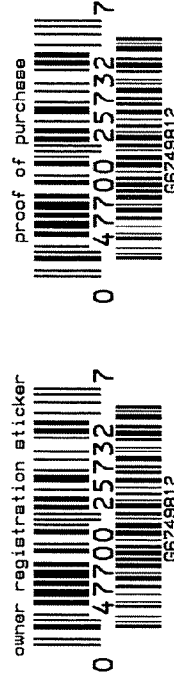


6674 9812

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

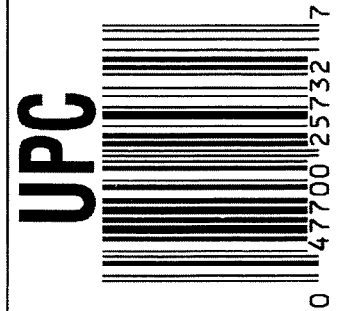
- INSTRUCTION BOOK 3518

BM FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6749812



25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SW5732X



.ABSW5732X

Start Date: 6/4/2008

Finish Date: 6/26/2008

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0006554655

0547

Gray Sandstrom Coat Bolt Assemblies

01PC001



0006554673

0610

Assemble Action to Stock.

89SWS1



0006554662

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6749812

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6/11/08	R.P.D.
430	ASSEMBLE TO STOCK		6/11/08	JP
440	PROOF		6-11-08	SD
460	CHECK HEADSPACE		6-11-08	SD
470	DIS-ASSEMBLE ACTION		6/11/08	R.P.D.
472	SERIALIZE BOLT HANDLE		6/12/08	R.P.D.
475	DRILL AND TAP SIGHT HOLES		6-13-08	TRW
480	MAGNAFLUX BBL ACTION		6/16/08	mmg
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/08	RT
520	GOFF BLAST BBL / REC		6/17/08	TR
542	APPLY COATINGS (BARREL ACTION)		6/18/08	W
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	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			

F004 REV 5/2006

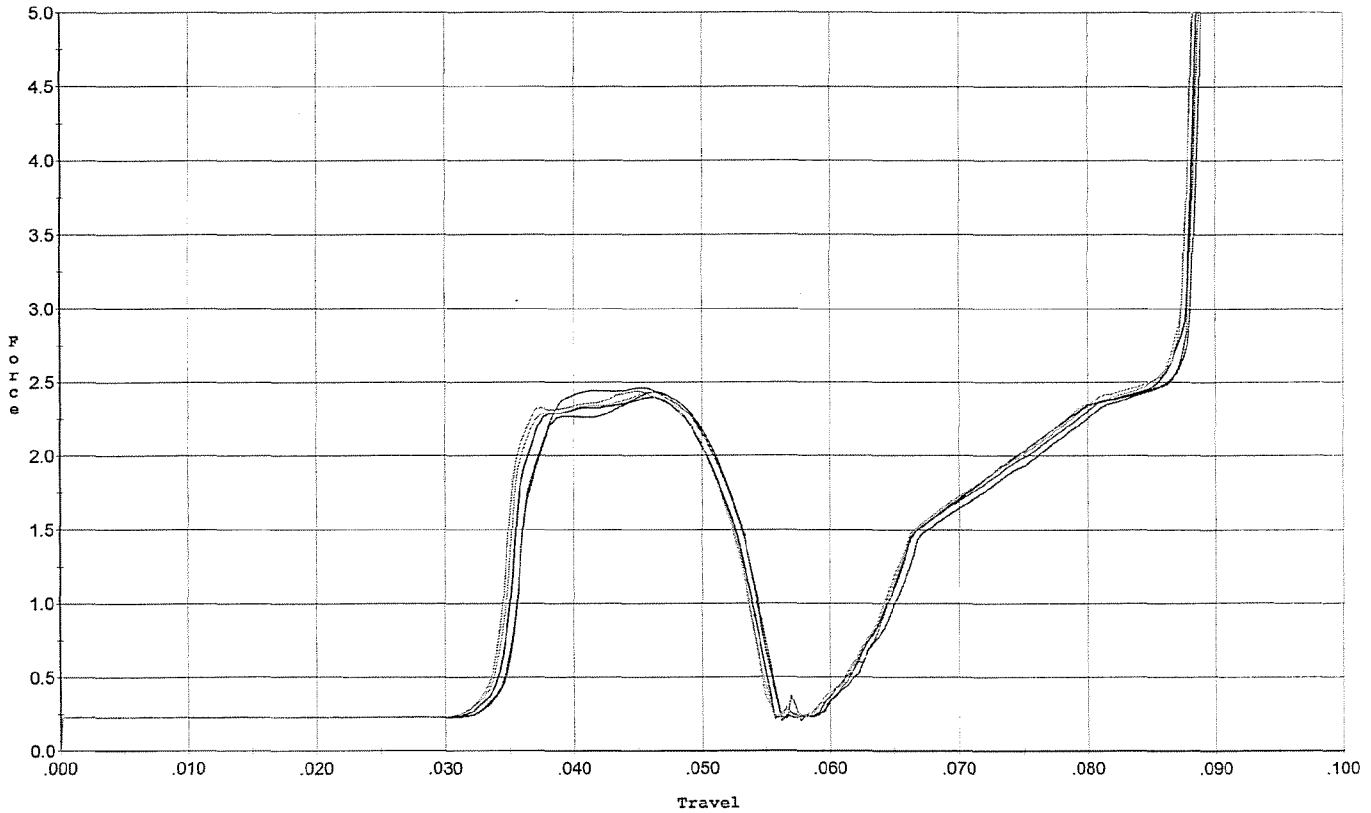
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁰</u> <u>7⁰</u> <u>7⁰</u>	6-26-08	RTZ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4⁰</u> <u>4⁰</u> <u>4⁰</u>	6-26-08	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>023</u> <u>023</u> <u>023</u>	6-26-08	RTZ
	J) ASSEMBLE STOCK		6-19-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		6-27-08	BSN
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	6-20-08	SD
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-20-08	SP
670	FINAL INSPECTION A) HEADSPACE		6-27-08	BSN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>289</u> <u>286</u> <u>268</u> <u>289</u> <u>296</u>	6-20-08	RTZ
	C) FUNCTION			
690	PACK		6/30/08	RP

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



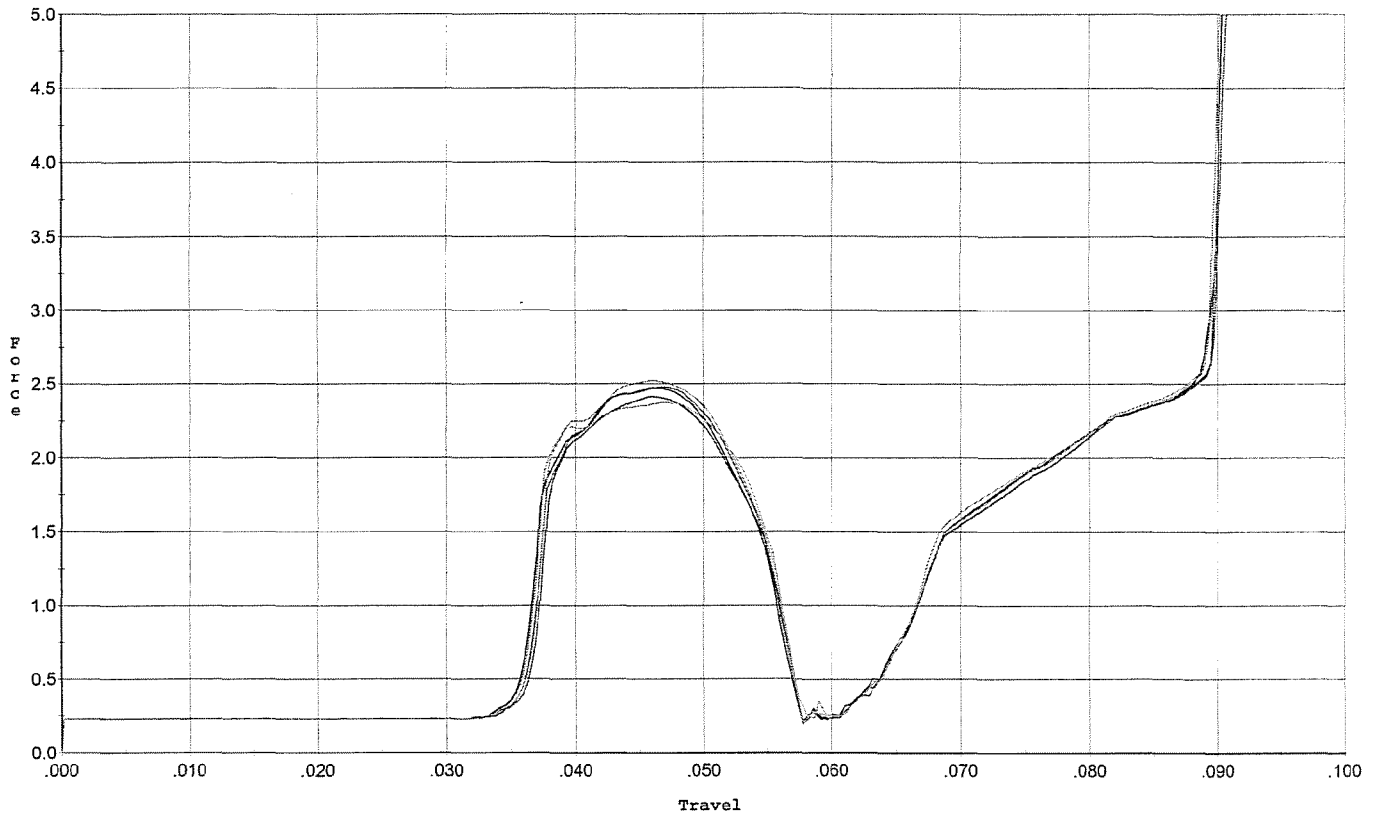
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.434	0.053	0.034	0.040	0.047		Set Trigger
2	2.397	0.054	0.034	0.039	0.048		Set Trigger
3	2.461	0.055	0.034	0.039	0.049		Set Trigger
4	2.432	0.053	0.034	0.039	0.048		Set Trigger
5	2.438	0.053	0.033	0.039	0.049		Set Trigger

Avg 2.43

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.



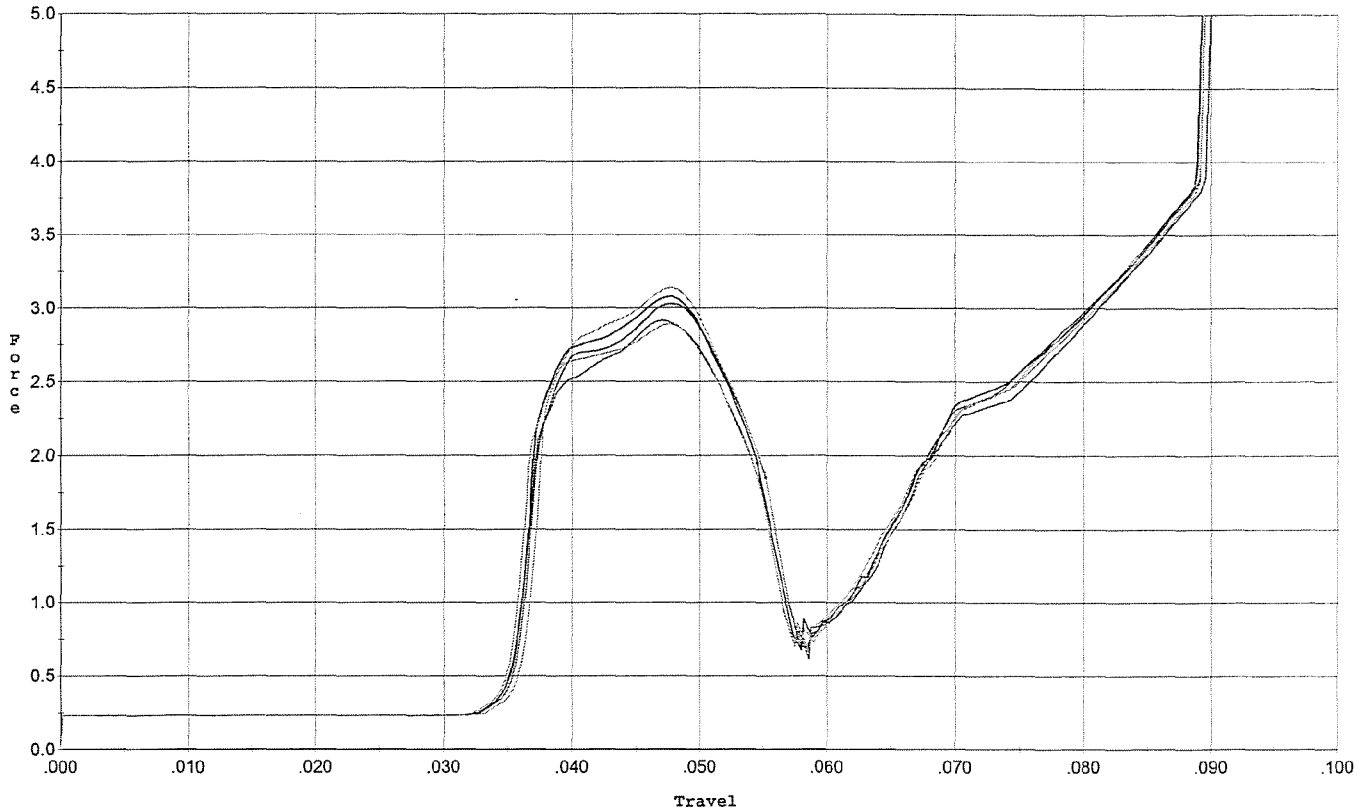
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.414	0.056	0.036	0.039	0.048		Set Trigger
2	2.472	0.055	0.035	0.040	0.048		Set Trigger
3	2.479	0.056	0.036	0.040	0.049		Set Trigger
4	2.374	0.055	0.036	0.039	0.048		Set Trigger
5	2.521	0.056	0.036	0.039	0.050		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

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

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



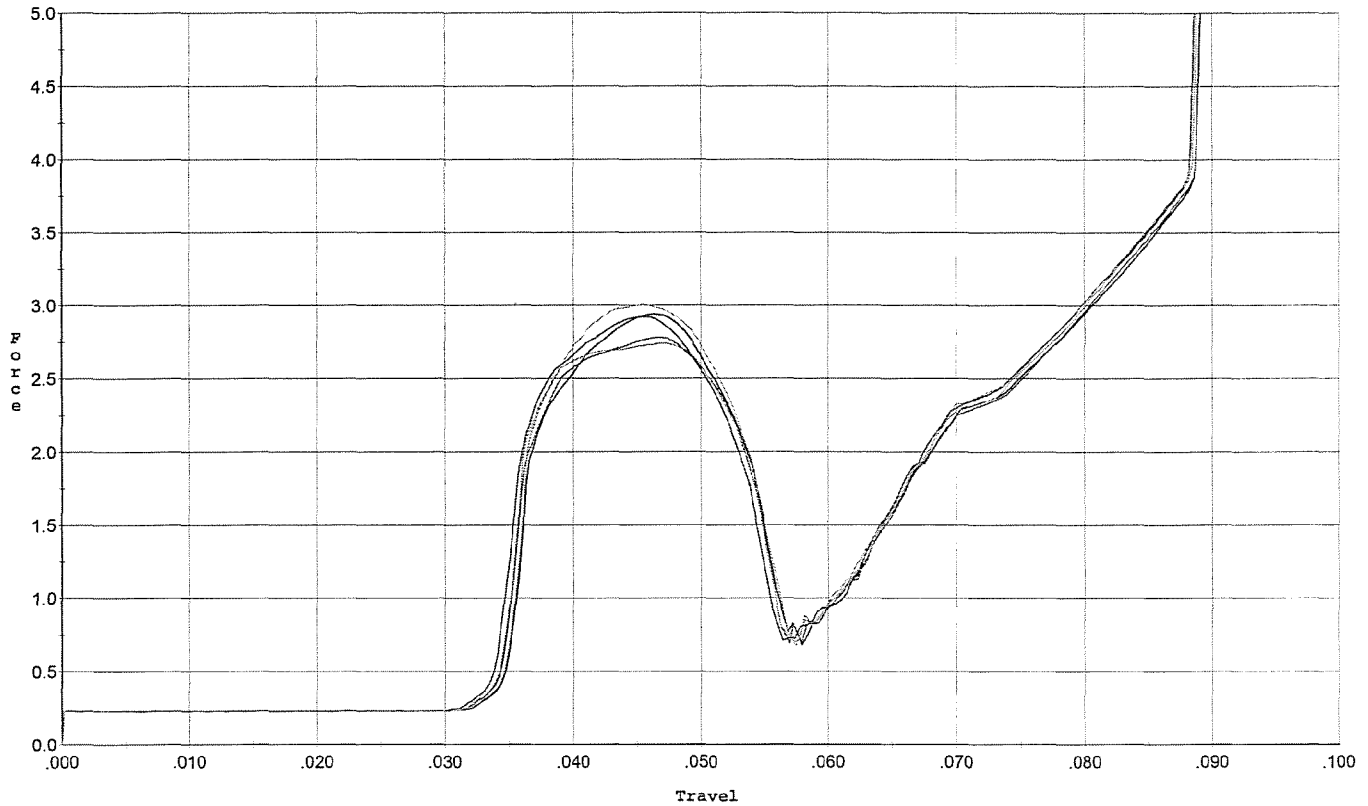
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.028	0.055	0.035	0.038	0.059		Set Trigger
2	3.080	0.055	0.035	0.038	0.058		Set Trigger
3	2.916	0.055	0.035	0.038	0.056		Set Trigger
4	3.139	0.055	0.035	0.038	0.059		Set Trigger
5	2.891	0.055	0.035	0.038	0.057		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

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

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



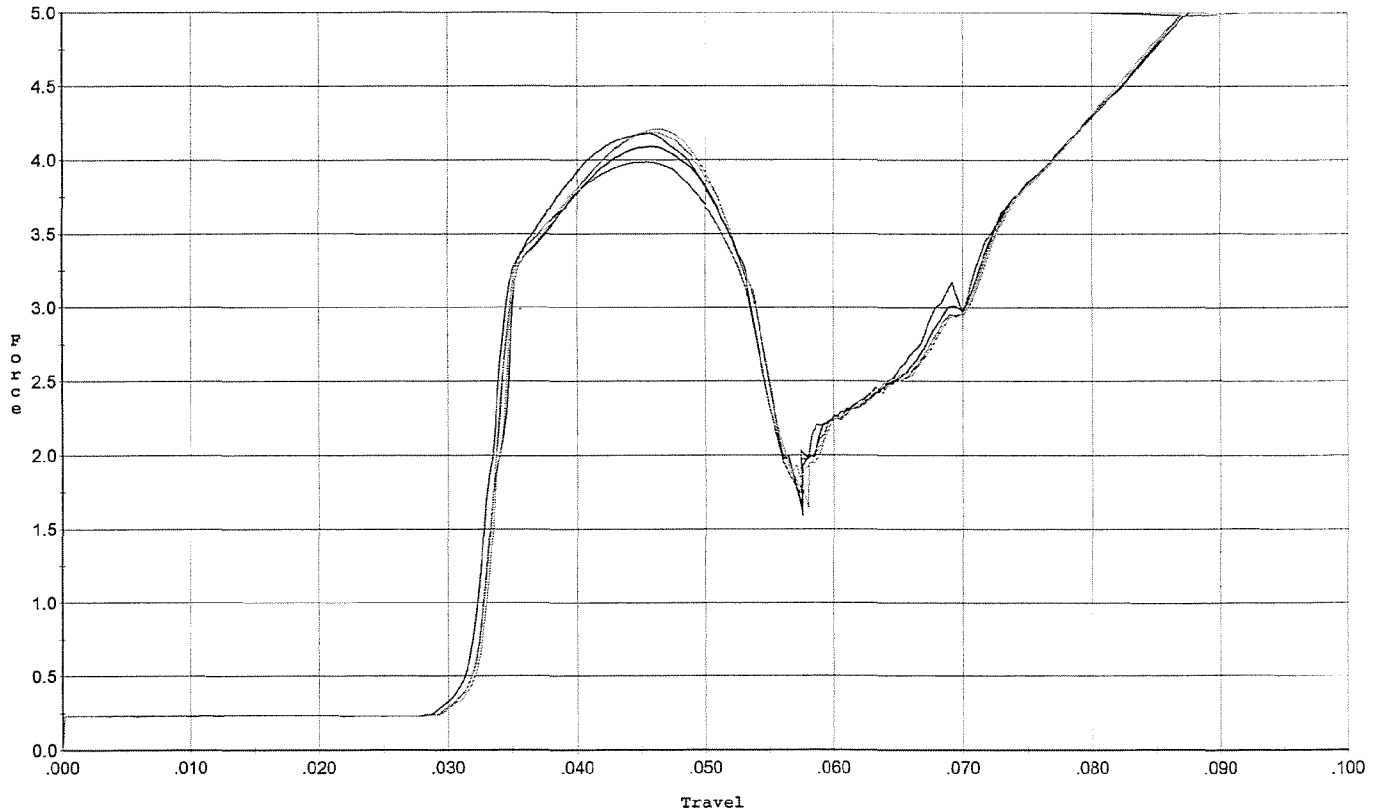
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.922	0.054	0.034	0.038	0.057		Set Trigger
2	2.938	0.054	0.035	0.038	0.056		Set Trigger
3	2.779	0.054	0.034	0.038	0.056		Set Trigger
4	3.004	0.054	0.034	0.038	0.058		Set Trigger
5	2.742	0.054	0.034	0.038	0.056		Set Trigger

Avg 2.87

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.



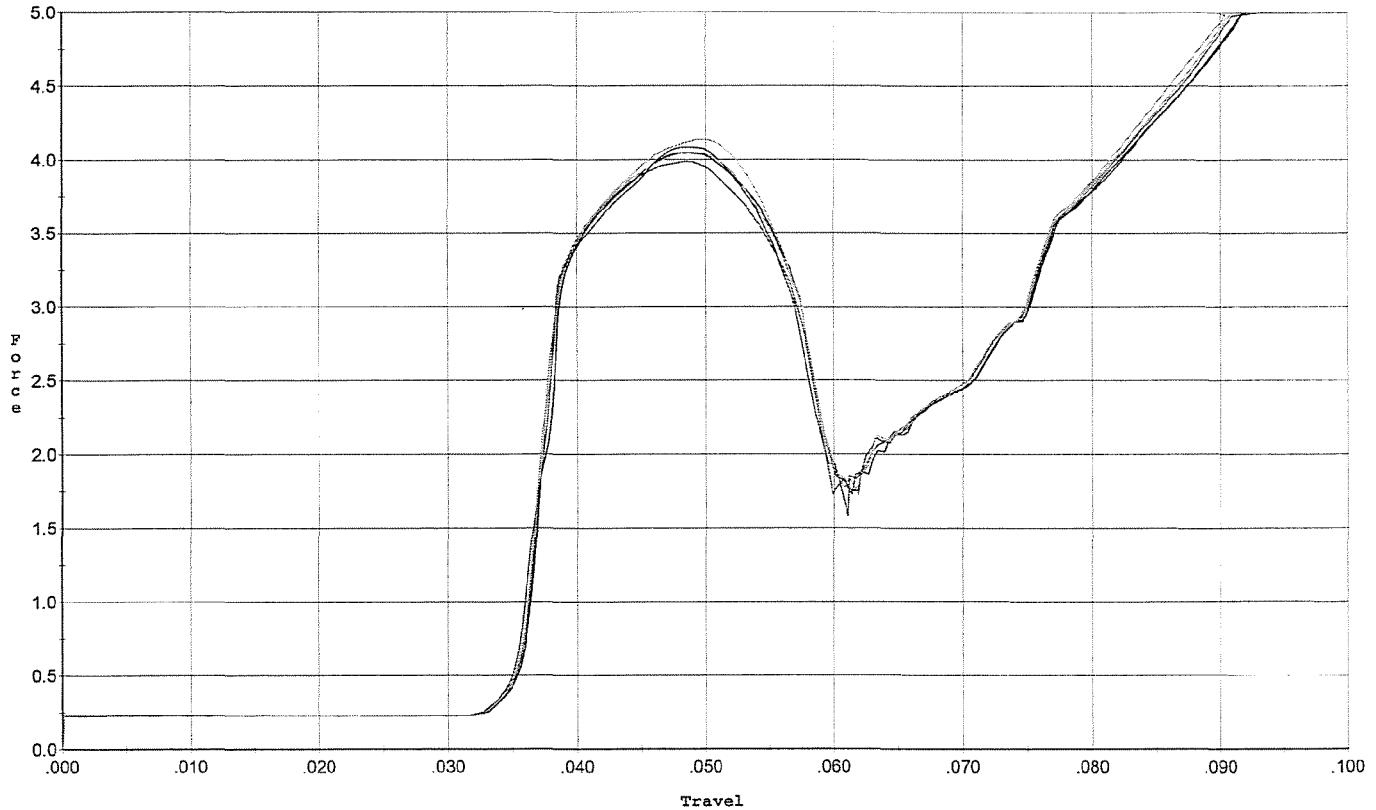
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.180	0.053	0.031	0.034	0.085		Set Trigger
2	4.091	0.054	0.032	0.035	0.084		Set Trigger
3	3.987	0.053	0.032	0.035	0.082		Set Trigger
4	4.187	0.054	0.032	0.035	0.085		Set Trigger
5	4.209	0.054	0.032	0.035	0.085		Set Trigger

Avg 4.13

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.



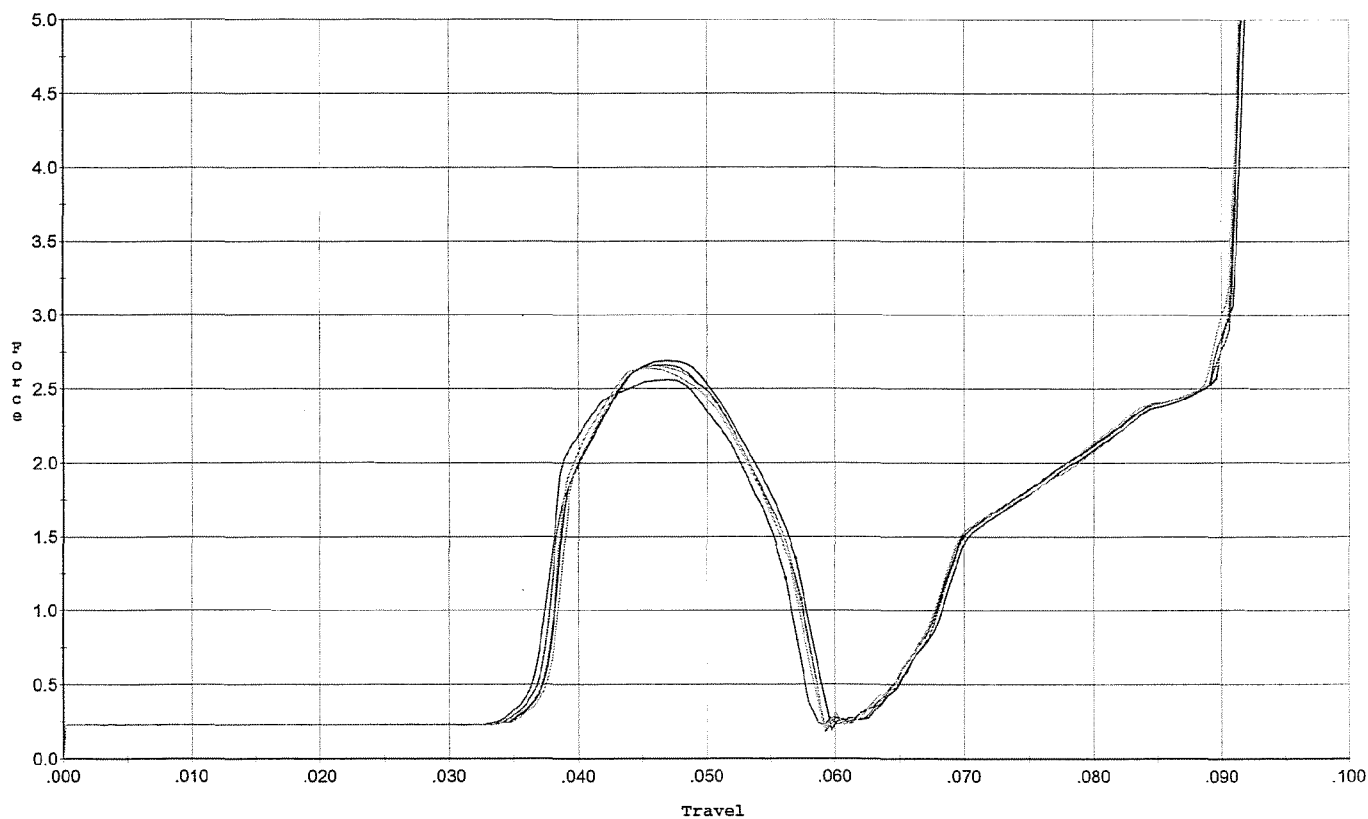
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.057	0.035	0.037	0.084		Set Trigger
2	4.046	0.057	0.035	0.037	0.084		Set Trigger
3	3.989	0.058	0.035	0.037	0.085		Set Trigger
4	4.047	0.057	0.035	0.037	0.085		Set Trigger
5	4.137	0.057	0.035	0.037	0.086		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: reset to 2.5 lbs. +/- .50 lbs. for final test



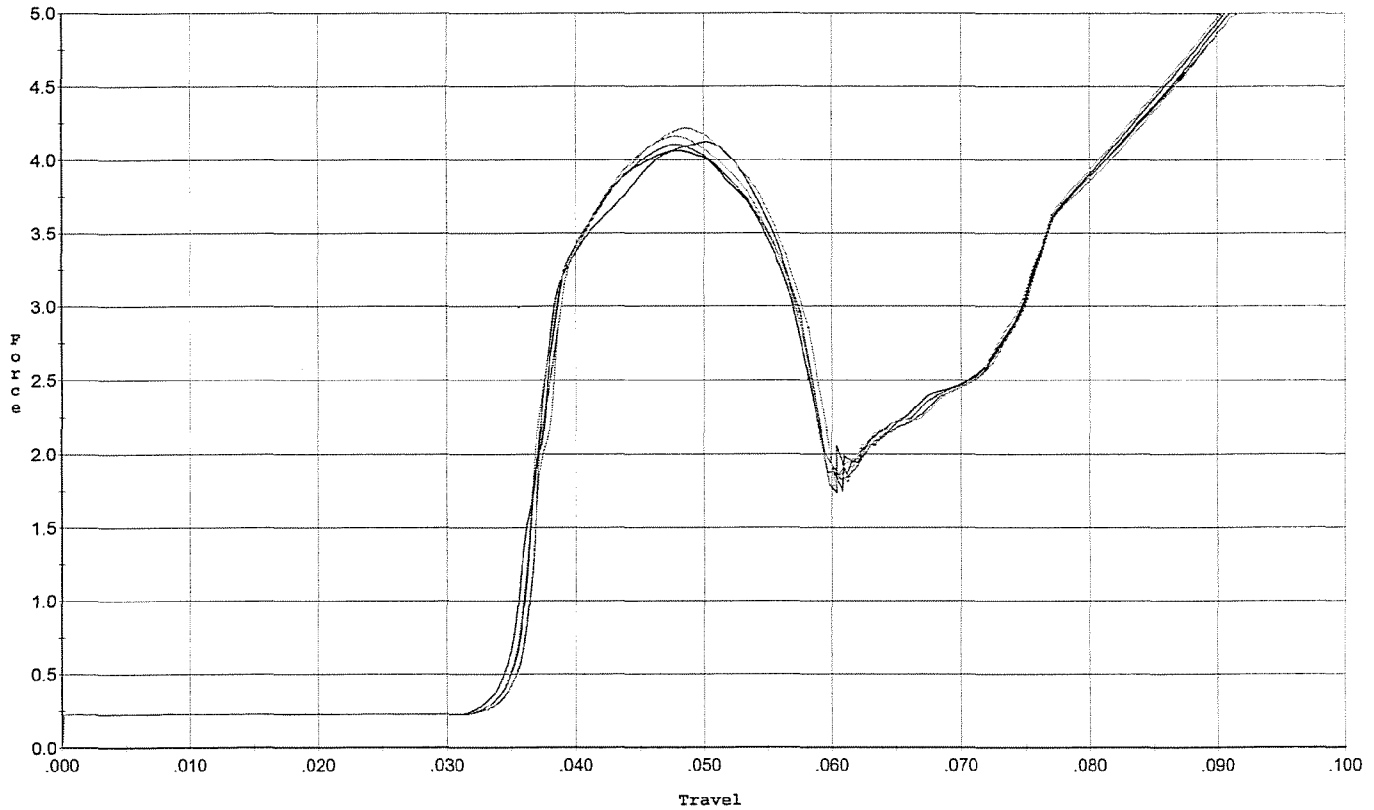
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.056	0.036	0.040	0.050		Set Trigger
2	2.689	0.057	0.037	0.040	0.051		Set Trigger
3	2.661	0.057	0.036	0.040	0.052		Set Trigger
4	2.636	0.057	0.037	0.040	0.050		Set Trigger
5	2.653	0.058	0.037	0.039	0.051		Set Trigger

Avg 2.64

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	4.123	0.058	0.034	0.036	0.087		Set Trigger
2	4.061	0.058	0.035	0.037	0.086		Set Trigger
3	4.105	0.057	0.035	0.037	0.085		Set Trigger
4	4.161	0.058	0.035	0.037	0.087		Set Trigger
5	4.218	0.058	0.035	0.037	0.088		Set Trigger

Avg 4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6749812.___0

FILE DATE AND TIME: 06/23/2008 05:33

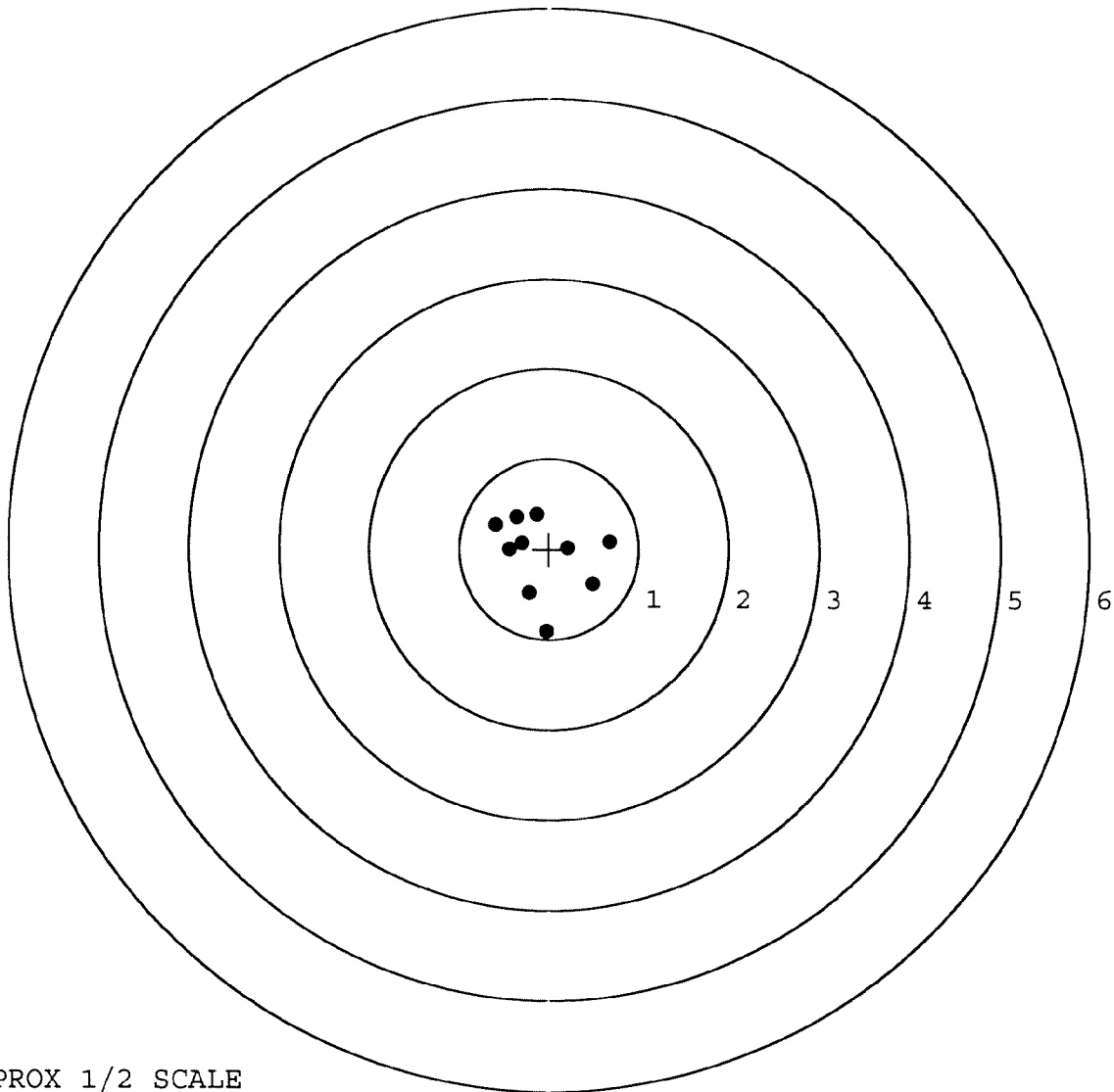
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.041
The Average Y Centroid of the Five Target Set:	-0.023
The Average Point of Impact of the Five Target Set:	0.048
The Average Mean Radius of the Five Target Set:	0.595
The Distance from POA to Centroid Target #1:	0.095
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.056
The Distance from Centroid Target #4 to Centroid Target #1:	0.081
The Distance from Centroid Target #5 to Centroid Target #1:	0.180

SERIAL NUMBER: G6749812. __0
TARGET NUMBER: 1
FILE DATE: 06/23/2008
FILE TIME: 05:33

POINT#	X	Y
1:	0.491	-0.387
2:	0.679	0.081
3:	0.212	-0.017
4:	-0.033	-0.920
5:	-0.226	-0.489
6:	-0.440	-0.002
7:	-0.139	0.385
8:	-0.366	0.354
9:	-0.598	0.269
10:	-0.301	0.067

X CENTROID: -0.072
Y CENTROID: -0.062
POA TO CENTROID: 0.095
HORZ SPREAD: 1.277
VERT SPREAD: 1.305
GROUP SPREAD: 1.317
MIN RADIUS: 0.263
MAX RADIUS: 0.858
MEAN RADIUS: 0.524
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749812. __0

TARGET NUMBER: 2

FILE DATE: 06/23/2008

FILE TIME: 05:33

POINT#	X	Y
1:	0.894	-0.856
2:	0.848	0.409
3:	0.571	-0.333
4:	-0.263	0.513
5:	-0.439	0.022
6:	-0.143	-0.196
7:	0.303	-0.245
8:	0.293	0.236
9:	-0.065	0.175
10:	-0.002	-0.098

X CENTROID: 0.200

Y CENTROID: -0.037

POA TO CENTROID: 0.203

HORZ SPREAD: 1.333

VERT SPREAD: 1.369

GROUP SPREAD: 1.792

MIN RADIUS: 0.211

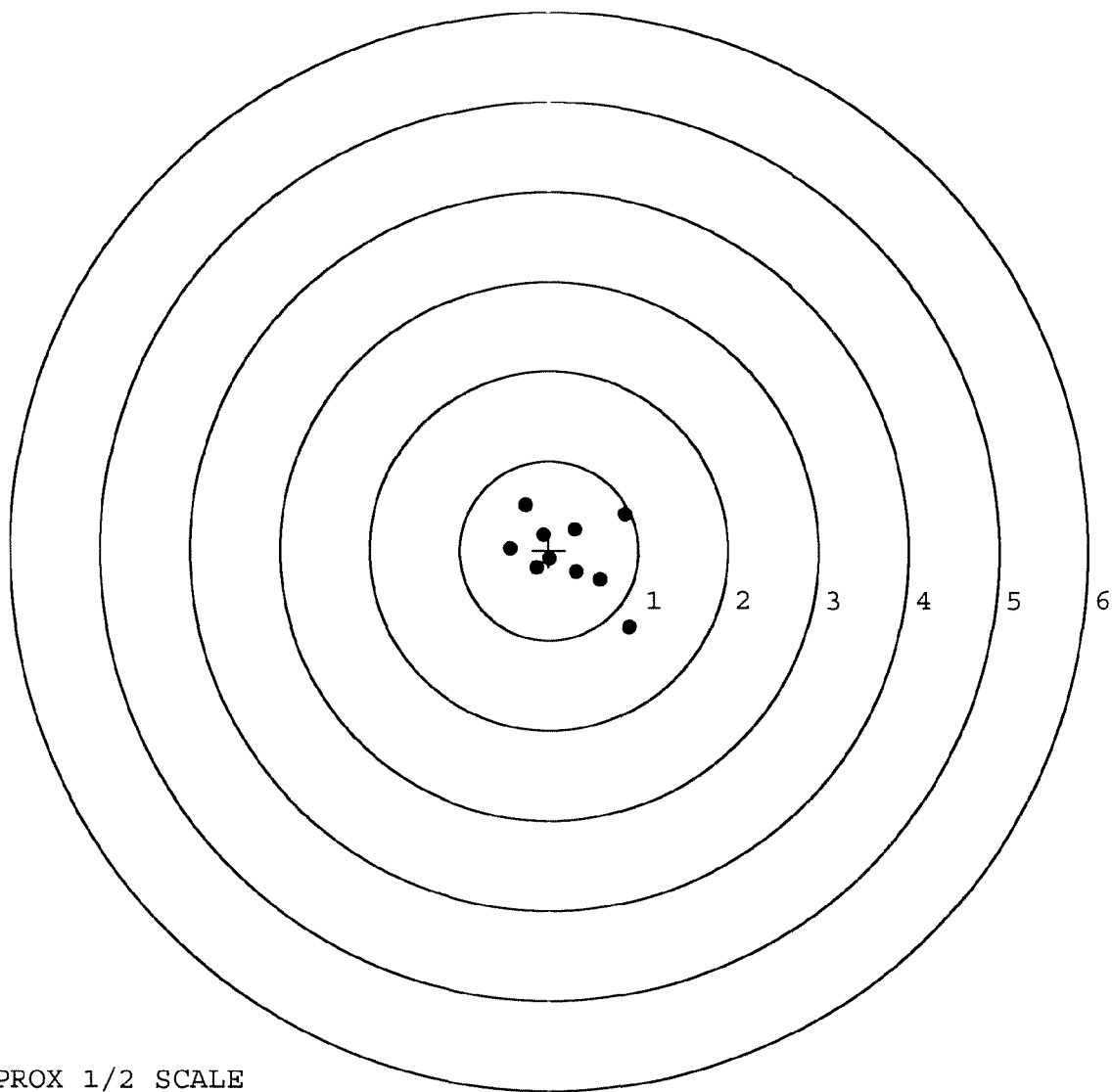
MAX RADIUS: 1.073

MEAN RADIUS: 0.514

IN 1 IN DIAMETER: 6

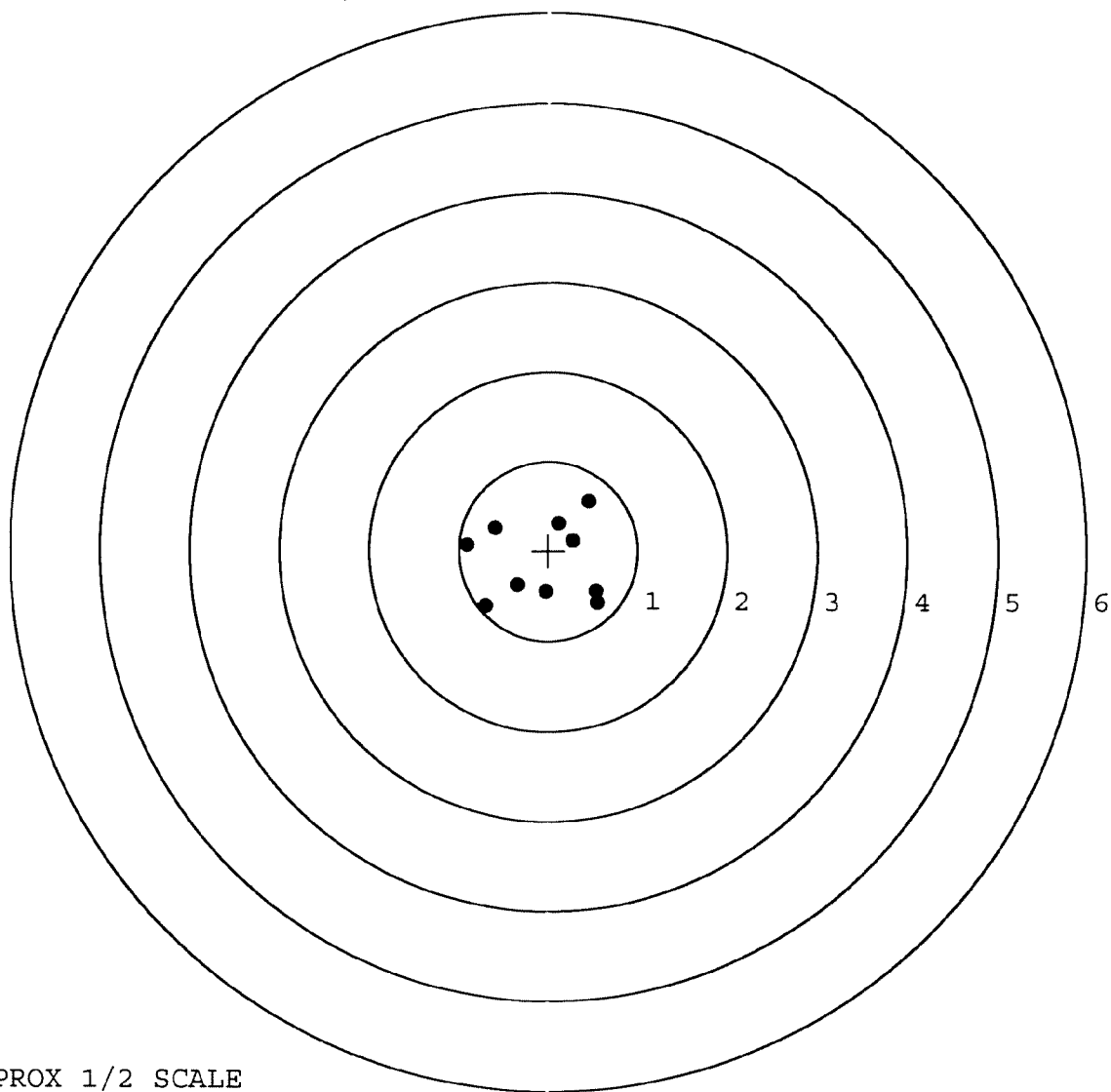
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749812. __0	POINT#	X	Y
TARGET NUMBER: 3	1:	0.552	-0.577
FILE DATE: 06/23/2008	2:	-0.032	-0.458
FILE TIME: 05:33	3:	-0.349	-0.382
	4:	-0.706	-0.614
X CENTROID: -0.066	5:	-0.911	0.065
Y CENTROID: -0.118	6:	-0.596	0.254
POA TO CENTROID: 0.135	7:	0.276	0.114
HORZ SPREAD: 1.463	8:	0.118	0.308
VERT SPREAD: 1.170	9:	0.456	0.556
GROUP SPREAD: 1.598	10:	0.535	-0.450
MIN RADIUS: 0.341			
MAX RADIUS: 0.865			
MEAN RADIUS: 0.624			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749812. __0

TARGET NUMBER: 4

FILE DATE: 06/23/2008

FILE TIME: 05:33

POINT#	X	Y
1:	0.997	0.502
2:	0.052	-0.688
3:	-0.321	-0.411
4:	-0.482	0.109
5:	-0.509	0.386
6:	-1.696	-1.011
7:	0.445	0.180
8:	0.035	0.244
9:	0.000	0.459
10:	0.269	0.245

X CENTROID: -0.121

Y CENTROID: 0.001

POA TO CENTROID: 0.121

HORZ SPREAD: 2.693

VERT SPREAD: 1.513

GROUP SPREAD: 3.089

MIN RADIUS: 0.288

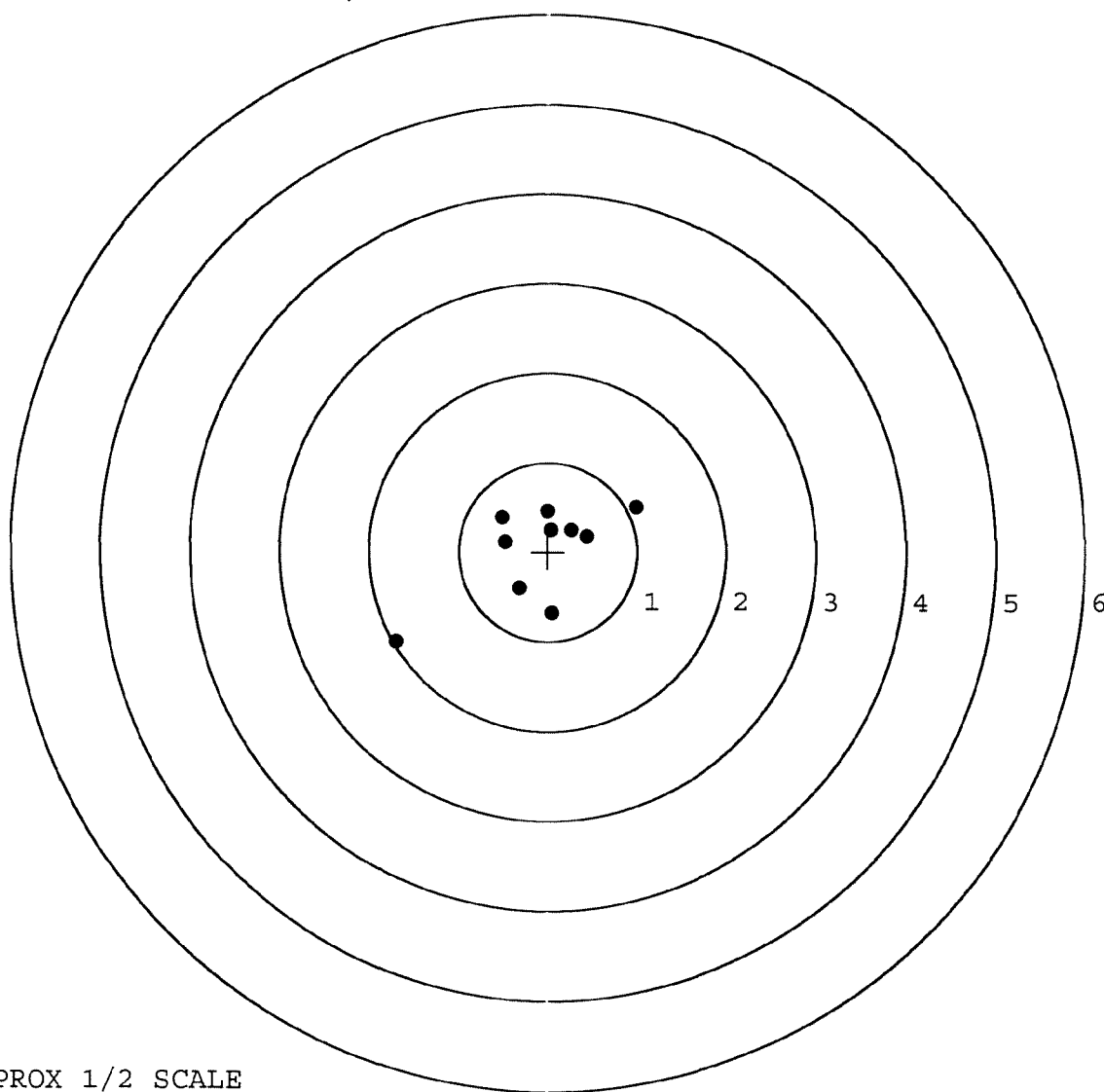
MAX RADIUS: 1.872

MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

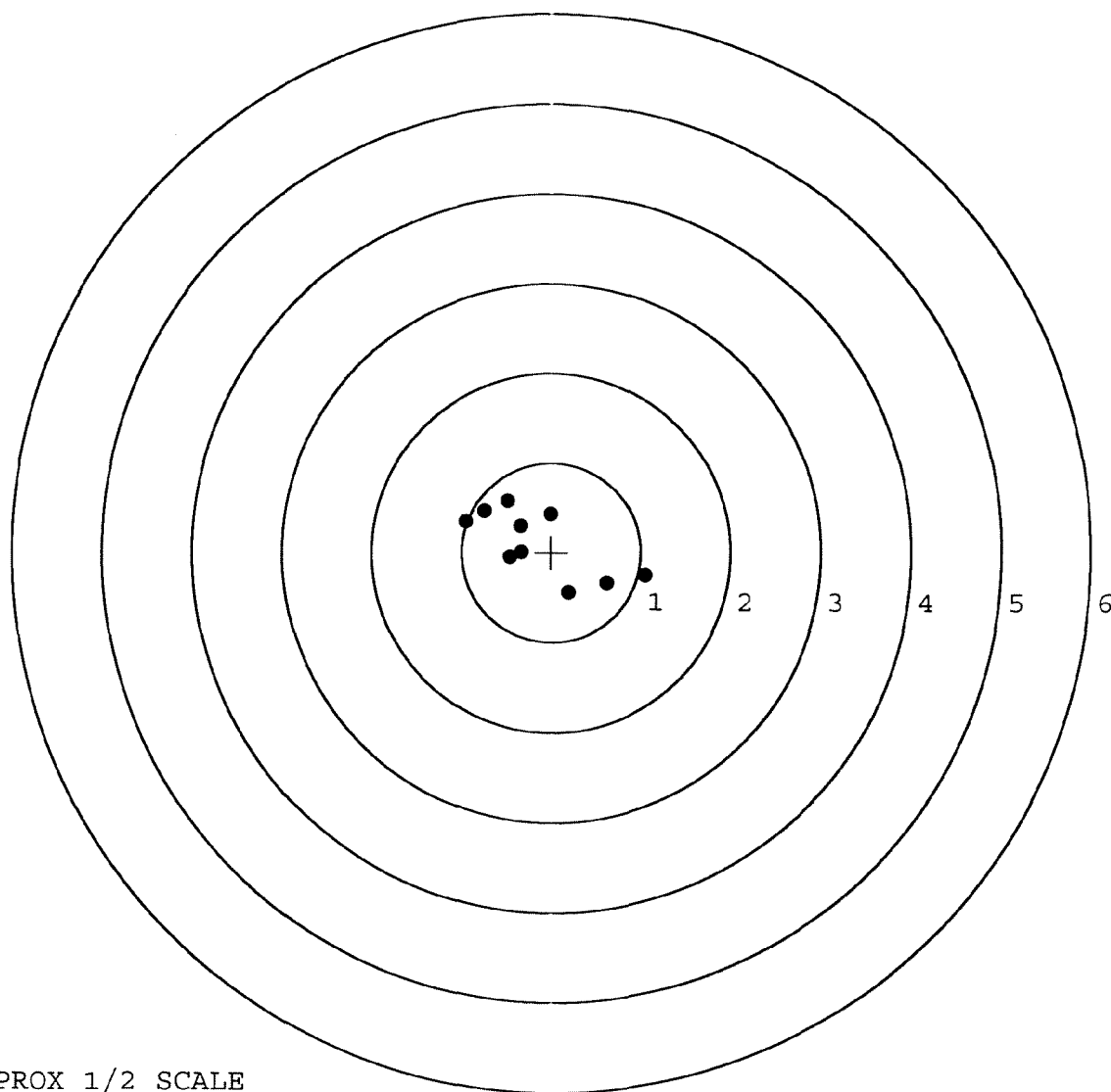


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749812.___0
TARGET NUMBER: 5
FILE DATE: 06/23/2008
FILE TIME: 05:33

POINT#	X	Y
1:	1.053	-0.262
2:	0.622	-0.342
3:	0.197	-0.451
4:	-0.461	-0.054
5:	-0.339	0.004
6:	-0.013	0.433
7:	-0.491	0.578
8:	-0.747	0.460
9:	-0.959	0.340
10:	-0.343	0.296

X CENTROID: -0.148
Y CENTROID: 0.100
POA TO CENTROID: 0.179
HORZ SPREAD: 2.012
VERT SPREAD: 1.029
GROUP SPREAD: 2.100
MIN RADIUS: 0.214
MAX RADIUS: 1.255
MEAN RADIUS: 0.612
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE