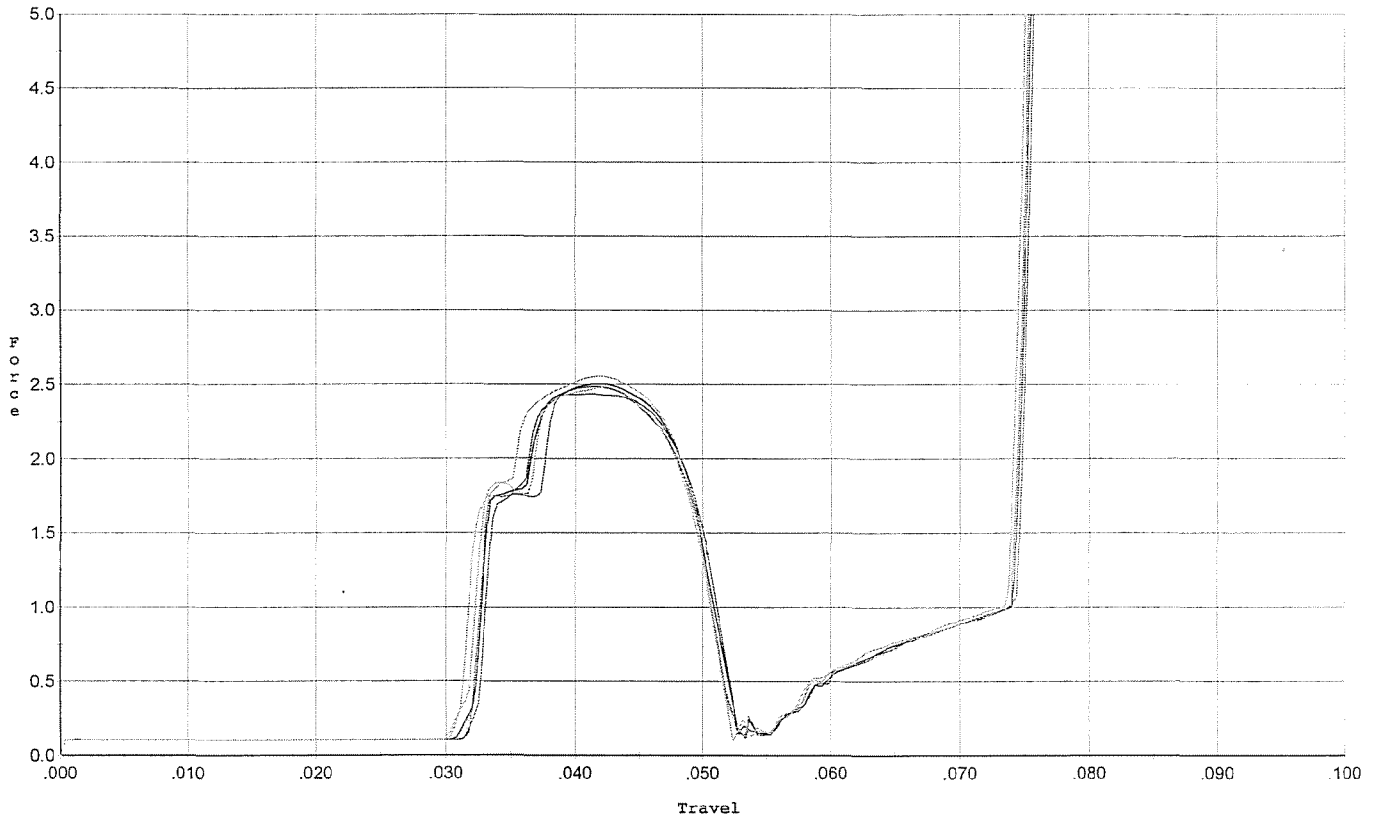
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.295	0.057	0.038	0.029	0.081		Set Trigger
2	4.263	0.057	0.038	0.029	0.080		Set Trigger
3	4.284	0.059	0.038	0.029	0.083		Set Trigger
4	4.271	0.058	0.038	0.029	0.080		Set Trigger
5	4.352	0.057	0.038	0.029	0.081		Set Trigger

Avg 4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/03/07

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	2.483	0.050	0.032	0.032	0.041		Set Trigger
2	2.501	0.050	0.031	0.032	0.041		Set Trigger
3	2.436	0.050	0.032	0.032	0.040		Set Trigger
4	2.482	0.050	0.031	0.032	0.042		Set Trigger
5	2.557	0.050	0.031	0.031	0.044		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile

GunType:

Make:

Note:

SWS

Rifle

Remington

R. Putch 4/03/07

Model:

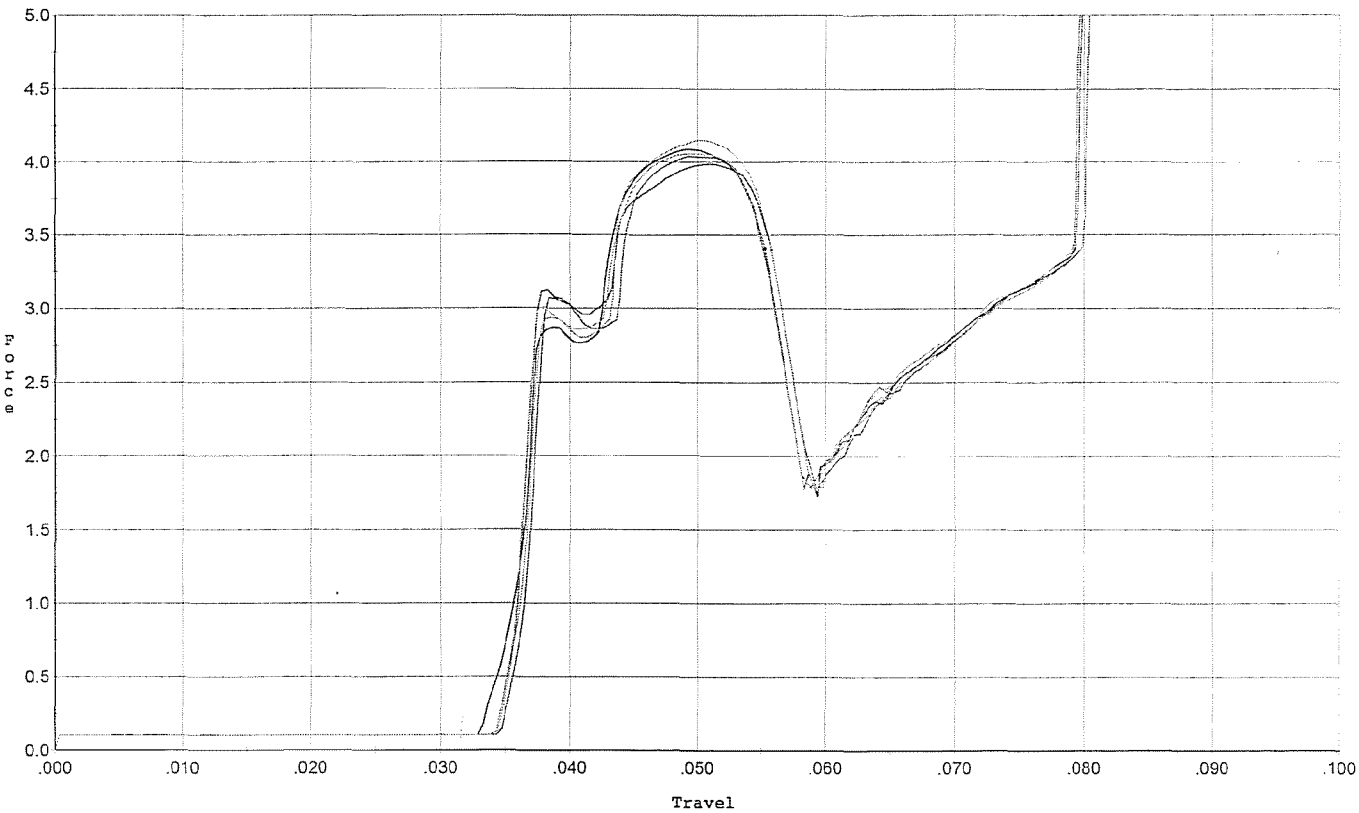
Serial No:

Trigger:

M/24

Form #F005

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	3.987	0.056	0.035	0.029	0.074		Set Trigger
2	4.083	0.056	0.033	0.029	0.075		Set Trigger
3	4.039	0.055	0.035	0.029	0.074		Set Trigger
4	4.058	0.056	0.035	0.029	0.075		Set Trigger
5	4.150	0.056	0.035	0.029	0.076		Set Trigger

AVG 4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6635213.___0

FILE DATE AND TIME: 04/09/2007 12:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.055
The Average Y Centroid of the Five Target Set:	-0.021
The Average Point of Impact of the Five Target Set:	0.059
The Average Mean Radius of the Five Target Set:	0.640
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.071
The Distance from Centroid Target #3 to Centroid Target #1:	0.214
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.046

BARBER - M24 0143744

SERIAL NUMBER: G6635213. __0

TARGET NUMBER: 1

FILE DATE: 04/09/2007

FILE TIME: 12:24

POINT#	X	Y
1:	0.131	-0.908
2:	-0.541	-0.775
3:	-0.732	-0.566
4:	-0.120	-0.314
5:	0.289	0.164
6:	0.294	0.417
7:	-0.127	0.565
8:	-0.319	0.122
9:	-0.035	0.188
10:	0.121	0.388

X CENTROID: -0.104

Y CENTROID: -0.072

POA TO CENTROID: 0.126

HORZ SPREAD: 1.026

VERT SPREAD: 1.473

GROUP SPREAD: 1.495

MIN RADIUS: 0.243

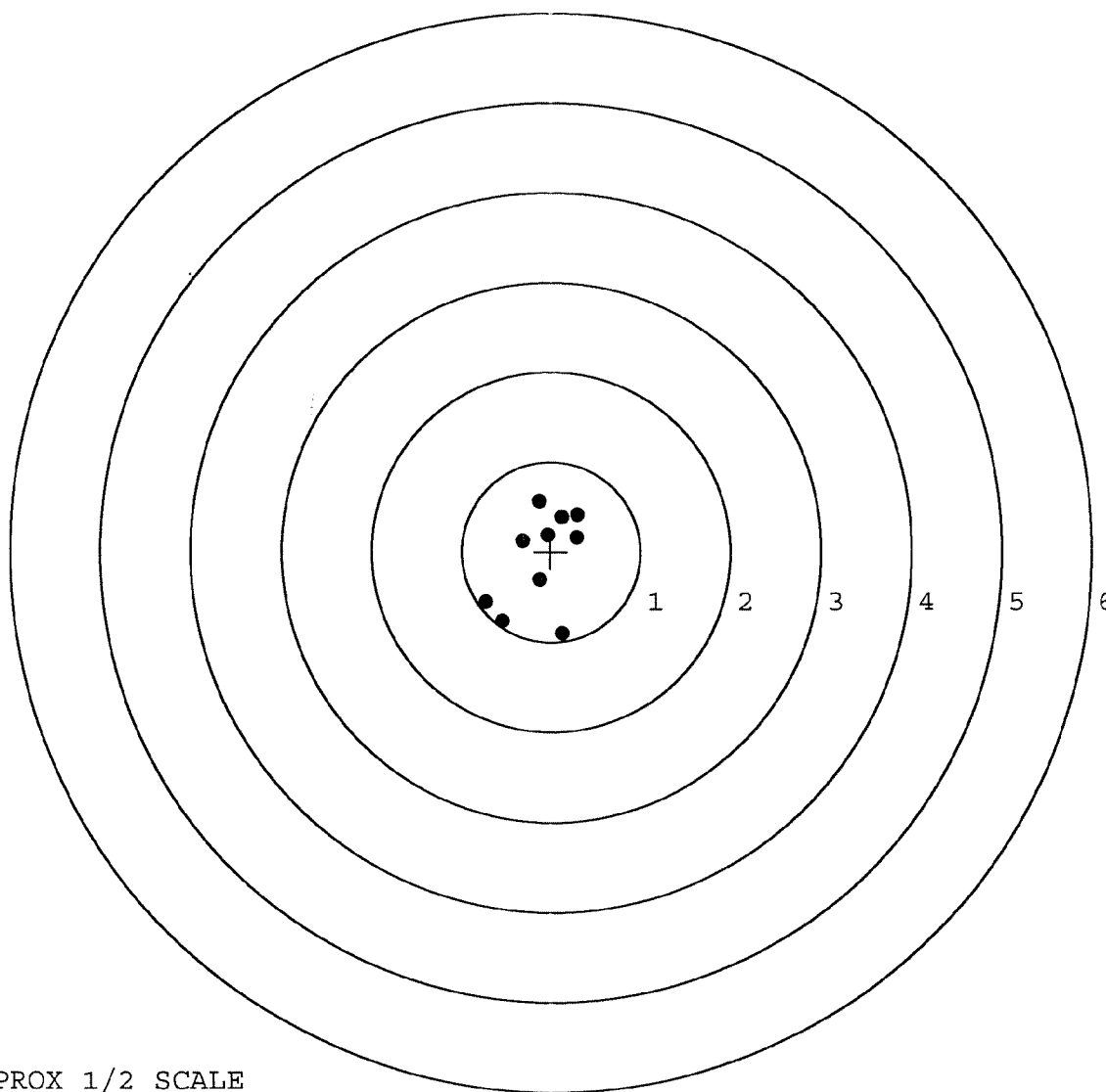
MAX RADIUS: 0.868

MEAN RADIUS: 0.553

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0143745

SERIAL NUMBER: G6635213. __0

TARGET NUMBER: 2

FILE DATE: 04/09/2007

FILE TIME: 12:24

POINT#	X	Y
1:	0.803	0.093
2:	0.211	-0.452
3:	-0.414	-0.484
4:	-0.128	-0.332
5:	0.032	-0.080
6:	-0.702	0.214
7:	-0.927	0.352
8:	-0.031	0.398
9:	-0.060	0.130
10:	0.099	0.146

X CENTROID: -0.112

Y CENTROID: -0.001

POA TO CENTROID: 0.112

HORZ SPREAD: 1.730

VERT SPREAD: 0.882

GROUP SPREAD: 1.749

MIN RADIUS: 0.141

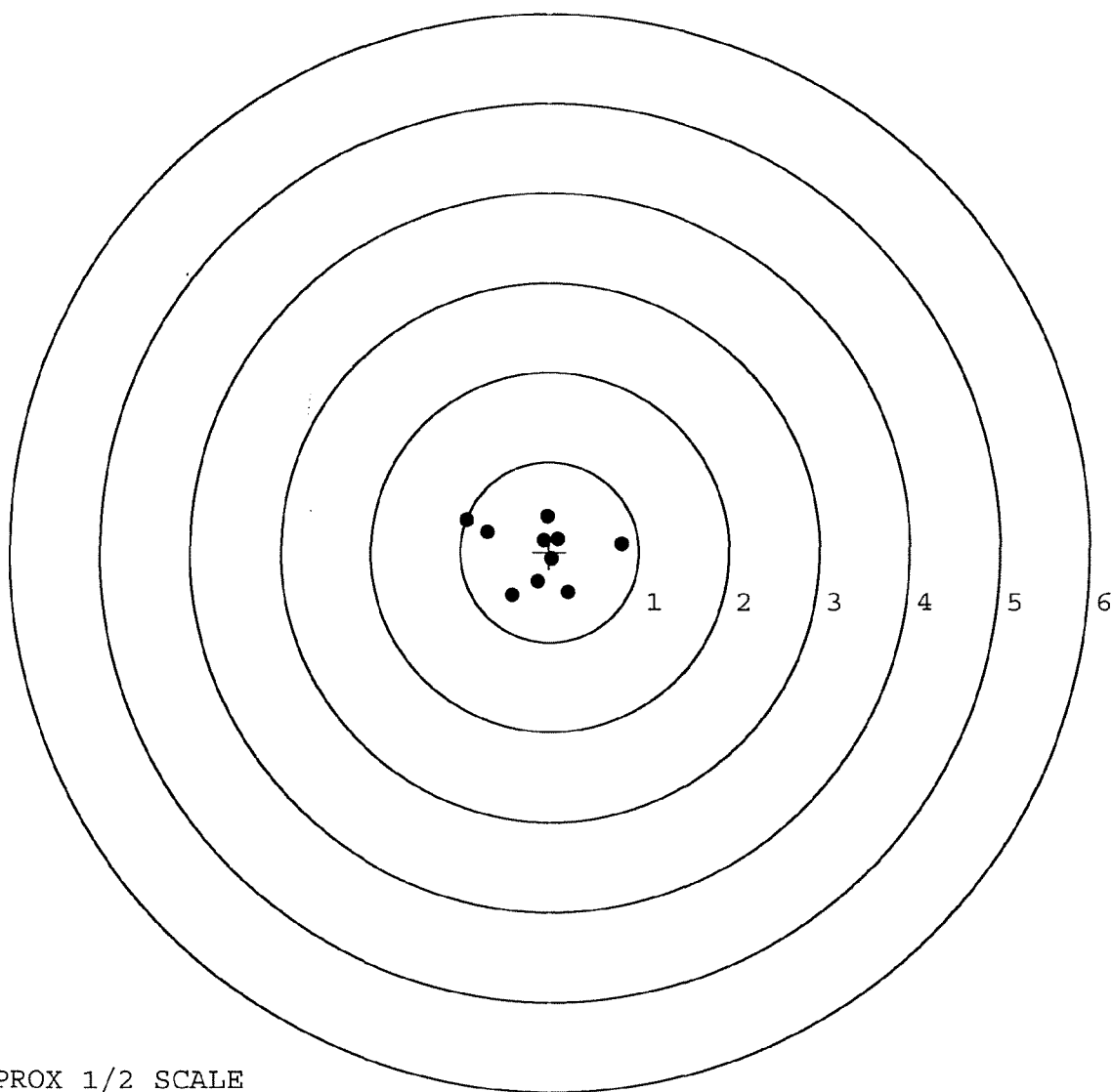
MAX RADIUS: 0.920

MEAN RADIUS: 0.486

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0143746

SERIAL NUMBER: G6635213. __0

TARGET NUMBER: 3

FILE DATE: 04/09/2007

FILE TIME: 12:24

POINT#	X	Y
1:	0.784	0.365
2:	0.592	-0.378
3:	0.042	-0.672
4:	-0.590	-0.943
5:	0.328	0.813
6:	0.173	0.659
7:	-0.120	1.091
8:	-0.027	0.144
9:	-0.416	0.072
10:	-0.914	0.074

X CENTROID: -0.015

Y CENTROID: 0.123

POA TO CENTROID: 0.123

HORZ SPREAD: 1.698

VERT SPREAD: 2.034

GROUP SPREAD: 2.088

MIN RADIUS: 0.025

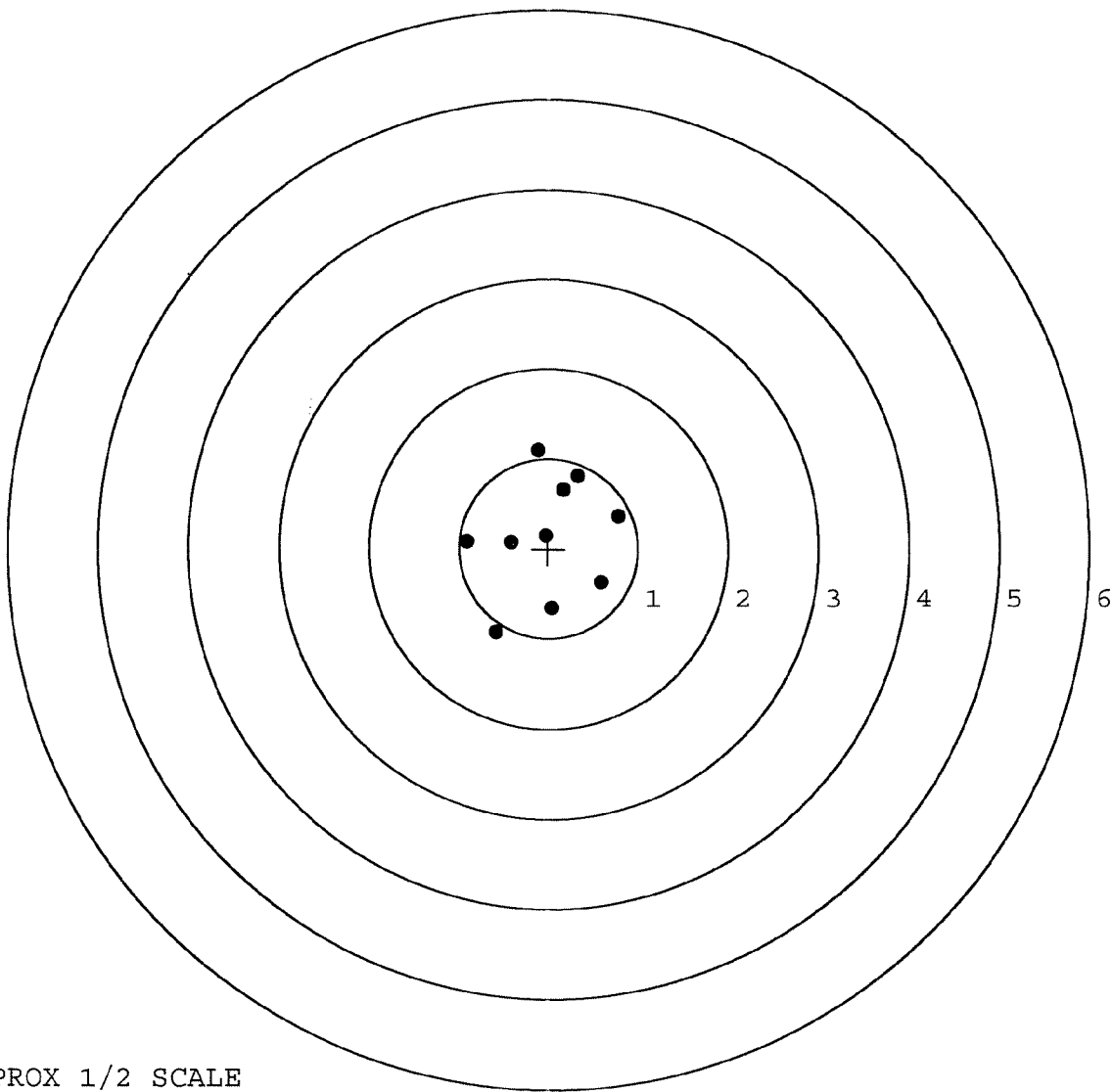
MAX RADIUS: 1.211

MEAN RADIUS: 0.727

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0143747

SERIAL NUMBER: G6635213. __ 0

TARGET NUMBER: 4

FILE DATE: 04/09/2007

FILE TIME: 12:24

POINT#	X	Y
1:	0.744	-0.544
2:	-0.312	-1.366
3:	-0.468	-0.867
4:	-0.219	-0.365
5:	0.018	-0.031
6:	-0.747	0.341
7:	0.525	0.539
8:	0.346	0.711
9:	0.273	0.457
10:	0.011	0.483

X CENTROID: 0.017

Y CENTROID: -0.064

POA TO CENTROID: 0.066

HORZ SPREAD: 1.491

VERT SPREAD: 2.077

GROUP SPREAD: 2.179

MIN RADIUS: 0.033

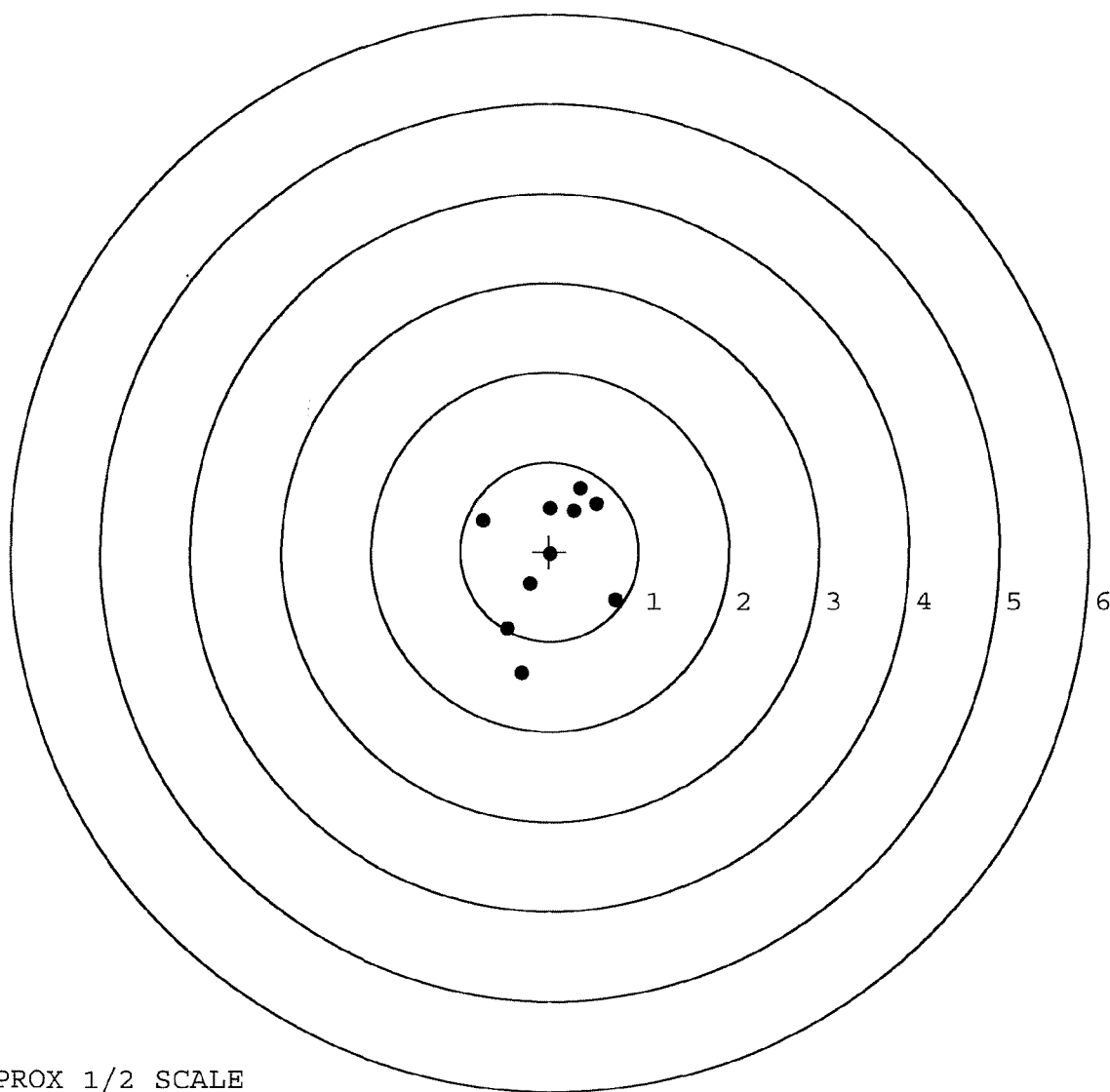
MAX RADIUS: 1.343

MEAN RADIUS: 0.719

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0143748

SERIAL NUMBER: G6635213. __0

TARGET NUMBER: 5

FILE DATE: 04/09/2007

FILE TIME: 12:24

POINT#	X	Y
1:	-0.228	-1.497
2:	-0.914	-0.660
3:	0.687	0.455
4:	0.468	-0.114
5:	0.069	-0.539
6:	-0.166	1.649
7:	0.103	0.179
8:	0.037	0.014
9:	-0.236	-0.156
10:	-0.442	-0.248

X CENTROID: -0.062

Y CENTROID: -0.092

POA TO CENTROID: 0.111

HORZ SPREAD: 1.601

VERT SPREAD: 3.146

GROUP SPREAD: 3.147

MIN RADIUS: 0.145

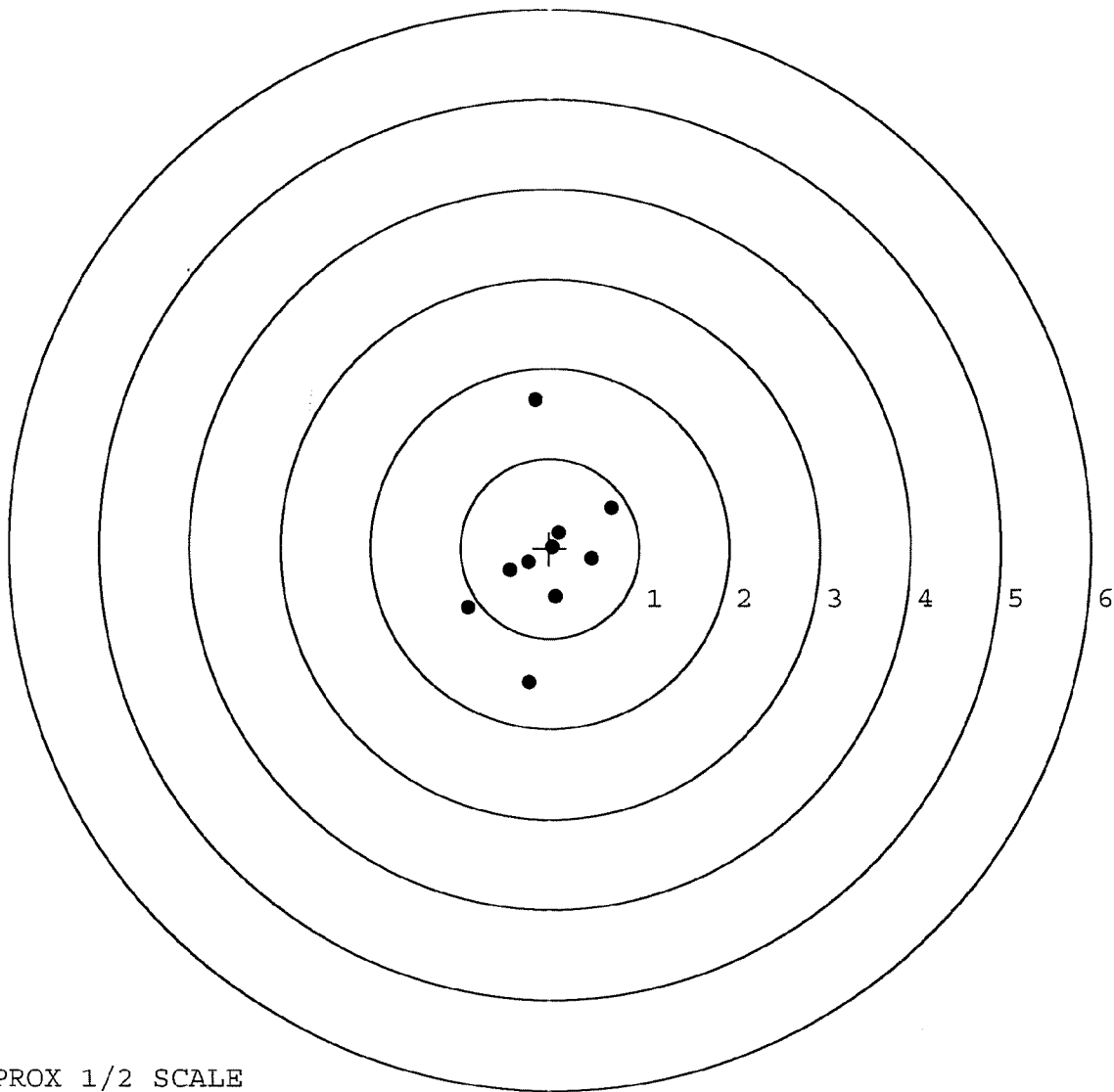
MAX RADIUS: 1.744

MEAN RADIUS: 0.717

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE