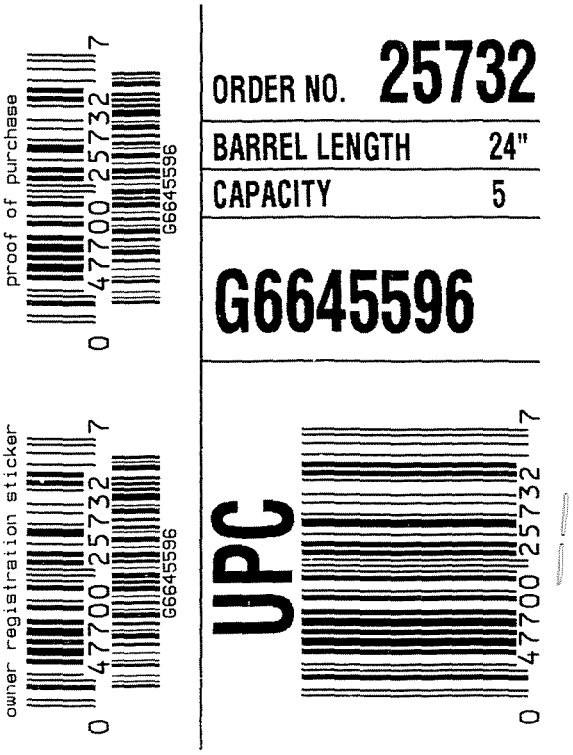
M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

DD FORM 200348



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

SERIAL NO.

 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6645596

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-18-07	RTZ
420	ASSEMBLE ACTION		5-16-07	L.P.D.
430	ASSEMBLE TO STOCK		5-17-07	FM
440	PROOF	MAGNA - FLUX MAY 21 2008 OPERATOR	5-17-07	TRW
460	CHECK HEADSPACE		5-17-07	TRW
470	DIS-ASSEMBLE ACTION		5-18-07	RTZ
480	MAGNAFLUX BBL ACTION		5/25/07	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-24-07	CW
510	DRILL AND TAP SIGHT HOLES		5-21-07	TRW
520	GOFF BLAST BBL / REC		5-22-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/23/07	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		5-30-07	L.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-30-07	L.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-30-07	L.P.D.
	D) OIL FIRING PIN ASSEMBLY		5-30-07	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

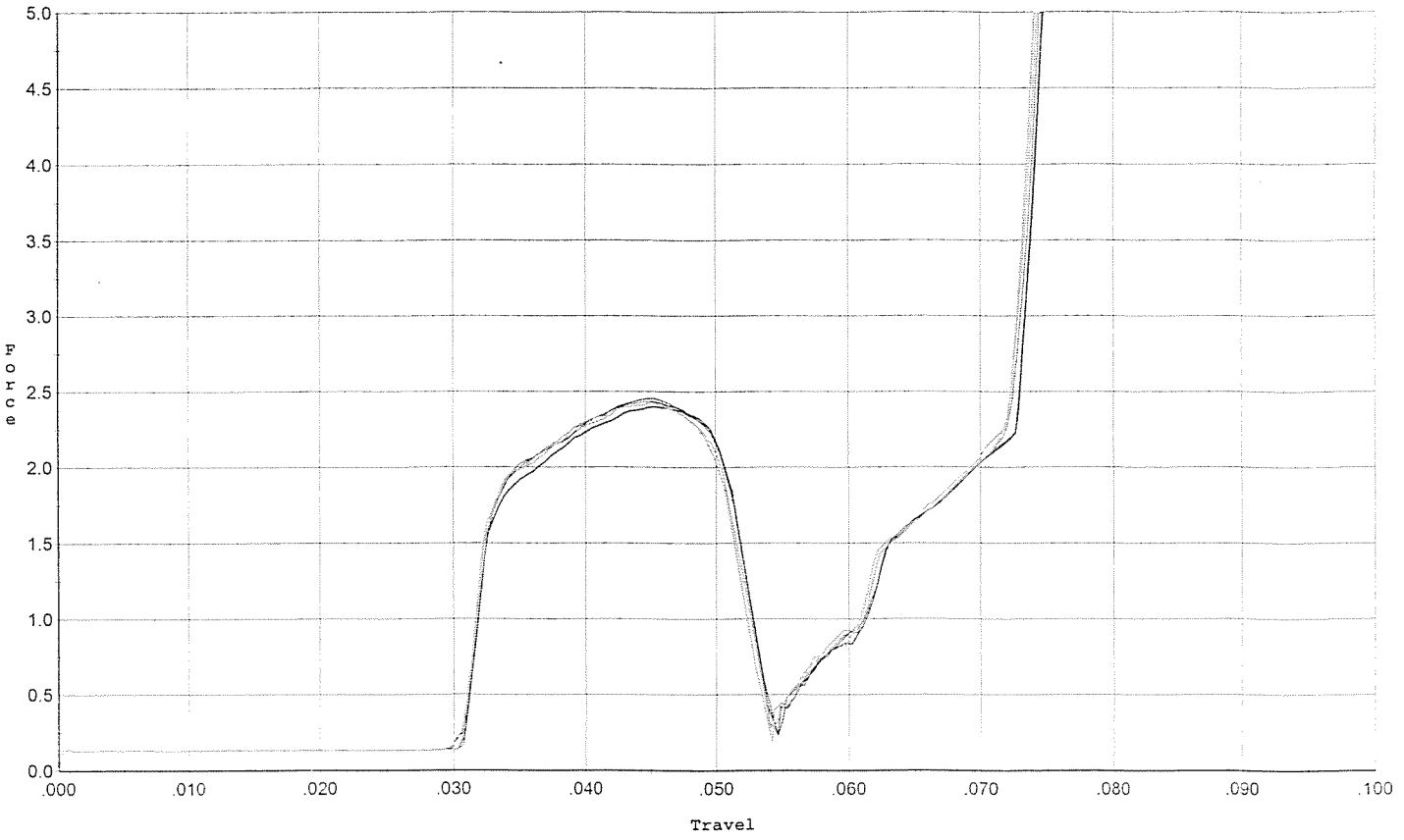
F004 REV 5/2006

560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	6.0	6.0	6.0	6-7-07	Fm
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0	3.5	3.5	6-7-07	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT [.020 MIN]	.024	.023	.024	6-7-07	Fm
	J) ASSEMBLE STOCK				5-30-07	
	K) ASSEMBLE SWIVEL STUDS				6-13-07	
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT					
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL (PASS) FAIL			6/4/07	
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
660	INSPECT FOR LIVE AMMO				6-4-07	SD
670	FINAL INSPECTION A) HEADSPACE				6/8/07	
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.65 2.54 2.54 2.51 2.55 ~~2.83~~ ~~2.32~~ ~~2.08~~ ~~2.07~~			6-7-07	Fm
	C) FUNCTION				6/8/07	
690	PACK				6-14-07	DH

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 5/30/07		

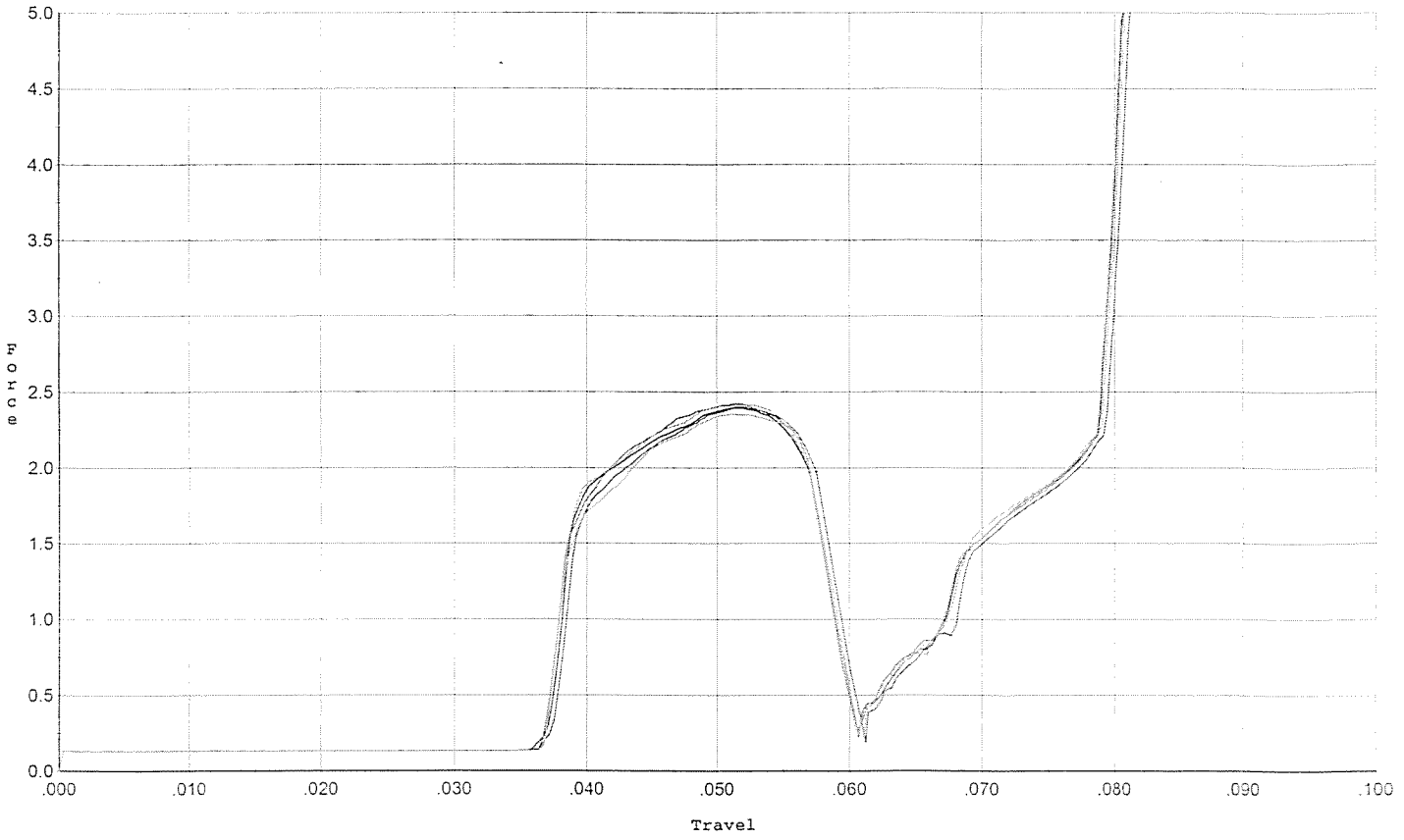


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.438	0.051	0.031	0.030	0.047		Set Trigger
2	2.399	0.051	0.030	0.030	0.047		Set Trigger
3	2.455	0.051	0.031	0.030	0.048		Set Trigger
4	2.426	0.052	0.031	0.030	0.048		Set Trigger
5	2.434	0.051	0.031	0.030	0.047		Set Trigger

Avg 2.42

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 5/30/07		

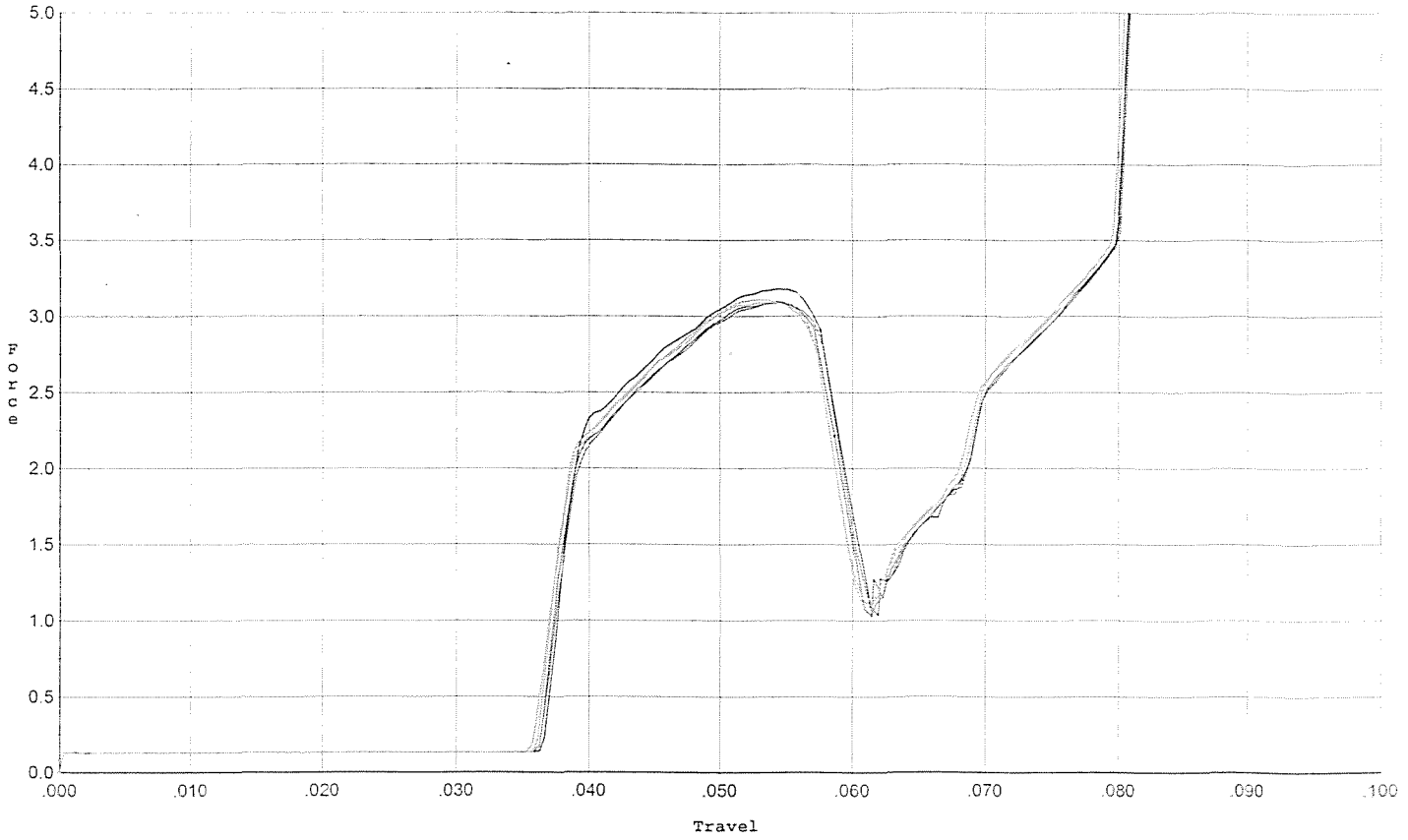


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.404	0.057	0.037	0.030	0.047		Set Trigger
2	2.399	0.057	0.037	0.030	0.047		Set Trigger
3	2.420	0.057	0.037	0.030	0.048		Set Trigger
4	2.352	0.059	0.037	0.030	0.048		Set Trigger
5	2.426	0.057	0.037	0.030	0.048		Set Trigger

Avg 2.40

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 5/30/07		

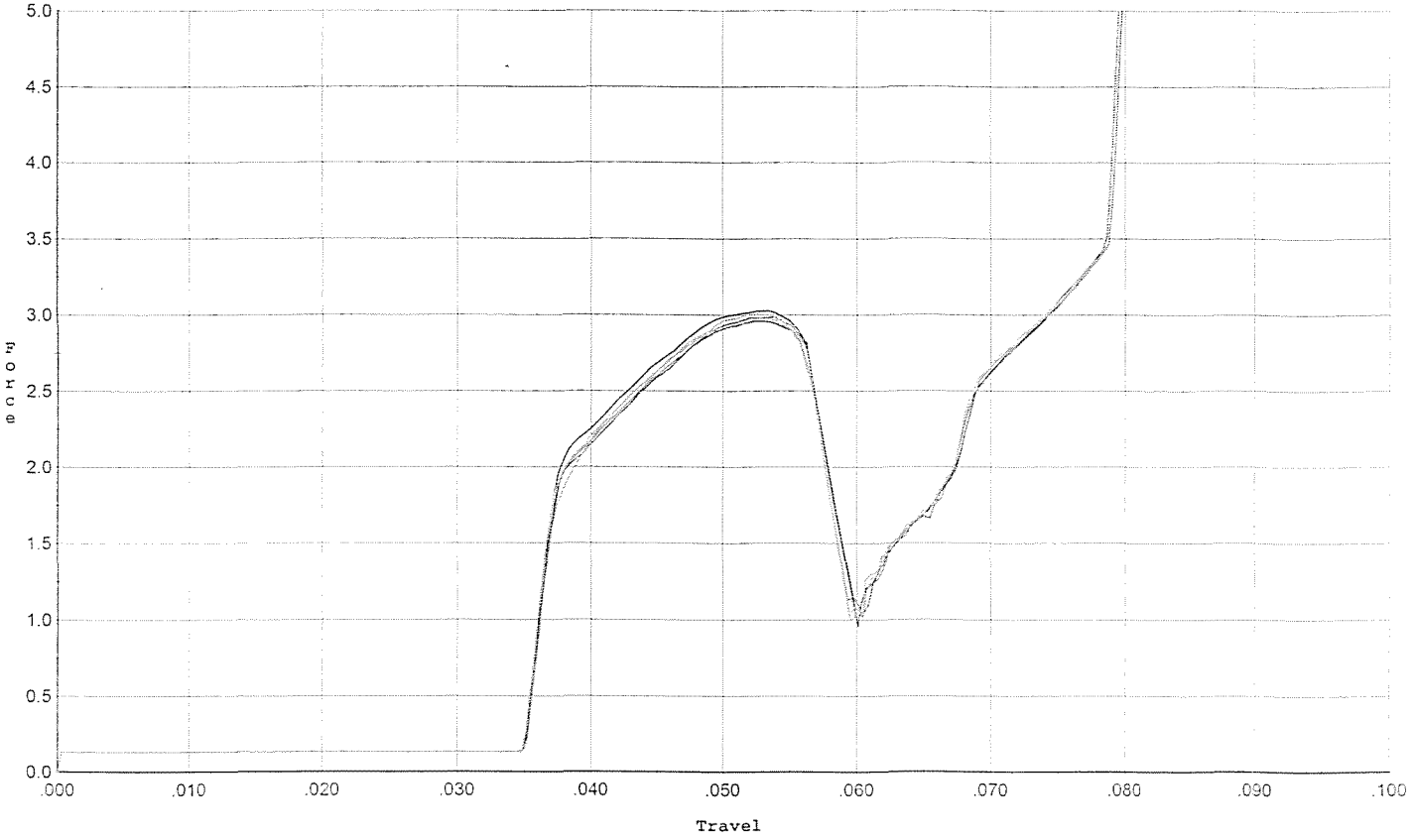


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.098	0.059	0.036	0.028	0.063		Set Trigger
2	3.178	0.058	0.037	0.028	0.063		Set Trigger
3	3.084	0.058	0.037	0.029	0.061		Set Trigger
4	3.109	0.057	0.036	0.029	0.062		Set Trigger
5	3.088	0.057	0.036	0.028	0.062		Set Trigger

Aug 3.11

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 5/30/07		

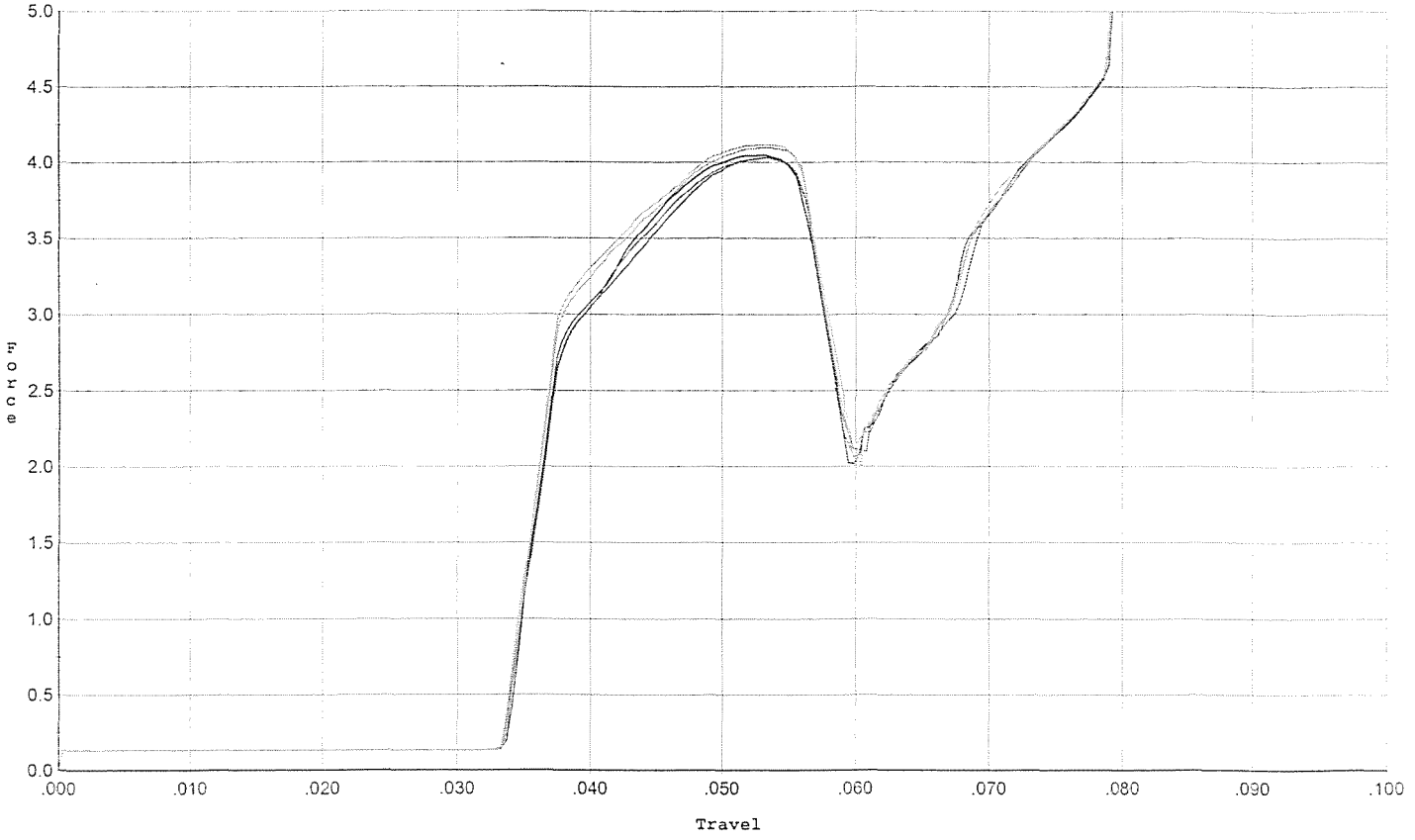


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.961	0.057	0.035	0.029	0.059		Set Trigger
2	3.030	0.056	0.035	0.029	0.060		Set Trigger
3	2.983	0.056	0.035	0.029	0.059		Set Trigger
4	3.004	0.057	0.035	0.029	0.060		Set Trigger
5	2.975	0.057	0.035	0.029	0.059		Set Trigger

Avg 2.99

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 5/30/07		



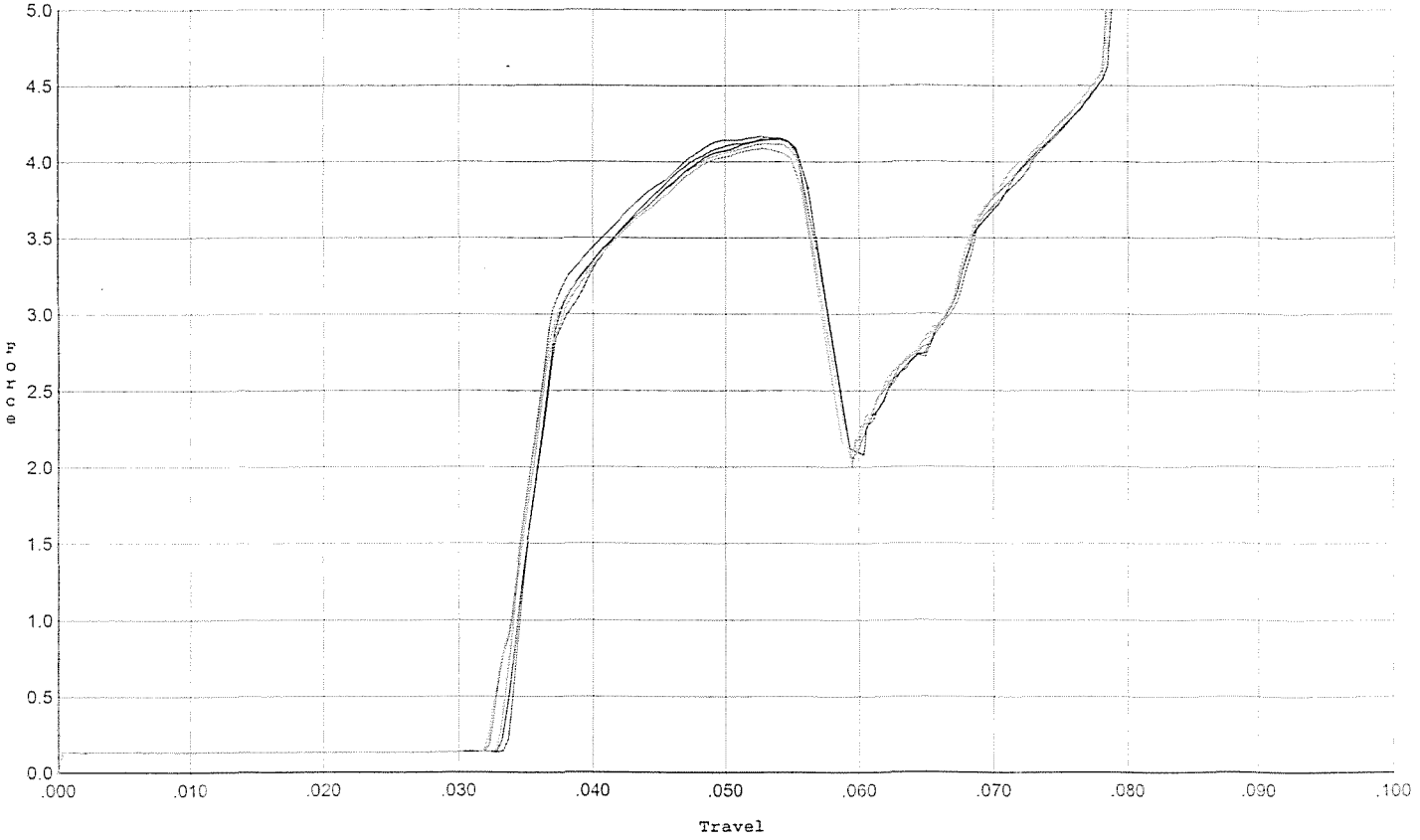
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.035	0.056	0.034	0.027	0.081		Set Trigger
2	4.046	0.057	0.034	0.027	0.083		Set Trigger
3	4.031	0.056	0.034	0.027	0.082		Set Trigger
4	4.115	0.056	0.034	0.027	0.084		Set Trigger
5	4.095	0.056	0.034	0.027	0.083		Set Trigger

Avg 4.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc., 5/30/2007 2:10:46 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 5/30/07		

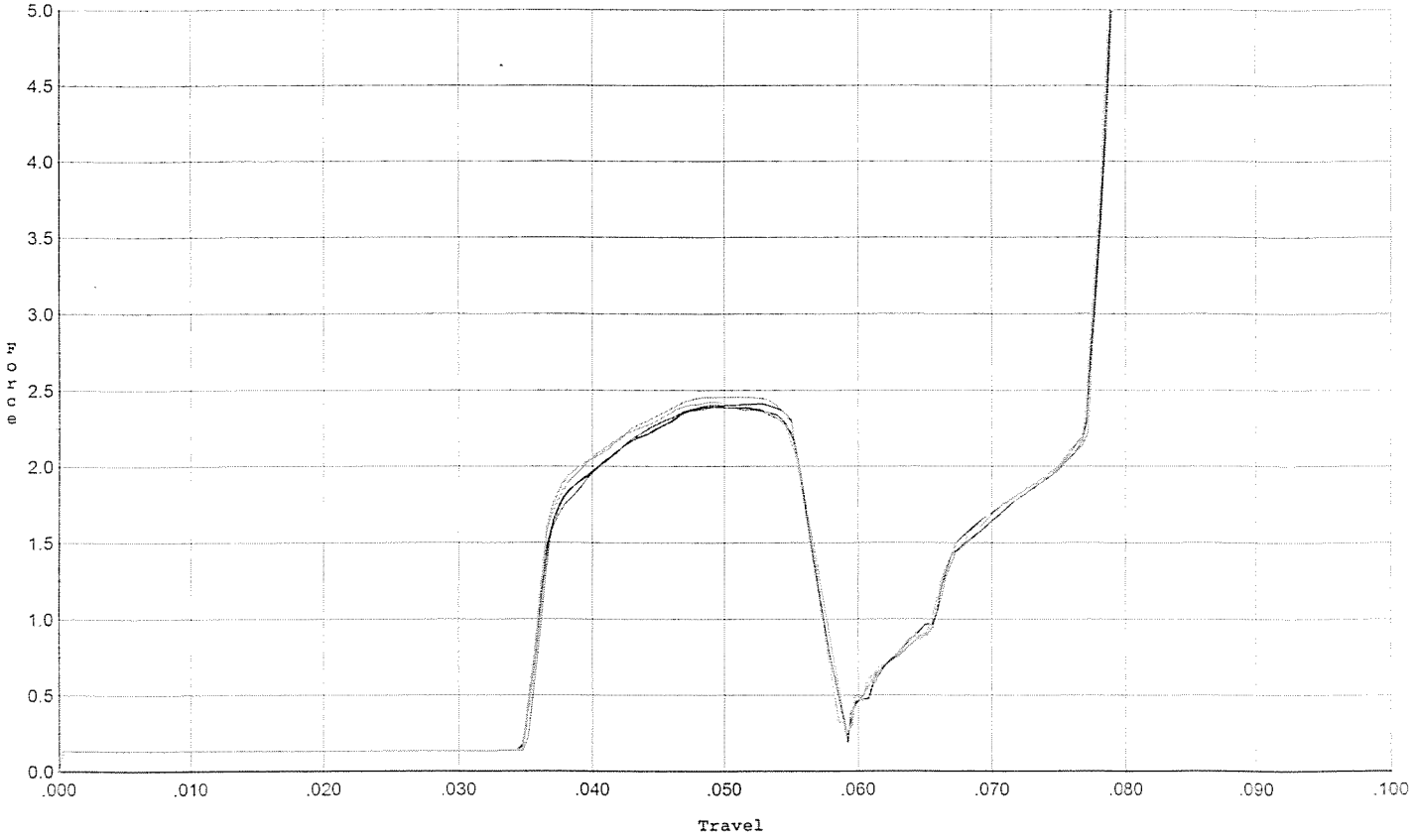


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.160	0.057	0.034	0.026	0.086		Set Trigger
2	4.145	0.056	0.033	0.026	0.086		Set Trigger
3	4.166	0.055	0.032	0.026	0.086		Set Trigger
4	4.087	0.056	0.032	0.026	0.085		Set Trigger
5	4.119	0.055	0.033	0.027	0.084		Set Trigger

Aug 4.13

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 5/30/07		

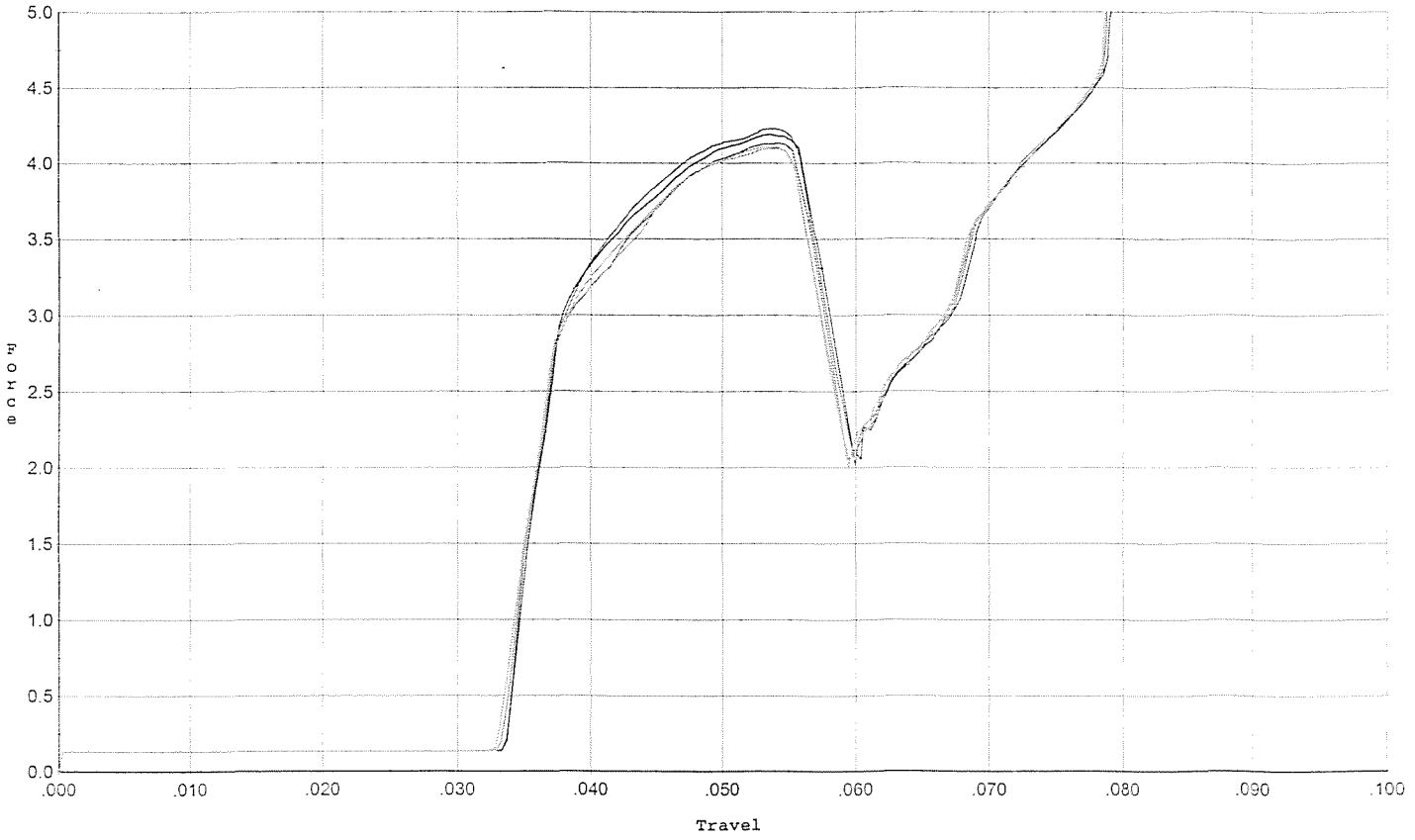


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.413	0.057	0.035	0.029	0.050		Set Trigger
2	2.390	0.055	0.035	0.030	0.048		Set Trigger
3	2.391	0.057	0.035	0.030	0.050		Set Trigger
4	2.425	0.055	0.035	0.030	0.049		Set Trigger
5	2.456	0.057	0.035	0.029	0.051		Set Trigger

Aug 2.41

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 5/30/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.228	0.056	0.034	0.026	0.085		Set Trigger
2	4.191	0.057	0.034	0.026	0.088		Set Trigger
3	4.133	0.056	0.033	0.026	0.084		Set Trigger
4	4.107	0.055	0.033	0.027	0.083		Set Trigger
5	4.099	0.055	0.033	0.027	0.082		Set Trigger

Avg 4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645596.__0
FILE DATE AND TIME: 06/04/2007 23:25

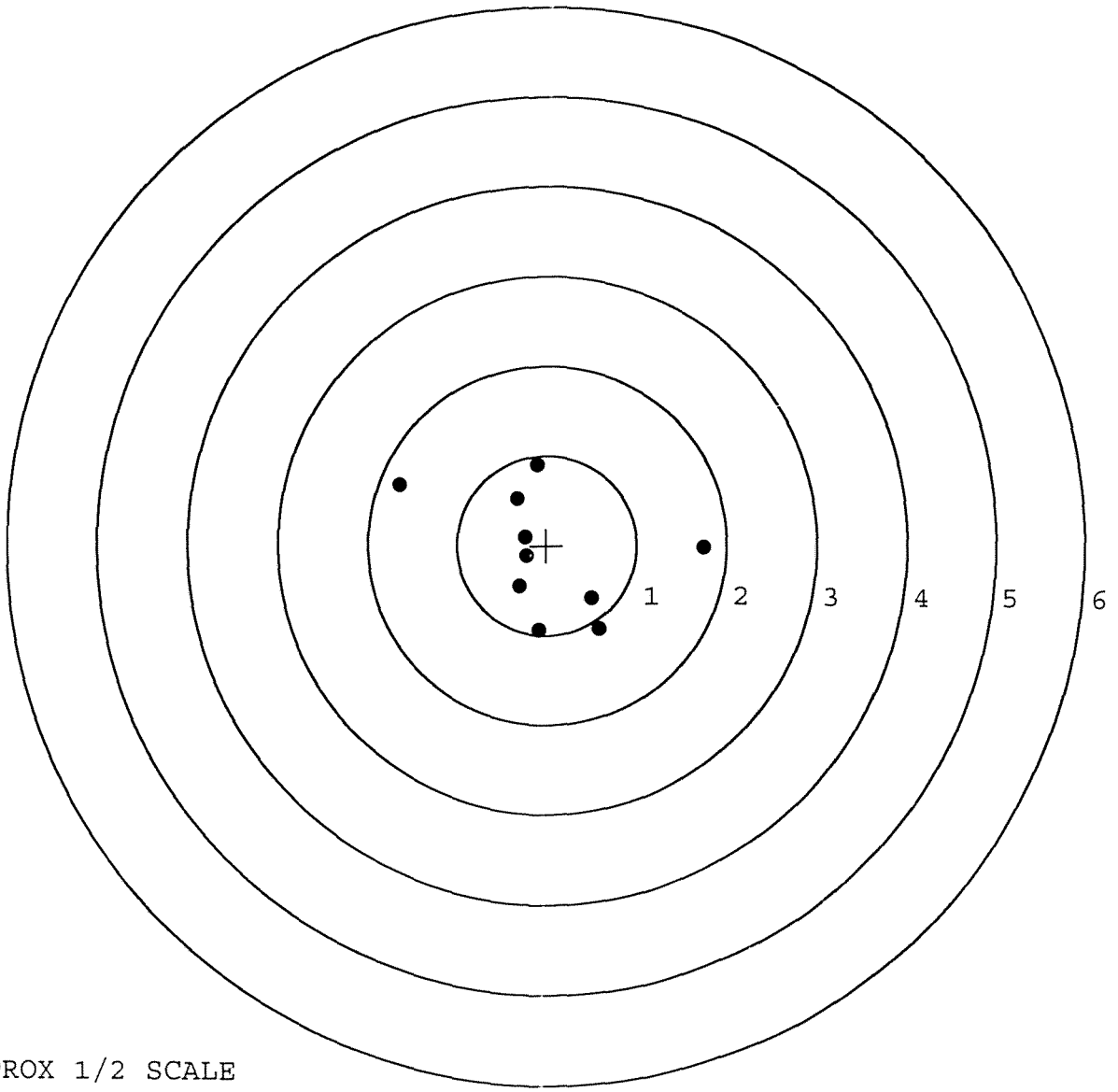
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.062
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.093
The Average Mean Radius of the Five Target Set:	0.701
The Distance from POA to Centroid Target #1:	0.092
The Distance from Centroid Target #2 to Centroid Target #1:	0.216
The Distance from Centroid Target #3 to Centroid Target #1:	0.122
The Distance from Centroid Target #4 to Centroid Target #1:	0.233
The Distance from Centroid Target #5 to Centroid Target #1:	0.066

SERIAL NUMBER: G6645596.__0
TARGET NUMBER: 1
FILE DATE: 06/04/2007
FILE TIME: 23:25

X CENTROID:	-0.007
Y CENTROID:	-0.091
POA TO CENTROID:	0.092
HORZ SPREAD:	3.398
VERT SPREAD:	1.848
GROUP SPREAD:	3.464
MIN RADIUS:	0.216
MAX RADIUS:	1.807
MEAN RADIUS:	0.884
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.107	0.900
2:	-0.329	0.517
3:	-0.237	0.088
4:	-0.221	-0.120
5:	-0.295	-0.465
6:	-0.076	-0.948
7:	0.510	-0.591
8:	0.600	-0.927
9:	1.744	-0.019
10:	-1.654	0.652

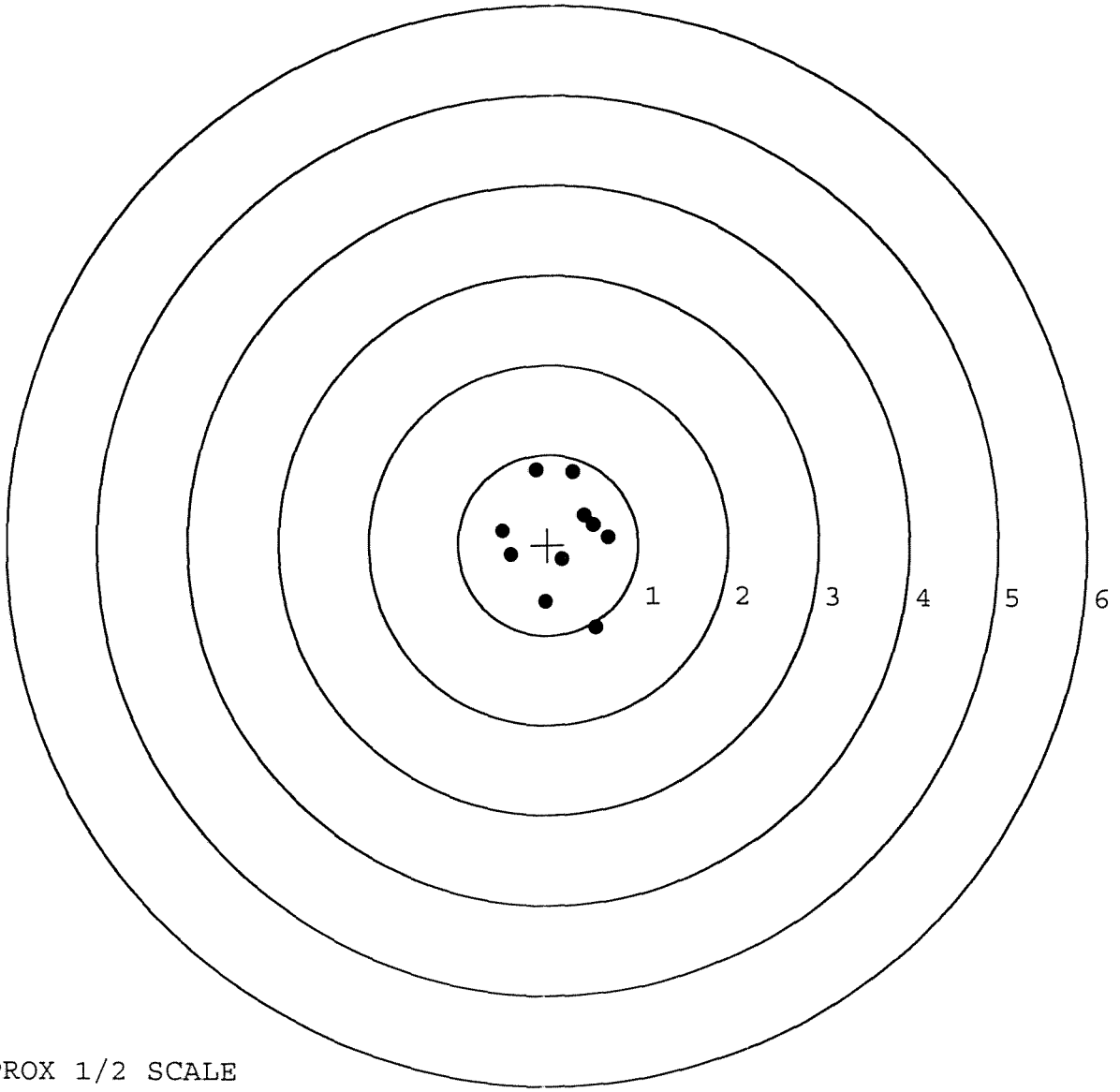


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645596.__0
TARGET NUMBER: 2
FILE DATE: 06/04/2007
FILE TIME: 23:25

X CENTROID:	0.148
Y CENTROID:	0.061
POA TO CENTROID:	0.159
HORZ SPREAD:	1.186
VERT SPREAD:	1.748
GROUP SPREAD:	1.877
MIN RADIUS:	0.227
MAX RADIUS:	1.056
MEAN RADIUS:	0.611
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.139	0.831
2:	0.277	0.813
3:	-0.513	0.147
4:	-0.411	-0.114
5:	-0.026	-0.629
6:	0.165	-0.166
7:	0.546	-0.917
8:	0.673	0.091
9:	0.503	0.222
10:	0.400	0.327

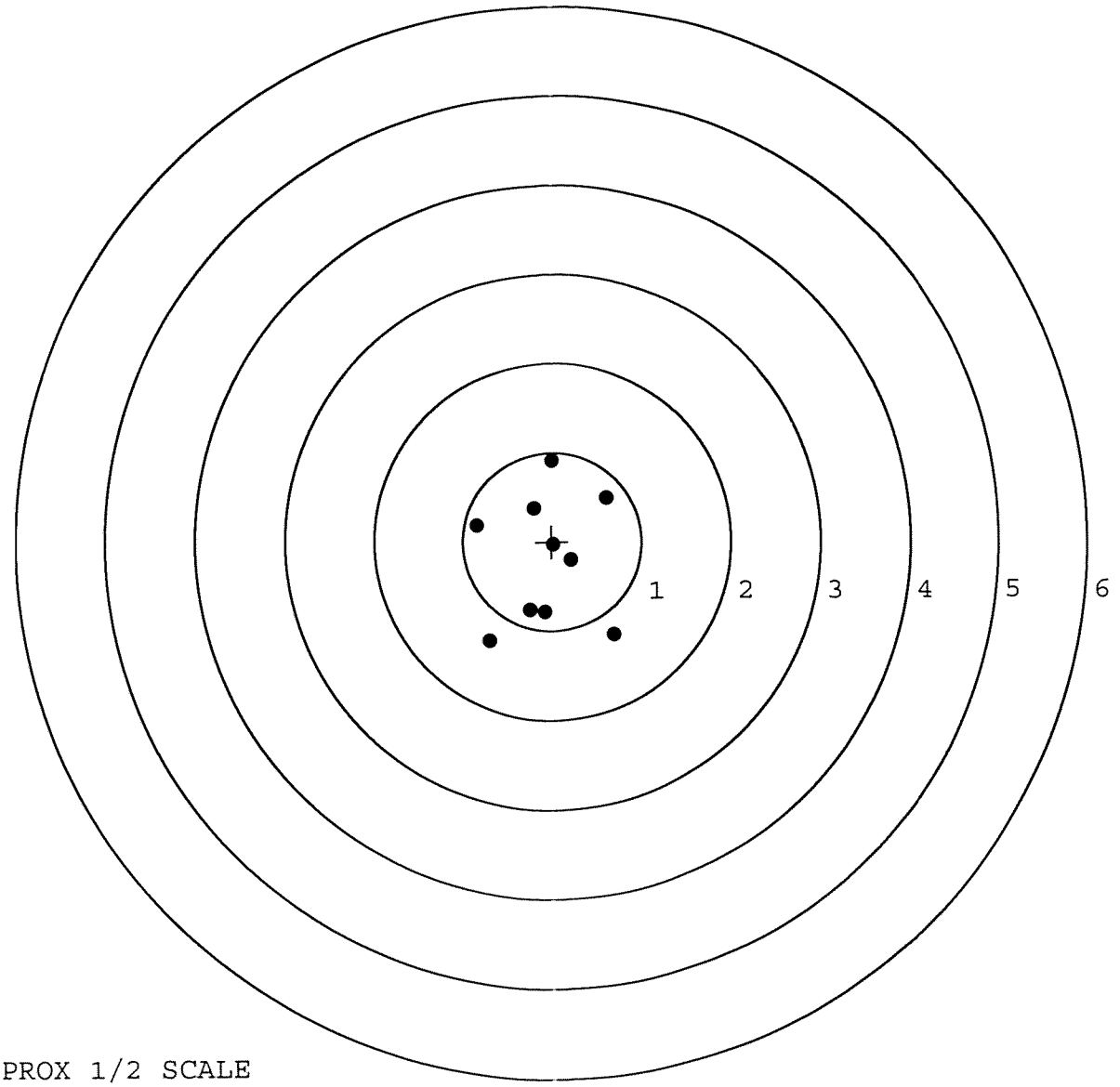


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645596.__0
TARGET NUMBER: 3
FILE DATE: 06/04/2007
FILE TIME: 23:25

X CENTROID:	-0.056
Y CENTROID:	-0.203
POA TO CENTROID:	0.210
HORZ SPREAD:	1.534
VERT SPREAD:	2.030
GROUP SPREAD:	2.080
MIN RADIUS:	0.179
MAX RADIUS:	1.129
MEAN RADIUS:	0.744
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.015	-0.038
2:	-0.003	0.911
3:	-0.202	0.374
4:	0.607	0.488
5:	0.214	-0.207
6:	-0.084	-0.800
7:	-0.248	-0.768
8:	-0.700	-1.119
9:	0.689	-1.051
10:	-0.845	0.182

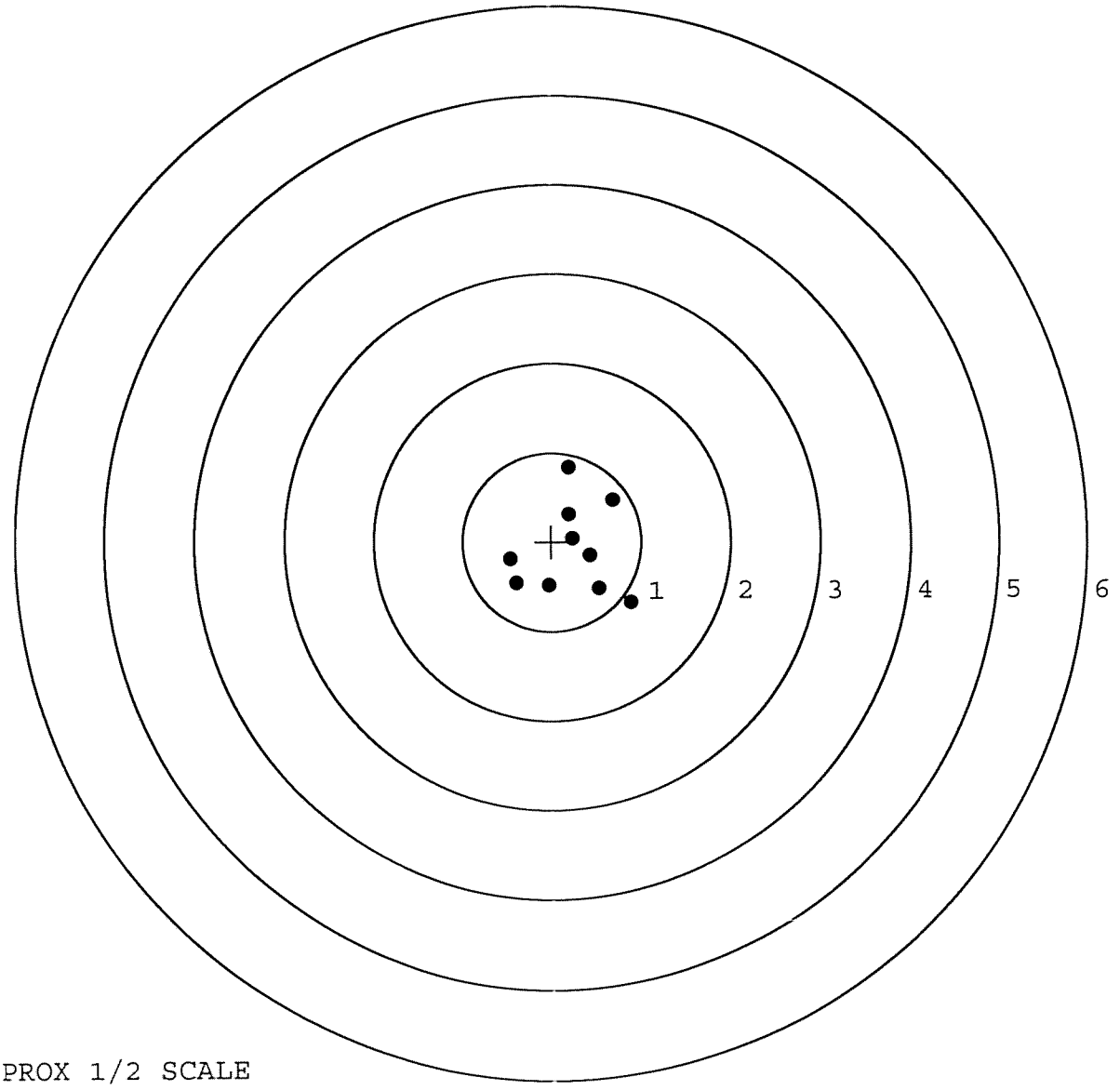


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645596.__0
TARGET NUMBER: 4
FILE DATE: 06/04/2007
FILE TIME: 23:25

X CENTROID:	0.227
Y CENTROID:	-0.087
POA TO CENTROID:	0.243
HORZ SPREAD:	1.348
VERT SPREAD:	1.515
GROUP SPREAD:	1.665
MIN RADIUS:	0.124
MAX RADIUS:	0.922
MEAN RADIUS:	0.571
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.195	0.834
2:	0.198	0.311
3:	0.237	0.037
4:	0.682	0.471
5:	0.885	-0.681
6:	0.428	-0.159
7:	0.533	-0.525
8:	-0.028	-0.493
9:	-0.400	-0.466
10:	-0.463	-0.199

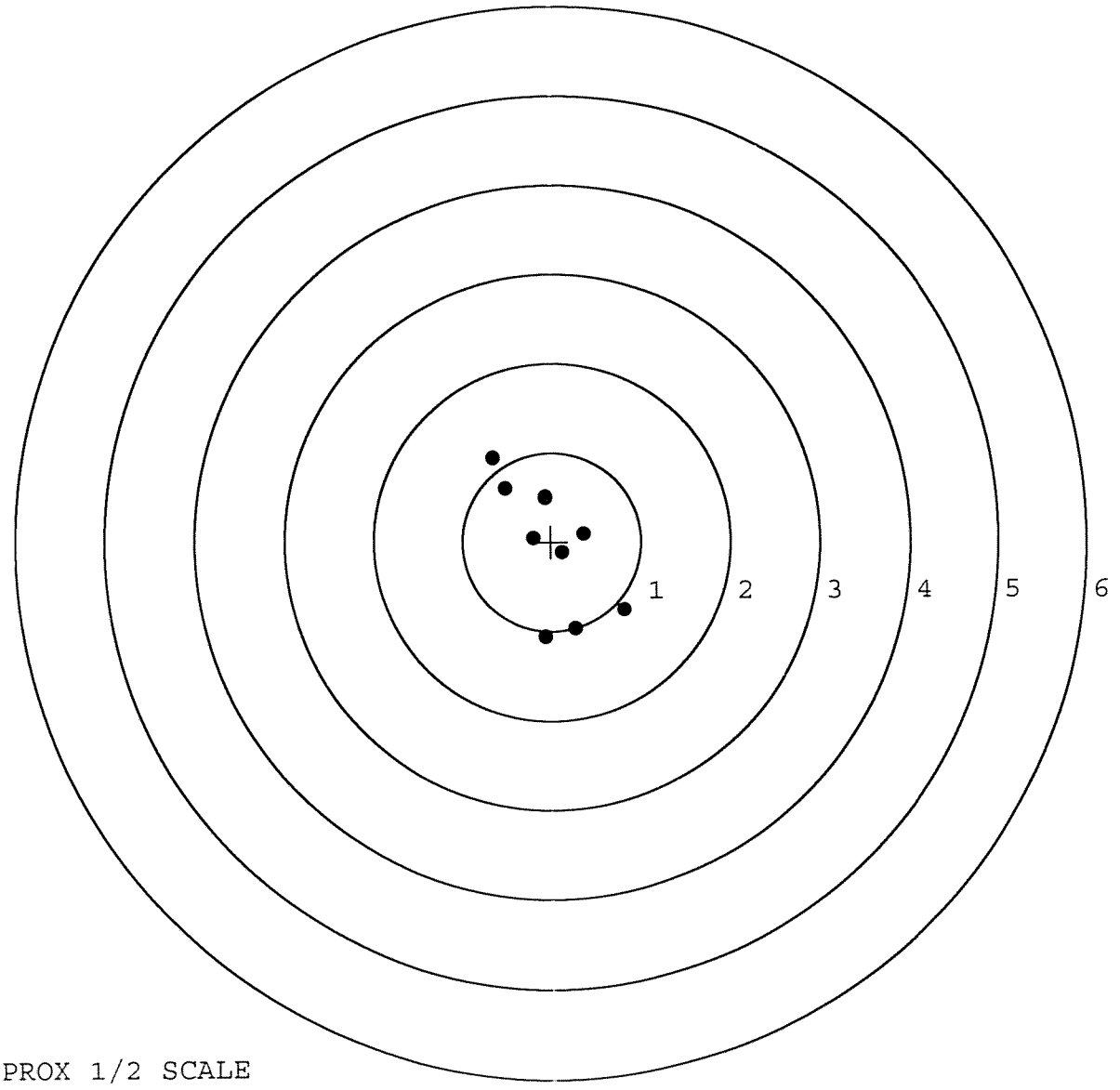


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645596.__0
TARGET NUMBER: 5
FILE DATE: 06/04/2007
FILE TIME: 23:25

X CENTROID:	-0.002
Y CENTROID:	-0.026
POA TO CENTROID:	0.026
HORZ SPREAD:	1.466
VERT SPREAD:	2.018
GROUP SPREAD:	2.257
MIN RADIUS:	0.161
MAX RADIUS:	1.171
MEAN RADIUS:	0.694
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.069	0.511
2:	-0.658	0.945
3:	-0.518	0.600
4:	-0.069	0.496
5:	-0.202	0.041
6:	0.125	-0.124
7:	0.361	0.093
8:	-0.071	-1.073
9:	0.270	-0.976
10:	0.808	-0.771



TARGET APPROX 1/2 SCALE