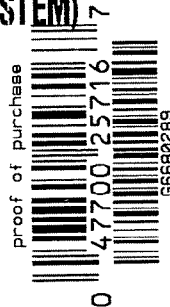


G 6680289

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

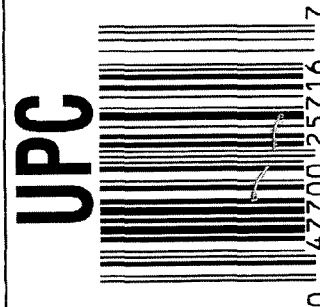
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6680289



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 # G 6680289

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		8/27/07	RPD
430	ASSEMBLE TO STOCK		8/29/07	RPD
440	PROOF	MAGNA - FLUX	8/29/07	RPD
460	CHECK HEADSPACE	SEP 05 2007	8/29/07	RPD
470	DIS-ASSEMBLE ACTION		8-31-07	RPZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>NRD</u>	9-5-07	NRD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-4-07	CW
510	DRILL AND TAP SIGHT HOLES		9-4-07	Fm
520	GOFF BLAST BBL / REC		9-5-07	LY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/6/07	RPB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/11/07	RP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/11/07	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/11/07	RP
	D) OIL FIRING PIN ASSEMBLY		9/11/07	RPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9/14/07	RPD

F004 REV 5/2006

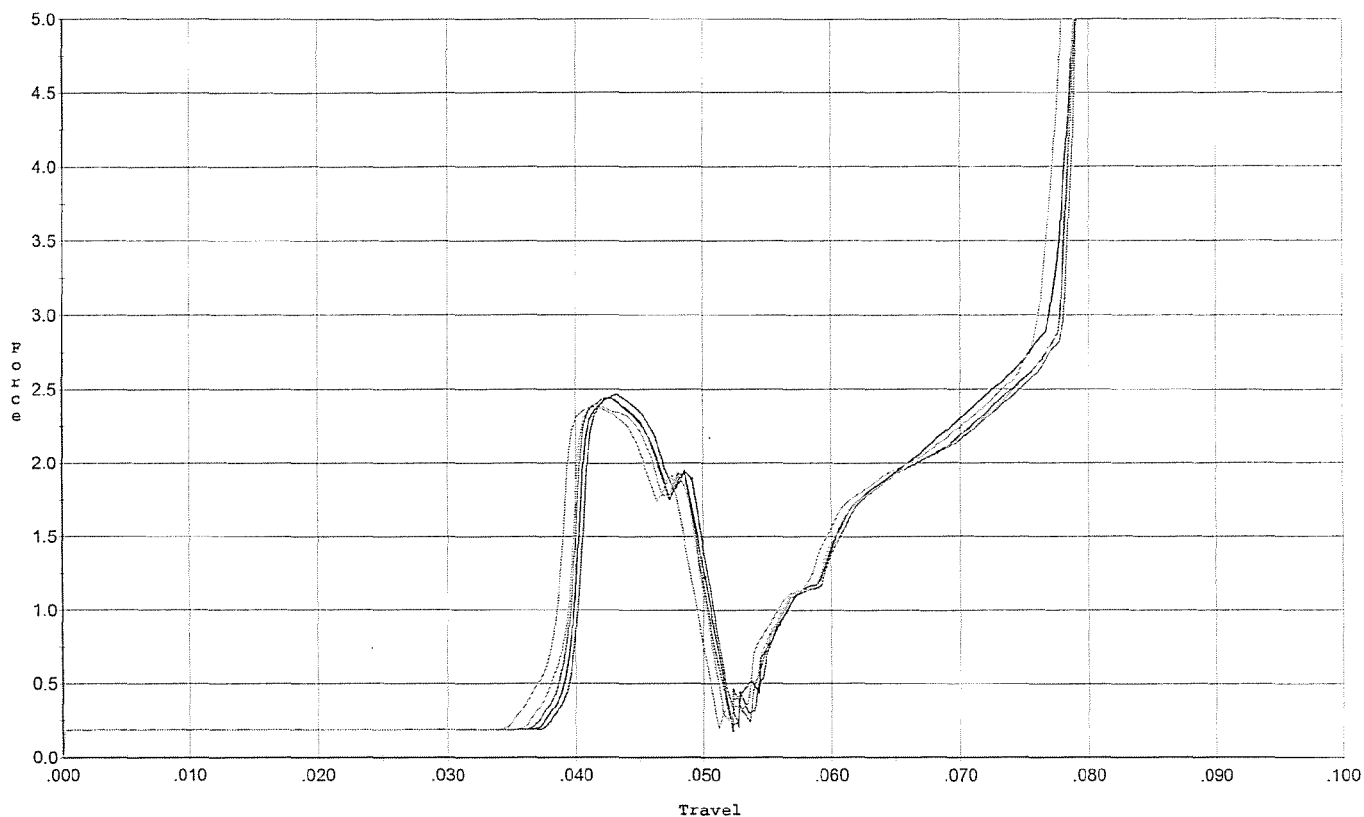
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>5.50</u>	<u>9/14/07</u>	<u>mm</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.75</u> <u>6.0</u> <u>6.0</u>	<u>9/14/07</u>	<u>mm</u>
	H) TRIGGER PULL TEST AND RETAINABILITY		<u>9/14/07</u>	<u>mm</u>
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	<u>9/14/07</u>	<u>mm</u>
	J) ASSEMBLE STOCK		<u>9/14/07</u>	<u>S.P.K.</u>
	K) ASSEMBLE SWIVEL STUDS		<u>9/14/07</u>	<u>mm</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>9/17/07</u>	<u>mm</u>
	M) IRON SIGHT ALIGNMENT		<u>9/17/07</u>	<u>mm</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>9/17/07</u>	<u>mm</u>
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	<u>9-12-07</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>9-12-07</u>	<u>DK</u>
670	FINAL INSPECTION A) HEADSPACE		<u>9/14/07</u>	<u>mm</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>262</u> <u>243</u> <u>257</u> <u>251</u> <u>240</u>	<u>9/13/07</u>	<u>mm</u>
	C) FUNCTION		<u>9/14/07</u>	<u>mm</u>
690	PACK		<u>9/18/07</u>	<u>SA</u>

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/6/07

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



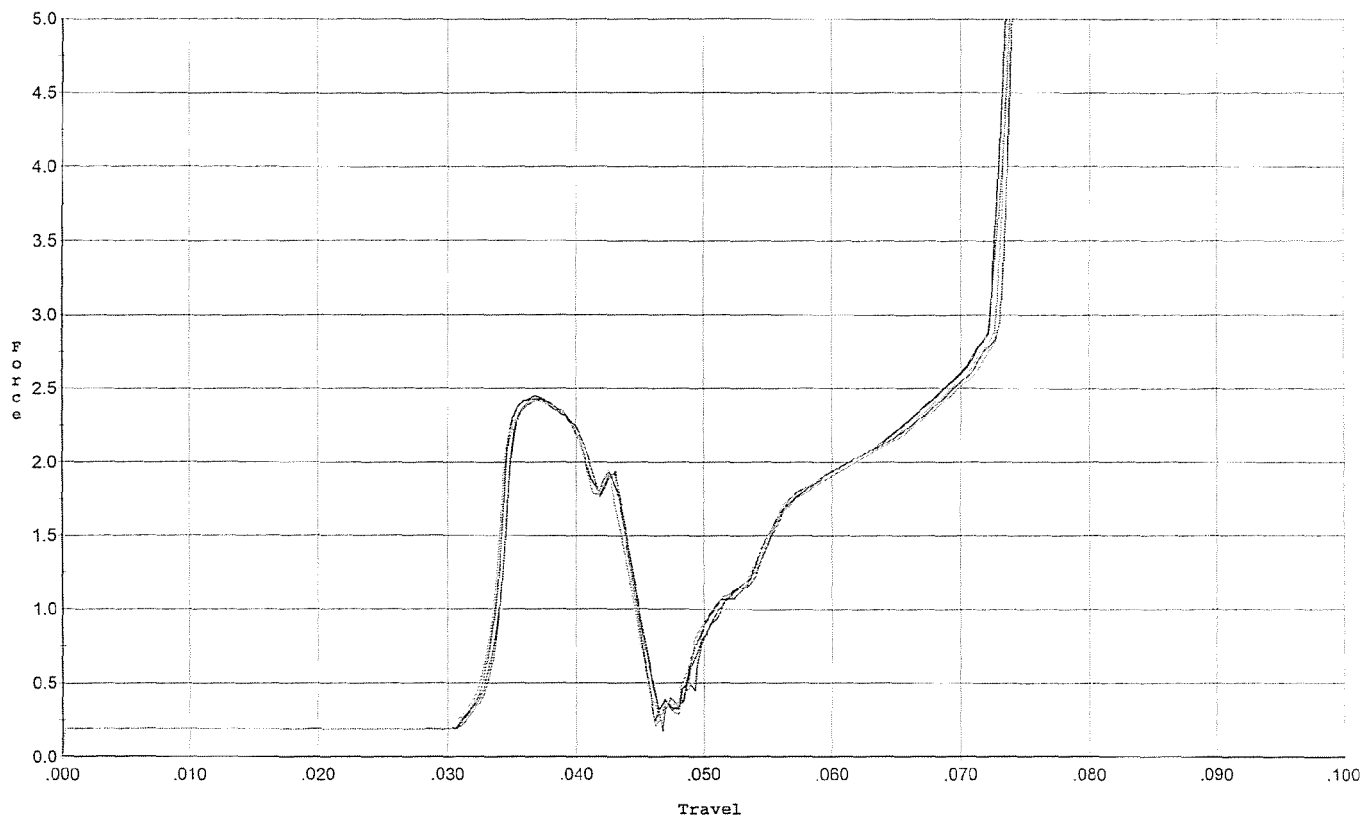
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.468	0.049	0.039	0.037	0.029		Set Trigger
2	2.443	0.050	0.039	0.036	0.030		Set Trigger
3	2.445	0.049	0.038	0.037	0.029		Set Trigger
4	2.396	0.049	0.037	0.037	0.029		Set Trigger
5	2.380	0.048	0.036	0.036	0.029		Set Trigger

AVG 2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/6/07

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



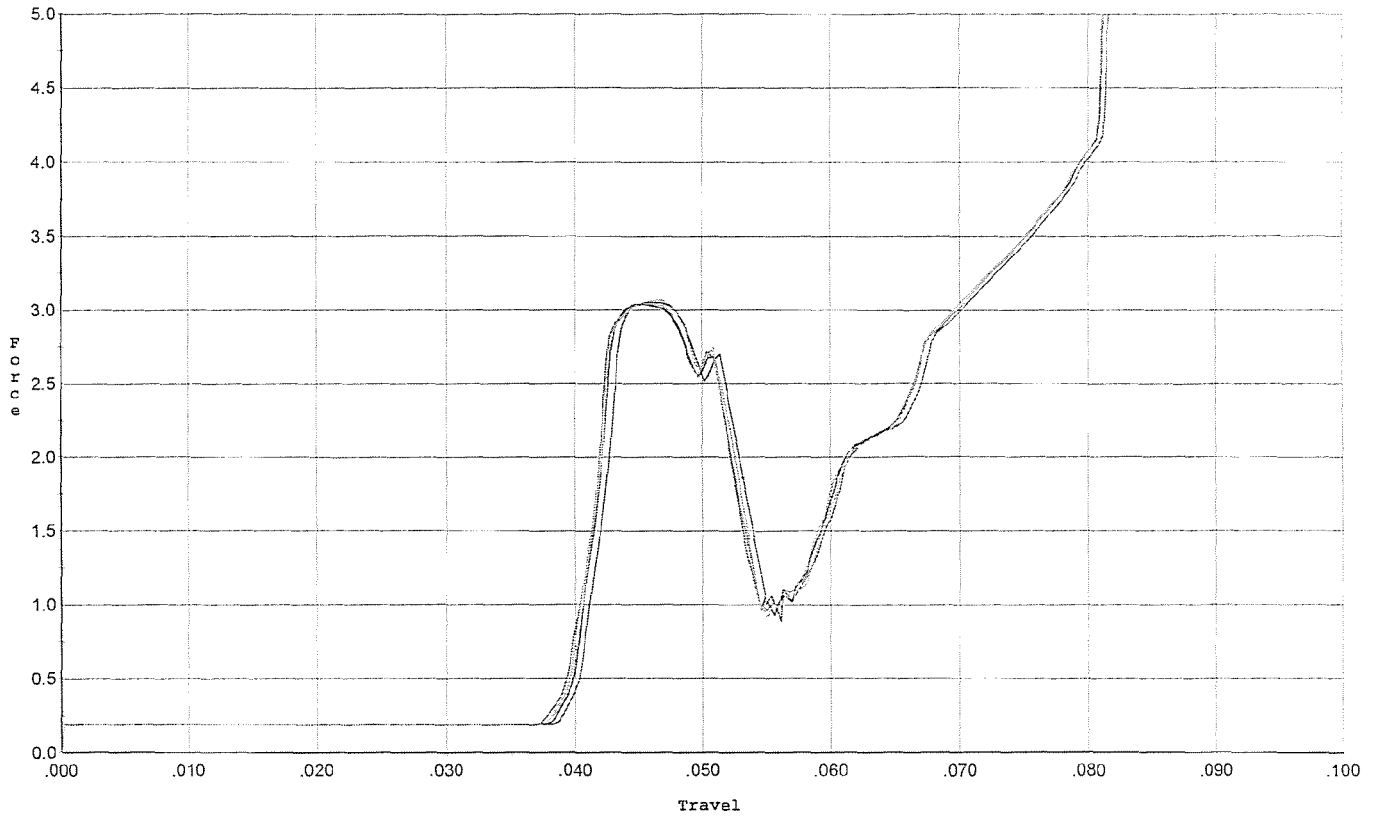
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.422	0.043	0.033	0.035	0.028		Set Trigger
2	2.447	0.043	0.032	0.035	0.029		Set Trigger
3	2.429	0.043	0.033	0.035	0.028		Set Trigger
4	2.416	0.044	0.032	0.034	0.029		Set Trigger
5	2.418	0.043	0.032	0.035	0.028		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/6/07

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



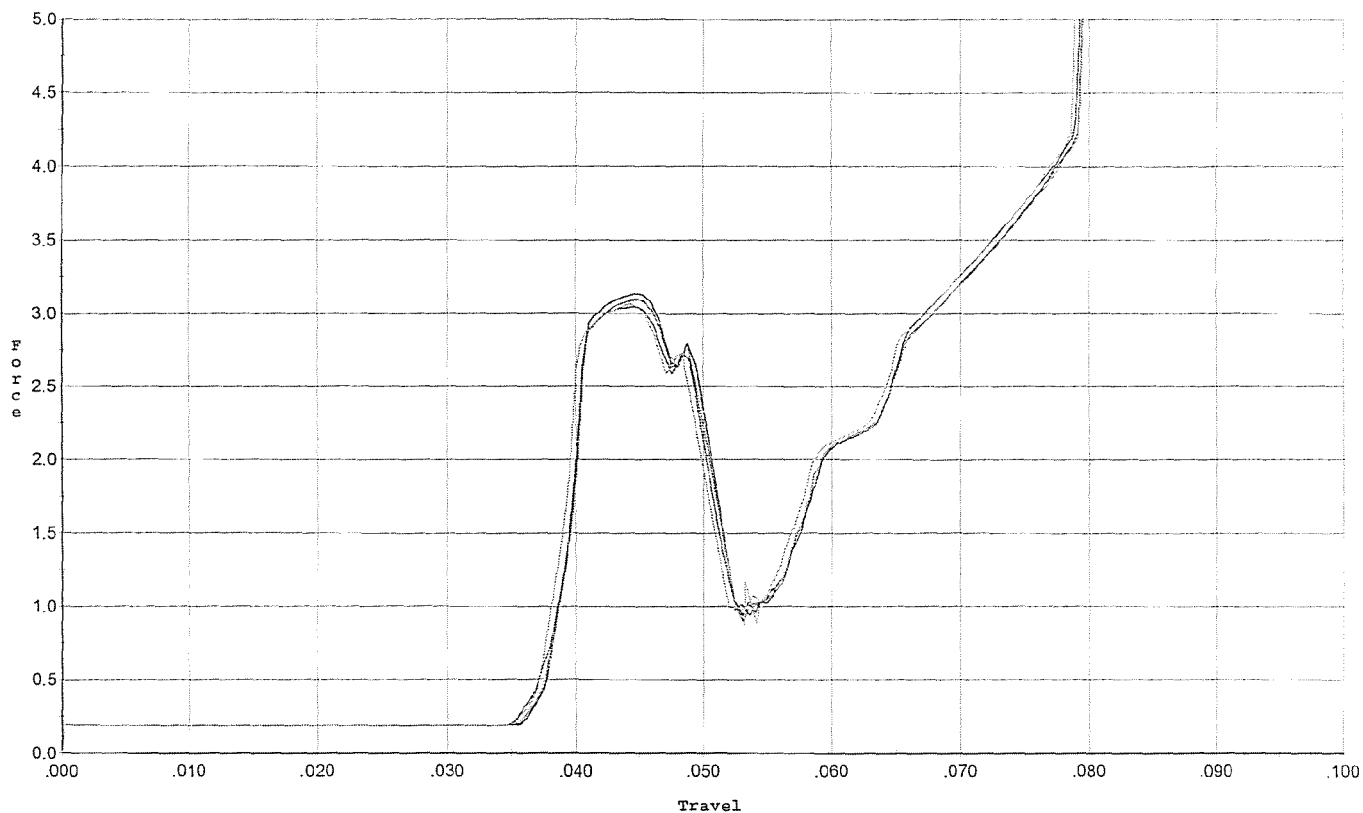
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.054	0.053	0.039	0.035	0.040		Set Trigger
2	3.044	0.051	0.039	0.036	0.039		Set Trigger
3	3.040	0.051	0.039	0.036	0.039		Set Trigger
4	3.045	0.051	0.039	0.036	0.039		Set Trigger
5	3.069	0.052	0.039	0.035	0.041		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/6/07

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



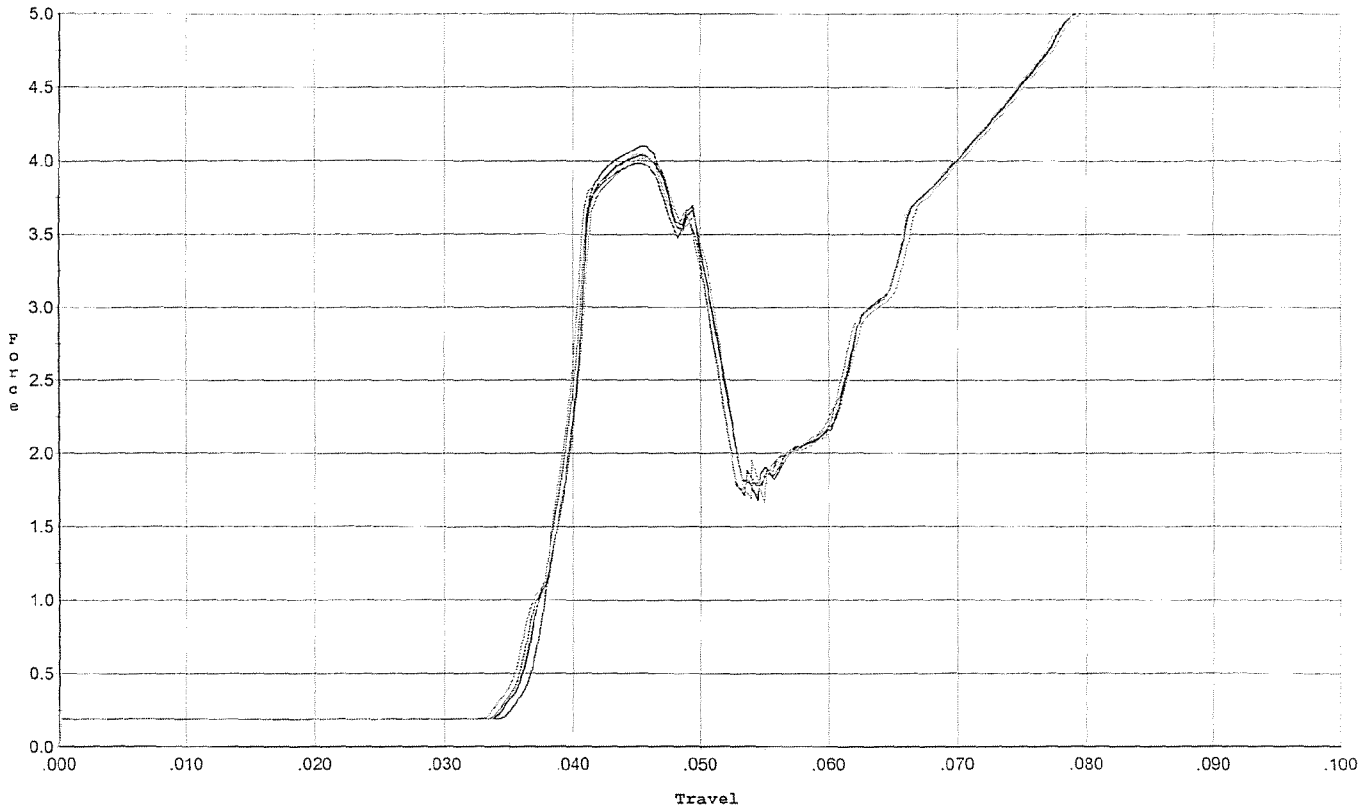
#	Peak Force	Travel To Actuate	Initial Take-up	Overtavel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.049	0.036	0.036	0.039		Set Trigger
2	3.137	0.050	0.037	0.035	0.040		Set Trigger
3	3.101	0.050	0.037	0.035	0.041		Set Trigger
4	3.093	0.050	0.037	0.035	0.040		Set Trigger
5	3.062	0.048	0.037	0.036	0.038		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/6/07

Model: M24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



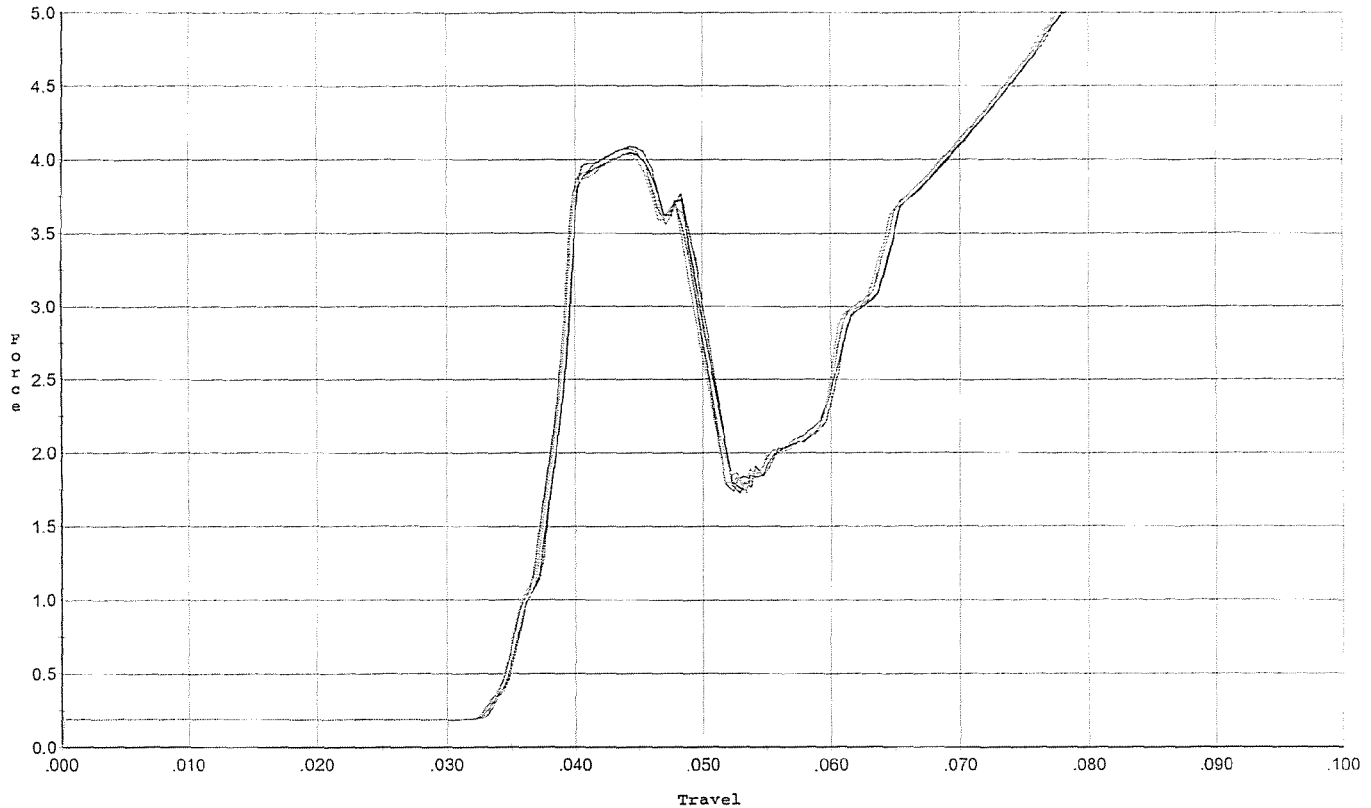
#	Peak Force	Travel To Actuate	Initial Take-up	Overtavel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.051	0.036	0.034	0.055		Set Trigger
2	4.040	0.051	0.036	0.034	0.055		Set Trigger
3	3.983	0.050	0.035	0.034	0.053		Set Trigger
4	4.022	0.051	0.036	0.034	0.054		Set Trigger
5	4.047	0.050	0.035	0.034	0.055		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/6/07

Model: M24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



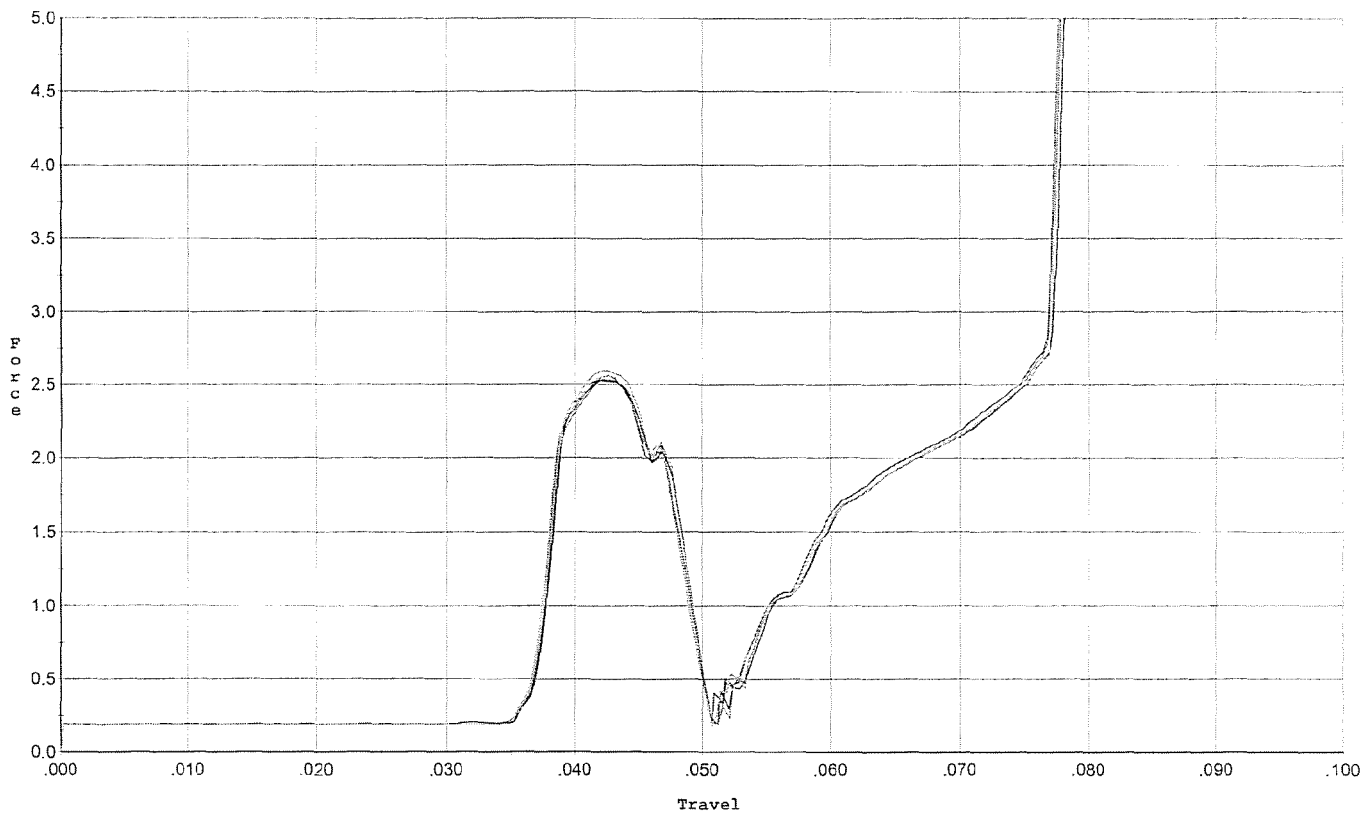
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.049	0.035	0.034	0.055		Set Trigger
2	4.048	0.048	0.034	0.034	0.053		Set Trigger
3	4.076	0.049	0.033	0.033	0.055		Set Trigger
4	4.039	0.048	0.033	0.033	0.052		Set Trigger
5	4.038	0.048	0.034	0.034	0.053		Set Trigger

AVG 4.05

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/6/07

Model: M24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



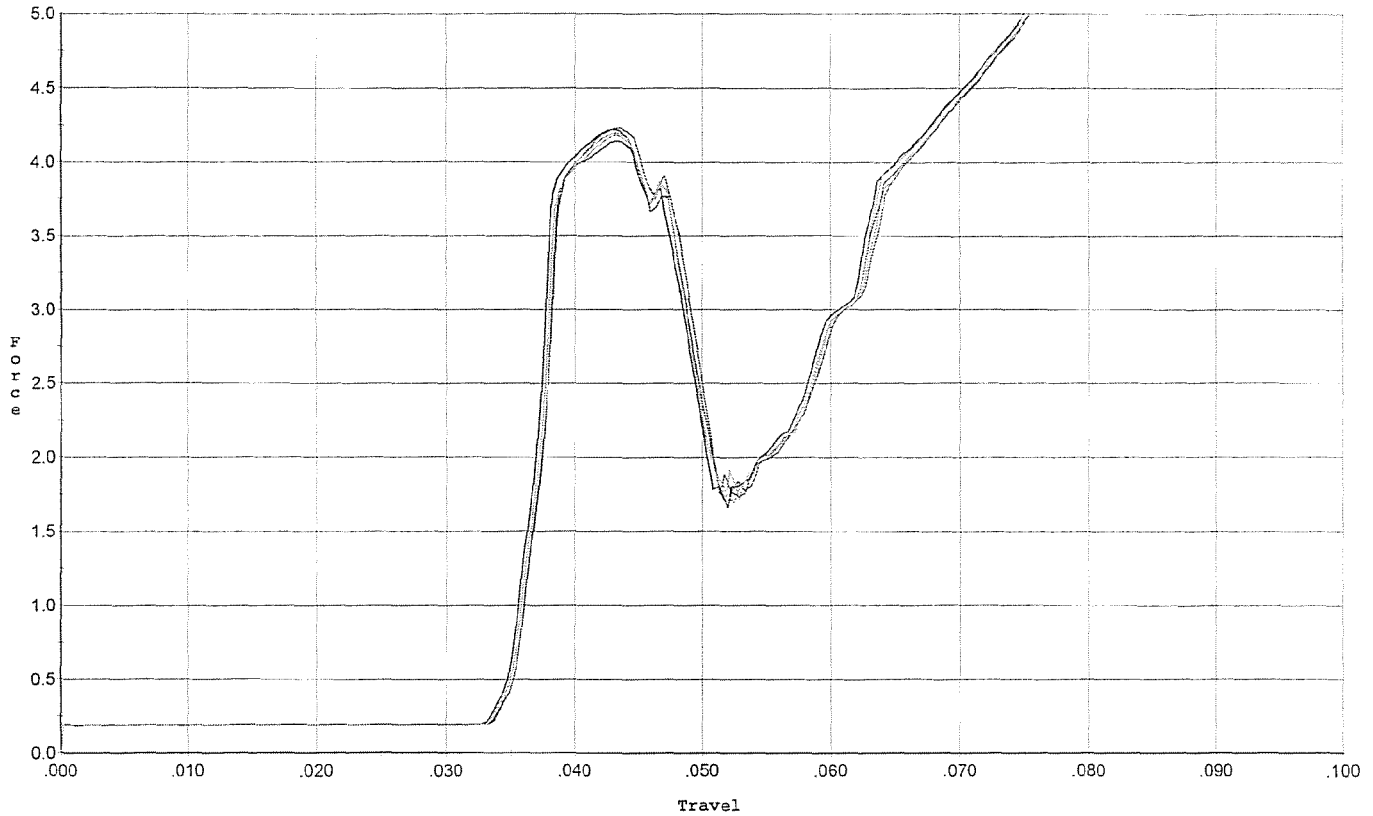
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.563	0.047	0.036	0.037	0.030		Set Trigger
2	2.530	0.048	0.037	0.037	0.031		Set Trigger
3	2.535	0.049	0.036	0.036	0.032		Set Trigger
4	2.561	0.047	0.036	0.037	0.031		Set Trigger
5	2.593	0.048	0.036	0.036	0.032		Set Trigger

AVG 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 9/6/07

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	4.142	0.047	0.034	0.034	0.053		Set Trigger
2	4.224	0.048	0.034	0.033	0.055		Set Trigger
3	4.232	0.048	0.034	0.033	0.055		Set Trigger
4	4.180	0.047	0.034	0.033	0.053		Set Trigger
5	4.198	0.047	0.034	0.033	0.054		Set Trigger

Avg 4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6680289. __0
FILE DATE AND TIME: 09/13/2007 05:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	-0.044
The Average Point of Impact of the Five Target Set:	0.045
The Average Mean Radius of the Five Target Set:	0.602
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.230
The Distance from Centroid Target #3 to Centroid Target #1:	0.288
The Distance from Centroid Target #4 to Centroid Target #1:	0.059
The Distance from Centroid Target #5 to Centroid Target #1:	0.211

BARBER - M24 0174595

SERIAL NUMBER: G6680289. __0

TARGET NUMBER: 1

FILE DATE: 09/13/2007

FILE TIME: 05:50

POINT#	X	Y
1:	1.048	-1.090
2:	0.791	-1.050
3:	0.575	-0.504
4:	0.314	-0.408
5:	0.197	-1.065
6:	0.109	0.173
7:	-0.075	0.735
8:	-0.572	0.721
9:	-0.795	0.113
10:	-1.099	0.444

X CENTROID: 0.049

Y CENTROID: -0.193

POA TO CENTROID: 0.199

HORZ SPREAD: 2.147

VERT SPREAD: 1.825

GROUP SPREAD: 2.639

MIN RADIUS: 0.341

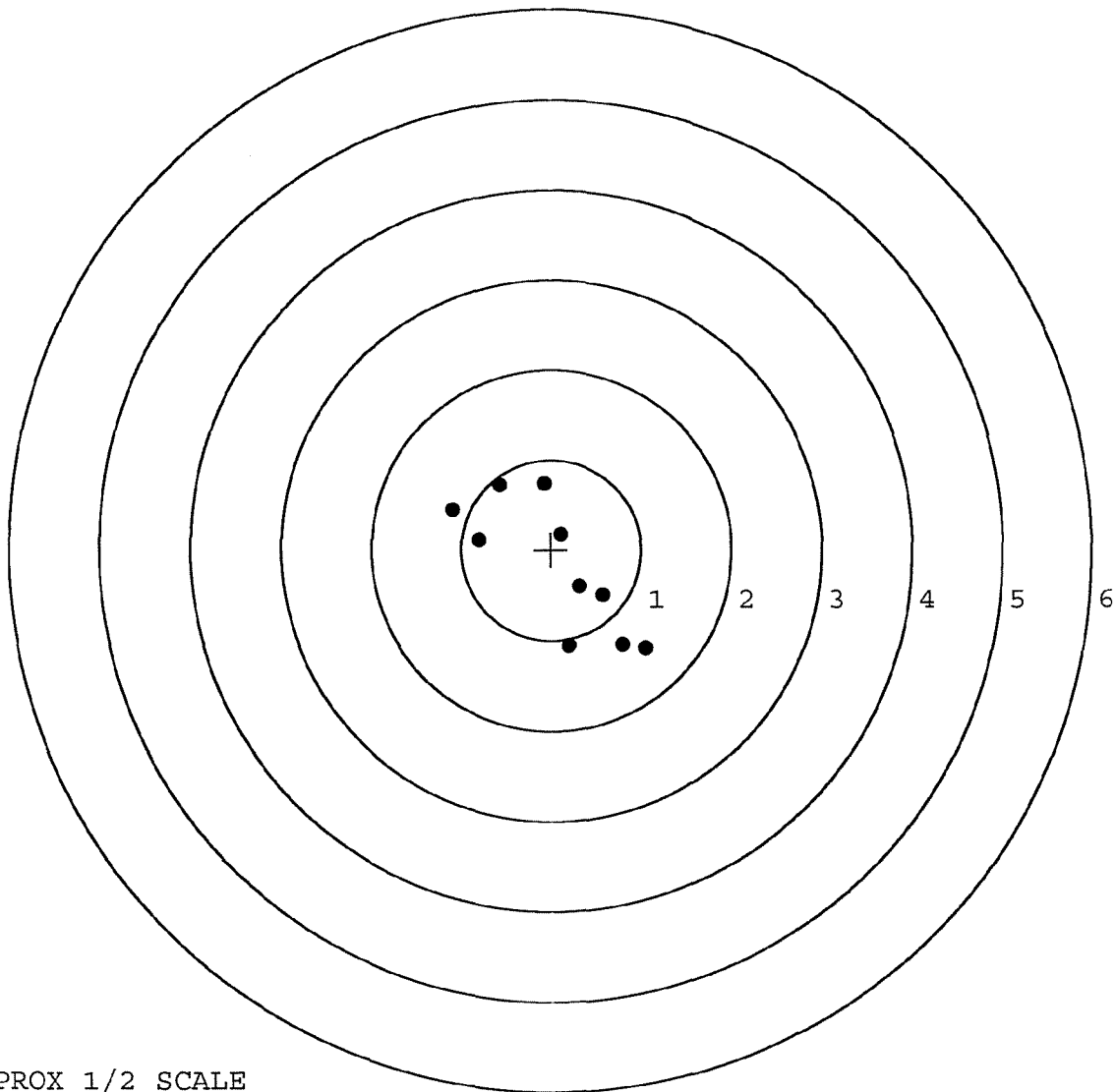
MAX RADIUS: 1.342

MEAN RADIUS: 0.894

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0174596

SERIAL NUMBER: G6680289. __0

TARGET NUMBER: 2

FILE DATE: 09/13/2007

FILE TIME: 05:50

POINT#	X	Y
1:	-0.135	0.753
2:	-0.261	0.430
3:	-0.443	0.090
4:	-0.207	-0.022
5:	0.262	0.212
6:	0.051	-0.014
7:	0.280	-0.354
8:	0.143	-0.392
9:	-0.211	-0.603
10:	-0.016	0.024

X CENTROID: -0.054

Y CENTROID: 0.012

POA TO CENTROID: 0.055

HORZ SPREAD: 0.723

VERT SPREAD: 1.356

GROUP SPREAD: 1.358

MIN RADIUS: 0.039

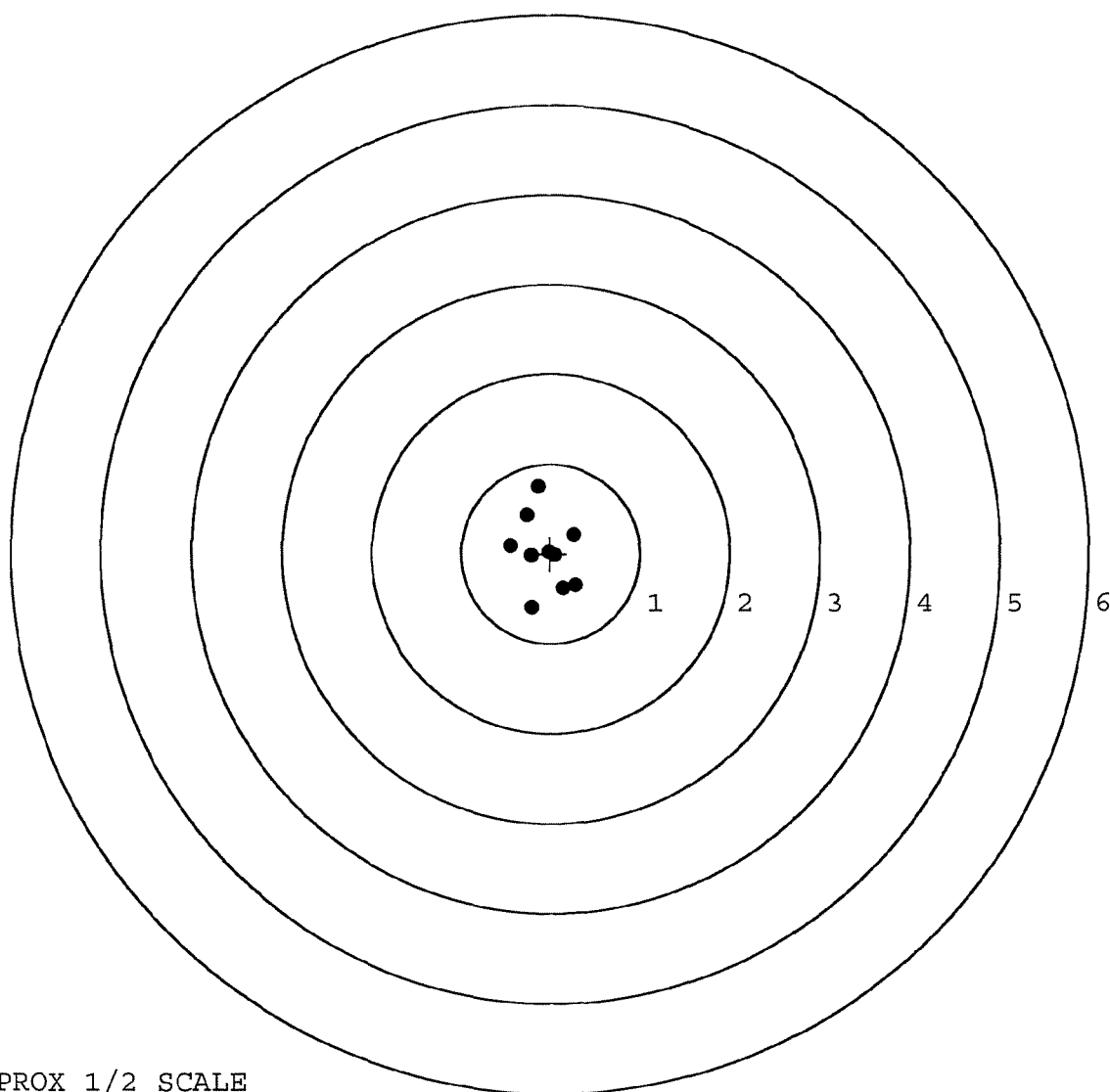
MAX RADIUS: 0.745

MEAN RADIUS: 0.387

IN 1 IN DIAMETER: 8

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6680289. 0

TARGET NUMBER: 3

FILE DATE: 09/13/2007

FILE TIME: 05:50

POINT#	X	Y
1:	0.752	0.724
2:	0.008	0.641
3:	0.453	0.167
4:	-0.813	0.165
5:	-0.516	-0.072
6:	-0.558	-0.677
7:	0.050	-0.458
8:	-0.180	-0.180
9:	0.012	-0.016
10:	0.643	0.584

X CENTROID: -0.015

Y CENTROID: 0.088

POA TO CENTROID: 0.089

HORZ SPREAD: 1.565

VERT SPREAD: 1.401

GROUP SPREAD: 1.918

MIN RADIUS: 0.107

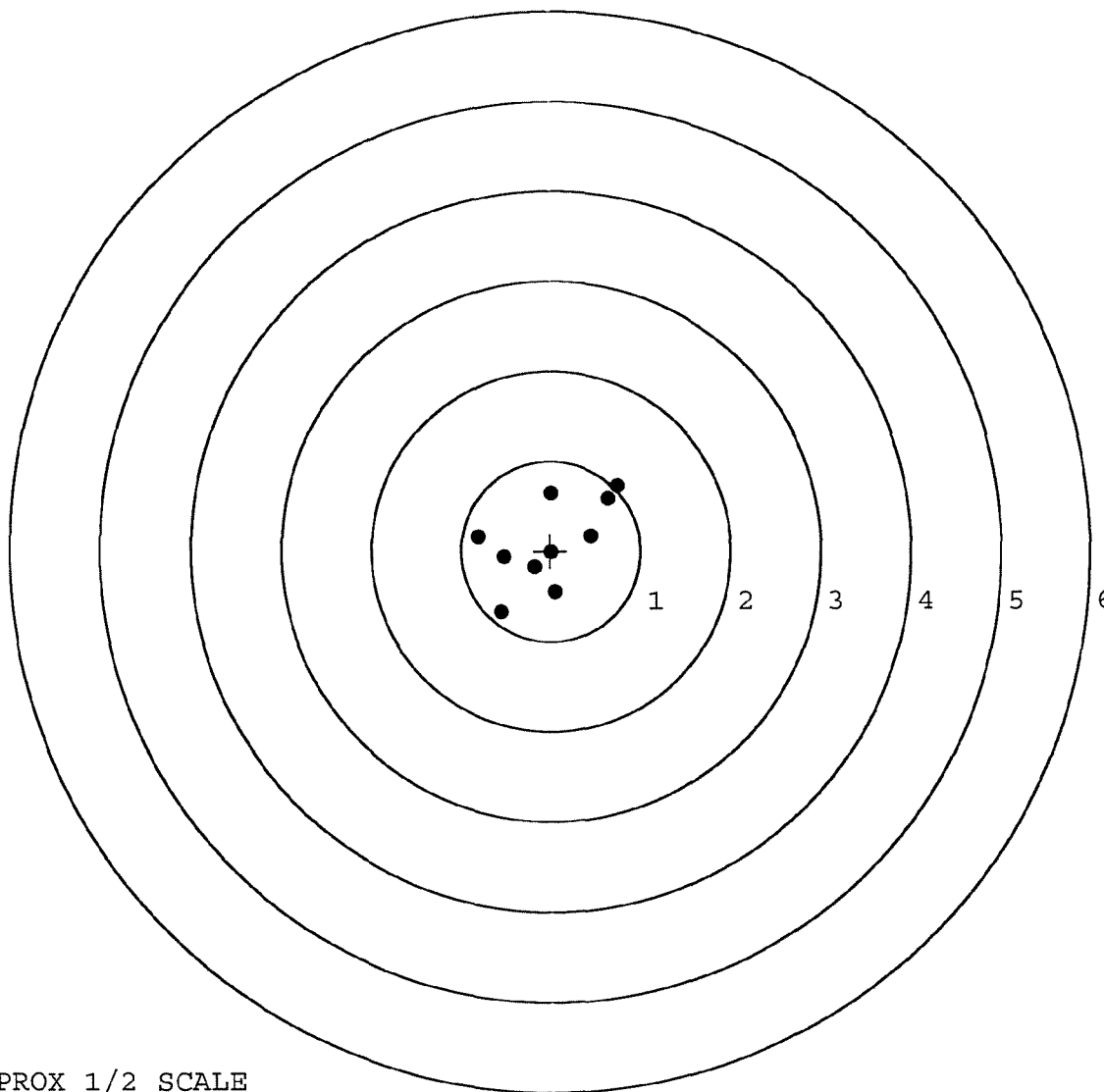
MAX RADIUS: 0.996

MEAN RADIUS: 0.609

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

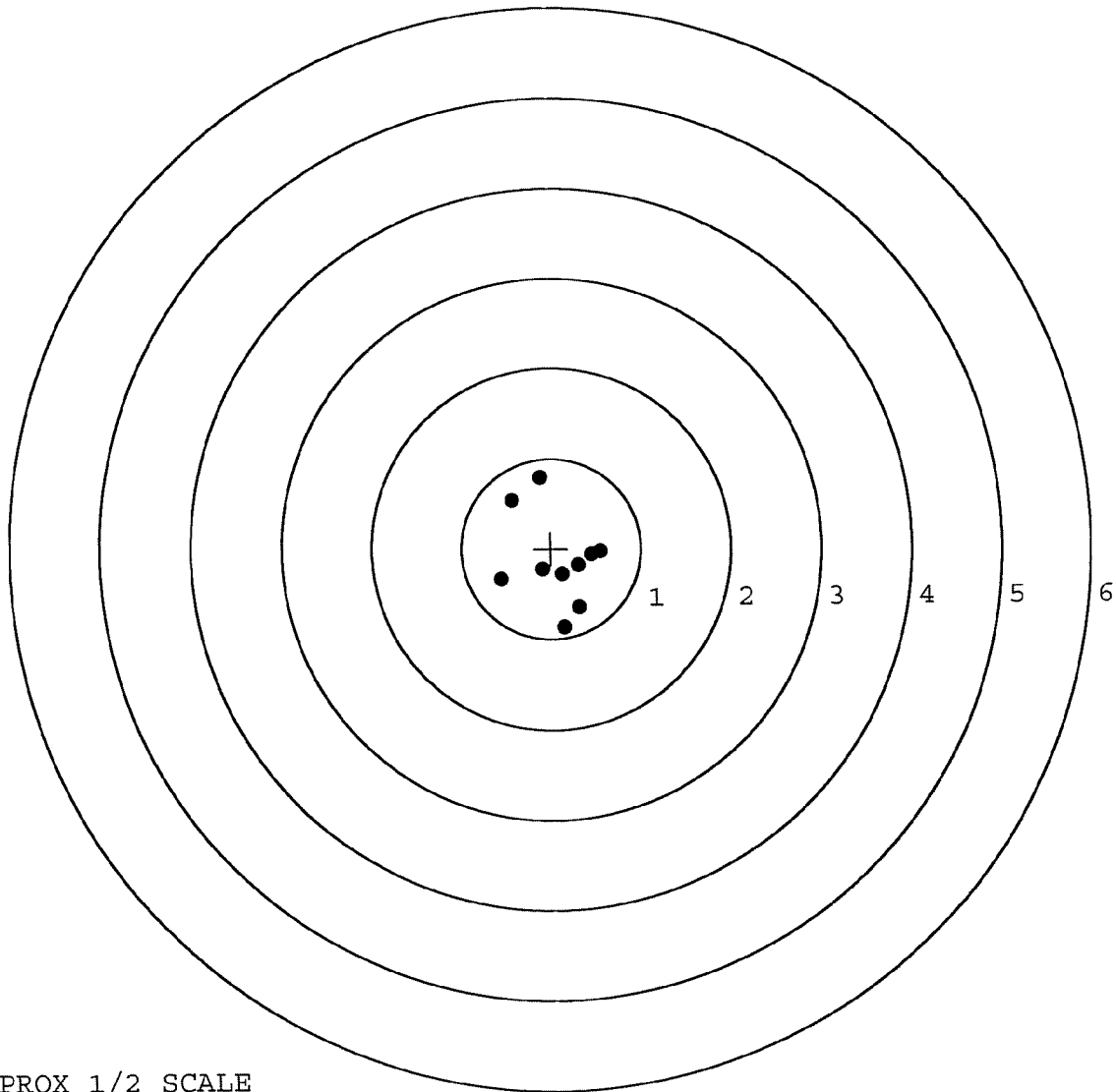


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6680289. __0
 TARGET NUMBER: 4
 FILE DATE: 09/13/2007
 FILE TIME: 05:50

POINT#	X	Y
1:	-0.118	0.788
2:	-0.431	0.539
3:	0.146	-0.874
4:	0.312	-0.658
5:	-0.556	-0.344
6:	-0.097	-0.240
7:	0.126	-0.290
8:	0.306	-0.187
9:	0.451	-0.070
10:	0.549	-0.037

X CENTROID: 0.069
 Y CENTROID: -0.137
 POA TO CENTROID: 0.154
 HORZ SPREAD: 1.105
 VERT SPREAD: 1.662
 GROUP SPREAD: 1.683
 MIN RADIUS: 0.163
 MAX RADIUS: 0.944
 MEAN RADIUS: 0.524
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6680289. __0

TARGET NUMBER: 5

FILE DATE: 09/13/2007

FILE TIME: 05:50

POINT#	X	Y
1:	0.072	0.549
2:	-0.139	0.454
3:	-0.678	0.420
4:	0.794	0.216
5:	0.484	-0.642
6:	0.431	-0.379
7:	-0.985	-0.191
8:	-0.365	-0.255
9:	0.013	-0.092
10:	0.379	0.045

X CENTROID: 0.001

Y CENTROID: 0.012

POA TO CENTROID: 0.013

HORZ SPREAD: 1.779

VERT SPREAD: 1.191

GROUP SPREAD: 1.825

MIN RADIUS: 0.105

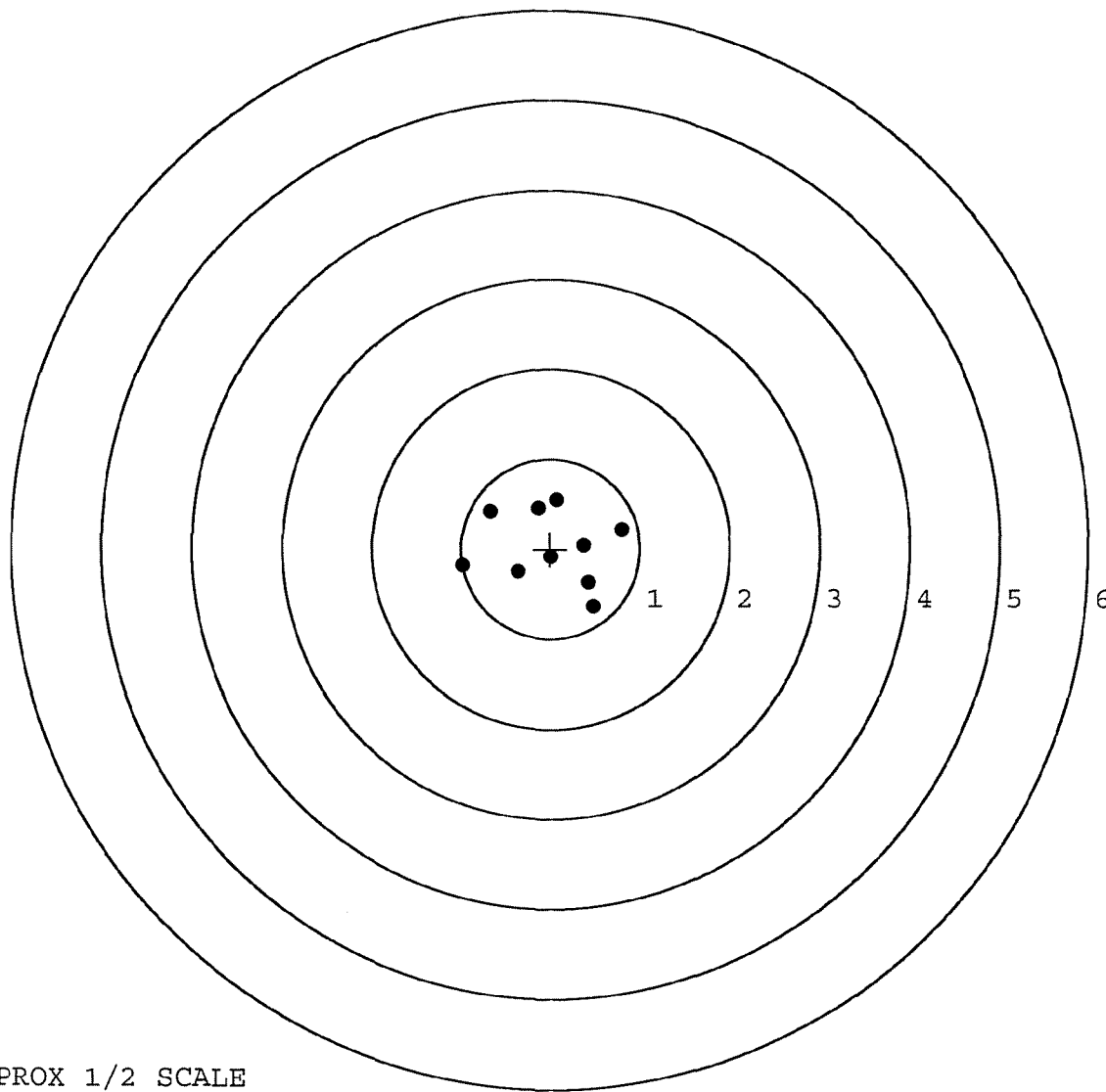
MAX RADIUS: 1.006

MEAN RADIUS: 0.595

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE