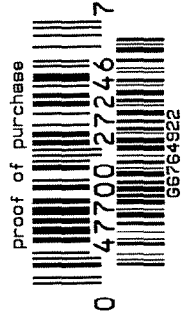


5676 4922

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

- INSTRUCTION BOOK 3518

BM FORM

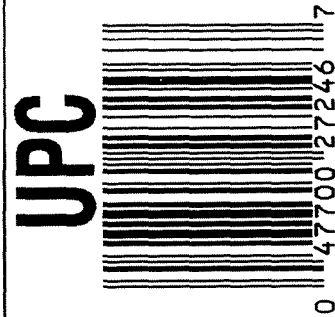


ORDER NO. **27246**

BARREL LENGTH **24"**

CAPACITY **6**

G6764922



M-24
INSPECTION CHECKLIST-NEW GUNS

SOP 6238

GUN SERIAL # C6764922

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-23-08	RTZ
430	ASSEMBLE TO STOCK		7-23-08	MED
440	PROOF		7-23-08	TRW
460	CHECK HEADSPACE		7-23-08	TRW
470	DIS-ASSEMBLE ACTION		7-23-08	RTZ
472	SERIALIZE BOLT HANDLE		7-24-08	RTZ
475	DRILL AND TAP SIGHT HOLES			
480	MAGNAFLUX BBL ACTION	Scrap	7-25-08	BT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/5/08	RT
520	GOFF BLAST BBL / REC		8/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		8/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		8/21/08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-15-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-15-08	JP
	D) OIL FIRING PIN ASSEMBLY		8-21-08	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>3.0</u> <u>3.0</u> <u>3.0</u>	9.4.08	RSW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.5</u> <u>5.5</u>	9.4.08	RSW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	9.4.08	RSW
	J) ASSEMBLE STOCK		8-21-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		9.5-08	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT		N/A	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL <u>PASS</u> FAIL	9.3.08	FN
	MALFUNCTION <i>Bolt Bands</i>	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9.3-08	TRW
670	FINAL INSPECTION A) HEADSPACE		9.4.08	RSW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>263</u> <u>265</u> <u>258</u> <u>265</u> <u>265</u>	9.4.08	RTZ
	C) FUNCTION		9.4.08	RSW
690	PACK			

F004 REV 5/2006

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER

SERIAL NUMBER

66264922

LOG-IN DATE

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN		
505	RE-BARREL		
560	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX	8-5-08	BT
510	DRILL AND TAP		
615	ROLLMARK CALIBER	8/5/08	RT
618	ROTO-BLAST	8/6/08	DG
620	APPLY COATINGS	8/8	
625	FINAL ASSEMBLY		
640	FUNCTION TEST AND	PASS FAIL	
650	TARGET	PASS FAIL	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION A) HEADSPACE	PASS FAIL	
	BI TRIGGER PULL		
	FI SAFETY ON FORCE		
	GI SAFETY OFF FORCE		
	I) FIRING PIN INDENT		
690	PACK		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6764922.___0
FILE DATE AND TIME: 09/03/2008 10:38

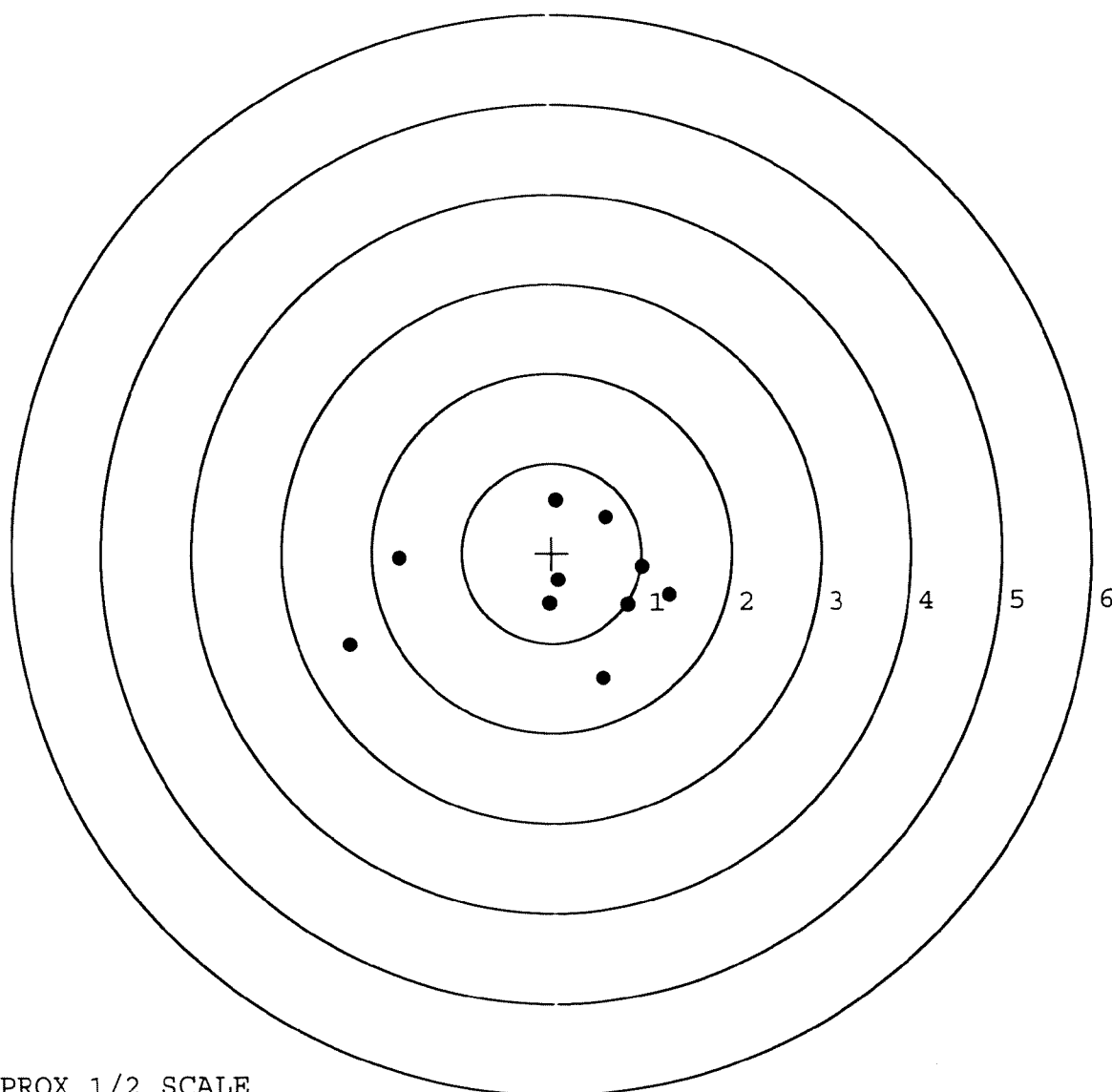
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	-0.082
The Average Point of Impact of the Five Target Set:	0.091
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.359
The Distance from Centroid Target #2 to Centroid Target #1:	0.558
The Distance from Centroid Target #3 to Centroid Target #1:	0.527
The Distance from Centroid Target #4 to Centroid Target #1:	0.172
The Distance from Centroid Target #5 to Centroid Target #1:	0.184

