

G6680267

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

- INSTRUCTION BOOK 3518

BM FORM

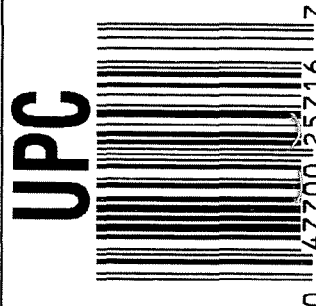


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6680267



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 # G6680267

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9/12/07	SPD
420	ASSEMBLE ACTION		9-11-07	SD
430	ASSEMBLE TO STOCK		9-11-07	SD
440	PROOF		9/11/07	mm
460	CHECK HEADSPACE	MAGNA - FLUX	9/11/07	mm
470	DIS-ASSEMBLE ACTION	SEP 11 2007	9-11-07	SD
480	MAGNAFLUX BBL ACTION		9-14-07	JB
490	MAGNAFLUX BOLT	OPERATOR JB		
500	ROLLMARK CALIBER		9-14-07	CW
510	DRILL AND TAP SIGHT HOLES		9-13-07	SD
520	GOFF BLAST BBL / REC		9-14-07	xy
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/18/07	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/19/07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/19/07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/19/07	SPD
	D) OIL FIRING PIN ASSEMBLY		9/19/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/10/07	mm

F004 REV 5/2006

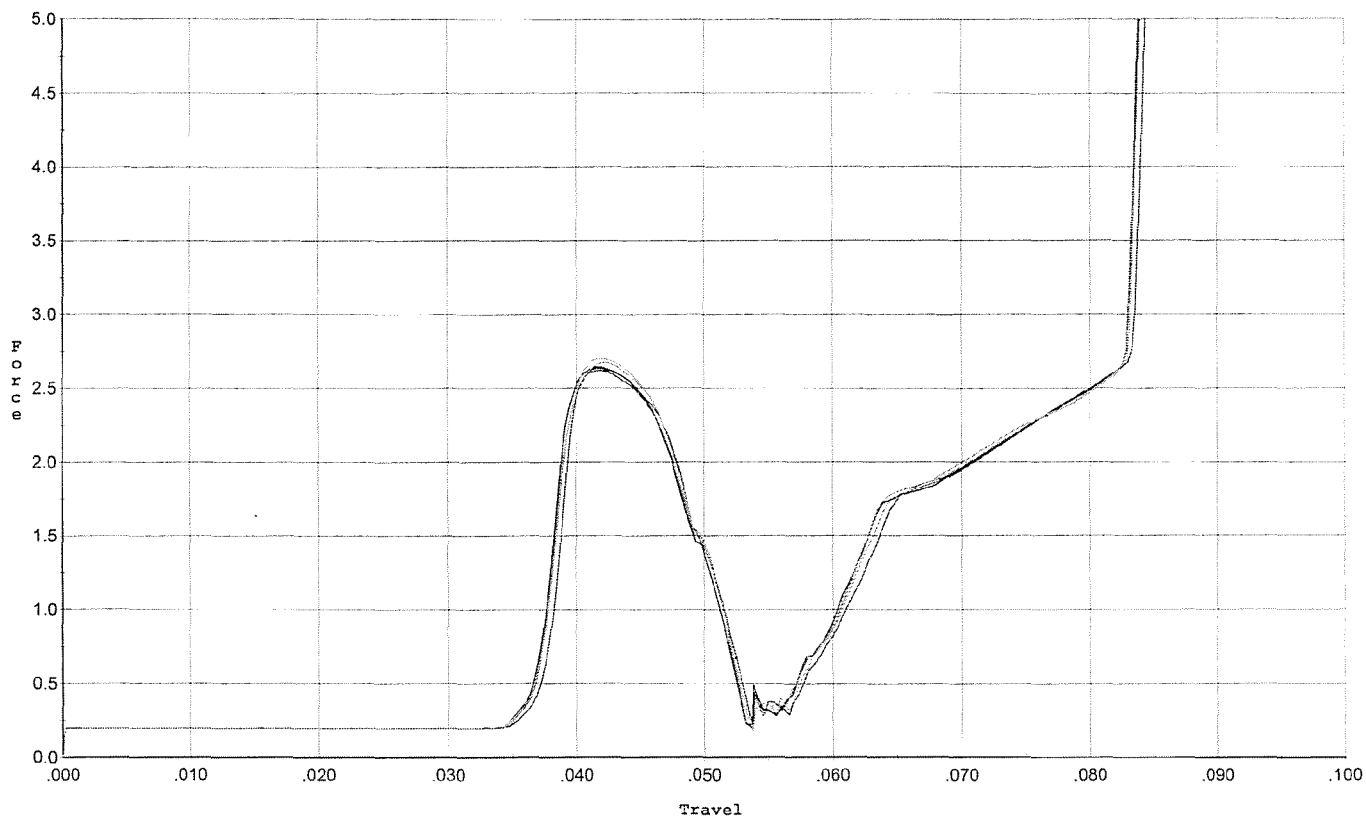
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>5.5</u> <u>5.5</u>	9/24/07	non
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.85</u> <u>6.0</u> <u>6.5</u>	9/24/07	non
	H) TRIGGER PULL TEST AND RETAINABILITY		9/24/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	9/24/07	non
	J) ASSEMBLE STOCK		9/19/07	R.H.D.
	K) ASSEMBLE SWIVEL STUDS		9/24/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10/10/07	non
	M) IRON SIGHT ALIGNMENT		10/10/07	non
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10/10/07	non
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-20-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-20-07	BWD
670	FINAL INSPECTION A) HEADSPACE		9/24/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.19</u> <u>2.17</u> <u>2.18</u> <u>2.22</u> <u>2.18</u>	9-24-07	DA
	C) FUNCTION		9/24/07	non
690	PACK		10-12-07	DA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/07

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



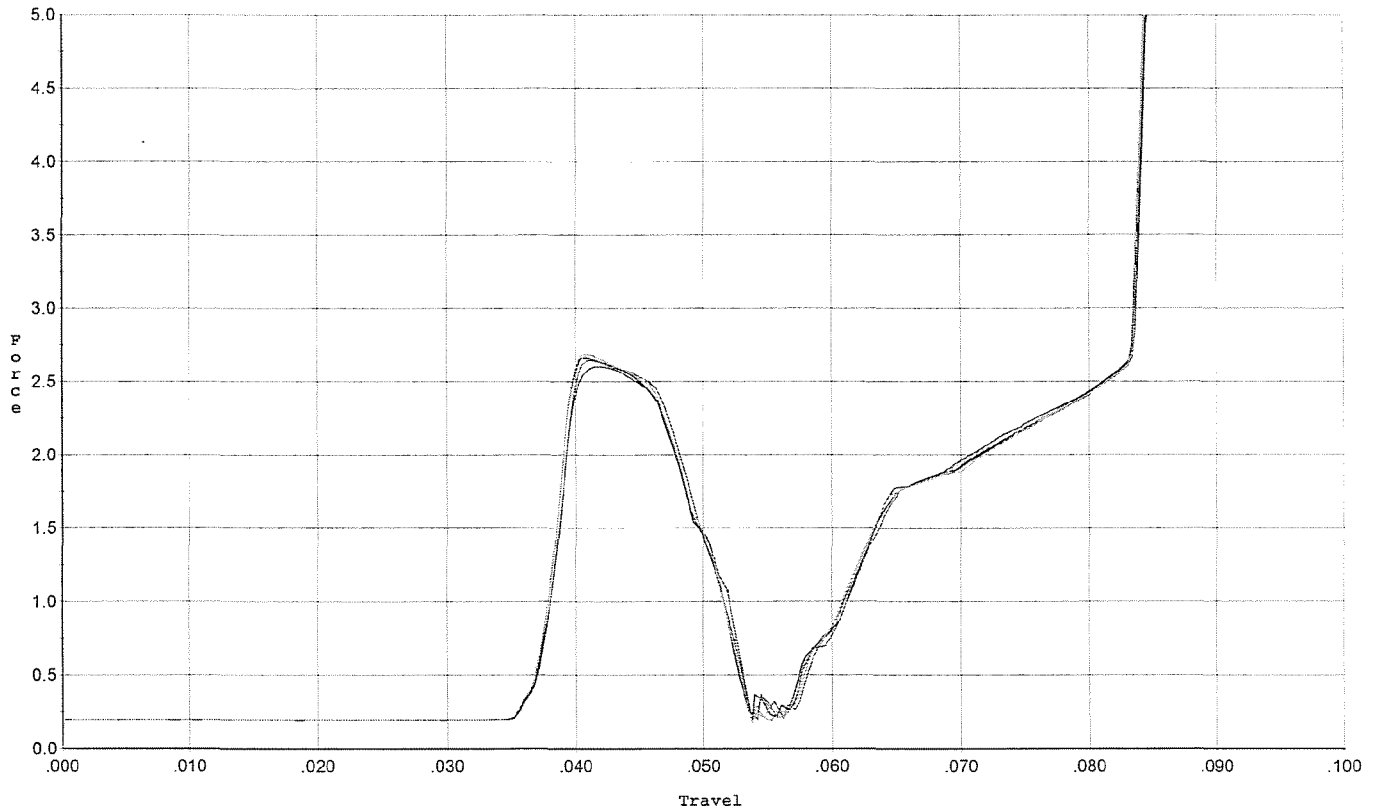
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.635	0.052	0.037	0.039	0.037		Set Trigger
2	2.647	0.052	0.036	0.038	0.037		Set Trigger
3	2.620	0.051	0.036	0.038	0.037		Set Trigger
4	2.699	0.051	0.036	0.039	0.037		Set Trigger
5	2.673	0.051	0.037	0.038	0.037		Set Trigger

AVG 2.65

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/07

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



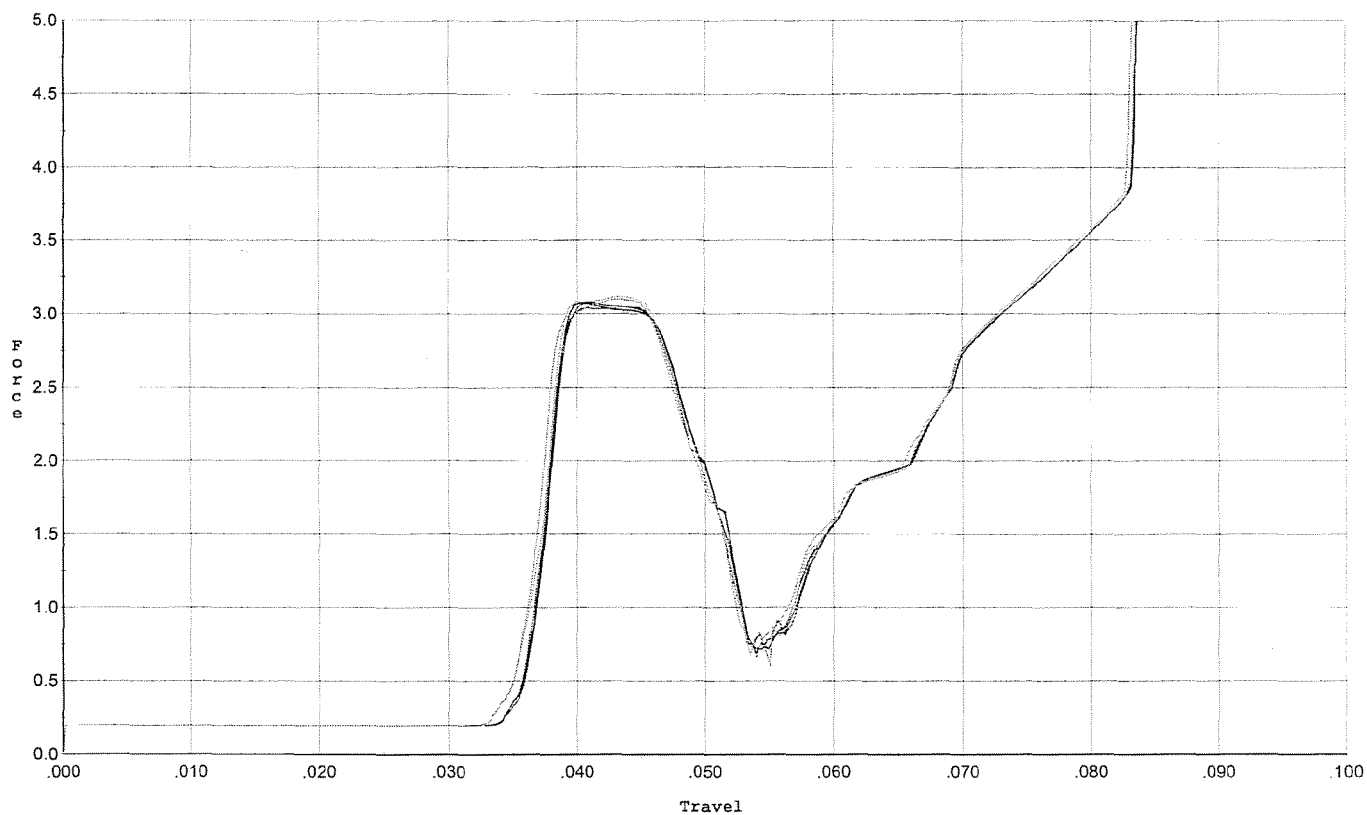
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.052	0.036	0.039	0.037		Set Trigger
2	2.662	0.051	0.036	0.039	0.037		Set Trigger
3	2.647	0.052	0.036	0.039	0.038		Set Trigger
4	2.682	0.051	0.036	0.039	0.037		Set Trigger
5	2.692	0.051	0.036	0.039	0.037		Set Trigger

AVG 2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/07

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



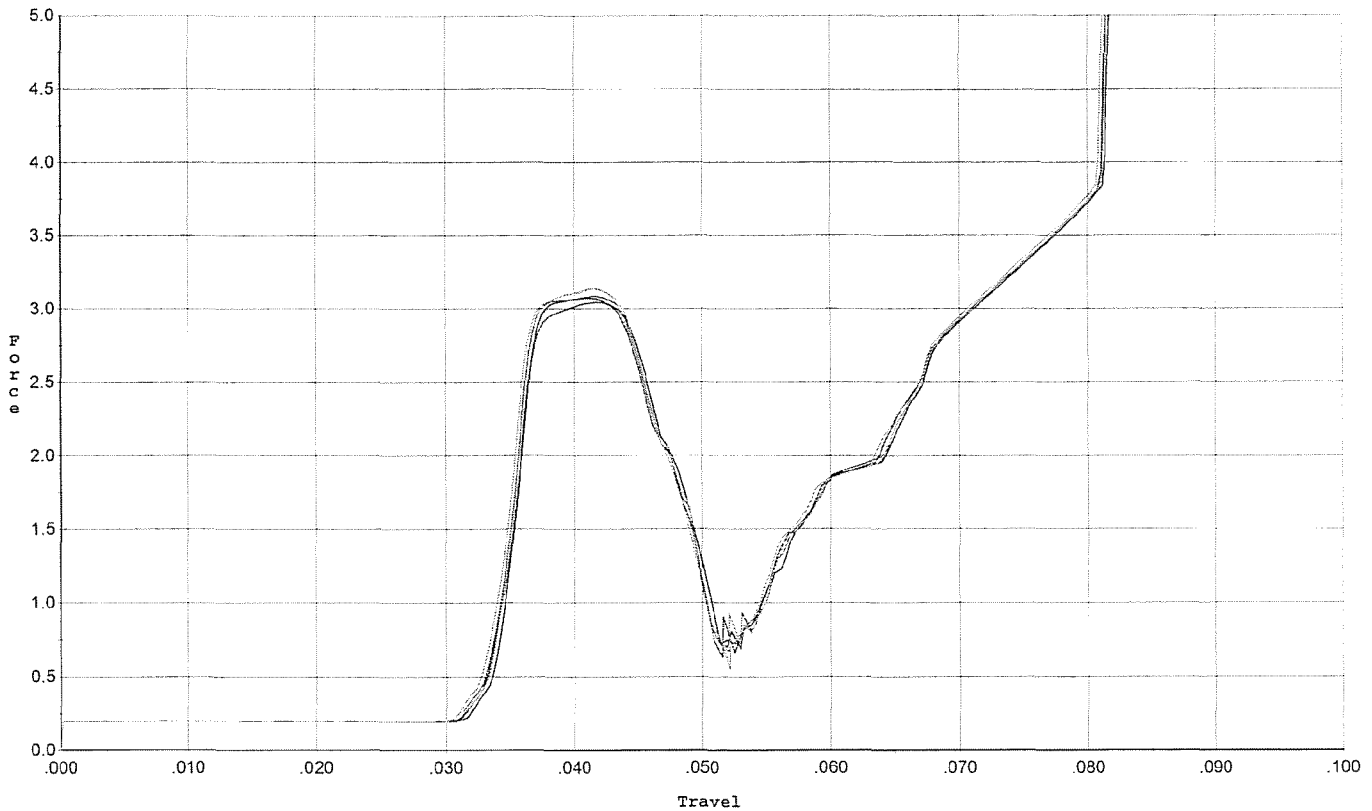
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.077	0.052	0.035	0.037	0.046		Set Trigger
2	3.074	0.051	0.035	0.037	0.046		Set Trigger
3	3.052	0.052	0.035	0.037	0.046		Set Trigger
4	3.115	0.052	0.034	0.037	0.048		Set Trigger
5	3.097	0.051	0.034	0.037	0.047		Set Trigger

AVG 3.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/19/07

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



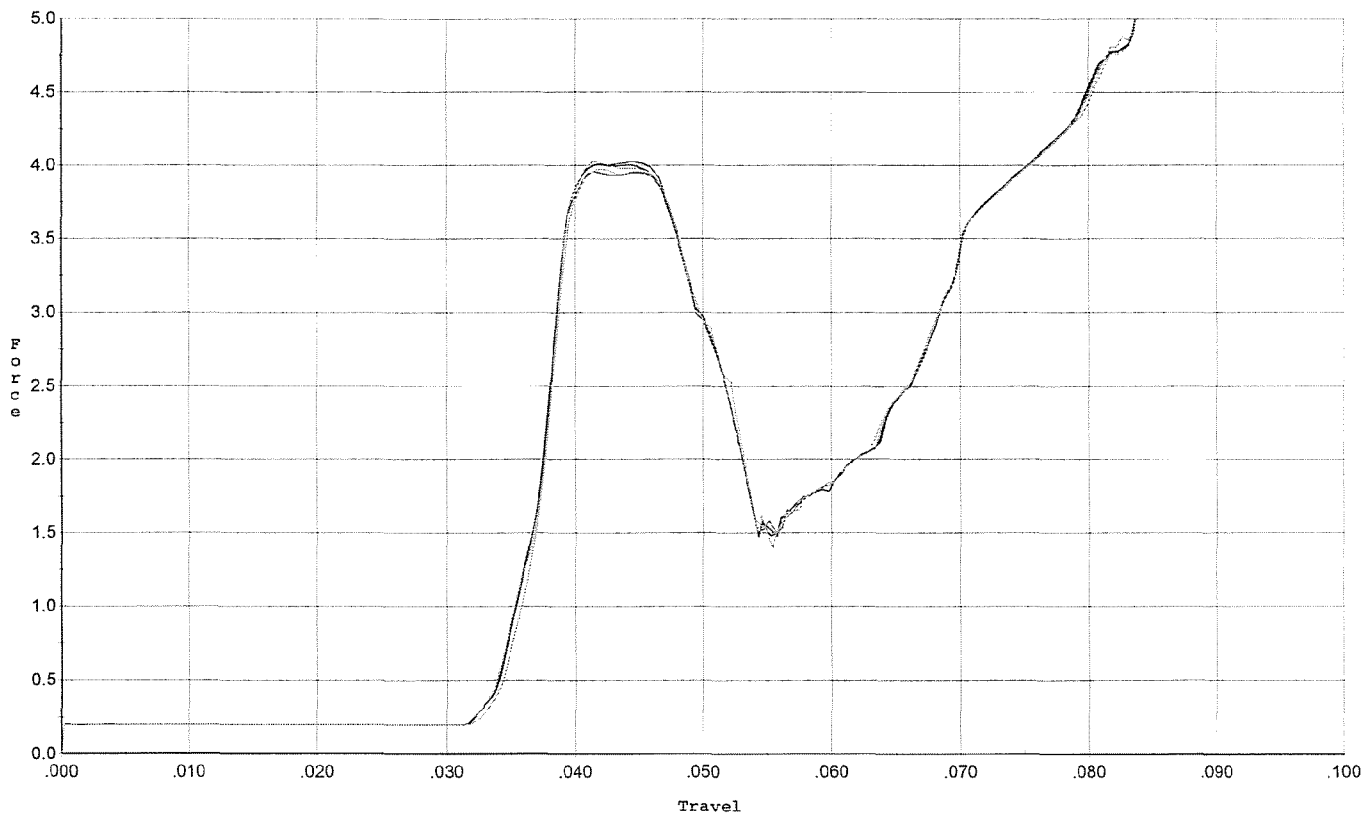
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.043	0.049	0.033	0.036	0.045		Set Trigger
2	3.073	0.050	0.032	0.036	0.046		Set Trigger
3	3.083	0.049	0.032	0.036	0.046		Set Trigger
4	3.139	0.049	0.032	0.036	0.046		Set Trigger
5	3.139	0.049	0.031	0.036	0.047		Set Trigger

AVG 3.09

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/19/07

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



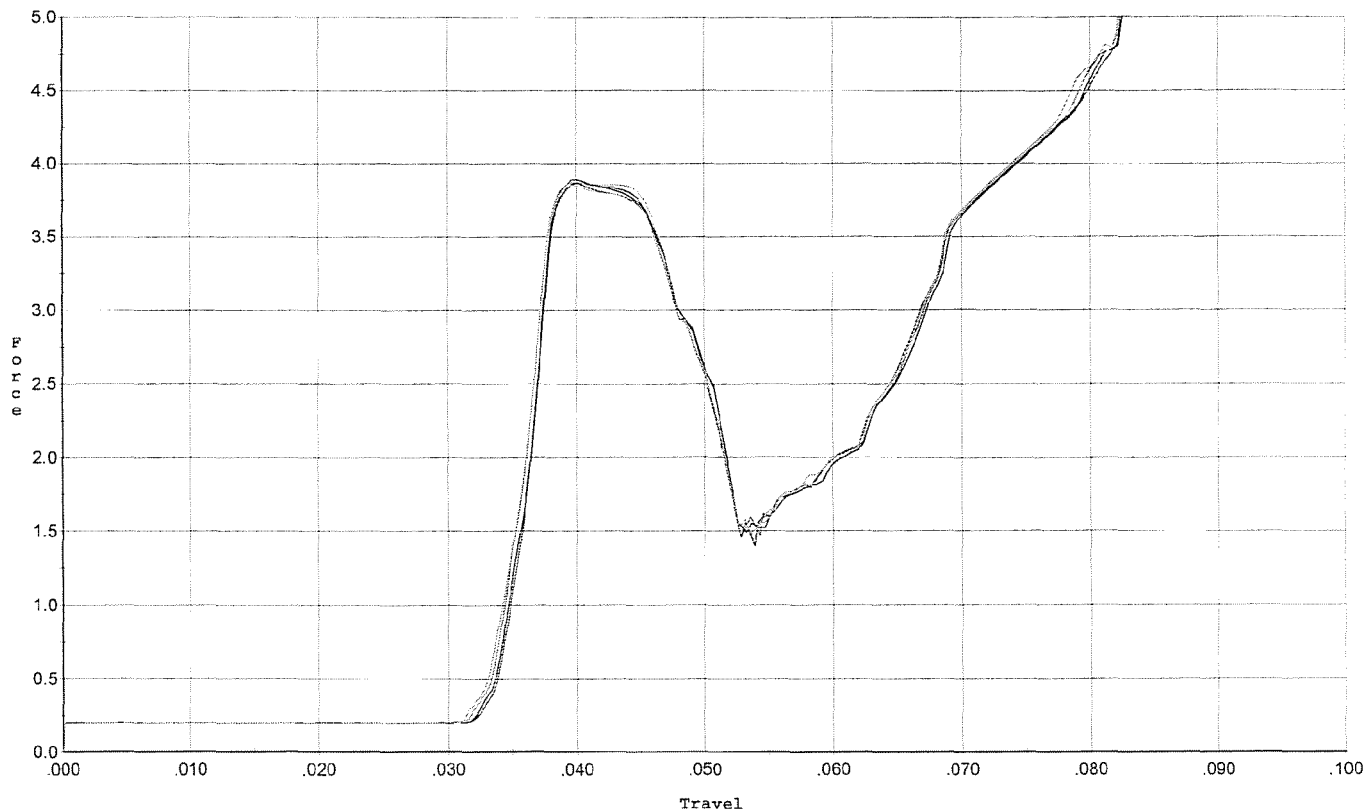
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.053	0.034	0.036	0.064		Set Trigger
2	4.010	0.053	0.034	0.036	0.064		Set Trigger
3	3.956	0.053	0.034	0.036	0.063		Set Trigger
4	3.975	0.052	0.033	0.036	0.062		Set Trigger
5	4.026	0.053	0.033	0.036	0.064		Set Trigger

Avg 3.99

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/07

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



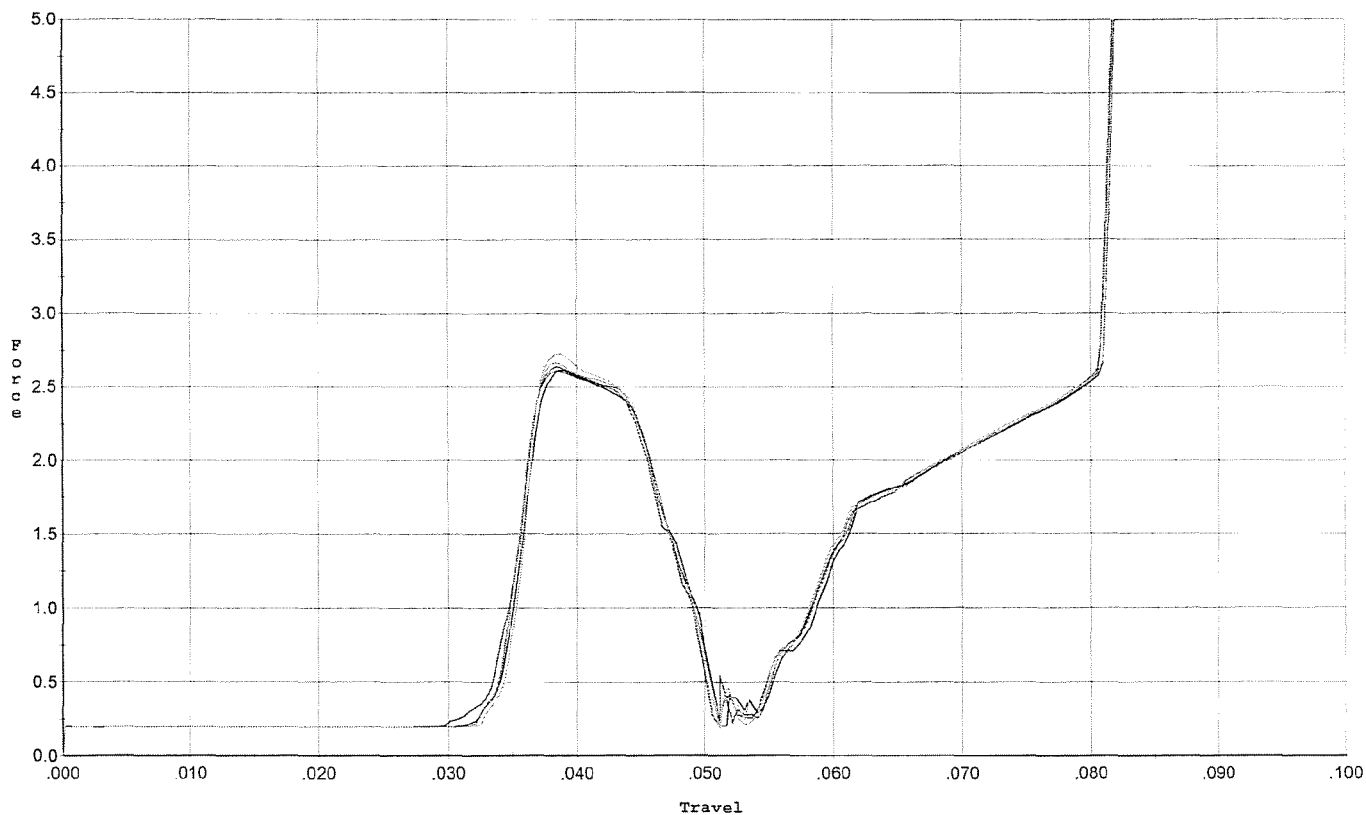
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.890	0.051	0.033	0.035	0.060		Set Trigger
2	3.872	0.051	0.033	0.035	0.060		Set Trigger
3	3.872	0.051	0.032	0.035	0.061		Set Trigger
4	3.854	0.051	0.032	0.035	0.061		Set Trigger
5	3.875	0.051	0.032	0.035	0.062		Set Trigger

AVG 3.87

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/07

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



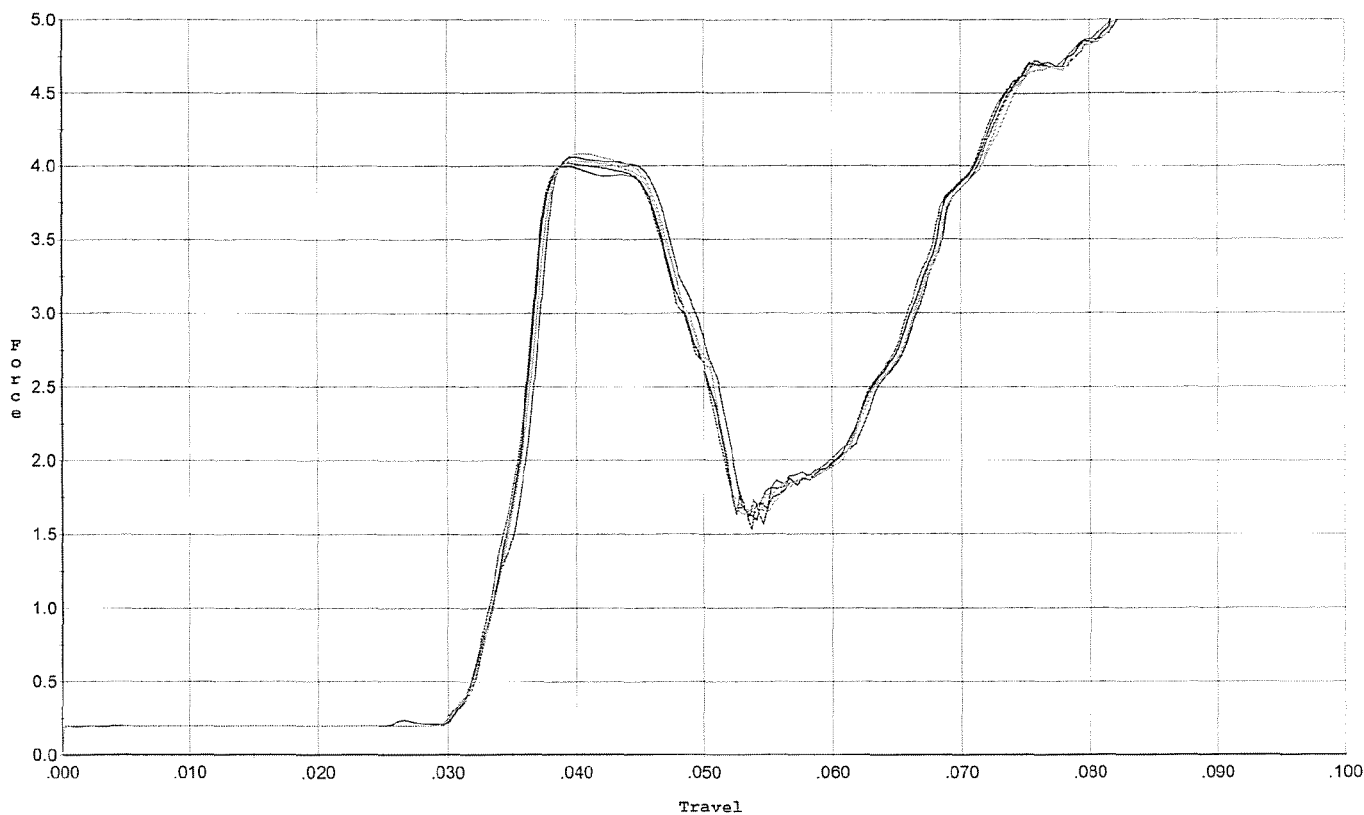
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.050	0.033	0.037	0.039		Set Trigger
2	2.613	0.050	0.033	0.037	0.038		Set Trigger
3	2.639	0.049	0.033	0.037	0.037		Set Trigger
4	2.726	0.050	0.033	0.037	0.038		Set Trigger
5	2.666	0.049	0.033	0.037	0.038		Set Trigger

AVG 2.65

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/19/07

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	4.063	0.051	0.032	0.035	0.066		Set Trigger
2	3.998	0.051	0.031	0.035	0.065		Set Trigger
3	4.019	0.050	0.032	0.035	0.064		Set Trigger
4	4.034	0.050	0.032	0.035	0.064		Set Trigger
5	4.082	0.050	0.032	0.035	0.065		Set Trigger

AVG 4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6680267.___0
FILE DATE AND TIME: 09/21/2007 05:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

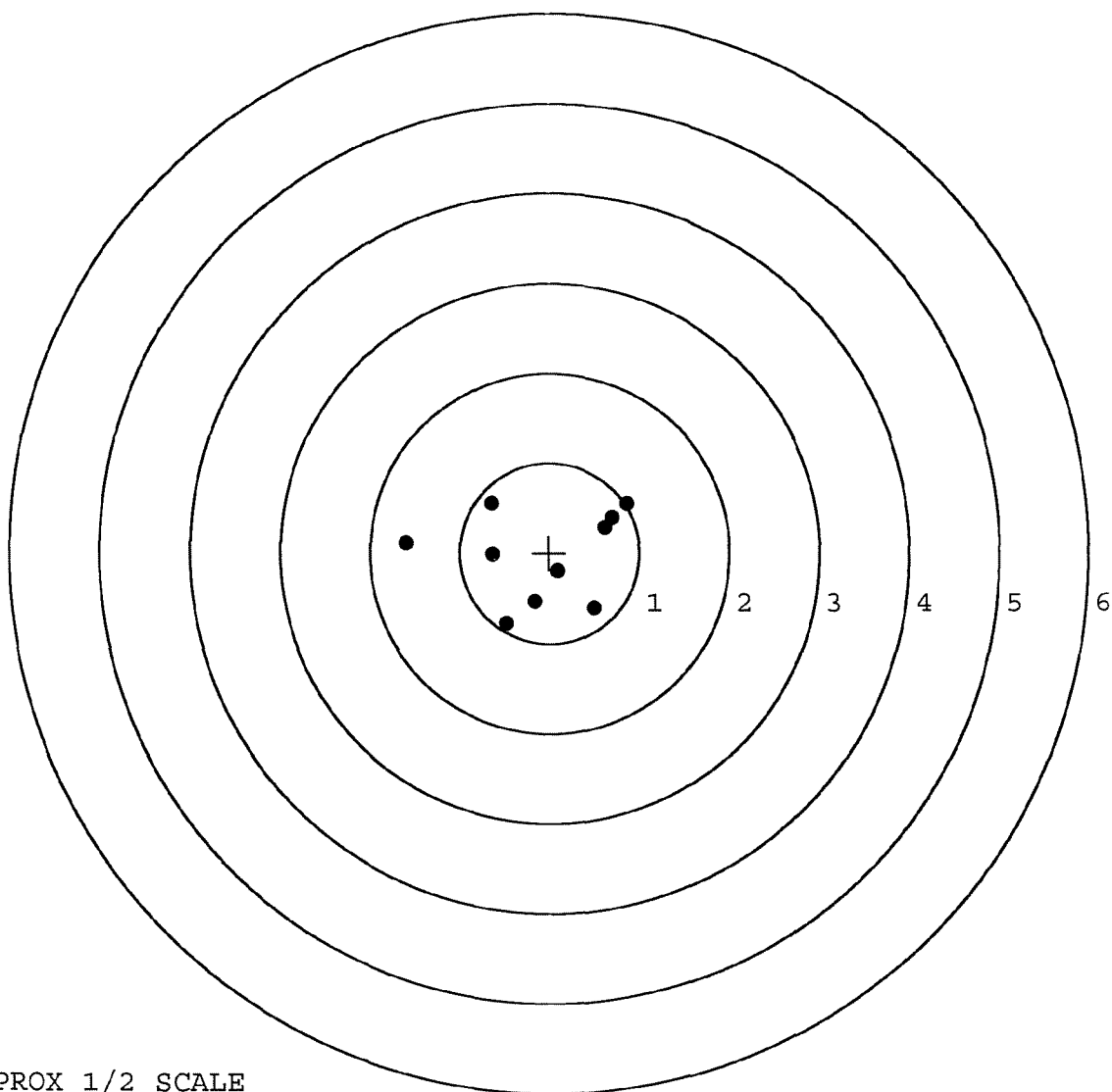
The Average X Centroid of the Five Target Set:	-0.027
The Average Y Centroid of the Five Target Set:	-0.035
The Average Point of Impact of the Five Target Set:	0.044
The Average Mean Radius of the Five Target Set:	0.727
The Distance from POA to Centroid Target #1:	0.079
The Distance from Centroid Target #2 to Centroid Target #1:	0.132
The Distance from Centroid Target #3 to Centroid Target #1:	0.169
The Distance from Centroid Target #4 to Centroid Target #1:	0.079
The Distance from Centroid Target #5 to Centroid Target #1:	0.025

BARBER - M24 0174191

SERIAL NUMBER: G6680267. __0
 TARGET NUMBER: 1
 FILE DATE: 09/21/2007
 FILE TIME: 05:43

POINT#	X	Y
1:	-1.597	0.110
2:	-0.641	0.547
3:	-0.628	-0.015
4:	-0.482	-0.784
5:	-0.162	-0.545
6:	0.097	-0.206
7:	0.497	-0.610
8:	0.866	0.541
9:	0.700	0.388
10:	0.615	0.280

X CENTROID: -0.074
 Y CENTROID: -0.029
 POA TO CENTROID: 0.079
 HORZ SPREAD: 2.463
 VERT SPREAD: 1.331
 GROUP SPREAD: 2.500
 MIN RADIUS: 0.245
 MAX RADIUS: 1.530
 MEAN RADIUS: 0.807
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



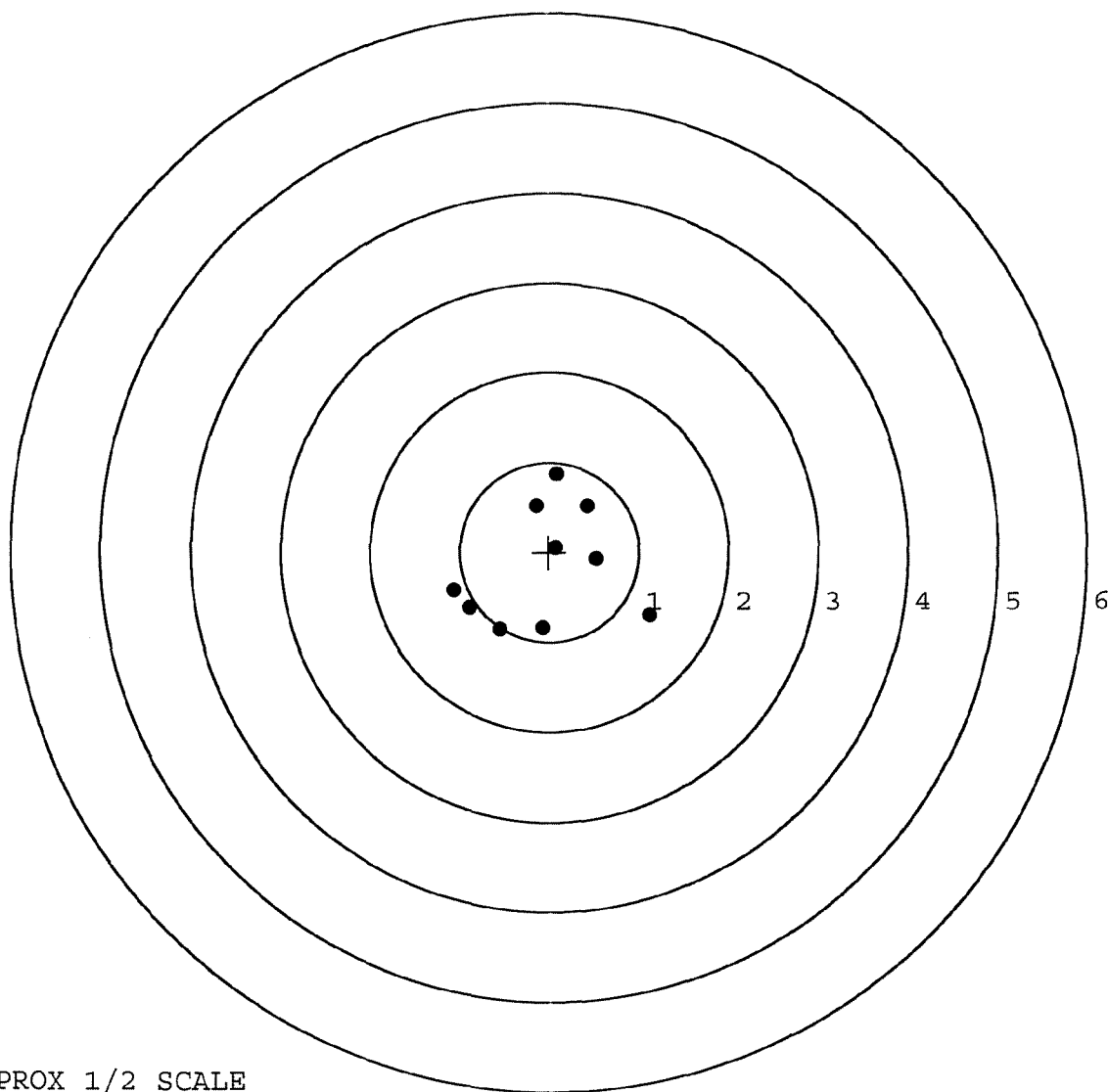
TARGET APPROX 1/2 SCALE

BARBER - M24 0174192

SERIAL NUMBER: G6680267. __0
 TARGET NUMBER: 2
 FILE DATE: 09/21/2007
 FILE TIME: 05:43

POINT#	X	Y
1:	-1.067	-0.432
2:	-0.894	-0.621
3:	-0.556	-0.865
4:	-0.077	-0.847
5:	0.431	0.518
6:	0.530	-0.074
7:	0.093	0.867
8:	-0.146	0.519
9:	0.074	0.049
10:	1.119	-0.710

X CENTROID: -0.049
 Y CENTROID: -0.160
 POA TO CENTROID: 0.167
 HORZ SPREAD: 2.186
 VERT SPREAD: 1.732
 GROUP SPREAD: 2.204
 MIN RADIUS: 0.242
 MAX RADIUS: 1.291
 MEAN RADIUS: 0.824
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



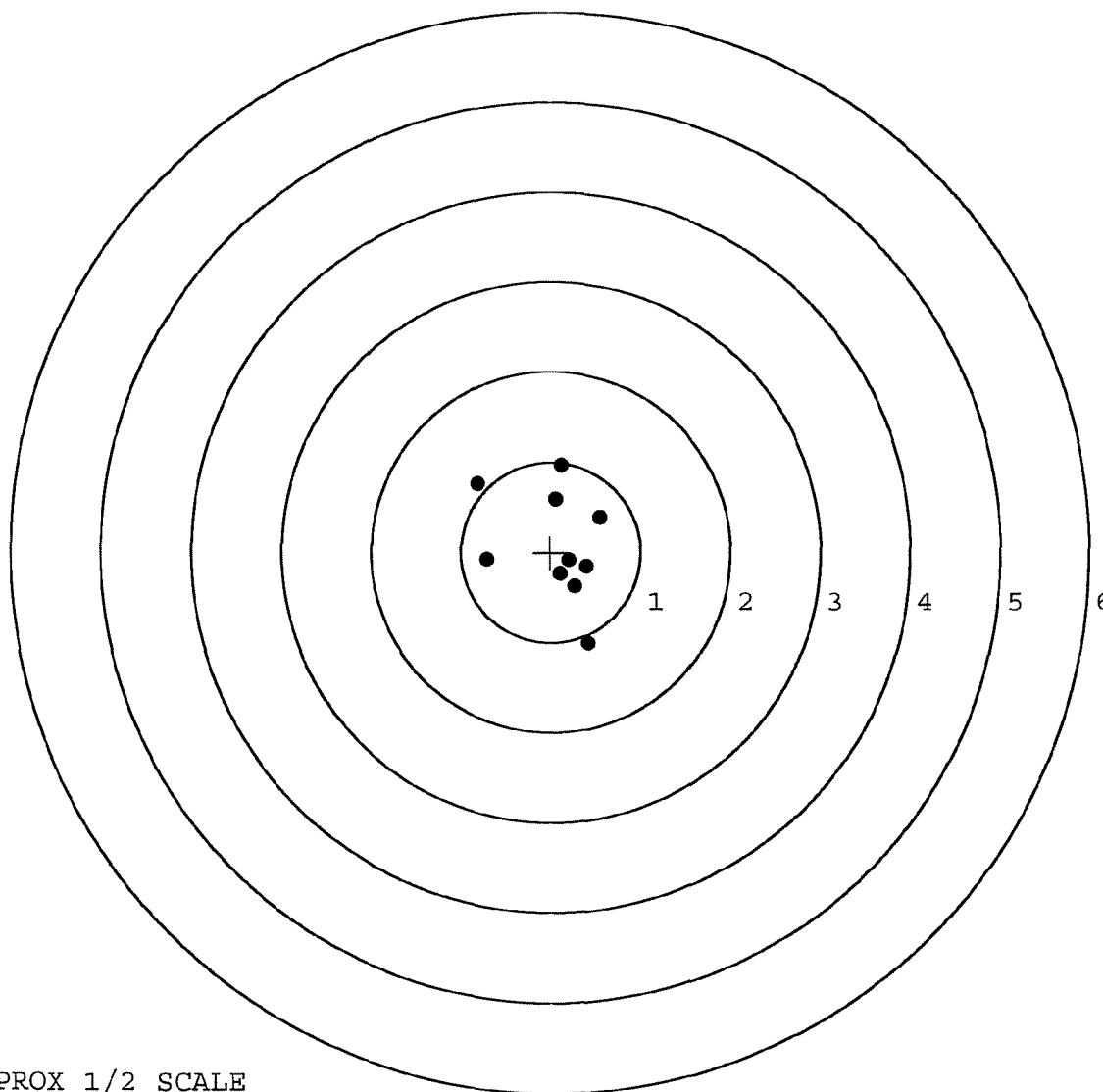
TARGET APPROX 1/2 SCALE

BARBER - M24 0174193

SERIAL NUMBER: G6680267. 0
 TARGET NUMBER: 3
 FILE DATE: 09/21/2007
 FILE TIME: 05:43

POINT#	X	Y
1:	-0.811	0.765
2:	-0.713	-0.081
3:	0.123	0.966
4:	0.057	0.588
5:	0.547	0.391
6:	0.418	-1.017
7:	0.404	-0.158
8:	0.204	-0.093
9:	0.269	-0.381
10:	0.111	-0.243

X CENTROID: 0.061
 Y CENTROID: 0.074
 POA TO CENTROID: 0.096
 HORZ SPREAD: 1.358
 VERT SPREAD: 1.983
 GROUP SPREAD: 2.165
 MIN RADIUS: 0.220
 MAX RADIUS: 1.148
 MEAN RADIUS: 0.649
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



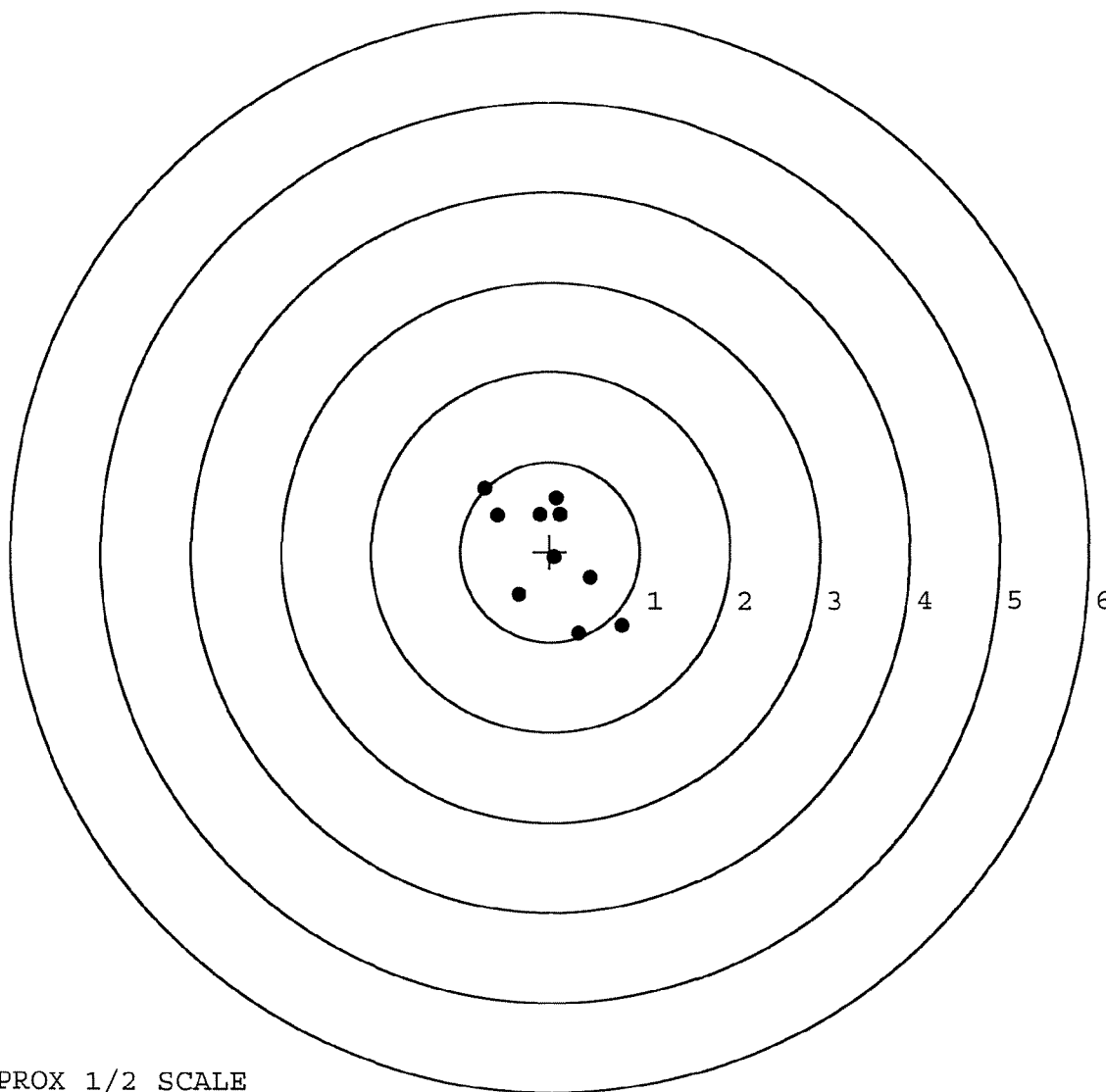
TARGET APPROX 1/2 SCALE

BARBER - M24 0174194

SERIAL NUMBER: G6680267. __0
 TARGET NUMBER: 4
 FILE DATE: 09/21/2007
 FILE TIME: 05:43

POINT#	X	Y
1:	0.798	-0.827
2:	0.319	-0.908
3:	-0.348	-0.475
4:	0.453	-0.292
5:	0.049	-0.064
6:	-0.725	0.704
7:	-0.590	0.405
8:	0.069	0.595
9:	-0.118	0.412
10:	0.108	0.412

X CENTROID: 0.001
 Y CENTROID: -0.004
 POA TO CENTROID: 0.004
 HORZ SPREAD: 1.523
 VERT SPREAD: 1.612
 GROUP SPREAD: 2.160
 MIN RADIUS: 0.077
 MAX RADIUS: 1.145
 MEAN RADIUS: 0.650
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0174195

SERIAL NUMBER: G6680267. __0

TARGET NUMBER: 5

FILE DATE: 09/21/2007

FILE TIME: 05:43

POINT#	X	Y
1:	0.557	1.254
2:	0.272	0.734
3:	0.219	0.371
4:	-0.673	0.464
5:	-0.817	-1.245
6:	0.019	-0.874
7:	-0.287	-0.366
8:	-0.050	-0.515
9:	0.128	-0.259
10:	-0.128	-0.104

X CENTROID: -0.076

Y CENTROID: -0.054

POA TO CENTROID: 0.093

HORZ SPREAD: 1.374

VERT SPREAD: 2.499

GROUP SPREAD: 2.852

MIN RADIUS: 0.072

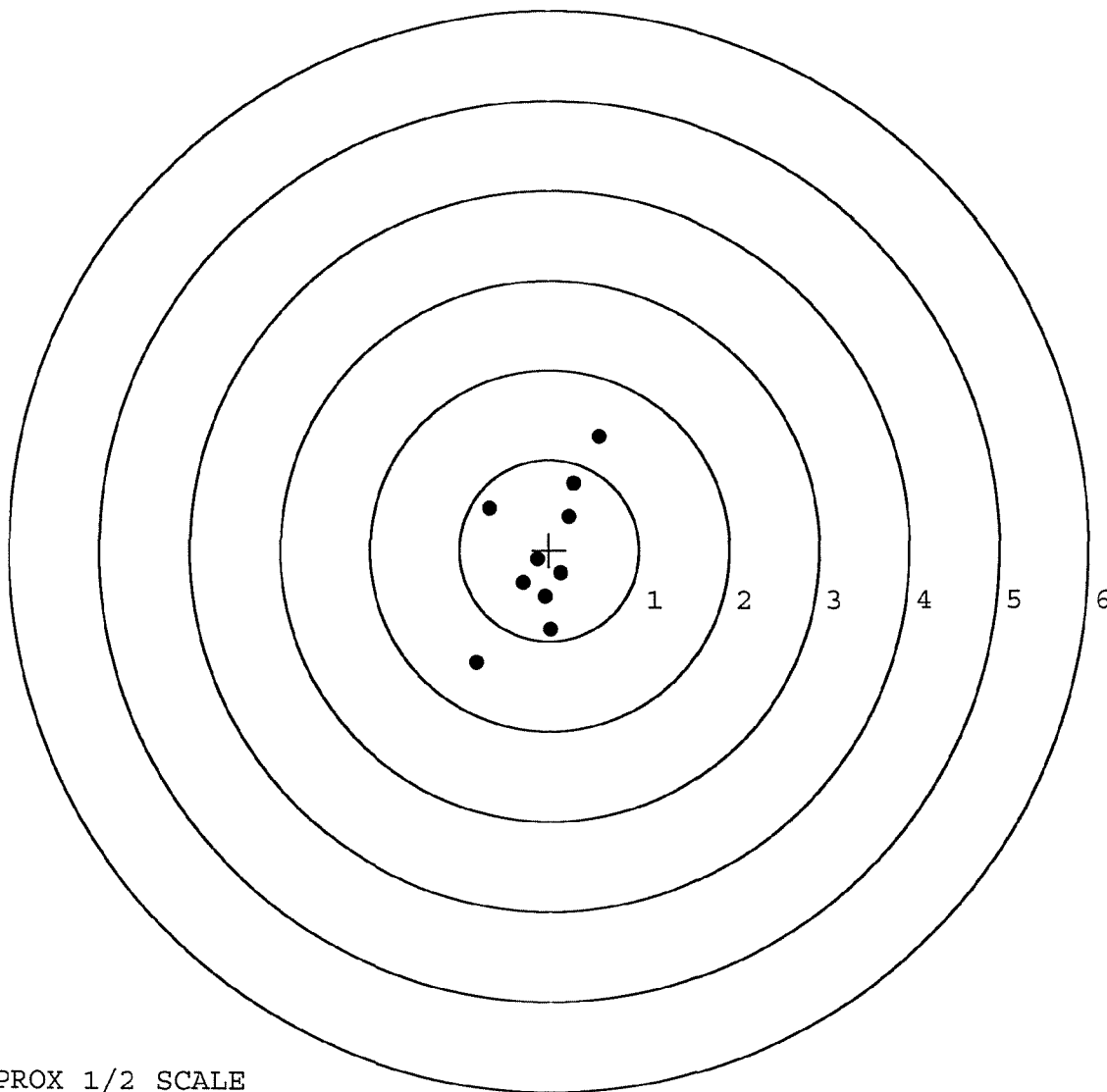
MAX RADIUS: 1.453

MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE