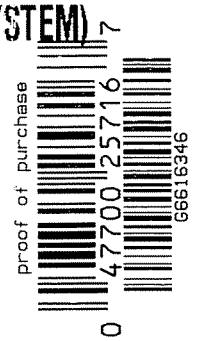
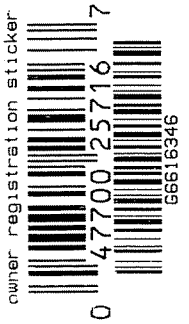
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

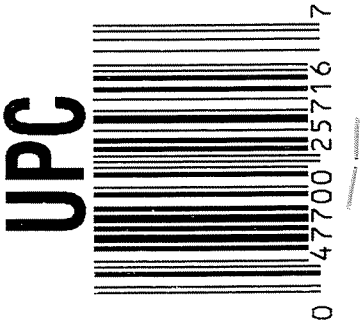
DD FORM





ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6616346



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYST
UPC

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYST
UPC

SERIAL NO.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6616346

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-23-06	RTL
420	ASSEMBLE ACTION		10-23-06	RTL
430	ASSEMBLE TO STOCK		11-21-06	SD
440	PROOF		11-21-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED NOV 29 2006	11-21-06	SD
470	DIS-ASSEMBLE ACTION		11-27-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR	11/29/06	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		11-29-06	CW
510	DRILL AND TAP SIGHT HOLES		11-28-06	SD
520	GOFF BLAST BBL / REC		11/29/06	
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/6/06	
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		12-12-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-12-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-12-06	SD
	D) OIL FIRING PIN ASSEMBLY		12-12-06	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

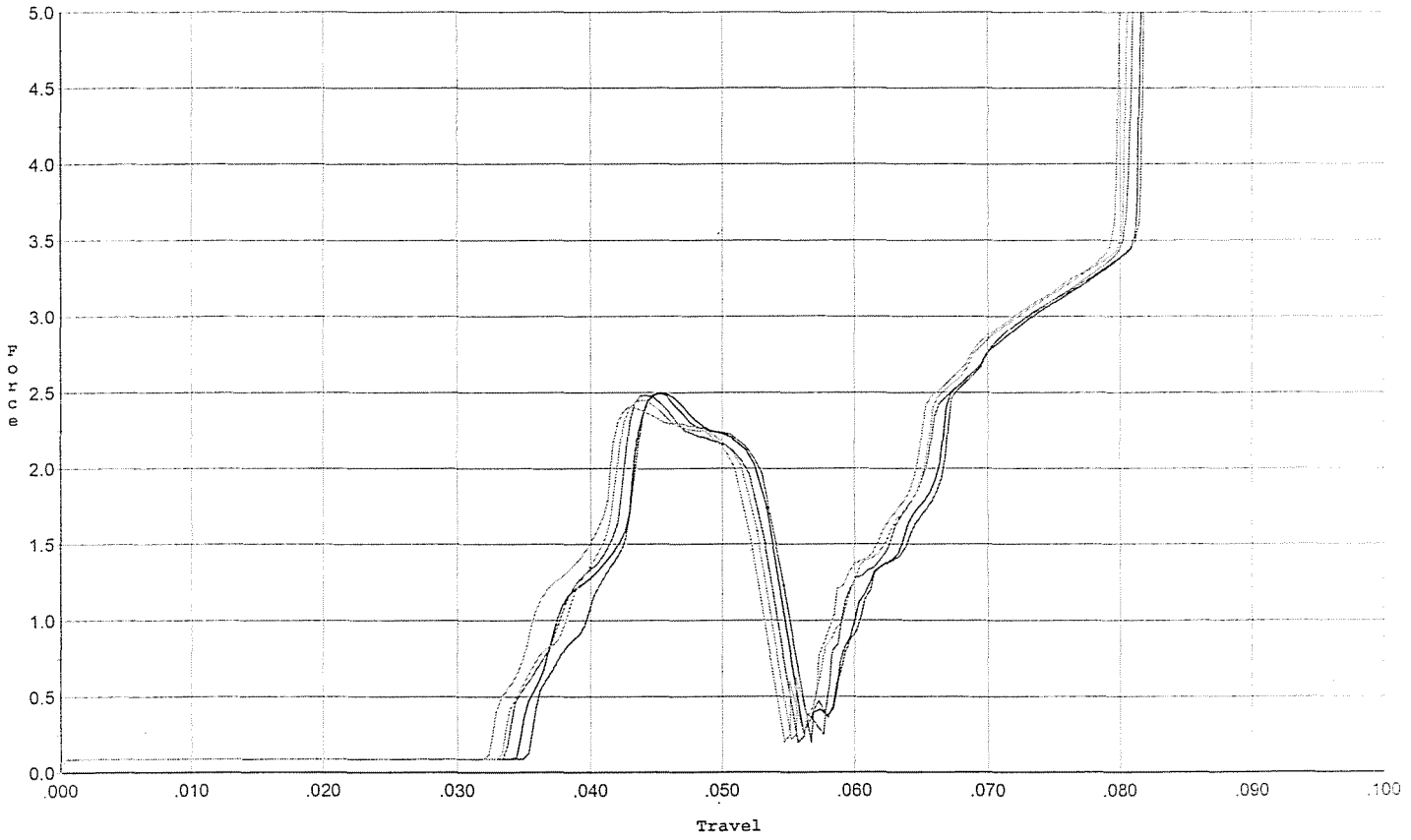
F004 REV 5/2006

560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	4# 3# 4#	12-14-06	SD
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	5# 5# 5#	12-14-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.025 .025 .025	12-14-06	SD
	J) ASSEMBLE STOCK		12-12-06	[illegible]
	K) ASSEMBLE SWIVEL STUDS		12-18-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-18-06	BLG
	M) IRON SIGHT ALIGNMENT		12-18-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-18-06	BLG
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL (PASS) FAIL	12-13-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-13-06	RP
670	FINAL INSPECTION A) HEADSPACE		12-18-06	BLG
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.67 2.72 2.87 2.69 2.68	12-14-06	BLG
	C) FUNCTION		12-18-06	BLG
690	PACK		2-7-07	DA

N/A

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 12/8/06		

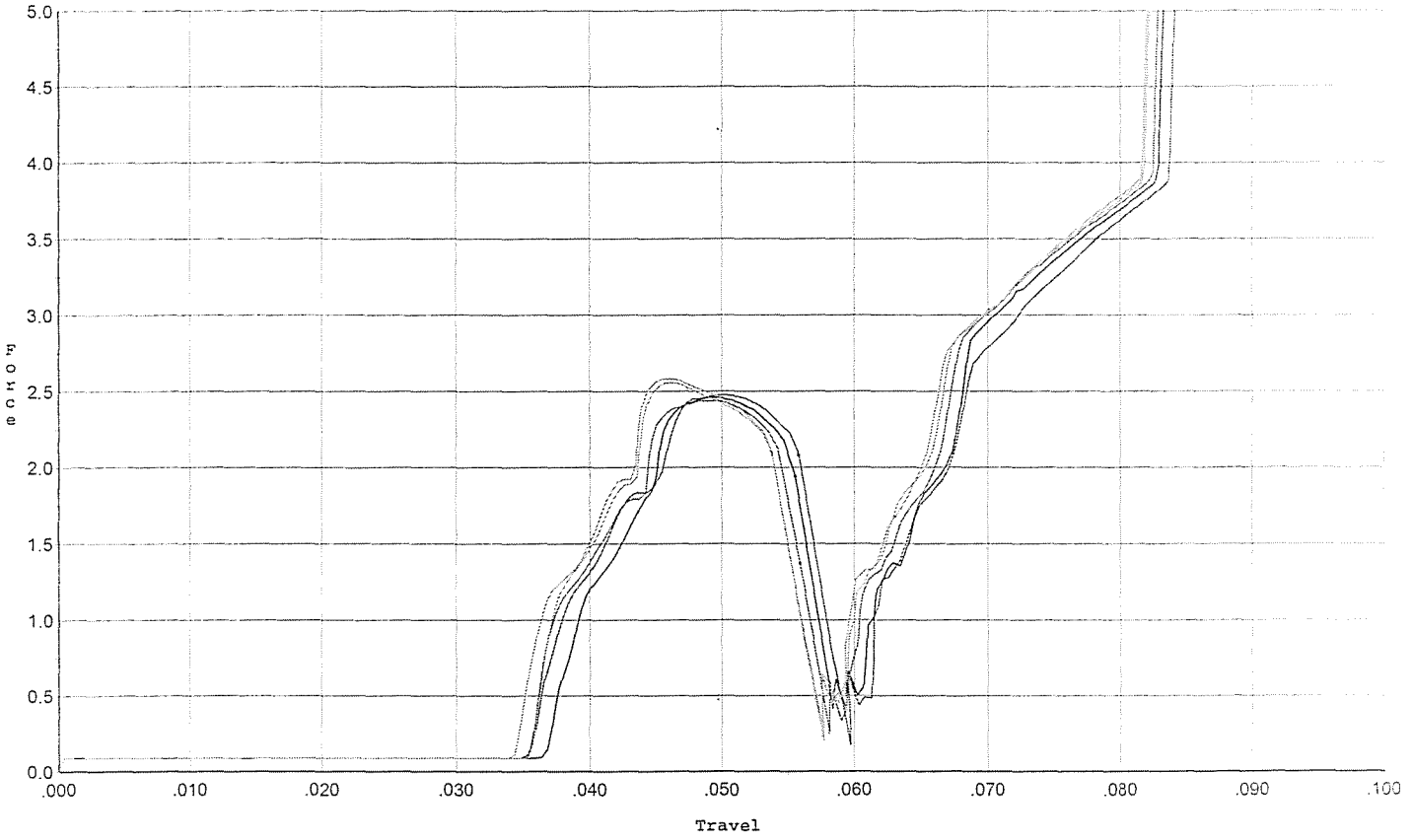


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.055	0.036	0.035	0.036		Set Trigger
2	2.493	0.053	0.035	0.035	0.036		Set Trigger
3	2.482	0.053	0.034	0.034	0.036		Set Trigger
4	2.449	0.053	0.034	0.035	0.036		Set Trigger
5	2.406	0.052	0.033	0.034	0.037		Set Trigger

Avg 2.46

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 12/8/06		

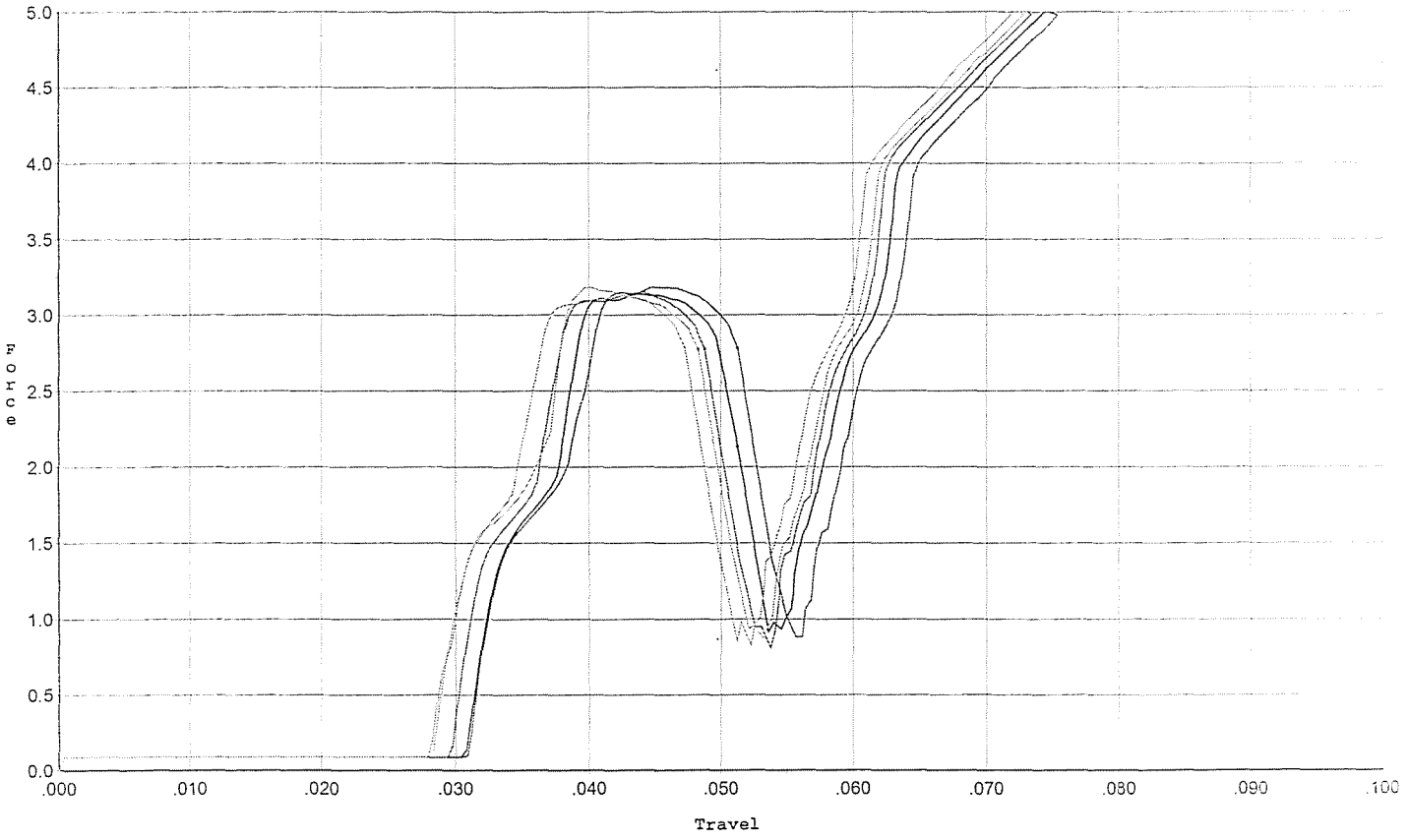


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.476	0.056	0.036	0.035	0.042		Set Trigger
2	2.460	0.056	0.037	0.035	0.039		Set Trigger
3	2.439	0.056	0.036	0.035	0.041		Set Trigger
4	2.556	0.054	0.036	0.035	0.040		Set Trigger
5	2.583	0.054	0.035	0.035	0.042		Set Trigger

Avg 2.50

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 12/8/06		

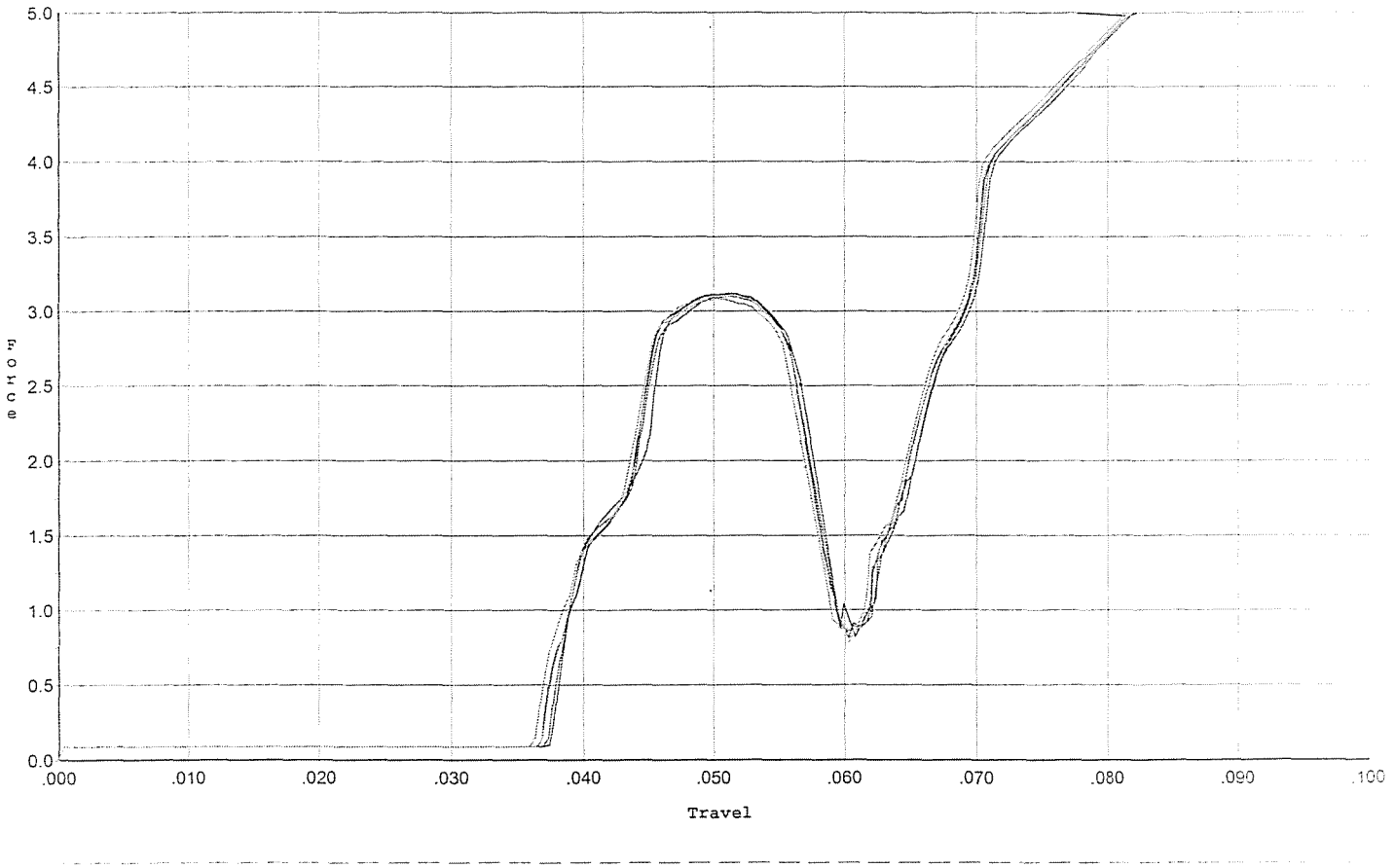


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.183	0.051	0.031	0.032	0.054		Set Trigger
2	3.139	0.051	0.031	0.032	0.053		Set Trigger
3	3.150	0.049	0.030	0.031	0.051		Set Trigger
4	3.184	0.048	0.029	0.031	0.052		Set Trigger
5	3.132	0.047	0.028	0.031	0.050		Set Trigger

Avg 3.15

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 12/8/06		

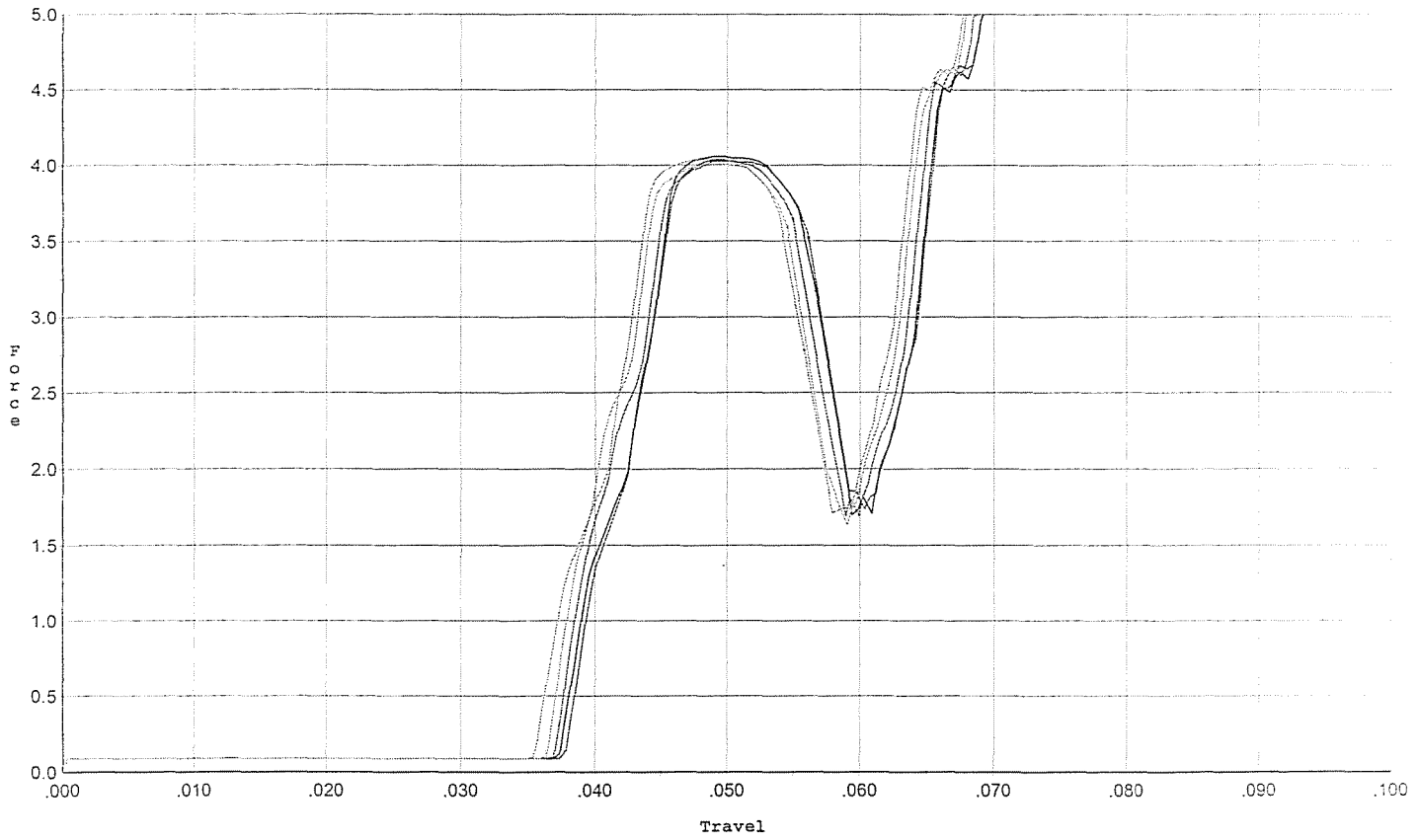


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.115	0.057	0.038	0.034	0.051		Set Trigger
2	3.119	0.056	0.037	0.034	0.050		Set Trigger
3	3.101	0.056	0.037	0.034	0.049		Set Trigger
4	3.101	0.056	0.037	0.034	0.050		Set Trigger
5	3.079	0.057	0.036	0.033	0.051		Set Trigger

AVG 3.10

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 12/8/06		



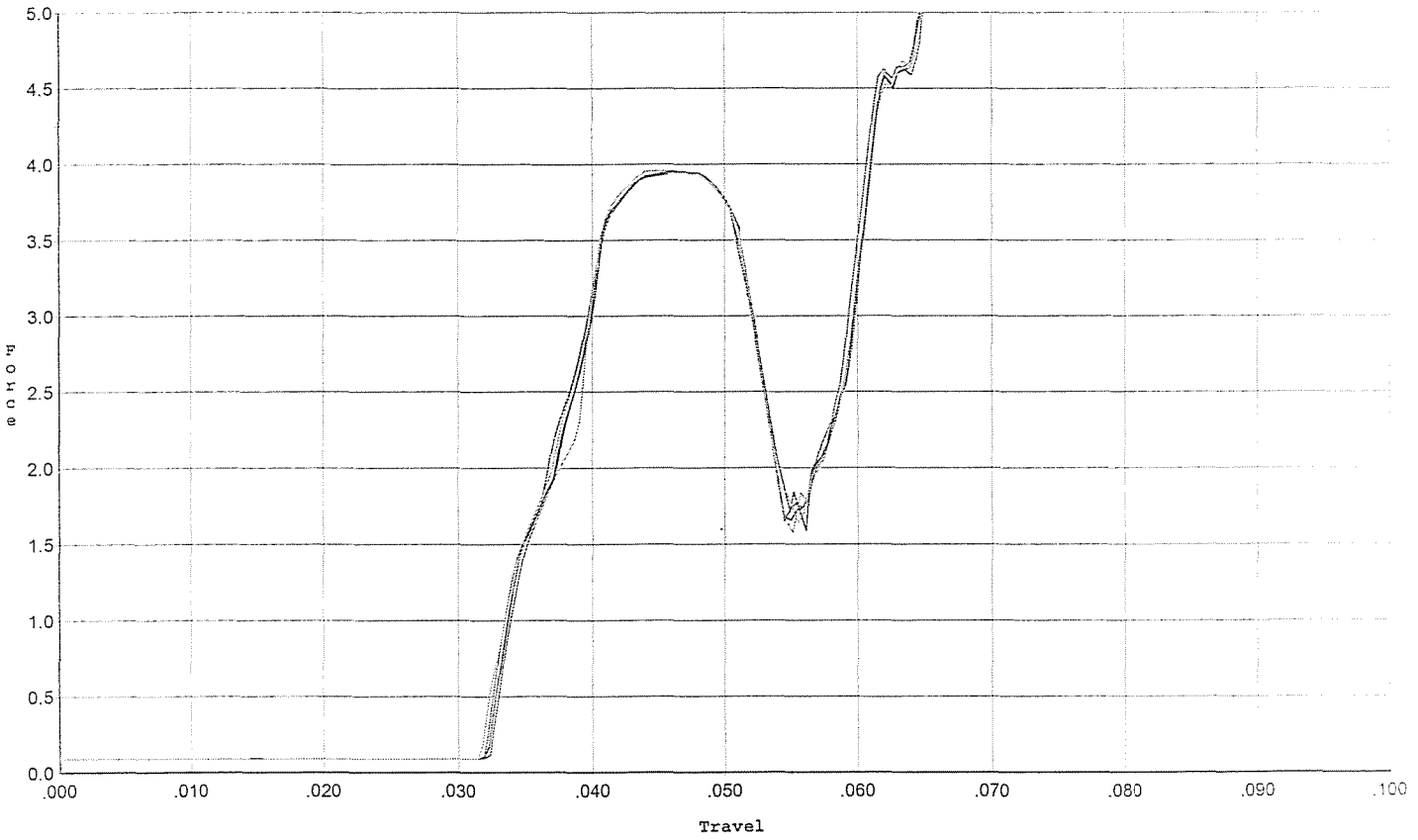
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.056	0.038	0.026	0.064		Set Trigger
2	4.058	0.057	0.038	0.026	0.065		Set Trigger
3	4.030	0.055	0.037	0.026	0.062		Set Trigger
4	4.009	0.055	0.037	0.026	0.063		Set Trigger
5	4.044	0.056	0.036	0.026	0.066		Set Trigger

Avg 4.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 12/8/2006 8:10:14 AM

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 12/8/06		

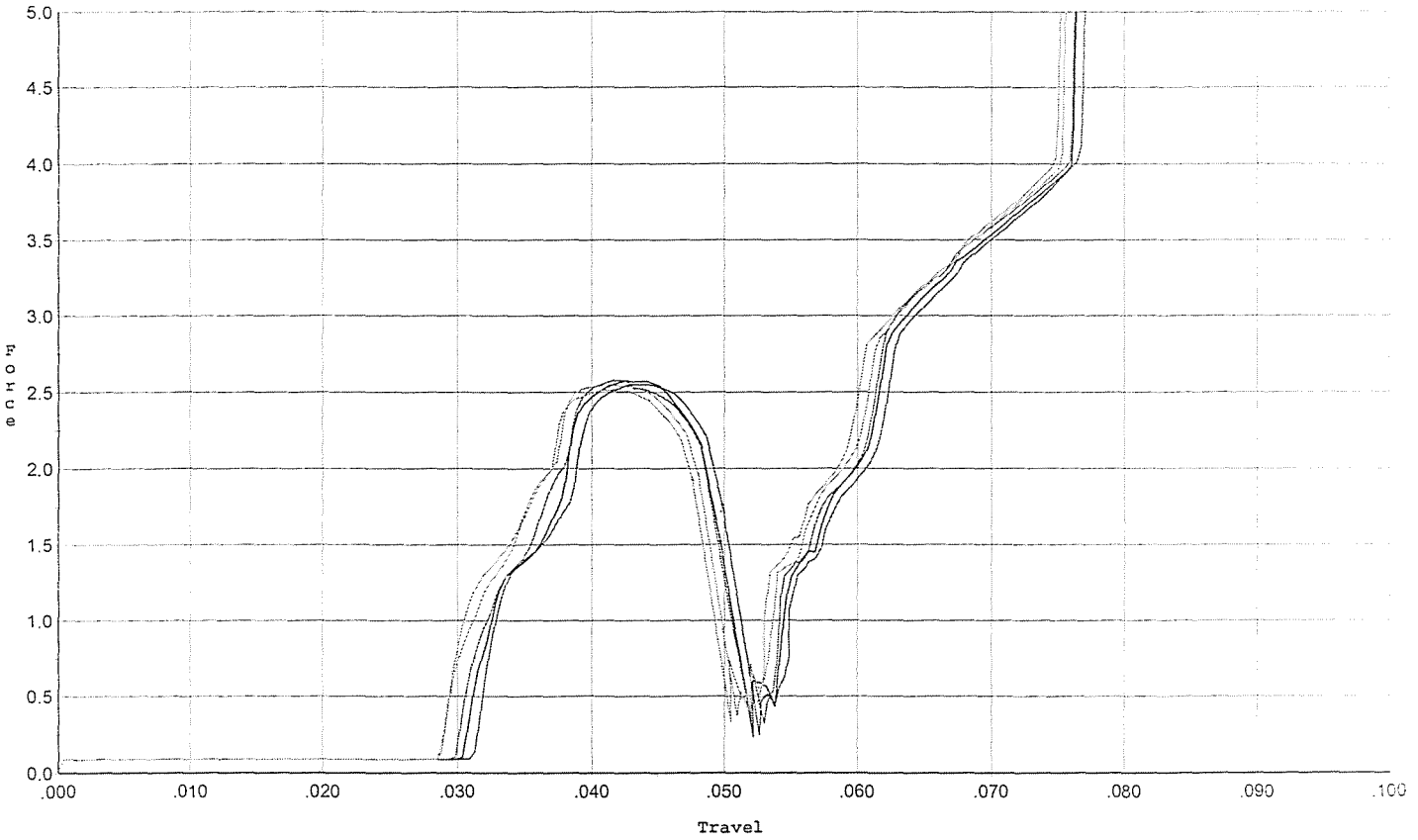


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.958	0.051	0.033	0.027	0.062		Set Trigger
2	3.950	0.051	0.032	0.027	0.063		Set Trigger
3	3.951	0.052	0.032	0.026	0.064		Set Trigger
4	3.961	0.051	0.032	0.027	0.063		Set Trigger
5	3.950	0.051	0.032	0.027	0.063		Set Trigger

Avg 3.95

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. for final test
Note:	R. Putch 12/8/06		

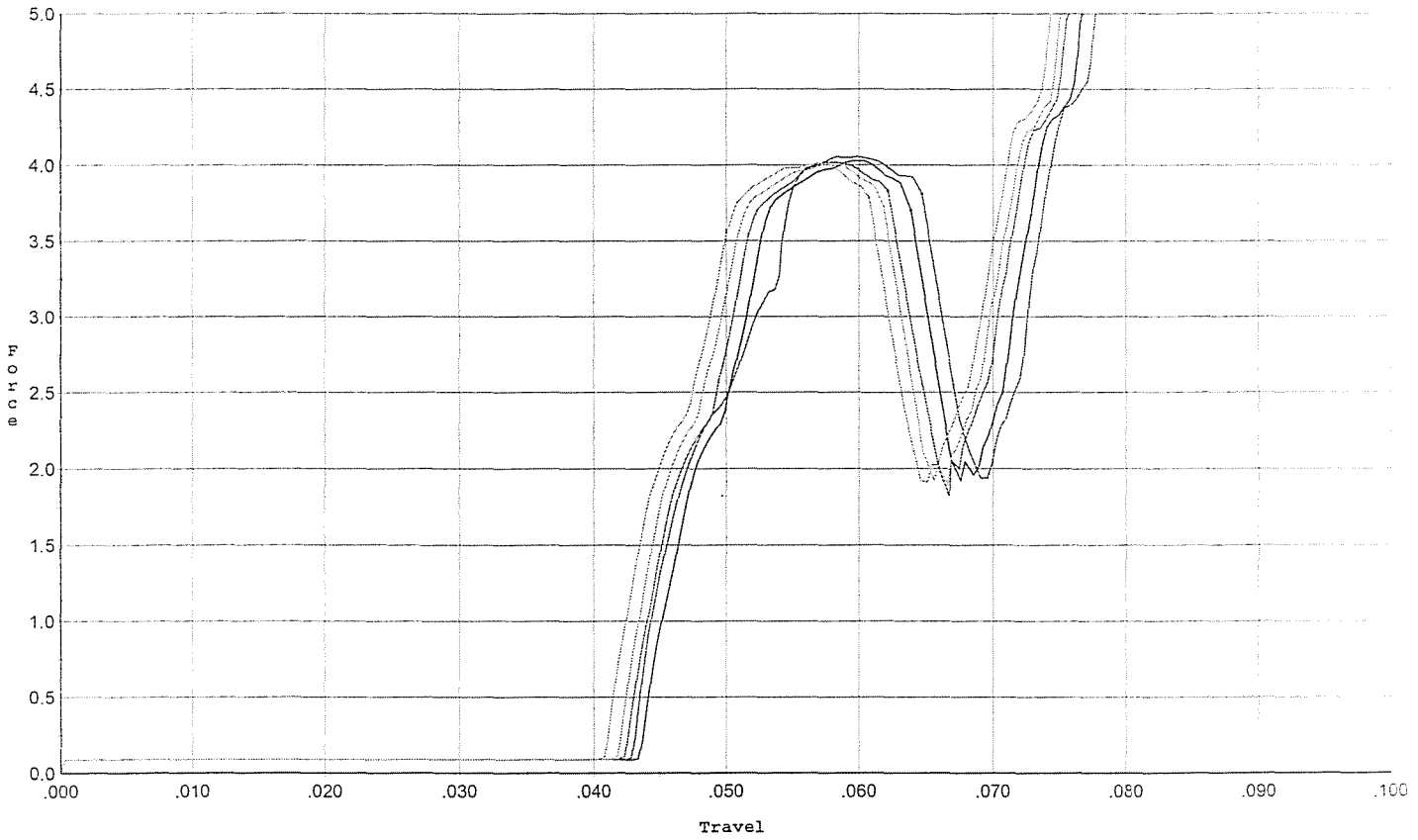


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.050	0.032	0.033	0.040		Set Trigger
2	2.575	0.050	0.031	0.032	0.040		Set Trigger
3	2.579	0.048	0.030	0.033	0.039		Set Trigger
4	2.547	0.048	0.029	0.033	0.040		Set Trigger
5	2.511	0.048	0.029	0.032	0.040		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. for target & accuracy
Note:	R. Putch 12/8/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.065	0.043	0.026	0.075		Set Trigger
2	4.028	0.064	0.044	0.026	0.071		Set Trigger
3	4.018	0.062	0.043	0.026	0.069		Set Trigger
4	4.012	0.062	0.042	0.026	0.069		Set Trigger
5	4.013	0.061	0.041	0.026	0.069		Set Trigger

Avg 4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6616346.__0
FILE DATE AND TIME: 12/14/2006 05:29

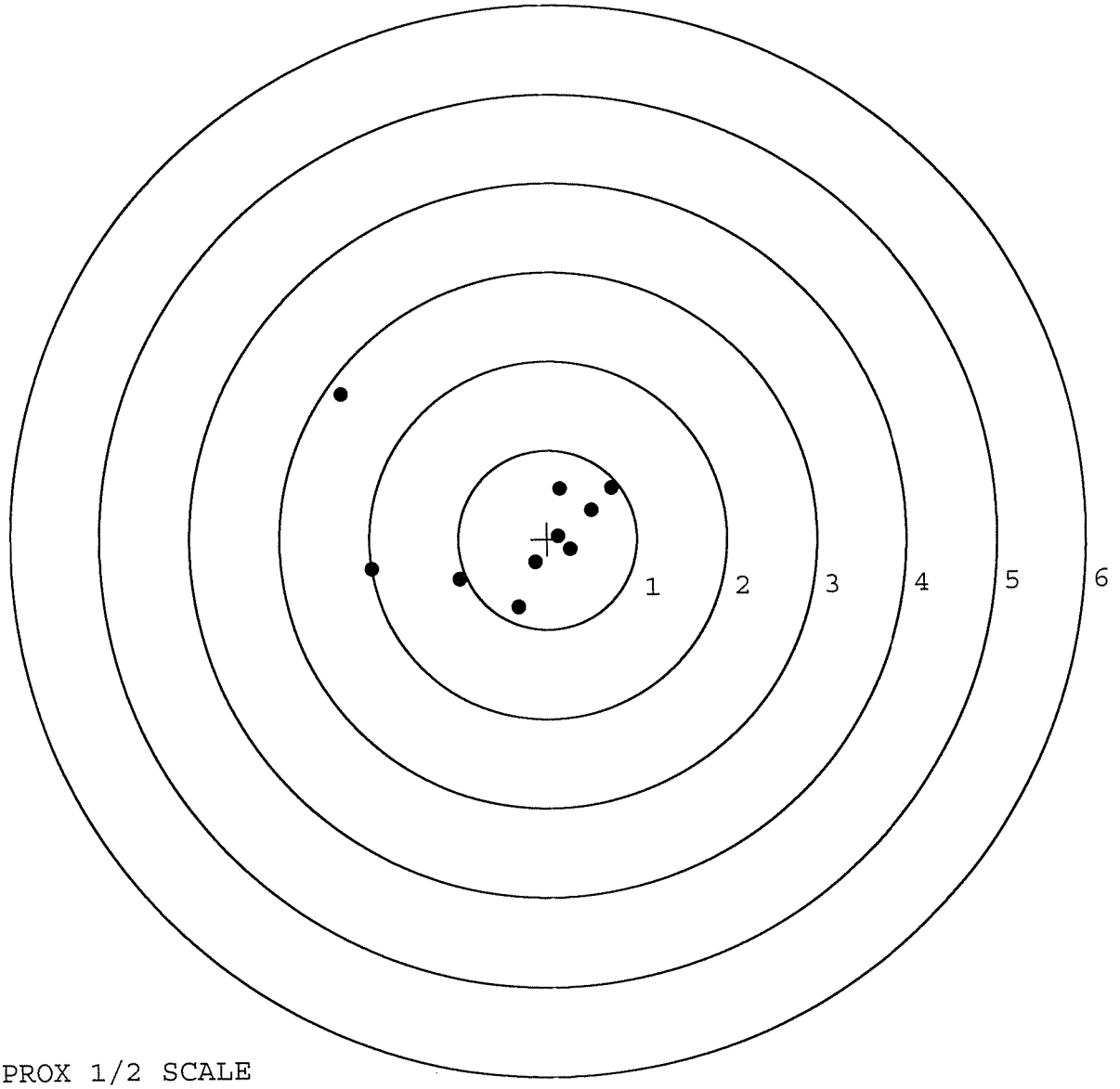
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.089
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.090
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.417
The Distance from Centroid Target #2 to Centroid Target #1:	0.442
The Distance from Centroid Target #3 to Centroid Target #1:	0.467
The Distance from Centroid Target #4 to Centroid Target #1:	0.396
The Distance from Centroid Target #5 to Centroid Target #1:	0.359

SERIAL NUMBER: G6616346.__0
TARGET NUMBER: 1
FILE DATE: 12/14/2006
FILE TIME: 05:29

X CENTROID:	-0.398
Y CENTROID:	0.125
POA TO CENTROID:	0.417
HORZ SPREAD:	3.011
VERT SPREAD:	2.423
GROUP SPREAD:	3.206
MIN RADIUS:	0.462
MAX RADIUS:	2.437
MEAN RADIUS:	1.029
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-1.975	-0.310
2:	-0.991	-0.436
3:	-0.336	-0.759
4:	-0.145	-0.262
5:	0.260	-0.120
6:	0.123	0.027
7:	0.724	0.564
8:	0.496	0.316
9:	0.151	0.566
10:	-2.287	1.664

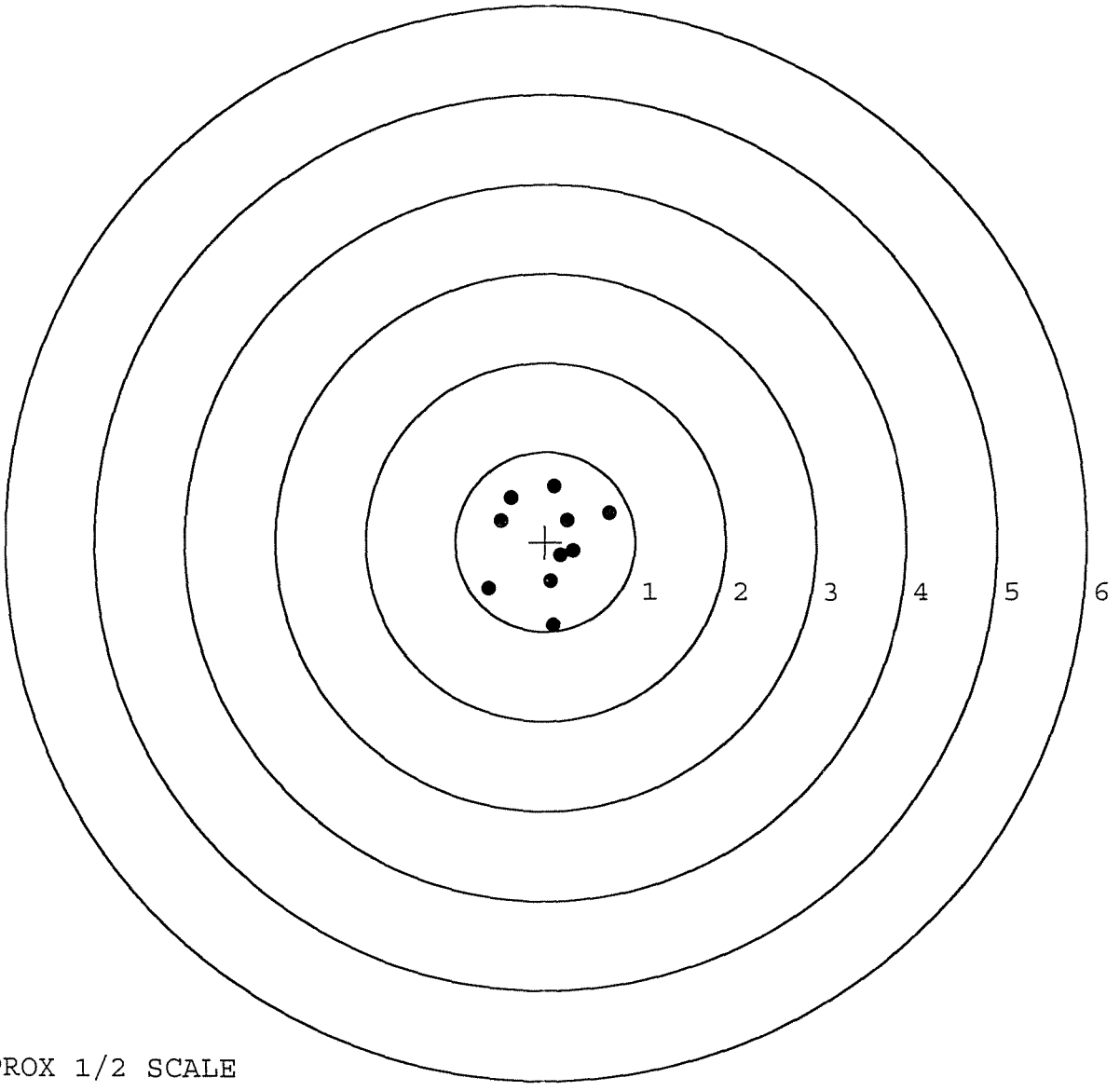


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6616346.__0
TARGET NUMBER: 2
FILE DATE: 12/14/2006
FILE TIME: 05:29

X CENTROID:	0.018
Y CENTROID:	-0.024
POA TO CENTROID:	0.030
HORZ SPREAD:	1.339
VERT SPREAD:	1.554
GROUP SPREAD:	1.554
MIN RADIUS:	0.196
MAX RADIUS:	0.915
MEAN RADIUS:	0.565
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.629	-0.526
2:	0.096	-0.936
3:	0.064	-0.446
4:	0.171	-0.147
5:	0.309	-0.100
6:	0.710	0.322
7:	0.242	0.244
8:	0.094	0.618
9:	-0.380	0.491
10:	-0.496	0.238

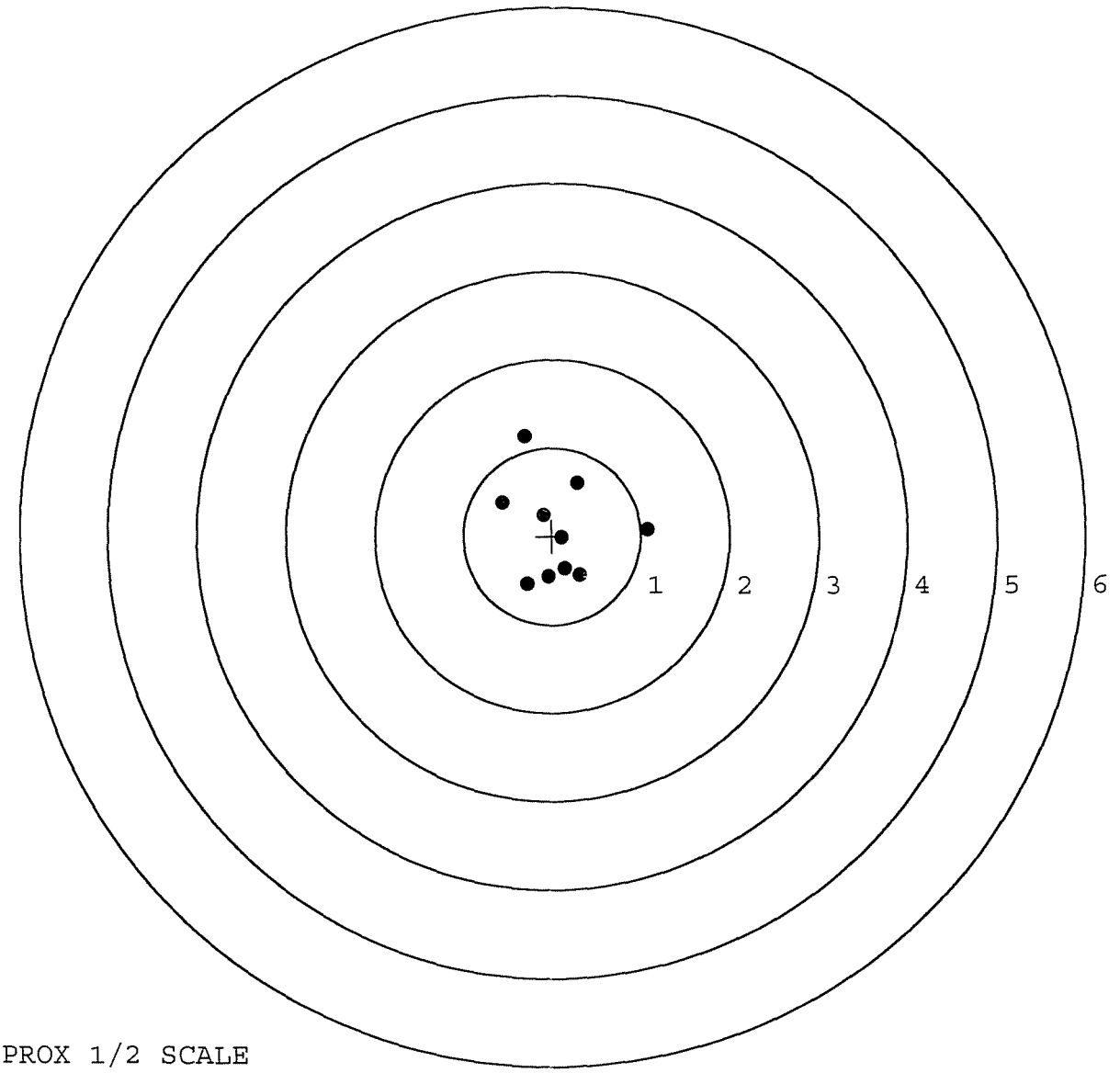


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6616346.__0
TARGET NUMBER: 3
FILE DATE: 12/14/2006
FILE TIME: 05:29

X CENTROID:	0.064
Y CENTROID:	0.056
POA TO CENTROID:	0.085
HORZ SPREAD:	1.641
VERT SPREAD:	1.676
GROUP SPREAD:	1.751
MIN RADIUS:	0.094
MAX RADIUS:	1.142
MEAN RADIUS:	0.599
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.317	1.132
2:	0.290	0.595
3:	1.078	0.073
4:	-0.563	0.371
5:	-0.095	0.228
6:	0.112	-0.025
7:	-0.285	-0.544
8:	0.315	-0.443
9:	-0.046	-0.463
10:	0.150	-0.368

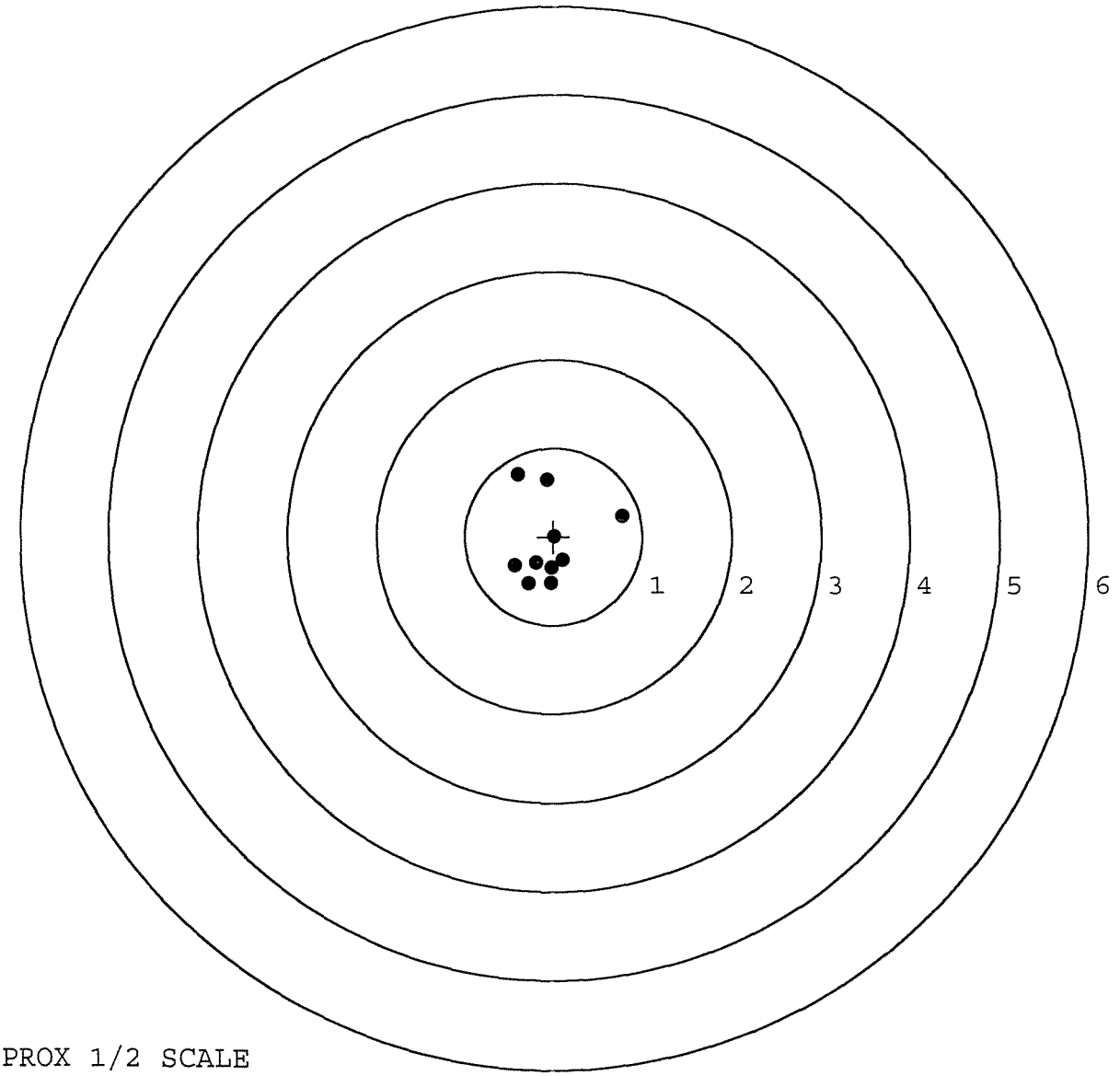


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6616346.__0
TARGET NUMBER: 4
FILE DATE: 12/14/2006
FILE TIME: 05:29

X CENTROID:	-0.057
Y CENTROID:	-0.076
POA TO CENTROID:	0.095
HORZ SPREAD:	1.205
VERT SPREAD:	1.239
GROUP SPREAD:	1.327
MIN RADIUS:	0.100
MAX RADIUS:	0.878
MEAN RADIUS:	0.478
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.404	0.701
2:	-0.079	0.644
3:	0.767	0.227
4:	0.011	-0.002
5:	0.111	-0.273
6:	-0.032	-0.529
7:	-0.282	-0.538
8:	-0.438	-0.329
9:	-0.200	-0.304
10:	-0.024	-0.355

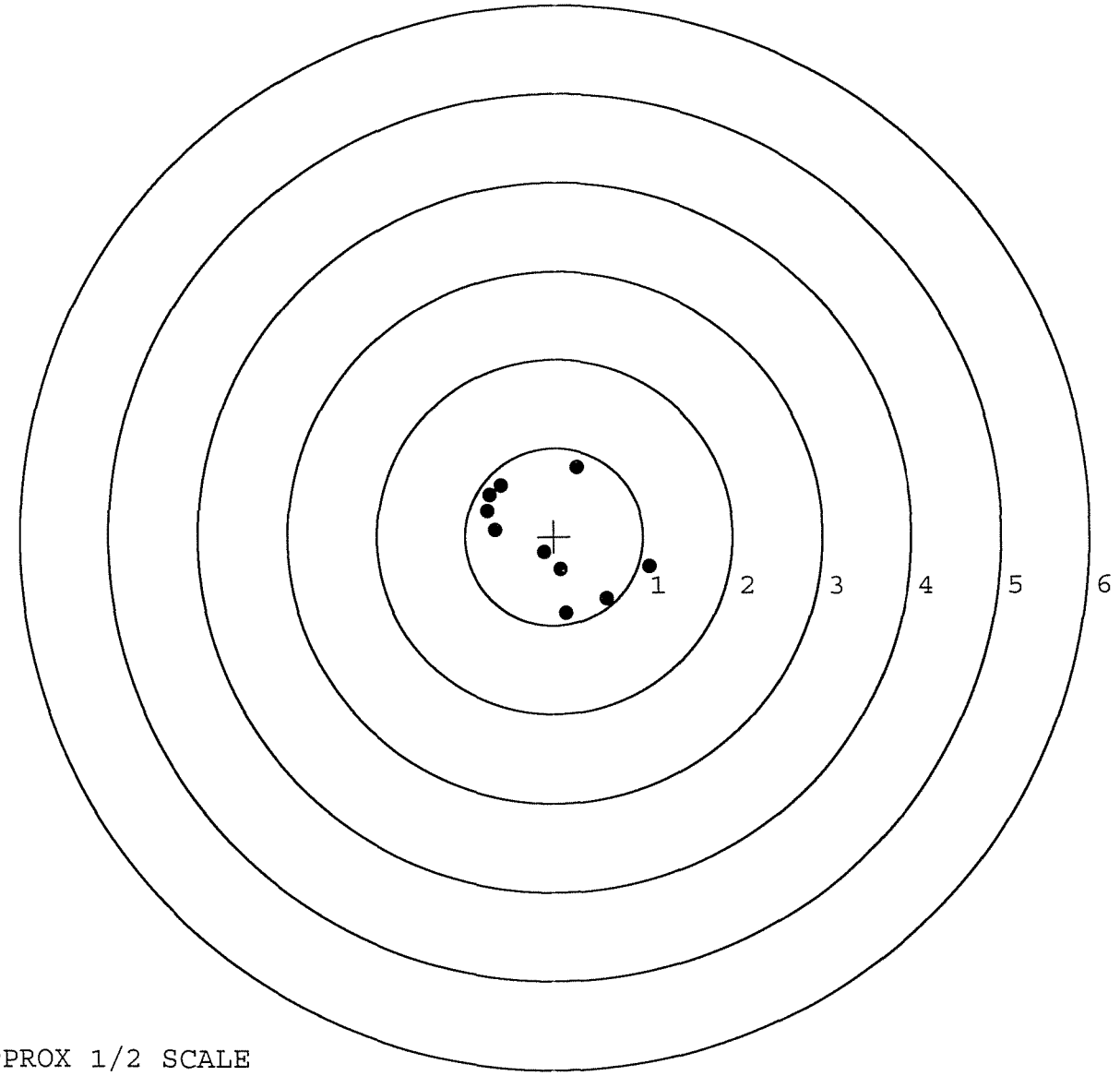


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6616346.__0
TARGET NUMBER: 5
FILE DATE: 12/14/2006
FILE TIME: 05:29

X CENTROID:	-0.074
Y CENTROID:	-0.028
POA TO CENTROID:	0.079
HORZ SPREAD:	1.828
VERT SPREAD:	1.646
GROUP SPREAD:	1.976
MIN RADIUS:	0.159
MAX RADIUS:	1.187
MEAN RADIUS:	0.738
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.260	0.778
2:	1.071	-0.344
3:	0.587	-0.703
4:	0.137	-0.868
5:	0.077	-0.376
6:	-0.118	-0.181
7:	-0.602	0.575
8:	-0.729	0.472
9:	-0.757	0.287
10:	-0.661	0.076



TARGET APPROX 1/2 SCALE