

G-63C 1030

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 5618

DD FORM



ORDER NO. **25716**  
BARREL LENGTH 24"  
CAPACITY 6  
**G6361030**

NEW! IMPORTANT!  
NEVER DISCARD THIS  
STICKER OR INSTRUCTION  
BOOK. IF YOU LOSE  
THEM, YOU WILL  
LOSE YOUR WARRANTY.

**Remington®**

**M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)**  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO

ORDER NO. **G6361030**  
**25716**

DD

96019699 9145

7/22/2004 3:19:29 PM

Ctrl

2

Original

**25716**

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)



**.MA25716**

Shop Order: SWS628758



**.ABSW628758**

Start Date: 7/20/2004

Finish Date: 8/19/2004

0630

01PC001

Flat Black Powder Coat, Barrel and



**0003338174**

0640

89SWS1

Reassemble Action.



**0003338175**

0685

89SWS1

Attach Front and Rear Sight Assemblies



**0003338180**

0710

89SWS1

Pack Rifle & Stenell SWS Container



**.OP0710**

M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 6636/030

| OP #         | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|--------------|----------------------------------------------------------------|---------------------|---------|---------|
| 575 &<br>580 | ASSEMBLE ACTION<br>AND STOCK                                   |                     | 4-6-04  | RT      |
| 600          | PROOF                                                          |                     | 4-6-04  | RT      |
| 607          | CHECK HEADSPACE                                                |                     | 4-6-04  | RT      |
| 610          | DIS-ASSEMBLE GUN                                               |                     | 4-6-04  | RT      |
| 612          | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         | RT                  |         |         |
| 615          | ROLLMARK CALIBER                                               |                     | 4/8/04  | JB      |
| 617          | DRILL AND TAP<br>SIGHT HOLES                                   |                     |         |         |
| 620          | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 5-7     | TA      |
|              | (BOLT)                                                         |                     | 5-7     | TA      |
| 625          | FINAL ASSEMBLY                                                 |                     |         |         |
|              | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 6-14-04 | RW      |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 6-14-04 | RW      |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 6-14-04 | RW      |
|              | D) OIL FIRING PIN ASSEMBLY                                     |                     | 6-14-04 | RW      |
|              | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

| OP #  | OPERATION NAME                                                           | READINGS                                               | DATE    | INITIAL |
|-------|--------------------------------------------------------------------------|--------------------------------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>50</u> <u>50</u> <u>50</u>                          | 6-21-04 | RT      |
| CONT. | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>250</u> <u>250</u> <u>255</u>                       | 6-21-04 | RT      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                        | 6-21-04 | RT      |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.022</u> <u>.022</u>                    | 6-21-04 | RT      |
|       | J) ASSEMBLE STOCK                                                        |                                                        | 6-18-04 | RL      |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                        | 6-28-04 | RT      |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                        |         |         |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                        |         |         |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                        |         |         |
| 640   | GALLERY TEST AND<br>TARGET                                               | PASS FAIL                                              | 6-18-04 | A       |
|       | MALFUNCTION                                                              | CORRECTION                                             | 6-18-04 | A       |
|       | MALFUNCTION                                                              | CORRECTION                                             | 6-18-04 | A       |
|       | MALFUNCTION                                                              | CORRECTION                                             | 6-18-04 | A       |
|       | MALFUNCTION                                                              | CORRECTION                                             | 6-18-04 | A       |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                        | 6-18-04 | A       |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                        | 6-28-04 | RT      |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>291</u> <u>286</u> <u>293</u> <u>289</u> <u>295</u> | 6-21-04 | RT      |
|       | C) FUNCTION                                                              |                                                        |         |         |
| 660   | PACK                                                                     |                                                        | 8-4-04  | WA      |

## AVERAGE PULL FORCE BETWEEN

SERIAL NO. \_\_\_\_\_

## INITIAL &amp; CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 6-14-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER<br>50 CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |       | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|-------|----------|
| PULL #1 | 2.57                | 2.35                        |                                   | 2.77  |          |
| PULL #2 | 2.62                | 2.46                        |                                   | 2.73  |          |
| PULL #3 | 2.69                | 2.37                        |                                   | 2.56  |          |
| PULL #4 | 2.80                | 2.36                        |                                   | 2.49  |          |
| PULL #5 | 2.92                | 2.38                        |                                   | 2.71  |          |
| TOTAL   | 13.60               | 11.92                       |                                   | 13.26 |          |
| AVERAGE | 2.72                | 2.38                        |                                   | 2.65  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.24                | 3.28                        |  |          |
| PULL #2 | 3.19                | 3.09                        |  |          |
| PULL #3 | 3.16                | 3.13                        |  |          |
| PULL #4 | 3.18                | 3.17                        |  |          |
| PULL #5 | 3.13                | 3.17                        |  |          |
| TOTAL   | 15.90               | 15.84                       |  |          |
| AVERAGE | 3.18                | 3.16                        |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER<br>20 CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 4.39                | 4.13                        |                                   | 4.23                                    |
| PULL #2 | 4.33                | 4.22                        |                                   | 4.20                                    |
| PULL #3 | 4.43                | 4.28                        |                                   | 4.24                                    |
| PULL #4 | 4.43                | 3.93                        |                                   | 3.79                                    |
| PULL #5 | 4.52                | 3.98                        |                                   | 4.04                                    |
| TOTAL   | 22.10               | 20.54                       |                                   | 20.50                                   |
| AVERAGE | 4.42                | 4.10                        |                                   | 4.10                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361030.\_\_0  
FILE DATE AND TIME: 06/18/2004 06:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.039 |
| The Average Y Centroid of the Five Target Set:              | 0.130  |
| The Average Point of Impact of the Five Target Set:         | 0.136  |
| The Average Mean Radius of the Five Target Set:             | 0.782  |
| The Distance from POA to Centroid Target #1:                | 0.301  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.128  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.405  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.160  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.145  |

SERIAL NUMBER: G6361030. \_\_0

TARGET NUMBER: 1

FILE DATE: 06/18/2004

FILE TIME: 06:43

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.995 | 1.711  |
| 2:     | -1.007 | 0.931  |
| 3:     | -0.148 | 1.058  |
| 4:     | -0.007 | 0.868  |
| 5:     | 0.574  | 0.870  |
| 6:     | 0.359  | 0.690  |
| 7:     | 0.665  | -0.535 |
| 8:     | 0.445  | -0.835 |
| 9:     | -0.228 | -0.436 |
| 10:    | -0.389 | -1.403 |

X CENTROID: -0.073

Y CENTROID: 0.292

POA TO CENTROID: 0.301

HORZ SPREAD: 1.672

VERT SPREAD: 3.114

GROUP SPREAD: 3.172

MIN RADIUS: 0.580

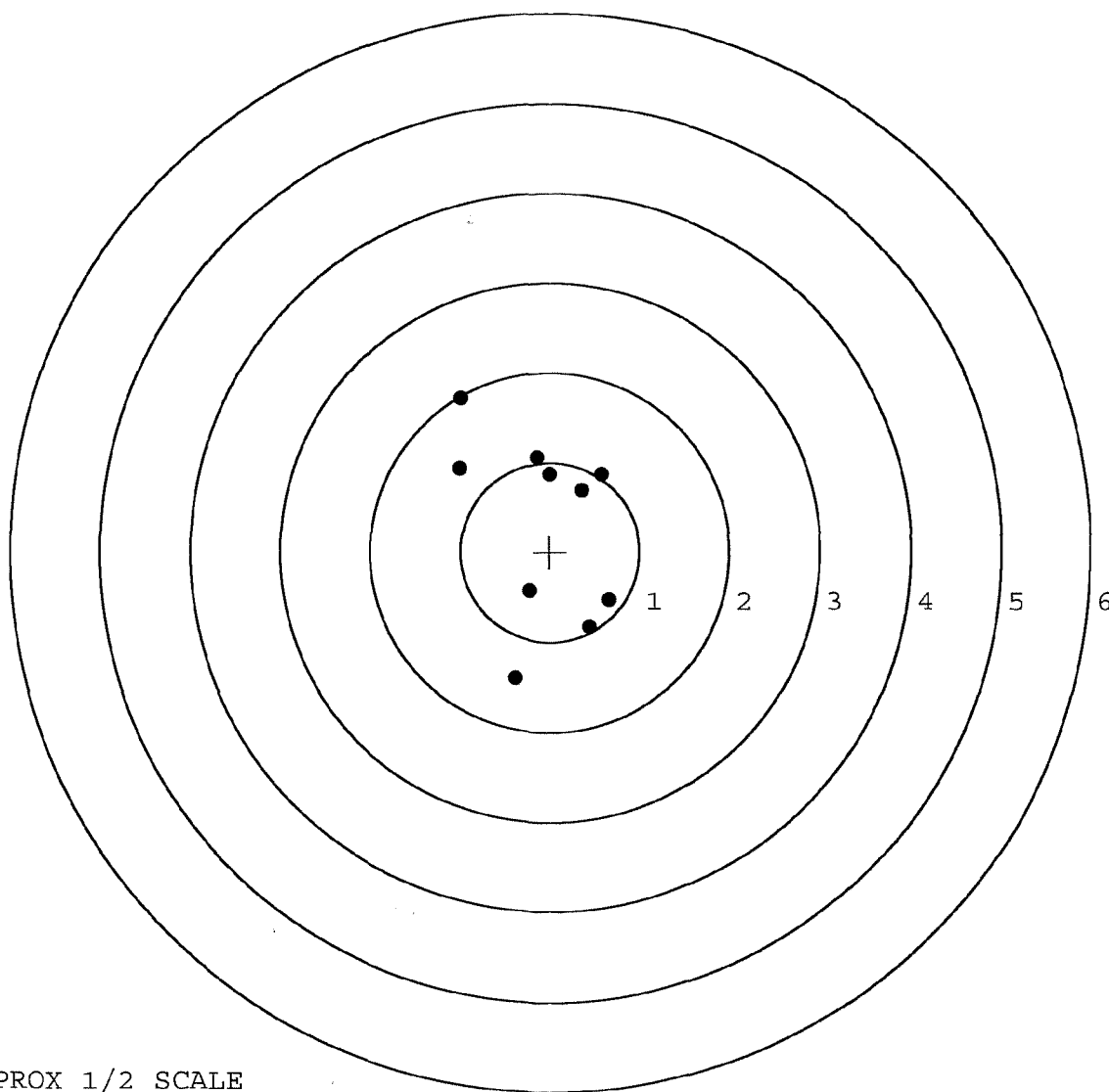
MAX RADIUS: 1.724

MEAN RADIUS: 1.045

# IN 1 IN DIAMETER: 0

# IN 2 IN DIAMETER: 5

# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 2

FILE DATE: 06/18/2004

FILE TIME: 06:43

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.495 | 1.463  |
| 2:     | 0.638  | 1.063  |
| 3:     | -1.087 | 0.842  |
| 4:     | -0.519 | 0.123  |
| 5:     | -0.090 | 0.445  |
| 6:     | 0.470  | -0.193 |
| 7:     | 0.030  | 0.009  |
| 8:     | -0.052 | -0.426 |
| 9:     | -0.002 | -0.742 |
| 10:    | 0.151  | -0.930 |

X CENTROID: -0.096

Y CENTROID: 0.165

POA TO CENTROID: 0.191

HORZ SPREAD: 1.725

VERT SPREAD: 2.393

GROUP SPREAD: 2.479

MIN RADIUS: 0.201

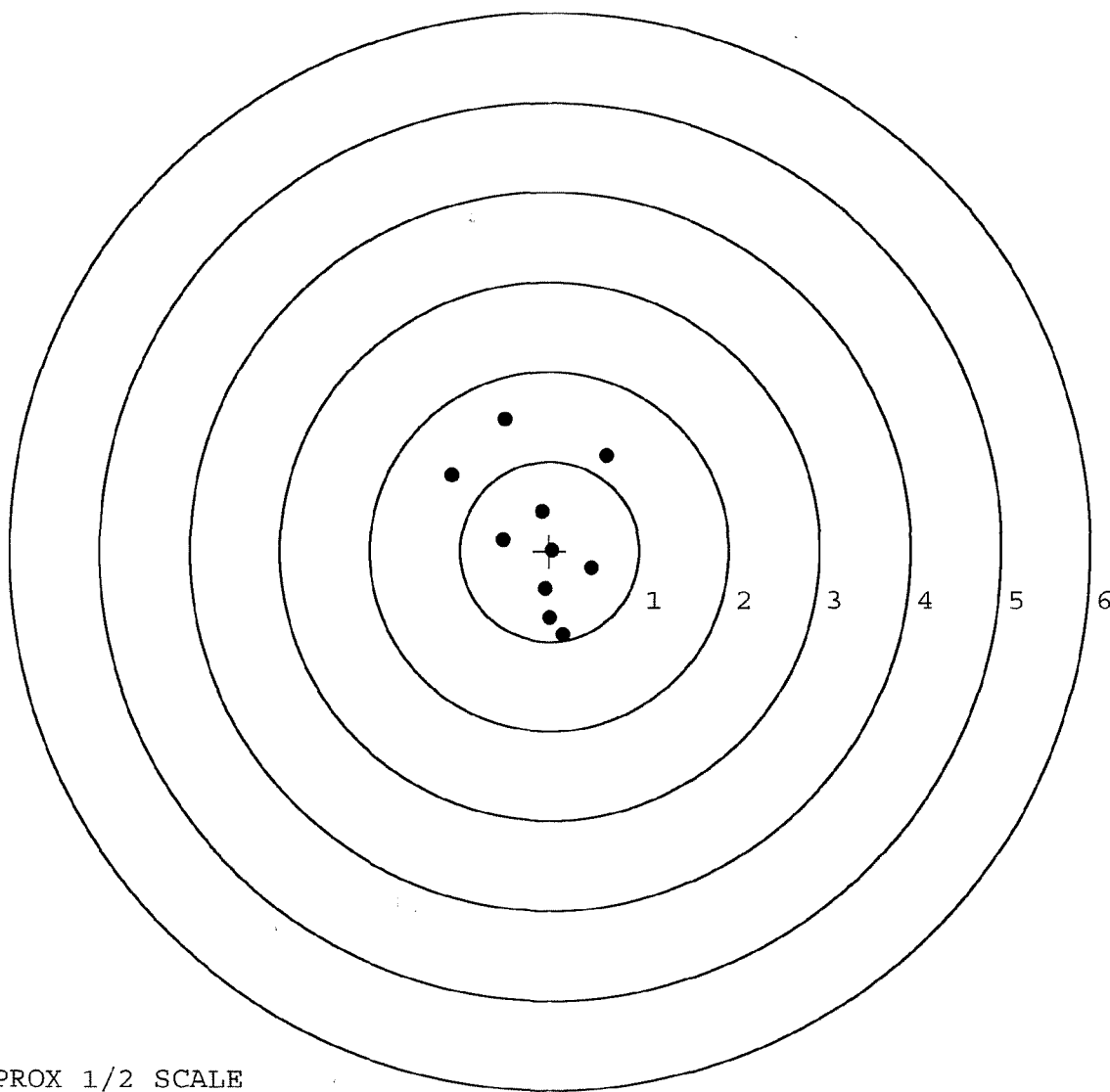
MAX RADIUS: 1.358

MEAN RADIUS: 0.792

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 3

FILE DATE: 06/18/2004

FILE TIME: 06:43

X CENTROID: 0.038

Y CENTROID: -0.097

POA TO CENTROID: 0.104

HORZ SPREAD: 2.433

VERT SPREAD: 1.735

GROUP SPREAD: 2.621

MIN RADIUS: 0.068

MAX RADIUS: 1.544

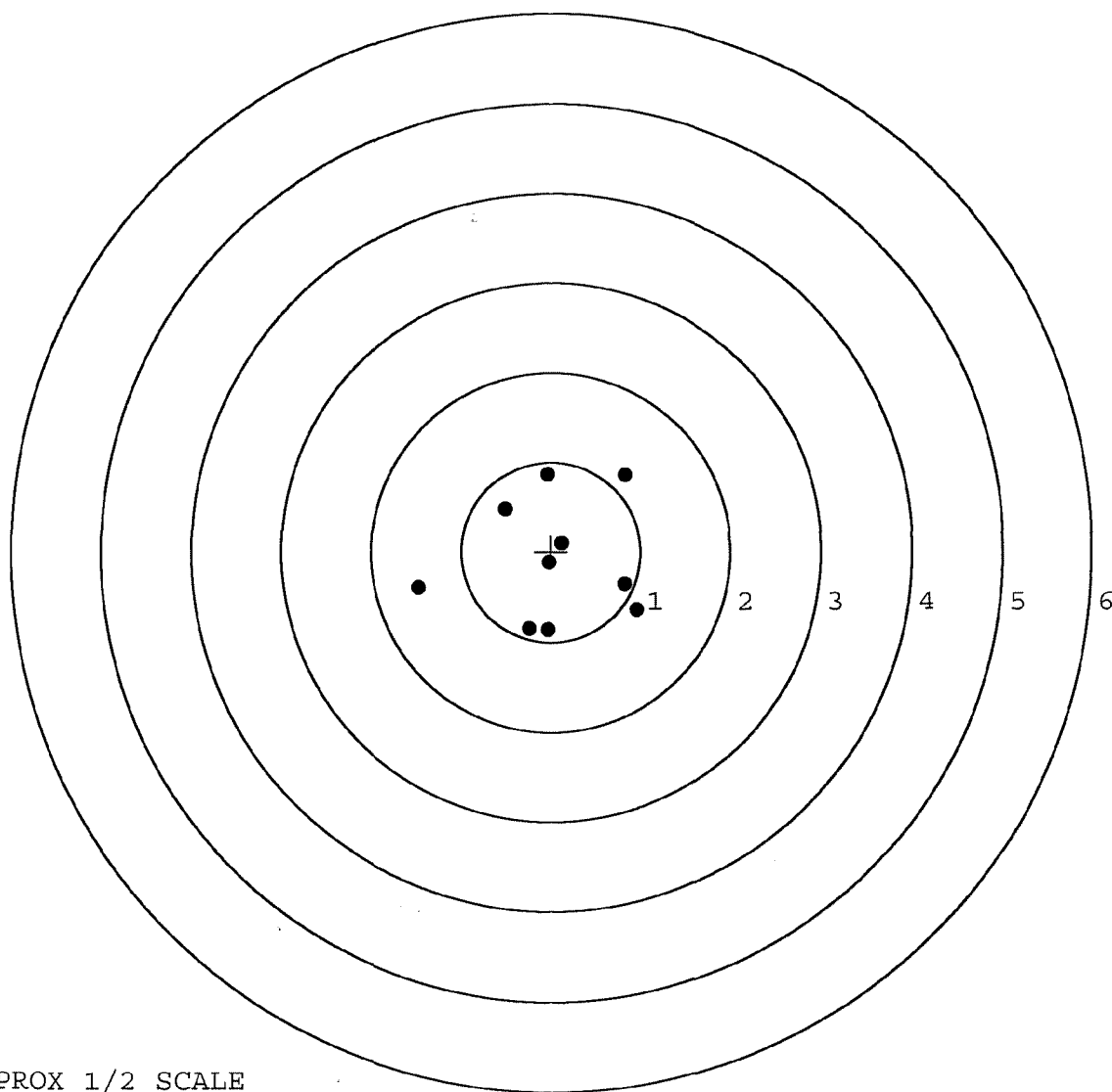
MEAN RADIUS: 0.832

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.823  | 0.859  |
| 2:     | -0.042 | 0.866  |
| 3:     | -0.515 | 0.475  |
| 4:     | 0.123  | 0.099  |
| 5:     | -0.023 | -0.126 |
| 6:     | 0.821  | -0.362 |
| 7:     | 0.958  | -0.652 |
| 8:     | -0.039 | -0.869 |
| 9:     | -1.475 | -0.402 |
| 10:    | -0.250 | -0.859 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 4

FILE DATE: 06/18/2004

FILE TIME: 06:43

X CENTROID: -0.024

Y CENTROID: 0.140

POA TO CENTROID: 0.142

HORZ SPREAD: 1.920

VERT SPREAD: 2.521

GROUP SPREAD: 2.613

MIN RADIUS: 0.221

MAX RADIUS: 1.661

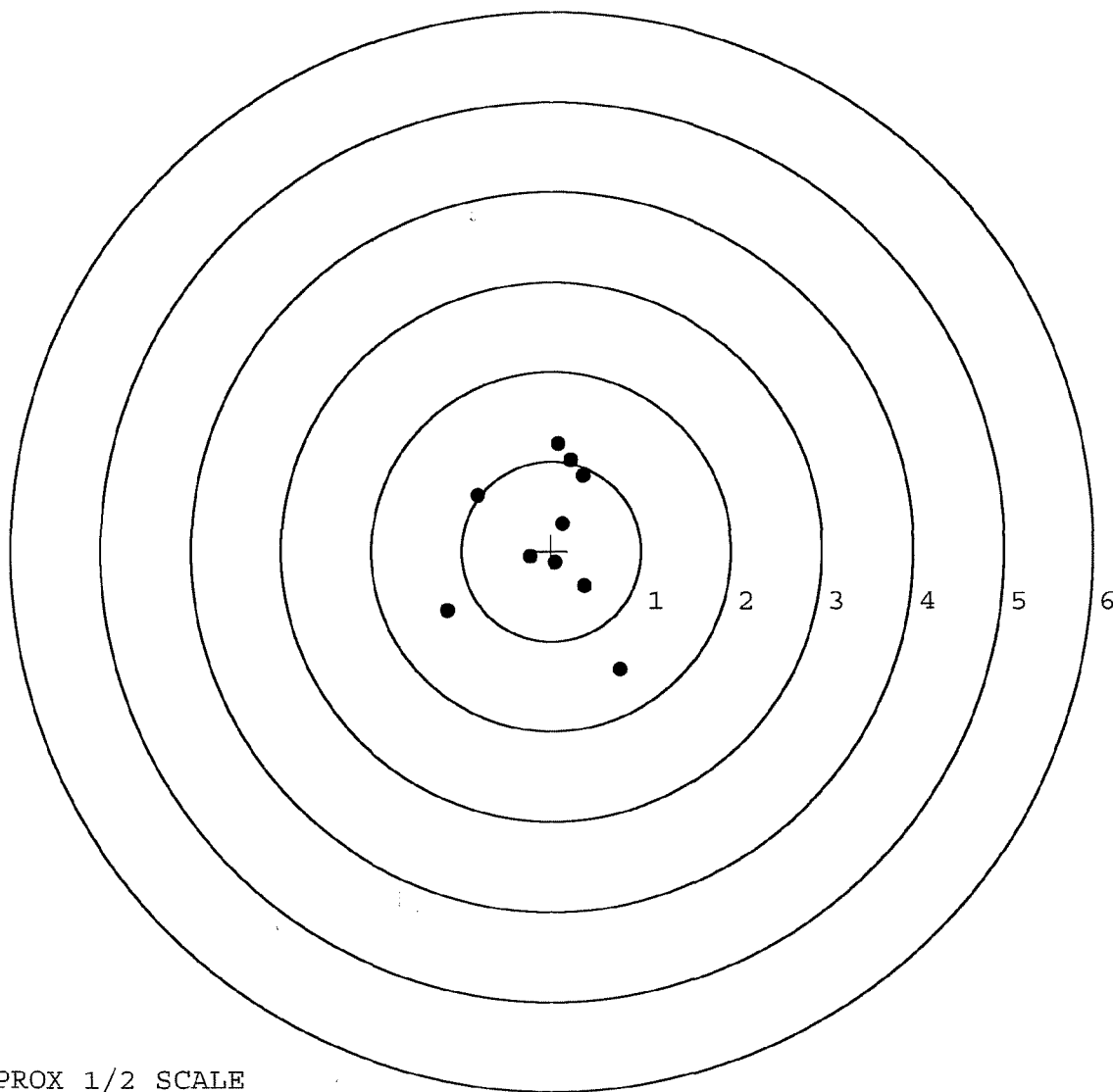
MEAN RADIUS: 0.819

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.077  | 1.199  |
| 2:     | 0.360  | 0.836  |
| 3:     | -0.817 | 0.615  |
| 4:     | 0.123  | 0.305  |
| 5:     | -0.236 | -0.063 |
| 6:     | 0.044  | -0.129 |
| 7:     | 0.372  | -0.387 |
| 8:     | -1.155 | -0.665 |
| 9:     | 0.765  | -1.322 |
| 10:    | 0.225  | 1.010  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361030. 0

TARGET NUMBER: 5

FILE DATE: 06/18/2004

FILE TIME: 06:43

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.411  | 0.776  |
| 2:     | -0.757 | 0.615  |
| 3:     | -0.202 | -0.543 |
| 4:     | -0.268 | 0.349  |
| 5:     | 0.309  | 0.296  |
| 6:     | 0.115  | 0.010  |
| 7:     | 0.163  | -0.245 |
| 8:     | -0.116 | -0.043 |
| 9:     | -0.096 | 0.303  |
| 10:    | 0.055  | -0.009 |

X CENTROID: -0.039

Y CENTROID: 0.151

POA TO CENTROID: 0.156

HORZ SPREAD: 1.168

VERT SPREAD: 1.319

GROUP SPREAD: 1.284

MIN RADIUS: 0.163

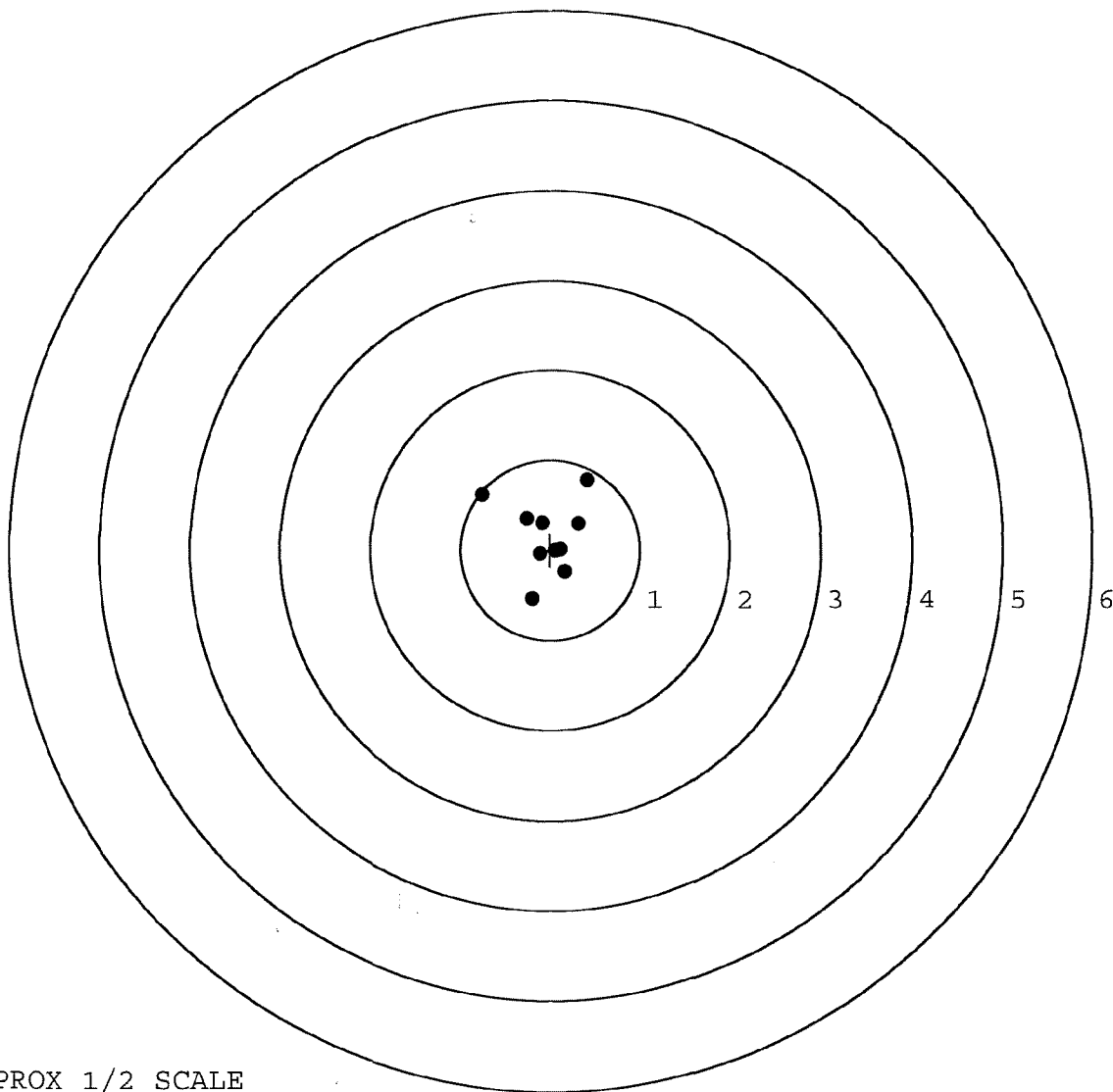
MAX RADIUS: 0.855

MEAN RADIUS: 0.423

# IN 1 IN DIAMETER: 7

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE