

G 6410 265

9/27/2004 10:33:18 AM

Original 47 Crib

25716

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



.MA25716

Shop Order: SWS631059



.ABSWS631059

Start Date: 8/9/2004

Finish Date: 10/26/2004

0540

01PC001

Flat Black Powder Coat, Barrel and



0003451403

0560

89SWS1

Reassemble Action.



0003451404

0690

89SWS1

Pack Rifle



0003451397

0700

89SWS1

Stencil SWS Container



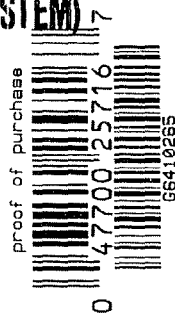
.OP0700

Remington [®]		VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM) BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO		SERIAL NO. G6410265
Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.		DD ORDER NO. 25716
 5716 G6410265		27DY

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

- INSTRUCTION BOOK 3518

DD FORM



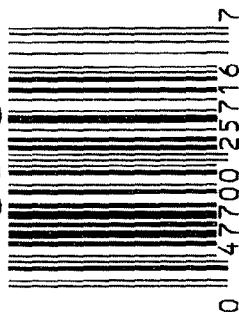
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410265

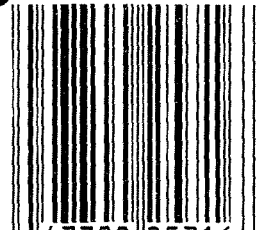
UPC



ORDER 25716

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

UPC

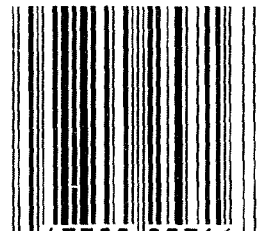


0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



66410265

25716

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



.MA25716

Shop Order: SWS631055



.ABSWS631055

Start Date: 7/23/2004

Finish Date: 9/23/2004

0630

Flat Black Powder Coat, Barrel and

01PC001



0003338116

0640

Reassemble Action.

89SW/S1



0003338117

0685

Attach Front and Rear Sight Assemblies

89SW/S1



0003338122

0710

Pack Rifle & Stencil SWS Container

89SW/S1



.OP0710

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # ~~G6410285~~ G6410265

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-11-04	RTL
600	PROOF		8-11-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX	8-11-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	8-11-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	8-11-04 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		8-13-04	SB/CW
617	DRILL AND TAP SIGHT HOLES		8-14-04	TRW
620	APPLY COATINGS (BARREL ACTION)		8/25	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-7-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-7-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-7-04	RW
	D) OIL FIRING PIN ASSEMBLY		9-7-04	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TRW

OP # OPERATION NAME			READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>9</u>	<u>8</u>	<u>8</u>	9-16-04	RW		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u>	<u>3</u>	<u>3</u>	9-16-04	RW		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.0245</u>	<u>.024</u>	<u>.025</u>	9-16-04	RW		
	J) ASSEMBLE STOCK					9-7-04	RW		
	K) ASSEMBLE SWIVEL STUDS					9-17-04	RW		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					9-7-04	RW		
	M) IRON SIGHT ALIGNMENT					9-7-04	RW		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					9-7-04	RW		
640	GALLERY TEST AND TARGET		PASS	FAIL		9-13-04	TRW		
	MALFUNCTION		CORRECTION			9-13-04	TRW		
	MALFUNCTION		CORRECTION			9-13-04	TRW		
	MALFUNCTION		CORRECTION			9-13-04	TRW		
	MALFUNCTION		CORRECTION			9-13-04	TRW		
645	INSPECT FOR LIVE AMMO					9-13-04	TRW		
655	FINAL INSPECTION A) HEADSPACE					9-17-04	RW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u>	<u>2.91</u>	<u>2.93</u>	<u>2.86</u>	<u>2.81</u>	9-16-04	RW
	C) FUNCTION					9-17-04	RW		
660	PACK					9-20-04	AC		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
BARBER - M24 0149458
2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 8-19-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.56		2.40	
PULL #2	2.08	2.60		2.40	
PULL #3	2.51	2.64		2.01	
PULL #4	2.13	2.59		2.58	
PULL #5	2.50	2.60		2.47	
TOTAL	11.56	12.99		11.86	
AVERAGE	2.31	2.59		2.37	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.29		
PULL #2	3.27	3.31		
PULL #3	3.28	3.09		
PULL #4	3.18	3.09		
PULL #5	3.27	3.13		
TOTAL	16.46	15.91		
AVERAGE	3.29	3.18		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.23	4.07		4.40
PULL #2	4.25	4.05		4.36
PULL #3	4.33	4.08		4.36
PULL #4	4.34	4.18		4.35
PULL #5	4.43	4.07		3.93
TOTAL	21.58	20.45		21.40
AVERAGE	4.31	4.09		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410265.___0

FILE DATE AND TIME: 09/13/2004 08:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.048
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.049
The Average Mean Radius of the Five Target Set:	0.611
The Distance from POA to Centroid Target #1:	0.160
The Distance from Centroid Target #2 to Centroid Target #1:	0.309
The Distance from Centroid Target #3 to Centroid Target #1:	0.174
The Distance from Centroid Target #4 to Centroid Target #1:	0.232
The Distance from Centroid Target #5 to Centroid Target #1:	0.224

SERIAL NUMBER: G6410265. __0

TARGET NUMBER: 1

FILE DATE: 09/13/2004

FILE TIME: 08:29

POINT#	X	Y
1:	-0.673	2.055
2:	-0.174	1.037
3:	-0.714	-0.135
4:	-0.123	0.340
5:	0.315	0.360
6:	0.811	-0.726
7:	0.142	-0.603
8:	-0.097	-0.422
9:	-0.081	-0.275
10:	0.008	-0.144

X CENTROID: -0.059

Y CENTROID: 0.149

POA TO CENTROID: 0.160

HORZ SPREAD: 1.525

VERT SPREAD: 2.781

GROUP SPREAD: 3.152

MIN RADIUS: 0.202

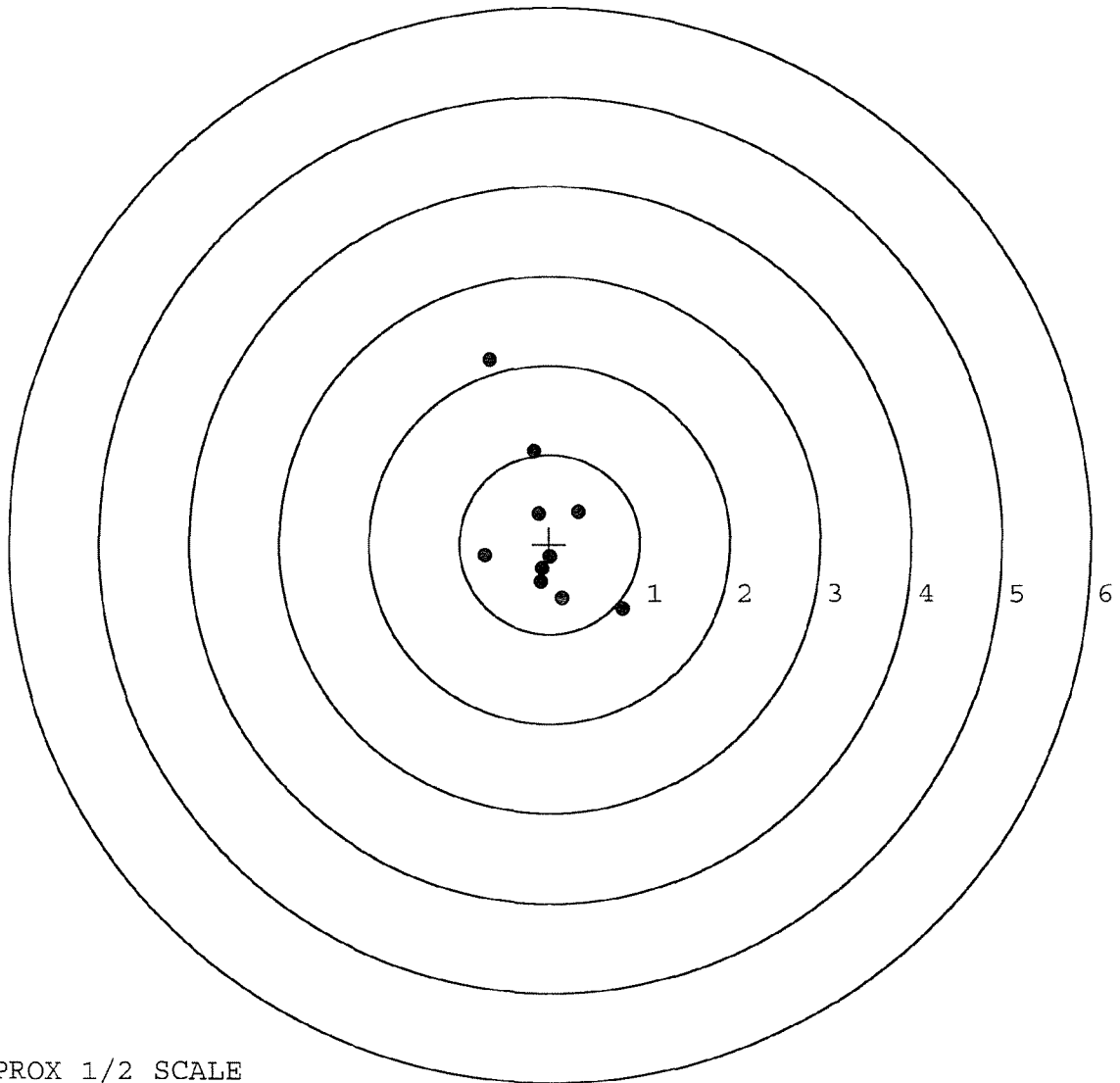
MAX RADIUS: 2.003

MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410265. __0

TARGET NUMBER: 2

FILE DATE: 09/13/2004

FILE TIME: 08:29

POINT#	X	Y
1:	1.168	-0.870
2:	0.732	-0.072
3:	0.024	0.749
4:	0.100	0.882
5:	-0.021	-0.533
6:	0.050	-0.272
7:	0.346	0.117
8:	0.085	0.159
9:	0.019	-0.043
10:	-0.270	0.098

X CENTROID: 0.223

Y CENTROID: 0.021

POA TO CENTROID: 0.224

HORZ SPREAD: 1.438

VERT SPREAD: 1.752

GROUP SPREAD: 2.052

MIN RADIUS: 0.155

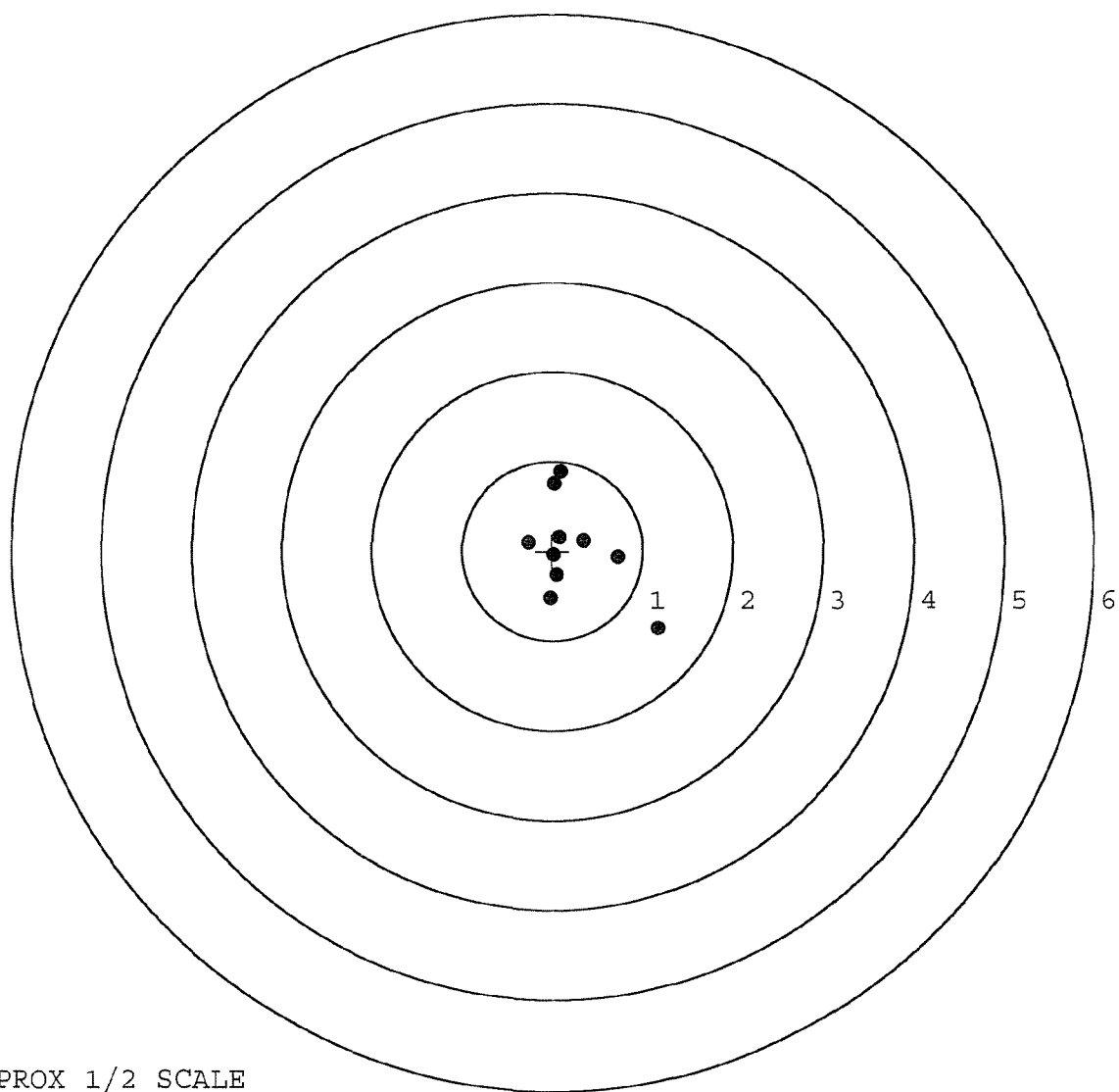
MAX RADIUS: 1.299

MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410265. __0

TARGET NUMBER: 3

FILE DATE: 09/13/2004

FILE TIME: 08:29

POINT#	X	Y
1:	0.747	-0.448
2:	0.861	-0.059
3:	-0.314	0.922
4:	-0.557	0.431
5:	-0.696	-0.084
6:	-0.787	-0.840
7:	-0.111	0.097
8:	0.227	0.032
9:	0.284	-0.275
10:	0.006	-0.015

X CENTROID: -0.034

Y CENTROID: -0.024

POA TO CENTROID: 0.042

HORZ SPREAD: 1.648

VERT SPREAD: 1.762

GROUP SPREAD: 1.824

MIN RADIUS: 0.041

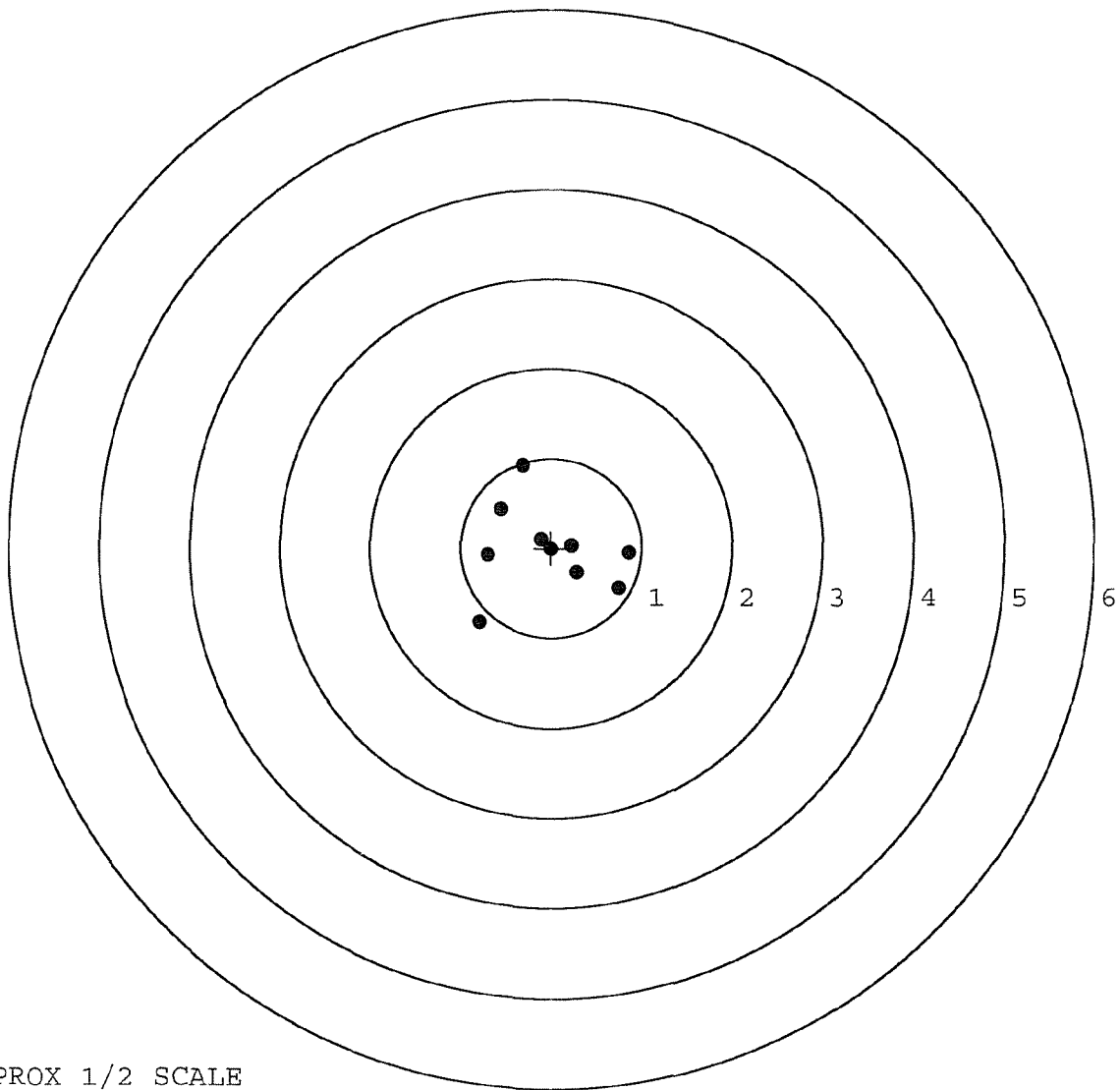
MAX RADIUS: 1.110

MEAN RADIUS: 0.610

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410265. __0

TARGET NUMBER: 4

FILE DATE: 09/13/2004

FILE TIME: 08:29

POINT#	X	Y
1:	0.921	-0.468
2:	-0.585	0.785
3:	0.315	0.634
4:	-0.163	0.333
5:	0.135	0.241
6:	0.026	-0.248
7:	0.201	-0.457
8:	0.026	-0.491
9:	-0.288	-0.502
10:	-0.105	-0.397

X CENTROID: 0.048

Y CENTROID: -0.057

POA TO CENTROID: 0.075

HORZ SPREAD: 1.506

VERT SPREAD: 1.287

GROUP SPREAD: 1.959

MIN RADIUS: 0.192

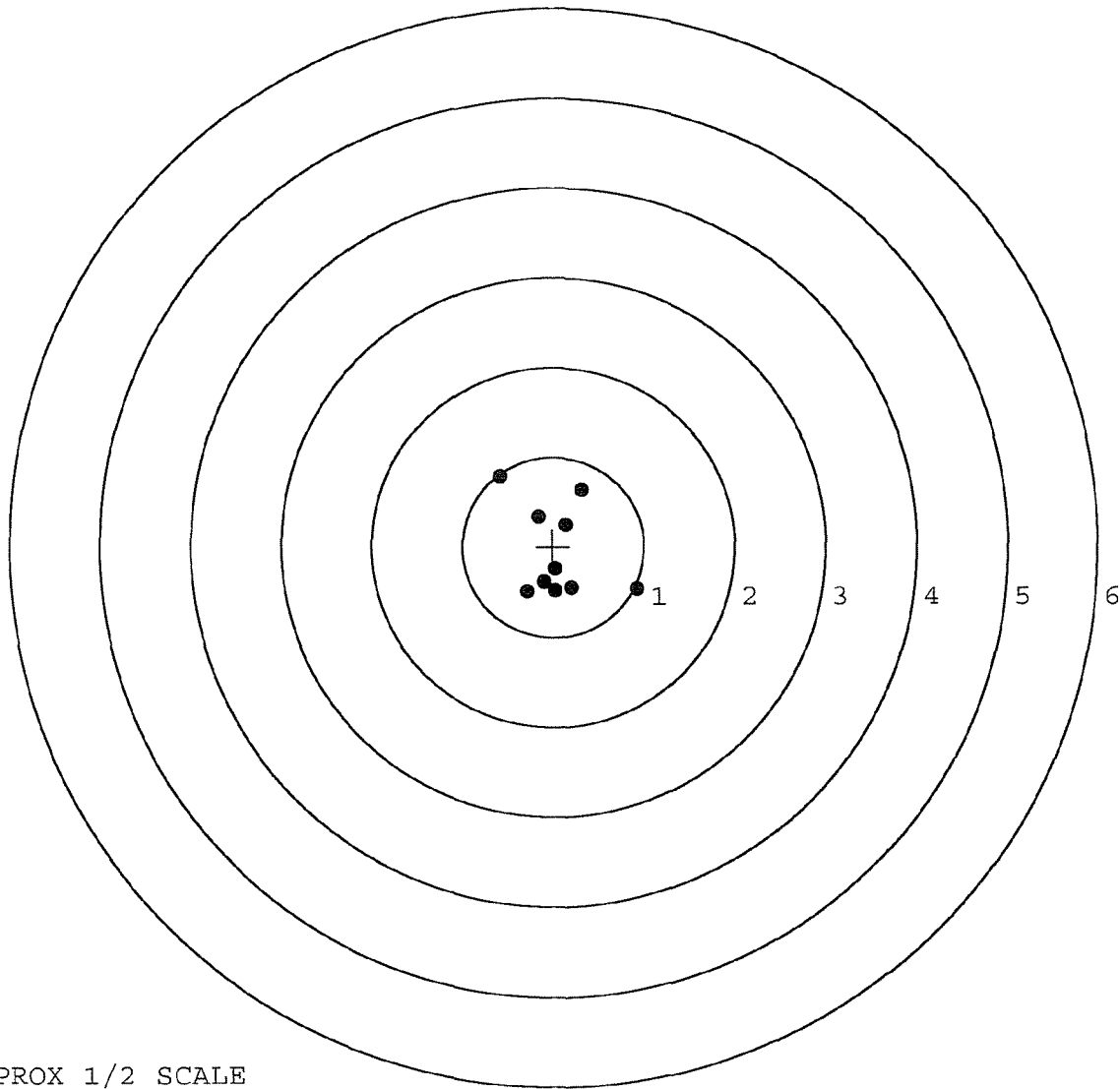
MAX RADIUS: 1.054

MEAN RADIUS: 0.550

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410265. 0

TARGET NUMBER: 5

FILE DATE: 09/13/2004

FILE TIME: 08:29

X CENTROID: 0.062

Y CENTROID: -0.040

POA TO CENTROID: 0.074

HORZ SPREAD: 1.565

VERT SPREAD: 1.284

GROUP SPREAD: 1.617

MIN RADIUS: 0.272

MAX RADIUS: 0.965

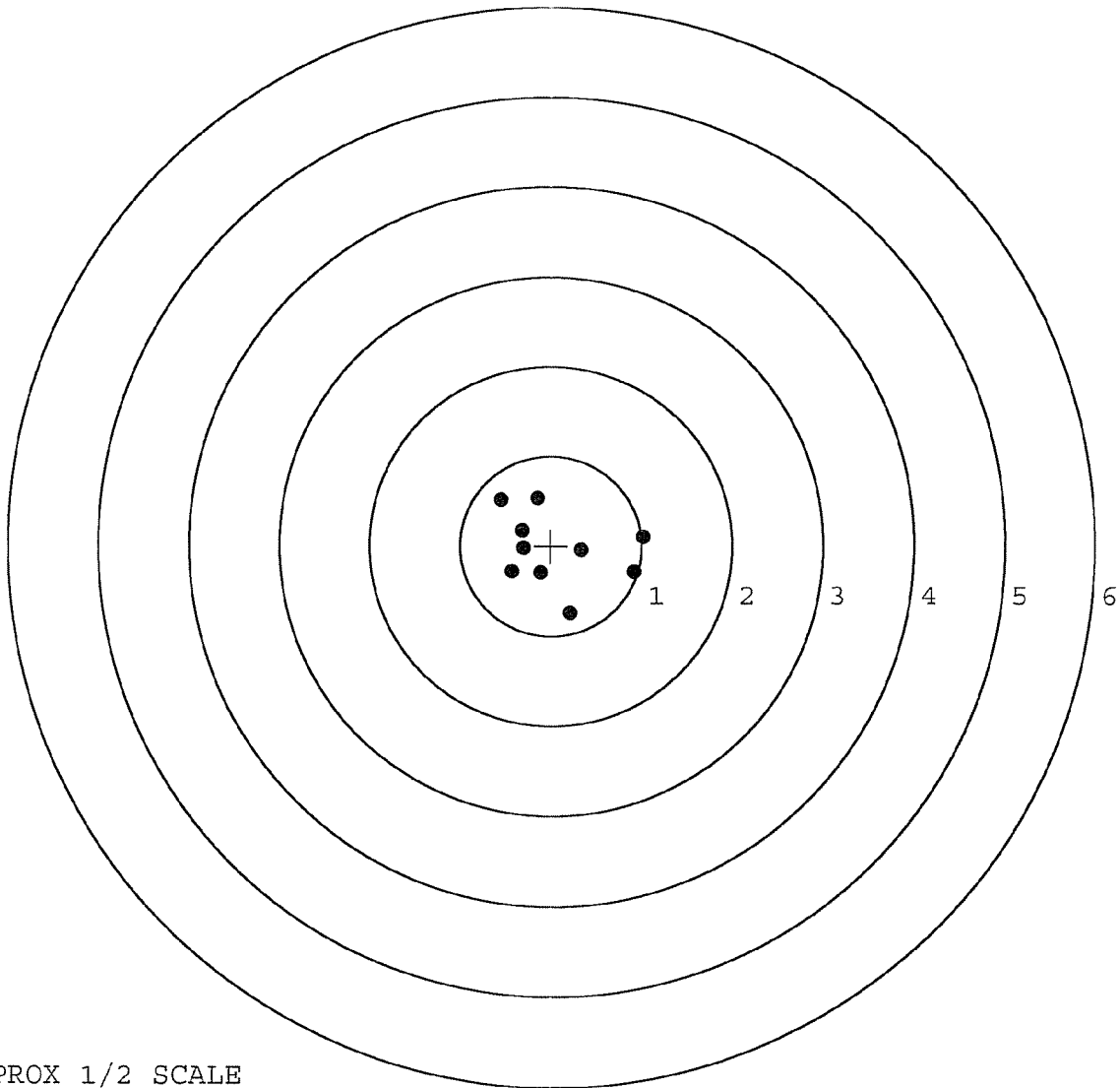
MEAN RADIUS: 0.596

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.549	0.510
2:	-0.149	0.533
3:	0.218	-0.751
4:	-0.116	-0.302
5:	-0.429	-0.290
6:	-0.305	-0.029
7:	-0.317	0.169
8:	0.334	-0.050
9:	0.917	-0.288
10:	1.016	0.103



TARGET APPROX 1/2 SCALE