

G646 14 76

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

- INSTRUCTION BOOK 3518

DD FORM

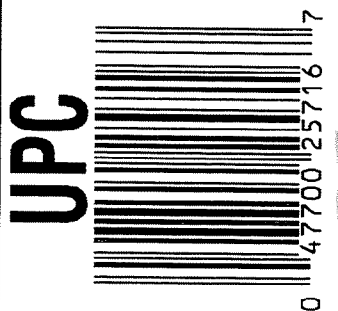


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461676



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



SERIAL NO.



M2400154667

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461676

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-9-05	RTZ
460	CHECK HEADSPACE		9-13-05	RTZ
470	DIS-ASSEMBLE ACTION		9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4800	9/14/05	unnd
500	ROLLMARK CALIBER		9-14-05	UN
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRLJ
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-05	DA
	D) OIL FIRING PIN ASSEMBLY		9-26-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.0</u> <u>4.0</u>	10/18/05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	10/18/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1025</u> <u>1024</u>	10/18/05	DA
	J) ASSEMBLE STOCK		9-26-05	RL
	K) ASSEMBLE SWIVEL STUDS		10-19-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-11-05	AC
	M) IRON SIGHT ALIGNMENT		10-11-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-11-05	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/13/05	MDJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-13-05	ngm
670	FINAL INSPECTION A) HEADSPACE		10-14-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.18</u> <u>2.18</u> <u>2.42</u> <u>2.30</u>	10-18-05	TRW
	C) FUNCTION		10-19-05	BC
690	PACK		10/28/05	DA

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)

SERIAL NO.

DATE

TESTER

9/21/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.35	2.28		2.48	
PULL #2	2.44	2.37		2.63	
PULL #3	2.56	2.55		2.74	
PULL #4	2.35	2.62		2.37	
PULL #5	2.33	2.10		2.43	
TOTAL	12.03	11.92		12.65	
AVERAGE	2.41	2.38		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	2.73		
PULL #2	3.32	2.89		
PULL #3	3.17	2.92		
PULL #4	2.78	3.05		
PULL #5	2.80	3.09		
TOTAL	15.11	14.68		
AVERAGE	3.02	2.94		

	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	4.18	3.75		4.09
PULL #2	4.11	4.12		4.04
PULL #3	4.04	3.84		3.96
PULL #4	4.02	4.01		4.09
PULL #5	3.93	4.18		3.97
TOTAL	20.28	19.90		20.15
AVERAGE	4.06	3.98		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461676.__0
FILE DATE AND TIME: 10/13/2005 18:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	0.142
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.799
The Distance from POA to Centroid Target #1:	0.563
The Distance from Centroid Target #2 to Centroid Target #1:	0.504
The Distance from Centroid Target #3 to Centroid Target #1:	0.629
The Distance from Centroid Target #4 to Centroid Target #1:	0.590
The Distance from Centroid Target #5 to Centroid Target #1:	0.439

SERIAL NUMBER: G6461676.___0

TARGET NUMBER: 1

FILE DATE: 10/13/2005

FILE TIME: 18:16

X CENTROID: 0.094

Y CENTROID: 0.555

POA TO CENTROID: 0.563

HORZ SPREAD: 1.340

VERT SPREAD: 4.794

GROUP SPREAD: 4.854

MIN RADIUS: 0.190

MAX RADIUS: 3.733

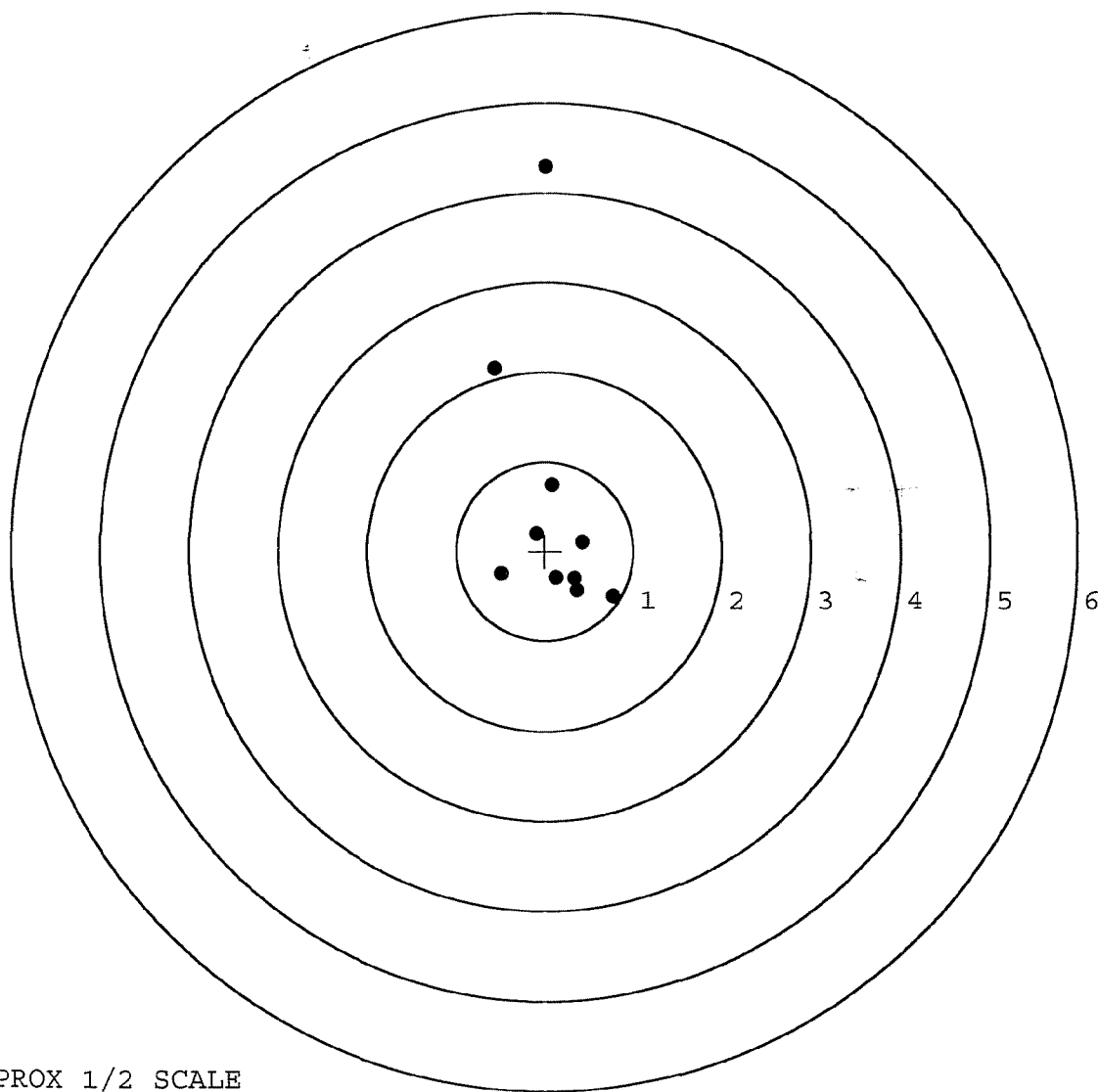
MEAN RADIUS: 1.157

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.126	-0.305
2:	0.362	-0.441
3:	0.772	-0.507
4:	0.425	0.106
5:	0.077	0.744
6:	-0.498	-0.255
7:	-0.568	2.037
8:	0.009	4.287
9:	0.336	-0.312
10:	-0.096	0.195



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461676. 0

TARGET NUMBER: 2

FILE DATE: 10/13/2005

FILE TIME: 18:16

X CENTROID: -0.160

Y CENTROID: 0.119

POA TO CENTROID: 0.199

HORZ SPREAD: 1.521

VERT SPREAD: 1.532

GROUP SPREAD: 1.636

MIN RADIUS: 0.284

MAX RADIUS: 1.004

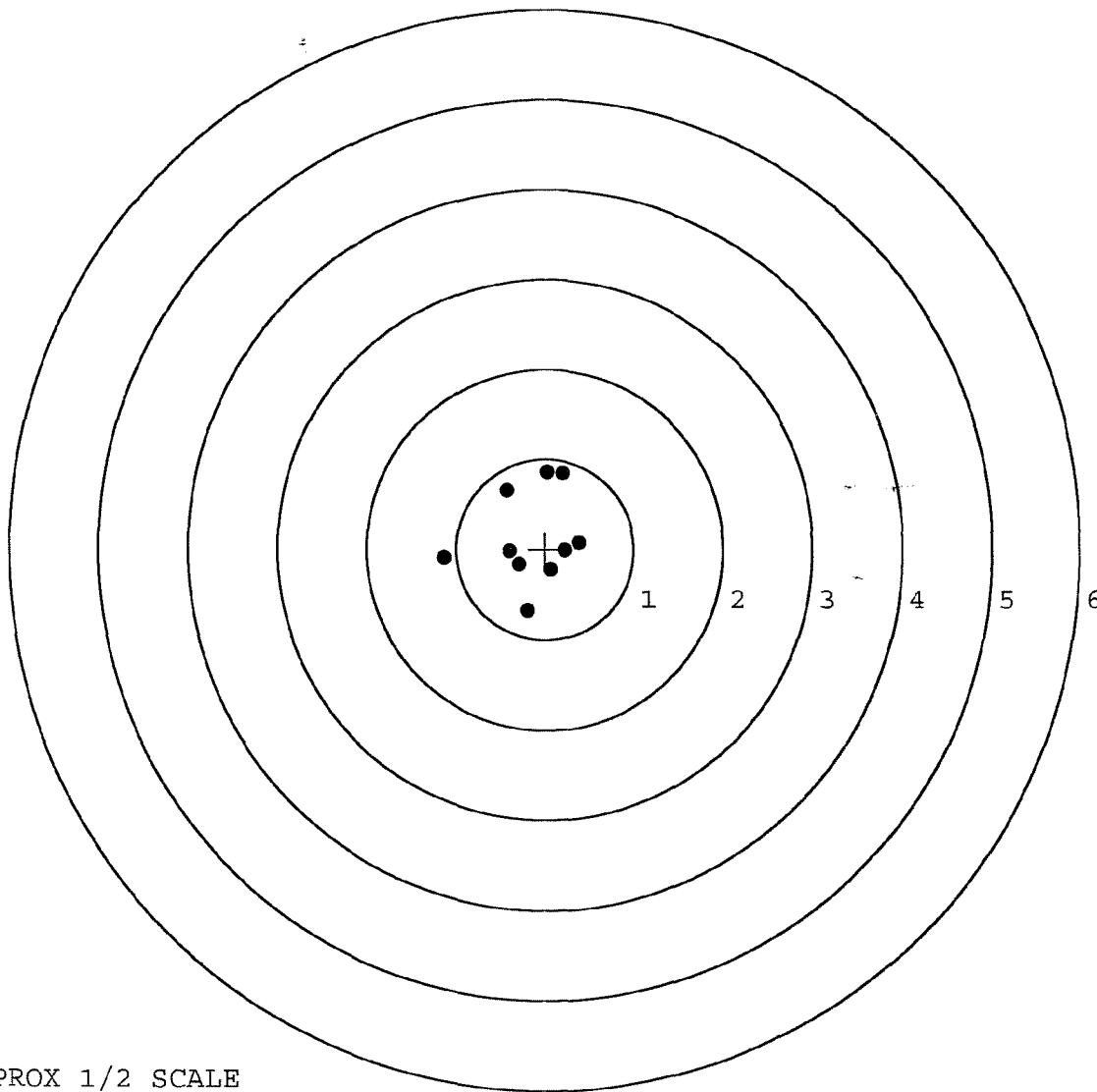
MEAN RADIUS: 0.593

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.062	-0.228
2:	0.383	0.076
3:	0.221	-0.015
4:	-0.205	-0.683
5:	-0.299	-0.171
6:	-0.406	-0.022
7:	-1.138	-0.104
8:	-0.436	0.652
9:	0.022	0.849
10:	0.200	0.838



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461676. 0

TARGET NUMBER: 3

FILE DATE: 10/13/2005

FILE TIME: 18:16

X CENTROID: 0.118

Y CENTROID: -0.074

POA TO CENTROID: 0.139

HORZ SPREAD: 1.961

VERT SPREAD: 2.053

GROUP SPREAD: 2.239

MIN RADIUS: 0.235

MAX RADIUS: 1.327

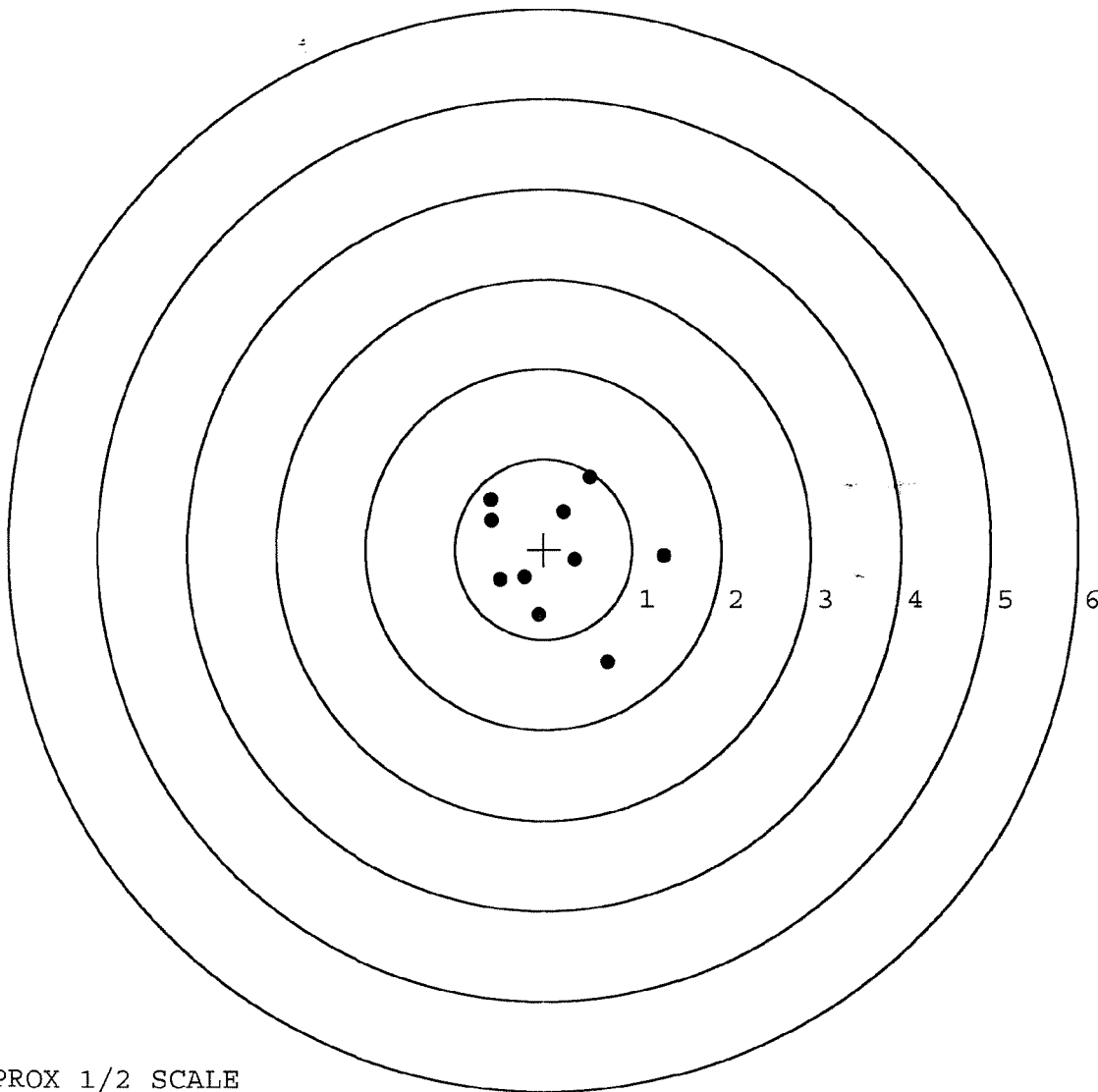
MEAN RADIUS: 0.779

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.065	-0.728
2:	0.715	-1.259
3:	1.357	-0.078
4:	0.349	-0.116
5:	-0.223	-0.307
6:	-0.499	-0.335
7:	-0.604	0.550
8:	0.220	0.415
9:	0.524	0.794
10:	-0.598	0.323

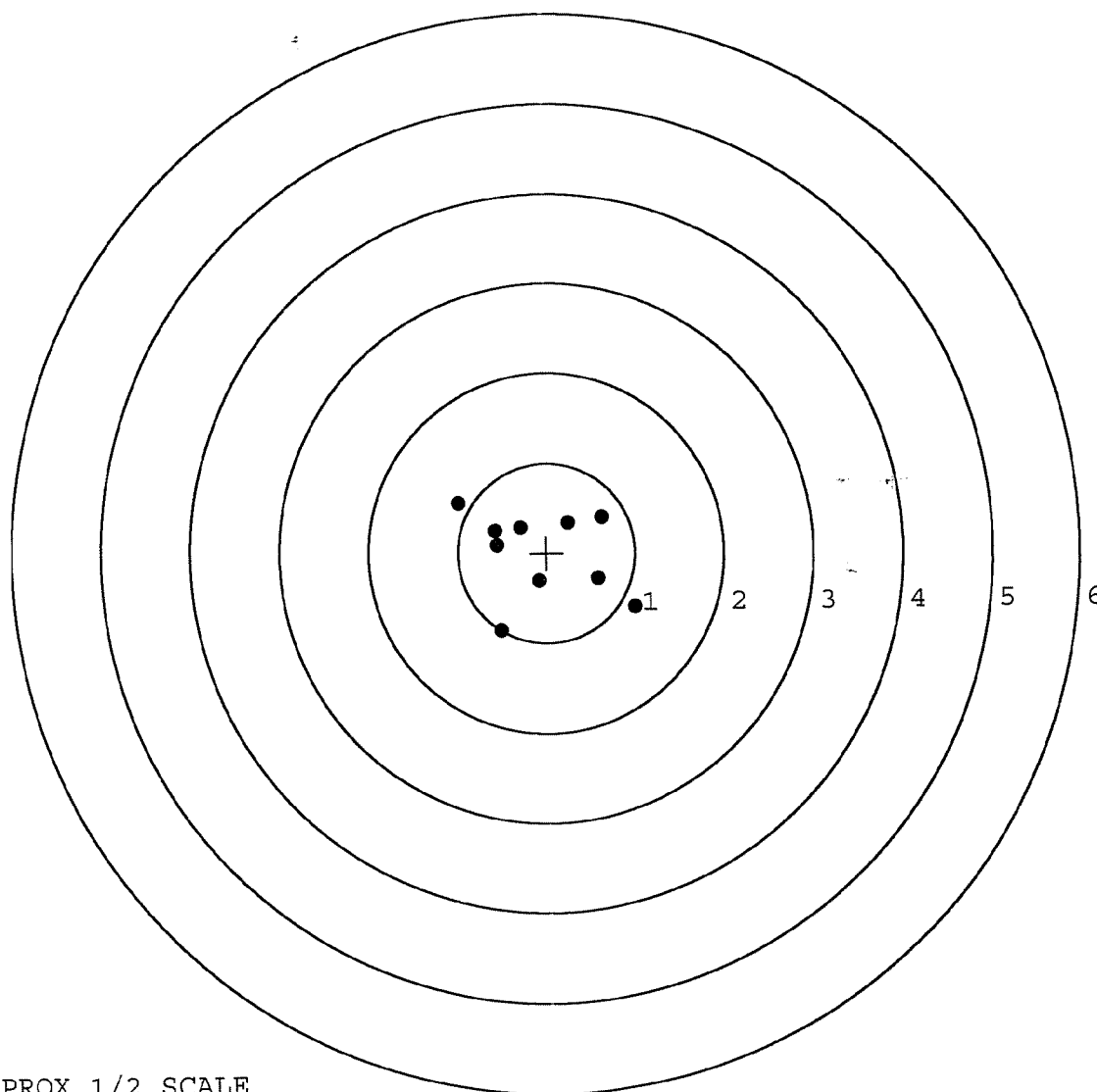


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461676. __0
TARGET NUMBER: 4
FILE DATE: 10/13/2005
FILE TIME: 18:16

X CENTROID: -0.060
Y CENTROID: -0.015
POA TO CENTROID: 0.062
HORZ SPREAD: 1.988
VERT SPREAD: 1.424
GROUP SPREAD: 2.307
MIN RADIUS: 0.303
MAX RADIUS: 1.211
MEAN RADIUS: 0.702
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.564	0.091
2:	-0.294	0.285
3:	-0.993	0.563
4:	-0.089	-0.316
5:	0.579	-0.290
6:	0.995	-0.608
7:	-0.524	-0.861
8:	0.244	0.340
9:	0.626	0.396
10:	-0.582	0.253

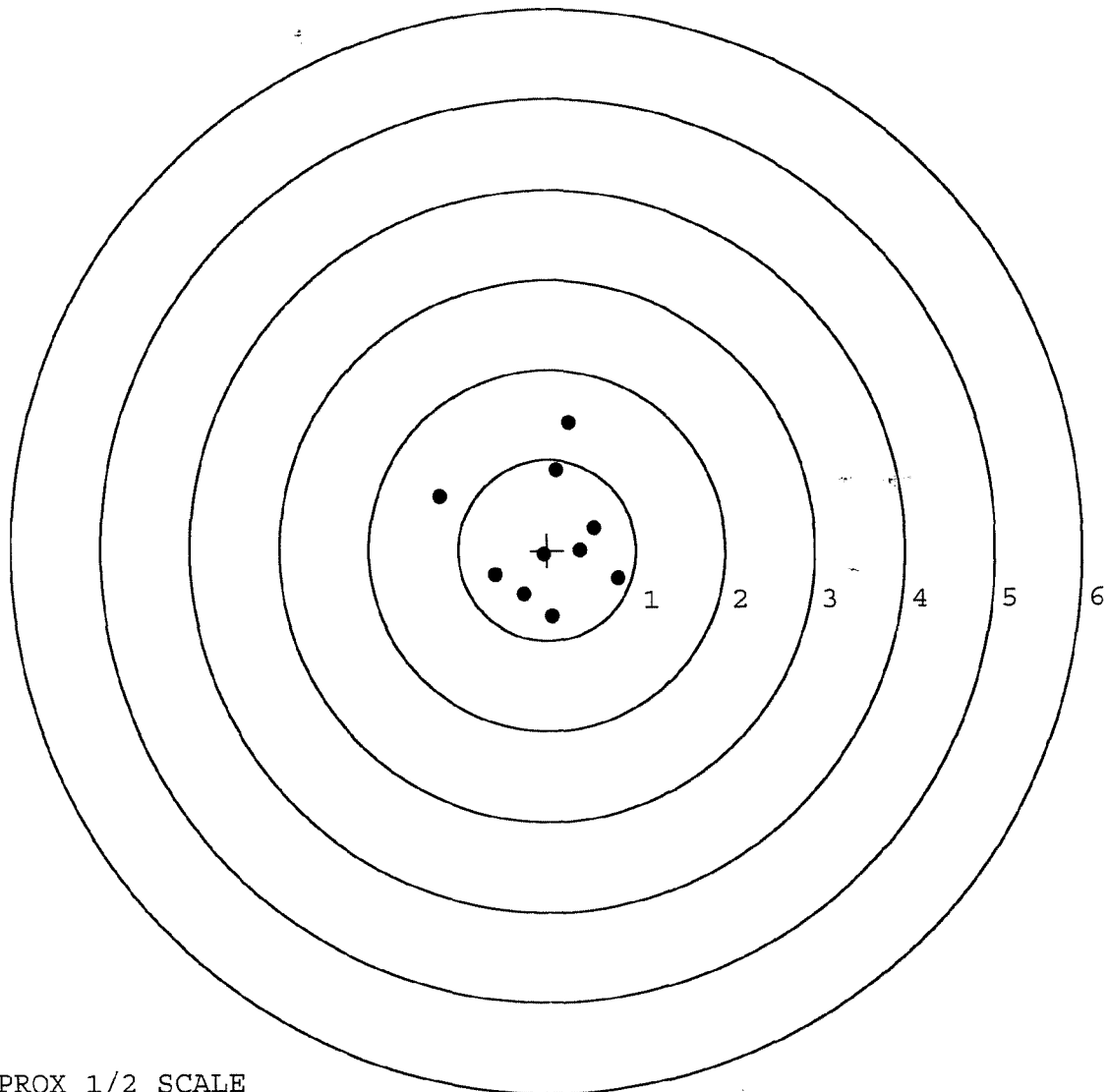


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461676. __0
TARGET NUMBER: 5
FILE DATE: 10/13/2005
FILE TIME: 18:16

X CENTROID: -0.003
Y CENTROID: 0.127
POA TO CENTROID: 0.127
HORZ SPREAD: 2.009
VERT SPREAD: 2.145
GROUP SPREAD: 2.154
MIN RADIUS: 0.178
MAX RADIUS: 1.305
MEAN RADIUS: 0.764
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.593	-0.268
2:	-0.272	-0.493
3:	0.048	-0.738
4:	-0.043	-0.047
5:	0.368	0.003
6:	0.527	0.247
7:	0.797	-0.318
8:	0.104	0.881
9:	0.249	1.407
10:	-1.212	0.594



TARGET APPROX 1/2 SCALE