SERIAL NUMBER: G6764922. __0
TARGET NUMBER: 1
FILE DATE: 09/03/2008
FILE TIME: 10:38

X CENTROID: 0.046
Y CENTROID: -0.356
POA TO CENTROID: 0.359
HORZ SPREAD: 3.552
VERT SPREAD: 1.996
GROUP SPREAD: 3.591
MIN RADIUS: 0.059
MAX RADIUS: 2.385
MEAN RADIUS: 1.056
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.566	-1.404
2:	-0.033	-0.563
3:	0.067	-0.301
4:	-2.247	-1.011
5:	-1.696	-0.047
6:	0.050	0.592
7:	0.603	0.399
8:	1.002	-0.166
9:	0.844	-0.584
10:	1.305	-0.480

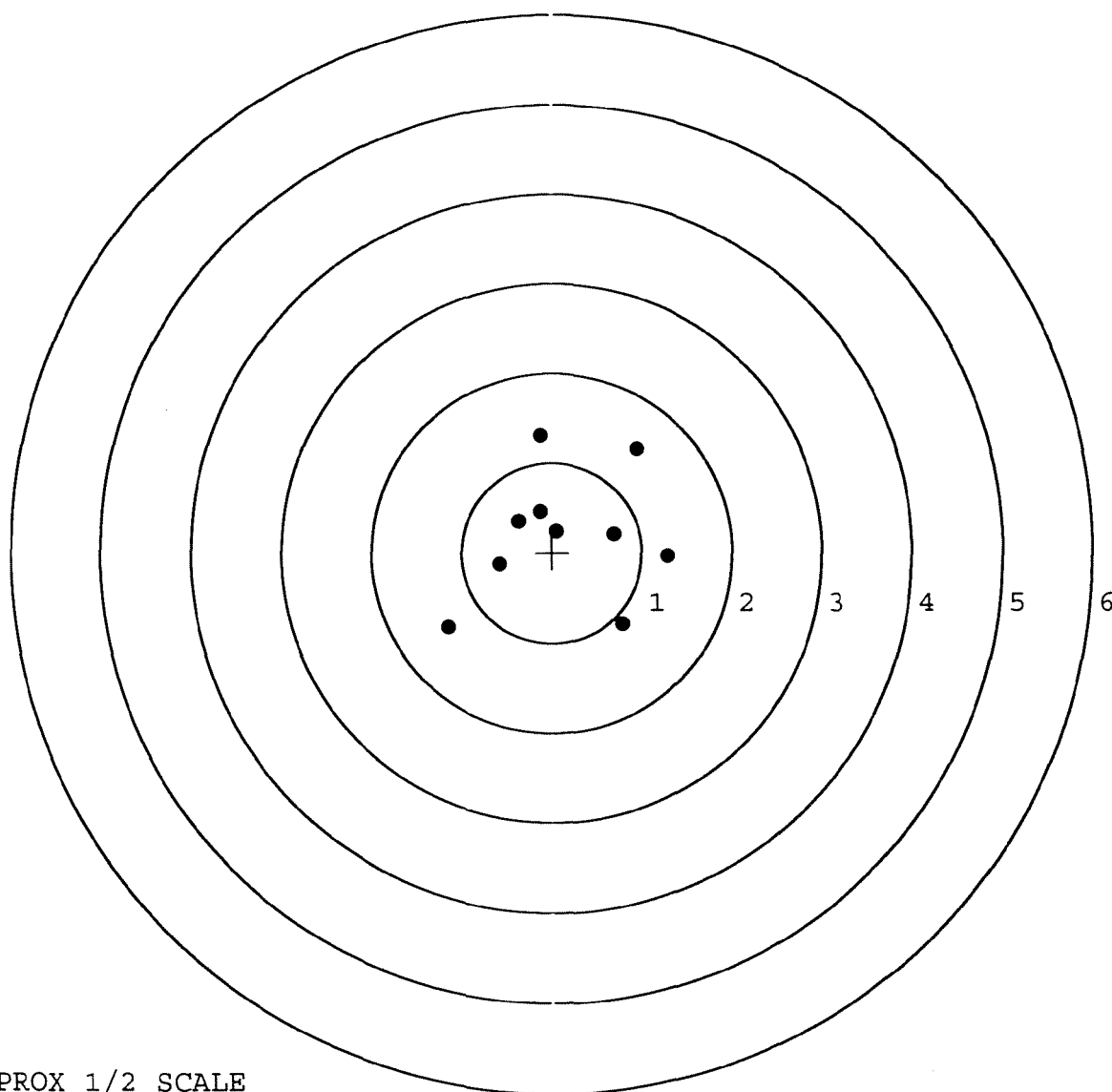


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. __0
TARGET NUMBER: 2
FILE DATE: 09/03/2008
FILE TIME: 10:38

POINT#	X	Y
1:	-1.147	-0.827
2:	-0.575	-0.127
3:	0.781	-0.788
4:	1.293	-0.042
5:	0.689	0.213
6:	0.953	1.156
7:	-0.131	1.306
8:	-0.132	0.457
9:	0.052	0.234
10:	-0.373	0.349

X CENTROID: 0.141
Y CENTROID: 0.193
POA TO CENTROID: 0.239
HORZ SPREAD: 2.440
VERT SPREAD: 2.133
GROUP SPREAD: 2.888
MIN RADIUS: 0.098
MAX RADIUS: 1.643
MEAN RADIUS: 0.874
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

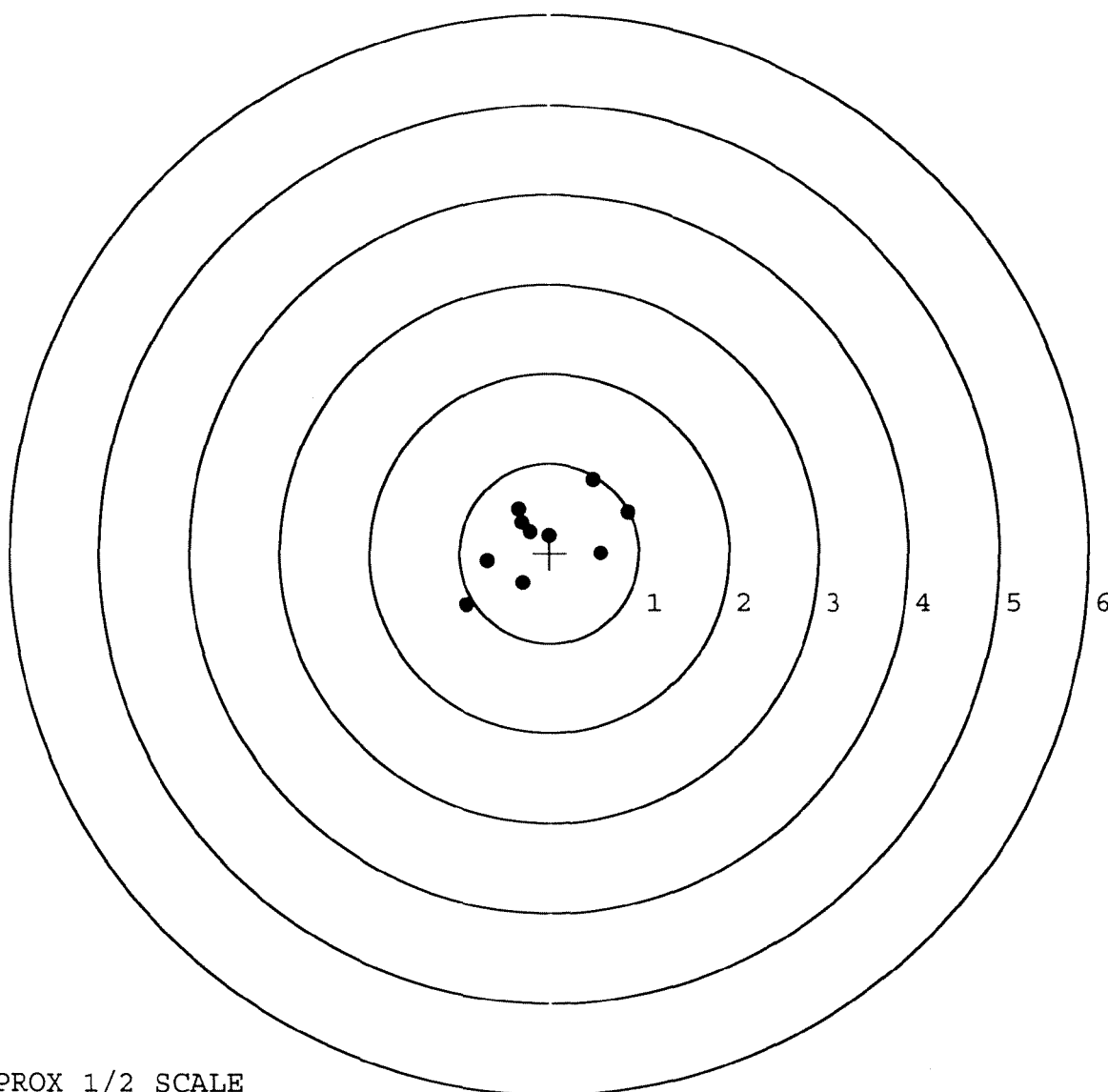


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. __0
TARGET NUMBER: 3
FILE DATE: 09/03/2008
FILE TIME: 10:38

POINT#	X	Y
1:	-0.922	-0.575
2:	-0.692	-0.089
3:	-0.296	-0.336
4:	-0.007	0.198
5:	-0.214	0.234
6:	-0.308	0.344
7:	-0.346	0.487
8:	0.578	0.001
9:	0.874	0.455
10:	0.488	0.821

X CENTROID: -0.084
Y CENTROID: 0.154
POA TO CENTROID: 0.176
HORZ SPREAD: 1.796
VERT SPREAD: 1.396
GROUP SPREAD: 2.070
MIN RADIUS: 0.089
MAX RADIUS: 1.110
MEAN RADIUS: 0.582
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



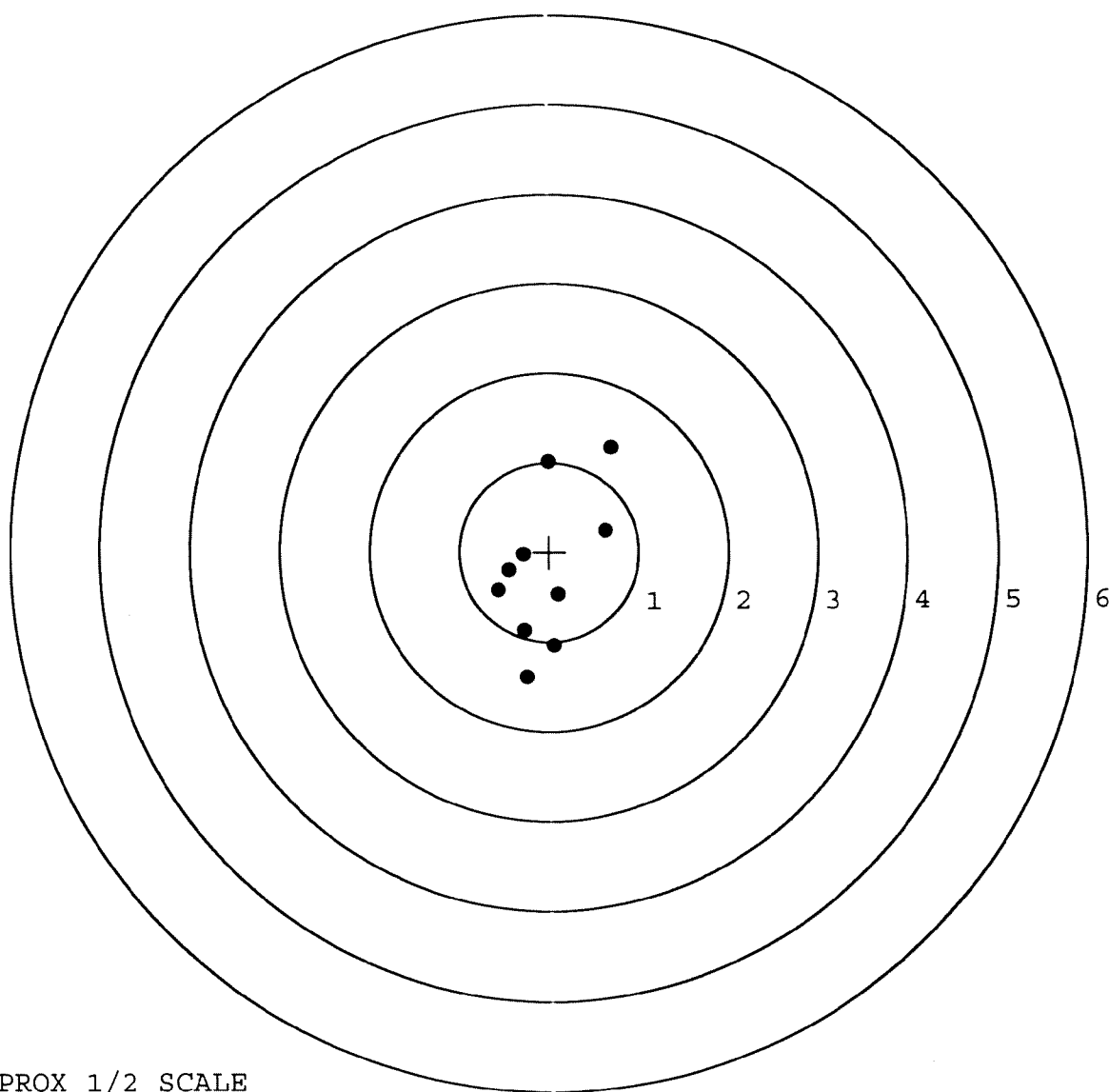
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922. __0
TARGET NUMBER: 4
FILE DATE: 09/03/2008
FILE TIME: 10:38

X CENTROID: -0.038
Y CENTROID: -0.206
POA TO CENTROID: 0.210
HORZ SPREAD: 1.265
VERT SPREAD: 2.571
GROUP SPREAD: 2.741
MIN RADIUS: 0.303
MAX RADIUS: 1.556
MEAN RADIUS: 0.795

POINT#	X	Y
1:	-0.255	-1.405
2:	0.050	-1.047
3:	-0.281	-0.883
4:	-0.570	-0.431
5:	-0.447	-0.204
6:	-0.292	-0.032
7:	0.630	0.237
8:	0.695	1.166
9:	-0.013	1.011
10:	0.099	-0.476

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

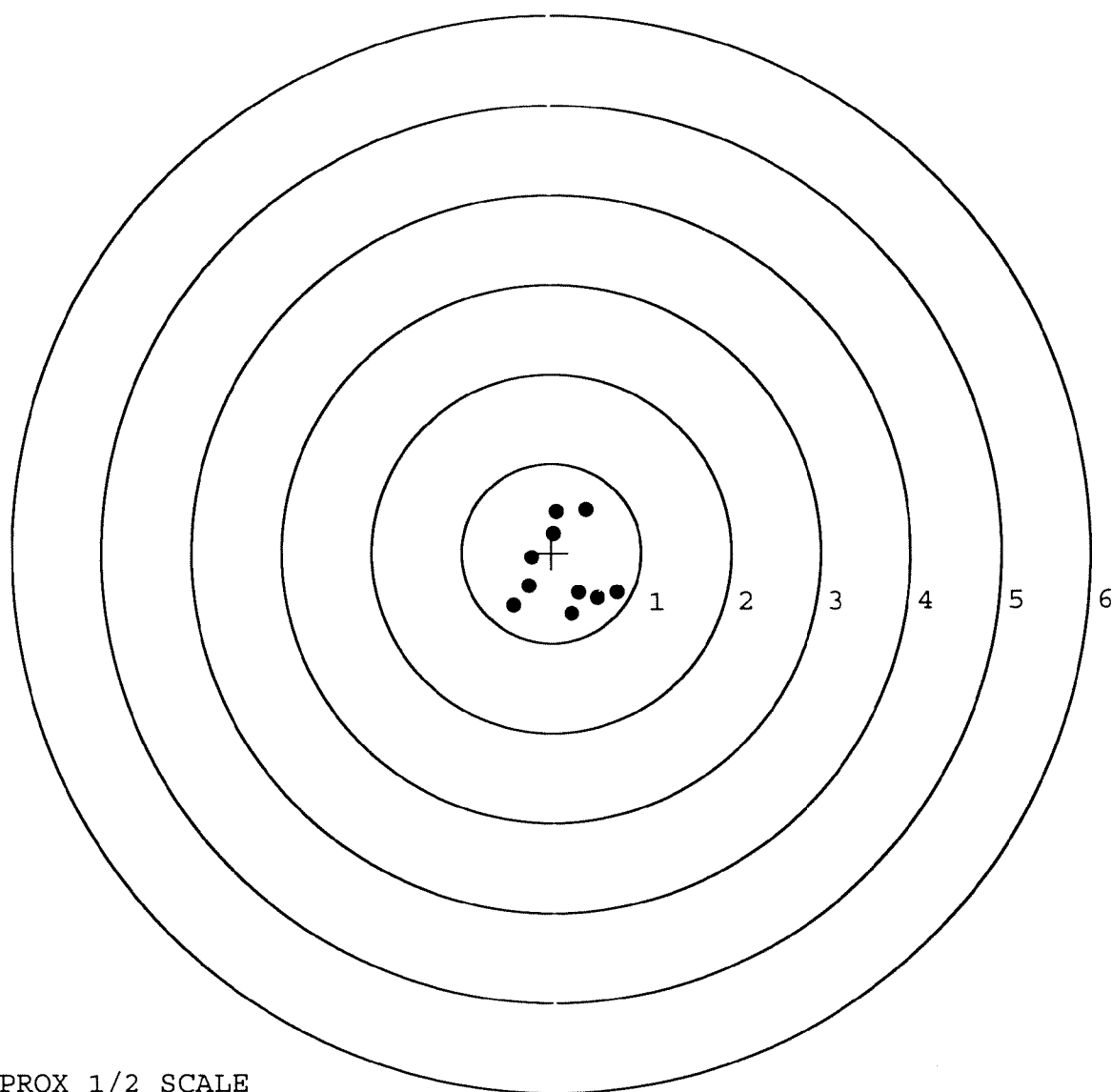


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764922.___0
TARGET NUMBER: 5
FILE DATE: 09/03/2008
FILE TIME: 10:38

X CENTROID: 0.134
Y CENTROID: -0.195
POA TO CENTROID: 0.236
HORZ SPREAD: 1.154
VERT SPREAD: 1.162
GROUP SPREAD: 1.343
MIN RADIUS: 0.305
MAX RADIUS: 0.723
MEAN RADIUS: 0.524
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.223	-0.681
2:	0.305	-0.447
3:	0.511	-0.513
4:	0.730	-0.449
5:	-0.424	-0.588
6:	-0.256	-0.376
7:	-0.222	-0.056
8:	0.022	0.219
9:	0.389	0.481
10:	0.059	0.460

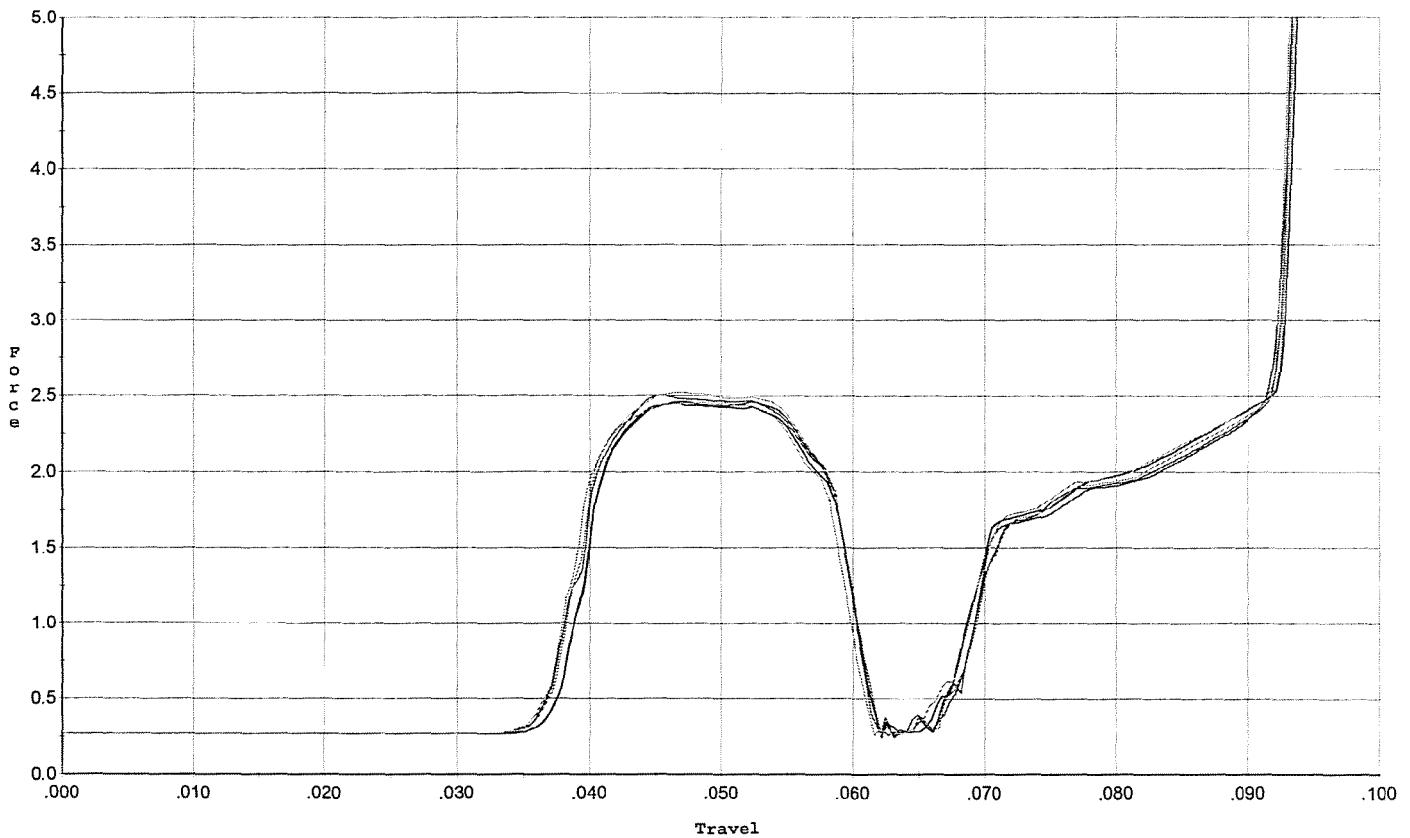


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



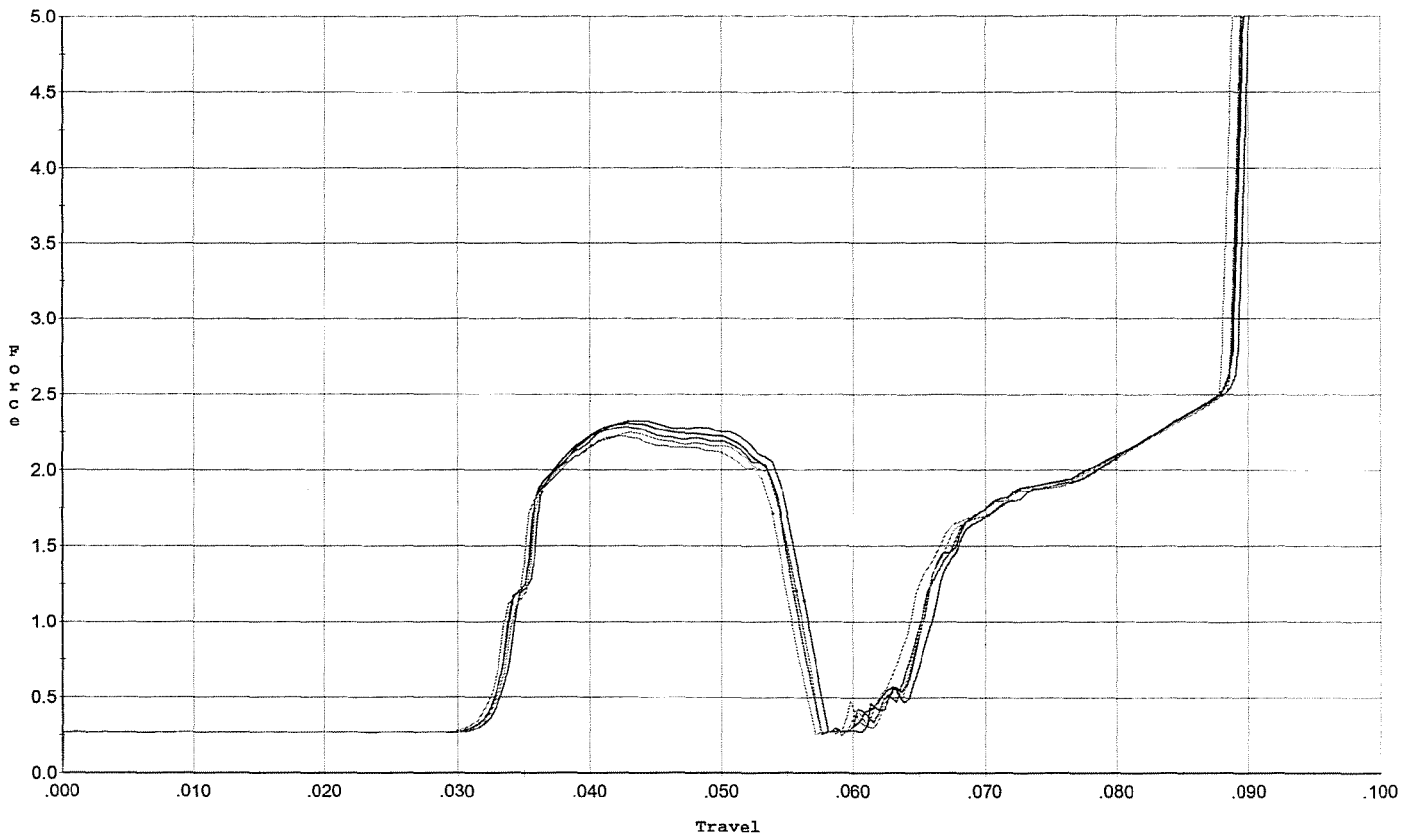
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.059	0.037	0.040	0.056		Set Trigger
2	2.460	0.059	0.037	0.040	0.056		Set Trigger
3	2.501	0.059	0.036	0.039	0.058		Set Trigger
4	2.526	0.059	0.036	0.040	0.058		Set Trigger
5	2.454	0.058	0.036	0.039	0.057		Set Trigger

Aug. 2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



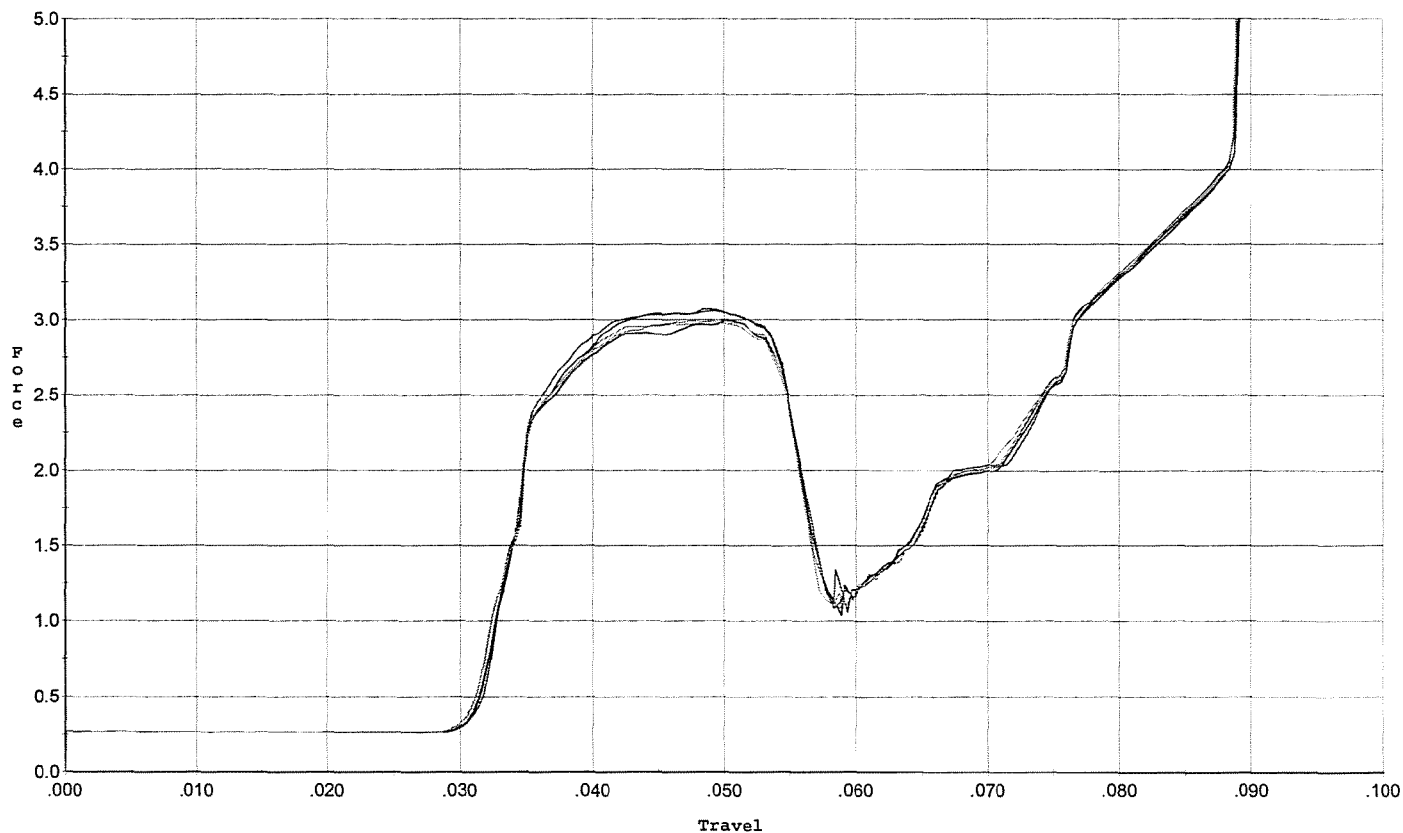
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.327	0.056	0.033	0.039	0.055		Set Trigger
2	2.312	0.056	0.032	0.039	0.054		Set Trigger
3	2.284	0.054	0.032	0.039	0.052		Set Trigger
4	2.250	0.056	0.033	0.039	0.053		Set Trigger
5	2.224	0.054	0.032	0.039	0.051		Set Trigger

Aug - 2.27

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



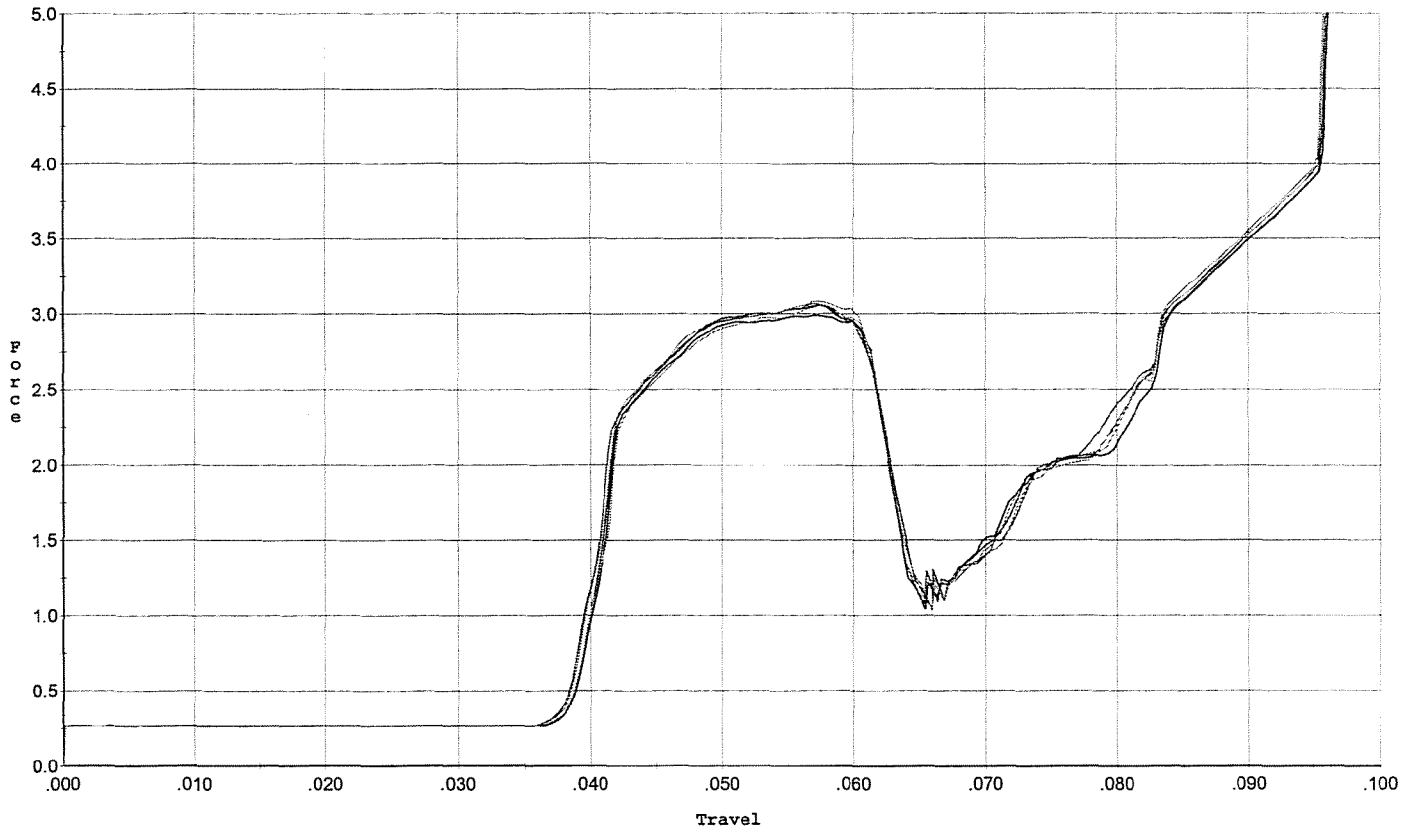
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.071	0.054	0.031	0.037	0.070		Set Trigger
2	2.997	0.055	0.031	0.037	0.069		Set Trigger
3	3.058	0.054	0.031	0.037	0.070		Set Trigger
4	2.985	0.055	0.031	0.036	0.070		Set Trigger
5	2.998	0.055	0.031	0.036	0.069		Set Trigger

Avg. 3.02

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



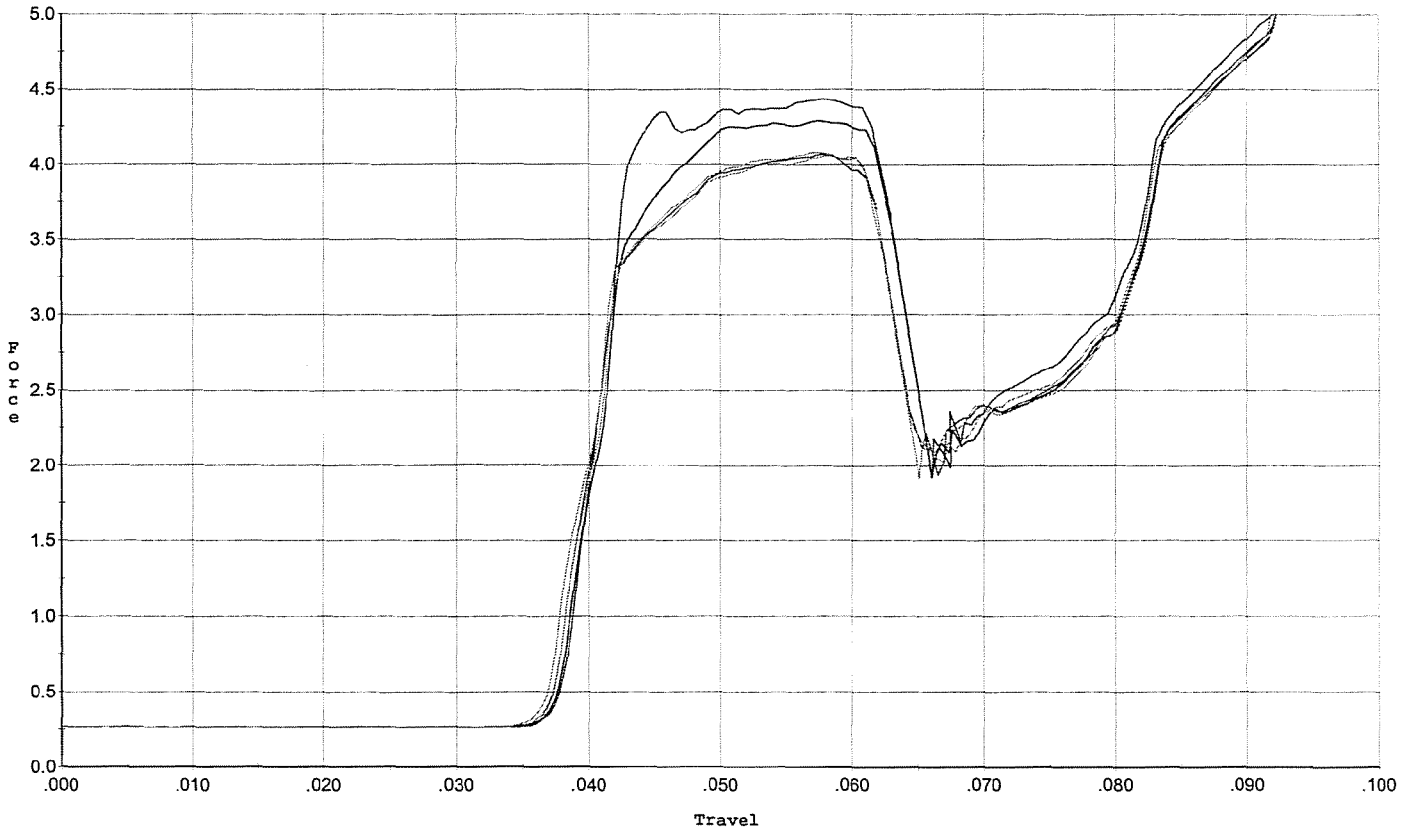
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.061	0.038	0.039	0.071		Set Trigger
2	2.990	0.062	0.038	0.039	0.071		Set Trigger
3	3.064	0.061	0.038	0.039	0.072		Set Trigger
4	3.054	0.061	0.039	0.039	0.071		Set Trigger
5	3.082	0.061	0.038	0.039	0.072		Set Trigger

Aug. 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



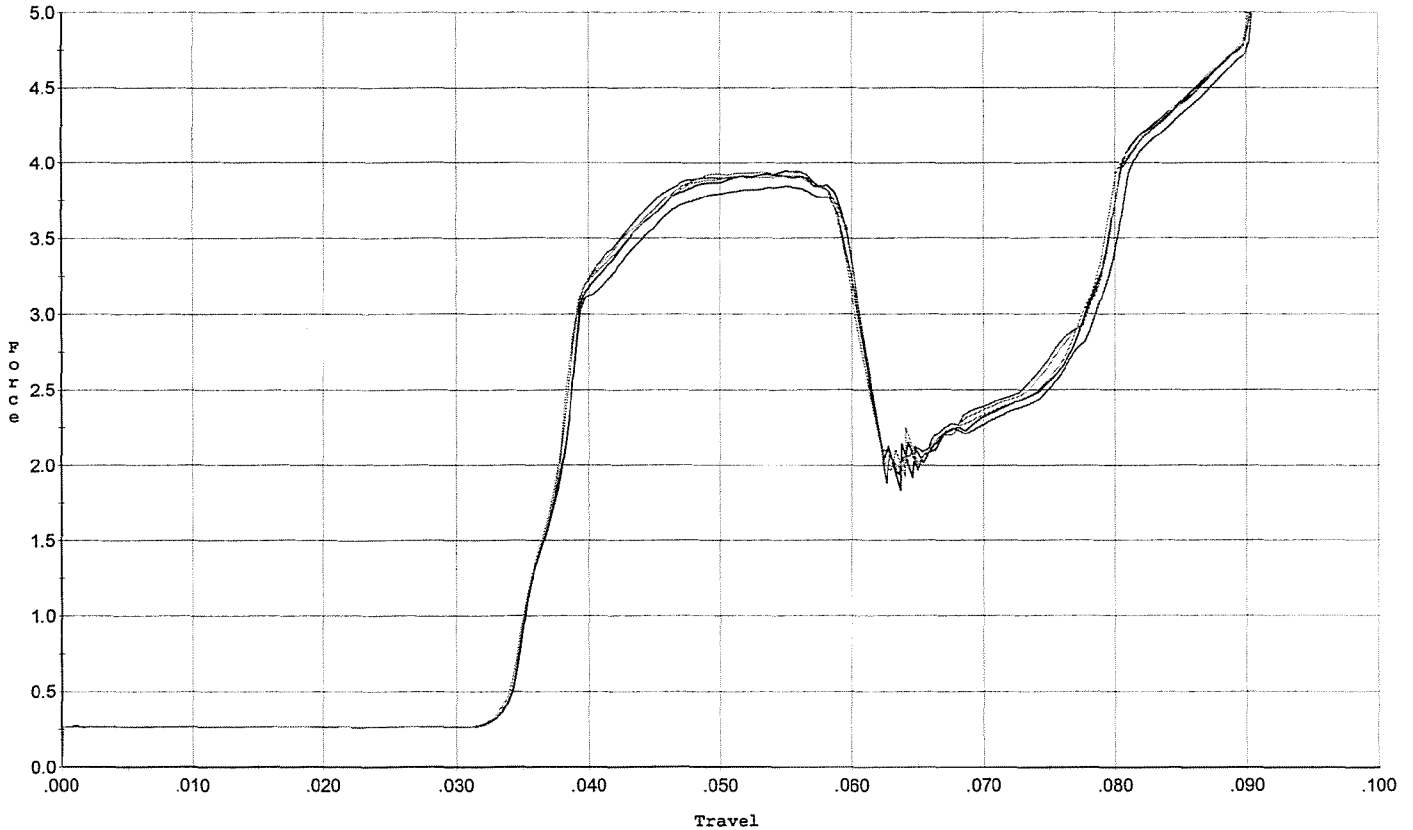
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.438	0.063	0.037	0.034	0.109		Set Trigger
2	4.291	0.063	0.037	0.034	0.105		Set Trigger
3	4.066	0.062	0.037	0.035	0.098		Set Trigger
4	4.056	0.062	0.037	0.035	0.097		Set Trigger
5	4.077	0.062	0.036	0.035	0.099		Set Trigger

Aug - 4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



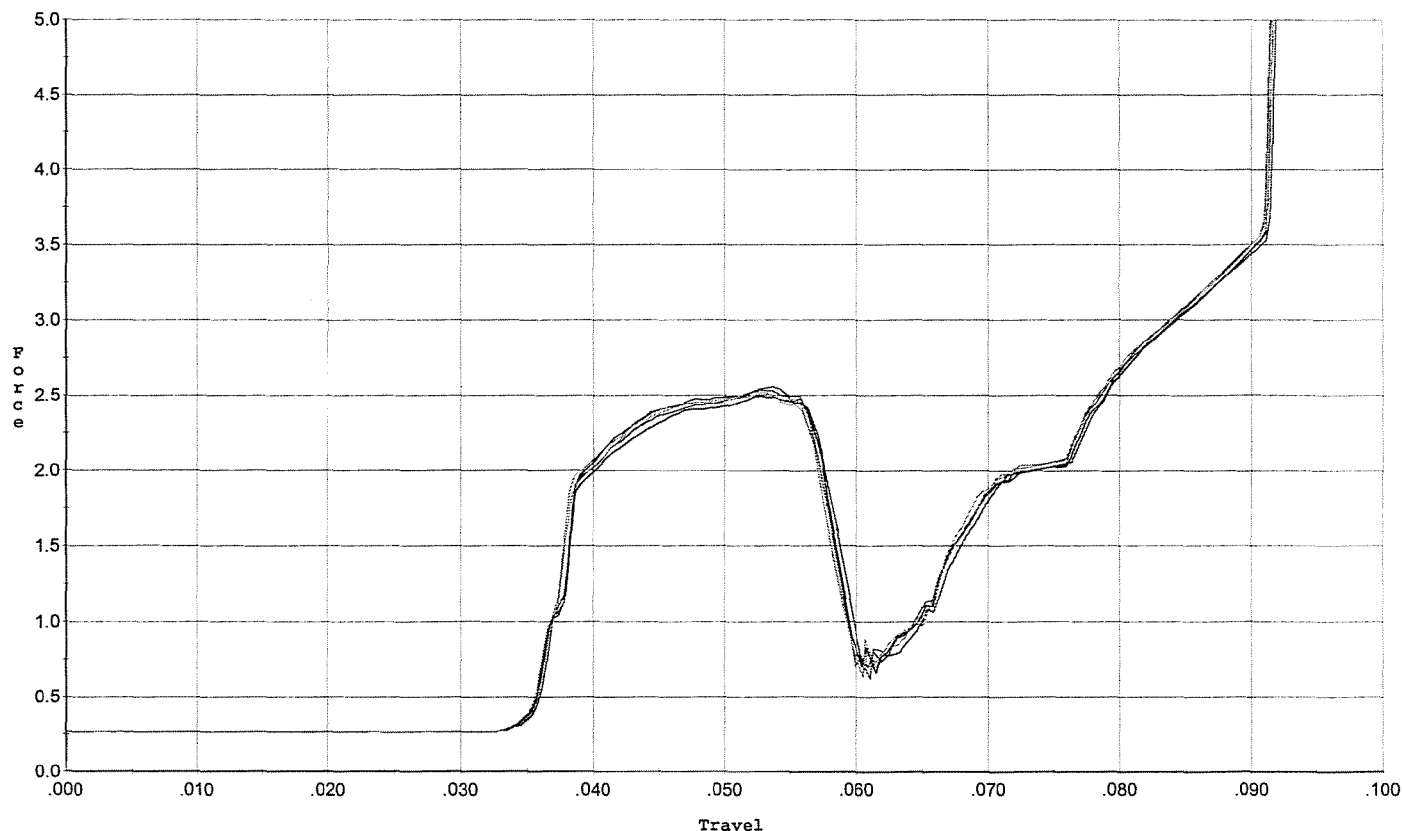
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.845	0.060	0.034	0.035	0.094		Set Trigger
2	3.920	0.060	0.034	0.035	0.095		Set Trigger
3	3.942	0.060	0.034	0.035	0.096		Set Trigger
4	3.912	0.059	0.034	0.035	0.094		Set Trigger
5	3.949	0.059	0.034	0.035	0.094		Set Trigger

Aug - 3.91

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



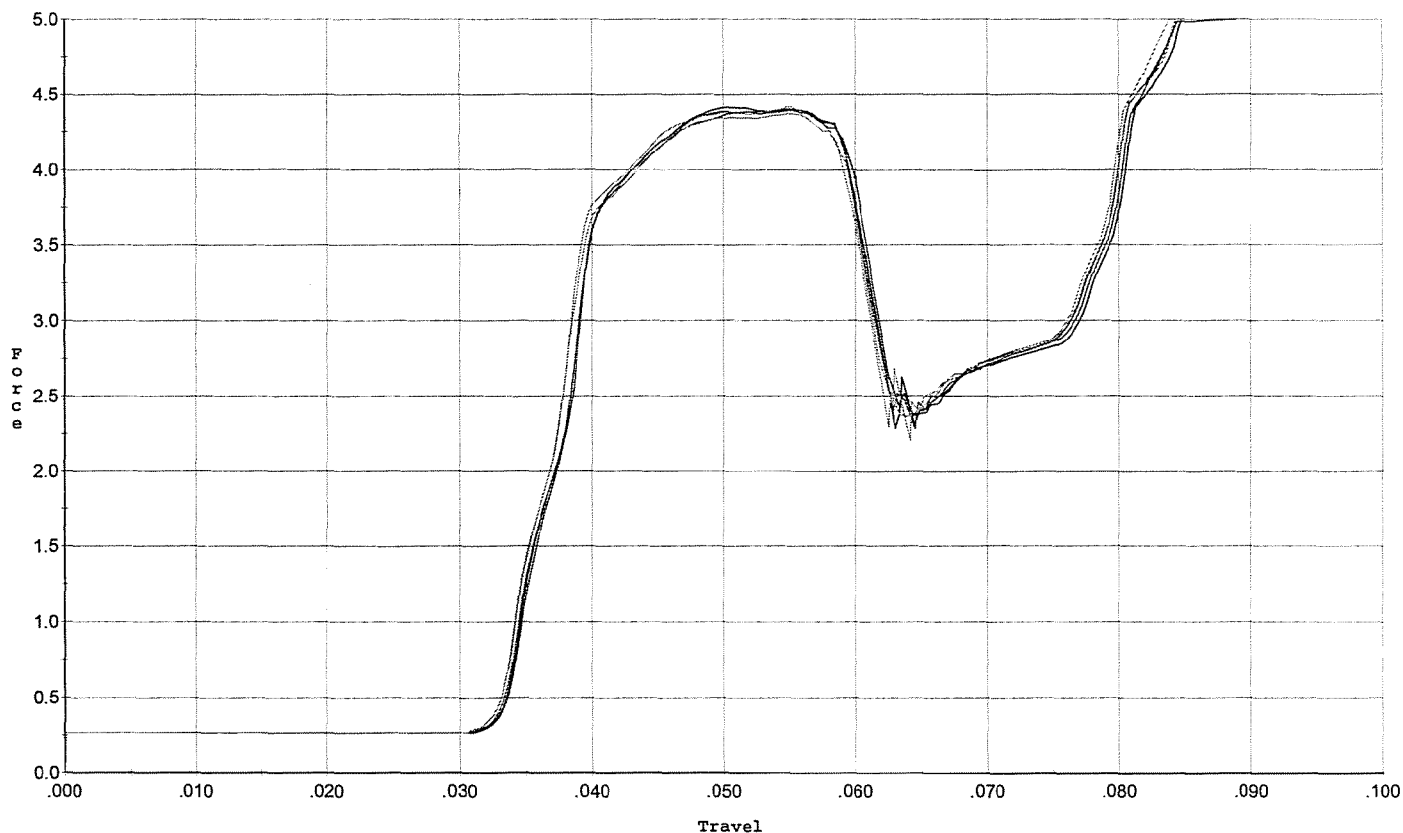
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.059	0.036	0.038	0.059		Set Trigger
2	2.496	0.057	0.036	0.038	0.057		Set Trigger
3	2.535	0.058	0.036	0.038	0.058		Set Trigger
4	2.512	0.057	0.036	0.039	0.056		Set Trigger
5	2.521	0.057	0.035	0.039	0.057		Set Trigger

Aug. 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. ini. +/- 1.0 lbs. for target&accur



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.394	0.060	0.033	0.031	0.108		Set Trigger
2	4.413	0.061	0.033	0.031	0.109		Set Trigger
3	4.393	0.059	0.033	0.031	0.106		Set Trigger
4	4.369	0.060	0.033	0.031	0.108		Set Trigger
5	4.413	0.059	0.033	0.031	0.108		Set Trigger

Avg. 4.39