

68-52 477-9

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

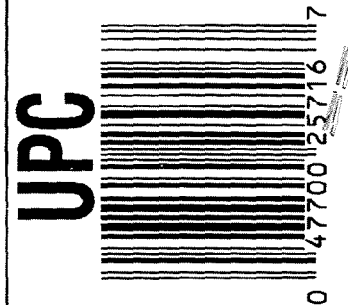
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6672589



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.



GUN SERIAL # G6672589

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		8-6-07	SD
430	ASSEMBLE TO STOCK		8/7/07	W
440	PROOF	MAGNA - FLUX	8/7/07	W
460	CHECK HEADSPACE	AUG 2007	8/7/07	W
470	DIS-ASSEMBLE ACTION		8-9-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>EMS</u>	8/13/07	EMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-13-07	CW
510	DRILL AND TAP SIGHT HOLES		8-10-07	TRW
520	GOFF BLAST BBL / REC		8/13/07	Ⓟ
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/23/07	RB
560	RE-ASSEMBLE ACTION		8-27-07	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-27-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-27-07	SD
	D) OIL FIRING PIN ASSEMBLY		8/30/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

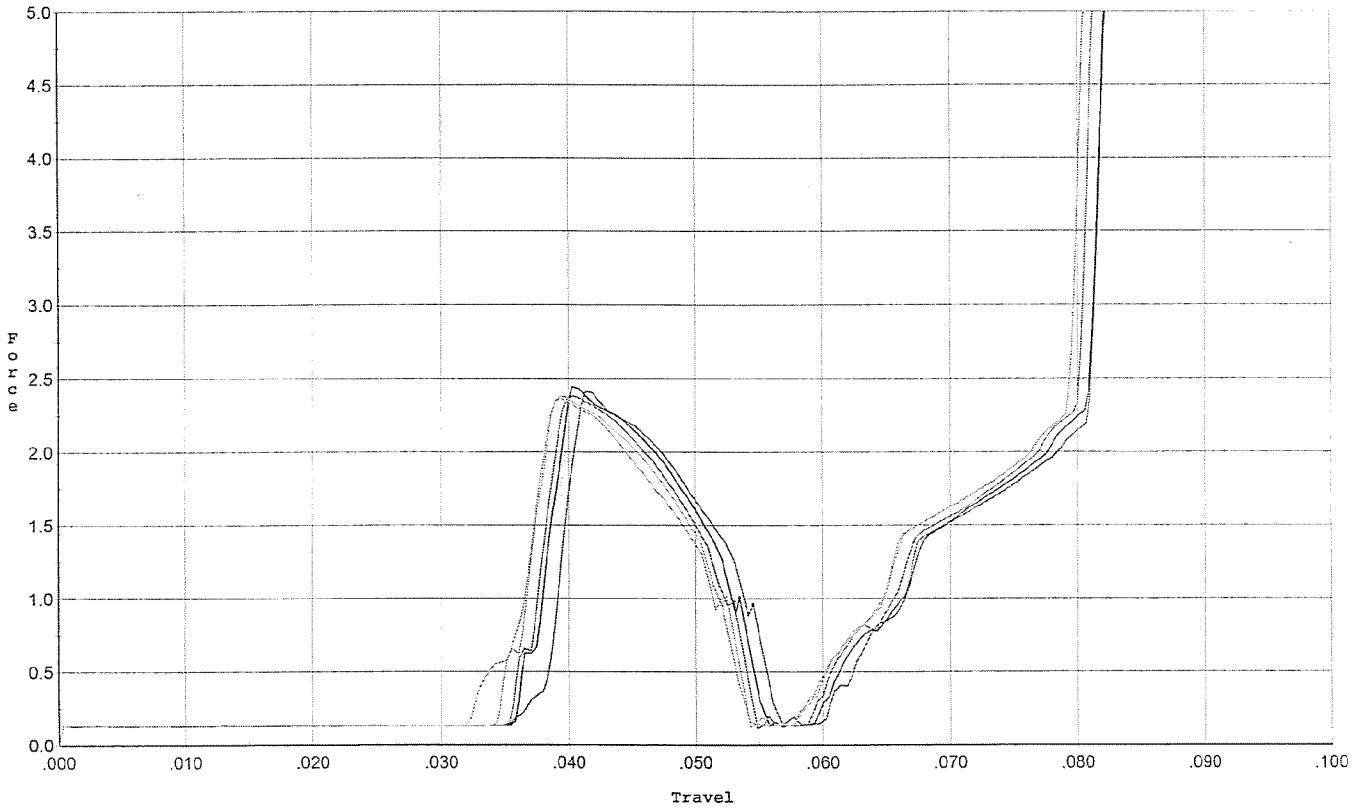
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>55</u> <u>55</u> <u>60</u>	9-6-07	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>35</u>	9-6-07	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	9-6-07	RA
	J) ASSEMBLE STOCK		8/30/07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		9-6-07	RA
	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	8-31-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-31-07	WR
670	FINAL INSPECTION A) HEADSPACE		9/6/07	S.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>274</u> <u>239</u> <u>235</u> <u>237</u> <u>245</u>	9/4/07	RP
	C) FUNCTION		9/6/07	S.P.D.
690	PACK		9-7-07	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



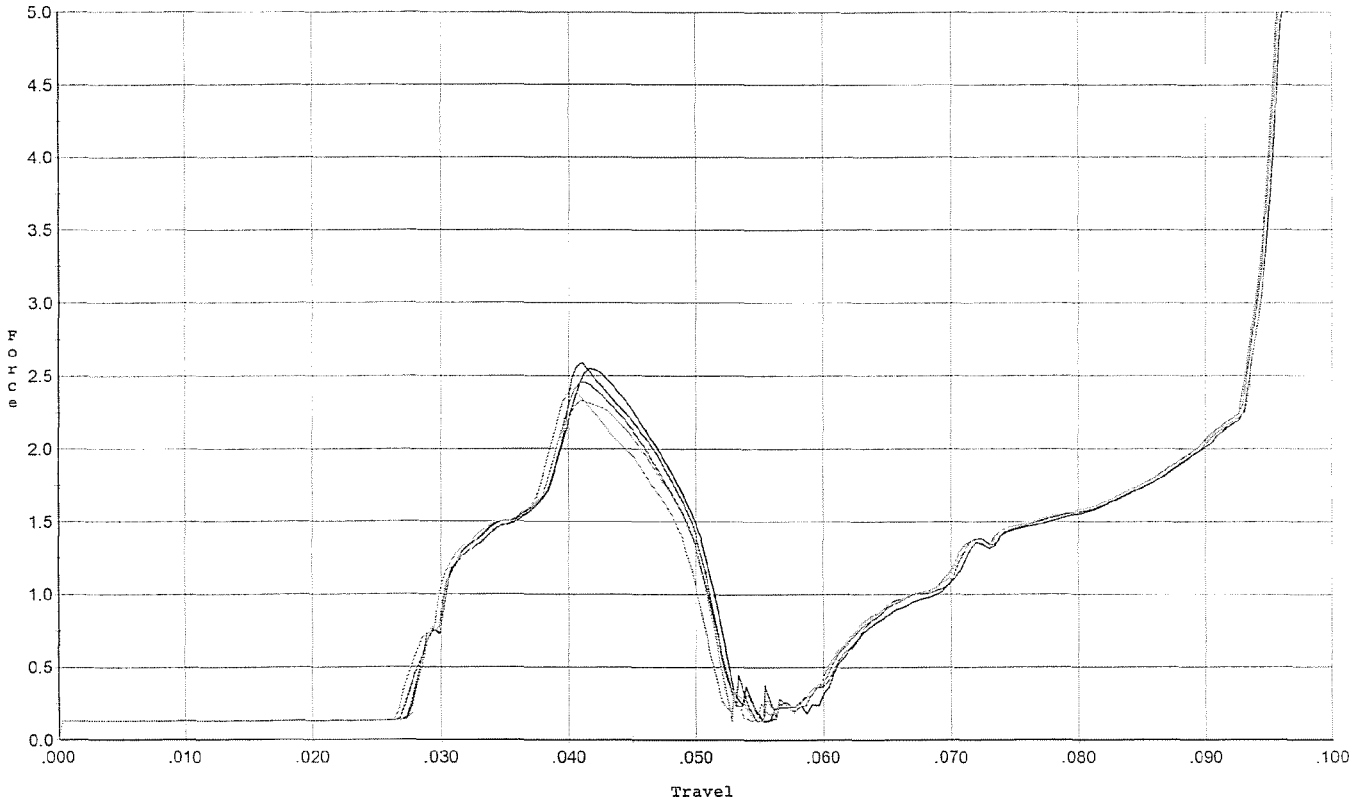
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.411	0.055	0.037	0.036	0.034		Set Trigger
2	2.445	0.053	0.036	0.036	0.035		Set Trigger
3	2.382	0.053	0.036	0.036	0.034		Set Trigger
4	2.379	0.052	0.035	0.036	0.035		Set Trigger
5	2.366	0.052	0.033	0.036	0.035		Set Trigger

2.40 kg

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



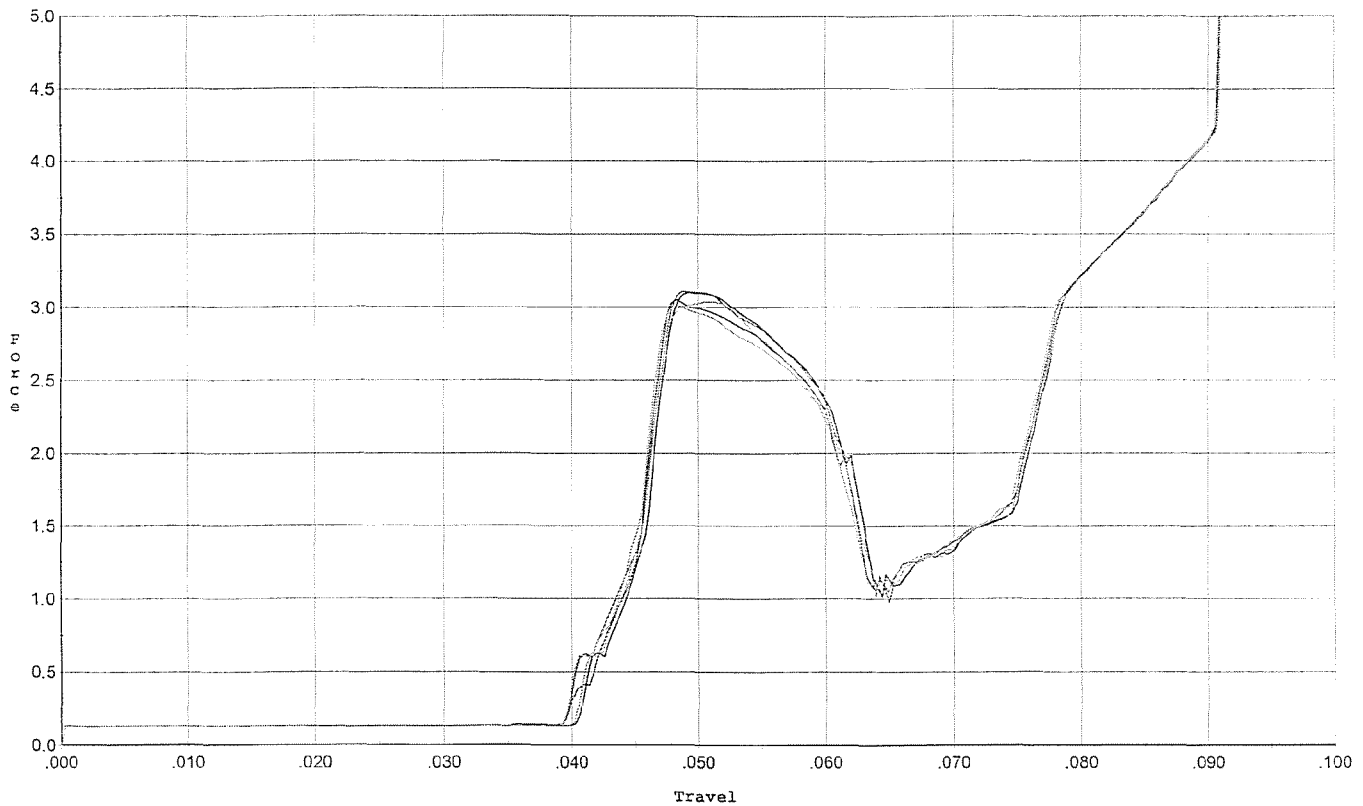
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.051	0.027	0.053	0.042		Set Trigger
2	2.553	0.051	0.028	0.051	0.043		Set Trigger
3	2.459	0.051	0.028	0.053	0.042		Set Trigger
4	2.413	0.050	0.027	0.054	0.040		Set Trigger
5	2.332	0.051	0.028	0.053	0.041		Set Trigger

2.47 Aug.

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



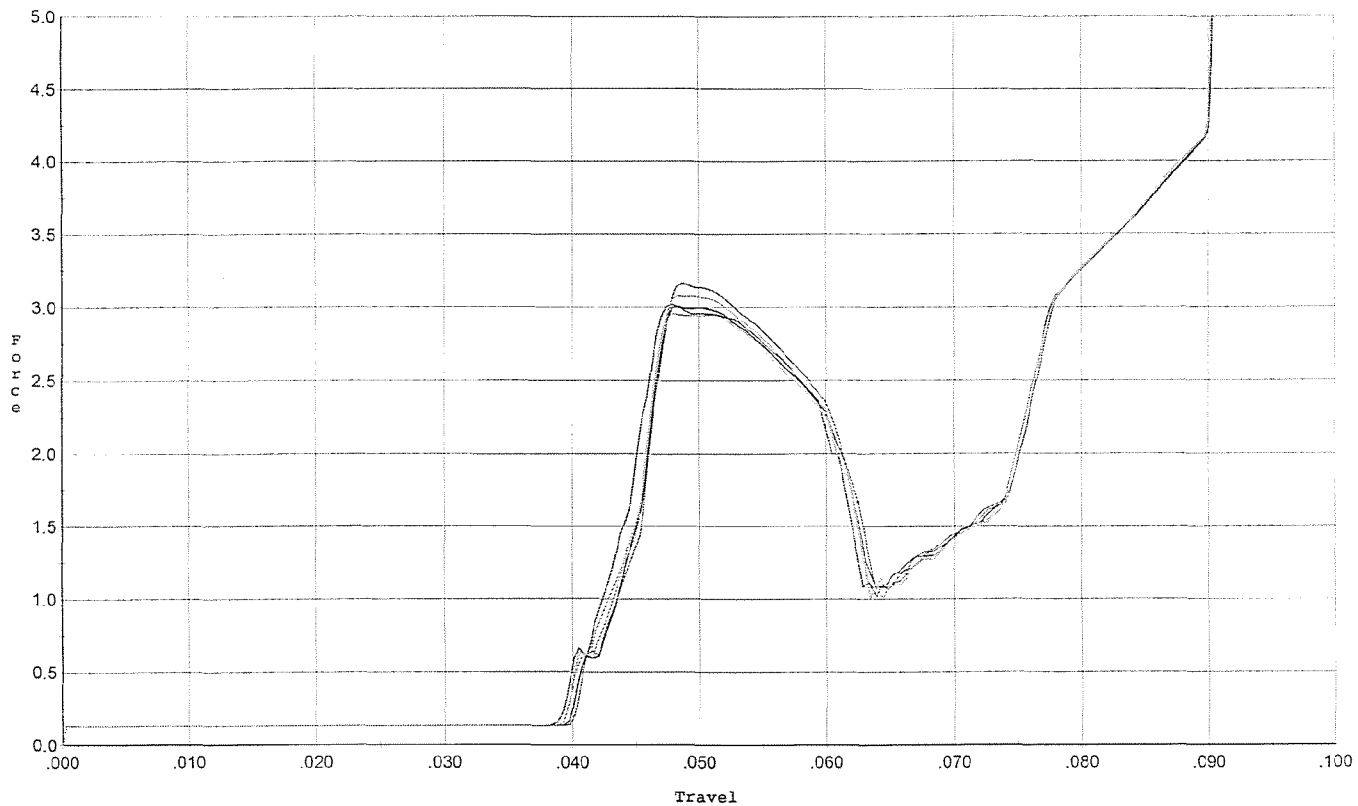
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.056	0.062	0.040	0.036	0.053		Set Trigger
2	3.109	0.062	0.041	0.035	0.054		Set Trigger
3	3.114	0.062	0.040	0.035	0.055		Set Trigger
4	3.009	0.062	0.040	0.036	0.054		Set Trigger
5	3.037	0.062	0.041	0.036	0.053		Set Trigger

3.01 Avg.

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



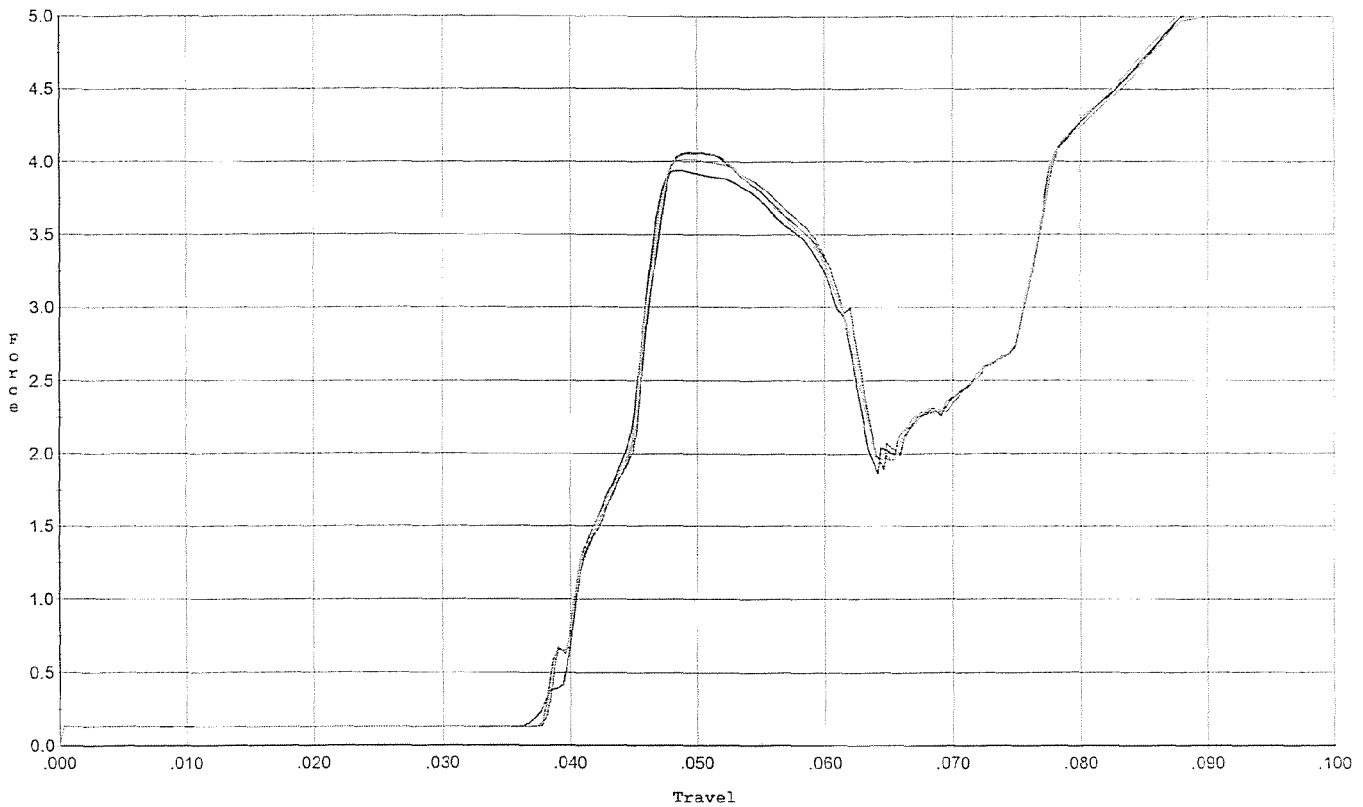
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.024	0.061	0.039	0.036	0.055		Set Trigger
2	3.013	0.062	0.040	0.035	0.054		Set Trigger
3	3.169	0.062	0.040	0.035	0.056		Set Trigger
4	3.078	0.062	0.040	0.035	0.055		Set Trigger
5	2.956	0.062	0.040	0.035	0.054		Set Trigger

3.05 Avg

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



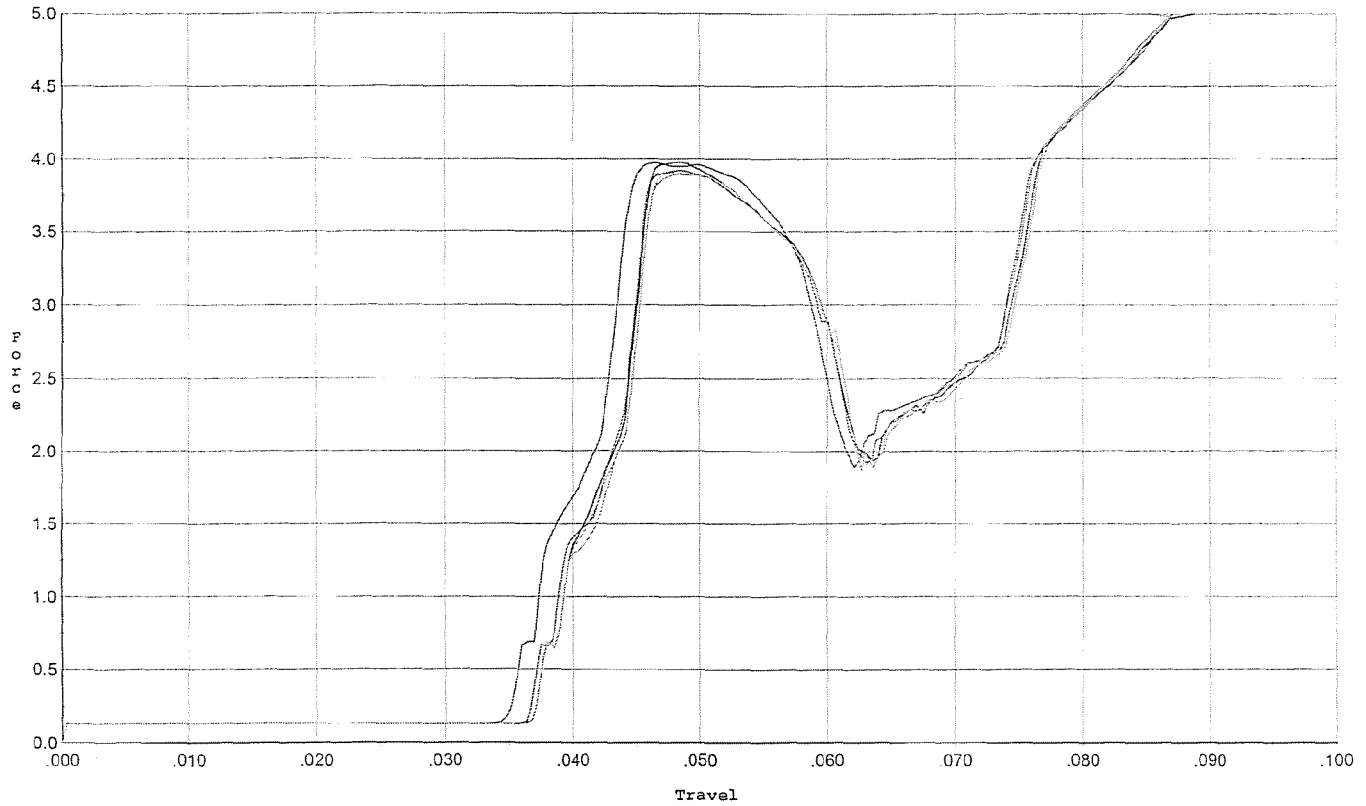
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.061	0.062	0.038	0.033	0.077		Set Trigger
2	3.938	0.062	0.038	0.033	0.075		Set Trigger
3	4.067	0.062	0.038	0.033	0.077		Set Trigger
4	4.066	0.062	0.038	0.033	0.078		Set Trigger
5	4.012	0.062	0.038	0.033	0.076		Set Trigger

4.03 Avg.

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



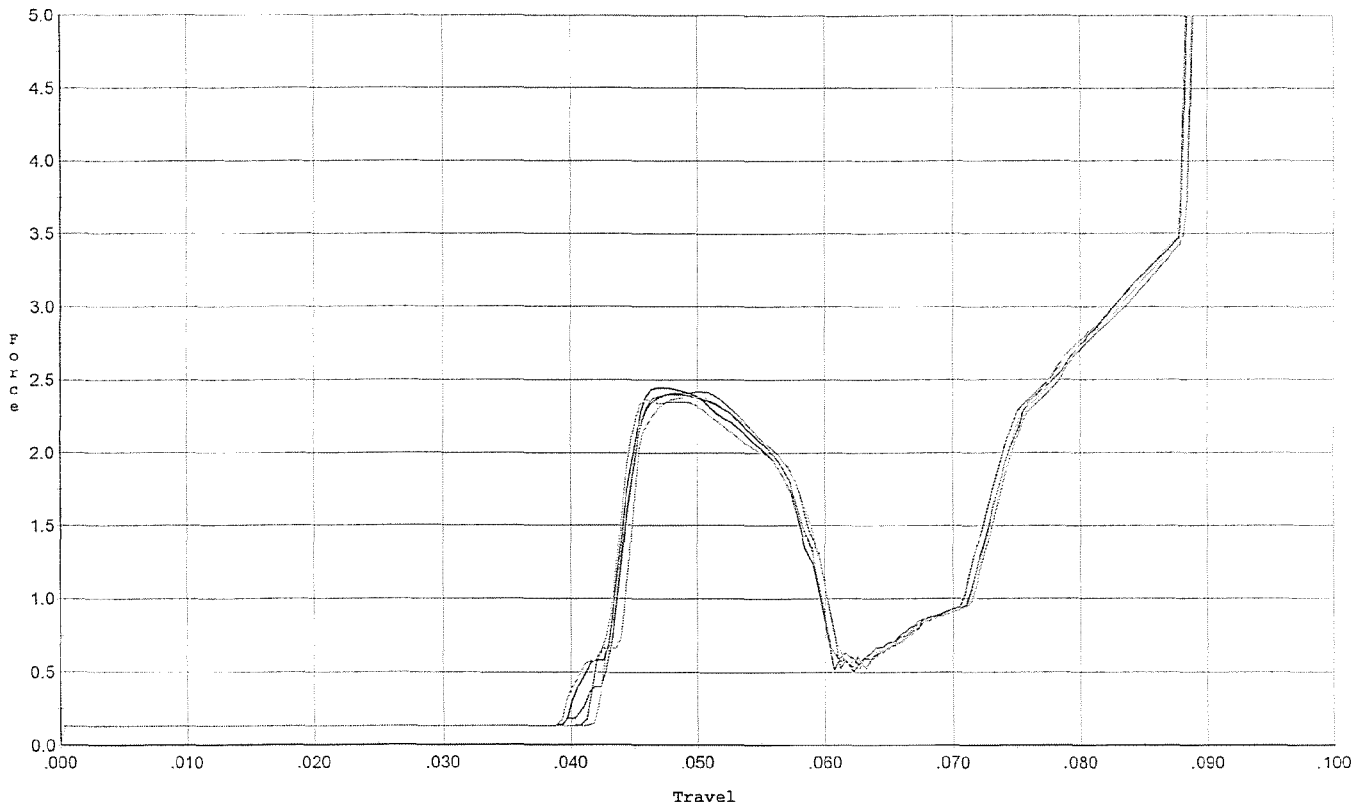
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.972	0.059	0.035	0.034	0.077		Set Trigger
2	3.977	0.060	0.037	0.034	0.074		Set Trigger
3	3.919	0.060	0.037	0.034	0.074		Set Trigger
4	3.904	0.061	0.037	0.033	0.074		Set Trigger
5	3.893	0.061	0.037	0.033	0.074		Set Trigger

3.93 avg.

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 6/15/07

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



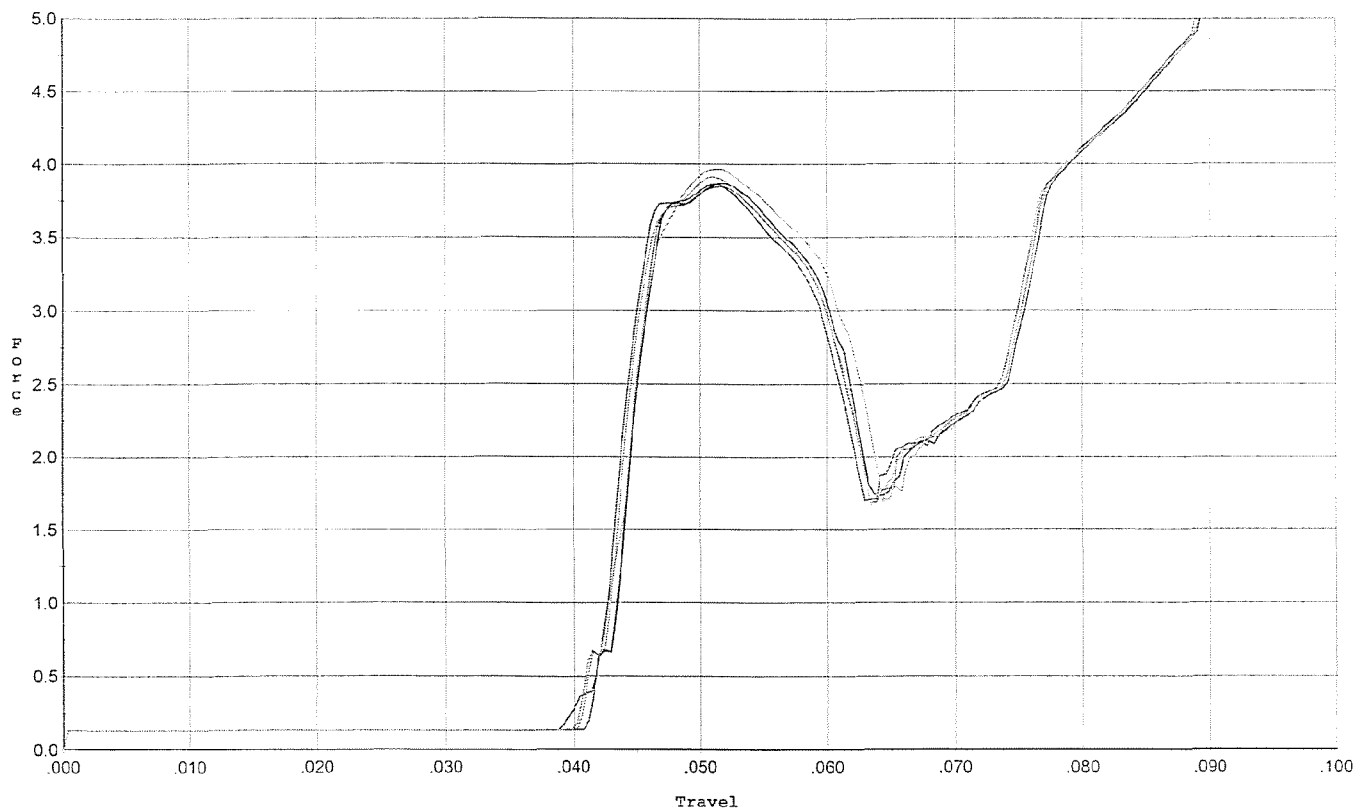
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.404	0.059	0.041	0.037	0.039		Set Trigger
2	2.445	0.059	0.040	0.037	0.040		Set Trigger
3	2.418	0.060	0.042	0.037	0.040		Set Trigger
4	2.382	0.060	0.042	0.037	0.039		Set Trigger
5	2.364	0.059	0.040	0.037	0.040		Set Trigger

2.40 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 6/15/07

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	3.863	0.061	0.040	0.033	0.069		Set Trigger
2	3.867	0.061	0.041	0.033	0.068		Set Trigger
3	3.847	0.062	0.041	0.033	0.069		Set Trigger
4	3.913	0.062	0.041	0.033	0.071		Set Trigger
5	3.966	0.063	0.041	0.032	0.074		Set Trigger

3.89 Avg.

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6672589.__0
FILE DATE AND TIME: 09/01/2007 04:52

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.038
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.594
The Distance from POA to Centroid Target #1:	0.074
The Distance from Centroid Target #2 to Centroid Target #1:	0.145
The Distance from Centroid Target #3 to Centroid Target #1:	0.054
The Distance from Centroid Target #4 to Centroid Target #1:	0.211
The Distance from Centroid Target #5 to Centroid Target #1:	0.201

BARBER - M24 0172998

SERIAL NUMBER: G6672589. __0

TARGET NUMBER: 1

FILE DATE: 09/01/2007

FILE TIME: 04:52

POINT#	X	Y
1:	0.114	-0.927
2:	0.697	-0.608
3:	0.529	-0.130
4:	0.504	0.436
5:	0.101	0.168
6:	-0.339	-0.242
7:	-0.684	-0.044
8:	-1.061	0.085
9:	-0.624	0.580
10:	0.210	1.168

X CENTROID: -0.055

Y CENTROID: 0.049

POA TO CENTROID: 0.074

HORZ SPREAD: 1.758

VERT SPREAD: 2.095

GROUP SPREAD: 2.097

MIN RADIUS: 0.197

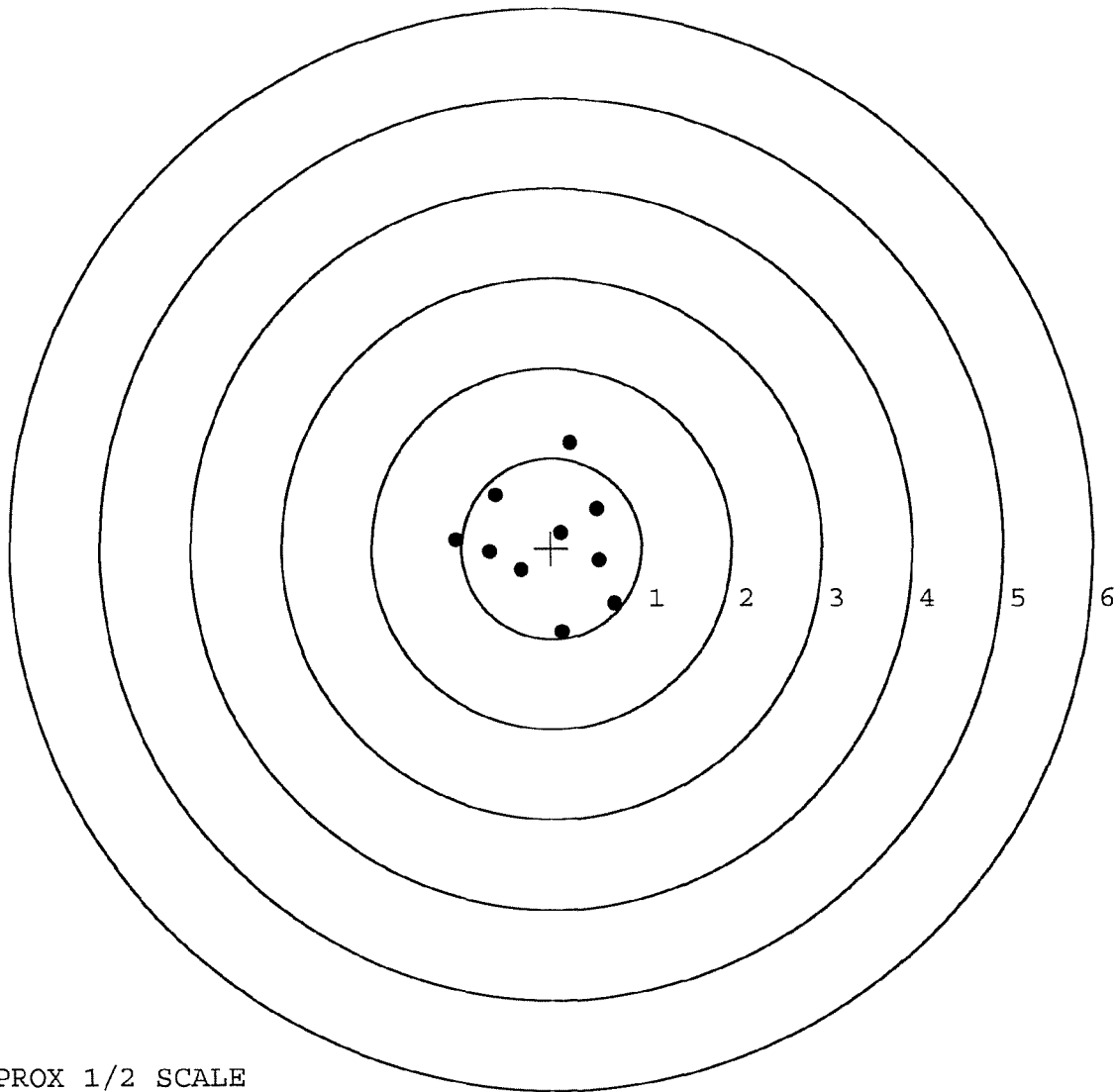
MAX RADIUS: 1.150

MEAN RADIUS: 0.745

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



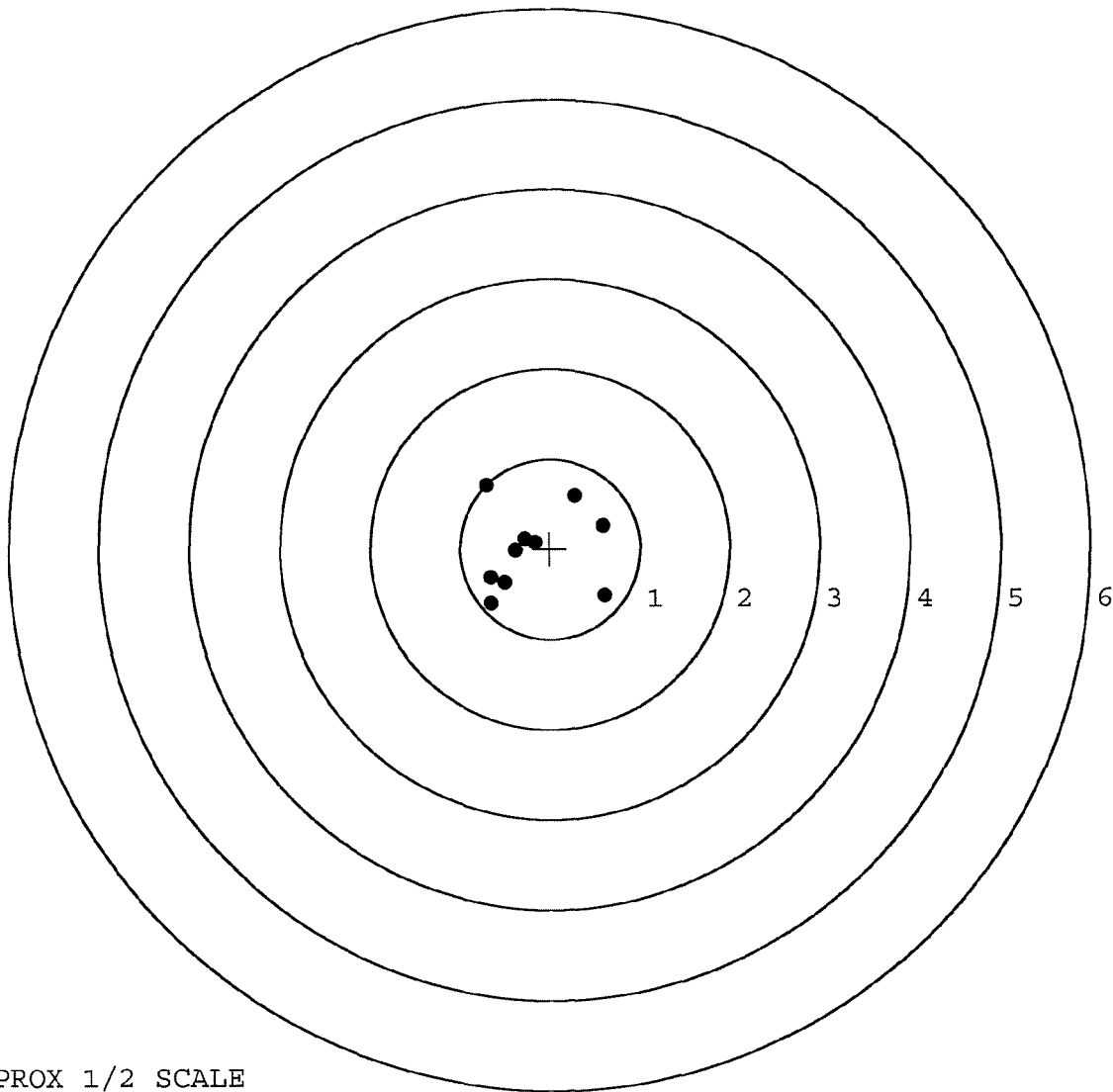
TARGET APPROX 1/2 SCALE

BARBER - M24 0172999

SERIAL NUMBER: G6672589. 0
 TARGET NUMBER: 2
 FILE DATE: 09/01/2007
 FILE TIME: 04:52

POINT#	X	Y
1:	0.611	-0.523
2:	0.590	0.256
3:	0.276	0.598
4:	-0.704	0.706
5:	-0.274	0.111
6:	-0.383	-0.026
7:	-0.655	-0.332
8:	-0.500	-0.383
9:	-0.657	-0.619
10:	-0.160	0.072

X CENTROID: -0.186
 Y CENTROID: -0.014
 POA TO CENTROID: 0.186
 HORZ SPREAD: 1.315
 VERT SPREAD: 1.325
 GROUP SPREAD: 1.800
 MIN RADIUS: 0.090
 MAX RADIUS: 0.945
 MEAN RADIUS: 0.568
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



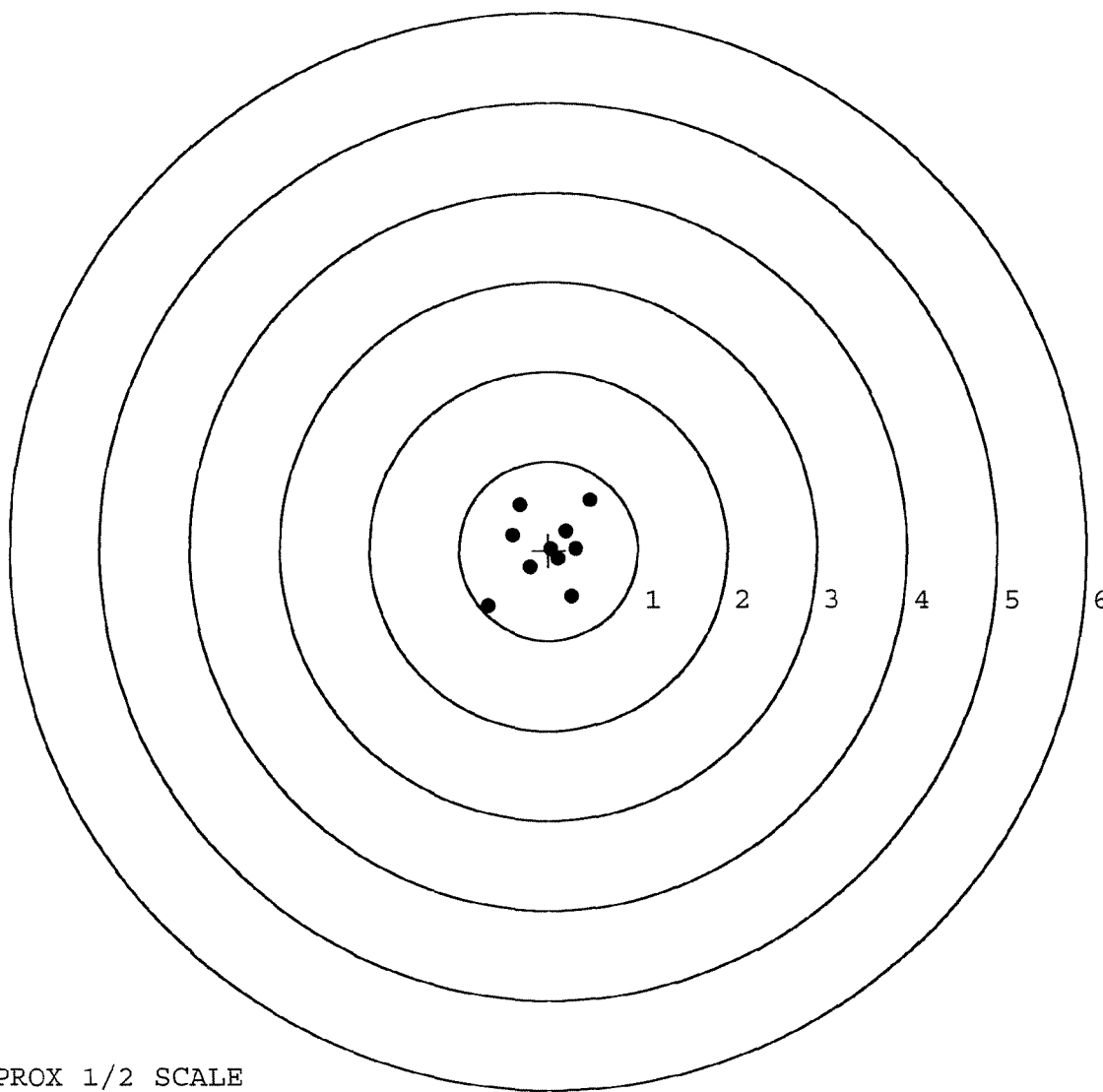
TARGET APPROX 1/2 SCALE

BARBER - M24 0173000

SERIAL NUMBER: G6672589. __0
 TARGET NUMBER: 3
 FILE DATE: 09/01/2007
 FILE TIME: 04:52

POINT#	X	Y
1:	0.468	0.563
2:	-0.316	0.509
3:	-0.401	0.166
4:	-0.674	-0.637
5:	0.256	-0.523
6:	0.195	0.220
7:	0.303	0.014
8:	0.101	-0.097
9:	-0.202	-0.189
10:	0.022	0.019

X CENTROID: -0.025
 Y CENTROID: 0.004
 POA TO CENTROID: 0.025
 HORZ SPREAD: 1.142
 VERT SPREAD: 1.200
 GROUP SPREAD: 1.657
 MIN RADIUS: 0.049
 MAX RADIUS: 0.913
 MEAN RADIUS: 0.436
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6672589. 0

TARGET NUMBER: 4

FILE DATE: 09/01/2007

FILE TIME: 04:52

X CENTROID: 0.130

Y CENTROID: -0.053

POA TO CENTROID: 0.140

HORZ SPREAD: 1.157

VERT SPREAD: 1.149

GROUP SPREAD: 1.271

MIN RADIUS: 0.218

MAX RADIUS: 0.676

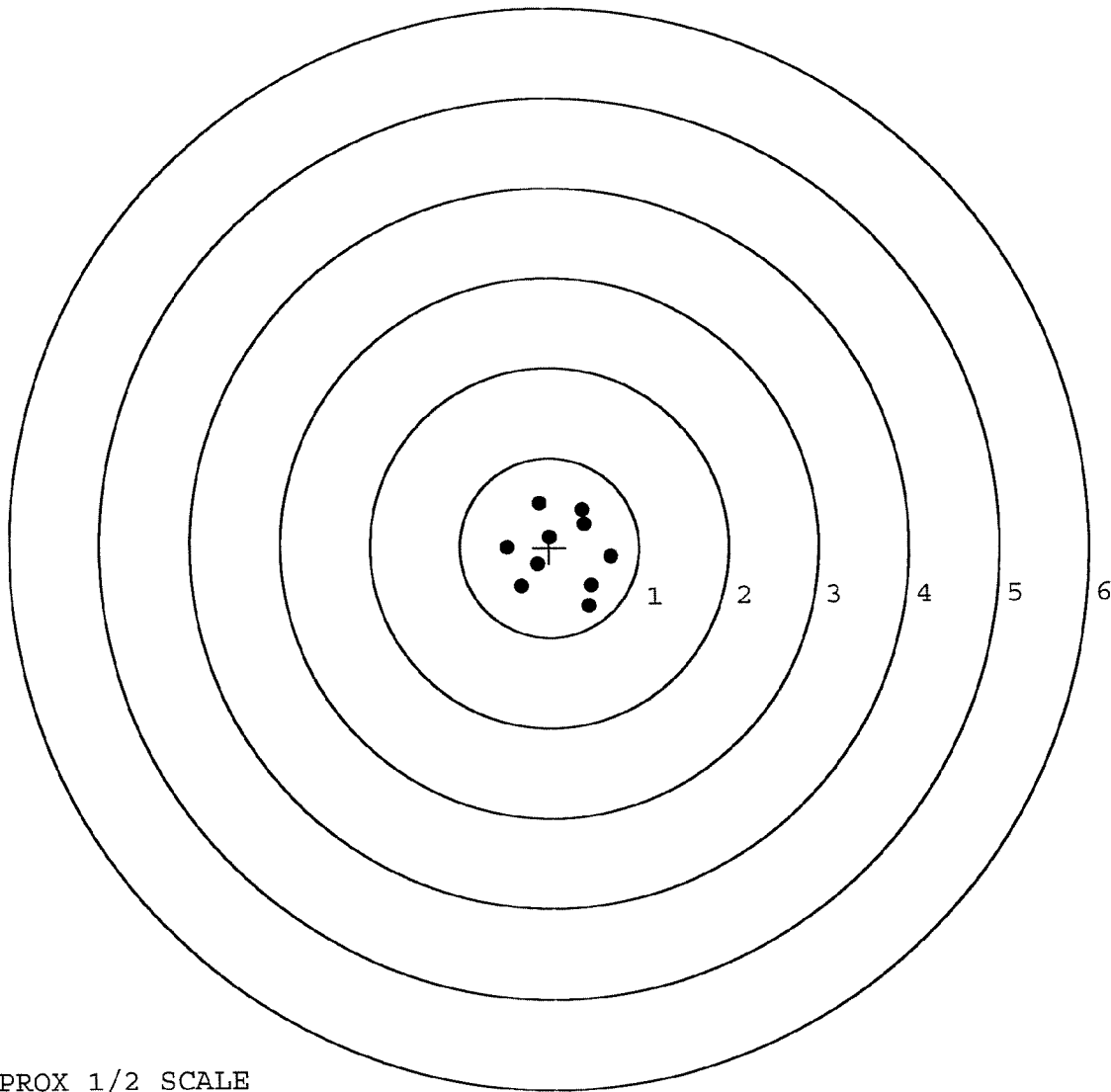
MEAN RADIUS: 0.498

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.436	-0.655
2:	0.462	-0.427
3:	0.684	-0.110
4:	0.387	0.262
5:	0.371	0.420
6:	-0.107	0.494
7:	-0.005	0.119
8:	-0.473	0.000
9:	-0.138	-0.190
10:	-0.316	-0.440



TARGET APPROX 1/2 SCALE

BARBER - M24 0173002

SERIAL NUMBER: G6672589. __0

TARGET NUMBER: 5

FILE DATE: 09/01/2007

FILE TIME: 04:52

X CENTROID: -0.054

Y CENTROID: -0.152

POA TO CENTROID: 0.161

HORZ SPREAD: 2.215

VERT SPREAD: 1.550

GROUP SPREAD: 2.548

MIN RADIUS: 0.255

MAX RADIUS: 1.405

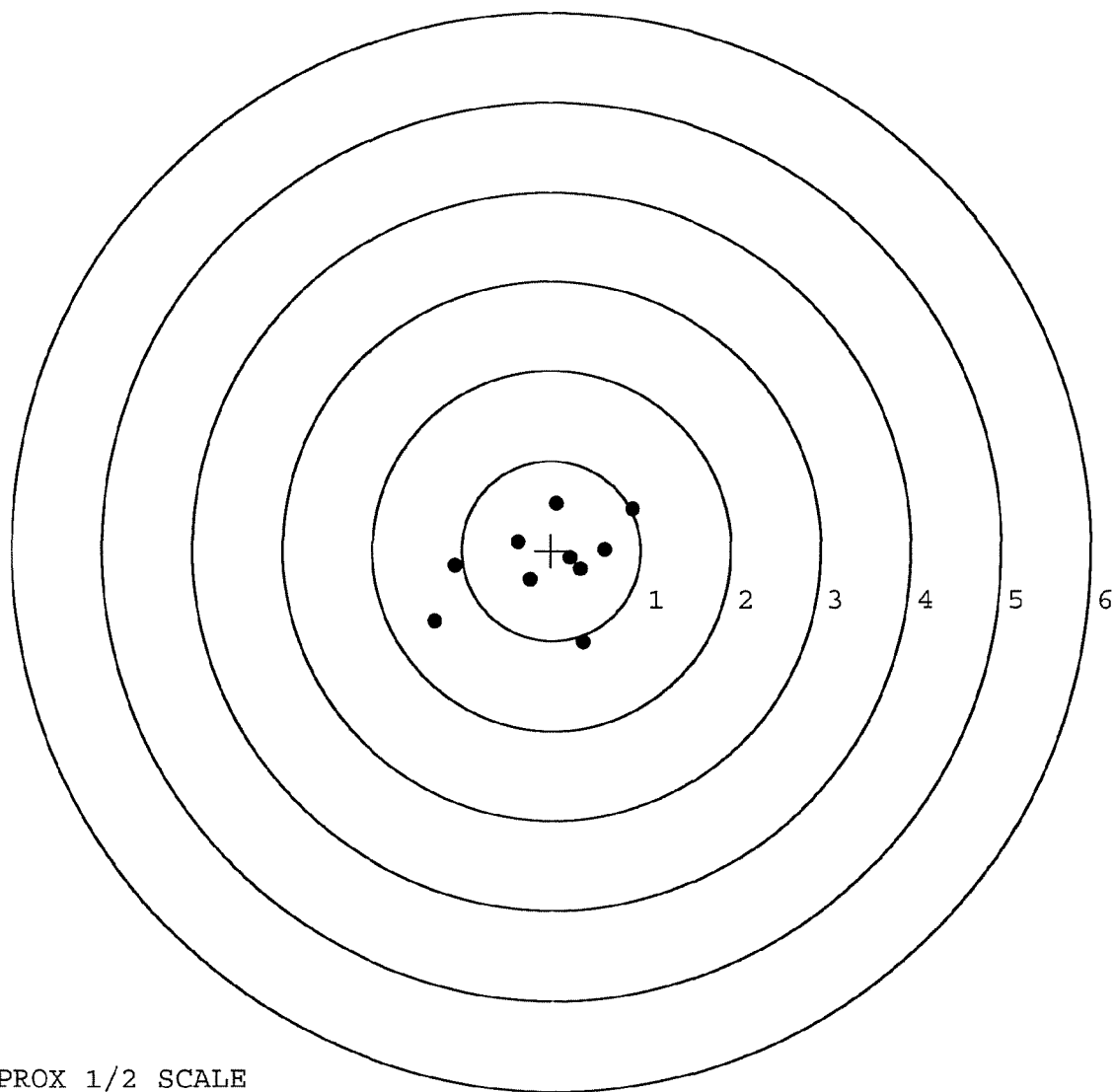
MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.352	-1.026
2:	0.059	0.524
3:	-0.238	-0.328
4:	-0.371	0.099
5:	-1.077	-0.178
6:	-1.302	-0.796
7:	0.324	-0.211
8:	0.594	0.013
9:	0.913	0.464
10:	0.209	-0.082



TARGET APPROX 1/2 SCALE