

G-660 5353

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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SERIAL NO.



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

- INSTRUCTION BOOK 3518

1P FORM

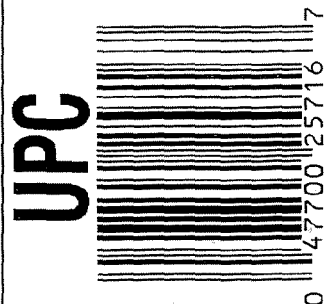


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6605353



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6605353

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RTZ
420	ASSEMBLE ACTION		10-6-06	RTZ
430	ASSEMBLE TO STOCK		10-6-06	BLP
440	PROOF		10-7-06	TRLW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-7-06	TRLW
470	DIS-ASSEMBLE ACTION	OCT 10 2006	10-7-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	CO
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRLW
520	GOFF BLAST BBL / REC		10-10-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/17/06	TRB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-24-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

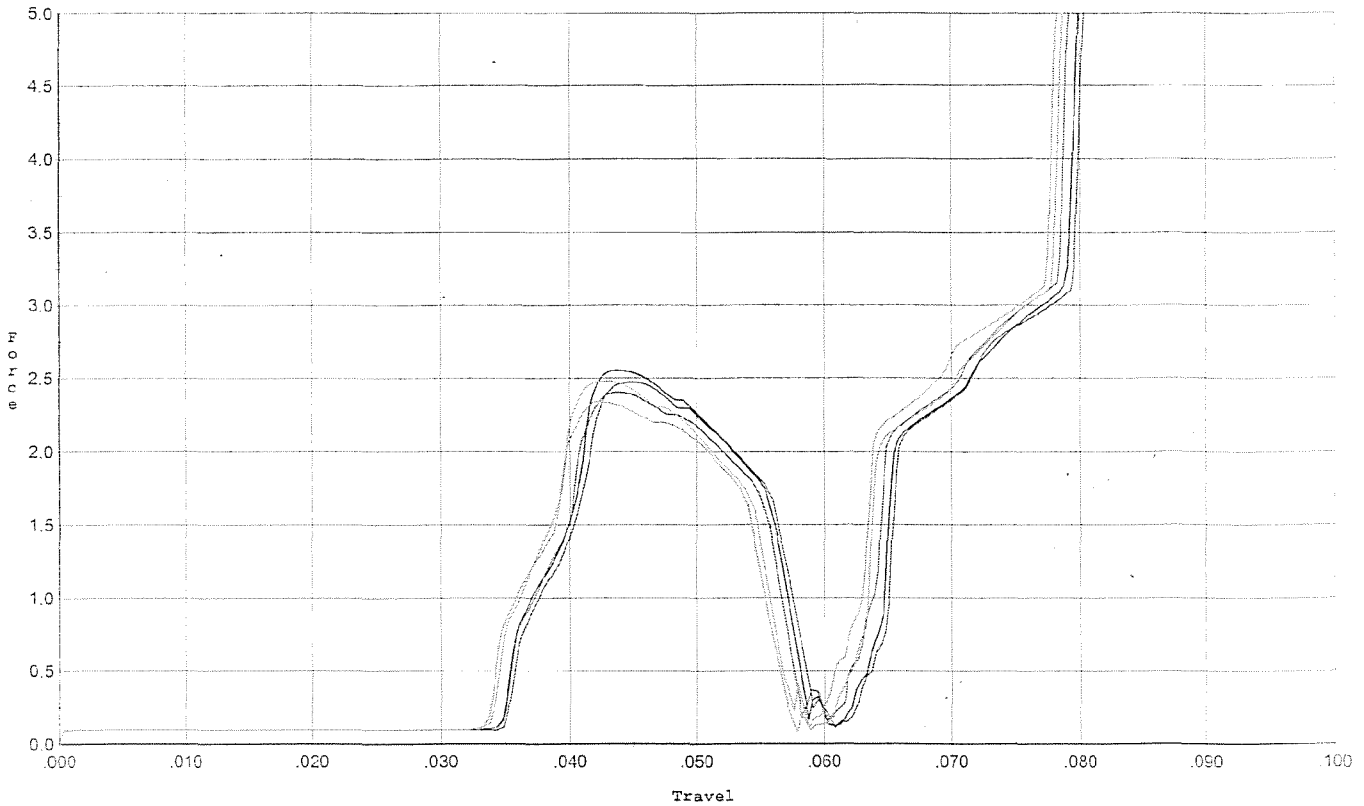
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.0</u> <u>2.0</u> <u>2.0</u>	11-18-06	L.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>3.0</u>	11-18-06	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0255</u> <u>.0255</u> <u>.0255</u>	11-18-06	L.P.D.
	J) ASSEMBLE STOCK		10-24-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-18-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-24-06	RTZ
	M) IRON SIGHT ALIGNMENT		10-24-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-24-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL <u>PASS</u> FAIL	10-24-06	TRW
	MALFUNCTION <i>29 clicks right</i> <u>CORRECTION</u>		11-17-06	RTZ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-25-06	R.P.
670	FINAL INSPECTION A) HEADSPACE		11-18-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u> <u>2.70</u> <u>2.72</u> <u>2.74</u> <u>2.68</u>	11-13-06	SD
	C) FUNCTION		11-18-06	L.P.D.
690	PACK		11-20-06	BLC-

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 2.5 ini.



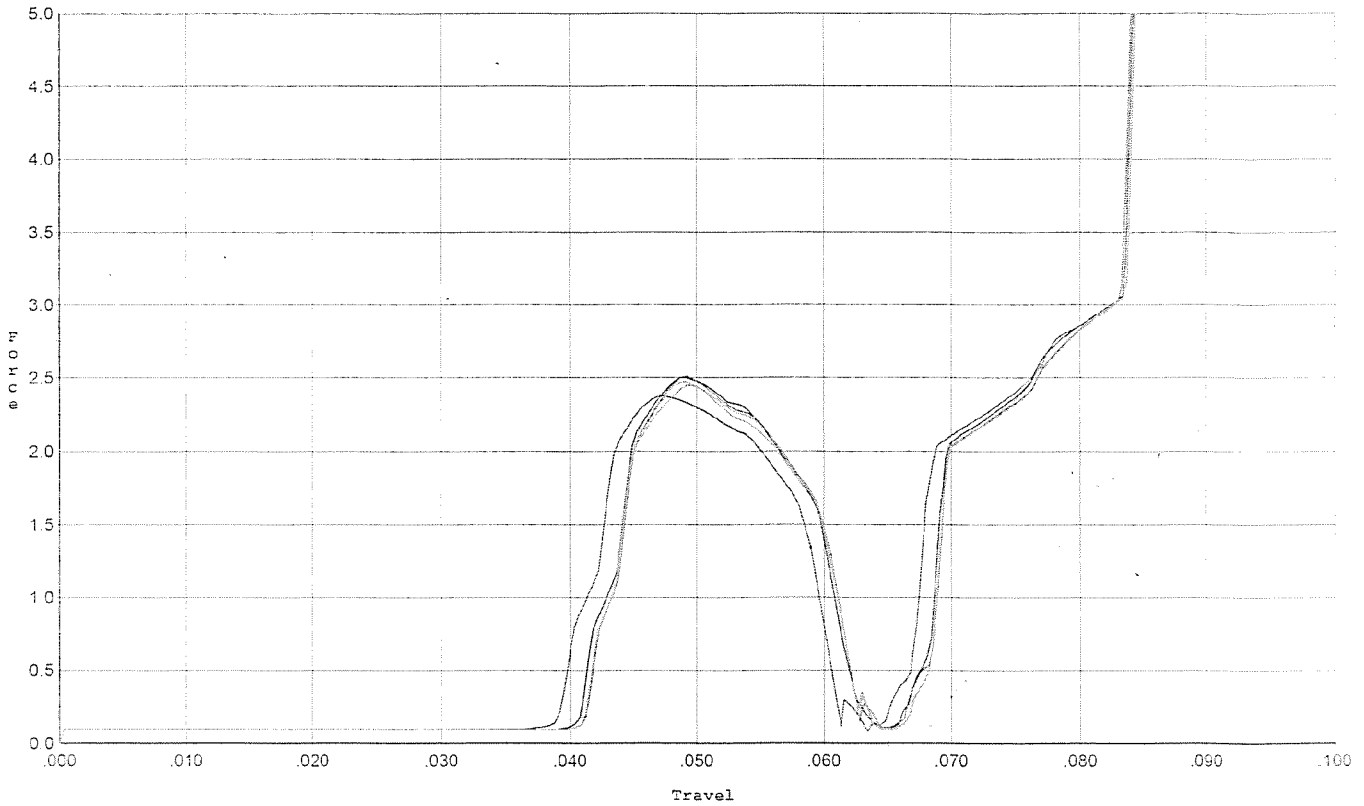
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.057	0.035	0.031	0.044		Set Trigger
2	2.555	0.056	0.035	0.031	0.045		Set Trigger
3	2.404	0.056	0.035	0.031	0.042		Set Trigger
4	2.479	0.055	0.034	0.031	0.043		Set Trigger
5	2.339	0.054	0.034	0.031	0.041		Set Trigger

AVG 2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 2.5 after 50 cycles



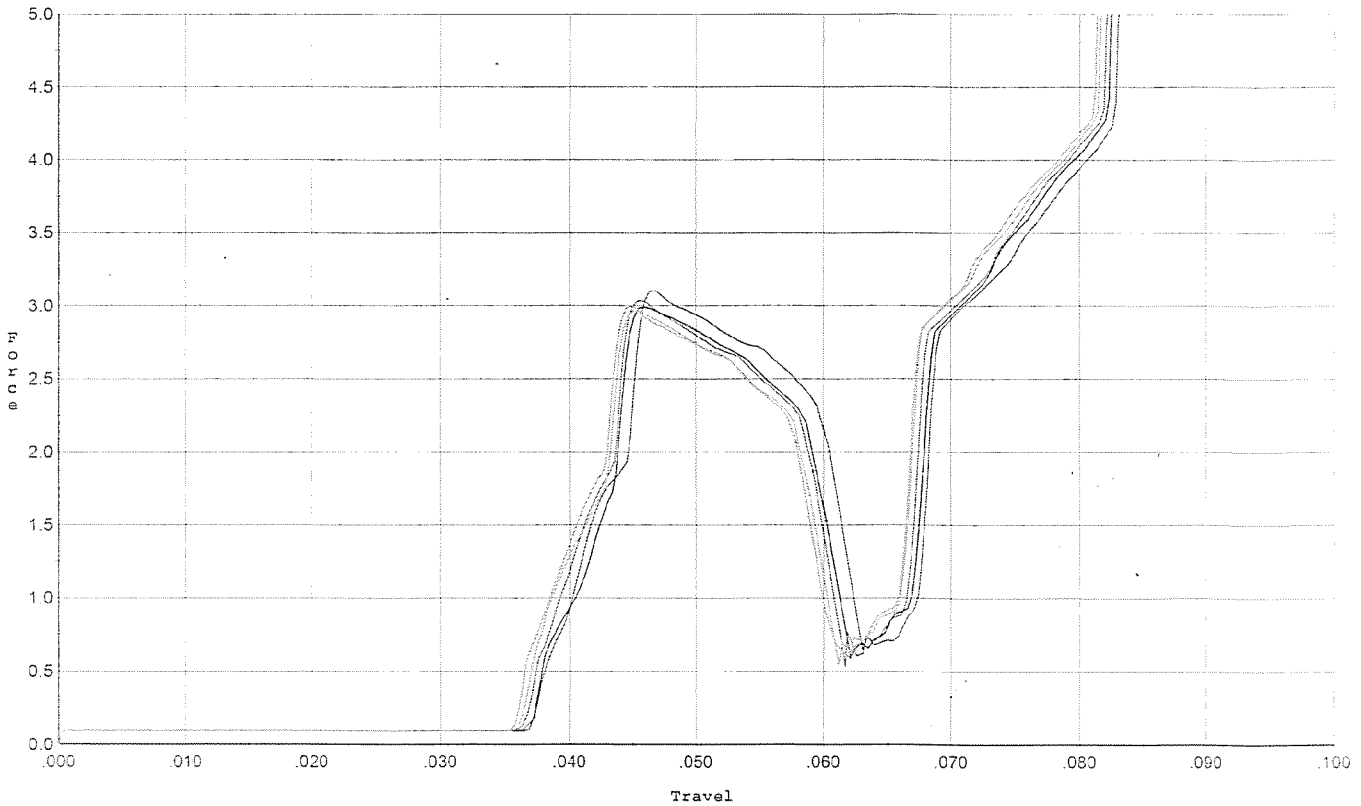
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.377	0.059	0.039	0.033	0.041		Set Trigger
2	2.499	0.060	0.041	0.032	0.041		Set Trigger
3	2.511	0.061	0.041	0.031	0.041		Set Trigger
4	2.471	0.061	0.041	0.031	0.041		Set Trigger
5	2.447	0.061	0.041	0.031	0.041		Set Trigger

AV6 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 3.0 ini.



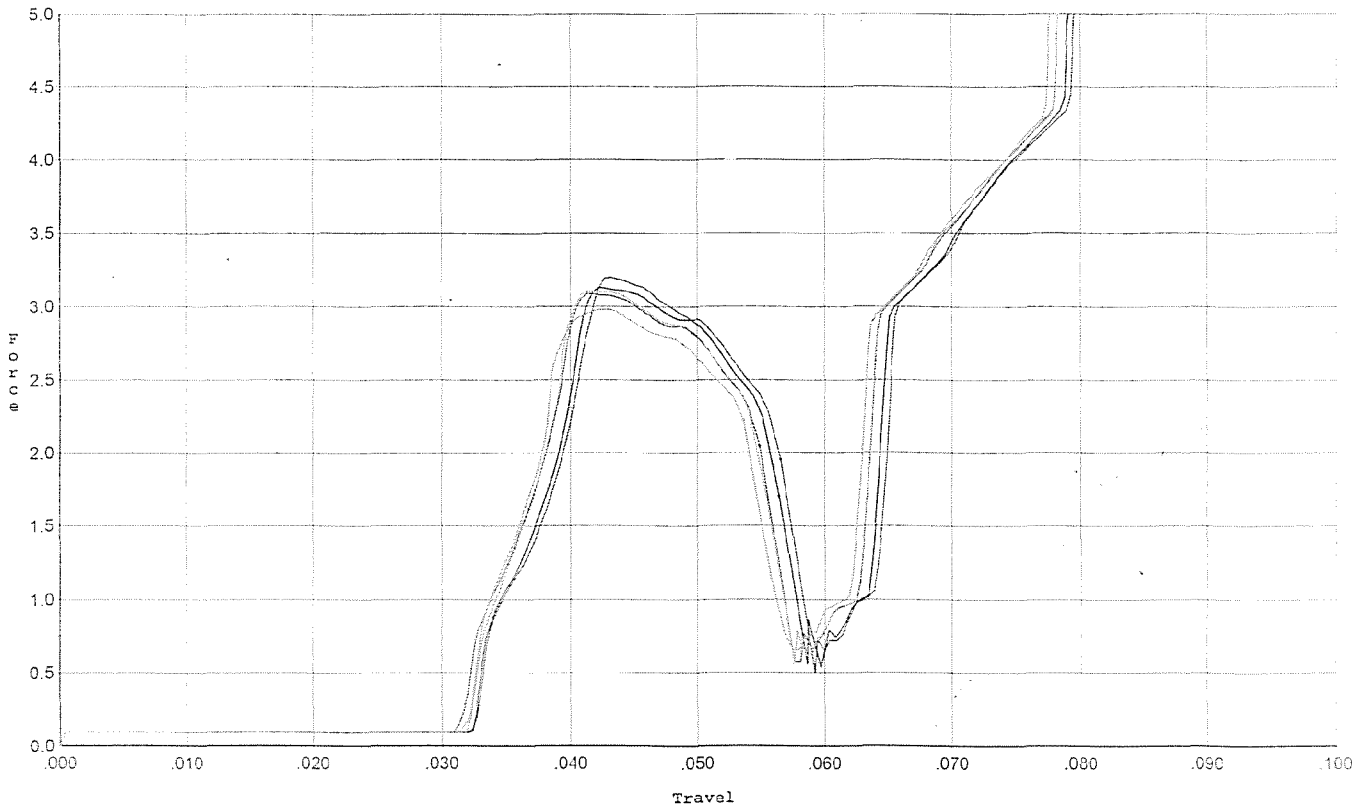
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.102	0.060	0.038	0.029	0.056		Set Trigger
2	2.991	0.060	0.037	0.029	0.053		Set Trigger
3	3.036	0.059	0.037	0.030	0.053		Set Trigger
4	2.966	0.059	0.036	0.030	0.053		Set Trigger
5	2.998	0.058	0.036	0.030	0.052		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 3.0 after 20 cycles



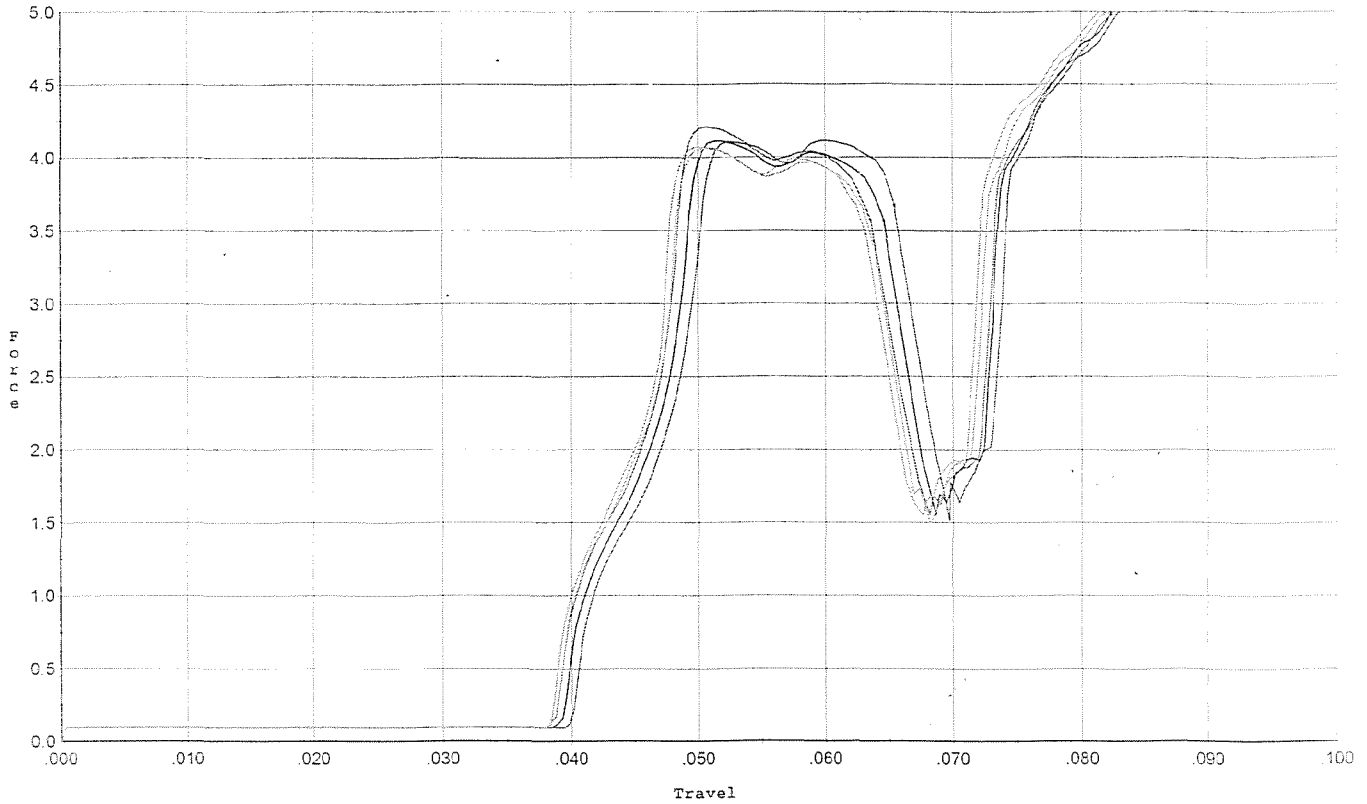
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.198	0.057	0.033	0.030	0.059		Set Trigger
2	3.129	0.056	0.033	0.030	0.059		Set Trigger
3	3.091	0.055	0.032	0.030	0.058		Set Trigger
4	3.104	0.055	0.032	0.030	0.058		Set Trigger
5	2.982	0.054	0.032	0.030	0.054		Set Trigger

AVG 3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 4.0 ini.



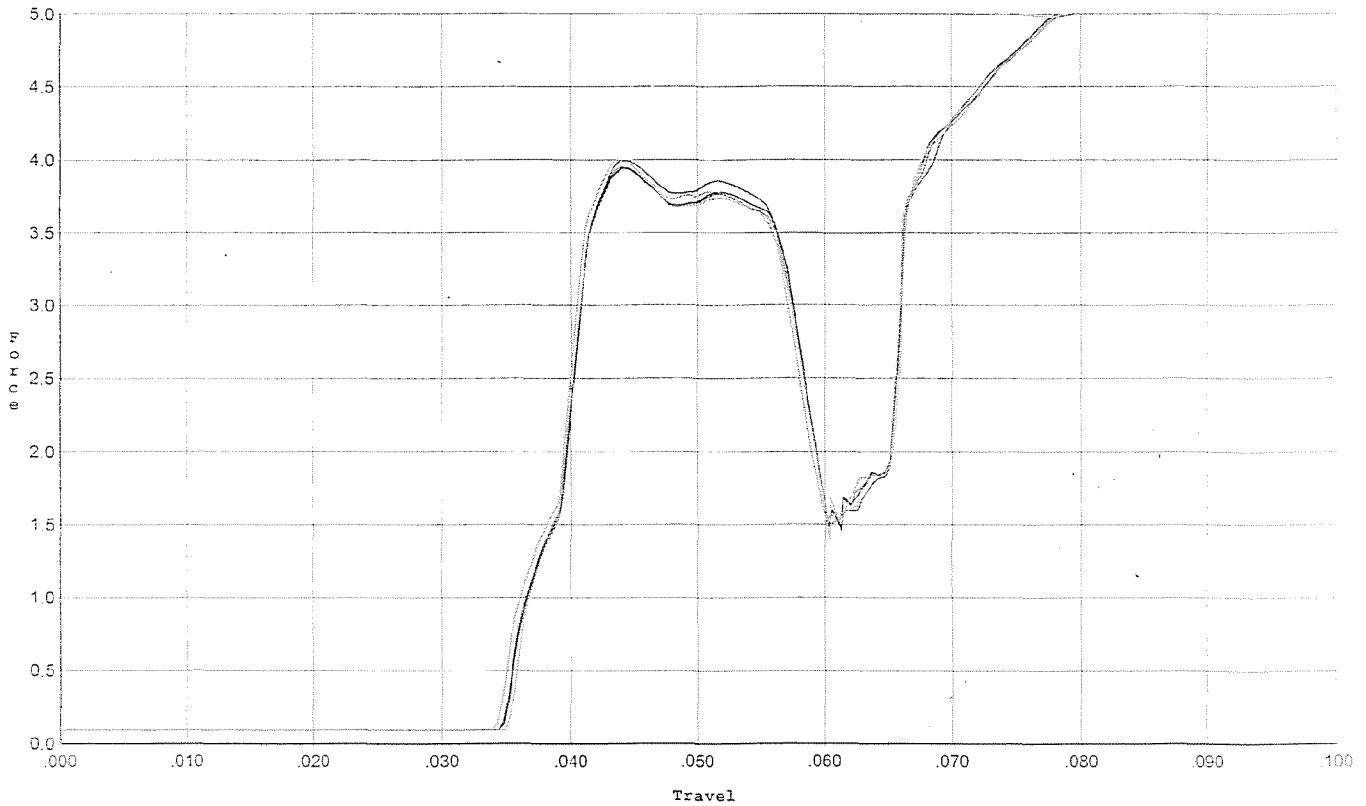
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.114	0.065	0.040	0.026	0.086		Set Trigger
2	4.112	0.065	0.040	0.027	0.085		Set Trigger
3	4.209	0.064	0.039	0.027	0.084		Set Trigger
4	4.063	0.064	0.039	0.027	0.083		Set Trigger
5	4.072	0.063	0.039	0.027	0.083		Set Trigger

Avg 4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: 4.0 after 20 cycles



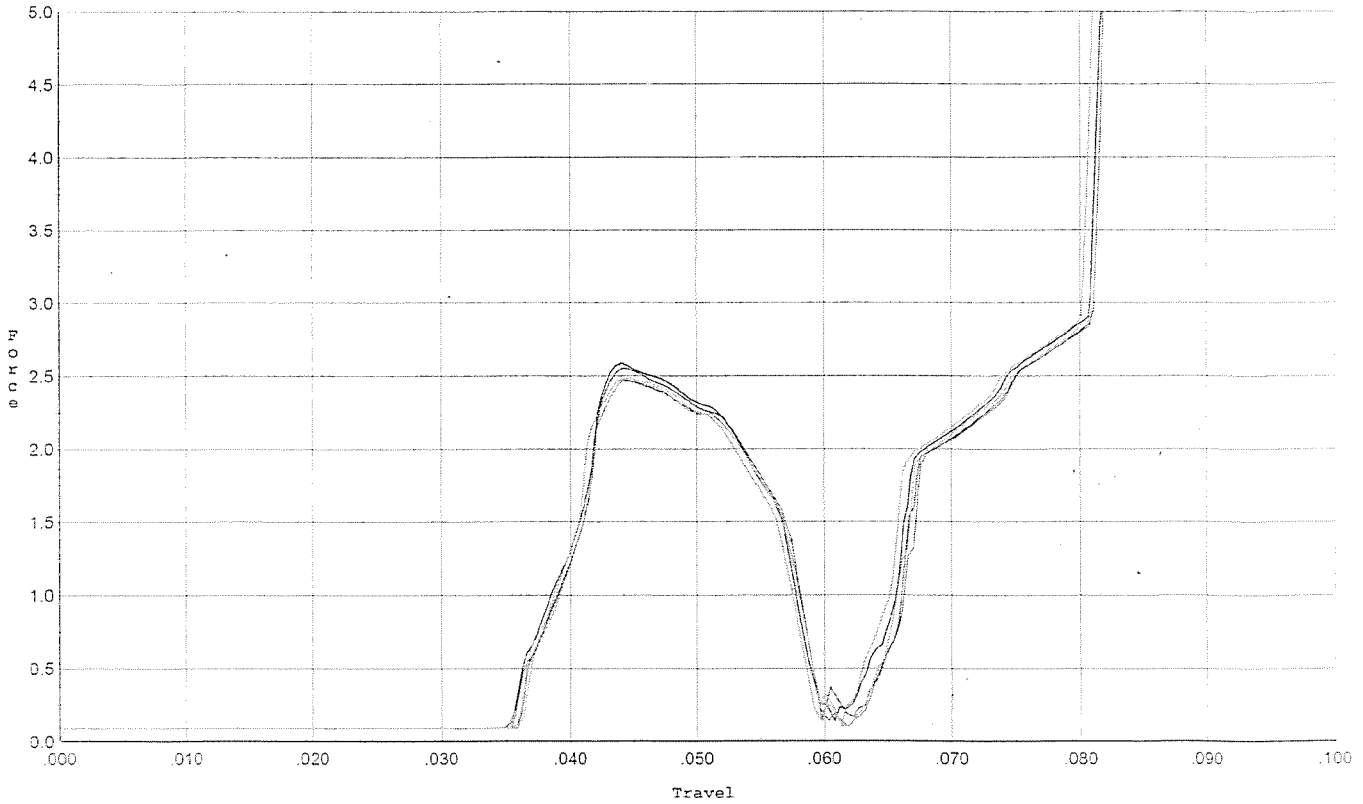
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.999	0.057	0.035	0.028	0.075		Set Trigger
2	3.945	0.057	0.035	0.028	0.074		Set Trigger
3	3.952	0.057	0.035	0.028	0.075		Set Trigger
4	3.934	0.058	0.035	0.028	0.074		Set Trigger
5	4.001	0.056	0.035	0.028	0.074		Set Trigger

AVG 3.96

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5



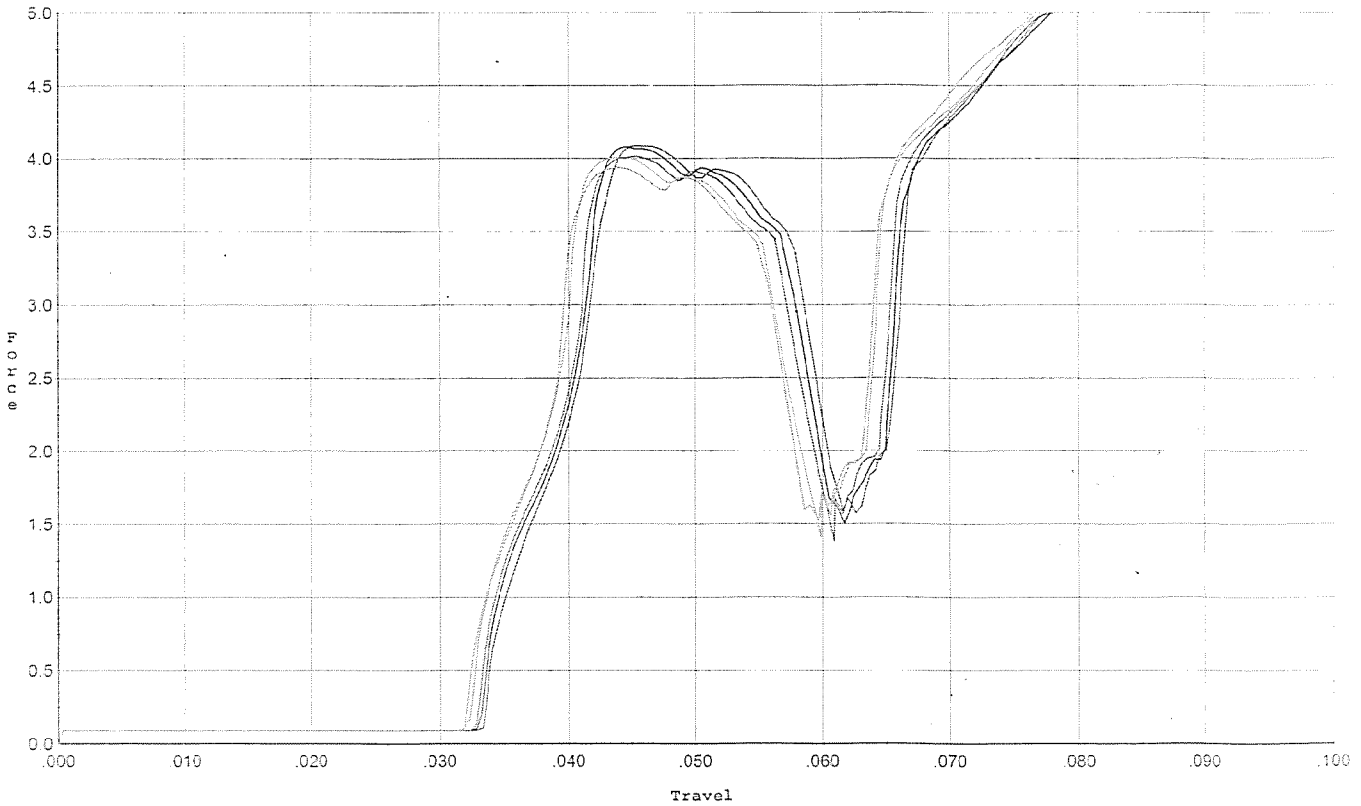
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.057	0.036	0.032	0.044		Set Trigger
2	2.587	0.057	0.036	0.032	0.044		Set Trigger
3	2.469	0.058	0.036	0.032	0.043		Set Trigger
4	2.488	0.058	0.037	0.032	0.043		Set Trigger
5	2.479	0.057	0.036	0.032	0.043		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/16/06

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.058	0.034	0.027	0.081		Set Trigger
2	4.077	0.058	0.033	0.027	0.081		Set Trigger
3	4.015	0.056	0.033	0.027	0.077		Set Trigger
4	4.010	0.055	0.032	0.028	0.076		Set Trigger
5	3.939	0.056	0.032	0.027	0.076		Set Trigger

AVG 4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605353.__0

FILE DATE AND TIME: 10/26/2006 06:07

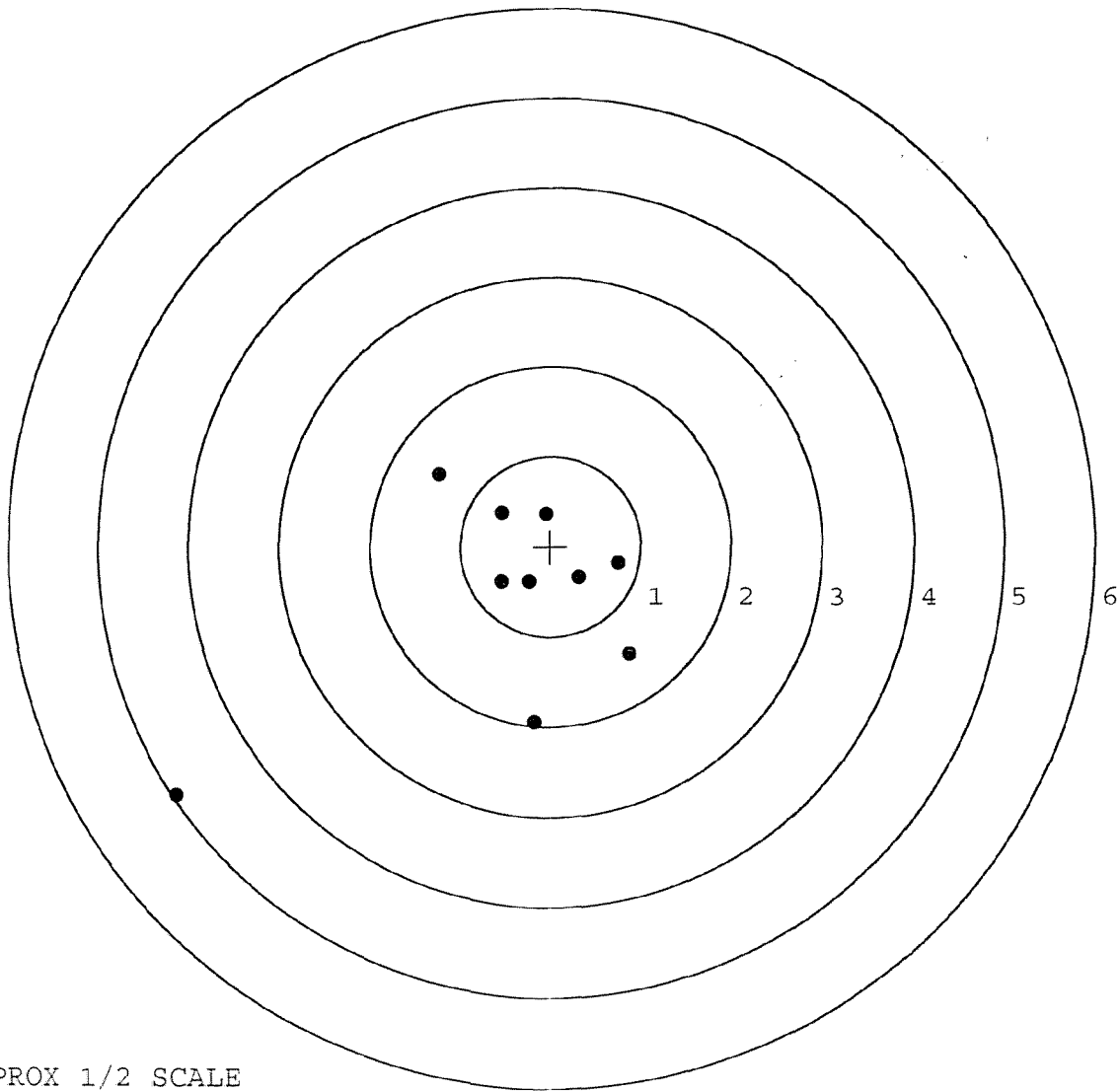
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.034
The Average Y Centroid of the Five Target Set:	-0.204
The Average Point of Impact of the Five Target Set:	0.207
The Average Mean Radius of the Five Target Set:	0.885
The Distance from POA to Centroid Target #1:	0.756
The Distance from Centroid Target #2 to Centroid Target #1:	0.882
The Distance from Centroid Target #3 to Centroid Target #1:	0.845
The Distance from Centroid Target #4 to Centroid Target #1:	0.773
The Distance from Centroid Target #5 to Centroid Target #1:	0.752

SERIAL NUMBER: G6605353. __ 0
TARGET NUMBER: 1
FILE DATE: 10/26/2006
FILE TIME: 06:07

X CENTROID: -0.498
Y CENTROID: -0.569
POA TO CENTROID: 0.756
HORZ SPREAD: 5.000
VERT SPREAD: 3.562
GROUP SPREAD: 5.509
MIN RADIUS: 0.187
MAX RADIUS: 4.237
MEAN RADIUS: 1.335
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-1.234	0.799
2:	-0.546	0.376
3:	-0.054	0.361
4:	0.878	-1.196
5:	-0.181	-1.955
6:	0.748	-0.188
7:	0.317	-0.348
8:	-0.236	-0.388
9:	-0.545	-0.388
10:	-4.122	-2.763

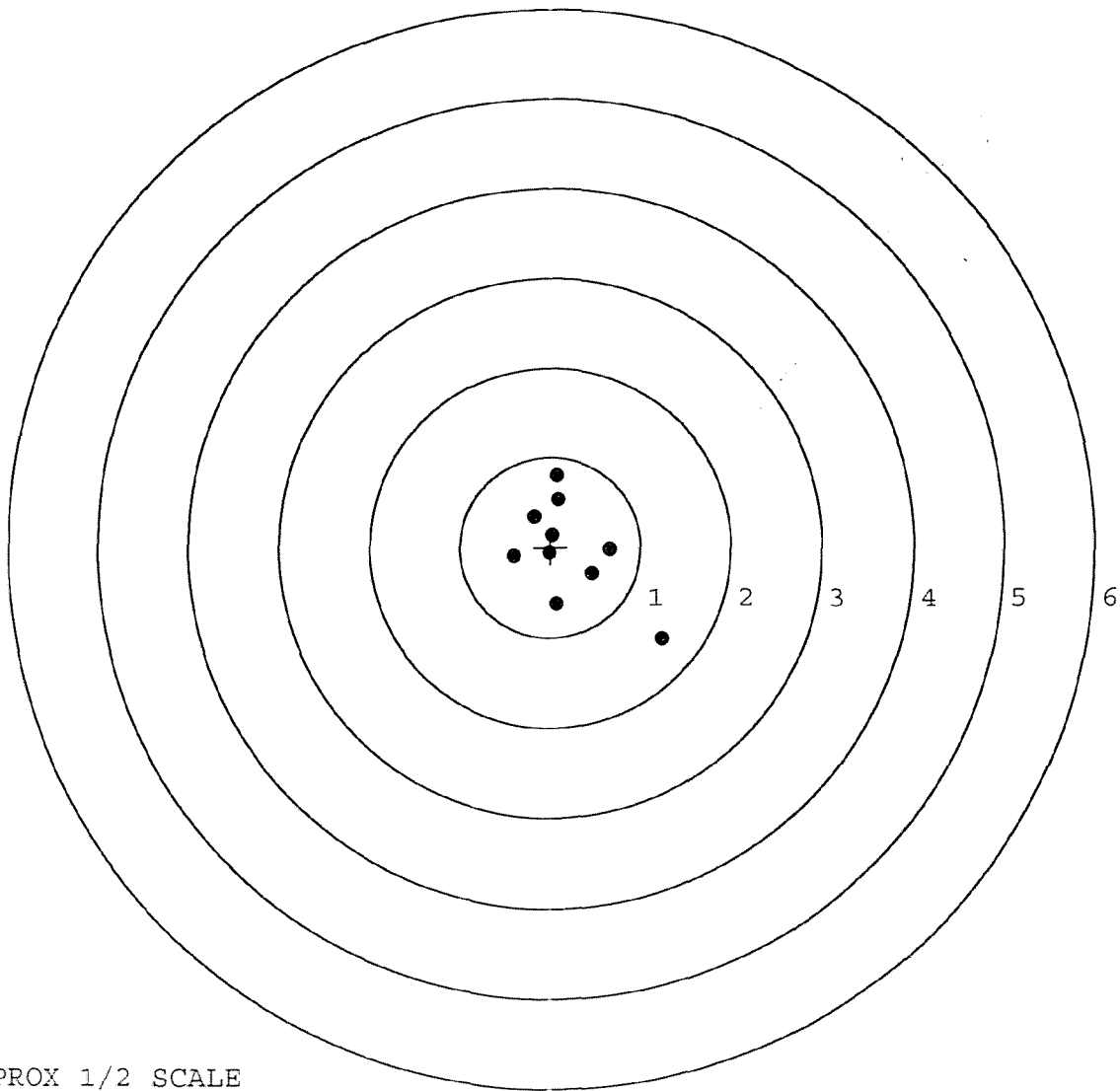


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605353. __0
TARGET NUMBER: 2
FILE DATE: 10/26/2006
FILE TIME: 06:07

X CENTROID: 0.202
Y CENTROID: -0.031
POA TO CENTROID: 0.204
HORZ SPREAD: 1.633
VERT SPREAD: 1.812
GROUP SPREAD: 2.149
MIN RADIUS: 0.222
MAX RADIUS: 1.425
MEAN RADIUS: 0.588
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.232	-1.015
2:	0.069	-0.631
3:	0.463	-0.287
4:	0.662	-0.025
5:	0.077	0.797
6:	0.092	0.528
7:	-0.186	0.345
8:	0.026	0.137
9:	-0.401	-0.097
10:	-0.018	-0.061



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605353. __0

TARGET NUMBER: 3

FILE DATE: 10/26/2006

FILE TIME: 06:07

POINT#	X	Y
1:	1.537	-0.216
2:	0.890	-0.853
3:	0.651	-1.001
4:	-0.572	-0.482
5:	-0.168	0.902
6:	0.059	0.529
7:	0.235	0.009
8:	-0.075	-0.065
9:	-0.422	0.002
10:	-0.074	0.157

X CENTROID: 0.206

Y CENTROID: -0.102

POA TO CENTROID: 0.230

HORZ SPREAD: 2.109

VERT SPREAD: 1.903

GROUP SPREAD: 2.126

MIN RADIUS: 0.115

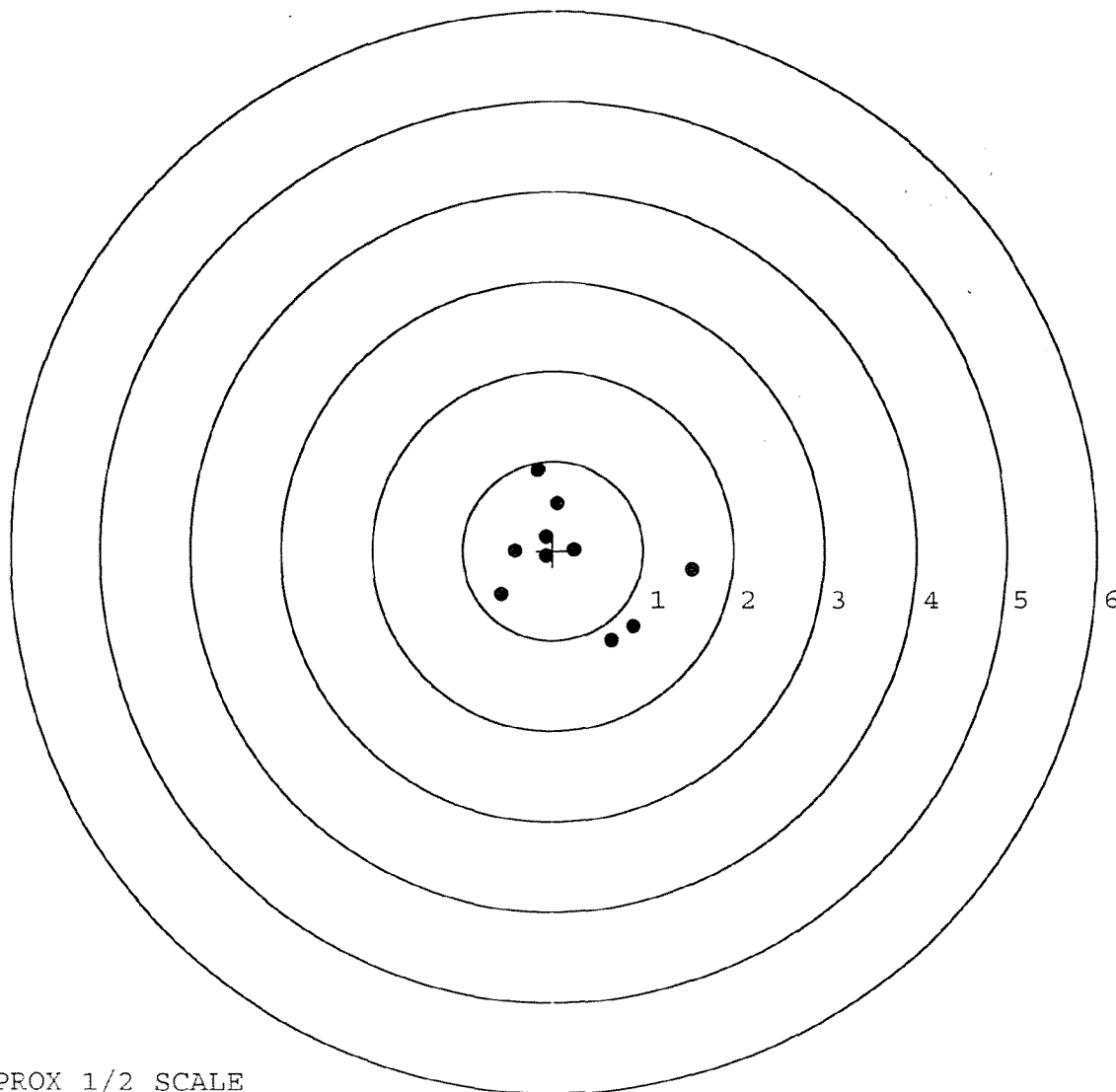
MAX RADIUS: 1.336

MEAN RADIUS: 0.736

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605353. __0

TARGET NUMBER: 4

FILE DATE: 10/26/2006

FILE TIME: 06:07

POINT#	X	Y
1:	-1.099	-0.256
2:	-0.612	-0.638
3:	1.407	-0.410
4:	0.153	-0.742
5:	-0.060	-0.385
6:	0.554	-0.163
7:	0.448	0.520
8:	-0.137	0.423
9:	0.187	0.233
10:	-0.169	1.004

X CENTROID: 0.067

Y CENTROID: -0.041

POA TO CENTROID: 0.079

HORZ SPREAD: 2.506

VERT SPREAD: 1.746

GROUP SPREAD: 2.511

MIN RADIUS: 0.299

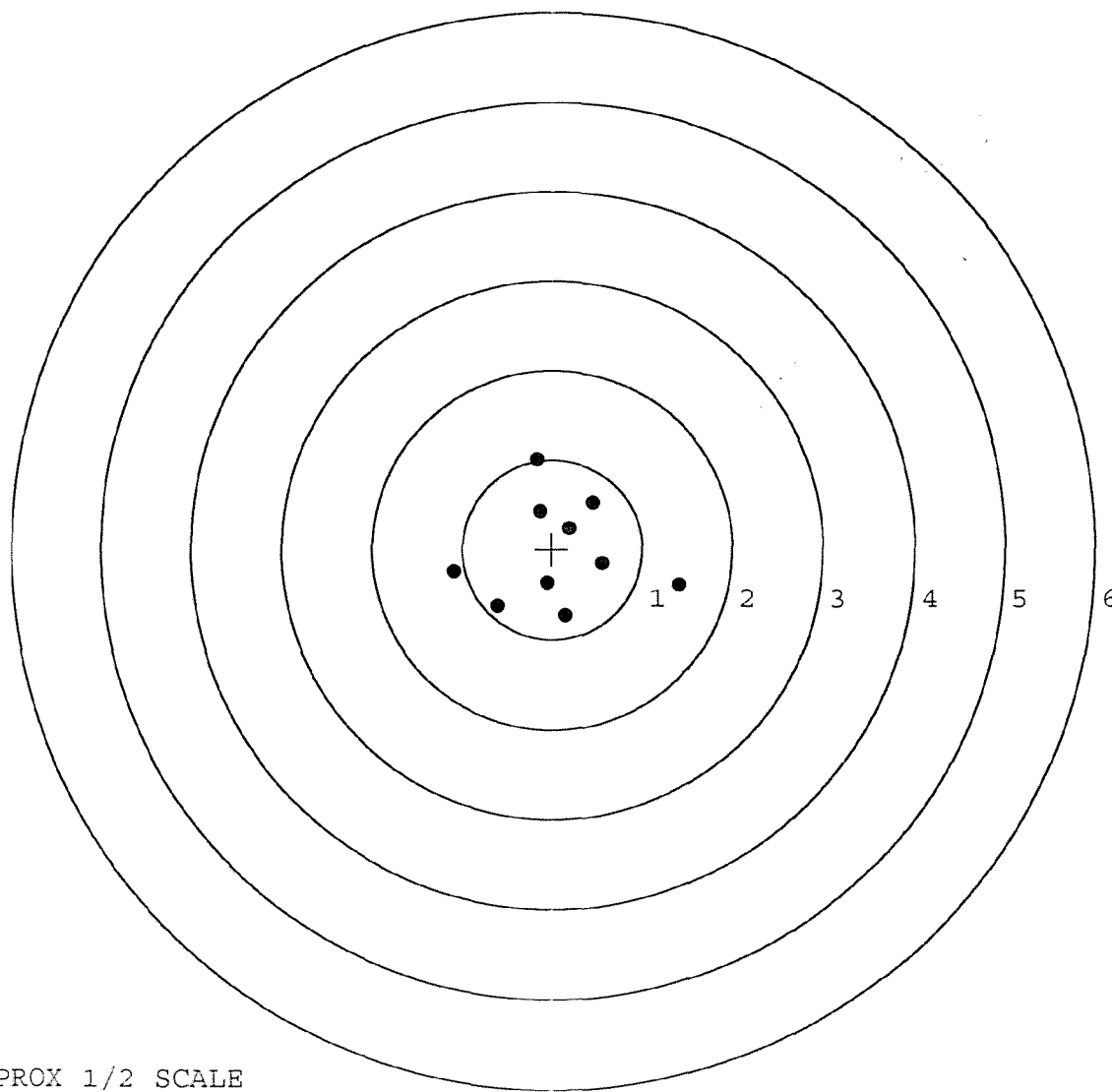
MAX RADIUS: 1.390

MEAN RADIUS: 0.761

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

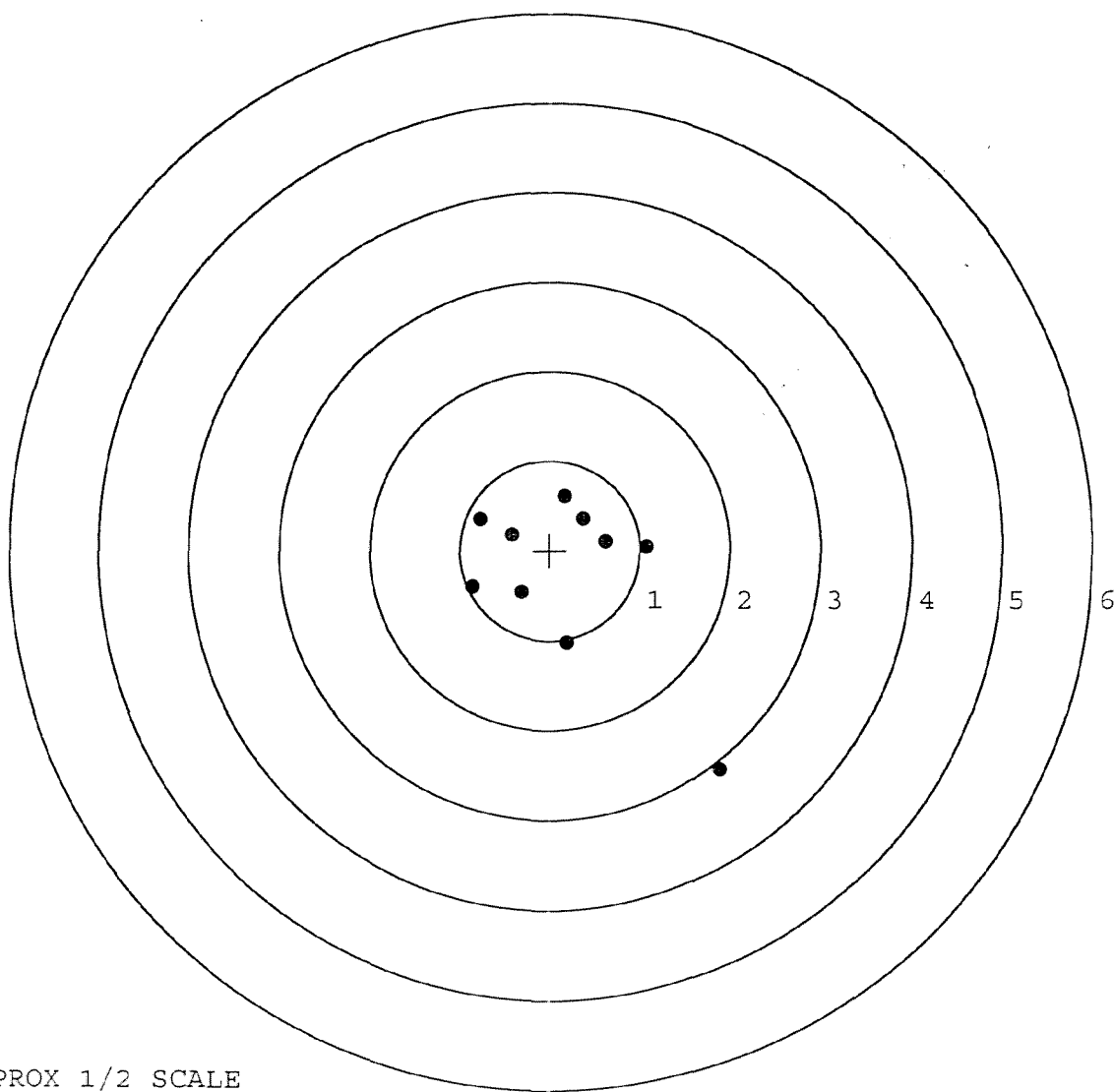


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605353. __0
TARGET NUMBER: 5
FILE DATE: 10/26/2006
FILE TIME: 06:07

POINT#	X	Y
1:	-0.778	0.346
2:	-0.423	0.168
3:	0.171	0.606
4:	0.369	0.347
5:	0.614	0.095
6:	1.068	0.035
7:	-0.857	-0.413
8:	-0.312	-0.472
9:	0.198	-1.030
10:	1.898	-2.446

X CENTROID: 0.195
Y CENTROID: -0.276
POA TO CENTROID: 0.338
HORZ SPREAD: 2.755
VERT SPREAD: 3.052
GROUP SPREAD: 3.867
MIN RADIUS: 0.543
MAX RADIUS: 2.758
MEAN RADIUS: 1.005
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE