GC637691

ORDER 25716

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

UPC

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UPC

SERIAL NO.

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

G6637691

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G663 7691

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		4-13-07	RTZ
420	ASSEMBLE ACTION		4/13/07	[illegible]
430	ASSEMBLE TO STOCK		4-16-07	TRW
440	PROOF	MAGNA - FLUX APR 19 2007	4-16-07	FM
460	CHECK HEADSPACE		4-16-07	FM
470	DIS-ASSEMBLE ACTION		4-16-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR APD	4-19-07	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-19-07	CW
510	DRILL AND TAP SIGHT HOLES		4-18-07	SD
520	GOFF BLAST BBL / REC		4/19/07	[illegible]
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		4/25/07	W
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		4-25-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-25-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-25-07	SD
	D) OIL FIRING PIN ASSEMBLY		4/26/07	[illegible]
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6/8/07	[illegible]

F004 REV 5/2006

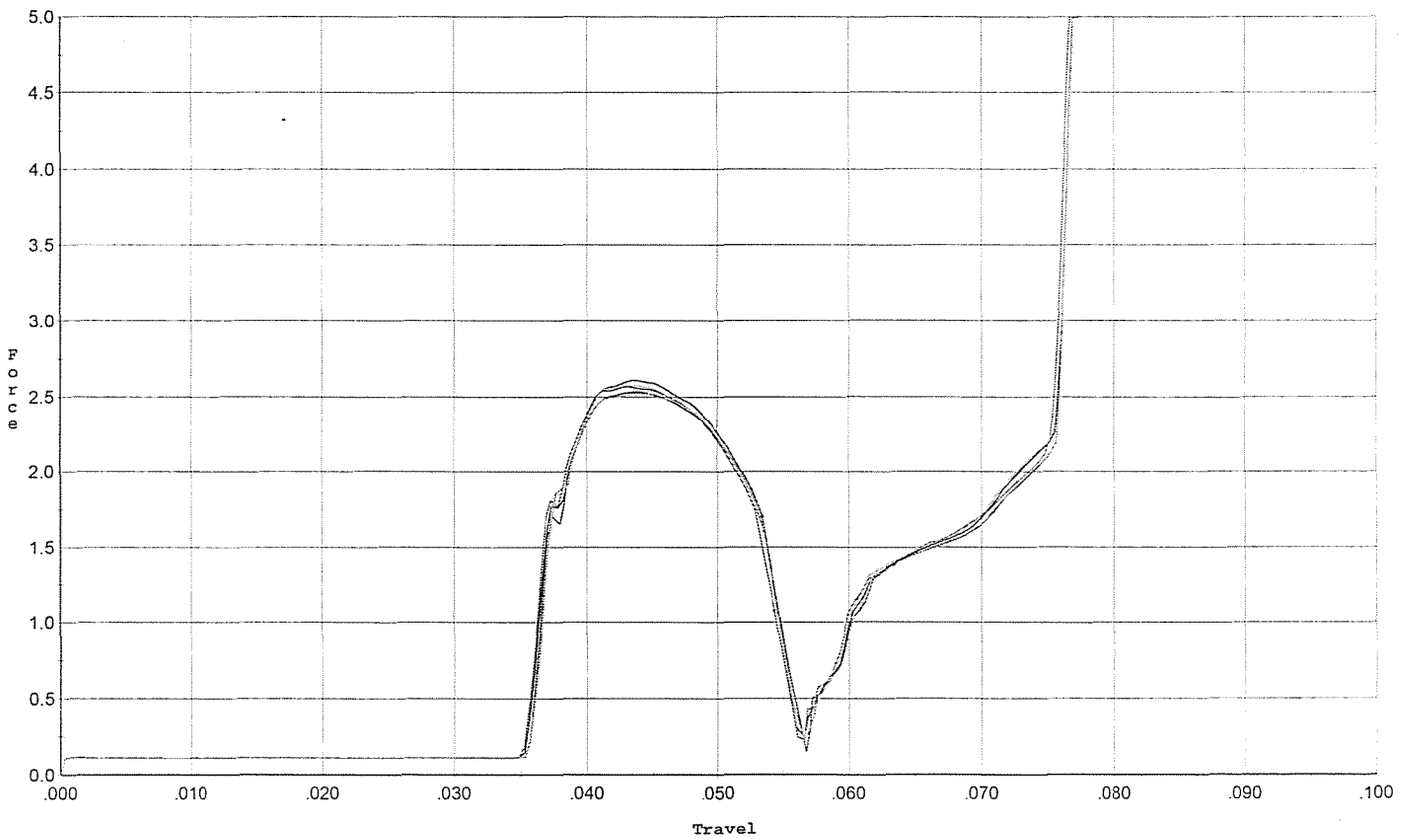
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	9.0 9.25 8.75	5-21-07	TRW
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	2.75 3.0 3.25	5-21-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		6/8/07	
	I) FIRING PIN INDENT (.020 MIN)	.023⁵ .023⁵ .023	5-21-07	TRW
	J) ASSEMBLE STOCK		4/26/07	
	K) ASSEMBLE SWIVEL STUDS		6-13-07	
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6/8/07	
	M) IRON SIGHT ALIGNMENT		6/8/07	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6/8/07	
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL / (PASS) FAIL	4-27-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-27-07	CAS
670	FINAL INSPECTION A) HEADSPACE		6/8/07	
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.37 2.38 2.29 2.30 2.20	5-21-07	TRW
	C) FUNCTION		6/8/07	
690	PACK		6-15-07	DH

N/A

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 4/26/07		



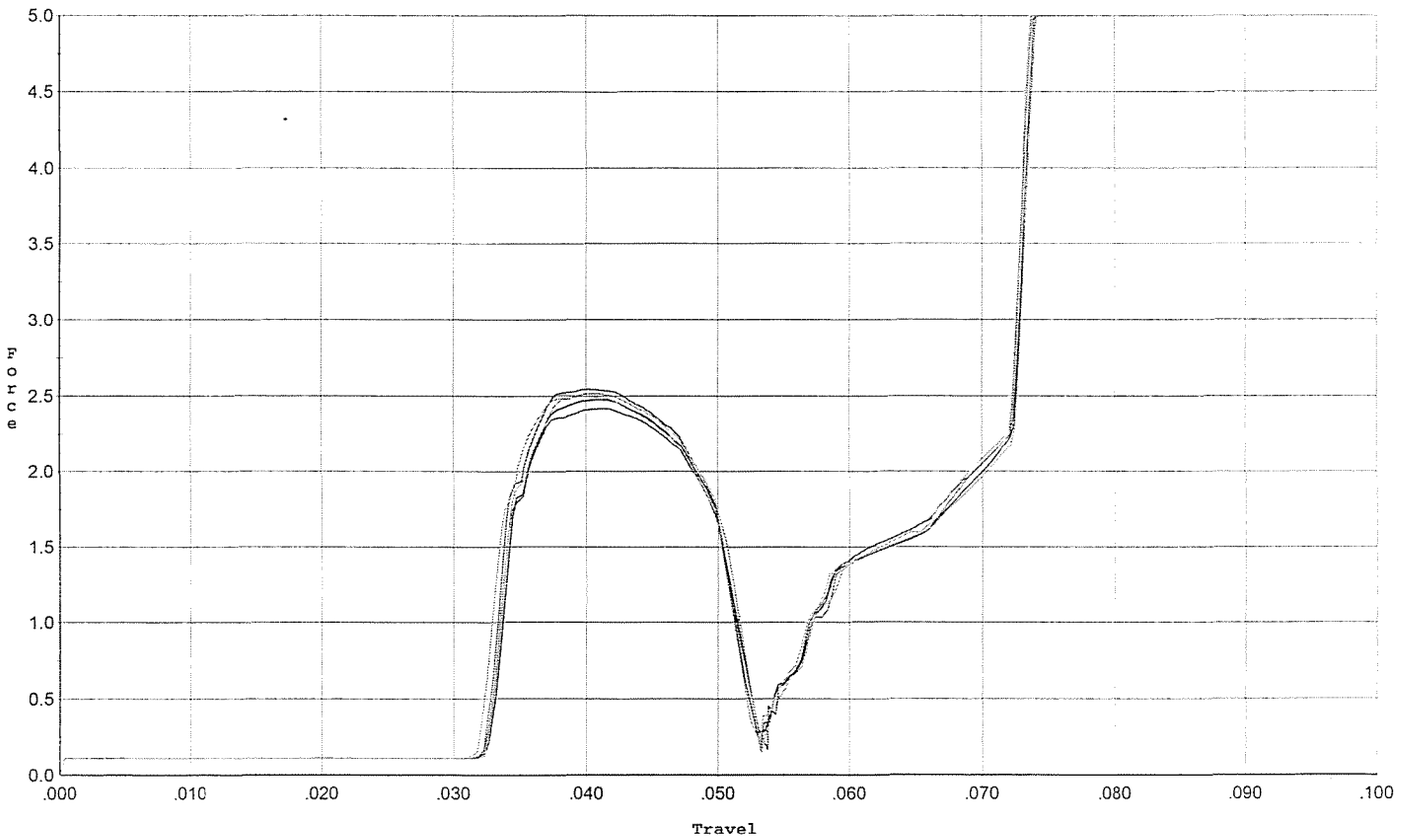
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.053	0.036	0.031	0.043		Set Trigger
2	2.533	0.054	0.036	0.031	0.043		Set Trigger
3	2.569	0.054	0.035	0.030	0.044		Set Trigger
4	2.576	0.054	0.036	0.030	0.043		Set Trigger
5	2.525	0.054	0.036	0.031	0.043		Set Trigger

Avg 2.56

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:41:11 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 4/26/07		



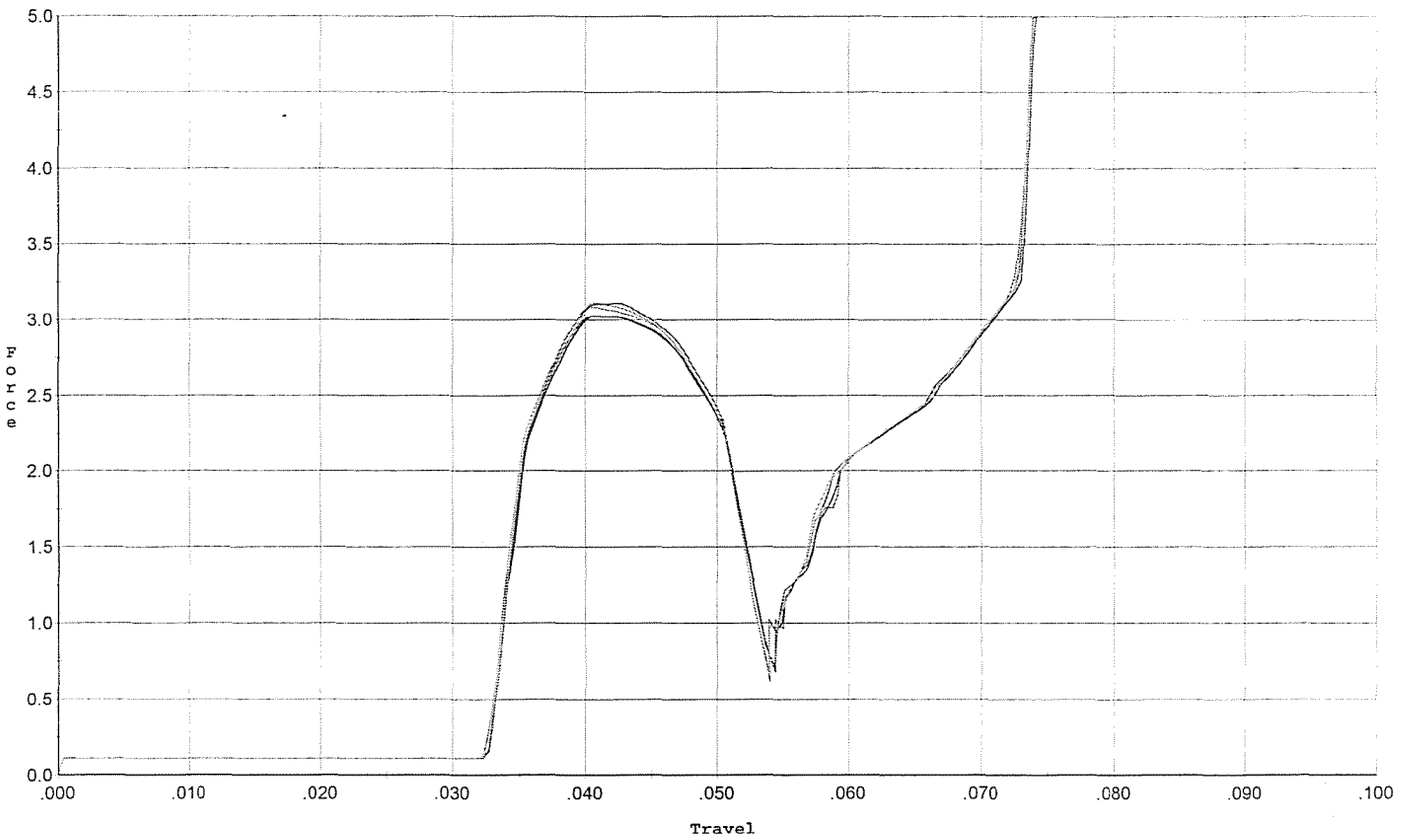
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.050	0.033	0.031	0.040		Set Trigger
2	2.476	0.051	0.033	0.031	0.042		Set Trigger
3	2.547	0.050	0.033	0.031	0.042		Set Trigger
4	2.499	0.050	0.032	0.031	0.042		Set Trigger
5	2.517	0.051	0.033	0.031	0.042		Set Trigger

Avg 2.49

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:43:05 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 4/26/07		



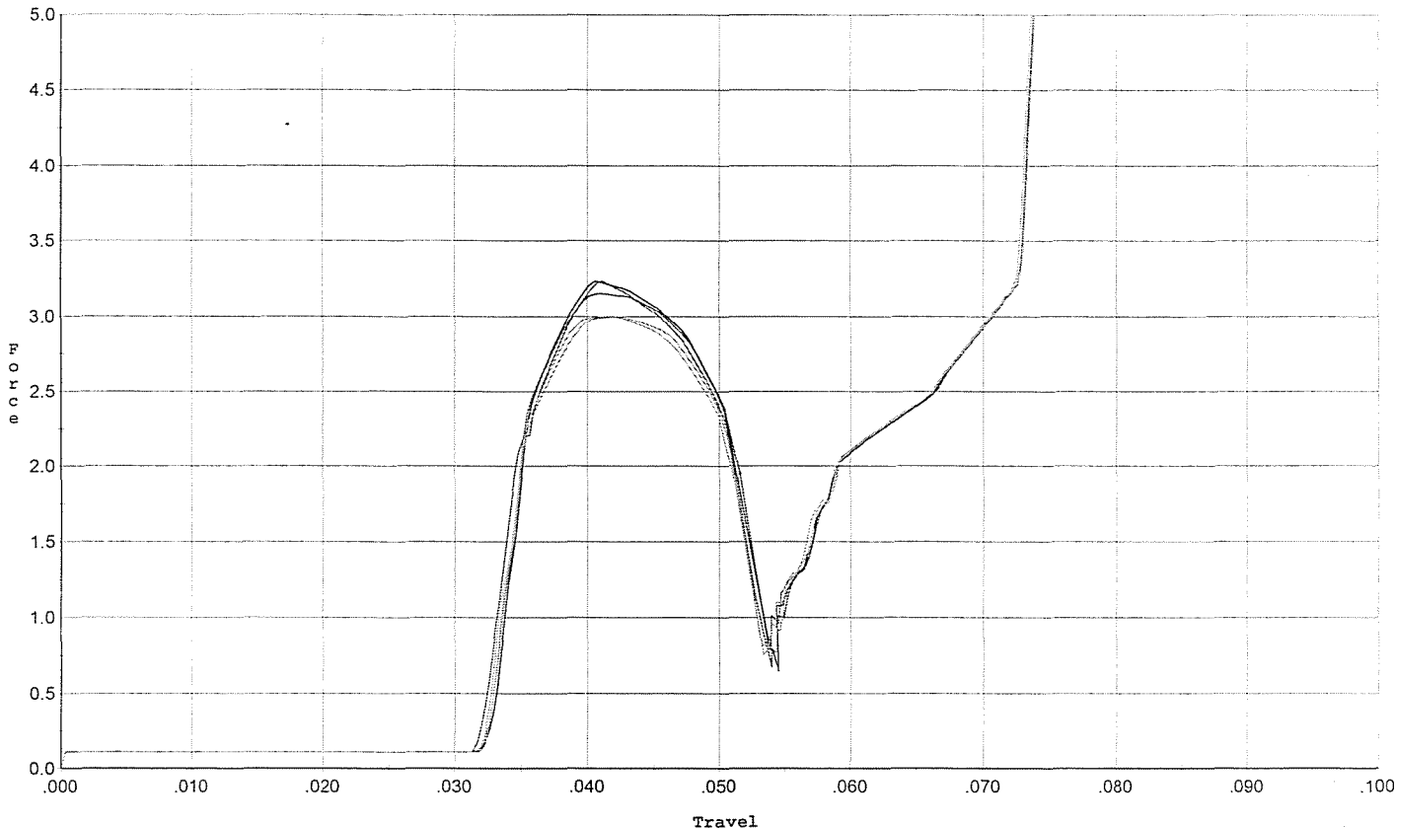
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.051	0.033	0.030	0.050		Set Trigger
2	3.027	0.051	0.033	0.030	0.049		Set Trigger
3	3.112	0.050	0.033	0.030	0.051		Set Trigger
4	3.085	0.051	0.033	0.030	0.050		Set Trigger
5	3.116	0.051	0.033	0.030	0.051		Set Trigger

Avg 3.07

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:52:02 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 4/26/07		



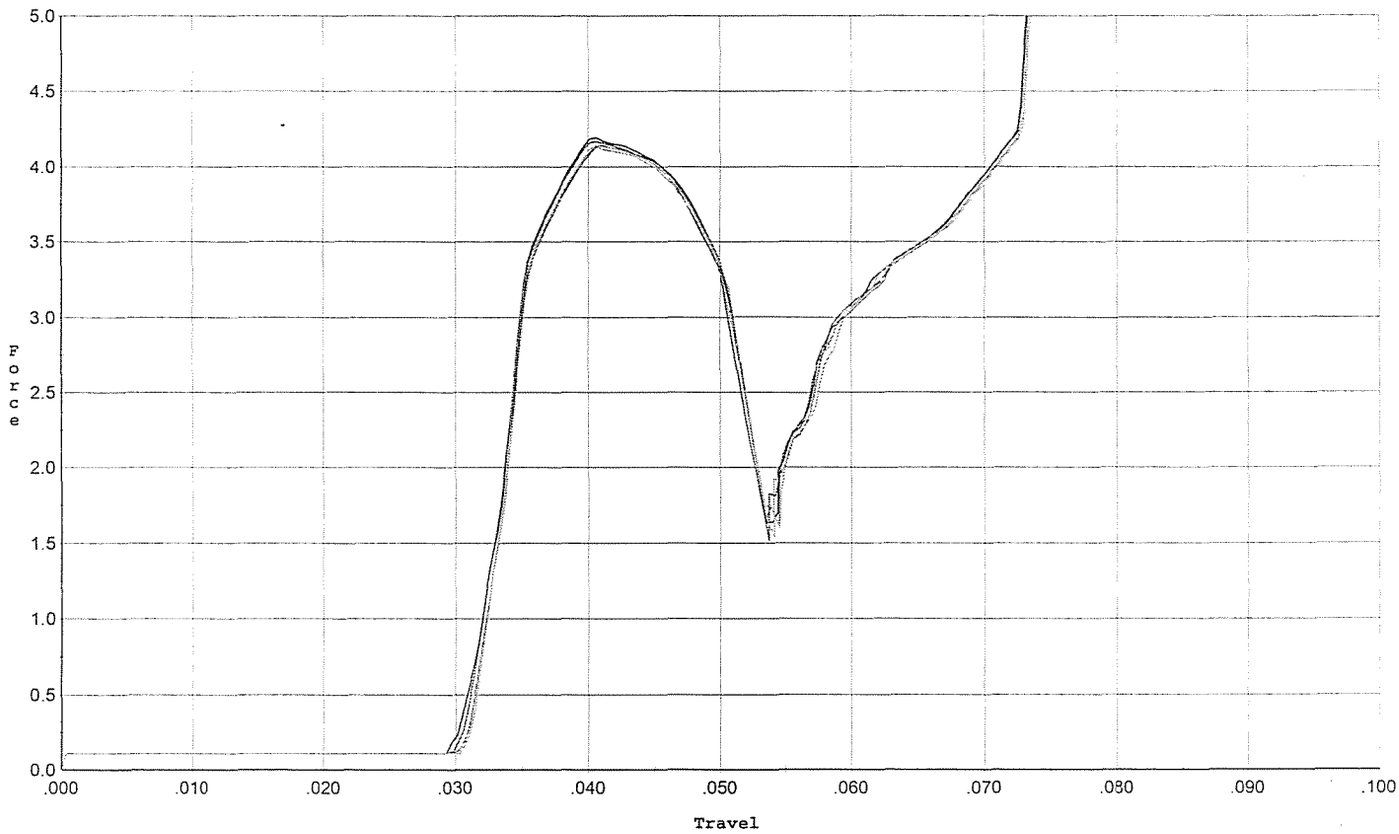
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.052	0.032	0.029	0.054		Set Trigger
2	3.234	0.050	0.033	0.030	0.052		Set Trigger
3	3.235	0.051	0.032	0.029	0.052		Set Trigger
4	3.001	0.051	0.032	0.029	0.051		Set Trigger
5	2.999	0.051	0.033	0.030	0.050		Set Trigger

AVG 3.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:53:57 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 4/26/07		



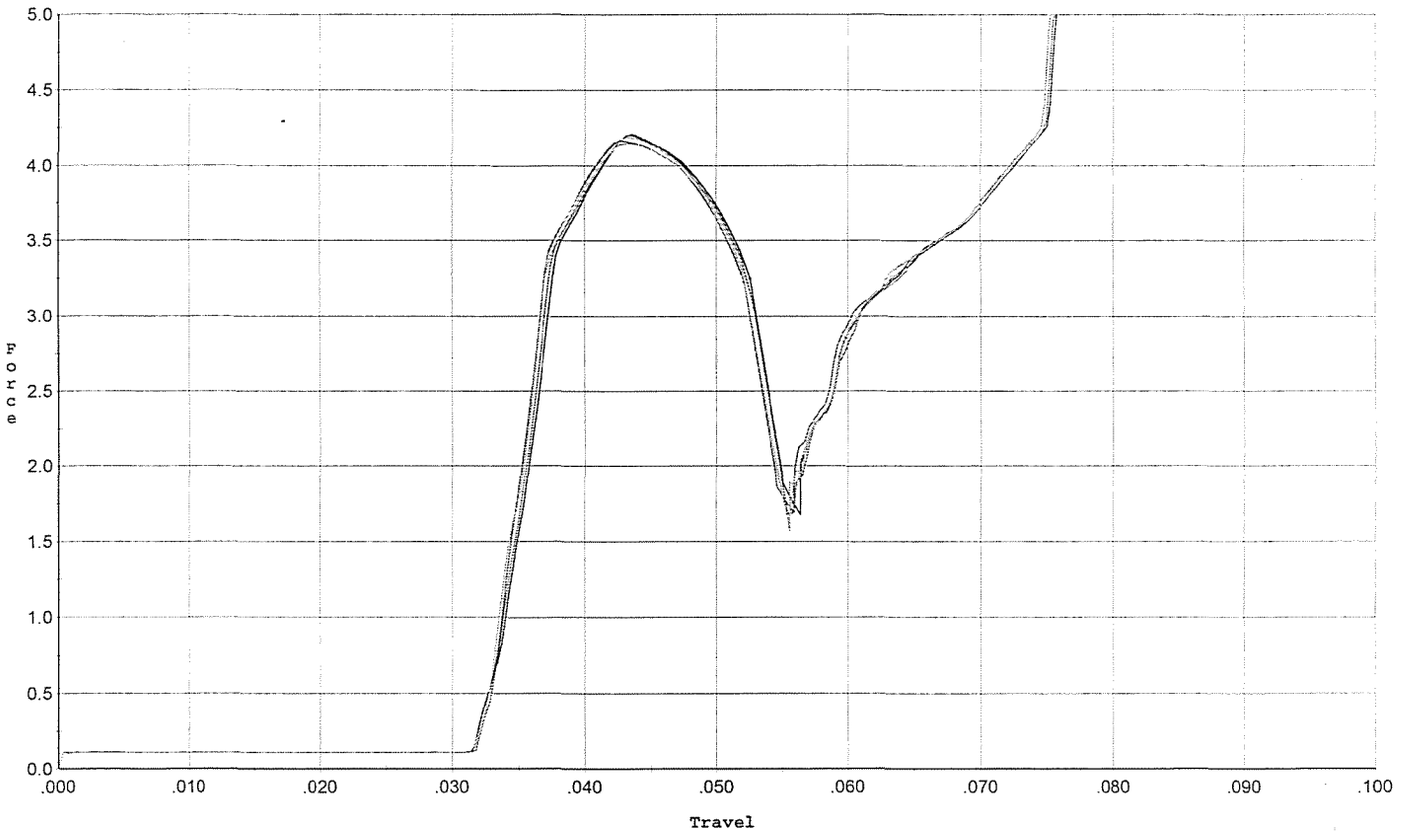
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.168	0.050	0.030	0.028	0.070		Set Trigger
2	4.194	0.051	0.030	0.027	0.072		Set Trigger
3	4.141	0.051	0.031	0.028	0.071		Set Trigger
4	4.142	0.051	0.031	0.028	0.071		Set Trigger
5	4.131	0.051	0.031	0.028	0.071		Set Trigger

AVG 4.15

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:56:00 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 4/26/07		



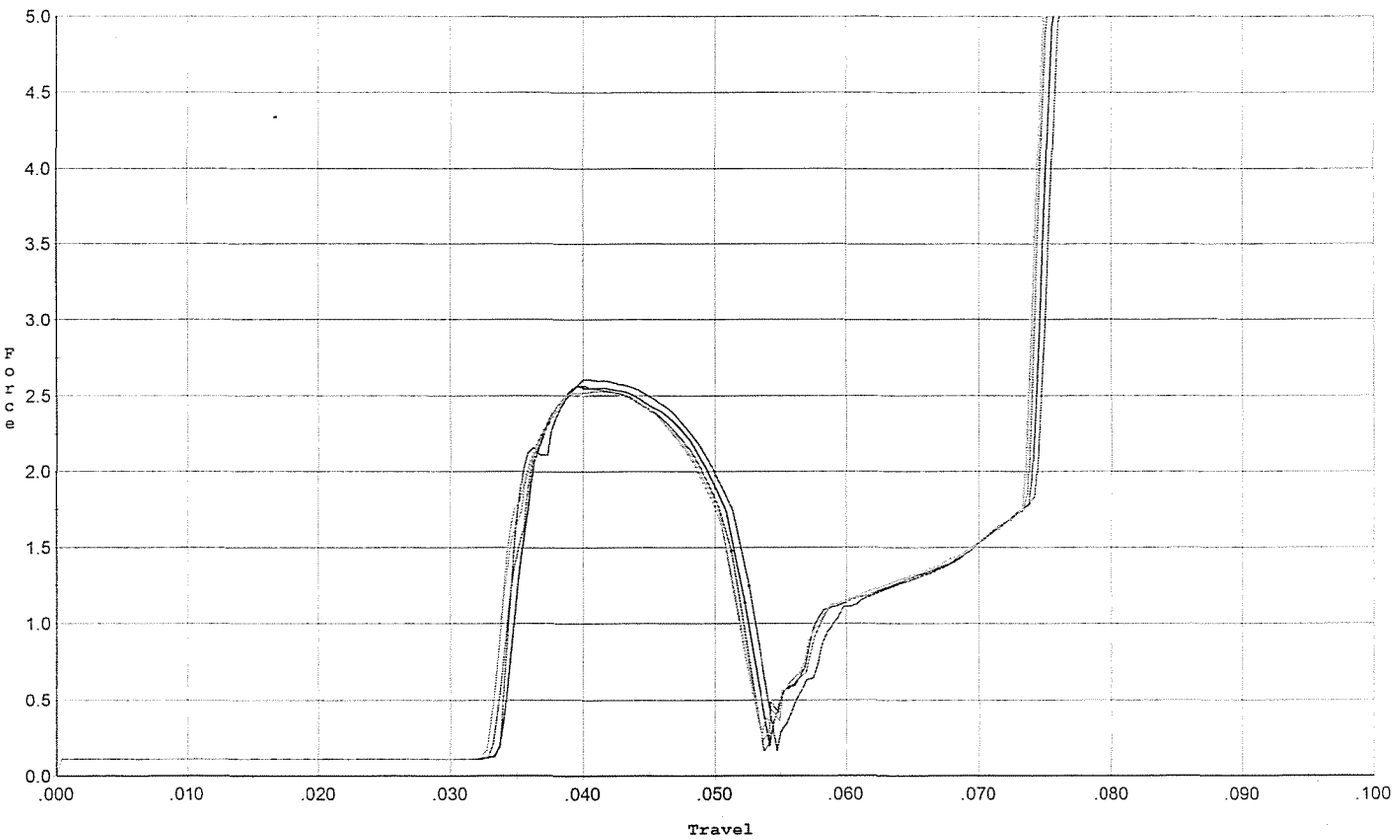
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.166	0.052	0.032	0.028	0.072		Set Trigger
2	4.201	0.053	0.032	0.028	0.072		Set Trigger
3	4.211	0.053	0.032	0.028	0.073		Set Trigger
4	4.187	0.052	0.032	0.028	0.072		Set Trigger
5	4.145	0.052	0.032	0.028	0.071		Set Trigger

AVG 4.18

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 2:58:59 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 4/26/07		

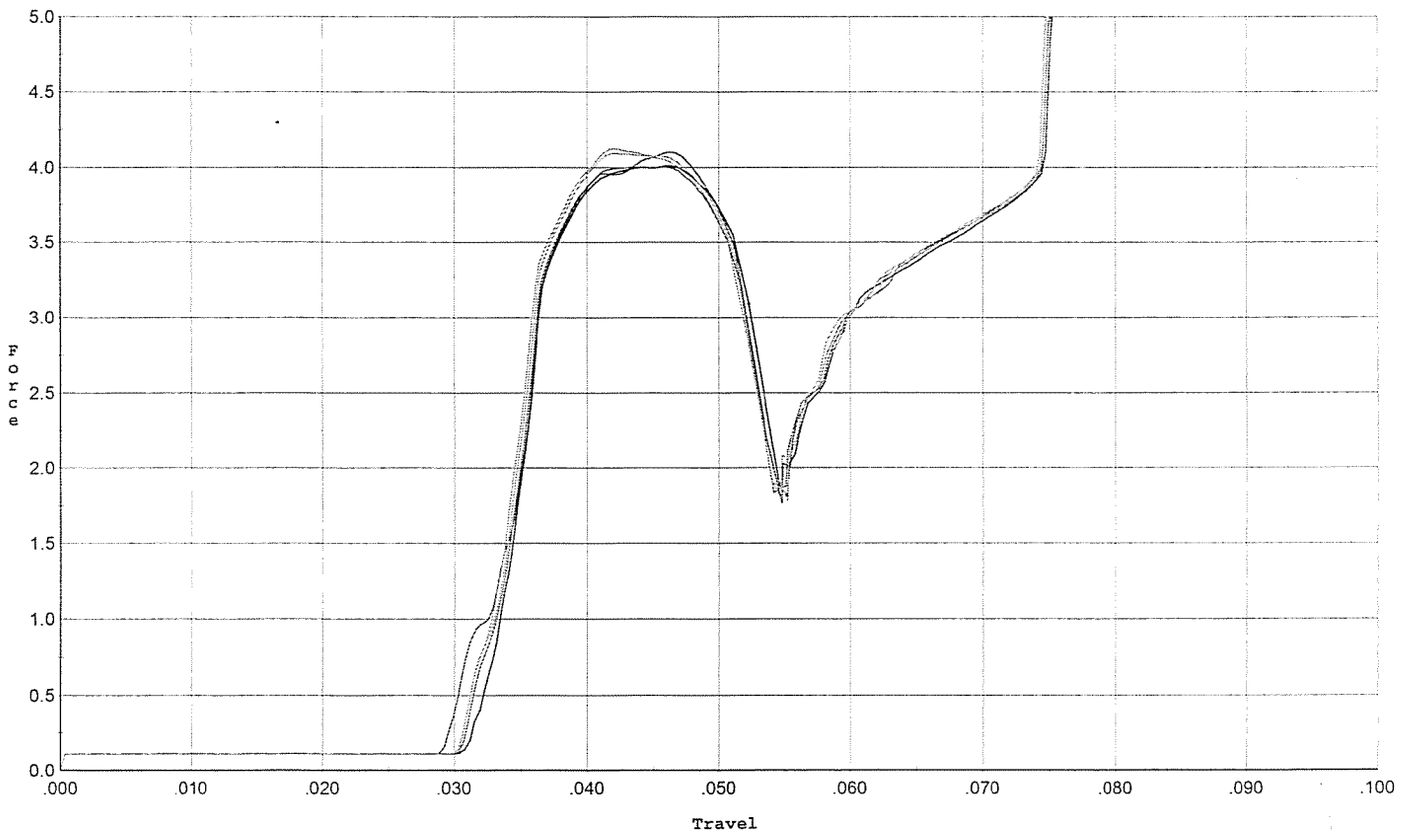


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.608	0.053	0.034	0.031	0.045		Set Trigger
2	2.566	0.052	0.034	0.031	0.043		Set Trigger
3	2.566	0.051	0.033	0.031	0.042		Set Trigger
4	2.517	0.050	0.033	0.032	0.042		Set Trigger
5	2.529	0.050	0.033	0.032	0.042		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. +/- 1.0 lbs. for target & accurac
Note:	R. Putch 4/26/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.051	0.030	0.028	0.072		Set Trigger
2	4.009	0.052	0.031	0.028	0.072		Set Trigger
3	4.005	0.052	0.031	0.028	0.071		Set Trigger
4	4.094	0.051	0.031	0.028	0.072		Set Trigger
5	4.126	0.052	0.031	0.028	0.074		Set Trigger

AVG 4.06

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/26/2007 3:07:27 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6637691.__0
FILE DATE AND TIME: 04/27/2007 10:52

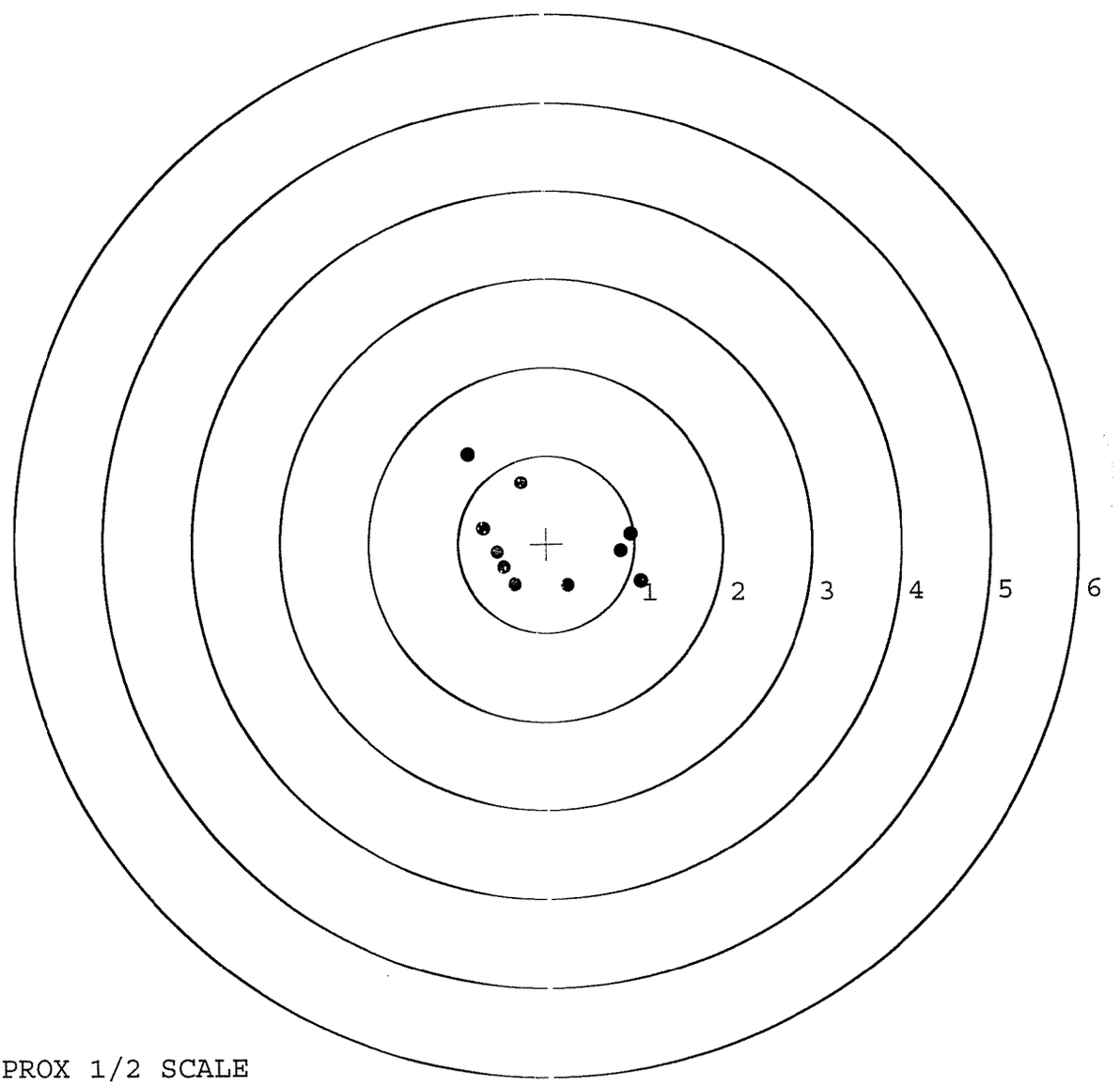
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.055
The Average Y Centroid of the Five Target Set:	-0.047
The Average Point of Impact of the Five Target Set:	0.072
The Average Mean Radius of the Five Target Set:	0.738
The Distance from POA to Centroid Target #1:	0.025
The Distance from Centroid Target #2 to Centroid Target #1:	0.066
The Distance from Centroid Target #3 to Centroid Target #1:	0.119
The Distance from Centroid Target #4 to Centroid Target #1:	0.226
The Distance from Centroid Target #5 to Centroid Target #1:	0.196

SERIAL NUMBER: G6637691.__0
TARGET NUMBER: 1
FILE DATE: 04/27/2007
FILE TIME: 10:52

X CENTROID:	-0.016
Y CENTROID:	0.019
POA TO CENTROID:	0.025
HORZ SPREAD:	1.953
VERT SPREAD:	1.482
GROUP SPREAD:	2.429
MIN RADIUS:	0.547
MAX RADIUS:	1.319
MEAN RADIUS:	0.802
# IN 1 IN DIAMETER:	0
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.071	-0.430
2:	0.957	0.101
3:	0.239	-0.468
4:	-0.281	0.698
5:	-0.882	1.014
6:	-0.711	0.178
7:	-0.559	-0.099
8:	-0.485	-0.263
9:	-0.356	-0.457
10:	0.844	-0.087

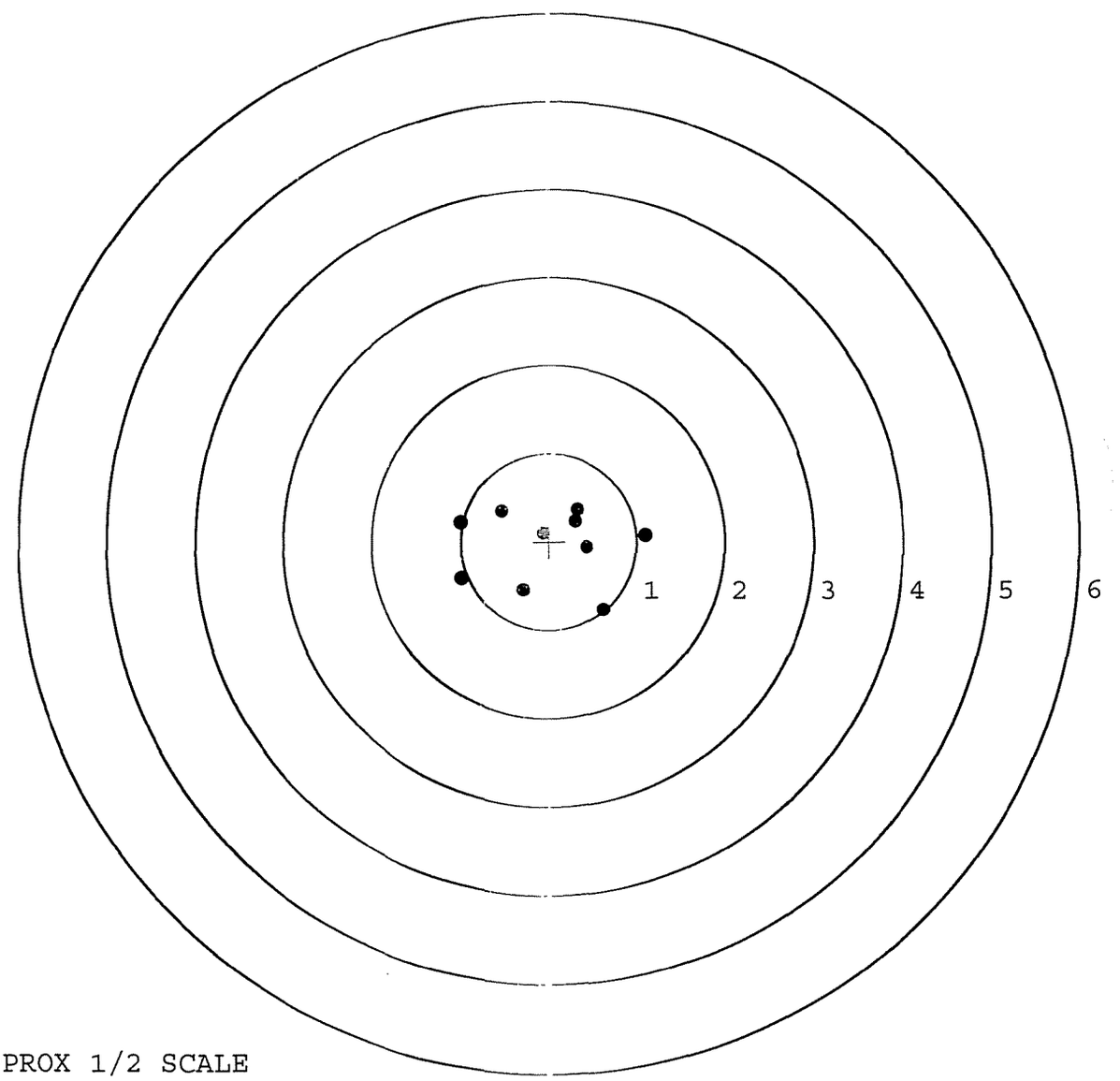


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637691.__0
TARGET NUMBER: 2
FILE DATE: 04/27/2007
FILE TIME: 10:52

X CENTROID:	-0.012
Y CENTROID:	-0.047
POA TO CENTROID:	0.048
HORZ SPREAD:	2.096
VERT SPREAD:	1.132
GROUP SPREAD:	2.146
MIN RADIUS:	0.153
MAX RADIUS:	1.114
MEAN RADIUS:	0.691
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.622	-0.767
2:	1.096	0.070
3:	0.429	-0.067
4:	0.326	0.365
5:	-0.067	0.096
6:	-0.287	-0.541
7:	-0.539	0.348
8:	-1.000	0.216
9:	-0.993	-0.420
10:	0.296	0.231

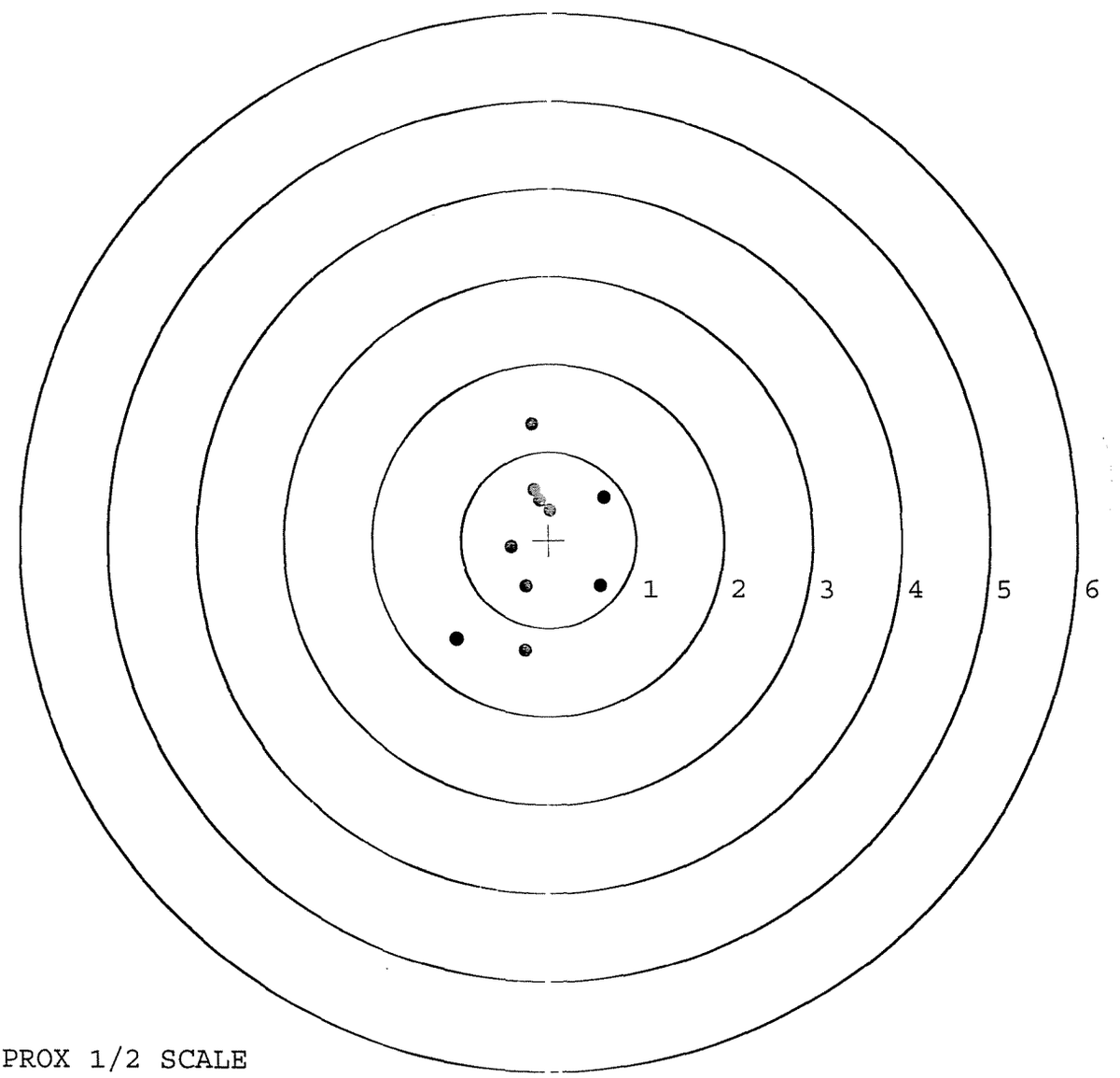


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637691.__0
TARGET NUMBER: 3
FILE DATE: 04/27/2007
FILE TIME: 10:52

X CENTROID:	-0.123
Y CENTROID:	-0.035
POA TO CENTROID:	0.128
HORZ SPREAD:	1.677
VERT SPREAD:	2.572
GROUP SPREAD:	2.586
MIN RADIUS:	0.308
MAX RADIUS:	1.430
MEAN RADIUS:	0.809
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.263	-1.257
2:	-1.045	-1.127
3:	0.599	-0.515
4:	0.632	0.481
5:	-0.195	1.315
6:	-0.256	-0.521
7:	-0.428	-0.078
8:	0.010	0.334
9:	-0.109	0.452
10:	-0.173	0.570

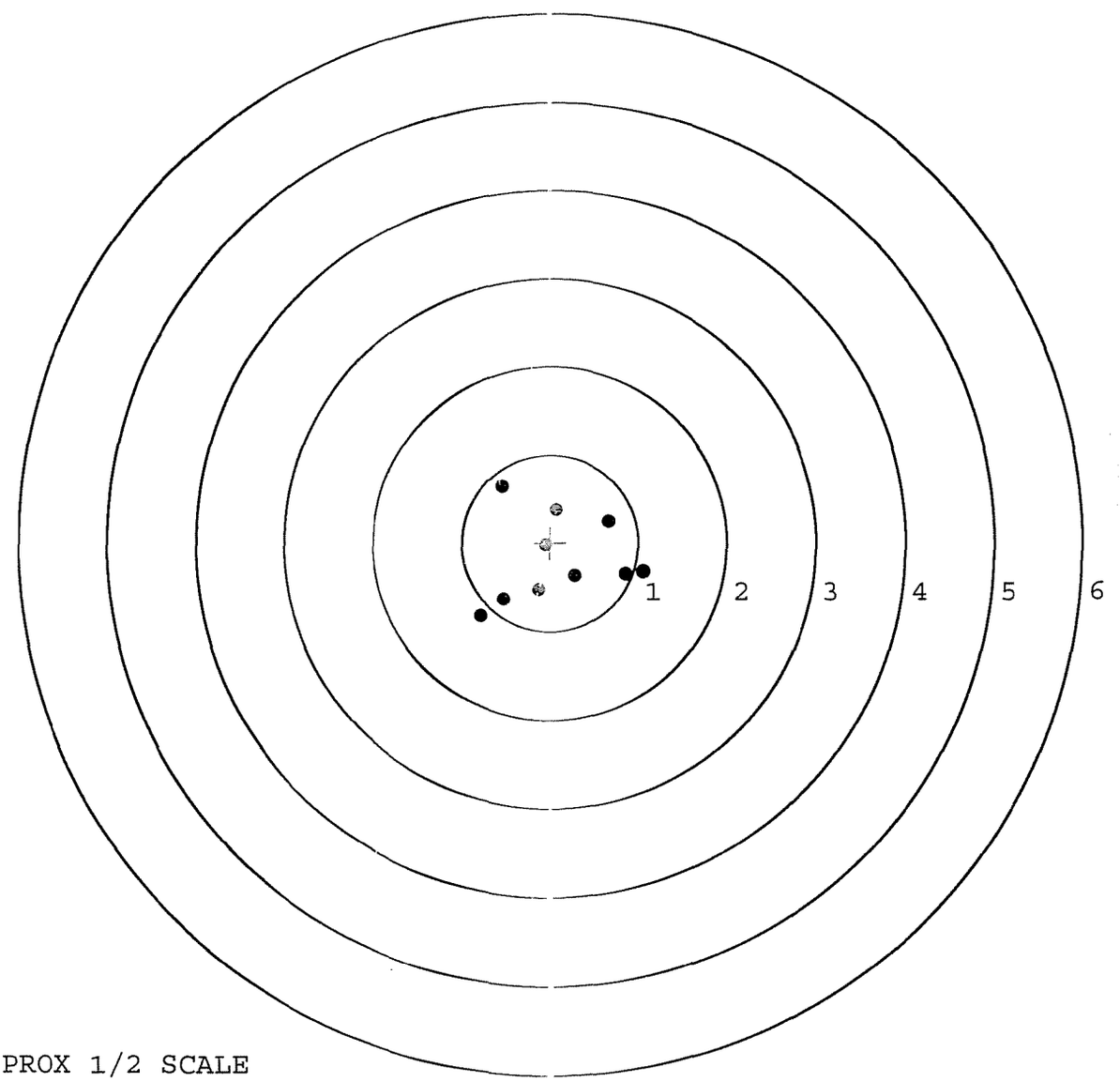


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637691.__0
TARGET NUMBER: 4
FILE DATE: 04/27/2007
FILE TIME: 10:52

X CENTROID:	0.087
Y CENTROID:	-0.182
POA TO CENTROID:	0.202
HORZ SPREAD:	1.849
VERT SPREAD:	1.474
GROUP SPREAD:	1.916
MIN RADIUS:	0.212
MAX RADIUS:	1.092
MEAN RADIUS:	0.683
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.059	-0.330
2:	0.854	-0.357
3:	0.663	0.246
4:	0.278	-0.374
5:	-0.128	-0.528
6:	-0.528	-0.636
7:	-0.790	-0.832
8:	-0.059	-0.029
9:	0.071	0.380
10:	-0.545	0.642

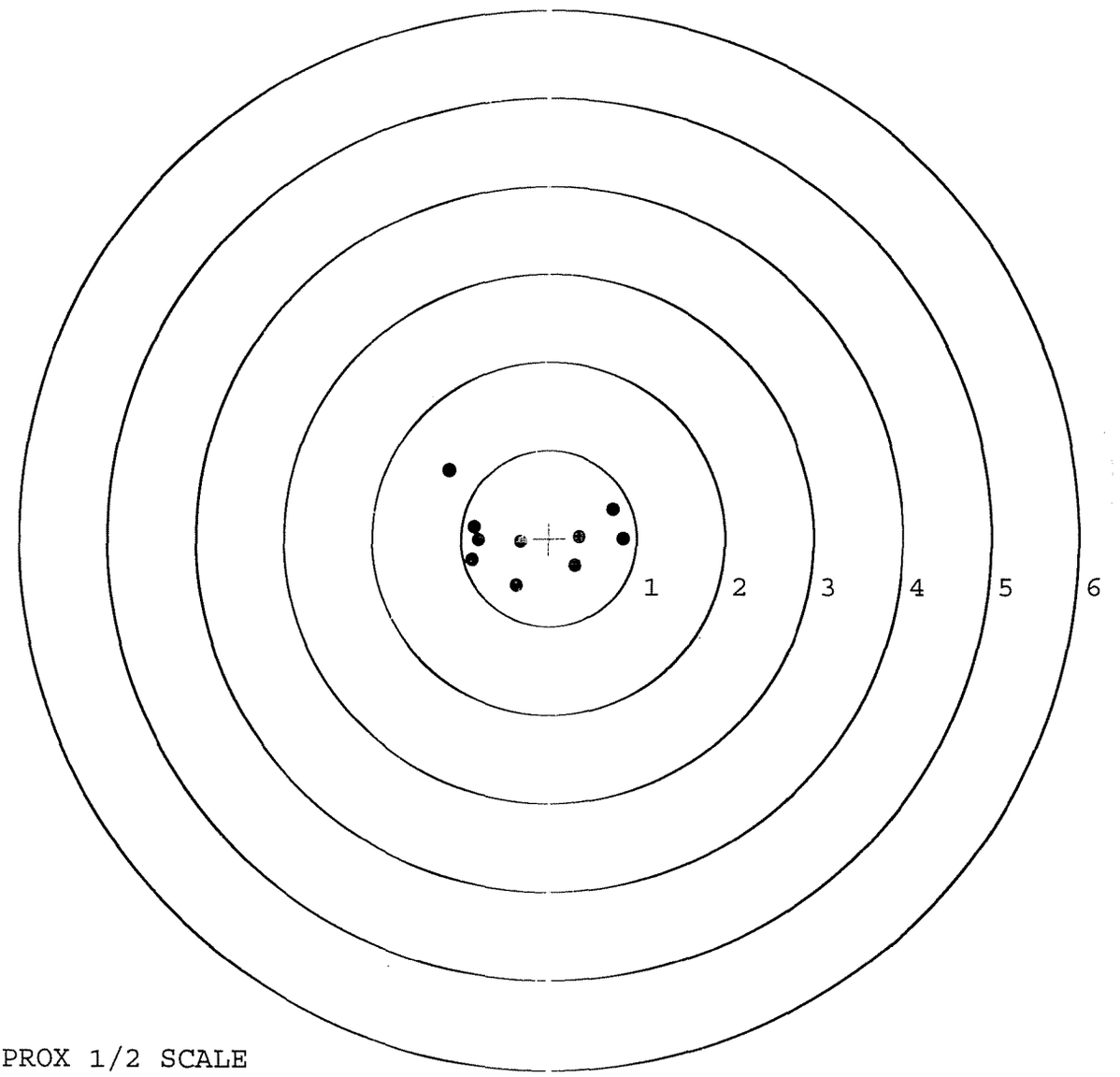


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637691.__0
TARGET NUMBER: 5
FILE DATE: 04/27/2007
FILE TIME: 10:52

X CENTROID:	-0.212
Y CENTROID:	0.010
POA TO CENTROID:	0.213
HORZ SPREAD:	1.972
VERT SPREAD:	1.301
GROUP SPREAD:	2.123
MIN RADIUS:	0.118
MAX RADIUS:	1.192
MEAN RADIUS:	0.703
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.844	-0.013
2:	0.732	0.333
3:	0.345	0.019
4:	0.295	-0.310
5:	-0.320	-0.038
6:	-0.369	-0.527
7:	-0.867	-0.242
8:	-0.805	-0.025
9:	-0.851	0.129
10:	-1.128	0.774



TARGET APPROX 1/2 SCALE