

6198 5429
G673 8619

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

P5 FORM 200348

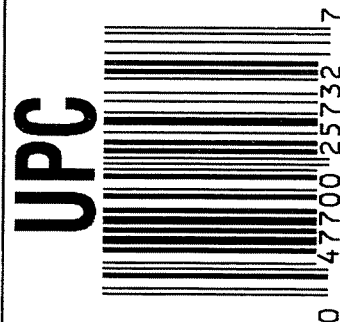


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6738619



Original

6/4/2008 10:35:38 AM

9

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SW5732X



.ABSW5732X

Start Date: 6/4/2008

Finish Date: 6/26/2008

0520

78ROT01

Goff Blast Barrel & Rec Assembly



0006554655

0547

01PC001

Gray Sandstrom Coat Bolt Assemblies



0006554673

0610

89SWS1

Assemble Action to Stock.



0006554662

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6738619

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6/11/08	R.P.D.
430	ASSEMBLE TO STOCK		6/11/08	SP
440	PROOF		6-11-08	SD
460	CHECK HEADSPACE		6-11-08	SD
470	DIS-ASSEMBLE ACTION		6/11/08	R.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	6-16-08	R.P.D.
475	DRILL AND TAP SIGHT HOLES	2008	6-17-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <i>und</i>	6/20/08	<i>und</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/18/08	RT
520	GOFF BLAST BBL / REC		6/20	BT
542	APPLY COATINGS (BARREL ACTION)		6-25-08	<i>und</i>
545	(BOLT)			
560	RE-ASSEMBLE ACTION		6/26/08	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6/26/08	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6/26/08	RP
	D) OIL FIRING PIN ASSEMBLY		6-27-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

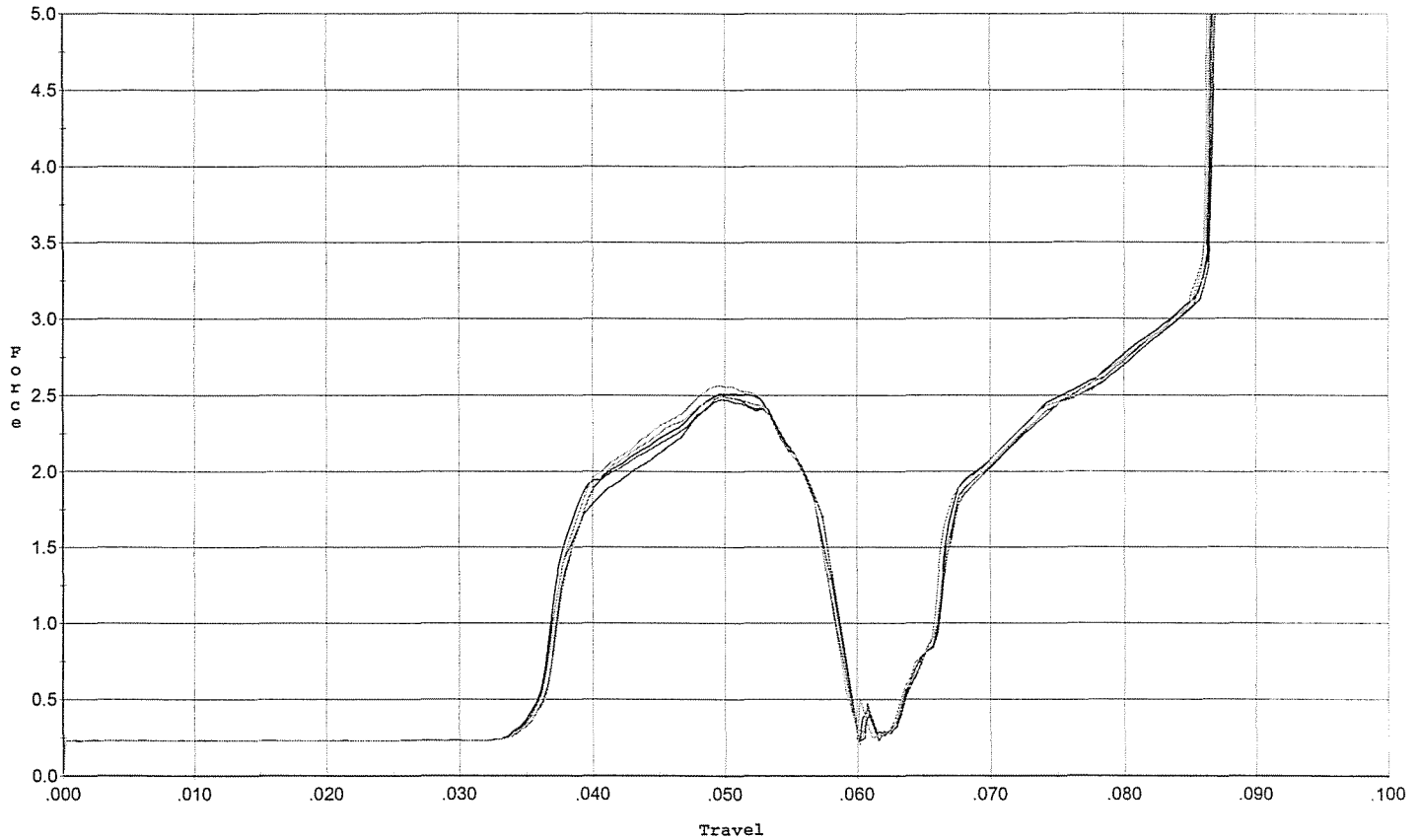
F004 REV 5/2006

OP #	OPERATION NAME	READING	DATE	INITIALS
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.6</u> <u>6.4</u> <u>6.4</u>	<u>6/30/08</u>	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.1</u>	<u>6/30/08</u>	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.021</u> <u>.024</u>	<u>6/30/08</u>	RP
	J) ASSEMBLE STOCK		<u>6-27-08</u>	LSN
	K) ASSEMBLE SWIVEL STUDS		<u>6/30/08</u>	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	<u>6-30-08</u>	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>6/30/08</u>	MEB
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.42</u> <u>2.40</u> <u>2.43</u> <u>2.35</u>	<u>6-30-08</u>	SD
	C) FUNCTION		<u>6-30-08</u>	RP
690	PACK		<u>6-30-08</u>	RP

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



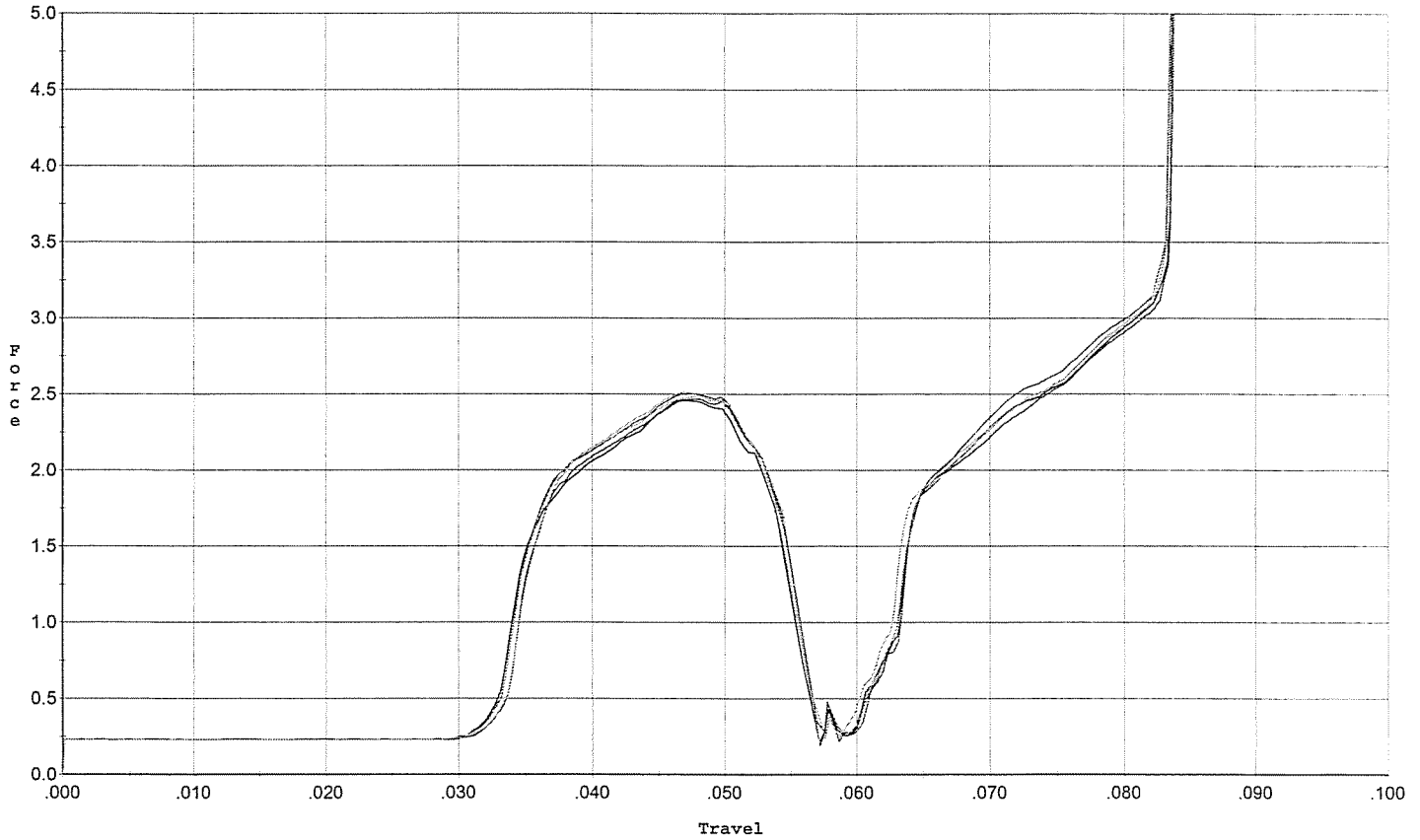
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.058	0.036	0.036	0.052		Set Trigger
2	2.512	0.057	0.035	0.036	0.052		Set Trigger
3	2.474	0.057	0.036	0.036	0.052		Set Trigger
4	2.565	0.057	0.036	0.036	0.053		Set Trigger
5	2.493	0.057	0.036	0.036	0.052		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



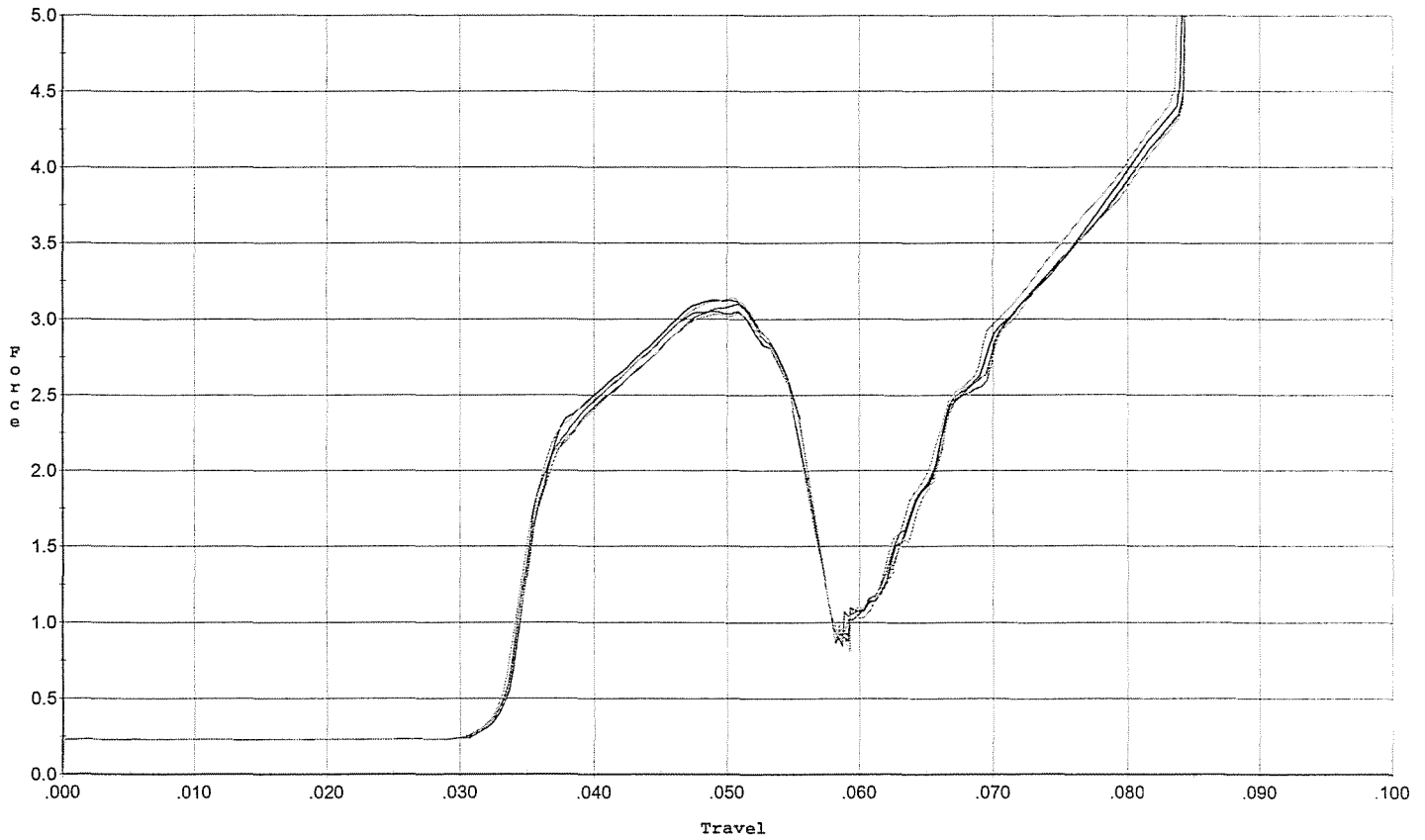
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.054	0.034	0.035	0.051		Set Trigger
2	2.459	0.054	0.032	0.035	0.051		Set Trigger
3	2.503	0.055	0.033	0.034	0.053		Set Trigger
4	2.482	0.055	0.033	0.034	0.053		Set Trigger
5	2.511	0.054	0.033	0.035	0.052		Set Trigger

Avg 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



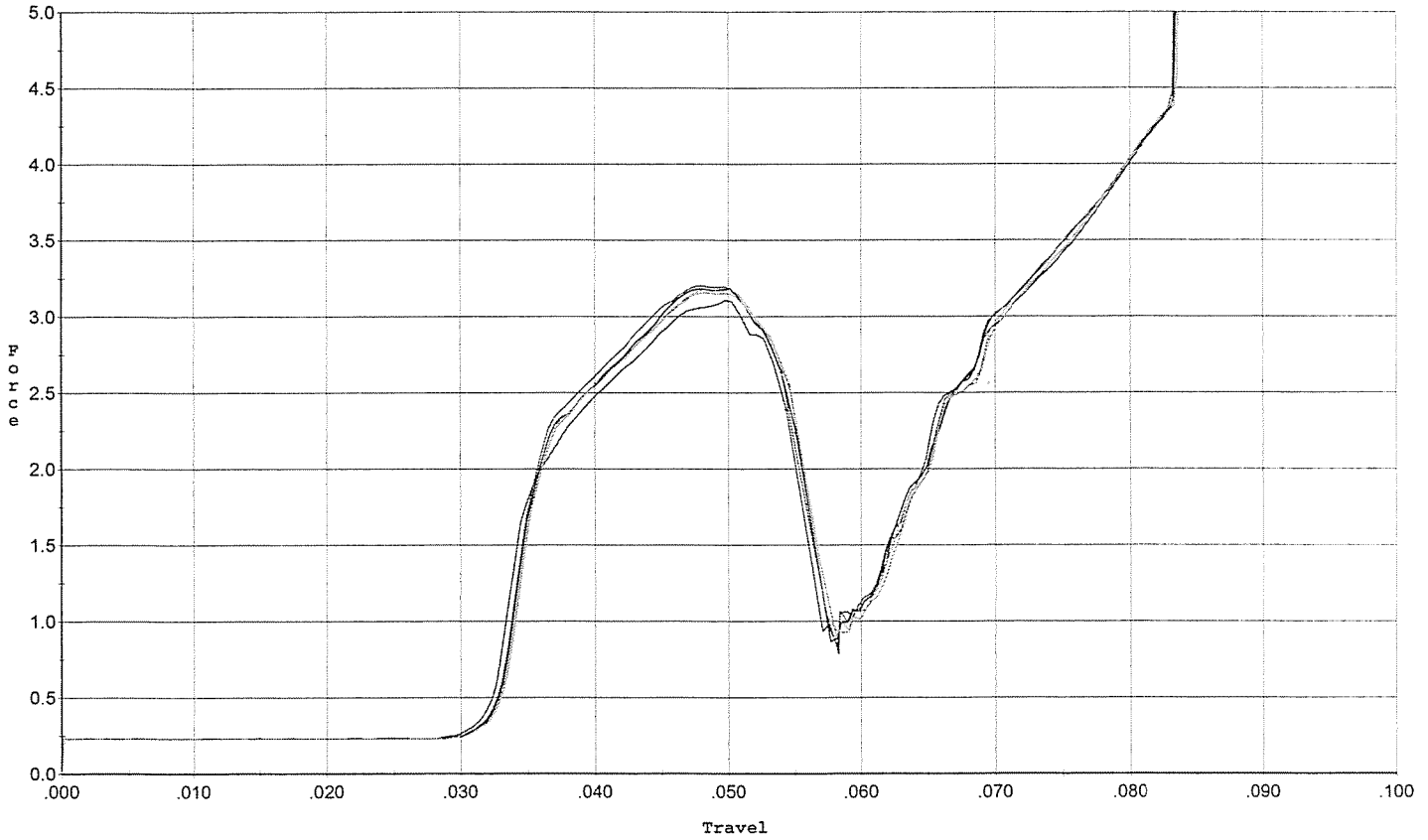
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.051	0.056	0.033	0.034	0.065		Set Trigger
2	3.126	0.055	0.033	0.034	0.065		Set Trigger
3	3.099	0.055	0.033	0.034	0.064		Set Trigger
4	3.038	0.055	0.033	0.034	0.064		Set Trigger
5	3.137	0.055	0.033	0.034	0.064		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



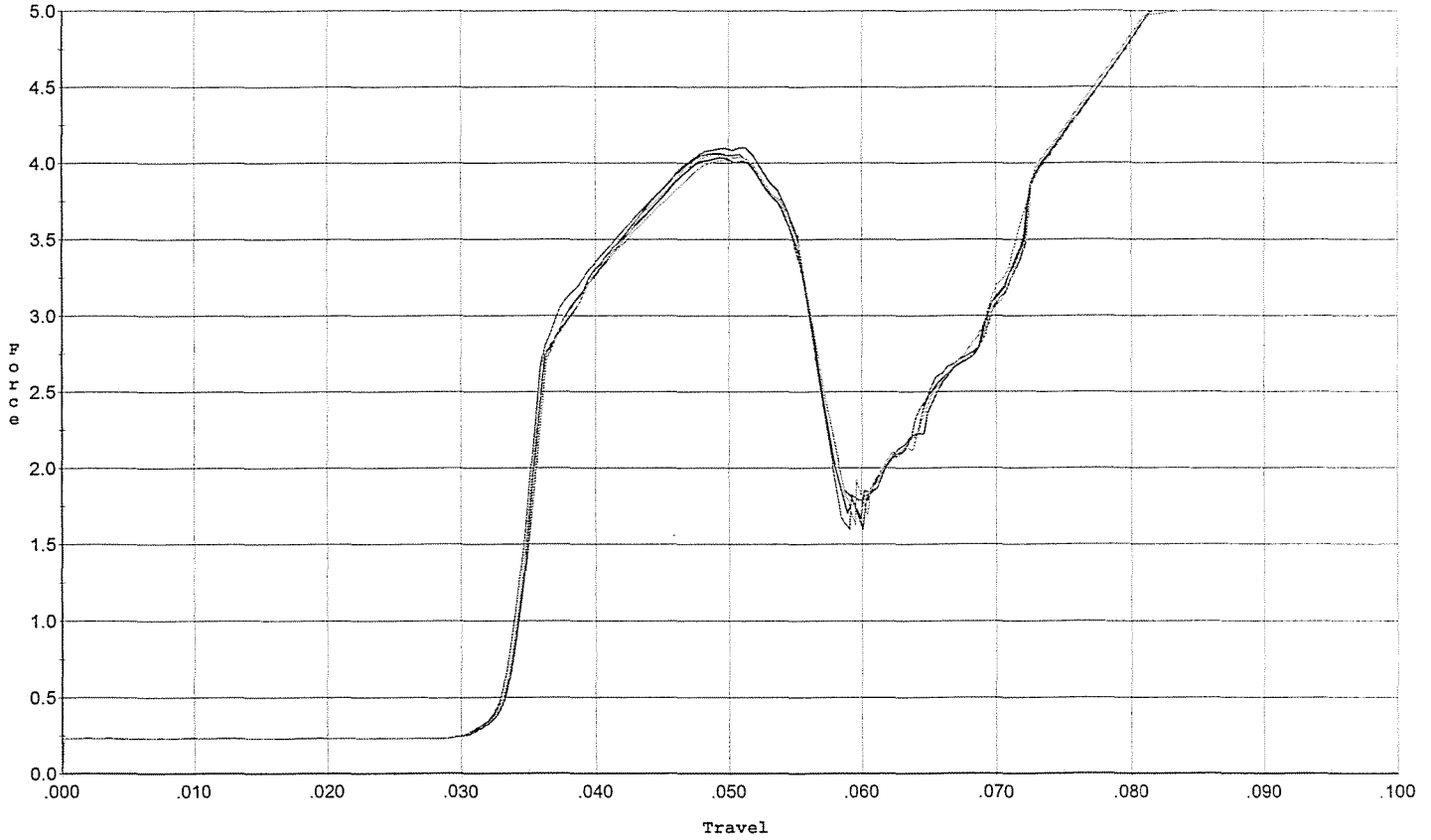
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.106	0.054	0.032	0.033	0.063		Set Trigger
2	3.182	0.055	0.032	0.033	0.066		Set Trigger
3	3.201	0.054	0.032	0.034	0.065		Set Trigger
4	3.157	0.055	0.032	0.033	0.065		Set Trigger
5	3.178	0.055	0.033	0.034	0.065		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



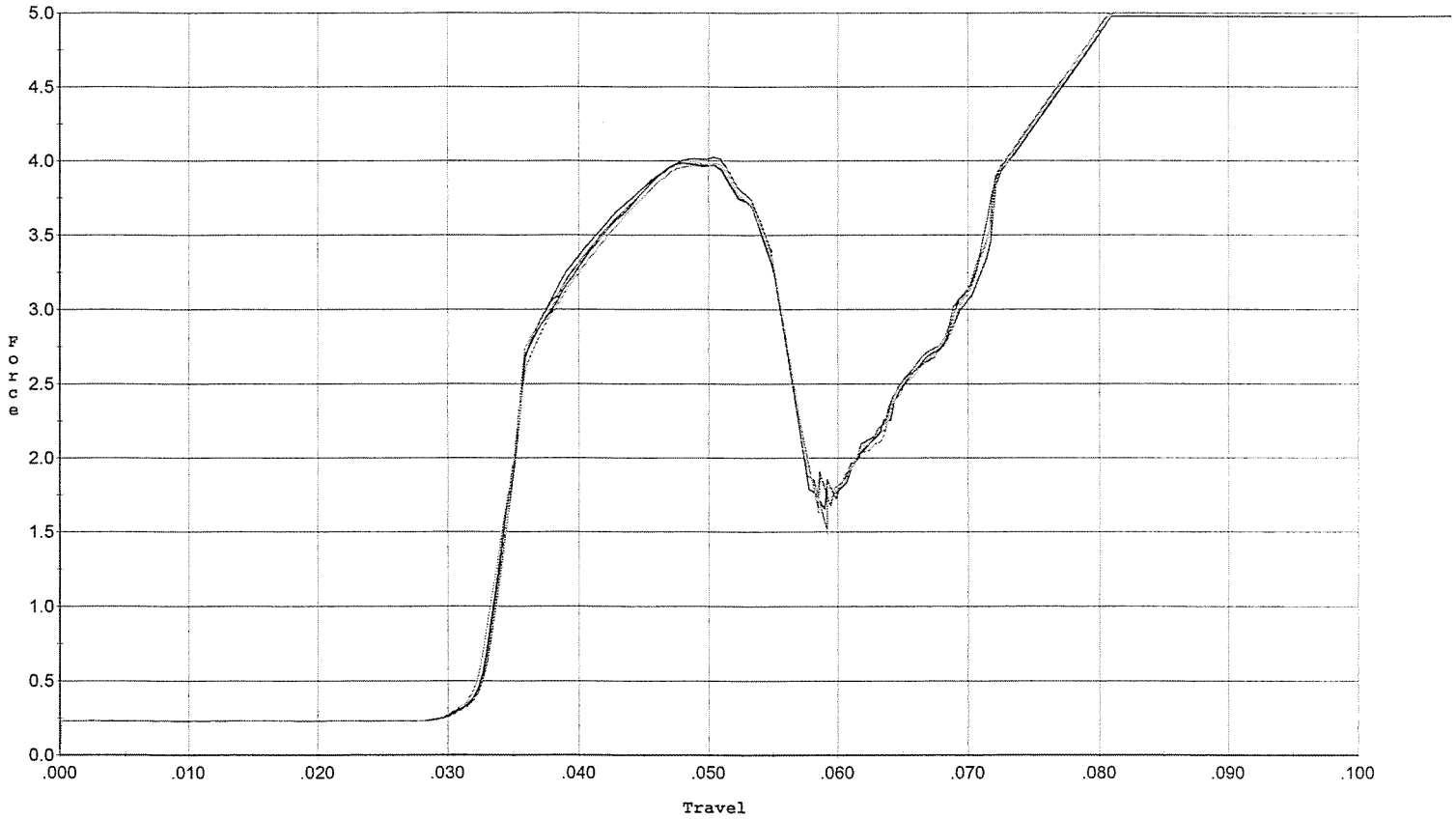
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.055	0.033	0.033	0.084		Set Trigger
2	4.037	0.055	0.033	0.032	0.083		Set Trigger
3	4.064	0.055	0.033	0.032	0.085		Set Trigger
4	4.054	0.055	0.033	0.032	0.083		Set Trigger
5	4.020	0.055	0.033	0.032	0.083		Set Trigger

AVG 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 5/14/08

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



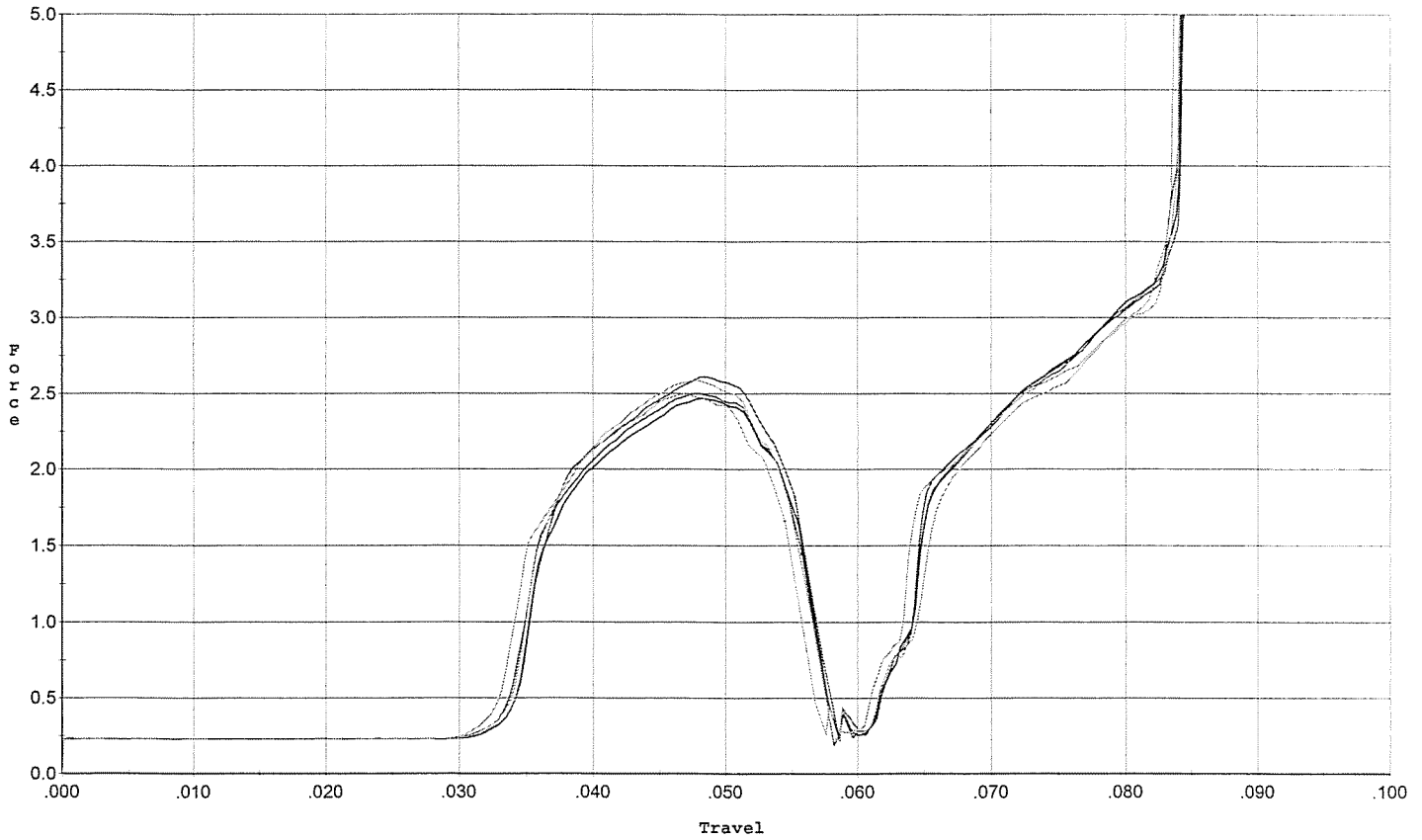
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.991	0.055	0.032	0.032	0.083		Set Trigger
2	3.978	0.055	0.032	0.032	0.083		Set Trigger
3	4.026	0.055	0.032	0.032	0.083		Set Trigger
4	3.988	0.055	0.032	0.032	0.083		Set Trigger
5	3.974	0.055	0.032	0.032	0.082		Set Trigger

Avg 3.99

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 5/14/08

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



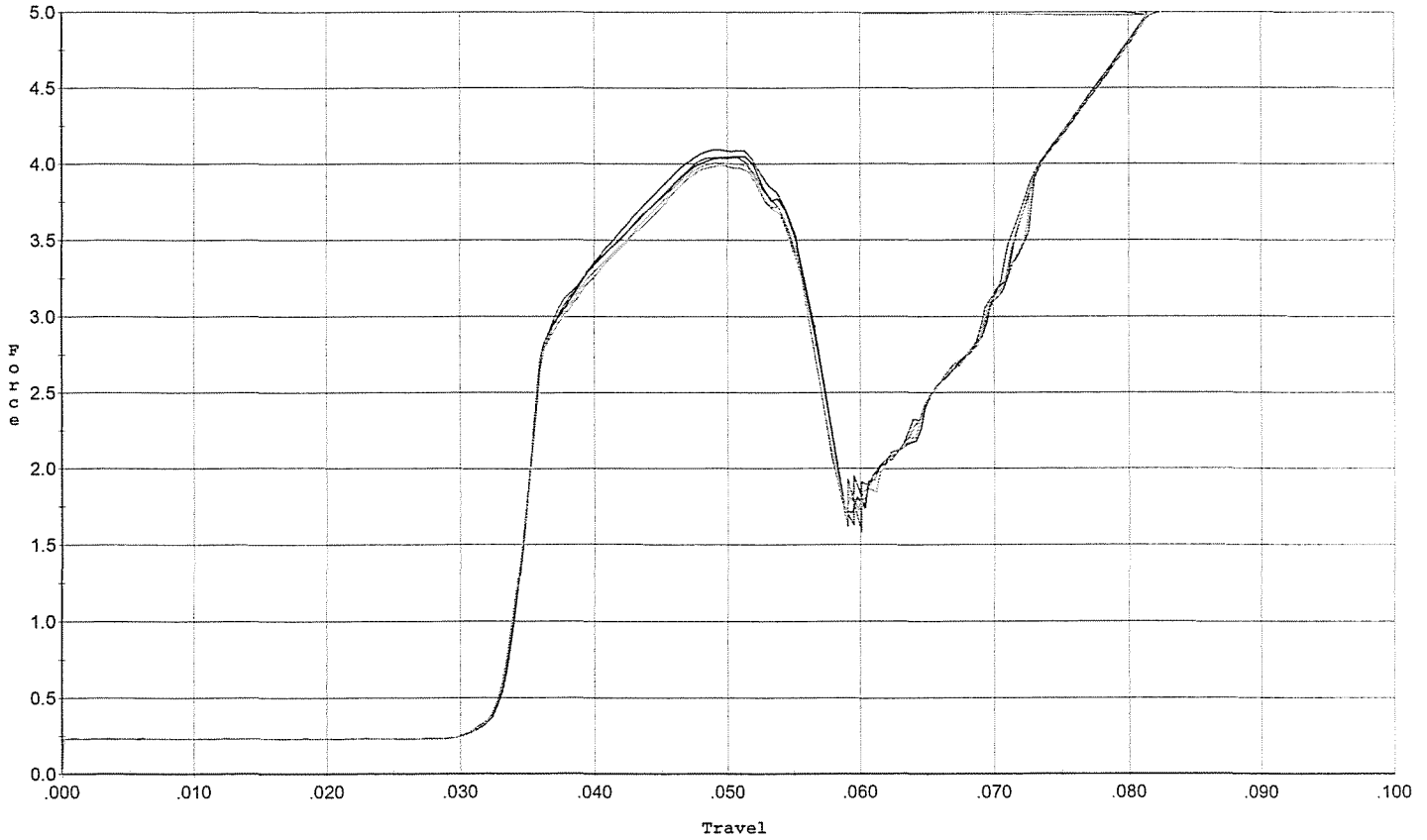
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.500	0.056	0.033	0.035	0.053		Set Trigger
2	2.469	0.055	0.034	0.035	0.052		Set Trigger
3	2.610	0.055	0.034	0.035	0.054		Set Trigger
4	2.588	0.056	0.033	0.035	0.055		Set Trigger
5	2.497	0.054	0.033	0.035	0.052		Set Trigger

AVG 2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 5/14/08

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	4.094	0.057	0.033	0.032	0.088		Set Trigger
2	4.048	0.057	0.033	0.032	0.087		Set Trigger
3	4.039	0.055	0.033	0.032	0.085		Set Trigger
4	4.007	0.055	0.033	0.033	0.084		Set Trigger
5	3.991	0.055	0.033	0.033	0.083		Set Trigger

Avg 4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6738619.___0
FILE DATE AND TIME: 06/30/2008 10:45

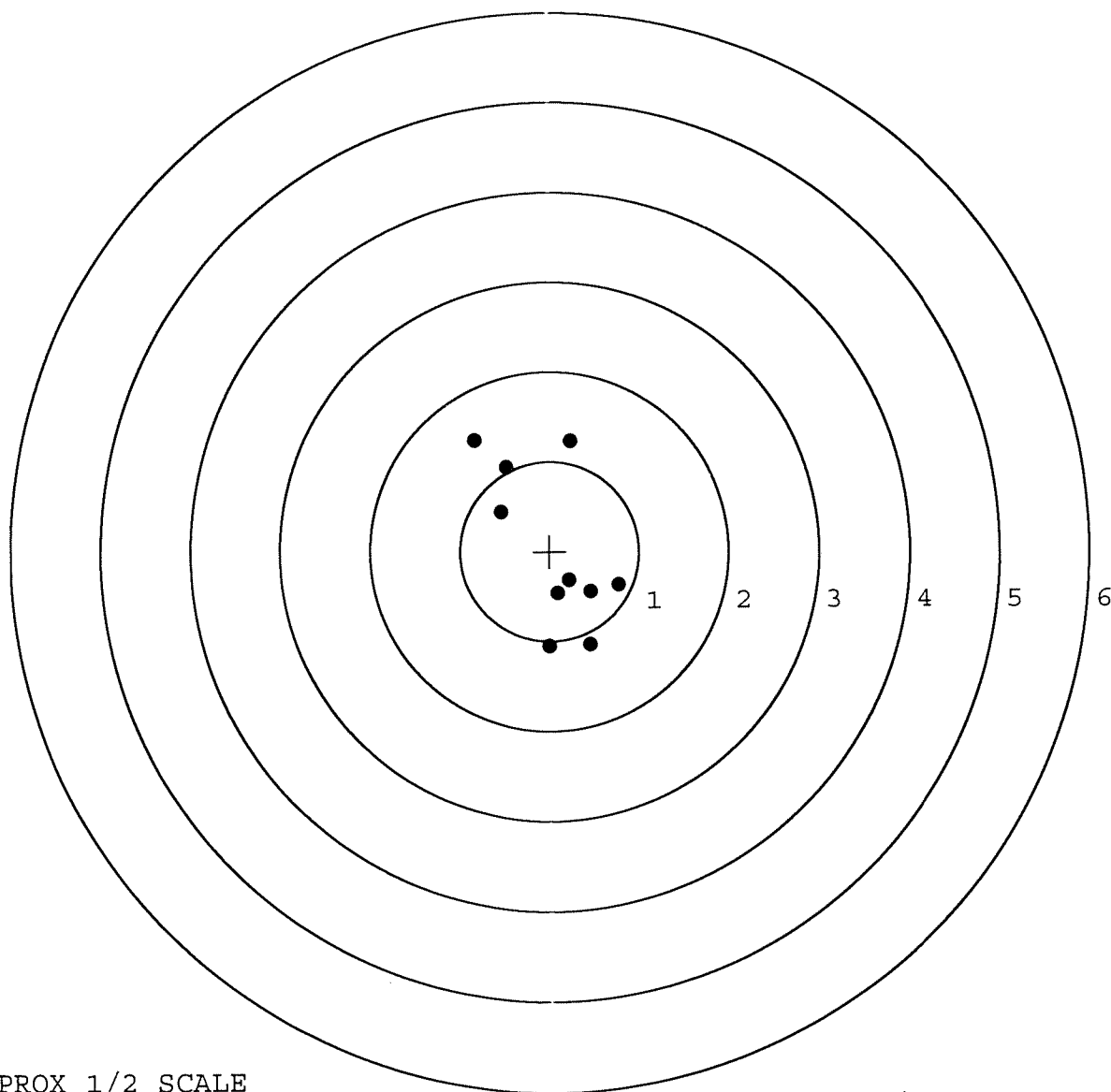
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.037
The Average Y Centroid of the Five Target Set:	0.054
The Average Point of Impact of the Five Target Set:	0.065
The Average Mean Radius of the Five Target Set:	0.694
The Distance from POA to Centroid Target #1:	0.036
The Distance from Centroid Target #2 to Centroid Target #1:	0.136
The Distance from Centroid Target #3 to Centroid Target #1:	0.100
The Distance from Centroid Target #4 to Centroid Target #1:	0.147
The Distance from Centroid Target #5 to Centroid Target #1:	0.200

SERIAL NUMBER: G6738619. __0
TARGET NUMBER: 1
FILE DATE: 06/30/2008
FILE TIME: 10:45

X CENTROID: 0.034
Y CENTROID: 0.011
POA TO CENTROID: 0.036
HORZ SPREAD: 1.611
VERT SPREAD: 2.290
GROUP SPREAD: 2.612
MIN RADIUS: 0.379
MAX RADIUS: 1.499
MEAN RADIUS: 0.904
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.240	1.223
2:	-0.839	1.229
3:	-0.486	0.938
4:	-0.543	0.444
5:	0.089	-0.470
6:	0.215	-0.322
7:	0.456	-0.449
8:	0.772	-0.380
9:	0.447	-1.044
10:	-0.007	-1.061



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738619. __0

TARGET NUMBER: 2

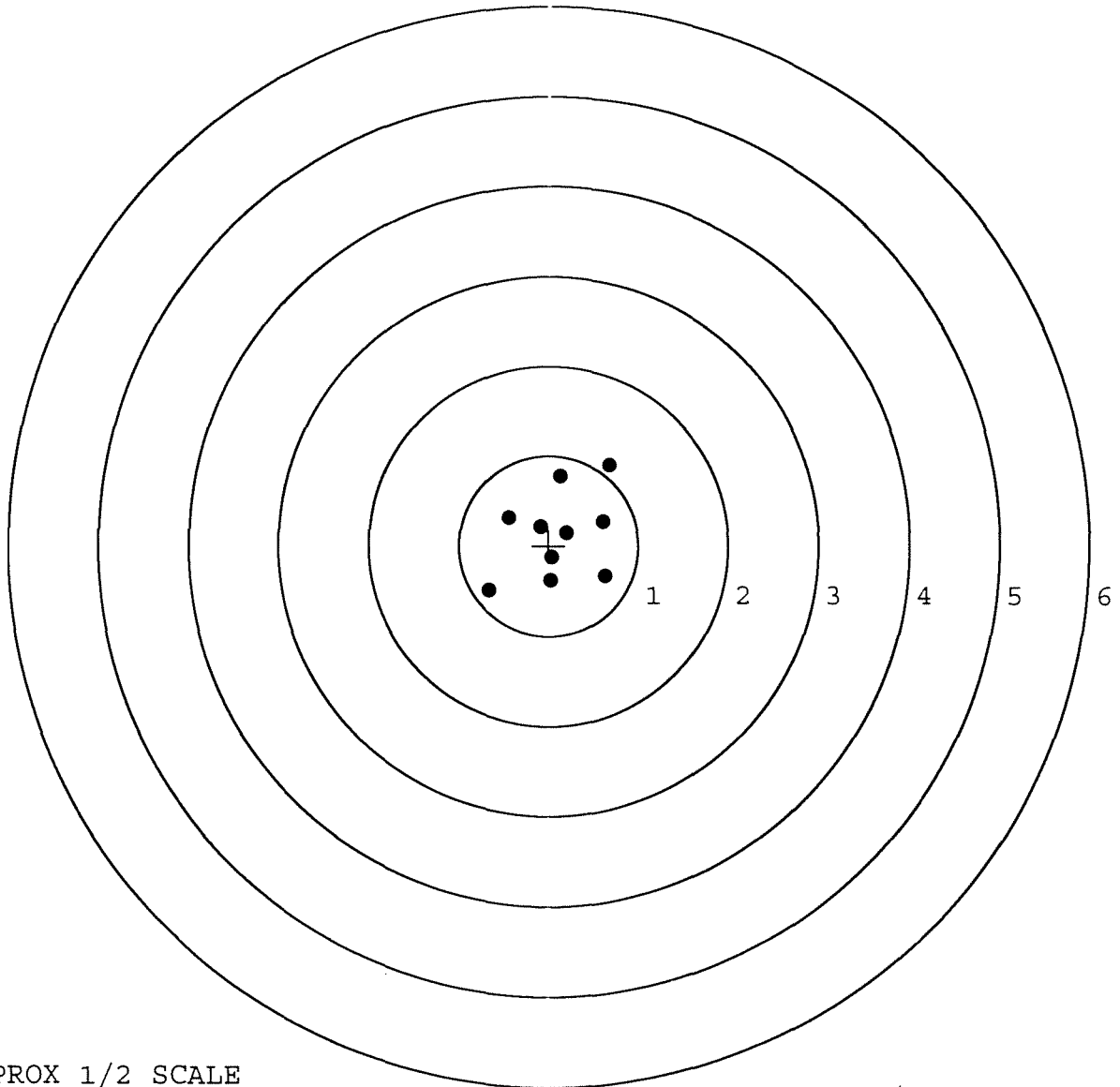
FILE DATE: 06/30/2008

FILE TIME: 10:45

X CENTROID: 0.109
Y CENTROID: 0.124
POA TO CENTROID: 0.166
HORZ SPREAD: 1.348
VERT SPREAD: 1.393
GROUP SPREAD: 1.938
MIN RADIUS: 0.097
MAX RADIUS: 0.998
MEAN RADIUS: 0.550

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.129	0.768
2:	0.677	0.896
3:	0.601	0.271
4:	0.204	0.146
5:	0.037	-0.132
6:	-0.092	0.211
7:	-0.448	0.307
8:	-0.671	-0.497
9:	0.026	-0.390
10:	0.631	-0.336

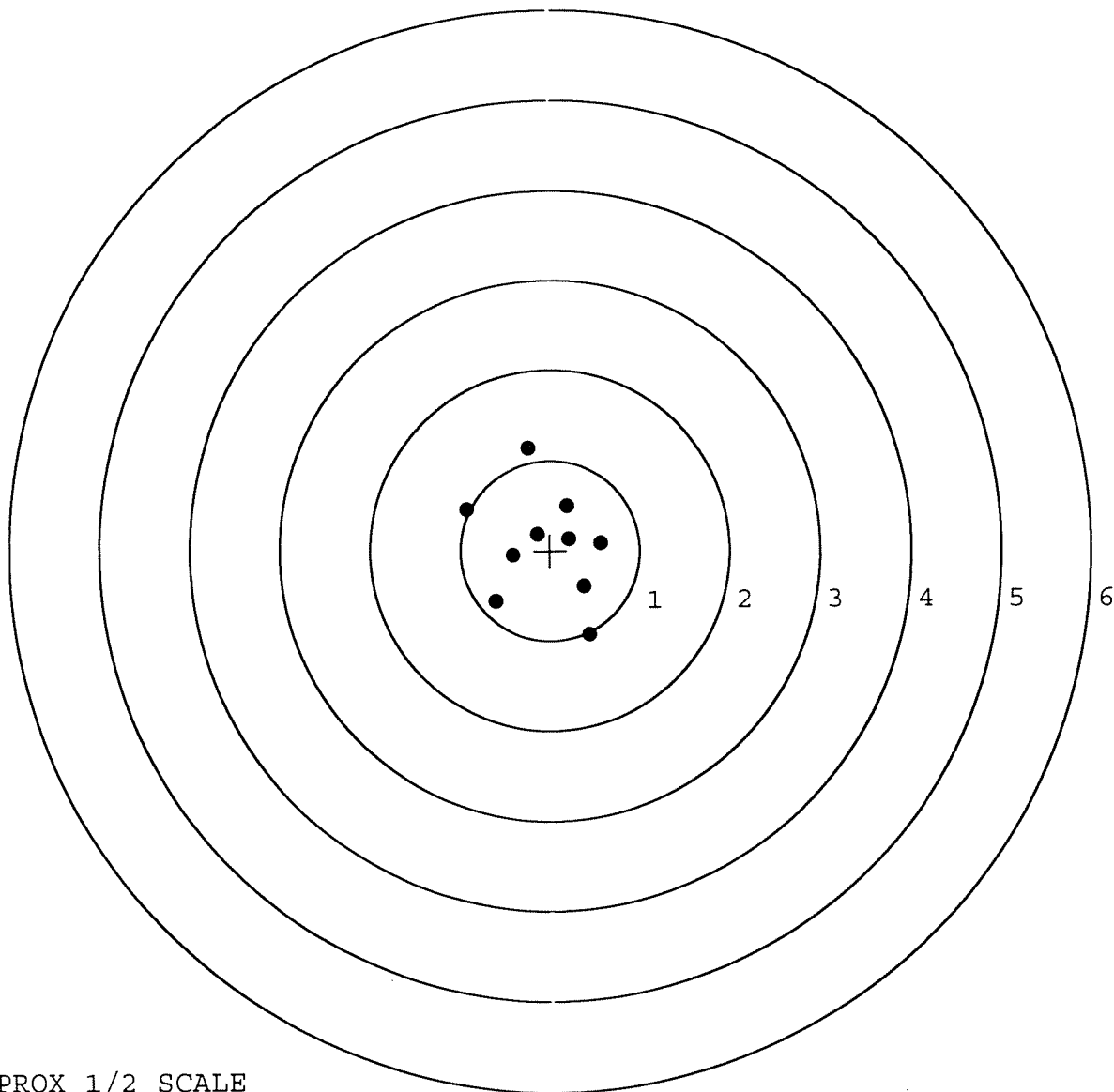


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738619.____0
TARGET NUMBER: 3
FILE DATE: 06/30/2008
FILE TIME: 10:45

X CENTROID: -0.056
Y CENTROID: 0.052
POA TO CENTROID: 0.077
HORZ SPREAD: 1.498
VERT SPREAD: 2.075
GROUP SPREAD: 2.184
MIN RADIUS: 0.158
MAX RADIUS: 1.104
MEAN RADIUS: 0.657
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.245	1.139
2:	0.193	0.498
3:	0.207	0.127
4:	-0.141	0.186
5:	-0.414	-0.058
6:	-0.608	-0.569
7:	-0.933	0.459
8:	0.565	0.082
9:	0.377	-0.406
10:	0.435	-0.936



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738619. __0

TARGET NUMBER: 4

FILE DATE: 06/30/2008

FILE TIME: 10:45

X CENTROID: -0.112

Y CENTROID: 0.027

POA TO CENTROID: 0.115

HORZ SPREAD: 1.506

VERT SPREAD: 1.385

GROUP SPREAD: 1.778

MIN RADIUS: 0.313

MAX RADIUS: 0.980

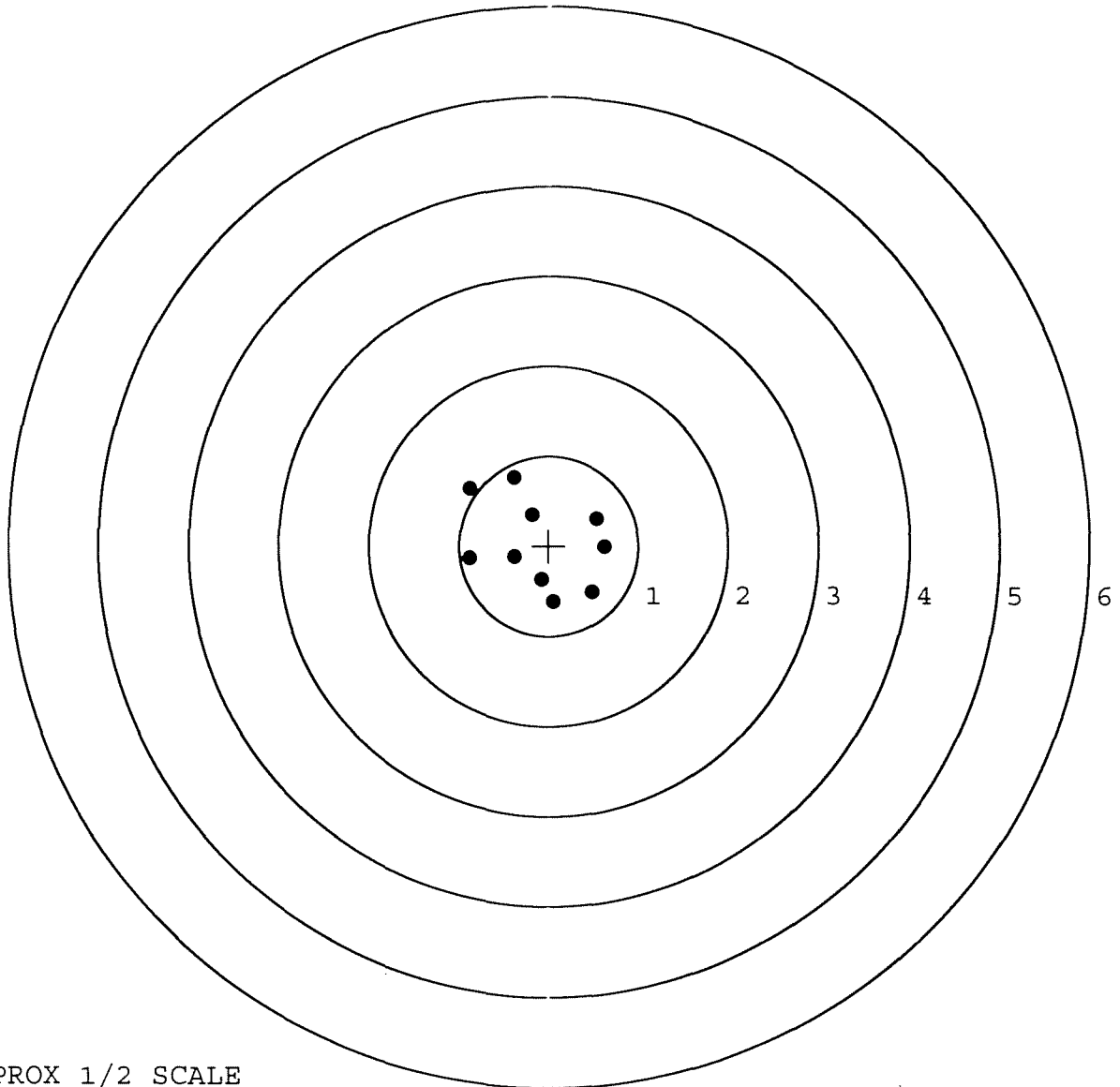
MEAN RADIUS: 0.651

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.389	0.760
2:	-0.189	0.349
3:	-0.881	0.635
4:	-0.881	-0.142
5:	-0.386	-0.124
6:	-0.084	-0.374
7:	0.049	-0.625
8:	0.482	-0.507
9:	0.625	-0.011
10:	0.533	0.307

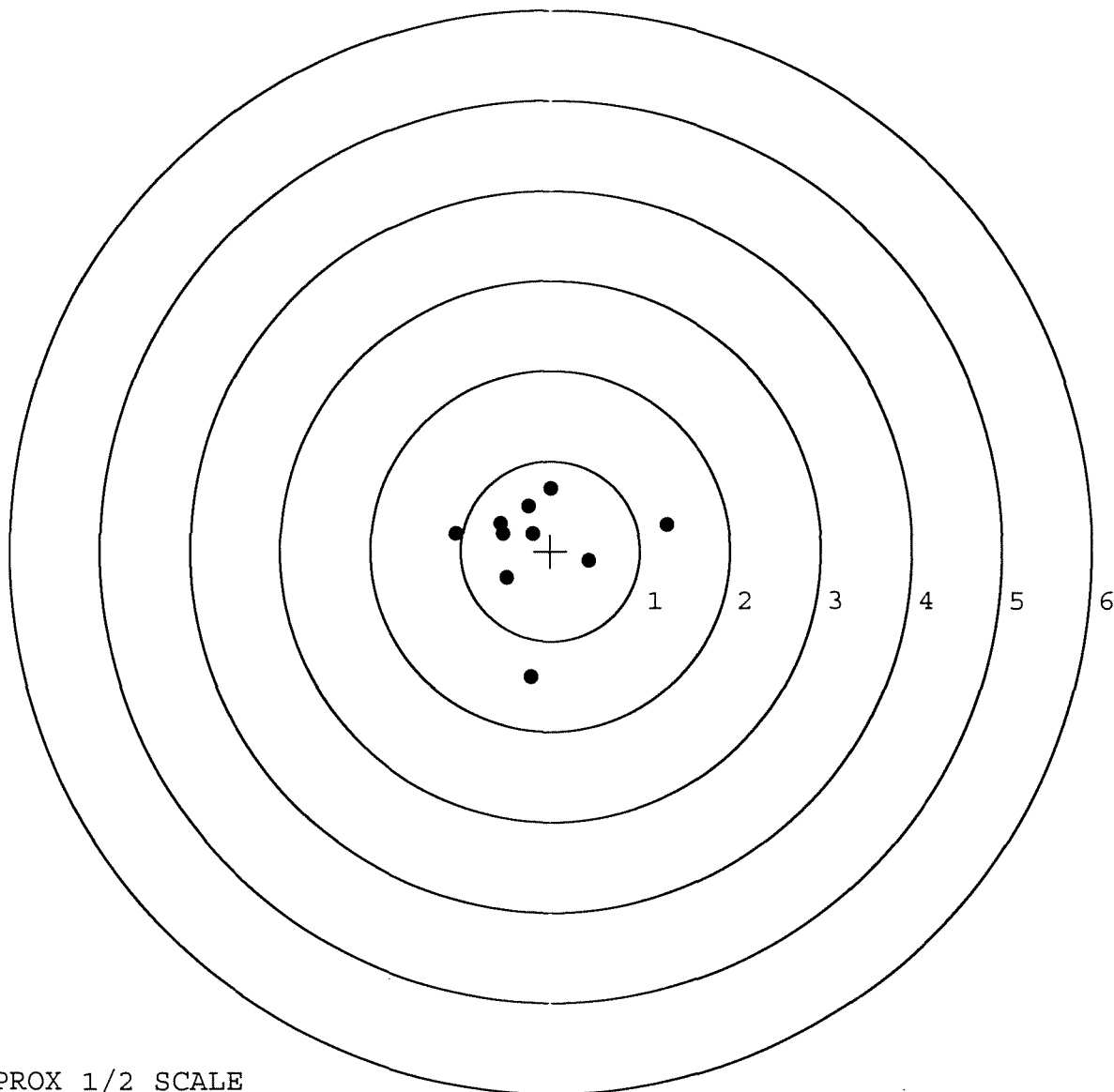


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6738619.____0
TARGET NUMBER: 5
FILE DATE: 06/30/2008
FILE TIME: 10:45

X CENTROID: -0.160
Y CENTROID: 0.054
POA TO CENTROID: 0.169
HORZ SPREAD: 2.359
VERT SPREAD: 2.098
GROUP SPREAD: 2.361
MIN RADIUS: 0.144
MAX RADIUS: 1.478
MEAN RADIUS: 0.706
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.006	0.697
2:	-0.250	0.494
3:	-0.534	0.191
4:	-0.205	0.191
5:	-0.488	-0.306
6:	-1.060	0.190
7:	0.427	-0.107
8:	1.299	0.288
9:	-0.225	-1.401
10:	-0.562	0.302



TARGET APPROX 1/2 SCALE