8/13/2020

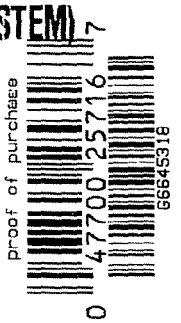
ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC

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

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

– INSTUCTION BOOK 3518

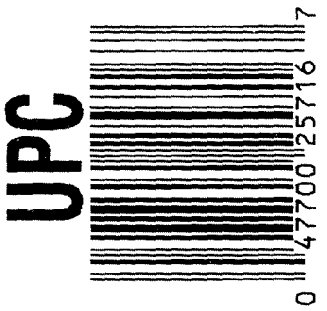
BM FORM



ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6645318



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6645318

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9/18/07	S.P.D.
420	ASSEMBLE ACTION			
430	ASSEMBLE TO STOCK		9-18-07	SD
440	PROOF	MAGNA - FLUX SEP 20 2007	9/18/07	[illegible]
460	CHECK HEADSPACE		9/18/07	[illegible]
470	DIS-ASSEMBLE ACTION		9-18-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR [illegible]	9/20/07	[illegible]
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-19-07	CW
510	DRILL AND TAP SIGHT HOLES		9-19-07	FM
520	GOFF BLAST BBL / REC		9-21-07	[illegible]
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/25/07	[illegible]
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/28/07	S.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/28/07	S.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/28/07	S.P.D.
	D) OIL FIRING PIN ASSEMBLY		9/28/07	S.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/12/07	[illegible]

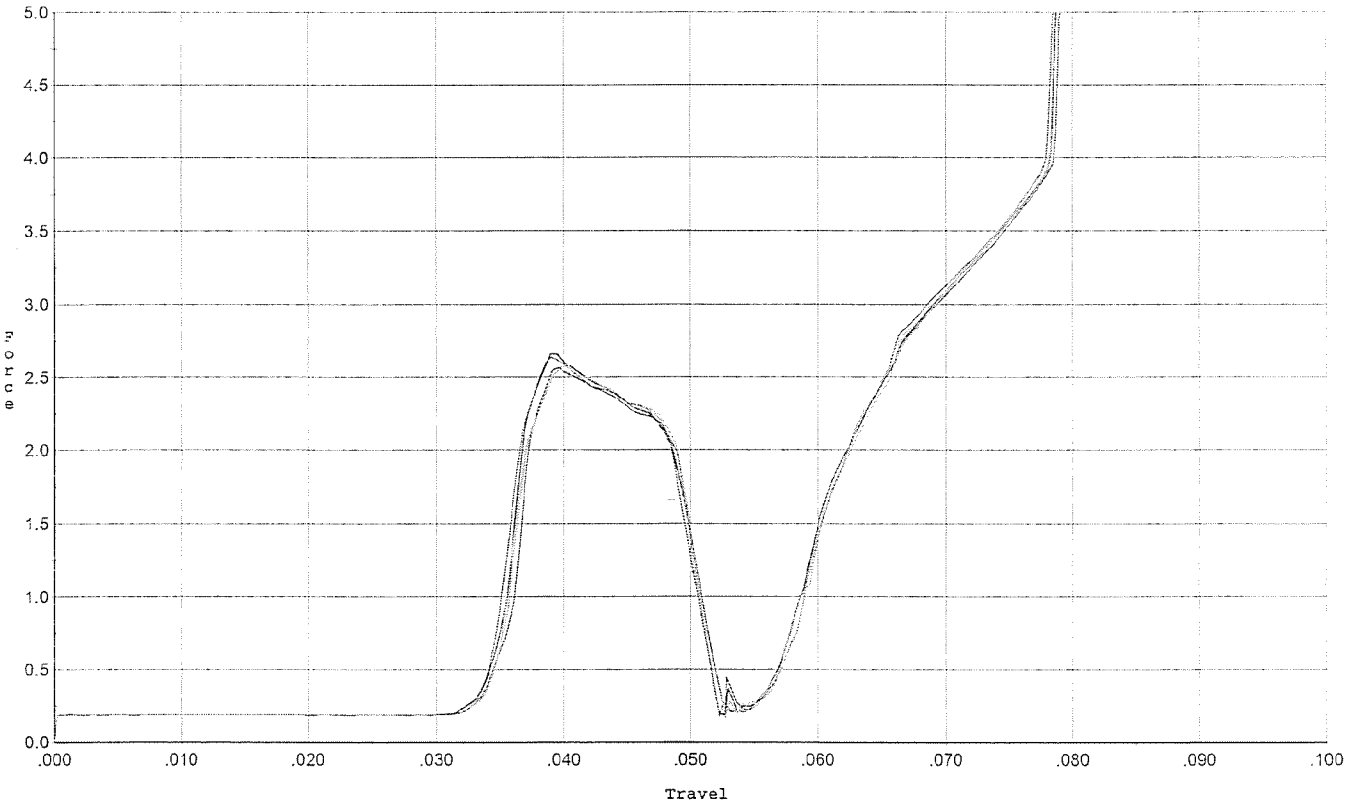
F004 REV 5/2006

OP #	OPERATION NAME BARBER - M24 0171413	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5.75 4.75 4.5	10/2/07	MJM
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	4.25 3.5 4.0	10/2/07	MJM
	H) TRIGGER PULL TEST AND RETAINABILITY		10/2/07	MJM
	I) FIRING PIN INDENT [.020 MIN]	.020 .020 .020	10/2/07	MJM
	J) ASSEMBLE STOCK		9/28/07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		10/2/07	MJM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10/2/07	MJM
	M) IRON SIGHT ALIGNMENT		10/2/07	MJM
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10/2/07	MJM
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	10-1-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-1-07	BWD
670	FINAL INSPECTION A) HEADSPACE		10/2/07	MJM
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	267 266 253 255 248	10/1/07	MJM
	C) FUNCTION		10/2/07	MJM
690	PACK		10/15/07	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. +/- .50 lbs.
Note:	R. Putch 9/17/07		



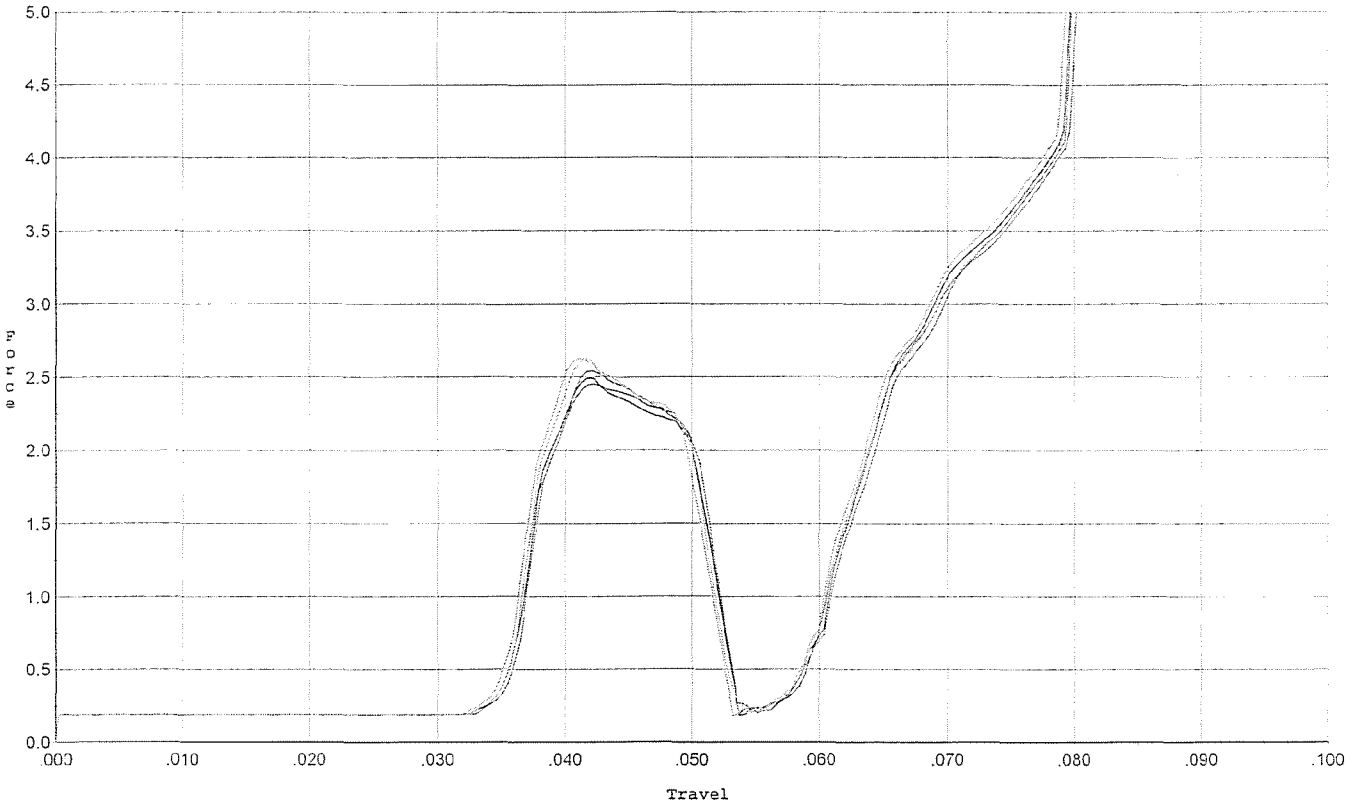
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.568	0.049	0.034	0.036	0.038		Set Trigger
2	2.661	0.049	0.034	0.035	0.040		Set Trigger
3	2.638	0.050	0.033	0.035	0.041		Set Trigger
4	2.555	0.049	0.034	0.035	0.039		Set Trigger
5	2.582	0.049	0.034	0.035	0.039		Set Trigger

Avg 2.60

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:23:49 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 +/- .50 lbs.
Note:	R. Putch 9/17/07		



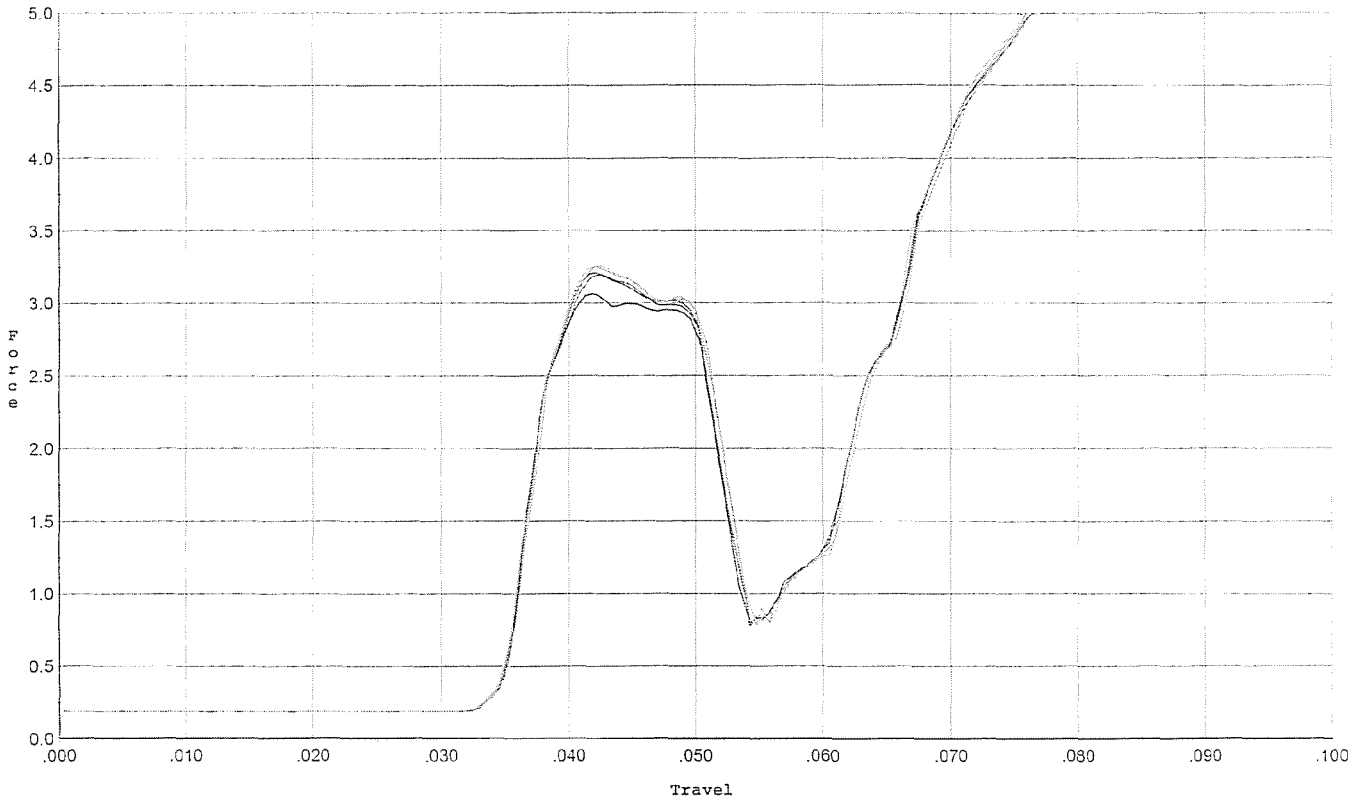
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.453	0.052	0.035	0.035	0.040		Set Trigger
2	2.491	0.051	0.035	0.035	0.039		Set Trigger
3	2.544	0.051	0.035	0.036	0.039		Set Trigger
4	2.631	0.050	0.035	0.036	0.039		Set Trigger
5	2.628	0.051	0.034	0.035	0.041		Set Trigger

AVG 2.54

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:25:39 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 9/17/07		



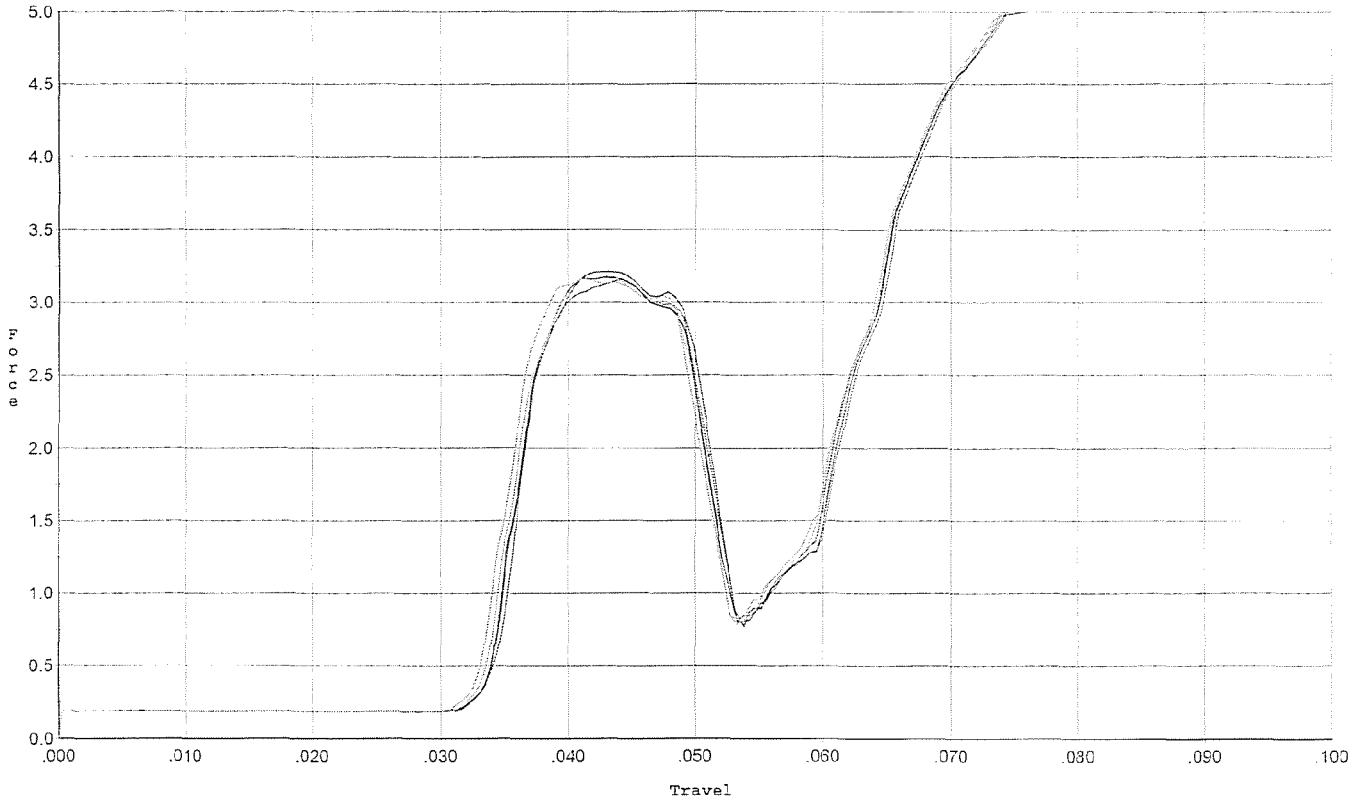
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.209	0.050	0.035	0.034	0.050		Set Trigger
2	3.064	0.050	0.035	0.034	0.049		Set Trigger
3	3.194	0.050	0.035	0.034	0.050		Set Trigger
4	3.253	0.051	0.035	0.034	0.052		Set Trigger
5	3.252	0.051	0.034	0.034	0.053		Set Trigger

Avg 3.19

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:28:01 PM

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 9/17/07		



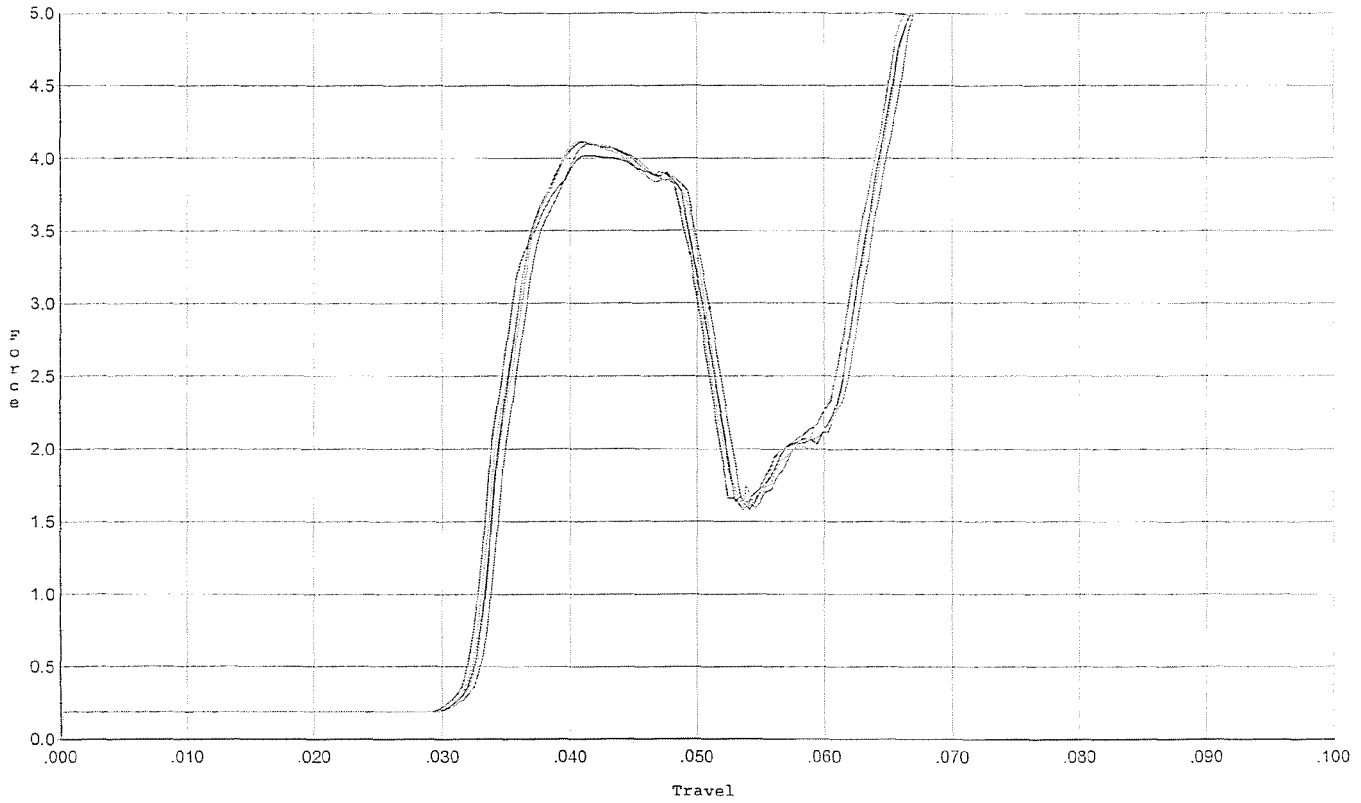
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.214	0.050	0.033	0.033	0.051		Set Trigger
2	3.174	0.049	0.033	0.033	0.050		Set Trigger
3	3.158	0.051	0.034	0.033	0.052		Set Trigger
4	3.160	0.050	0.033	0.033	0.051		Set Trigger
5	3.188	0.049	0.033	0.033	0.051		Set Trigger

Avg 3.17

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:29:20 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 9/17/07		



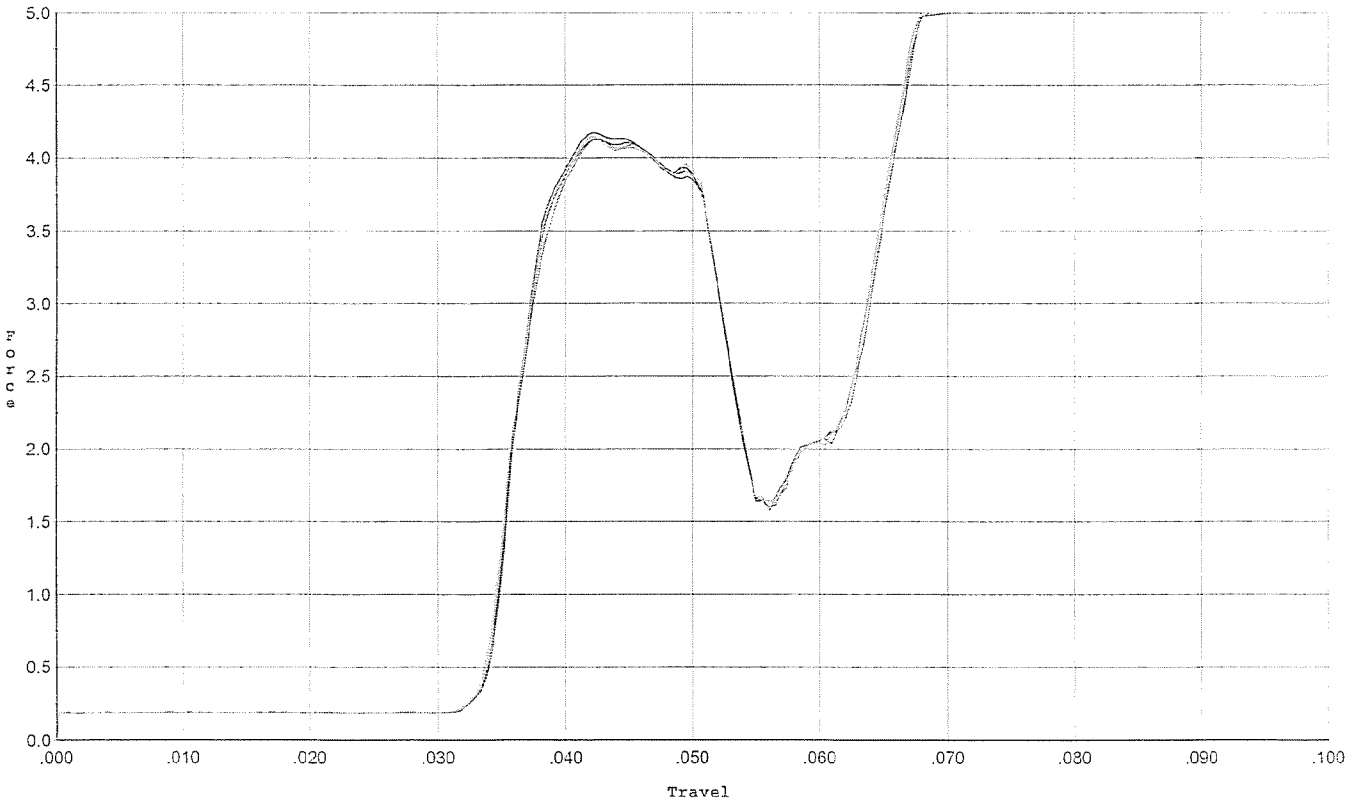
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.017	0.049	0.031	0.029	0.068		Set Trigger
2	4.108	0.051	0.032	0.029	0.070		Set Trigger
3	4.098	0.051	0.033	0.029	0.069		Set Trigger
4	4.127	0.050	0.032	0.029	0.068		Set Trigger
5	4.116	0.049	0.032	0.030	0.067		Set Trigger

AVG 4.09

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:30:56 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 +/- 1.0 lbs.
Note:	R. Putch 9/17/07		



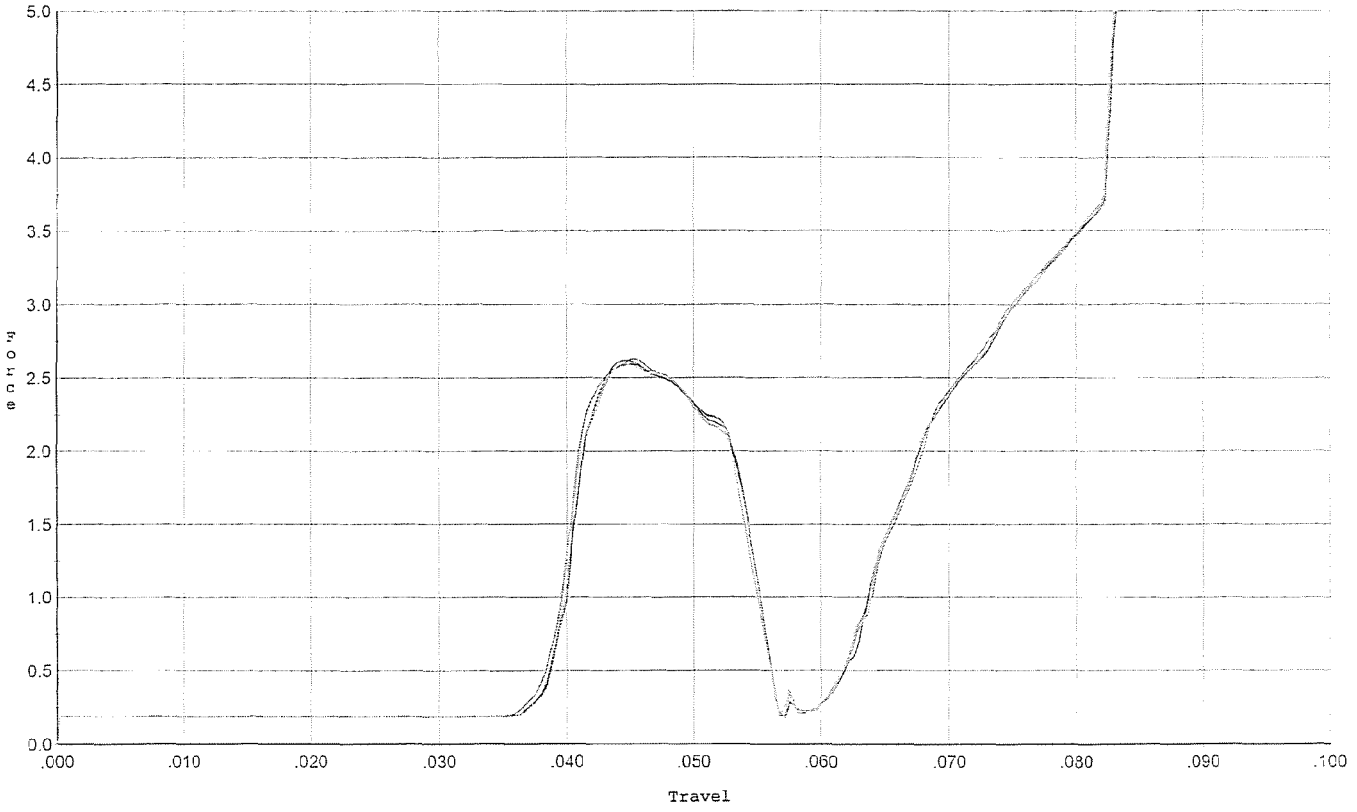
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.126	0.051	0.034	0.029	0.069		Set Trigger
2	4.175	0.051	0.033	0.029	0.070		Set Trigger
3	4.131	0.051	0.034	0.029	0.069		Set Trigger
4	4.155	0.051	0.033	0.029	0.070		Set Trigger
5	4.144	0.051	0.033	0.029	0.070		Set Trigger

Avg 4.14

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:32:33 PM

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 9/17/07		



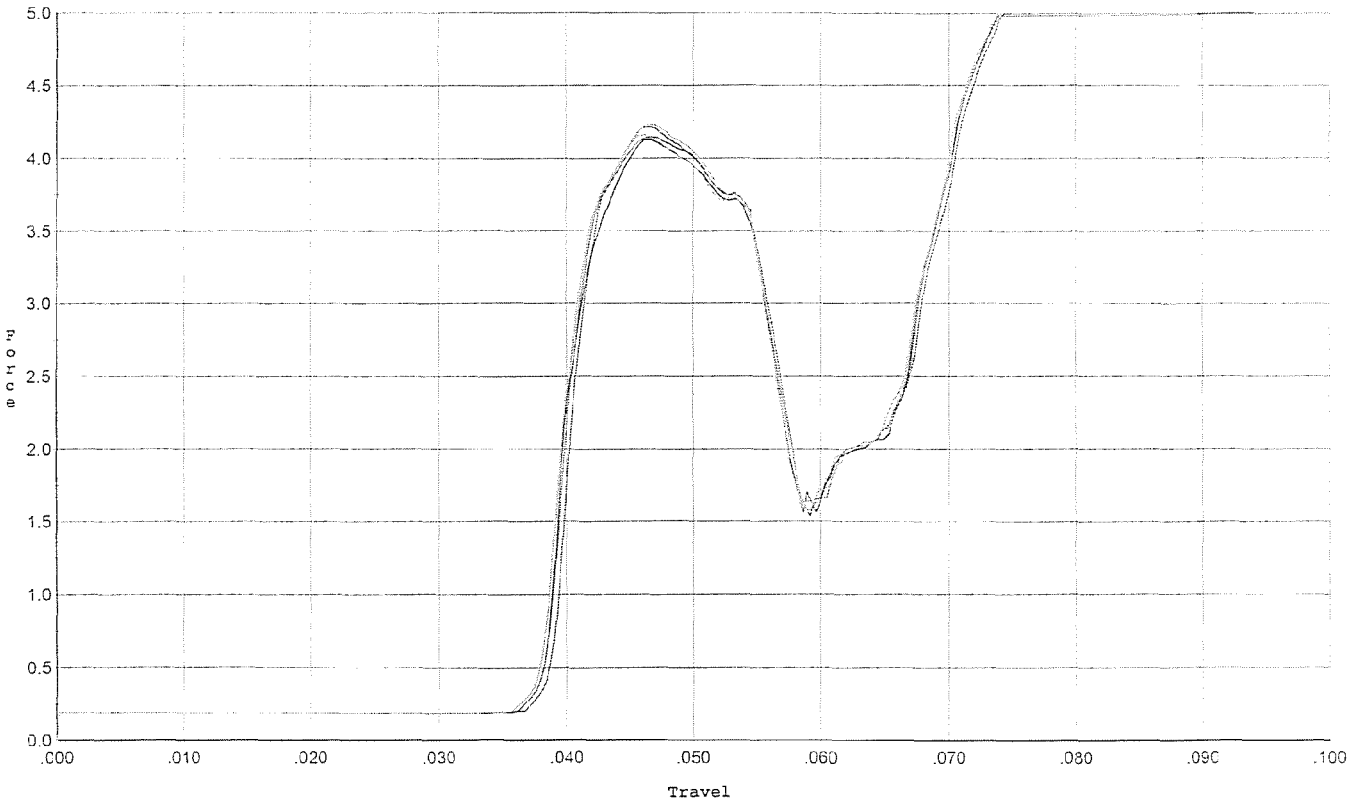
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.054	0.038	0.036	0.041		Set Trigger
2	2.592	0.054	0.038	0.036	0.041		Set Trigger
3	2.628	0.054	0.038	0.036	0.042		Set Trigger
4	2.592	0.054	0.038	0.036	0.041		Set Trigger
5	2.596	0.053	0.038	0.037	0.040		Set Trigger

AVG 2.60

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:38:28 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 9/17/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.146	0.055	0.038	0.032	0.067		Set Trigger
2	4.128	0.055	0.038	0.032	0.068		Set Trigger
3	4.218	0.056	0.038	0.031	0.072		Set Trigger
4	4.163	0.055	0.037	0.032	0.069		Set Trigger
5	4.236	0.055	0.037	0.032	0.070		Set Trigger

Avg 4.17

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 9/17/2007 3:40:02 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645318.__1
FILE DATE AND TIME: 10/01/2007 20:30

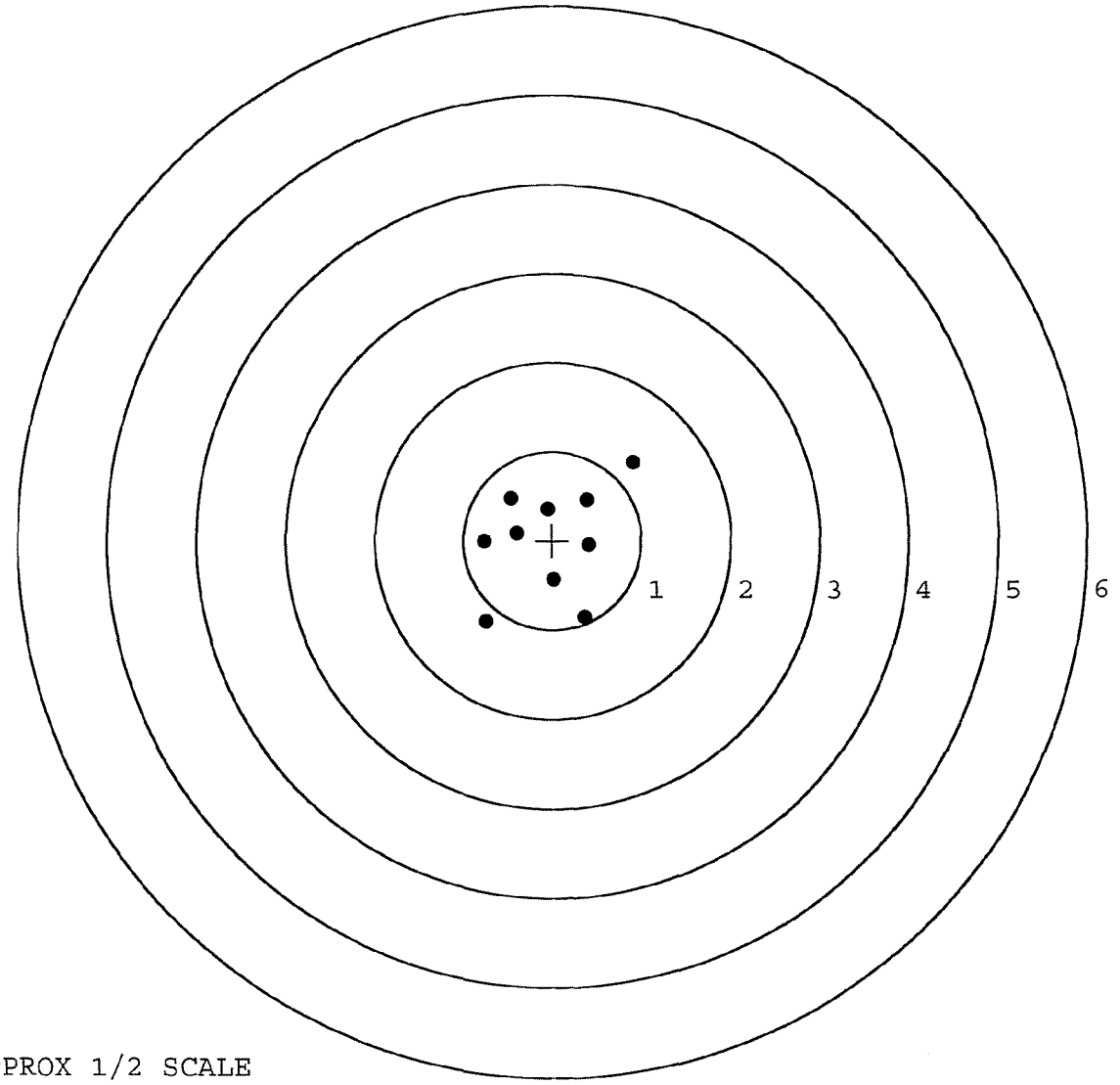
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	0.004
The Average Point of Impact of the Five Target Set:	0.012
The Average Mean Radius of the Five Target Set:	0.551
The Distance from POA to Centroid Target #1:	0.034
The Distance from Centroid Target #2 to Centroid Target #1:	0.114
The Distance from Centroid Target #3 to Centroid Target #1:	0.093
The Distance from Centroid Target #4 to Centroid Target #1:	0.107
The Distance from Centroid Target #5 to Centroid Target #1:	0.111

SERIAL NUMBER: G6645318.__1
TARGET NUMBER: 1
FILE DATE: 10/01/2007
FILE TIME: 20:30

X CENTROID:	-0.033
Y CENTROID:	-0.005
POA TO CENTROID:	0.034
HORZ SPREAD:	1.672
VERT SPREAD:	1.785
GROUP SPREAD:	2.436
MIN RADIUS:	0.357
MAX RADIUS:	1.289
MEAN RADIUS:	0.702
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.910	0.874
2:	0.389	0.455
3:	0.419	-0.050
4:	0.016	-0.445
5:	0.360	-0.866
6:	-0.748	-0.911
7:	-0.762	-0.010
8:	-0.401	0.086
9:	-0.463	0.468
10:	-0.055	0.352

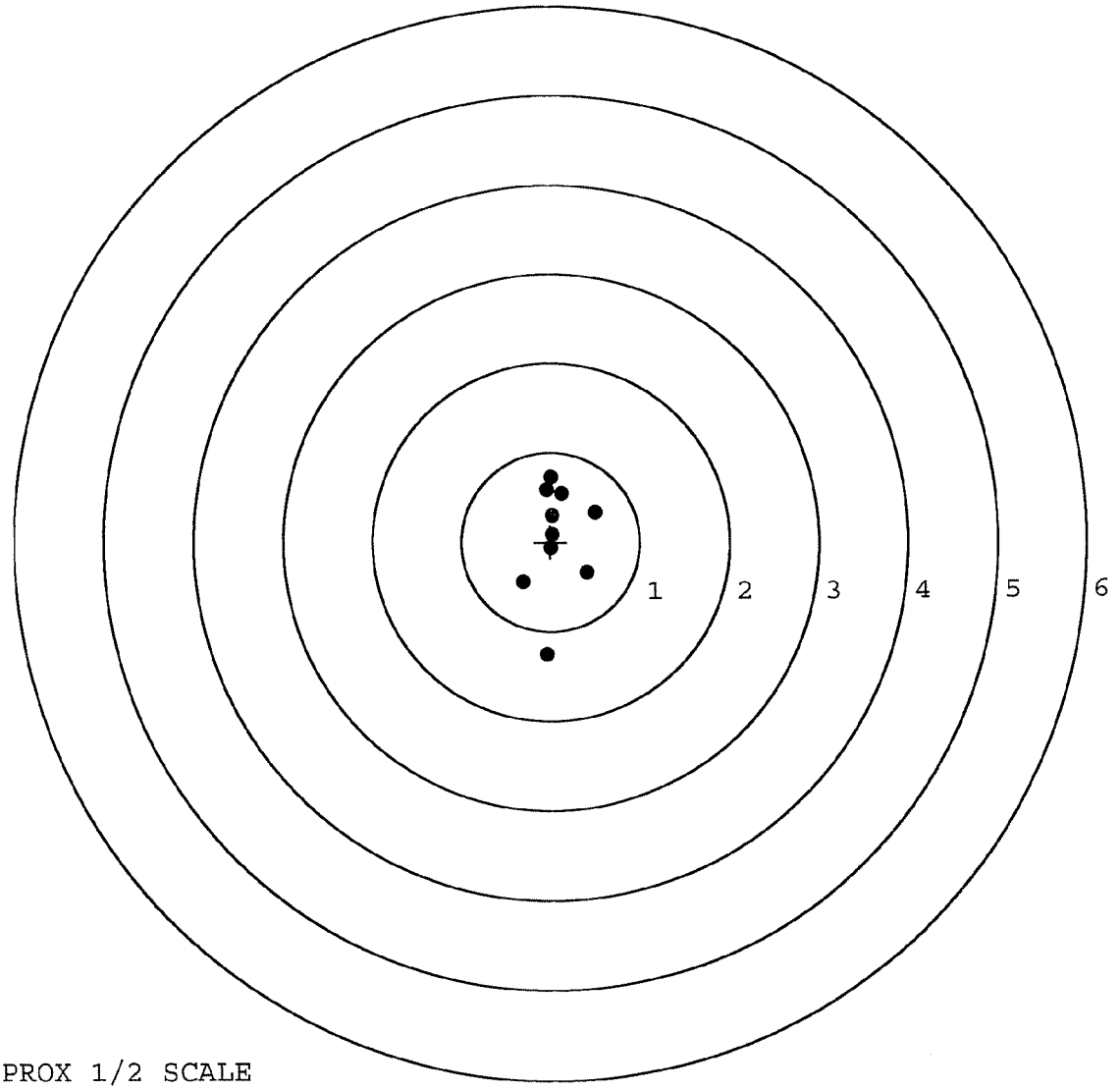


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645318.__1
TARGET NUMBER: 2
FILE DATE: 10/01/2007
FILE TIME: 20:30

X CENTROID:	0.070
Y CENTROID:	0.043
POA TO CENTROID:	0.082
HORZ SPREAD:	0.809
VERT SPREAD:	1.988
GROUP SPREAD:	1.989
MIN RADIUS:	0.064
MAX RADIUS:	1.314
MEAN RADIUS:	0.515
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.049	-1.265
2:	-0.308	-0.450
3:	0.410	-0.343
4:	0.501	0.330
5:	0.025	0.298
6:	0.004	-0.068
7:	-0.045	0.580
8:	0.010	0.723
9:	0.132	0.543
10:	0.020	0.083

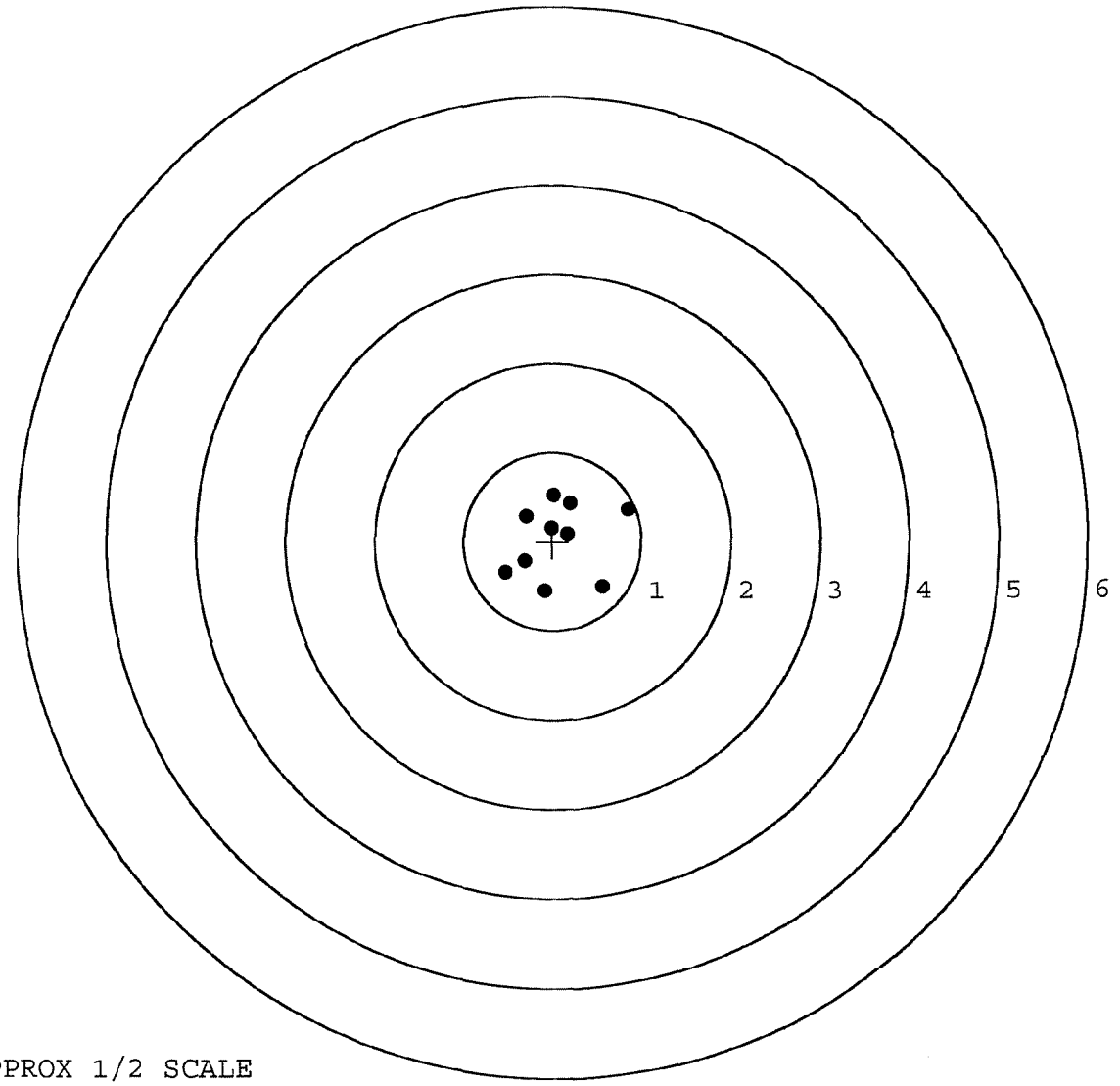


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645318.__1
TARGET NUMBER: 3
FILE DATE: 10/01/2007
FILE TIME: 20:30

X CENTROID:	0.056
Y CENTROID:	0.019
POA TO CENTROID:	0.059
HORZ SPREAD:	1.379
VERT SPREAD:	1.087
GROUP SPREAD:	1.551
MIN RADIUS:	0.136
MAX RADIUS:	0.861
MEAN RADIUS:	0.500
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.848	0.358
2:	0.562	-0.511
3:	-0.092	-0.562
4:	0.017	0.525
5:	0.202	0.433
6:	0.175	0.086
7:	-0.300	0.281
8:	-0.007	0.150
9:	-0.310	-0.221
10:	-0.531	-0.351

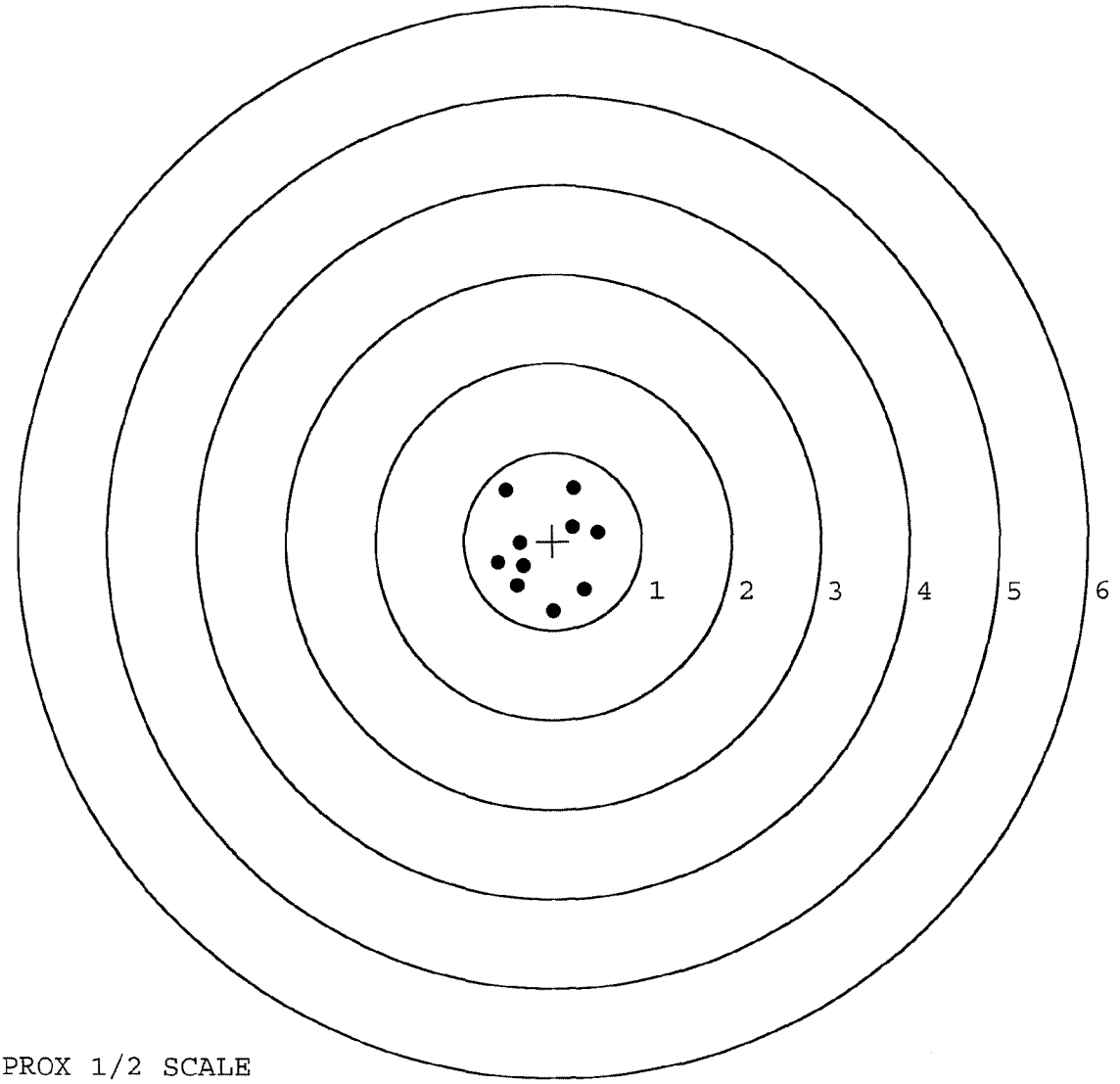


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645318.__1
TARGET NUMBER: 4
FILE DATE: 10/01/2007
FILE TIME: 20:30

X CENTROID:	-0.094
Y CENTROID:	-0.094
POA TO CENTROID:	0.133
HORZ SPREAD:	1.118
VERT SPREAD:	1.386
GROUP SPREAD:	1.460
MIN RADIUS:	0.285
MAX RADIUS:	0.797
MEAN RADIUS:	0.558
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.234	0.598
2:	0.220	0.163
3:	0.503	0.106
4:	0.358	-0.542
5:	-0.005	-0.788
6:	-0.528	0.575
7:	-0.369	-0.020
8:	-0.332	-0.283
9:	-0.405	-0.501
10:	-0.615	-0.244

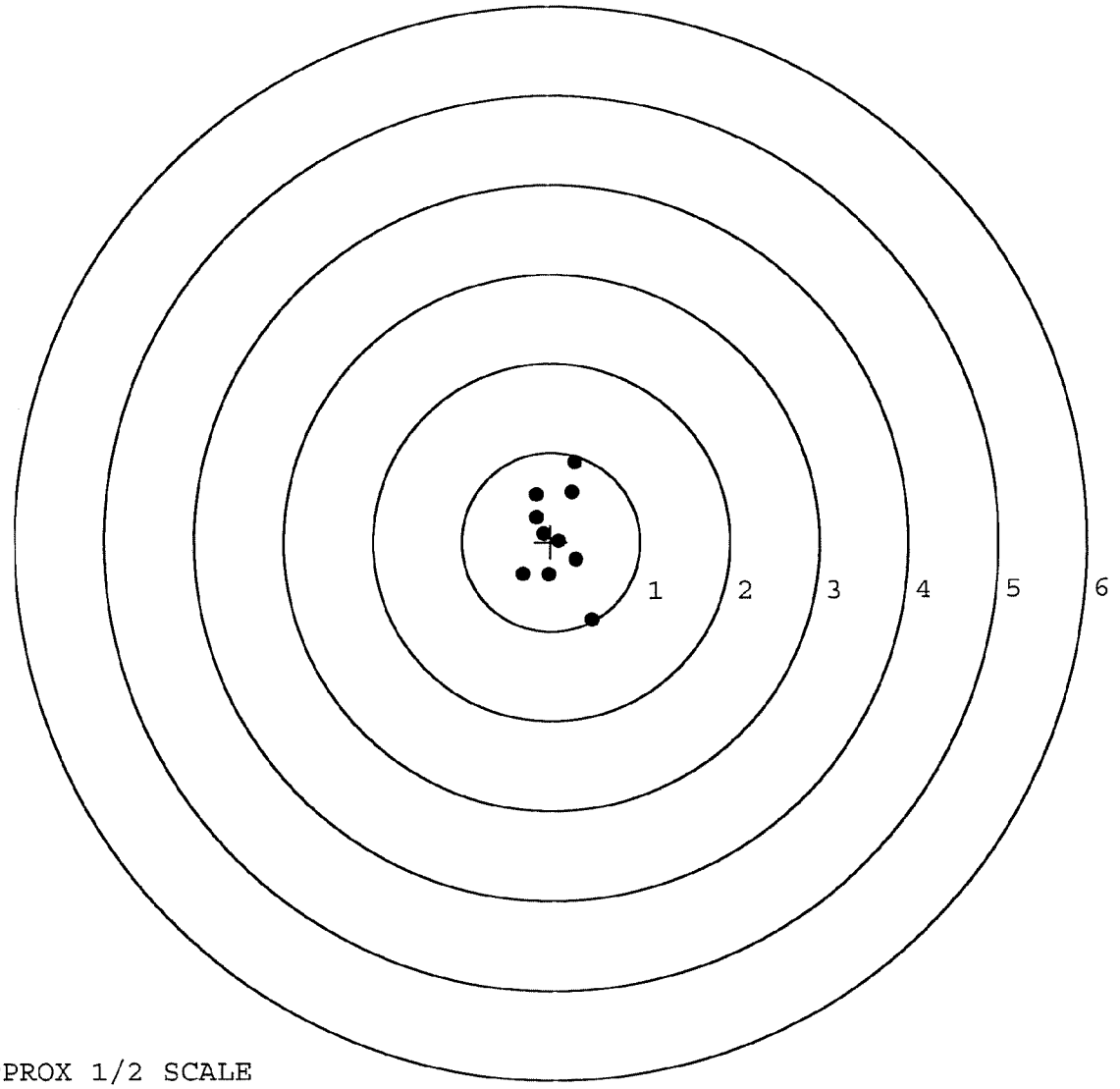


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645318.__1
TARGET NUMBER: 5
FILE DATE: 10/01/2007
FILE TIME: 20:30

X CENTROID:	0.060
Y CENTROID:	0.054
POA TO CENTROID:	0.081
HORZ SPREAD:	0.774
VERT SPREAD:	1.766
GROUP SPREAD:	1.776
MIN RADIUS:	0.052
MAX RADIUS:	1.012
MEAN RADIUS:	0.478
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.276	0.891
2:	0.246	0.556
3:	0.460	-0.875
4:	-0.314	-0.363
5:	-0.027	-0.373
6:	0.282	-0.201
7:	0.090	0.012
8:	-0.082	0.090
9:	-0.162	0.278
10:	-0.166	0.528



TARGET APPROX 1/2 SCALE