

018699810

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

— INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



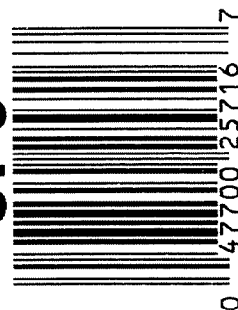
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6699810

UPC



GUN SERIAL # 66699810

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-4-08	RT
420	ASSEMBLE ACTION		3-4-08	RT
430	ASSEMBLE TO STOCK		3-4-08	TRW
440	PROOF	MAGNA - FLUX	3-4-08	TRW
460	CHECK HEADSPACE	0.008	3-4-08	TRW
470	DIS-ASSEMBLE ACTION		3-5-08	TRW
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mmms</u>	3/6/07	mmms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-5-08	CW
510	DRILL AND TAP SIGHT HOLES		3-5-08	TRW
520	GOFF BLAST BBL / REC		3-7-08	DL
530 & 540	APPLY COATINGS (BARREL ACTION)		3-17-08	CW
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-18-08	Fm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-18-08	Fm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-18-08	Fm
	D) OIL FIRING PIN ASSEMBLY		3-20-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

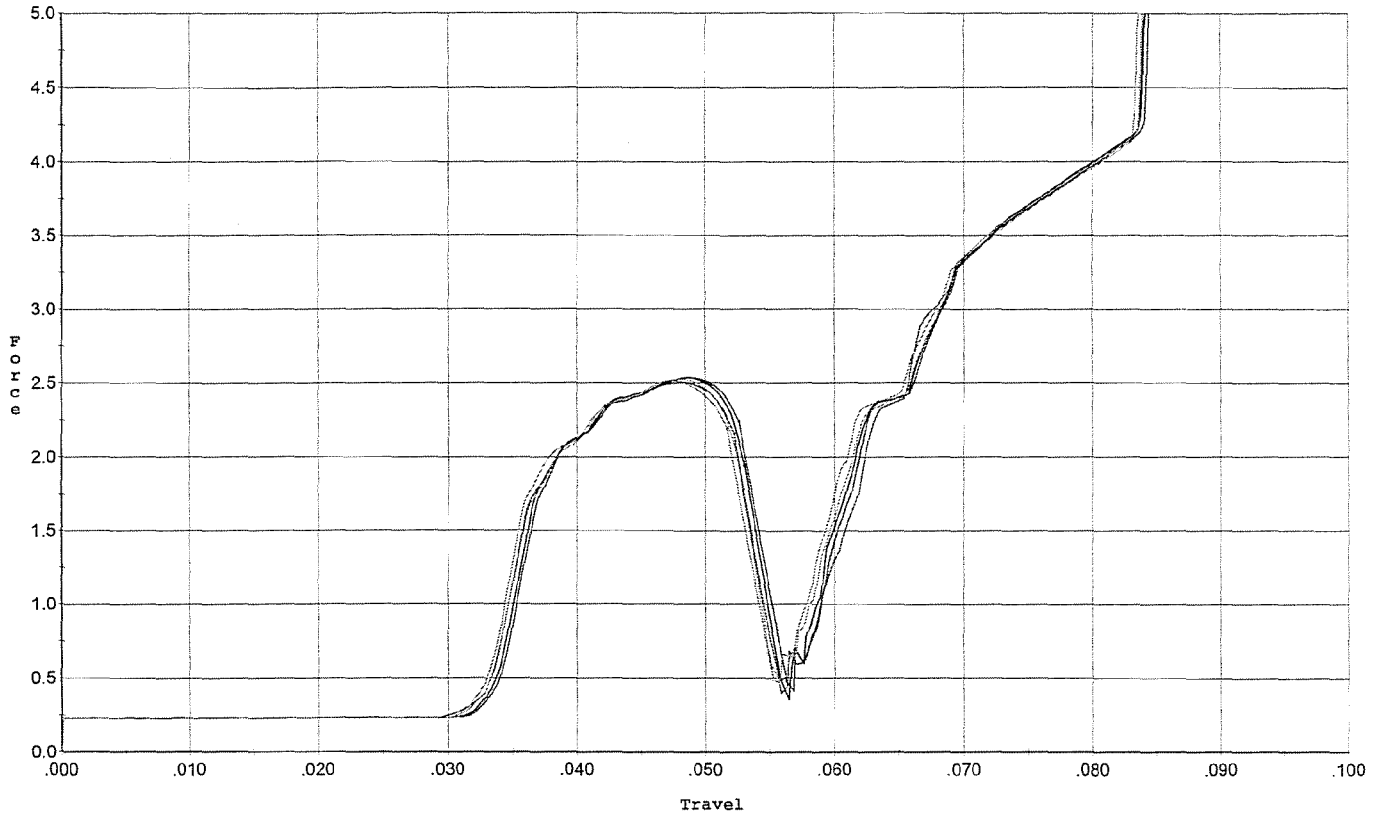
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2 1/2 lb.</u> <u>2 1/2 lb.</u> <u>2 1/2 lb.</u>	4-11-08	S.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lb.</u> <u>4 lb.</u> <u>4 lb.</u>	4-11-08	S.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	4-11-08	S.P.D.
	J) ASSEMBLE STOCK		3-20-08	RTL
	K) ASSEMBLE SWIVEL STUDS		4-11-08	S.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-11-08	S.P.D.
	M) IRON SIGHT ALIGNMENT		4-11-08	S.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-11-08	S.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-10-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-10-08	TRW
670	FINAL INSPECTION A) HEADSPACE		4-11-08	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.65</u> <u>2.50</u> <u>2.57</u> <u>2.62</u>	4-10-08	RTL
	C) FUNCTION		4-11-08	RTL
690	PACK		4/14/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



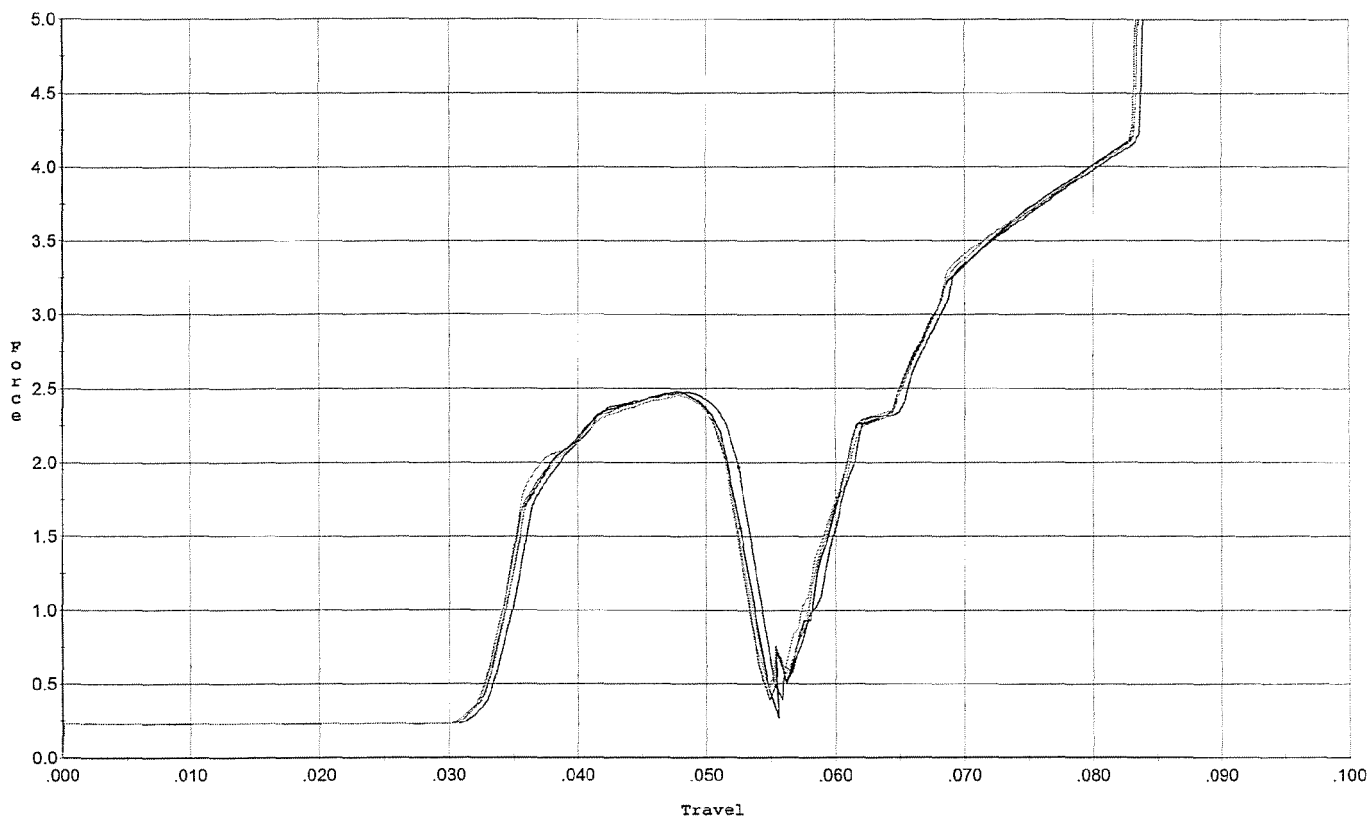
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.053	0.034	0.036	0.049		Set Trigger
2	2.534	0.053	0.033	0.036	0.049		Set Trigger
3	2.507	0.052	0.033	0.036	0.049		Set Trigger
4	2.524	0.052	0.033	0.036	0.049		Set Trigger
5	2.513	0.052	0.033	0.036	0.048		Set Trigger

AVG 2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



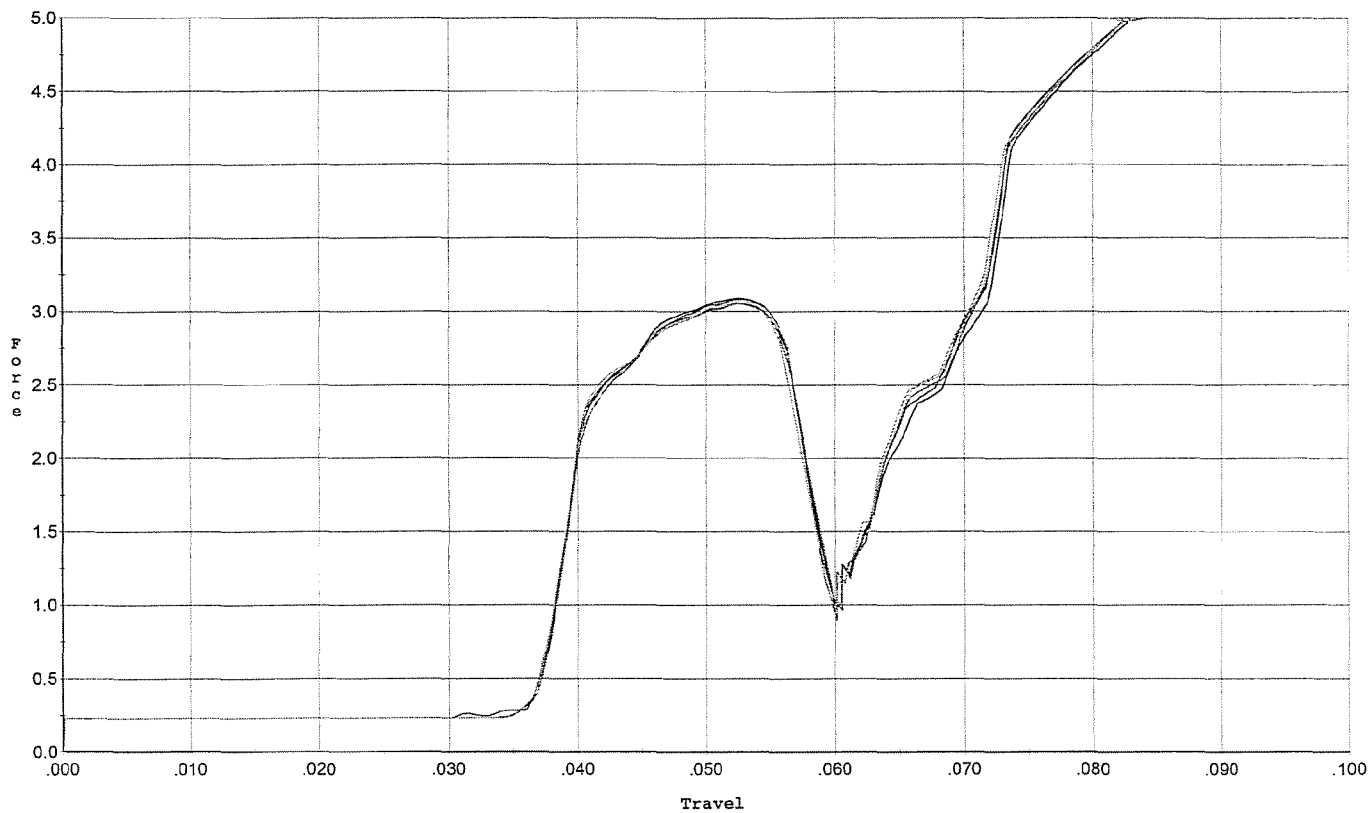
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.052	0.033	0.036	0.048		Set Trigger
2	2.468	0.053	0.033	0.036	0.048		Set Trigger
3	2.482	0.051	0.033	0.036	0.047		Set Trigger
4	2.457	0.051	0.033	0.036	0.046		Set Trigger
5	2.474	0.051	0.032	0.036	0.047		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/17/08

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



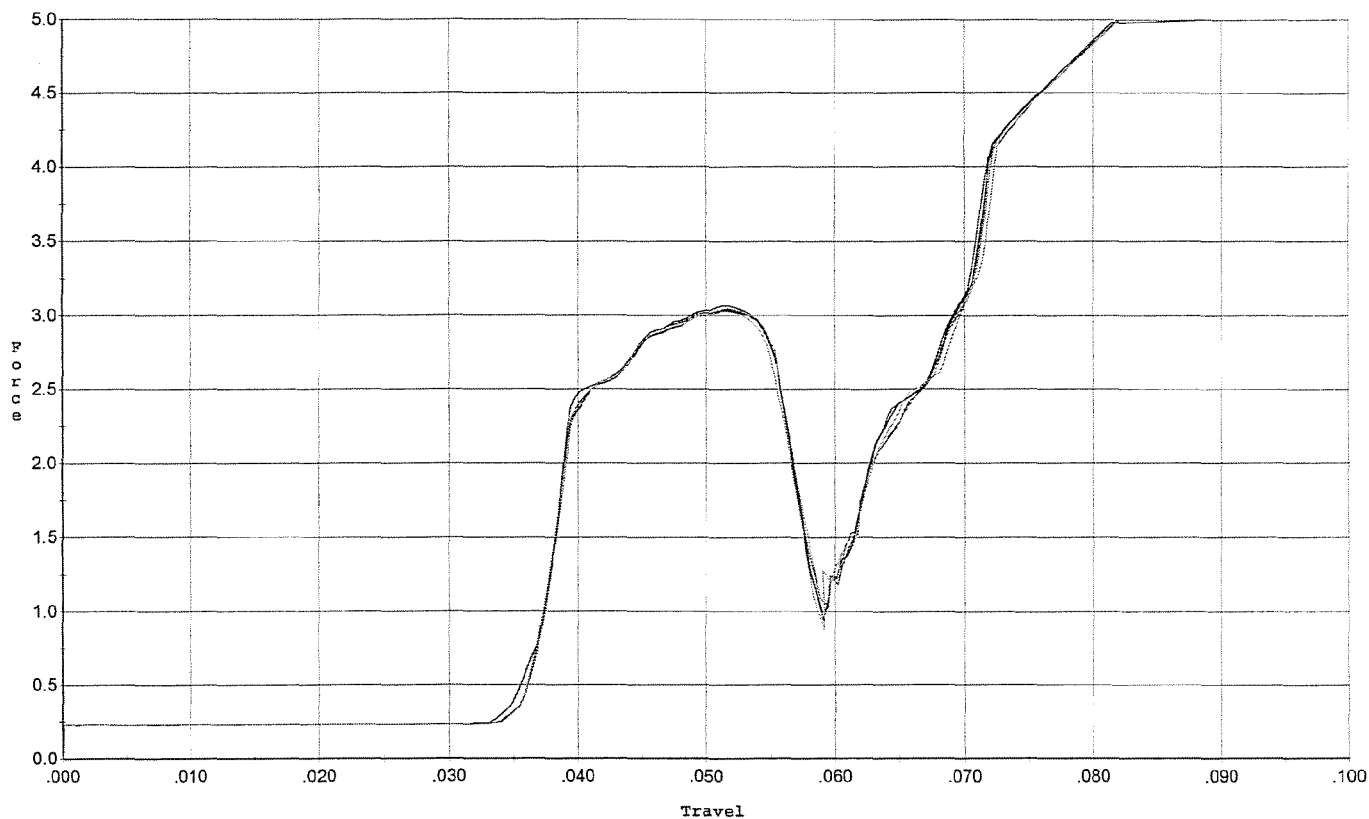
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.056	0.036	0.036	0.061		Set Trigger
2	3.088	0.056	0.037	0.036	0.061		Set Trigger
3	3.058	0.057	0.037	0.036	0.060		Set Trigger
4	3.078	0.056	0.037	0.036	0.060		Set Trigger
5	3.053	0.057	0.037	0.036	0.061		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



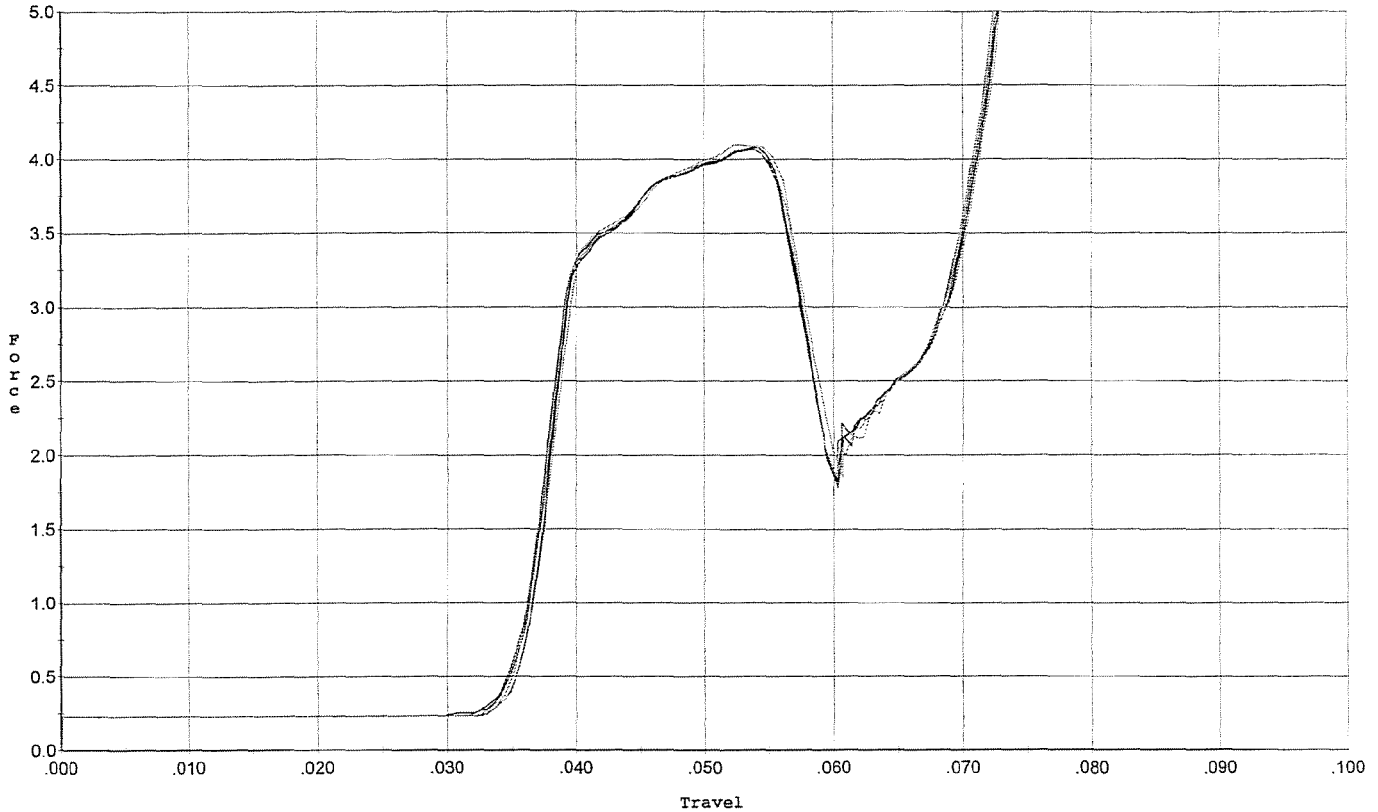
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.067	0.055	0.035	0.036	0.060		Set Trigger
2	3.032	0.055	0.036	0.036	0.060		Set Trigger
3	3.040	0.055	0.036	0.036	0.060		Set Trigger
4	3.029	0.056	0.036	0.036	0.060		Set Trigger
5	3.047	0.055	0.036	0.036	0.059		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/17/08

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



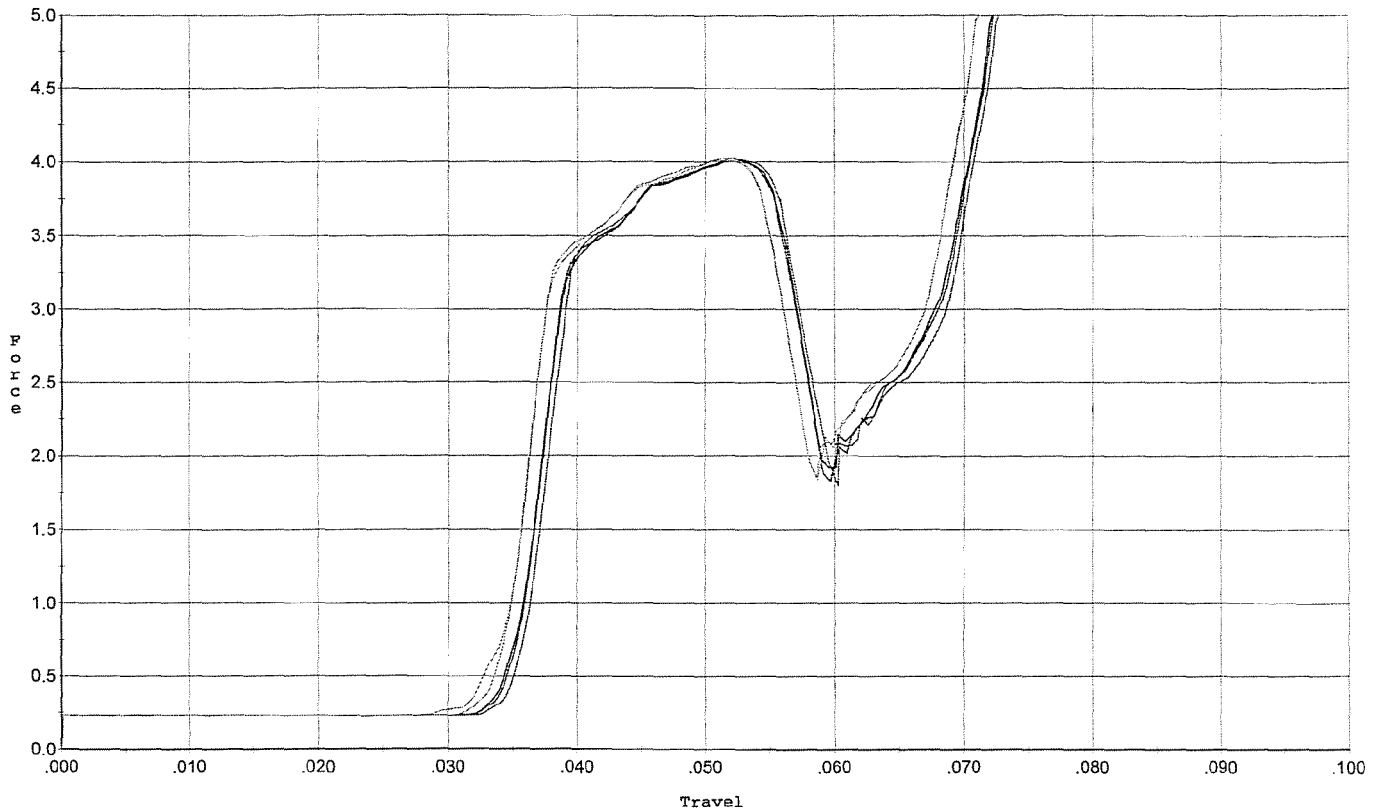
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.077	0.057	0.034	0.029	0.084		Set Trigger
2	4.080	0.057	0.035	0.029	0.083		Set Trigger
3	4.066	0.057	0.034	0.029	0.085		Set Trigger
4	4.092	0.056	0.035	0.029	0.082		Set Trigger
5	4.096	0.056	0.035	0.029	0.083		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 1/17/08

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



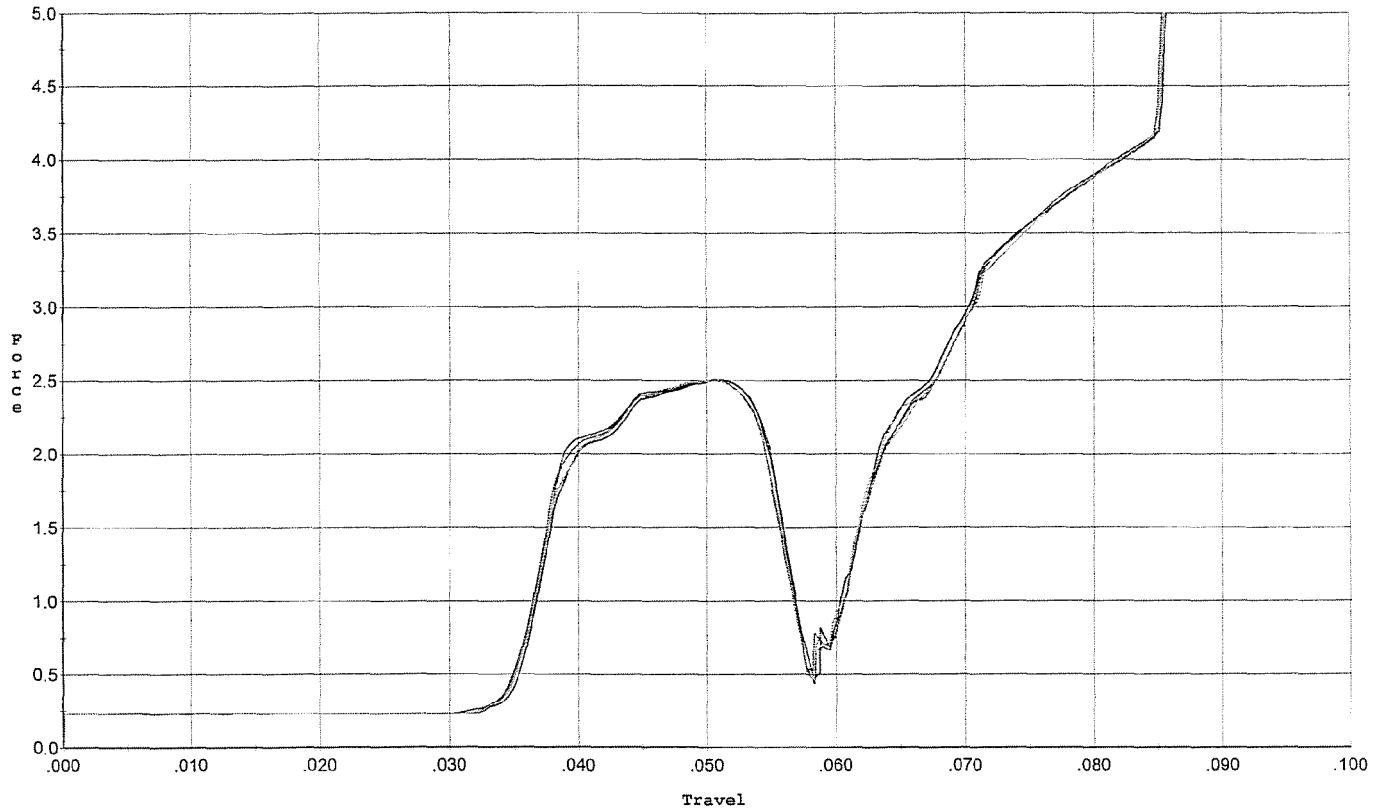
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.020	0.057	0.034	0.030	0.083		Set Trigger
2	4.001	0.056	0.034	0.029	0.083		Set Trigger
3	4.023	0.056	0.035	0.030	0.081		Set Trigger
4	4.008	0.056	0.032	0.029	0.083		Set Trigger
5	4.023	0.055	0.033	0.029	0.083		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/17/08

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



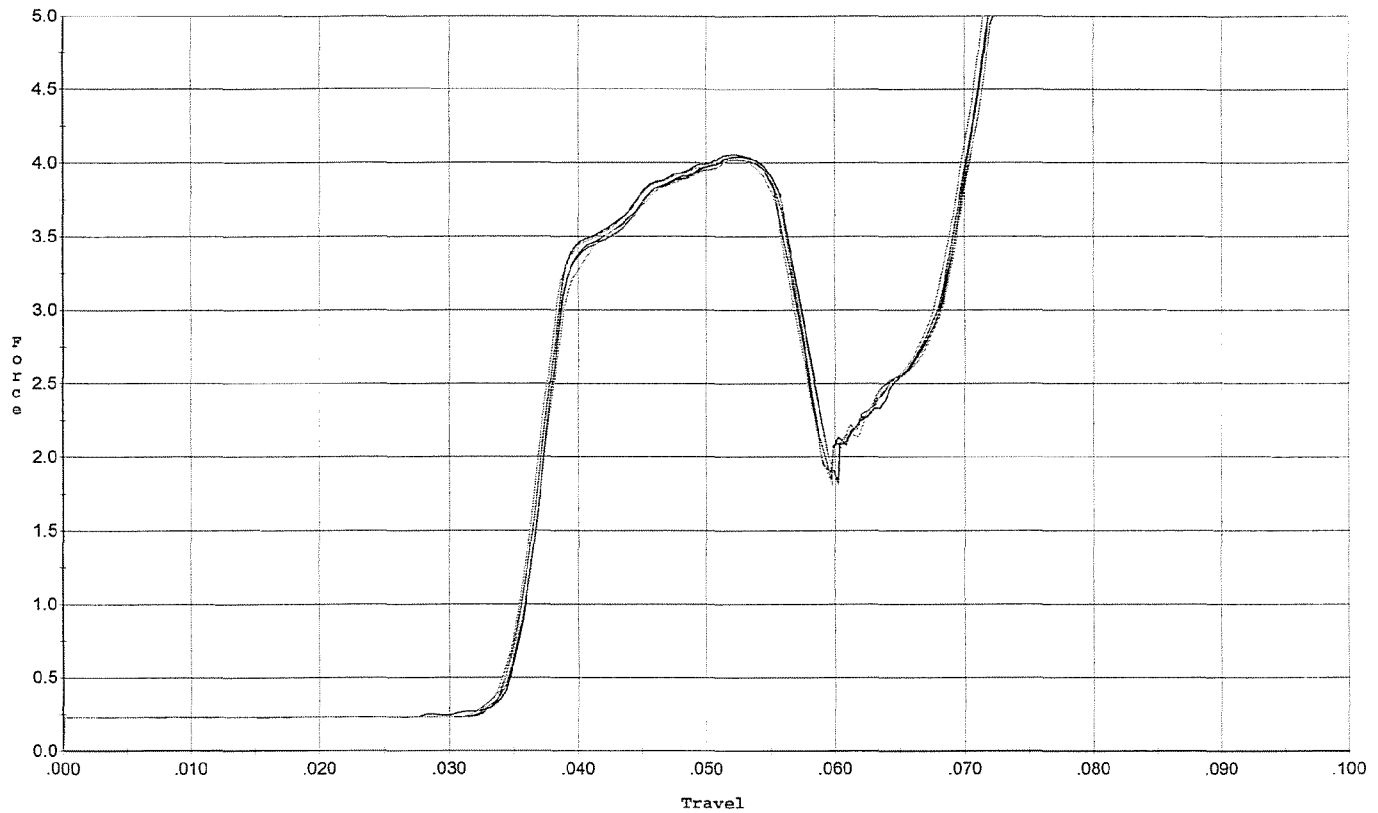
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.506	0.055	0.034	0.036	0.051		Set Trigger
2	2.507	0.055	0.035	0.036	0.050		Set Trigger
3	2.510	0.054	0.035	0.036	0.050		Set Trigger
4	2.507	0.056	0.035	0.036	0.051		Set Trigger
5	2.499	0.056	0.035	0.036	0.051		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/17/08

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	4.056	0.057	0.034	0.029	0.084		Set Trigger
2	4.042	0.056	0.034	0.029	0.082		Set Trigger
3	4.019	0.056	0.034	0.029	0.082		Set Trigger
4	4.028	0.056	0.034	0.029	0.082		Set Trigger
5	4.034	0.055	0.034	0.029	0.082		Set Trigger

Avg 4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6699810.___0

FILE DATE AND TIME: 04/10/2008 10:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

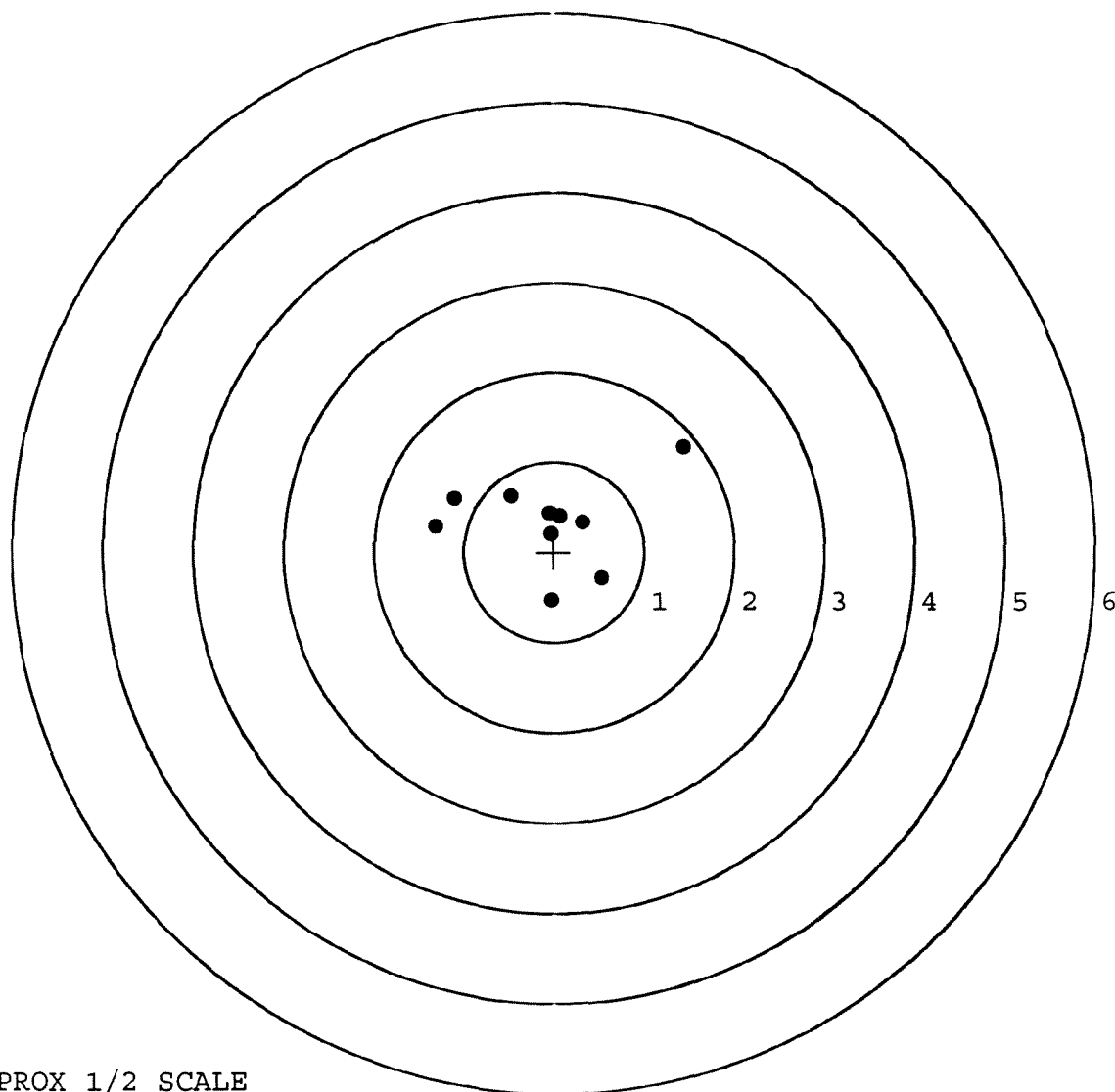
The Average X Centroid of the Five Target Set:	0.028
The Average Y Centroid of the Five Target Set:	0.093
The Average Point of Impact of the Five Target Set:	0.097
The Average Mean Radius of the Five Target Set:	0.750
The Distance from POA to Centroid Target #1:	0.325
The Distance from Centroid Target #2 to Centroid Target #1:	0.222
The Distance from Centroid Target #3 to Centroid Target #1:	0.444
The Distance from Centroid Target #4 to Centroid Target #1:	0.302
The Distance from Centroid Target #5 to Centroid Target #1:	0.394

BARBER - M24 0178718

SERIAL NUMBER: G6699810. __0
 TARGET NUMBER: 1
 FILE DATE: 04/10/2008
 FILE TIME: 10:51

POINT#	X	Y
1:	1.439	1.159
2:	0.062	0.397
3:	0.314	0.331
4:	-0.027	0.203
5:	-0.480	0.625
6:	-1.105	0.587
7:	-1.316	0.281
8:	-0.031	-0.541
9:	0.533	-0.287
10:	-0.051	0.430

X CENTROID: -0.066
 Y CENTROID: 0.318
 POA TO CENTROID: 0.325
 HORZ SPREAD: 2.755
 VERT SPREAD: 1.700
 GROUP SPREAD: 2.892
 MIN RADIUS: 0.113
 MAX RADIUS: 1.724
 MEAN RADIUS: 0.704
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



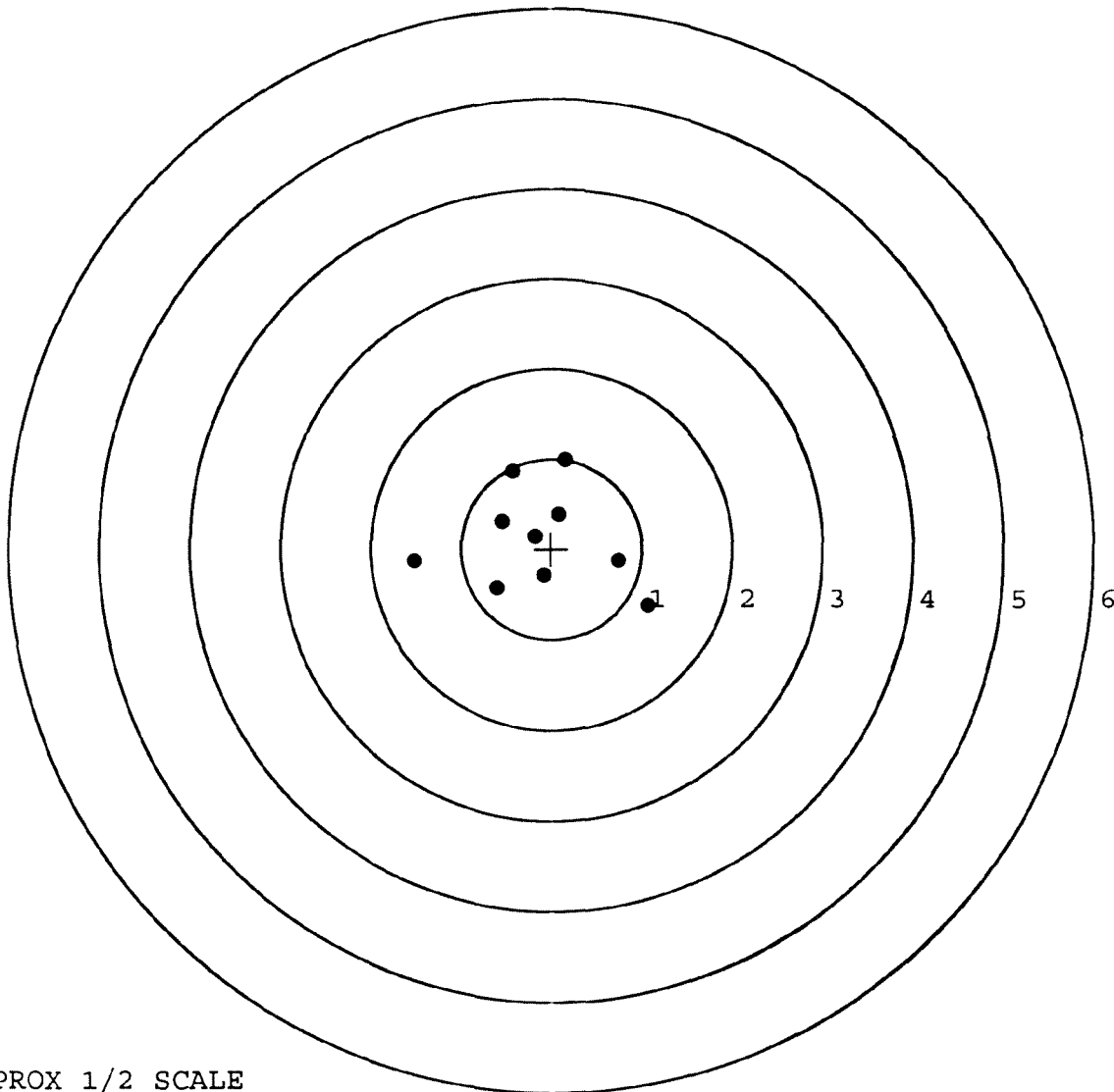
TARGET APPROX 1/2 SCALE

BARBER - M24 0178719

SERIAL NUMBER: G6699810. __0
 TARGET NUMBER: 2
 FILE DATE: 04/10/2008
 FILE TIME: 10:51

POINT#	X	Y
1:	-0.432	0.865
2:	0.158	0.991
3:	0.083	0.385
4:	-0.185	0.144
5:	-0.083	-0.294
6:	-0.601	-0.437
7:	-0.549	0.309
8:	-1.515	-0.144
9:	0.745	-0.129
10:	1.066	-0.630

X CENTROID: -0.131
 Y CENTROID: 0.106
 POA TO CENTROID: 0.169
 HORZ SPREAD: 2.581
 VERT SPREAD: 1.621
 GROUP SPREAD: 2.626
 MIN RADIUS: 0.066
 MAX RADIUS: 1.406
 MEAN RADIUS: 0.747
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0178720

SERIAL NUMBER: G6699810. __0

TARGET NUMBER: 3

FILE DATE: 04/10/2008

FILE TIME: 10:51

POINT#	X	Y
1:	0.567	0.405
2:	0.353	0.114
3:	0.197	-0.289
4:	0.248	-0.703
5:	0.079	-0.935
6:	-0.472	-0.611
7:	0.862	-0.440
8:	-0.349	0.412
9:	-0.853	0.245
10:	-1.016	0.554

X CENTROID: -0.038

Y CENTROID: -0.125

POA TO CENTROID: 0.131

HORZ SPREAD: 1.878

VERT SPREAD: 1.489

GROUP SPREAD: 2.125

MIN RADIUS: 0.287

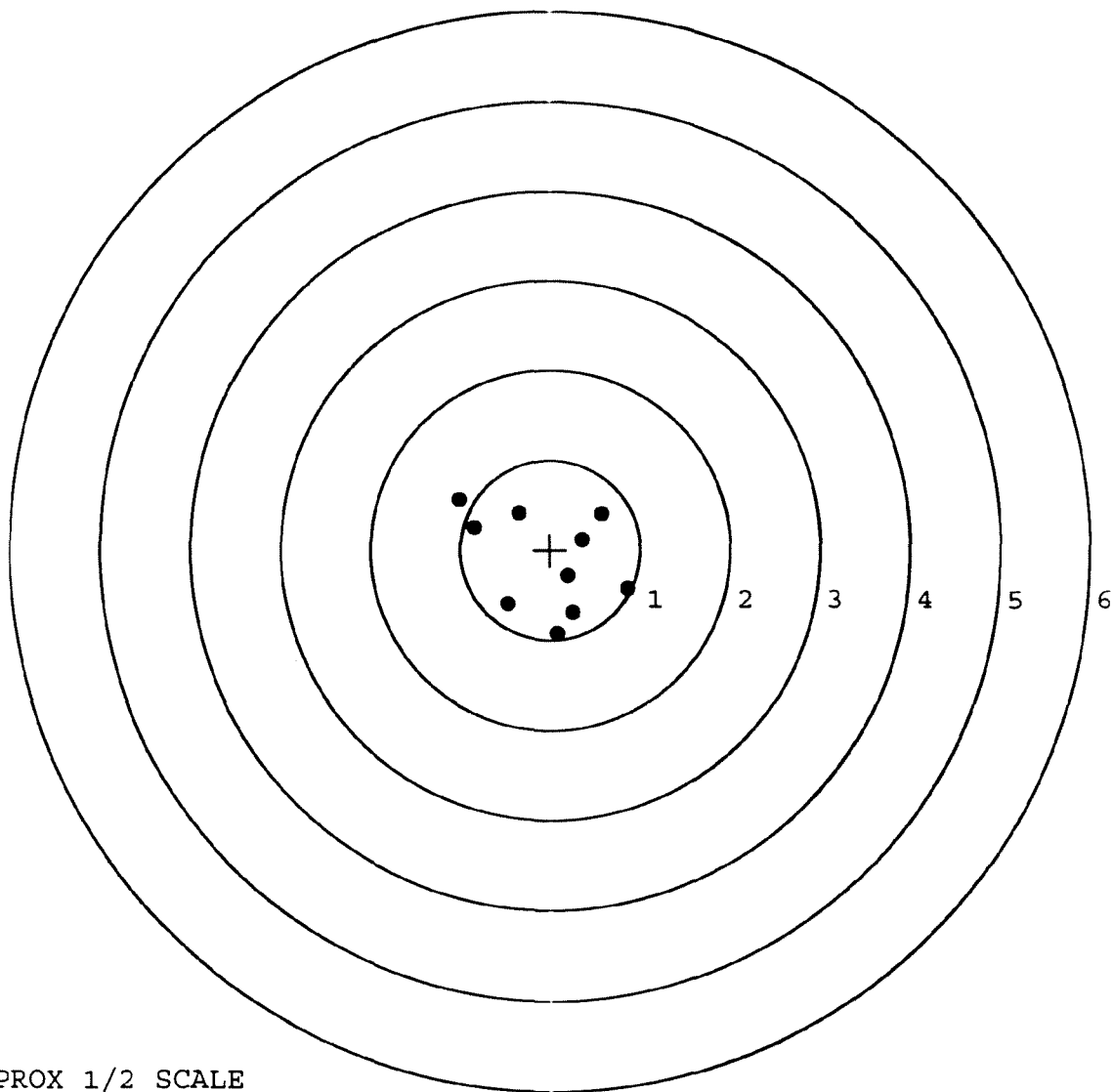
MAX RADIUS: 1.190

MEAN RADIUS: 0.732

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



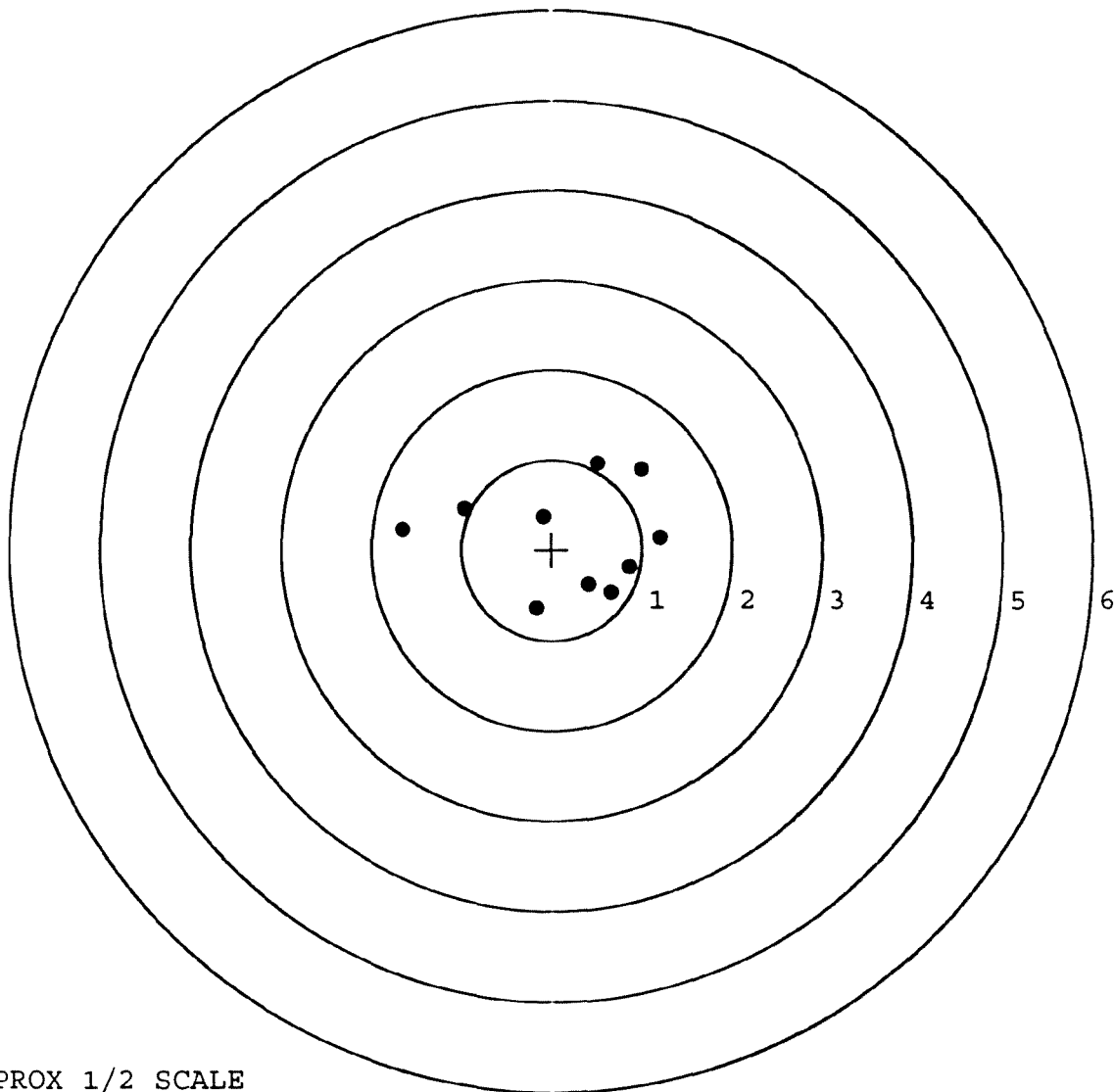
TARGET APPROX 1/2 SCALE

BARBER - M24 0178721

SERIAL NUMBER: G6699810. __0
 TARGET NUMBER: 4
 FILE DATE: 04/10/2008
 FILE TIME: 10:51

POINT#	X	Y
1:	0.511	0.961
2:	0.995	0.898
3:	1.196	0.135
4:	0.861	-0.189
5:	0.654	-0.472
6:	0.407	-0.384
7:	-0.171	-0.647
8:	-0.097	0.363
9:	-0.970	0.451
10:	-1.658	0.215

X CENTROID: 0.173
 Y CENTROID: 0.133
 POA TO CENTROID: 0.218
 HORZ SPREAD: 2.854
 VERT SPREAD: 1.608
 GROUP SPREAD: 2.855
 MIN RADIUS: 0.354
 MAX RADIUS: 1.833
 MEAN RADIUS: 0.937
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

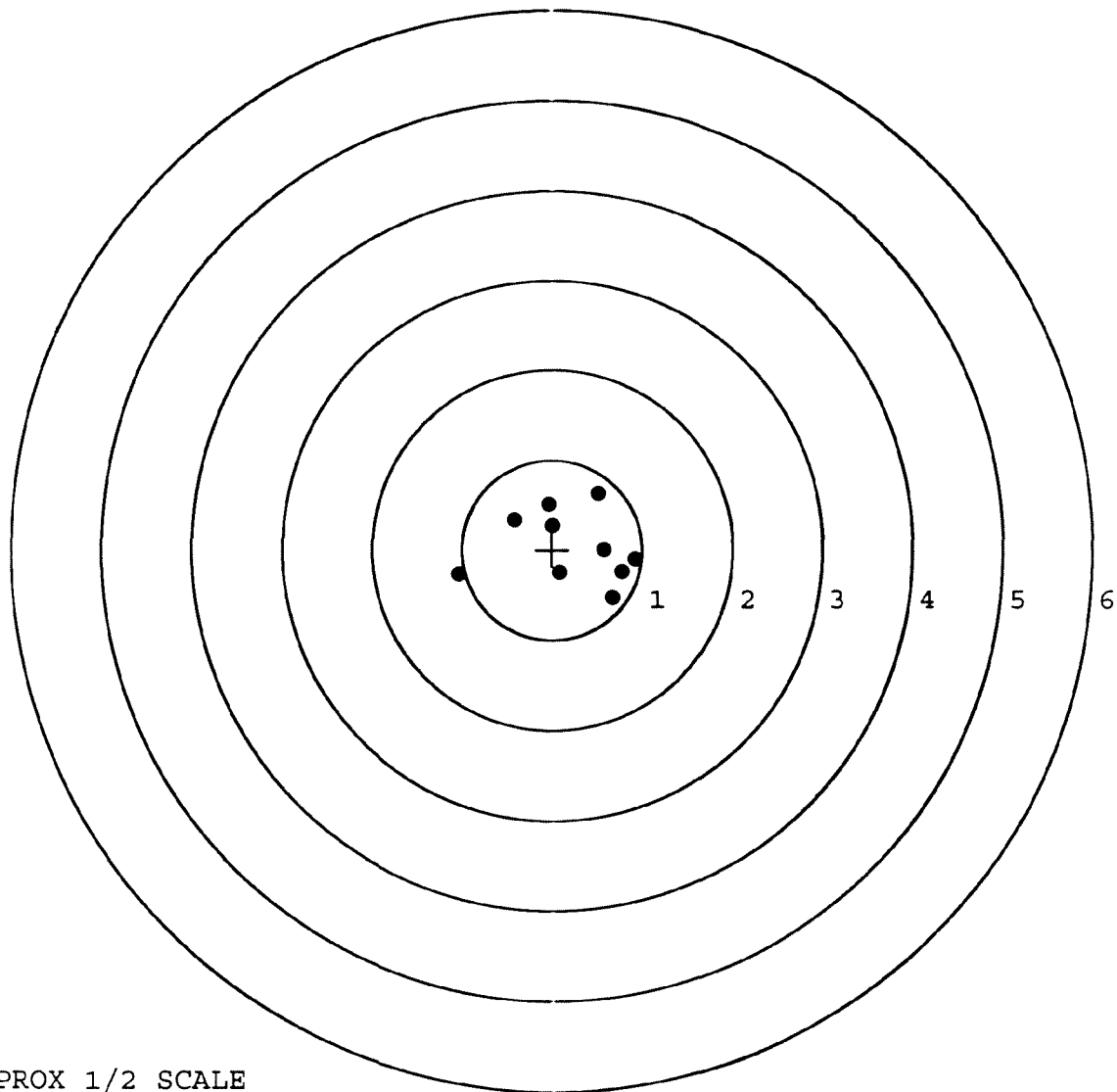


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699810. __0
 TARGET NUMBER: 5
 FILE DATE: 04/10/2008
 FILE TIME: 10:51

POINT#	X	Y
1:	-0.426	0.338
2:	-0.046	0.513
3:	0.011	0.269
4:	0.509	0.628
5:	0.576	-0.005
6:	0.921	-0.109
7:	0.672	-0.539
8:	0.081	-0.258
9:	-1.039	-0.278
10:	0.777	-0.248

X CENTROID: 0.204
 Y CENTROID: 0.031
 POA TO CENTROID: 0.206
 HORZ SPREAD: 1.960
 VERT SPREAD: 1.167
 GROUP SPREAD: 1.967
 MIN RADIUS: 0.306
 MAX RADIUS: 1.280
 MEAN RADIUS: 0.629
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE