

16E56775

M24A2 SWS RIFLE -- W/OPTICS ONLY
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

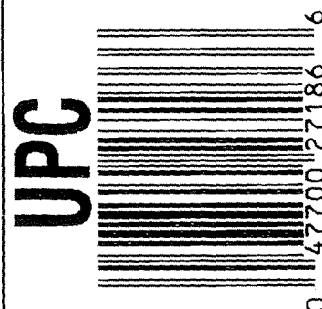


ORDER NO. **27186**

BARREL LENGTH **24"**

CAPACITY **6**

G6695391



ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

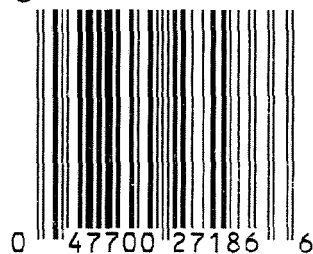
UPC



ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

UPC



SERIAL NO.



GUN SERIAL #

G669 5391

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		1-14-08	RTZ
420	ASSEMBLE ACTION		1-14-08	RTZ
430	ASSEMBLE TO STOCK		1-14-08	RTZ
440	PROOF		1-14-08	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	1-14-08	TRW
470	DIS-ASSEMBLE ACTION	2008		
480	MAGNAFLUX BBL ACTION		1/14/08	SMS
490	MAGNAFLUX BOLT	OPERATOR		
500	ROLLMARK CALIBER		1/15/08	(S)
510	DRILL AND TAP SIGHT HOLES		1-15-08	Yy
520	GOFF BLAST BBL / REC			
530 & 540	APPLY COATINGS (BARREL ACTION)		1/15/08	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-16-08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-16-08	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-16-08	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-16-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

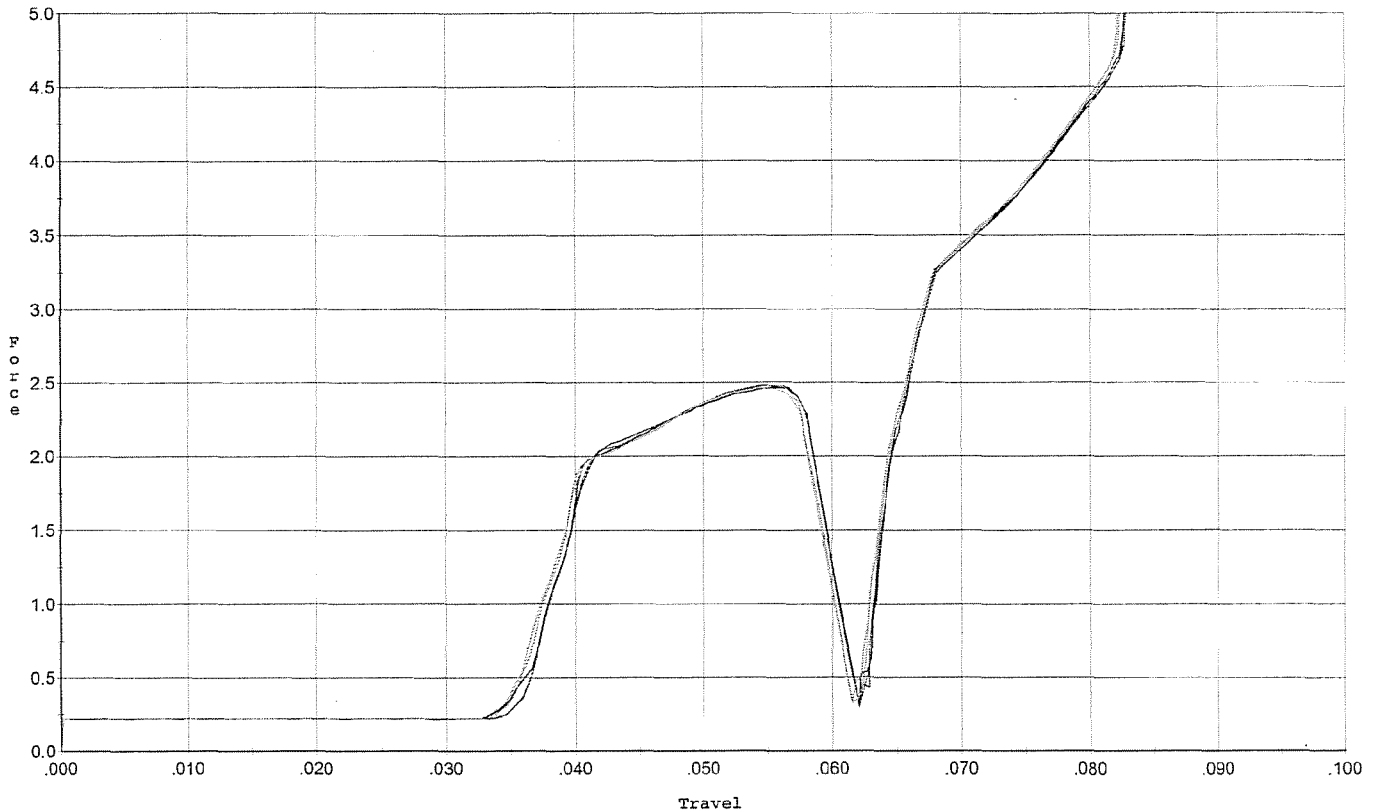
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.2</u> <u>7.5</u> <u>7.5</u>	1-18-08	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	1-18-08	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.022</u>	1-18-08	RA
	J) ASSEMBLE STOCK		1-16-08	RT
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N/A		
	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	1-17-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-17-08	Fm
670	FINAL INSPECTION A) HEADSPACE		1-18-08	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.35</u> <u>2.35</u> <u>2.30</u> <u>2.30</u>	1-18-08	RA
	C) FUNCTION		1-18-08	RT
690	PACK			

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



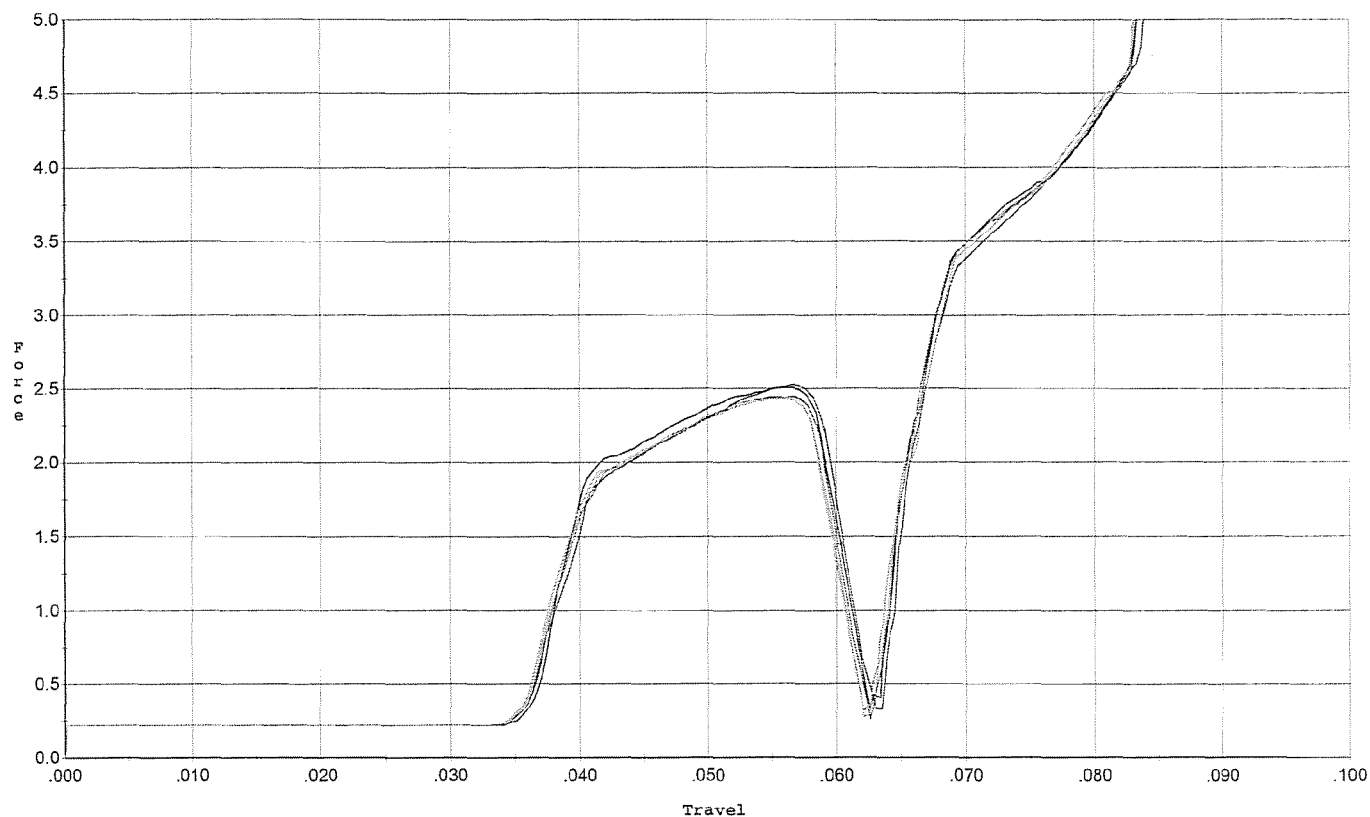
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.058	0.036	0.031	0.054		Set Trigger
2	2.465	0.058	0.035	0.031	0.054		Set Trigger
3	2.482	0.058	0.036	0.031	0.054		Set Trigger
4	2.464	0.059	0.035	0.031	0.056		Set Trigger
5	2.484	0.059	0.035	0.030	0.056		Set Trigger

AVG 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



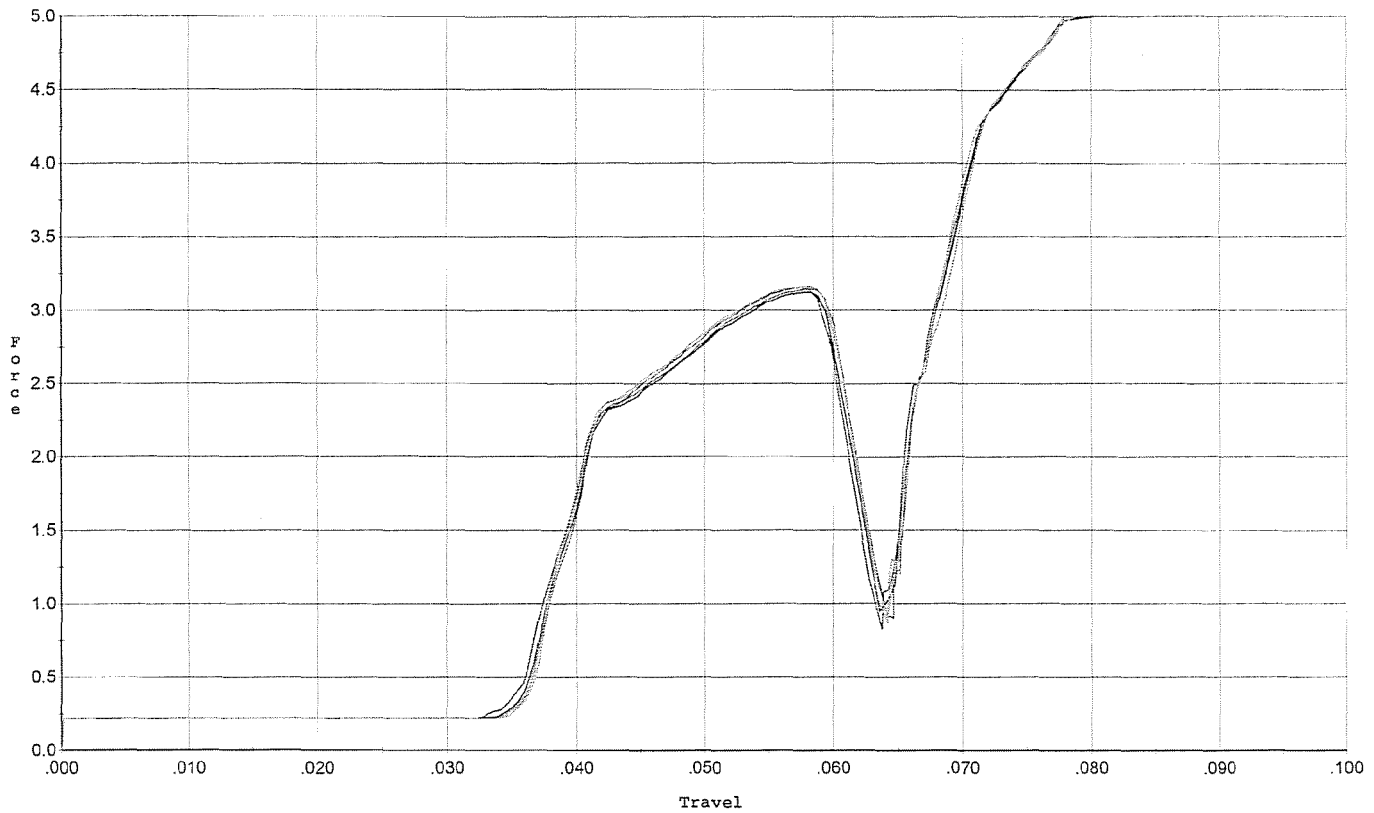
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.526	0.059	0.036	0.031	0.056		Set Trigger
2	2.506	0.060	0.036	0.031	0.057		Set Trigger
3	2.445	0.059	0.036	0.031	0.054		Set Trigger
4	2.442	0.060	0.036	0.031	0.056		Set Trigger
5	2.431	0.059	0.036	0.031	0.055		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



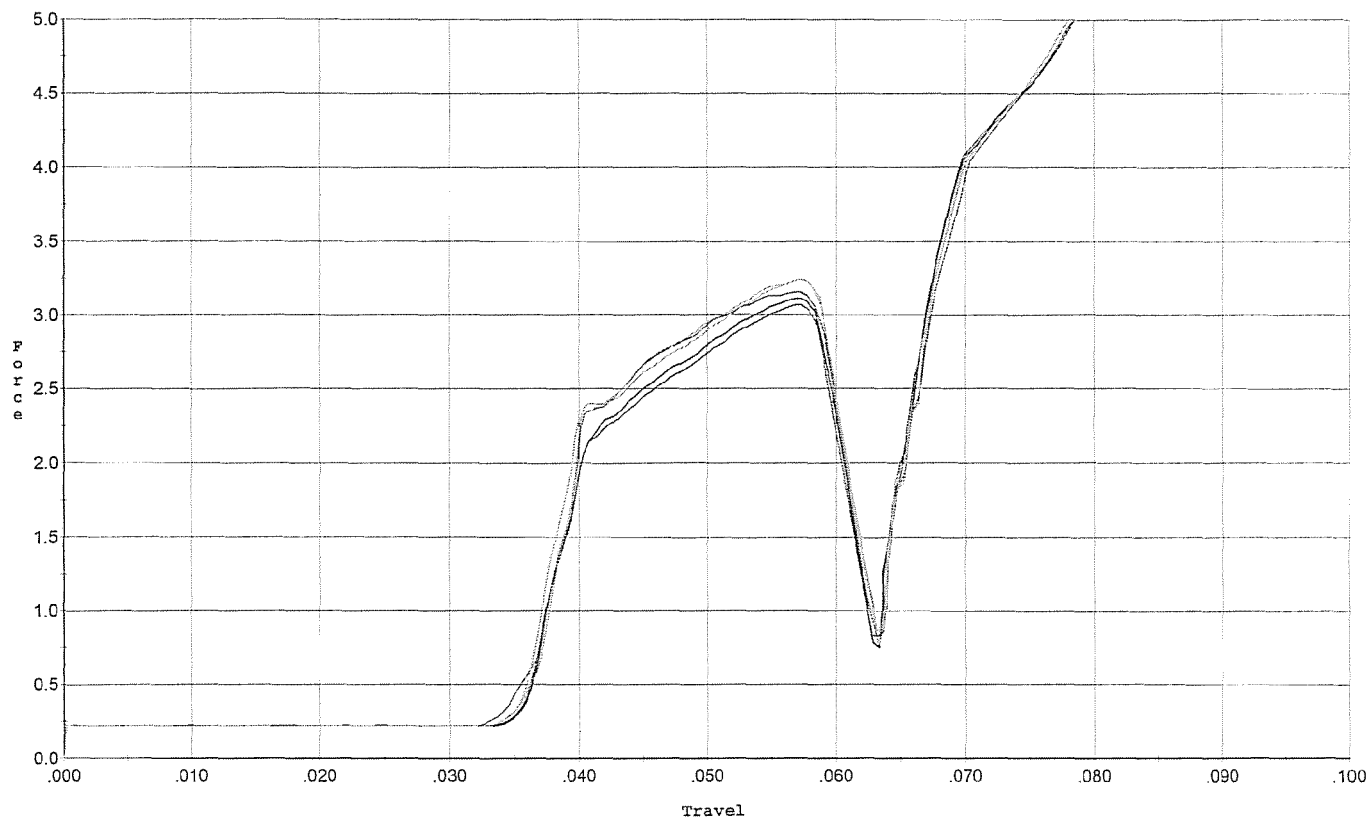
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.149	0.060	0.036	0.029	0.069		Set Trigger
2	3.123	0.061	0.036	0.029	0.070		Set Trigger
3	3.145	0.060	0.036	0.029	0.069		Set Trigger
4	3.160	0.060	0.036	0.029	0.069		Set Trigger
5	3.166	0.060	0.036	0.029	0.070		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



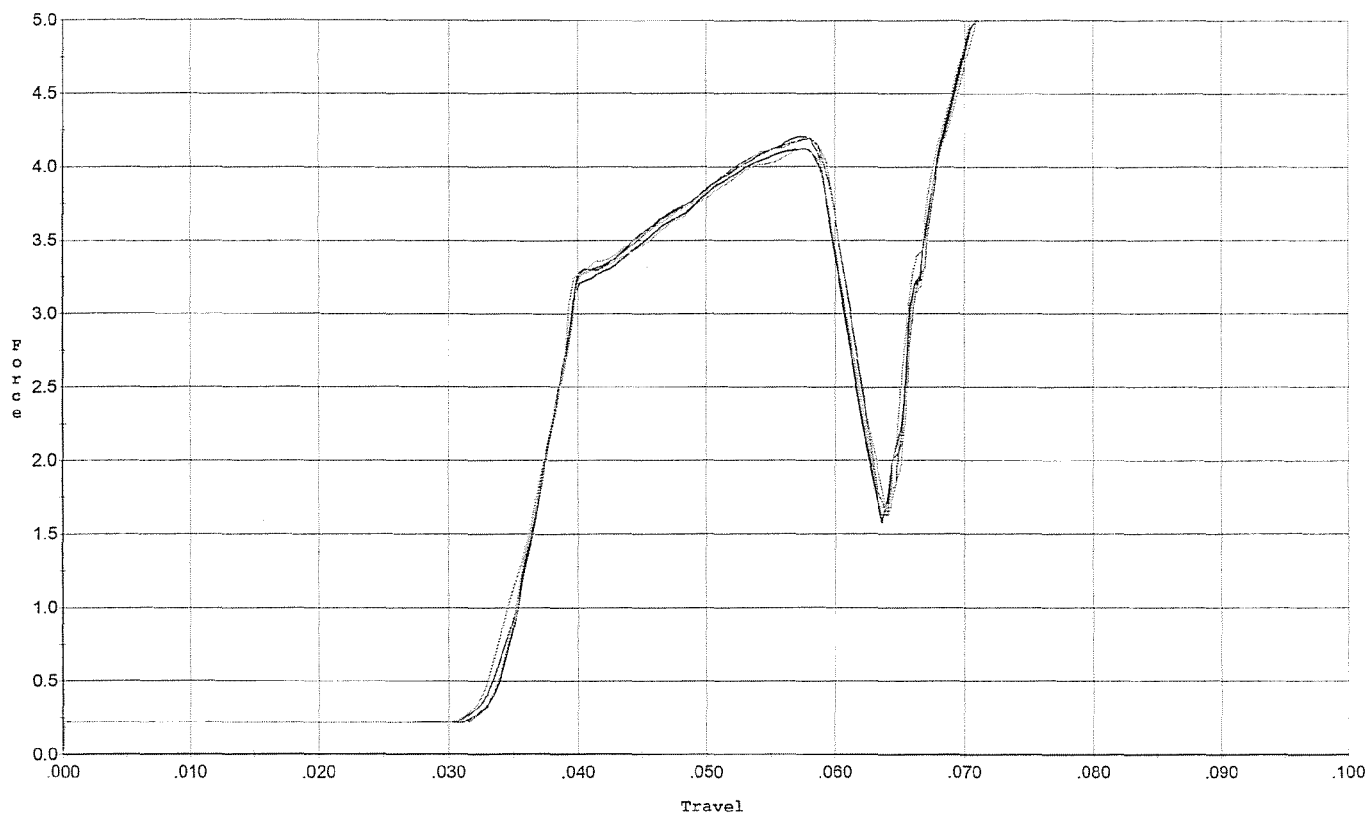
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.059	0.036	0.029	0.065		Set Trigger
2	3.113	0.060	0.036	0.029	0.067		Set Trigger
3	3.155	0.059	0.035	0.029	0.069		Set Trigger
4	3.242	0.059	0.035	0.029	0.070		Set Trigger
5	3.240	0.059	0.036	0.029	0.069		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



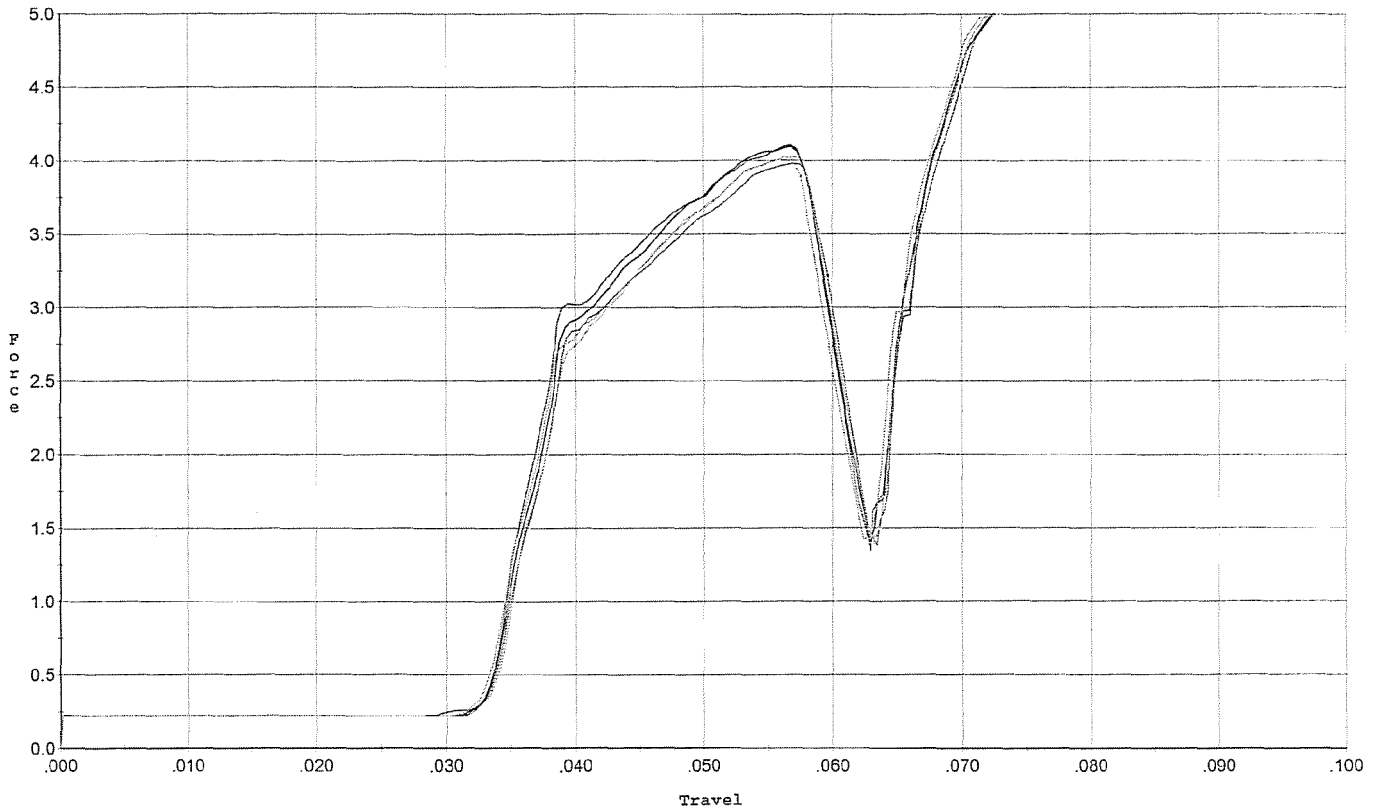
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.204	0.059	0.033	0.024	0.094		Set Trigger
2	4.127	0.059	0.033	0.023	0.093		Set Trigger
3	4.191	0.060	0.033	0.023	0.096		Set Trigger
4	4.121	0.059	0.032	0.023	0.094		Set Trigger
5	4.194	0.059	0.033	0.023	0.096		Set Trigger

AVG 4.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 1/15/08

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



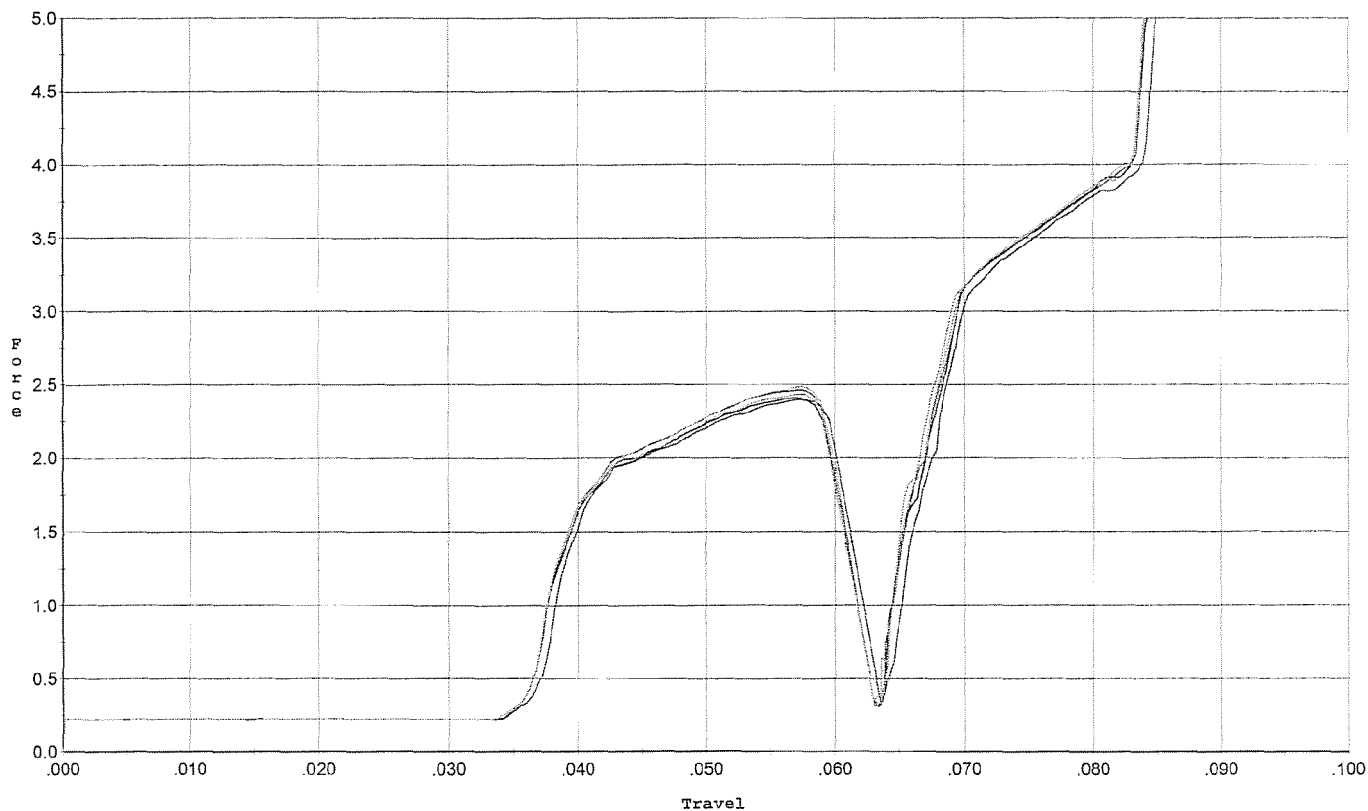
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.058	0.033	0.026	0.090		Set Trigger
2	4.098	0.058	0.033	0.026	0.088		Set Trigger
3	3.981	0.060	0.033	0.026	0.089		Set Trigger
4	4.029	0.058	0.034	0.026	0.086		Set Trigger
5	4.030	0.058	0.033	0.026	0.086		Set Trigger

AVG 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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



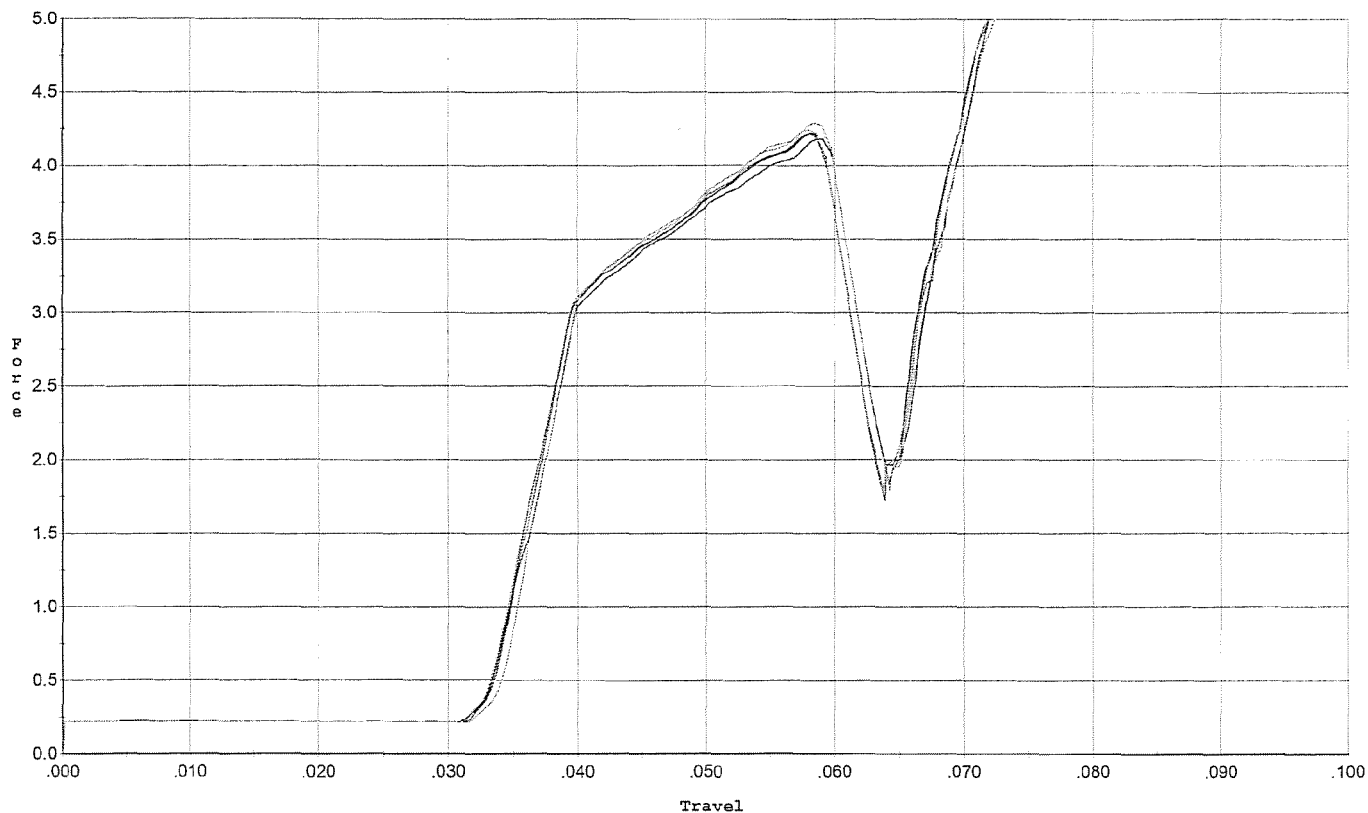
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.393	0.061	0.037	0.031	0.057		Set Trigger
2	2.407	0.061	0.036	0.031	0.057		Set Trigger
3	2.458	0.060	0.036	0.031	0.057		Set Trigger
4	2.480	0.060	0.036	0.031	0.057		Set Trigger
5	2.428	0.061	0.036	0.031	0.057		Set Trigger

AVG 2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 1/15/08

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	4.185	0.060	0.033	0.027	0.096		Set Trigger
2	4.220	0.059	0.033	0.027	0.095		Set Trigger
3	4.218	0.059	0.033	0.027	0.096		Set Trigger
4	4.247	0.059	0.033	0.027	0.096		Set Trigger
5	4.291	0.060	0.034	0.027	0.097		Set Trigger

AVG 4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695391.___0
FILE DATE AND TIME: 01/18/2008 12:15

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.072
The Average Y Centroid of the Five Target Set:	-0.147
The Average Point of Impact of the Five Target Set:	0.164
The Average Mean Radius of the Five Target Set:	0.667
The Distance from POA to Centroid Target #1:	0.274
The Distance from Centroid Target #2 to Centroid Target #1:	0.262
The Distance from Centroid Target #3 to Centroid Target #1:	0.246
The Distance from Centroid Target #4 to Centroid Target #1:	0.101
The Distance from Centroid Target #5 to Centroid Target #1:	0.208

BARBER - M24 0179715

SERIAL NUMBER: G6695391. 0

TARGET NUMBER: 1

FILE DATE: 01/18/2008

FILE TIME: 12:15

POINT#	X	Y
1:	0.472	-0.955
2:	1.538	-0.438
3:	1.108	-0.003
4:	0.527	-0.383
5:	0.231	0.009
6:	-0.017	-0.370
7:	-0.115	-0.158
8:	-0.667	-0.489
9:	-0.542	0.201
10:	-0.336	0.949

X CENTROID: 0.220

Y CENTROID: -0.164

POA TO CENTROID: 0.274

HORZ SPREAD: 2.205

VERT SPREAD: 1.904

GROUP SPREAD: 2.331

MIN RADIUS: 0.173

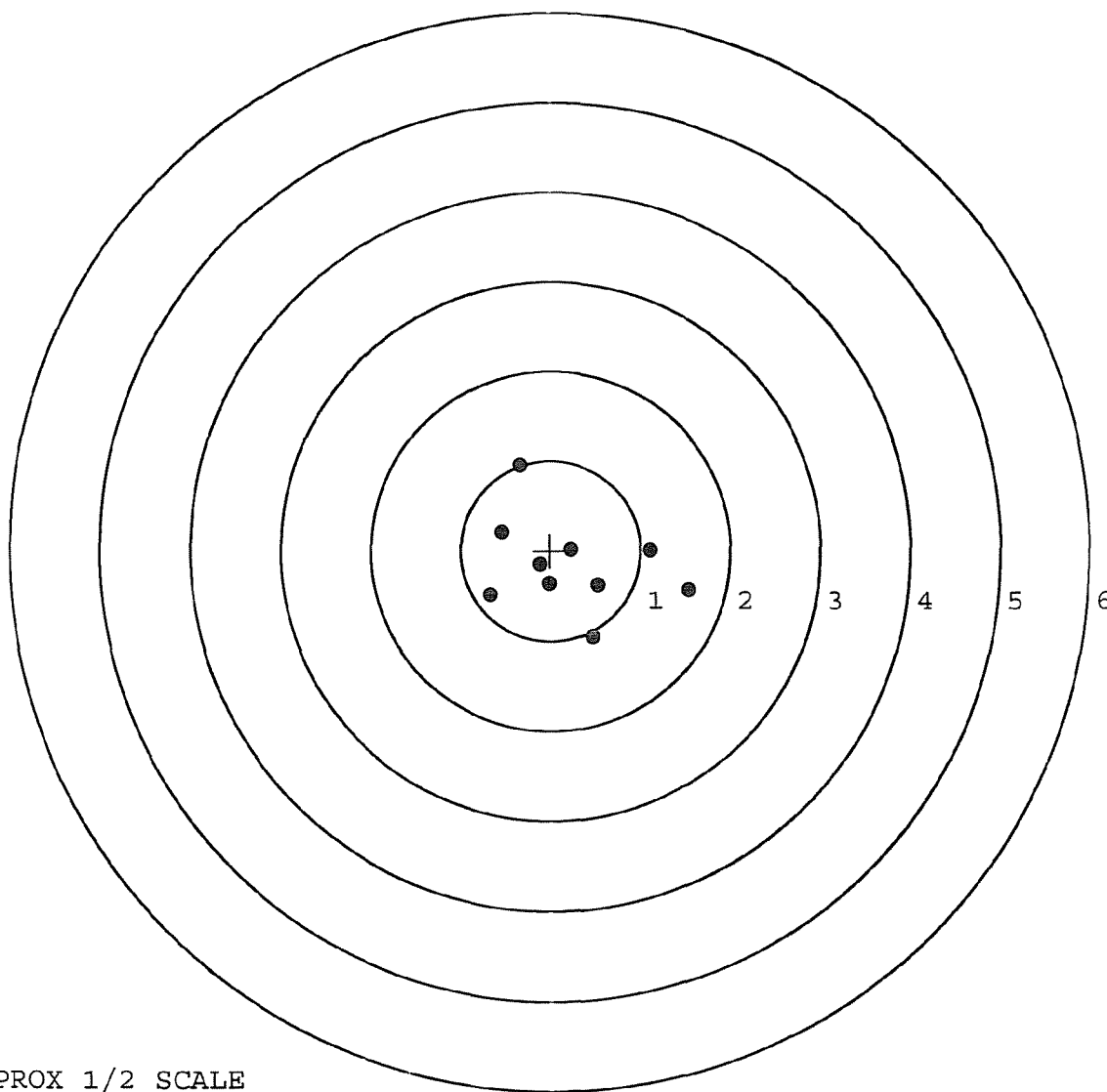
MAX RADIUS: 1.346

MEAN RADIUS: 0.731

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



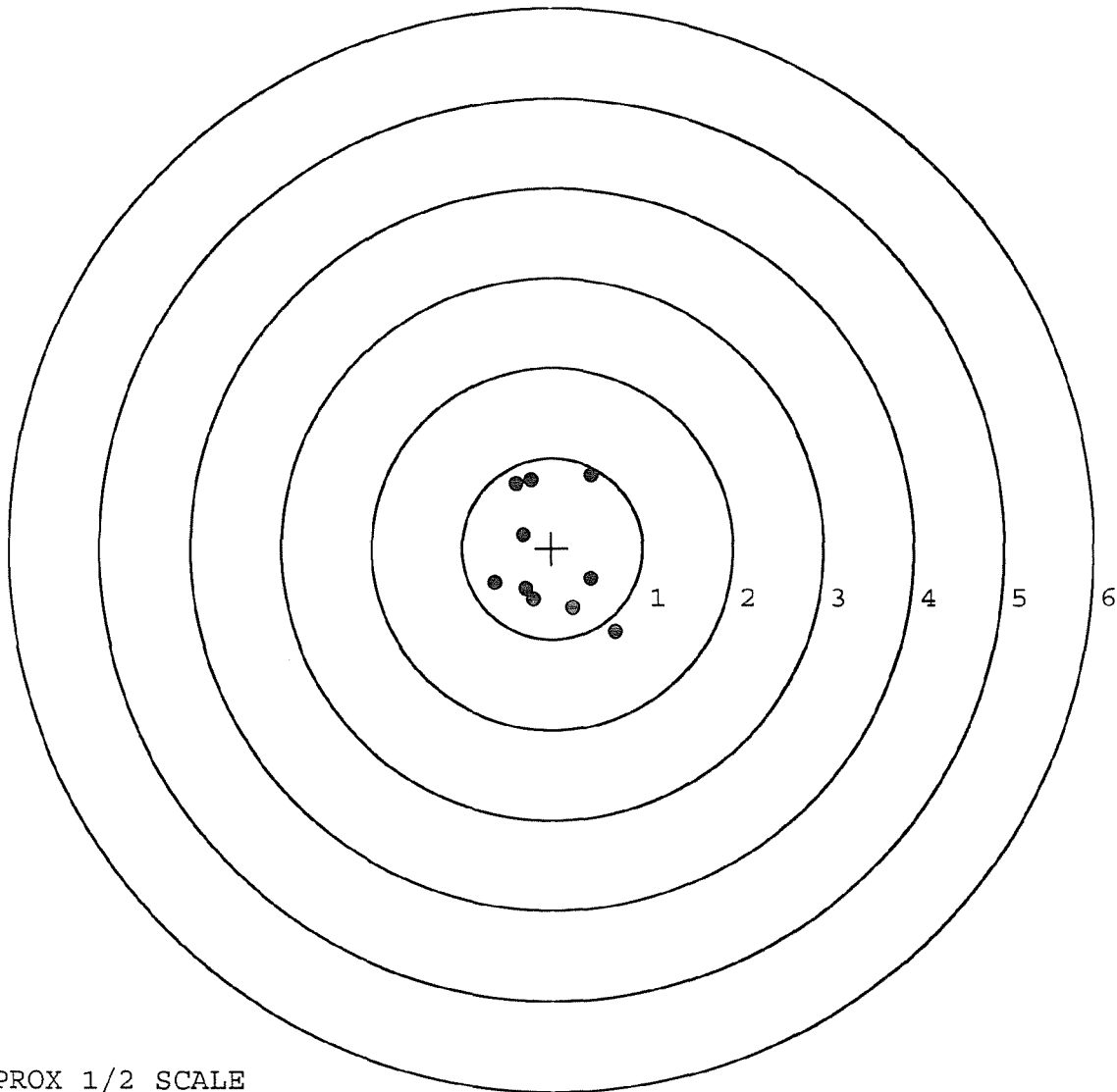
TARGET APPROX 1/2 SCALE

BARBER - M24 0179716

SERIAL NUMBER: G6695391. 0
 TARGET NUMBER: 2
 FILE DATE: 01/18/2008
 FILE TIME: 12:15

POINT#	X	Y
1:	0.700	-0.921
2:	0.427	-0.334
3:	0.227	-0.664
4:	-0.211	-0.573
5:	-0.298	-0.449
6:	-0.640	-0.383
7:	-0.322	0.153
8:	-0.394	0.720
9:	-0.231	0.754
10:	0.434	0.808

X CENTROID: -0.031
 Y CENTROID: -0.089
 POA TO CENTROID: 0.094
 HORZ SPREAD: 1.340
 VERT SPREAD: 1.729
 GROUP SPREAD: 1.972
 MIN RADIUS: 0.379
 MAX RADIUS: 1.107
 MEAN RADIUS: 0.704
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0179717

SERIAL NUMBER: G6695391. 0

TARGET NUMBER: 3

FILE DATE: 01/18/2008

FILE TIME: 12:15

POINT#	X	Y
1:	-0.583	0.044
2:	-0.573	-0.534
3:	-0.327	0.071
4:	-0.048	0.390
5:	0.072	0.122
6:	0.365	0.268
7:	0.365	-0.066
8:	0.164	-0.229
9:	-0.006	-0.406
10:	0.413	-1.995

X CENTROID: -0.016

Y CENTROID: -0.233

POA TO CENTROID: 0.234

HORZ SPREAD: 0.996

VERT SPREAD: 2.385

GROUP SPREAD: 2.429

MIN RADIUS: 0.173

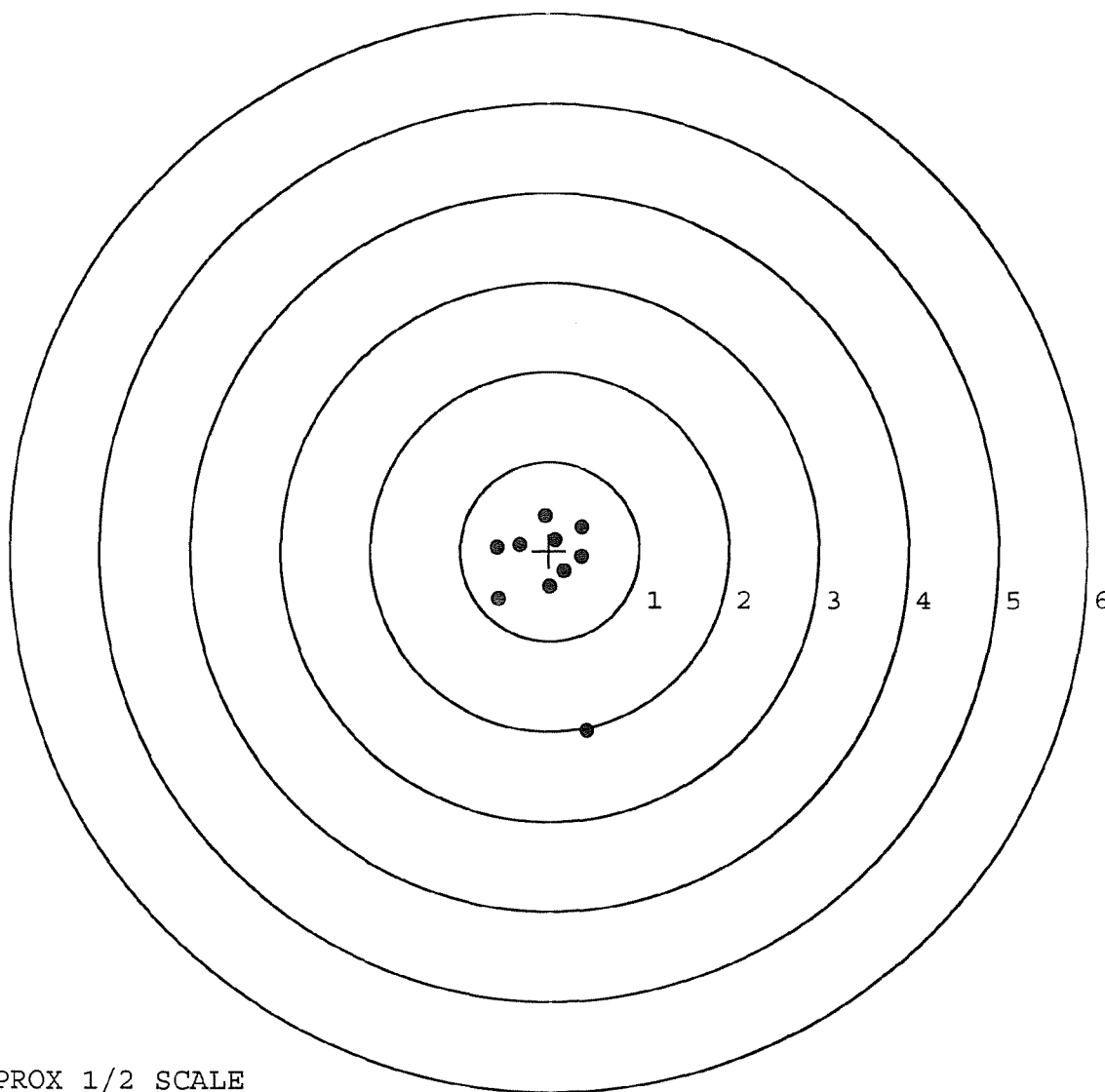
MAX RADIUS: 1.813

MEAN RADIUS: 0.590

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0179718

SERIAL NUMBER: G6695391. 0

TARGET NUMBER: 4

FILE DATE: 01/18/2008

FILE TIME: 12:15

POINT#	X	Y
1:	1.358	-0.975
2:	0.828	-0.359
3:	0.485	-0.523
4:	0.516	-0.167
5:	0.374	0.010
6:	0.206	0.387
7:	-0.101	-0.299
8:	-0.299	0.131
9:	-0.873	0.426
10:	-1.176	-0.752

X CENTROID: 0.132

Y CENTROID: -0.212

POA TO CENTROID: 0.250

HORZ SPREAD: 2.534

VERT SPREAD: 1.401

GROUP SPREAD: 2.634

MIN RADIUS: 0.248

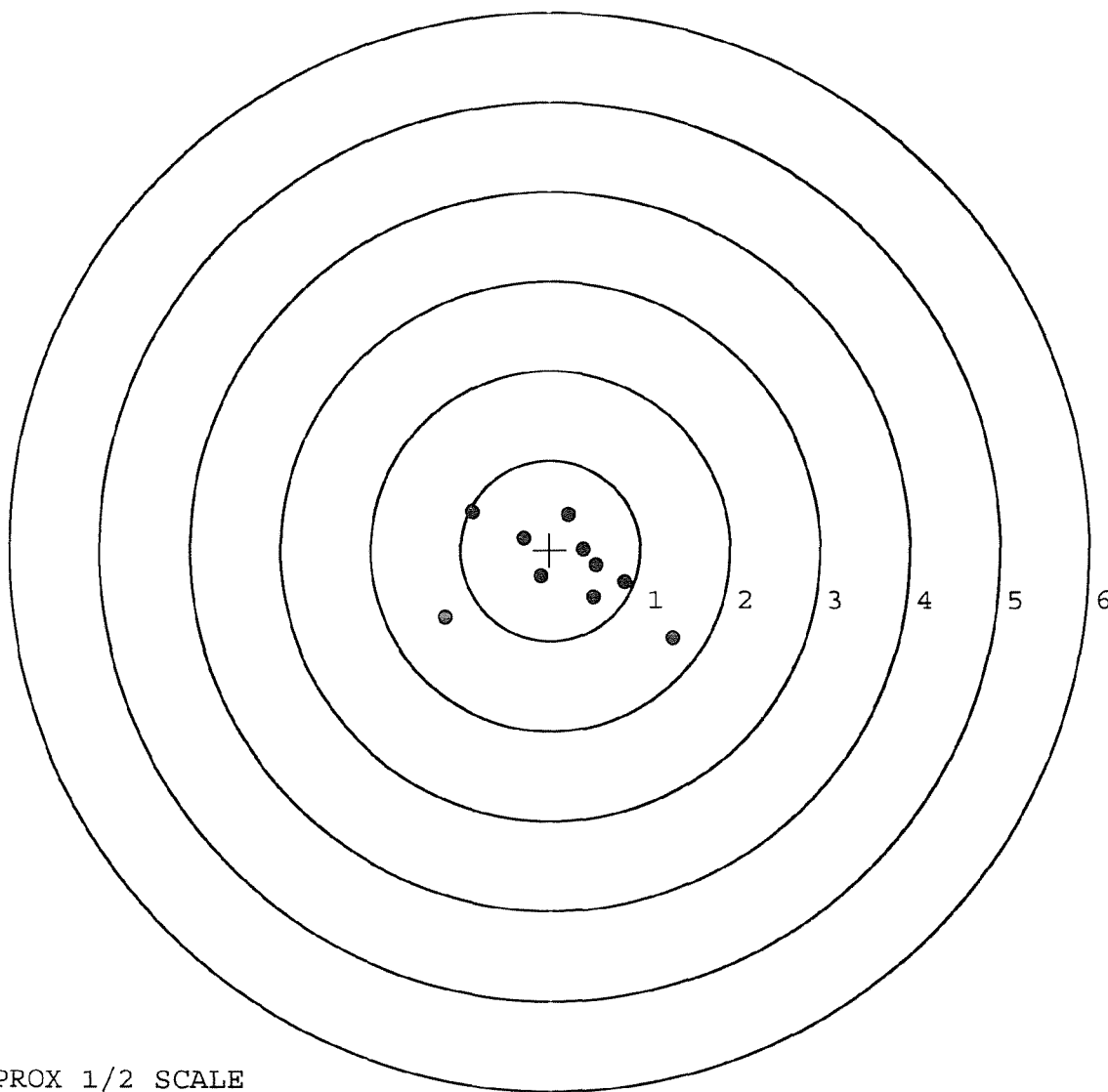
MAX RADIUS: 1.444

MEAN RADIUS: 0.735

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0179719

SERIAL NUMBER: G6695391. __0

TARGET NUMBER: 5

FILE DATE: 01/18/2008

FILE TIME: 12:15

POINT#	X	Y
1:	1.226	-0.318
2:	0.362	0.402
3:	-0.291	0.680
4:	-0.355	0.374
5:	-0.710	-0.031
6:	-0.128	0.184
7:	0.186	-0.184
8:	0.070	-0.233
9:	0.233	-0.626
10:	-0.035	-0.609

X CENTROID: 0.056

Y CENTROID: -0.036

POA TO CENTROID: 0.066

HORZ SPREAD: 1.936

VERT SPREAD: 1.306

GROUP SPREAD: 1.957

MIN RADIUS: 0.197

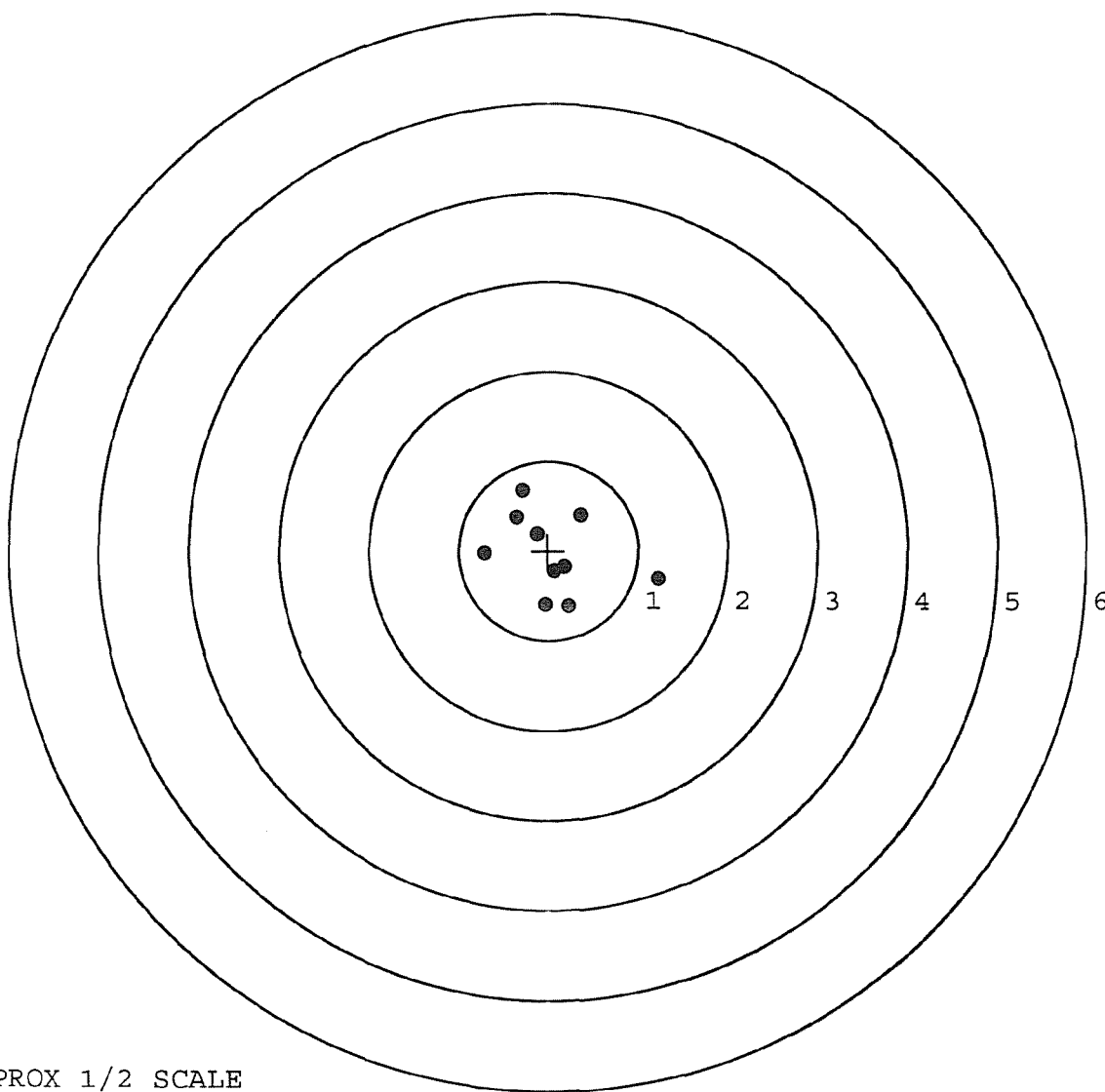
MAX RADIUS: 1.204

MEAN RADIUS: 0.576

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE