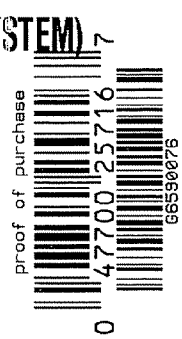
G659 0076

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

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

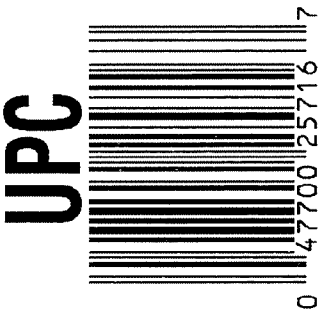
– INSTUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6590076



ORDER 25716

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

UPC

ORDER 25716

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

UPC

SERIAL NO.

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590076

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-17-06	RTZ
420	ASSEMBLE ACTION		10-17-06	RTZ
430	ASSEMBLE TO STOCK		10-17-06	L.P.D.
440	PROOF		10-17-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-17-06	L.P.D.
470	DIS-ASSEMBLE ACTION	OCT 19 2006	10-18-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR APD	10-19-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		102006	CW
510	DRILL AND TAP SIGHT HOLES		10-18-06	TRW
520	GOFF BLAST BBL / REC		10-23-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/27/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11/17/06	mm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/17/06	mm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/17/06	mm
	D) OIL FIRING PIN ASSEMBLY		11-30-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

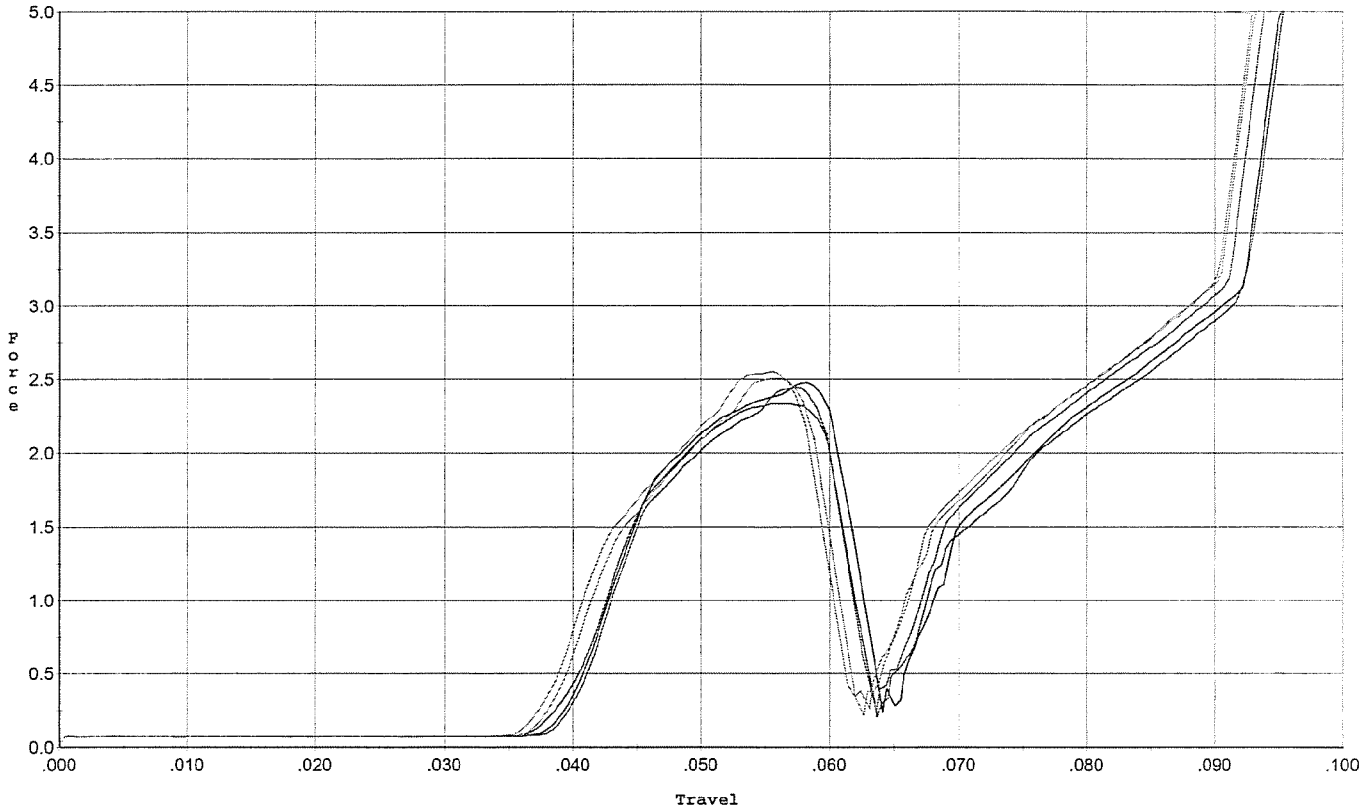
F004 REV 5/2006

OP #	OPERATION NAME BARBER - M24 0164195	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5.5 5.5 5.5	11/30/06	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.5 2.5 3.0	11/30/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.026 .025 .026	11/30/06	DA
	J) ASSEMBLE STOCK		11-29-06	LTL
	K) ASSEMBLE SWIVEL STUDS		12-12-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-12-06	BLG
	M) IRON SIGHT ALIGNMENT		12-12-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-12-06	BLG
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	11-29-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-29-06	RP
670	FINAL INSPECTION A) HEADSPACE		12-12-06	BLG
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.81 2.77 2.76 2.76 2.69	11/30/06	DA
	C) FUNCTION		12-12-06	BLG
690	PACK		12-8-07	DA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini.
Note:	M. Mckinney 11/15/06		



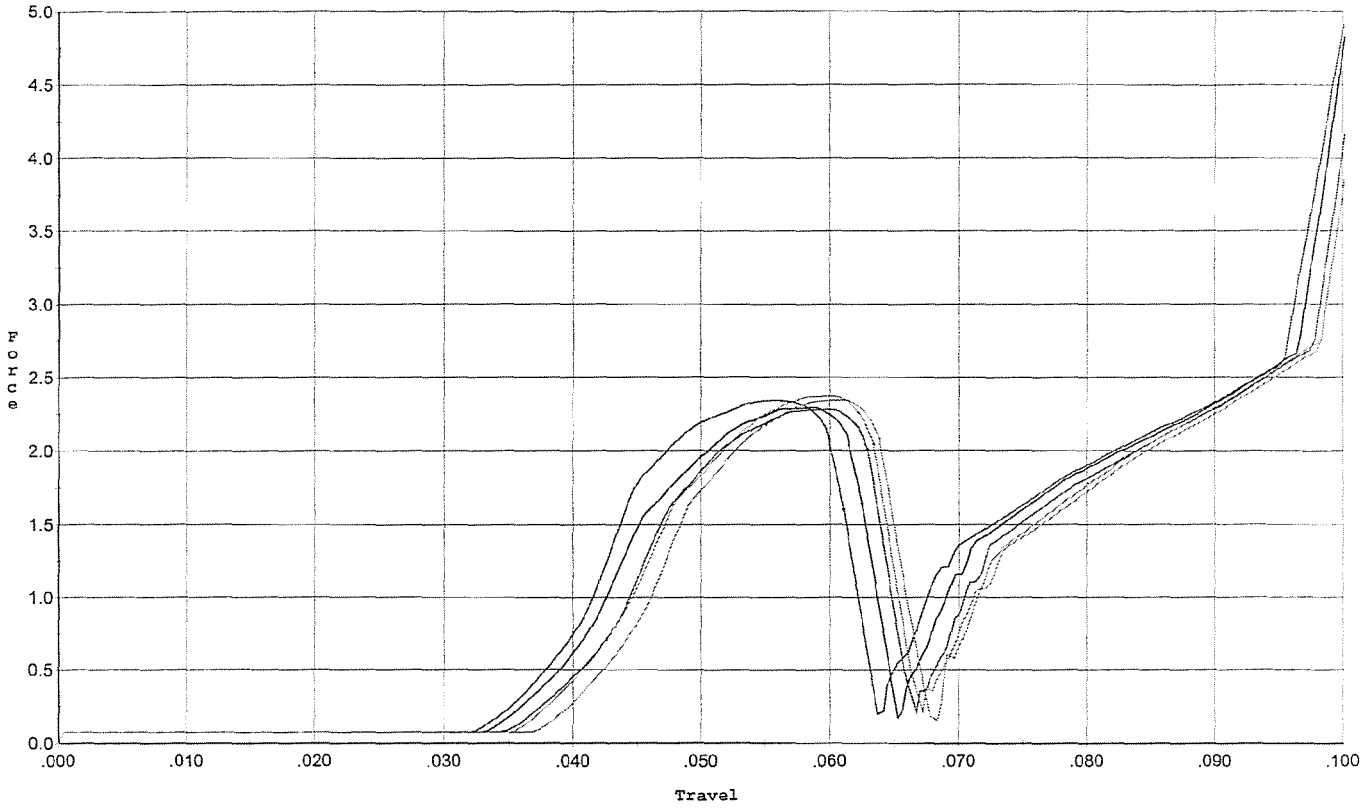
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.334	0.060	0.040	0.042	0.042		Set Trigger
2	2.479	0.062	0.040	0.041	0.045		Set Trigger
3	2.448	0.060	0.040	0.041	0.041		Set Trigger
4	2.507	0.059	0.038	0.041	0.041		Set Trigger
5	2.554	0.058	0.038	0.041	0.042		Set Trigger

2.46 Avg

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 3:55:54 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
Note:	M. Mckinney 11/15/06		



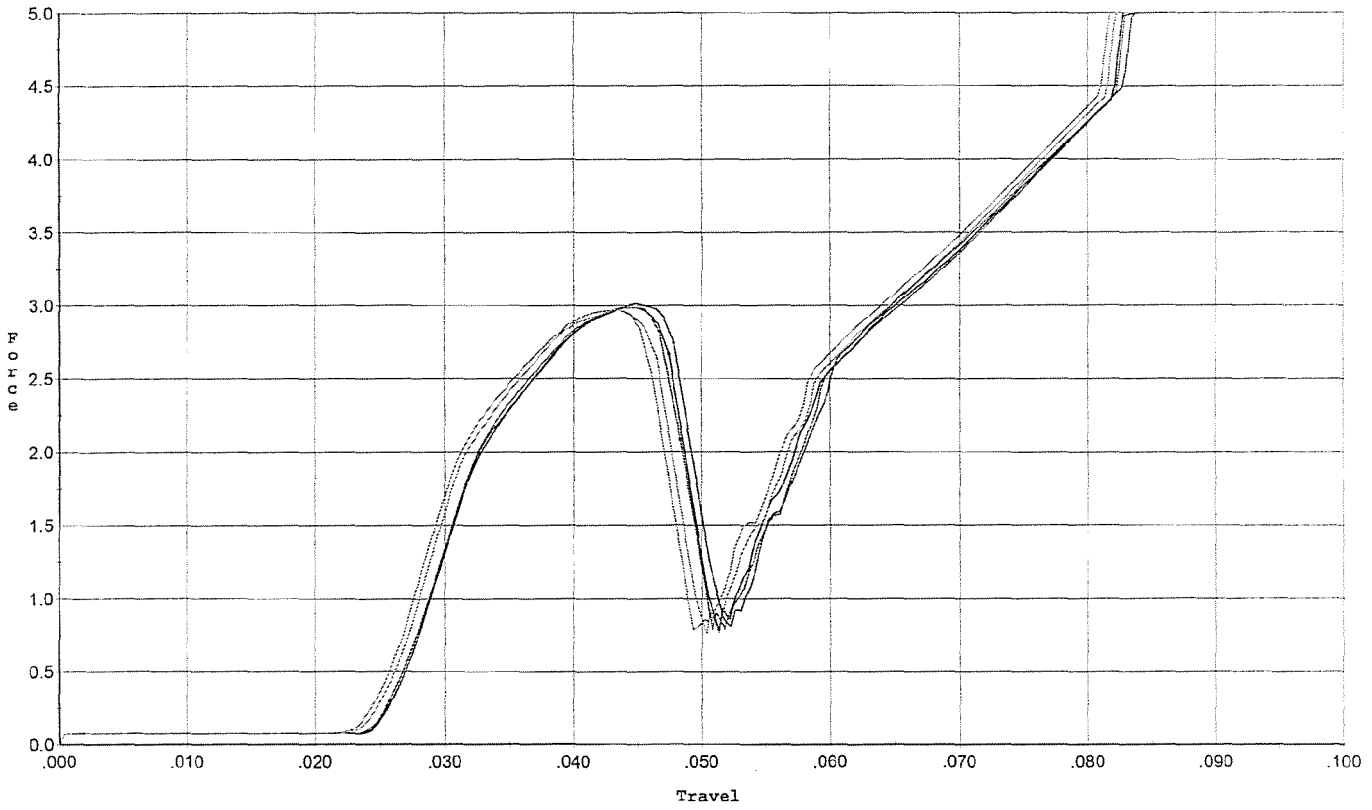
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.343	0.061	0.040	0.045	0.047		Set Trigger
2	2.293	0.063	0.041	0.044	0.046		Set Trigger
3	2.280	0.063	0.043	0.045	0.045		Set Trigger
4	2.370	0.063	0.043	0.045	0.046		Set Trigger
5	2.343	0.064	0.045	0.045	0.044		Set Trigger

2.33 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 3:57:23 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs ini.
Note:	M. Mckinney 11/15/06		



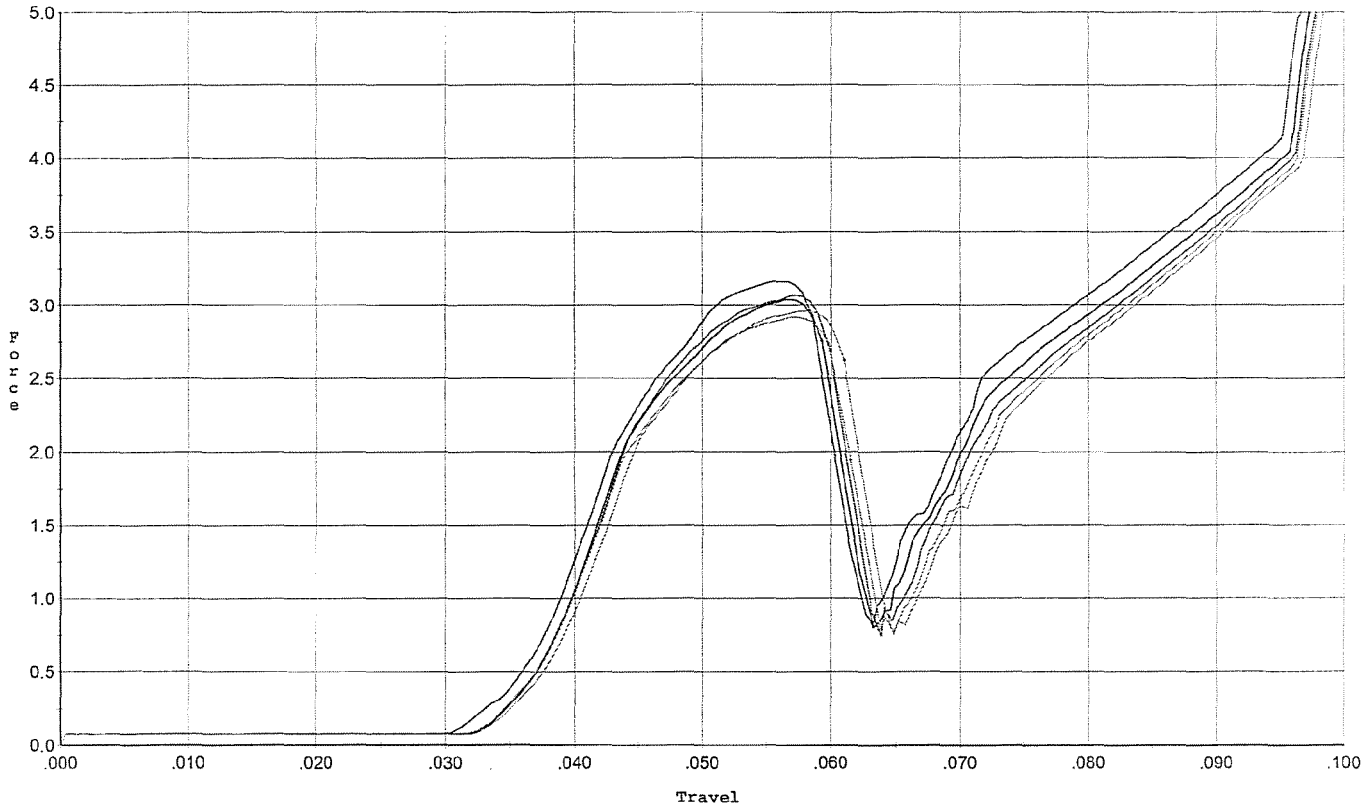
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.014	0.048	0.025	0.038	0.053		Set Trigger
2	2.985	0.047	0.026	0.038	0.051		Set Trigger
3	2.987	0.048	0.026	0.038	0.052		Set Trigger
4	2.966	0.046	0.025	0.038	0.051		Set Trigger
5	2.971	0.046	0.024	0.038	0.051		Set Trigger

3.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 3:59:27 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs ~~lbs~~ After 20 cycles
Note:	M. Mckinney 11/15/06		



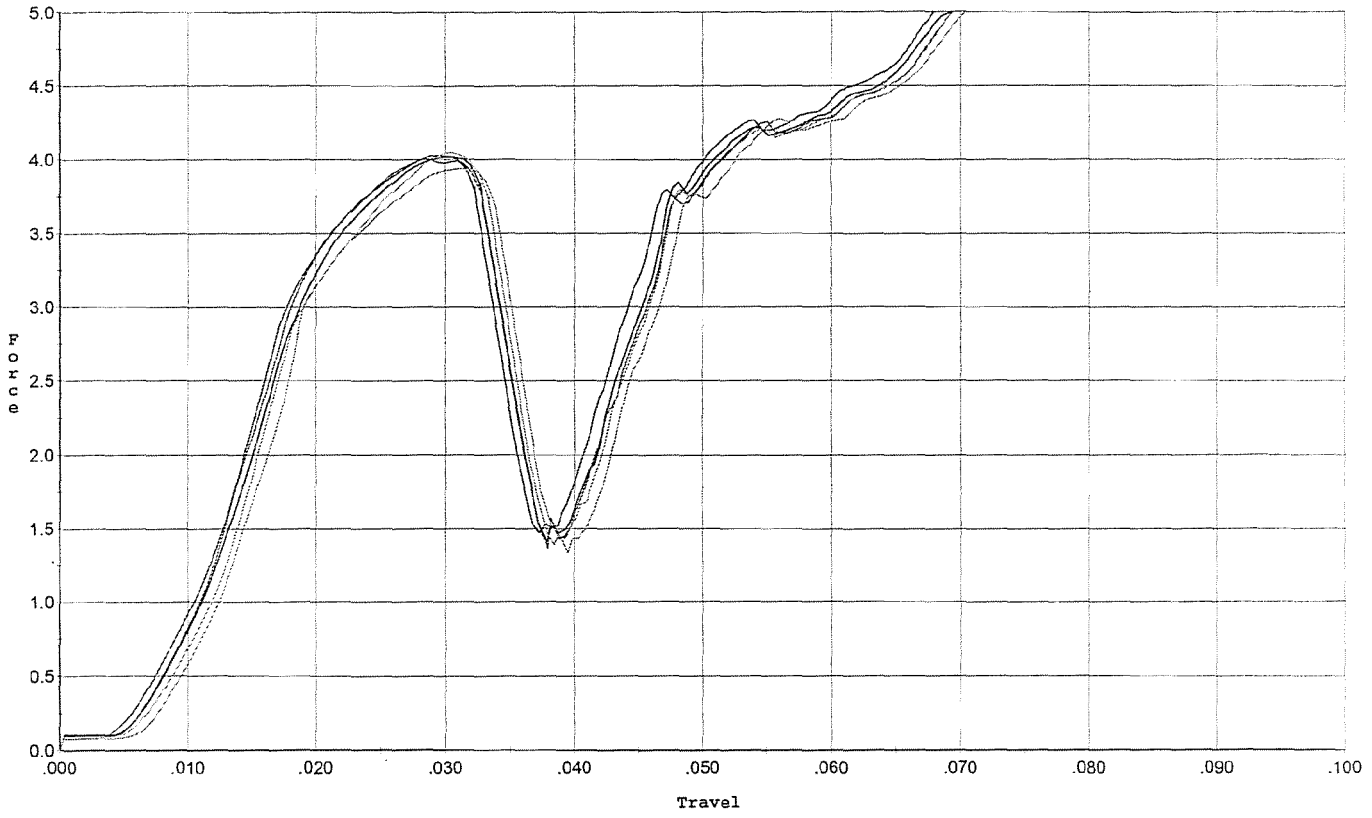
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.059	0.037	0.042	0.059		Set Trigger
2	3.038	0.059	0.037	0.042	0.056		Set Trigger
3	3.068	0.060	0.037	0.042	0.058		Set Trigger
4	2.919	0.062	0.038	0.042	0.058		Set Trigger
5	2.958	0.061	0.038	0.042	0.058		Set Trigger

3.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 4:01:22 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	M. Mckinney 11/15/06		



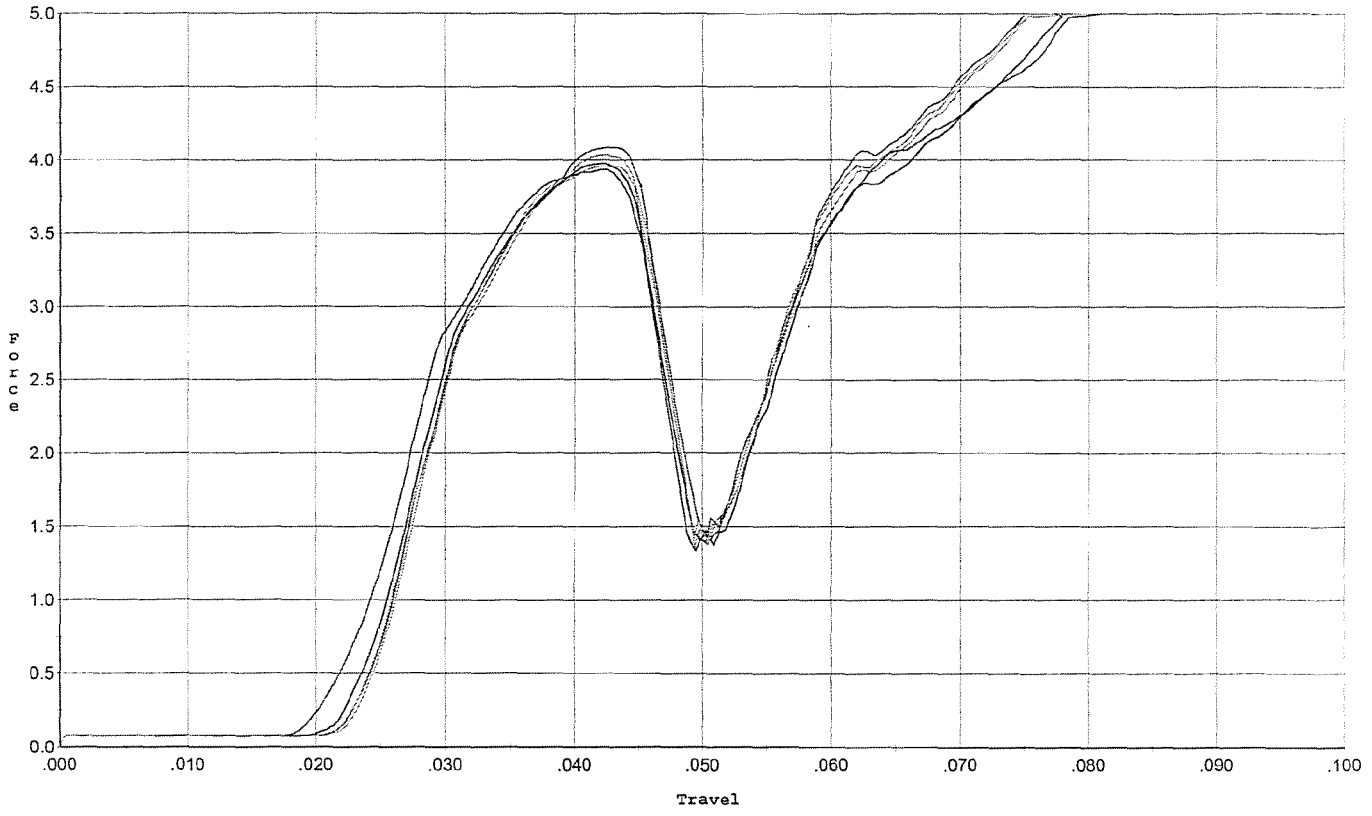
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.032	0.006	0.039	0.071		Set Trigger
2	4.020	0.033	0.007	0.039	0.070		Set Trigger
3	4.003	0.033	0.007	0.039	0.072		Set Trigger
4	4.048	0.033	0.008	0.039	0.070		Set Trigger
5	3.940	0.034	0.008	0.039	0.070		Set Trigger

4.01

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 4:11:00 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
Note:	M. Mckinney 11/15/06		

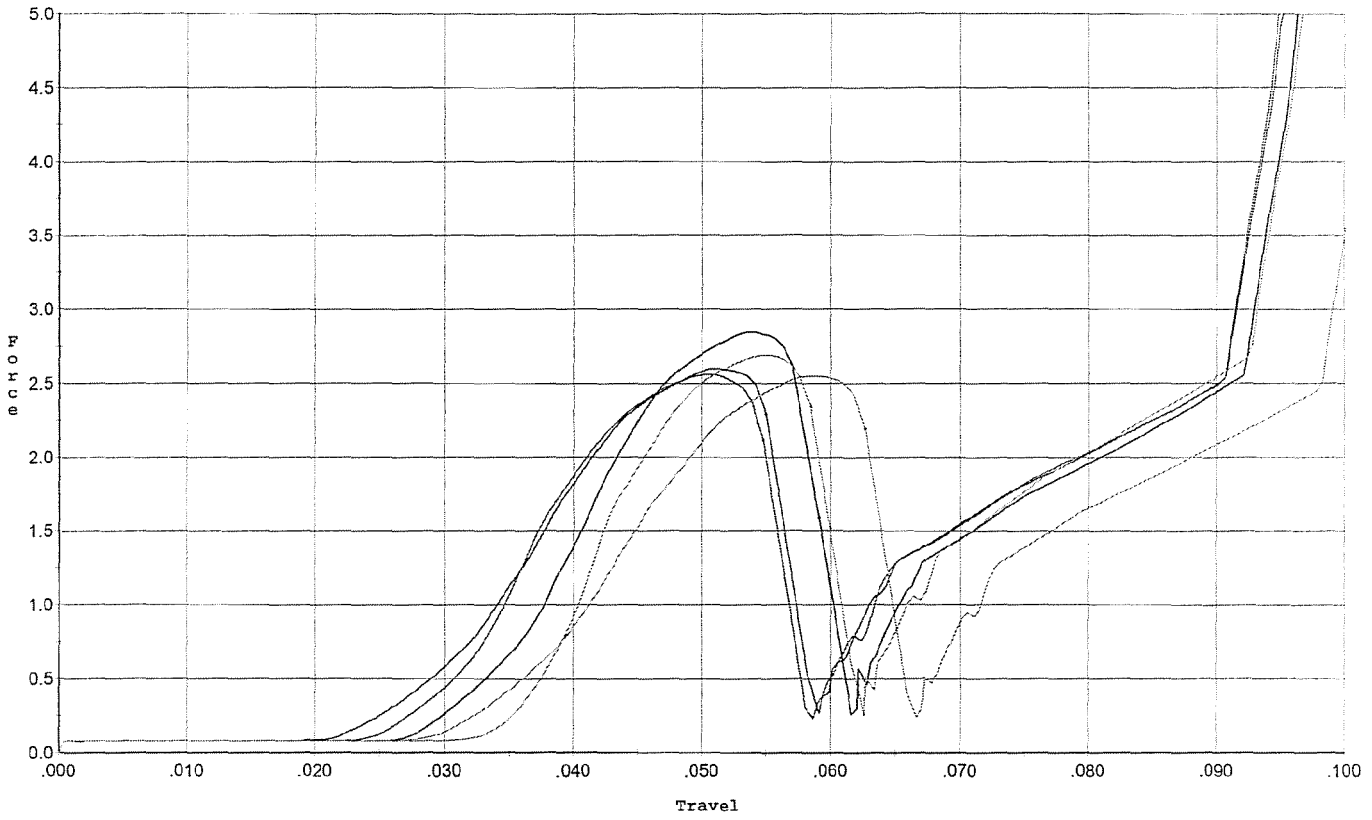


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.935	0.045	0.021	0.035	0.072		Set Trigger
2	3.974	0.045	0.022	0.034	0.068		Set Trigger
3	4.086	0.045	0.023	0.034	0.069		Set Trigger
4	4.031	0.046	0.023	0.034	0.069		Set Trigger
5	3.959	0.046	0.023	0.034	0.069		Set Trigger

4.00 Avg.

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	Final Test & To Reset 2.5 lbs.
Note:	M. Mckinney 11/15/06		

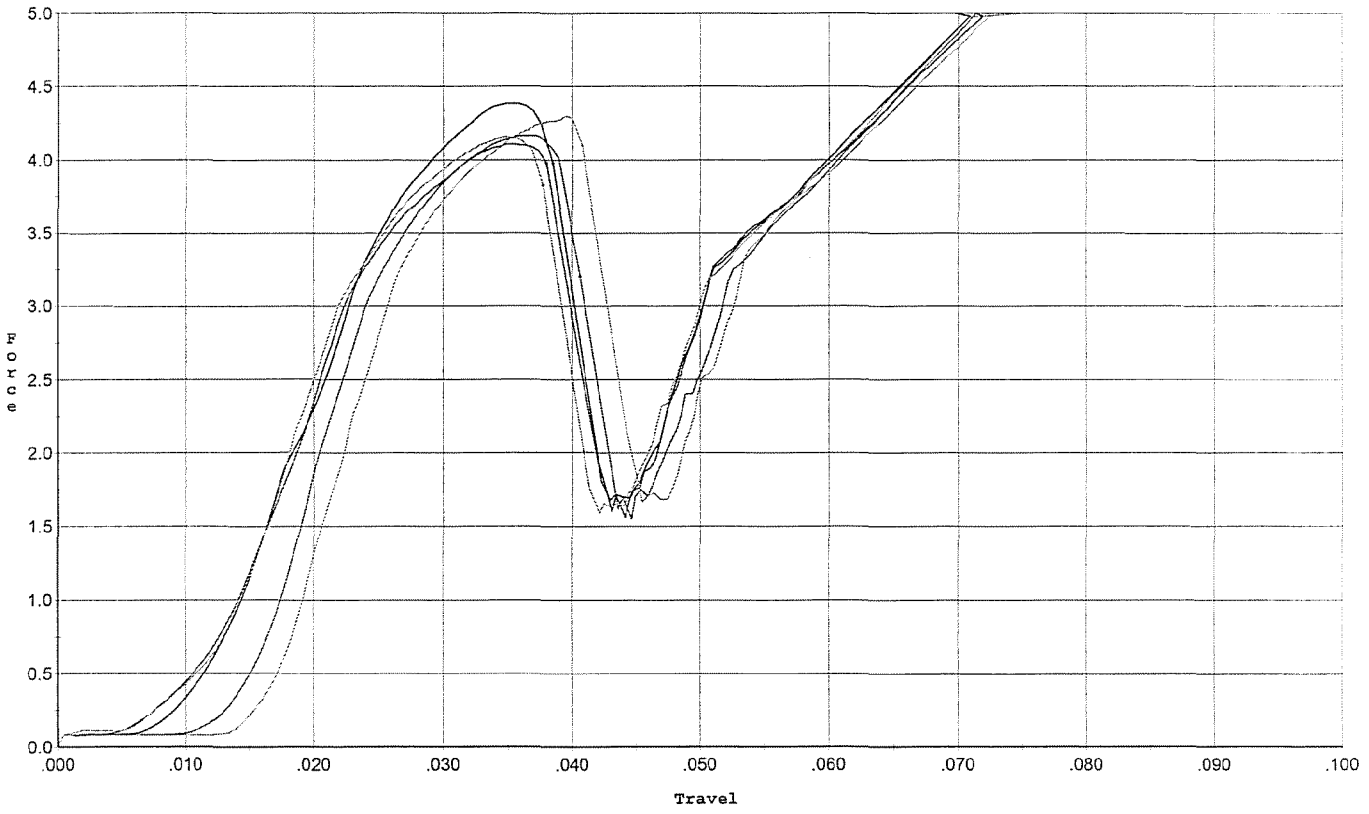


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.055	0.034	0.044	0.053		Set Trigger
2	2.844	0.059	0.037	0.043	0.056		Set Trigger
3	2.561	0.055	0.033	0.044	0.050		Set Trigger
4	2.690	0.058	0.038	0.043	0.048		Set Trigger
5	2.550	0.063	0.042	0.045	0.054		Set Trigger

2.65 Avg.

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	Reset to 4.0 lbs. For Target & Accuracy
Note:	M. Mckinney 11/15/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.110	0.038	0.012	0.034	0.080		Set Trigger
2	4.385	0.038	0.012	0.033	0.083		Set Trigger
3	4.167	0.041	0.014	0.033	0.080		Set Trigger
4	4.300	0.041	0.016	0.033	0.078		Set Trigger
5	4.160	0.038	0.013	0.034	0.079		Set Trigger

4.22 Avg.

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 11/15/2006 4:17:08 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590076.__0
FILE DATE AND TIME: 11/30/2006 00:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

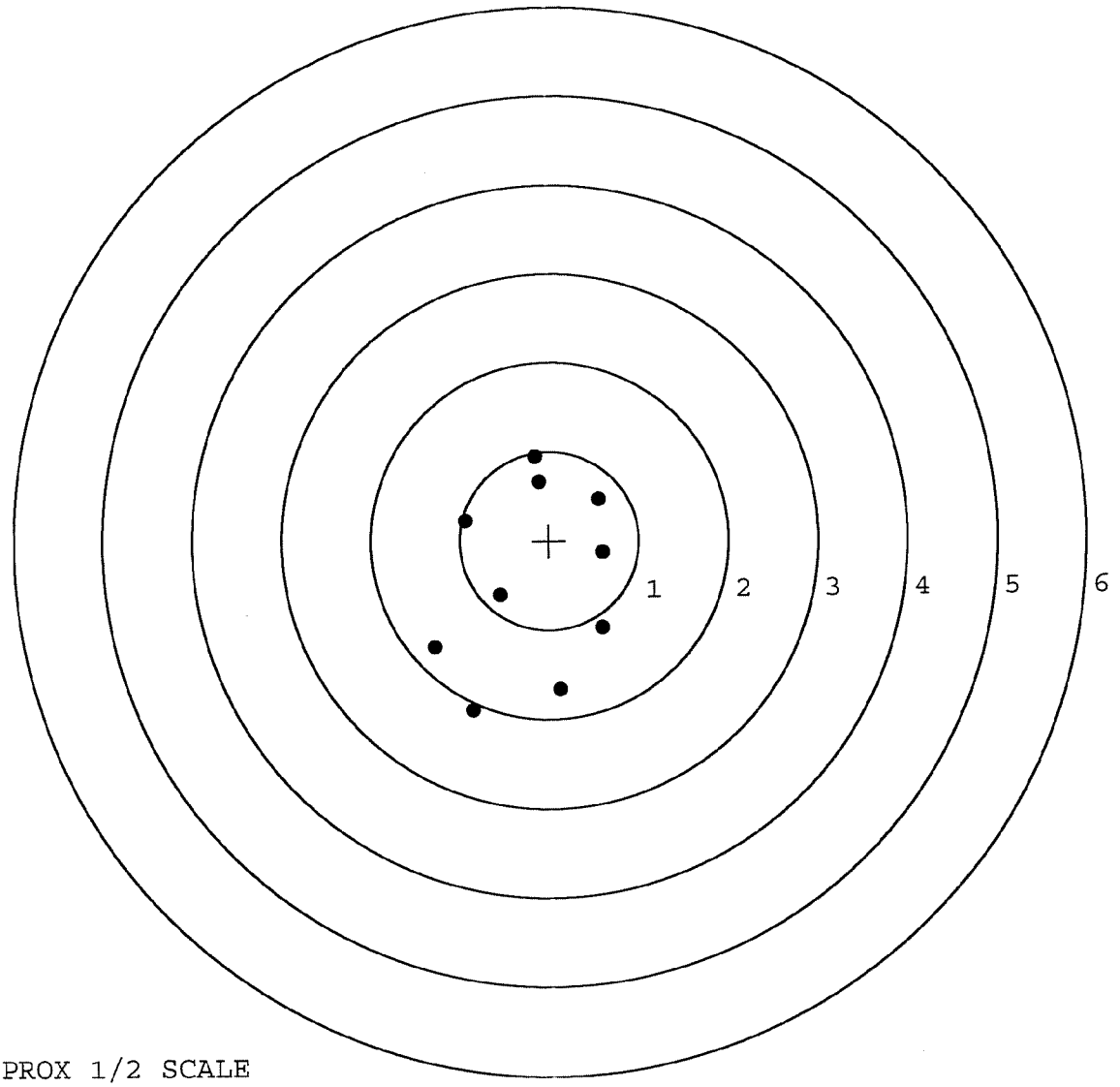
The Average X Centroid of the Five Target Set:	-0.105
The Average Y Centroid of the Five Target Set:	-0.159
The Average Point of Impact of the Five Target Set:	0.190
The Average Mean Radius of the Five Target Set:	0.714
The Distance from POA to Centroid Target #1:	0.469
The Distance from Centroid Target #2 to Centroid Target #1:	0.229
The Distance from Centroid Target #3 to Centroid Target #1:	0.420
The Distance from Centroid Target #4 to Centroid Target #1:	0.398
The Distance from Centroid Target #5 to Centroid Target #1:	0.418

BARBER - M24 0164205

SERIAL NUMBER: G6590076.__0
TARGET NUMBER: 1
FILE DATE: 11/30/2006
FILE TIME: 00:48

X CENTROID:	-0.206
Y CENTROID:	-0.421
POA TO CENTROID:	0.469
HORZ SPREAD:	1.888
VERT SPREAD:	2.844
GROUP SPREAD:	2.931
MIN RADIUS:	0.396
MAX RADIUS:	1.621
MEAN RADIUS:	1.107
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.156	0.943
2:	-0.113	0.663
3:	0.557	0.460
4:	0.597	-0.139
5:	0.588	-0.984
6:	0.114	-1.680
7:	-0.866	-1.901
8:	-1.291	-1.190
9:	-0.553	-0.611
10:	-0.939	0.232

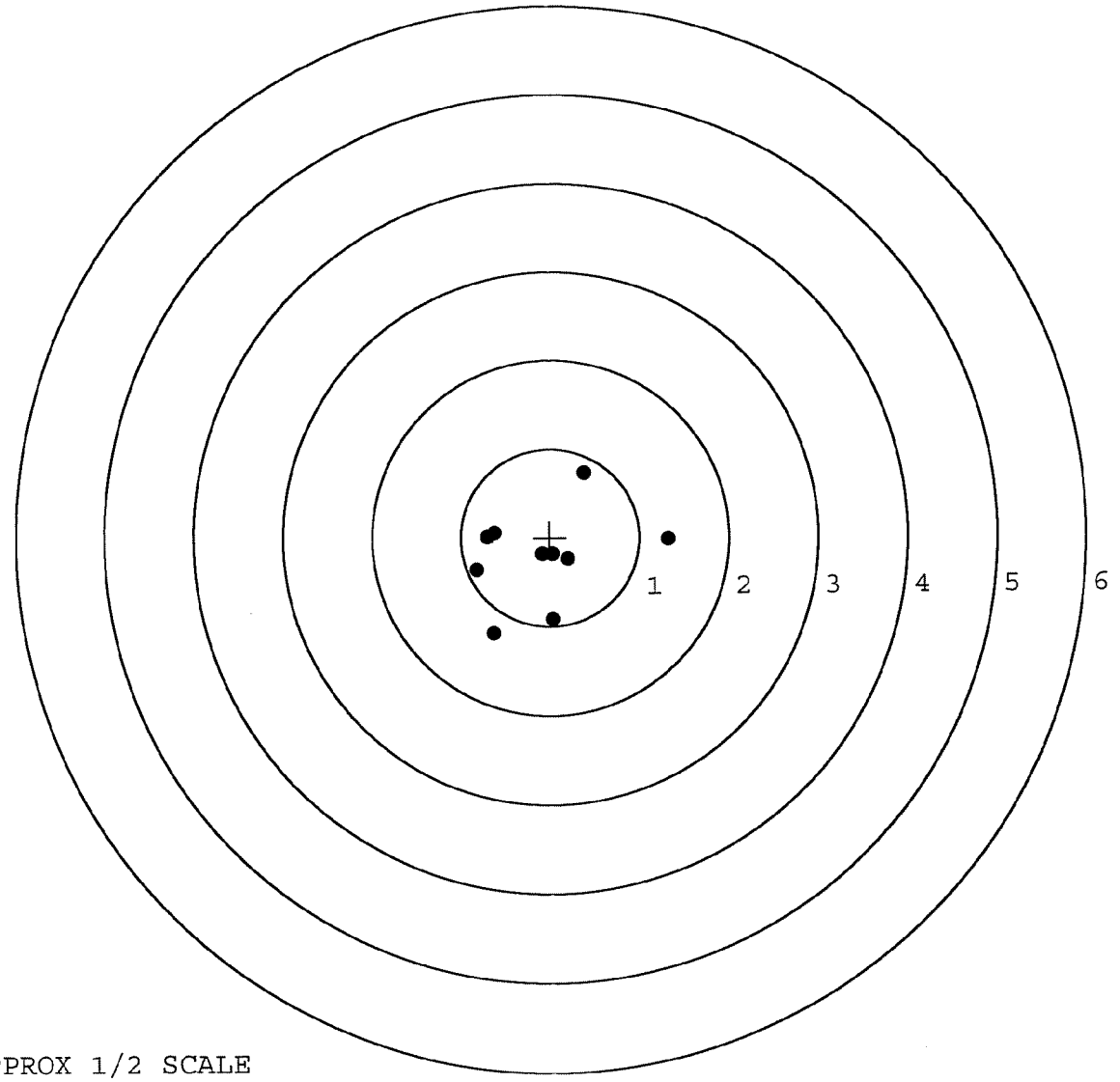


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590076.__0
TARGET NUMBER: 2
FILE DATE: 11/30/2006
FILE TIME: 00:48

X CENTROID:	-0.090
Y CENTROID:	-0.223
POA TO CENTROID:	0.241
HORZ SPREAD:	2.149
VERT SPREAD:	1.819
GROUP SPREAD:	2.226
MIN RADIUS:	0.032
MAX RADIUS:	1.426
MEAN RADIUS:	0.669
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.391	0.733
2:	1.324	-0.033
3:	0.206	-0.245
4:	-0.087	-0.191
5:	-0.622	0.057
6:	-0.825	-0.361
7:	-0.637	-1.086
8:	0.029	-0.927
9:	0.030	-0.193
10:	-0.705	0.013



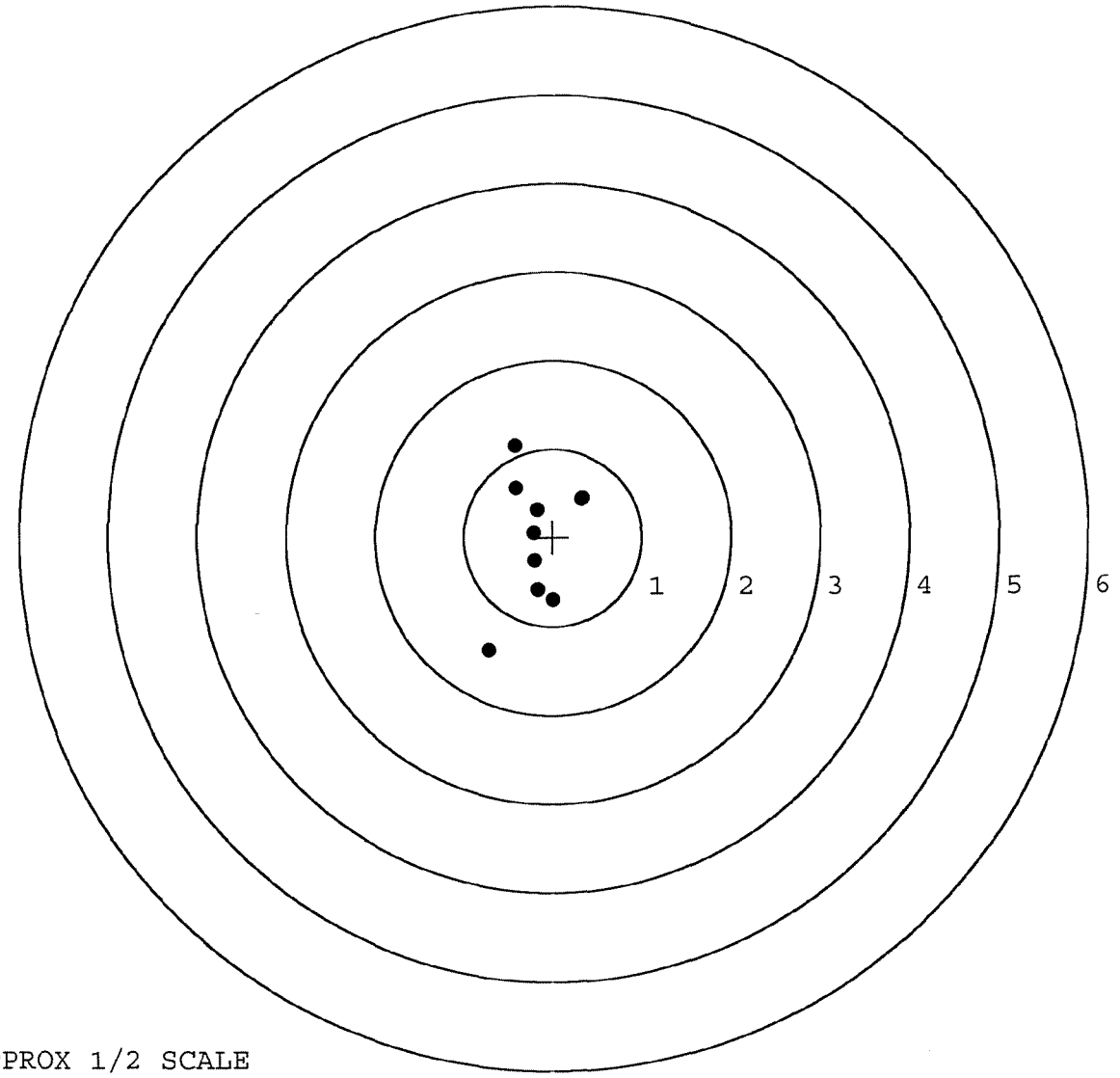
TARGET APPROX 1/2 SCALE

BARBER - M24 0164207

SERIAL NUMBER: G6590076.__0
TARGET NUMBER: 3
FILE DATE: 11/30/2006
FILE TIME: 00:48

X CENTROID:	-0.165
Y CENTROID:	-0.003
POA TO CENTROID:	0.165
HORZ SPREAD:	1.055
VERT SPREAD:	2.312
GROUP SPREAD:	2.331
MIN RADIUS:	0.069
MAX RADIUS:	1.384
MEAN RADIUS:	0.637
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.421	1.040
2:	0.326	0.431
3:	-0.416	0.556
4:	-0.178	0.309
5:	-0.213	0.047
6:	-0.201	-0.269
7:	-0.171	-0.599
8:	0.001	-0.712
9:	-0.718	-1.272
10:	0.337	0.443



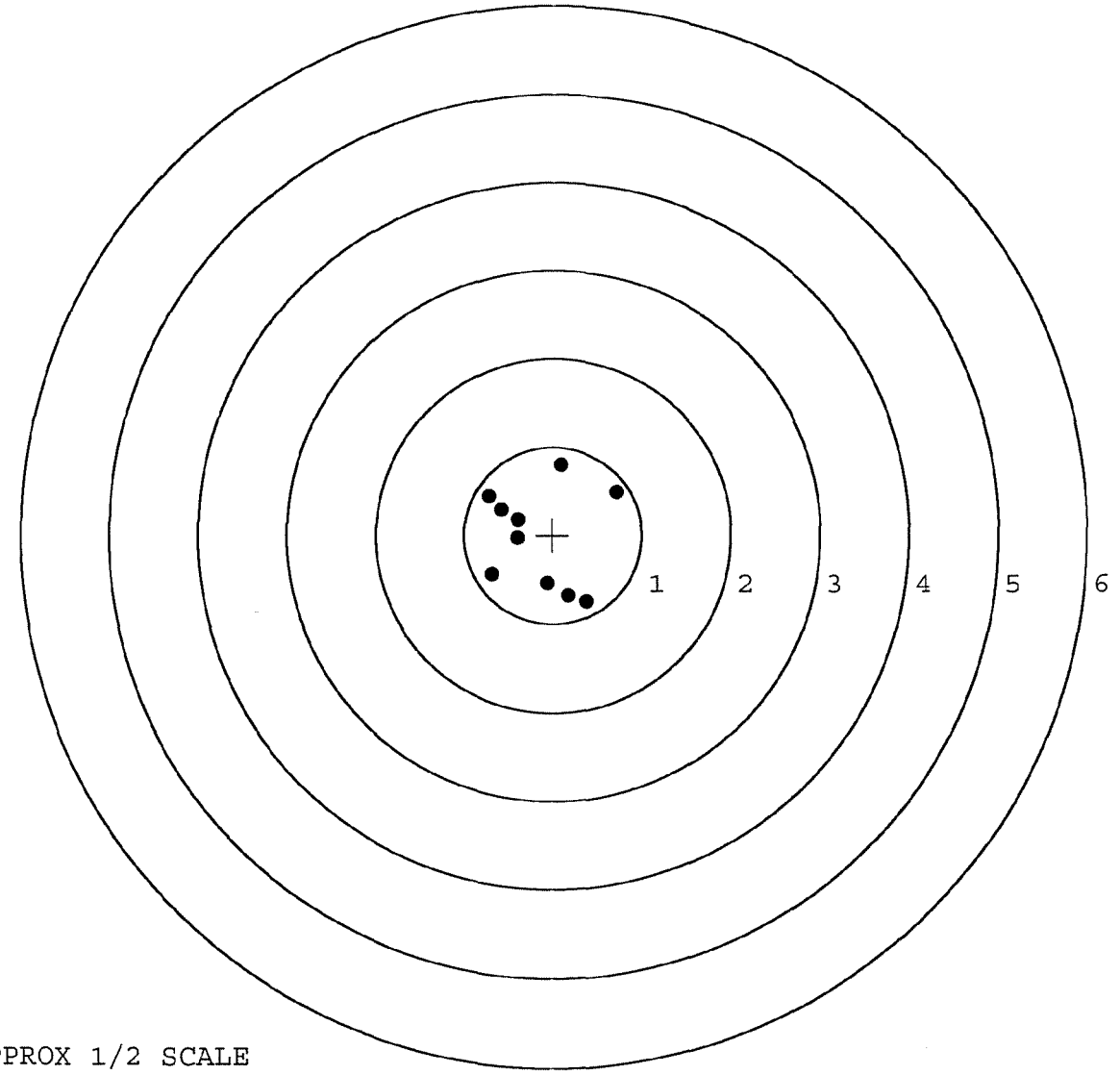
TARGET APPROX 1/2 SCALE

BARBER - M24 0164208

SERIAL NUMBER: G6590076.__0
TARGET NUMBER: 4
FILE DATE: 11/30/2006
FILE TIME: 00:48

X CENTROID:	-0.146
Y CENTROID:	-0.027
POA TO CENTROID:	0.149
HORZ SPREAD:	1.439
VERT SPREAD:	1.545
GROUP SPREAD:	1.682
MIN RADIUS:	0.250
MAX RADIUS:	1.006
MEAN RADIUS:	0.656
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.100	0.798
2:	0.717	0.490
3:	-0.722	0.442
4:	-0.586	0.288
5:	-0.396	0.177
6:	-0.396	-0.036
7:	-0.680	-0.446
8:	-0.062	-0.552
9:	0.179	-0.687
10:	0.383	-0.747



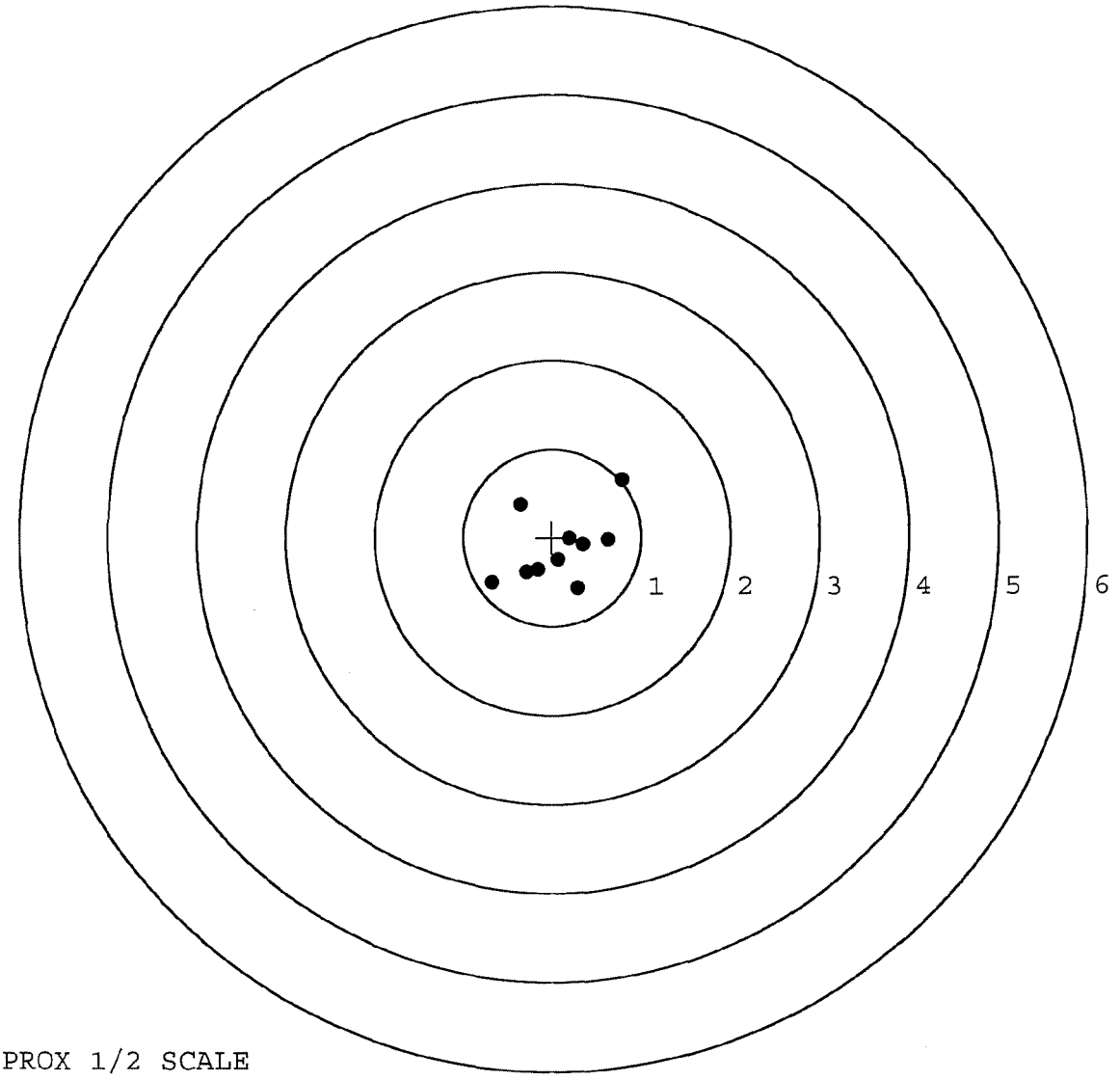
TARGET APPROX 1/2 SCALE

BARBER - M24 0164209

SERIAL NUMBER: G6590076.__0
TARGET NUMBER: 5
FILE DATE: 11/30/2006
FILE TIME: 00:48

X CENTROID:	0.084
Y CENTROID:	-0.120
POA TO CENTROID:	0.147
HORZ SPREAD:	1.460
VERT SPREAD:	1.229
GROUP SPREAD:	1.867
MIN RADIUS:	0.134
MAX RADIUS:	1.045
MEAN RADIUS:	0.500
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.785	0.654
2:	-0.360	0.378
3:	0.629	-0.032
4:	0.199	-0.017
5:	0.352	-0.080
6:	0.293	-0.575
7:	0.072	-0.254
8:	-0.163	-0.372
9:	-0.293	-0.395
10:	-0.675	-0.510



TARGET APPROX 1/2 SCALE