

6676 4936

M-24
INSPECTION CHECKLIST-NEW GUNS

A-2

GUN SERIAL # G-6764936

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		6-17-08	RTZ
600	PROOF		6-17-08	TRW
607	CHECK HEADSPACE		6-17-08	TRW
610	DIS-ASSEMBLE GUN		6-17-08	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	MAGNA-FLUX JUN 17 2008 OPERATOR <i>unus</i>	6/17/08	<i>unus</i>
615	ROLLMARK CALIBER		6/17/08	RT
617	DRILL AND TAP SIGHT HOLES	N/A	6-17-08	TRW
620	APPLY COATINGS (BARREL ACTION)		6/19/08	<i>unus</i>
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-19-08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-19-08	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-19-08	RTZ
	D) OIL FIRING PIN ASSEMBLY		6-19-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>675</u> <u>615</u> <u>72</u>	<u>6-20-08</u>	<u>RTZ</u>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	<u>6-20-08</u>	<u>RTZ</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>021</u> <u>022</u> <u>022</u>	<u>6-20-08</u>	<u>RTZ</u>
	J) ASSEMBLE STOCK		<u>6-19-08</u>	<u>RTZ</u>
	K) ASSEMBLE SWIVEL STUDS		<u>6-20-08</u>	<u>RTZ</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			<u>N/A</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	<u>6-20-08</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		<u>6/20/08</u>	<u>KW</u>
655	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>250</u> <u>253</u> <u>257</u> <u>251</u> <u>248</u>	<u>6-20-08</u>	<u>RTZ</u>
	C) FUNCTION		<u>6-20-08</u>	<u>RTZ</u>
660	PACK		<u>6/20/08</u>	<u>Fm</u>

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6764936.___0
FILE DATE AND TIME: 06/20/2008 10:21

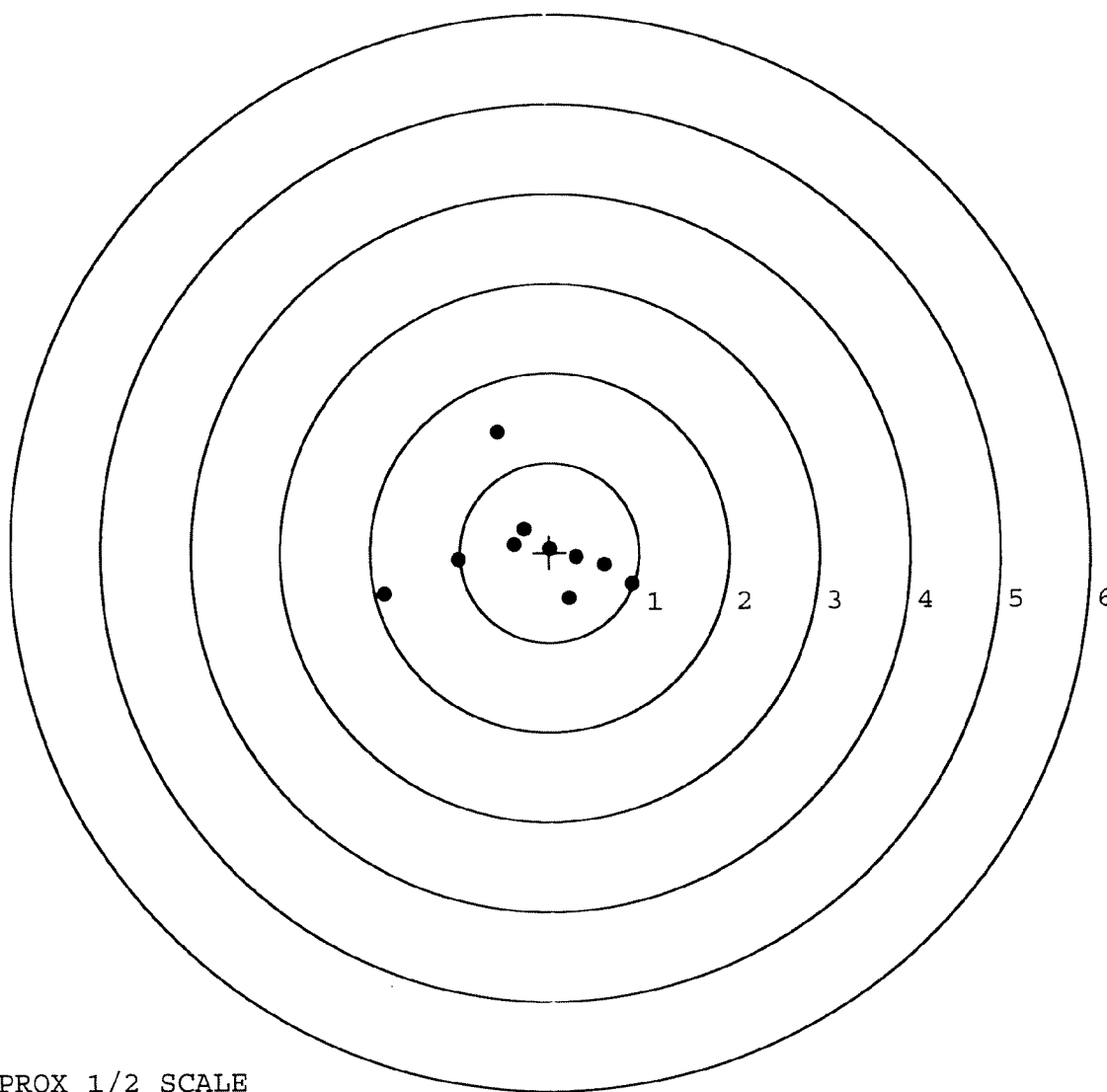
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.166
The Average Y Centroid of the Five Target Set:	0.080
The Average Point of Impact of the Five Target Set:	0.184
The Average Mean Radius of the Five Target Set:	0.739
The Distance from POA to Centroid Target #1:	0.208
The Distance from Centroid Target #2 to Centroid Target #1:	0.193
The Distance from Centroid Target #3 to Centroid Target #1:	0.091
The Distance from Centroid Target #4 to Centroid Target #1:	0.146
The Distance from Centroid Target #5 to Centroid Target #1:	0.256

SERIAL NUMBER: G6764936. 0
TARGET NUMBER: 1
FILE DATE: 06/20/2008
FILE TIME: 10:21

X CENTROID: -0.207
Y CENTROID: 0.015
POA TO CENTROID: 0.208
HORZ SPREAD: 2.760
VERT SPREAD: 1.848
GROUP SPREAD: 2.762
MIN RADIUS: 0.205
MAX RADIUS: 1.702
MEAN RADIUS: 0.776
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.915	-0.357
2:	0.216	-0.508
3:	0.610	-0.142
4:	0.299	-0.058
5:	-0.001	0.045
6:	-0.285	0.265
7:	-0.397	0.093
8:	-1.014	-0.080
9:	-1.845	-0.449
10:	-0.572	1.340

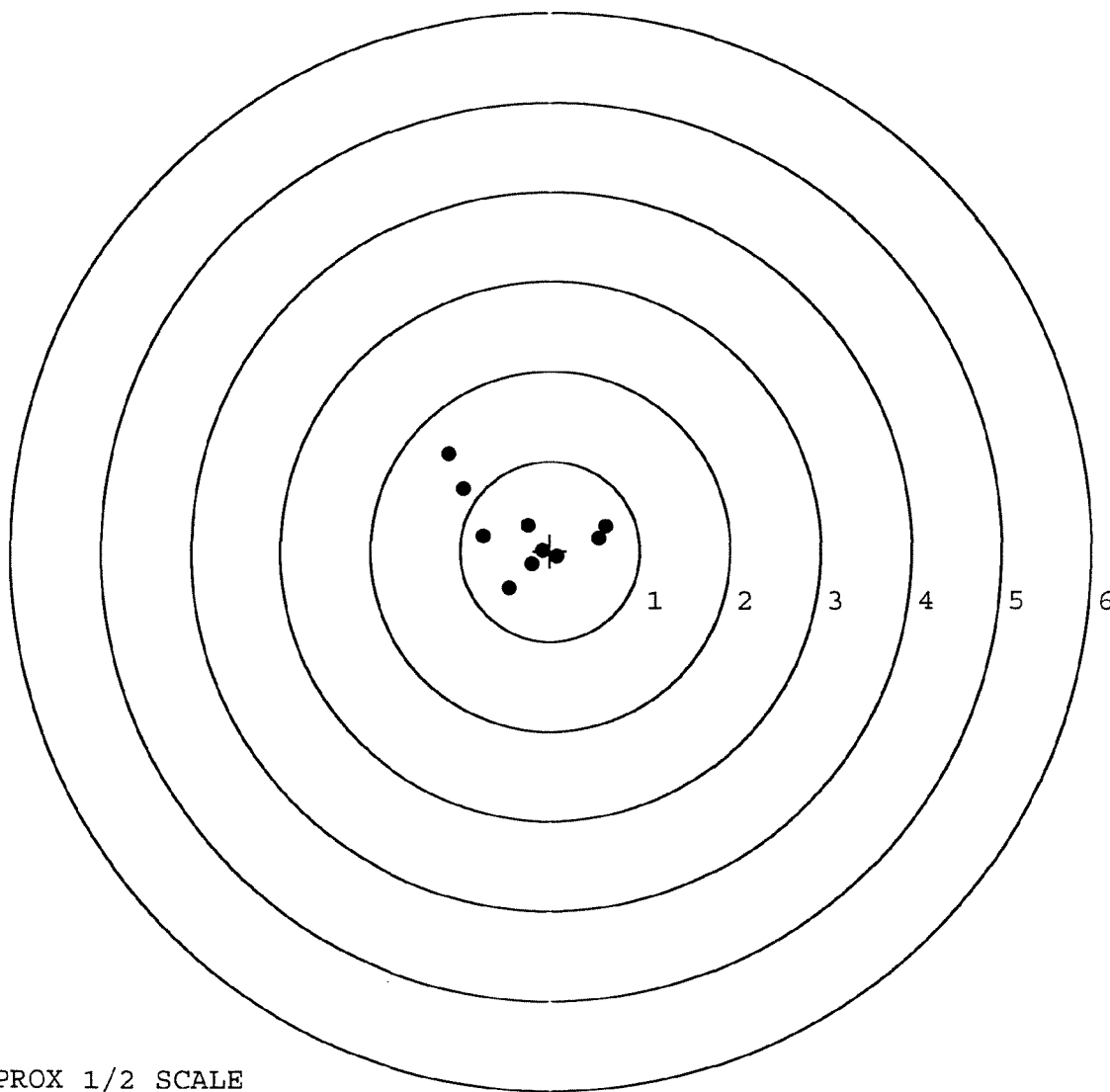


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764936.___0
TARGET NUMBER: 2
FILE DATE: 06/20/2008
FILE TIME: 10:21

POINT#	X	Y
1:	-1.127	1.082
2:	-0.970	0.696
3:	-0.753	0.161
4:	-0.454	-0.414
5:	0.608	0.268
6:	0.537	0.140
7:	0.078	-0.060
8:	-0.202	-0.150
9:	-0.247	0.283
10:	-0.082	0.000

X CENTROID: -0.261
Y CENTROID: 0.201
POA TO CENTROID: 0.329
HORZ SPREAD: 1.735
VERT SPREAD: 1.496
GROUP SPREAD: 1.916
MIN RADIUS: 0.084
MAX RADIUS: 1.236
MEAN RADIUS: 0.605
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

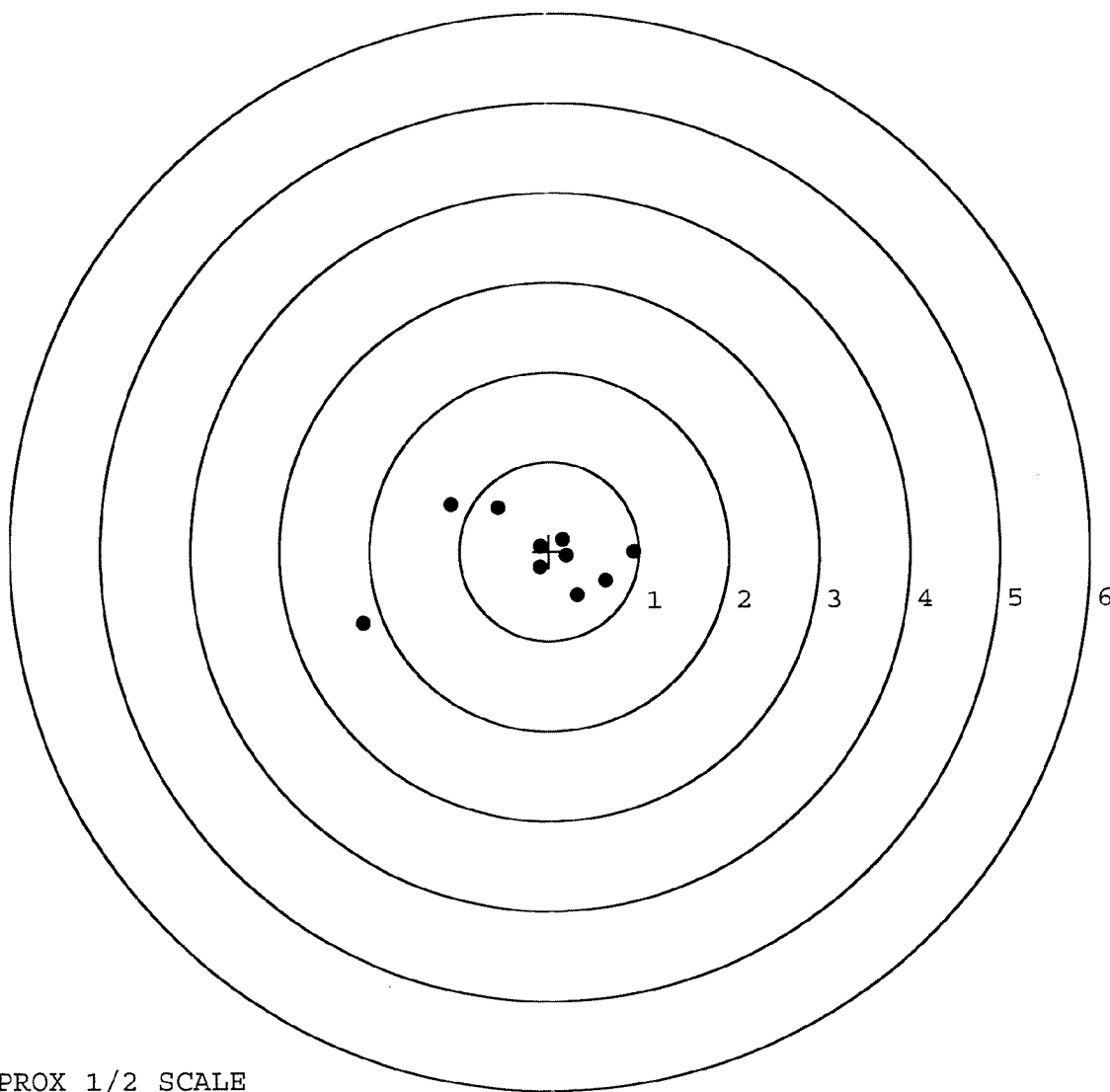


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764936. __0
TARGET NUMBER: 3
FILE DATE: 06/20/2008
FILE TIME: 10:21

X CENTROID: -0.171
Y CENTROID: -0.068
POA TO CENTROID: 0.184
HORZ SPREAD: 3.019
VERT SPREAD: 1.334
GROUP SPREAD: 3.119
MIN RADIUS: 0.134
MAX RADIUS: 2.041
MEAN RADIUS: 0.745
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-2.076	-0.802
2:	-1.089	0.532
3:	-0.567	0.493
4:	0.943	-0.017
5:	0.623	-0.337
6:	0.313	-0.497
7:	0.192	-0.055
8:	0.152	0.129
9:	-0.095	0.057
10:	-0.106	-0.185

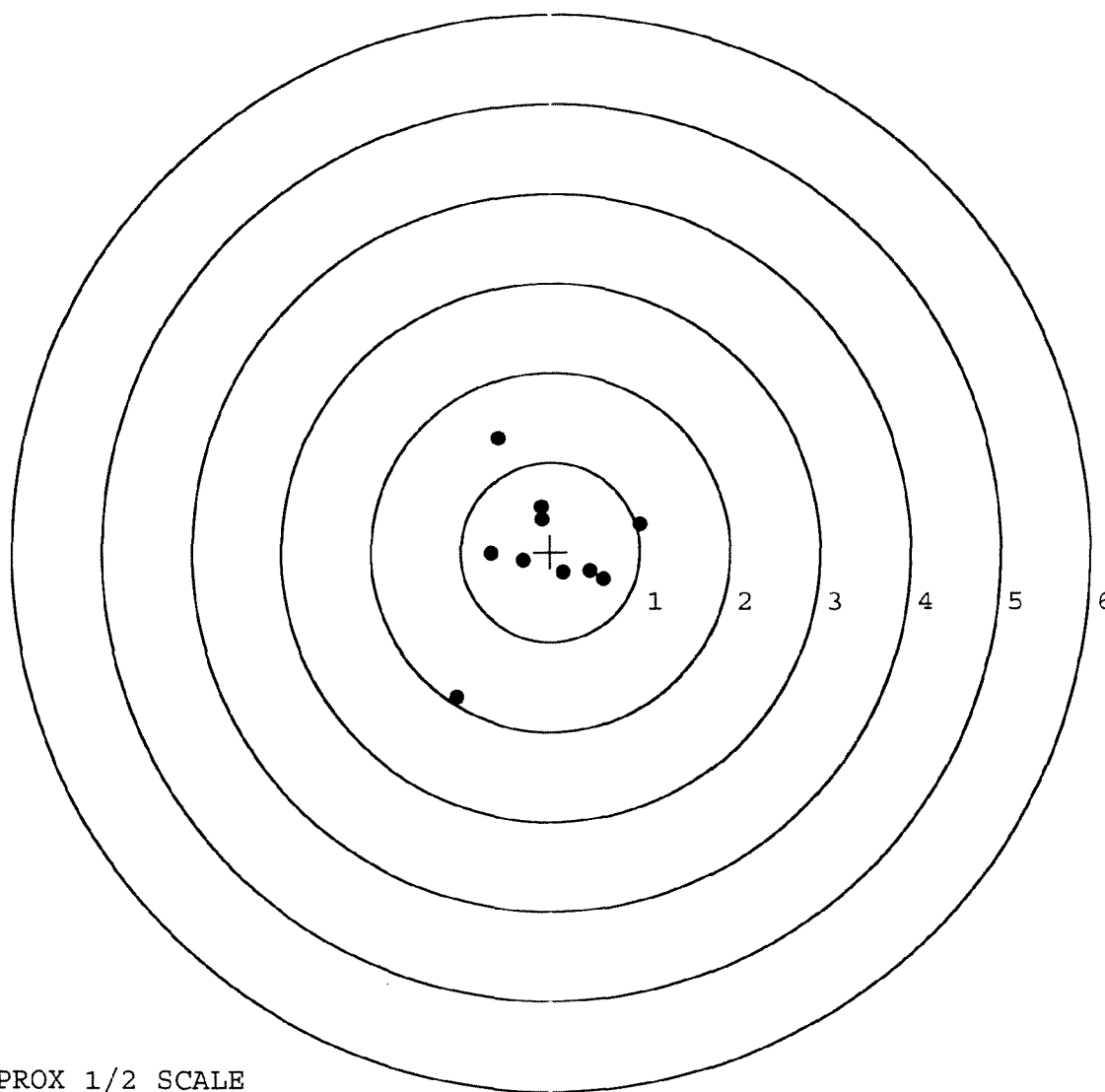


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764936. __0
TARGET NUMBER: 4
FILE DATE: 06/20/2008
FILE TIME: 10:21

X CENTROID: -0.063
Y CENTROID: -0.006
POA TO CENTROID: 0.064
HORZ SPREAD: 2.042
VERT SPREAD: 2.890
GROUP SPREAD: 2.925
MIN RADIUS: 0.257
MAX RADIUS: 1.893
MEAN RADIUS: 0.769
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.046	-1.624
2:	-0.592	1.266
3:	0.996	0.313
4:	-0.094	0.363
5:	-0.664	-0.027
6:	-0.303	-0.100
7:	0.592	-0.308
8:	0.140	-0.231
9:	0.442	-0.217
10:	-0.104	0.501

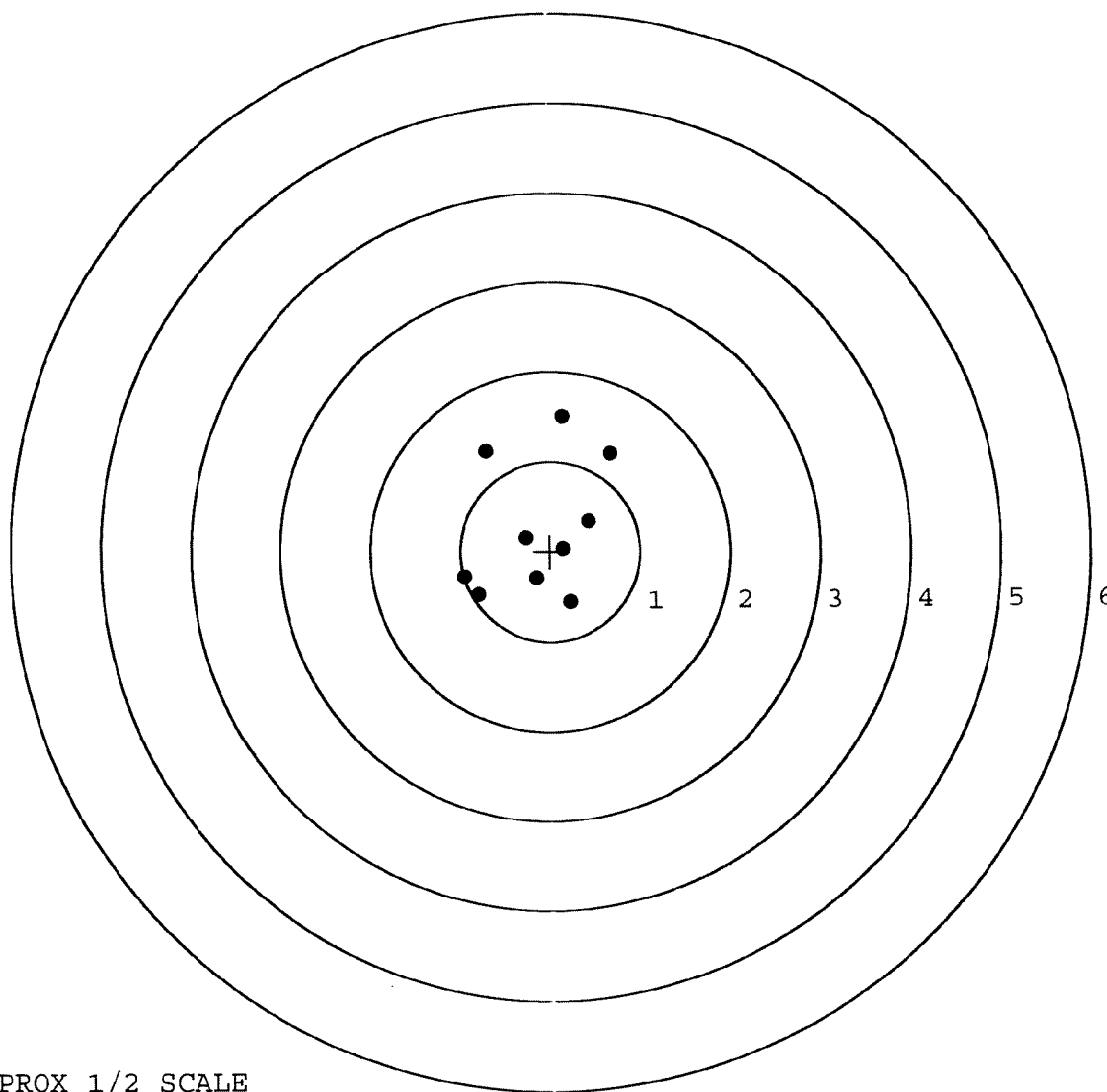


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6764936. 0
TARGET NUMBER: 5
FILE DATE: 06/20/2008
FILE TIME: 10:21

X CENTROID: -0.128
Y CENTROID: 0.258
POA TO CENTROID: 0.288
HORZ SPREAD: 1.633
VERT SPREAD: 2.074
GROUP SPREAD: 2.198
MIN RADIUS: 0.180
MAX RADIUS: 1.273
MEAN RADIUS: 0.802
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.958	-0.281
2:	-0.804	-0.482
3:	0.226	-0.572
4:	-0.159	-0.301
5:	0.433	0.333
6:	0.146	0.031
7:	-0.272	0.150
8:	0.675	1.083
9:	0.141	1.502
10:	-0.712	1.117

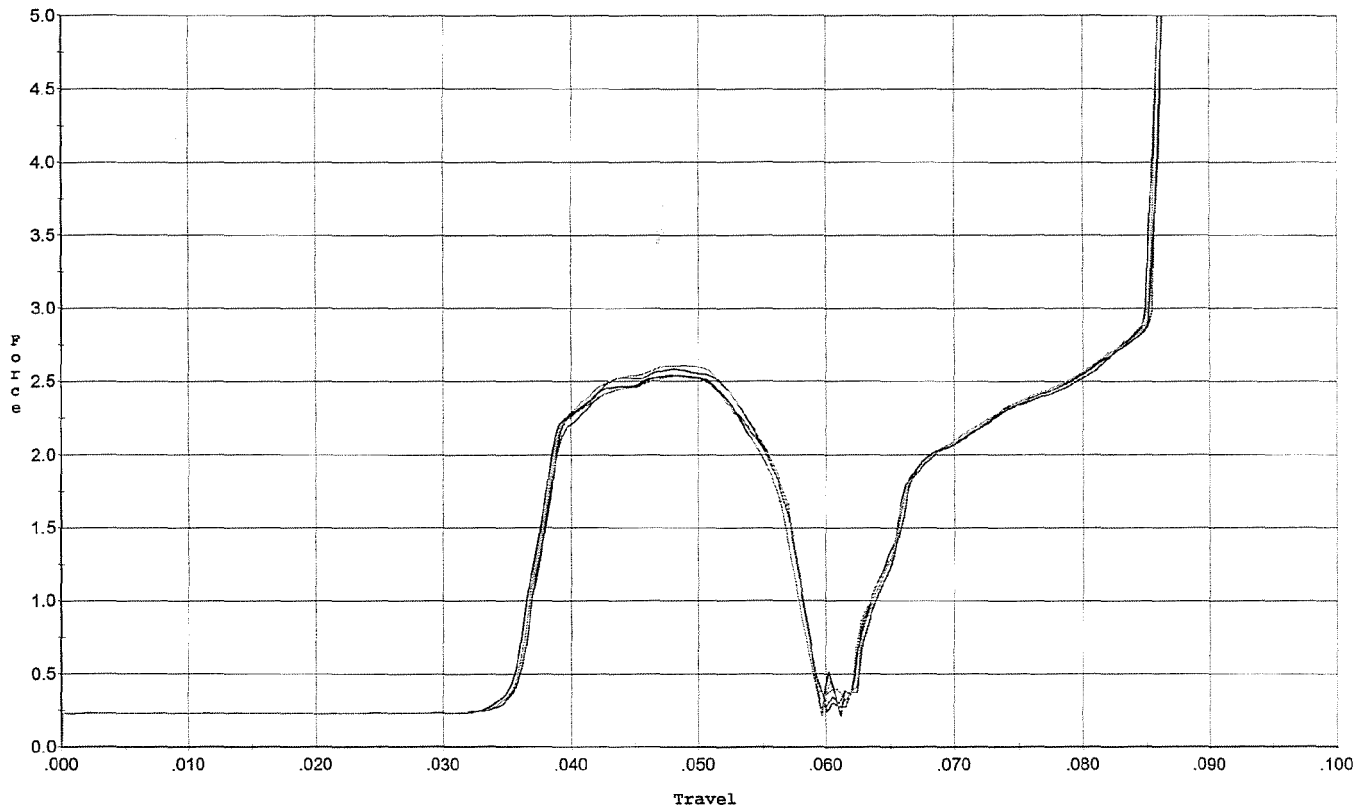


TARGET APPROX 1/2 SCALE

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



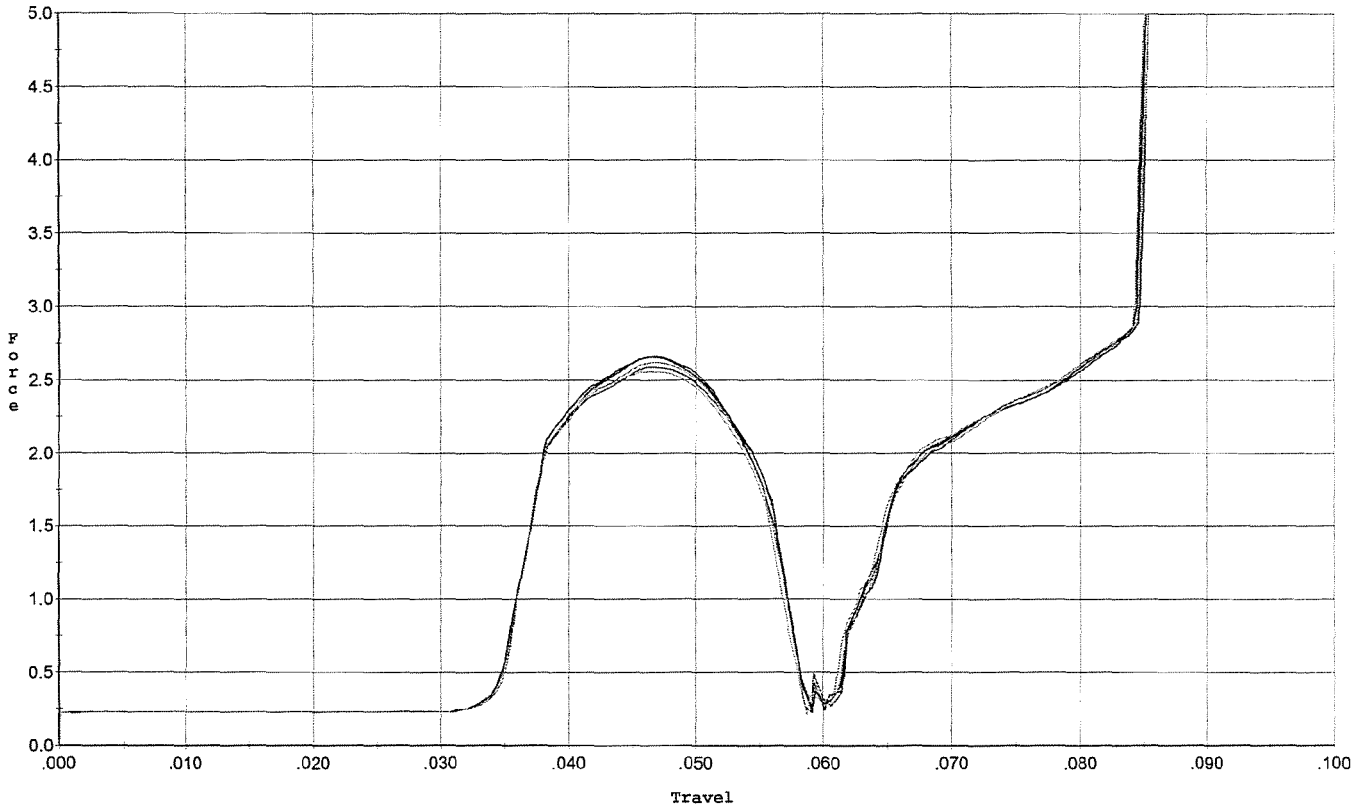
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.582	0.057	0.036	0.036	0.055		Set Trigger
2	2.542	0.056	0.035	0.036	0.054		Set Trigger
3	2.540	0.057	0.036	0.035	0.055		Set Trigger
4	2.537	0.056	0.036	0.036	0.054		Set Trigger
5	2.609	0.057	0.036	0.035	0.056		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



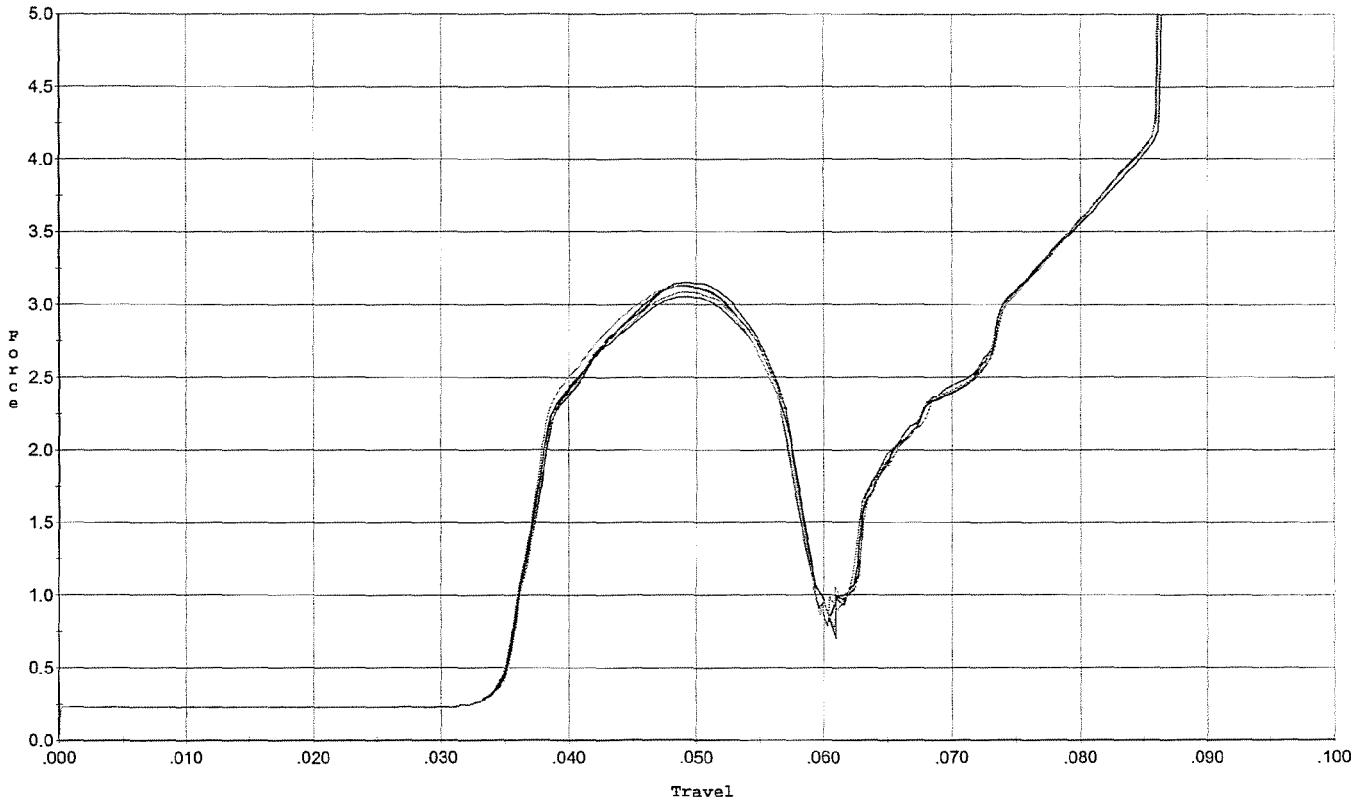
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.662	0.056	0.034	0.035	0.055		Set Trigger
2	2.660	0.056	0.034	0.035	0.055		Set Trigger
3	2.590	0.056	0.034	0.035	0.054		Set Trigger
4	2.559	0.056	0.035	0.035	0.053		Set Trigger
5	2.623	0.057	0.035	0.035	0.054		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



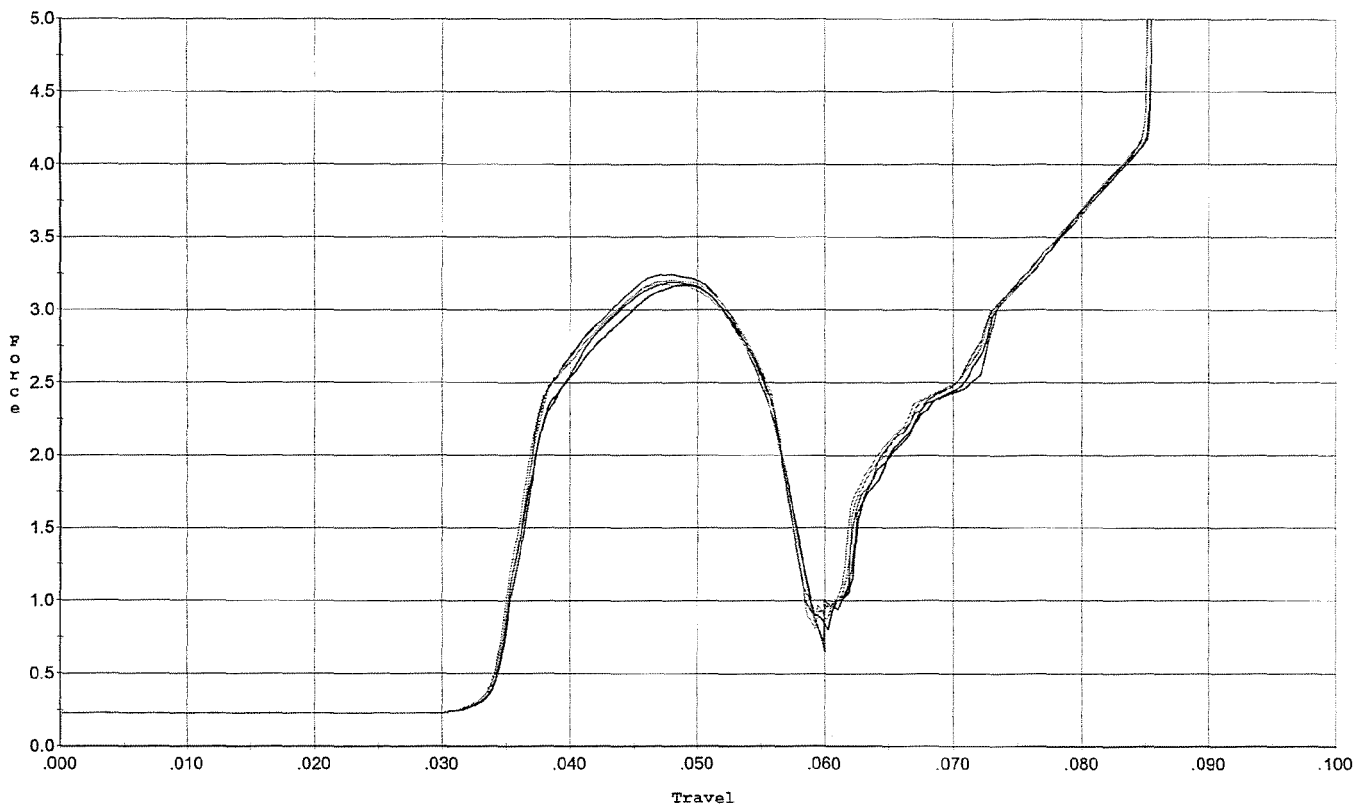
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.149	0.057	0.035	0.035	0.066		Set Trigger
2	3.128	0.057	0.035	0.034	0.066		Set Trigger
3	3.052	0.056	0.035	0.035	0.063		Set Trigger
4	3.126	0.056	0.035	0.035	0.065		Set Trigger
5	3.084	0.058	0.035	0.034	0.066		Set Trigger

Avg 3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



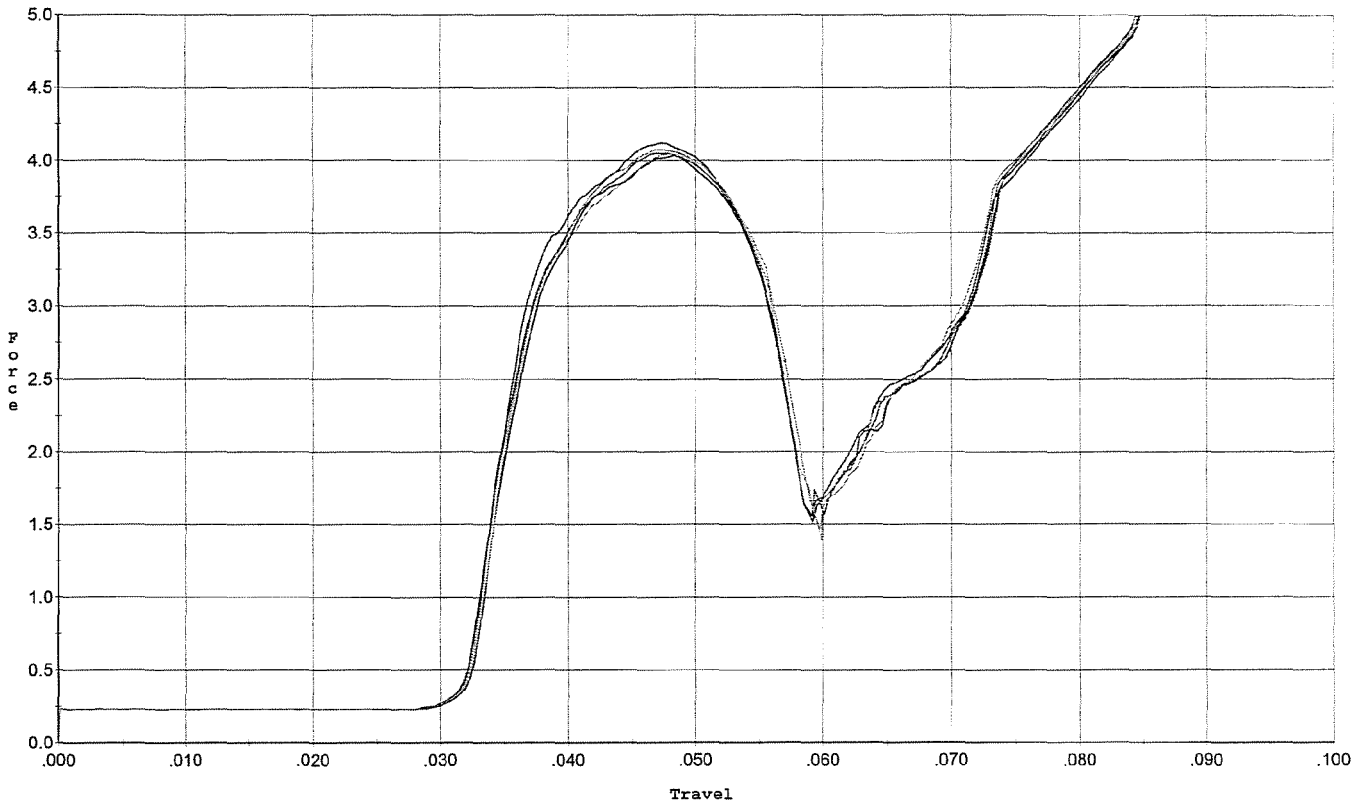
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.190	0.056	0.034	0.035	0.066		Set Trigger
2	3.170	0.056	0.034	0.035	0.065		Set Trigger
3	3.243	0.056	0.034	0.034	0.067		Set Trigger
4	3.173	0.056	0.034	0.034	0.067		Set Trigger
5	3.205	0.056	0.034	0.035	0.067		Set Trigger

Avg 3.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 6/02/08

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



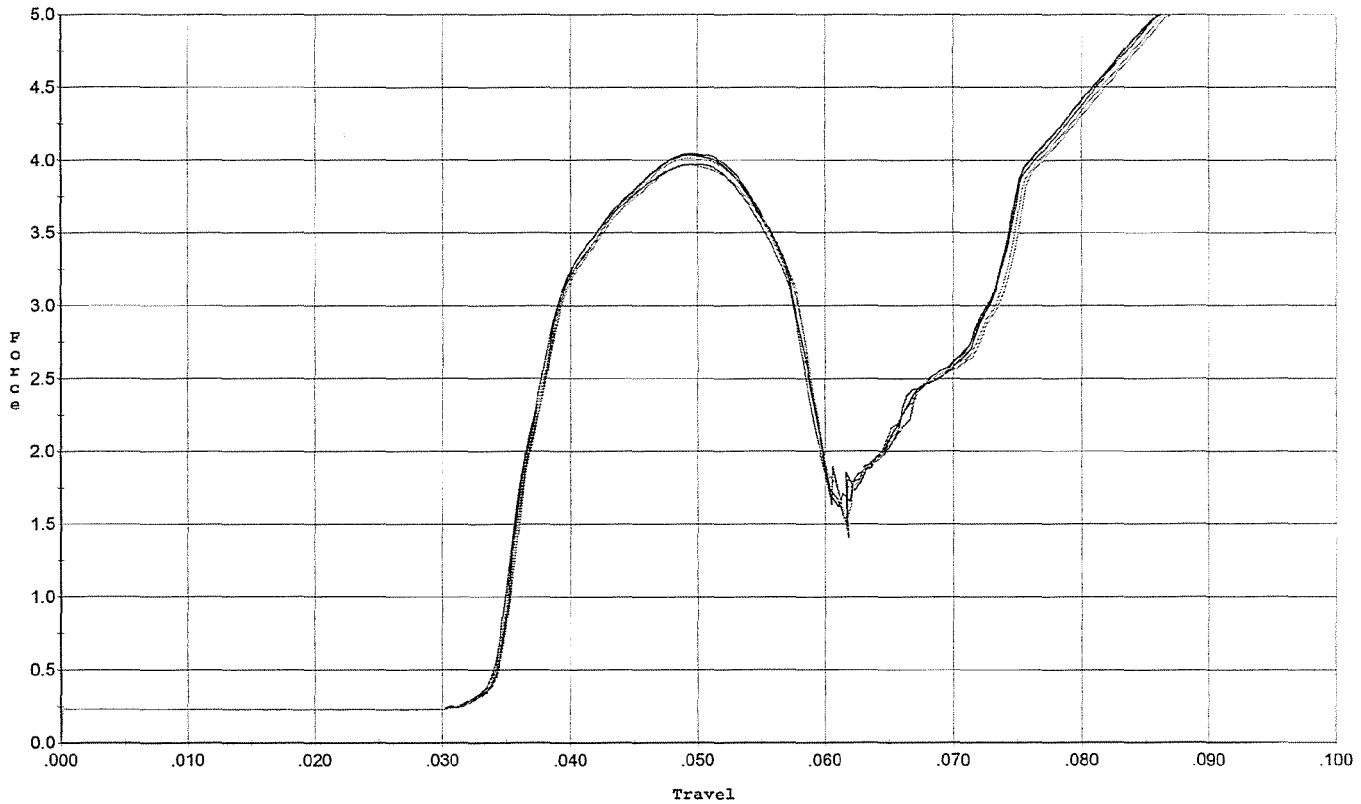
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.056	0.032	0.033	0.089		Set Trigger
2	4.035	0.056	0.032	0.033	0.086		Set Trigger
3	4.050	0.056	0.032	0.032	0.088		Set Trigger
4	4.042	0.057	0.032	0.033	0.088		Set Trigger
5	4.075	0.056	0.032	0.033	0.087		Set Trigger

AVG 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



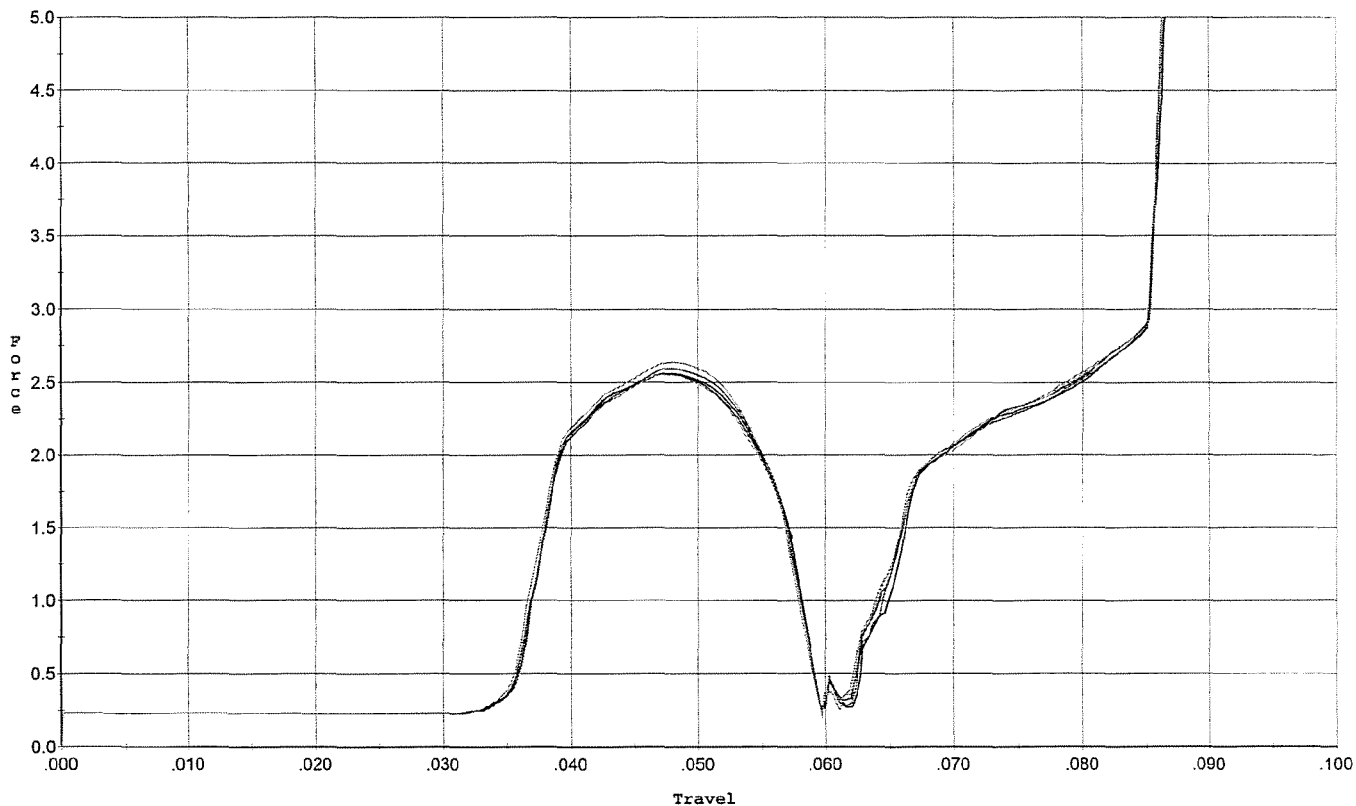
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.046	0.058	0.034	0.033	0.087		Set Trigger
2	4.037	0.059	0.034	0.033	0.088		Set Trigger
3	3.969	0.057	0.034	0.033	0.085		Set Trigger
4	4.018	0.058	0.034	0.033	0.087		Set Trigger
5	3.971	0.058	0.034	0.033	0.086		Set Trigger

Avg 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



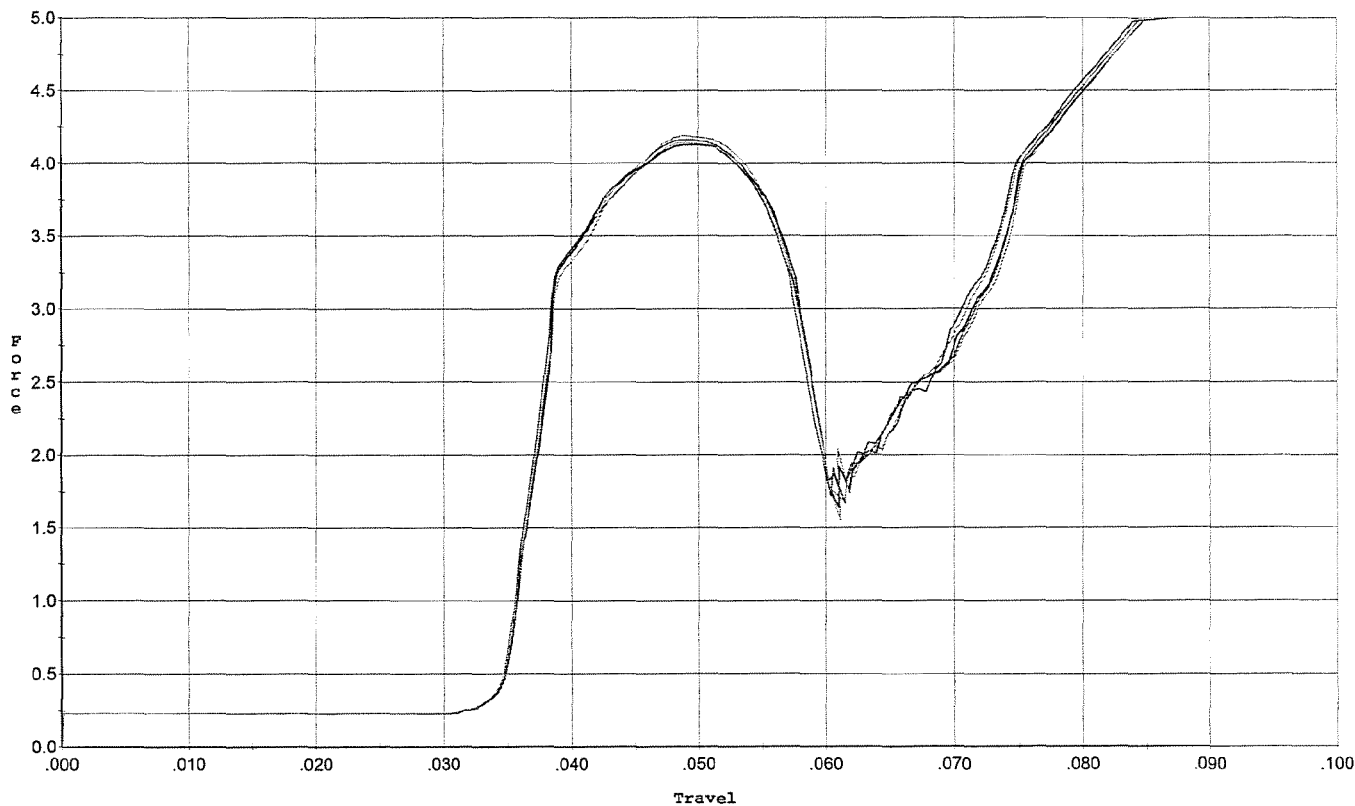
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.058	0.035	0.036	0.055		Set Trigger
2	2.564	0.057	0.036	0.036	0.054		Set Trigger
3	2.596	0.057	0.036	0.036	0.055		Set Trigger
4	2.639	0.058	0.036	0.036	0.056		Set Trigger
5	2.555	0.057	0.035	0.036	0.053		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 6/02/08

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



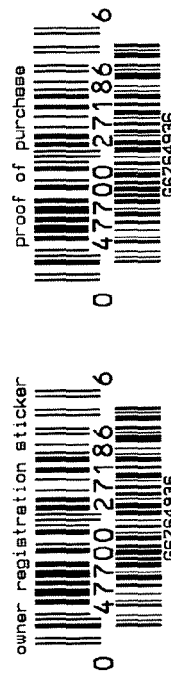
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.130	0.058	0.034	0.033	0.088		Set Trigger
2	4.126	0.058	0.035	0.033	0.089		Set Trigger
3	4.161	0.057	0.034	0.033	0.087		Set Trigger
4	4.143	0.058	0.034	0.033	0.089		Set Trigger
5	4.188	0.058	0.035	0.033	0.089		Set Trigger

Avg 4.15

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

– INSTRUCTION BOOK 3518

BM FORM

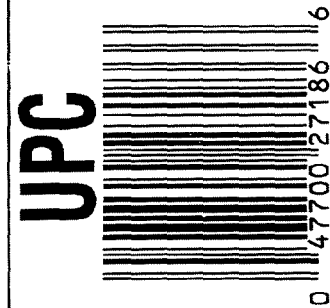


ORDER NO. 27186

BARREL LENGTH 24"

CAPACITY 6

G6764936



6/12/2008 2:45:04 PM

Crib

Original

27186

M/24 A2 7.62 NATO (RIFLE W/OPTICS)



.MA27186

Shop Order: SW897229



.ABSW897229

Start Date: 8/7/2008

Finish Date: 8/14/2008

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0006587296

0547

01PC001

Gray Sandstrom Coat Bolt Assemblies



0006587302

0610

89SWS1

Assemble Action to Stock.



0006587307

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

Murray, Fran B.

From: Balio, John R.
Sent: Tuesday, June 24, 2008 11:38 AM
To: Allen, Christopher; Murray, Fran B.; Reynolds, Raymond
Cc: Nagle, Thomas J.; Tucker, Peter L.; Matousek, Rob A.; Balio, John R.
Subject: SWS Pack Error
Importance: High

The gun below was packed on the wrong order as the wrong SKU. It should have been packed as a 27186 not a 27246. We need to correct by close of business today.

Chris – Please reverse the conformation and receipt on order SW885951 and change the S/N back to rolled. Let us know when done.

Fran – Once Chris updates the S/N and conformation, please pack this gun on order SW897229 (27186) and relable the box. Let us know when done.

Ray – Please reverse the conformation you posted on SW885951. Let us know when done.

Thanks,

John

6/24/2008

Production Serial Number Inquiry

File Window

Serial Inquiry - DMSIn

Options

Serial #'s

From: ☒ PartialTo:

Status

☒ Assigned☐ DeleteMe☐ Etched☒ All

Material

27246

Model:

On-Hold

☐ On-Hold Items Only☐ Exclude On-Hold ItemsTransfer:

Actions

☐ Sequence Check

File Record

Limit: 64999

☐ :Direct to File

Total Recs:

1 Records

Total Viewed:

1 Records

SerialNbr	HoldStatus	VendBatch	ProdOrderNbr	ShipUnitNbr	CustomerPO	PhyInvCou
G6764936	Material ina		SW885951			

Serial History - G6764936

SerialNbr	ActivityCode	ActivityDate	ActivityBy	ActivityDesc1	ActivityDesc2
G6764936	Assigned	5/26/2008 9:29:57 AM	haywardmc	700	
G6764936	Rolled	6/9/2008 7:32:09 AM	harwickce		
G6764936	Print	6/20/2008 9:23:51 AM	murrayfb	Packer Print	
G6764936	Packed	6/20/2008 9:23:51 AM	murrayfb	.ABS'W885951	
G6764936	Override	6/20/2008 9:23:51 AM	murrayfb	Model>SN:700 LIKE: SKU:SW'S	
G6764936	Warehoused	6/20/2008 10:16:17 AM	murrayfb	SW885951	

File Name

8590

Done.

6/24/2008

Remington®



VERY IMPORTANT: Instruction Book enclosed
to assure safe use of this firearm.

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

G6764936

Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.

BM ORDER NO. 27246

20PC



27246 66764936

Do Not Use

ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

UPC



ORDER 27186

M24A2 SWS RIFLE - W/OPTICS ONLY

UPC



SERIAL NO.



Do Not Use

SNA - Serial Number Warehousing

File OverPacking Palletizing Receiving Locate What's This Help

What's This

Location / Pallet / OverPack / Serial Case: G6764936

This Serial Case contains: 1 Serial Numbers.

Serial Nbr	Status	Date	User ID	Location	Pallet	OverPack	Shipment	Delivery	Material	Hold Status
G6764936	Warehoused	6/24/2008 1:09:35 PM	murraylb	Warehouse					27186	Material ina

Local Serial Number History

Activity	Date & Time	User ID	Description
Assigned	5/26/2008 9:29:57 AM	haywardmc	700
Rolled	6/9/2008 7:32:09 AM	harwickce	
Print	6/20/2008 9:23:51 AM	murraylb	Packer Print
Packed	6/20/2008 9:23:51 AM	murraylb	ABSW895951
Override	6/20/2008 9:23:51 AM	murraylb	Model>SN:700 LIKE: SKU:SWS
Warehoused	6/20/2008 10:16:17 AM	murraylb	SW885951
Correction	6/24/2008 11:41:00 AM	allenop	Changed Status from Warehoused to Rolled
Print	6/24/2008 12:58:18 PM	murraylb	Packer Print
Packed	6/24/2008 12:58:19 PM	murraylb	ABSW897229
Warehoused	6/24/2008 1:09:35 PM	murraylb	SW897229

Serial Number: G6764936 Refresh Close

murraylb 6/24/2008 1:10 PM CAPS NUM INS SCRL

start DmsLN NtysDoor Plan SNA - Serial Number ... 1:10 PM