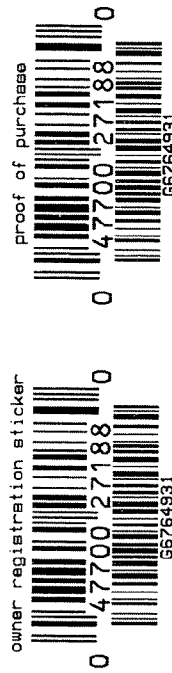


96764931

M24A2 SWS – RIFLE ONLY
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTRUCTION BOOK 3518

BM FORM

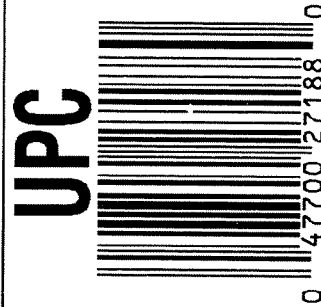


ORDER NO. **27188**

BARREL LENGTH **24"**

CAPACITY **6**

G6764931



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6764931

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-15-08	RTZ
430	ASSEMBLE TO STOCK		9-15-08	RTZ
440	PROOF		9-16-08	TRW
460	CHECK HEADSPACE		9-16-08	TRW
470	DIS-ASSEMBLE ACTION		9-16-08	RTZ
472	SERIALIZE BOLT HANDLE		9-16-08	RTZ
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX SEP 17 2008 OPERATOR BSA	N/A	
480	MAGNAFLUX BBL ACTION		9-17-08	BSA
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/18/08	RT
520	GOFF BLAST BBL / REC		9/19/08	DB
542	APPLY COATINGS (BARREL ACTION)		9-24	a
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-27-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

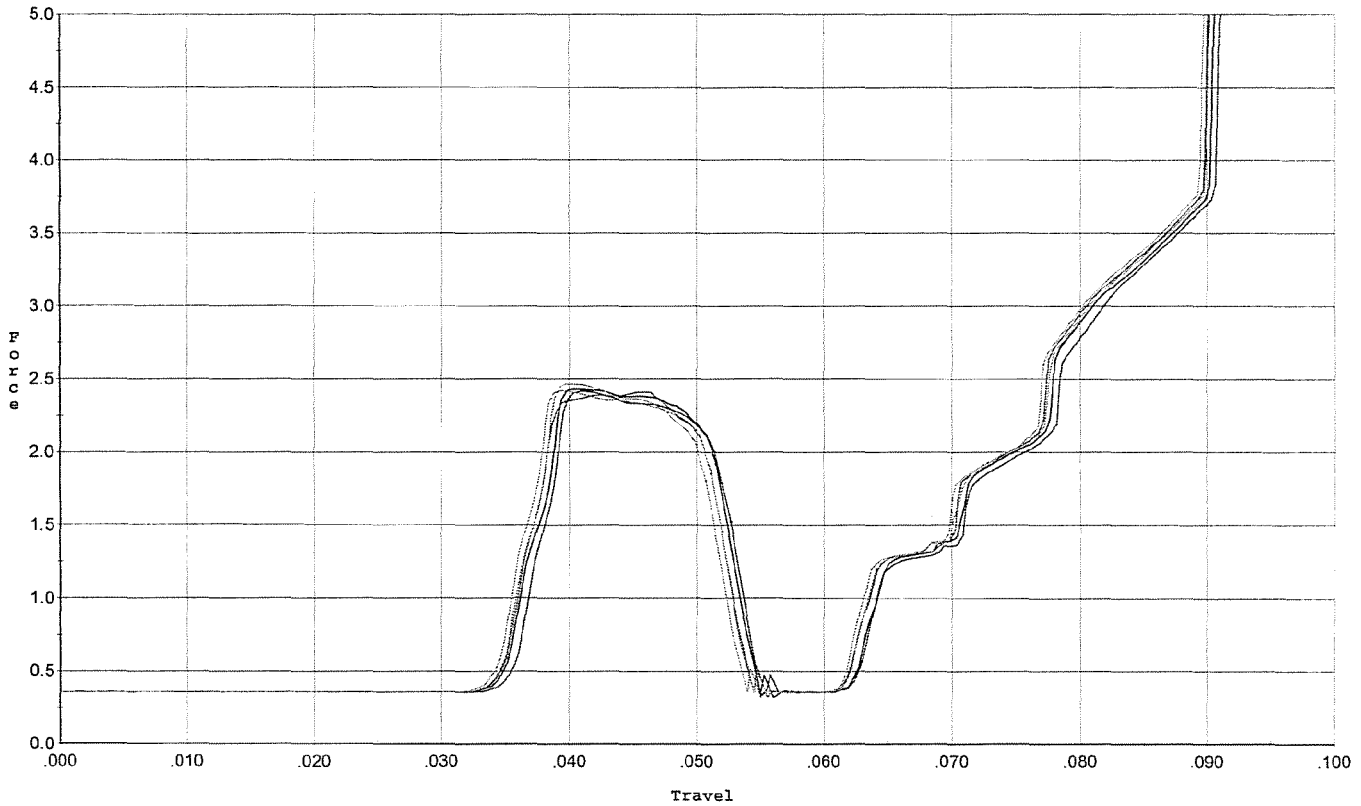
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>2.5</u>	10-2-08	L. N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	10-2-08	L. N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	10-2-08	L. N.
	J) ASSEMBLE STOCK		9-27-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-2-08	L. N.
	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	9-27-08	L. N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-27-08	TRU
670	FINAL INSPECTION A) HEADSPACE		10-2-08	L. N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.26</u> <u>2.20</u> <u>2.24</u> <u>2.25</u>	9-29-08	TL
	C) FUNCTION		10-2-08	L. N.
690	PACK		10/6/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/22/08

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



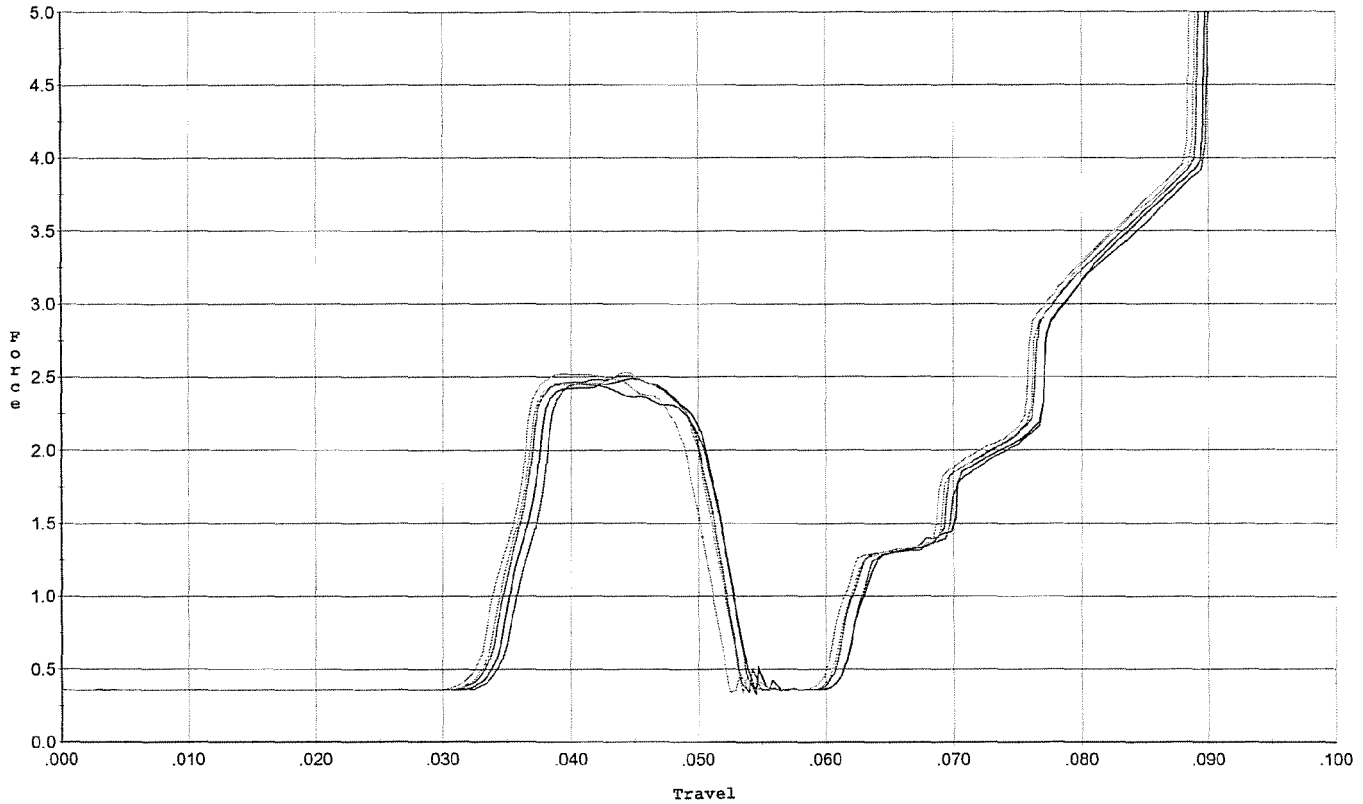
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.053	0.036	0.042	0.048		Set Trigger
2	2.431	0.052	0.035	0.042	0.048		Set Trigger
3	2.412	0.051	0.035	0.042	0.047		Set Trigger
4	2.469	0.051	0.035	0.042	0.047		Set Trigger
5	2.422	0.051	0.035	0.042	0.047		Set Trigger

Avg 2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



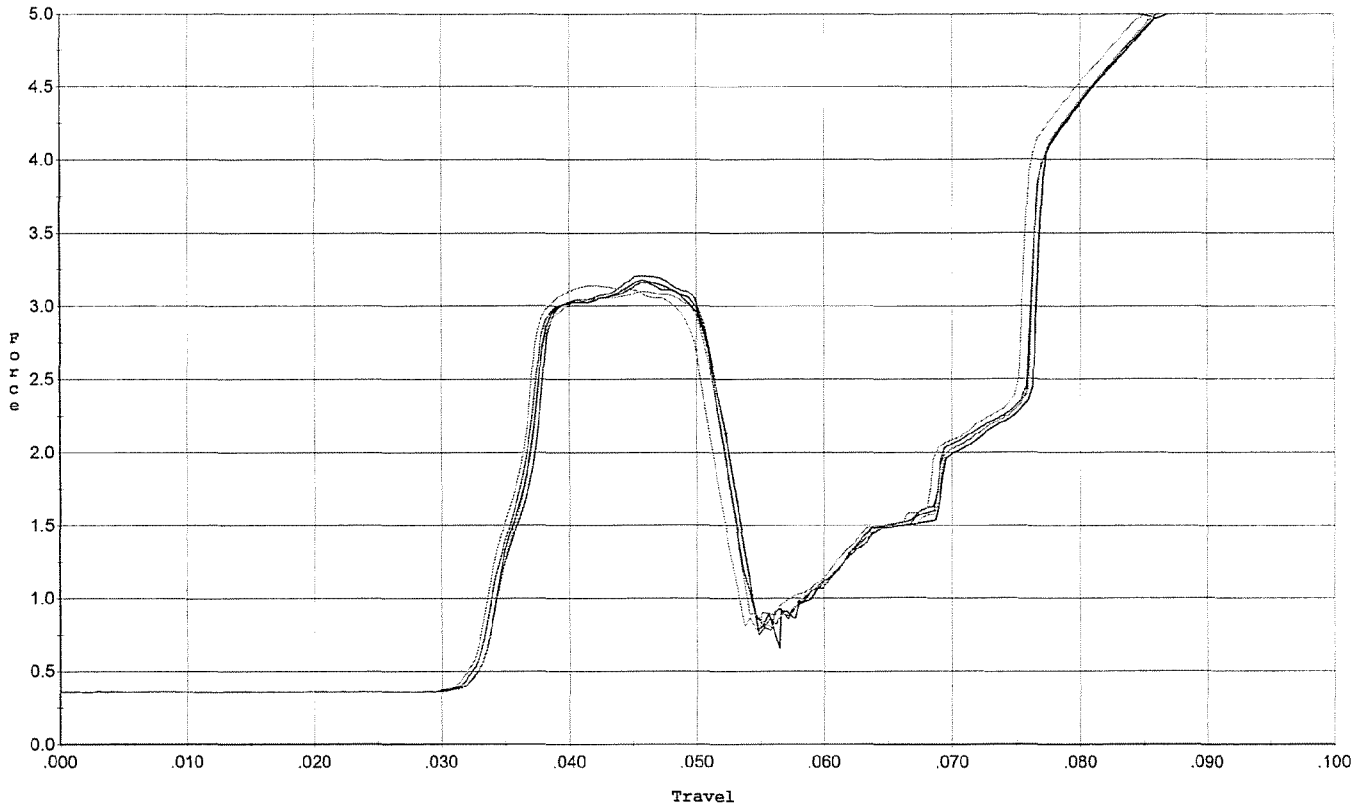
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.450	0.052	0.035	0.042	0.048		Set Trigger
2	2.488	0.051	0.034	0.042	0.049		Set Trigger
3	2.505	0.051	0.033	0.042	0.050		Set Trigger
4	2.531	0.052	0.033	0.042	0.050		Set Trigger
5	2.519	0.050	0.033	0.042	0.049		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



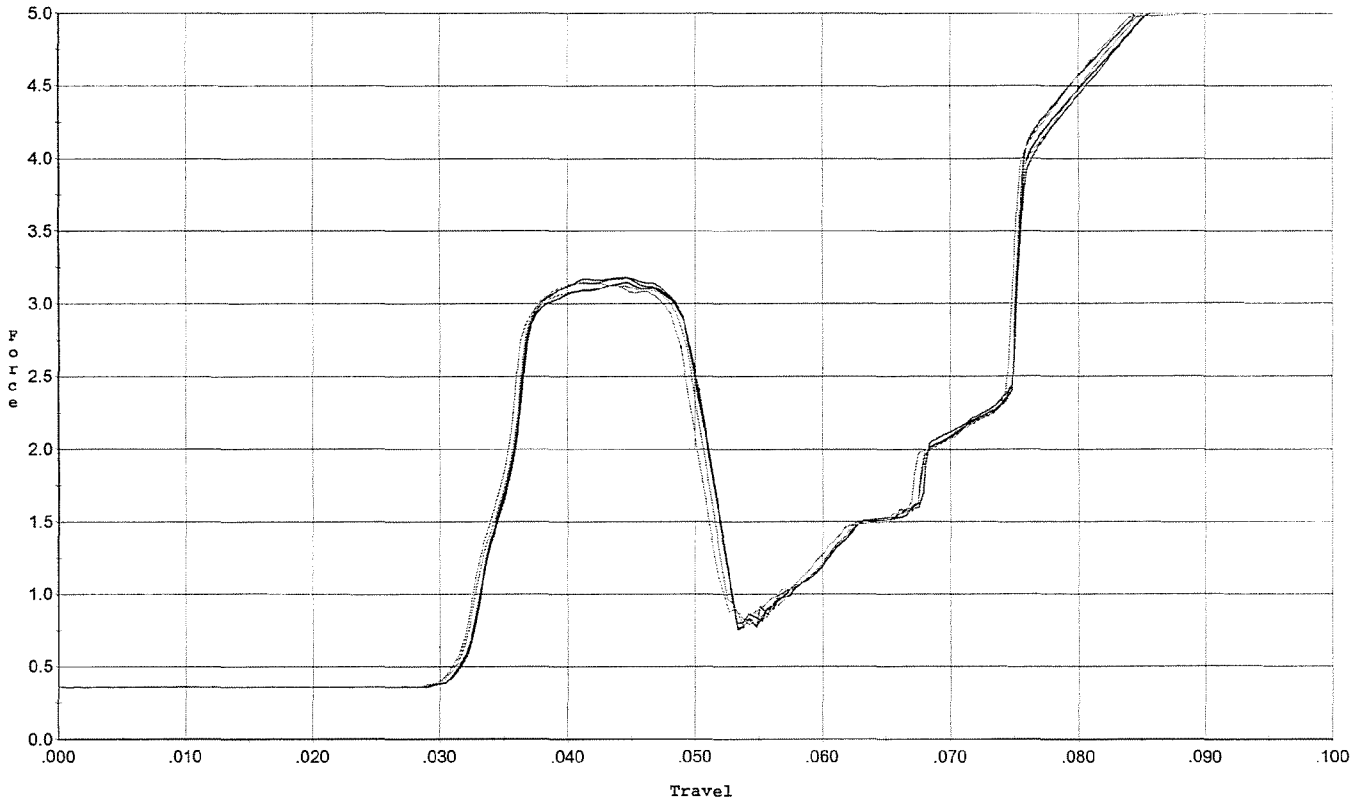
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.051	0.033	0.039	0.060		Set Trigger
2	3.176	0.052	0.033	0.039	0.062		Set Trigger
3	3.206	0.052	0.033	0.039	0.063		Set Trigger
4	3.102	0.051	0.033	0.039	0.060		Set Trigger
5	3.139	0.050	0.032	0.039	0.059		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



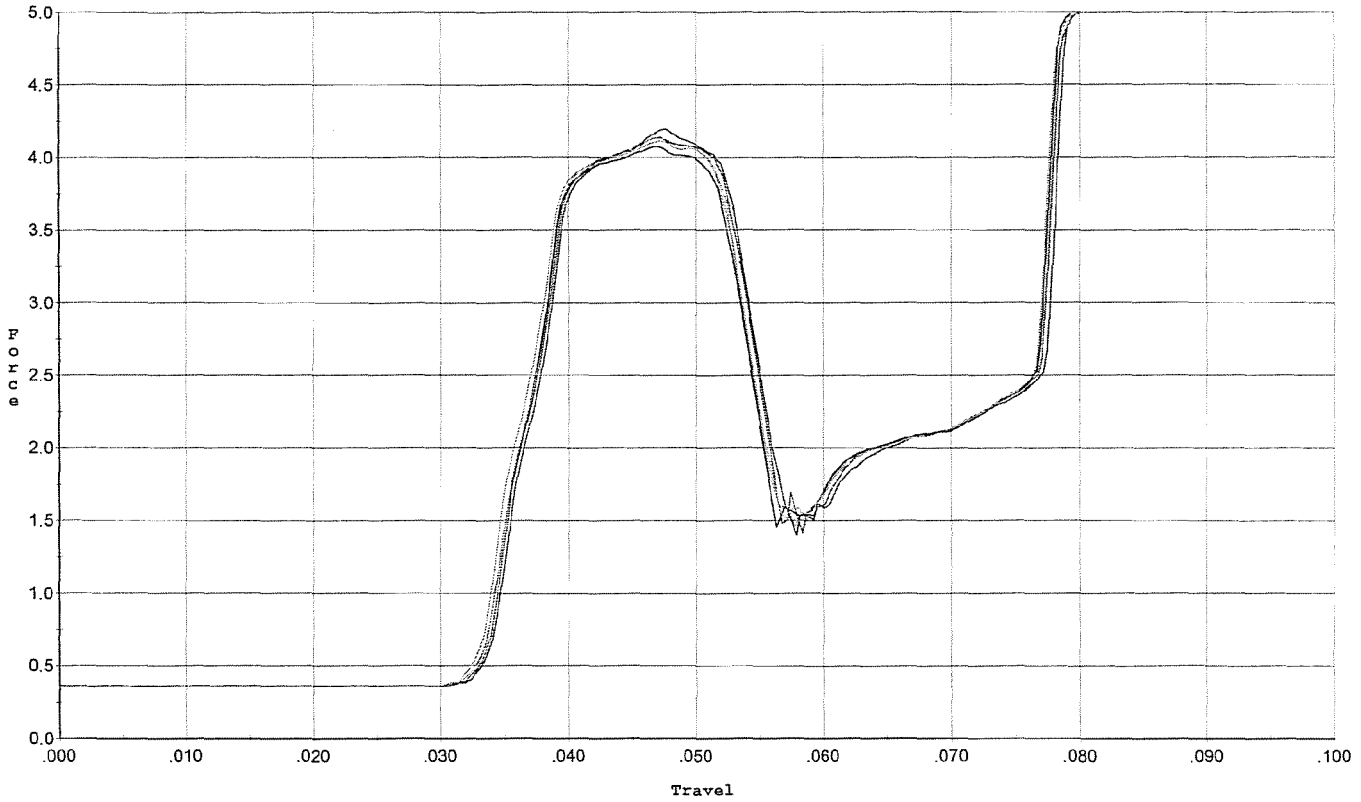
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.050	0.032	0.039	0.061		Set Trigger
2	3.145	0.051	0.032	0.039	0.061		Set Trigger
3	3.177	0.051	0.032	0.039	0.061		Set Trigger
4	3.142	0.049	0.032	0.040	0.059		Set Trigger
5	3.124	0.049	0.032	0.040	0.058		Set Trigger

AVG 3.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



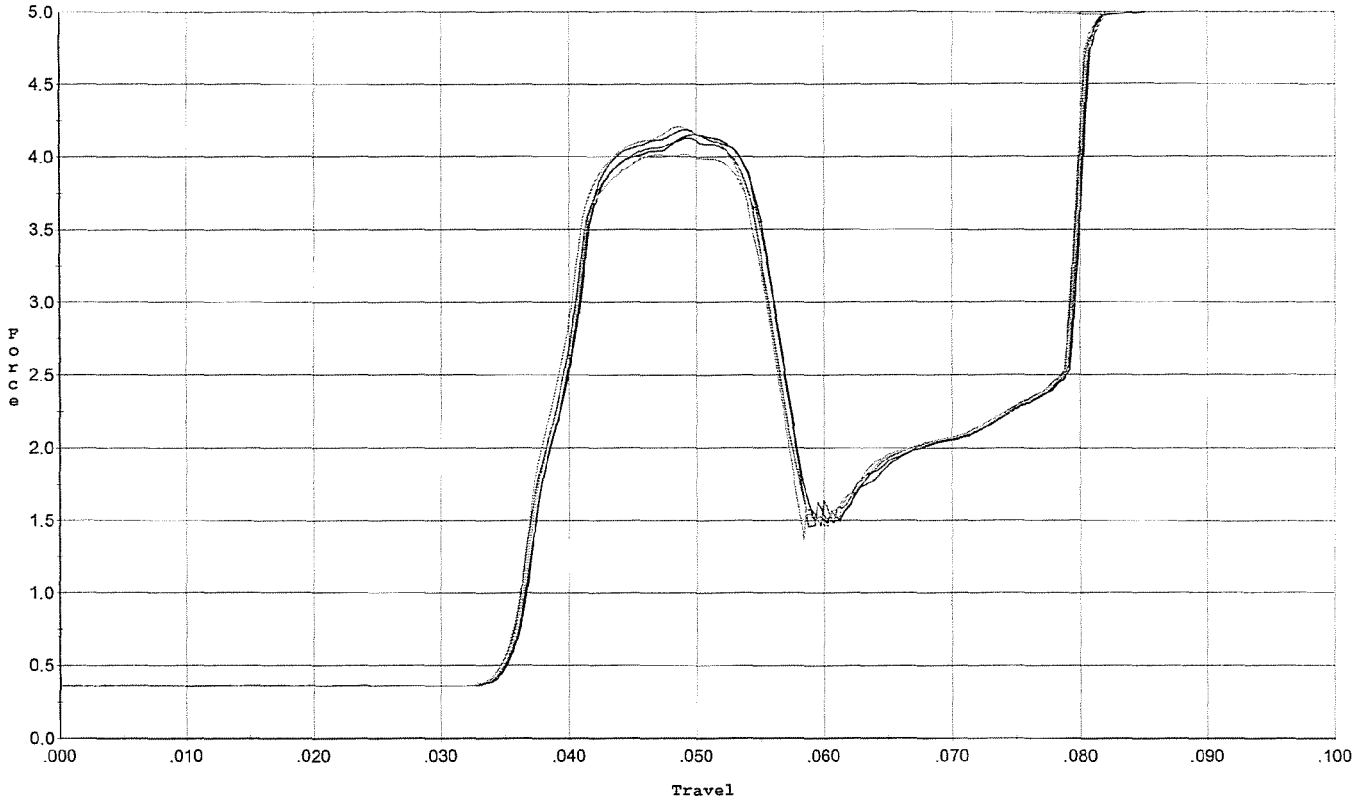
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.196	0.053	0.034	0.036	0.080		Set Trigger
2	4.078	0.053	0.033	0.036	0.080		Set Trigger
3	4.141	0.054	0.034	0.036	0.082		Set Trigger
4	4.114	0.052	0.033	0.036	0.079		Set Trigger
5	4.136	0.053	0.033	0.036	0.081		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



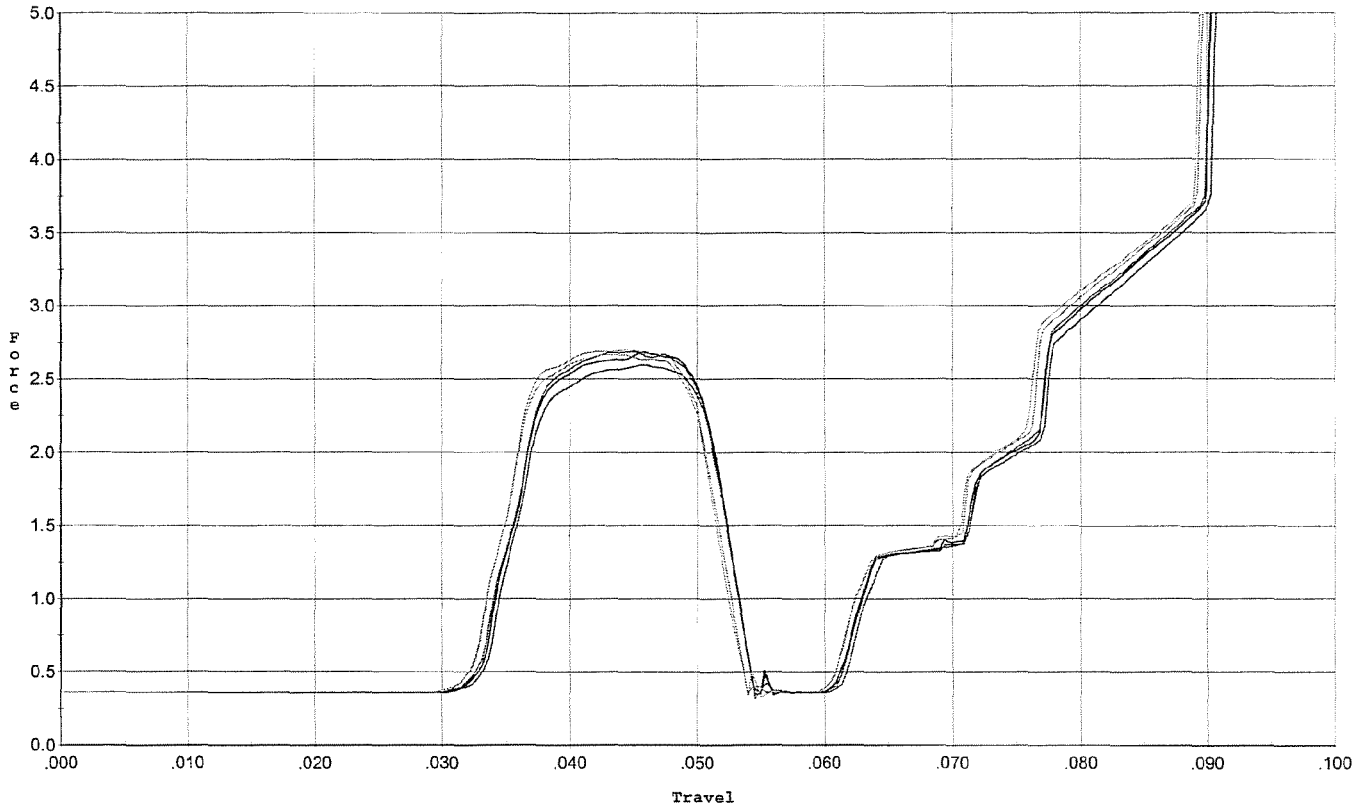
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.055	0.035	0.037	0.082		Set Trigger
2	4.152	0.055	0.035	0.038	0.081		Set Trigger
3	4.127	0.054	0.035	0.037	0.080		Set Trigger
4	4.206	0.055	0.035	0.037	0.082		Set Trigger
5	4.014	0.055	0.035	0.037	0.080		Set Trigger

Aug 4.13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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



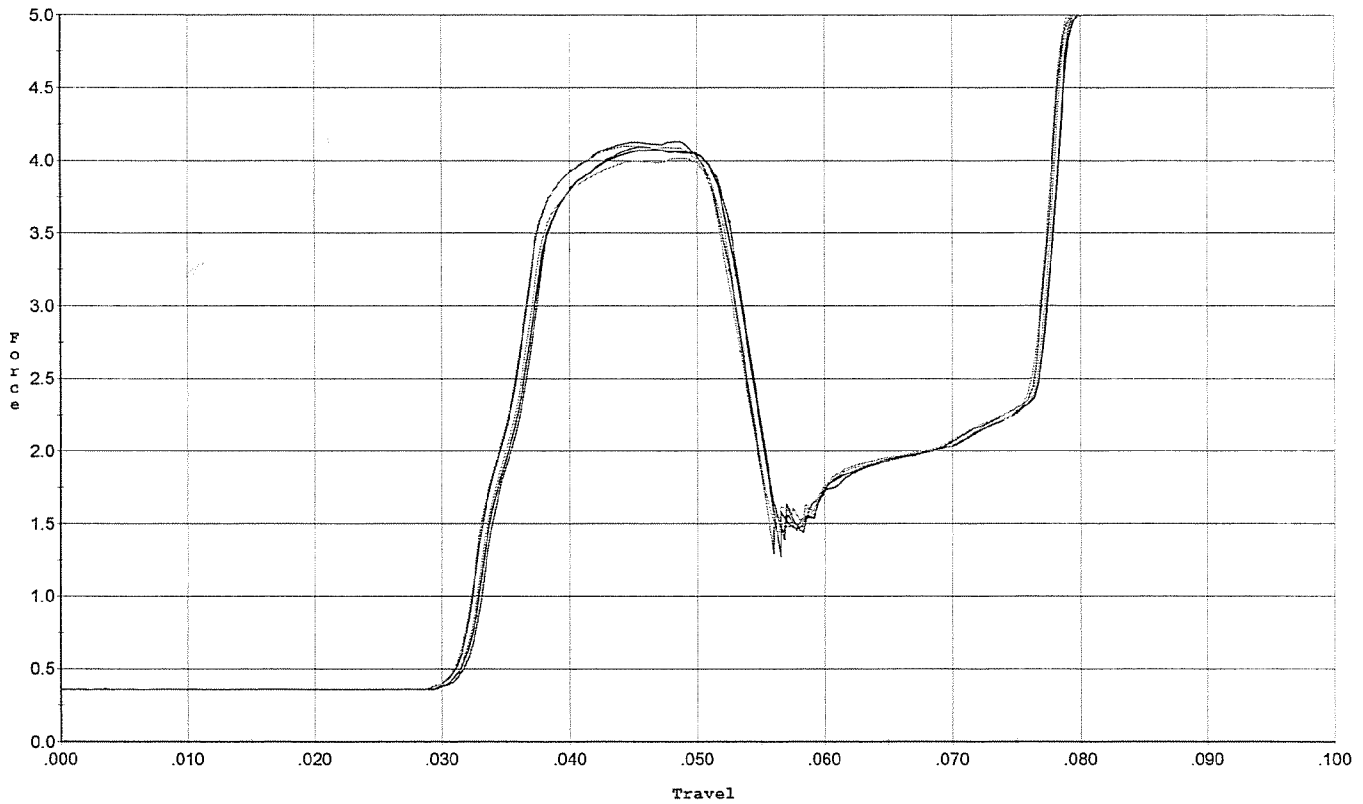
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.596	0.052	0.034	0.042	0.053		Set Trigger
2	2.683	0.052	0.033	0.042	0.054		Set Trigger
3	2.687	0.052	0.033	0.041	0.055		Set Trigger
4	2.664	0.050	0.033	0.042	0.053		Set Trigger
5	2.703	0.052	0.033	0.041	0.056		Set Trigger

Avg 2.66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/22/08

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	4.093	0.053	0.032	0.037	0.082		Set Trigger
2	4.073	0.053	0.032	0.037	0.084		Set Trigger
3	4.131	0.053	0.031	0.036	0.084		Set Trigger
4	4.019	0.052	0.032	0.036	0.081		Set Trigger
5	4.101	0.053	0.031	0.036	0.085		Set Trigger

Avg 4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

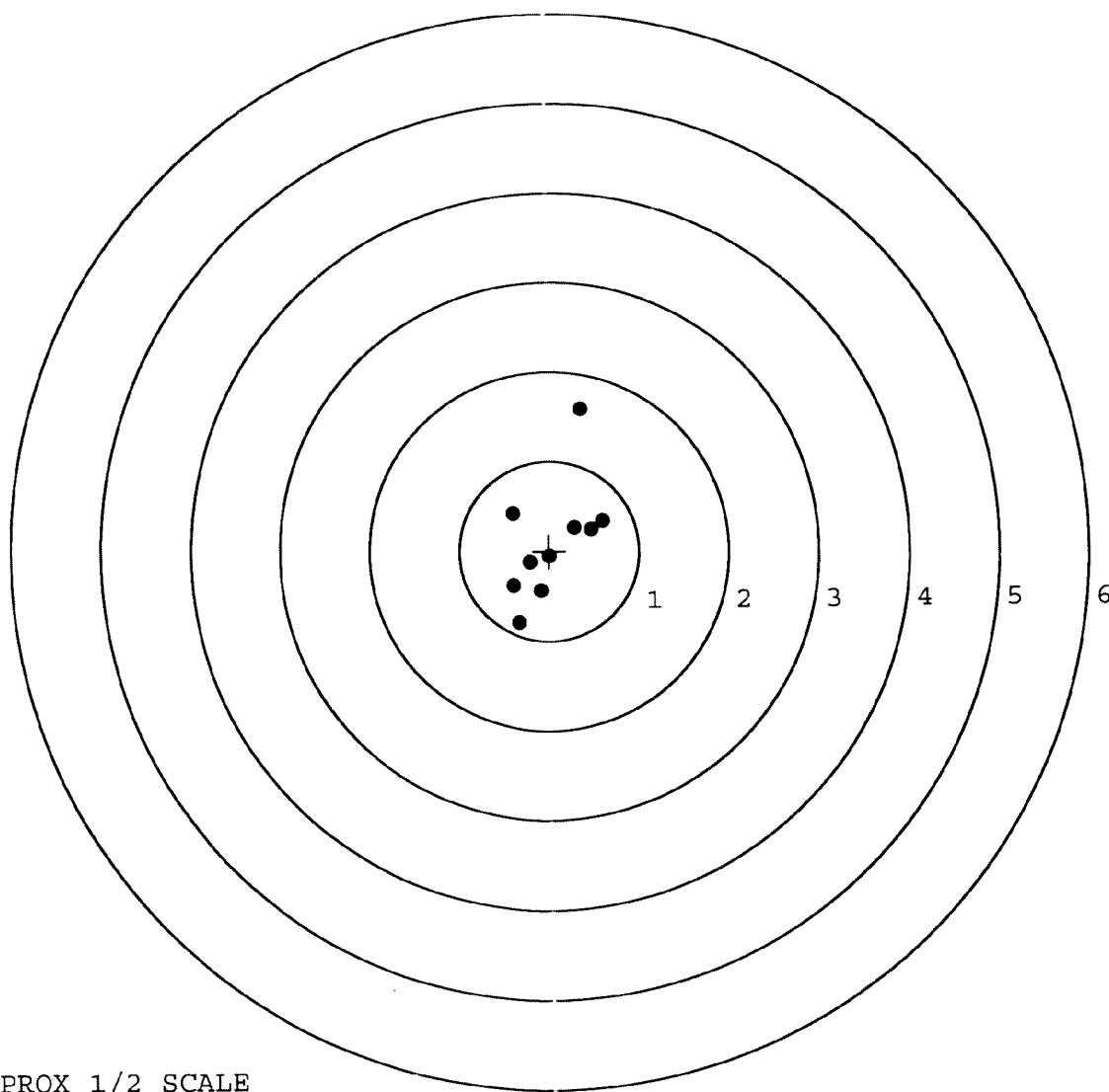
FIREARM SERIAL NUMBER / DATASET NAME: G6764931.___0
FILE DATE AND TIME: 09/27/2008 09:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.015
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.018
The Average Mean Radius of the Five Target Set:	0.775
The Distance from POA to Centroid Target #1:	0.106
The Distance from Centroid Target #2 to Centroid Target #1:	0.286
The Distance from Centroid Target #3 to Centroid Target #1:	0.210
The Distance from Centroid Target #4 to Centroid Target #1:	0.226
The Distance from Centroid Target #5 to Centroid Target #1:	0.294

SERIAL NUMBER: G6764931. __0
TARGET NUMBER: 1
FILE DATE: 09/27/2008
FILE TIME: 09:13

		POINT#	X	Y
X CENTROID:	0.025	1:	0.362	1.577
Y CENTROID:	0.103	2:	-0.402	0.417
POA TO CENTROID:	0.106	3:	0.595	0.328
HORZ SPREAD:	0.997	4:	0.280	0.258
VERT SPREAD:	2.371	5:	0.005	-0.055
GROUP SPREAD:	2.473	6:	-0.220	-0.122
MIN RADIUS:	0.159	7:	-0.096	-0.441
MAX RADIUS:	1.512	8:	-0.401	-0.382
MEAN RADIUS:	0.608	9:	-0.341	-0.794
# IN 1 IN DIAMETER:	4	10:	0.470	0.240
# IN 2 IN DIAMETER:	9			
# in 3 IN DIAMETER:	9			

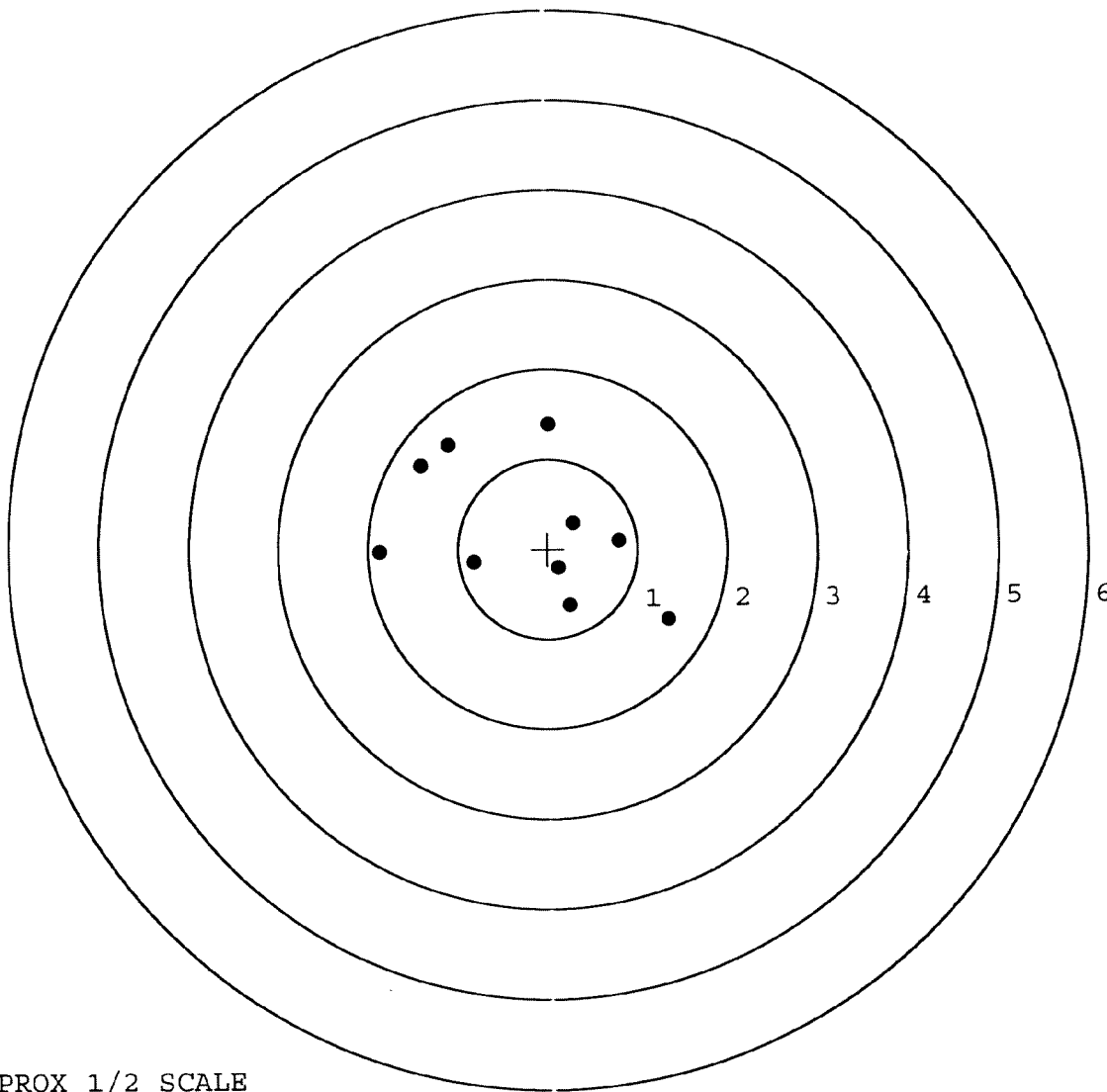


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764931. __0
 TARGET NUMBER: 2
 FILE DATE: 09/27/2008
 FILE TIME: 09:13

X CENTROID: -0.241
 Y CENTROID: 0.206
 POA TO CENTROID: 0.317
 HORZ SPREAD: 3.207
 VERT SPREAD: 2.182
 GROUP SPREAD: 3.299
 MIN RADIUS: 0.530
 MAX RADIUS: 1.870
 MEAN RADIUS: 1.114
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.338	-0.795
2:	0.790	0.087
3:	0.282	0.290
4:	0.117	-0.211
5:	0.242	-0.628
6:	-0.824	-0.140
7:	-1.869	-0.023
8:	-1.403	0.937
9:	-1.098	1.161
10:	0.016	1.387

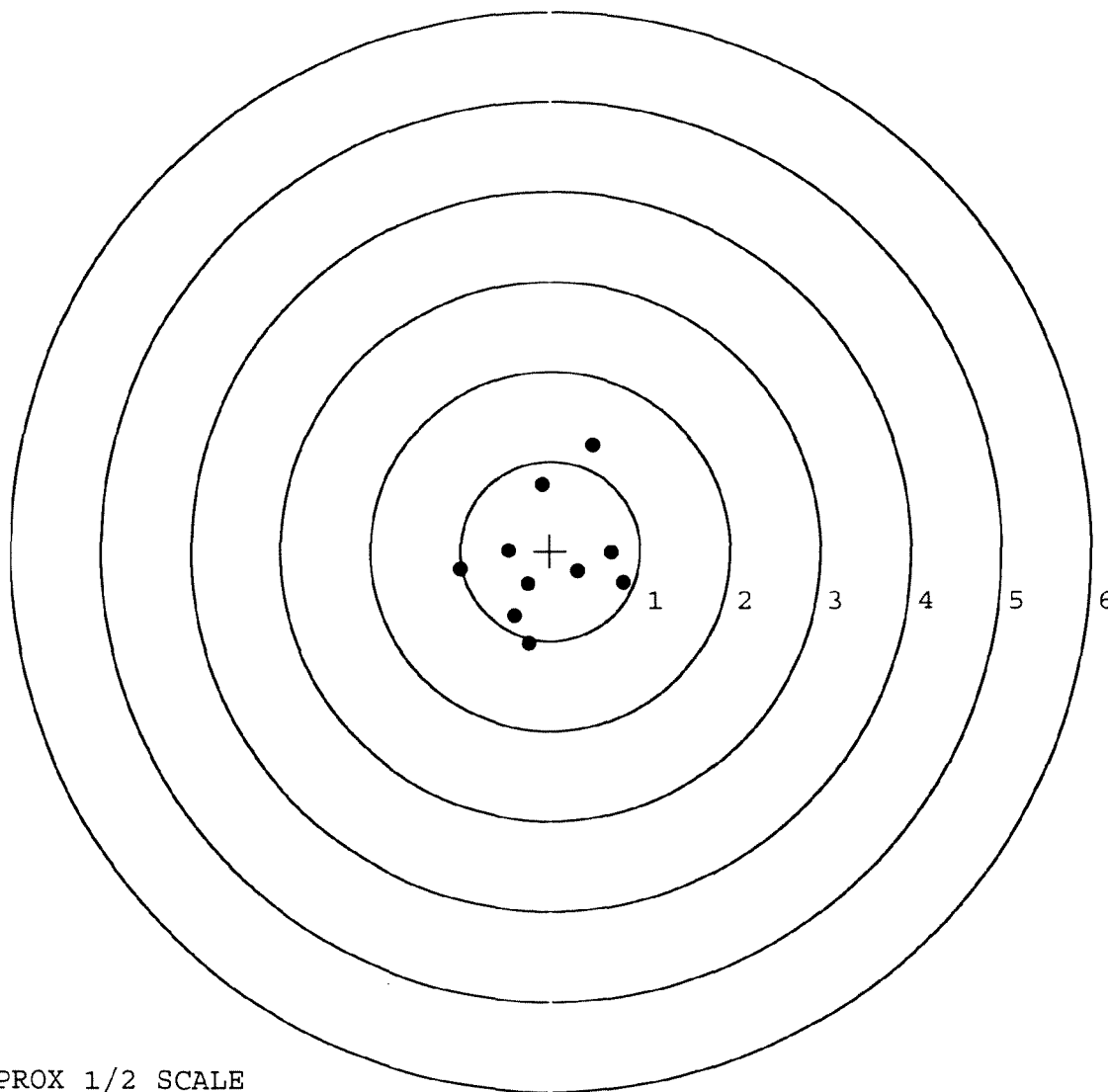


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764931. __0
TARGET NUMBER: 3
FILE DATE: 09/27/2008
FILE TIME: 09:13

X CENTROID: -0.016
Y CENTROID: -0.103
POA TO CENTROID: 0.105
HORZ SPREAD: 1.818
VERT SPREAD: 2.214
GROUP SPREAD: 2.328
MIN RADIUS: 0.350
MAX RADIUS: 1.371
MEAN RADIUS: 0.764
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.478	1.176
2:	-0.087	0.738
3:	-0.463	0.006
4:	-0.999	-0.207
5:	0.819	-0.358
6:	0.681	-0.024
7:	0.310	-0.232
8:	-0.241	-1.038
9:	-0.402	-0.723
10:	-0.251	-0.373

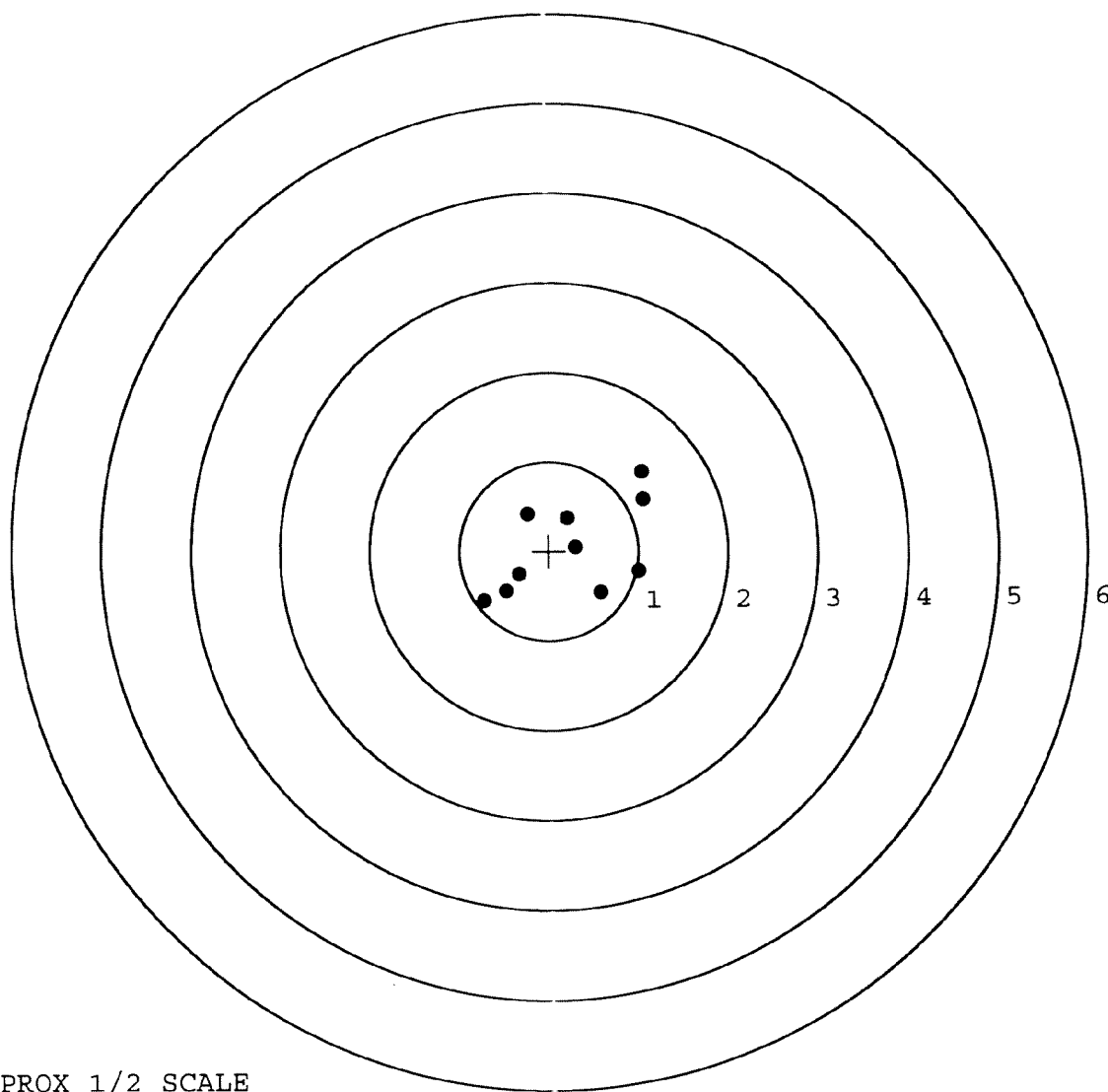


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764931. __0
TARGET NUMBER: 4
FILE DATE: 09/27/2008
FILE TIME: 09:13

X CENTROID: 0.240
Y CENTROID: 0.031
POA TO CENTROID: 0.242
HORZ SPREAD: 1.784
VERT SPREAD: 1.438
GROUP SPREAD: 2.283
MIN RADIUS: 0.060
MAX RADIUS: 1.169
MEAN RADIUS: 0.722
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.043	0.880
2:	1.054	0.573
3:	1.004	-0.237
4:	0.574	-0.468
5:	0.299	0.043
6:	0.208	0.373
7:	-0.234	0.414
8:	-0.334	-0.261
9:	-0.486	-0.448
10:	-0.730	-0.558

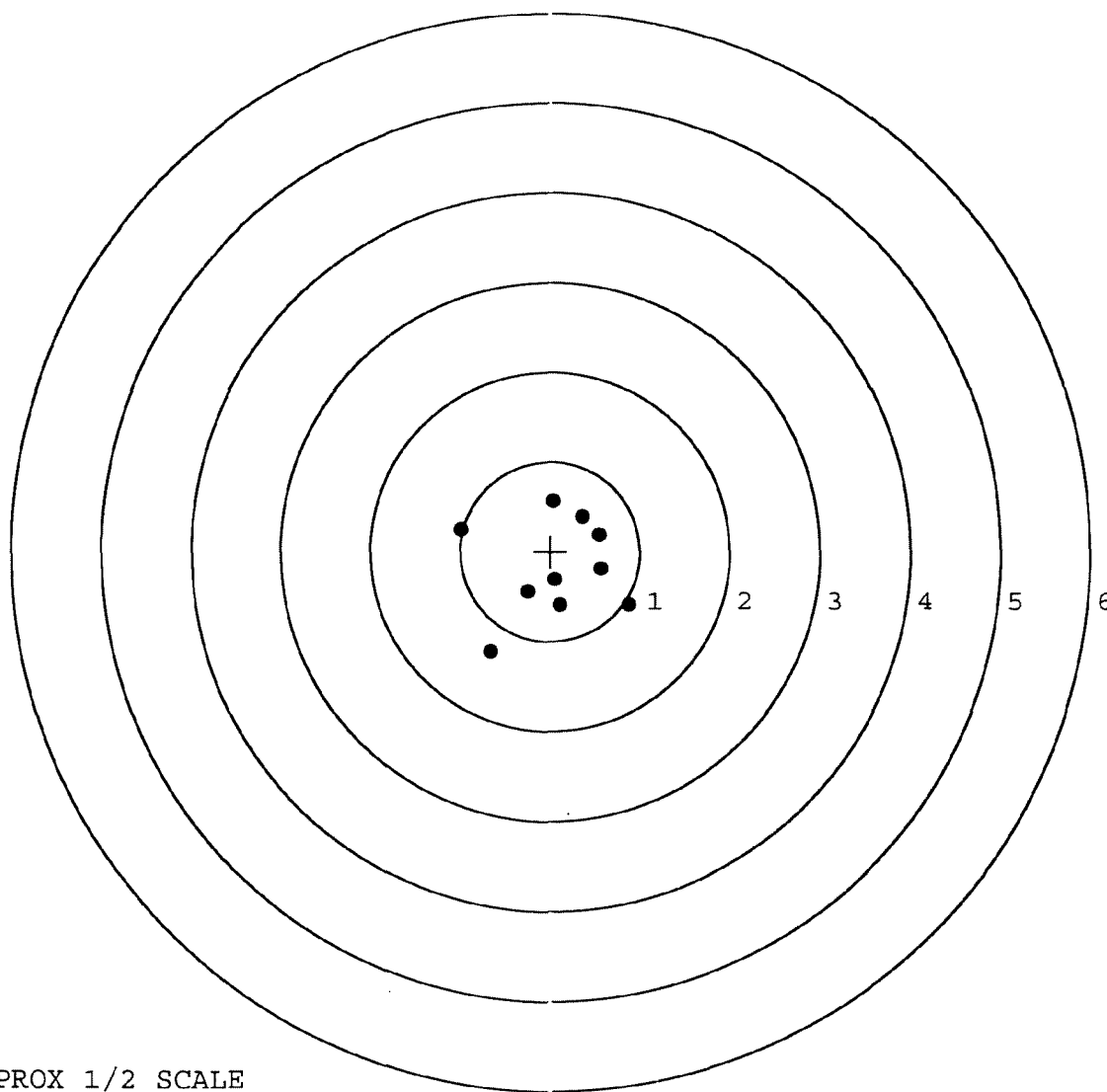


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764931.____0
TARGET NUMBER: 5
FILE DATE: 09/27/2008
FILE TIME: 09:13

POINT#	X	Y
1:	-0.664	-1.120
2:	-0.990	0.251
3:	0.880	-0.597
4:	0.113	-0.602
5:	0.051	-0.314
6:	-0.249	-0.449
7:	0.563	-0.197
8:	0.547	0.188
9:	0.361	0.387
10:	0.037	0.564

X CENTROID: 0.065
Y CENTROID: -0.189
POA TO CENTROID: 0.200
HORZ SPREAD: 1.870
VERT SPREAD: 1.684
GROUP SPREAD: 1.824
MIN RADIUS: 0.126
MAX RADIUS: 1.182
MEAN RADIUS: 0.670
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE