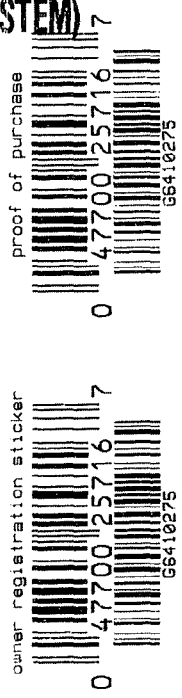


G 6410275

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

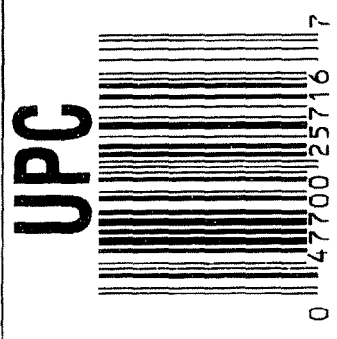
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410275



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.



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400149605

25716

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

**.MA25716**

Shop Order: SWS10-15-1

**.ABSWS10-15-1**

Start Date: 10/22/2004

Finish Date: 12/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001

**0003517903**

0560

Reassemble Action.

89SWS1

**0003517904**

0690

Pack Rifle

89SWS1

**0003517897**

0700

Stencil SWS Container

89SWS1

**.OP0700**

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6410275

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTL
600	PROOF		8-24-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTL
610	DIS-ASSEMBLE GUN		8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR		
615	ROLLMARK CALIBER		8/25/04	RL
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRL
620	APPLY COATINGS (BARREL ACTION)		9/7	HSP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/5/04	RTA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/5/04	RTA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/5/04	RTA
	D) OIL FIRING PIN ASSEMBLY		10-11-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.9</u> <u>6.9</u> <u>6.9</u>	11-15-04	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11-15-04	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	11-15-04	RA
	J) ASSEMBLE STOCK		10-11-04	RTL
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RTL
	M) IRON SIGHT ALIGNMENT		11-29-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RTL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	10-27-04	TRW
	MALFUNCTION <i>Creep in trigger</i>	CORRECTION	10-27-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		10-27-04	TRW
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.69</u> <u>2.79</u> <u>2.72</u> <u>2.67</u>	11-15-04	RA
	C) FUNCTION		11-29-04	RTL
660	PACK		11-29-04	RA

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 10-9-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.24	2.32		2.11	
PULL #2	2.45	2.26		2.07	
PULL #3	2.72	2.41		2.17	
PULL #4	2.65	2.03		2.28	
PULL #5	2.67	2.31		2.21	
TOTAL	12.73	11.33		10.84	
AVERAGE	2.54	2.26		2.16	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.43	3.14		
PULL #2	2.99	3.25		
PULL #3	3.03	3.32		
PULL #4	3.10	3.12		
PULL #5	3.26	3.07		
TOTAL	15.81	15.90		
AVERAGE	3.16	3.18		

	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	4.24	4.21		4.57
PULL #2	4.42	4.01		4.33
PULL #3	4.24	3.97		4.33
PULL #4	4.20	4.00		4.31
PULL #5	4.22	3.97		4.24
TOTAL	21.32	20.16		21.78
AVERAGE	4.26	4.03		4.35

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410275.___0

FILE DATE AND TIME: 10/27/2004 08:26

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.080
The Average Y Centroid of the Five Target Set:	-0.241
The Average Point of Impact of the Five Target Set:	0.254
The Average Mean Radius of the Five Target Set:	0.850
The Distance from POA to Centroid Target #1:	0.267
The Distance from Centroid Target #2 to Centroid Target #1:	0.101
The Distance from Centroid Target #3 to Centroid Target #1:	0.027
The Distance from Centroid Target #4 to Centroid Target #1:	0.240
The Distance from Centroid Target #5 to Centroid Target #1:	0.293

SERIAL NUMBER: G6410275. __0

TARGET NUMBER: 1

FILE DATE: 10/27/2004

FILE TIME: 08:26

POINT#	X	Y
1:	1.429	-0.668
2:	-0.143	-0.528
3:	-0.582	-0.811
4:	-0.602	-1.218
5:	-1.097	-1.218
6:	-1.262	0.401
7:	0.370	1.004
8:	0.114	0.472
9:	-0.056	0.363
10:	0.193	0.088

X CENTROID: -0.164

Y CENTROID: -0.212

POA TO CENTROID: 0.267

HORZ SPREAD: 2.691

VERT SPREAD: 2.222

GROUP SPREAD: 2.896

MIN RADIUS: 0.317

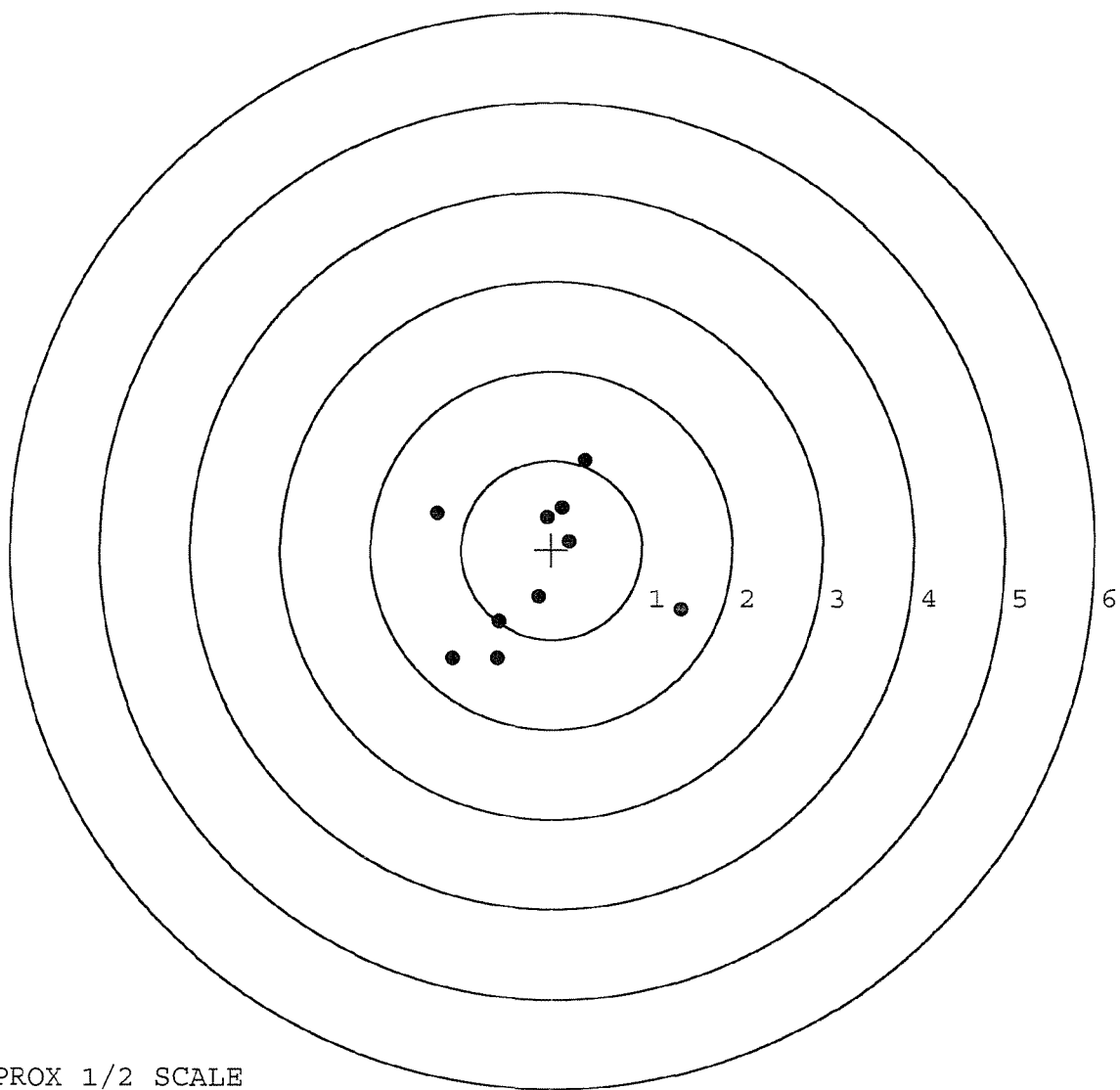
MAX RADIUS: 1.657

MEAN RADIUS: 0.955

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

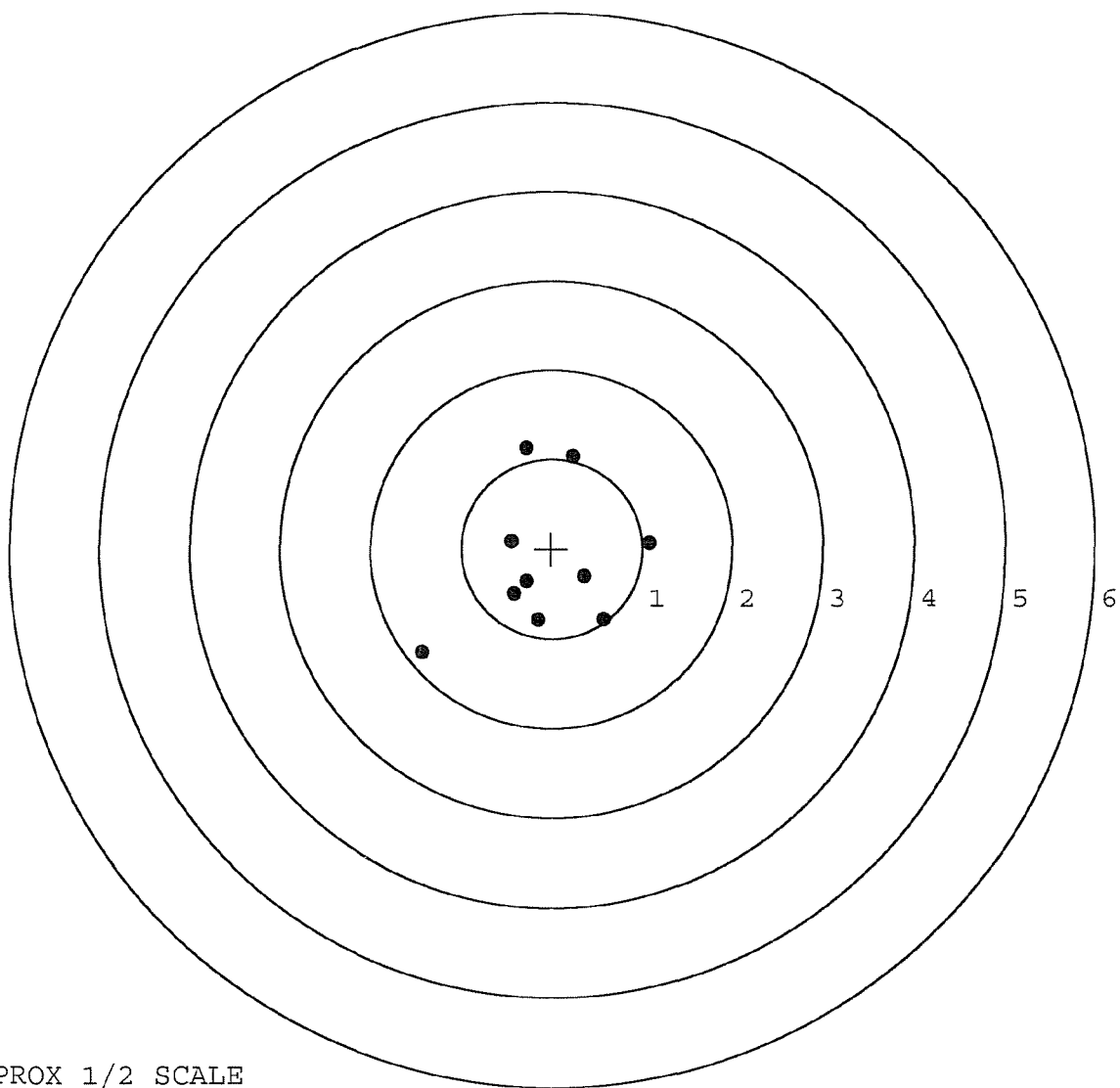


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410275. __0
TARGET NUMBER: 2
FILE DATE: 10/27/2004
FILE TIME: 08:26

X CENTROID: -0.077
Y CENTROID: -0.161
POA TO CENTROID: 0.178
HORZ SPREAD: 2.507
VERT SPREAD: 2.282
GROUP SPREAD: 2.789
MIN RADIUS: 0.284
MAX RADIUS: 1.681
MEAN RADIUS: 0.861
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.075	0.065
2:	0.573	-0.790
3:	0.364	-0.307
4:	-0.153	-0.799
5:	-0.420	-0.500
6:	-0.276	-0.363
7:	-0.452	0.084
8:	-1.432	-1.156
9:	0.238	1.029
10:	-0.283	1.126

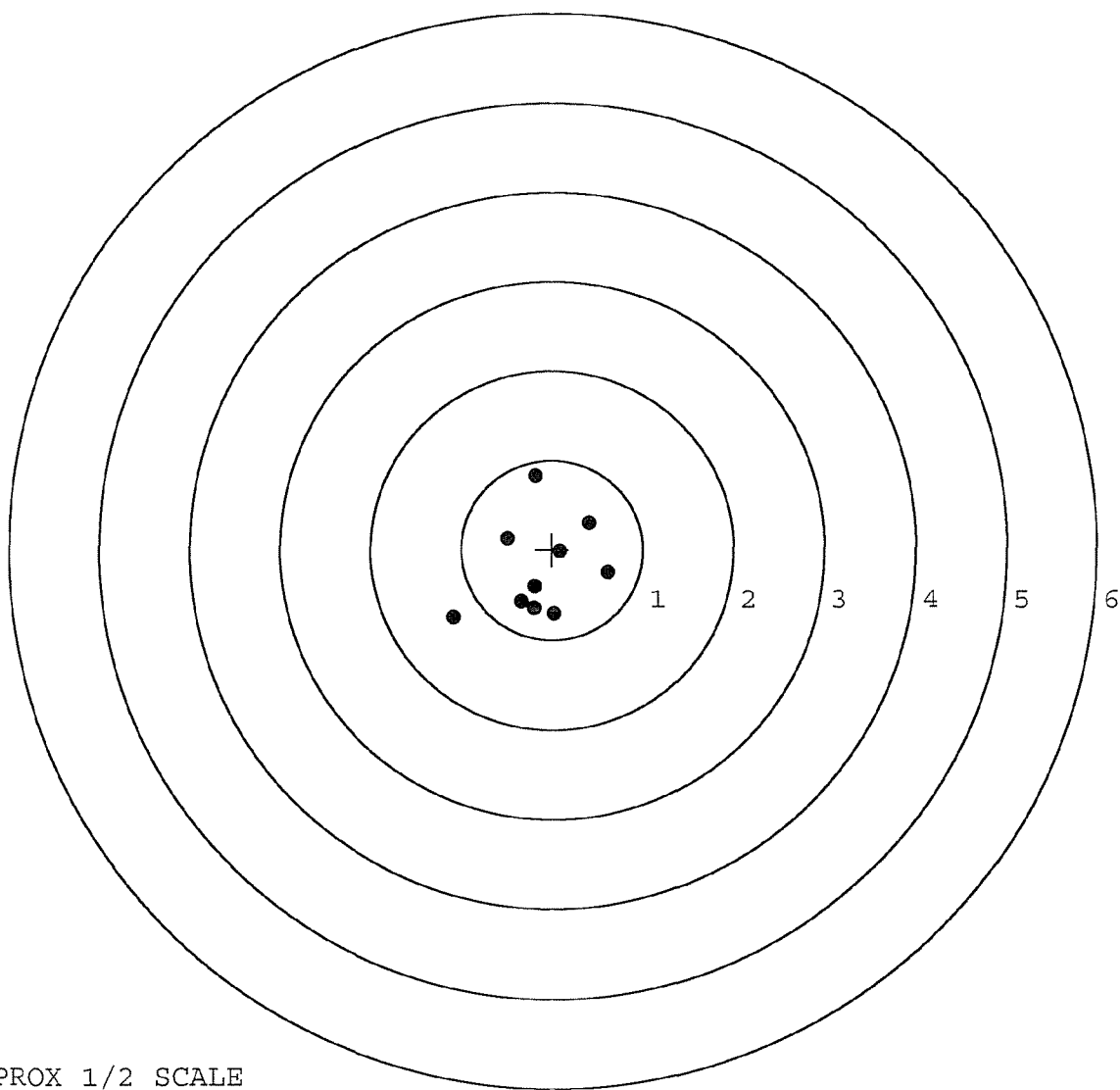


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410275. __0
TARGET NUMBER: 3
FILE DATE: 10/27/2004
FILE TIME: 08:26

X CENTROID: -0.138
Y CENTROID: -0.217
POA TO CENTROID: 0.257
HORZ SPREAD: 1.704
VERT SPREAD: 1.582
GROUP SPREAD: 1.827
MIN RADIUS: 0.208
MAX RADIUS: 1.093
MEAN RADIUS: 0.603
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.616	-0.257
2:	0.406	0.296
3:	0.093	-0.025
4:	-0.189	0.826
5:	-0.498	0.121
6:	-1.088	-0.756
7:	-0.194	-0.417
8:	-0.341	-0.585
9:	-0.205	-0.655
10:	0.024	-0.719

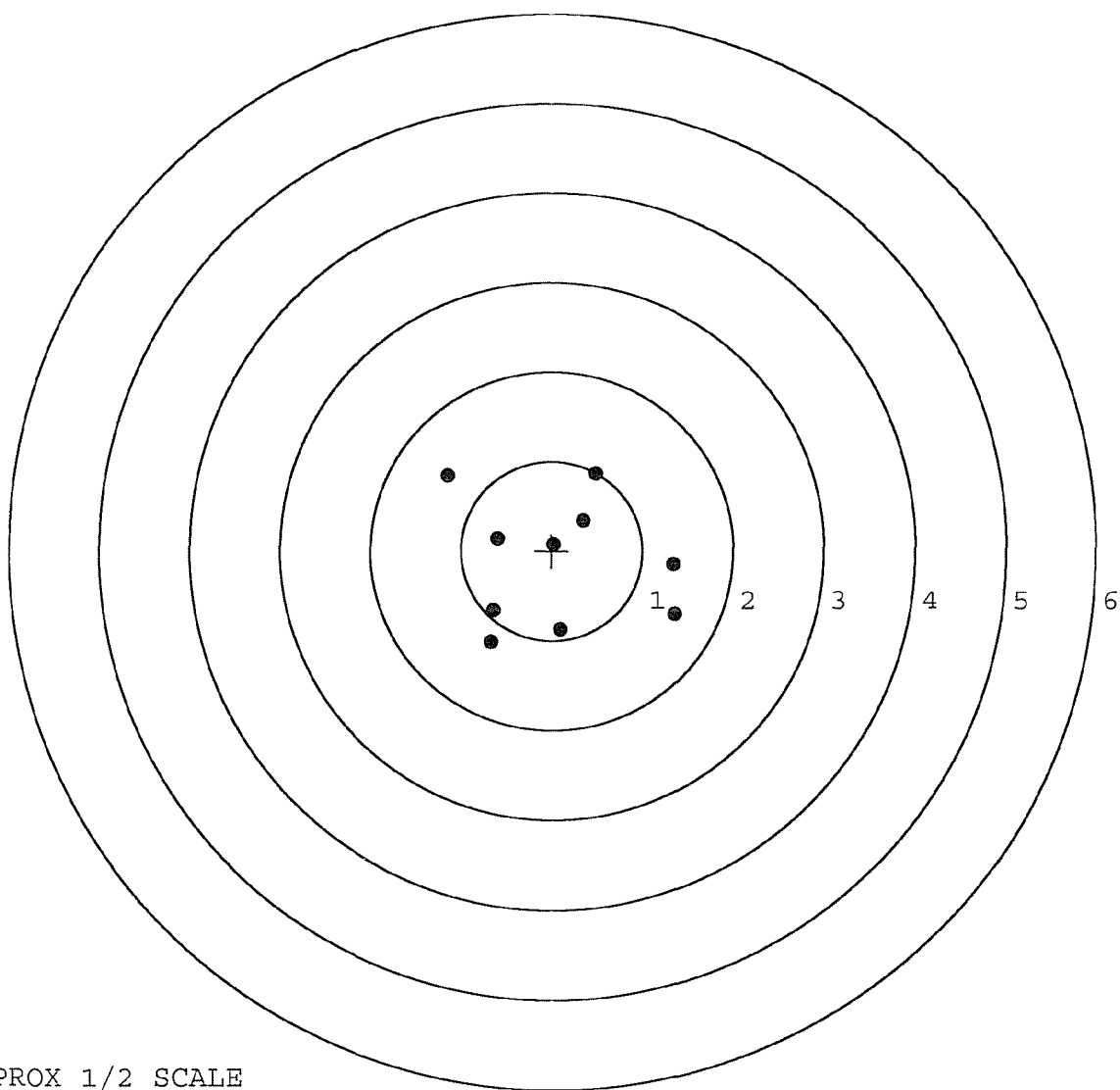


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410275. __0
TARGET NUMBER: 4
FILE DATE: 10/27/2004
FILE TIME: 08:26

POINT#	X	Y
1:	1.357	-0.713
2:	1.344	-0.158
3:	0.097	-0.883
4:	-0.671	-1.022
5:	-0.643	-0.673
6:	0.022	0.069
7:	0.343	0.339
8:	0.493	0.865
9:	-0.604	0.139
10:	-1.151	0.836

X CENTROID: 0.059
Y CENTROID: -0.120
POA TO CENTROID: 0.134
HORZ SPREAD: 2.508
VERT SPREAD: 1.887
GROUP SPREAD: 2.948
MIN RADIUS: 0.193
MAX RADIUS: 1.542
MEAN RADIUS: 0.959
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410275. 0

TARGET NUMBER: 5

FILE DATE: 10/27/2004

FILE TIME: 08:26

POINT#	X	Y
1:	0.983	-0.543
2:	0.402	0.435
3:	0.217	0.686
4:	0.031	-0.021
5:	-0.147	-0.333
6:	0.262	-0.531
7:	-0.108	-0.652
8:	-0.471	-0.903
9:	-1.916	-2.576

X CENTROID: -0.083

Y CENTROID: -0.493

POA TO CENTROID: 0.500

HORZ SPREAD: 2.899

VERT SPREAD: 3.262

GROUP SPREAD: 3.897

MIN RADIUS: 0.161

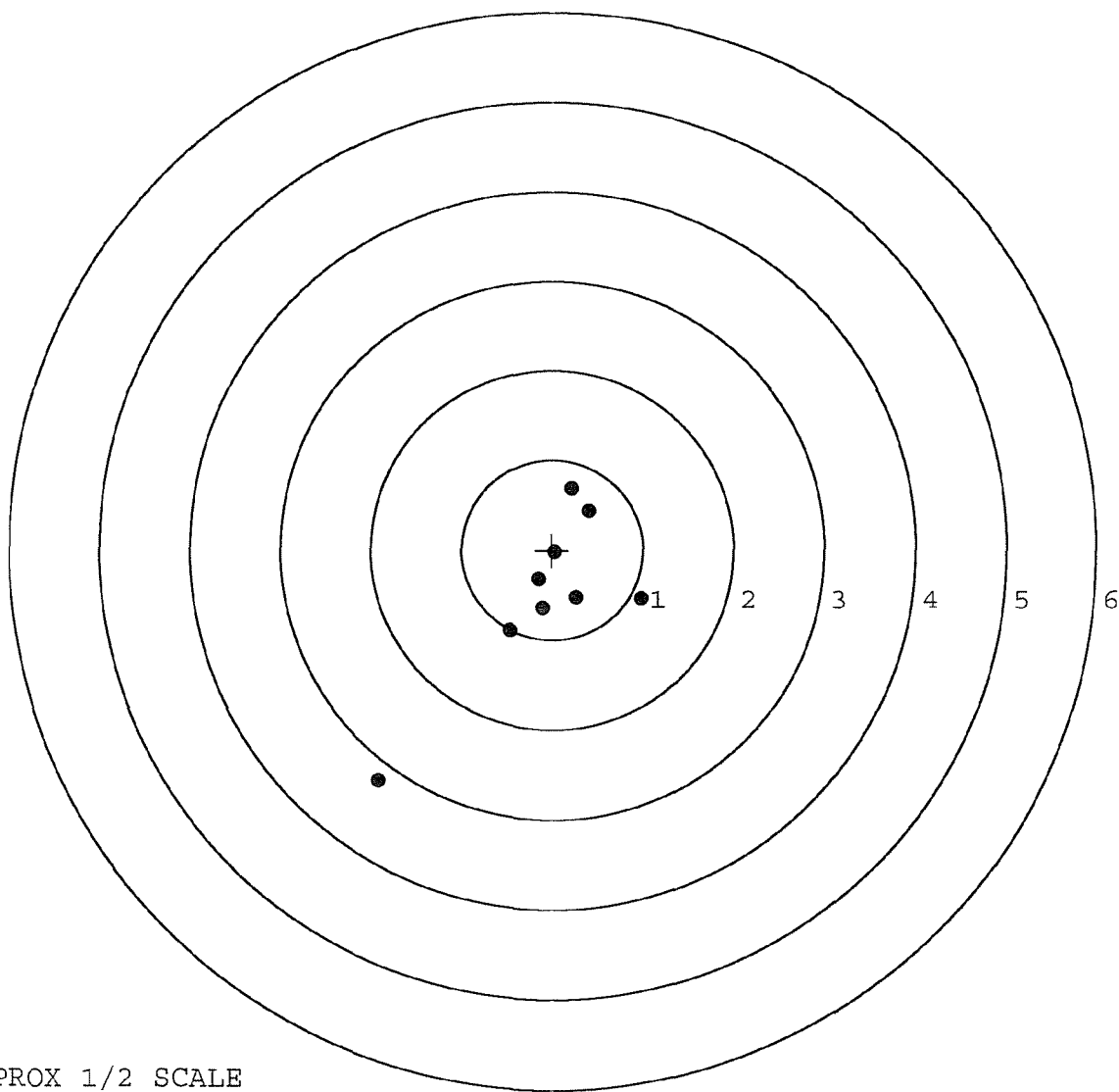
MAX RADIUS: 2.775

MEAN RADIUS: 0.871

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE