

Q6693334

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

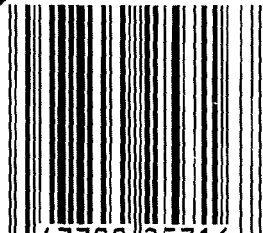
G6693334



ORDER — 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC

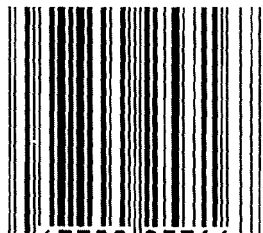


0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



0 47700 25716 7

SERIAL NO.



66693334

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6693334

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10/9/07	SPD
420	ASSEMBLE ACTION		10-8-07	SD
430	ASSEMBLE TO STOCK		10-8-07	SD
440	PROOF	MAGNA - FLUX	10/8/07	mm
460	CHECK HEADSPACE		10/8/07	mm
470	DIS-ASSEMBLE ACTION		10-8-07	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	10/11/07	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-07	CW
510	DRILL AND TAP SIGHT HOLES		10-10-07	TRW
520	GOFF BLAST BBL / REC		10-12-07	My
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/12/07	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/25/07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/25/07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/25/07	SPD
	D) OIL FIRING PIN ASSEMBLY		10/25/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/29/07	mm

F004 REV 5/2006

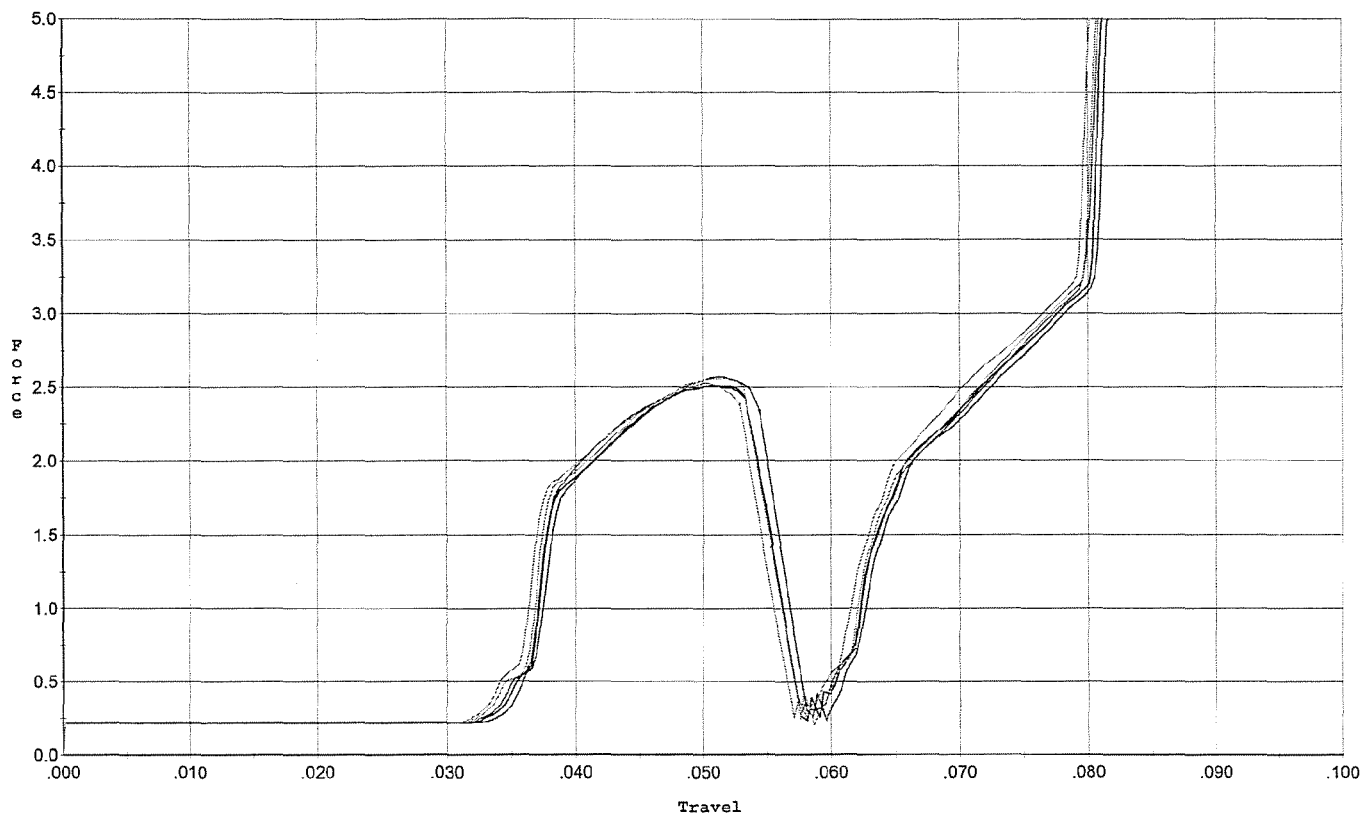
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.25</u> <u>5.0</u> <u>5.75</u>	10/29/07	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10/29/07	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		10/29/07	mm
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10/29/07	mm
	J) ASSEMBLE STOCK		10/29/07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		10/29/07	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10/29/07	mm
	M) IRON SIGHT ALIGNMENT		10/29/07	mm
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10/29/07	mm
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	10/29/07	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-26-07	SD
670	FINAL INSPECTION A) HEADSPACE		10/29/07	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.26</u> <u>2.34</u> <u>2.23</u> <u>2.30</u>	10/29/07	mm
	C) FUNCTION		10/29/07	mm
690	PACK		10/30/07	mm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/07

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



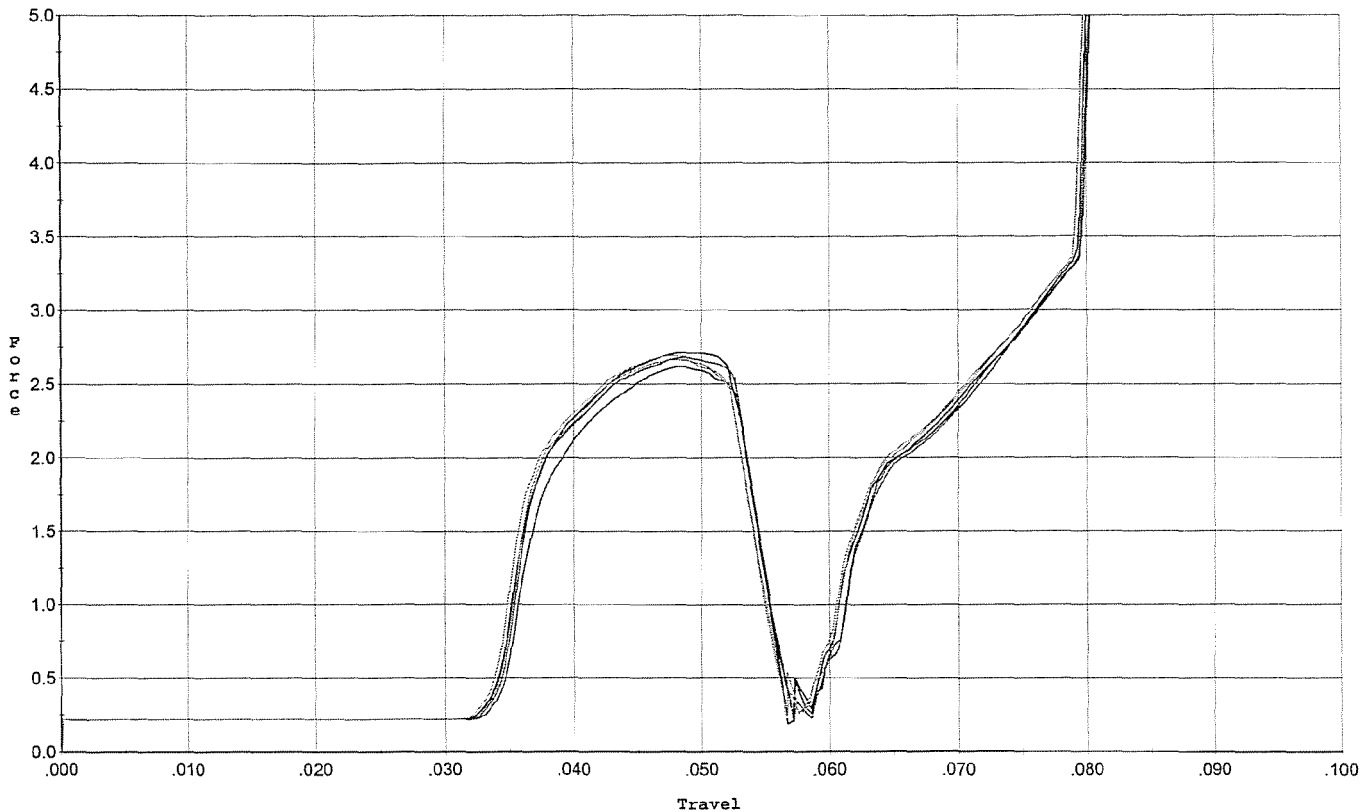
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.054	0.035	0.033	0.049		Set Trigger
2	2.516	0.055	0.035	0.033	0.048		Set Trigger
3	2.511	0.055	0.035	0.033	0.049		Set Trigger
4	2.561	0.055	0.034	0.033	0.050		Set Trigger
5	2.528	0.053	0.033	0.033	0.047		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/07

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



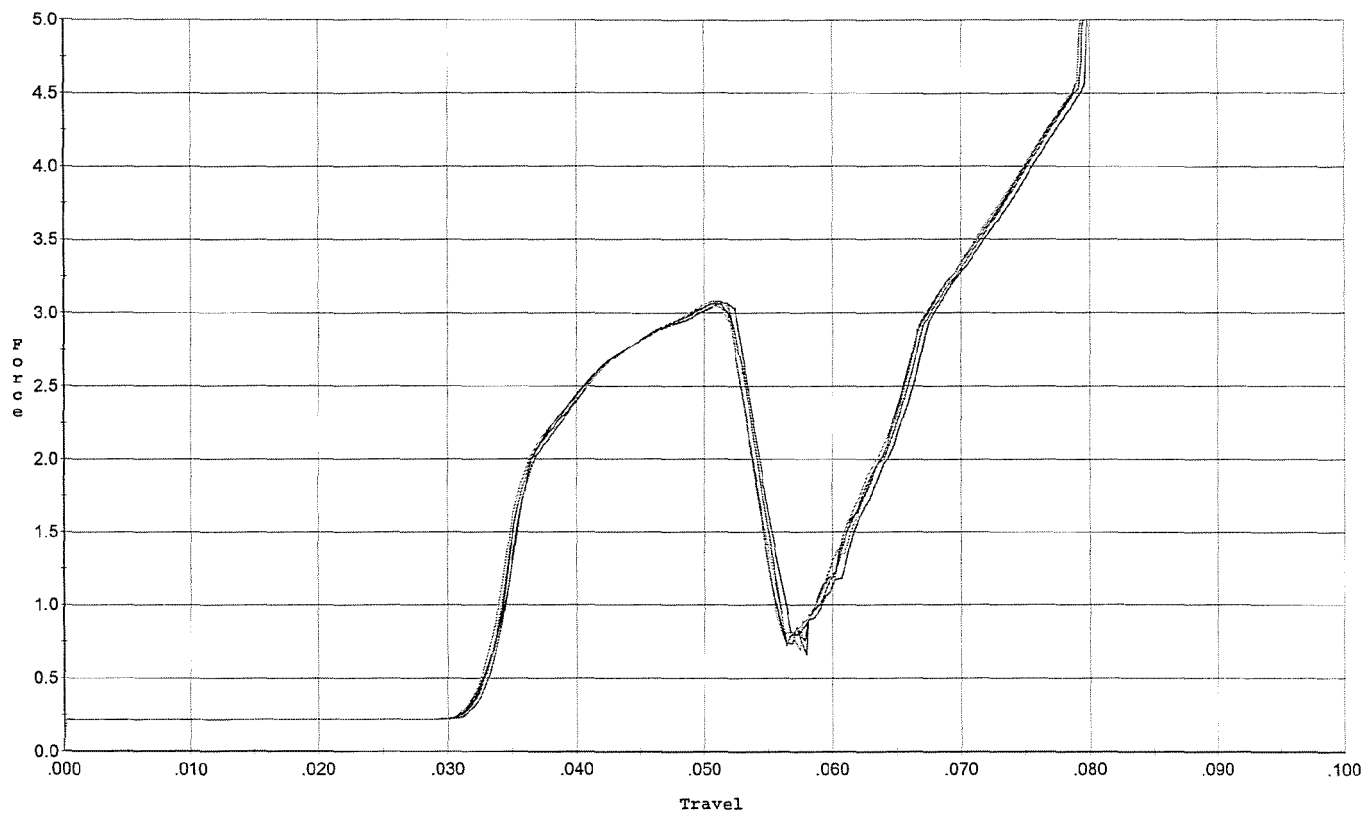
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.053	0.034	0.033	0.049		Set Trigger
2	2.712	0.053	0.033	0.033	0.052		Set Trigger
3	2.680	0.053	0.034	0.033	0.051		Set Trigger
4	2.693	0.052	0.033	0.033	0.051		Set Trigger
5	2.664	0.052	0.033	0.033	0.050		Set Trigger

AVG 2.67

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/07

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



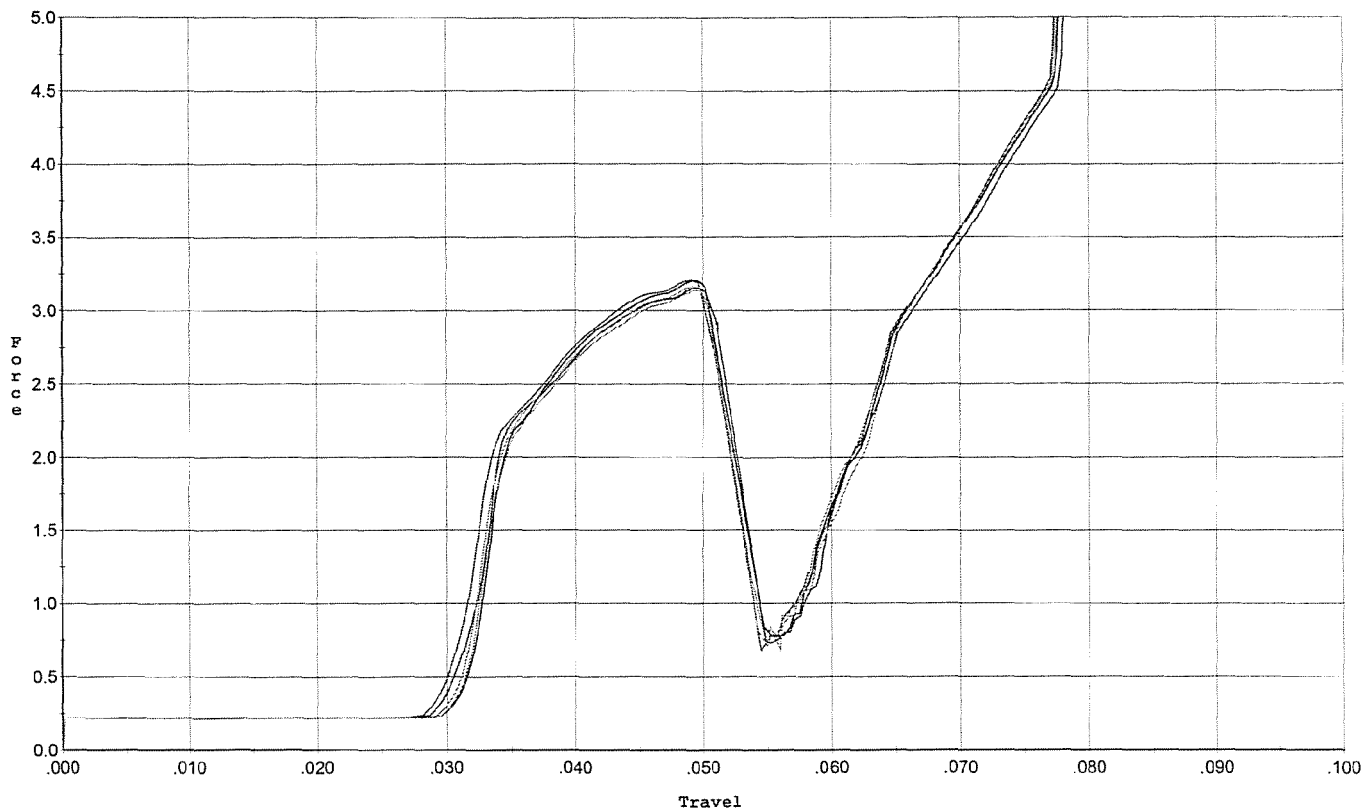
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.065	0.052	0.032	0.032	0.057		Set Trigger
2	3.064	0.052	0.032	0.032	0.056		Set Trigger
3	3.074	0.053	0.033	0.032	0.058		Set Trigger
4	3.044	0.052	0.032	0.032	0.056		Set Trigger
5	3.082	0.052	0.032	0.032	0.057		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/07

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



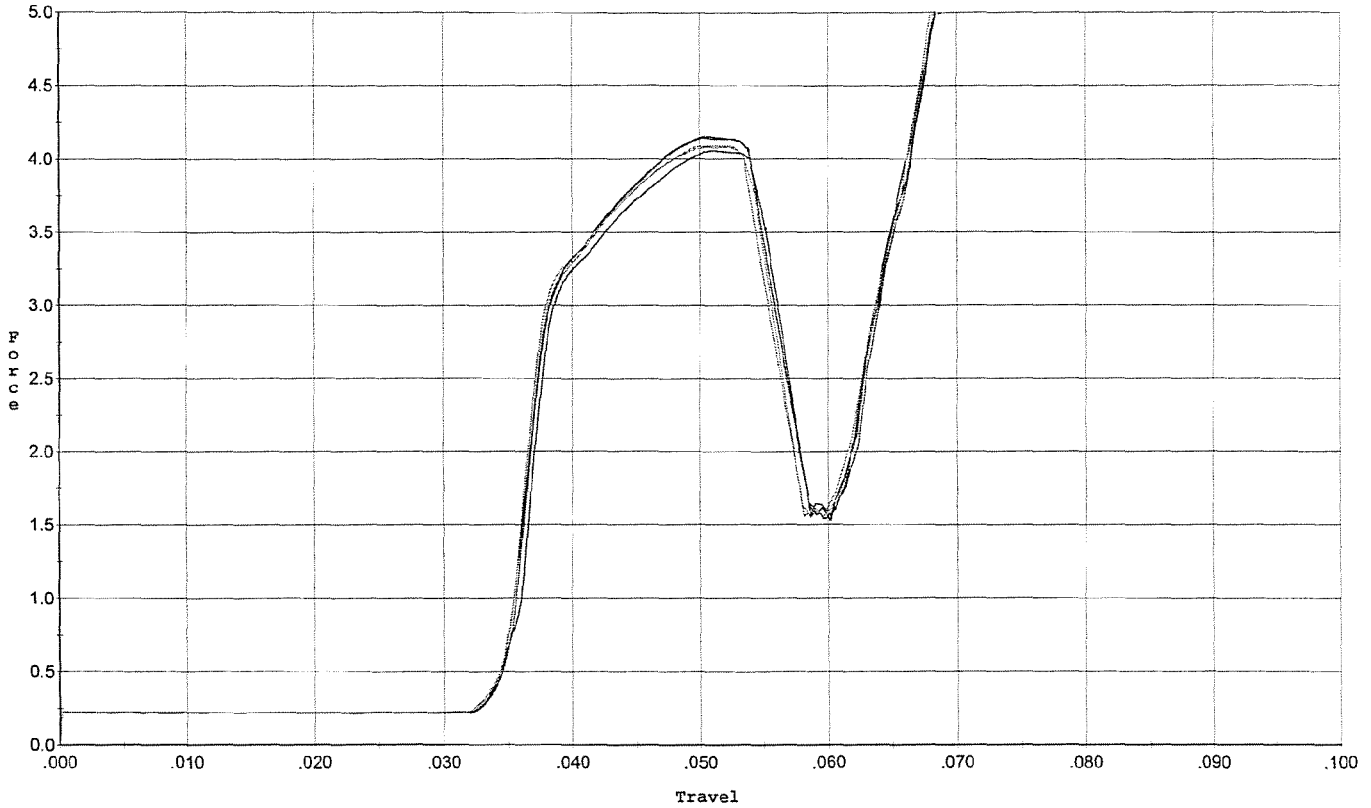
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.151	0.051	0.030	0.031	0.060		Set Trigger
2	3.204	0.052	0.031	0.031	0.061		Set Trigger
3	3.207	0.051	0.029	0.031	0.061		Set Trigger
4	3.164	0.050	0.031	0.031	0.058		Set Trigger
5	3.137	0.050	0.031	0.032	0.057		Set Trigger

Avg 3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/07

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



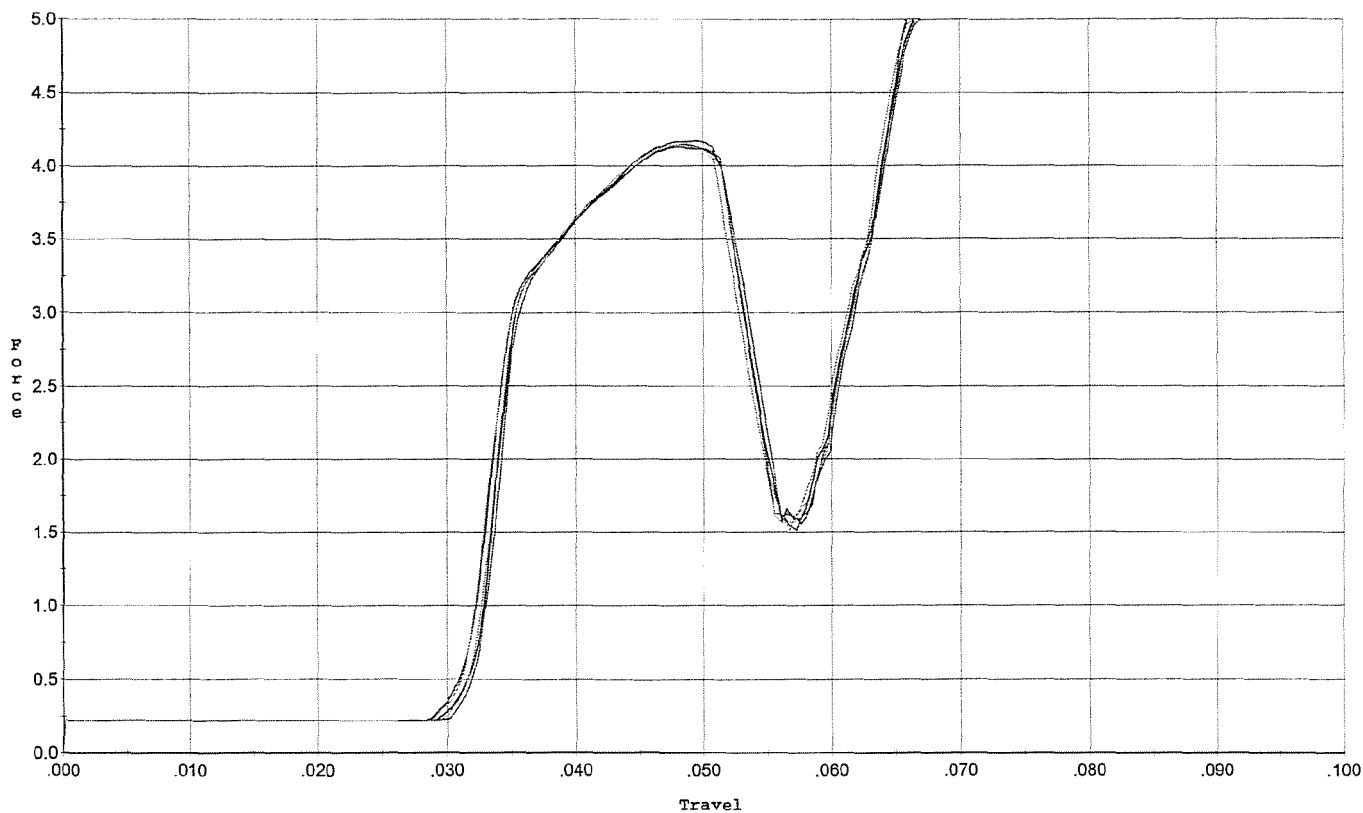
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.057	0.055	0.034	0.026	0.079		Set Trigger
2	4.154	0.054	0.033	0.028	0.078		Set Trigger
3	4.139	0.054	0.034	0.028	0.078		Set Trigger
4	4.080	0.054	0.034	0.027	0.078		Set Trigger
5	4.092	0.053	0.034	0.028	0.076		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/07

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



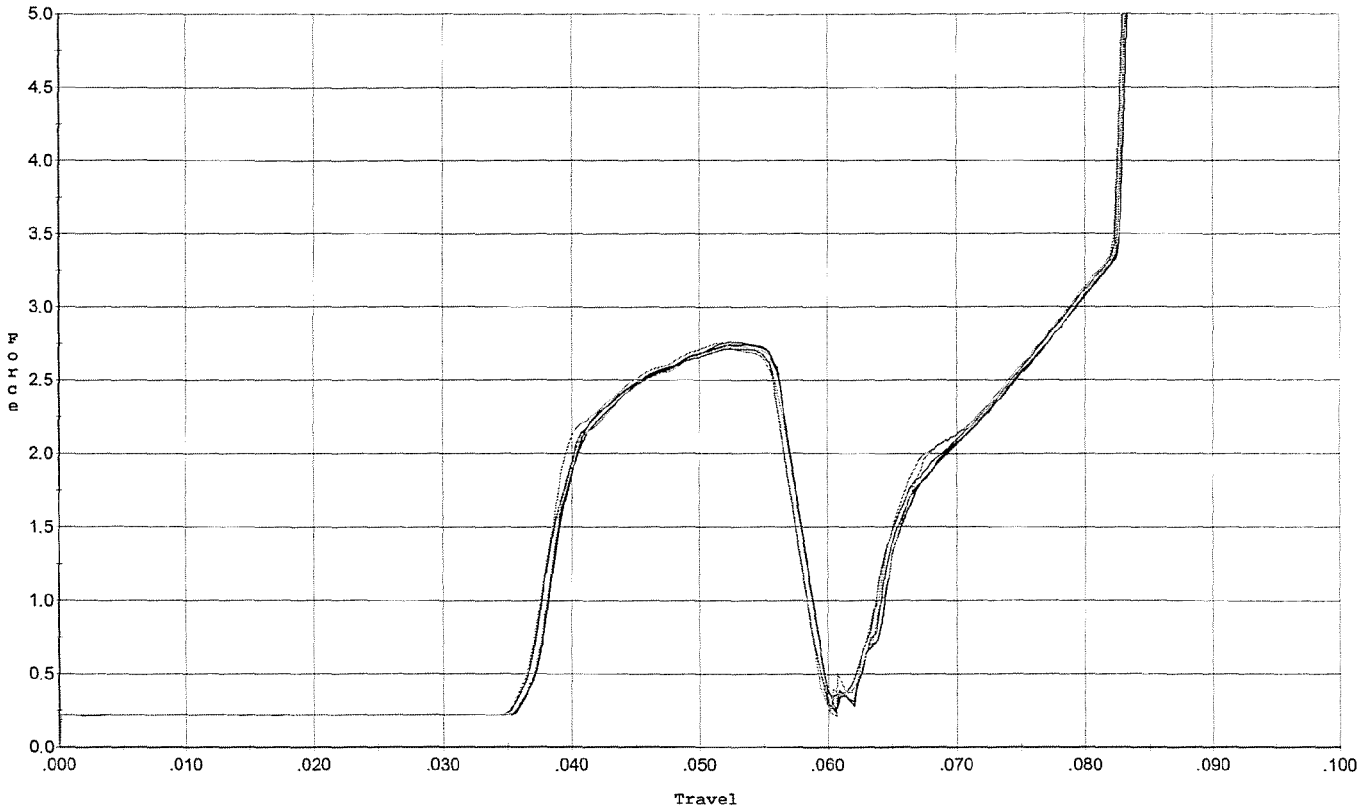
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.051	0.030	0.027	0.080		Set Trigger
2	4.132	0.051	0.031	0.028	0.078		Set Trigger
3	4.149	0.053	0.031	0.028	0.081		Set Trigger
4	4.136	0.051	0.031	0.028	0.078		Set Trigger
5	4.147	0.051	0.031	0.028	0.079		Set Trigger

Avg 4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/07

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



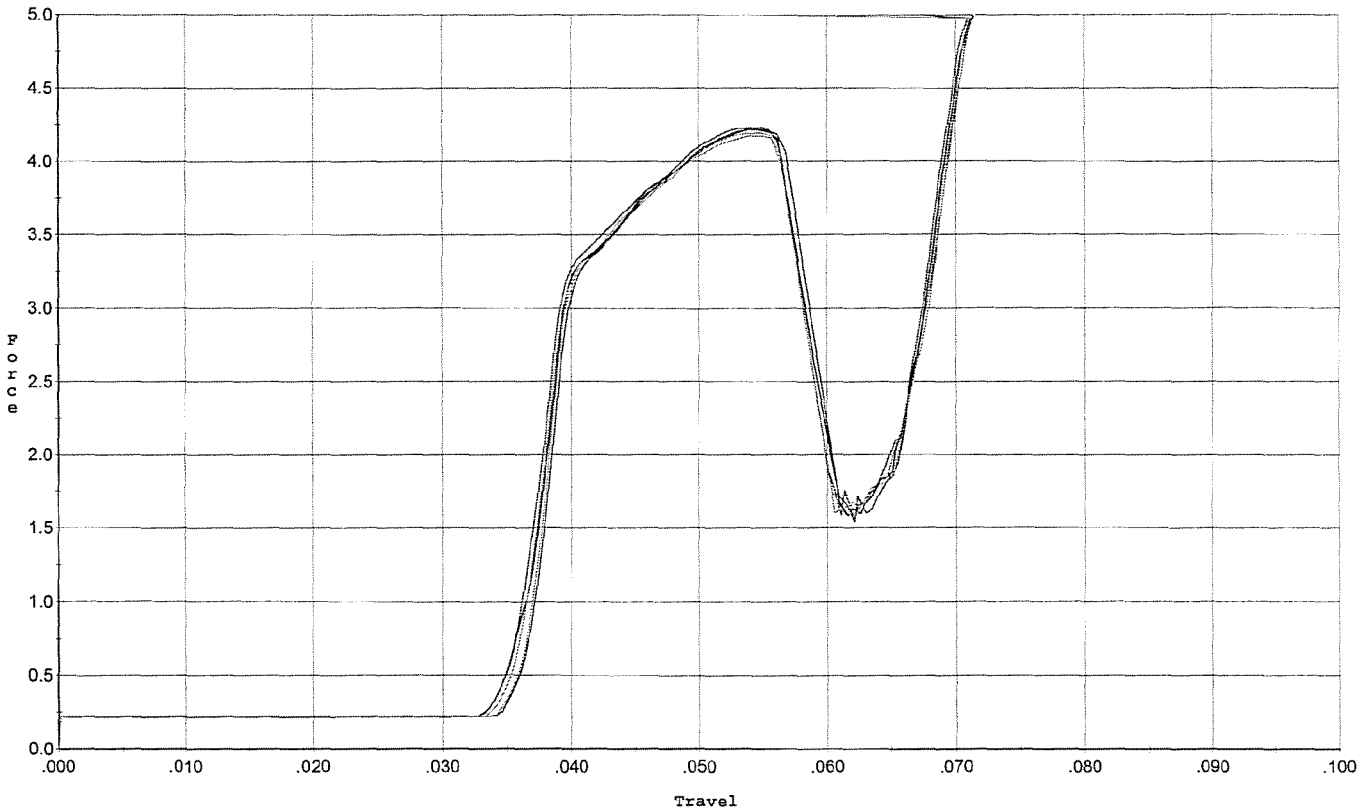
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.758	0.056	0.036	0.033	0.054		Set Trigger
2	2.741	0.056	0.036	0.033	0.054		Set Trigger
3	2.714	0.056	0.036	0.033	0.054		Set Trigger
4	2.756	0.056	0.036	0.033	0.055		Set Trigger
5	2.733	0.057	0.036	0.033	0.055		Set Trigger

AVG 2.74

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/07

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	4.218	0.057	0.035	0.026	0.084		Set Trigger
2	4.219	0.056	0.034	0.027	0.084		Set Trigger
3	4.231	0.056	0.034	0.026	0.085		Set Trigger
4	4.195	0.056	0.034	0.026	0.084		Set Trigger
5	4.175	0.056	0.035	0.026	0.083		Set Trigger

AVG 4.20

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693334.___0
FILE DATE AND TIME: 10/26/2007 22:45

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

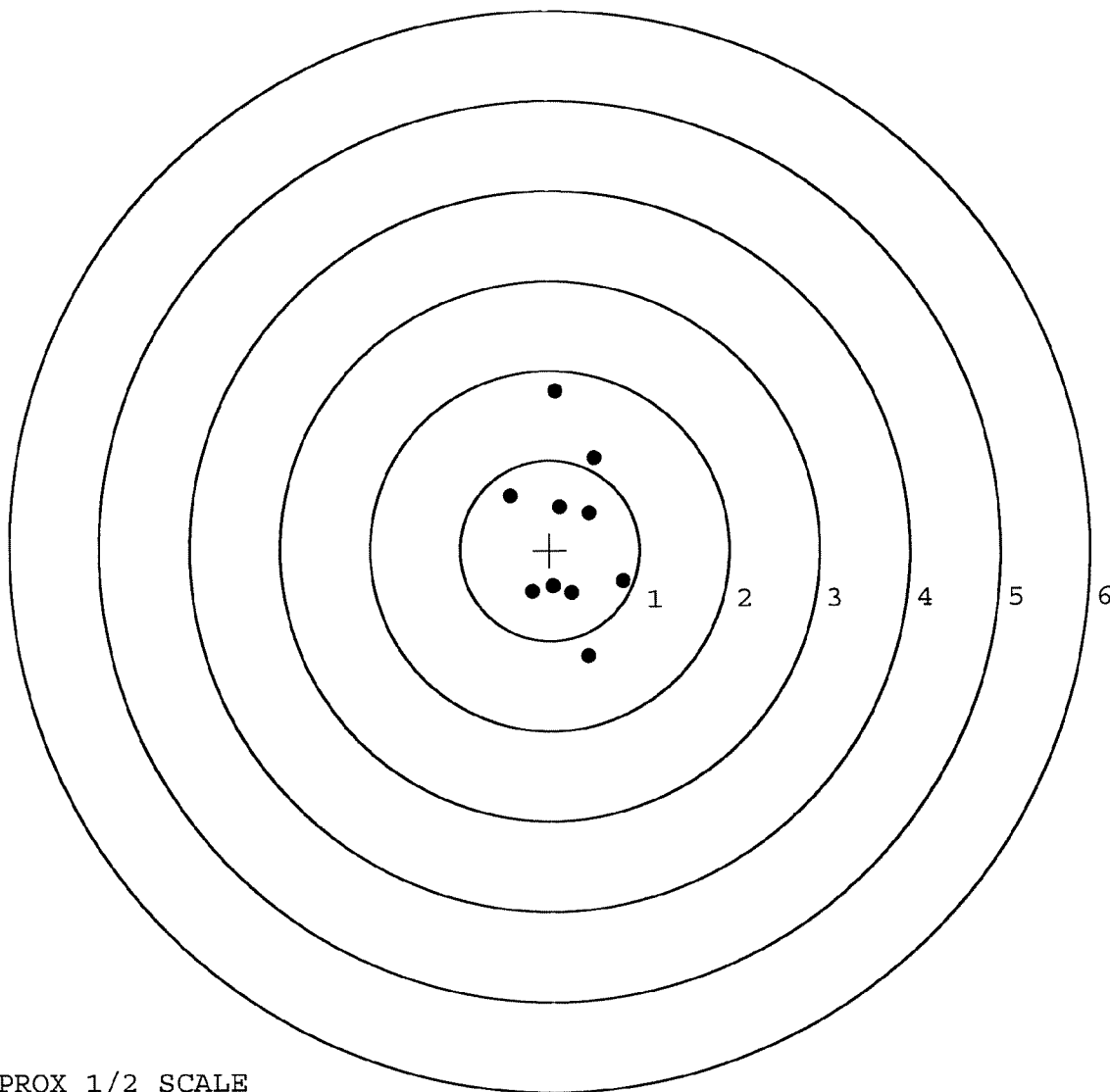
The Average X Centroid of the Five Target Set:	0.107
The Average Y Centroid of the Five Target Set:	0.009
The Average Point of Impact of the Five Target Set:	0.107
The Average Mean Radius of the Five Target Set:	0.636
The Distance from POA to Centroid Target #1:	0.247
The Distance from Centroid Target #2 to Centroid Target #1:	0.130
The Distance from Centroid Target #3 to Centroid Target #1:	0.241
The Distance from Centroid Target #4 to Centroid Target #1:	0.233
The Distance from Centroid Target #5 to Centroid Target #1:	0.270

BARBER - M24 0178070

SERIAL NUMBER: G6693334. __0
 TARGET NUMBER: 1
 FILE DATE: 10/26/2007
 FILE TIME: 22:45

POINT#	X	Y
1:	-0.437	0.602
2:	0.117	0.475
3:	0.441	0.412
4:	0.815	-0.350
5:	0.421	-1.176
6:	0.245	-0.479
7:	0.034	-0.403
8:	-0.195	-0.464
9:	0.504	1.026
10:	0.078	1.769

X CENTROID: 0.202
 Y CENTROID: 0.141
 POA TO CENTROID: 0.247
 HORZ SPREAD: 1.252
 VERT SPREAD: 2.945
 GROUP SPREAD: 2.965
 MIN RADIUS: 0.345
 MAX RADIUS: 1.633
 MEAN RADIUS: 0.810
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



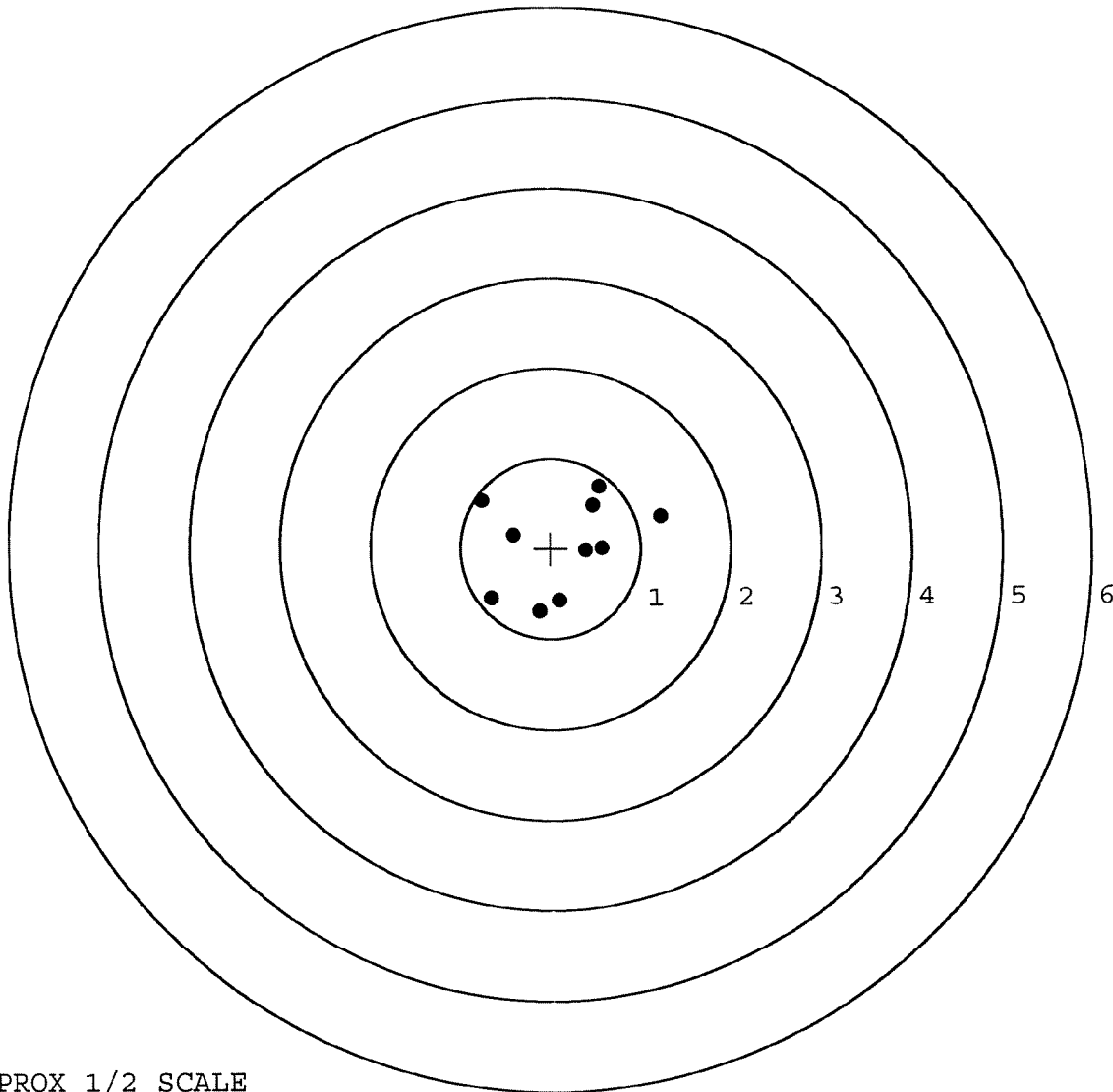
TARGET APPROX 1/2 SCALE

BARBER - M24 0178071

SERIAL NUMBER: G6693334. __0
TARGET NUMBER: 2
FILE DATE: 10/26/2007
FILE TIME: 22:45

POINT#	X	Y
1:	0.473	0.478
2:	0.543	0.681
3:	1.220	0.347
4:	0.570	0.004
5:	0.387	-0.022
6:	0.094	-0.584
7:	-0.129	-0.705
8:	-0.664	-0.558
9:	-0.420	0.153
10:	-0.763	0.532

X CENTROID: 0.131
Y CENTROID: 0.033
POA TO CENTROID: 0.135
HORZ SPREAD: 1.983
VERT SPREAD: 1.386
GROUP SPREAD: 2.090
MIN RADIUS: 0.262
MAX RADIUS: 1.133
MEAN RADIUS: 0.714
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0178072

SERIAL NUMBER: G6693334. 0

TARGET NUMBER: 3

FILE DATE: 10/26/2007

FILE TIME: 22:45

POINT#	X	Y
1:	0.422	-0.511
2:	0.661	-0.885
3:	-0.323	0.124
4:	-0.582	0.012
5:	-0.365	-0.166
6:	-0.312	-0.421
7:	0.212	-0.103
8:	0.214	0.269
9:	0.327	0.425
10:	0.614	0.557

X CENTROID: 0.087

Y CENTROID: -0.070

POA TO CENTROID: 0.111

HORZ SPREAD: 1.243

VERT SPREAD: 1.442

GROUP SPREAD: 1.533

MIN RADIUS: 0.130

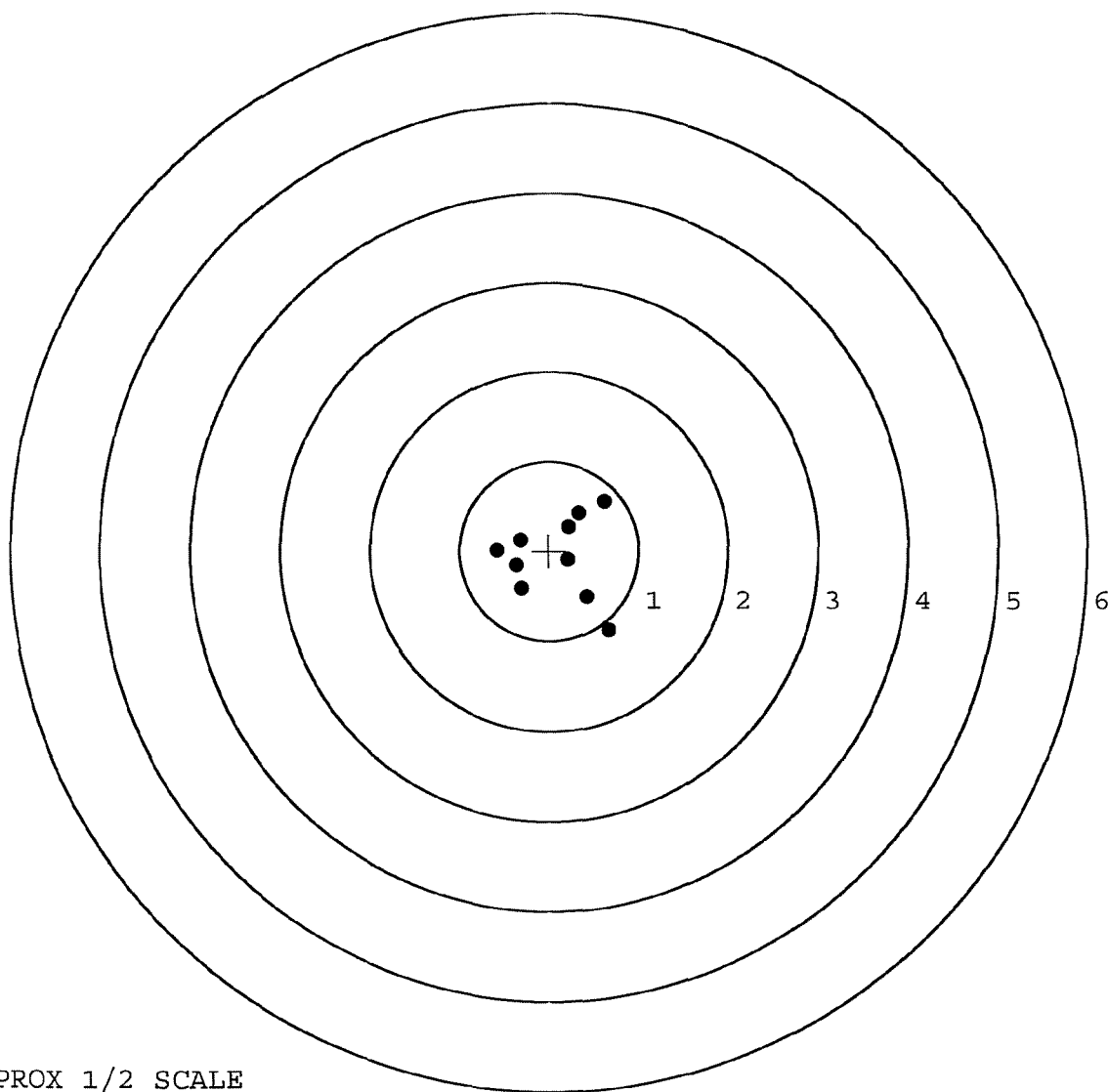
MAX RADIUS: 0.997

MEAN RADIUS: 0.553

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0178073

SERIAL NUMBER: G6693334. 0

TARGET NUMBER: 4

FILE DATE: 10/26/2007

FILE TIME: 22:45

POINT#	X	Y
1:	0.488	0.120
2:	0.479	-0.249
3:	0.021	-0.555
4:	-0.059	-0.326
5:	-0.069	0.065
6:	-0.526	-0.209
7:	-0.341	0.668
8:	-0.166	0.622
9:	0.142	0.616
10:	-0.120	-0.170

X CENTROID: -0.015

Y CENTROID: 0.058

POA TO CENTROID: 0.060

HORZ SPREAD: 1.014

VERT SPREAD: 1.223

GROUP SPREAD: 1.275

MIN RADIUS: 0.054

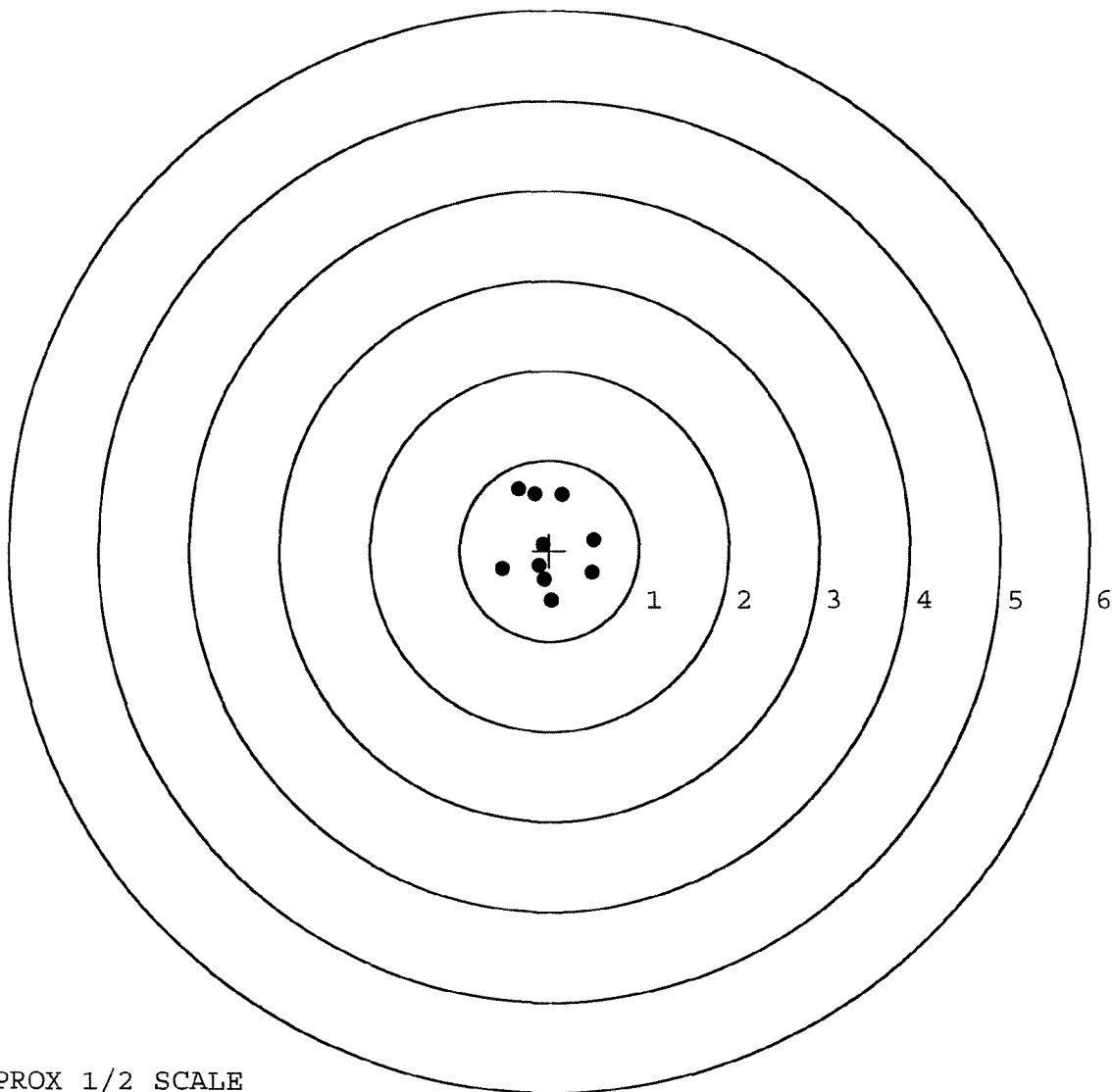
MAX RADIUS: 0.691

MEAN RADIUS: 0.483

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0178074

SERIAL NUMBER: G6693334. __0

TARGET NUMBER: 5

FILE DATE: 10/26/2007

FILE TIME: 22:45

POINT#	X	Y
1:	-0.069	0.785
2:	0.130	1.117
3:	-0.466	-0.158
4:	0.839	0.033
5:	0.766	-0.883
6:	0.148	-0.530
7:	0.176	-0.108
8:	-0.093	-0.283
9:	0.006	-0.492
10:	-0.144	-0.666

X CENTROID: 0.129

Y CENTROID: -0.118

POA TO CENTROID: 0.175

HORZ SPREAD: 1.305

VERT SPREAD: 2.000

GROUP SPREAD: 2.099

MIN RADIUS: 0.048

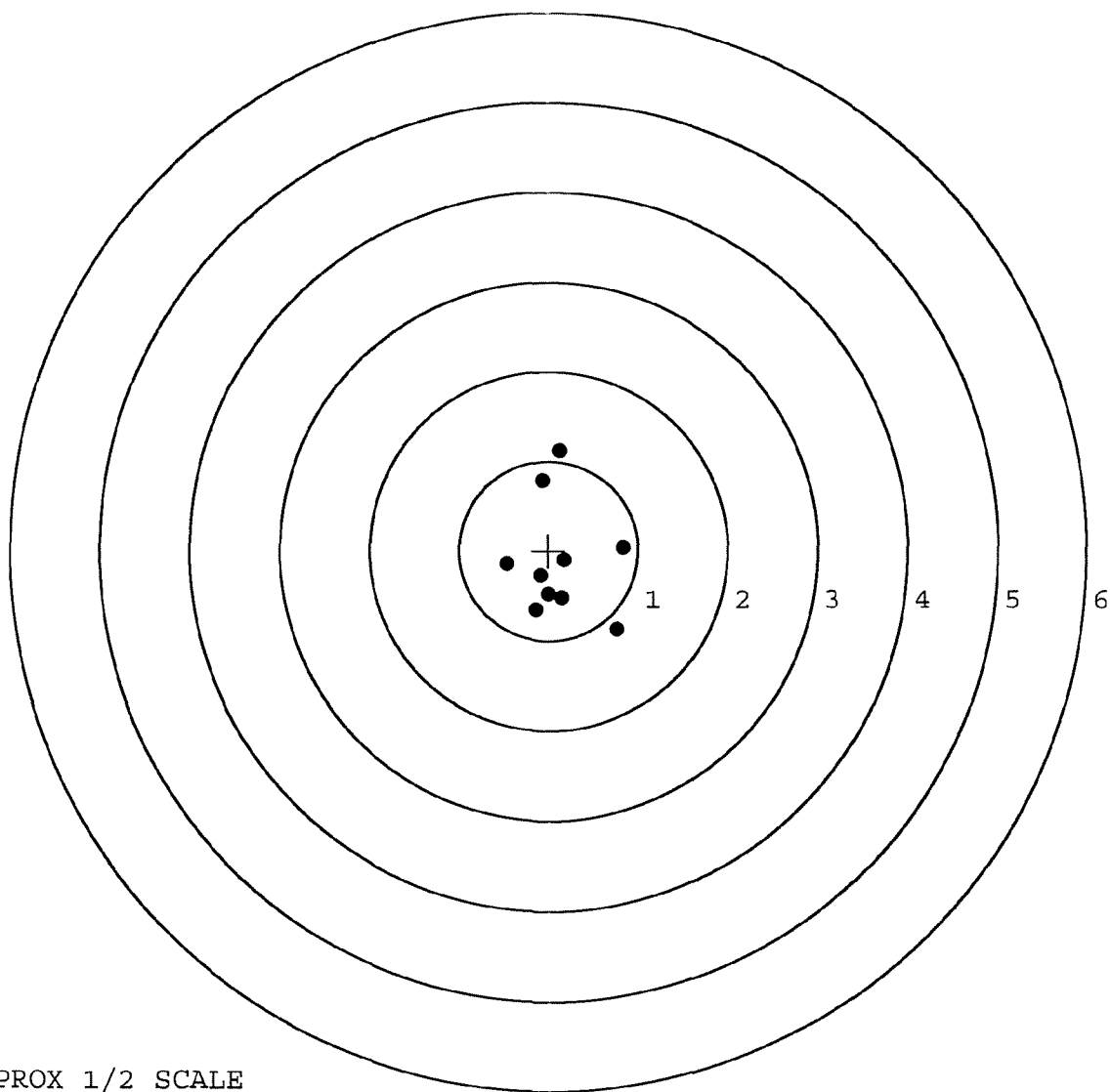
MAX RADIUS: 1.236

MEAN RADIUS: 0.622

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE