

G 663 5 215

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

- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO. **25732**

BARREL LENGTH **24"**

CAPACITY **5**

G6635215

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

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SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6635215

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-7-07	RTZ
420	ASSEMBLE ACTION		5-4-07	SPD
430	ASSEMBLE TO STOCK		5-7-07	TRW
440	PROOF	MAGNA - FLUX	5-7-07	Fm
460	CHECK HEADSPACE	MAY 10 2008	5-7-07	Fm
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	5/10/07	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-9-07	CW
510	DRILL AND TAP SIGHT HOLES		5-9-07	TRW
520	GOFF BLAST BBL / REC		5-10-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5-17-07	W
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-07	SPD
	D) OIL FIRING PIN ASSEMBLY		5-25-07	SPD
	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>65</u> <u>60</u> <u>60</u>	6-1-07	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>25</u> <u>2.5</u> <u>2.5</u>	6-1-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		6-1-07	DA
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	6-1-07	DA
	J) ASSEMBLE STOCK		5-25-07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		6-6-07	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	5/30/07	nm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-30-07	SD
670	FINAL INSPECTION A) HEADSPACE		6-6-07	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>284</u> <u>282</u> <u>276</u> <u>288</u> <u>289</u>	6-1-07	DA
	C) FUNCTION		6-6-07	L.P.D.
690	PACK		6-11-07	DA

F004 REV 5/2006

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 5-25-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.46		2.58	
PULL #2	2.54	2.65		2.57	
PULL #3	2.51	2.67		2.51	
PULL #4	2.51	2.55		2.61	
PULL #5	2.49	2.51		2.64	
TOTAL	12.55	12.84		12.91	
AVERAGE	2.51	2.56		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.06		
PULL #2	3.17	3.27		
PULL #3	3.17	3.23		
PULL #4	3.40	3.31		
PULL #5	3.20	3.12		
TOTAL	16.07	15.99		
AVERAGE	3.21	3.19		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	4.38	4.33		4.61
PULL #2	4.43	4.47		4.59
PULL #3	4.35	4.45		4.71
PULL #4	4.30	4.49		4.74
PULL #5	4.41	4.39		4.53
TOTAL	21.87	22.13		23.18
AVERAGE	4.37	4.42		4.63

EXAMINATION REQUIRED: MAG-TRIGGER ASSEMBLY

5005 REV 5/2006

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400143805

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6635215.___0
FILE DATE AND TIME: 05/31/2007 01:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.031
The Average Y Centroid of the Five Target Set:	-0.047
The Average Point of Impact of the Five Target Set:	0.057
The Average Mean Radius of the Five Target Set:	0.634
The Distance from POA to Centroid Target #1:	0.121
The Distance from Centroid Target #2 to Centroid Target #1:	0.231
The Distance from Centroid Target #3 to Centroid Target #1:	0.389
The Distance from Centroid Target #4 to Centroid Target #1:	0.142
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: G6635215. __0

TARGET NUMBER: 1

FILE DATE: 05/31/2007

FILE TIME: 01:11

POINT#	X	Y
1:	-0.353	0.629
2:	-0.040	0.320
3:	0.093	0.717
4:	0.776	0.553
5:	-0.038	-0.208
6:	0.296	-0.386
7:	0.163	-0.535
8:	-0.020	-0.593
9:	-0.452	-0.738
10:	-0.184	-0.942

X CENTROID: 0.024

Y CENTROID: -0.118

POA TO CENTROID: 0.121

HORZ SPREAD: 1.228

VERT SPREAD: 1.659

GROUP SPREAD: 1.782

MIN RADIUS: 0.109

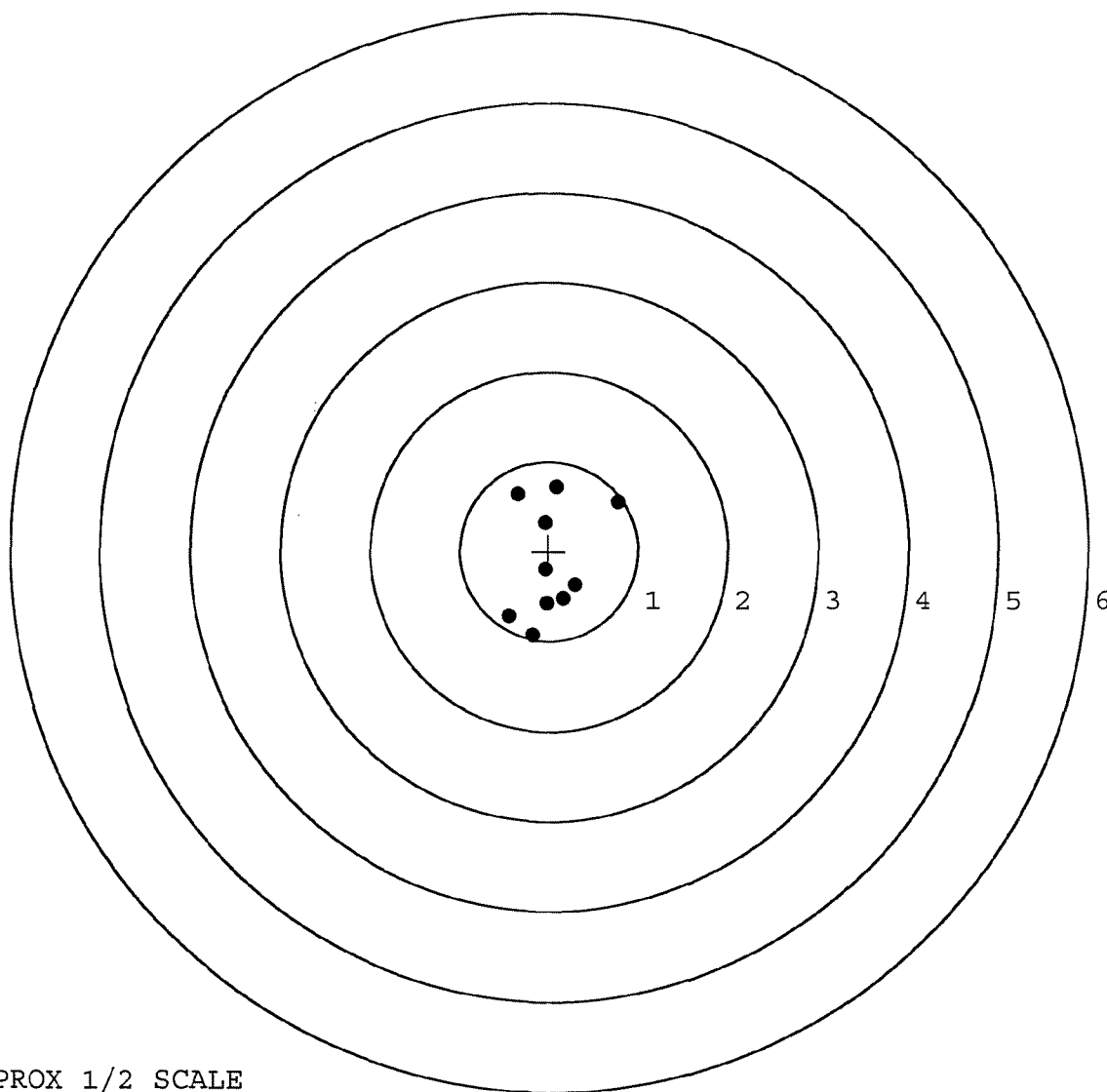
MAX RADIUS: 1.008

MEAN RADIUS: 0.616

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635215. __ 0

TARGET NUMBER: 2

FILE DATE: 05/31/2007

FILE TIME: 01:11

POINT#	X	Y
1:	-0.266	1.602
2:	-0.252	0.653
3:	-0.005	0.327
4:	0.404	0.487
5:	0.284	0.151
6:	0.506	-0.054
7:	-0.340	0.026
8:	-0.566	-0.467
9:	-0.346	-0.982
10:	0.247	-0.693

X CENTROID: -0.033

Y CENTROID: 0.105

POA TO CENTROID: 0.110

HORZ SPREAD: 1.072

VERT SPREAD: 2.584

GROUP SPREAD: 2.585

MIN RADIUS: 0.224

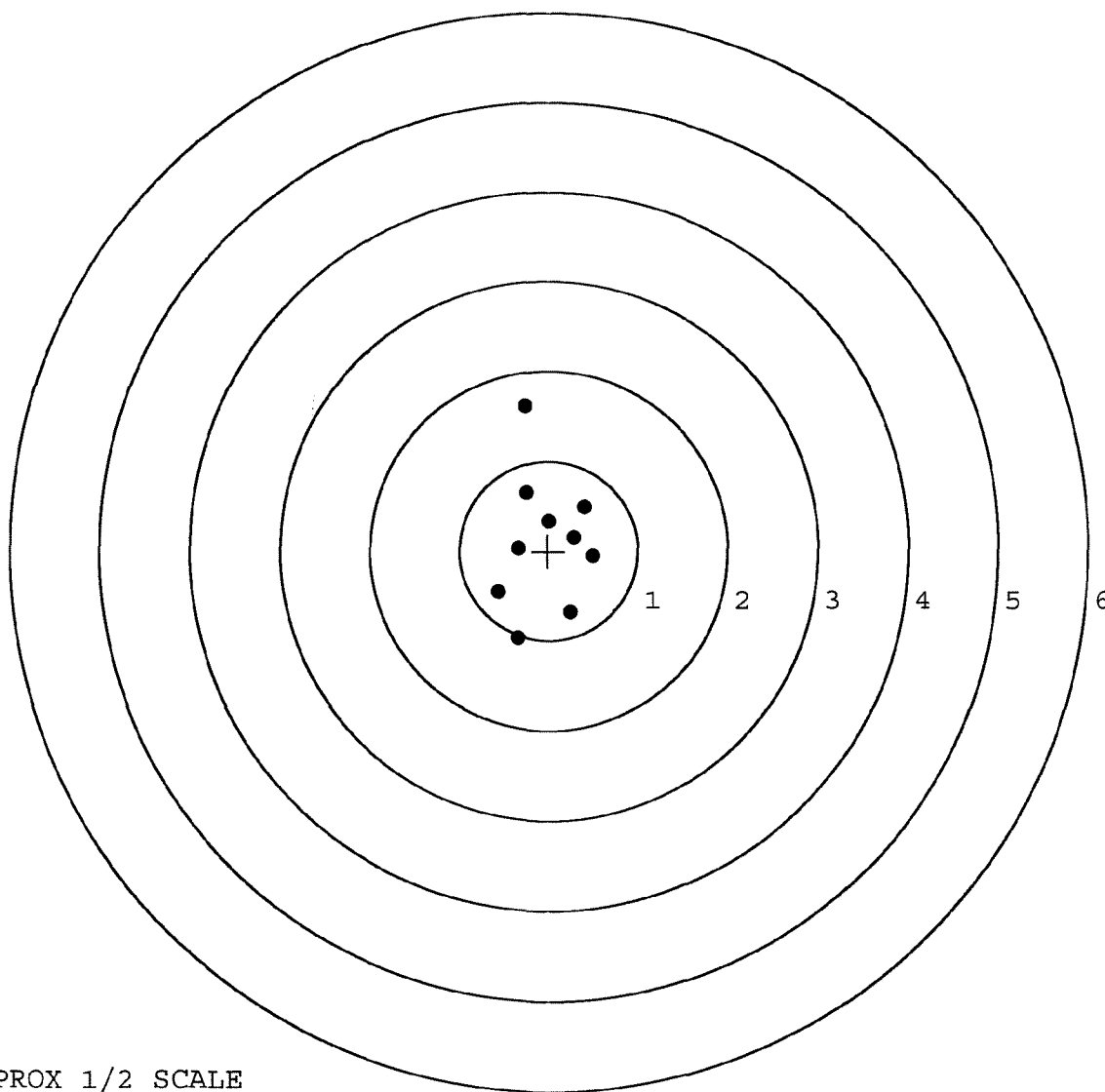
MAX RADIUS: 1.515

MEAN RADIUS: 0.687

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635215. __0

TARGET NUMBER: 3

FILE DATE: 05/31/2007

FILE TIME: 01:11

POINT#	X	Y
1:	-0.559	0.737
2:	0.527	0.791
3:	0.758	0.496
4:	1.598	0.063
5:	1.492	-0.736
6:	0.408	0.130
7:	0.229	0.199
8:	-0.579	-0.194
9:	-0.428	-0.524
10:	0.433	-0.773

X CENTROID: 0.388

Y CENTROID: 0.019

POA TO CENTROID: 0.388

HORZ SPREAD: 2.177

VERT SPREAD: 1.564

GROUP SPREAD: 2.525

MIN RADIUS: 0.113

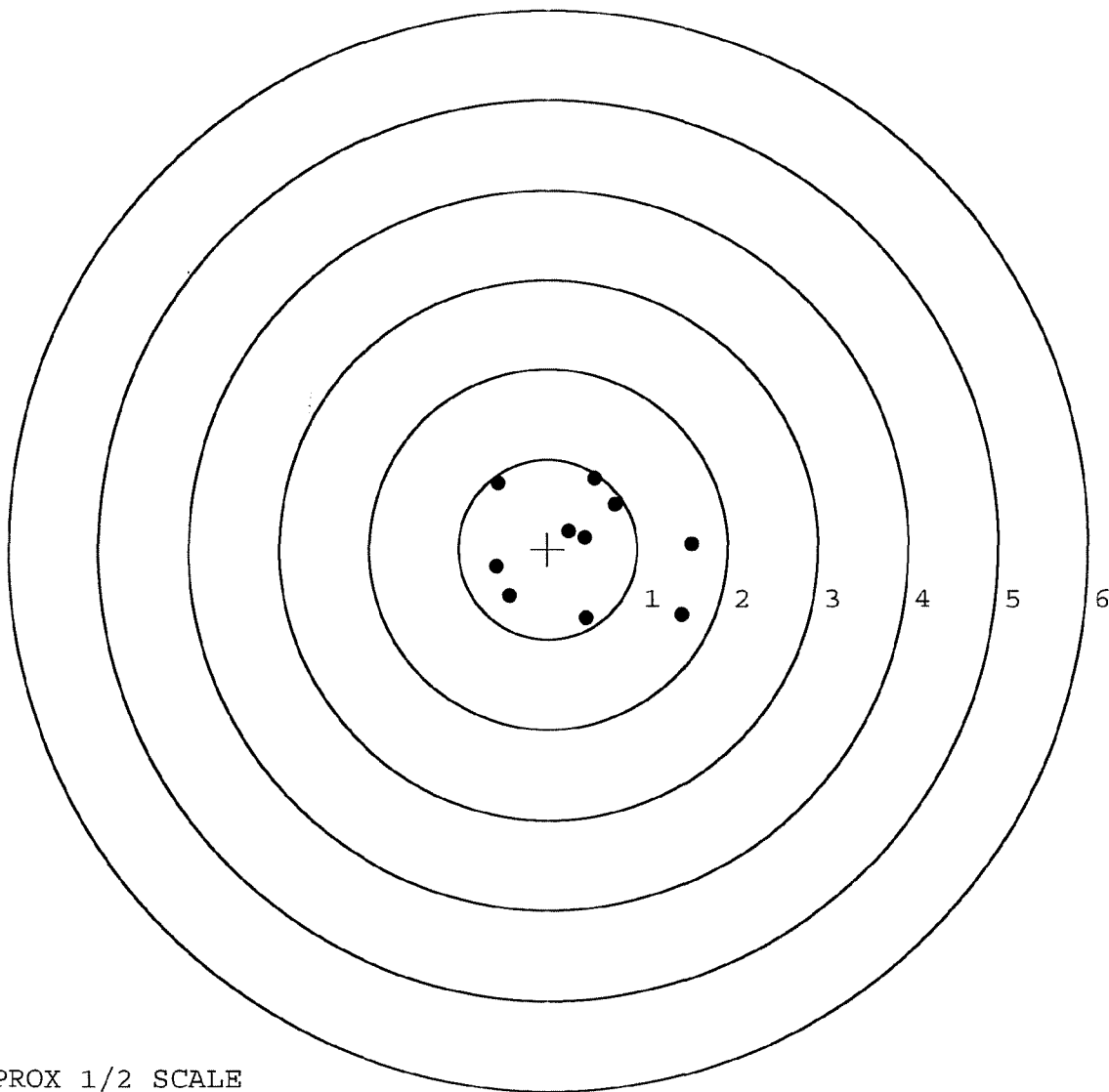
MAX RADIUS: 1.338

MEAN RADIUS: 0.824

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635215. __0

TARGET NUMBER: 4

FILE DATE: 05/31/2007

FILE TIME: 01:11

POINT#	X	Y
1:	-0.692	0.198
2:	-0.745	-0.025
3:	-0.253	-0.723
4:	0.316	-0.097
5:	0.105	0.201
6:	0.477	0.455
7:	0.697	0.302
8:	-0.339	-0.059
9:	-0.229	-0.361
10:	-0.149	-0.117

X CENTROID: -0.081

Y CENTROID: -0.023

POA TO CENTROID: 0.084

HORZ SPREAD: 1.442

VERT SPREAD: 1.178

GROUP SPREAD: 1.479

MIN RADIUS: 0.116

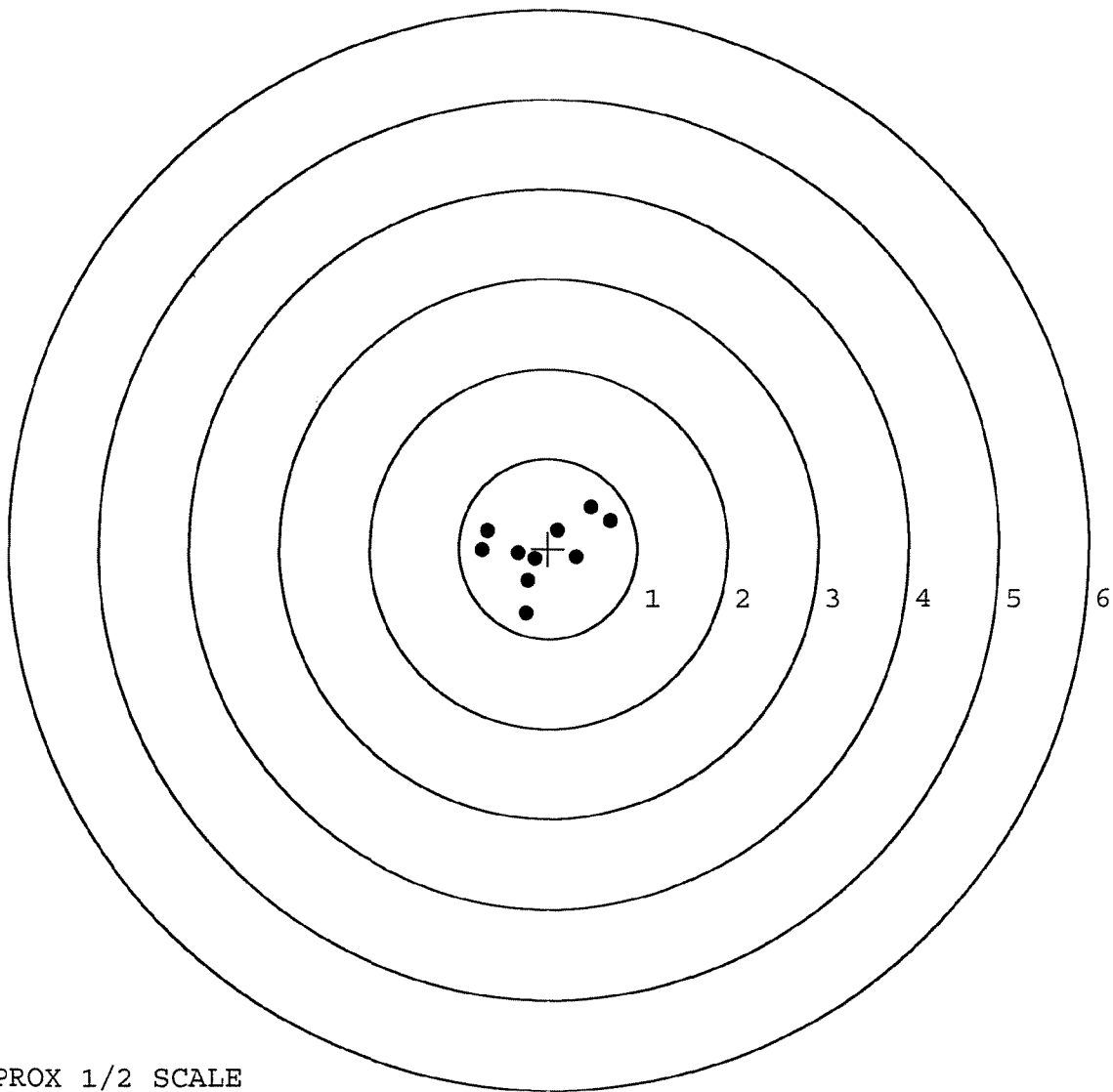
MAX RADIUS: 0.843

MEAN RADIUS: 0.505

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635215. __0

TARGET NUMBER: 5

FILE DATE: 05/31/2007

FILE TIME: 01:11

POINT#	X	Y
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1:	0.160	0.326
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2:	0.263	0.485
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3:	-0.271	0.695
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4:	-0.086	-0.124
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5:	-0.005	-0.353
----	--------	--------

6:	0.242	-0.465
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7:	-0.384	-0.469
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8:	-0.248	-0.580
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9:	-0.523	-0.725
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10:	-0.571	-0.994
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X CENTROID: -0.142

Y CENTROID: -0.220

POA TO CENTROID: 0.262

HORZ SPREAD: 0.834

VERT SPREAD: 1.689

GROUP SPREAD: 1.715

MIN RADIUS: 0.112

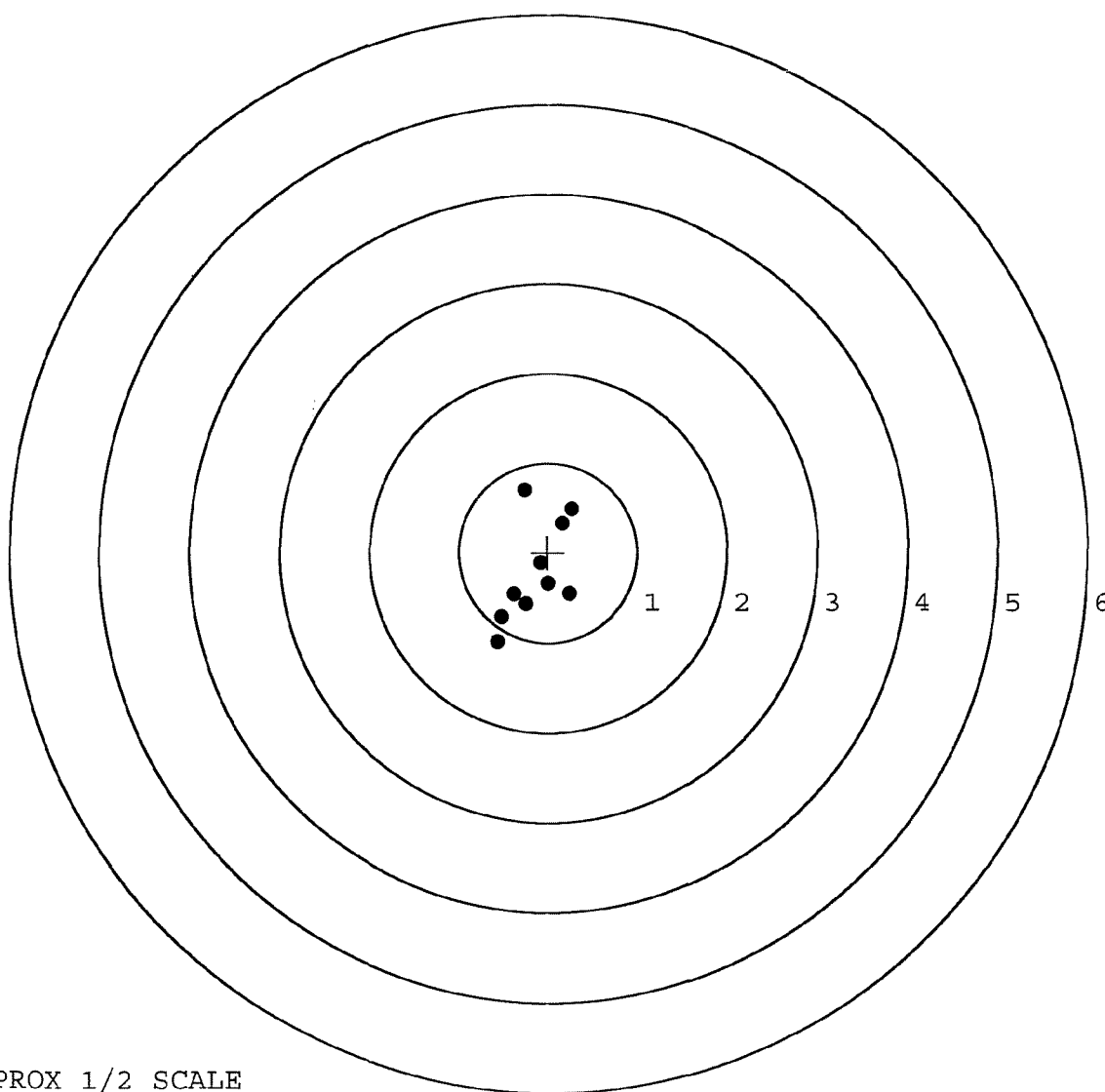
MAX RADIUS: 0.924

MEAN RADIUS: 0.536

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE