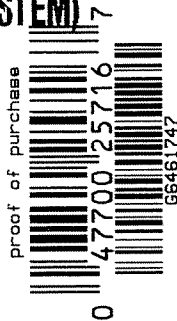


G-646 1747

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

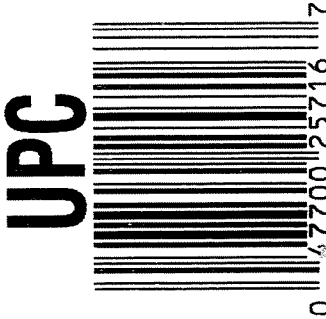
- INSTRUCTION BOOK 3518



DD FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461747



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.



CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400155671

4/7/2005 2:48:09 PM

Crib

71

Original

25716

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



.MA25716

Shop Order: SW5716 – APR



.ABSW5716 – APR

Start Date: 3/11/2005

Finish Date: 4/14/2005

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0003858612

0540

Flat Black Powder Coat, Barrel and

01PC001



0003858602

0560

Reassemble Action.

89SWS1



0003858603

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G64601747

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	AC
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-18-05	AC
610	DIS-ASSEMBLE GUN	APR 26 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRW
620	APPLY COATINGS (BARREL ACTION)		5-6-05	WD
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-12-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-12-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-12-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-12-05	RTZ
	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 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	5-31-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	5-31-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	Ac
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-31-05	Ac
	J) ASSEMBLE STOCK		5-12-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-31-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-12-05	RTZ
	M) IRON SIGHT ALIGNMENT		5-12-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-12-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-12-05	RTZ TRW
	MALFUNCTION	CORRECTION	3	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-13-05	Ac
655	FINAL INSPECTION A) HEADSPACE		5-31-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.82</u> <u>2.85</u> <u>2.68</u> <u>2.99</u> <u>2.95</u>	5-23-05	Ac
	C) FUNCTION		5-31-05	Ac
660	PACK		5-31-05	RTZ

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 5-3-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.41		2.65	
PULL #2	2.23	2.71		2.35	
PULL #3	2.49	2.90		2.71	
PULL #4	2.60	2.72		2.58	
PULL #5	2.71	2.39		2.64	
TOTAL	12.36	13.13		12.93	
AVERAGE	2.47	2.62		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.26		
PULL #2	3.16	3.40		
PULL #3	3.19	3.34		
PULL #4	3.17	3.33		
PULL #5	3.09	3.29		
TOTAL	15.72	16.62		
AVERAGE	3.14	3.32		

	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	4.46	4.61		4.50
PULL #2	4.34	4.45		4.42
PULL #3	4.51	4.42		4.28
PULL #4	4.46	4.42		4.32
PULL #5	4.33	4.39		4.38
TOTAL	22.10	22.29		21.90
AVERAGE	4.42	4.45		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461747.___0
FILE DATE AND TIME: 05/13/2005 06:22

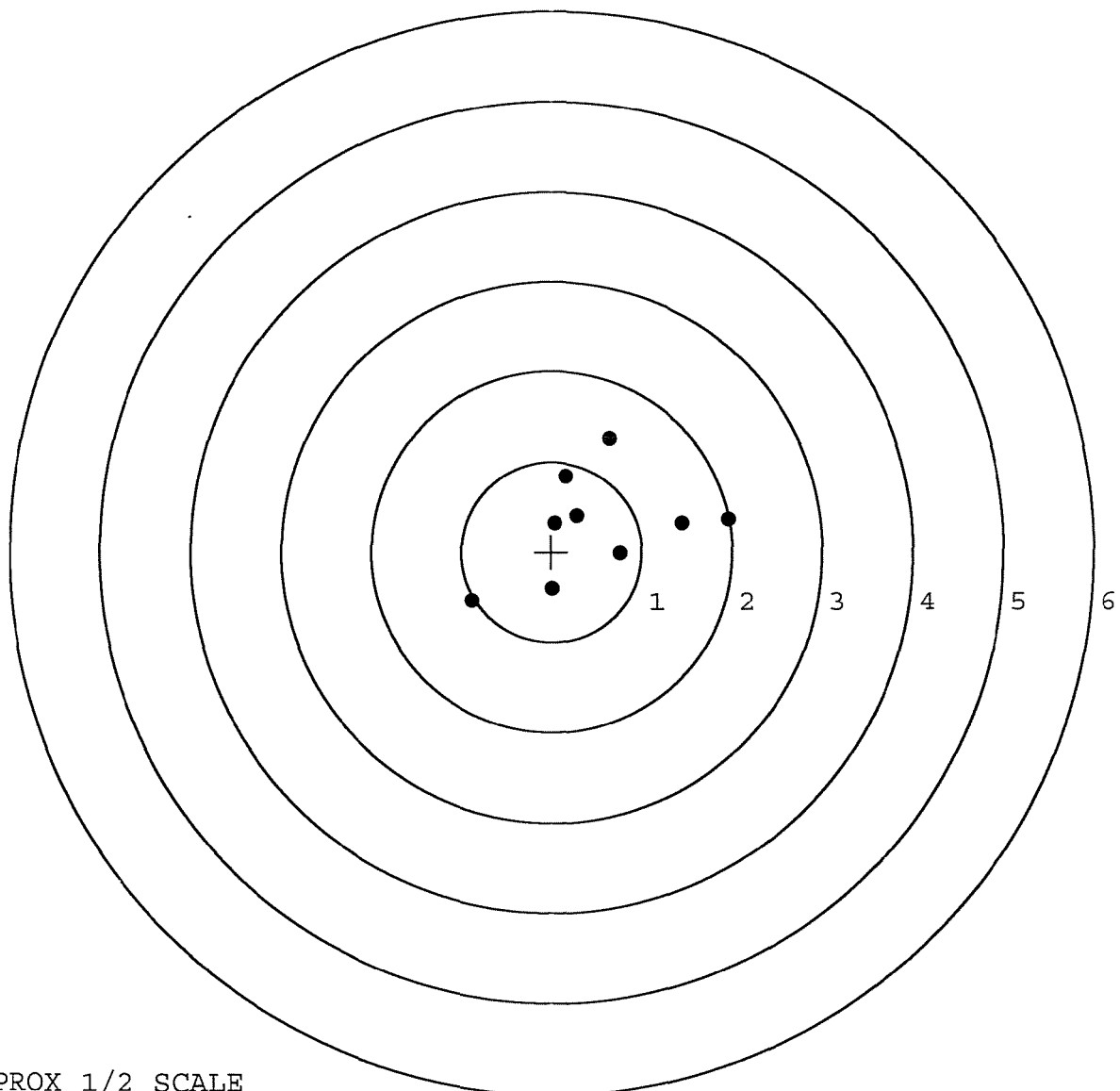
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	0.124
The Average Point of Impact of the Five Target Set:	0.125
The Average Mean Radius of the Five Target Set:	0.800
The Distance from POA to Centroid Target #1:	0.553
The Distance from Centroid Target #2 to Centroid Target #1:	0.488
The Distance from Centroid Target #3 to Centroid Target #1:	0.687
The Distance from Centroid Target #4 to Centroid Target #1:	0.951
The Distance from Centroid Target #5 to Centroid Target #1:	0.495

SERIAL NUMBER: G6461747. __0
TARGET NUMBER: 1
FILE DATE: 05/13/2005
FILE TIME: 06:22

POINT#	X	Y
1:	0.640	1.257
2:	1.957	0.365
3:	1.441	0.323
4:	0.162	0.840
5:	0.284	0.403
6:	0.285	0.400
7:	0.036	0.316
8:	0.760	-0.014
9:	0.007	-0.411
10:	-0.886	-0.543

X CENTROID: 0.469
Y CENTROID: 0.294
POA TO CENTROID: 0.553
HORZ SPREAD: 2.843
VERT SPREAD: 1.800
GROUP SPREAD: 2.984
MIN RADIUS: 0.212
MAX RADIUS: 1.592
MEAN RADIUS: 0.779
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

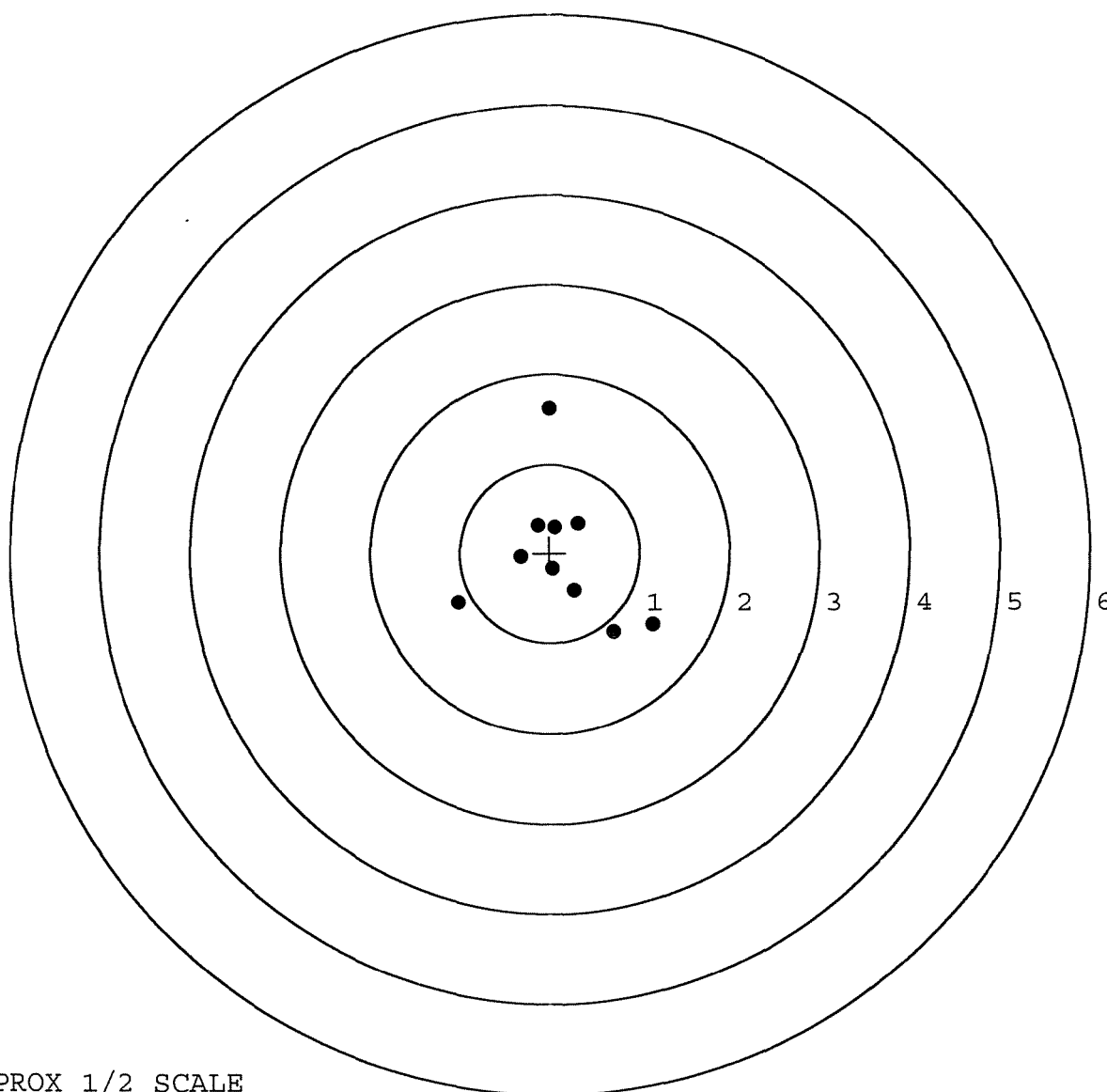


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461747. __0
TARGET NUMBER: 2
FILE DATE: 05/13/2005
FILE TIME: 06:22

POINT#	X	Y
1:	-0.011	1.618
2:	-0.324	-0.046
3:	-0.134	0.311
4:	-1.015	-0.555
5:	1.144	-0.804
6:	0.709	-0.885
7:	0.276	-0.415
8:	0.037	-0.178
9:	0.315	0.339
10:	0.057	0.287

X CENTROID: 0.105
Y CENTROID: -0.033
POA TO CENTROID: 0.110
HORZ SPREAD: 2.159
VERT SPREAD: 2.503
GROUP SPREAD: 2.683
MIN RADIUS: 0.161
MAX RADIUS: 1.655
MEAN RADIUS: 0.741
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

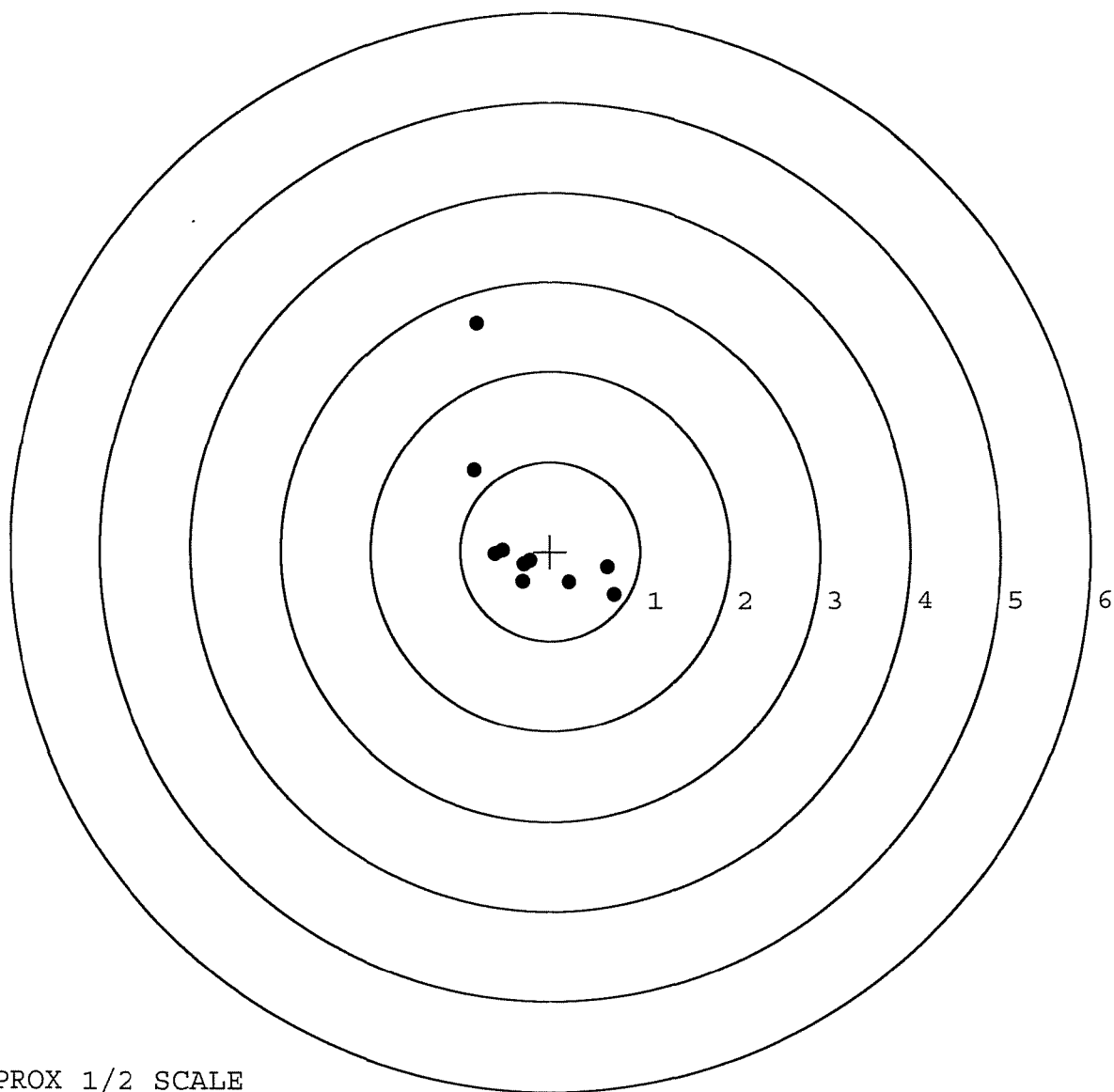


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461747.____0
TARGET NUMBER: 3
FILE DATE: 05/13/2005
FILE TIME: 06:22

X CENTROID: -0.209
Y CENTROID: 0.184
POA TO CENTROID: 0.279
HORZ SPREAD: 1.556
VERT SPREAD: 3.022
GROUP SPREAD: 3.387
MIN RADIUS: 0.290
MAX RADIUS: 2.432
MEAN RADIUS: 0.811
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.634	-0.178
2:	0.712	-0.483
3:	0.208	-0.345
4:	-0.230	-0.105
5:	-0.309	-0.338
6:	-0.530	0.017
7:	-0.844	0.909
8:	-0.818	2.539
9:	-0.619	-0.030
10:	-0.296	-0.142

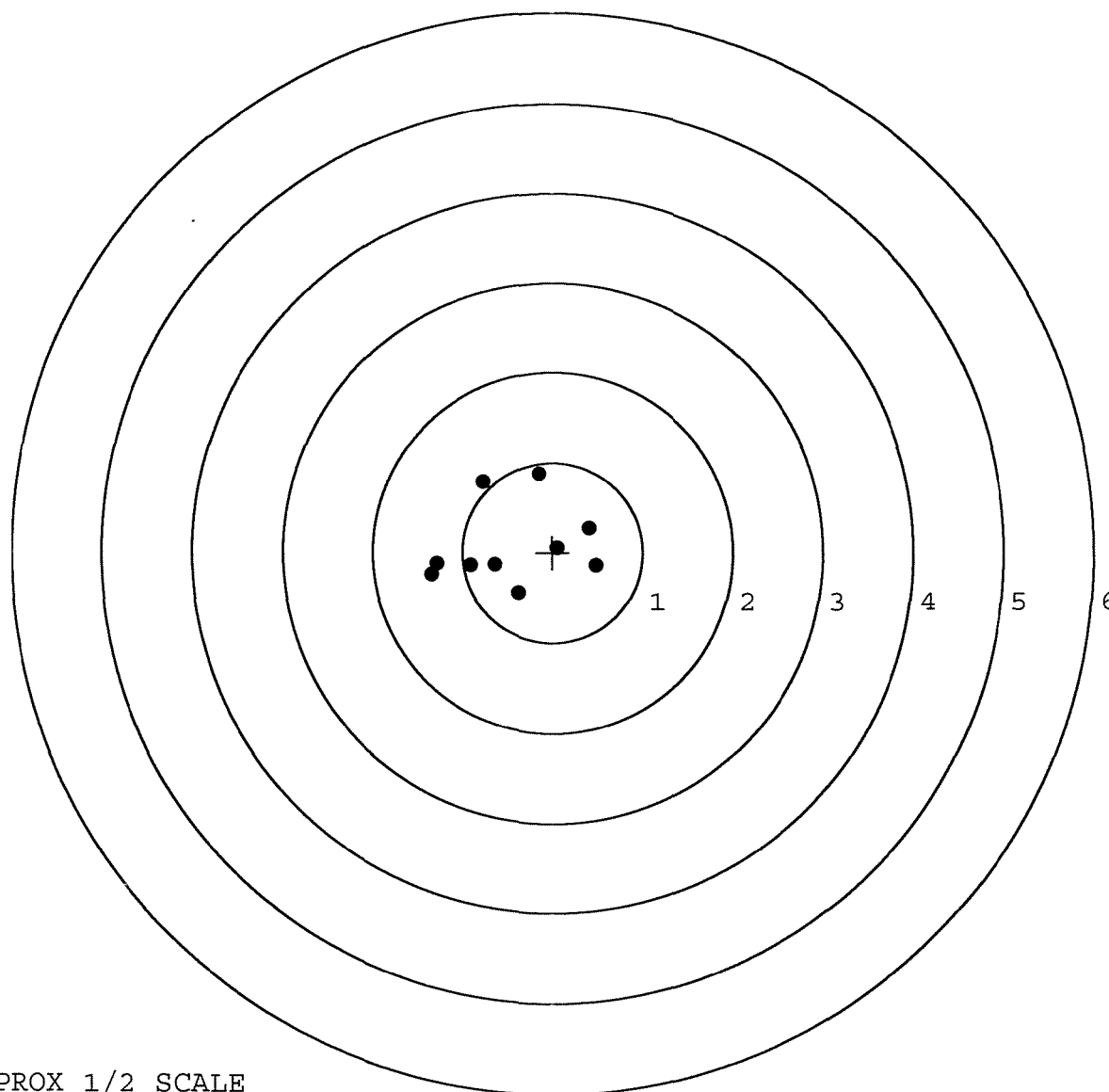


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461747. __0
TARGET NUMBER: 4
FILE DATE: 05/13/2005
FILE TIME: 06:22

X CENTROID: -0.456
Y CENTROID: 0.070
POA TO CENTROID: 0.461
HORZ SPREAD: 1.836
VERT SPREAD: 1.332
GROUP SPREAD: 1.839
MIN RADIUS: 0.282
MAX RADIUS: 0.965
MEAN RADIUS: 0.713
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.909	-0.150
2:	-0.643	-0.141
3:	-0.383	-0.454
4:	0.484	-0.148
5:	-1.352	-0.249
6:	-1.292	-0.132
7:	-0.152	0.878
8:	-0.773	0.781
9:	0.053	0.047
10:	0.408	0.267

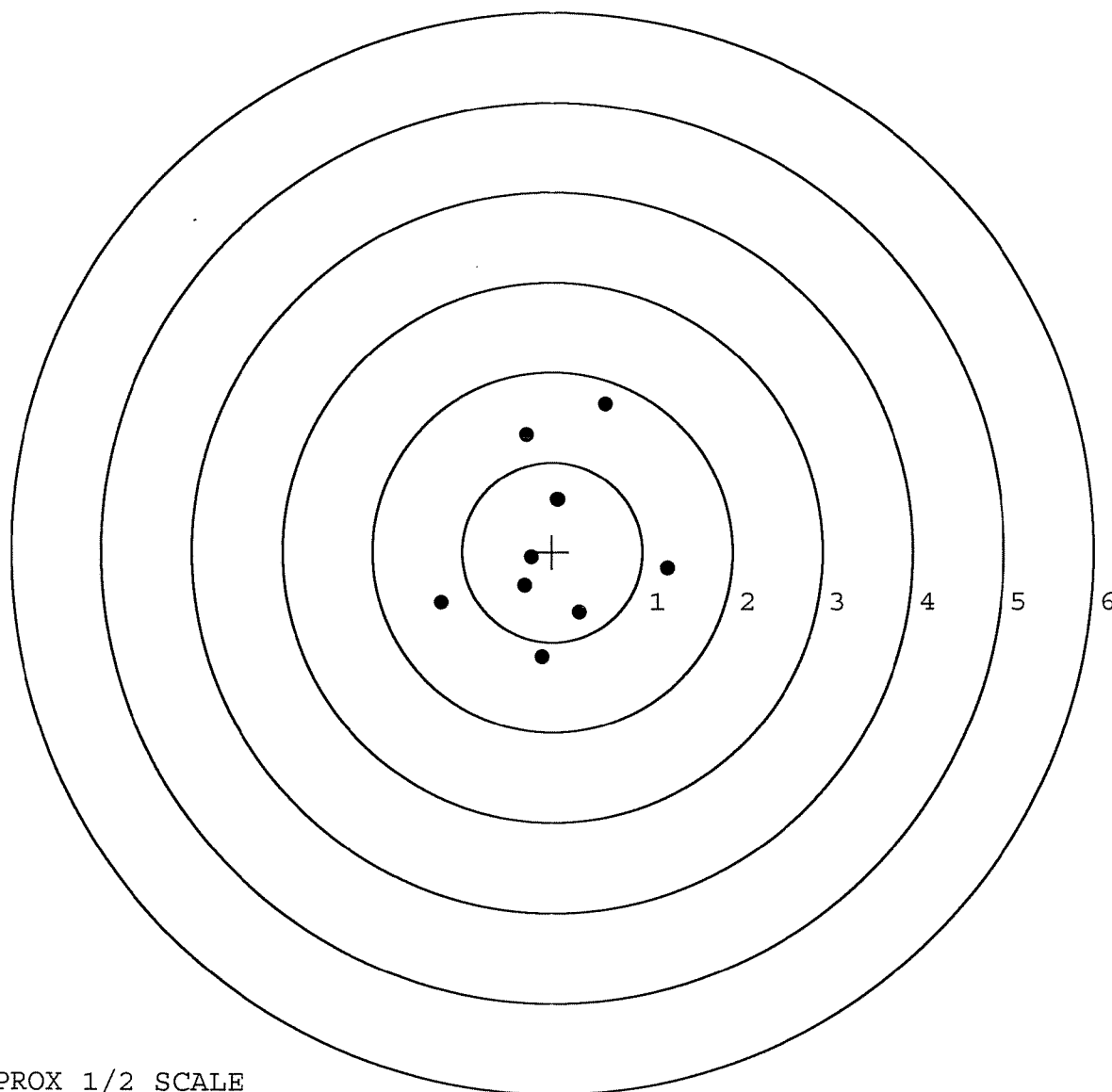


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461747. 0
TARGET NUMBER: 5
FILE DATE: 05/13/2005
FILE TIME: 06:22

X CENTROID: 0.010
Y CENTROID: 0.107
POA TO CENTROID: 0.107
HORZ SPREAD: 2.516
VERT SPREAD: 2.813
GROUP SPREAD: 2.900
MIN RADIUS: 0.299
MAX RADIUS: 1.645
MEAN RADIUS: 0.955
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.279	-0.184
2:	0.304	-0.676
3:	-0.115	-1.167
4:	-1.237	-0.568
5:	-0.313	-0.378
6:	-0.234	-0.066
7:	0.592	1.646
8:	-0.293	1.300
9:	0.060	0.583
10:	0.059	0.580



TARGET APPROX 1/2 SCALE