

66691403

**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
COMPLETE SYSTEM - LE/EXPORT**

98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

BM FORM 96253



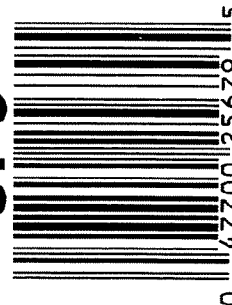
ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6691403

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



GUN SERIAL # G6691403

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-24-07	RJL
420	ASSEMBLE ACTION		9-24-07	RJL
430	ASSEMBLE TO STOCK		9-24-07	SD
440	PROOF	MAGNA-FLUX	9/24/07	mm
460	CHECK HEADSPACE	SEP 25 2007	9/24/07	mm
470	DIS-ASSEMBLE ACTION		9-24-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <i>mm</i>	9/25/07	<i>mm</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-25-07	CW
510	DRILL AND TAP SIGHT HOLES		9-25-07	FM
520	GOFF BLAST BBL / REC		9-26-07	<i>JK</i>
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/1/07	RJL
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/8/07	<i>RJL</i>
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/8/07	<i>RJL</i>
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/8/07	<i>RJL</i>
	D) OIL FIRING PIN ASSEMBLY		10/8/07	<i>RJL</i>
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

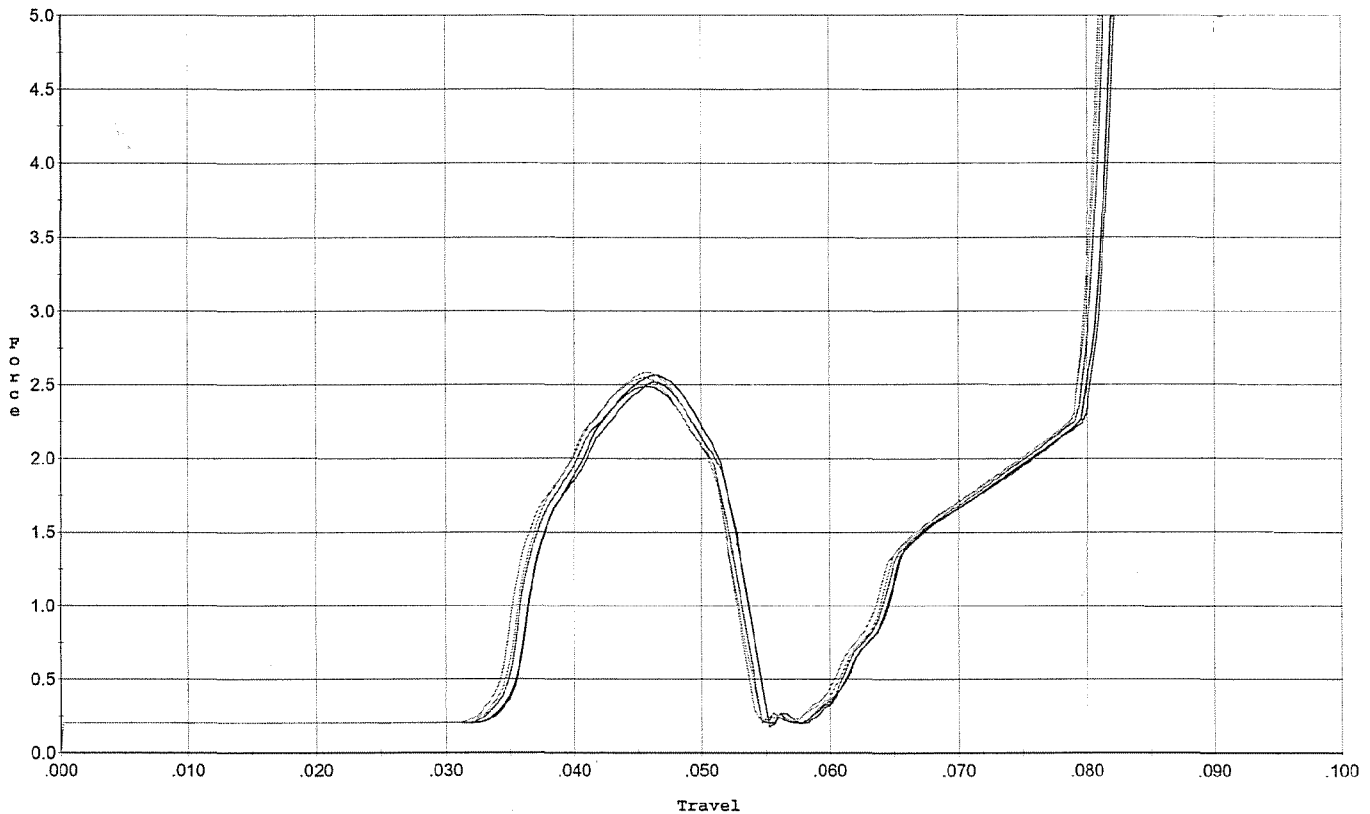
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.0</u> <u>5.25</u>	10/16/07	nm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.75</u>	10/16/07	nm
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/07	nm
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.021</u>	10/16/07	nm
	J) ASSEMBLE STOCK		10/8/07	nm
	K) ASSEMBLE SWIVEL STUDS		10/16/07	nm
	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/19/07	nm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-9-07	SD
670	FINAL INSPECTION A) HEADSPACE		10/16/07	nm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.2</u> <u>2.54</u> <u>2.45</u> <u>2.50</u> <u>2.78</u>	10/15/07	nm
	C) FUNCTION		10/16/07	nm
690	PACK		10/18/07	nm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/5/07

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



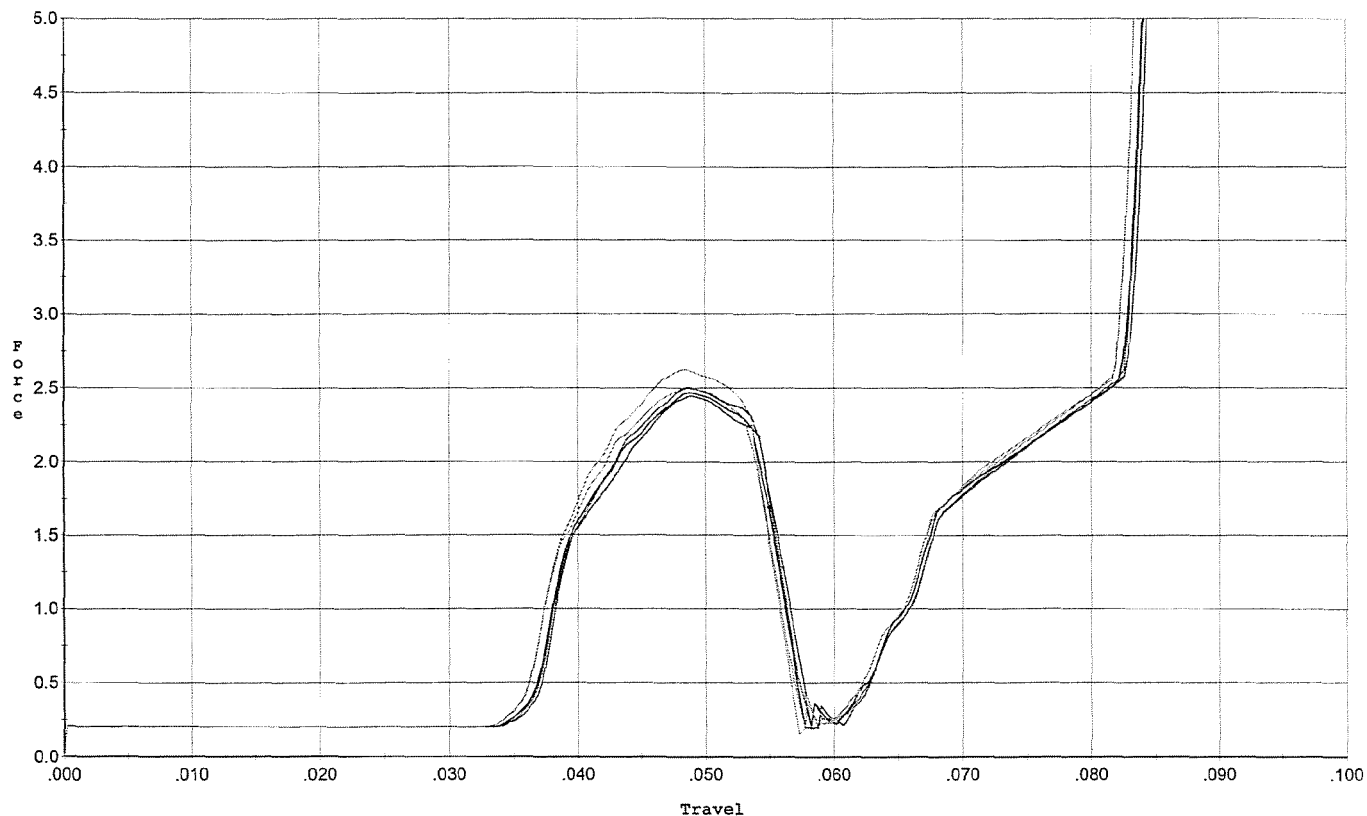
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.053	0.035	0.036	0.042		Set Trigger
2	2.566	0.053	0.035	0.036	0.043		Set Trigger
3	2.488	0.052	0.035	0.035	0.042		Set Trigger
4	2.585	0.051	0.034	0.036	0.042		Set Trigger
5	2.554	0.051	0.034	0.035	0.043		Set Trigger

AVG 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/5/07

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



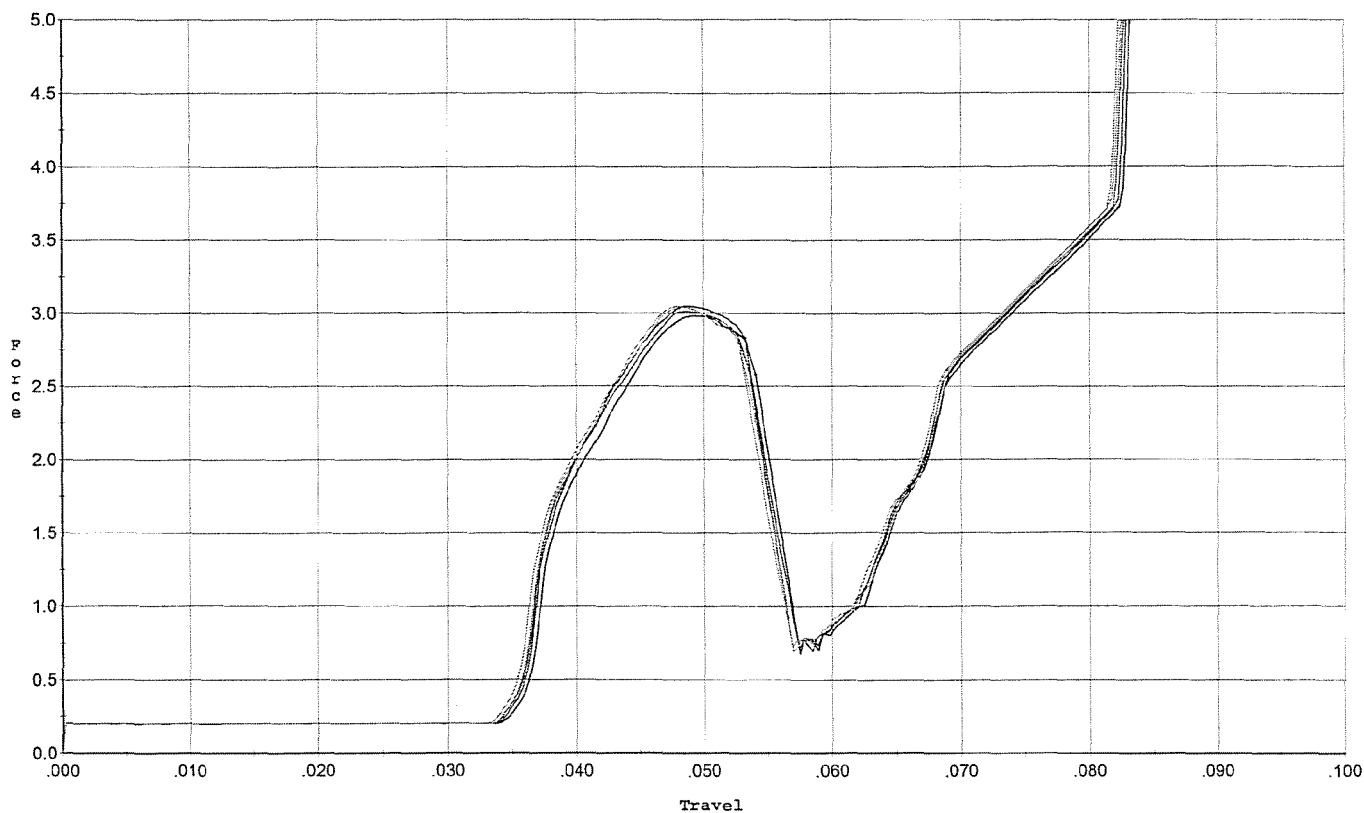
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.056	0.037	0.036	0.045		Set Trigger
2	2.469	0.055	0.037	0.036	0.044		Set Trigger
3	2.501	0.054	0.037	0.036	0.044		Set Trigger
4	2.507	0.054	0.036	0.036	0.045		Set Trigger
5	2.625	0.053	0.036	0.036	0.046		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/5/07

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



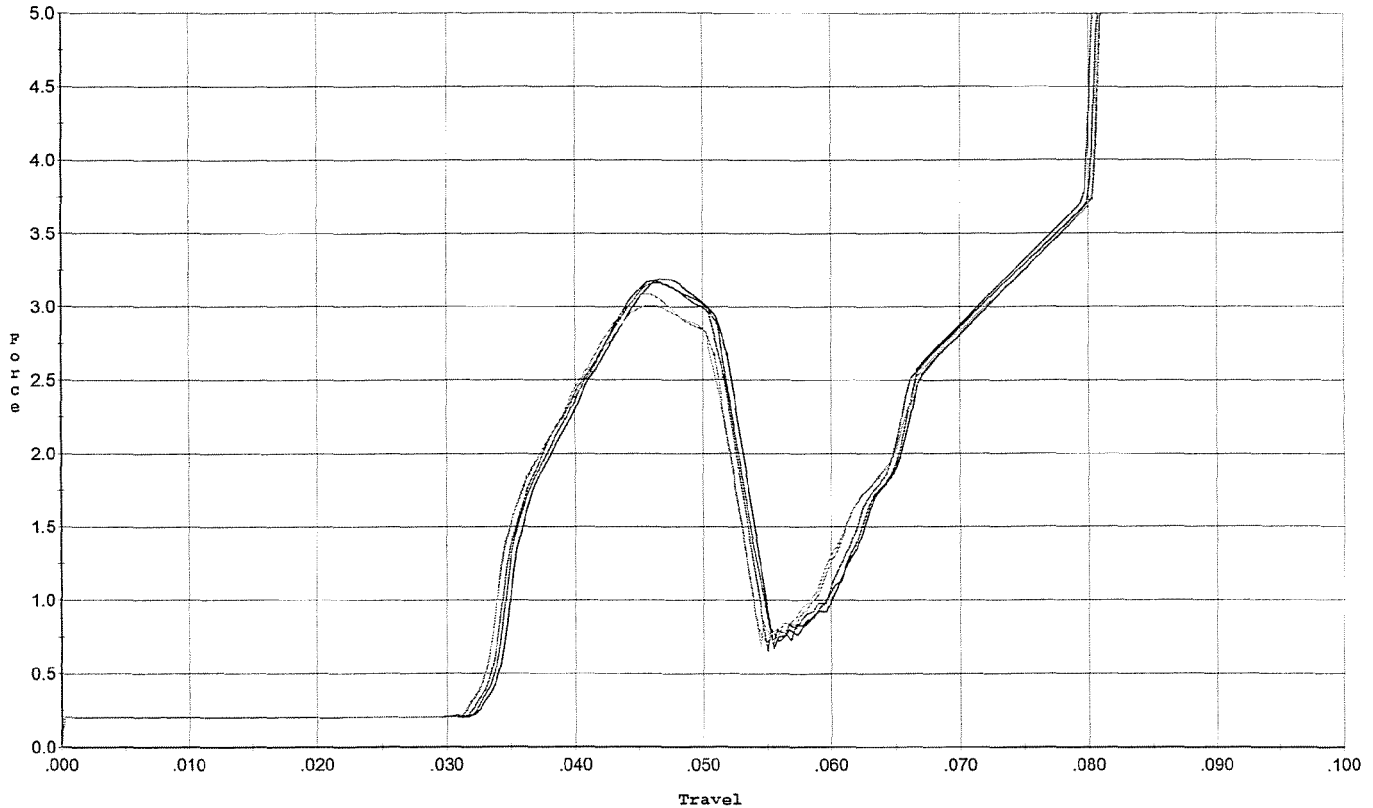
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.048	0.053	0.036	0.035	0.052		Set Trigger
2	2.982	0.054	0.036	0.035	0.052		Set Trigger
3	3.012	0.054	0.035	0.035	0.052		Set Trigger
4	3.048	0.053	0.034	0.034	0.052		Set Trigger
5	3.042	0.054	0.035	0.035	0.053		Set Trigger

AVG 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/5/07

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



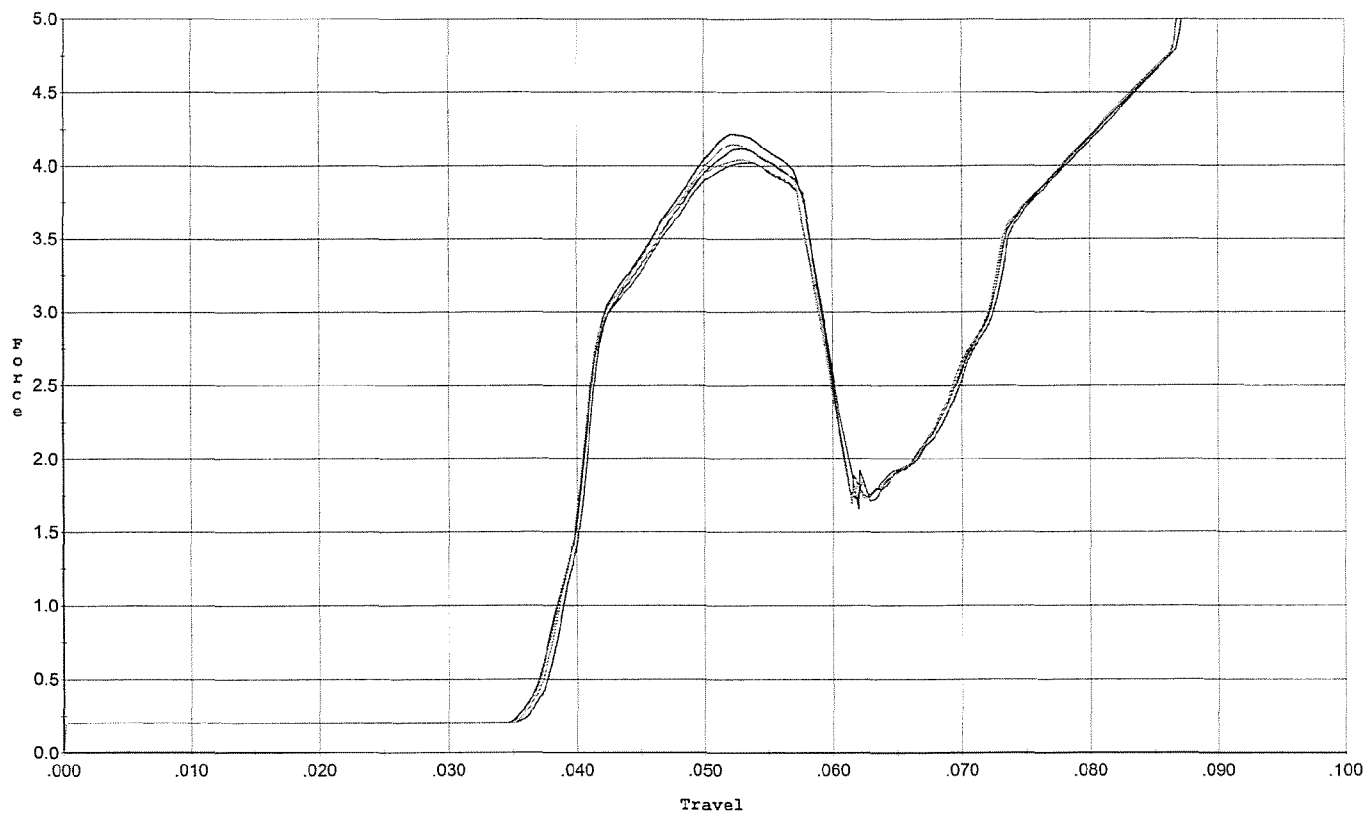
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.051	0.033	0.034	0.053		Set Trigger
2	3.188	0.052	0.033	0.034	0.054		Set Trigger
3	3.160	0.052	0.032	0.034	0.054		Set Trigger
4	3.007	0.051	0.032	0.034	0.052		Set Trigger
5	3.085	0.051	0.032	0.034	0.053		Set Trigger

AVG 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/5/07

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



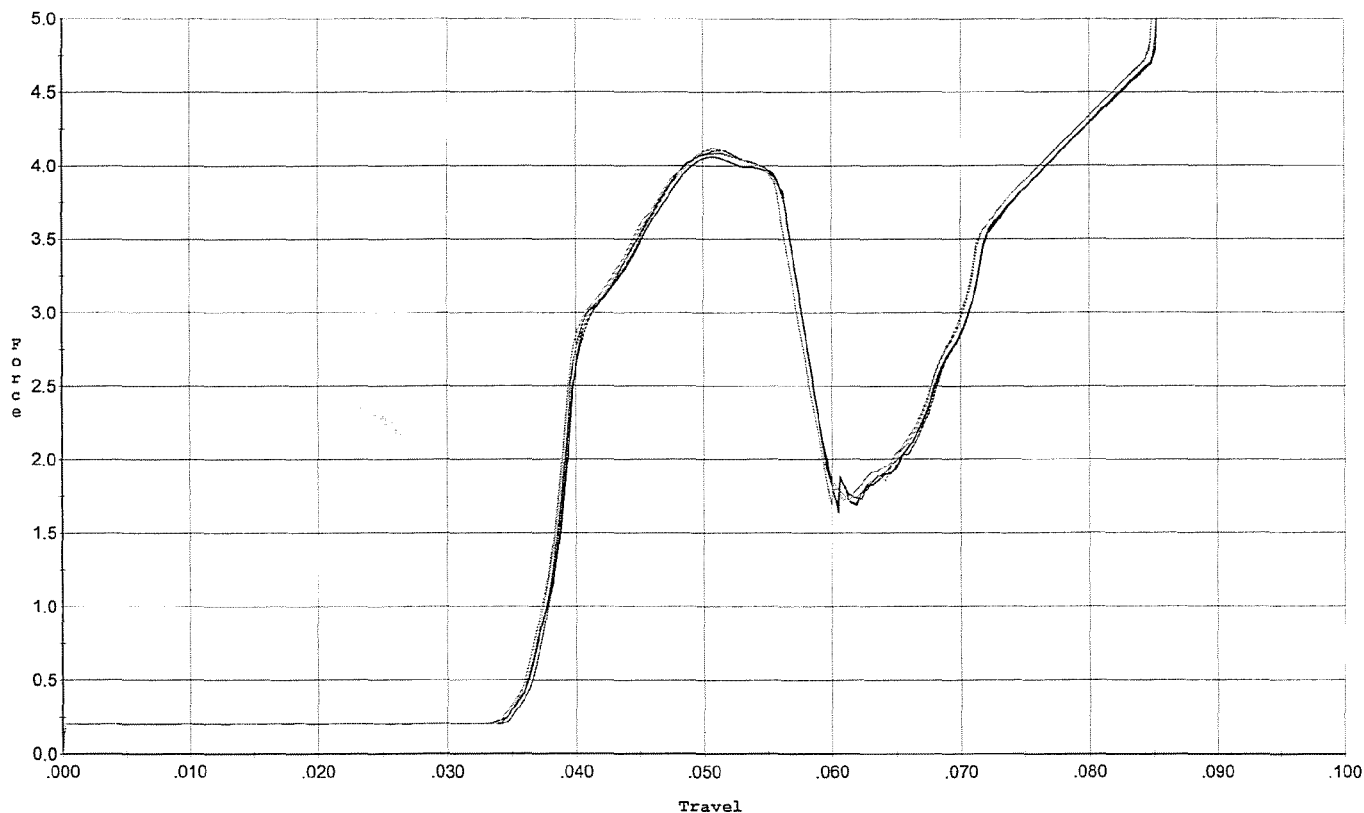
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.058	0.037	0.033	0.077		Set Trigger
2	4.218	0.058	0.036	0.033	0.079		Set Trigger
3	4.020	0.059	0.036	0.033	0.078		Set Trigger
4	4.047	0.059	0.036	0.033	0.079		Set Trigger
5	4.150	0.059	0.036	0.033	0.080		Set Trigger

Avg 4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/5/07

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



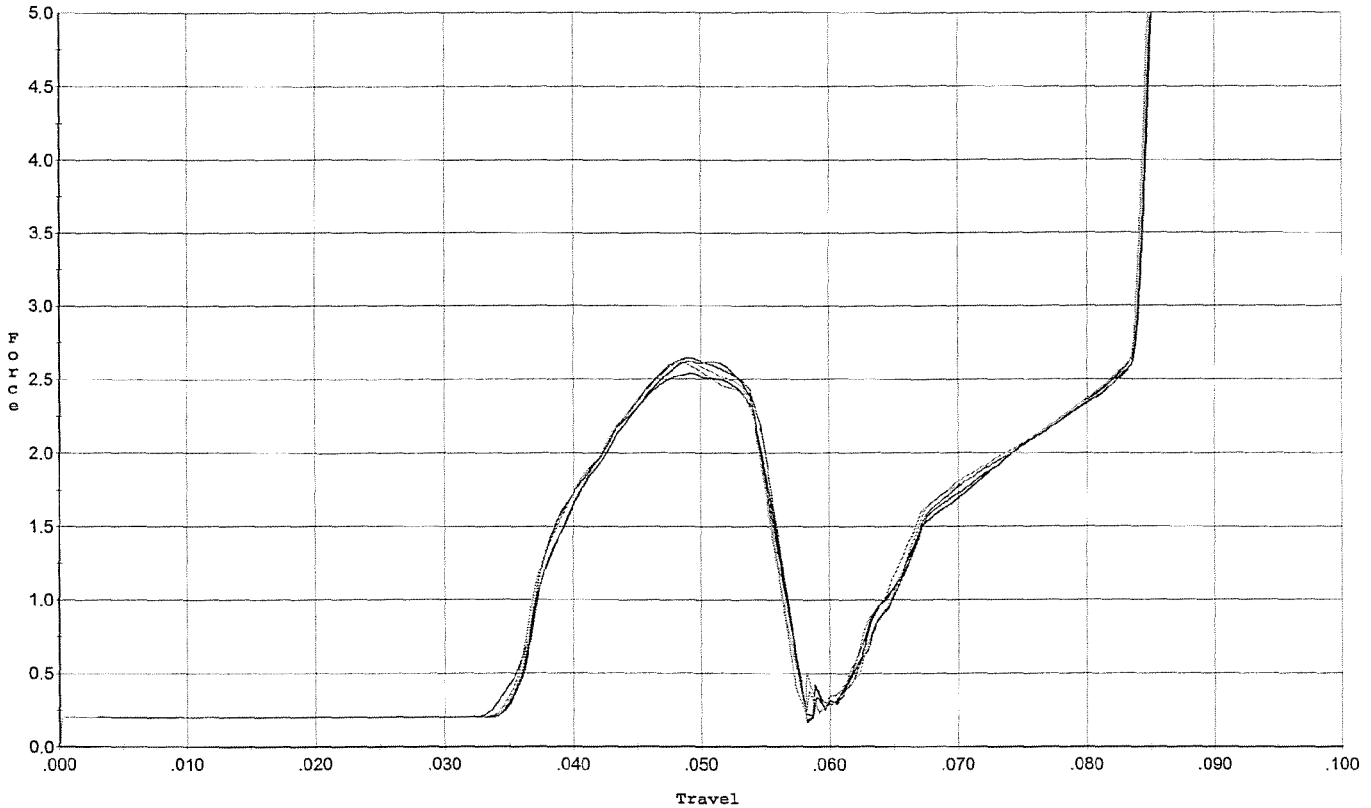
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.108	0.056	0.035	0.033	0.077		Set Trigger
2	4.064	0.056	0.036	0.033	0.076		Set Trigger
3	4.087	0.056	0.036	0.033	0.076		Set Trigger
4	4.111	0.056	0.035	0.033	0.076		Set Trigger
5	4.120	0.056	0.035	0.033	0.075		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/5/07

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



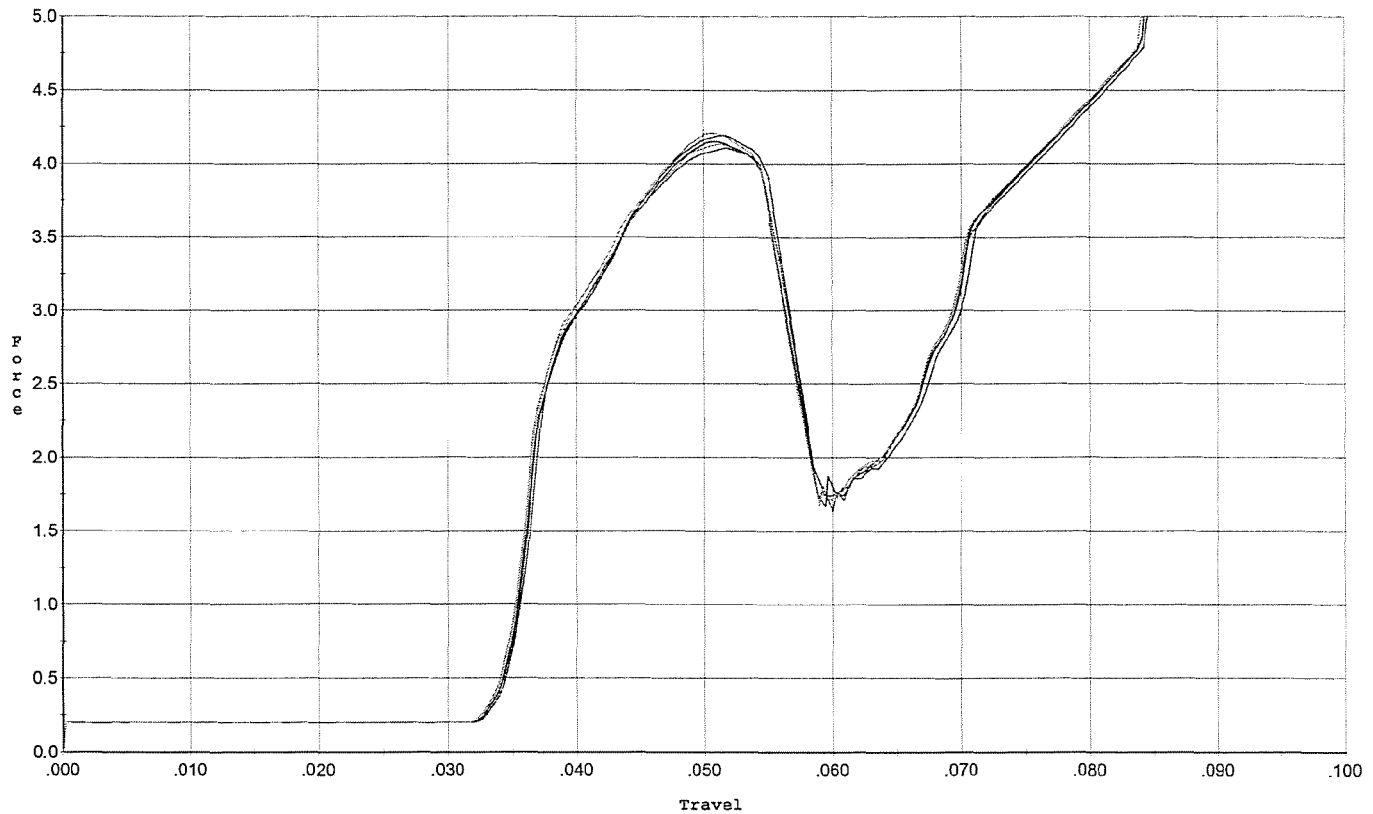
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.056	0.035	0.036	0.049		Set Trigger
2	2.619	0.055	0.035	0.036	0.048		Set Trigger
3	2.646	0.055	0.035	0.036	0.048		Set Trigger
4	2.632	0.054	0.035	0.036	0.047		Set Trigger
5	2.612	0.054	0.035	0.036	0.047		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/5/07

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	4.195	0.055	0.034	0.033	0.080		Set Trigger
2	4.153	0.054	0.033	0.033	0.078		Set Trigger
3	4.111	0.056	0.033	0.033	0.080		Set Trigger
4	4.134	0.055	0.033	0.033	0.078		Set Trigger
5	4.210	0.054	0.033	0.033	0.079		Set Trigger

Avg 4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6691403.___0

FILE DATE AND TIME: 10/10/2007 05:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	-0.082
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.798
The Distance from POA to Centroid Target #1:	0.117
The Distance from Centroid Target #2 to Centroid Target #1:	0.101
The Distance from Centroid Target #3 to Centroid Target #1:	0.186
The Distance from Centroid Target #4 to Centroid Target #1:	0.146
The Distance from Centroid Target #5 to Centroid Target #1:	0.159

BARBER - M24 0175847

SERIAL NUMBER: G6691403. __0

TARGET NUMBER: 1

FILE DATE: 10/10/2007

FILE TIME: 05:05

POINT#	X	Y
1:	0.414	0.545
2:	0.005	0.310
3:	-0.567	-0.309
4:	-0.604	-0.137
5:	-1.060	-0.157
6:	-1.025	0.436
7:	0.269	-0.084
8:	0.618	-0.191
9:	0.420	-0.345
10:	0.586	-0.763

X CENTROID: -0.094

Y CENTROID: -0.069

POA TO CENTROID: 0.117

HORZ SPREAD: 1.678

VERT SPREAD: 1.308

GROUP SPREAD: 2.008

MIN RADIUS: 0.364

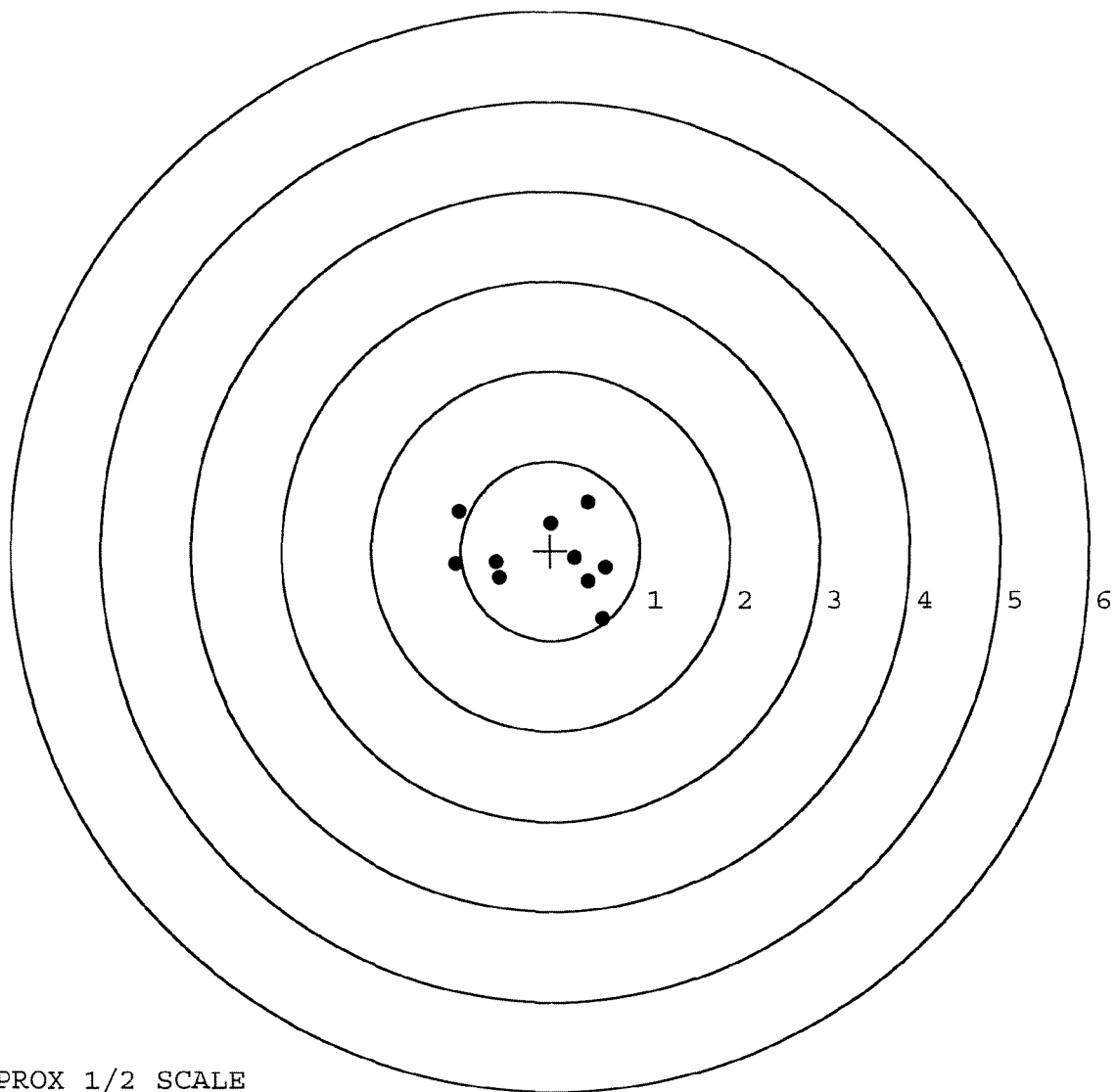
MAX RADIUS: 1.059

MEAN RADIUS: 0.690

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0175848

SERIAL NUMBER: G6691403. __0

TARGET NUMBER: 2

FILE DATE: 10/10/2007

FILE TIME: 05:05

POINT#	X	Y
1:	1.220	-0.305
2:	1.012	-0.796
3:	0.766	1.140
4:	0.343	0.601
5:	0.198	-0.116
6:	-0.144	-0.328
7:	0.065	-0.573
8:	-0.551	-0.730
9:	-1.314	-0.303
10:	-1.916	-0.079

X CENTROID: -0.032

Y CENTROID: -0.149

POA TO CENTROID: 0.152

HORZ SPREAD: 3.136

VERT SPREAD: 1.936

GROUP SPREAD: 3.144

MIN RADIUS: 0.211

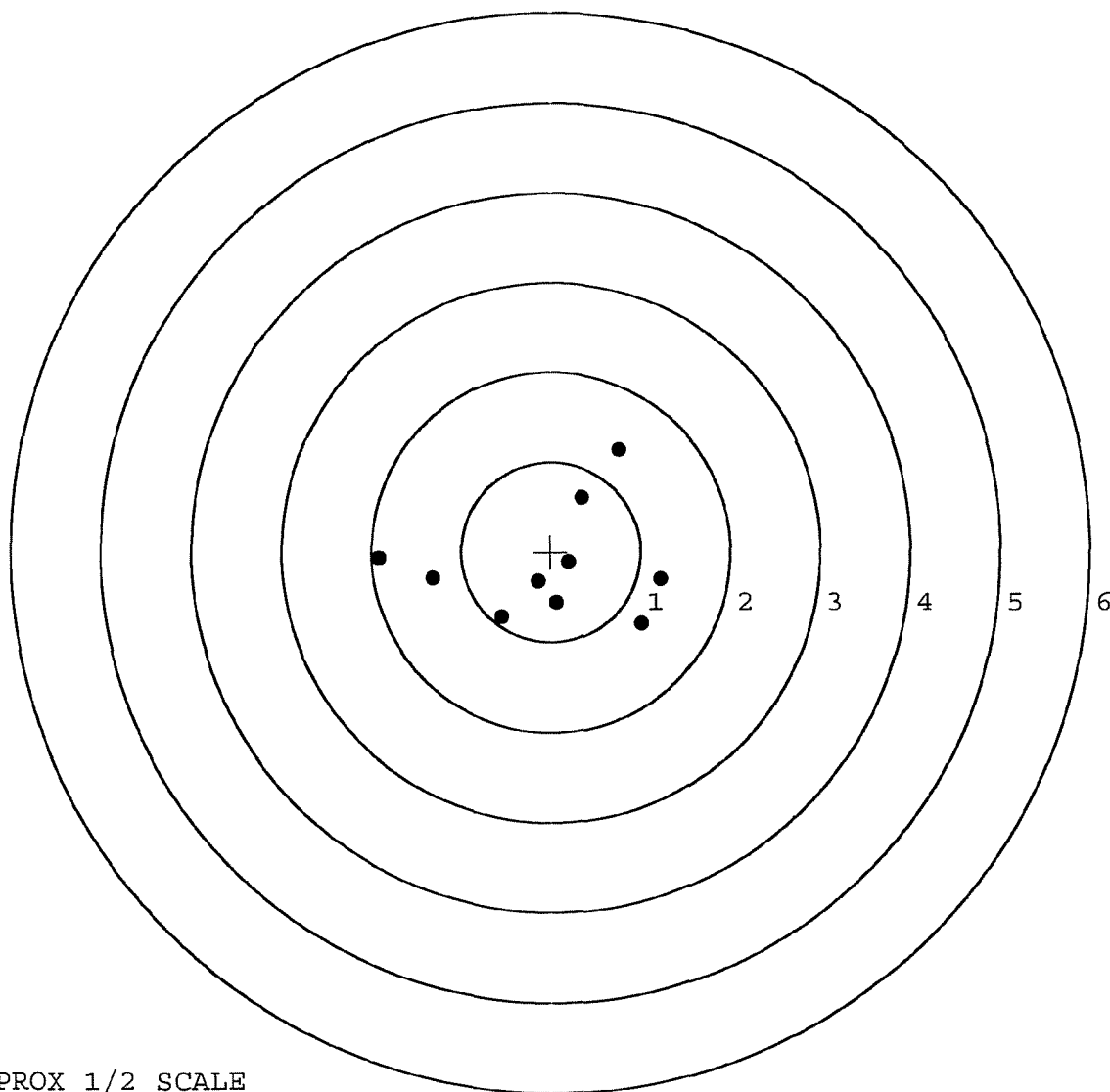
MAX RADIUS: 1.885

MEAN RADIUS: 0.968

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



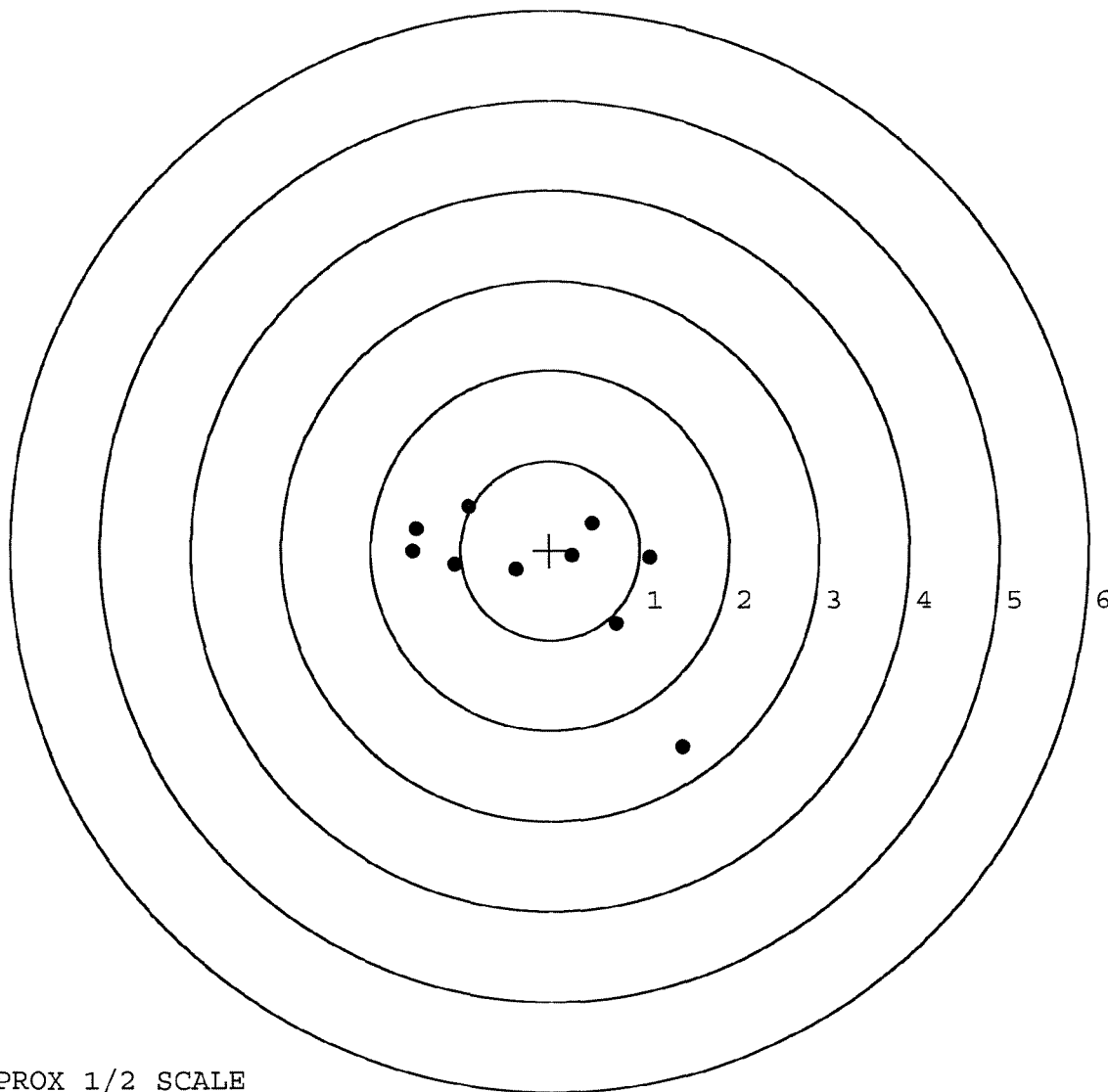
TARGET APPROX 1/2 SCALE

BARBER - M24 0175849

SERIAL NUMBER: G6691403. __0
 TARGET NUMBER: 3
 FILE DATE: 10/10/2007
 FILE TIME: 05:05

POINT#	X	Y
1:	1.117	-0.083
2:	0.736	-0.818
3:	0.251	-0.066
4:	0.469	0.312
5:	-0.376	-0.218
6:	-1.065	-0.162
7:	-1.530	-0.017
8:	-1.499	0.235
9:	-0.908	0.492
10:	1.469	-2.191

X CENTROID: -0.134
 Y CENTROID: -0.252
 POA TO CENTROID: 0.285
 HORZ SPREAD: 2.999
 VERT SPREAD: 2.683
 GROUP SPREAD: 3.833
 MIN RADIUS: 0.245
 MAX RADIUS: 2.516
 MEAN RADIUS: 1.119
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0175850

SERIAL NUMBER: G6691403. 0

TARGET NUMBER: 4

FILE DATE: 10/10/2007

FILE TIME: 05:05

POINT#	X	Y
1:	0.890	0.009
2:	0.631	-0.724
3:	0.449	-0.219
4:	-0.139	-0.641
5:	-0.377	-0.478
6:	-0.388	0.439
7:	-0.581	0.385
8:	-0.007	0.585
9:	-1.027	0.333
10:	-1.006	0.946

X CENTROID: -0.155

Y CENTROID: 0.064

POA TO CENTROID: 0.168

HORZ SPREAD: 1.917

VERT SPREAD: 1.670

GROUP SPREAD: 2.339

MIN RADIUS: 0.442

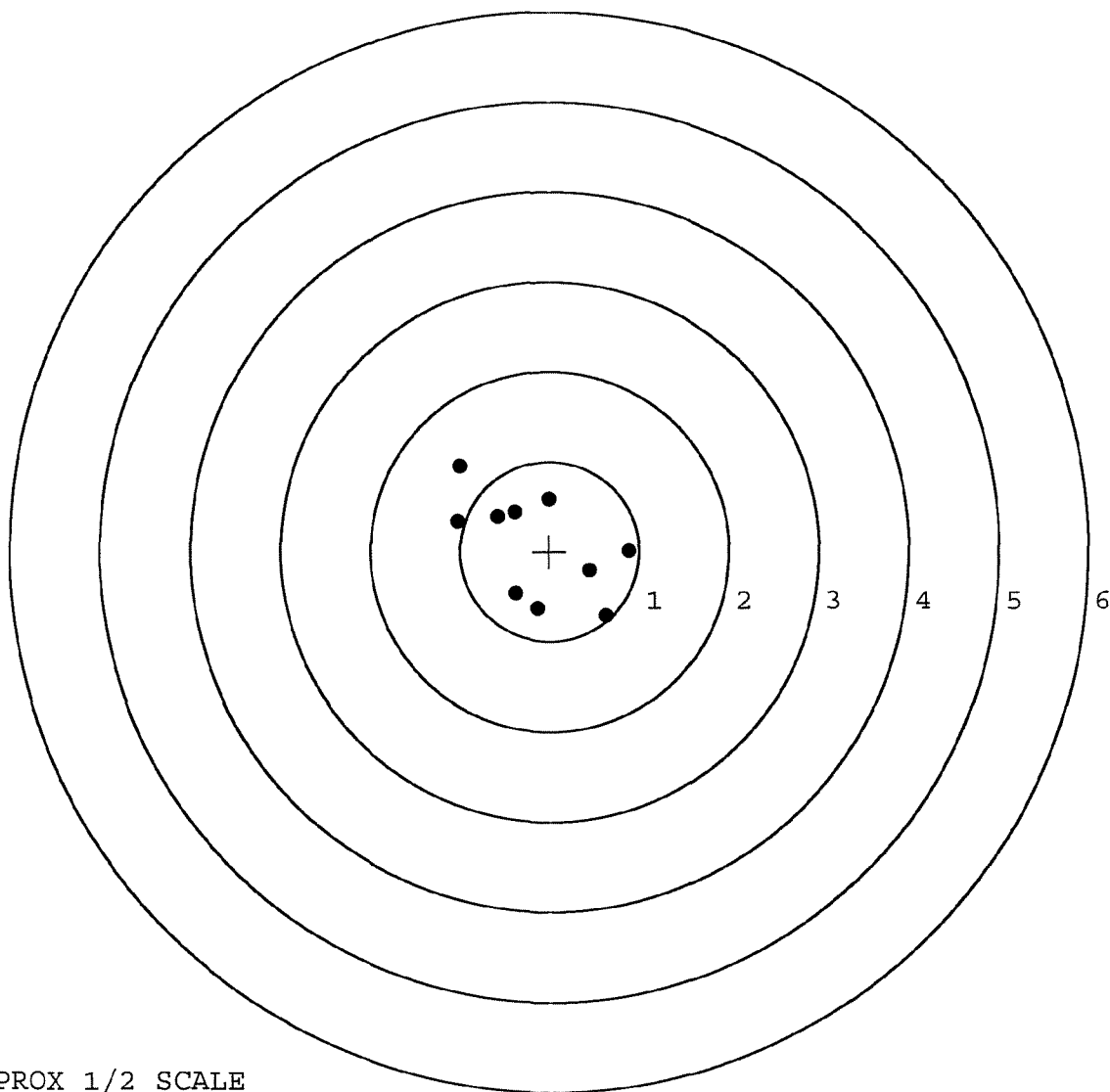
MAX RADIUS: 1.226

MEAN RADIUS: 0.777

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



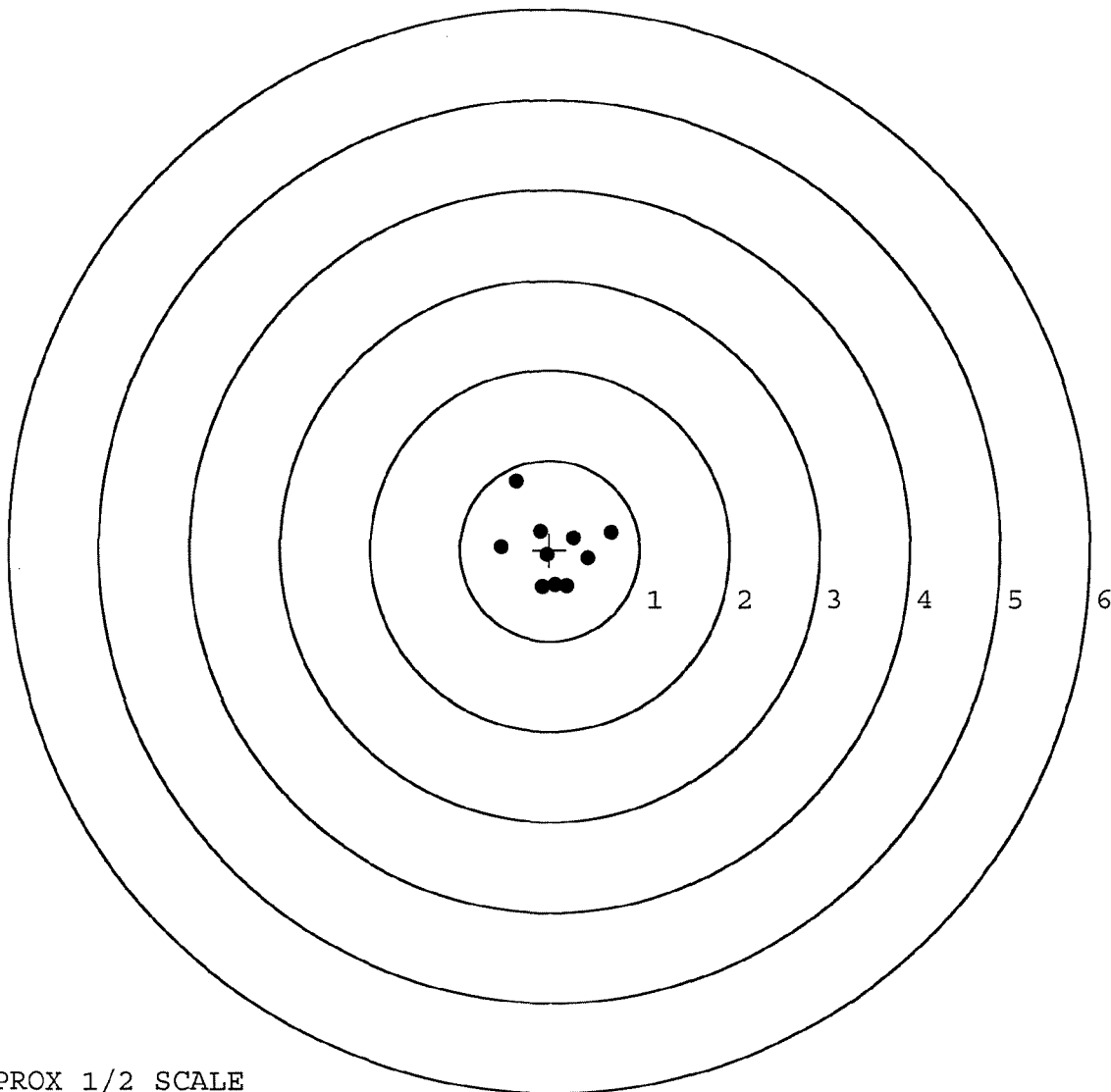
TARGET APPROX 1/2 SCALE

BARBER - M24 0175851

SERIAL NUMBER: G6691403. __0
 TARGET NUMBER: 5
 FILE DATE: 10/10/2007
 FILE TIME: 05:05

POINT#	X	Y
1:	-0.372	-0.761
2:	-0.534	0.027
3:	0.681	0.195
4:	0.431	-0.098
5:	0.262	0.138
6:	-0.111	0.208
7:	-0.030	-0.054
8:	-0.084	-0.411
9:	0.065	-0.392
10:	0.191	-0.406

X CENTROID: 0.050
 Y CENTROID: -0.003
 POA TO CENTROID: 0.050
 HORZ SPREAD: 1.215
 VERT SPREAD: 1.172
 GROUP SPREAD: 1.296
 MIN RADIUS: 0.095
 MAX RADIUS: 0.873
 MEAN RADIUS: 0.437
 # IN 1 IN DIAMETER: 7
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE