

G 636 1002

M24A2 7.62 NATO COMPLETE SYSTEM
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

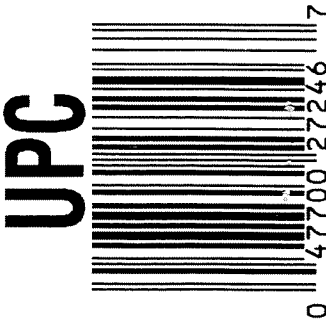
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	27246
BARREL LENGTH	24"
CAPACITY	6

G6361002



ORDER 27246

M24A2 7.62 NATO COMPLETE SYSTEM

UPC



ORDER 27246

M24A2 7.62 NATO COMPLETE SYSTEM

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6361002

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-19-06	RTZ
440	PROOF		1-19-06	RTZ
460	CHECK HEADSPACE	MAGNA - FLUX	1-19-06	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	1-19-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480 EJECTOR CPD JAN 20 2006	1-20-06	APD
500	ROLLMARK CALIBER		1-19-06	CW
510	DRILL AND TAP SIGHT HOLES	N/A		
520	GOFF BLAST BBL / REC		1-20-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1-23	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-23-06	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-23-06	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-23-06	AC
	D) OIL FIRING PIN ASSEMBLY		3-6-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.2</u> <u>4.2</u> <u>4.5</u>	9-20-07	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.2</u> <u>4.2</u> <u>3.5</u>	9-20-07	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	9-20-07	RA
	J) ASSEMBLE STOCK		3-6-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		9-20-07	RA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-6-06	RTZ
	M) IRON SIGHT ALIGNMENT		3-6-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-6-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-6-07 3-9-06	TRW TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO	8/6/07 FM	3/7/06	RP
670	FINAL INSPECTION A) HEADSPACE		9-20-07	RA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.65</u> <u>2.55</u> <u>2.70</u> <u>2.65</u>	9-20-07	RA
	C) FUNCTION			
690	PACK		9-20-07	RA

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361002.___0
FILE DATE AND TIME: 08/06/2007 11:21

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

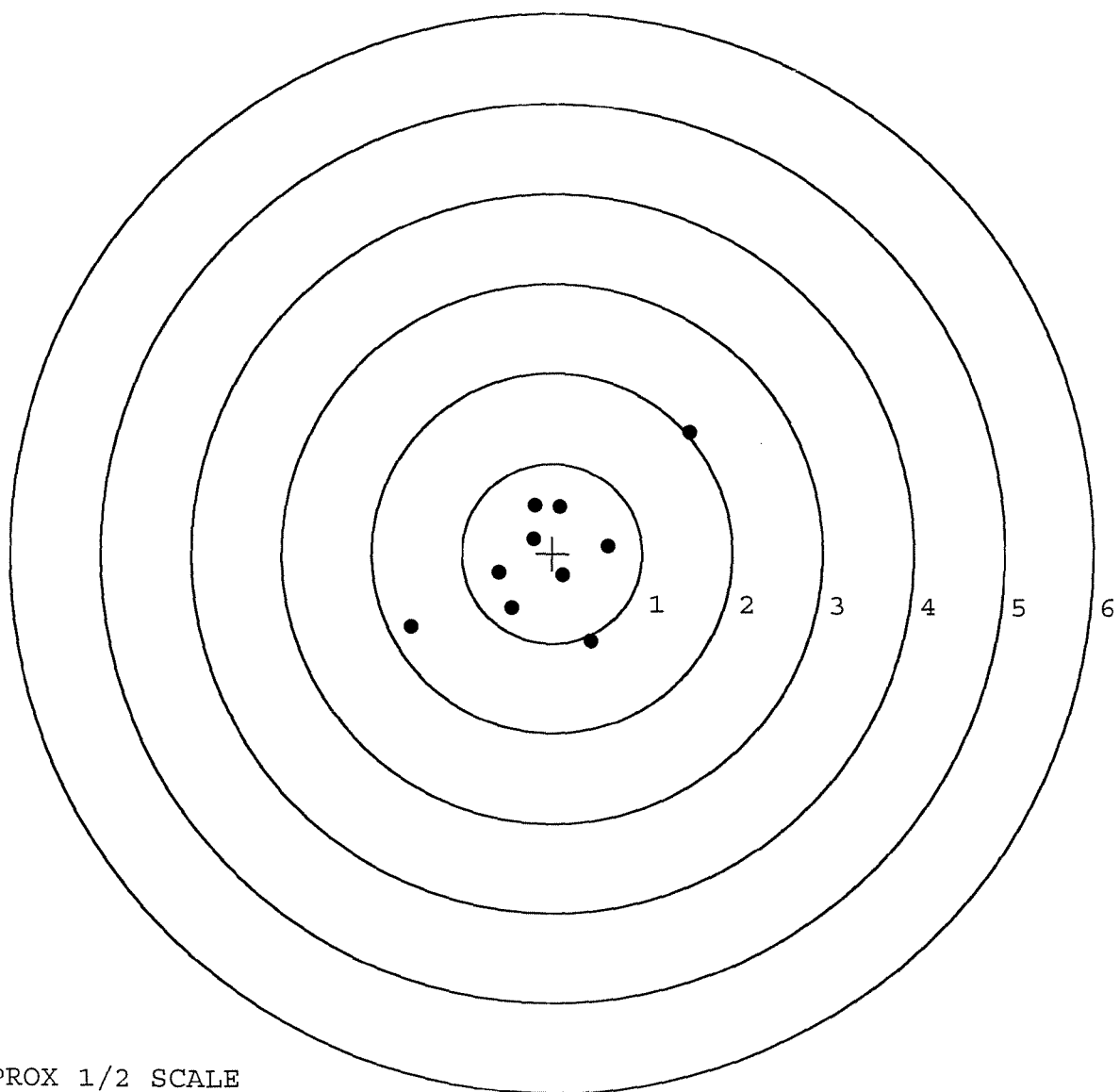
The Average X Centroid of the Five Target Set:	0.001
The Average Y Centroid of the Five Target Set:	-0.025
The Average Point of Impact of the Five Target Set:	0.025
The Average Mean Radius of the Five Target Set:	0.708
The Distance from POA to Centroid Target #1:	0.034
The Distance from Centroid Target #2 to Centroid Target #1:	0.174
The Distance from Centroid Target #3 to Centroid Target #1:	0.188
The Distance from Centroid Target #4 to Centroid Target #1:	0.165
The Distance from Centroid Target #5 to Centroid Target #1:	0.305

SERIAL NUMBER: G6361002.___0
TARGET NUMBER: 1
FILE DATE: 08/06/2007
FILE TIME: 11:21

X CENTROID: -0.023
Y CENTROID: -0.025
POA TO CENTROID: 0.034
HORZ SPREAD: 3.079
VERT SPREAD: 2.332
GROUP SPREAD: 3.778
MIN RADIUS: 0.258
MAX RADIUS: 2.067
MEAN RADIUS: 0.850

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.441	-0.976
2:	0.118	-0.244
3:	0.624	0.083
4:	0.074	0.515
5:	-0.204	0.532
6:	-0.208	0.155
7:	-0.587	-0.219
8:	-0.442	-0.616
9:	-1.564	-0.834
10:	1.515	1.356

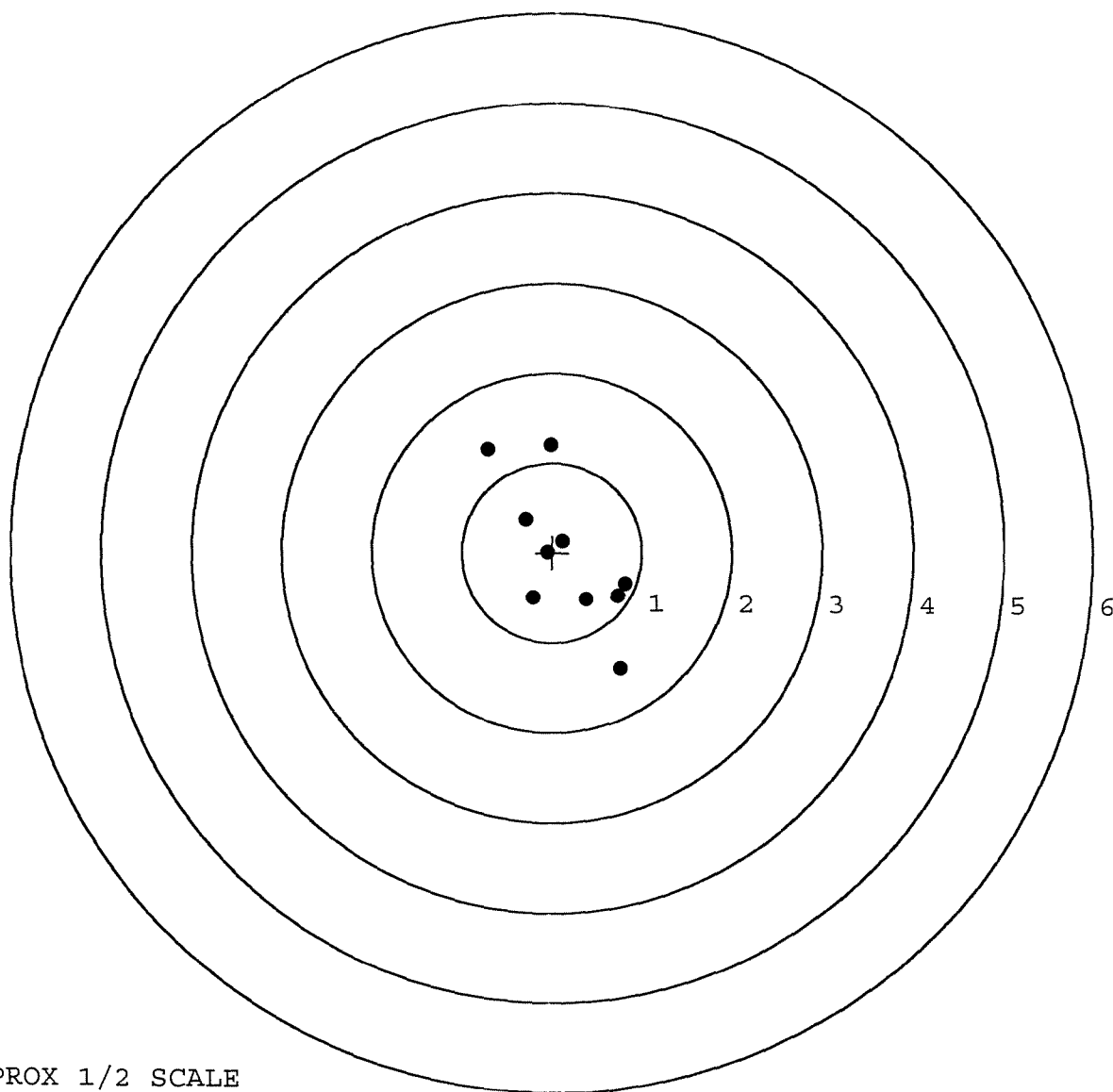


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361002.___0
TARGET NUMBER: 2
FILE DATE: 08/06/2007
FILE TIME: 11:21

X CENTROID: 0.150
Y CENTROID: -0.029
POA TO CENTROID: 0.153
HORZ SPREAD: 1.542
VERT SPREAD: 2.484
GROUP SPREAD: 2.855
MIN RADIUS: 0.167
MAX RADIUS: 1.466
MEAN RADIUS: 0.770
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.770	-1.286
2:	0.817	-0.341
3:	0.739	-0.475
4:	0.388	-0.515
5:	-0.212	-0.512
6:	-0.058	-0.002
7:	0.112	0.133
8:	-0.299	0.360
9:	-0.725	1.146
10:	-0.028	1.198

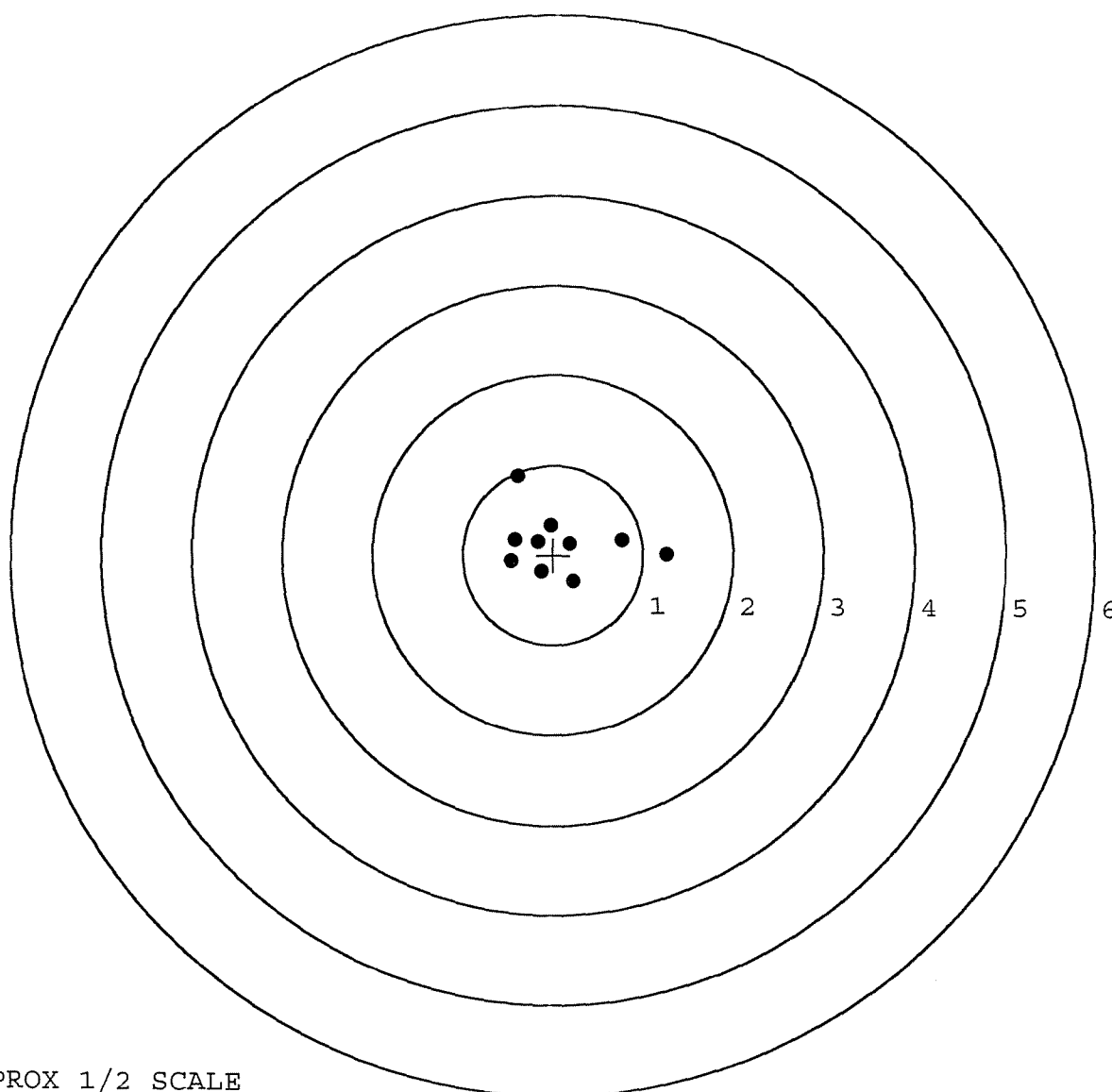


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361002.___0
TARGET NUMBER: 3
FILE DATE: 08/06/2007
FILE TIME: 11:21

X CENTROID: 0.079
Y CENTROID: 0.133
POA TO CENTROID: 0.155
HORZ SPREAD: 1.736
VERT SPREAD: 1.164
GROUP SPREAD: 1.872
MIN RADIUS: 0.101
MAX RADIUS: 1.192
MEAN RADIUS: 0.528
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.266	0.025
2:	0.765	0.180
3:	-0.401	0.877
4:	-0.033	0.333
5:	0.180	0.132
6:	0.229	-0.287
7:	-0.136	-0.181
8:	-0.470	-0.067
9:	-0.433	0.170
10:	-0.180	0.153

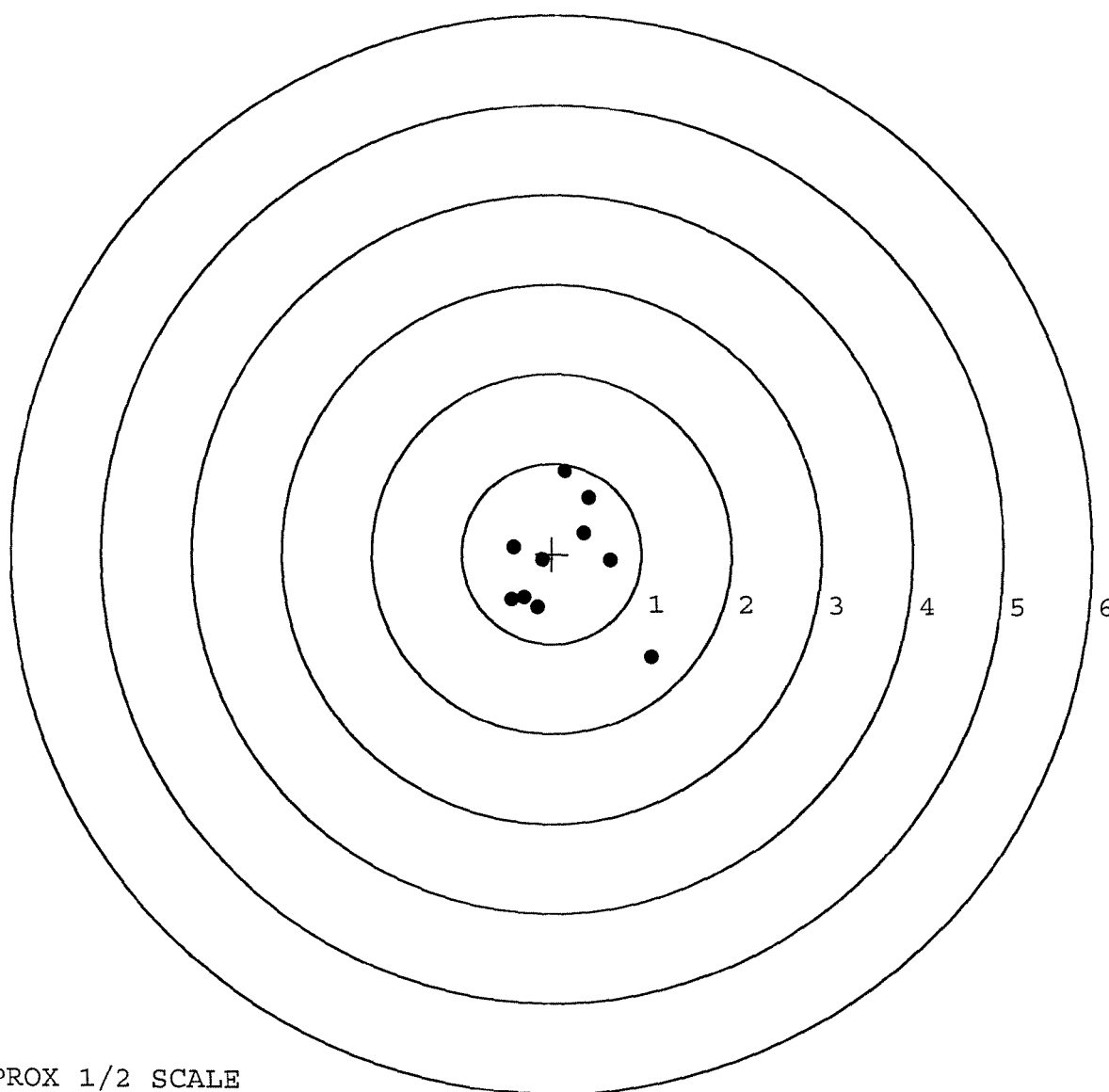


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361002.___0
TARGET NUMBER: 4
FILE DATE: 08/06/2007
FILE TIME: 11:21

X CENTROID: 0.121
Y CENTROID: -0.106
POA TO CENTROID: 0.161
HORZ SPREAD: 1.568
VERT SPREAD: 2.061
GROUP SPREAD: 2.282
MIN RADIUS: 0.235
MAX RADIUS: 1.440
MEAN RADIUS: 0.685
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.650	-0.073
2:	0.358	0.228
3:	0.410	0.625
4:	0.138	0.916
5:	-0.111	-0.069
6:	-0.430	0.067
7:	-0.166	-0.605
8:	-0.309	-0.490
9:	-0.450	-0.515
10:	1.118	-1.145

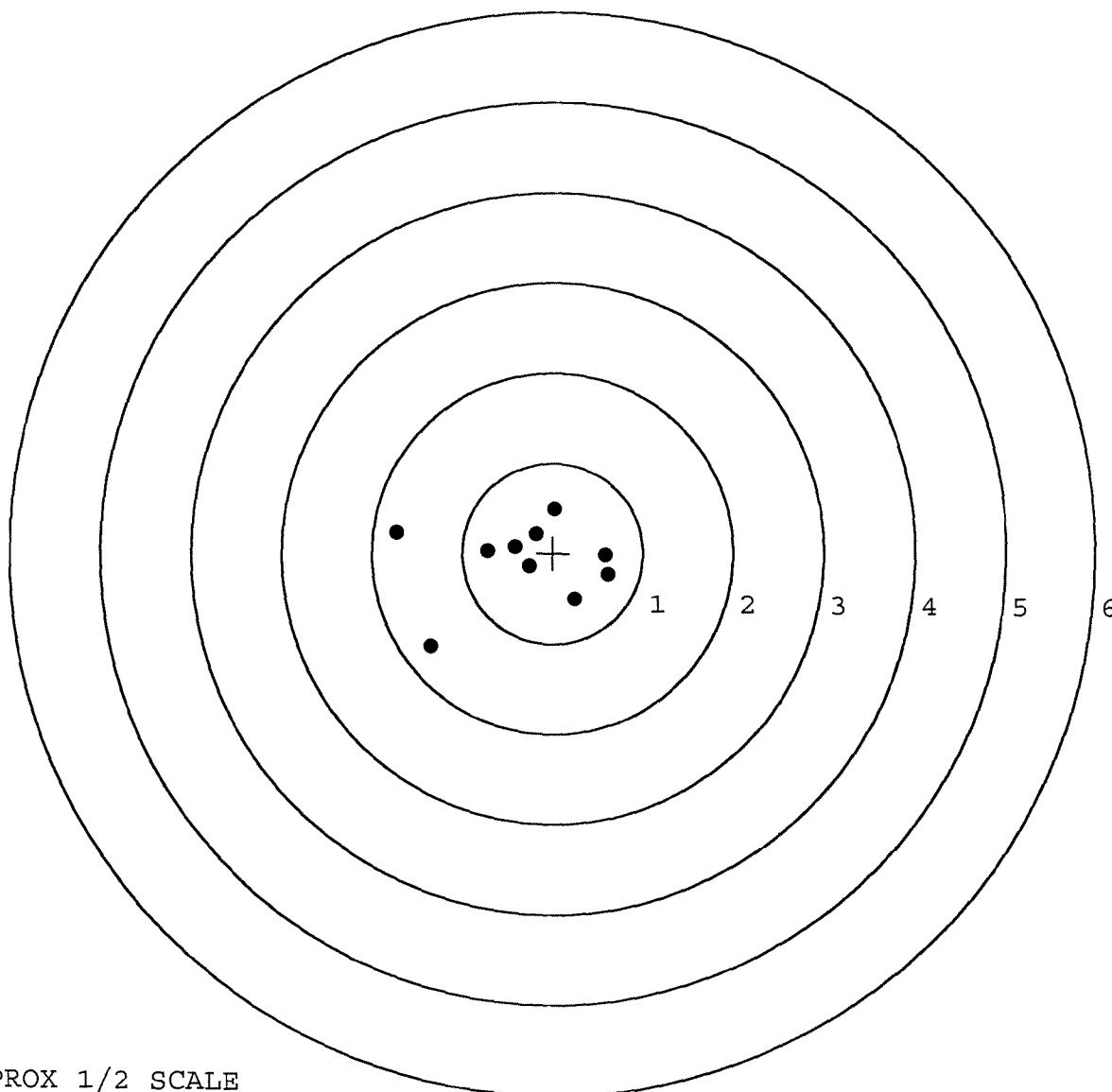


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361002.___0
TARGET NUMBER: 5
FILE DATE: 08/06/2007
FILE TIME: 11:21

POINT#	X	Y
1:	0.620	-0.236
2:	0.583	-0.022
3:	0.018	0.482
4:	0.251	-0.512
5:	-0.263	-0.147
6:	-0.188	0.213
7:	-0.423	0.064
8:	-0.721	0.019
9:	-1.730	0.209
10:	-1.346	-1.046

X CENTROID: -0.320
Y CENTROID: -0.098
POA TO CENTROID: 0.334
HORZ SPREAD: 2.350
VERT SPREAD: 1.528
GROUP SPREAD: 2.392
MIN RADIUS: 0.075
MAX RADIUS: 1.443
MEAN RADIUS: 0.709
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

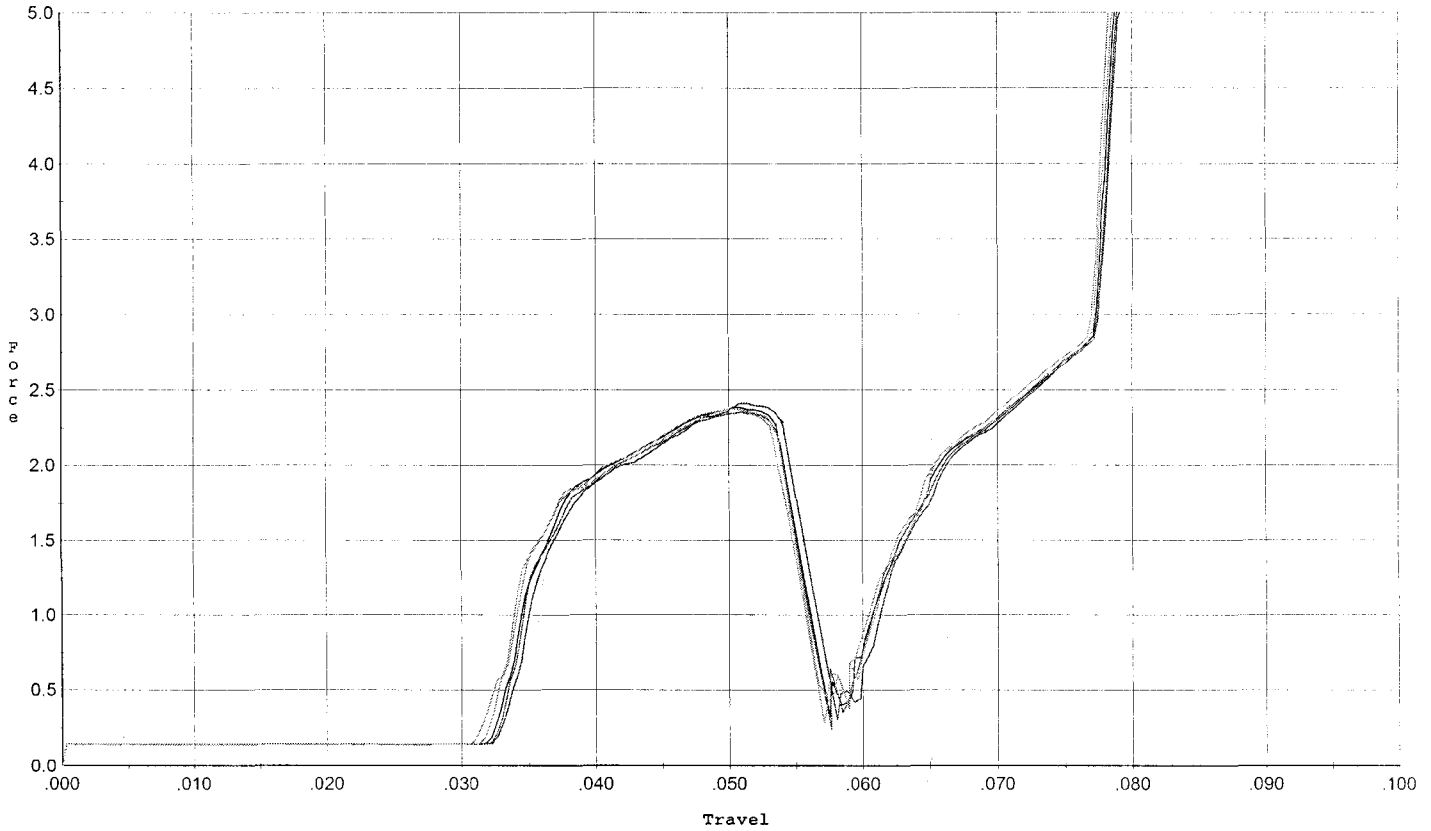


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

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



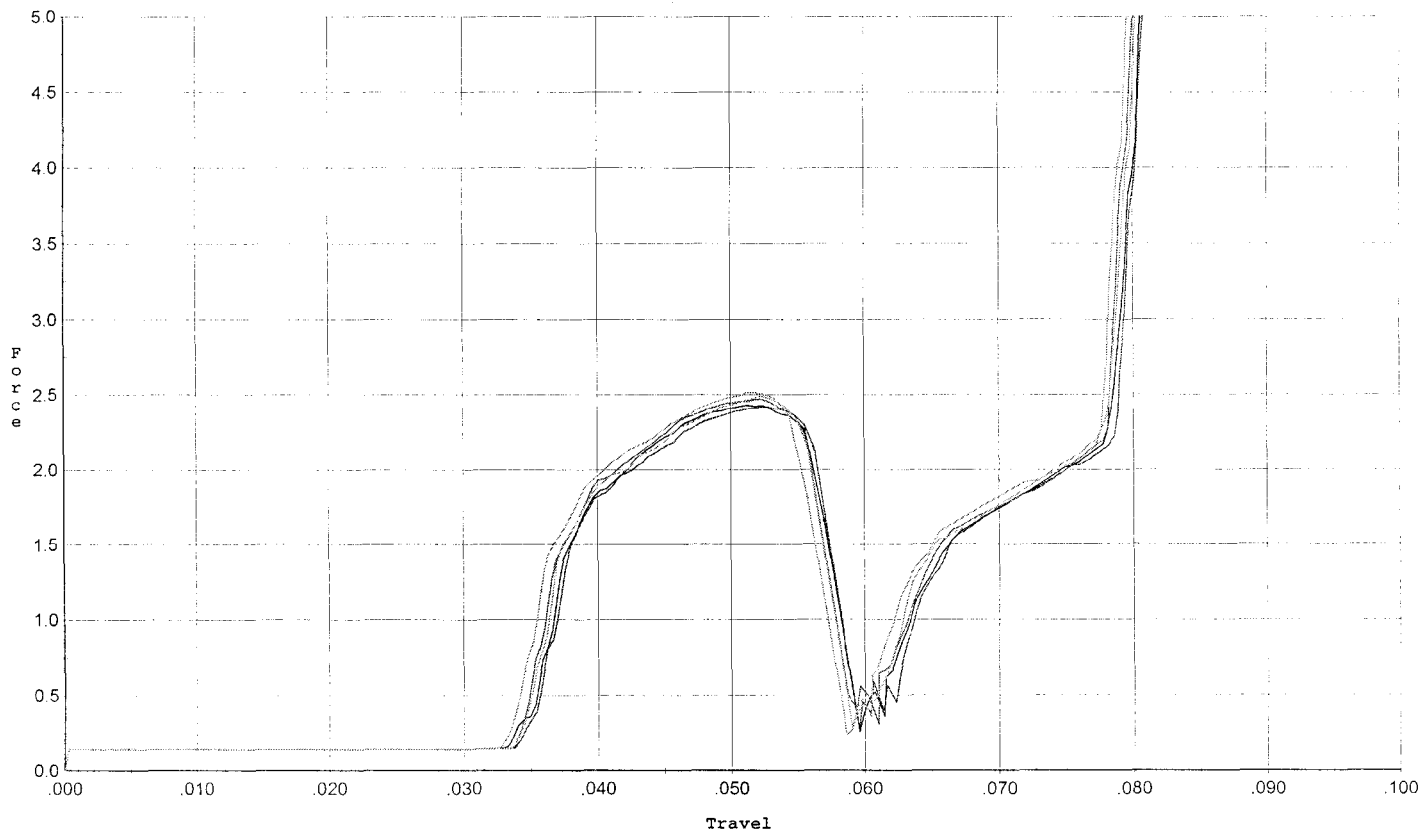
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.412	0.054	0.033	0.031	0.046		Set Trigger
2	2.382	0.054	0.033	0.031	0.046		Set Trigger
3	2.354	0.054	0.033	0.031	0.046		Set Trigger
4	2.374	0.054	0.032	0.031	0.048		Set Trigger
5	2.374	0.054	0.032	0.031	0.047		Set Trigger

Aug 237

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/28/07

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



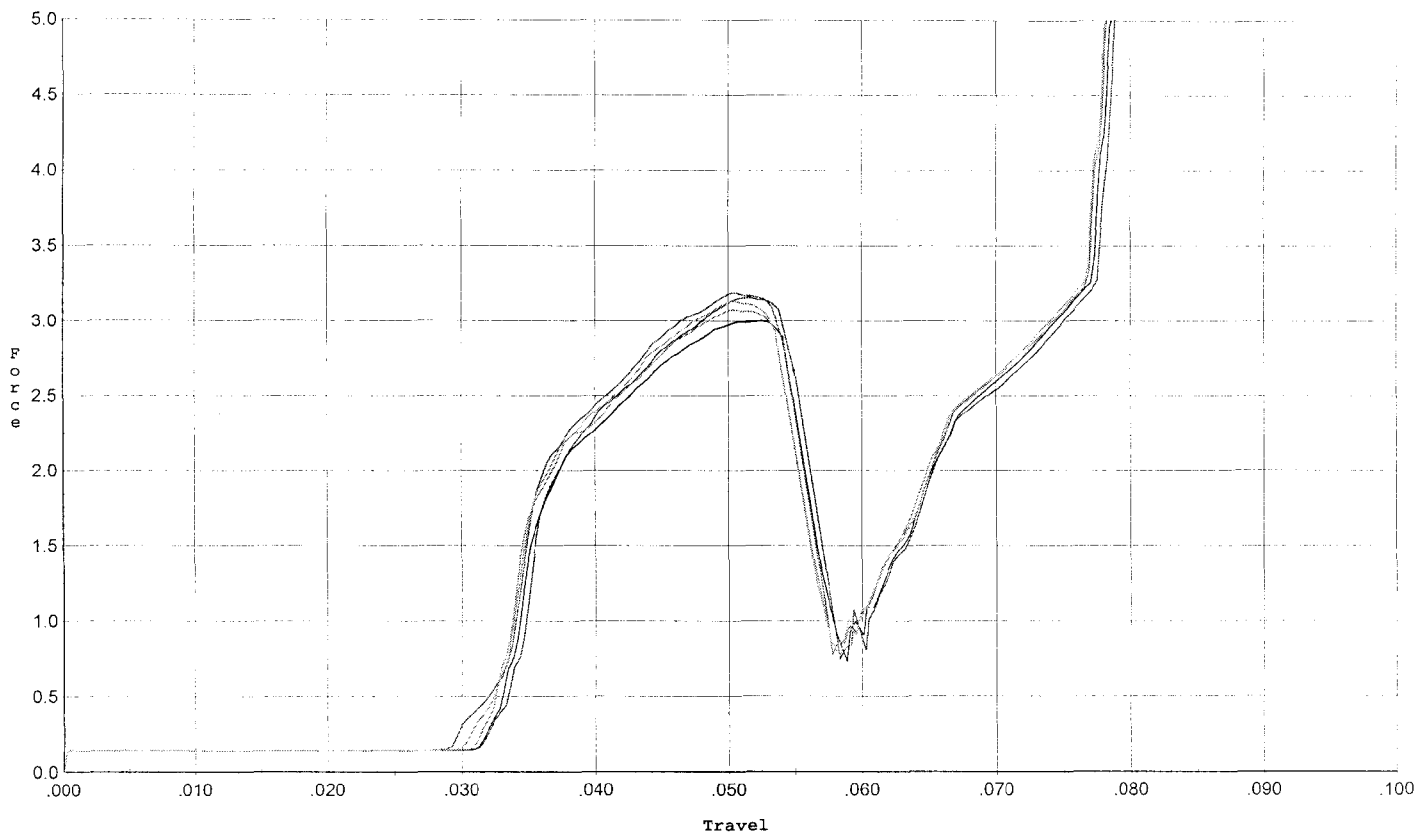
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.056	0.035	0.031	0.048		Set Trigger
2	2.430	0.057	0.034	0.031	0.050		Set Trigger
3	2.471	0.056	0.034	0.031	0.049		Set Trigger
4	2.491	0.056	0.034	0.031	0.049		Set Trigger
5	2.516	0.056	0.033	0.031	0.050		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/28/07

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



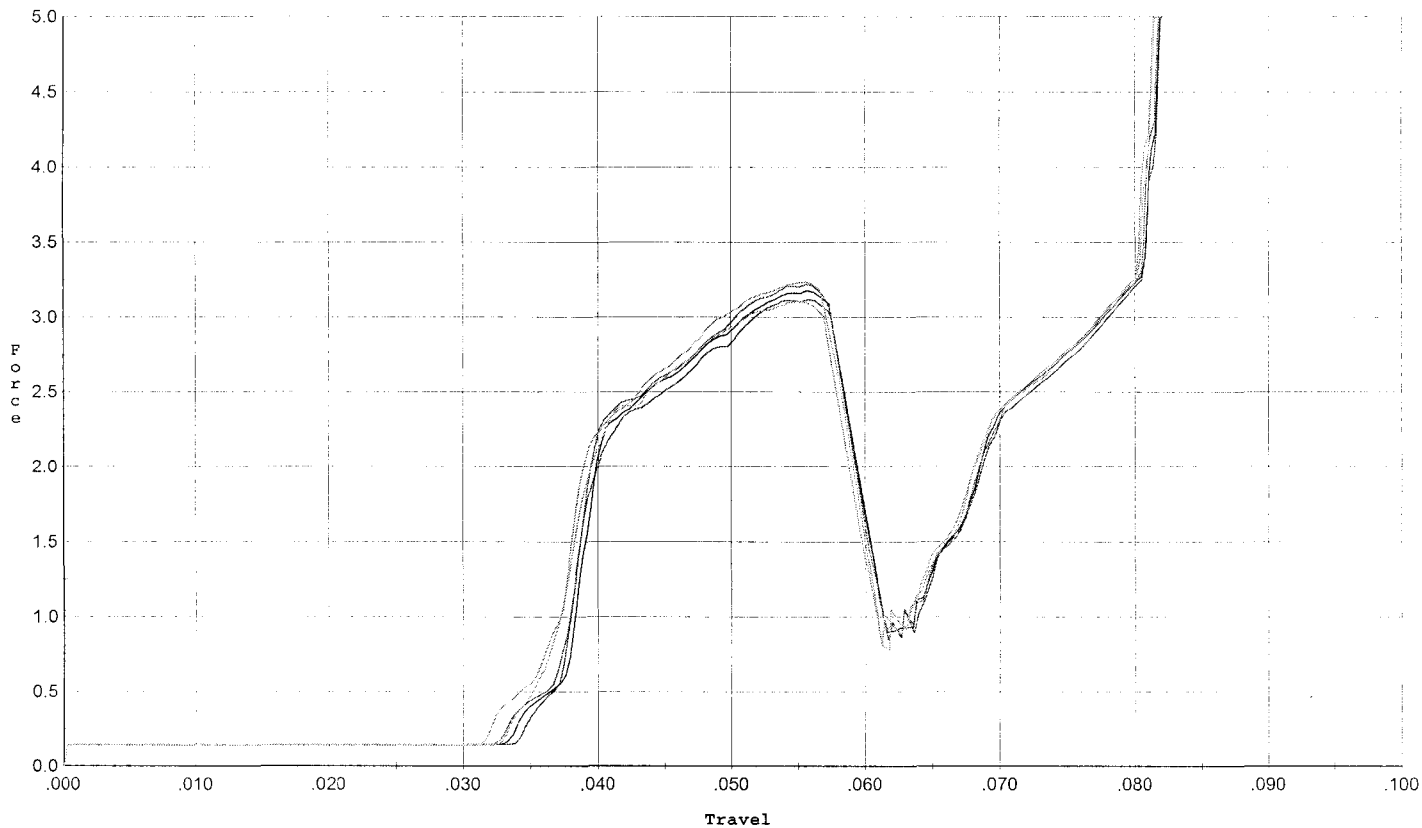
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.156	0.055	0.032	0.029	0.061		Set Trigger
2	3.001	0.054	0.032	0.030	0.058		Set Trigger
3	3.186	0.054	0.030	0.029	0.062		Set Trigger
4	3.130	0.054	0.031	0.030	0.059		Set Trigger
5	3.078	0.054	0.032	0.030	0.059		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/28/07

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



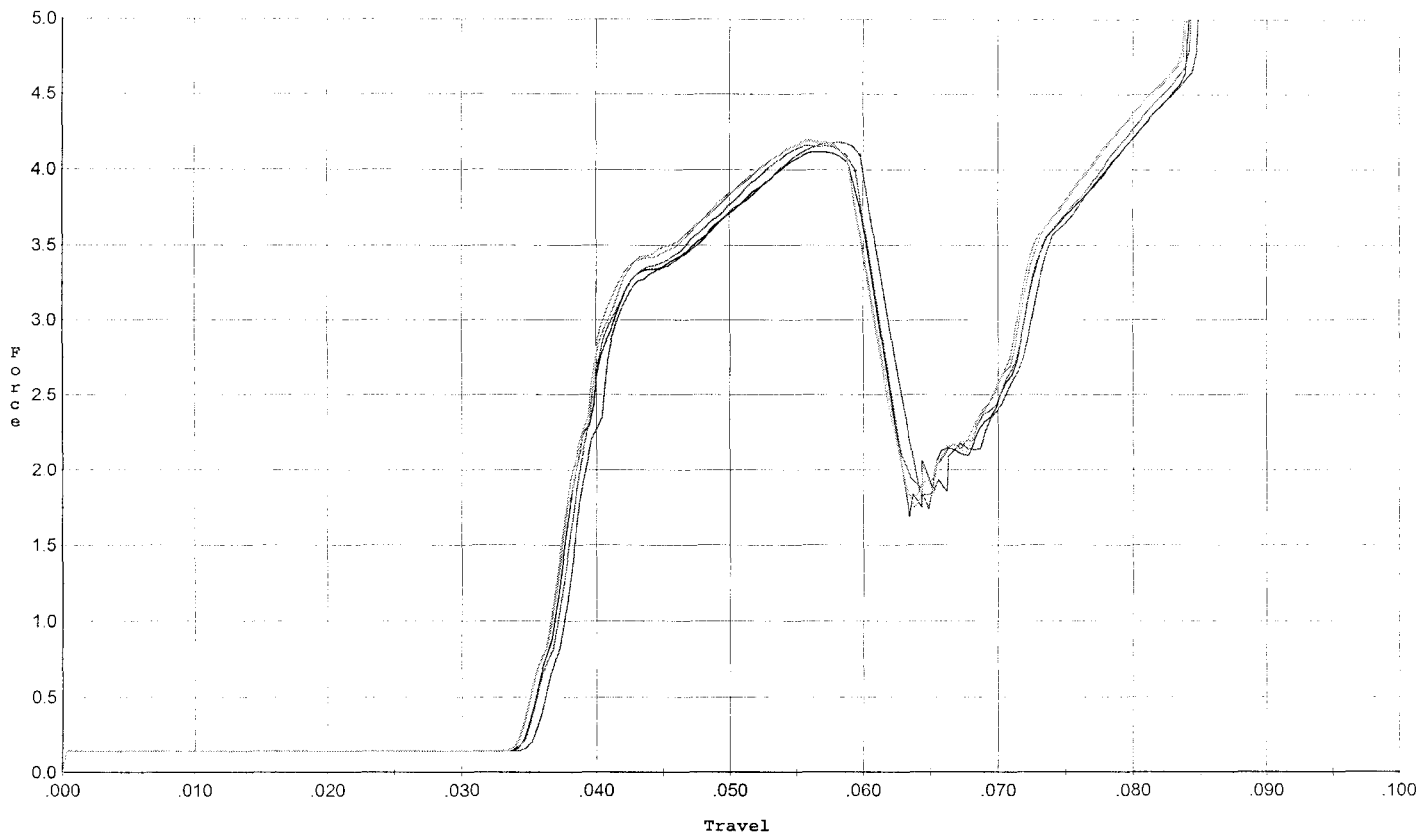
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.057	0.035	0.029	0.060		Set Trigger
2	3.177	0.057	0.034	0.029	0.061		Set Trigger
3	3.218	0.057	0.033	0.029	0.063		Set Trigger
4	3.104	0.057	0.033	0.030	0.061		Set Trigger
5	3.236	0.058	0.032	0.029	0.065		Set Trigger

Avg 3.17

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/28/07

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



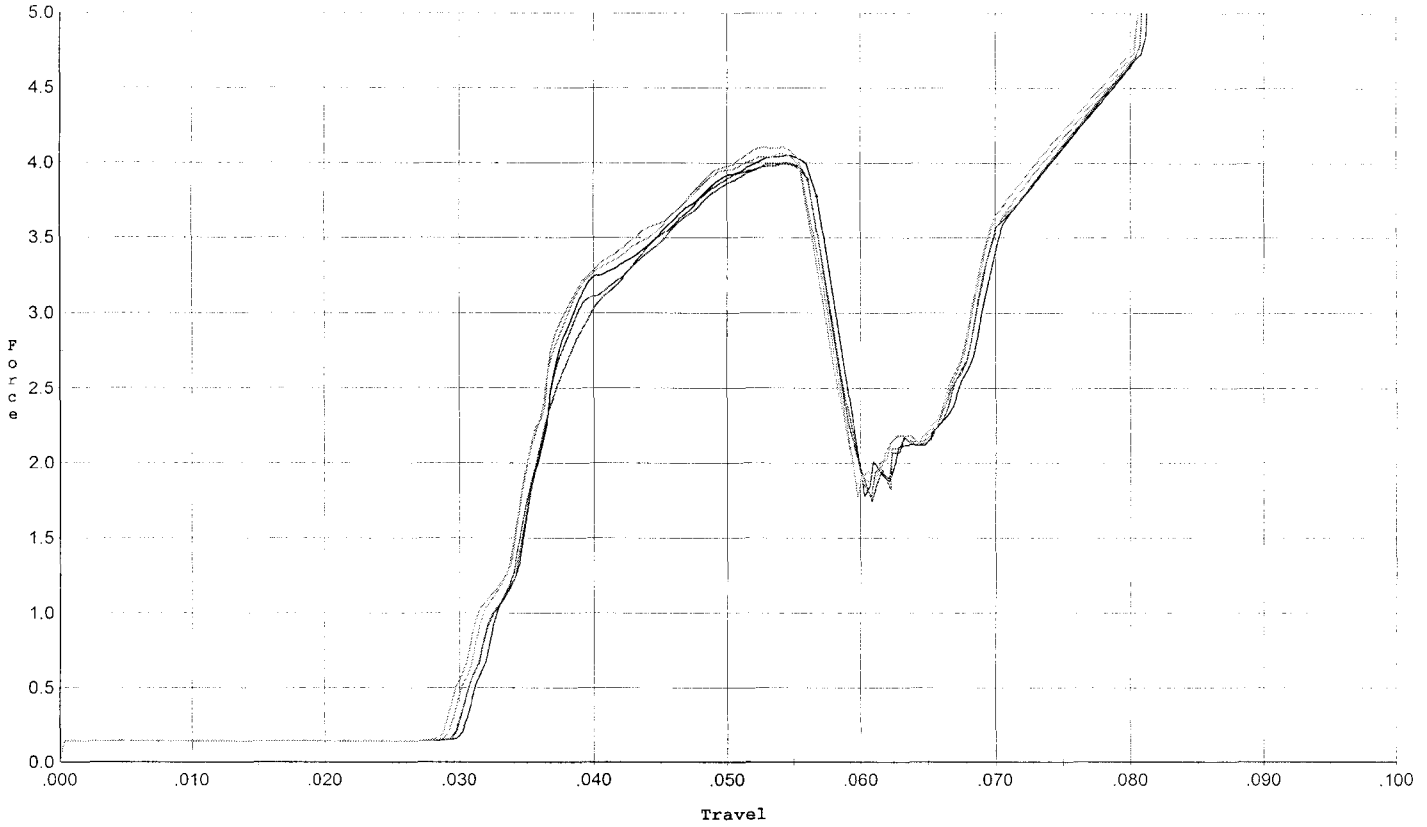
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.182	0.060	0.036	0.028	0.087		Set Trigger
2	4.118	0.060	0.035	0.028	0.088		Set Trigger
3	4.158	0.059	0.035	0.028	0.088		Set Trigger
4	4.190	0.059	0.035	0.028	0.088		Set Trigger
5	4.194	0.059	0.035	0.028	0.088		Set Trigger

Avg 4.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 6/28/07

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



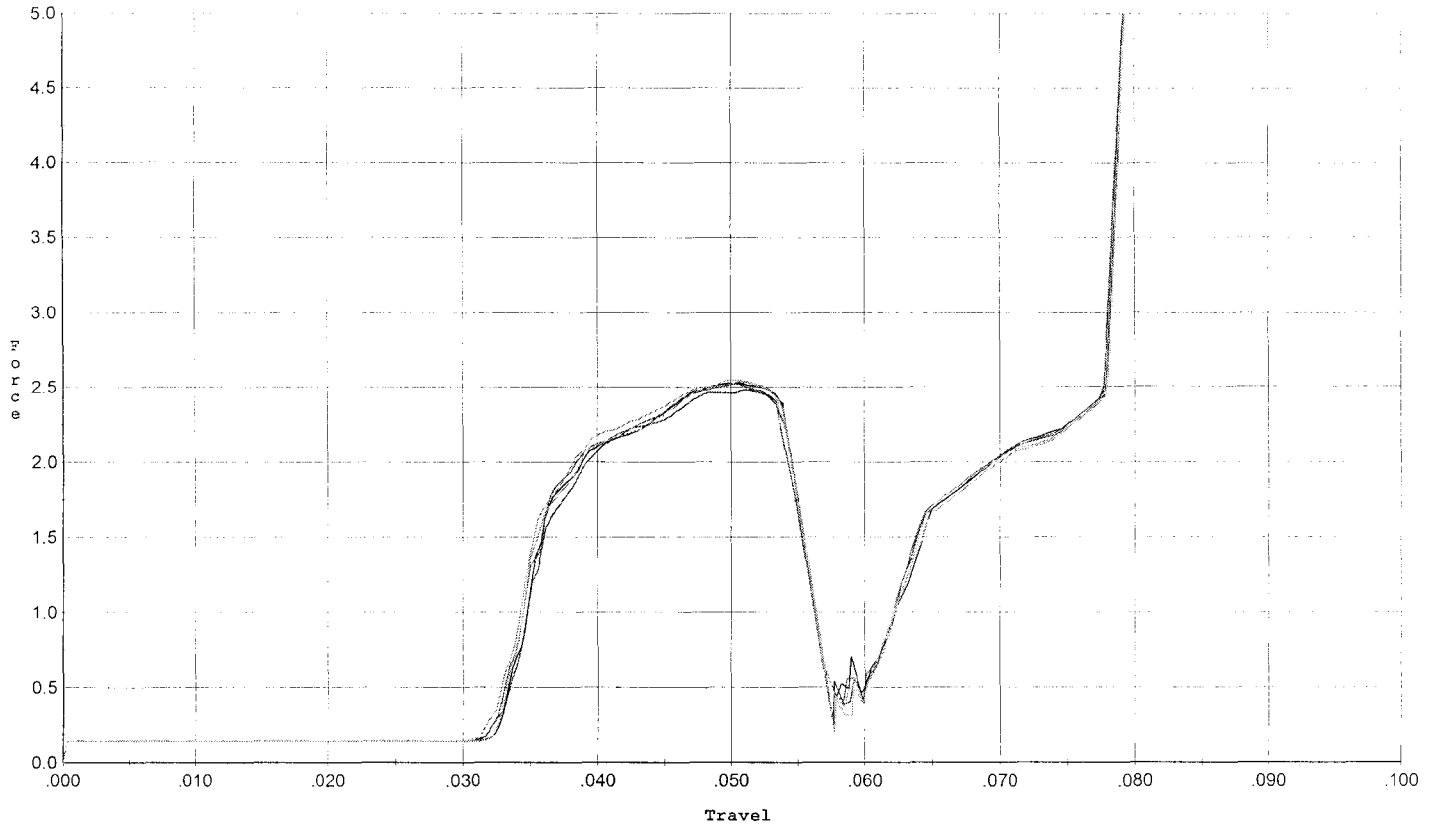
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.005	0.056	0.030	0.028	0.085		Set Trigger
2	4.049	0.057	0.031	0.028	0.087		Set Trigger
3	3.996	0.056	0.030	0.028	0.084		Set Trigger
4	4.061	0.055	0.030	0.029	0.085		Set Trigger
5	4.104	0.057	0.029	0.028	0.090		Set Trigger

Aug 4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/28/07

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



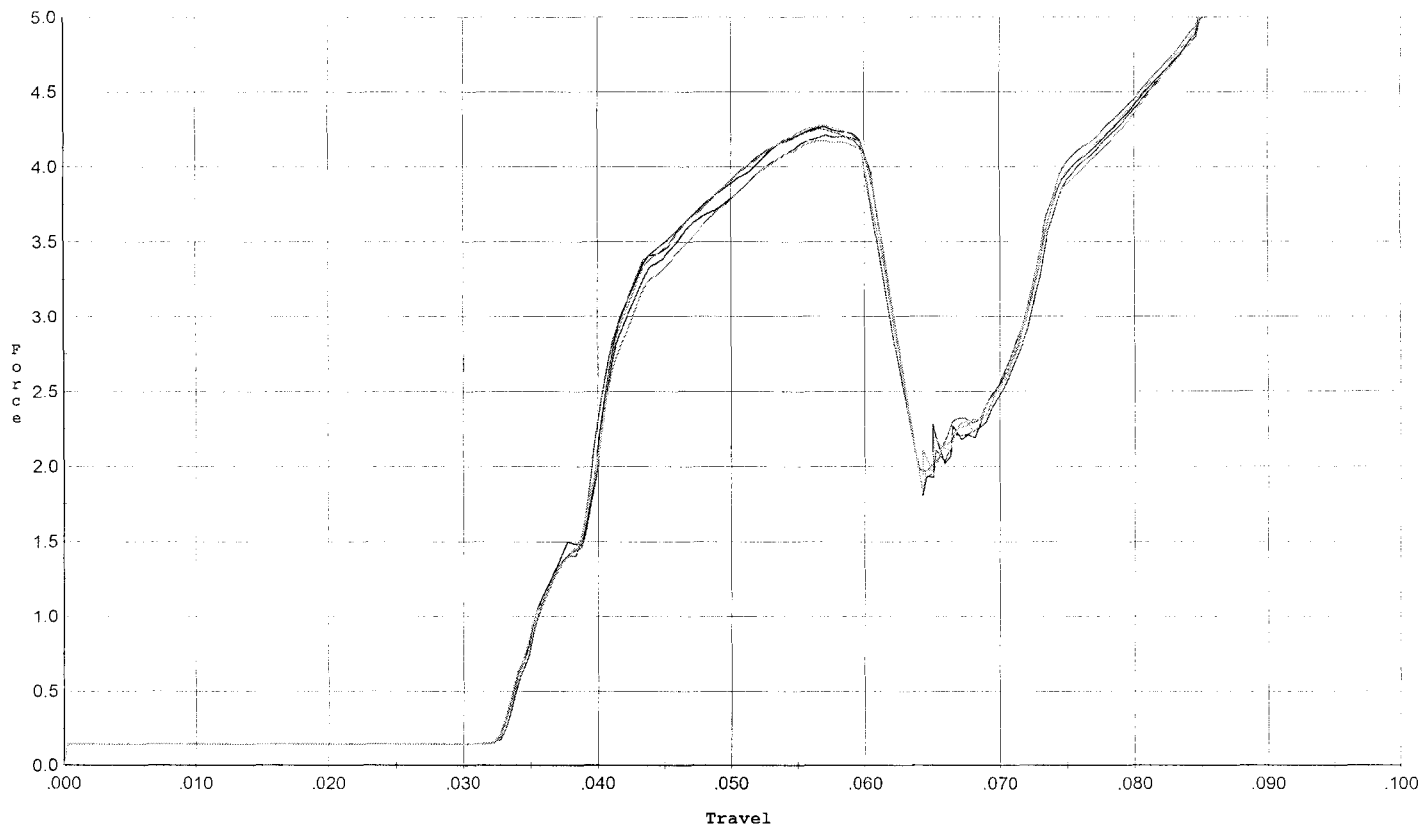
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.054	0.032	0.031	0.049		Set Trigger
2	2.530	0.054	0.033	0.031	0.050		Set Trigger
3	2.522	0.055	0.032	0.031	0.051		Set Trigger
4	2.549	0.054	0.032	0.031	0.051		Set Trigger
5	2.539	0.054	0.033	0.031	0.051		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 6/28/07

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	4.215	0.060	0.033	0.028	0.092		Set Trigger
2	4.272	0.061	0.033	0.028	0.094		Set Trigger
3	4.258	0.060	0.033	0.028	0.092		Set Trigger
4	4.175	0.061	0.033	0.028	0.093		Set Trigger
5	4.287	0.061	0.033	0.028	0.094		Set Trigger

AVG 4.24