0284 9820

M/24 7.62 NATO S.W.S.

BOLT ACTION CENTERFIRE RIFLE
24" BARREL WITH MARS RAIL
COMPLETE SYSTEM – LE/EXPORT

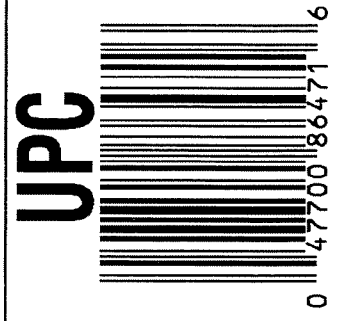
98606 – M–24 OPERATORS MANUAL
96229 – SWS SLING STRAP ASSEMBLY
96117 – TRS BI POD ASSB
96082 SCOPE RING ASSEMBLY
400061 SCOPE RING ASSEMBLY 306–09

BM FORM 1692

ORDER NO. 86471

BARREL LENGTH	24"
CAPACITY	6

G6749820



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6749820

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6/11/08	LPD
430	ASSEMBLE TO STOCK		6-12-08	TRW
440	PROOF		6-12-08	TRW
460	CHECK HEADSPACE		6-12-08	TRW
470	DIS-ASSEMBLE ACTION		6-12-08	RP
472	SERIALIZE BOLT HANDLE		6-13-08	LPD
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX JUN 2008 OPERATOR	6-16-08	TRW
480	MAGNAFLUX BBL ACTION		6/16/08	
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	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		6-23-08	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-23-08	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-23-08	RTZ
	D) OIL FIRING PIN ASSEMBLY		6-23-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

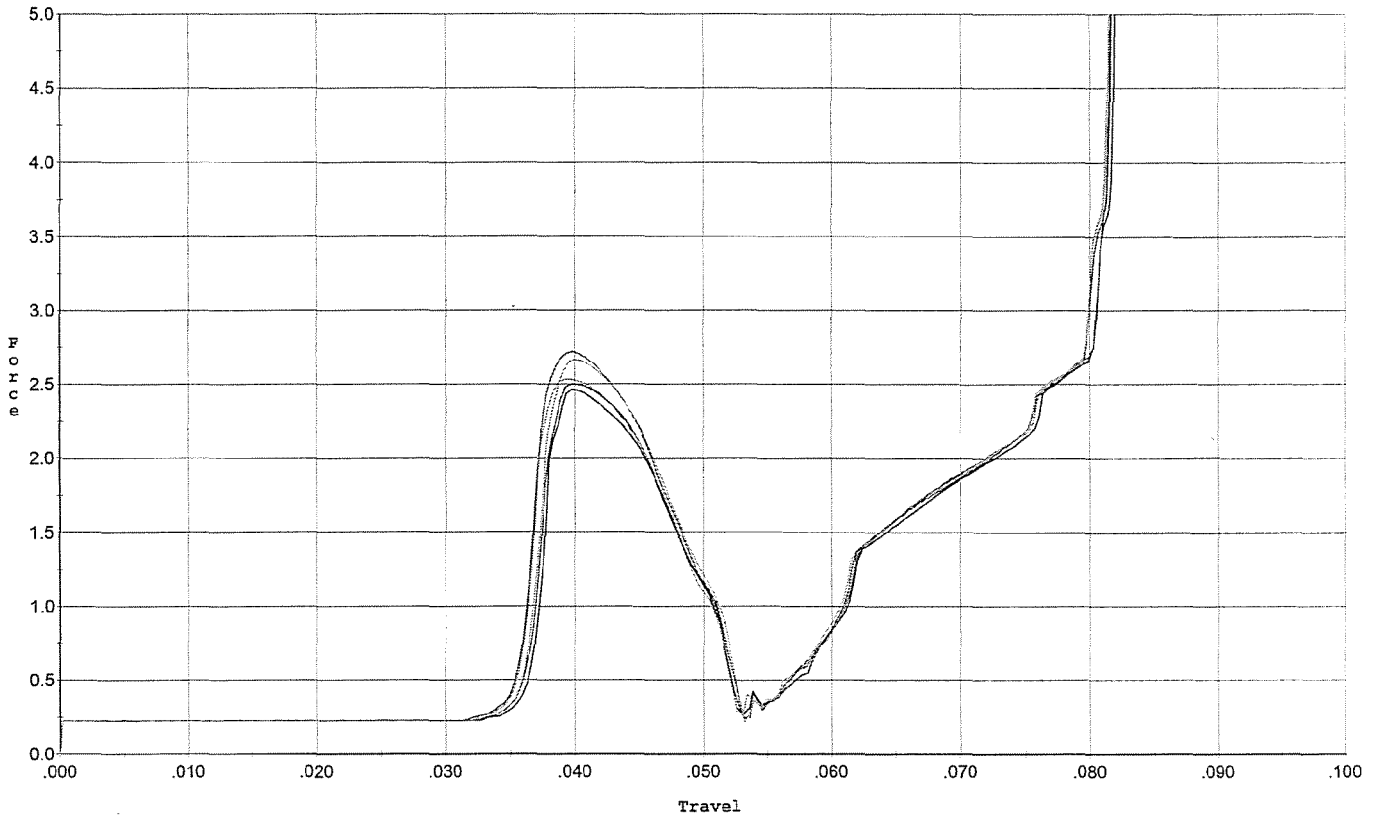
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	6.5 6.5 6.5	6/26/08	RTL
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.9 3.9 3.9	6/26/08	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.023 .023 .023	6/26/08	RTL
	J) ASSEMBLE STOCK		6/27/08	RTL
	K) ASSEMBLE SWIVEL STUDS		6.27.08	BSN
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6.27.08	BSN
	M) IRON SIGHT ALIGNMENT		6.27.08	BSN
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6.27.08	BSN
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	6-25-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-25-08	CMS
670	FINAL INSPECTION A) HEADSPACE		6.27.08	BSN
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.20 2.19 2.20 2.09 2.30	6/26/08	RTL
	C) FUNCTION			
690	PACK		6/30/08	RP

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. +/- .50 lbs.
Note:	R. Putch 5/28/08		



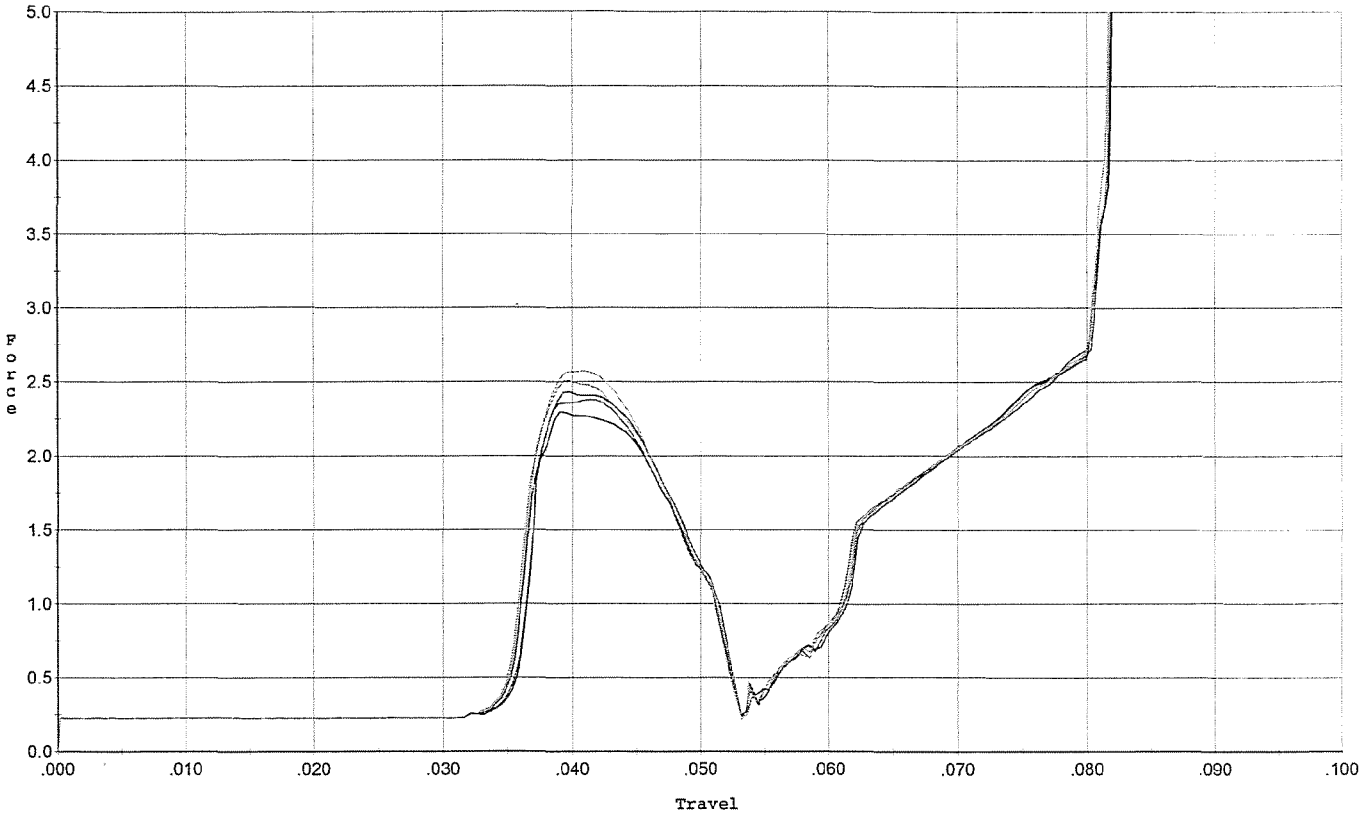
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.500	0.051	0.036	0.037	0.036		Set Trigger
2	2.465	0.051	0.036	0.037	0.035		Set Trigger
3	2.718	0.051	0.035	0.037	0.039		Set Trigger
4	2.668	0.052	0.036	0.037	0.039		Set Trigger
5	2.532	0.051	0.035	0.037	0.038		Set Trigger

Avg 2.57

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/28/2008 11:49:19 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 5/28/08		



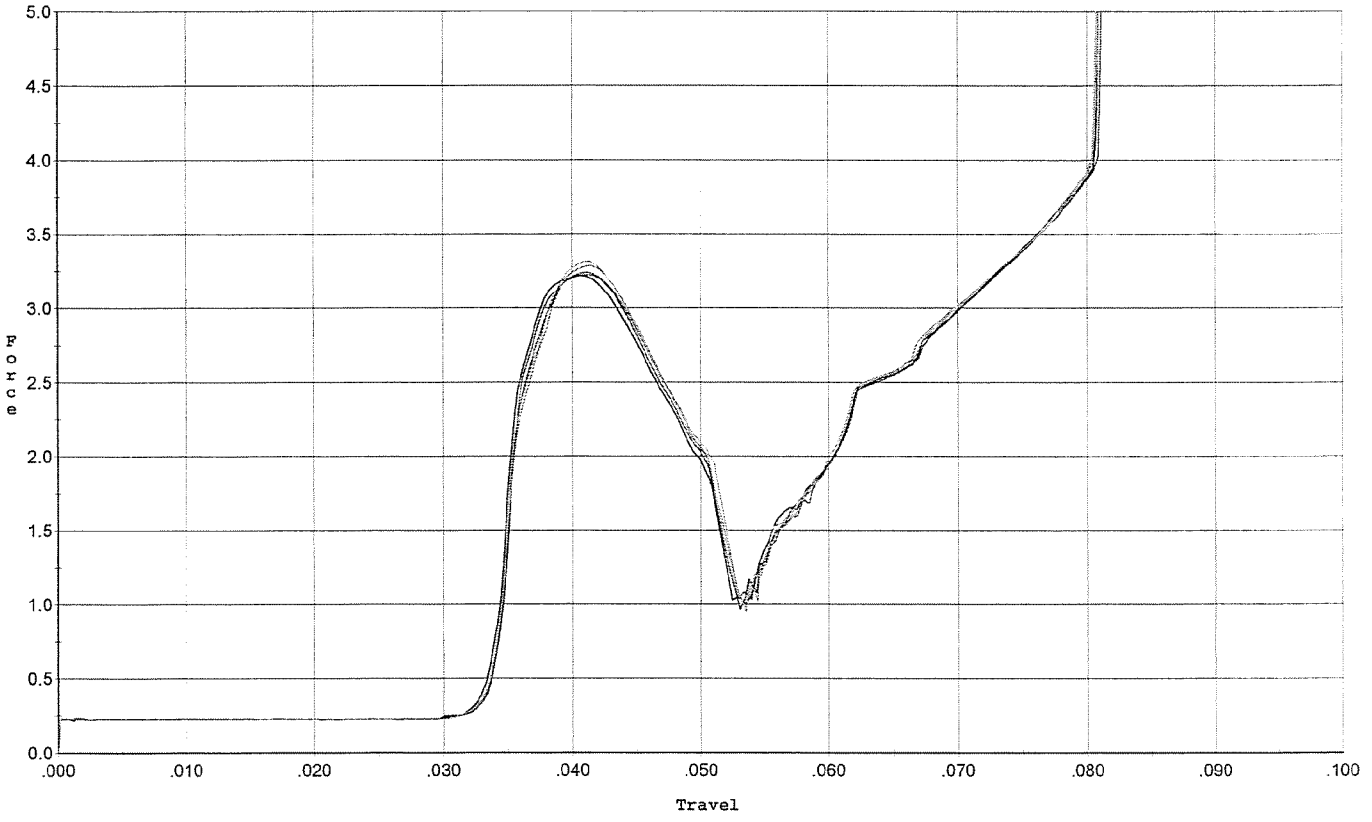
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.432	0.052	0.035	0.036	0.039		Set Trigger
2	2.298	0.051	0.035	0.037	0.036		Set Trigger
3	2.380	0.051	0.035	0.037	0.037		Set Trigger
4	2.569	0.052	0.035	0.036	0.040		Set Trigger
5	2.509	0.051	0.035	0.036	0.039		Set Trigger

Avg 2.43

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/28/2008 11:52:30 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 5/28/08		



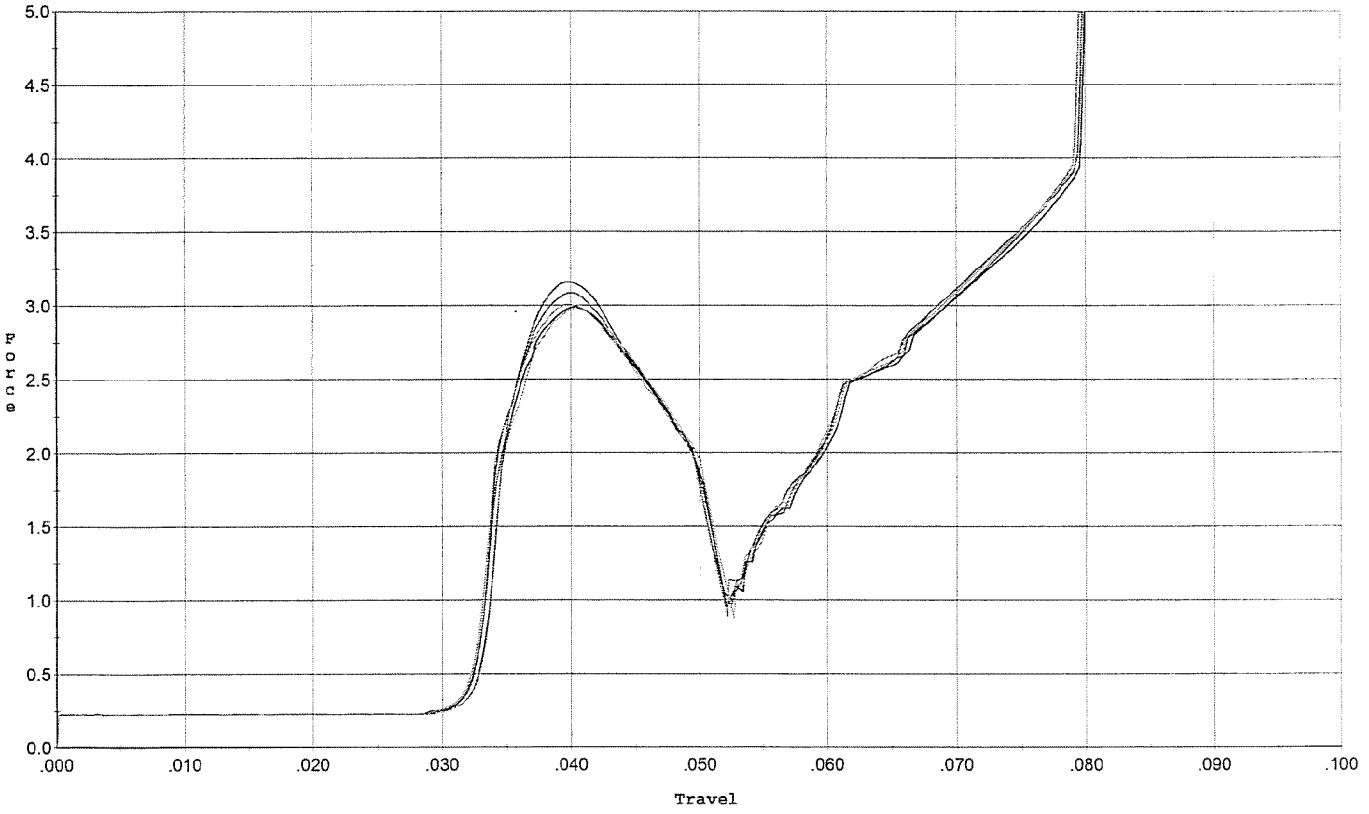
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.224	0.051	0.033	0.035	0.052		Set Trigger
2	3.216	0.051	0.033	0.035	0.052		Set Trigger
3	3.240	0.052	0.033	0.035	0.053		Set Trigger
4	3.312	0.050	0.033	0.035	0.052		Set Trigger
5	3.285	0.051	0.033	0.035	0.053		Set Trigger

Avg 3.25

Trigger Scan 2.01 ,SN 10337. printed by Remingyton Arms Co., Inc.. 5/28/2008 11:55:10 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 5/28/08		



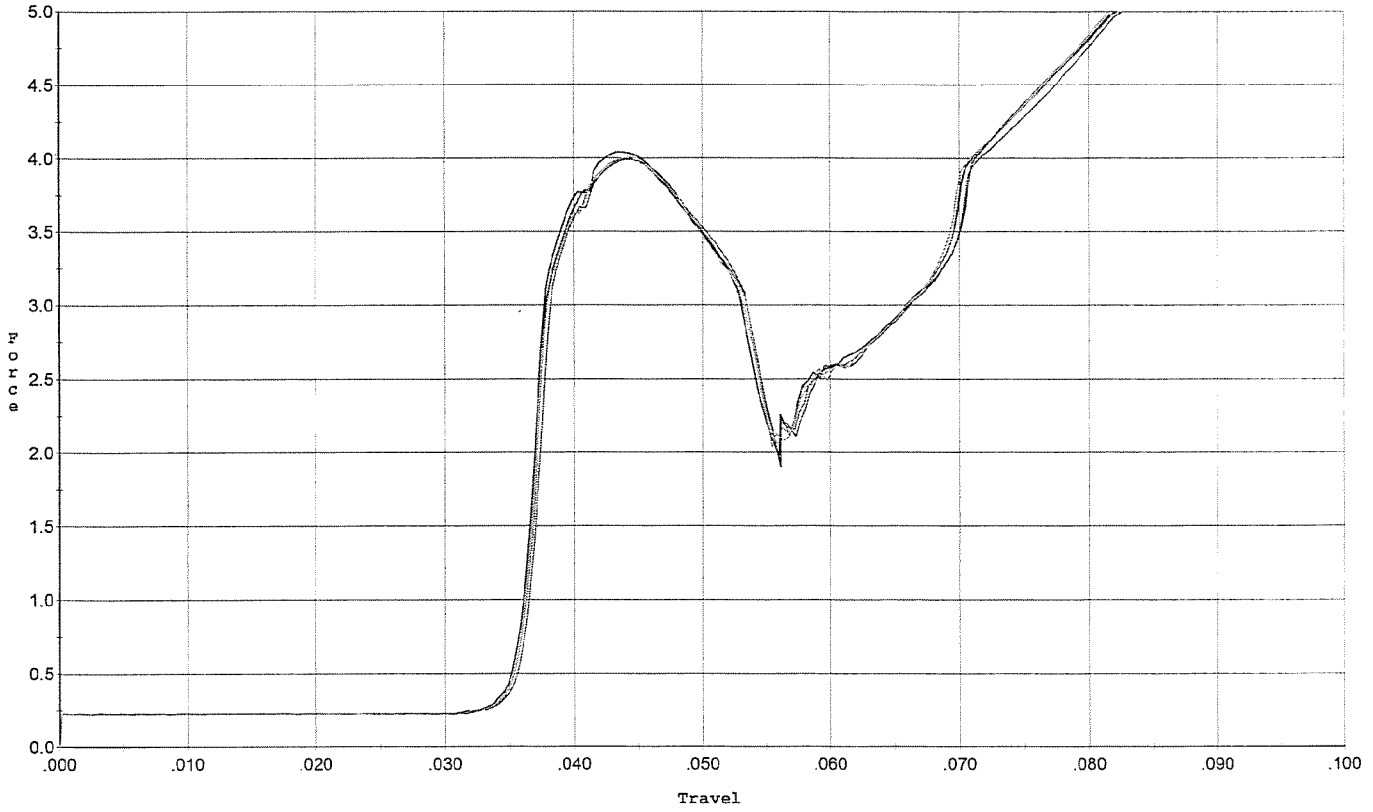
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.159	0.049	0.032	0.034	0.051		Set Trigger
2	2.992	0.050	0.032	0.034	0.050		Set Trigger
3	3.084	0.050	0.032	0.034	0.051		Set Trigger
4	2.980	0.050	0.033	0.034	0.050		Set Trigger
5	3.006	0.050	0.032	0.034	0.050		Set Trigger

Avg 3.04

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/28/2008 11:56:25 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 5/28/08		



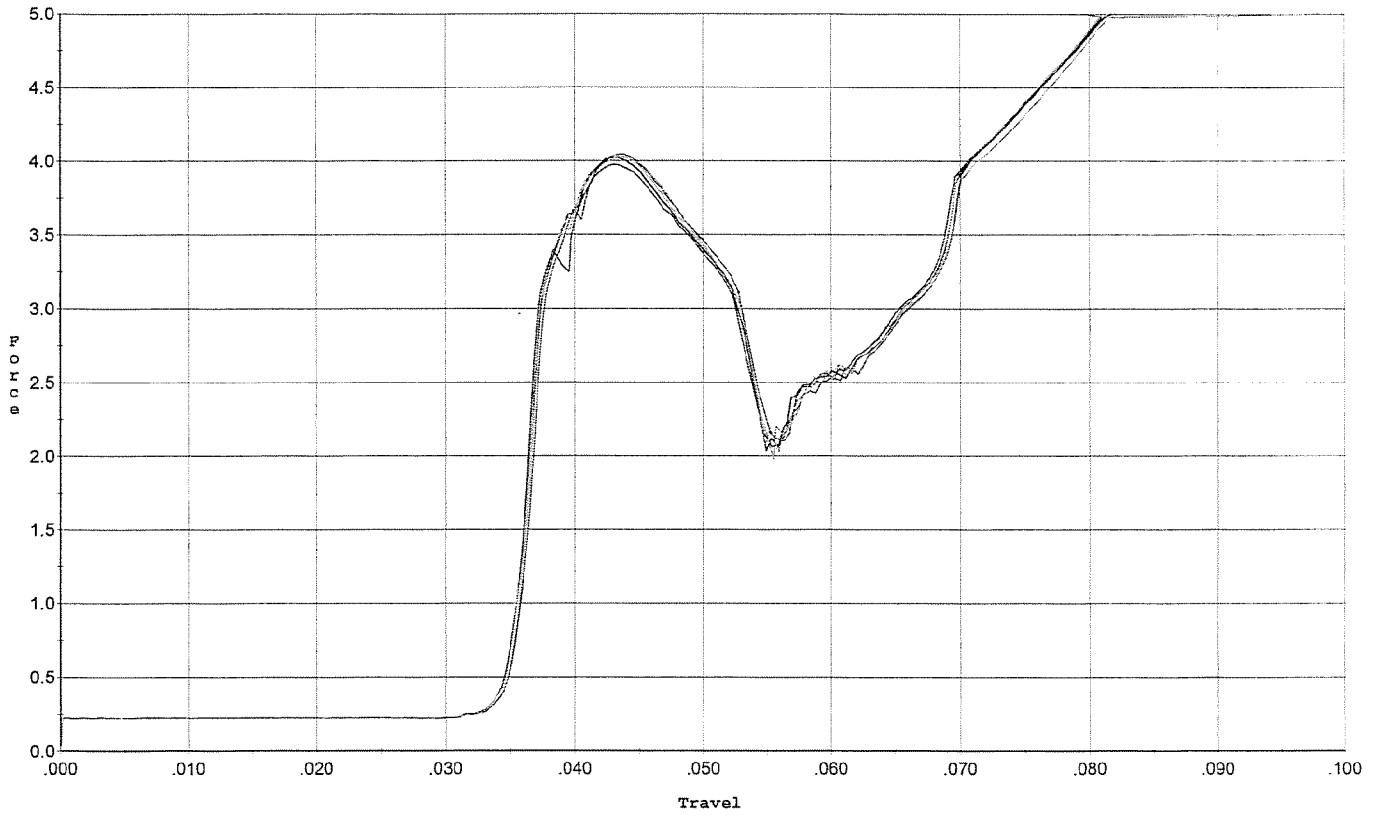
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.993	0.053	0.035	0.034	0.070		Set Trigger
2	4.041	0.053	0.035	0.034	0.070		Set Trigger
3	3.988	0.053	0.035	0.035	0.070		Set Trigger
4	4.006	0.053	0.035	0.034	0.070		Set Trigger
5	3.988	0.054	0.035	0.034	0.071		Set Trigger

Avg 4.00

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/28/2008 11:58:25 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 5/28/08		



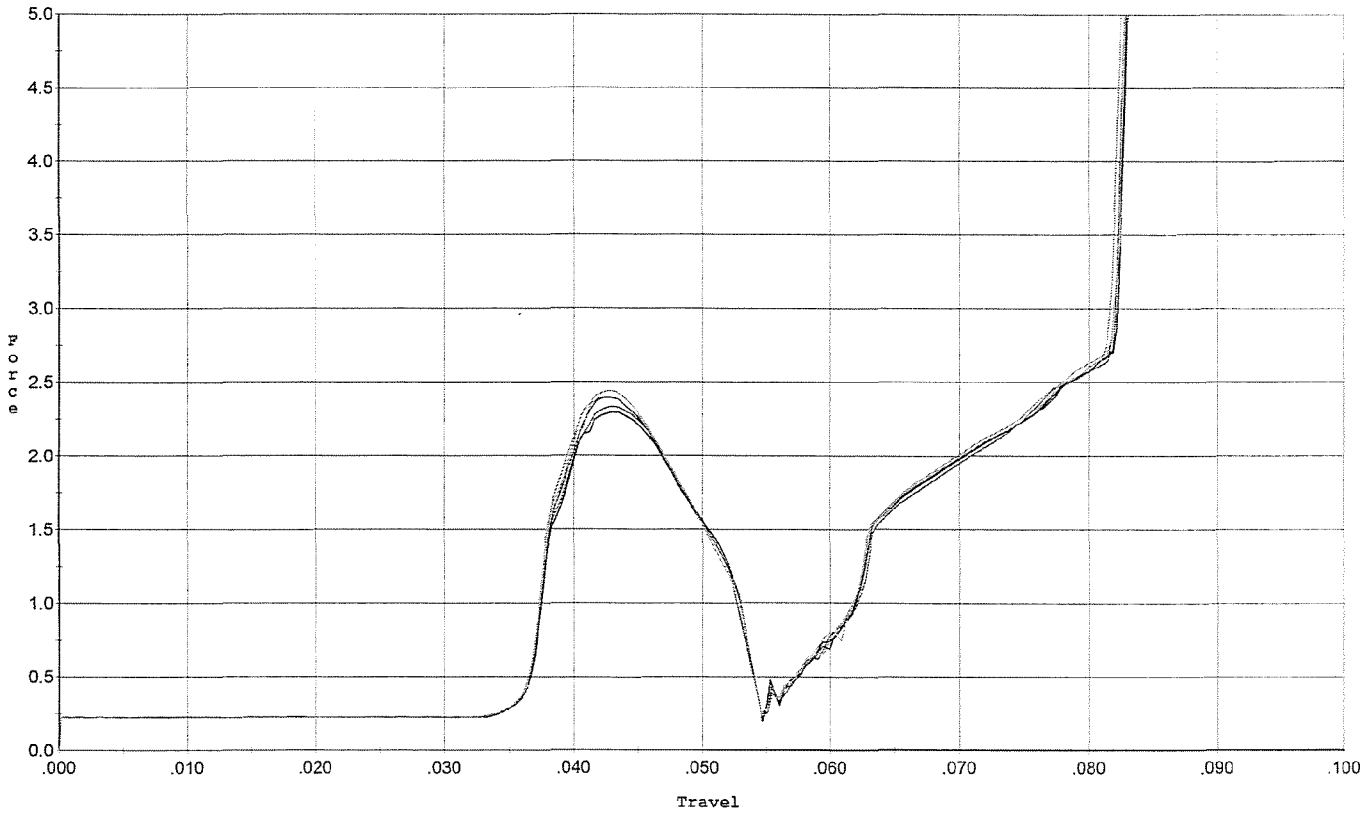
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.975	0.052	0.034	0.034	0.068		Set Trigger
2	4.023	0.053	0.034	0.034	0.071		Set Trigger
3	4.042	0.053	0.035	0.034	0.070		Set Trigger
4	4.035	0.053	0.034	0.034	0.071		Set Trigger
5	4.031	0.053	0.035	0.034	0.070		Set Trigger

Avg 4.02

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/28/2008 11:59:49 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 5/28/08		



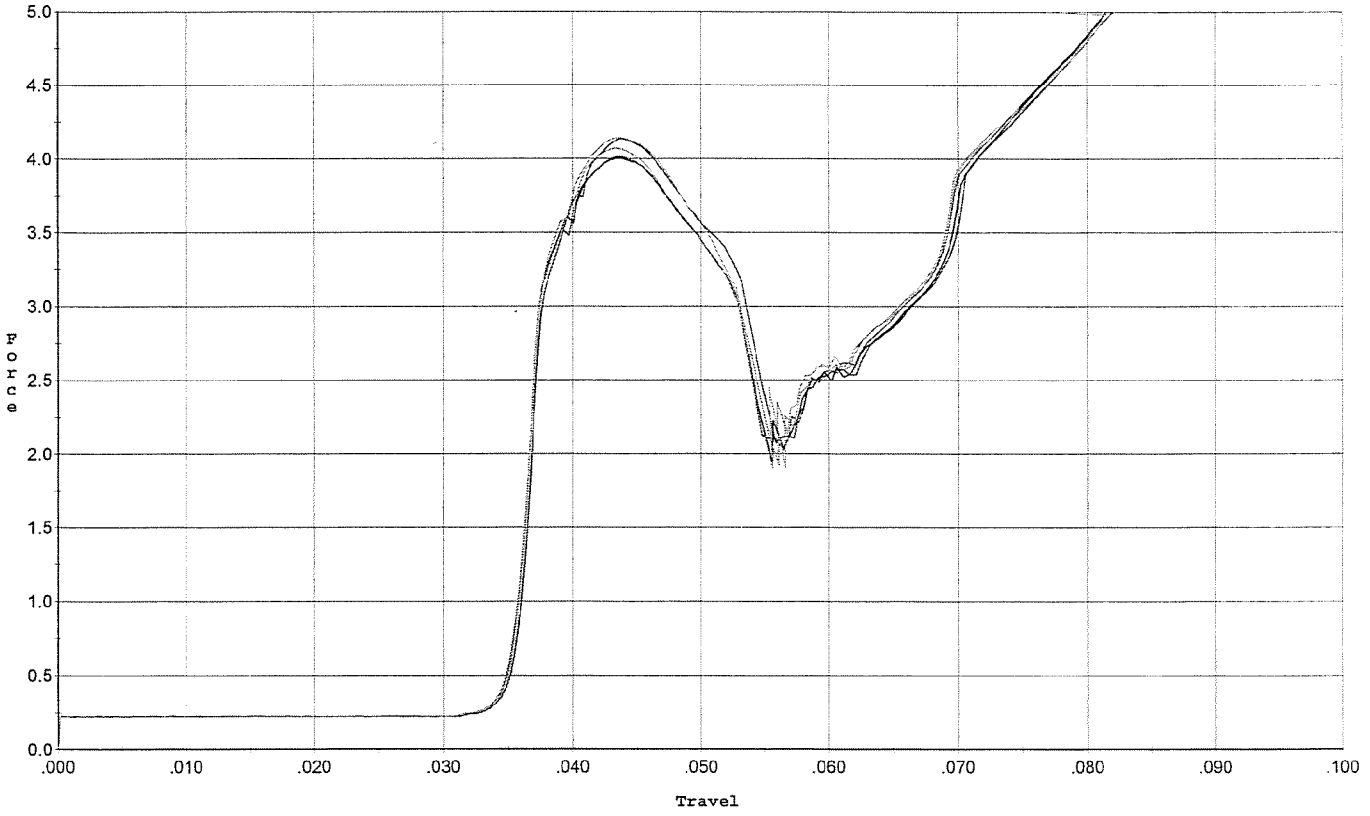
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.393	0.053	0.036	0.037	0.038		Set Trigger
2	2.295	0.053	0.036	0.037	0.038		Set Trigger
3	2.332	0.053	0.036	0.037	0.038		Set Trigger
4	2.441	0.053	0.036	0.037	0.039		Set Trigger
5	2.401	0.052	0.036	0.037	0.038		Set Trigger

Avg 2.37

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/29/2008 12:01:43 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 5/28/08		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.133	0.053	0.035	0.034	0.072		Set Trigger
2	4.002	0.053	0.035	0.034	0.070		Set Trigger
3	4.011	0.053	0.035	0.034	0.070		Set Trigger
4	4.070	0.053	0.034	0.034	0.070		Set Trigger
5	4.142	0.054	0.035	0.034	0.073		Set Trigger

Avg 4.07

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 5/29/2008 12:03:23 AM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6749820.__0
FILE DATE AND TIME: 06/25/2008 14:24

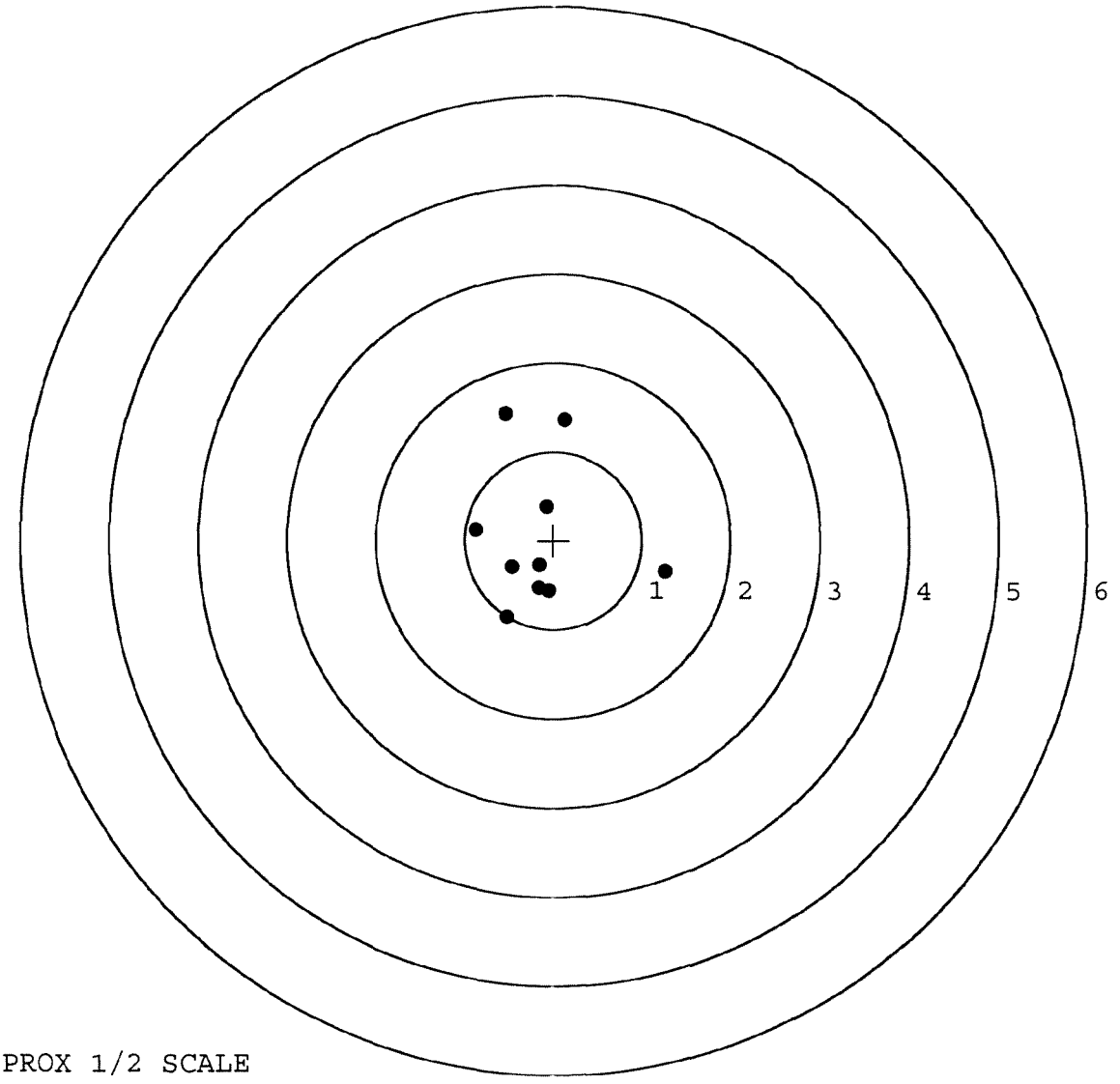
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.033
The Average Y Centroid of the Five Target Set:	-0.032
The Average Point of Impact of the Five Target Set:	0.046
The Average Mean Radius of the Five Target Set:	0.733
The Distance from POA to Centroid Target #1:	0.155
The Distance from Centroid Target #2 to Centroid Target #1:	0.272
The Distance from Centroid Target #3 to Centroid Target #1:	0.071
The Distance from Centroid Target #4 to Centroid Target #1:	0.282
The Distance from Centroid Target #5 to Centroid Target #1:	0.256

SERIAL NUMBER: G6749820.__0
TARGET NUMBER: 1
FILE DATE: 06/25/2008
FILE TIME: 14:24

X CENTROID:	-0.151
Y CENTROID:	0.037
POA TO CENTROID:	0.155
HORZ SPREAD:	2.140
VERT SPREAD:	2.294
GROUP SPREAD:	2.542
MIN RADIUS:	0.322
MAX RADIUS:	1.465
MEAN RADIUS:	0.831
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.262	-0.353
2:	-0.083	0.385
3:	-0.878	0.119
4:	-0.162	-0.285
5:	-0.057	-0.573
6:	-0.473	-0.305
7:	-0.527	-0.864
8:	0.132	1.356
9:	-0.550	1.430
10:	-0.170	-0.539

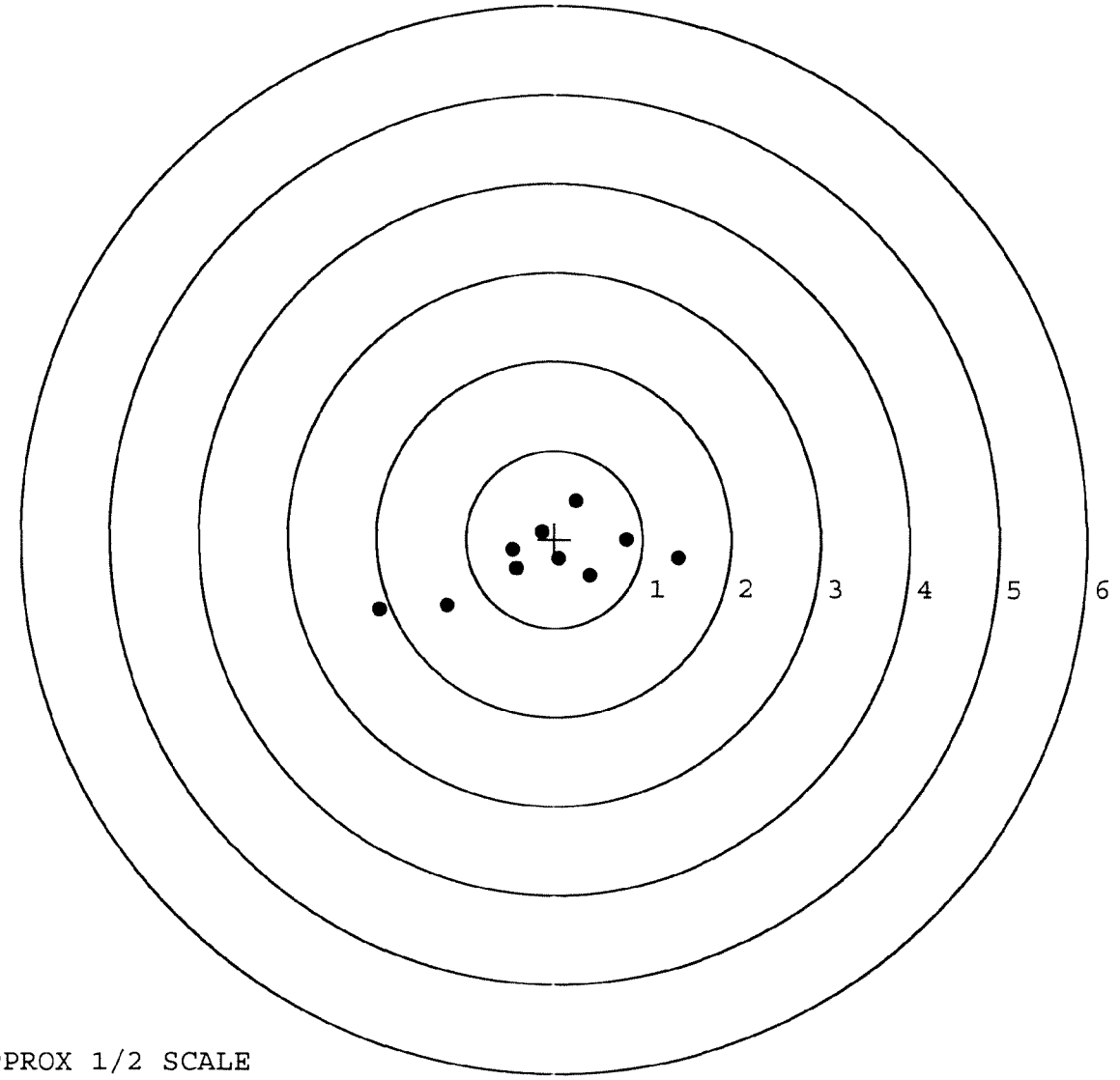


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749820.__0
TARGET NUMBER: 2
FILE DATE: 06/25/2008
FILE TIME: 14:24

X CENTROID:	-0.130
Y CENTROID:	-0.234
POA TO CENTROID:	0.268
HORZ SPREAD:	3.375
VERT SPREAD:	1.232
GROUP SPREAD:	3.425
MIN RADIUS:	0.184
MAX RADIUS:	1.923
MEAN RADIUS:	0.815
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.405	-0.209
2:	0.818	-0.003
3:	0.402	-0.410
4:	0.053	-0.222
5:	-0.144	0.083
6:	0.251	0.438
7:	-0.475	-0.126
8:	-0.428	-0.340
9:	-1.213	-0.759
10:	-1.970	-0.794

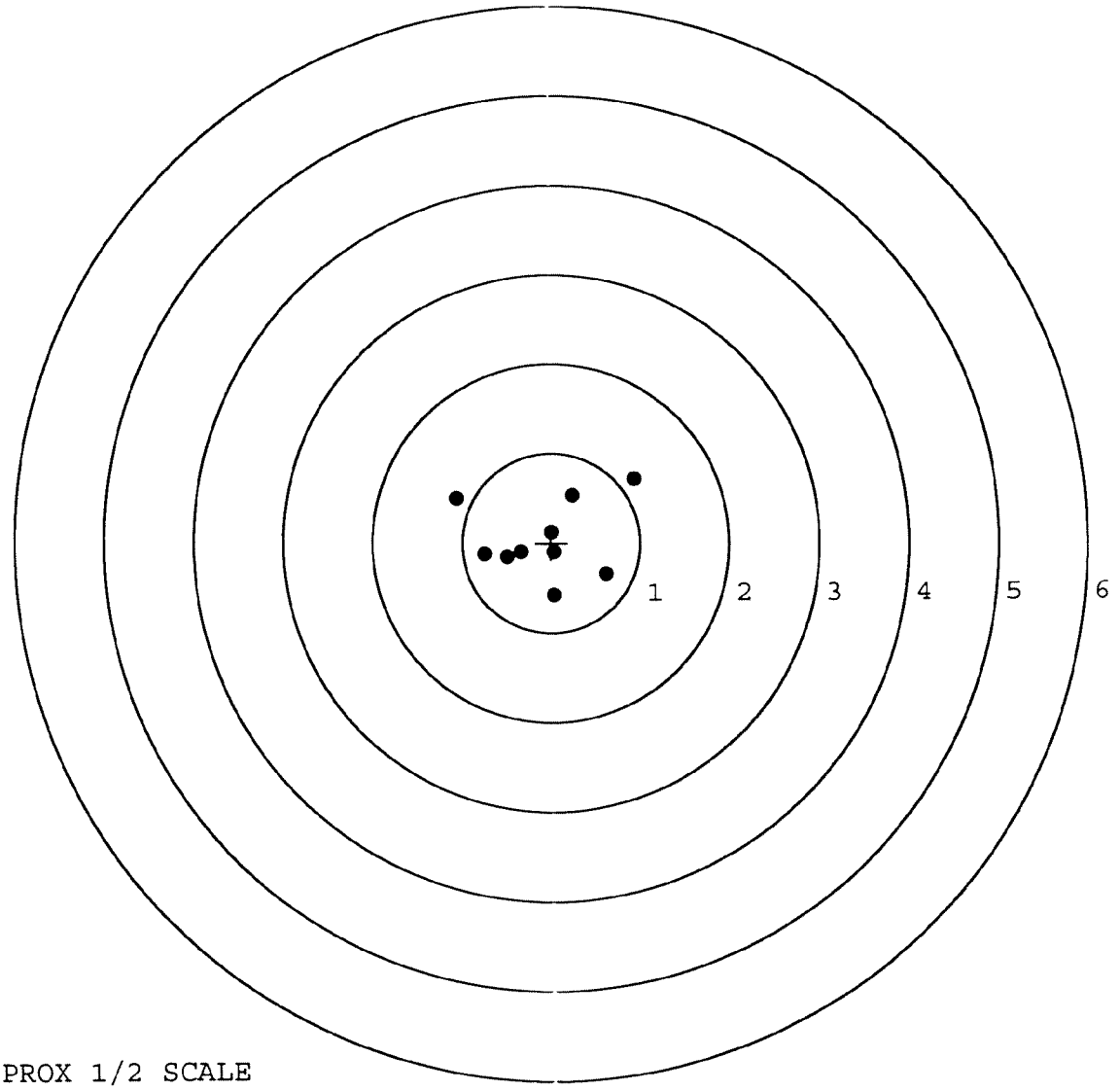


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749820.__0
TARGET NUMBER: 3
FILE DATE: 06/25/2008
FILE TIME: 14:24

X CENTROID:	-0.080
Y CENTROID:	0.043
POA TO CENTROID:	0.091
HORZ SPREAD:	2.005
VERT SPREAD:	1.292
GROUP SPREAD:	2.015
MIN RADIUS:	0.109
MAX RADIUS:	1.217
MEAN RADIUS:	0.608
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.618	-0.353
2:	0.940	0.707
3:	0.244	0.528
4:	0.029	-0.585
5:	0.032	-0.102
6:	-0.006	0.124
7:	-0.344	-0.106
8:	-0.494	-0.159
9:	-0.752	-0.124
10:	-1.065	0.503

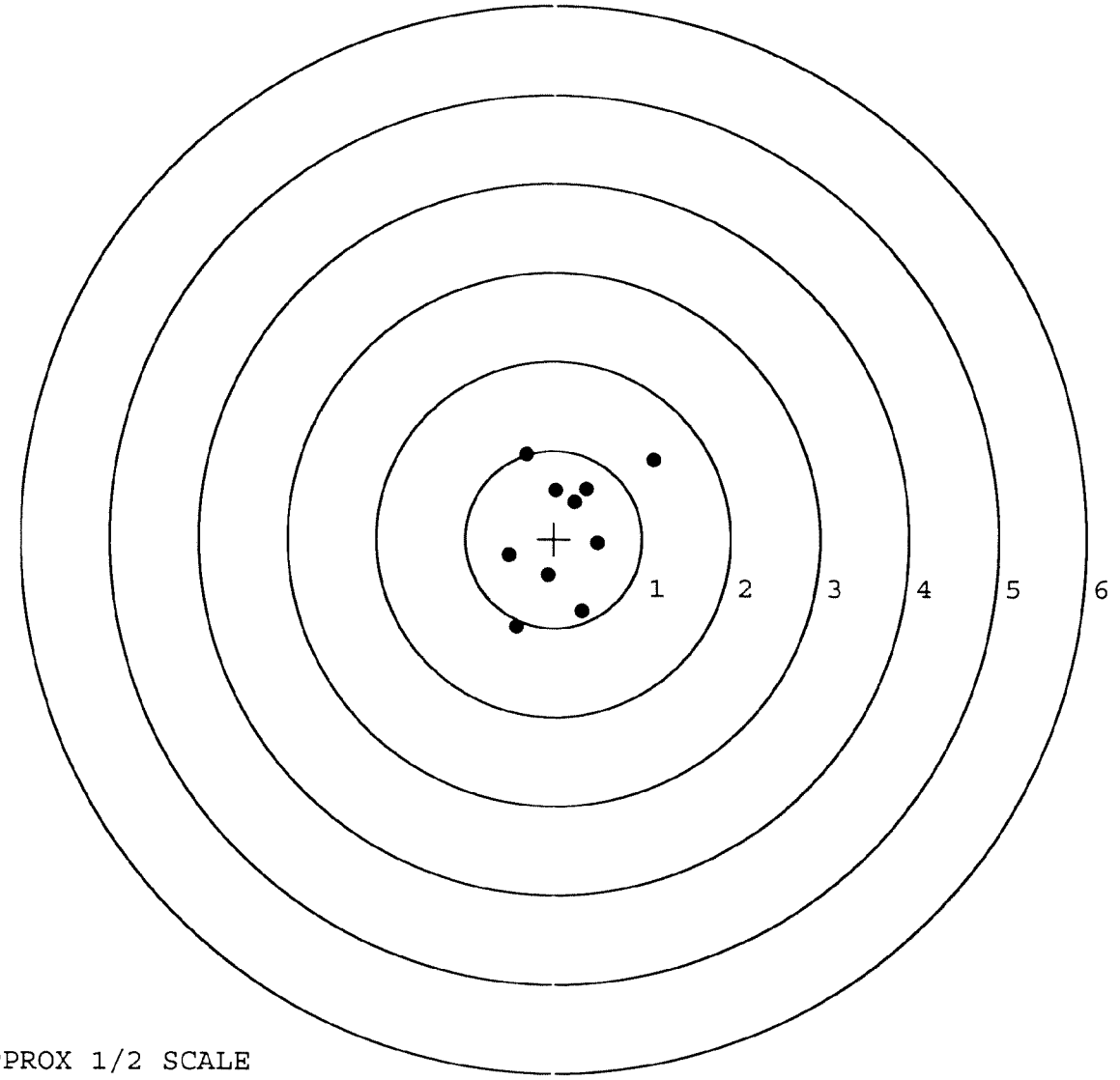


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749820.__0
TARGET NUMBER: 4
FILE DATE: 06/25/2008
FILE TIME: 14:24

X CENTROID:	0.126
Y CENTROID:	0.092
POA TO CENTROID:	0.156
HORZ SPREAD:	1.642
VERT SPREAD:	1.956
GROUP SPREAD:	2.451
MIN RADIUS:	0.342
MAX RADIUS:	1.288
MEAN RADIUS:	0.738
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.132	0.896
2:	0.371	0.562
3:	0.234	0.416
4:	0.025	0.547
5:	-0.313	0.958
6:	0.498	-0.048
7:	0.321	-0.816
8:	-0.069	-0.413
9:	-0.510	-0.187
10:	-0.424	-0.998

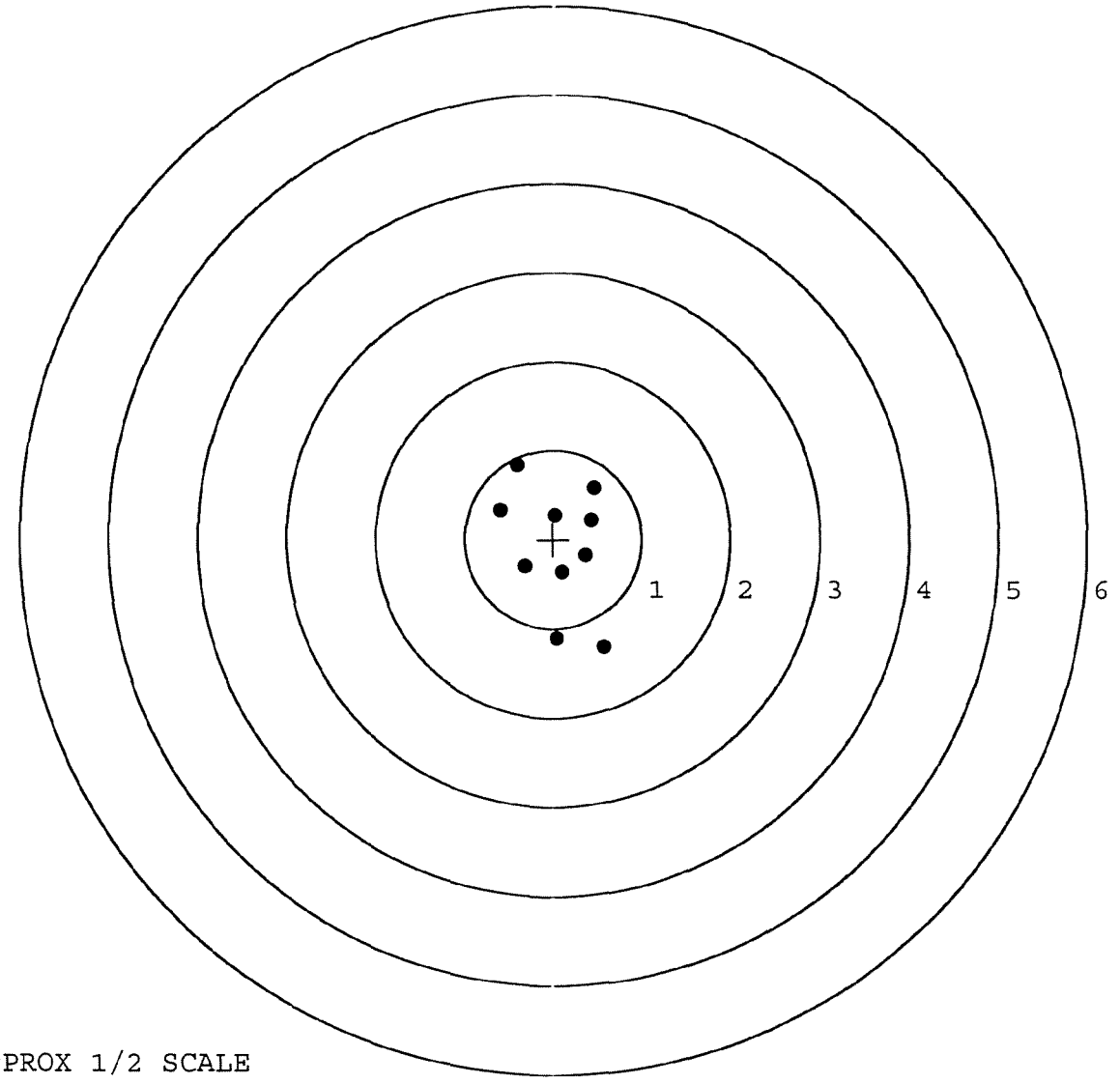


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6749820.__0
TARGET NUMBER: 5
FILE DATE: 06/25/2008
FILE TIME: 14:24

X CENTROID:	0.067
Y CENTROID:	-0.097
POA TO CENTROID:	0.118
HORZ SPREAD:	1.182
VERT SPREAD:	2.040
GROUP SPREAD:	2.267
MIN RADIUS:	0.273
MAX RADIUS:	1.226
MEAN RADIUS:	0.675
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.576	-1.212
2:	0.043	-1.115
3:	0.106	-0.367
4:	0.370	-0.185
5:	0.430	0.219
6:	0.464	0.577
7:	0.025	0.272
8:	-0.325	-0.309
9:	-0.606	0.325
10:	-0.412	0.828



TARGET APPROX 1/2 SCALE