

G 63005-86

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	84118		
SERIAL NUMBER	G 6300 586		
LOG-IN DATE	8-23-04		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS		
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE		
D	SAFETY "OFF" FORCE		
E	FIRING PIN INDENT		
640	TARGET		
655	FINAL INSPECT	8-23-04	RTL
660	PACK	8-23-04	RTL
STOCK Chipped Replace Stock		8-23-04	RTL
		SHIP DATE	
QAR INSPECTION DATE			

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

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



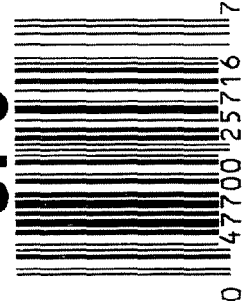
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6300586

UPC



Remington®

VERY IMPORTANT!
Instruction Book
enclosed to assure
safe use of this
firearm.

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

SERIAL NO.
G6300586

DD

ORDER NO.
25716

Made in Ilion, NY Reg. U.S. Pat & tm. Off. Marca Registrada Marque Deposee.



5716 G6300586

04WY

7/22/2004 3:19:13 PM

Copy

Original

25716

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



.MA25716

Shop Order: SWS626544



.ABSWS626544

Start Date: 7/8/2004

Finish Date: 7/23/2004

0630

01PC001

Flat Black Powder Coat, Barrel and



0003338145

0640

89SWS1

Reassemble Action.



0003338146

0685

89SWS1

Attach Front and Rear Sight Assemblies



0003338151

0710

89SWS1

Pack Rifle & Stencil SWS Container



.OP0710

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6300586

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-6-04	RTL
600	PROOF		4-6-04	RTL
607	CHECK HEADSPACE		4-6-04	RTL
610	DIS-ASSEMBLE GUN		4-6-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RL		
615	ROLLMARK CALIBER		4/8/04	RB
617	DRILL AND TAP SIGHT HOLES			
620	APPLY COATINGS (BARREL ACTION)		5-7	TA
	(BOLT)		5-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-15-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-15-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-15-04	RW
	D) OIL FIRING PIN ASSEMBLY		6-15-04	RW
	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>8⁰</u> <u>8⁰</u> <u>8⁰</u>	6-27-04	RT
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.25</u> <u>2.20</u>	6-21-04	RT
	H) TRIGGER PULL TEST AND RETAINABILITY		6-21-04	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.022</u>	6-21-04	RTL
	J) ASSEMBLE STOCK		6-15-04	Rec)
	K) ASSEMBLE SWIVEL STUDS		6-28-04	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	6-16-04	AL
	MALFUNCTION	CORRECTION	6-16-04	AC
	MALFUNCTION	CORRECTION	6-16-04	AC
	MALFUNCTION	CORRECTION	6-16-04	AC
	MALFUNCTION	CORRECTION	6-16-04	AC
645	INSPECT FOR LIVE AMMO		6-16-04	AL
655	FINAL INSPECTION A) HEADSPACE		6-28-04	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.55</u> <u>2.49</u> <u>2.72</u> <u>2.16</u>	6-21-04	RTL
	C) FUNCTION			
660	PACK		8-24-04	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 6-15-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.47	2.34		2.42	
PULL #2	2.22	2.34		2.46	
PULL #3	2.27	2.32		2.38	
PULL #4	2.28	2.30		2.35	
PULL #5	2.26	2.30		2.45	
TOTAL	11.50	11.60		12.06	
AVERAGE	2.30	2.32		2.41	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.14		
PULL #2	3.07	3.08		
PULL #3	3.06	3.18		
PULL #4	3.10	3.09		
PULL #5	3.06	3.08		
TOTAL	15.38	15.57		
AVERAGE	3.07	3.11		

	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	4.40	4.18		4.37
PULL #2	4.30	4.13		4.27
PULL #3	4.35	4.20		4.49
PULL #4	4.32	4.26		4.20
PULL #5	4.39	3.99		4.18
TOTAL	21.76	20.76		21.51
AVERAGE	4.35			4.30

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6300586.___0

FILE DATE AND TIME: 06/16/2004 07:05

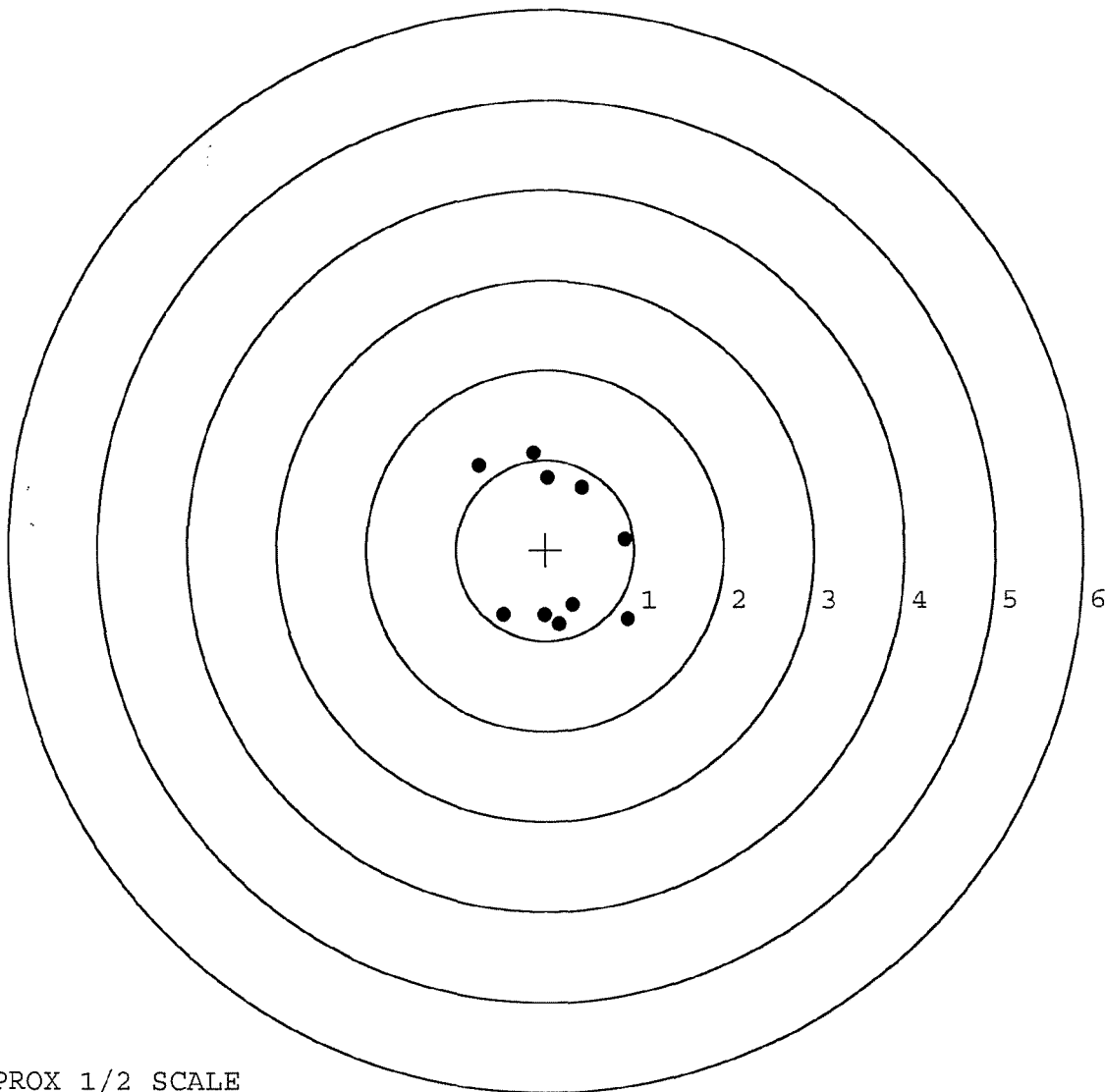
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.178
The Average Y Centroid of the Five Target Set:	0.006
The Average Point of Impact of the Five Target Set:	0.178
The Average Mean Radius of the Five Target Set:	0.842
The Distance from POA to Centroid Target #1:	0.132
The Distance from Centroid Target #2 to Centroid Target #1:	0.237
The Distance from Centroid Target #3 to Centroid Target #1:	0.122
The Distance from Centroid Target #4 to Centroid Target #1:	0.306
The Distance from Centroid Target #5 to Centroid Target #1:	0.197

SERIAL NUMBER: G6300586. 0
TARGET NUMBER: 1
FILE DATE: 06/16/2004
FILE TIME: 07:05

X CENTROID: 0.132
Y CENTROID: 0.001
POA TO CENTROID: 0.132
HORZ SPREAD: 1.664
VERT SPREAD: 1.899
GROUP SPREAD: 2.385
MIN RADIUS: 0.631
MAX RADIUS: 1.287
MEAN RADIUS: 0.896
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.744	0.943
2:	-0.140	1.075
3:	0.024	0.801
4:	0.407	0.697
5:	0.899	0.126
6:	0.920	-0.765
7:	0.305	-0.606
8:	0.148	-0.824
9:	-0.020	-0.722
10:	-0.476	-0.716



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300586. 0

TARGET NUMBER: 2

FILE DATE: 06/16/2004

FILE TIME: 07:05

X CENTROID: 0.341

Y CENTROID: 0.112

POA TO CENTROID: 0.359

HORZ SPREAD: 1.347

VERT SPREAD: 2.463

GROUP SPREAD: 2.476

MIN RADIUS: 0.114

MAX RADIUS: 1.384

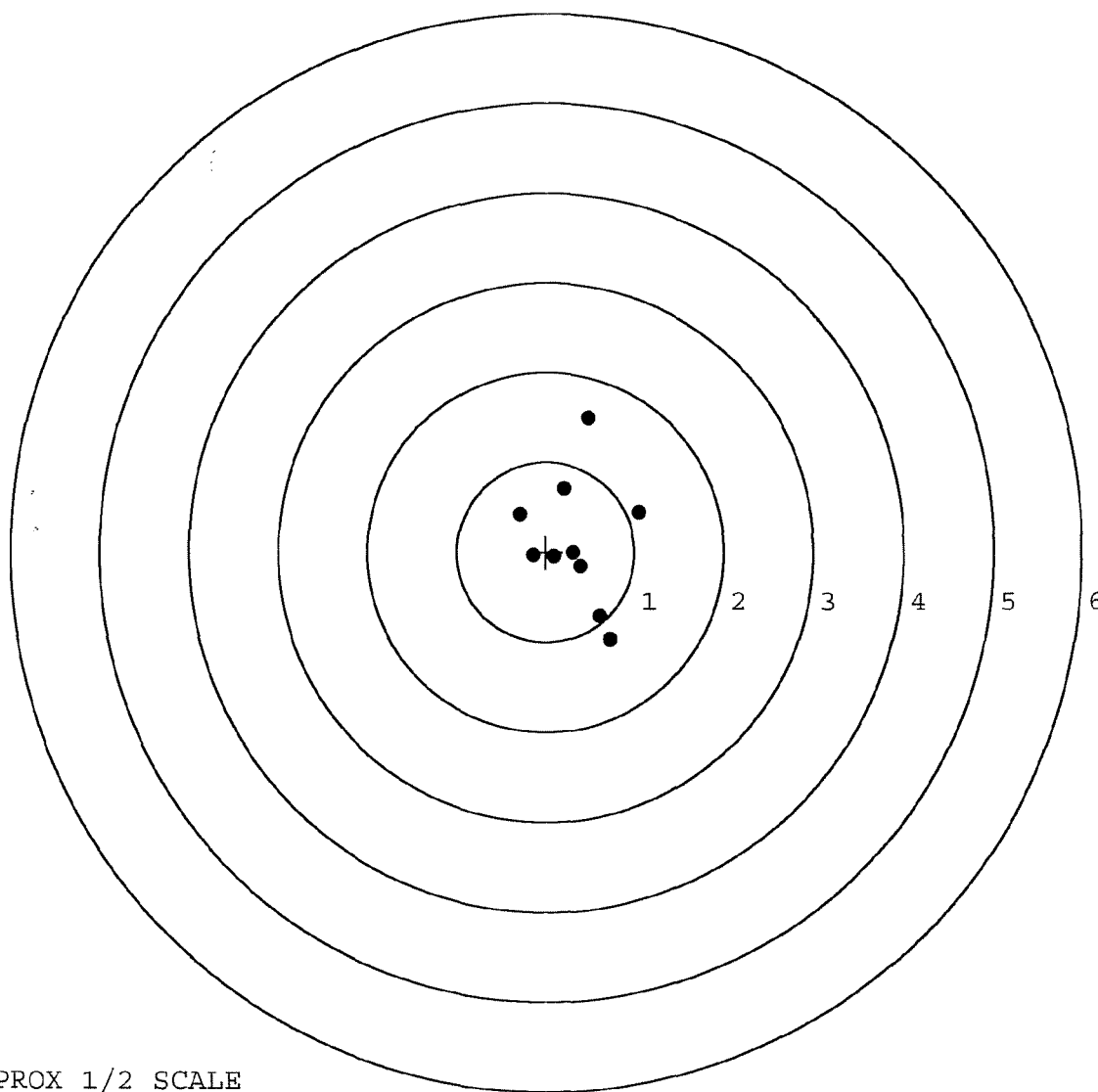
MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.475	1.489
2:	0.205	0.702
3:	-0.298	0.420
4:	1.049	0.444
5:	-0.144	-0.039
6:	0.087	-0.049
7:	0.309	0.003
8:	0.392	-0.158
9:	0.610	-0.719
10:	0.727	-0.974



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300586. 0

TARGET NUMBER: 3

FILE DATE: 06/16/2004

FILE TIME: 07:05

X CENTROID: 0.234

Y CENTROID: 0.069

POA TO CENTROID: 0.244

HORZ SPREAD: 0.930

VERT SPREAD: 2.433

GROUP SPREAD: 2.469

MIN RADIUS: 0.151

MAX RADIUS: 1.629

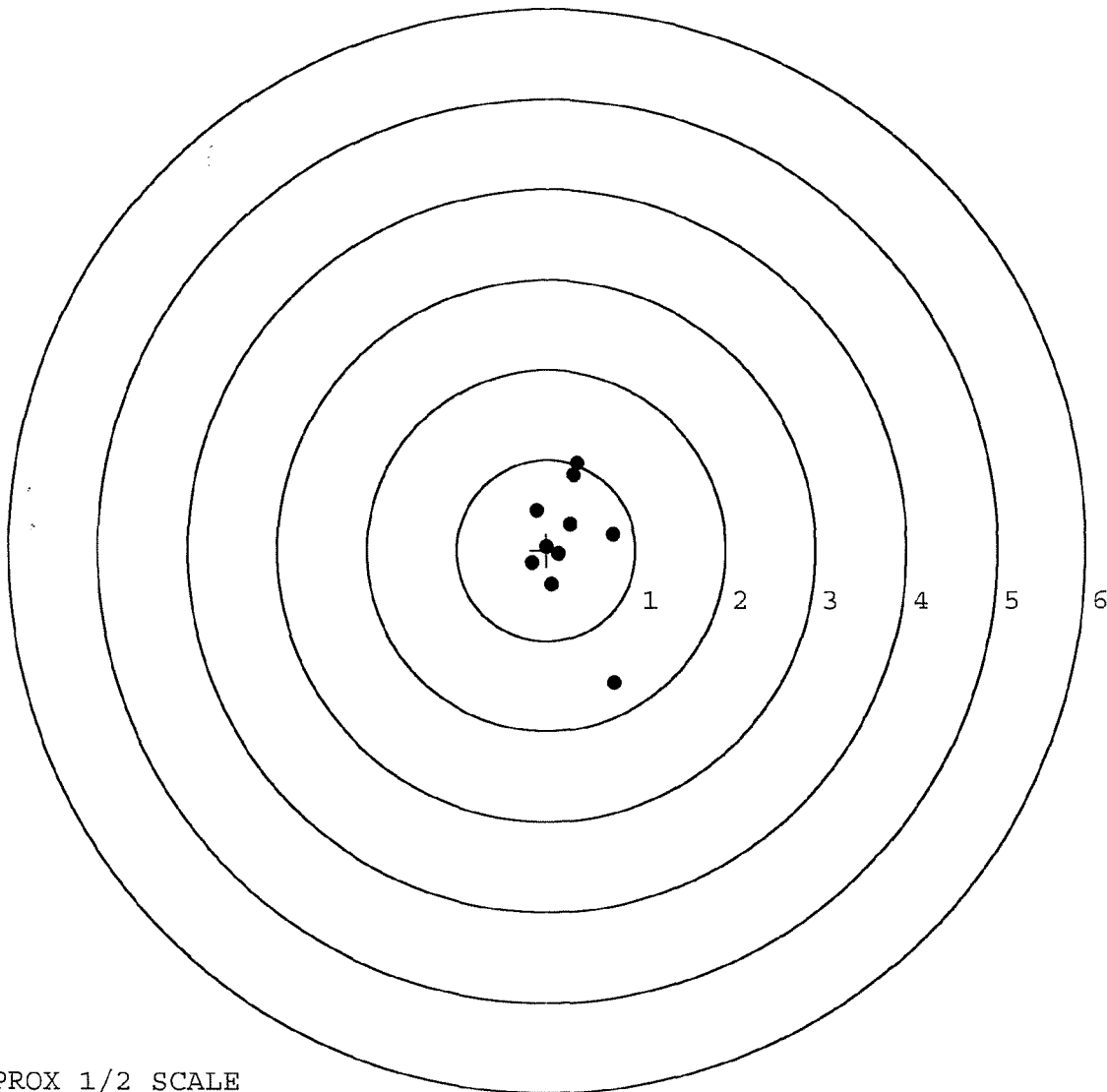
MEAN RADIUS: 0.586

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.301	0.828
2:	0.343	0.962
3:	-0.114	0.438
4:	0.749	0.177
5:	0.263	0.288
6:	-0.166	-0.146
7:	0.056	-0.381
8:	0.135	-0.046
9:	0.005	0.039
10:	0.764	-1.471



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300586. 0

TARGET NUMBER: 4

FILE DATE: 06/16/2004

FILE TIME: 07:05

X CENTROID: 0.182

Y CENTROID: -0.301

POA TO CENTROID: 0.351

HORZ SPREAD: 2.910

VERT SPREAD: 3.188

GROUP SPREAD: 3.237

MIN RADIUS: 0.299

MAX RADIUS: 1.897

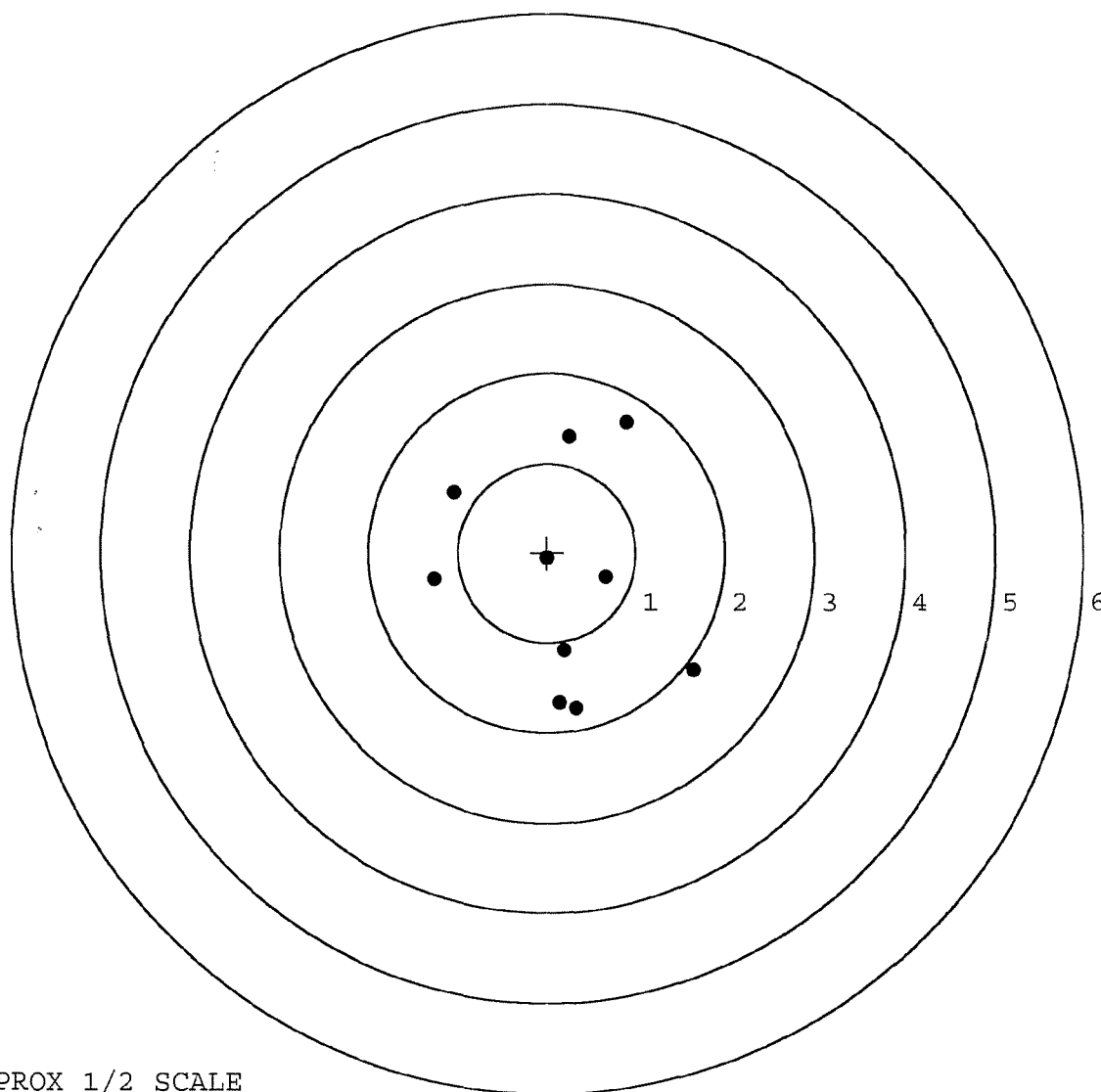
MEAN RADIUS: 1.267

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.892	1.458
2:	0.247	1.295
3:	-1.046	0.675
4:	-1.263	-0.299
5:	0.004	-0.060
6:	0.662	-0.268
7:	0.199	-1.093
8:	0.141	-1.676
9:	0.332	-1.730
10:	1.647	-1.311

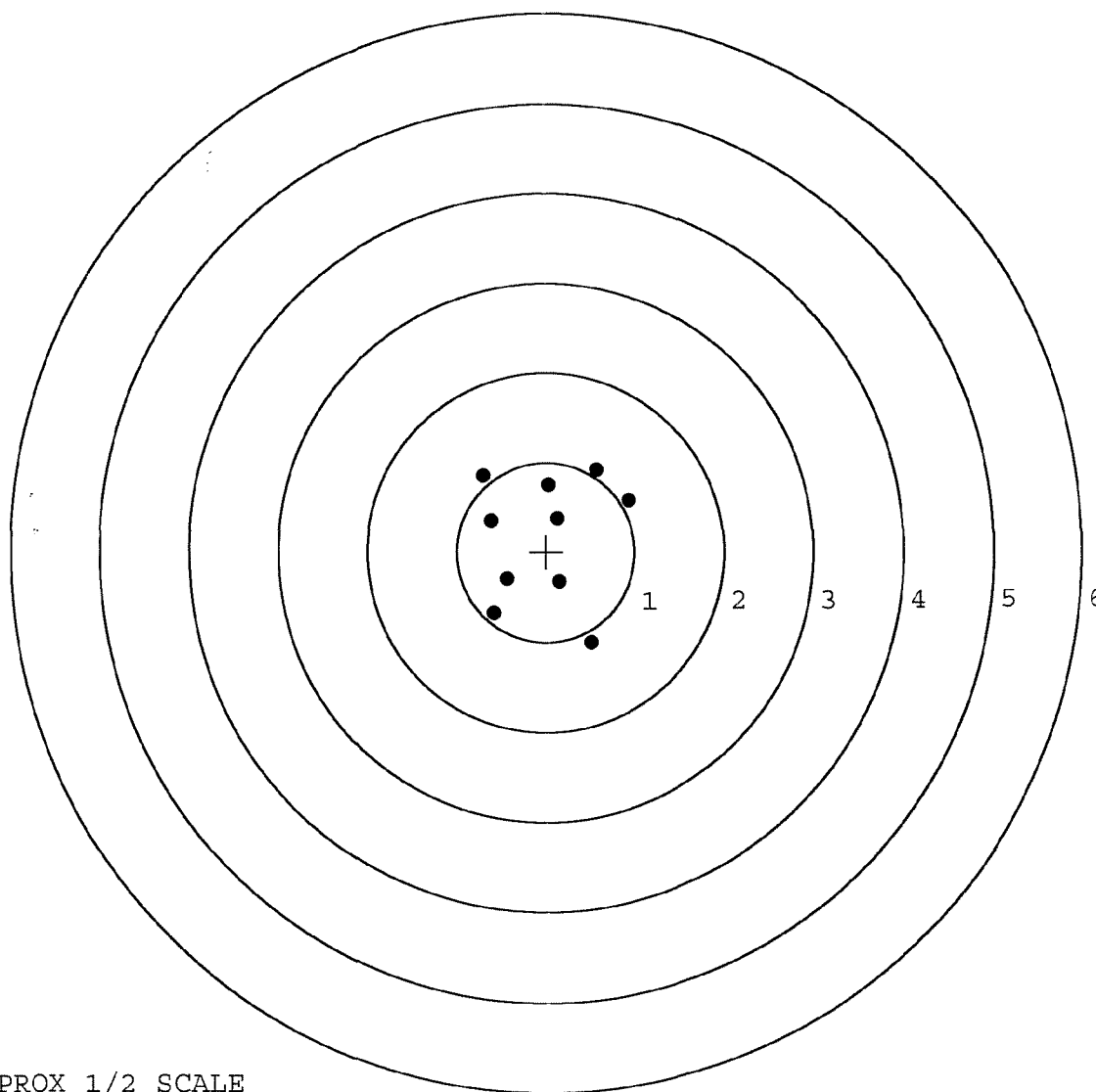


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300586. __0
TARGET NUMBER: 5
FILE DATE: 06/16/2004
FILE TIME: 07:05

X CENTROID: 0.002
Y CENTROID: 0.149
POA TO CENTROID: 0.149
HORZ SPREAD: 1.643
VERT SPREAD: 1.926
GROUP SPREAD: 2.223
MIN RADIUS: 0.259
MAX RADIUS: 1.265
MEAN RADIUS: 0.792
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.573	0.916
2:	0.945	0.577
3:	0.039	0.753
4:	0.140	0.368
5:	-0.698	0.857
6:	-0.609	0.347
7:	-0.444	-0.304
8:	0.153	-0.334
9:	-0.588	-0.680
10:	0.508	-1.010



TARGET APPROX 1/2 SCALE