

6669 9789

**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 BIPOD ASSB

BM FORM 96253



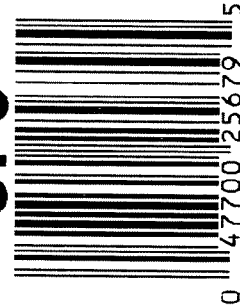
ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6699789

UPC



GUN SERIAL # 66699789

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-5-08	RTZ
420	ASSEMBLE ACTION		3-5-08	RTZ
430	ASSEMBLE TO STOCK		3-5-08	RTZ
440	PROOF	MAGNA - FLUX	3-6-08	TRW
460	CHECK HEADSPACE	MAR 07 2008	3-6-08	TRW
470	DIS-ASSEMBLE ACTION		3-6-08	SPD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unns</u>	3/7/08	unns
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-6-08	CW
510	DRILL AND TAP SIGHT HOLES		3-6-08	TRW
520	GOFF BLAST BBL / REC		3-7-08	TR
530 & 540	APPLY COATINGS (BARREL ACTION)		3-11-08	CW
	(BOLT)			
560	RE-ASSEMBLE ACTION		3-25-08	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-08	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-08	SD
	D) OIL FIRING PIN ASSEMBLY		3-26-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

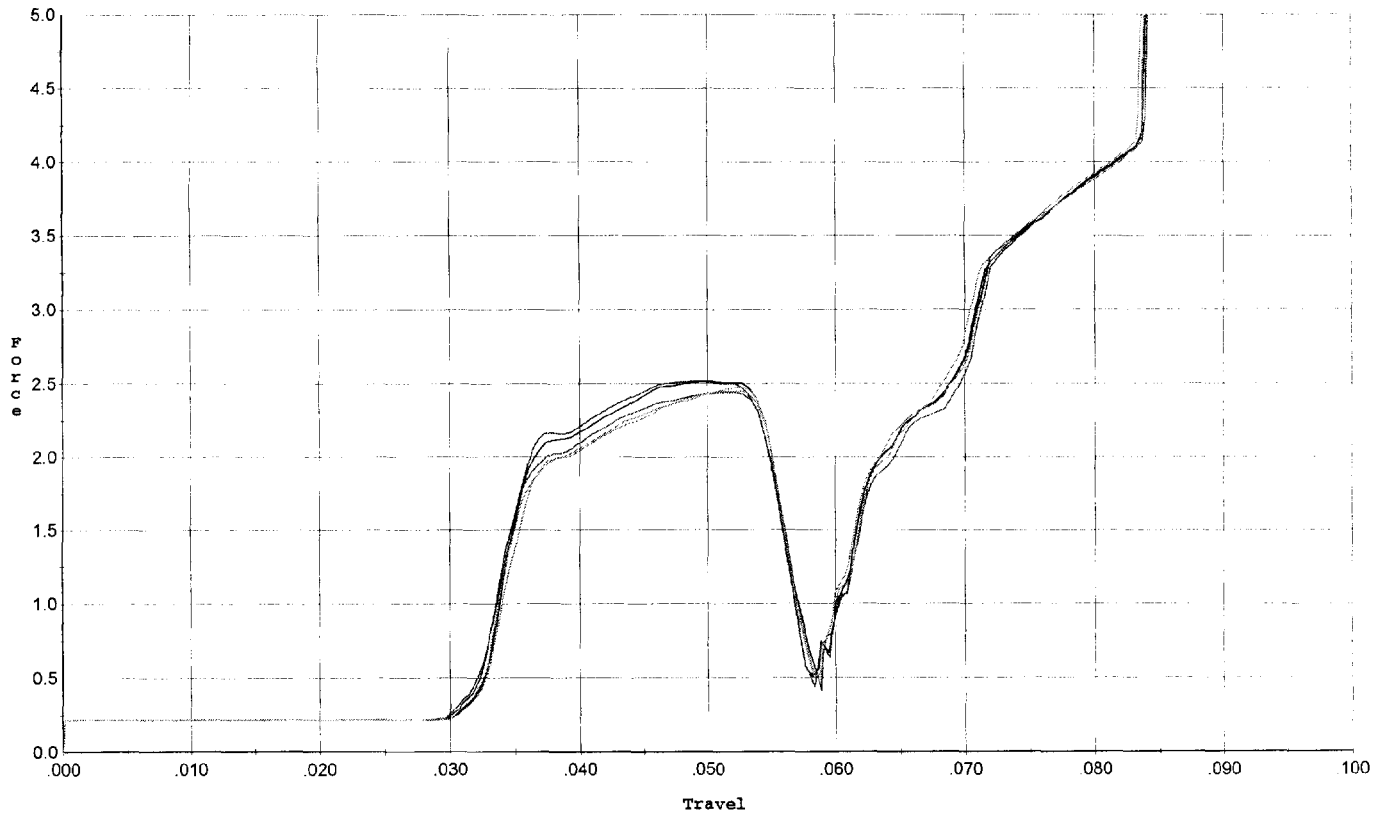
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.5</u> <u>5.5</u>	4-22-08	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.15</u> <u>2.5</u>	4-21-08	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022⁵</u> <u>.022⁵</u> <u>.022</u>	4-21-08	TRW
	J) ASSEMBLE STOCK		3-26-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-22-08	TRW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-23-08	L.P.D.
	M) IRON SIGHT ALIGNMENT		4-22-08	L.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-23-08	L.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-15-08	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-15-08	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		4-22-08	TRW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.52</u> <u>2.71</u> <u>2.52</u> <u>2.64</u>	4-21-08	TRW
	C) FUNCTION		4-22-08	TRW
690	PACK		5-5-08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/16/08

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



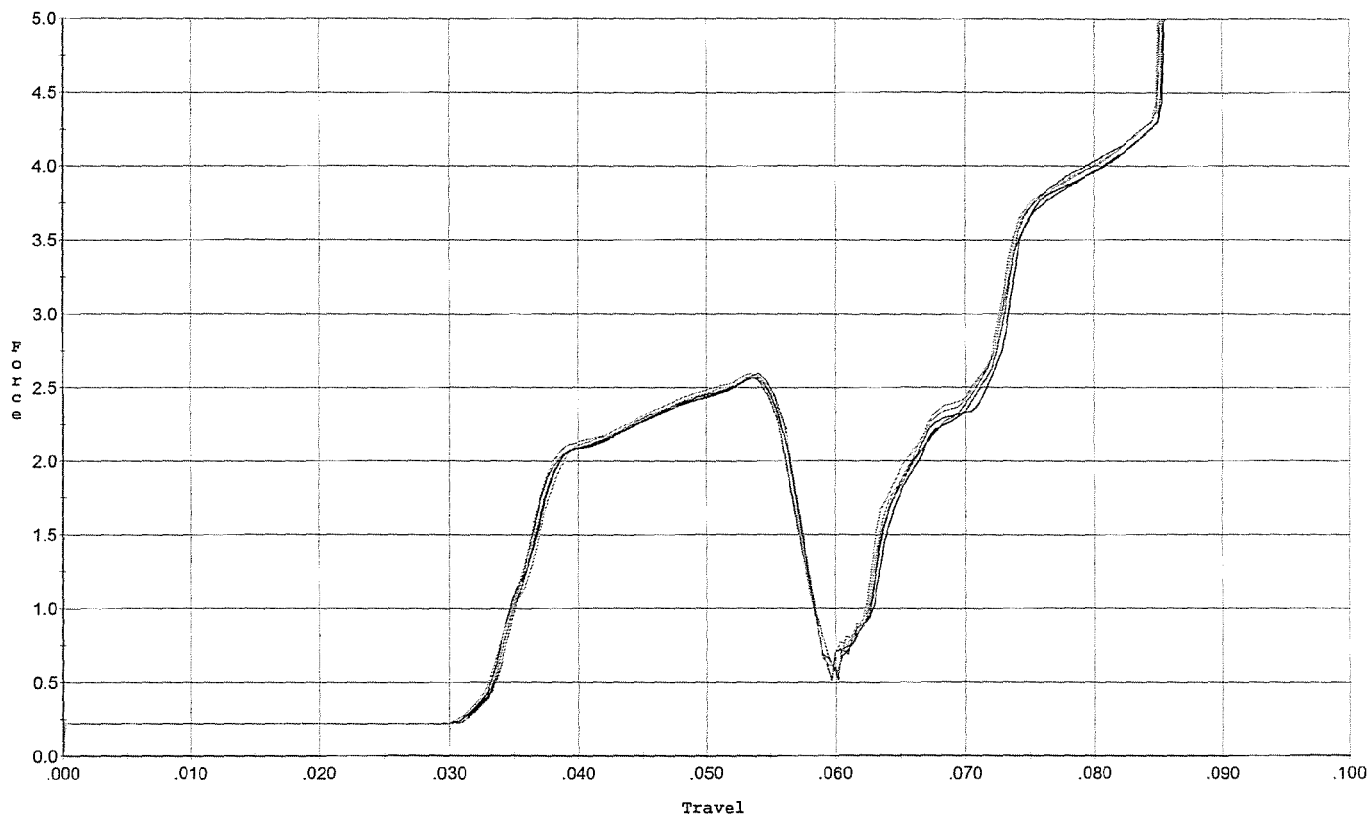
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.517	0.055	0.032	0.034	0.057		Set Trigger
2	2.516	0.055	0.032	0.034	0.056		Set Trigger
3	2.438	0.055	0.032	0.034	0.055		Set Trigger
4	2.450	0.055	0.032	0.034	0.054		Set Trigger
5	2.477	0.055	0.032	0.034	0.054		Set Trigger

Avg 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/16/08

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



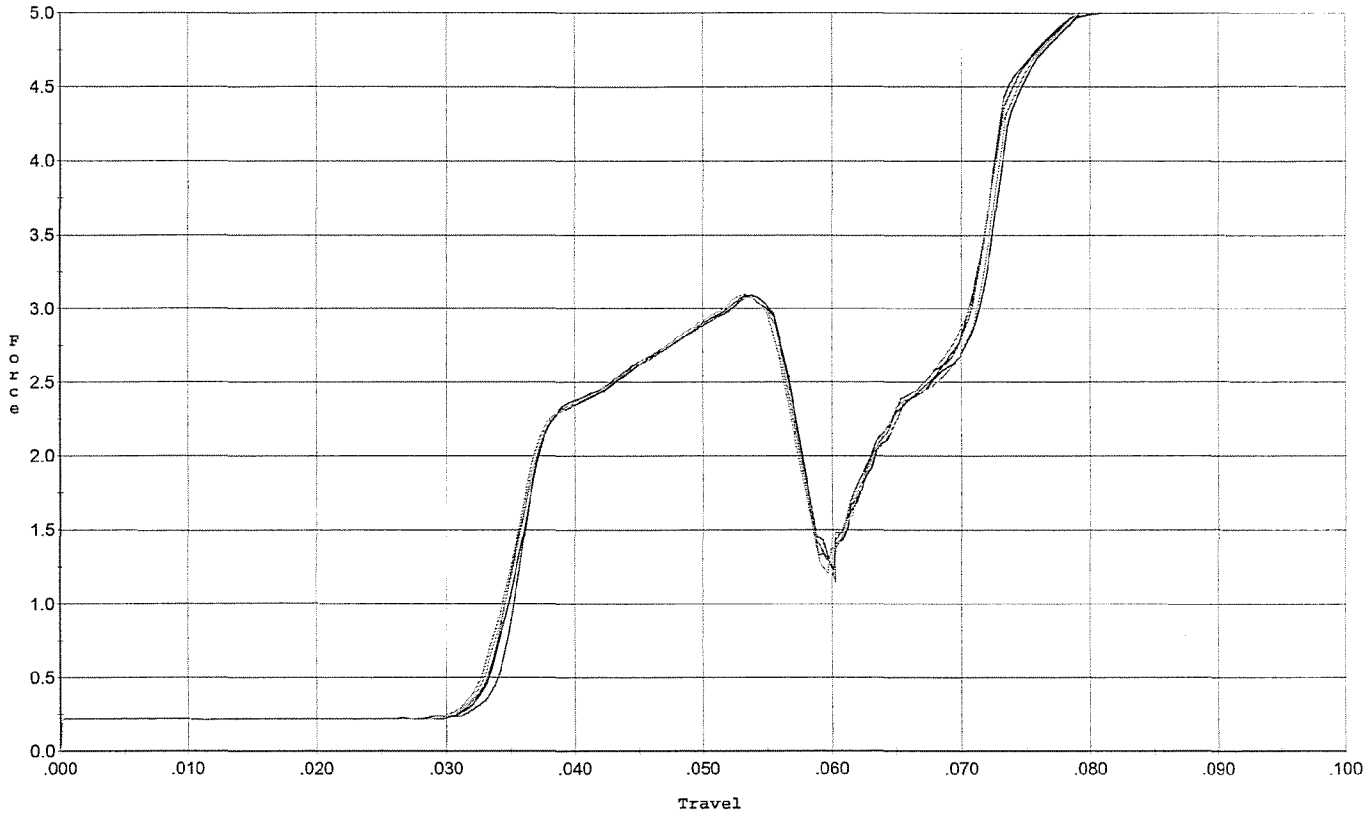
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.597	0.056	0.033	0.034	0.056		Set Trigger
2	2.569	0.056	0.033	0.034	0.056		Set Trigger
3	2.569	0.056	0.033	0.035	0.055		Set Trigger
4	2.596	0.057	0.033	0.034	0.058		Set Trigger
5	2.580	0.056	0.033	0.034	0.056		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/16/08

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



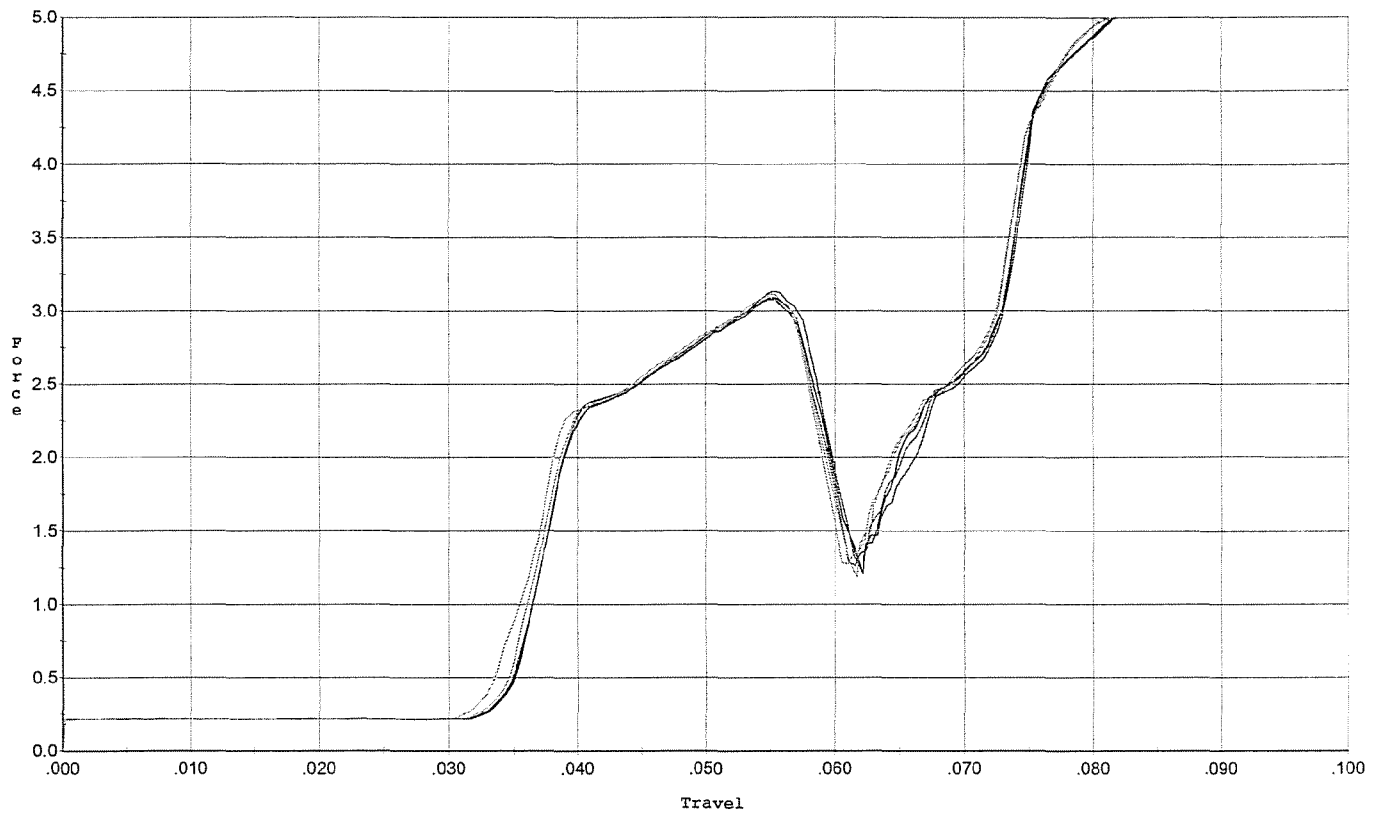
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.085	0.057	0.034	0.033	0.065		Set Trigger
2	3.091	0.057	0.033	0.033	0.065		Set Trigger
3	3.087	0.057	0.033	0.033	0.066		Set Trigger
4	3.074	0.057	0.033	0.033	0.066		Set Trigger
5	3.096	0.056	0.032	0.033	0.065		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/16/08

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



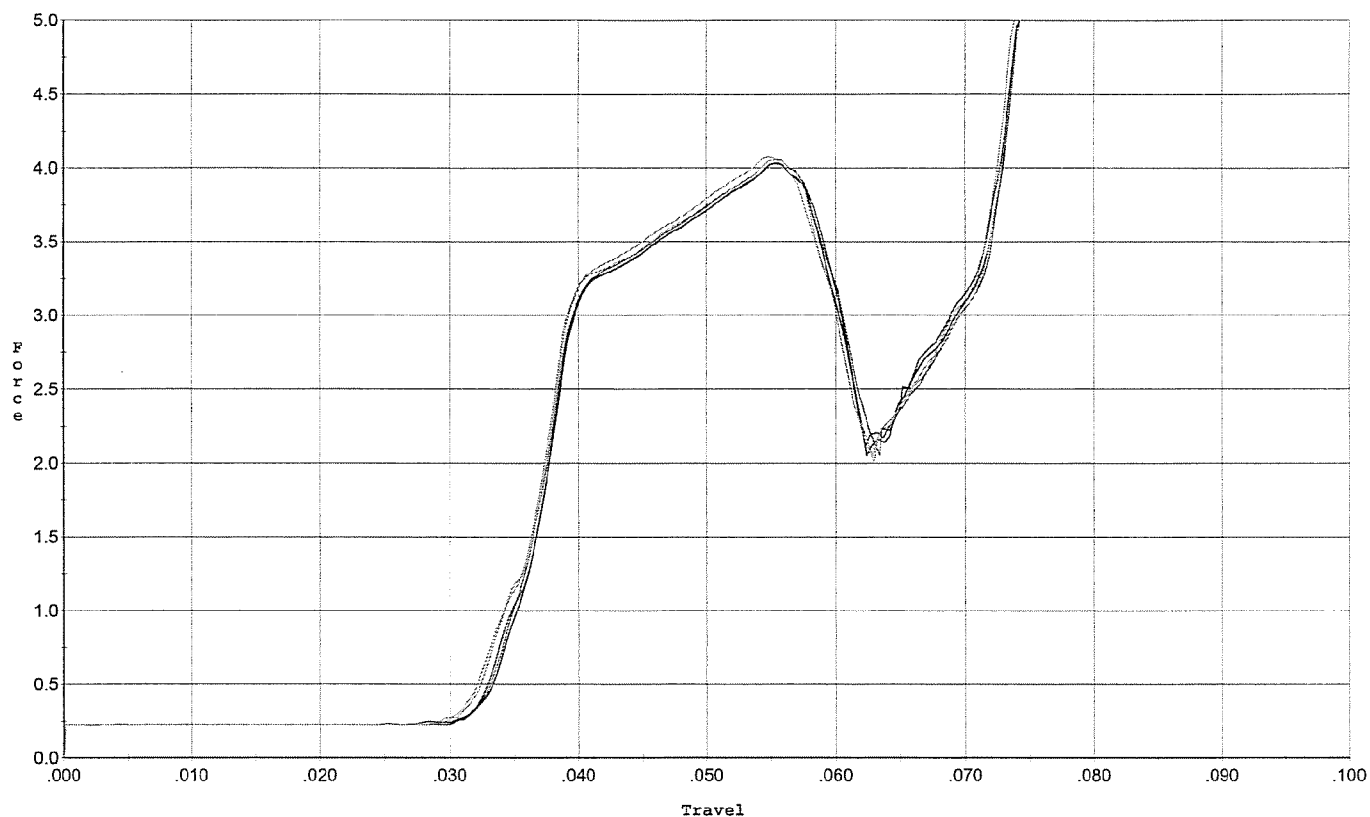
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.134	0.059	0.035	0.034	0.067		Set Trigger
2	3.091	0.059	0.035	0.033	0.067		Set Trigger
3	3.075	0.059	0.035	0.033	0.067		Set Trigger
4	3.098	0.059	0.033	0.033	0.068		Set Trigger
5	3.115	0.057	0.035	0.034	0.064		Set Trigger

Avg 3.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/16/08

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



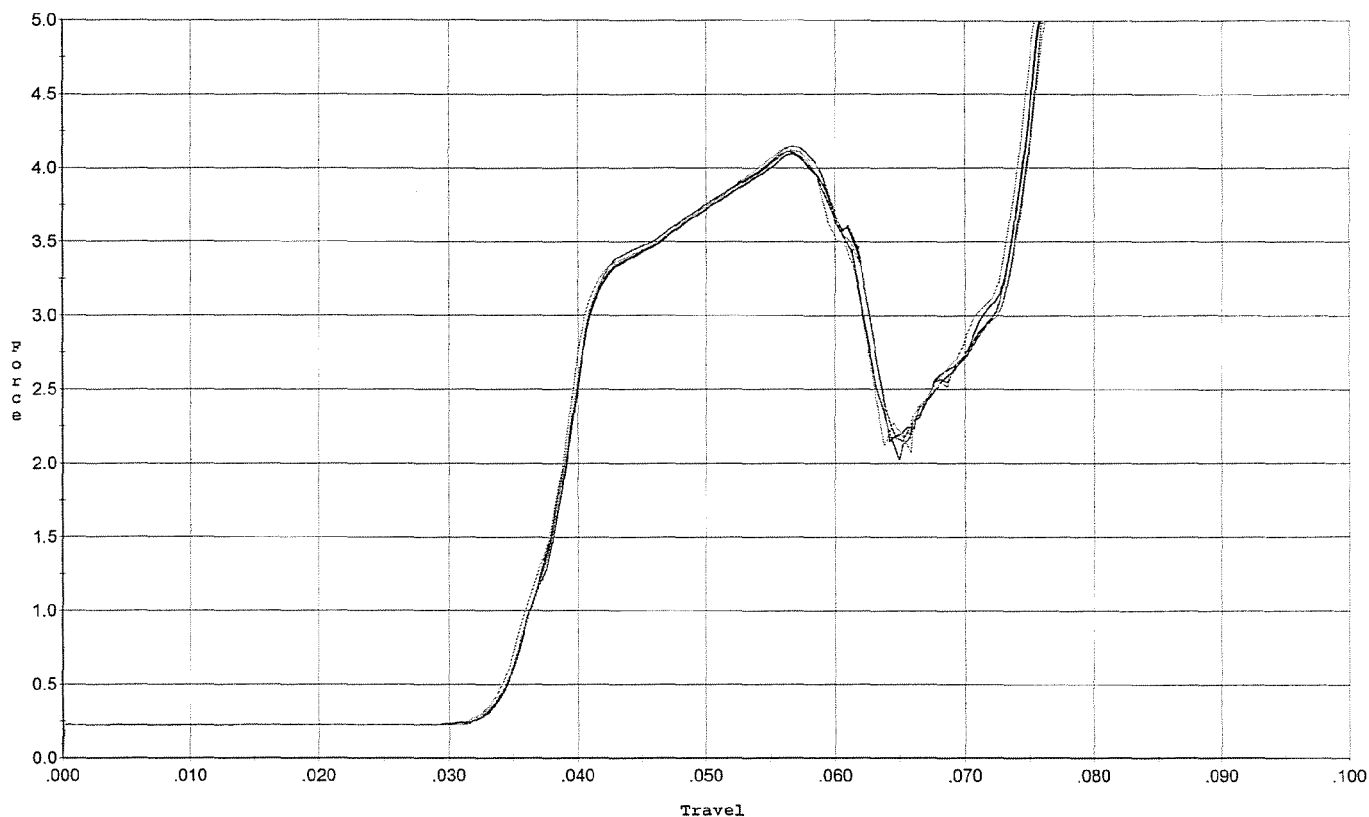
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.032	0.060	0.033	0.025	0.094		Set Trigger
2	4.034	0.061	0.033	0.025	0.093		Set Trigger
3	4.061	0.060	0.033	0.025	0.094		Set Trigger
4	4.062	0.060	0.032	0.025	0.093		Set Trigger
5	4.080	0.060	0.032	0.025	0.094		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/16/08

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



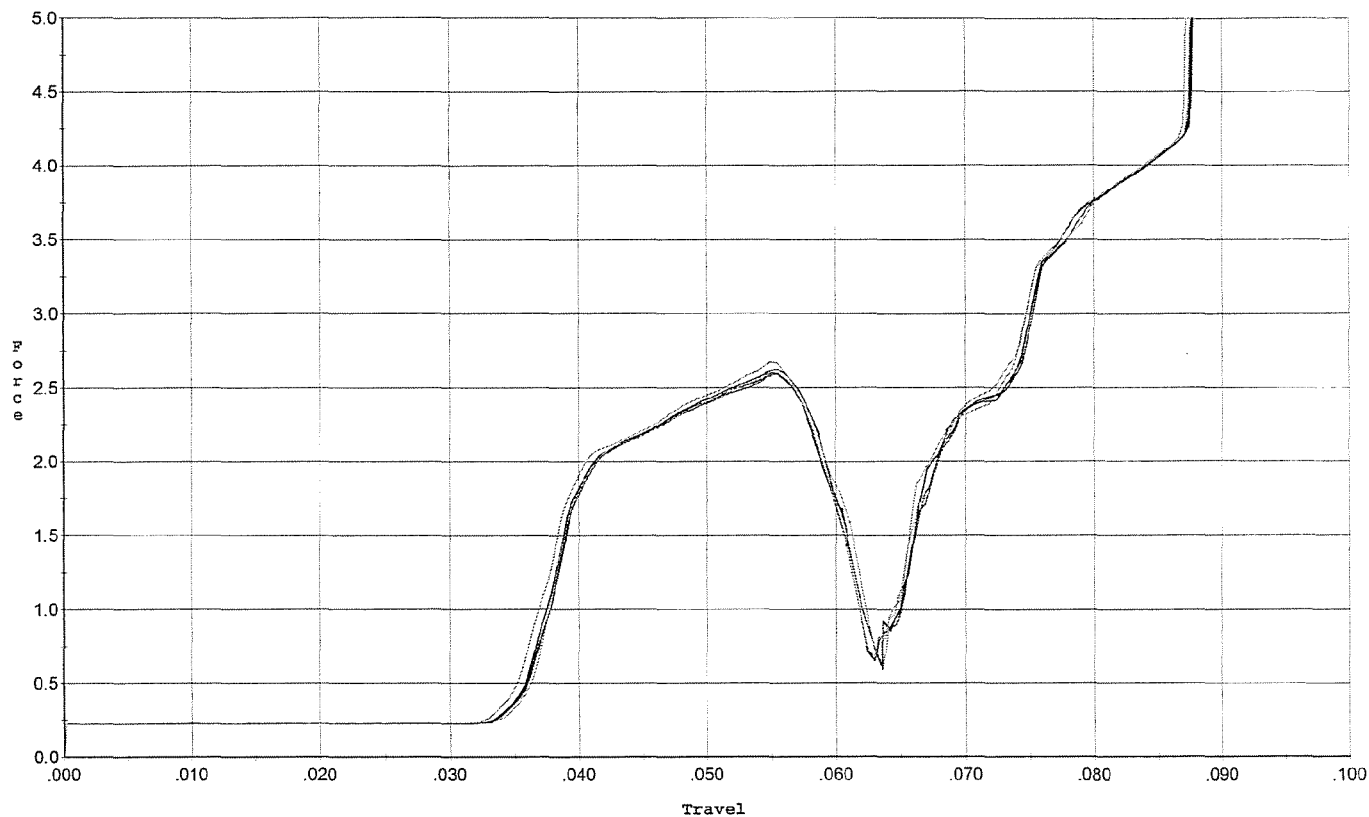
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.113	0.061	0.034	0.024	0.095		Set Trigger
2	4.099	0.062	0.034	0.024	0.097		Set Trigger
3	4.149	0.062	0.034	0.024	0.097		Set Trigger
4	4.129	0.061	0.034	0.024	0.096		Set Trigger
5	4.121	0.062	0.034	0.024	0.097		Set Trigger

Avg 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/16/08

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



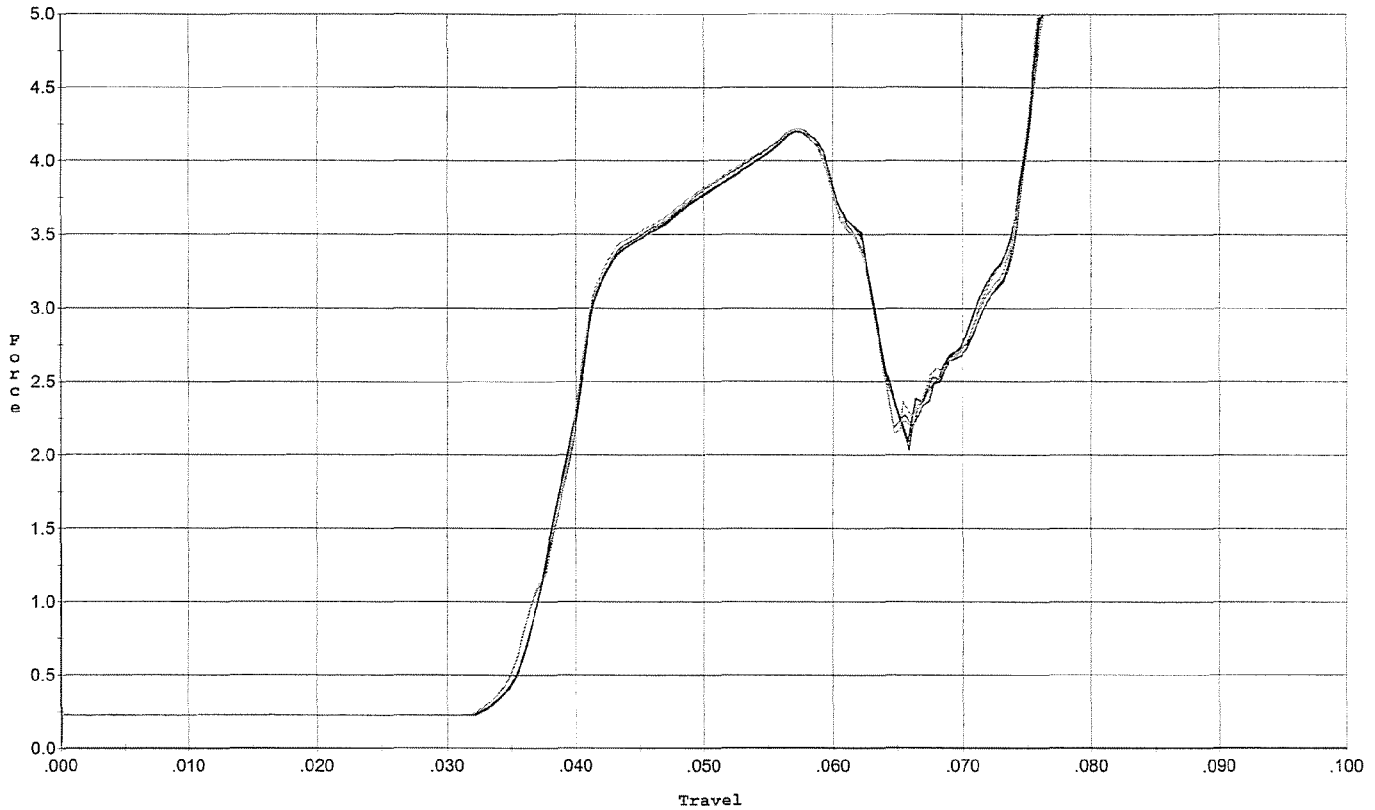
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.628	0.061	0.036	0.034	0.060		Set Trigger
2	2.601	0.061	0.036	0.034	0.060		Set Trigger
3	2.598	0.060	0.036	0.034	0.059		Set Trigger
4	2.628	0.061	0.036	0.034	0.061		Set Trigger
5	2.676	0.061	0.035	0.034	0.062		Set Trigger

Avg 2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/16/08

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	4.208	0.062	0.035	0.024	0.098		Set Trigger
2	4.199	0.062	0.035	0.024	0.098		Set Trigger
3	4.219	0.062	0.035	0.023	0.098		Set Trigger
4	4.220	0.062	0.035	0.023	0.099		Set Trigger
5	4.208	0.062	0.035	0.023	0.099		Set Trigger

Avg 4.21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6699789.___0
FILE DATE AND TIME: 04/16/2008 00:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

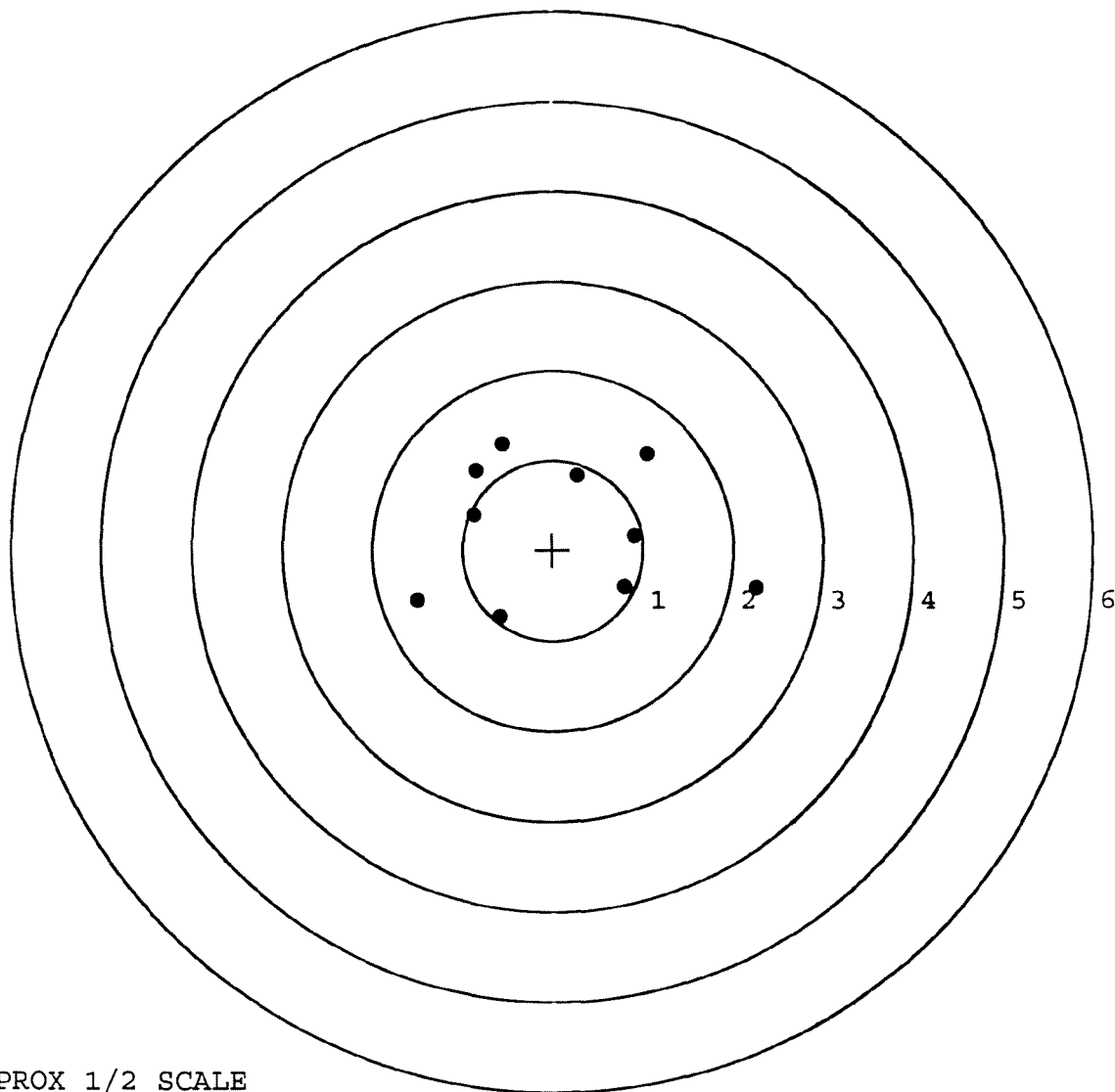
The Average X Centroid of the Five Target Set:	0.188
The Average Y Centroid of the Five Target Set:	0.038
The Average Point of Impact of the Five Target Set:	0.192
The Average Mean Radius of the Five Target Set:	0.923
The Distance from POA to Centroid Target #1:	0.257
The Distance from Centroid Target #2 to Centroid Target #1:	0.247
The Distance from Centroid Target #3 to Centroid Target #1:	0.309
The Distance from Centroid Target #4 to Centroid Target #1:	0.274
The Distance from Centroid Target #5 to Centroid Target #1:	0.309

BARBER - M24 0179320

SERIAL NUMBER: G6699789. __0
 TARGET NUMBER: 1
 FILE DATE: 04/16/2008
 FILE TIME: 00:03

POINT#	X	Y
1:	-0.550	1.185
2:	-0.845	0.892
3:	-0.870	0.391
4:	0.275	0.828
5:	1.052	1.069
6:	0.905	0.157
7:	0.795	-0.409
8:	2.249	-0.424
9:	-0.583	-0.735
10:	-1.501	-0.554

X CENTROID: 0.093
 Y CENTROID: 0.240
 POA TO CENTROID: 0.257
 HORZ SPREAD: 3.750
 VERT SPREAD: 1.920
 GROUP SPREAD: 3.752
 MIN RADIUS: 0.616
 MAX RADIUS: 2.256
 MEAN RADIUS: 1.214
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



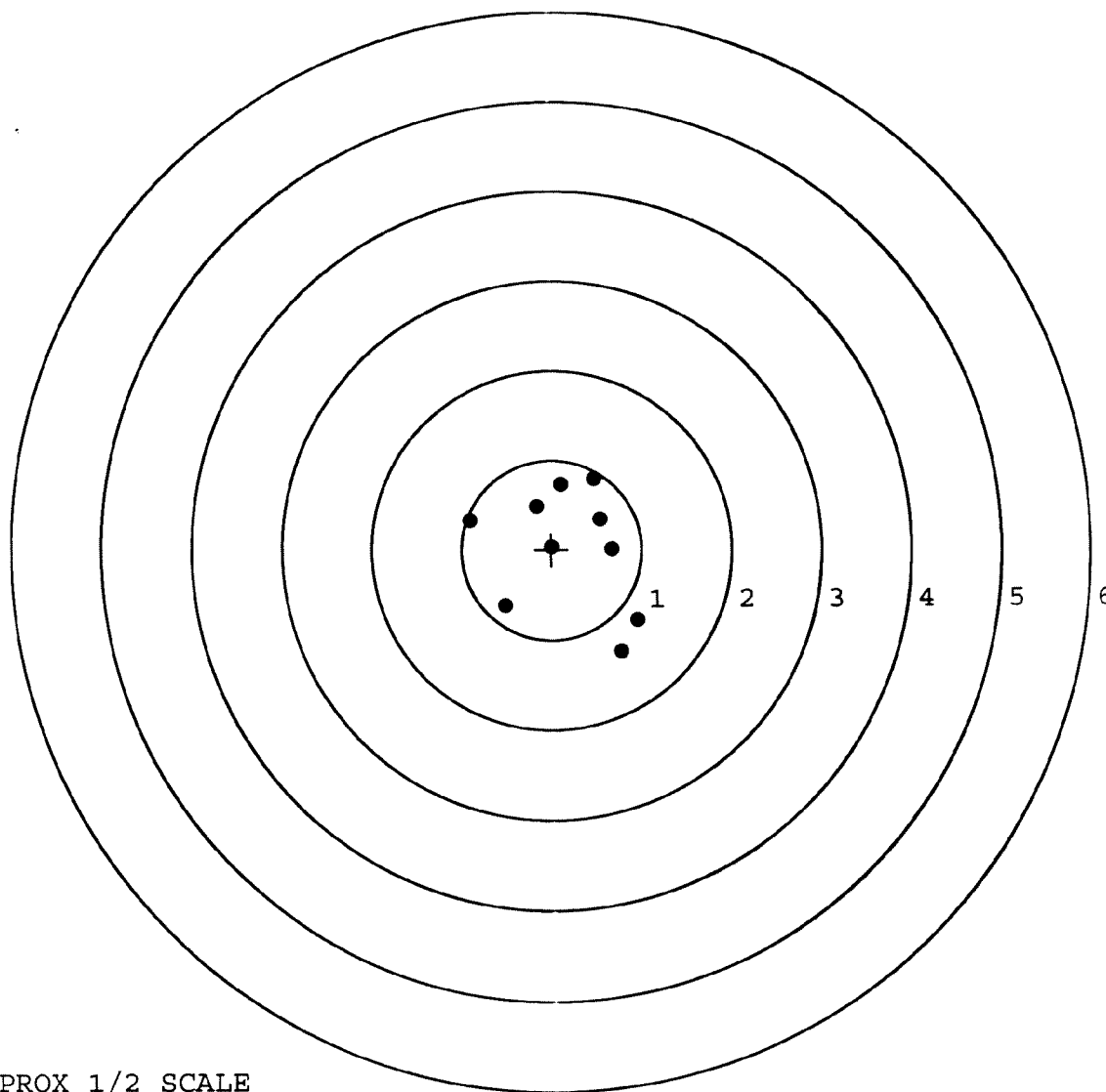
TARGET APPROX 1/2 SCALE

BARBER - M24 0179321

SERIAL NUMBER: G6699789. __0
 TARGET NUMBER: 2
 FILE DATE: 04/16/2008
 FILE TIME: 00:03

POINT#	X	Y
1:	0.476	0.787
2:	0.111	0.729
3:	-0.161	0.484
4:	-0.905	0.328
5:	0.005	0.031
6:	0.543	0.338
7:	0.671	0.002
8:	0.951	-0.787
9:	0.770	-1.139
10:	-0.514	-0.622

X CENTROID: 0.195
 Y CENTROID: 0.015
 POA TO CENTROID: 0.195
 HORZ SPREAD: 1.856
 VERT SPREAD: 1.926
 GROUP SPREAD: 2.227
 MIN RADIUS: 0.190
 MAX RADIUS: 1.290
 MEAN RADIUS: 0.776
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

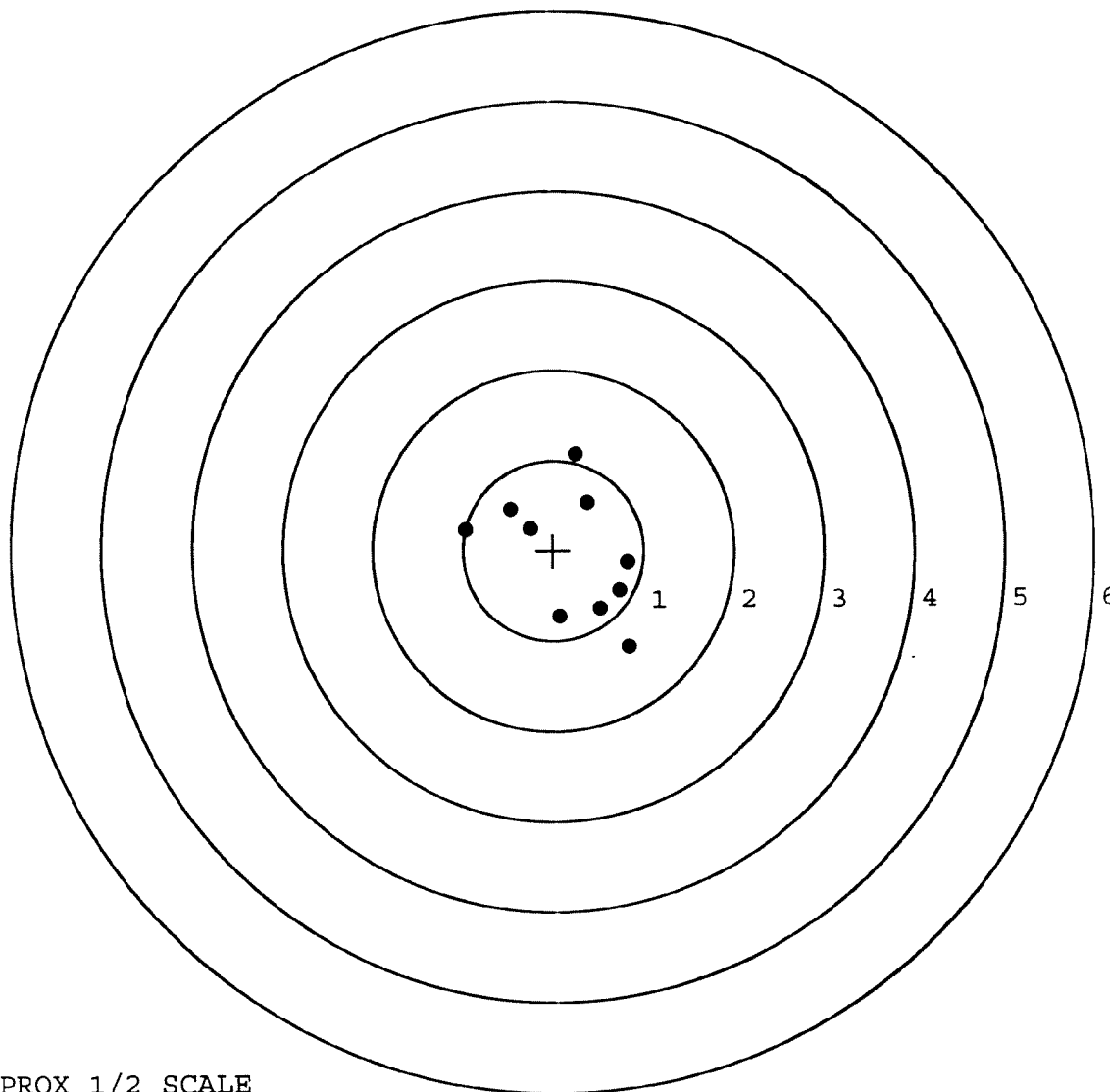


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699789. 0
 TARGET NUMBER: 3
 FILE DATE: 04/16/2008
 FILE TIME: 00:03

POINT#	X	Y
1:	0.258	1.067
2:	0.380	0.529
3:	-0.249	0.243
4:	-0.468	0.462
5:	-0.967	0.237
6:	0.823	-0.139
7:	0.728	-0.452
8:	0.516	-0.653
9:	0.068	-0.738
10:	0.831	-1.079

X CENTROID: 0.192
 Y CENTROID: -0.052
 POA TO CENTROID: 0.199
 HORZ SPREAD: 1.798
 VERT SPREAD: 2.146
 GROUP SPREAD: 2.228
 MIN RADIUS: 0.531
 MAX RADIUS: 1.209
 MEAN RADIUS: 0.819
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

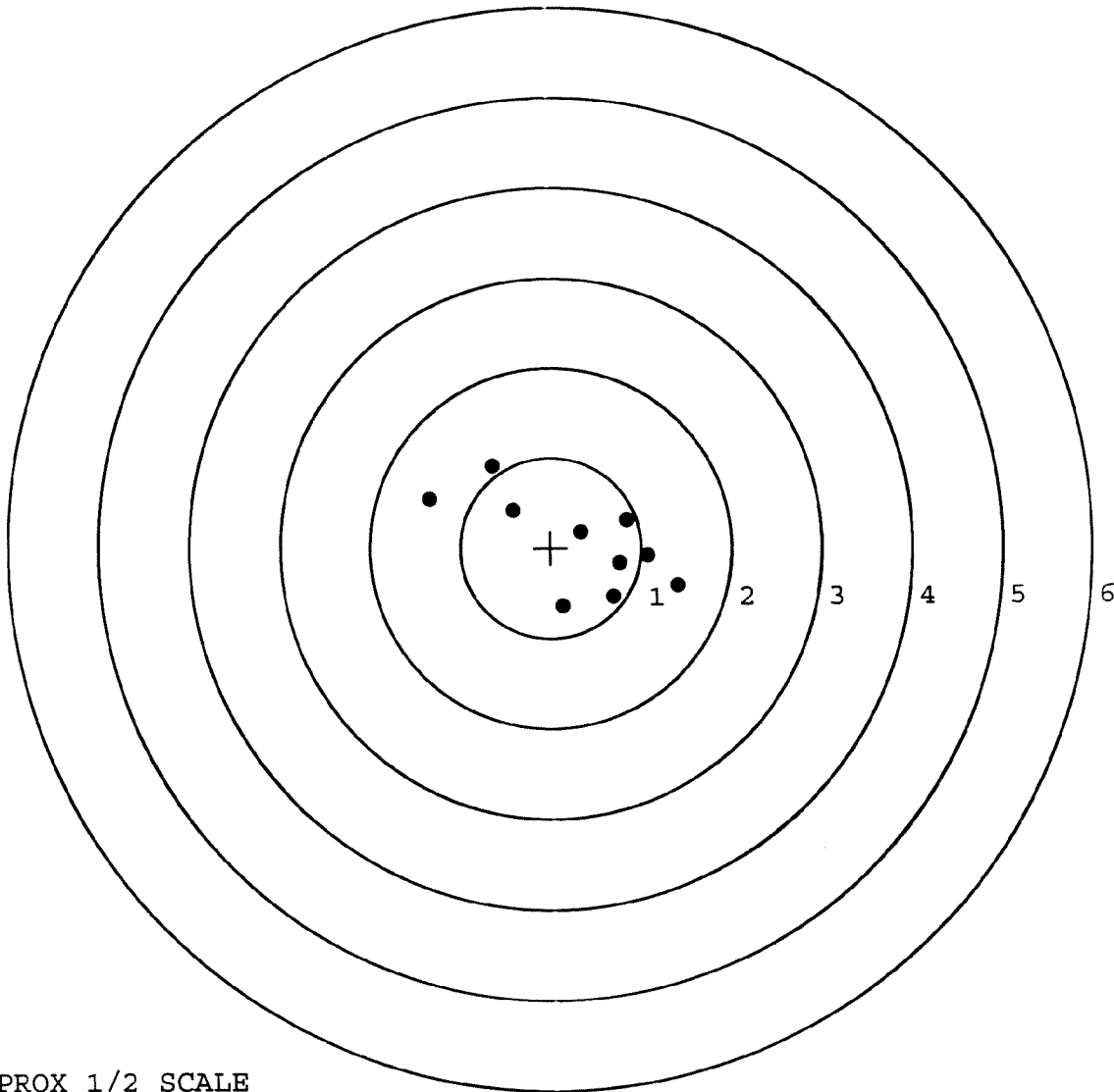


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699789. __0
 TARGET NUMBER: 4
 FILE DATE: 04/16/2008
 FILE TIME: 00:03

POINT#	X	Y
1:	-0.637	0.907
2:	-0.410	0.414
3:	-1.338	0.549
4:	0.334	0.179
5:	0.842	0.301
6:	1.072	-0.099
7:	0.761	-0.176
8:	1.402	-0.432
9:	0.688	-0.549
10:	0.133	-0.649

X CENTROID: 0.285
 Y CENTROID: 0.045
 POA TO CENTROID: 0.288
 HORZ SPREAD: 2.740
 VERT SPREAD: 1.556
 GROUP SPREAD: 2.910
 MIN RADIUS: 0.143
 MAX RADIUS: 1.699
 MEAN RADIUS: 0.847
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

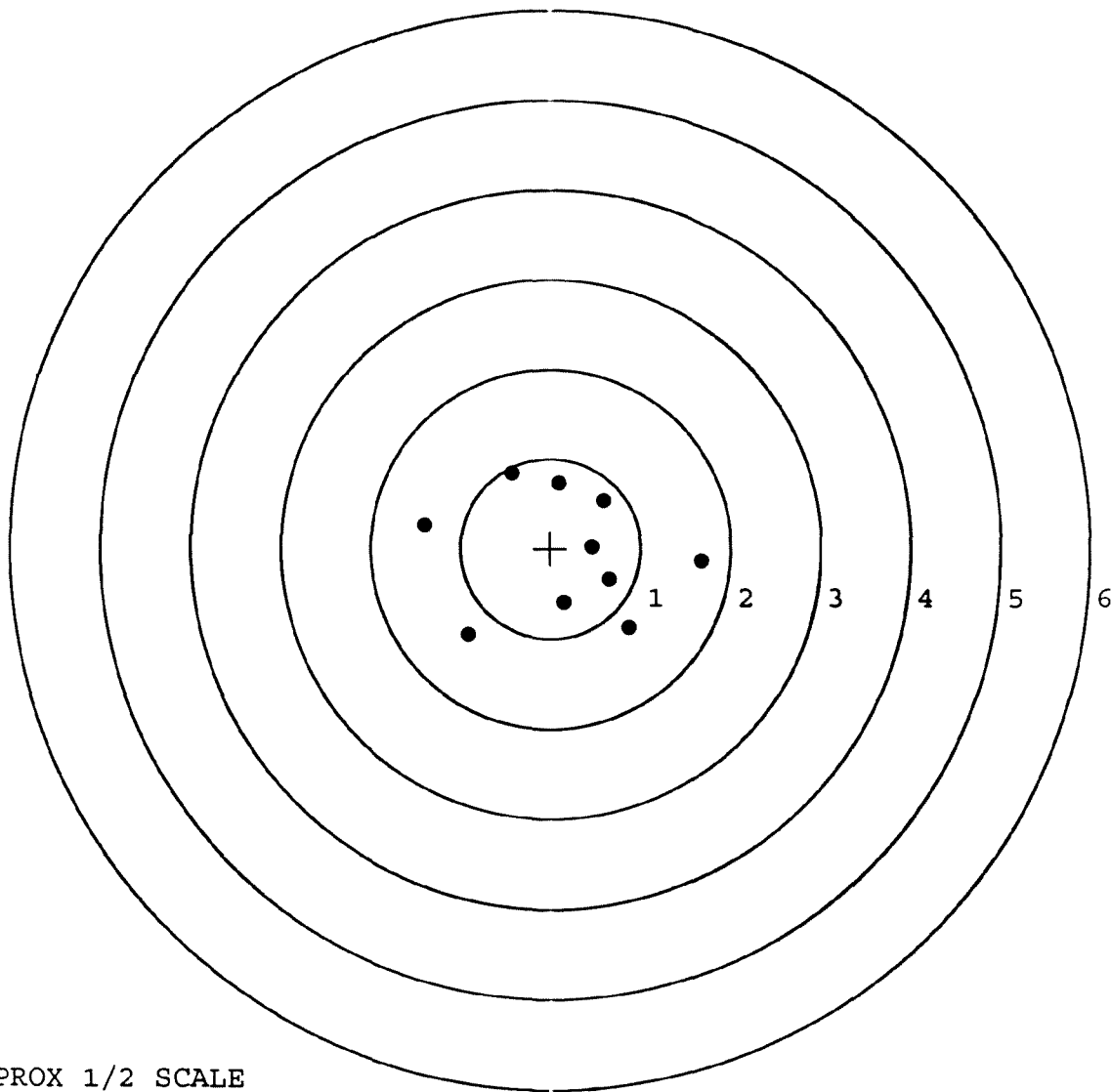


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699789. __0
 TARGET NUMBER: 5
 FILE DATE: 04/16/2008
 FILE TIME: 00:03

POINT#	X	Y
1:	-0.430	0.839
2:	0.096	0.733
3:	0.589	0.529
4:	0.463	0.014
5:	0.652	-0.350
6:	0.150	-0.605
7:	0.868	-0.883
8:	1.676	-0.145
9:	-0.914	-0.963
10:	-1.402	0.255

X CENTROID: 0.175
 Y CENTROID: -0.058
 POA TO CENTROID: 0.184
 HORZ SPREAD: 3.078
 VERT SPREAD: 1.802
 GROUP SPREAD: 3.104
 MIN RADIUS: 0.297
 MAX RADIUS: 1.607
 MEAN RADIUS: 0.960
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE