

G669 5340-5

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

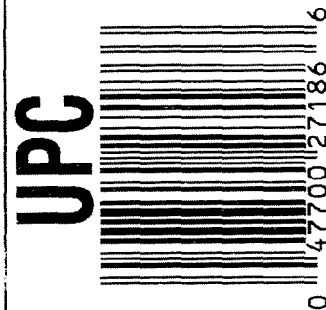
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	27186
BARREL LENGTH	24"
CAPACITY	6

G6695365



ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

UPC



ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

UPC



SERIAL NO.



GUN SERIAL # G6695365

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		1-14-08	TRW
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION		1/14/08	SMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		1/15/08	HS
510	DRILL AND TAP SIGHT HOLES		1-15-08	TRW
520	GOFF BLAST BBL / REC		1/15/08	TRW
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(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

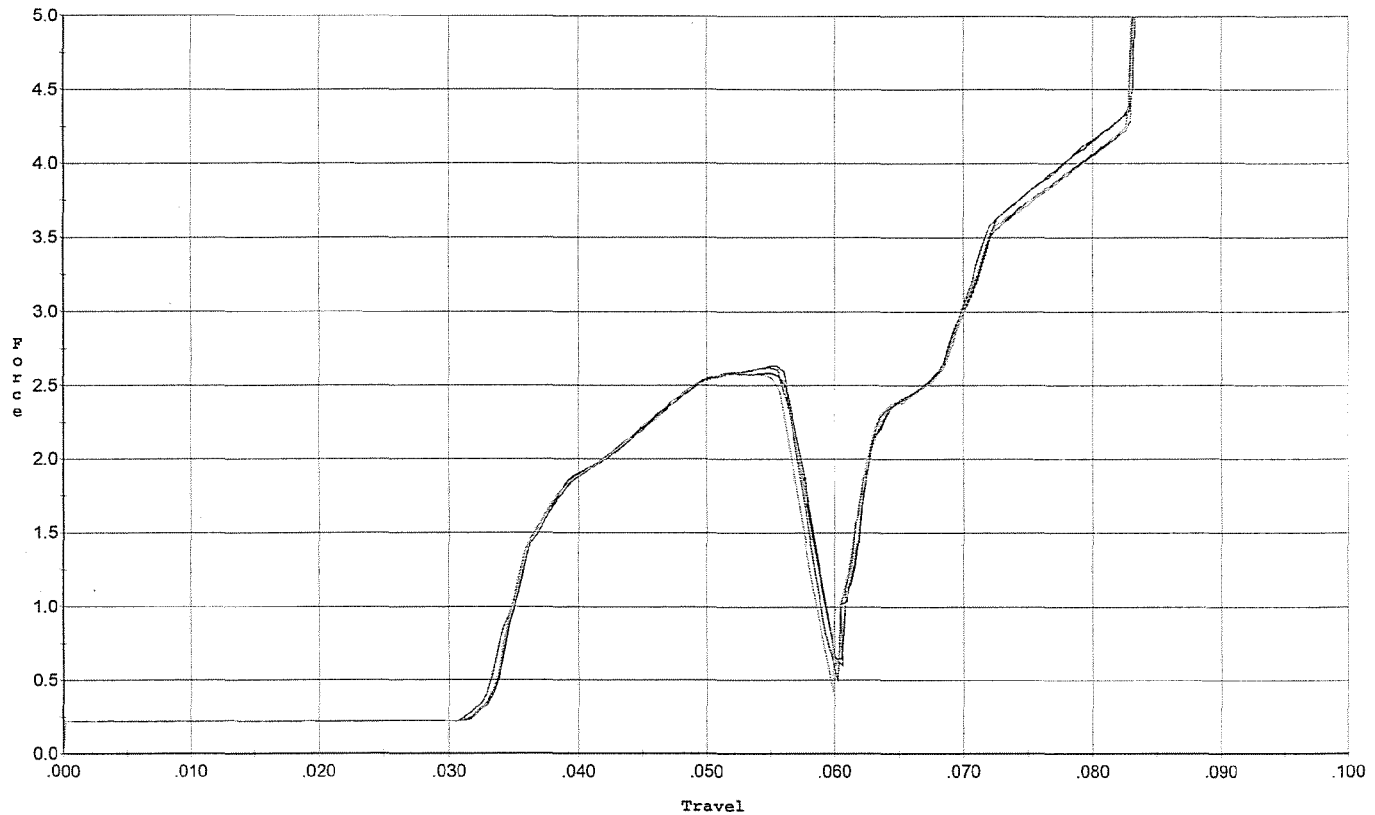
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.5</u> <u>80</u> <u>80</u>	1-18-08	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	1-18-08	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	1-18-08	DA
	J) ASSEMBLE STOCK		1-16-08	RT
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	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>2.70</u> <u>2.75</u> <u>2.70</u> <u>2.80</u> <u>2.75</u>	1-18-08	DA
	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.



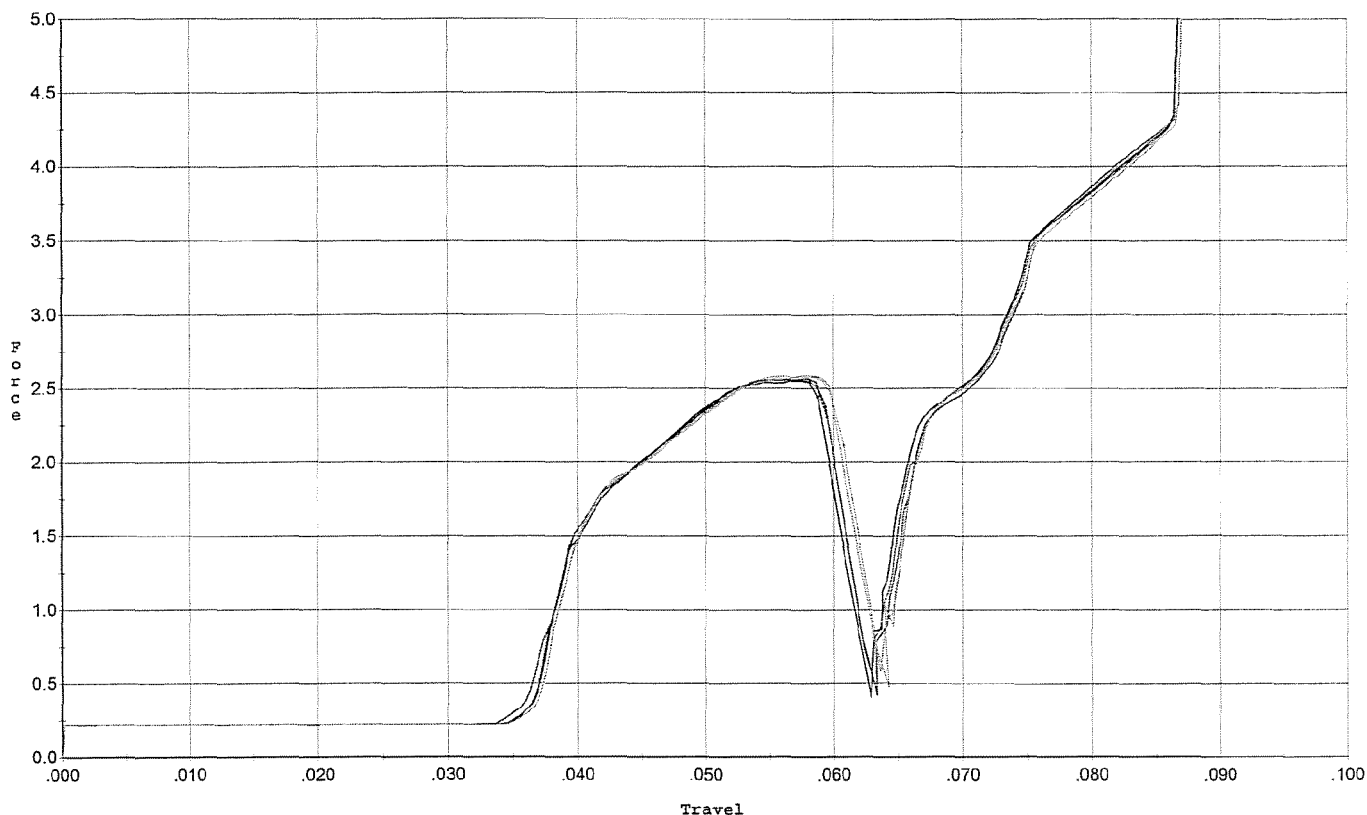
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.634	0.058	0.033	0.032	0.058		Set Trigger
2	2.582	0.056	0.033	0.033	0.056		Set Trigger
3	2.624	0.056	0.033	0.032	0.057		Set Trigger
4	2.583	0.056	0.033	0.033	0.055		Set Trigger
5	2.625	0.056	0.033	0.033	0.056		Set Trigger

Avg 2.61

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.



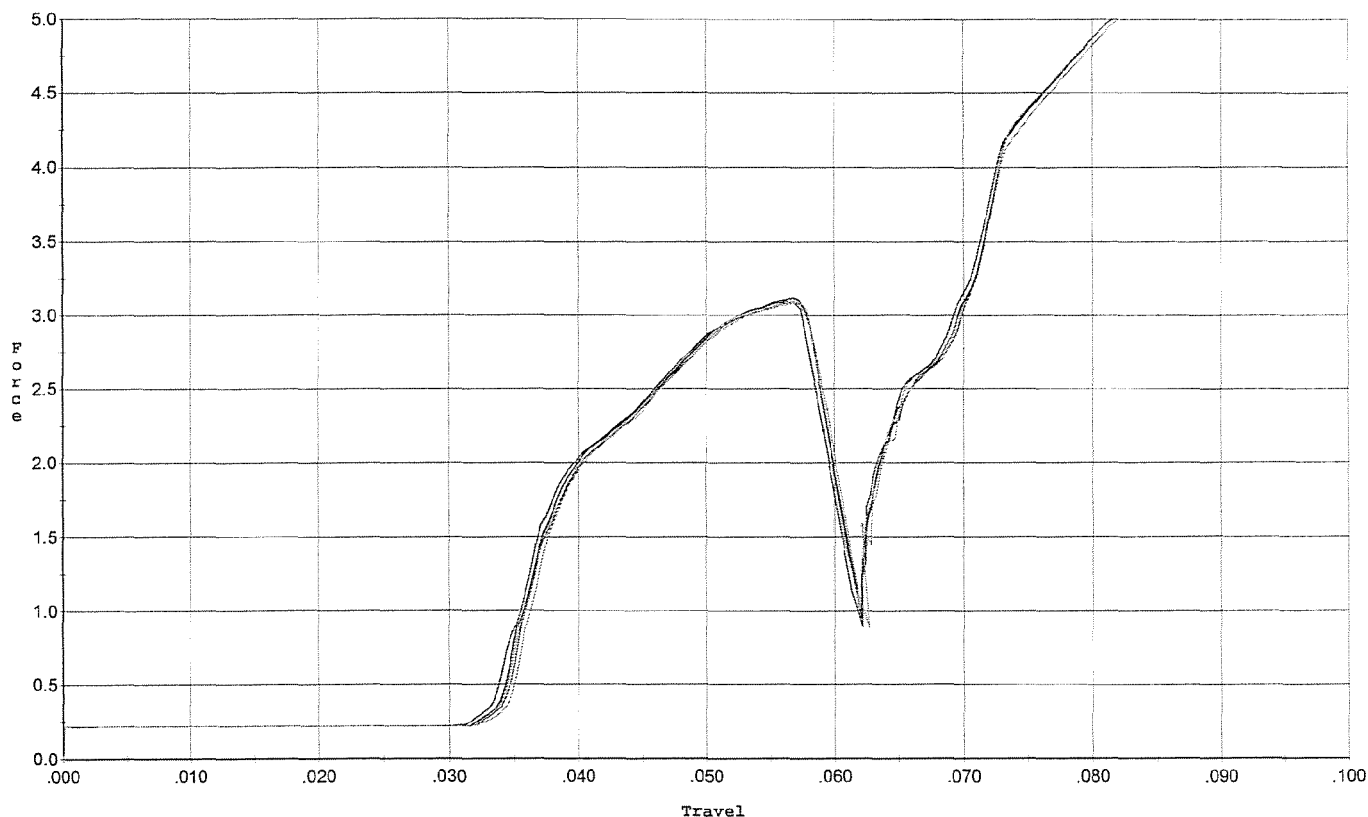
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.562	0.059	0.036	0.033	0.057		Set Trigger
2	2.548	0.059	0.037	0.034	0.055		Set Trigger
3	2.555	0.059	0.037	0.033	0.057		Set Trigger
4	2.576	0.060	0.037	0.033	0.057		Set Trigger
5	2.586	0.061	0.037	0.032	0.059		Set Trigger

Avg 2.56

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.



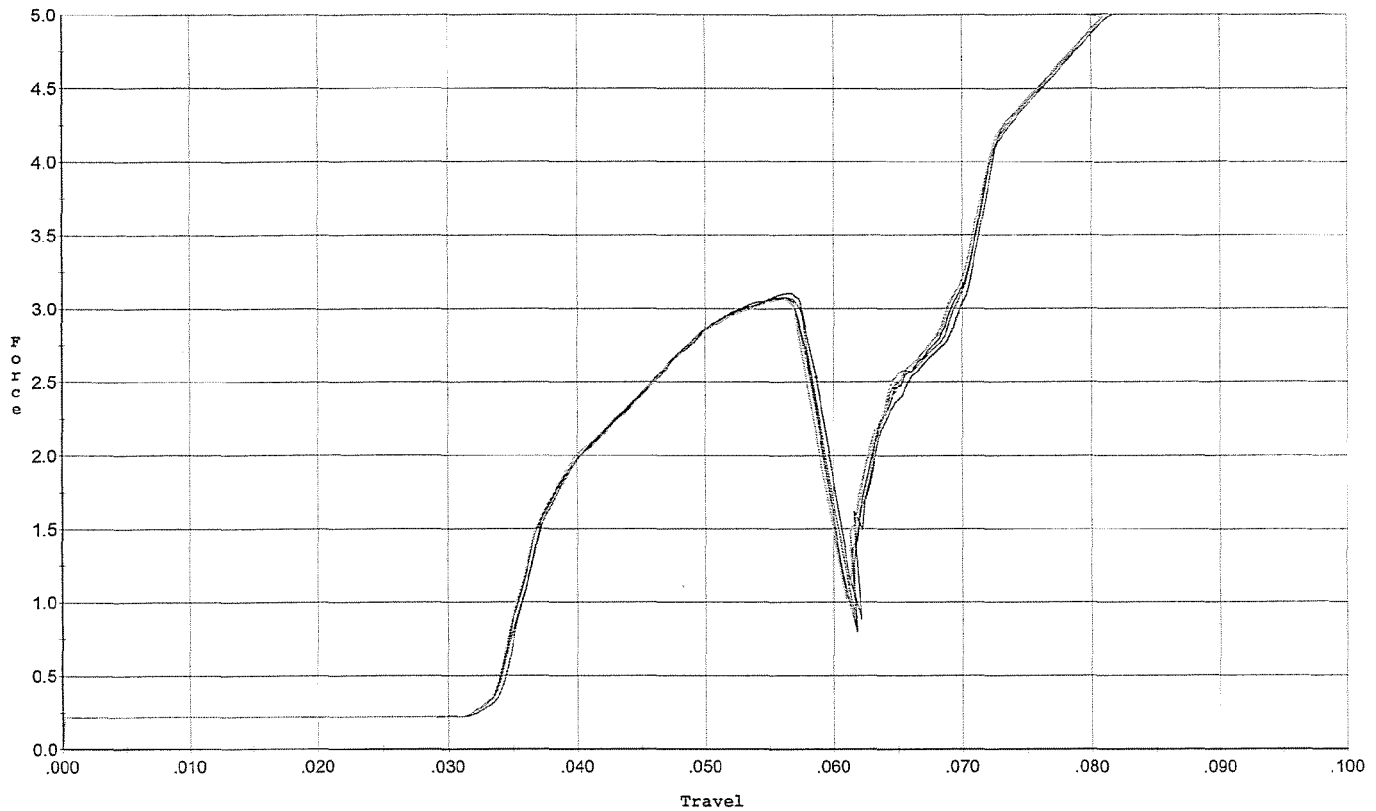
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.059	0.033	0.031	0.068		Set Trigger
2	3.120	0.058	0.034	0.031	0.066		Set Trigger
3	3.091	0.058	0.034	0.031	0.065		Set Trigger
4	3.087	0.059	0.035	0.031	0.067		Set Trigger
5	3.097	0.058	0.034	0.031	0.066		Set Trigger

Avg 3.09

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.



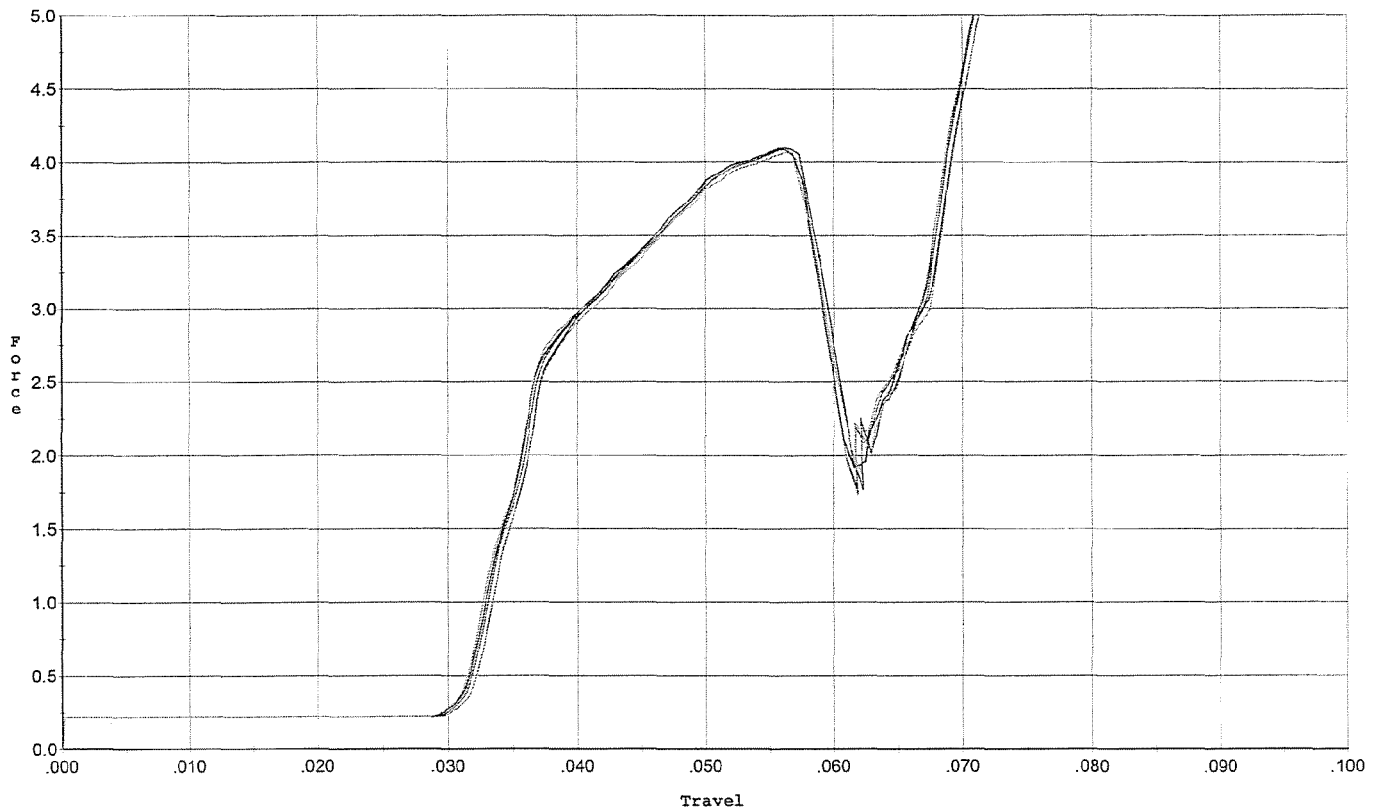
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.102	0.059	0.034	0.031	0.067		Set Trigger
2	3.076	0.058	0.034	0.031	0.066		Set Trigger
3	3.074	0.057	0.034	0.031	0.065		Set Trigger
4	3.064	0.057	0.034	0.032	0.064		Set Trigger
5	3.069	0.058	0.034	0.031	0.065		Set Trigger

Avg 3.07

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.



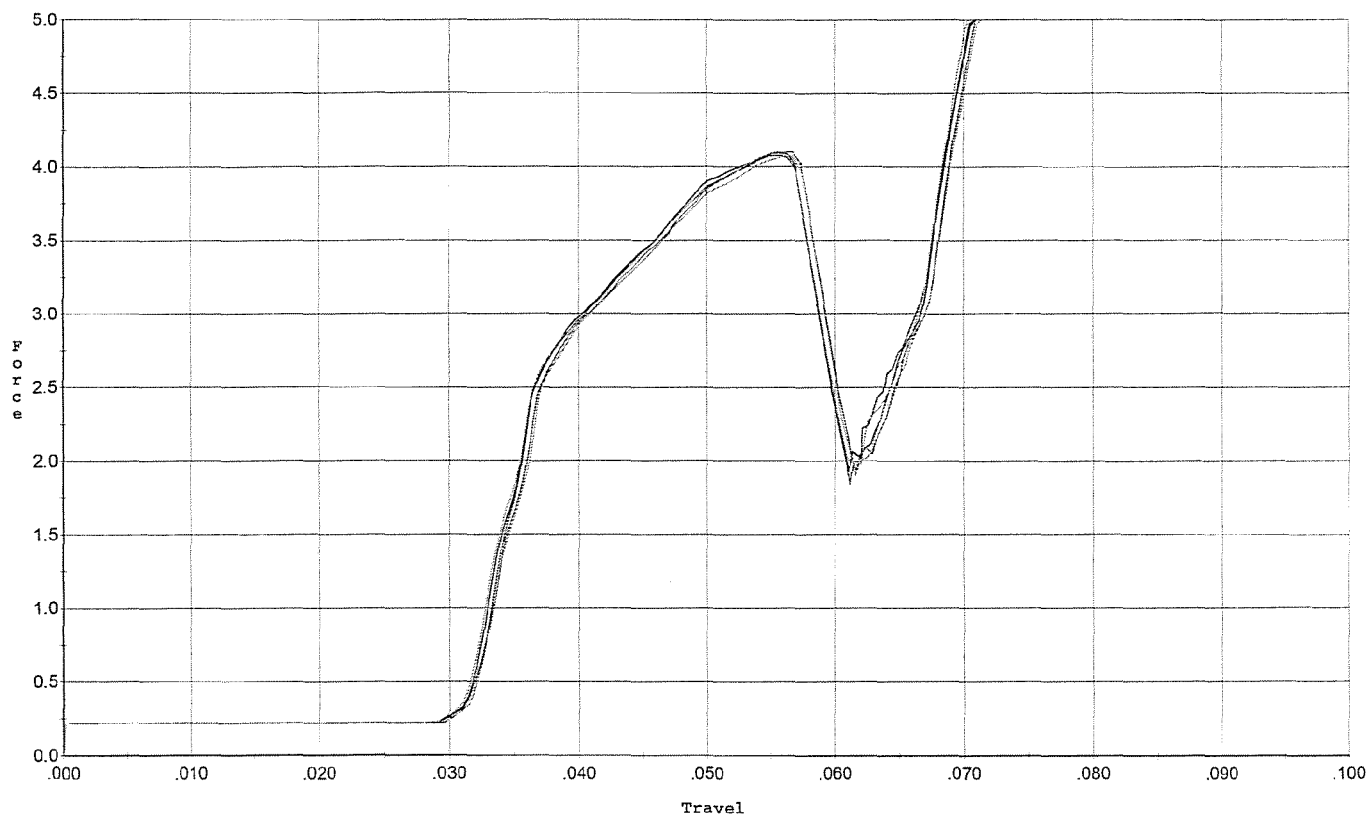
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.097	0.059	0.032	0.026	0.093		Set Trigger
2	4.091	0.058	0.031	0.026	0.091		Set Trigger
3	4.084	0.058	0.031	0.026	0.091		Set Trigger
4	4.066	0.057	0.032	0.026	0.089		Set Trigger
5	4.099	0.058	0.031	0.026	0.092		Set Trigger

AVG 4.08

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.



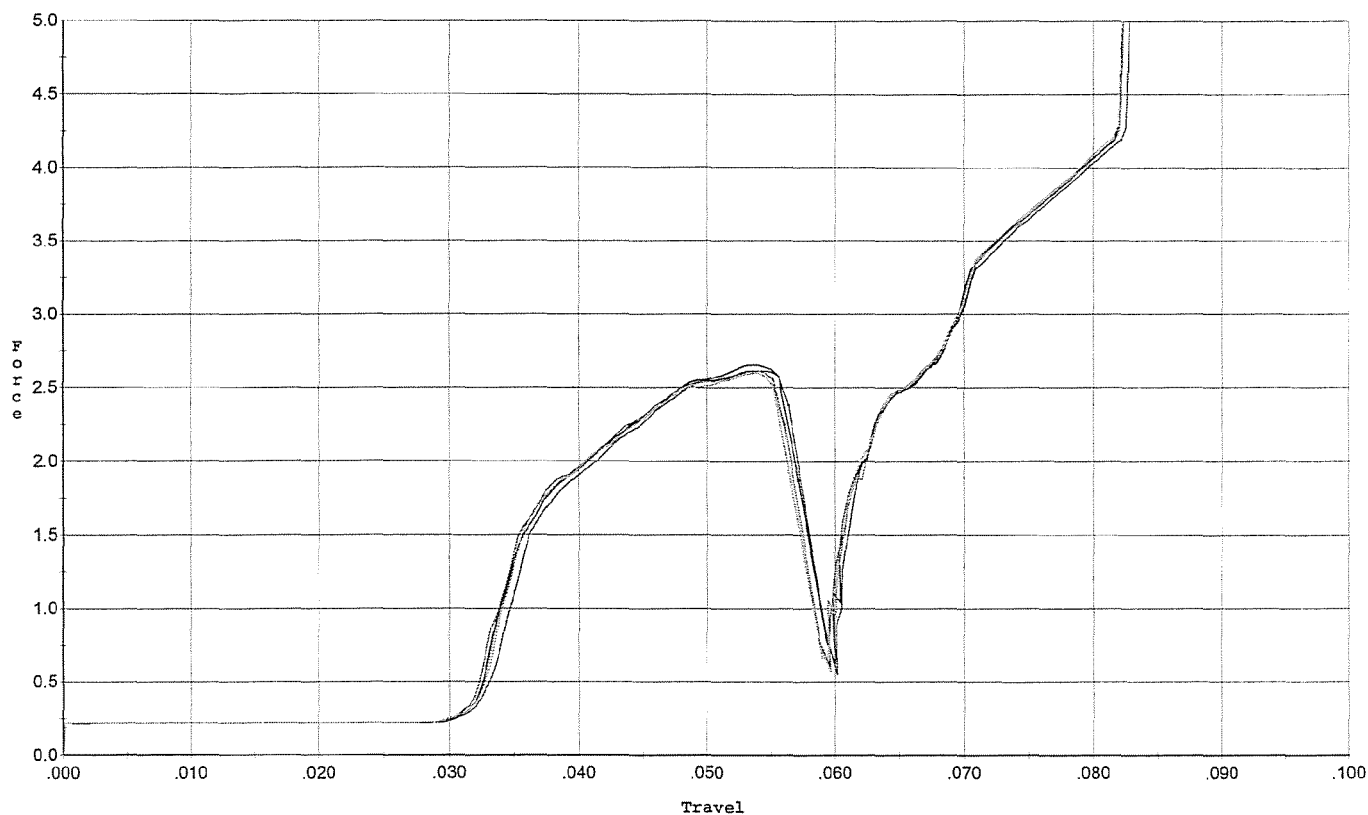
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.077	0.057	0.031	0.026	0.089		Set Trigger
2	4.091	0.057	0.031	0.026	0.090		Set Trigger
3	4.104	0.057	0.032	0.025	0.090		Set Trigger
4	4.104	0.057	0.031	0.025	0.090		Set Trigger
5	4.077	0.057	0.032	0.025	0.089		Set Trigger

Avg 4.09

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



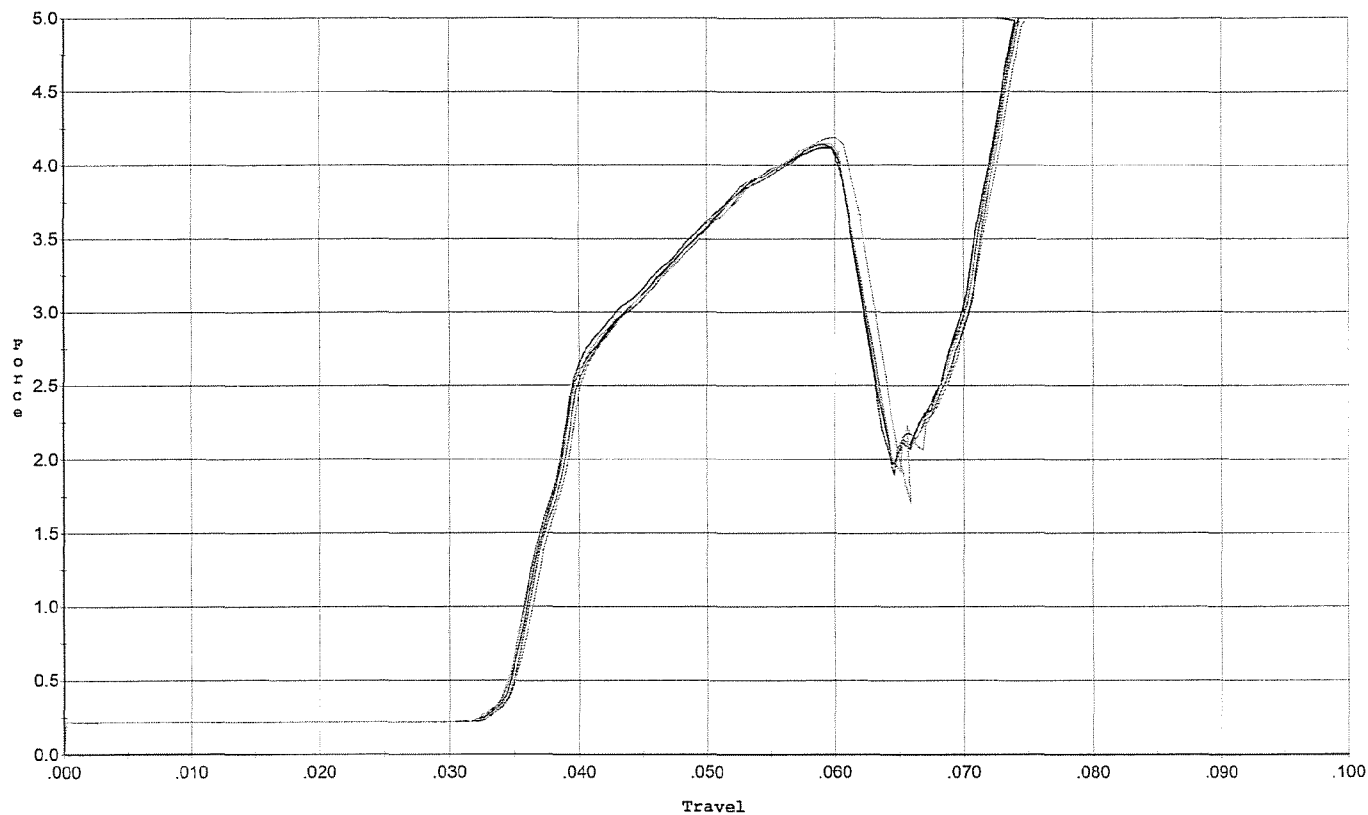
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.056	0.032	0.032	0.057		Set Trigger
2	2.653	0.057	0.032	0.032	0.059		Set Trigger
3	2.614	0.056	0.032	0.032	0.058		Set Trigger
4	2.615	0.056	0.032	0.032	0.057		Set Trigger
5	2.596	0.057	0.032	0.032	0.058		Set Trigger

Avg 2.61

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	4.144	0.061	0.034	0.025	0.093		Set Trigger
2	4.122	0.060	0.034	0.025	0.092		Set Trigger
3	4.132	0.062	0.035	0.025	0.095		Set Trigger
4	4.152	0.060	0.034	0.025	0.092		Set Trigger
5	4.187	0.062	0.035	0.024	0.095		Set Trigger

Avg 4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695365.__0
FILE DATE AND TIME: 01/18/2008 12:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	0.063
The Average Point of Impact of the Five Target Set:	0.065
The Average Mean Radius of the Five Target Set:	0.829
The Distance from POA to Centroid Target #1:	0.218
The Distance from Centroid Target #2 to Centroid Target #1:	0.248
The Distance from Centroid Target #3 to Centroid Target #1:	0.168
The Distance from Centroid Target #4 to Centroid Target #1:	0.272
The Distance from Centroid Target #5 to Centroid Target #1:	0.264

BARBER - M24 0180456

SERIAL NUMBER: G6695365. 0

TARGET NUMBER: 1

FILE DATE: 01/18/2008

FILE TIME: 12:20

X CENTROID: -0.112

Y CENTROID: 0.187

POA TO CENTROID: 0.218

HORZ SPREAD: 1.828

VERT SPREAD: 1.949

GROUP SPREAD: 2.327

MIN RADIUS: 0.135

MAX RADIUS: 1.445

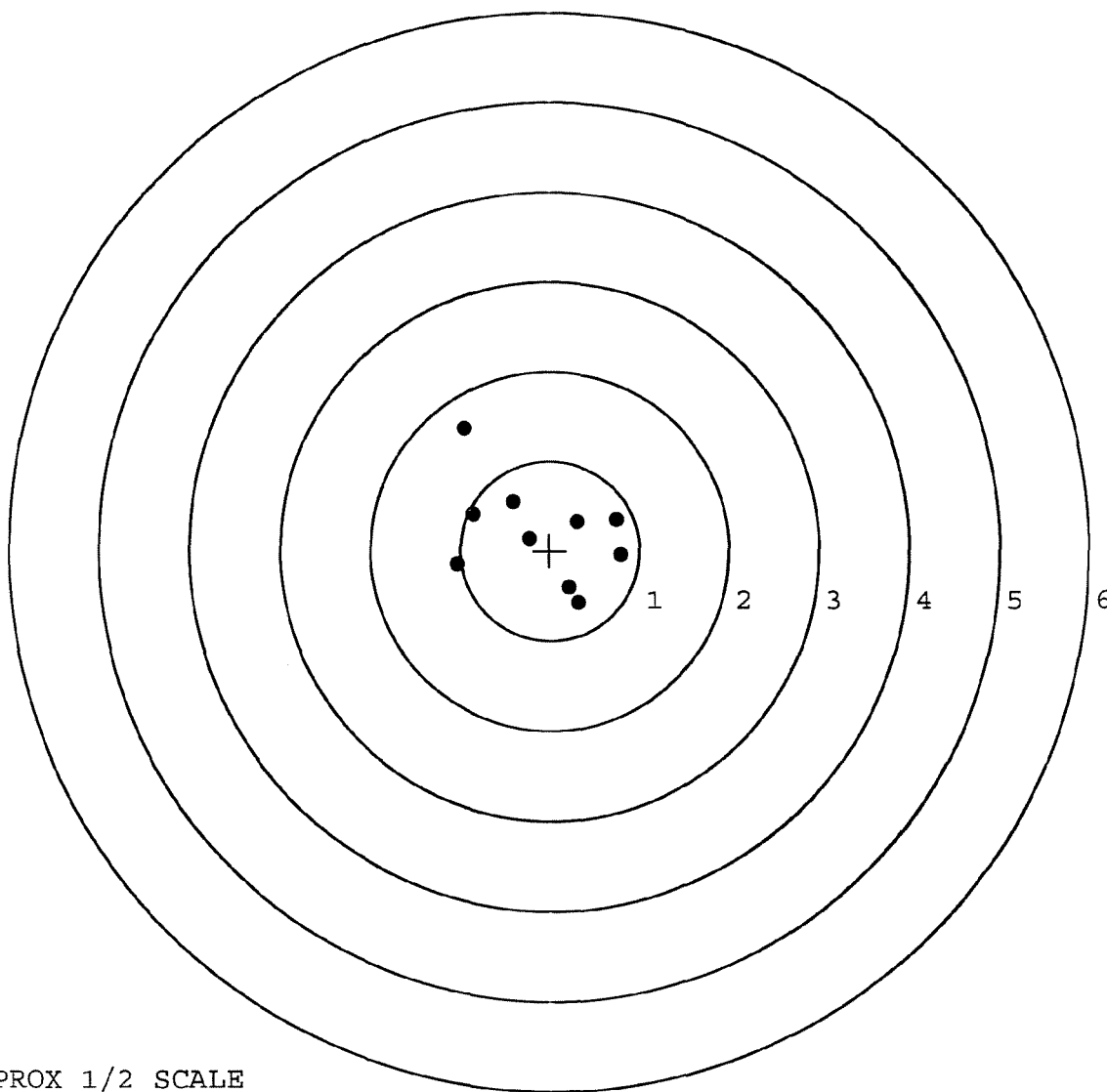
MEAN RADIUS: 0.762

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.794	-0.051
2:	0.741	0.344
3:	0.306	0.319
4:	0.316	-0.589
5:	0.214	-0.415
6:	-0.233	0.127
7:	-0.407	0.543
8:	-0.860	0.401
9:	-1.034	-0.164
10:	-0.956	1.360



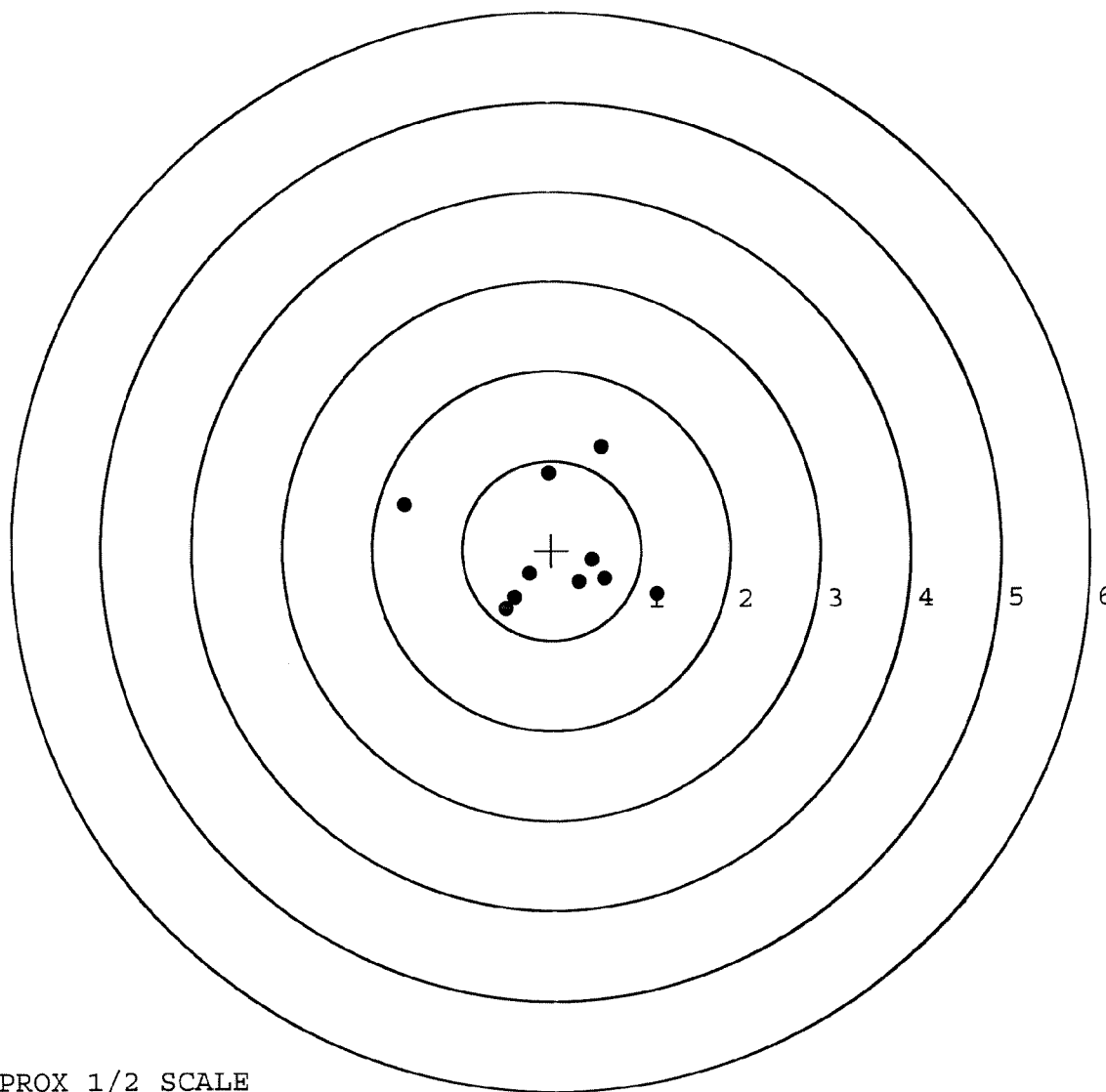
TARGET APPROX 1/2 SCALE

BARBER - M24 0180457

SERIAL NUMBER: G6695365. __0
 TARGET NUMBER: 2
 FILE DATE: 01/18/2008
 FILE TIME: 12:20

POINT#	X	Y
1:	0.565	1.147
2:	-0.033	0.866
3:	-1.635	0.512
4:	-0.515	-0.656
5:	-0.419	-0.532
6:	-0.248	-0.264
7:	1.169	-0.495
8:	0.588	-0.323
9:	0.451	-0.109
10:	0.302	-0.358

X CENTROID: 0.023
 Y CENTROID: -0.021
 POA TO CENTROID: 0.031
 HORZ SPREAD: 2.804
 VERT SPREAD: 1.803
 GROUP SPREAD: 2.979
 MIN RADIUS: 0.363
 MAX RADIUS: 1.741
 MEAN RADIUS: 0.855
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



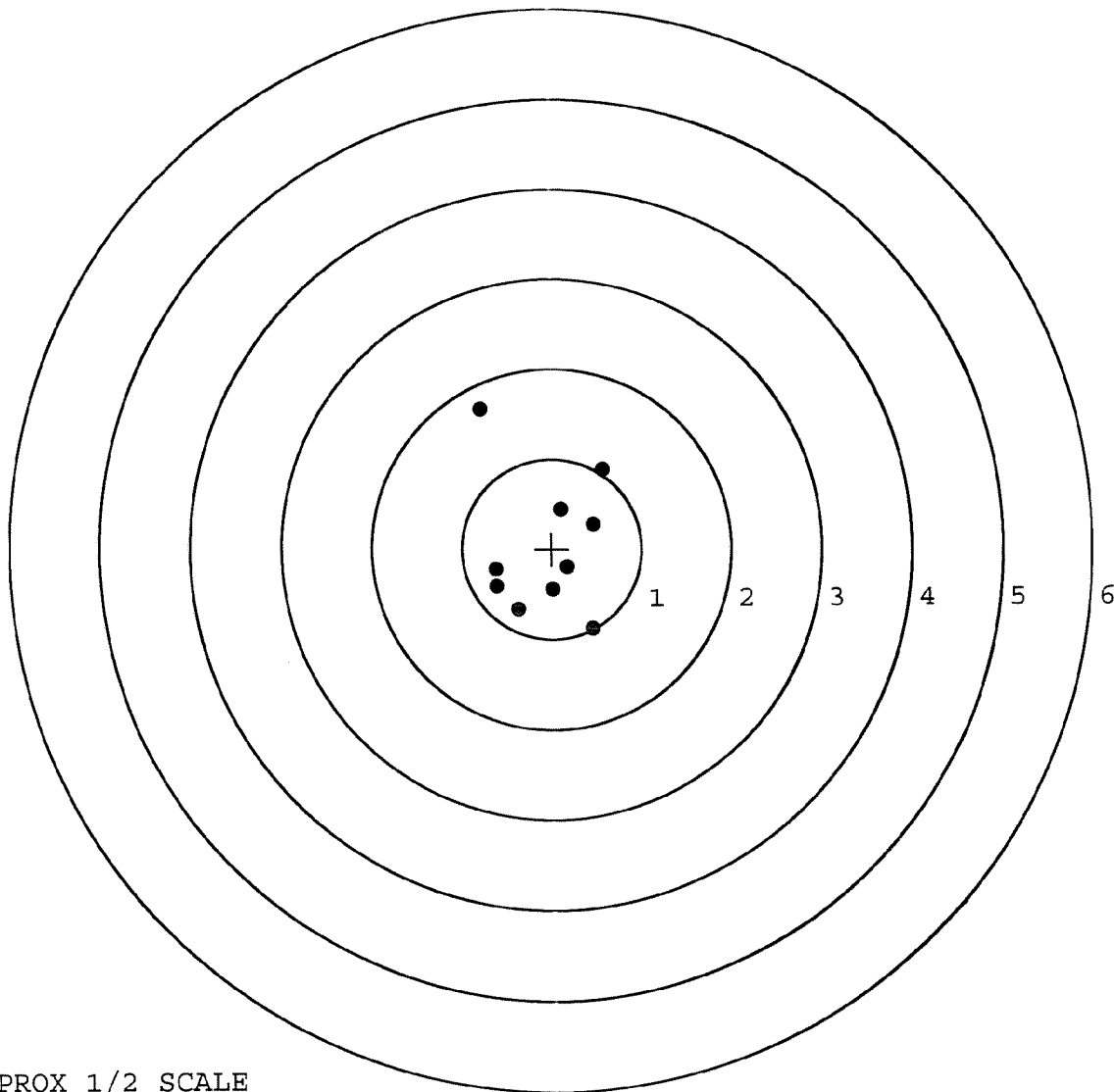
TARGET APPROX 1/2 SCALE

BARBER - M24 0180458

SERIAL NUMBER: G6695365. __ 0
 TARGET NUMBER: 3
 FILE DATE: 01/18/2008
 FILE TIME: 12:20

POINT#	X	Y
1:	-0.792	1.552
2:	0.572	0.884
3:	0.464	0.278
4:	0.105	0.440
5:	0.169	-0.206
6:	0.448	-0.887
7:	0.009	-0.459
8:	-0.377	-0.680
9:	-0.614	-0.423
10:	-0.620	-0.228

X CENTROID: -0.064
 Y CENTROID: 0.027
 POA TO CENTROID: 0.069
 HORZ SPREAD: 1.364
 VERT SPREAD: 2.439
 GROUP SPREAD: 2.736
 MIN RADIUS: 0.329
 MAX RADIUS: 1.690
 MEAN RADIUS: 0.775
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0180459

SERIAL NUMBER: G6695365. __0

TARGET NUMBER: 4

FILE DATE: 01/18/2008

FILE TIME: 12:20

POINT#	X	Y
1:	1.118	0.007
2:	0.942	-0.099
3:	0.423	-0.293
4:	0.631	-0.986
5:	-0.619	0.137
6:	-0.895	0.238
7:	-0.217	0.412
8:	-0.372	0.245
9:	-0.131	0.205
10:	-0.188	-0.026

X CENTROID: 0.069

Y CENTROID: -0.016

POA TO CENTROID: 0.071

HORZ SPREAD: 2.013

VERT SPREAD: 1.398

GROUP SPREAD: 1.956

MIN RADIUS: 0.257

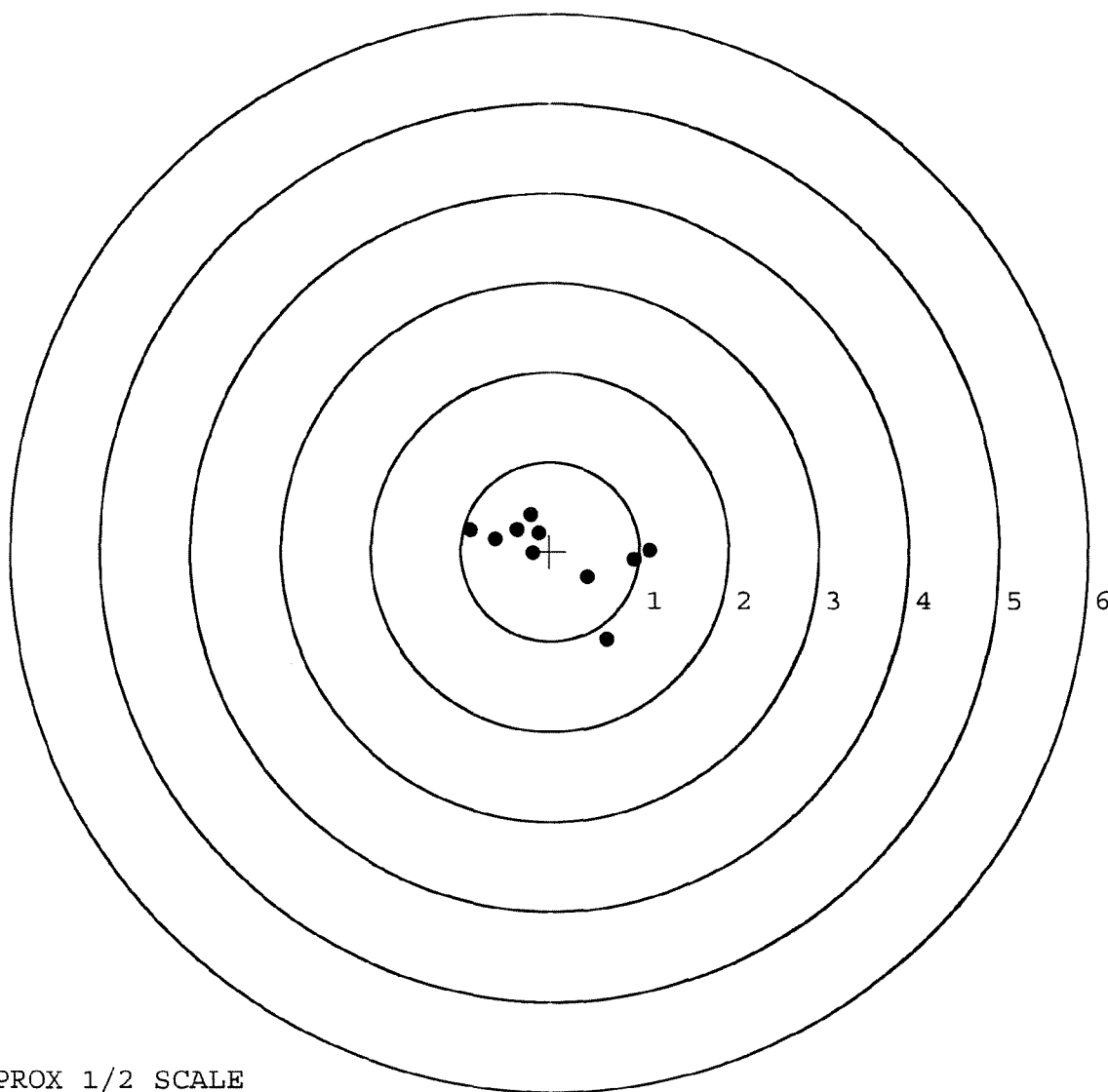
MAX RADIUS: 1.121

MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



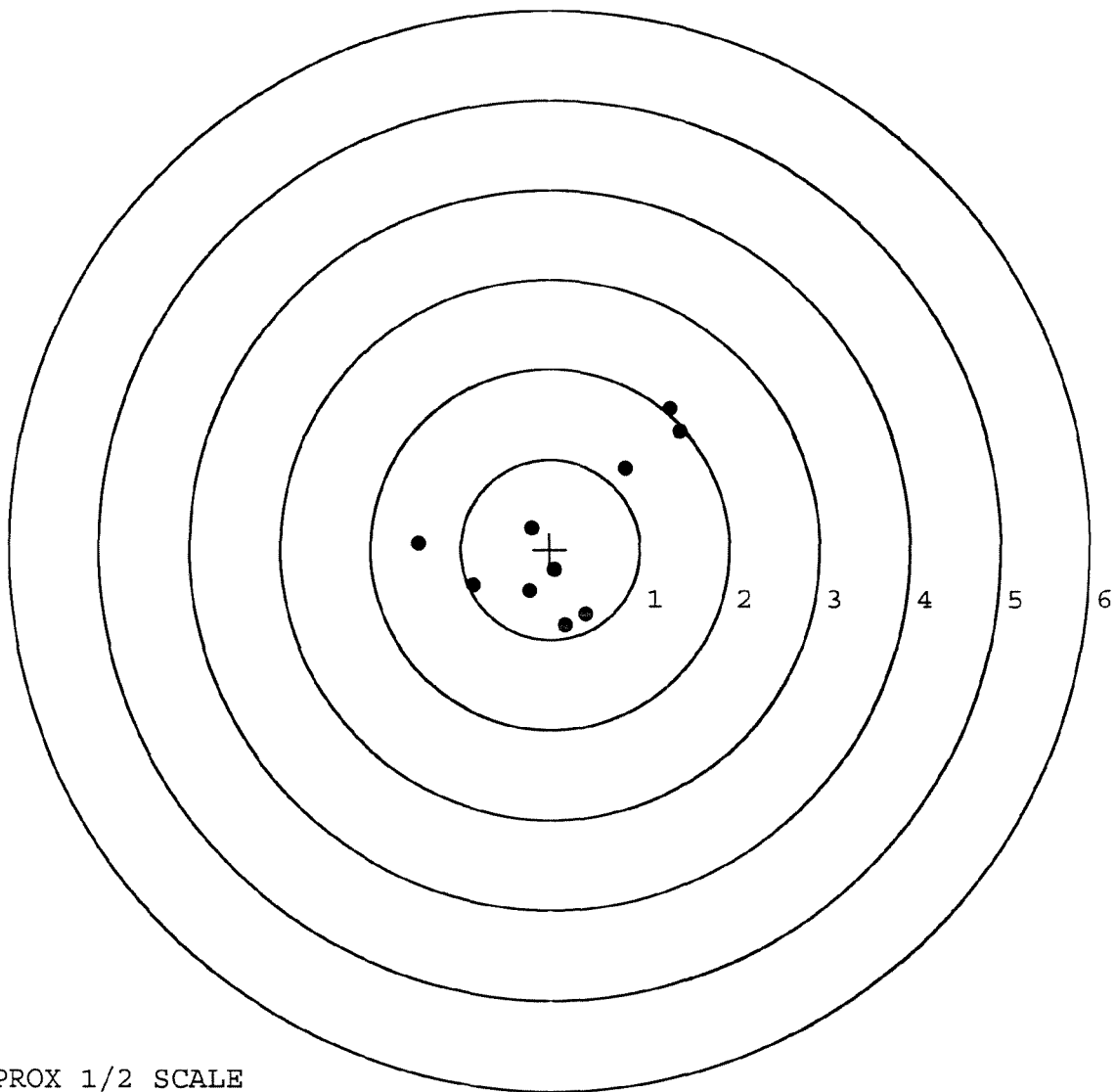
TARGET APPROX 1/2 SCALE

BARBER - M24 0180460

SERIAL NUMBER: G6695365. __0
 TARGET NUMBER: 5
 FILE DATE: 01/18/2008
 FILE TIME: 12:20

POINT#	X	Y
1:	0.398	-0.726
2:	0.165	-0.851
3:	0.048	-0.233
4:	-0.233	-0.460
5:	-0.854	-0.406
6:	-0.213	0.238
7:	-1.461	0.061
8:	0.842	0.905
9:	1.451	1.306
10:	1.335	1.555

X CENTROID: 0.148
 Y CENTROID: 0.139
 POA TO CENTROID: 0.203
 HORZ SPREAD: 2.912
 VERT SPREAD: 2.406
 GROUP SPREAD: 3.170
 MIN RADIUS: 0.374
 MAX RADIUS: 1.848
 MEAN RADIUS: 1.074
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE