

6669 3304

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

- INSTRUCTION BOOK 3518

BM FORM



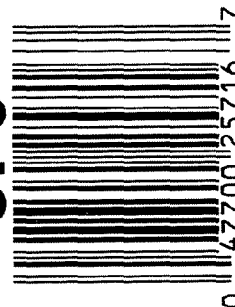
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6693304

UPC



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.



66693304

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0177495 77534

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6693304

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10/2/07	SPD
420	ASSEMBLE ACTION		10-1-07	SD
430	ASSEMBLE TO STOCK		10-1-07	SD
440	PROOF	MAGNA - FLUX	10/1/07	mm
460	CHECK HEADSPACE	UCI 08 2007	10/1/07	mm
470	DIS-ASSEMBLE ACTION		10-1-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <i>mm</i>	10/3/07	<i>mm</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-3-07	CW
510	DRILL AND TAP SIGHT HOLES		10-2-07	SD
520	GOFF BLAST BBL / REC		10-3-07	YU
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/10/07	RB
560	RE-ASSEMBLE ACTION		10-12-07	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-12-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-12-07	SD
	D) OIL FIRING PIN ASSEMBLY		10/15/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/29/07	DA

F004 REV 5/2006

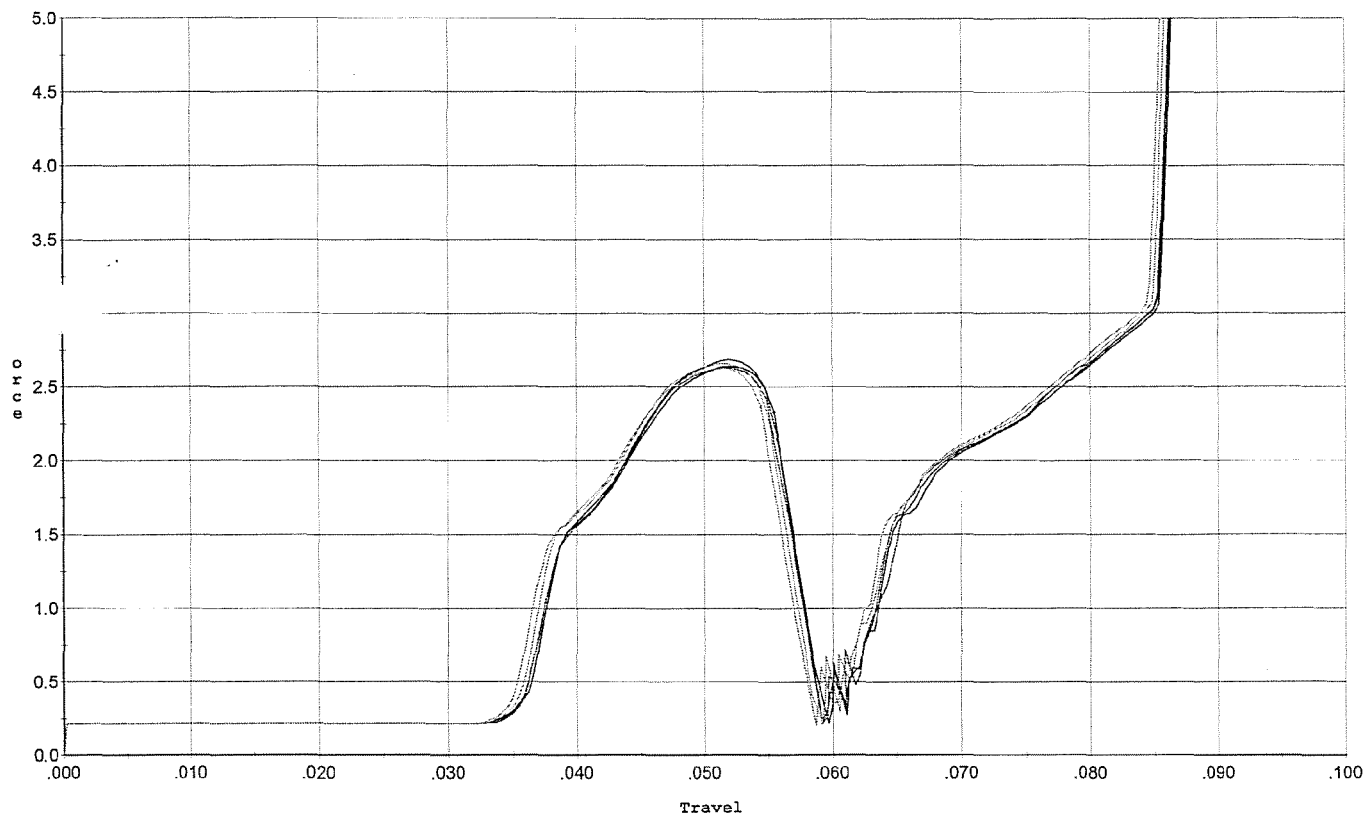
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.25</u> <u>5.75</u>	10/23/07	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.75</u> <u>5.75</u> <u>5.25</u>	10/23/07	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		10/23/07	mm
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	10/23/07	mm
	J) ASSEMBLE STOCK		10/15/07	RPD
	K) ASSEMBLE SWIVEL STUDS		10/25/07	RA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-29-07	RTZ
	M) IRON SIGHT ALIGNMENT		10-29-07	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-29-07	RTZ
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	10-17-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-17-07	BWD
670	FINAL INSPECTION A) HEADSPACE		10/24/07	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.65</u> <u>2.62</u> <u>2.62</u> <u>2.62</u>	10/23/07	mm
	C) FUNCTION		10/24/07	mm
690	PACK		10/29/07	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



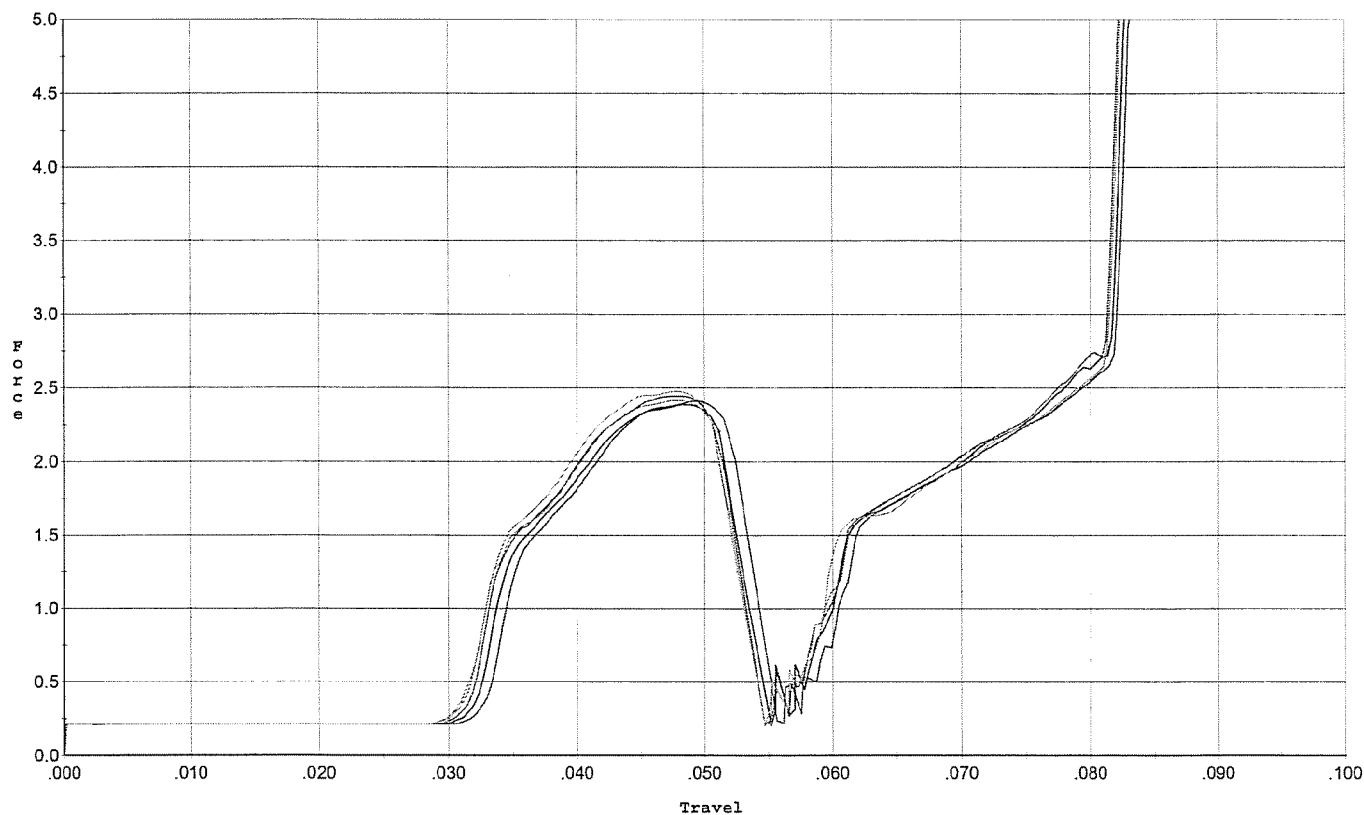
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.683	0.056	0.036	0.036	0.050		Set Trigger
2	2.637	0.055	0.036	0.036	0.049		Set Trigger
3	2.628	0.056	0.036	0.036	0.050		Set Trigger
4	2.655	0.055	0.035	0.036	0.049		Set Trigger
5	2.624	0.054	0.035	0.036	0.049		Set Trigger

Avg 2.64

Trigger Profile [lbs,inch]

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

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



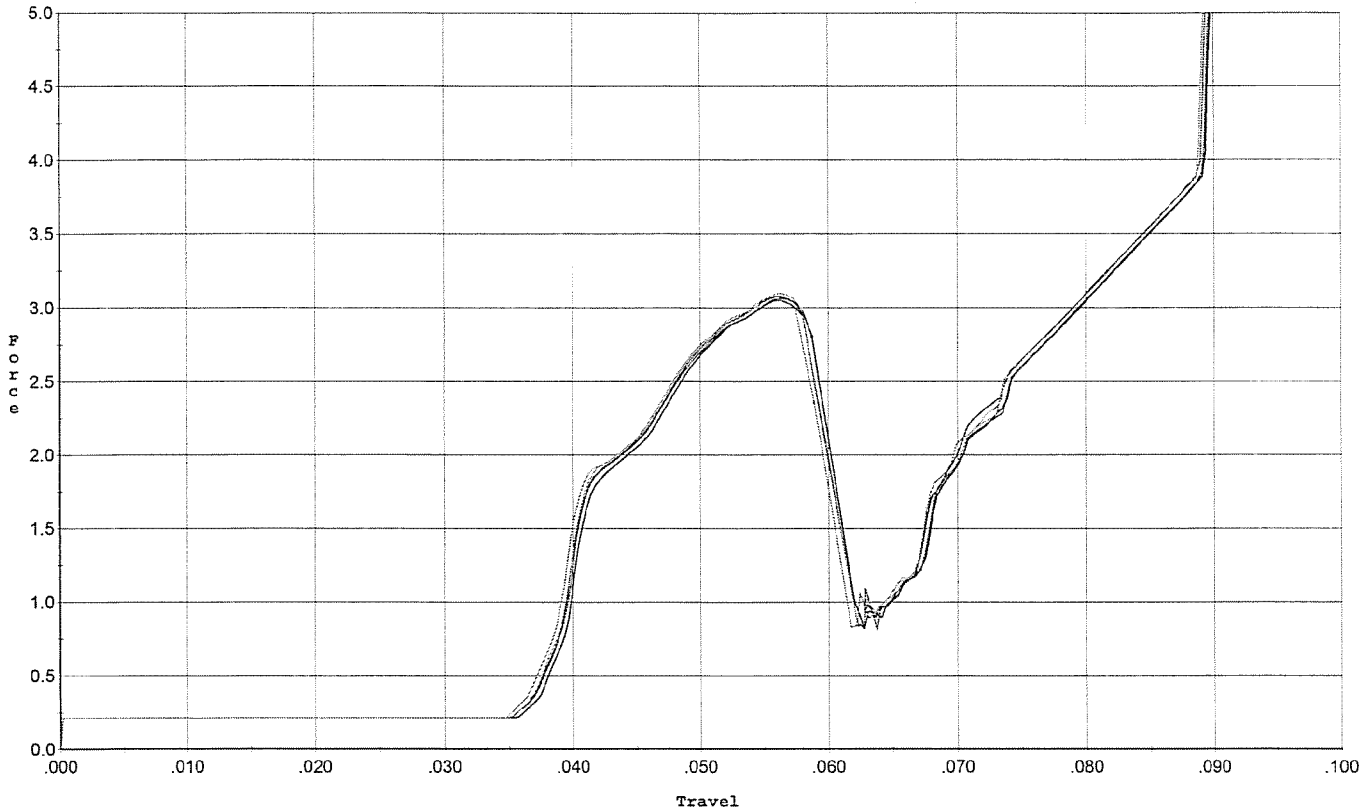
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.412	0.052	0.033	0.035	0.045		Set Trigger
2	2.388	0.051	0.032	0.036	0.044		Set Trigger
3	2.445	0.052	0.032	0.035	0.046		Set Trigger
4	2.477	0.053	0.031	0.035	0.048		Set Trigger
5	2.415	0.052	0.031	0.035	0.047		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

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

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



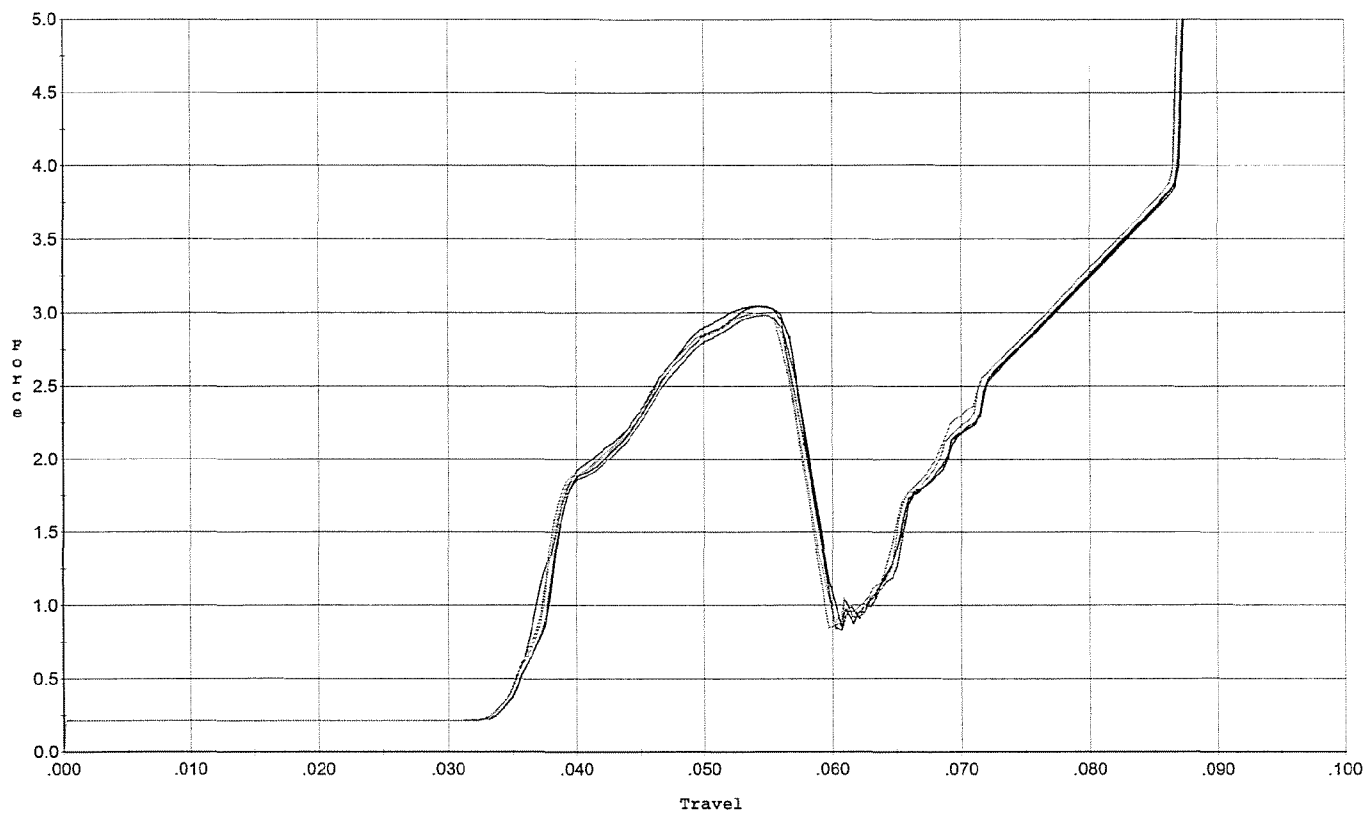
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.049	0.060	0.037	0.036	0.060		Set Trigger
2	3.066	0.059	0.038	0.036	0.059		Set Trigger
3	3.075	0.058	0.037	0.037	0.058		Set Trigger
4	3.098	0.060	0.037	0.036	0.061		Set Trigger
5	3.064	0.059	0.037	0.036	0.060		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

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

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



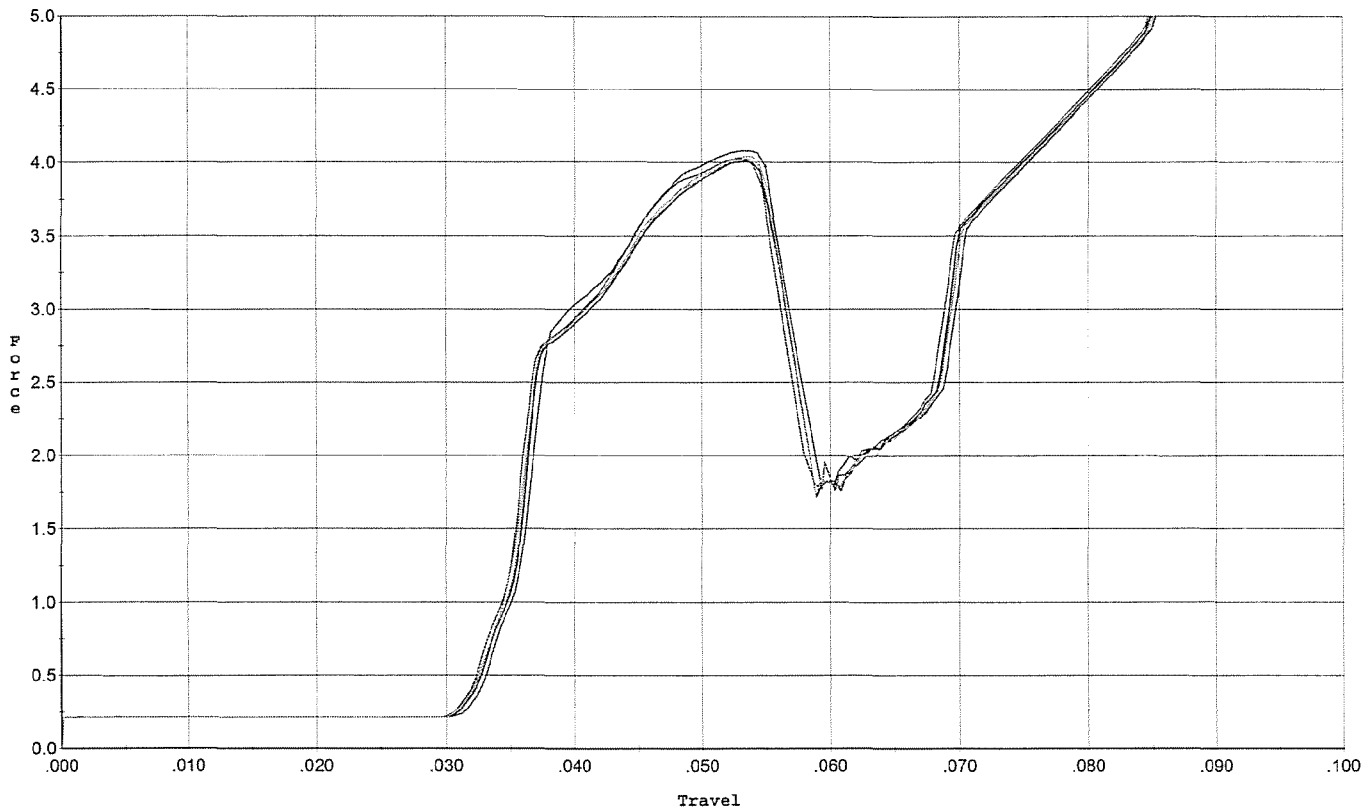
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.057	0.035	0.035	0.060		Set Trigger
2	3.042	0.057	0.035	0.035	0.058		Set Trigger
3	2.980	0.058	0.035	0.035	0.058		Set Trigger
4	2.988	0.056	0.035	0.035	0.057		Set Trigger
5	2.997	0.057	0.035	0.035	0.058		Set Trigger

AVG 3.01

Trigger Profile [lbs,inch]

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

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



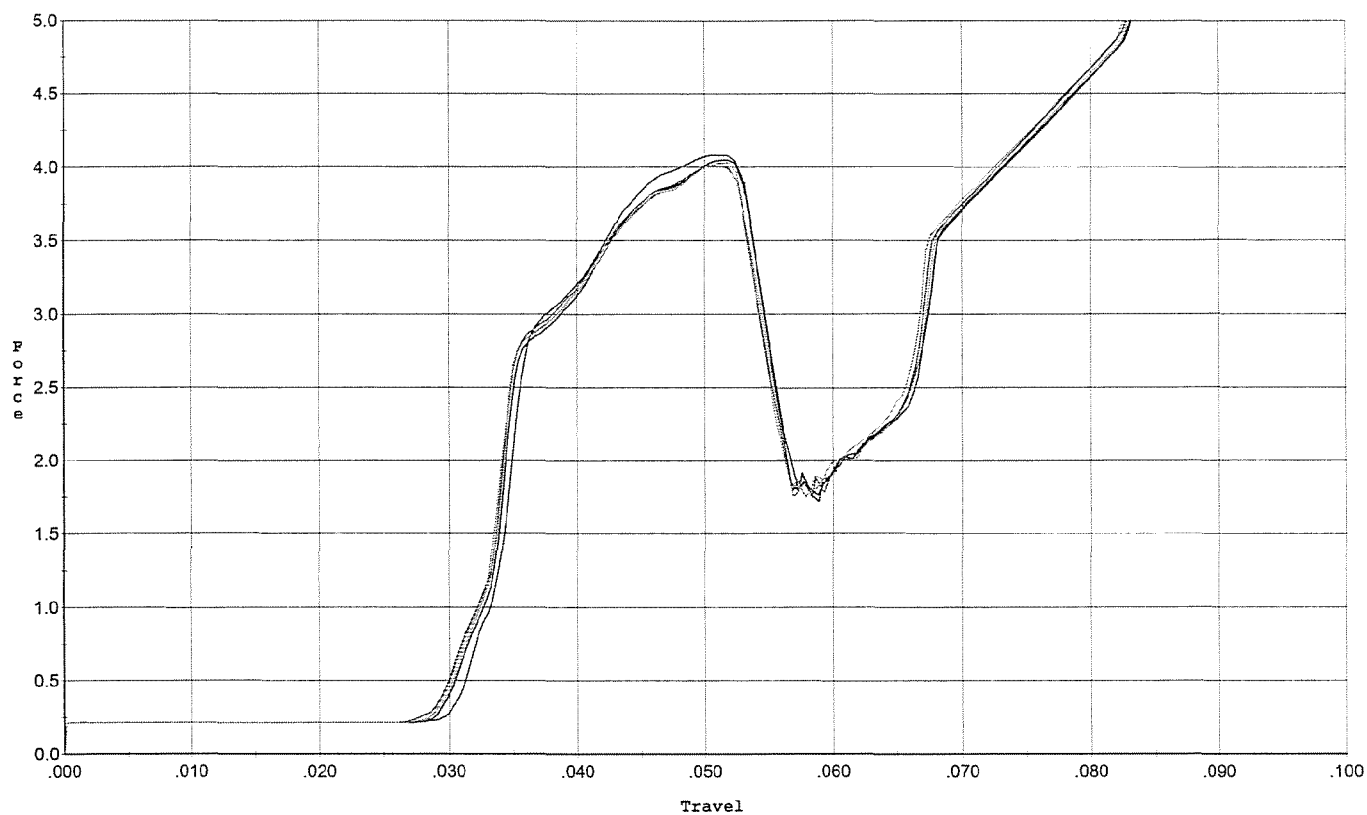
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.079	0.055	0.033	0.033	0.080		Set Trigger
2	4.008	0.056	0.032	0.033	0.080		Set Trigger
3	4.027	0.055	0.032	0.033	0.079		Set Trigger
4	4.026	0.056	0.032	0.033	0.080		Set Trigger
5	4.038	0.055	0.032	0.033	0.080		Set Trigger

AVG 4.03

Trigger Profile [lbs,inch]

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

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



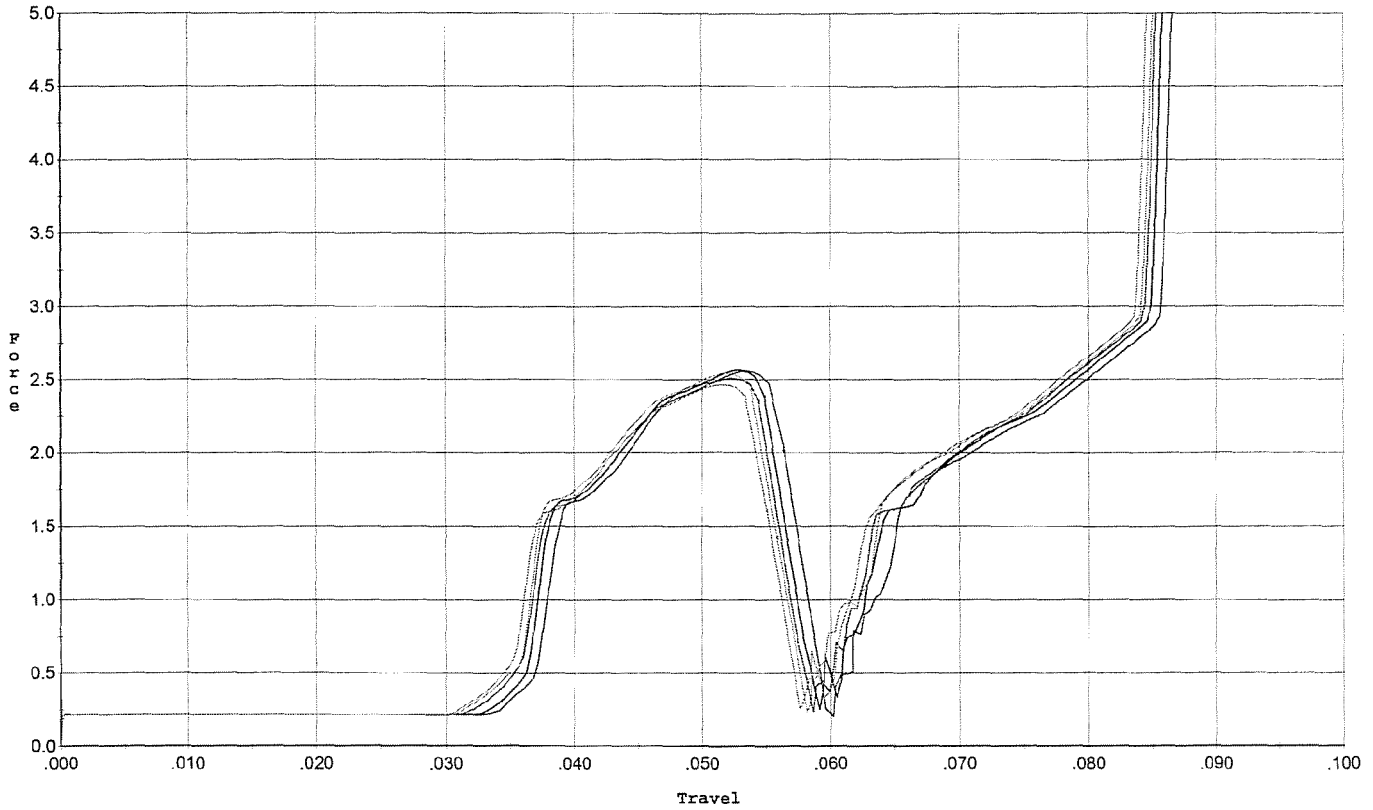
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.082	0.053	0.030	0.033	0.079		Set Trigger
2	4.048	0.053	0.030	0.033	0.079		Set Trigger
3	4.007	0.053	0.029	0.032	0.079		Set Trigger
4	4.021	0.053	0.029	0.032	0.078		Set Trigger
5	4.028	0.054	0.029	0.032	0.081		Set Trigger

AVG 4.03

Trigger Profile [lbs,inch]

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

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



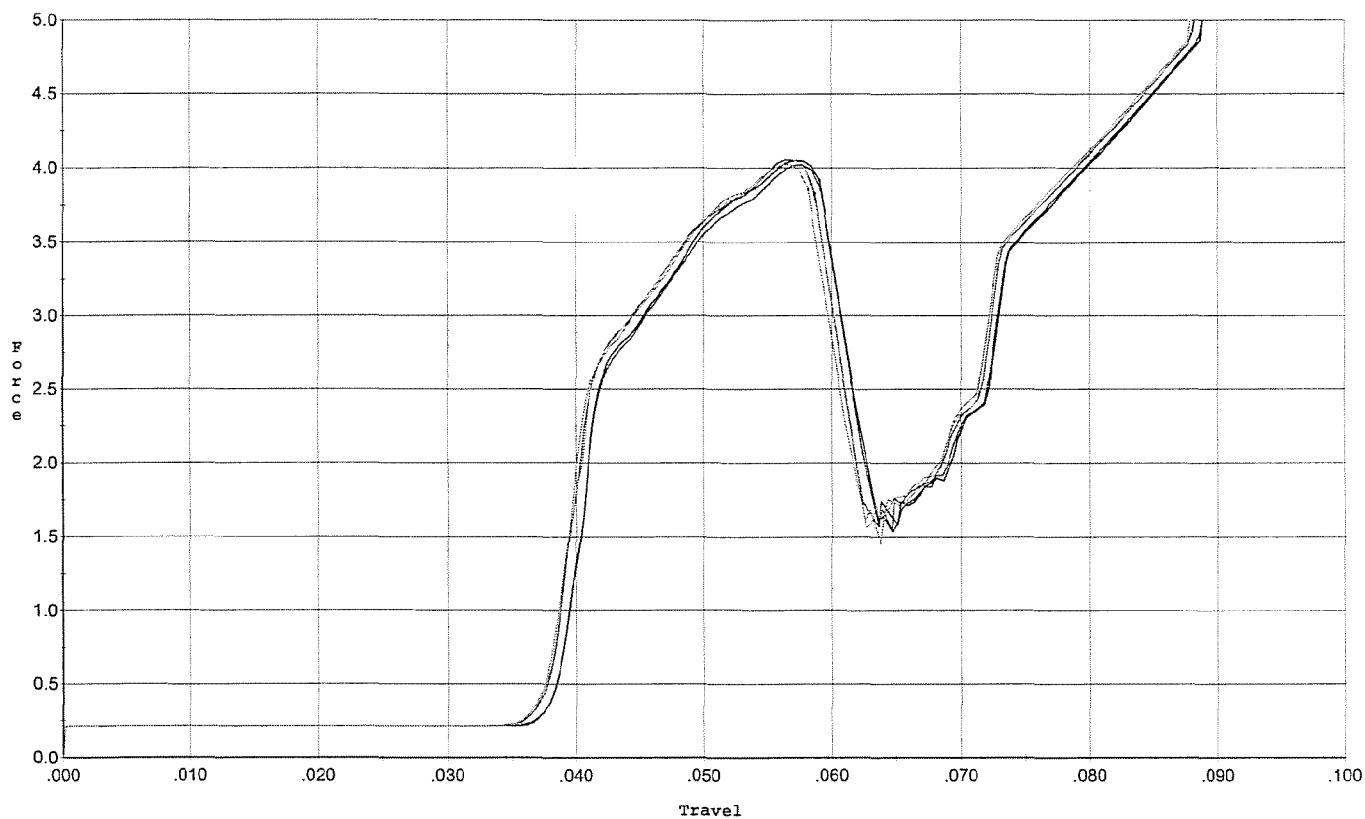
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.556	0.056	0.037	0.036	0.050		Set Trigger
2	2.564	0.055	0.036	0.036	0.048		Set Trigger
3	2.511	0.054	0.036	0.036	0.048		Set Trigger
4	2.545	0.056	0.036	0.036	0.050		Set Trigger
5	2.466	0.055	0.035	0.036	0.048		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

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

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	4.021	0.059	0.038	0.033	0.078		Set Trigger
2	4.050	0.059	0.038	0.033	0.078		Set Trigger
3	4.055	0.059	0.037	0.033	0.079		Set Trigger
4	4.056	0.059	0.037	0.033	0.079		Set Trigger
5	4.026	0.058	0.037	0.033	0.077		Set Trigger

AVG 4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693304.__0

FILE DATE AND TIME: 10/17/2007 14:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

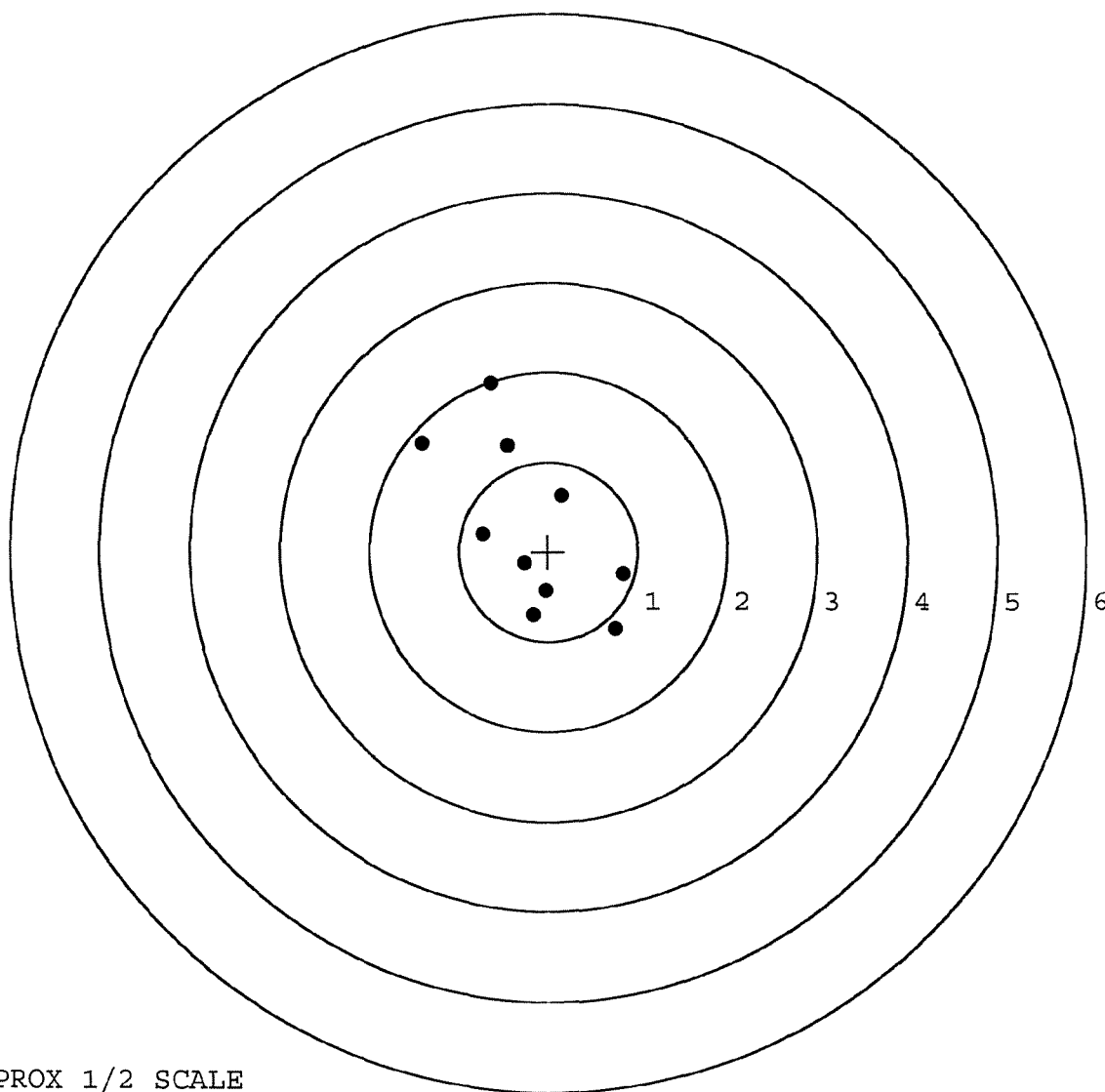
The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	0.006
The Average Point of Impact of the Five Target Set:	0.017
The Average Mean Radius of the Five Target Set:	0.862
The Distance from POA to Centroid Target #1:	0.334
The Distance from Centroid Target #2 to Centroid Target #1:	0.421
The Distance from Centroid Target #3 to Centroid Target #1:	0.318
The Distance from Centroid Target #4 to Centroid Target #1:	0.501
The Distance from Centroid Target #5 to Centroid Target #1:	0.463

BARBER - M24 0177507

SERIAL NUMBER: G6693304. __0
 TARGET NUMBER: 1
 FILE DATE: 10/17/2007
 FILE TIME: 14:39

POINT#	X	Y
1:	0.841	-0.248
2:	0.751	-0.865
3:	-0.029	-0.436
4:	-0.167	-0.710
5:	-0.266	-0.132
6:	-0.740	0.200
7:	0.152	0.629
8:	-0.454	1.183
9:	-0.642	1.876
10:	-1.409	1.204

X CENTROID: -0.196
 Y CENTROID: 0.270
 POA TO CENTROID: 0.334
 HORZ SPREAD: 2.250
 VERT SPREAD: 2.741
 GROUP SPREAD: 3.075
 MIN RADIUS: 0.408
 MAX RADIUS: 1.667
 MEAN RADIUS: 0.995
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0177508

SERIAL NUMBER: G6693304. __0

TARGET NUMBER: 2

FILE DATE: 10/17/2007

FILE TIME: 14:39

POINT#	X	Y
1:	1.409	-0.348
2:	1.244	-0.159
3:	0.487	-0.925
4:	0.008	0.111
5:	-0.650	0.501
6:	-0.477	0.917
7:	-0.954	0.982
8:	0.211	-0.458
9:	-0.241	-0.346
10:	-0.061	-0.583

X CENTROID: 0.098

Y CENTROID: -0.031

POA TO CENTROID: 0.102

HORZ SPREAD: 2.363

VERT SPREAD: 1.907

GROUP SPREAD: 2.712

MIN RADIUS: 0.168

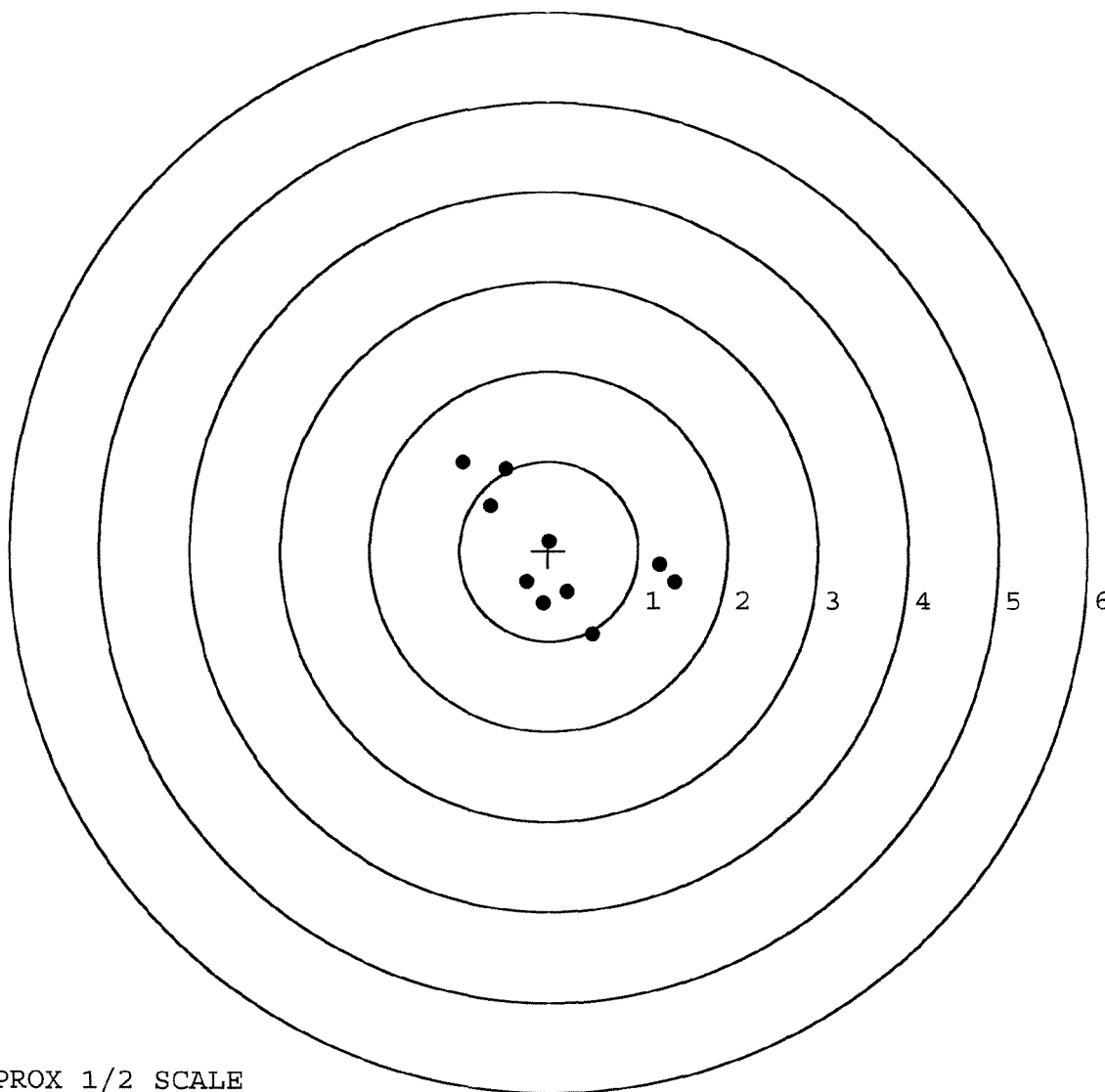
MAX RADIUS: 1.460

MEAN RADIUS: 0.861

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



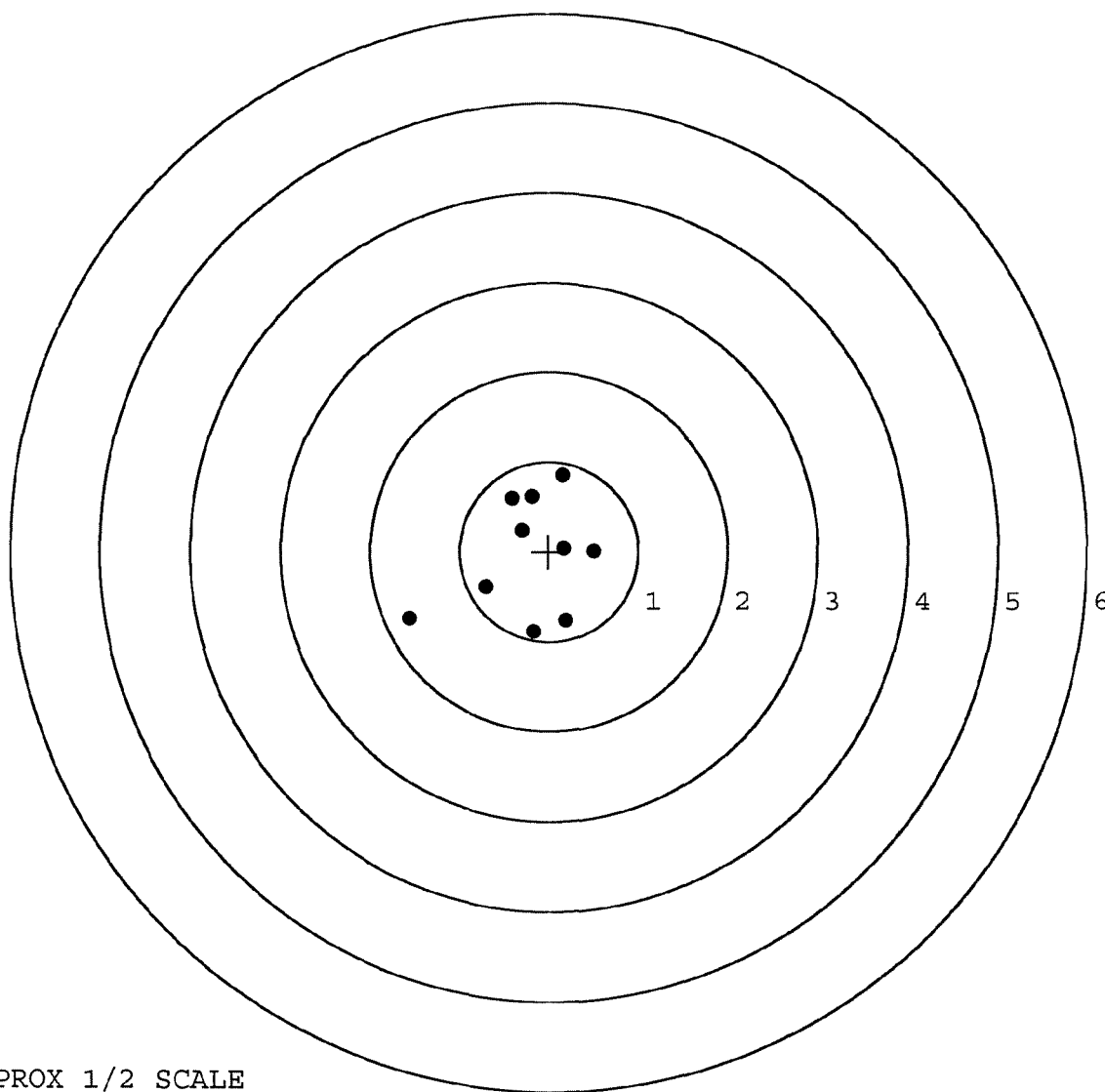
TARGET APPROX 1/2 SCALE

BARBER - M24 0177509

SERIAL NUMBER: G6693304. __0
 TARGET NUMBER: 3
 FILE DATE: 10/17/2007
 FILE TIME: 14:39

POINT#	X	Y
1:	0.188	-0.767
2:	-0.180	-0.896
3:	-0.706	-0.397
4:	-1.561	-0.748
5:	0.512	0.008
6:	0.172	0.039
7:	0.159	0.851
8:	-0.188	0.615
9:	-0.409	0.598
10:	-0.303	0.236

X CENTROID: -0.232
 Y CENTROID: -0.046
 POA TO CENTROID: 0.236
 HORZ SPREAD: 2.073
 VERT SPREAD: 1.747
 GROUP SPREAD: 2.348
 MIN RADIUS: 0.291
 MAX RADIUS: 1.503
 MEAN RADIUS: 0.754
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0177510

SERIAL NUMBER: G6693304. __0

TARGET NUMBER: 4

FILE DATE: 10/17/2007

FILE TIME: 14:39

POINT#	X	Y
1:	1.040	-1.347
2:	1.002	-0.453
3:	0.613	-0.208
4:	0.441	0.211
5:	-0.452	-1.004
6:	-0.534	-0.324
7:	-0.499	-0.174
8:	-0.517	0.233
9:	-0.197	0.487
10:	-0.073	1.122

X CENTROID: 0.082

Y CENTROID: -0.146

POA TO CENTROID: 0.167

HORZ SPREAD: 1.574

VERT SPREAD: 2.469

GROUP SPREAD: 2.708

MIN RADIUS: 0.506

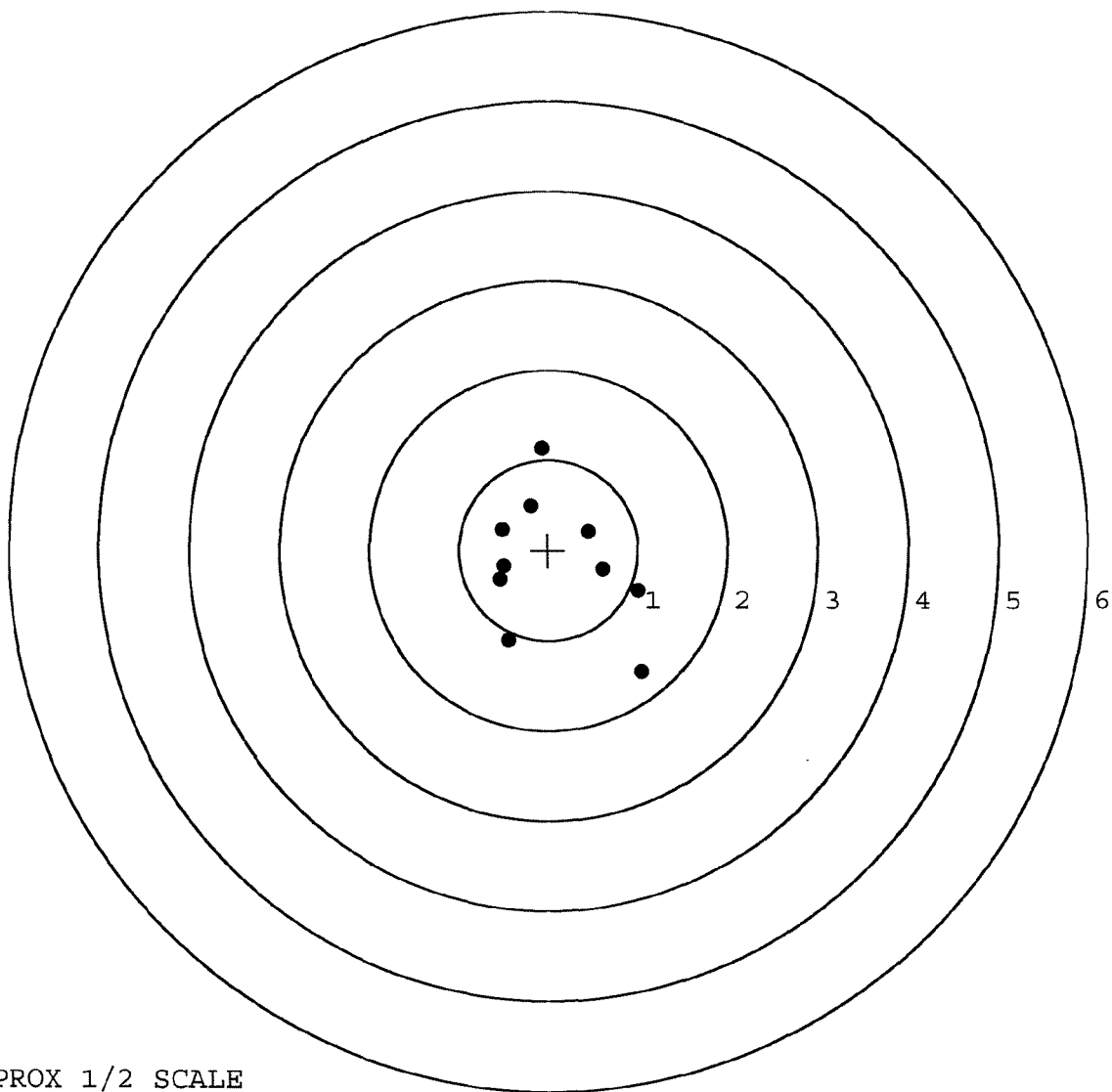
MAX RADIUS: 1.536

MEAN RADIUS: 0.846

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0177511

SERIAL NUMBER: G6693304. __0

TARGET NUMBER: 5

FILE DATE: 10/17/2007

FILE TIME: 14:39

POINT#	X	Y
1:	1.183	-1.294
2:	0.957	-0.535
3:	0.546	-0.218
4:	-0.040	0.017
5:	-0.305	0.250
6:	-0.266	0.023
7:	-0.647	-0.099
8:	-0.476	-0.420
9:	-0.551	0.673
10:	1.253	1.416

X CENTROID: 0.165

Y CENTROID: -0.019

POA TO CENTROID: 0.166

HORZ SPREAD: 1.900

VERT SPREAD: 2.710

GROUP SPREAD: 2.711

MIN RADIUS: 0.208

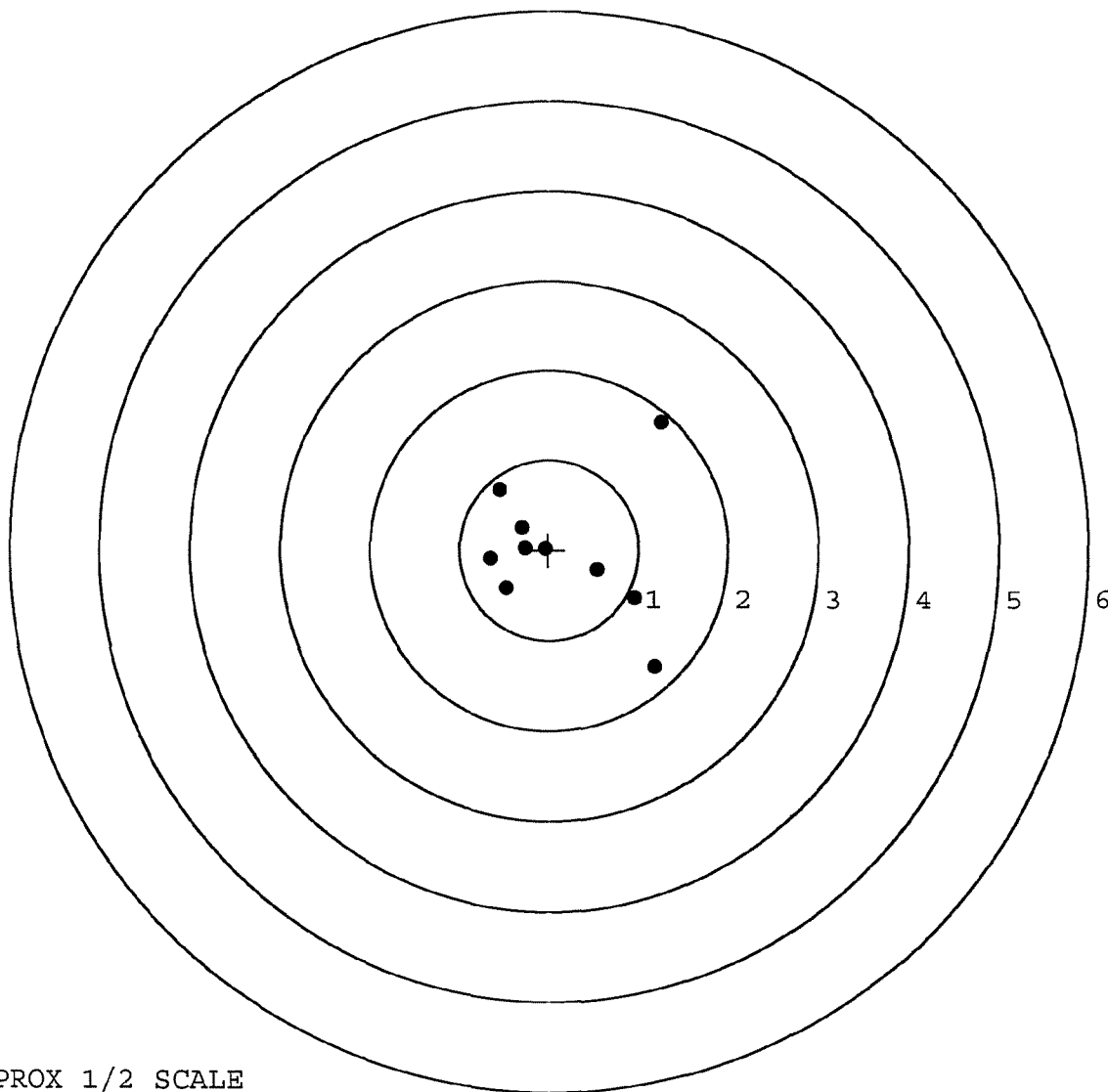
MAX RADIUS: 1.800

MEAN RADIUS: 0.856

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE