

G-6590132

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

- INSTRUCTION BOOK 3518

DD FORM

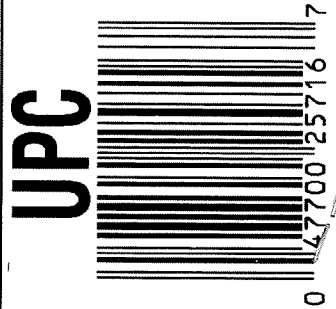


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6590132



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.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590132

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-20-06	RTZ
420	ASSEMBLE ACTION		9-25-06	RTZ
430	ASSEMBLE TO STOCK		9-25-06	DK
440	PROOF		9-25-06	TRW
460	CHECK HEADSPACE		9-25-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 26 2006	9-25-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unus</u>	9/26/06	unus
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-27-06	CW
510	DRILL AND TAP SIGHT HOLES		9-26-06	TRW
520	GOFF BLAST BBL / REC		9-28-06	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/29/06	TE
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/2/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/2/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/2/06	DA
	D) OIL FIRING PIN ASSEMBLY		10-5-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/10/06	unus

F004 REV 5/2006

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400165248

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>55</u> <u>55</u> <u>5.5</u>	10-10-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	10-10-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/10/06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	10-10-06	DA
	J) ASSEMBLE STOCK		10-5-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/10/06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-5-06	RTZ
	M) IRON SIGHT ALIGNMENT		10-5-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-5-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/5/06	MTM
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-5-06	SPD
670	FINAL INSPECTION A) HEADSPACE		10/10/06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.29</u> <u>2.35</u> <u>2.33</u> <u>2.25</u>	10-9-06	DA
	C) FUNCTION		10/10/06	MTM
690	PACK		10-26-06	DA

F004 REV 5/2006

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 10-2-06

TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	247	259		260	
PULL #2	246	259		254	
PULL #3	246	261		254	
PULL #4	250	249		253	
PULL #5	249	245		250	
TOTAL	1238	1273		1271	
AVERAGE	247	254		254	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	317	284		
PULL #2	310	300		
PULL #3	314	314		
PULL #4	312	305		
PULL #5	316	304		
TOTAL	1569	1507		
AVERAGE	313	301		

	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	402	414		403
PULL #2	398	405		400
PULL #3	403	397		404
PULL #4	404	404		406
PULL #5	406	407		405
TOTAL	2013	2027		2018
AVERAGE	402	405		403

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590132.__1
FILE DATE AND TIME: 10/07/2006 07:41

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.041
The Average Y Centroid of the Five Target Set:	-0.020
The Average Point of Impact of the Five Target Set:	0.046
The Average Mean Radius of the Five Target Set:	0.716
The Distance from POA to Centroid Target #1:	0.118
The Distance from Centroid Target #2 to Centroid Target #1:	0.073
The Distance from Centroid Target #3 to Centroid Target #1:	0.200
The Distance from Centroid Target #4 to Centroid Target #1:	0.195
The Distance from Centroid Target #5 to Centroid Target #1:	0.077

SERIAL NUMBER: G6590132. __1

TARGET NUMBER: 1

FILE DATE: 10/07/2006

FILE TIME: 07:41

POINT#	X	Y
1:	0.528	-1.017
2:	0.495	-0.477
3:	0.678	-0.241
4:	-0.139	-0.637
5:	-0.109	-0.270
6:	-0.485	-0.220
7:	0.026	0.098
8:	-0.986	-0.014
9:	-0.458	0.840
10:	-0.092	0.889

X CENTROID: -0.054

Y CENTROID: -0.105

POA TO CENTROID: 0.118

HORZ SPREAD: 1.664

VERT SPREAD: 1.906

GROUP SPREAD: 2.103

MIN RADIUS: 0.174

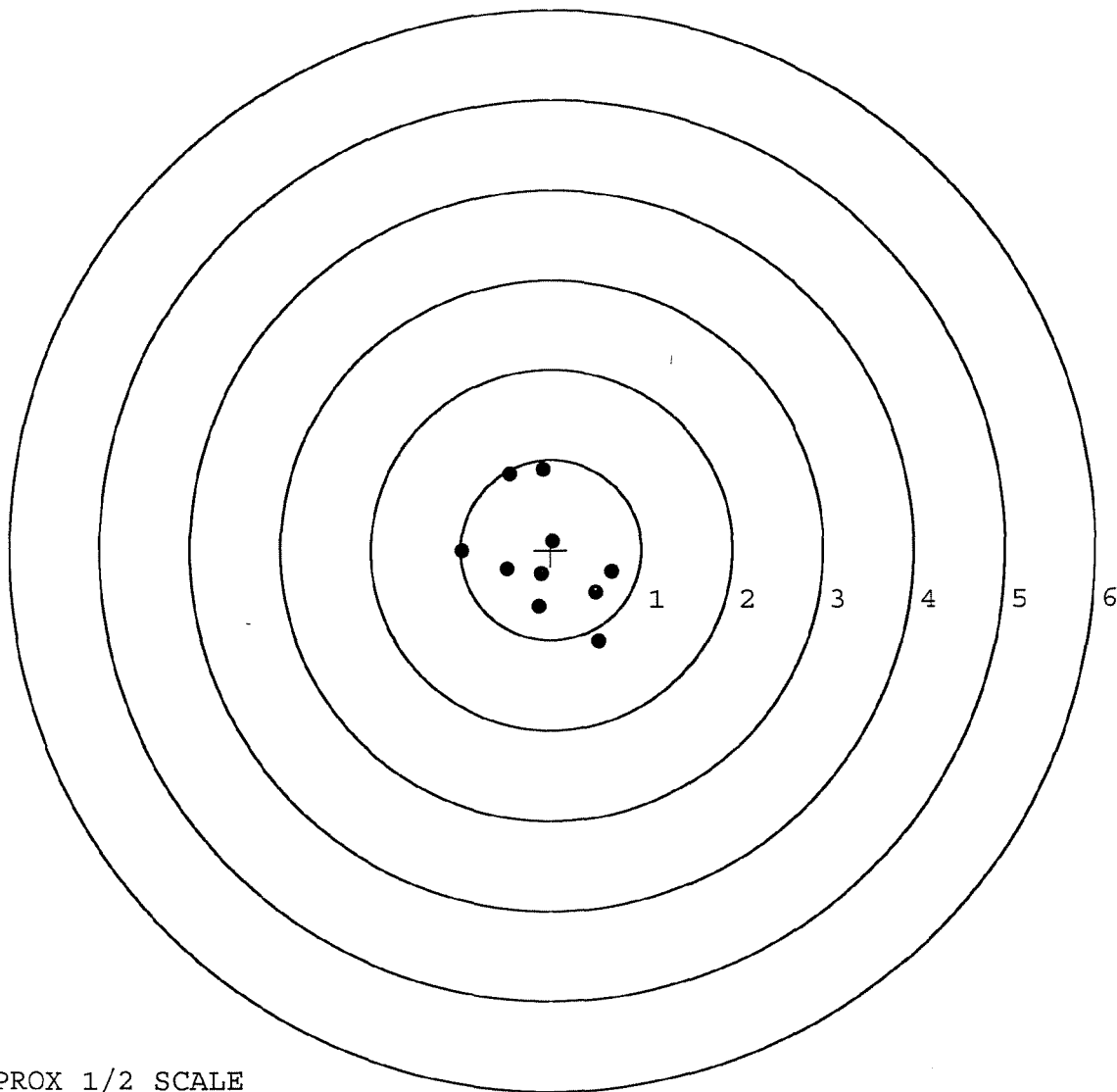
MAX RADIUS: 1.082

MEAN RADIUS: 0.683

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590132. __1

TARGET NUMBER: 2

FILE DATE: 10/07/2006

FILE TIME: 07:41

POINT#	X	Y
1:	1.185	-0.016
2:	0.894	-0.380
3:	0.295	0.100
4:	0.241	-0.377
5:	-0.733	0.252
6:	-0.558	0.264
7:	-0.494	0.659
8:	-1.041	-0.067
9:	-0.344	-0.273
10:	-0.275	-0.541

X CENTROID: -0.083

Y CENTROID: -0.038

POA TO CENTROID: 0.091

HORZ SPREAD: 2.226

VERT SPREAD: 1.200

GROUP SPREAD: 2.227

MIN RADIUS: 0.351

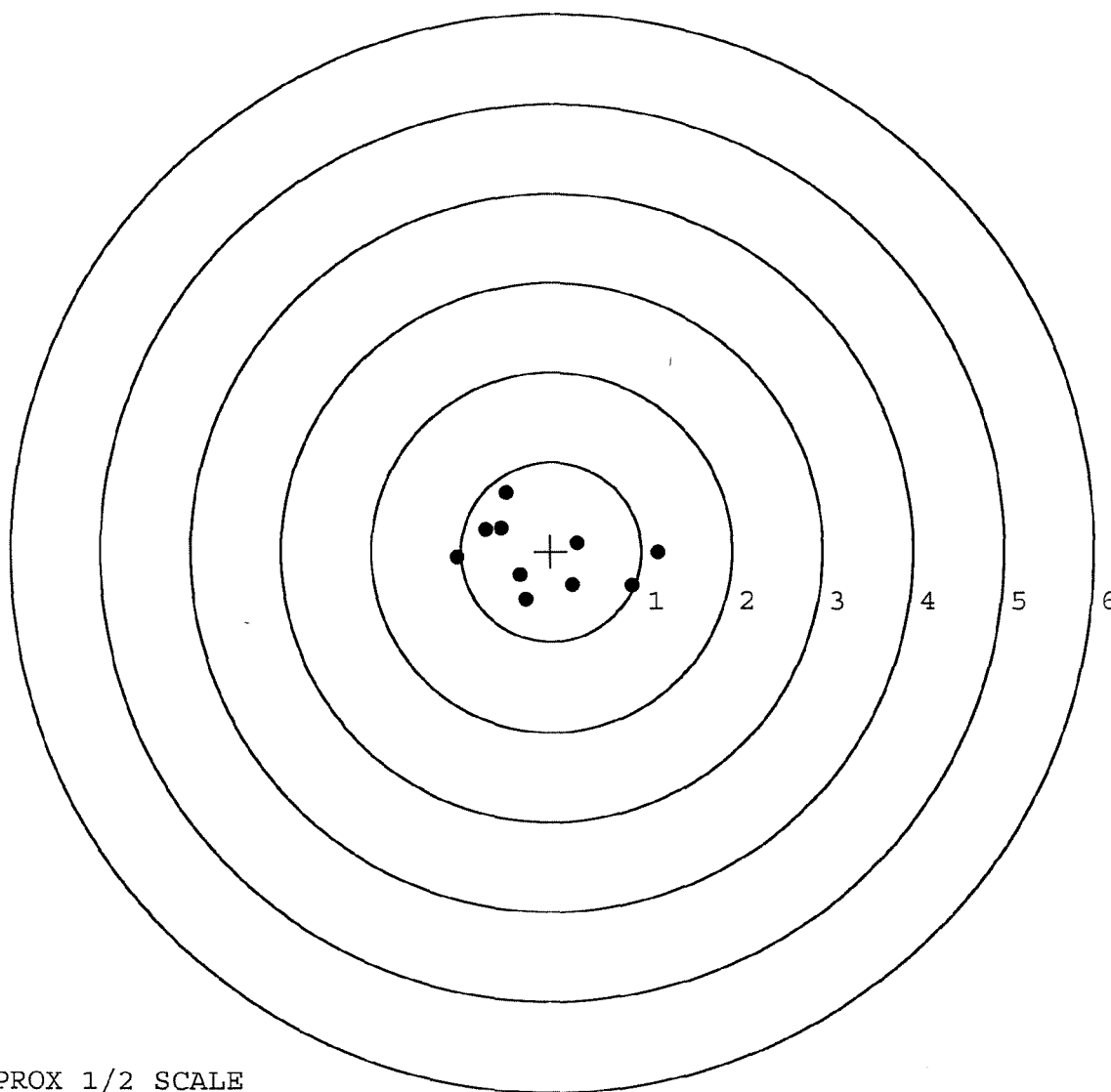
MAX RADIUS: 1.268

MEAN RADIUS: 0.711

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590132. __1

TARGET NUMBER: 3

FILE DATE: 10/07/2006

FILE TIME: 07:41

POINT#	X	Y
1:	0.330	-0.887
2:	-0.054	-1.091
3:	-0.241	-0.362
4:	0.065	-0.148
5:	0.004	0.212
6:	-0.537	0.392
7:	-1.302	0.298
8:	0.507	1.021
9:	0.209	1.240
10:	-0.201	0.154

X CENTROID: -0.122

Y CENTROID: 0.083

POA TO CENTROID: 0.148

HORZ SPREAD: 1.809

VERT SPREAD: 2.331

GROUP SPREAD: 2.346

MIN RADIUS: 0.106

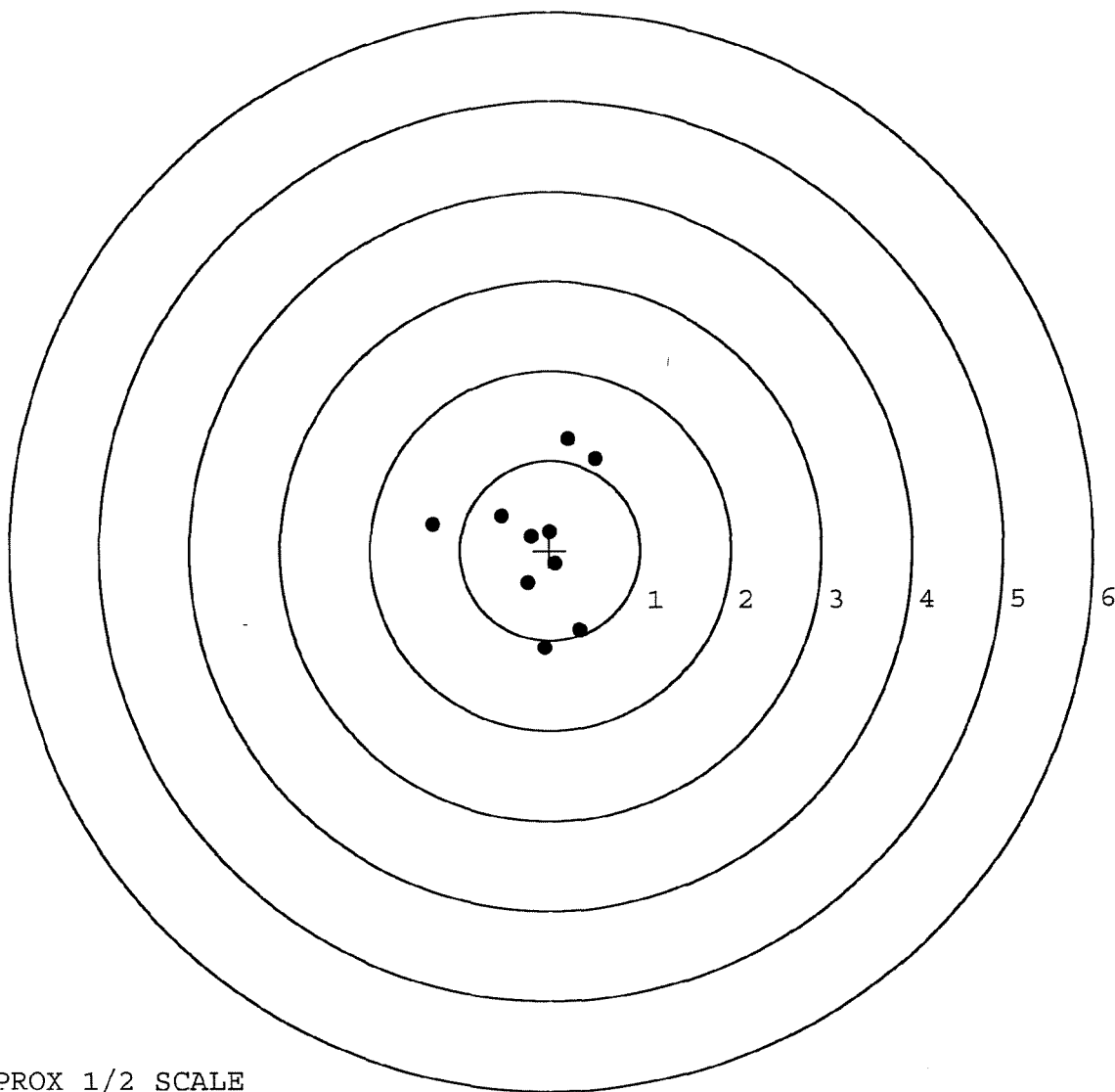
MAX RADIUS: 1.204

MEAN RADIUS: 0.734

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

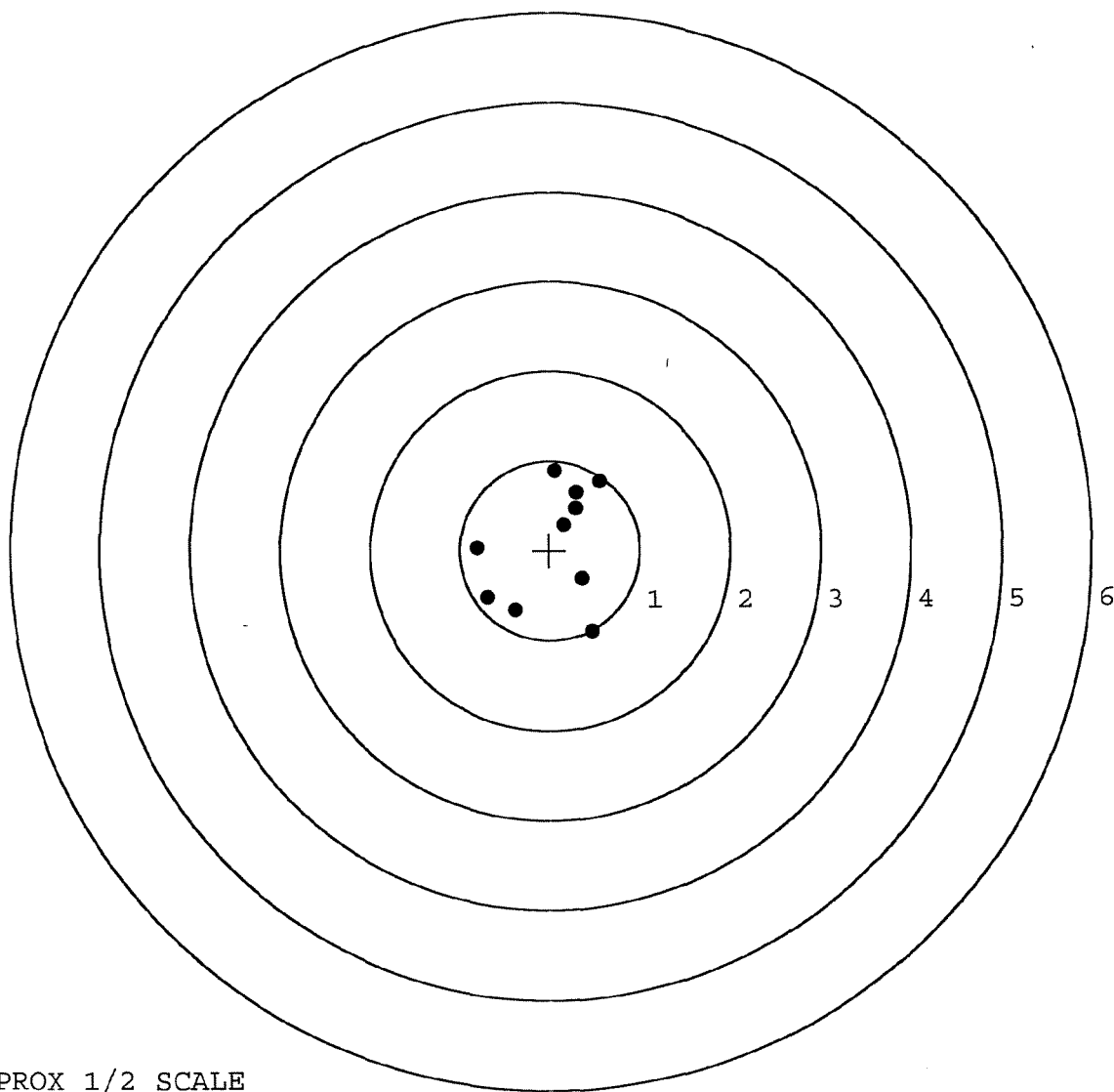


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590132. __1
TARGET NUMBER: 4
FILE DATE: 10/07/2006
FILE TIME: 07:41

X CENTROID: 0.033
Y CENTROID: 0.070
POA TO CENTROID: 0.077
HORZ SPREAD: 1.356
VERT SPREAD: 1.791
GROUP SPREAD: 1.837
MIN RADIUS: 0.251
MAX RADIUS: 1.066
MEAN RADIUS: 0.726
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.471	-0.902
2:	0.362	-0.316
3:	-0.384	-0.673
4:	-0.689	-0.523
5:	-0.801	0.039
6:	0.555	0.774
7:	0.064	0.889
8:	0.299	0.653
9:	0.290	0.470
10:	0.159	0.286

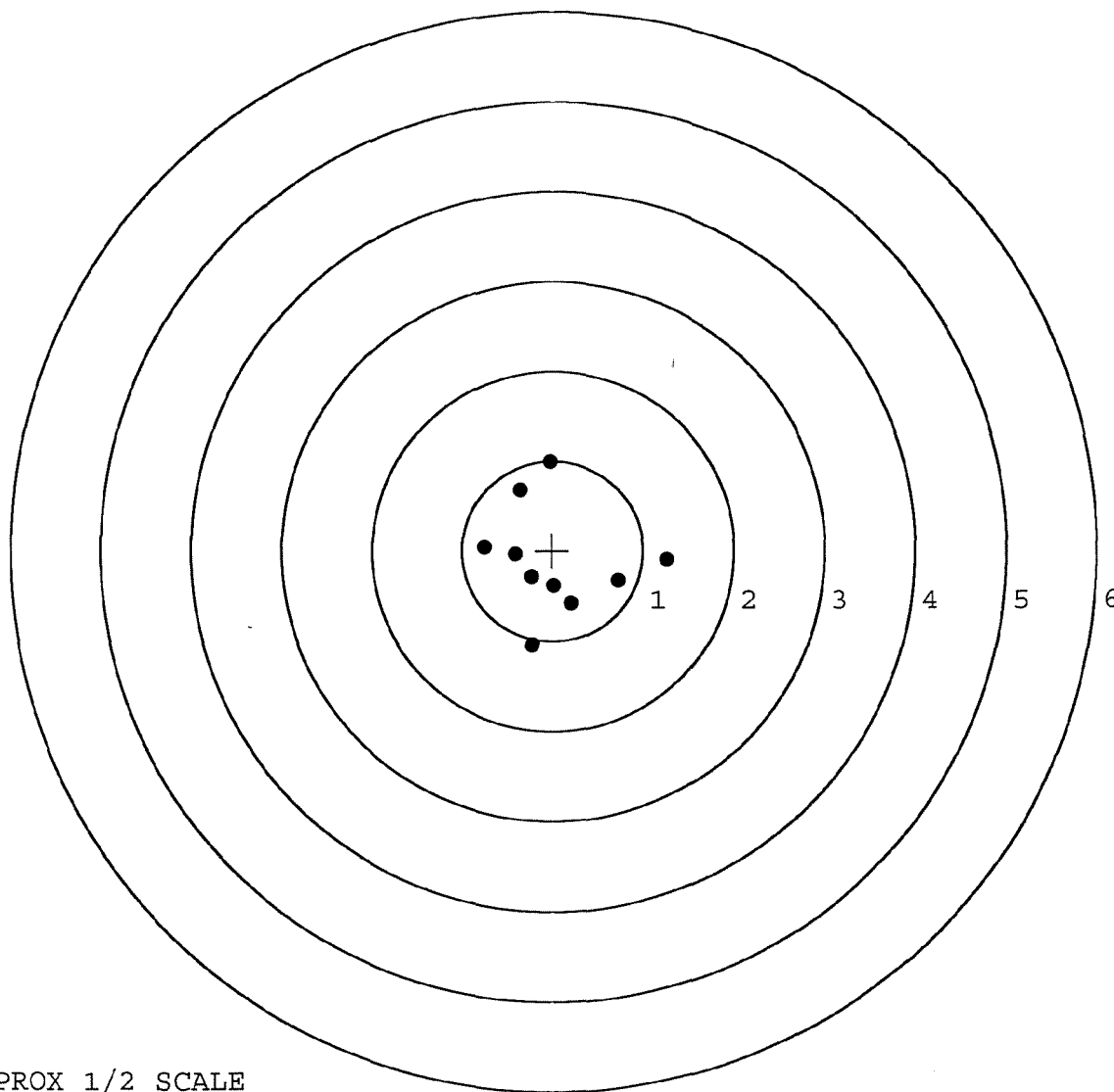


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590132. __1
TARGET NUMBER: 5
FILE DATE: 10/07/2006
FILE TIME: 07:41

X CENTROID: 0.022
Y CENTROID: -0.111
POA TO CENTROID: 0.113
HORZ SPREAD: 2.017
VERT SPREAD: 2.034
GROUP SPREAD: 2.023
MIN RADIUS: 0.286
MAX RADIUS: 1.243
MEAN RADIUS: 0.726
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.265	-0.112
2:	0.727	-0.337
3:	-0.223	-1.047
4:	-0.026	0.987
5:	-0.357	0.674
6:	-0.752	0.046
7:	-0.407	-0.042
8:	-0.231	-0.297
9:	0.017	-0.397
10:	0.212	-0.587



TARGET APPROX 1/2 SCALE