

G 6645342

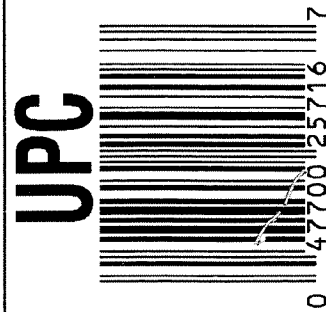
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6645342



BM, FORM

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.



66645342

GUN SERIAL # G6645342

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		7-24-07	SPD
420	ASSEMBLE ACTION		7-16-07	SD
430	ASSEMBLE TO STOCK		7/17/07	nan
440	PROOF		7/17/07	nan
460	CHECK HEADSPACE		7/17/07	nan
470	DIS-ASSEMBLE ACTION		7-24-07	SD
480	MAGNAFLUX BBL ACTION		8/3/07	NRD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/2/07	CW
510	DRILL AND TAP SIGHT HOLES		7-26-07	SD
520	GOFF BLAST BBL / REC		8-9-07	24
530 & 540	APPLY COATINGS (BARREL ACTION)		8-19-07	um
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-17-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-17-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-17-07	SD
	D) OIL FIRING PIN ASSEMBLY		8/21/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
		2.50 LBS +/- .5 LBS		

F004 REV 5/2006

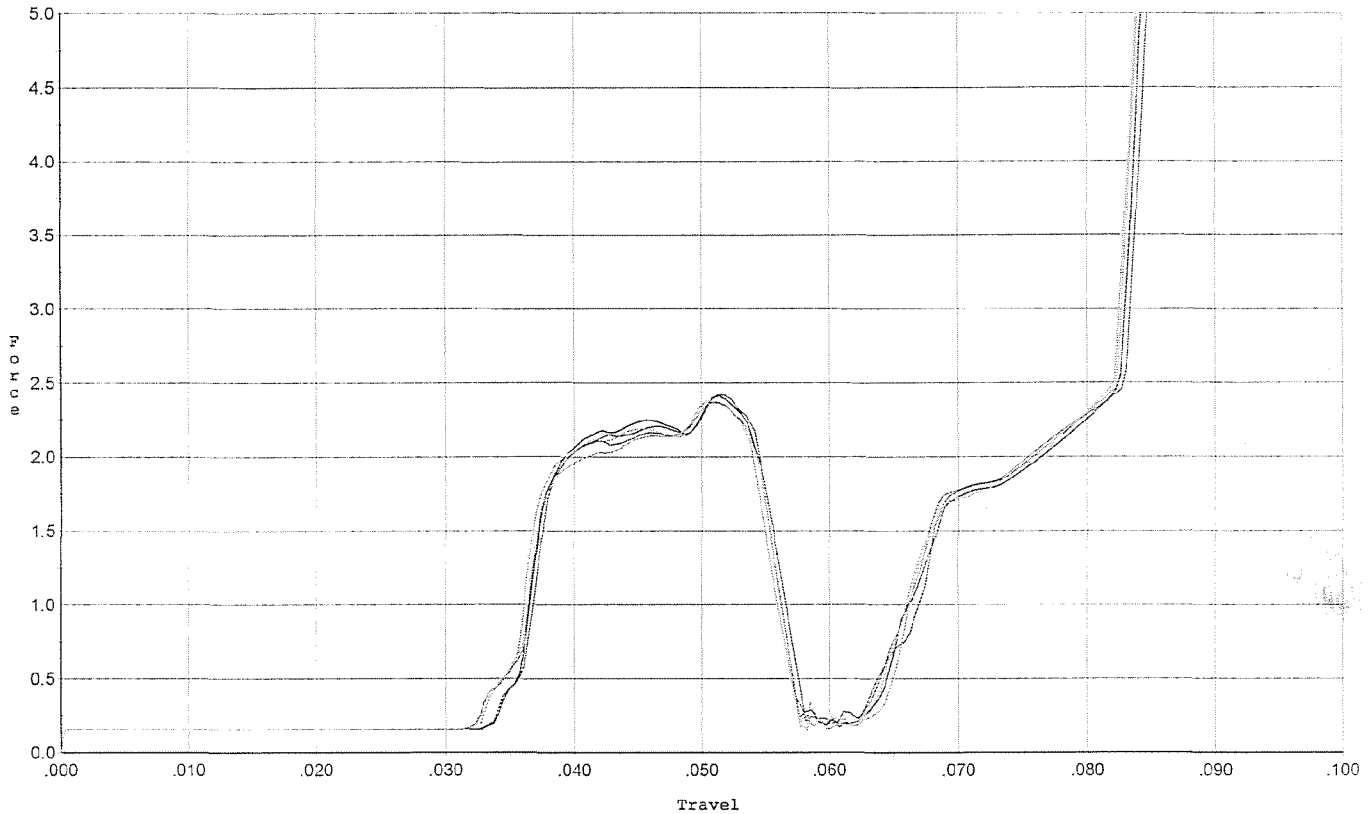
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.75</u> <u>6.5</u>	9/5/07	non
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.75</u> <u>5.25</u>	9/5/07	non
	H) TRIGGER PULL TEST AND RETAINABILITY		9/5/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	9/5/07	non
	J) ASSEMBLE STOCK		8/21/07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		9/5/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9/6/07	S.P.D.
	M) IRON SIGHT ALIGNMENT		9/6/07	S.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9/6/07	S.P.D.
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	9-5-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-5-07	DR
670	FINAL INSPECTION A) HEADSPACE		9/5/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.73</u> <u>2.61</u> <u>2.38</u> <u>2.60</u>	9/5/07	RP
	C) FUNCTION		9/5/07	non
690	PACK		9-2-07	DR

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/8/07

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



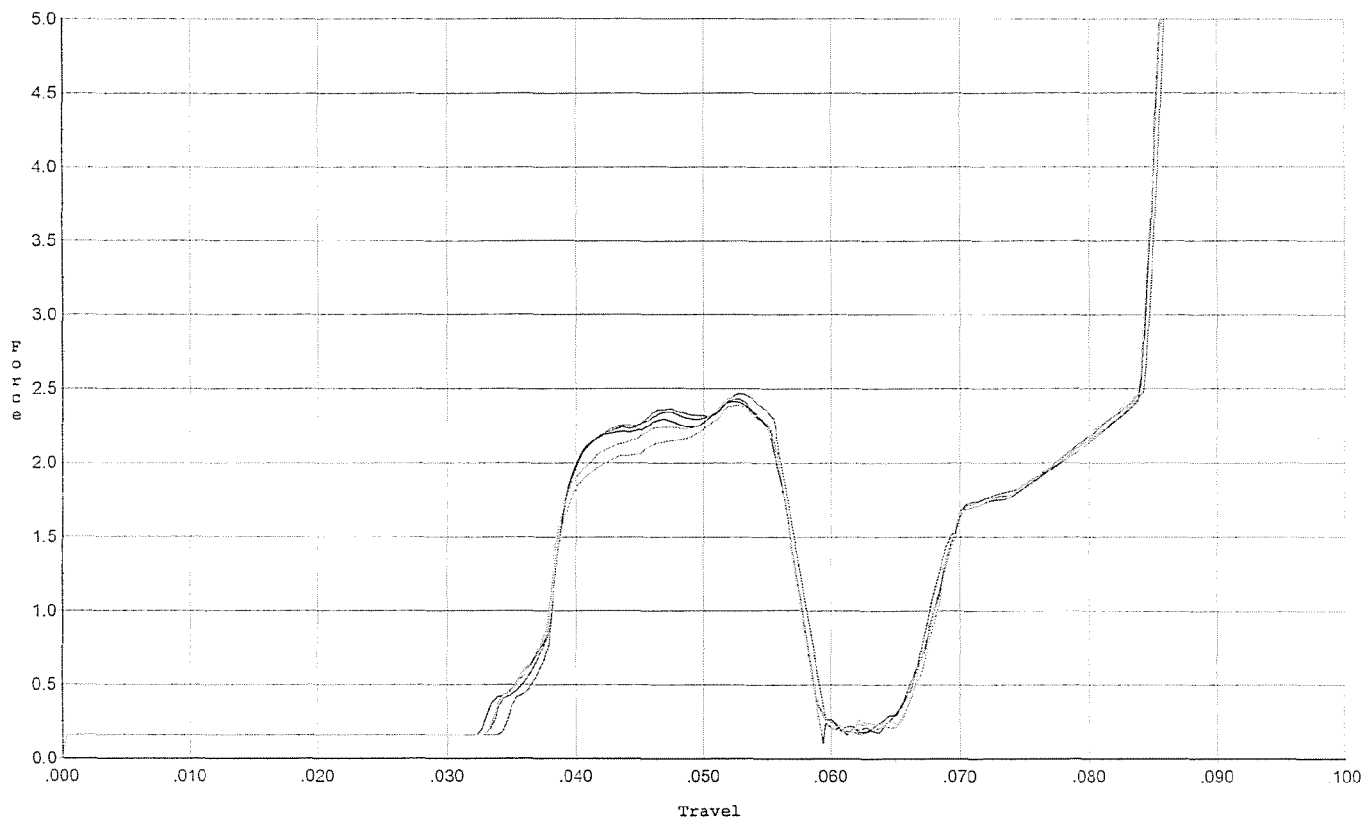
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.056	0.034	0.036	0.047		Set Trigger
2	2.415	0.054	0.034	0.036	0.046		Set Trigger
3	2.374	0.055	0.033	0.036	0.046		Set Trigger
4	2.378	0.054	0.033	0.036	0.045		Set Trigger
5	2.365	0.055	0.033	0.036	0.046		Set Trigger

AVG 2.39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



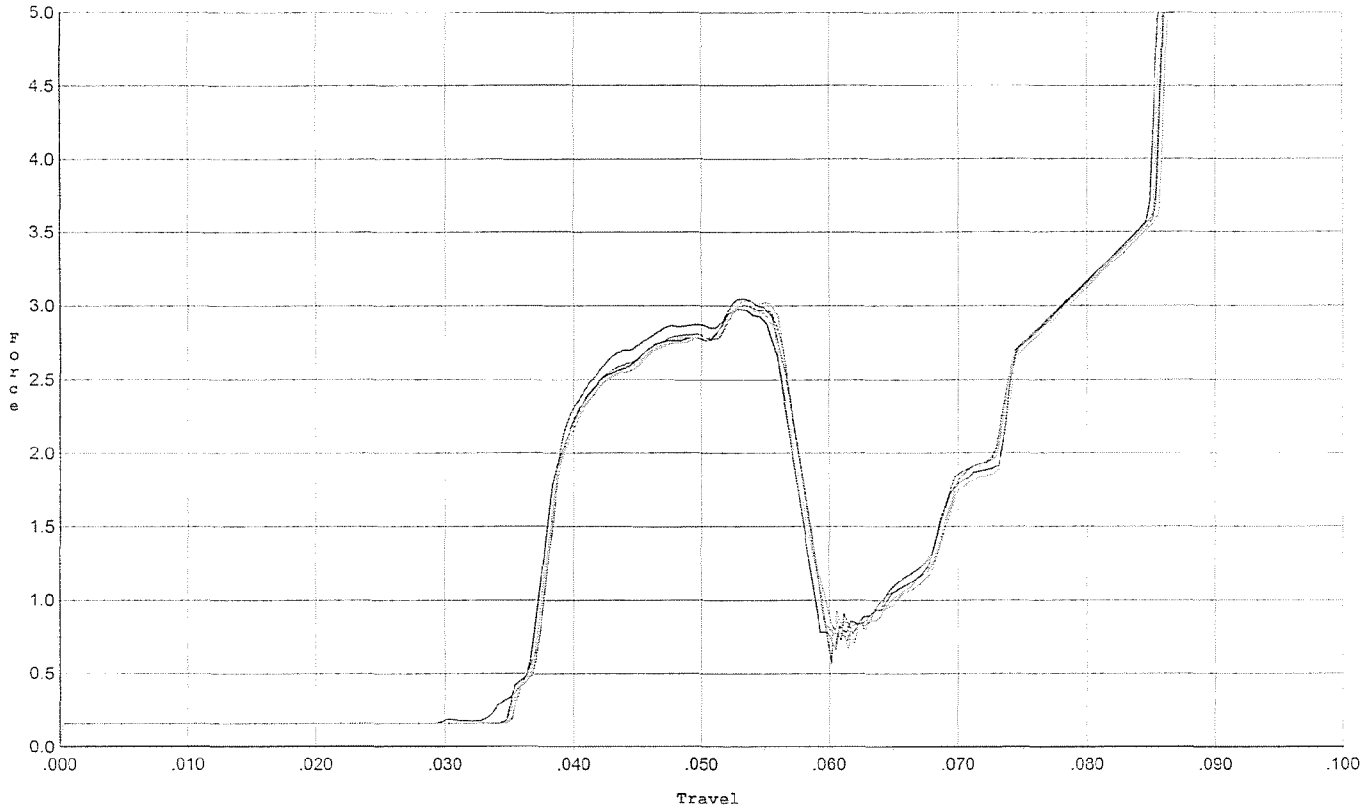
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.427	0.056	0.034	0.036	0.048		Set Trigger
2	2.415	0.056	0.033	0.036	0.048		Set Trigger
3	2.469	0.057	0.035	0.035	0.050		Set Trigger
4	2.444	0.056	0.034	0.036	0.048		Set Trigger
5	2.385	0.056	0.034	0.036	0.046		Set Trigger

Aug 2.42

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



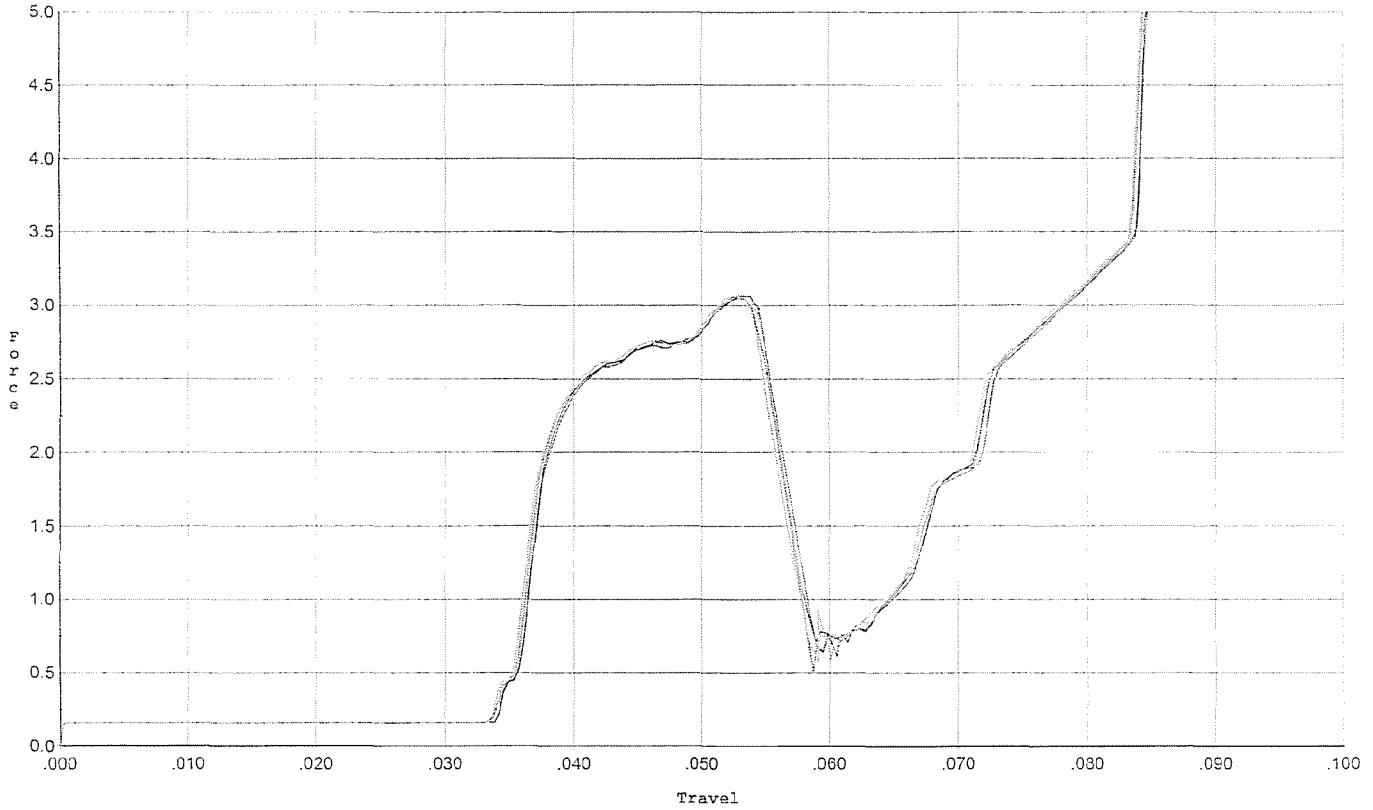
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.057	0.034	0.035	0.060		Set Trigger
2	2.976	0.056	0.035	0.035	0.057		Set Trigger
3	3.005	0.056	0.036	0.035	0.058		Set Trigger
4	2.996	0.056	0.035	0.035	0.056		Set Trigger
5	3.034	0.056	0.036	0.035	0.057		Set Trigger

Aug 3.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



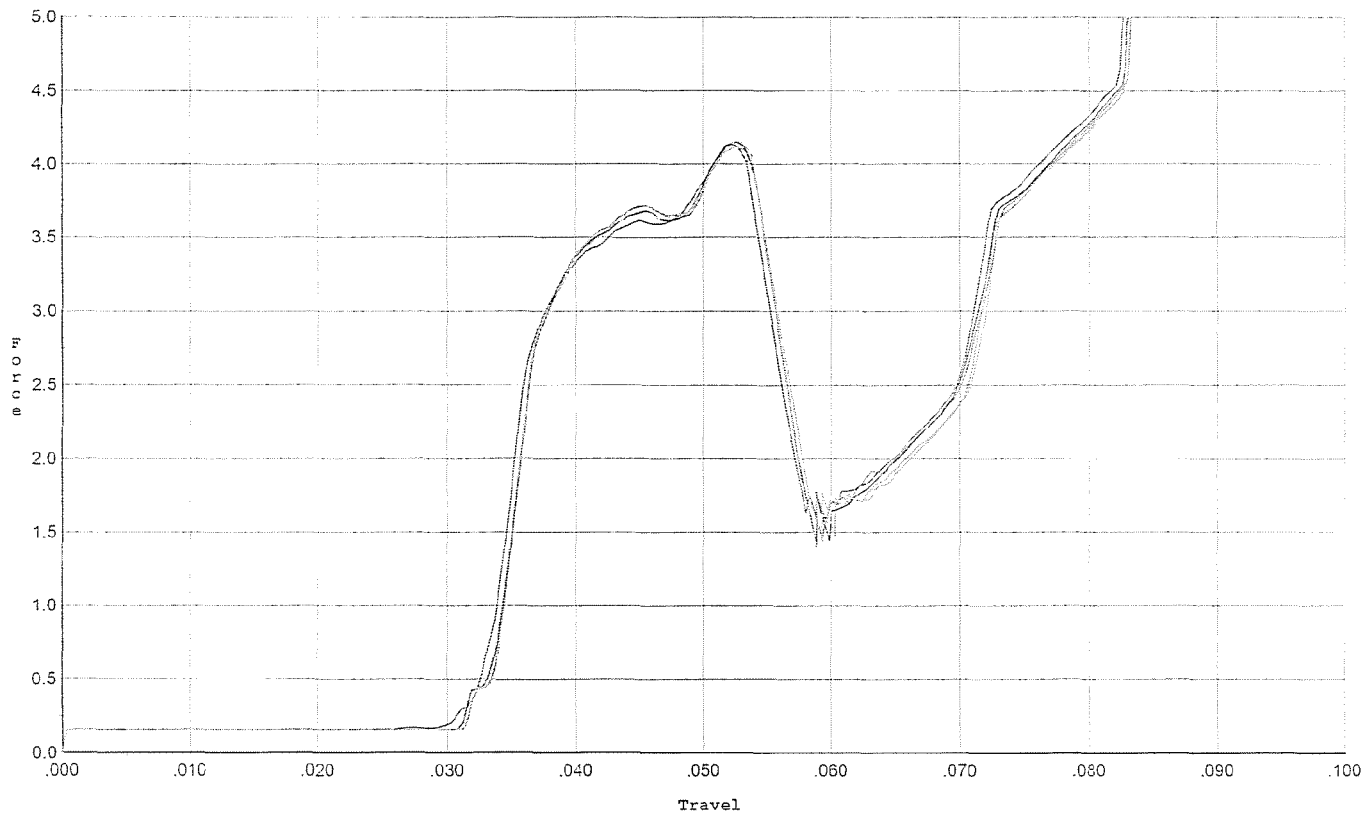
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.068	0.054	0.034	0.035	0.056		Set Trigger
2	3.061	0.055	0.034	0.035	0.056		Set Trigger
3	3.042	0.055	0.034	0.034	0.057		Set Trigger
4	3.059	0.054	0.034	0.035	0.056		Set Trigger
5	3.072	0.055	0.034	0.034	0.057		Set Trigger

AVG 3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



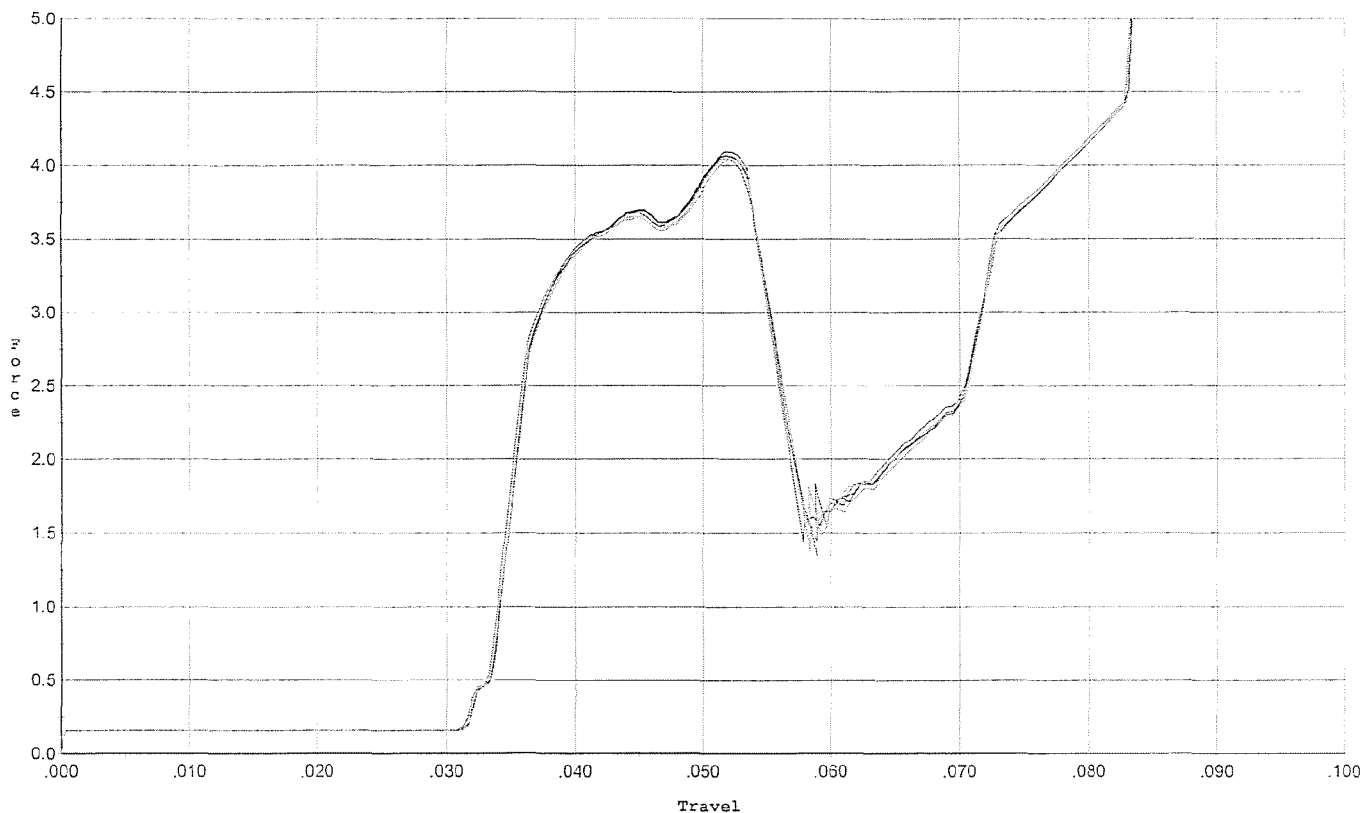
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.053	0.032	0.032	0.077		Set Trigger
2	4.151	0.054	0.032	0.032	0.078		Set Trigger
3	4.120	0.054	0.032	0.032	0.078		Set Trigger
4	4.117	0.054	0.031	0.032	0.078		Set Trigger
5	4.155	0.054	0.032	0.032	0.077		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



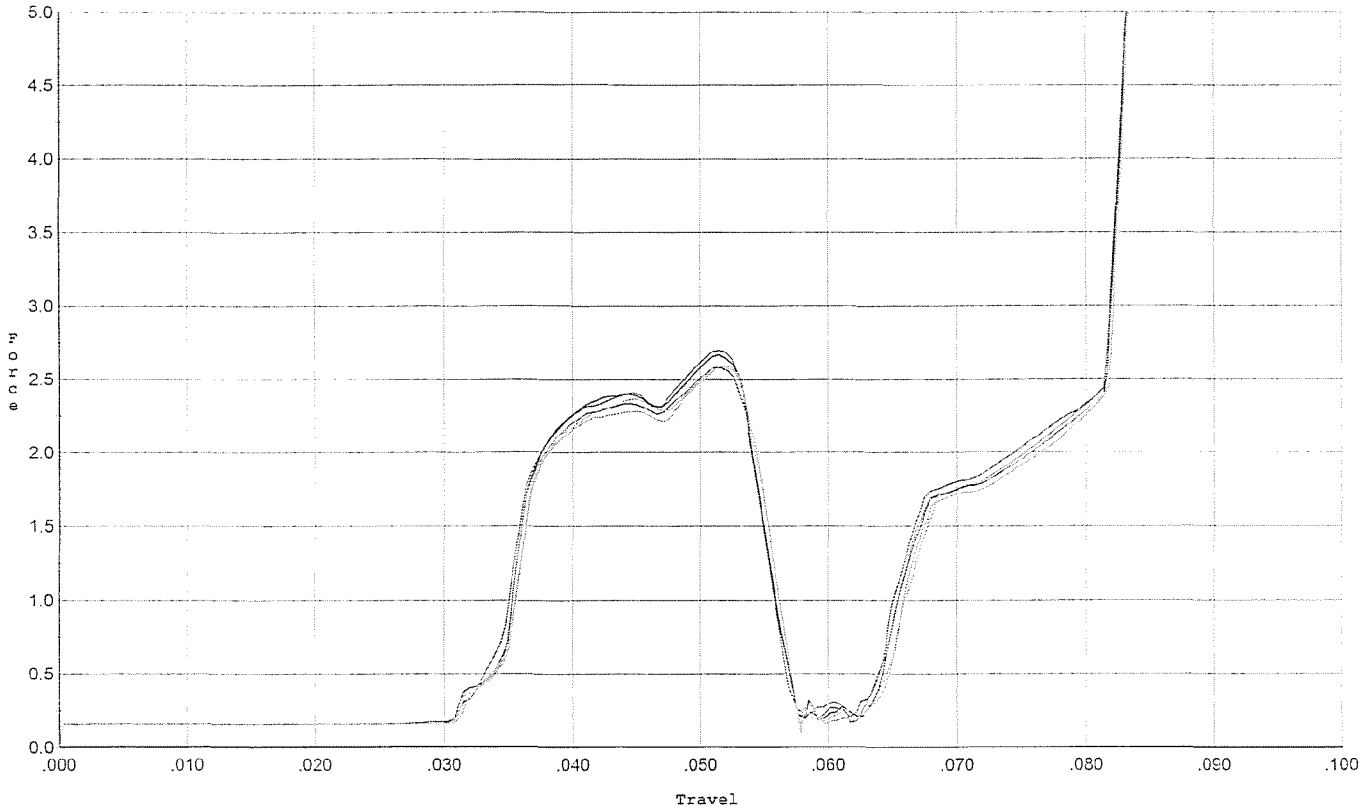
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.053	0.032	0.033	0.077		Set Trigger
2	4.068	0.054	0.032	0.033	0.077		Set Trigger
3	4.046	0.054	0.032	0.033	0.077		Set Trigger
4	4.046	0.056	0.032	0.032	0.079		Set Trigger
5	4.048	0.054	0.032	0.033	0.076		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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



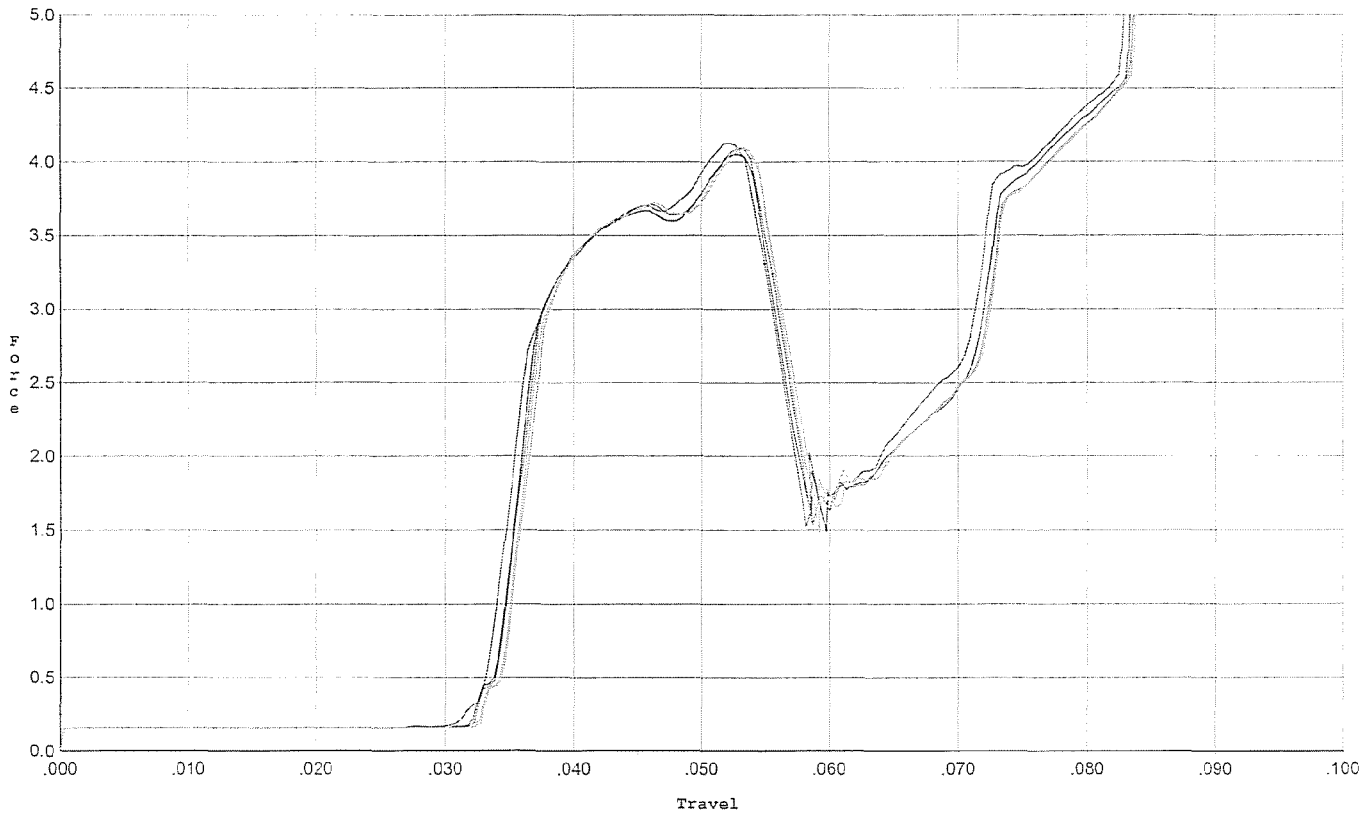
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.053	0.031	0.035	0.051		Set Trigger
2	2.667	0.053	0.031	0.035	0.050		Set Trigger
3	2.580	0.054	0.031	0.035	0.049		Set Trigger
4	2.591	0.054	0.031	0.035	0.050		Set Trigger
5	2.588	0.055	0.032	0.035	0.050		Set Trigger

Avg 2.62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/8/07

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	4.128	0.055	0.032	0.032	0.080		Set Trigger
2	4.055	0.054	0.032	0.032	0.077		Set Trigger
3	4.091	0.056	0.033	0.033	0.080		Set Trigger
4	4.104	0.055	0.033	0.033	0.077		Set Trigger
5	4.087	0.054	0.033	0.033	0.077		Set Trigger

Avg 4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645342. __0

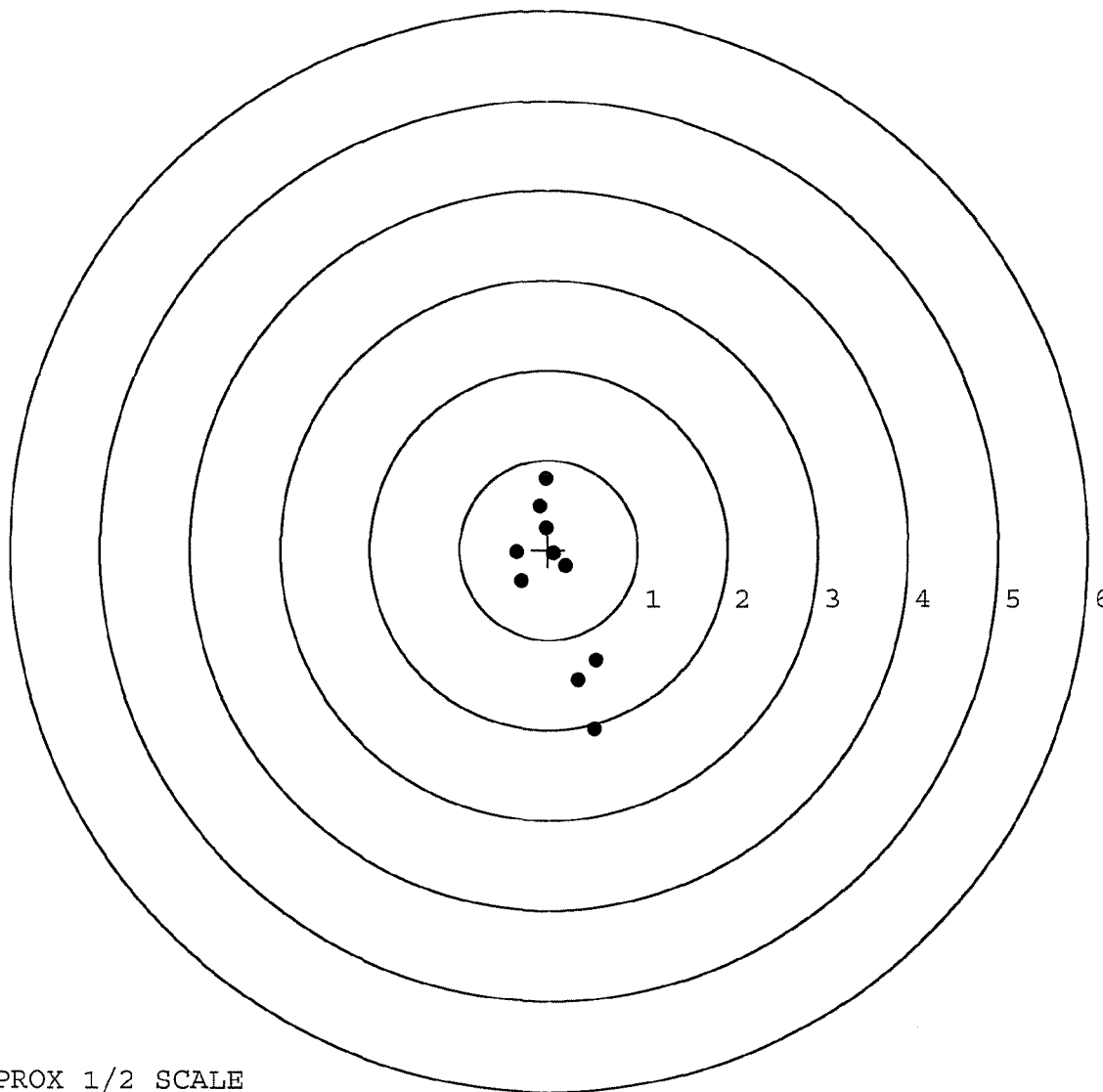
FILE DATE AND TIME: 09/05/2007 15:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.029
The Average Y Centroid of the Five Target Set:	-0.060
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.720
The Distance from POA to Centroid Target #1:	0.386
The Distance from Centroid Target #2 to Centroid Target #1:	0.623
The Distance from Centroid Target #3 to Centroid Target #1:	0.147
The Distance from Centroid Target #4 to Centroid Target #1:	0.265
The Distance from Centroid Target #5 to Centroid Target #1:	0.598

BARBER - M24 0171865

SERIAL NUMBER: G6645342. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	0.519	-1.999
FILE DATE: 09/05/2007	2:	0.328	-1.450
FILE TIME: 15:01	3:	0.529	-1.227
	4:	-0.305	-0.360
X CENTROID: 0.082	5:	-0.355	-0.038
Y CENTROID: -0.377	6:	0.196	-0.183
POA TO CENTROID: 0.386	7:	0.060	-0.044
HORZ SPREAD: 0.884	8:	-0.021	0.245
VERT SPREAD: 2.795	9:	-0.098	0.492
GROUP SPREAD: 2.849	10:	-0.031	0.796
MIN RADIUS: 0.225			
MAX RADIUS: 1.680			
MEAN RADIUS: 0.794			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

BARBER - M24 0171866

SERIAL NUMBER: G6645342. 0

TARGET NUMBER: 2

FILE DATE: 09/05/2007

FILE TIME: 15:01

POINT#	X	Y
1:	0.790	-0.871
2:	0.339	-0.701
3:	-0.476	-0.645
4:	0.426	0.361
5:	-0.105	0.430
6:	-0.452	0.477
7:	-0.424	0.236
8:	-0.705	0.386
9:	0.983	1.175
10:	0.580	1.611

X CENTROID: 0.096

Y CENTROID: 0.246

POA TO CENTROID: 0.264

HORZ SPREAD: 1.688

VERT SPREAD: 2.482

GROUP SPREAD: 2.491

MIN RADIUS: 0.272

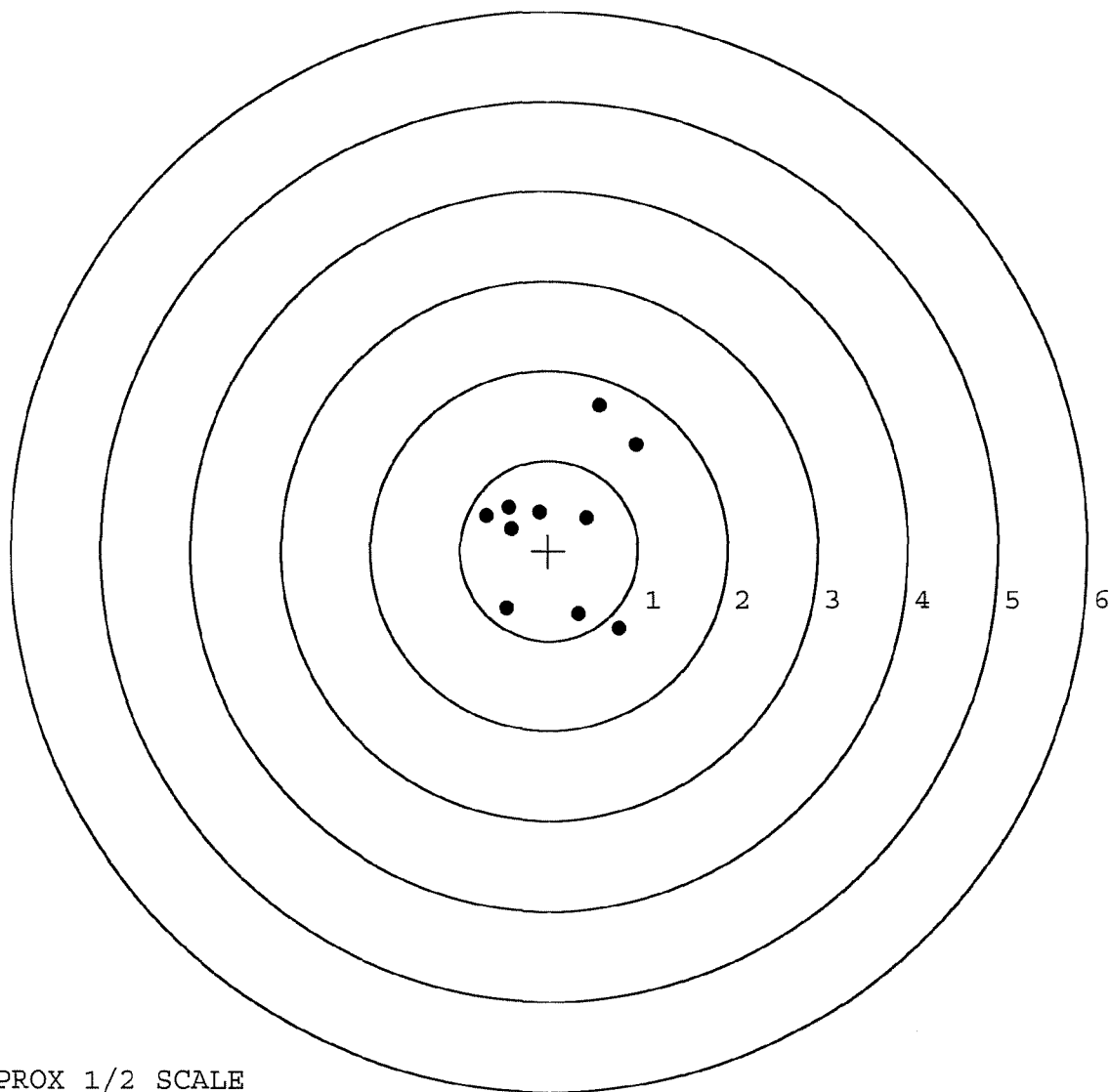
MAX RADIUS: 1.448

MEAN RADIUS: 0.863

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



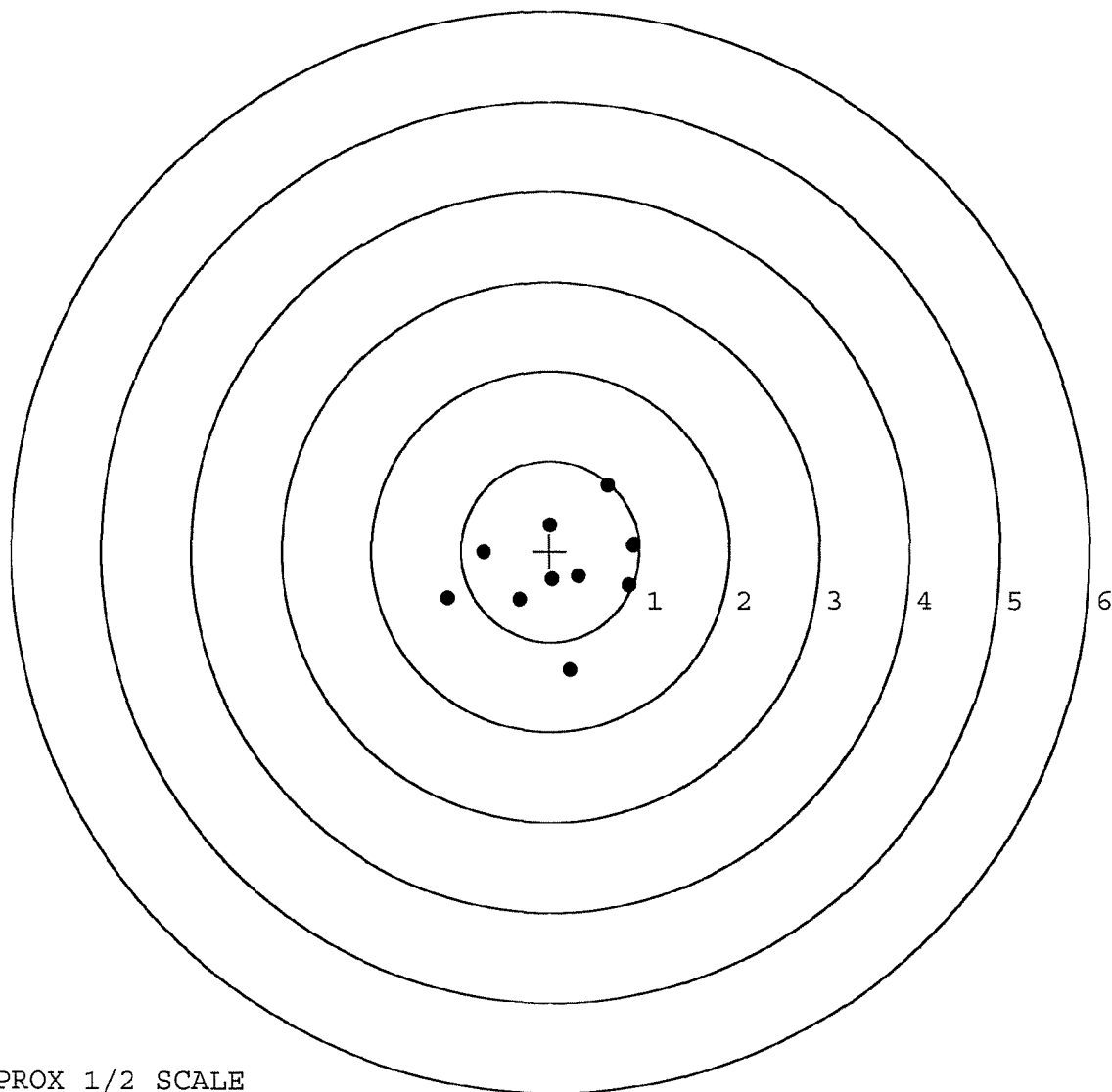
TARGET APPROX 1/2 SCALE

BARBER - M24 0171867

SERIAL NUMBER: G6645342.____0
 TARGET NUMBER: 3
 FILE DATE: 09/05/2007
 FILE TIME: 15:01

POINT#	X	Y
1:	0.221	-1.317
2:	0.883	-0.381
3:	0.934	0.060
4:	0.653	0.727
5:	-0.006	0.287
6:	0.322	-0.274
7:	0.030	-0.311
8:	-0.345	-0.542
9:	-0.740	-0.017
10:	-1.147	-0.533

X CENTROID: 0.080
 Y CENTROID: -0.230
 POA TO CENTROID: 0.244
 HORZ SPREAD: 2.081
 VERT SPREAD: 2.044
 GROUP SPREAD: 2.197
 MIN RADIUS: 0.095
 MAX RADIUS: 1.264
 MEAN RADIUS: 0.743
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0171868

SERIAL NUMBER: G6645342. __0

TARGET NUMBER: 4

FILE DATE: 09/05/2007

FILE TIME: 15:01

POINT#	X	Y
1:	0.004	-1.220
2:	-1.226	-0.251
3:	-0.358	0.353
4:	0.514	0.442
5:	0.499	-0.268
6:	0.223	-0.314
7:	-0.166	-0.212
8:	0.087	-0.116
9:	0.027	0.156
10:	0.262	0.130

X CENTROID: -0.013

Y CENTROID: -0.130

POA TO CENTROID: 0.131

HORZ SPREAD: 1.740

VERT SPREAD: 1.662

GROUP SPREAD: 1.873

MIN RADIUS: 0.101

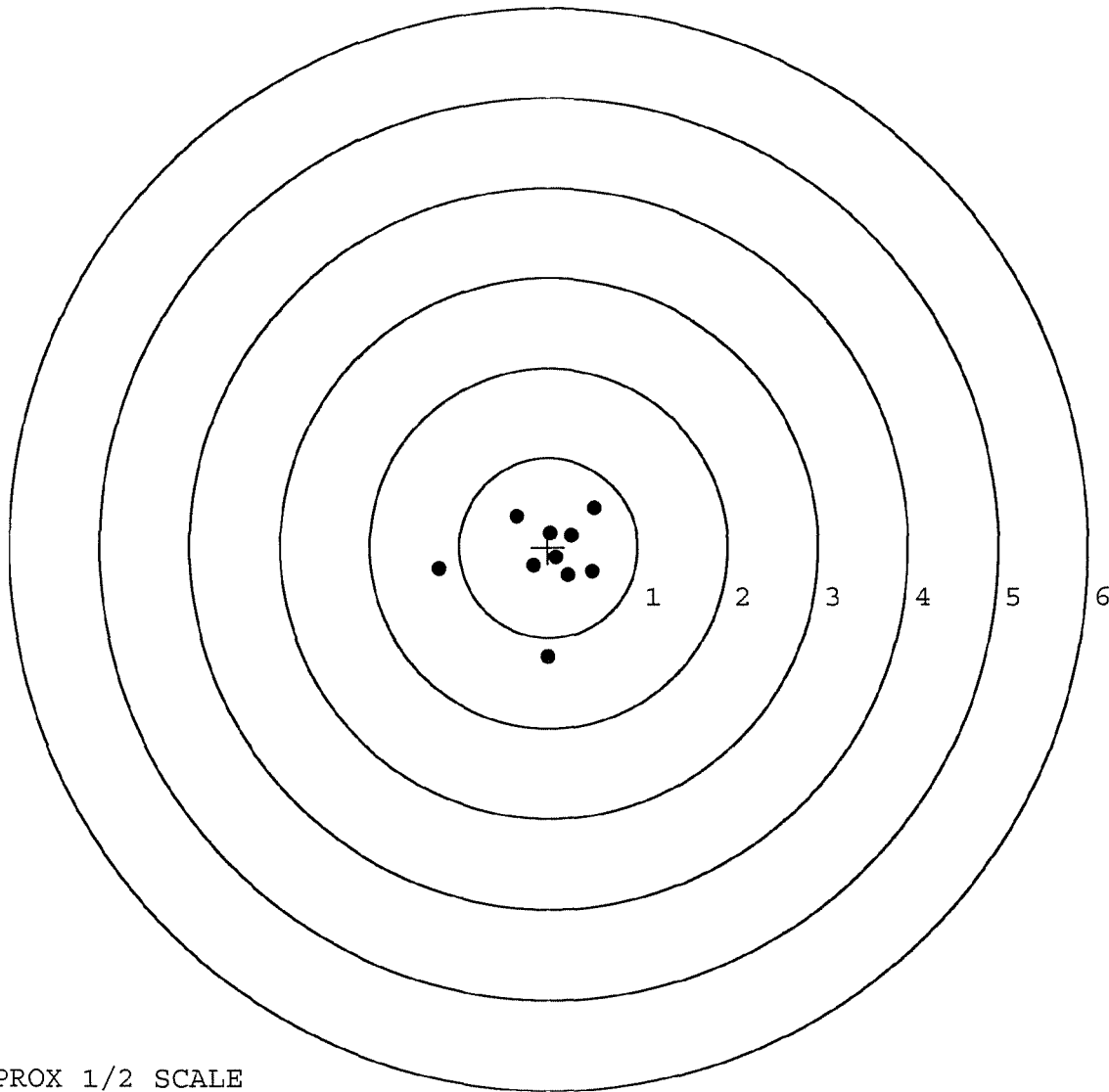
MAX RADIUS: 1.219

MEAN RADIUS: 0.545

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645342. __0

TARGET NUMBER: 5

FILE DATE: 09/05/2007

FILE TIME: 15:01

POINT#	X	Y
1:	0.842	-0.002
2:	0.165	0.341
3:	-0.411	0.236
4:	-0.782	-0.131
5:	-0.307	-0.338
6:	0.335	1.216
7:	-1.262	0.921
8:	-0.011	-0.076
9:	0.114	-0.101
10:	0.302	-0.144

X CENTROID: -0.102

Y CENTROID: 0.192

POA TO CENTROID: 0.217

HORZ SPREAD: 2.104

VERT SPREAD: 1.554

GROUP SPREAD: 2.298

MIN RADIUS: 0.283

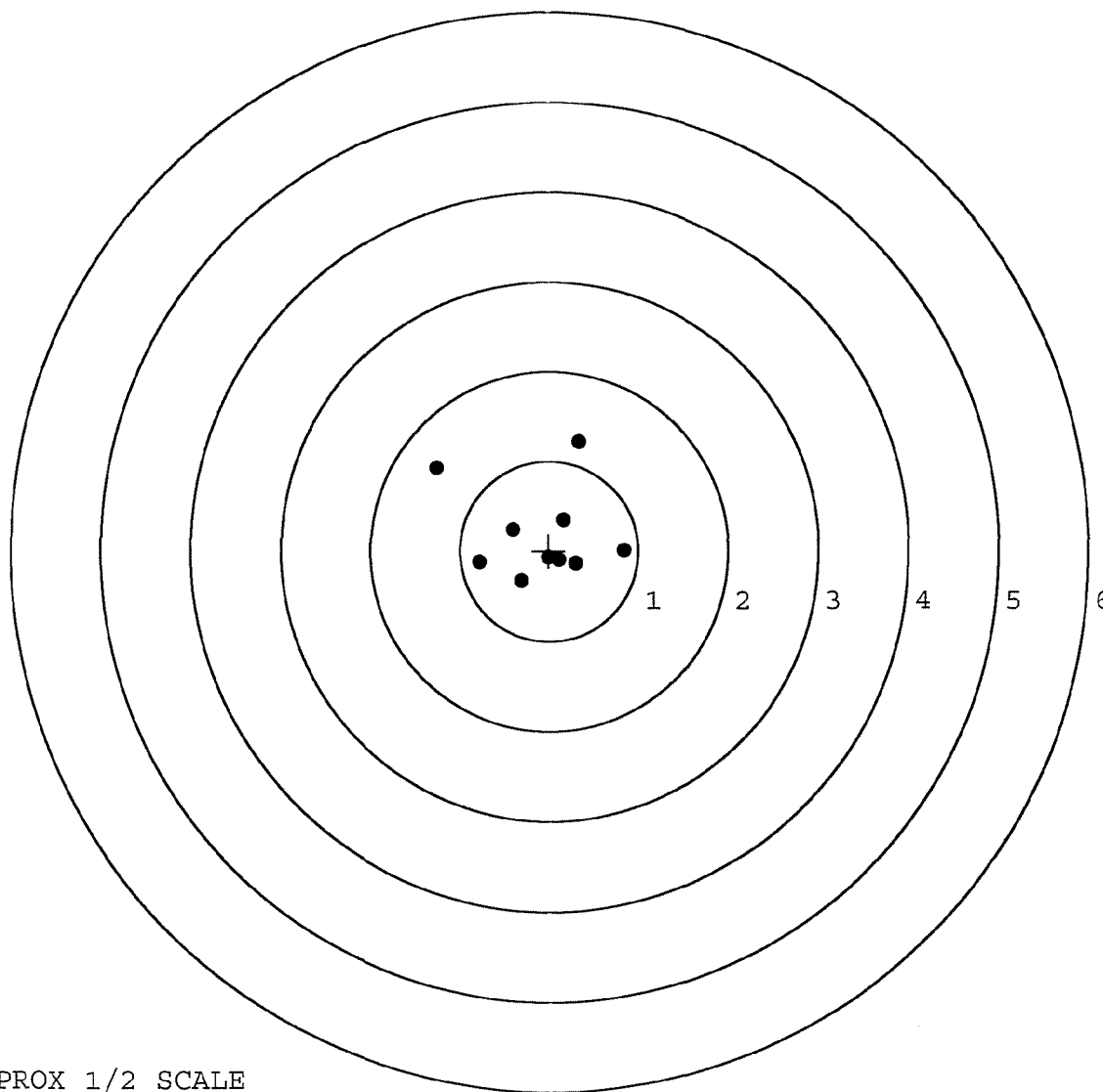
MAX RADIUS: 1.370

MEAN RADIUS: 0.656

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE