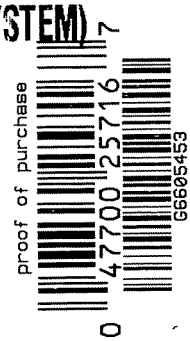
GCCO 5453

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

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

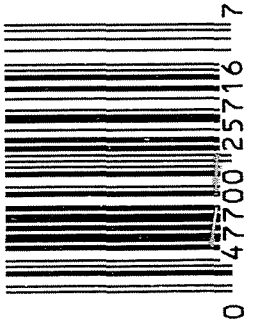
– INSTUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6605453



ORDER 25716

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

UPC

ORDER 25716

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

UPC

SERIAL NO.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6605453

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		10-3-06	SD
430	ASSEMBLE TO STOCK		10-4-06	DK
440	PROOF	MAGNA-FLUX INSPECTED OCT 05 2006	10-4-06	TRW
460	CHECK HEADSPACE		10-4-06	TRW
470	DIS-ASSEMBLE ACTION		10-4-06	SD
480	MAGNAFLUX BBL ACTION	OPERATOR CLD	10-03-06	RPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-6-06	RP
510	DRILL AND TAP SIGHT HOLES		10-4-06	SD
520	GOFF BLAST BBL / REC		10-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/13/06	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-20-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-20-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-20-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-30-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

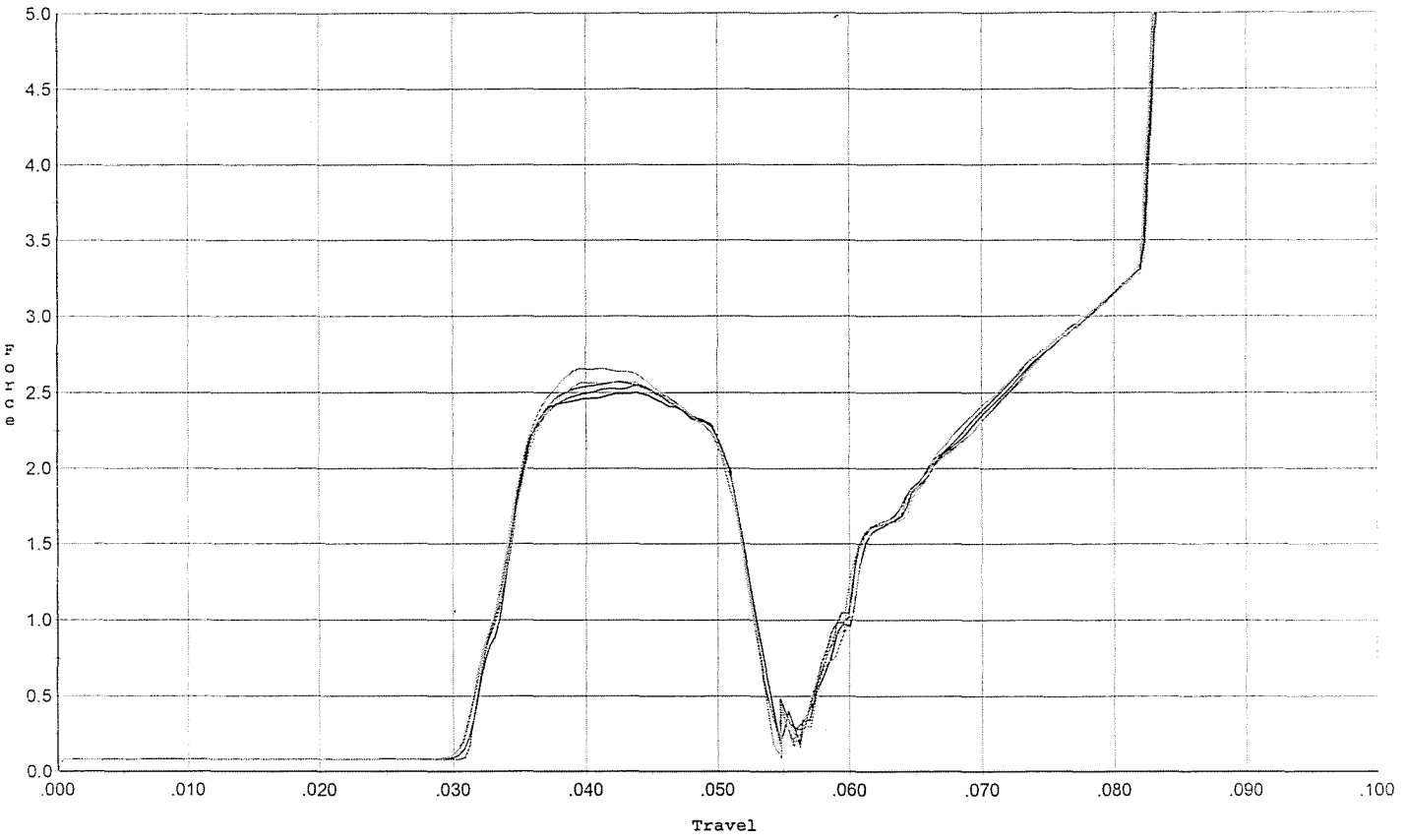
F004 REV 5/2006

560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	7.0	7.0	7.0	11-11-06	L.P.D.
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0	3.0	3.0	11-11-06	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY					[redacted]
	I) FIRING PIN INDENT [.020 MIN]	.0255	.0255	.0255	11-11-06	L.P.D.
	J) ASSEMBLE STOCK				10-30-06	BLC
	K) ASSEMBLE SWIVEL STUDS				11-17-06	BLC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10-30-06	BLC
	M) IRON SIGHT ALIGNMENT				10-30-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10-30-06	BLC
640 &	FUNCTION TEST AND	(PASS)	FAIL			
650	TARGET	(PASS)	FAIL		10/30/06	mom
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION	N/A			
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
660	INSPECT FOR LIVE AMMO				10-30-06	SD
670	FINAL INSPECTION A) HEADSPACE				11-17-06	BLC
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.65	2.47	2.49	2.53 2.48	11/10/06	mom
	C) FUNCTION				11-17-06	BLC
690	PACK				11-17-06	[redacted]

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs ini.
Note:	R. Putch 10/23/06		



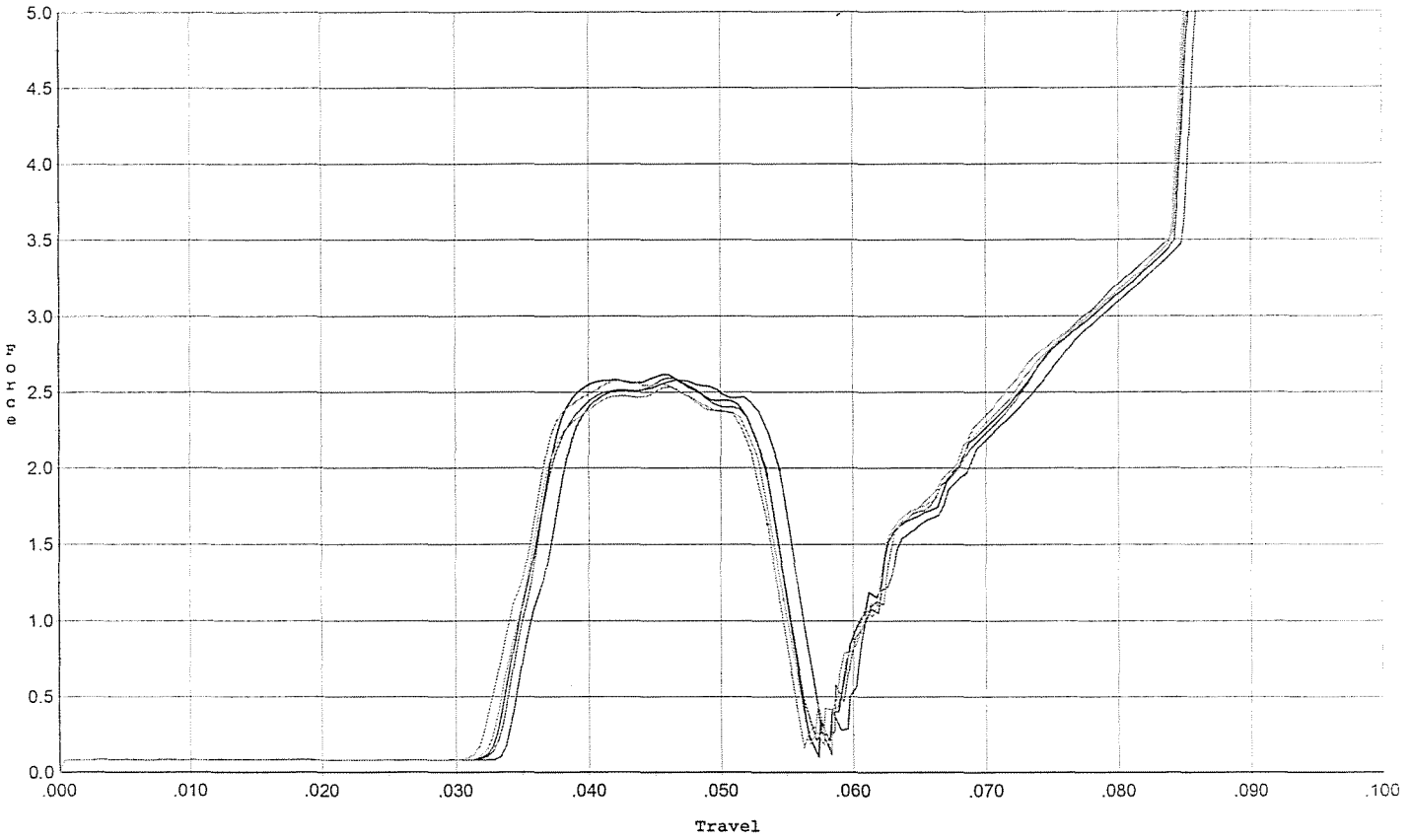
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.547	0.051	0.031	0.036	0.046		Set Trigger
2	2.499	0.051	0.031	0.036	0.045		Set Trigger
3	2.566	0.051	0.031	0.036	0.046		Set Trigger
4	2.572	0.051	0.031	0.036	0.046		Set Trigger
5	2.654	0.051	0.031	0.036	0.047		Set Trigger

AVG 2.56

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 11:24:43 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs after 50 cycles
Note:	R. Putch 10/23/06		

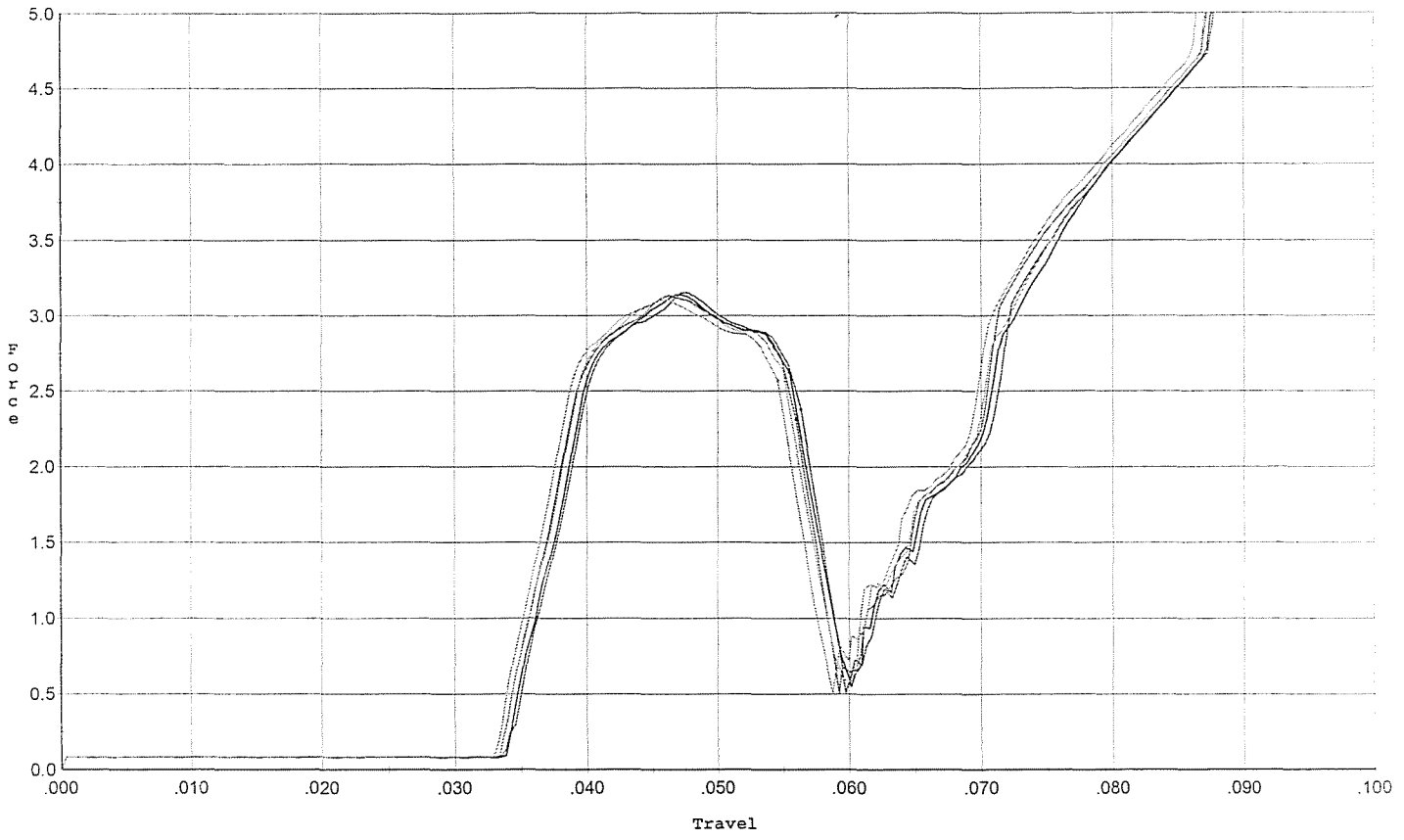


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.580	0.054	0.034	0.037	0.048		Set Trigger
2	2.617	0.054	0.033	0.036	0.049		Set Trigger
3	2.593	0.053	0.033	0.036	0.047		Set Trigger
4	2.536	0.055	0.033	0.036	0.048		Set Trigger
5	2.578	0.054	0.032	0.036	0.048		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini.
Note:	R. Putch 10/23/06		



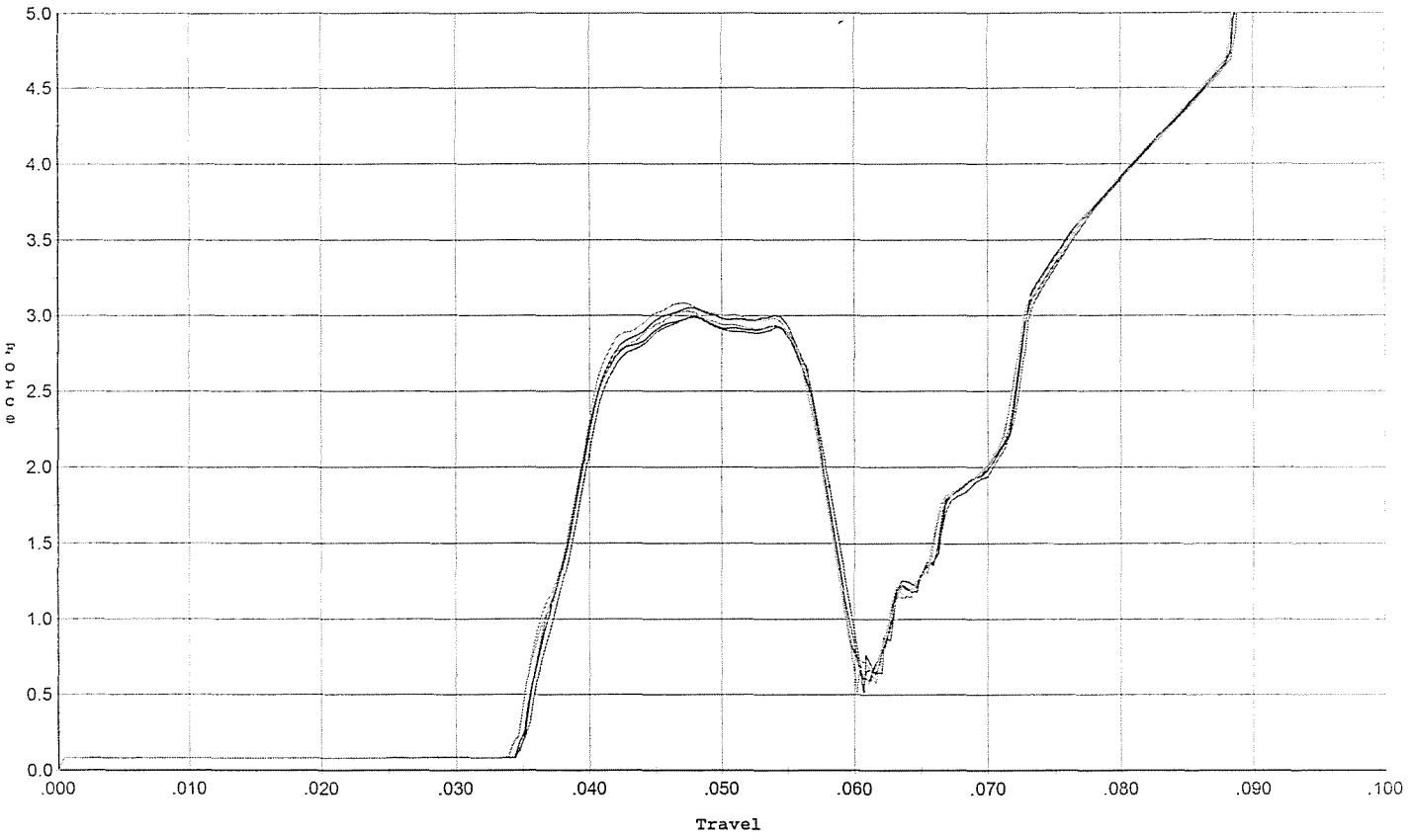
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.155	0.056	0.034	0.036	0.059		Set Trigger
2	3.139	0.056	0.034	0.036	0.058		Set Trigger
3	3.131	0.056	0.034	0.036	0.060		Set Trigger
4	3.139	0.055	0.034	0.036	0.058		Set Trigger
5	3.109	0.055	0.033	0.036	0.058		Set Trigger

Avg 3.13

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 11:33:28 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles
Note:	R. Putch 10/23/06		



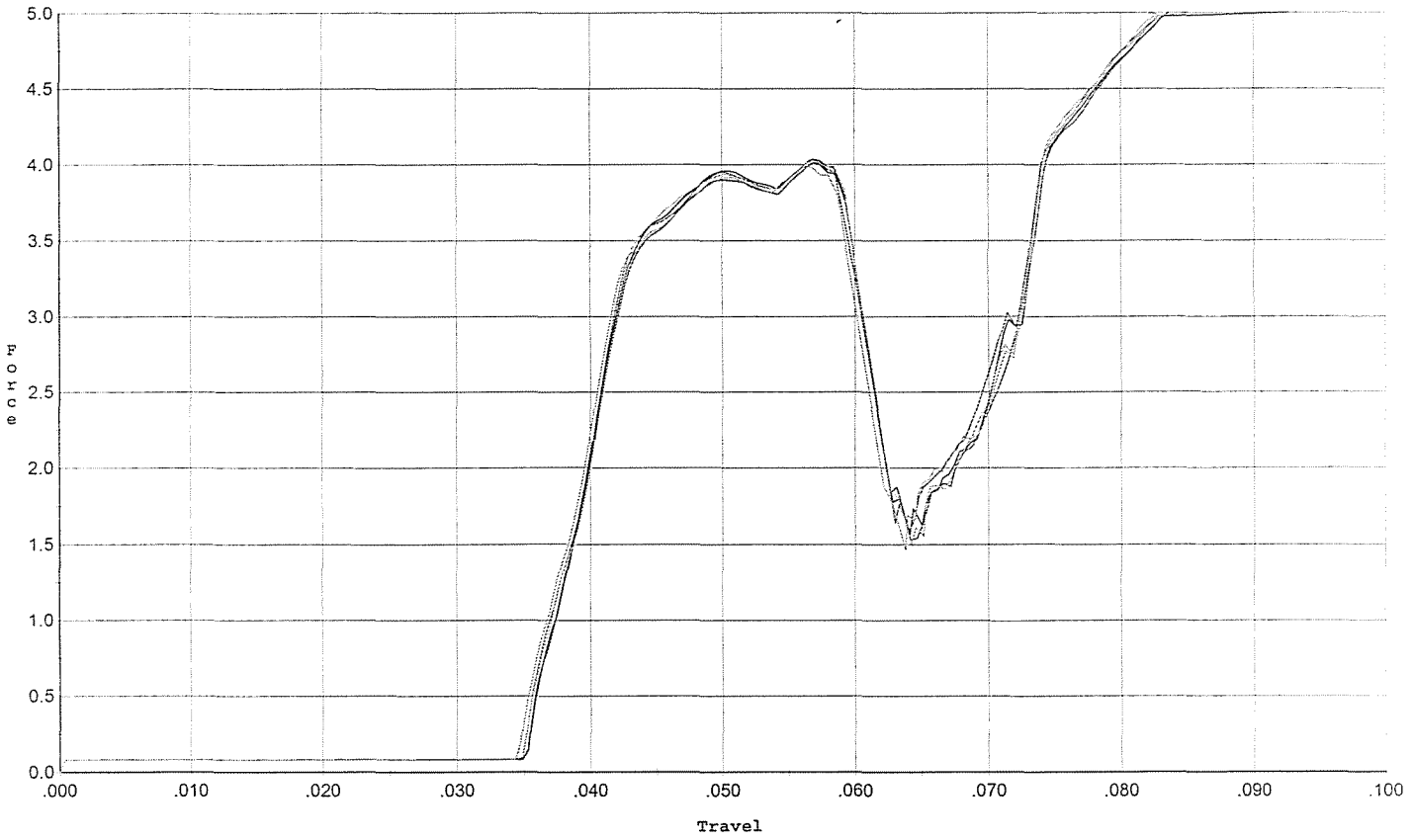
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.052	0.056	0.035	0.037	0.059		Set Trigger
2	2.998	0.057	0.035	0.037	0.058		Set Trigger
3	2.991	0.058	0.035	0.037	0.059		Set Trigger
4	3.082	0.057	0.034	0.036	0.060		Set Trigger
5	3.029	0.057	0.034	0.036	0.058		Set Trigger

AVG 3.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 11:35:28 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	R. Putch 10/23/06		

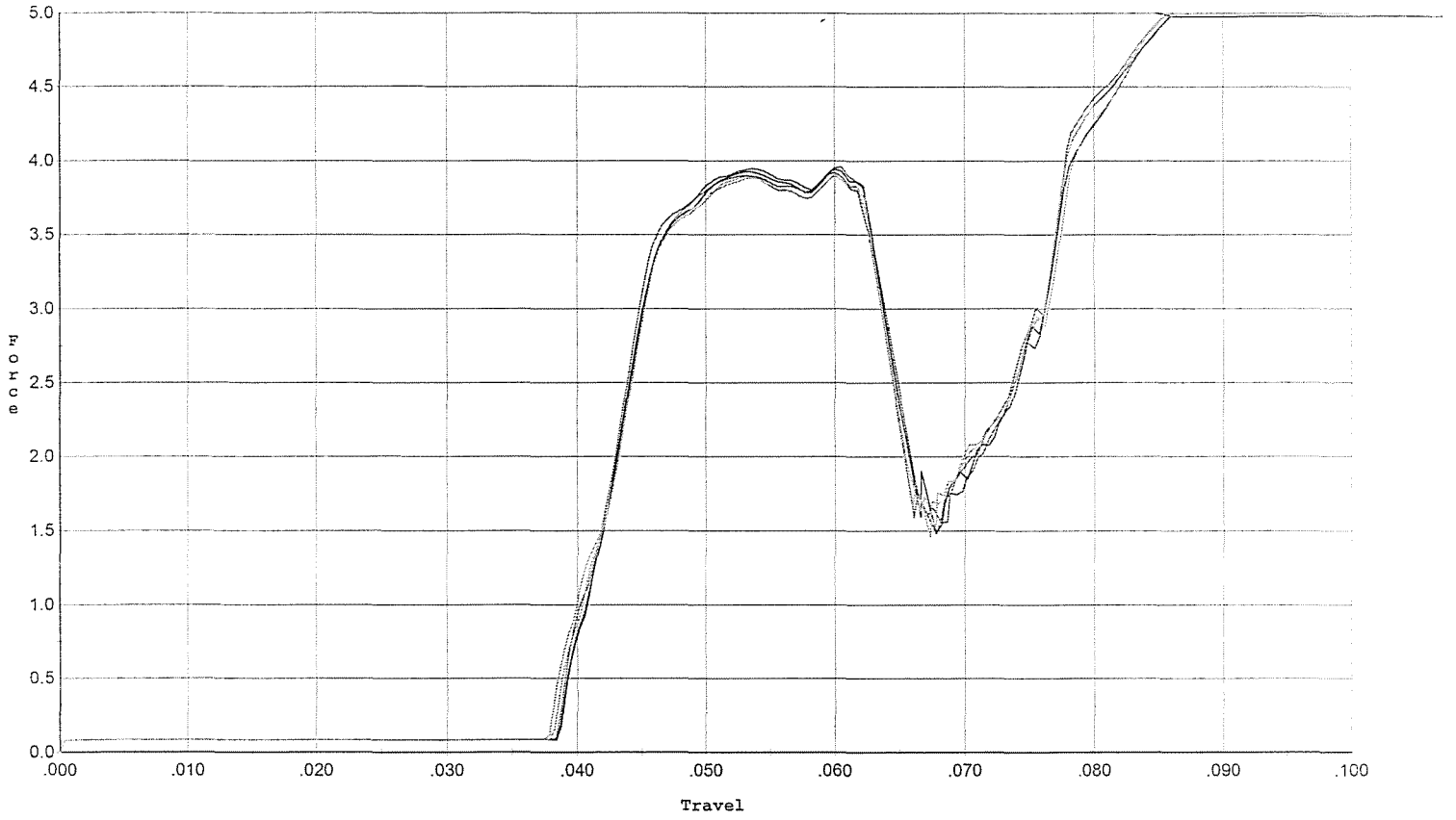


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.012	0.059	0.035	0.034	0.082		Set Trigger
2	4.036	0.059	0.035	0.034	0.083		Set Trigger
3	4.028	0.060	0.035	0.034	0.084		Set Trigger
4	4.030	0.059	0.035	0.034	0.082		Set Trigger
5	3.991	0.059	0.035	0.034	0.082		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles
Note:	R. Putch 10/23/06		



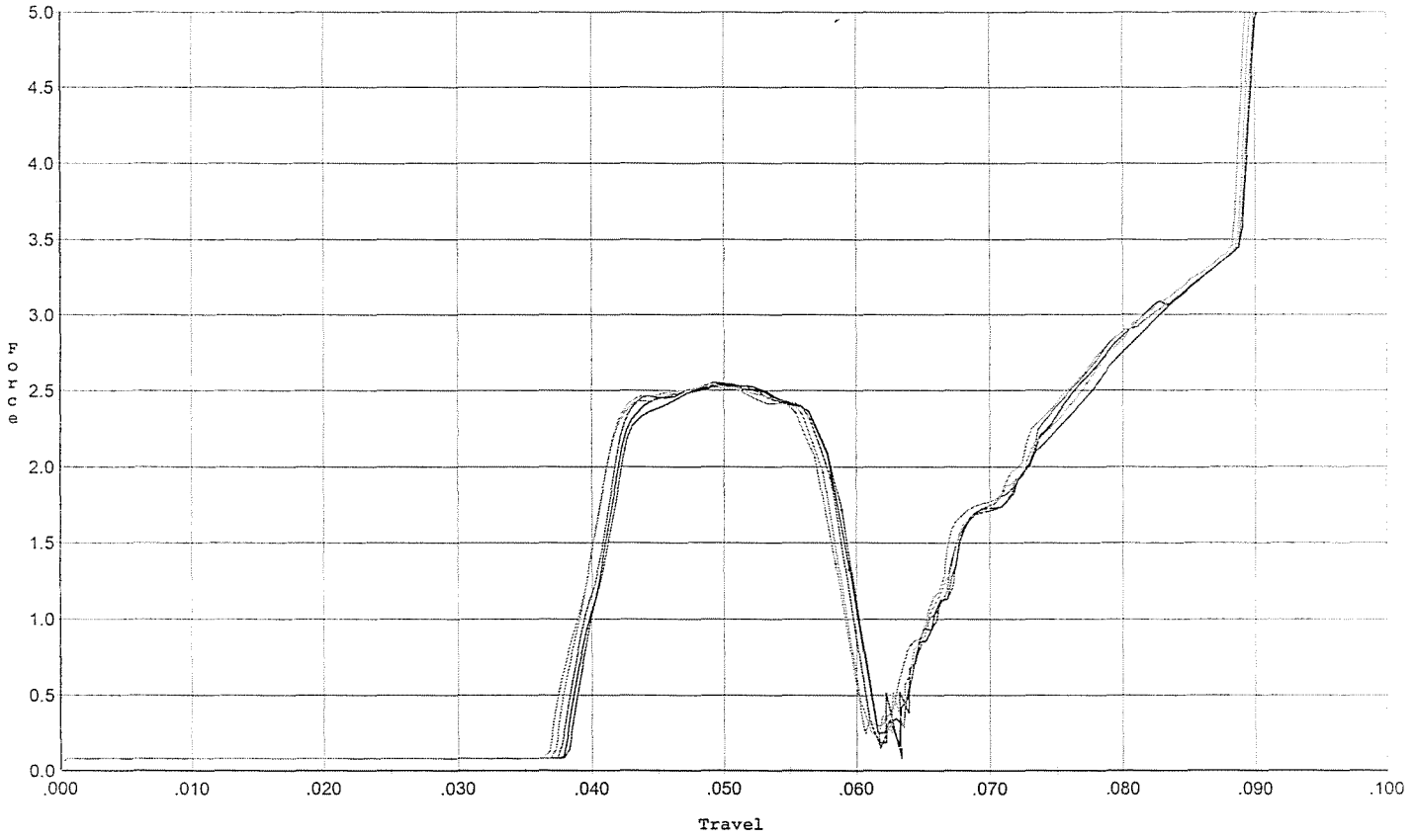
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.960	0.064	0.039	0.034	0.085		Set Trigger
2	3.944	0.062	0.039	0.034	0.082		Set Trigger
3	3.923	0.063	0.039	0.034	0.083		Set Trigger
4	3.899	0.062	0.038	0.034	0.082		Set Trigger
5	3.904	0.062	0.038	0.034	0.082		Set Trigger

Avg 3.92

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 11:41:15 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 for final test
Note:	R. Putch 10/23/06		



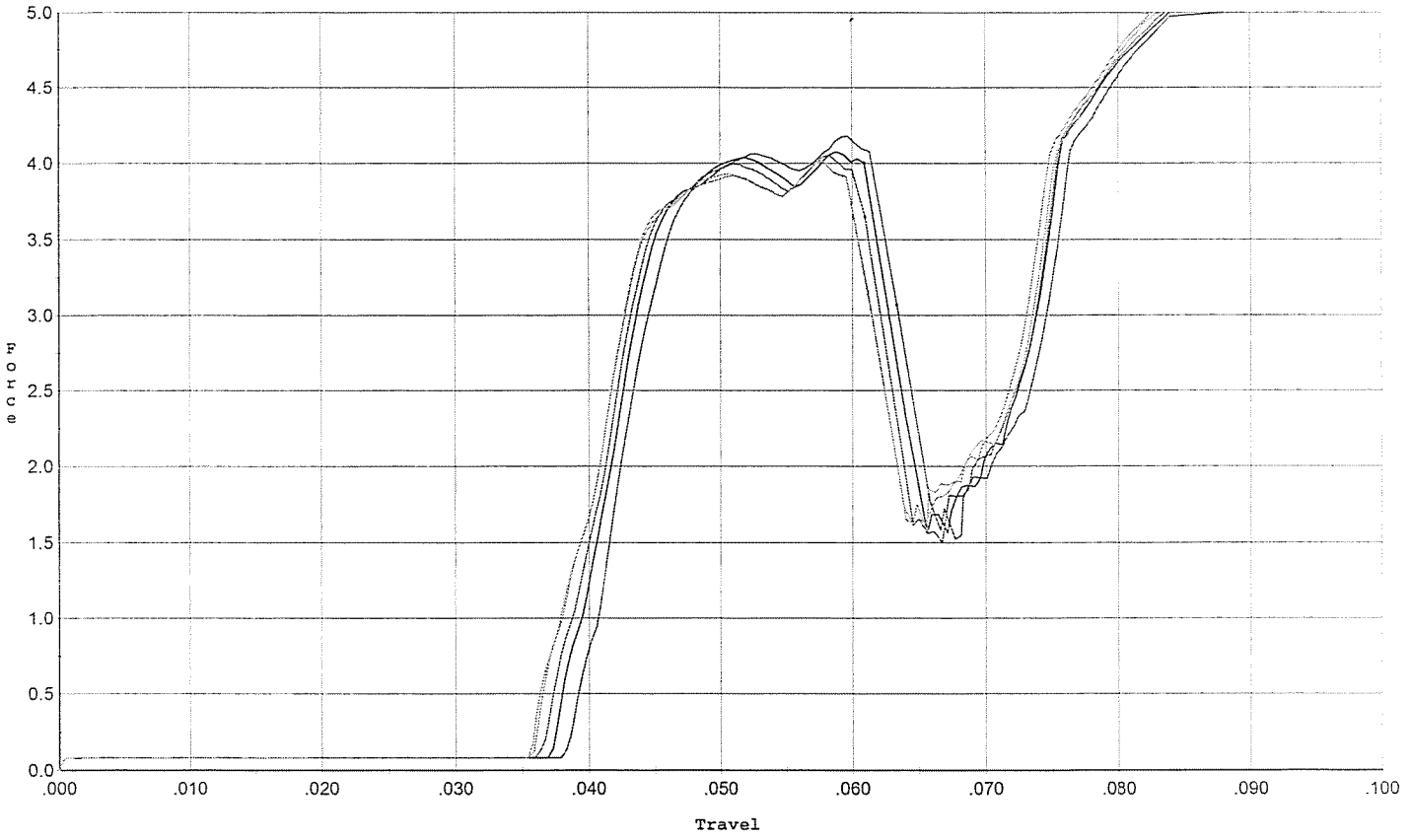
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.059	0.038	0.038	0.048		Set Trigger
2	2.543	0.059	0.038	0.038	0.049		Set Trigger
3	2.553	0.058	0.038	0.038	0.048		Set Trigger
4	2.540	0.058	0.037	0.038	0.048		Set Trigger
5	2.525	0.058	0.037	0.038	0.048		Set Trigger

Avg 2.53

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 11:43:35 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 for target & accuracy
Note:	R. Putch 10/23/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.178	0.063	0.039	0.033	0.087		Set Trigger
2	4.076	0.061	0.037	0.033	0.084		Set Trigger
3	4.053	0.061	0.037	0.033	0.085		Set Trigger
4	4.009	0.061	0.036	0.033	0.085		Set Trigger
5	4.014	0.061	0.036	0.033	0.085		Set Trigger

Avg 4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605453.__0
FILE DATE AND TIME: 10/31/2006 06:04

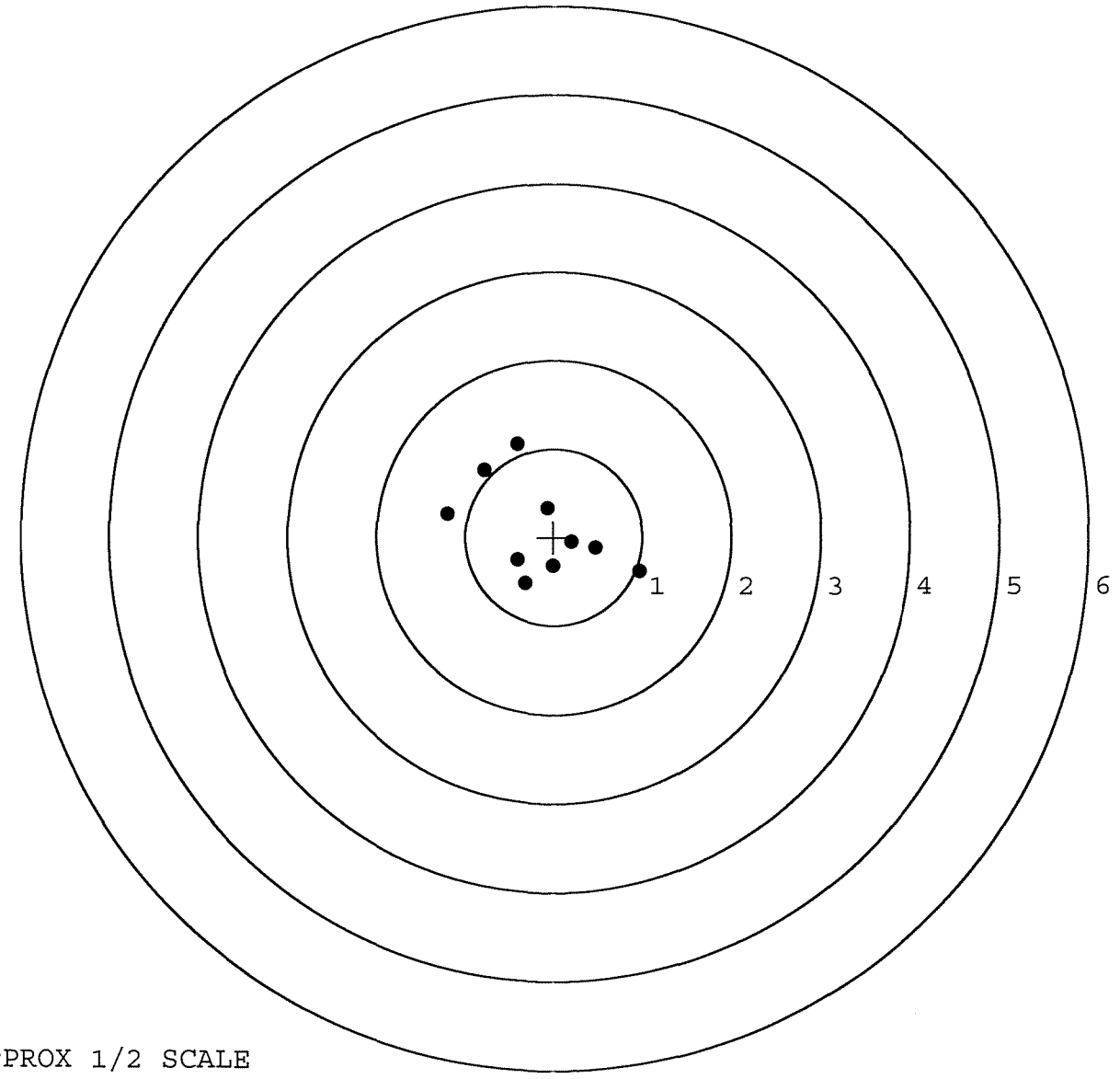
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.017
The Average Y Centroid of the Five Target Set:	0.038
The Average Point of Impact of the Five Target Set:	0.041
The Average Mean Radius of the Five Target Set:	0.714
The Distance from POA to Centroid Target #1:	0.173
The Distance from Centroid Target #2 to Centroid Target #1:	0.167
The Distance from Centroid Target #3 to Centroid Target #1:	0.264
The Distance from Centroid Target #4 to Centroid Target #1:	0.200
The Distance from Centroid Target #5 to Centroid Target #1:	0.165

SERIAL NUMBER: G6605453.__0
TARGET NUMBER: 1
FILE DATE: 10/31/2006
FILE TIME: 06:04

X CENTROID:	-0.158
Y CENTROID:	0.070
POA TO CENTROID:	0.173
HORZ SPREAD:	2.169
VERT SPREAD:	1.578
GROUP SPREAD:	2.265
MIN RADIUS:	0.271
MAX RADIUS:	1.216
MEAN RADIUS:	0.701
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.419	1.050
2:	-0.793	0.756
3:	-1.202	0.262
4:	-0.078	0.329
5:	0.967	-0.391
6:	0.480	-0.126
7:	0.206	-0.058
8:	-0.010	-0.327
9:	-0.321	-0.528
10:	-0.408	-0.262

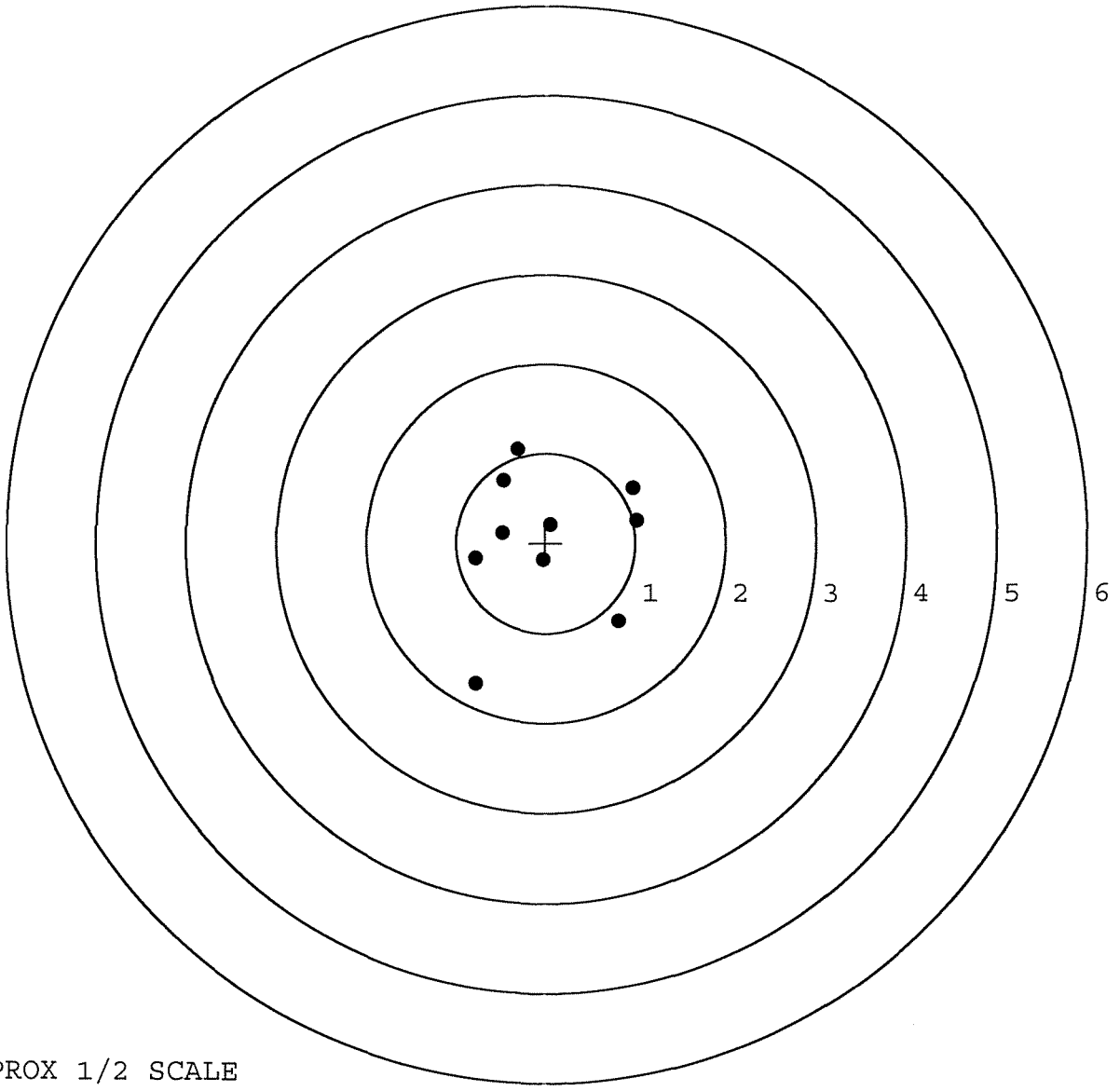


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605453.__0
TARGET NUMBER: 2
FILE DATE: 10/31/2006
FILE TIME: 06:04

X CENTROID:	-0.002
Y CENTROID:	0.009
POA TO CENTROID:	0.010
HORZ SPREAD:	1.792
VERT SPREAD:	2.615
GROUP SPREAD:	2.797
MIN RADIUS:	0.202
MAX RADIUS:	1.762
MEAN RADIUS:	0.876
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.779	-1.572
2:	0.815	-0.868
3:	0.973	0.608
4:	1.007	0.253
5:	-0.030	-0.193
6:	0.059	0.202
7:	-0.485	0.107
8:	-0.785	-0.177
9:	-0.316	1.043
10:	-0.480	0.692

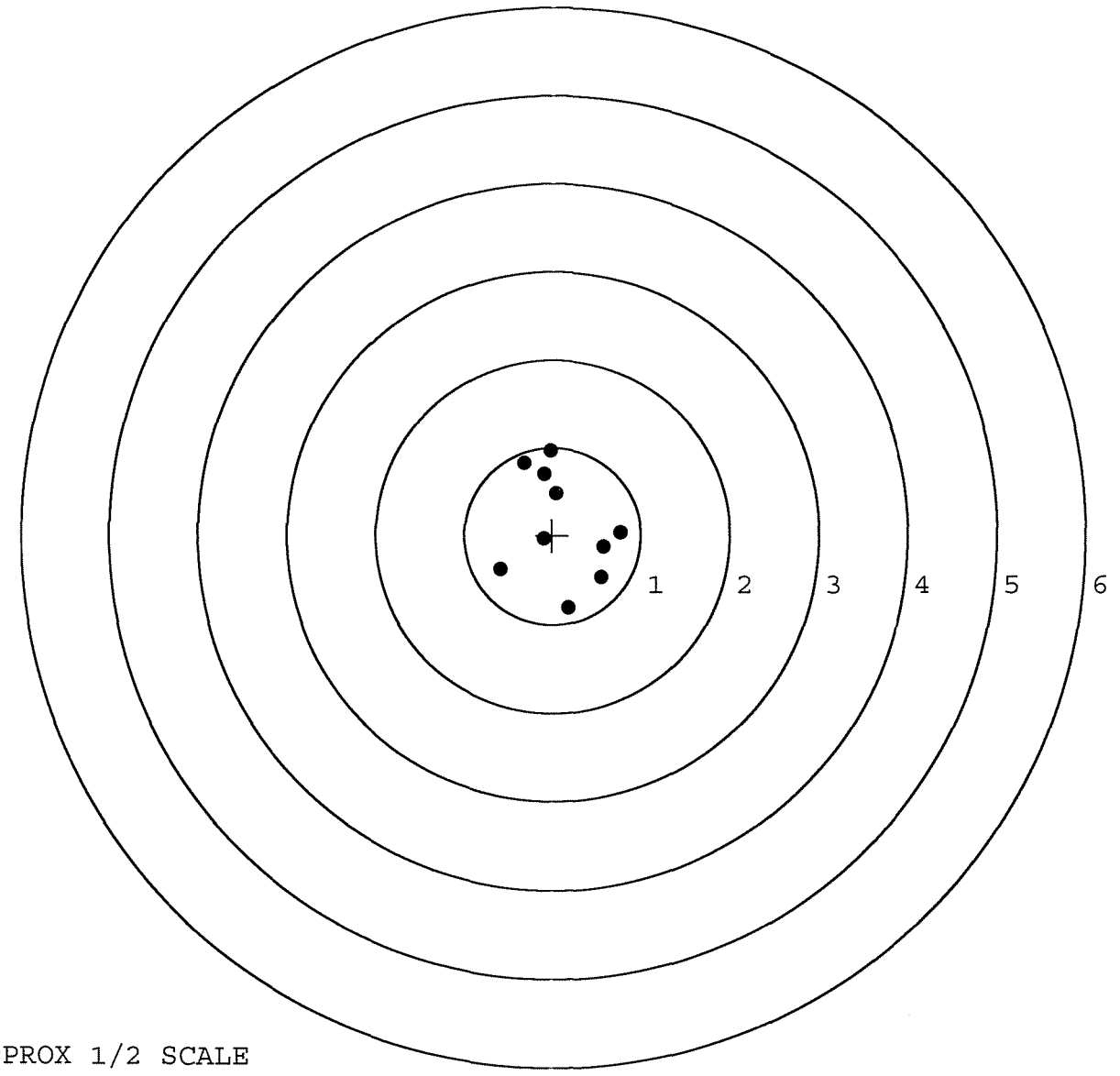


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605453.__0
TARGET NUMBER: 3
FILE DATE: 10/31/2006
FILE TIME: 06:04

X CENTROID:	0.103
Y CENTROID:	0.115
POA TO CENTROID:	0.154
HORZ SPREAD:	1.366
VERT SPREAD:	1.783
GROUP SPREAD:	1.795
MIN RADIUS:	0.255
MAX RADIUS:	0.938
MEAN RADIUS:	0.667
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.186	-0.819
2:	0.559	-0.471
3:	0.580	-0.129
4:	0.779	0.035
5:	-0.096	-0.044
6:	-0.587	-0.380
7:	-0.321	0.822
8:	-0.024	0.964
9:	0.045	0.478
10:	-0.095	0.698

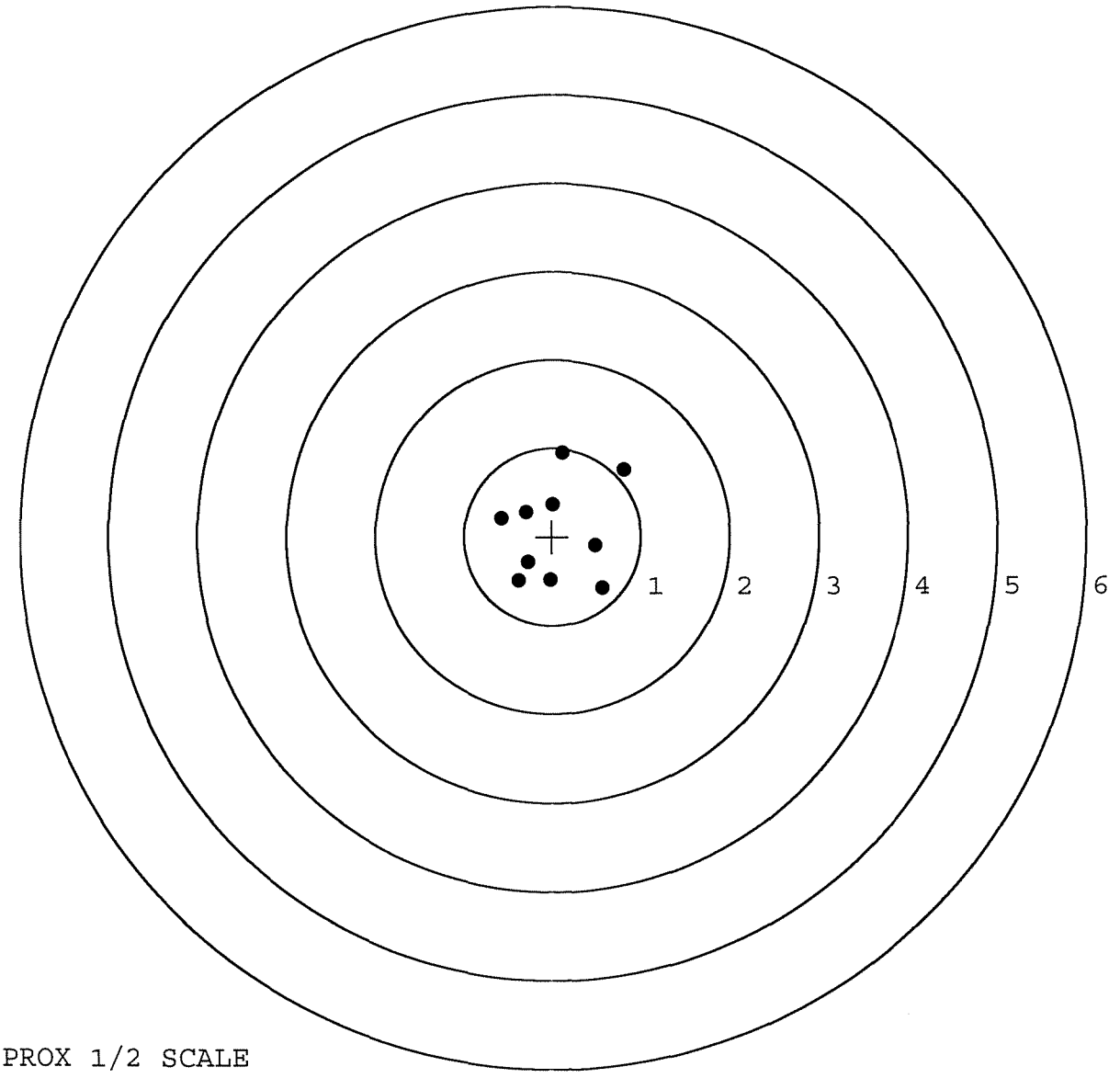


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605453.__0
TARGET NUMBER: 4
FILE DATE: 10/31/2006
FILE TIME: 06:04

X CENTROID:	0.041
Y CENTROID:	0.059
POA TO CENTROID:	0.072
HORZ SPREAD:	1.396
VERT SPREAD:	1.520
GROUP SPREAD:	1.728
MIN RADIUS:	0.304
MAX RADIUS:	1.038
MEAN RADIUS:	0.631
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.119	0.941
2:	0.810	0.757
3:	0.569	-0.579
4:	0.490	-0.096
5:	0.001	0.361
6:	-0.306	0.274
7:	-0.586	0.212
8:	-0.023	-0.491
9:	-0.381	-0.495
10:	-0.279	-0.290

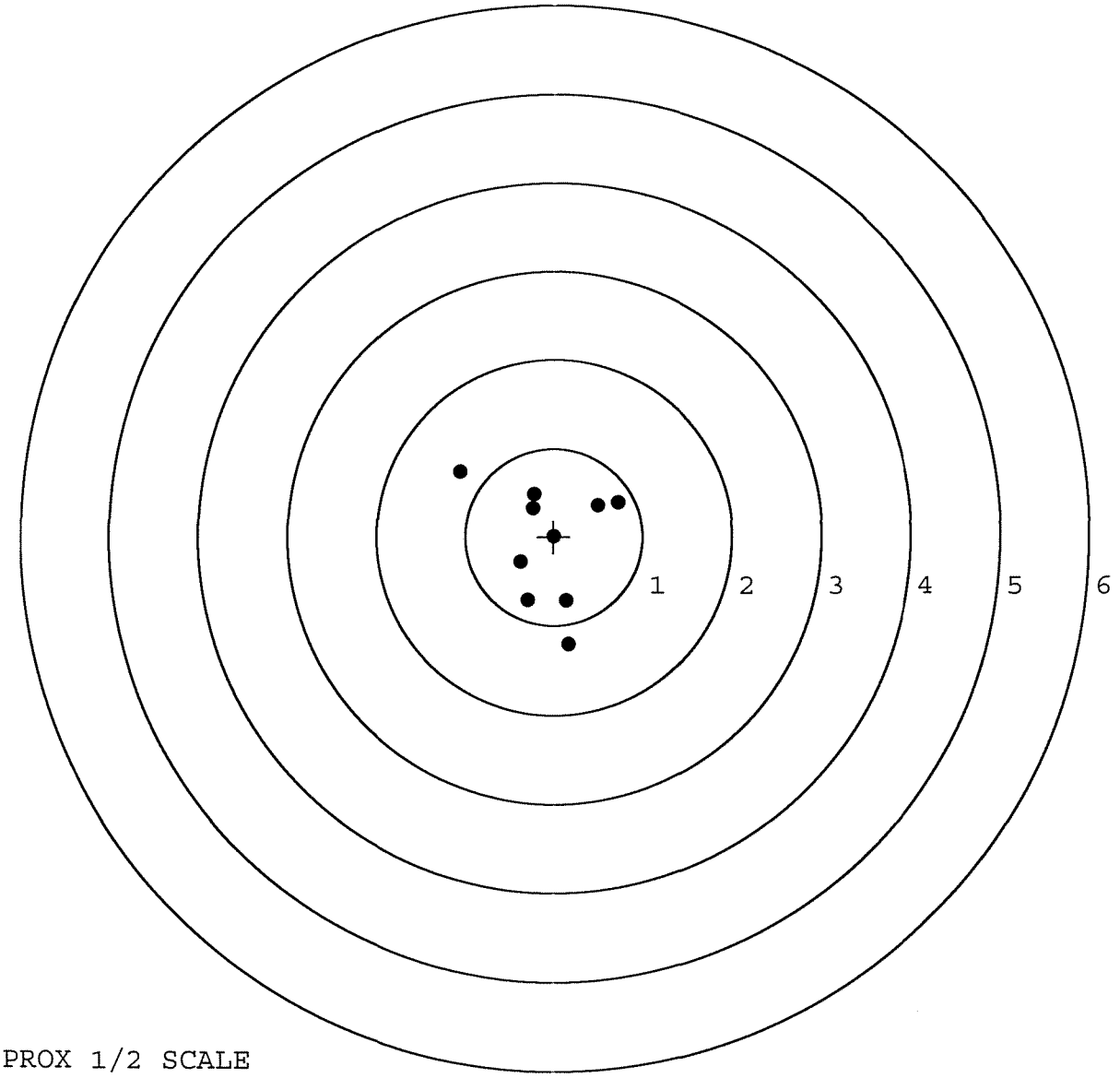


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605453.__0
TARGET NUMBER: 5
FILE DATE: 10/31/2006
FILE TIME: 06:04

X CENTROID:	-0.068
Y CENTROID:	-0.067
POA TO CENTROID:	0.095
HORZ SPREAD:	1.787
VERT SPREAD:	1.950
GROUP SPREAD:	2.307
MIN RADIUS:	0.098
MAX RADIUS:	1.278
MEAN RADIUS:	0.695
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.170	-1.215
2:	0.143	-0.730
3:	-0.299	-0.726
4:	-0.377	-0.293
5:	-0.002	0.005
6:	-1.063	0.735
7:	-0.240	0.320
8:	0.724	0.392
9:	0.498	0.355
10:	-0.232	0.485



TARGET APPROX 1/2 SCALE