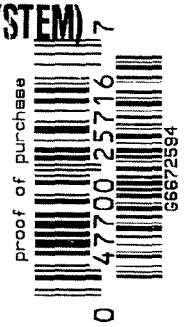
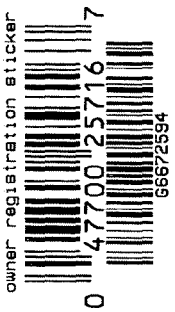
M24000173118

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

– INSTUCTION BOOK 3518

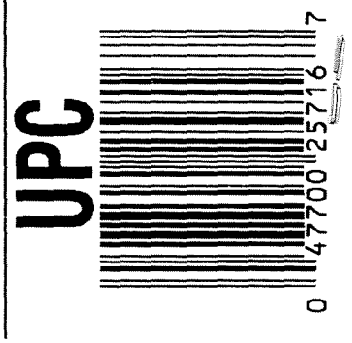




ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6672594



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

BARBER - M24 0173082 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6672594

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8/13/07	
420	ASSEMBLE ACTION		8-10-07	SD
430	ASSEMBLE TO STOCK		8/10/07	
440	PROOF	MAGNA - FLUX AUG 15 2007	8/10/07	
460	CHECK HEADSPACE		8/10/07	
470	DIS-ASSEMBLE ACTION		8/13/07	
480	MAGNAFLUX BBL ACTION	OPERATOR	8-15-07	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-14-07	CW
510	DRILL AND TAP SIGHT HOLES		8-14-07	TRW
520	GOFF BLAST BBL / REC		8-15-07	
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/22/07	
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		8-22-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-22-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-22-07	SD
	D) OIL FIRING PIN ASSEMBLY		8/27/07	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

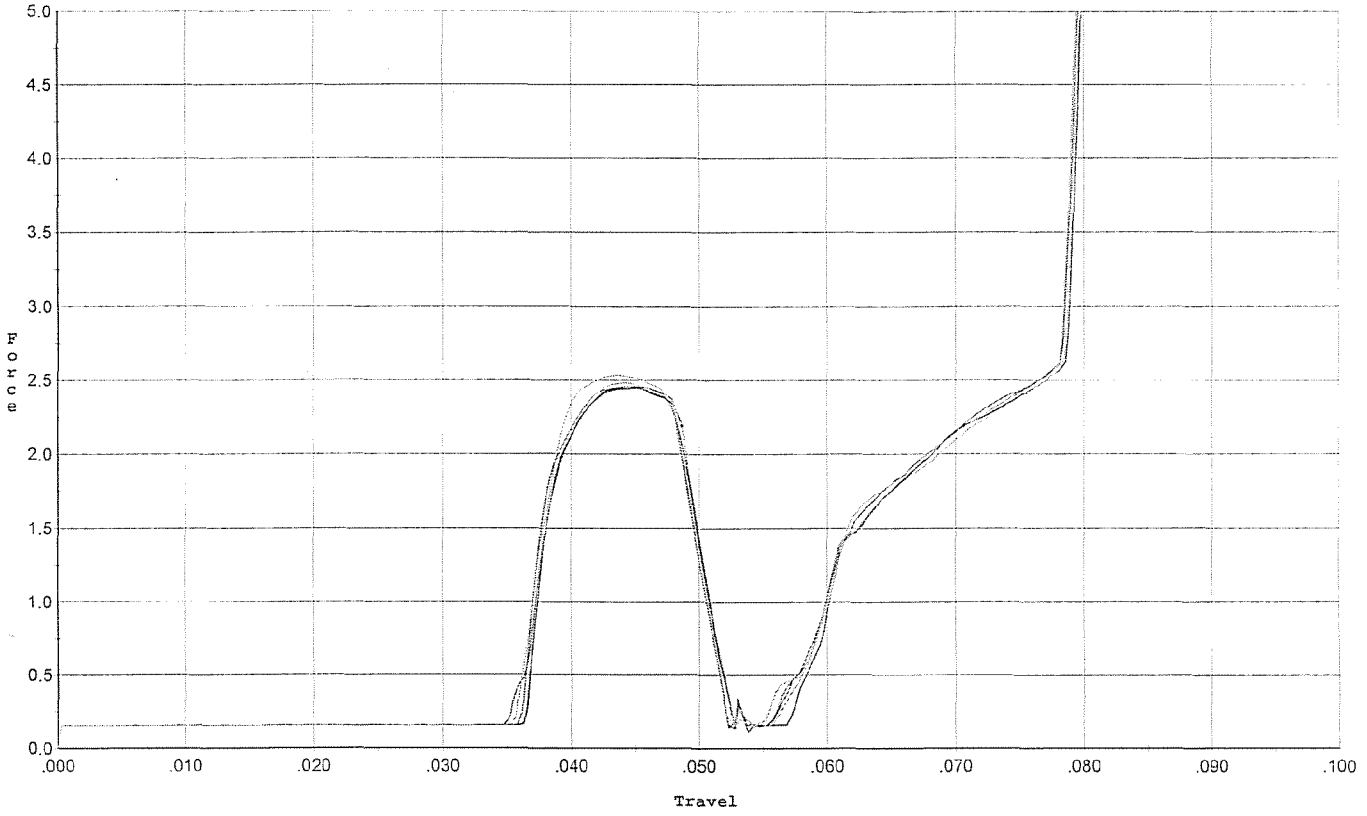
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
	BARBER - M24 0173083			
560	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	5.8 5.8 5.8	8/28/07	RP
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	3.2 3.4 3.4	8/28/07	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.023 .023 .023	8/28/07	RP
	J) ASSEMBLE STOCK		8/27/07	RP
	K) ASSEMBLE SWIVEL STUDS		8/28/07	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-29-07	RTZ
	M) IRON SIGHT ALIGNMENT		8-29-07	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-29-07	RTZ
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	8-28-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-28-07	WK
670	FINAL INSPECTION A) HEADSPACE		8-29-07	RTZ
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.63 2.67 2.67 2.62 2.62	8/28/07	07
	C) FUNCTION			
690	PACK		8/29/07	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 8/17/07		



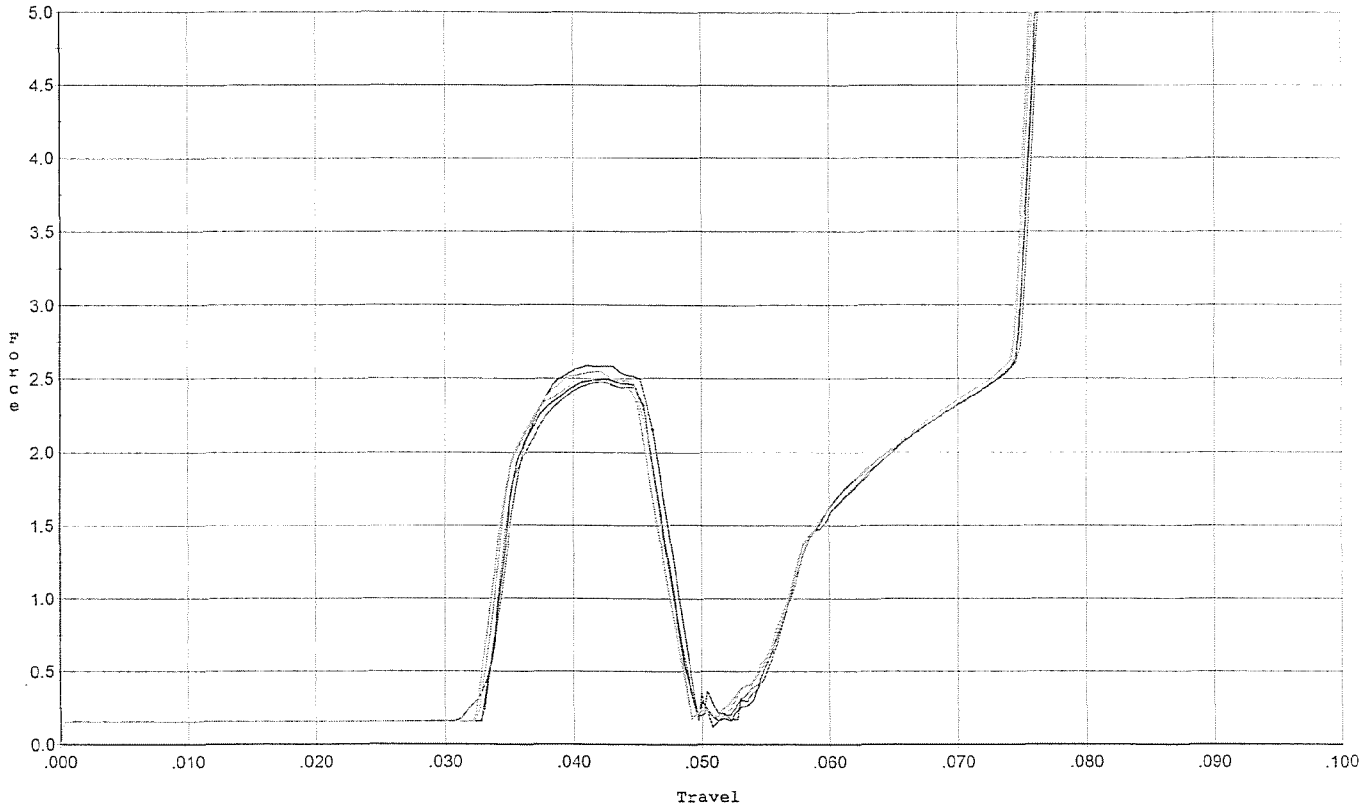
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.446	0.049	0.035	0.037	0.034		Set Trigger
2	2.455	0.049	0.037	0.037	0.033		Set Trigger
3	2.455	0.048	0.036	0.037	0.033		Set Trigger
4	2.536	0.050	0.036	0.036	0.035		Set Trigger
5	2.482	0.049	0.037	0.037	0.034		Set Trigger

Avg 2.47

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:26:32 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 8/17/07		



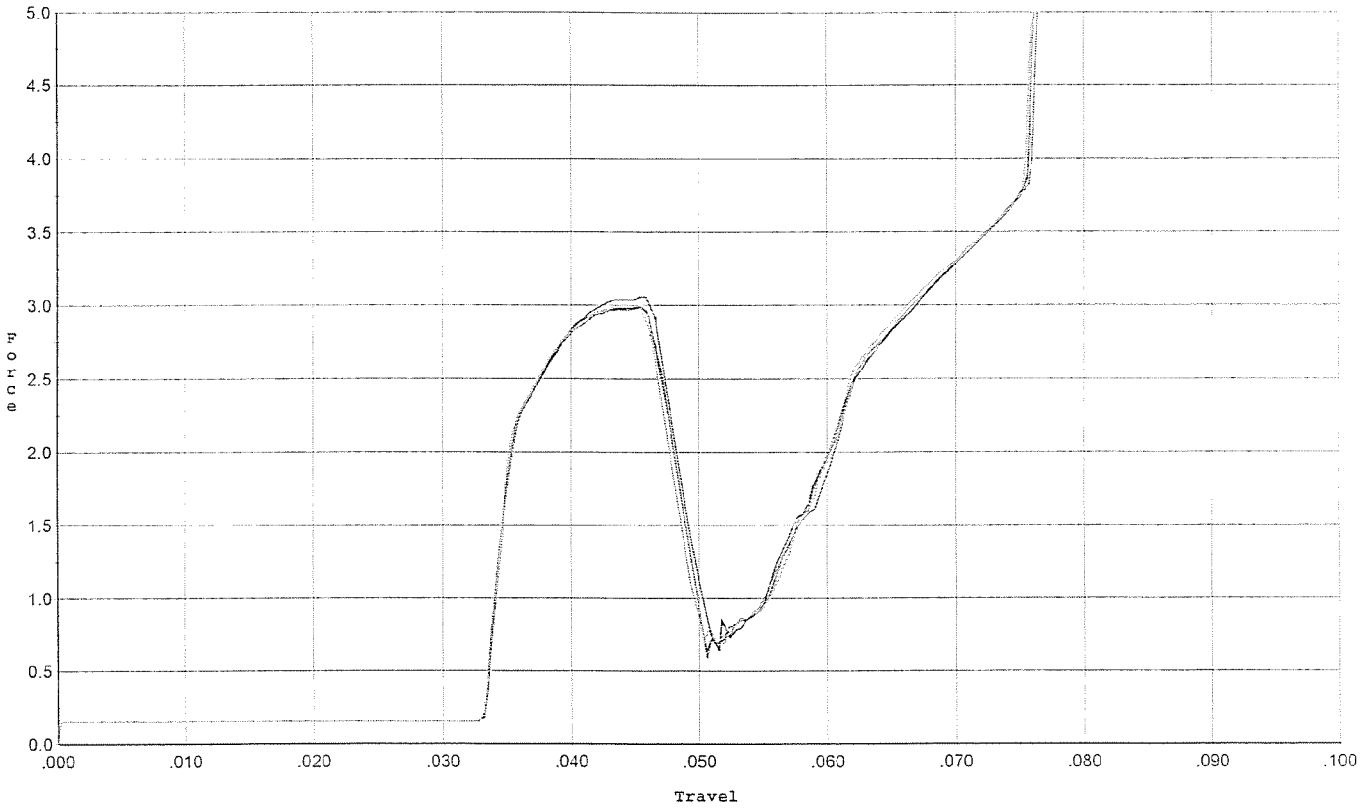
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.590	0.046	0.033	0.035	0.036		Set Trigger
2	2.496	0.046	0.033	0.035	0.034		Set Trigger
3	2.477	0.045	0.033	0.035	0.033		Set Trigger
4	2.488	0.045	0.033	0.035	0.034		Set Trigger
5	2.545	0.046	0.033	0.034	0.035		Set Trigger

Avg 2.51

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:28:11 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 8/17/07		



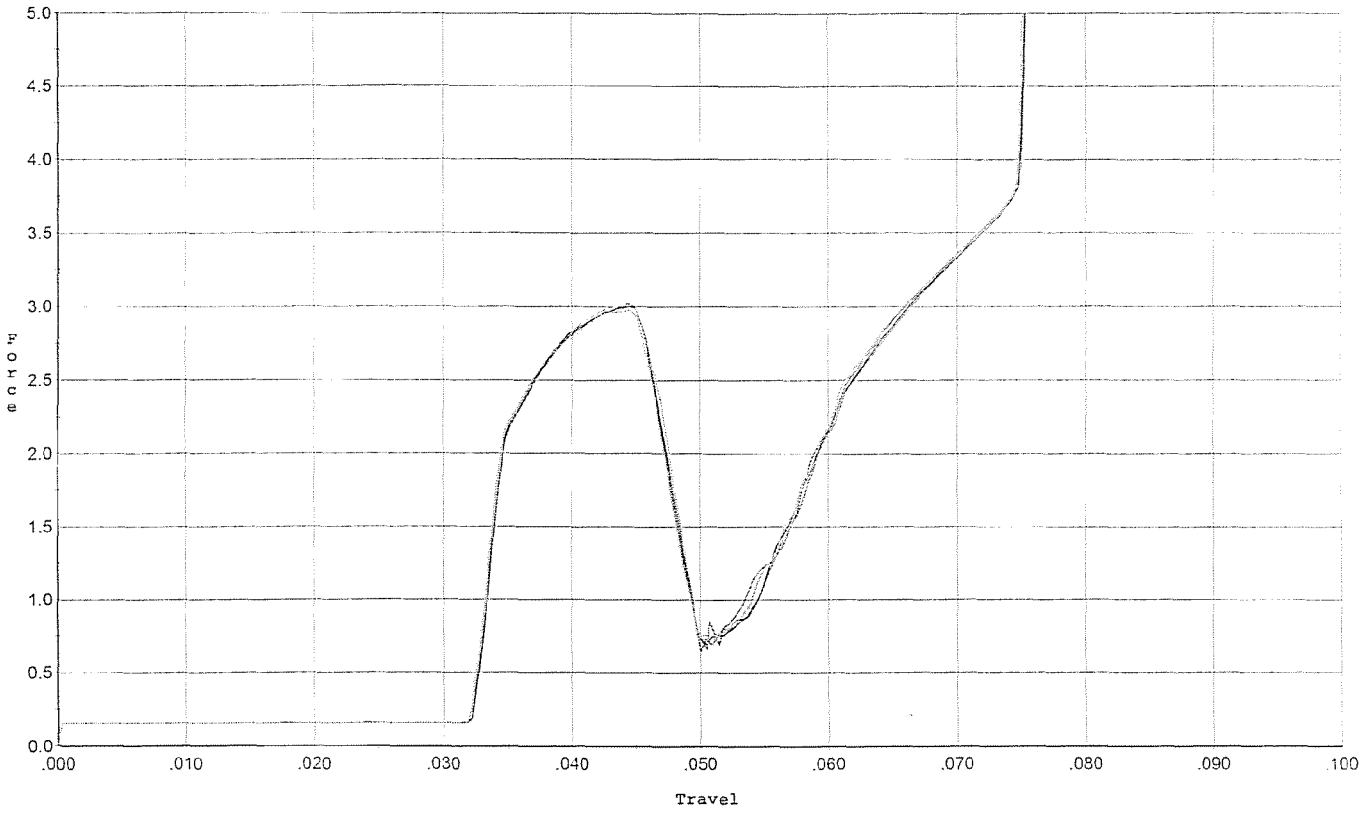
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.058	0.047	0.033	0.034	0.042		Set Trigger
2	2.991	0.047	0.033	0.034	0.042		Set Trigger
3	2.985	0.048	0.033	0.034	0.042		Set Trigger
4	3.000	0.047	0.033	0.034	0.042		Set Trigger
5	2.996	0.046	0.033	0.034	0.041		Set Trigger

AVG 3.00

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:29:56 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 8/17/07		



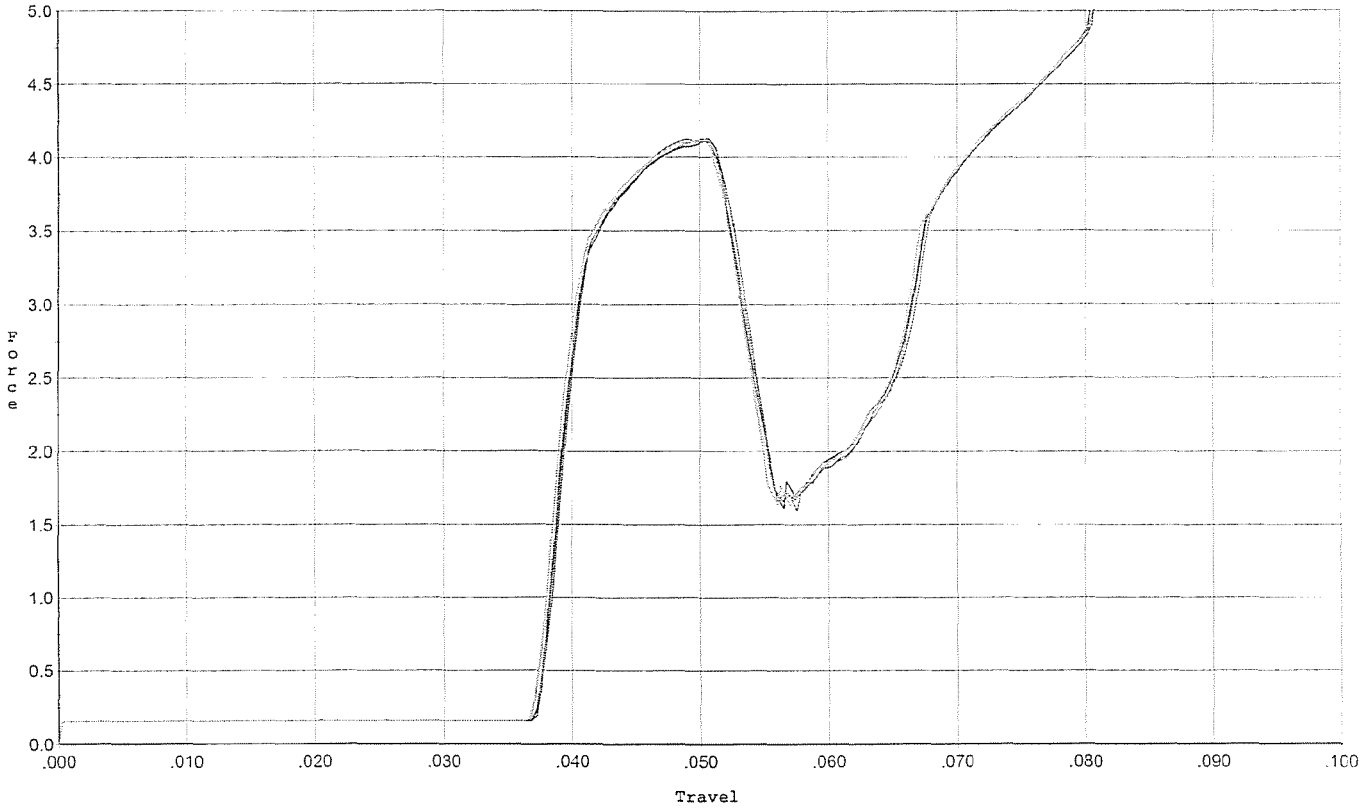
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.015	0.048	0.032	0.033	0.043		Set Trigger
2	3.018	0.046	0.032	0.033	0.041		Set Trigger
3	3.003	0.046	0.032	0.033	0.041		Set Trigger
4	3.015	0.047	0.032	0.033	0.043		Set Trigger
5	2.980	0.046	0.032	0.033	0.041		Set Trigger

Avg 3.00

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co.. Inc.. 8/17/2007 10:31:37 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 8/17/07		



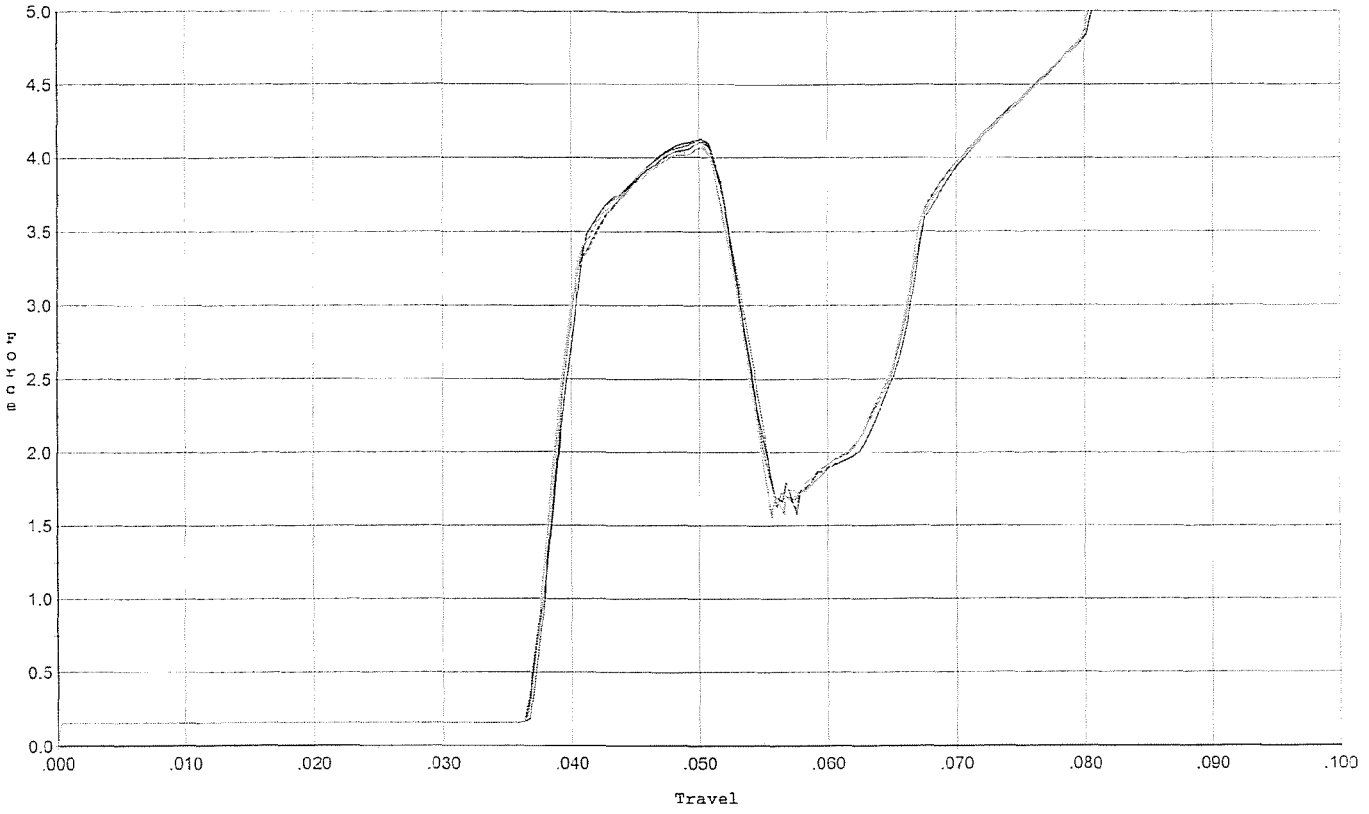
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.053	0.037	0.032	0.061		Set Trigger
2	4.109	0.051	0.037	0.032	0.059		Set Trigger
3	4.127	0.053	0.037	0.032	0.062		Set Trigger
4	4.136	0.052	0.037	0.032	0.060		Set Trigger
5	4.123	0.052	0.037	0.032	0.061		Set Trigger

AVG ~~4.13~~ RP
4.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:33:15 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 8/17/07		



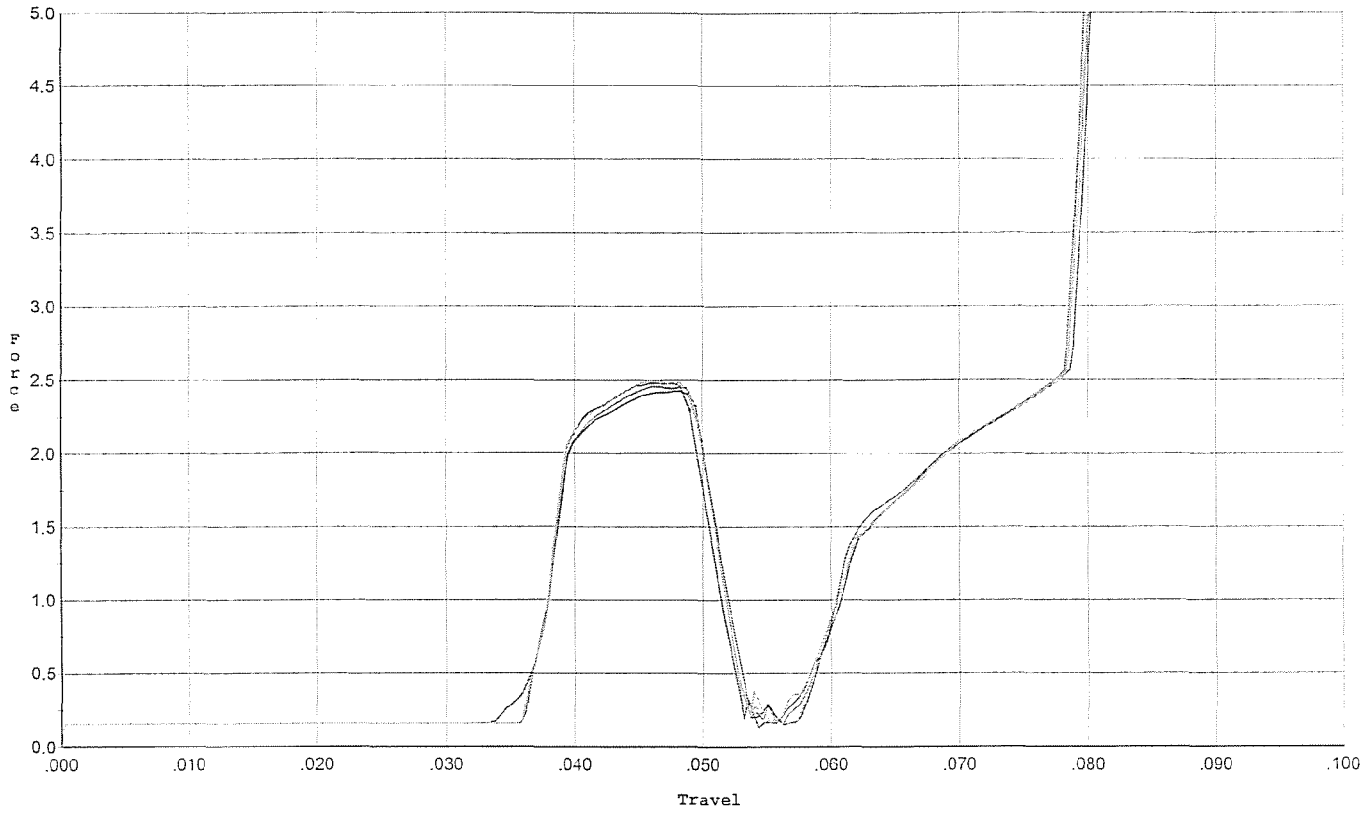
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.052	0.037	0.032	0.060		Set Trigger
2	4.130	0.052	0.037	0.032	0.061		Set Trigger
3	4.125	0.054	0.037	0.032	0.064		Set Trigger
4	4.097	0.053	0.037	0.032	0.062		Set Trigger
5	4.074	0.052	0.037	0.032	0.061		Set Trigger

Avg 4.10

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:34:57 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 8/17/07		



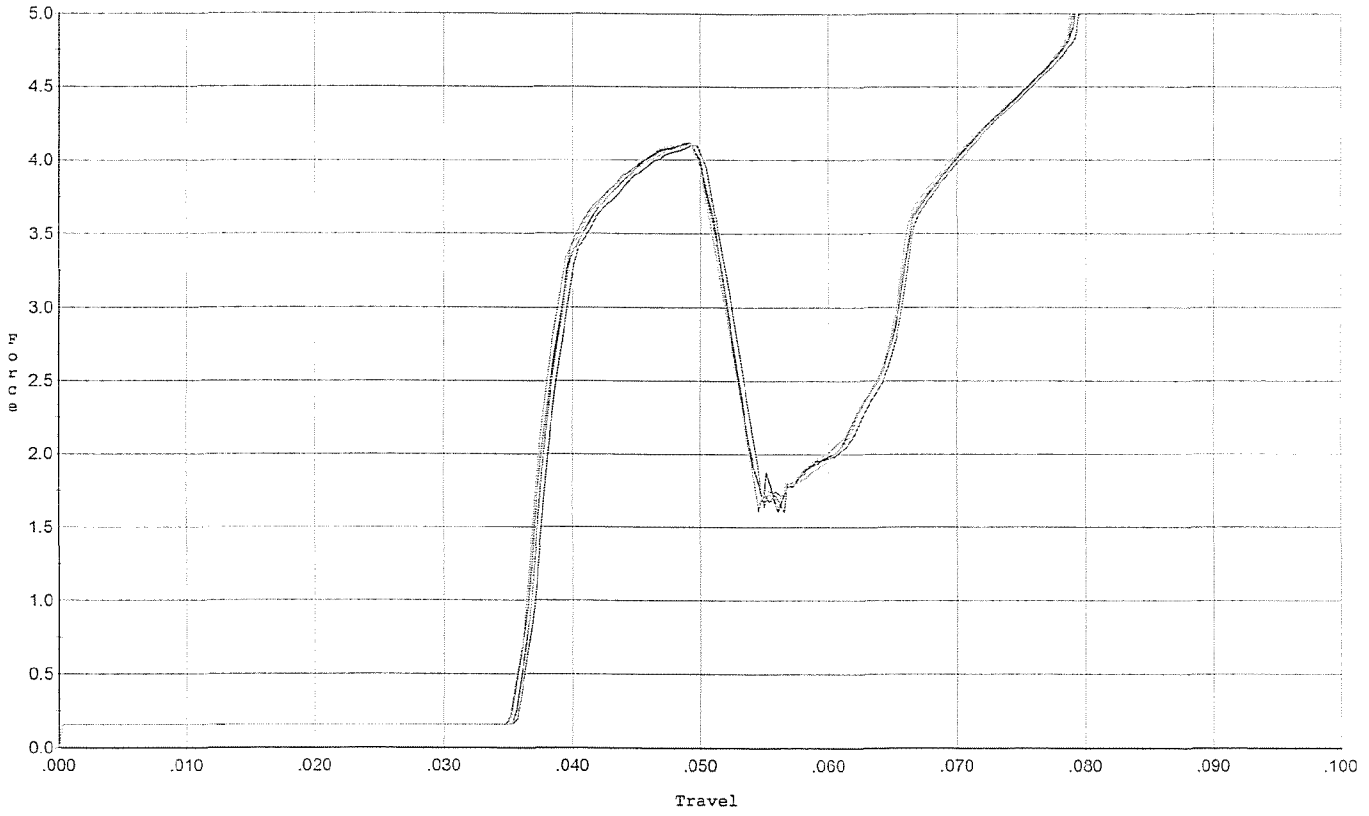
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.475	0.049	0.036	0.036	0.034		Set Trigger
2	2.423	0.050	0.036	0.036	0.034		Set Trigger
3	2.454	0.049	0.036	0.036	0.035		Set Trigger
4	2.501	0.050	0.036	0.036	0.035		Set Trigger
5	2.483	0.050	0.036	0.036	0.035		Set Trigger

AVG 2.46

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:36:35 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 8/17/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.096	0.052	0.036	0.032	0.062		Set Trigger
2	4.119	0.051	0.036	0.032	0.061		Set Trigger
3	4.123	0.051	0.035	0.032	0.062		Set Trigger
4	4.118	0.051	0.036	0.032	0.061		Set Trigger
5	4.123	0.052	0.035	0.032	0.063		Set Trigger

Avg 4.11

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 8/17/2007 10:38:27 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6672594.__0
FILE DATE AND TIME: 08/29/2007 04:49

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

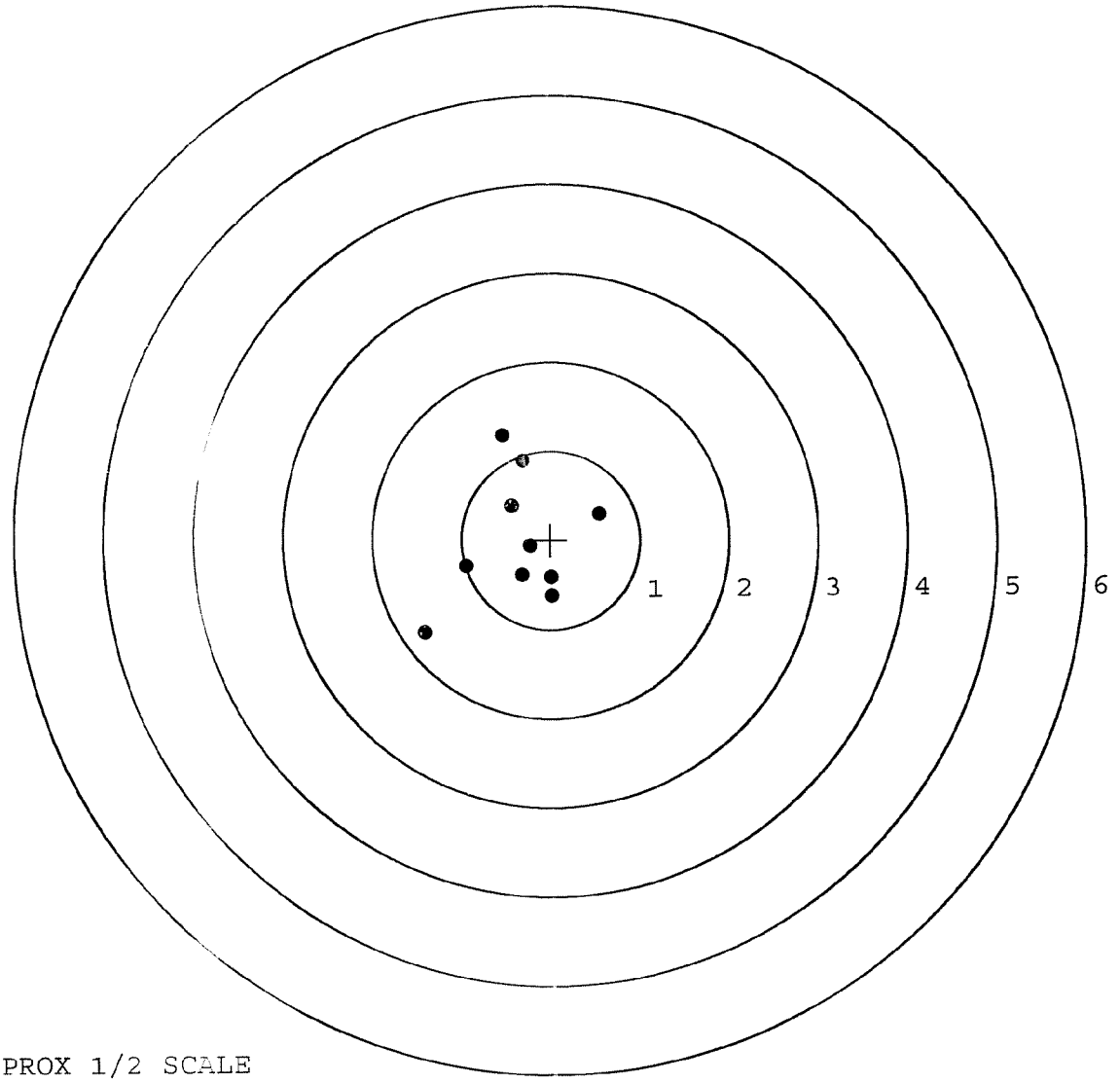
The Average X Centroid of the Five Target Set:	-0.068
The Average Y Centroid of the Five Target Set:	0.047
The Average Point of Impact of the Five Target Set:	0.083
The Average Mean Radius of the Five Target Set:	0.687
The Distance from POA to Centroid Target #1:	0.363
The Distance from Centroid Target #2 to Centroid Target #1:	0.454
The Distance from Centroid Target #3 to Centroid Target #1:	0.410
The Distance from Centroid Target #4 to Centroid Target #1:	0.314
The Distance from Centroid Target #5 to Centroid Target #1:	0.339

BARBER - M24 0173093

SERIAL NUMBER: G6672594.__0
TARGET NUMBER: 1
FILE DATE: 08/29/2007
FILE TIME: 04:49

X CENTROID:	-0.363
Y CENTROID:	-0.011
POA TO CENTROID:	0.363
HORZ SPREAD:	1.966
VERT SPREAD:	2.214
GROUP SPREAD:	2.387
MIN RADIUS:	0.146
MAX RADIUS:	1.473
MEAN RADIUS:	0.740
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.011	-0.631
2:	0.004	-0.422
3:	-0.321	-0.396
4:	-0.228	-0.067
5:	0.547	0.293
6:	-0.436	0.384
7:	-0.311	0.889
8:	-0.527	1.175
9:	-0.953	-0.297
10:	-1.419	-1.039



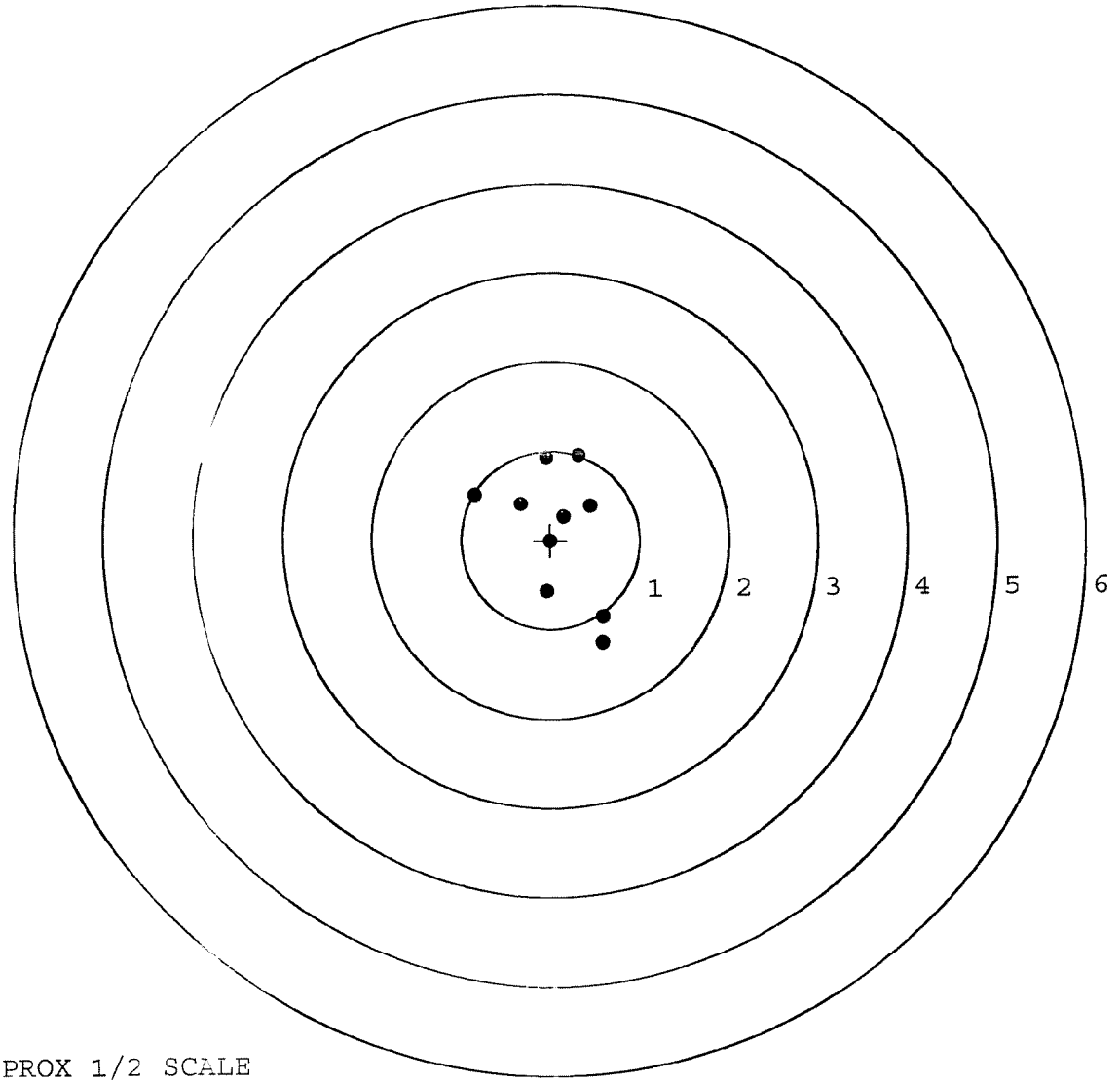
TARGET APPROX 1/2 SCALE

BARBER - M24 0173094

SERIAL NUMBER: G6672594.__0
TARGET NUMBER: 2
FILE DATE: 08/29/2007
FILE TIME: 04:49

X CENTROID:	0.081
Y CENTROID:	0.081
POA TO CENTROID:	0.115
HORZ SPREAD:	1.427
VERT SPREAD:	2.109
GROUP SPREAD:	2.188
MIN RADIUS:	0.136
MAX RADIUS:	1.334
MEAN RADIUS:	0.720
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.575	-1.158
2:	0.586	-0.869
3:	-0.049	-0.583
4:	0.451	0.382
5:	0.153	0.261
6:	-0.011	-0.019
7:	-0.332	0.408
8:	-0.841	0.510
9:	-0.045	0.928
10:	0.326	0.951



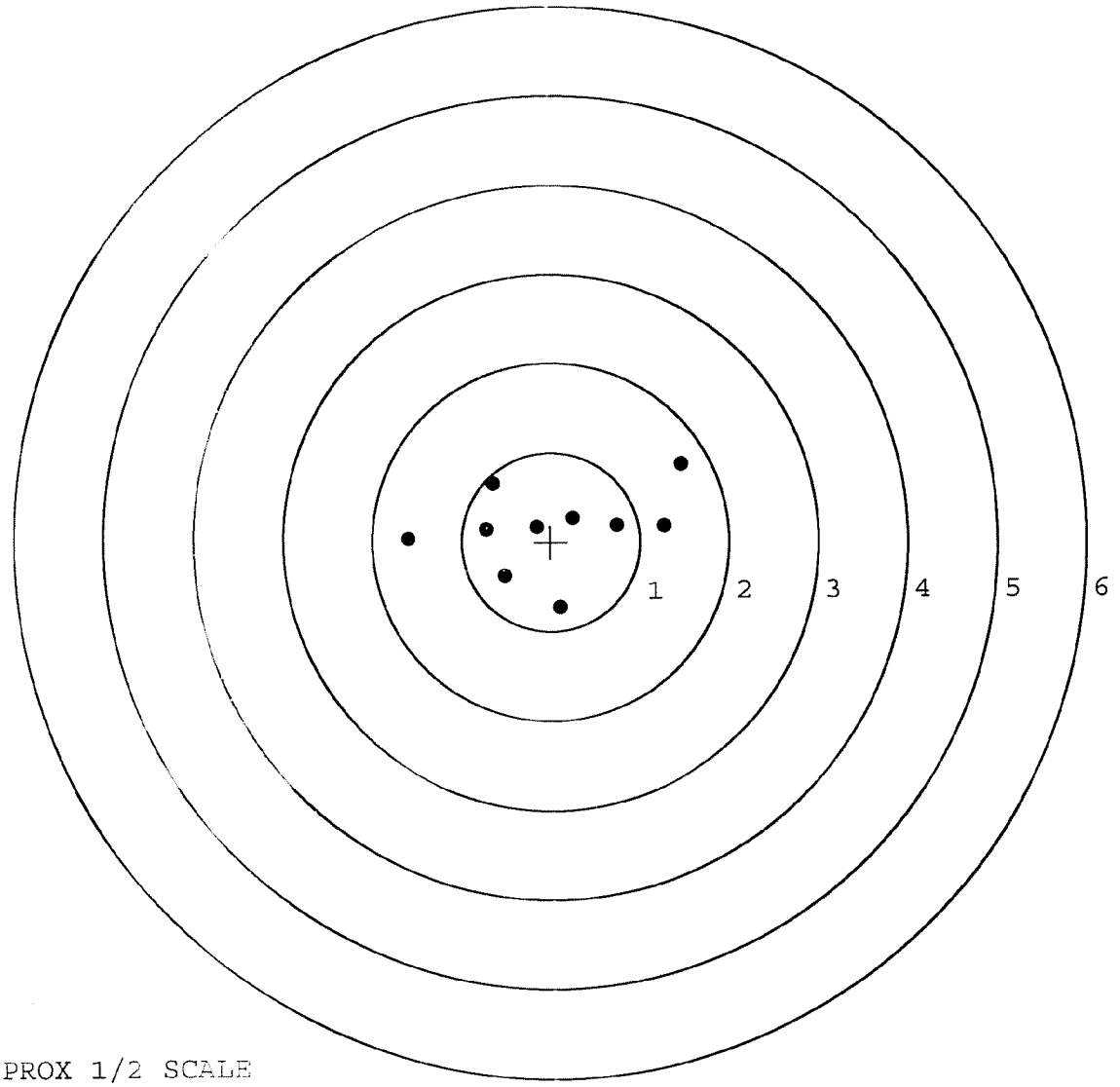
TARGET APPROX 1/2 SCALE

BARBER - M24 0173095

SERIAL NUMBER: G6672594.__0
TARGET NUMBER: 3
FILE DATE: 08/29/2007
FILE TIME: 04:49

X CENTROID:	0.019
Y CENTROID:	0.138
POA TO CENTROID:	0.140
HORZ SPREAD:	3.063
VERT SPREAD:	1.602
GROUP SPREAD:	3.172
MIN RADIUS:	0.178
MAX RADIUS:	1.622
MEAN RADIUS:	0.887
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.270	0.180
2:	1.463	0.863
3:	0.105	-0.739
4:	-0.517	-0.382
5:	-0.726	0.145
6:	-0.644	0.654
7:	-1.600	0.039
8:	-0.156	0.173
9:	0.249	0.269
10:	0.744	0.183



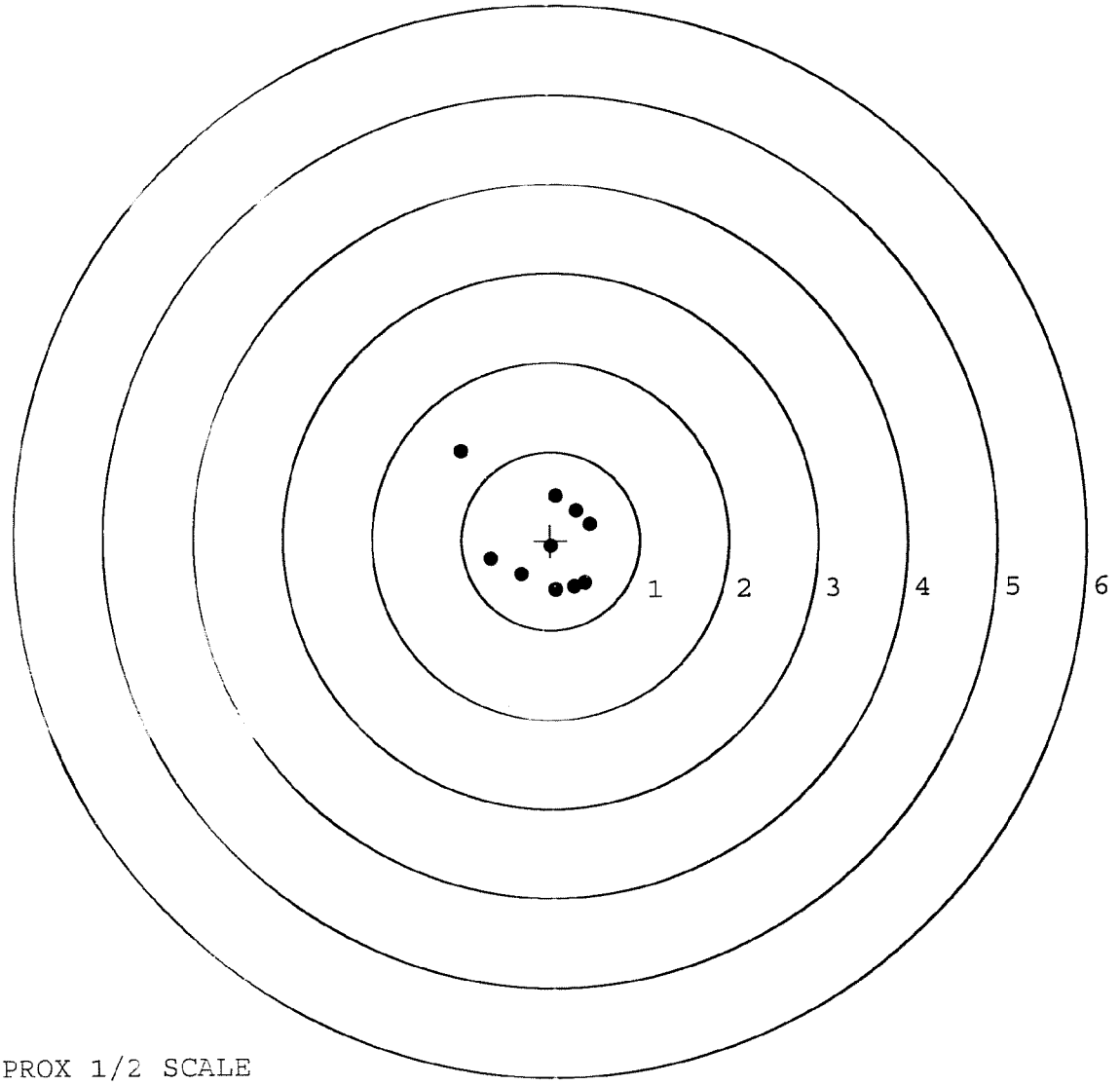
TARGET APPROX 1/2 SCALE

BARBER - M24 0173096

SERIAL NUMBER: G6672594.__0
TARGET NUMBER: 4
FILE DATE: 08/29/2007
FILE TIME: 04:49

X CENTROID:	-0.050
Y CENTROID:	-0.018
POA TO CENTROID:	0.053
HORZ SPREAD:	1.435
VERT SPREAD:	1.565
GROUP SPREAD:	2.033
MIN RADIUS:	0.065
MAX RADIUS:	1.397
MEAN RADIUS:	0.590
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.382	-0.485
2:	0.263	-0.521
3:	0.055	-0.555
4:	-0.329	-0.385
5:	-0.668	-0.212
6:	-0.001	-0.062
7:	0.440	0.186
8:	0.290	0.336
9:	0.065	0.504
10:	-0.995	1.010



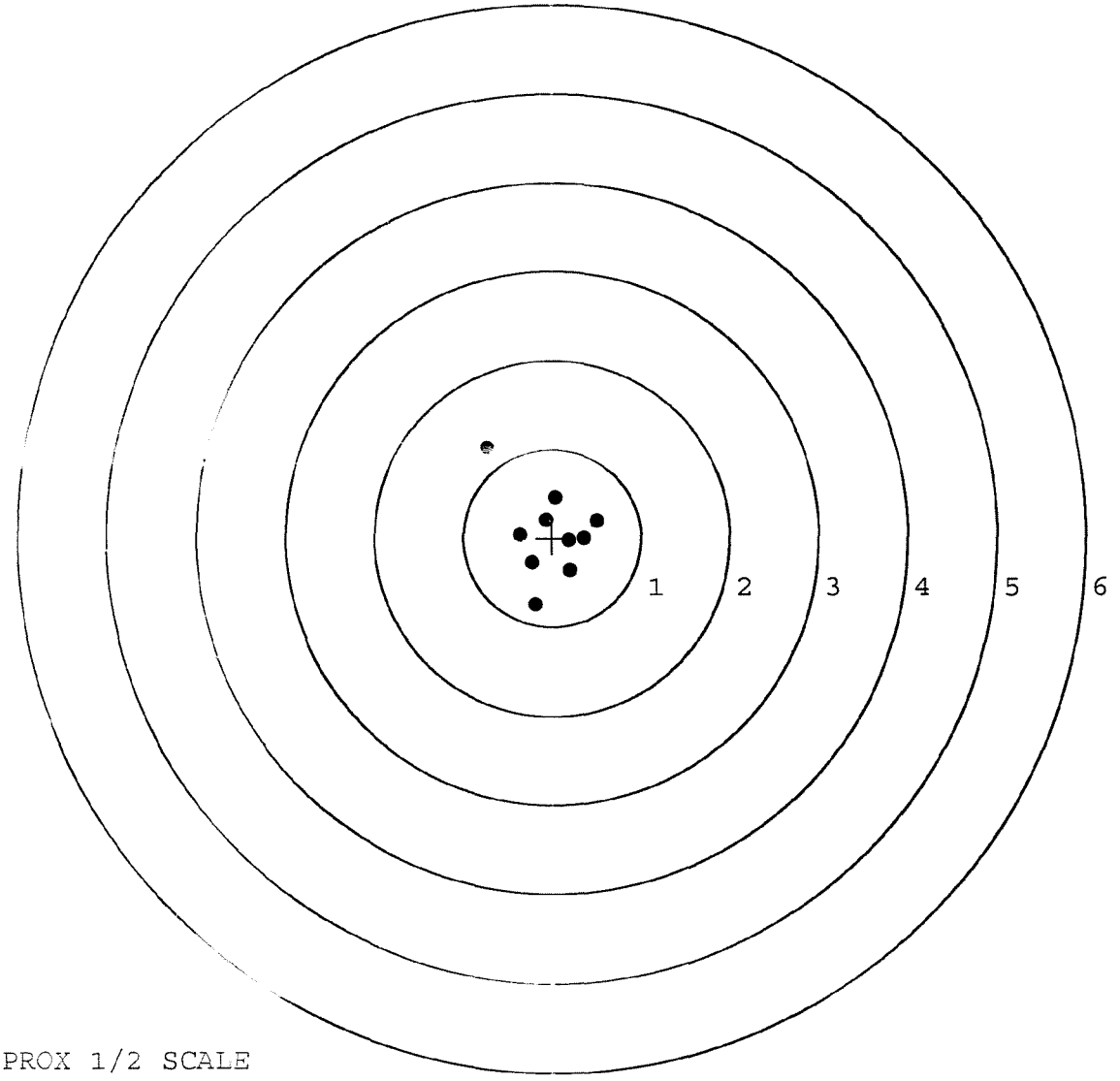
TARGET APPROX 1/2 SCALE

BARBER - M24 0173097

SERIAL NUMBER: G6672594.__0
TARGET NUMBER: 5
FILE DATE: 08/29/2007
FILE TIME: 04:49

X CENTROID:	-0.029
Y CENTROID:	0.047
POA TO CENTROID:	0.055
HORZ SPREAD:	1.230
VERT SPREAD:	1.775
GROUP SPREAD:	1.854
MIN RADIUS:	0.162
MAX RADIUS:	1.195
MEAN RADIUS:	0.496
# IN 1 IN DIAMETER:	7
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.728	1.017
2:	-0.191	-0.758
3:	0.502	0.196
4:	0.364	-0.001
5:	0.180	-0.028
6:	0.202	-0.372
7:	-0.226	-0.283
8:	-0.358	0.038
9:	-0.073	0.203
10:	0.038	0.460



TARGET APPROX 1/2 SCALE

425
240
665
960
55 525

685
240
925
500
425