

G6591519

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

G6591519



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 6591519

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RTZ
420	ASSEMBLE ACTION		10-6-06	RLG
430	ASSEMBLE TO STOCK		10-7-06	WR
440	PROOF	MAGNA-FLUX INSPECTED	10-7-07	TRLW
460	CHECK HEADSPACE	OCT 10 2006	10-7-07	TRLW
470	DIS-ASSEMBLE ACTION	OPERATOR <u>CPD</u>	10-9-06	RTZ
480	MAGNAFLUX BBL ACTION		10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	CW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRLW
520	GOFF BLAST BBL / REC		10-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/18/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-24-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-24-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-24-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-7-06	RLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

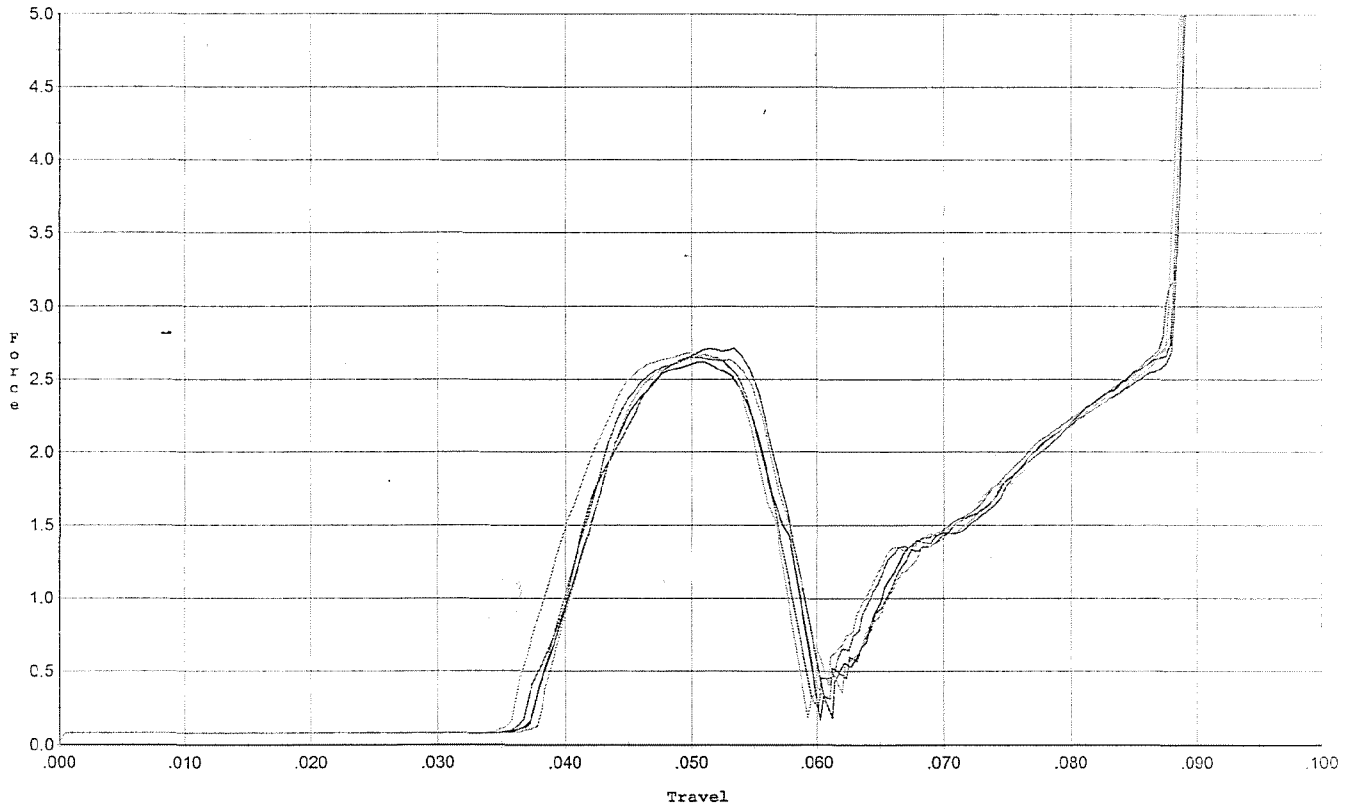
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>49</u> <u>49</u>	11-14-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>69</u> <u>69</u> <u>69</u>	11-14-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	11-14-06	SD
	J) ASSEMBLE STOCK		11-7-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-17-06	S.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-17-06	RTZ
	M) IRON SIGHT ALIGNMENT		11-17-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-17-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11-7-06	S.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-17-06	MM
670	FINAL INSPECTION A) HEADSPACE		11-17-06	S.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.55</u> <u>2.64</u> <u>2.48</u> <u>2.57</u>	11/14/06	MM
	C) FUNCTION		11-17-06	S.P.D.
690	PACK		12-8-06	RA

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/06/06

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini.



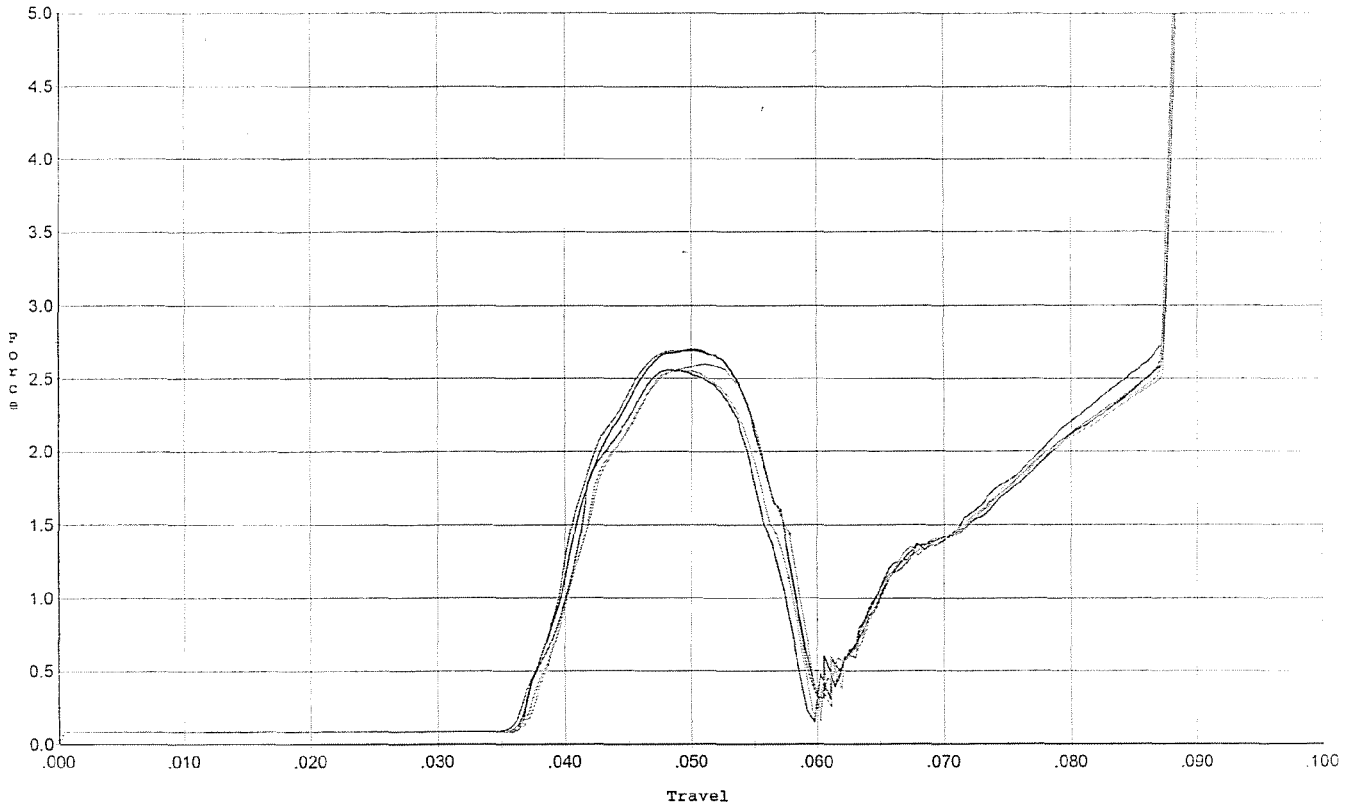
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.715	0.059	0.037	0.037	0.046		Set Trigger
2	2.619	0.058	0.038	0.038	0.043		Set Trigger
3	2.653	0.058	0.038	0.039	0.044		Set Trigger
4	2.684	0.057	0.036	0.038	0.046		Set Trigger
5	2.671	0.058	0.038	0.038	0.044		Set Trigger

Aug 2.66

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/06/06

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles



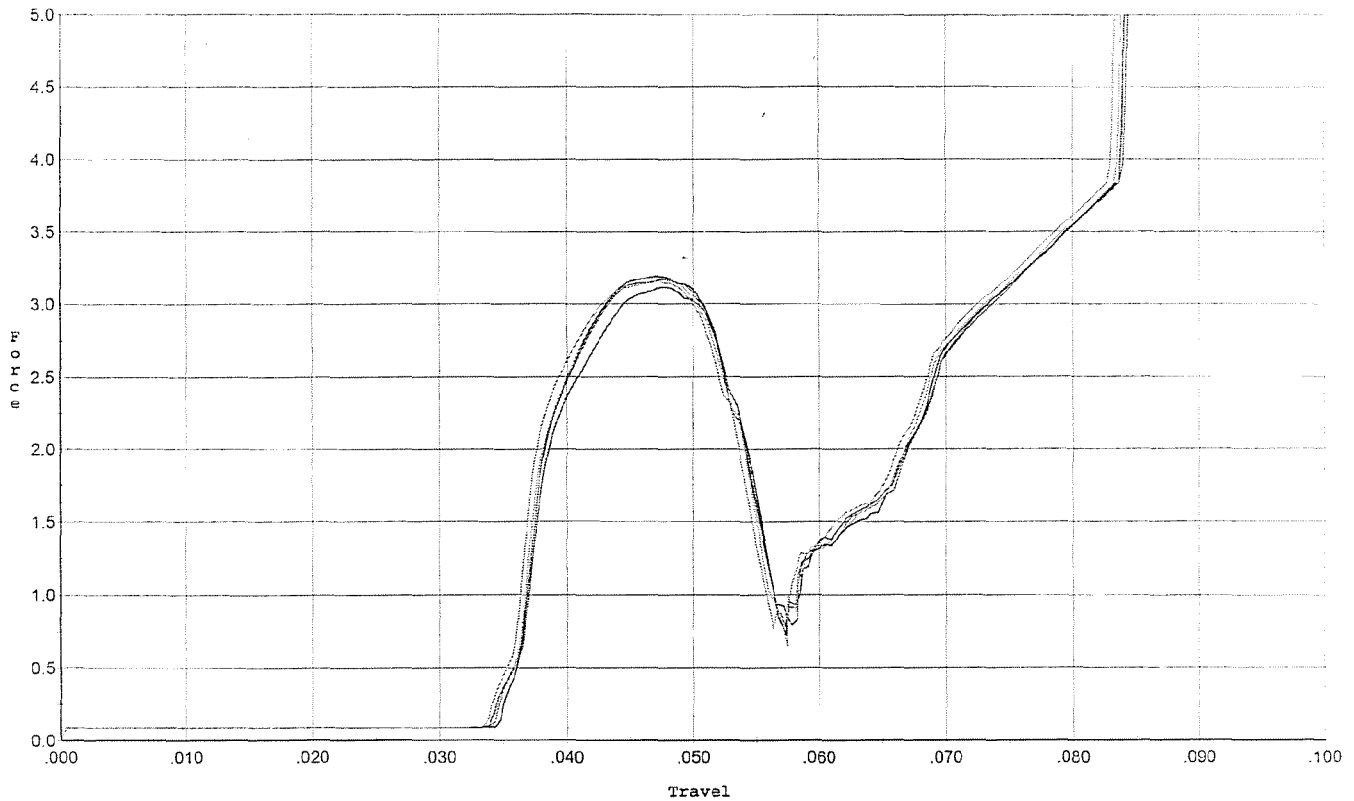
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.558	0.057	0.037	0.038	0.041		Set Trigger
2	2.700	0.057	0.037	0.038	0.045		Set Trigger
3	2.691	0.057	0.037	0.038	0.045		Set Trigger
4	2.551	0.058	0.038	0.038	0.041		Set Trigger
5	2.599	0.058	0.037	0.038	0.043		Set Trigger

Aug 262

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/06/06

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini.



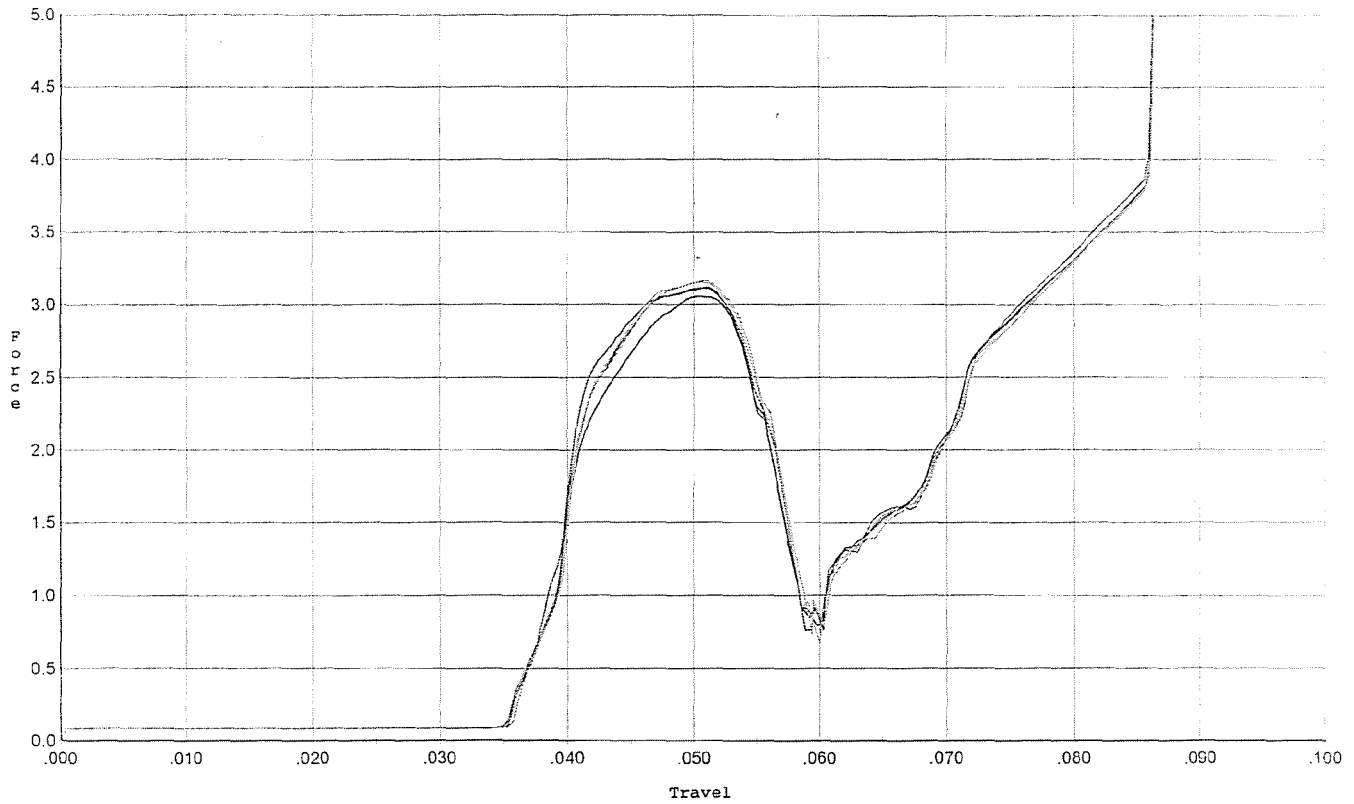
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.117	0.054	0.034	0.036	0.050		Set Trigger
2	3.191	0.055	0.035	0.036	0.053		Set Trigger
3	3.168	0.055	0.035	0.035	0.053		Set Trigger
4	3.185	0.054	0.035	0.036	0.051		Set Trigger
5	3.158	0.053	0.034	0.036	0.051		Set Trigger

Aug 3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/06/06

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles



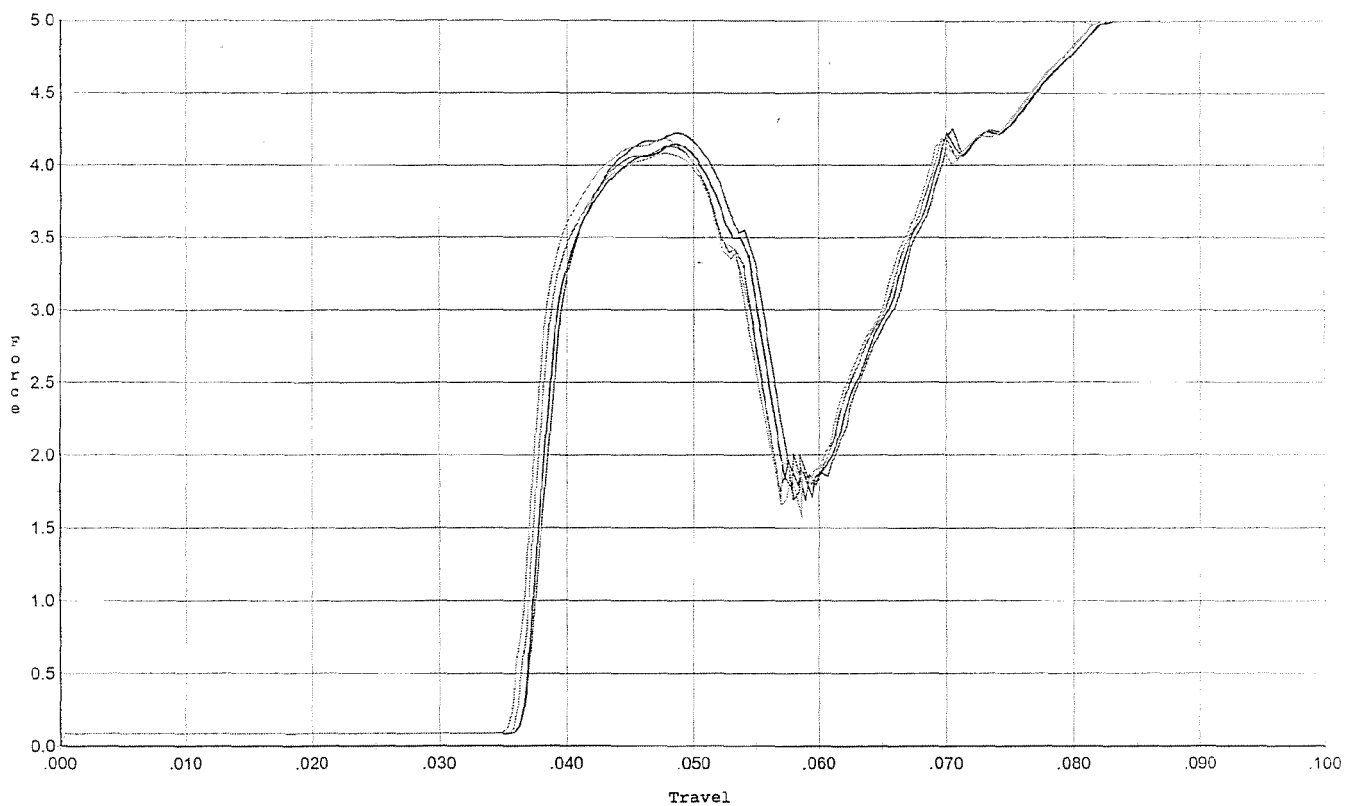
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.119	0.056	0.036	0.036	0.051		Set Trigger
2	3.059	0.056	0.036	0.036	0.049		Set Trigger
3	3.113	0.056	0.036	0.036	0.052		Set Trigger
4	3.153	0.056	0.036	0.036	0.052		Set Trigger
5	3.165	0.056	0.036	0.036	0.052		Set Trigger

Aug 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/06/06

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini.



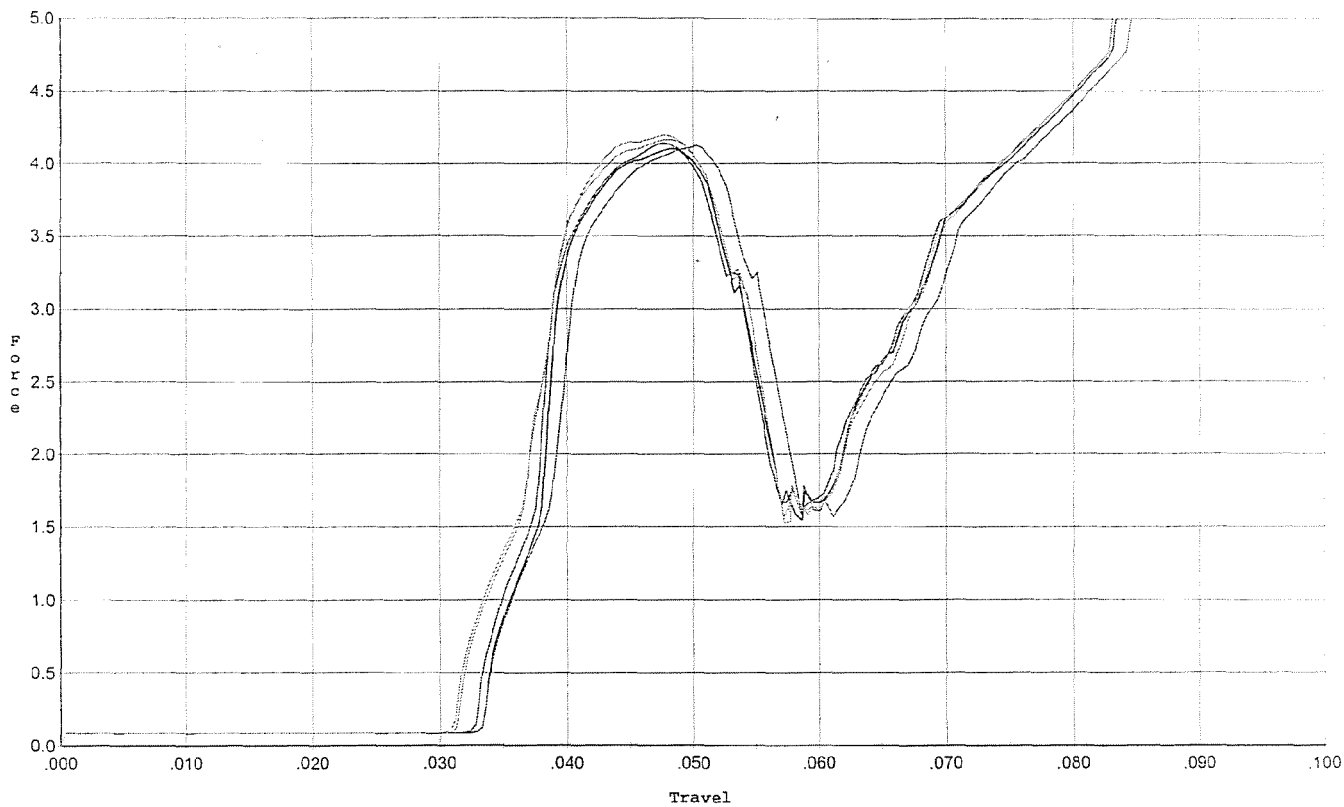
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.226	0.055	0.037	0.033	0.071		Set Trigger
2	4.149	0.054	0.037	0.033	0.068		Set Trigger
3	4.132	0.054	0.036	0.033	0.068		Set Trigger
4	4.084	0.054	0.036	0.033	0.068		Set Trigger
5	4.180	0.053	0.036	0.033	0.068		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/06/06

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles



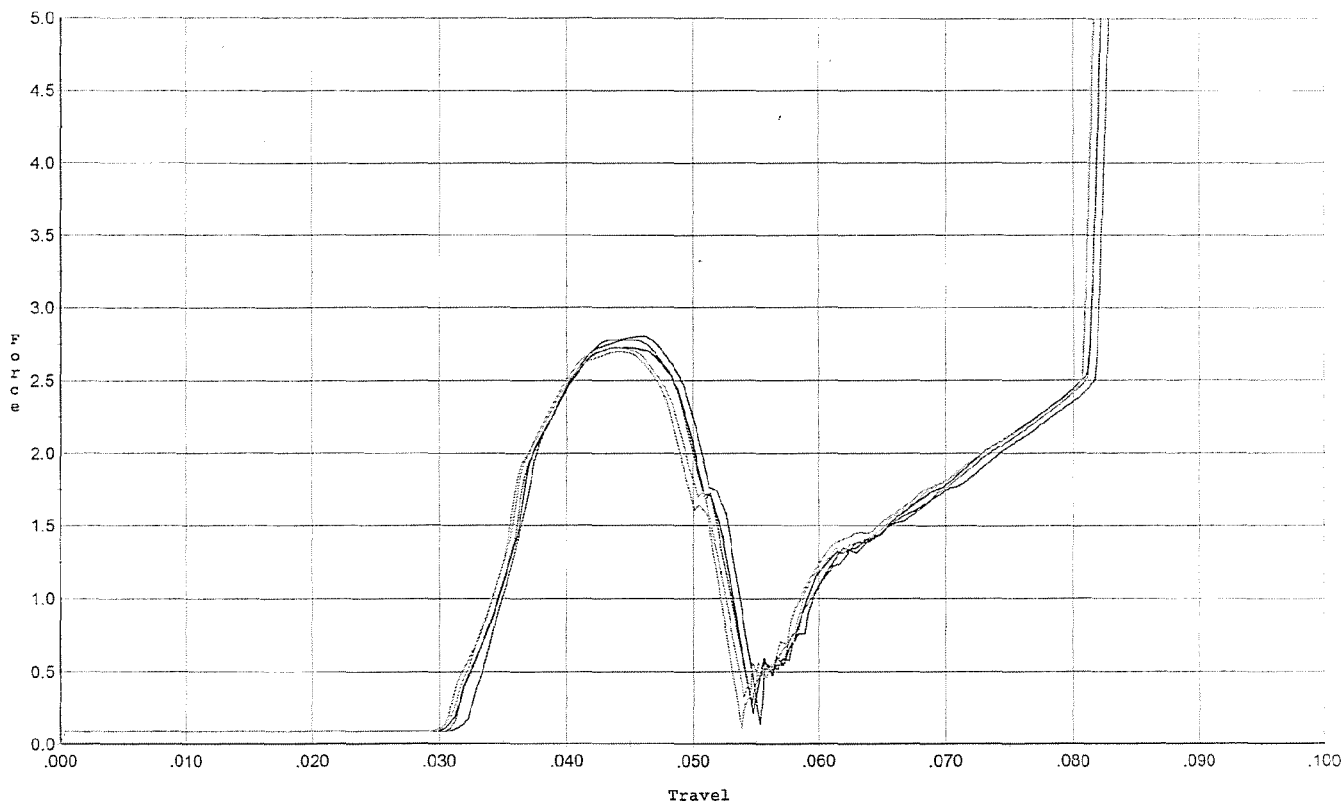
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.142	0.054	0.033	0.034	0.069		Set Trigger
2	4.104	0.055	0.034	0.034	0.070		Set Trigger
3	4.124	0.055	0.034	0.034	0.071		Set Trigger
4	4.195	0.054	0.031	0.033	0.075		Set Trigger
5	4.164	0.054	0.032	0.033	0.074		Set Trigger

Avg 4.14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/06/06

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. for final test



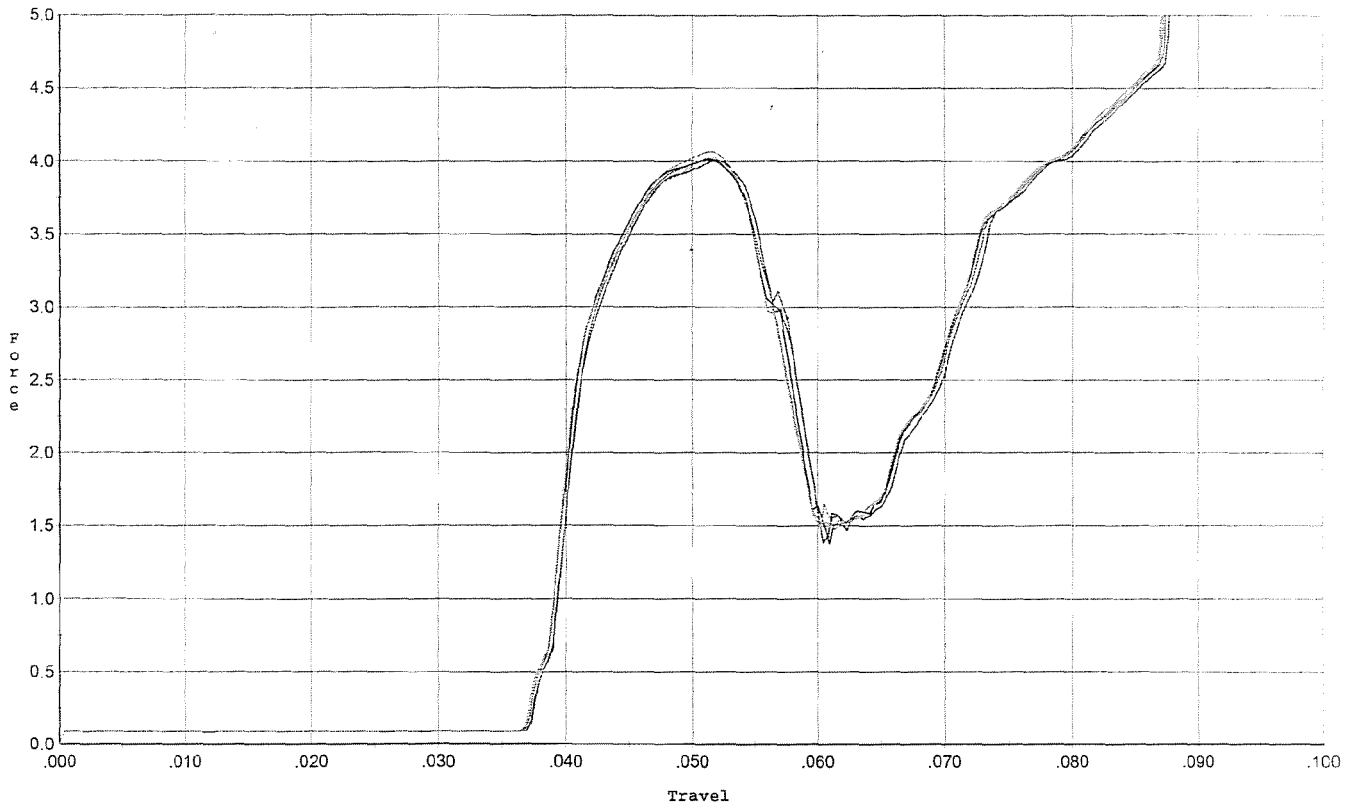
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.803	0.053	0.033	0.036	0.045		Set Trigger
2	2.725	0.052	0.032	0.036	0.045		Set Trigger
3	2.777	0.053	0.031	0.036	0.045		Set Trigger
4	2.723	0.052	0.031	0.035	0.044		Set Trigger
5	2.694	0.051	0.031	0.036	0.043		Set Trigger

Aug 2.74

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/06/06

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.006	0.058	0.037	0.035	0.068		Set Trigger
2	4.015	0.057	0.037	0.035	0.068		Set Trigger
3	4.009	0.058	0.038	0.035	0.068		Set Trigger
4	4.029	0.057	0.037	0.036	0.066		Set Trigger
5	4.064	0.058	0.037	0.035	0.069		Set Trigger

Aug 4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591519.__0
FILE DATE AND TIME: 11/08/2006 13:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.031
The Average Y Centroid of the Five Target Set:	0.002
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.686
The Distance from POA to Centroid Target #1:	0.023
The Distance from Centroid Target #2 to Centroid Target #1:	0.228
The Distance from Centroid Target #3 to Centroid Target #1:	0.084
The Distance from Centroid Target #4 to Centroid Target #1:	0.118
The Distance from Centroid Target #5 to Centroid Target #1:	0.085

SERIAL NUMBER: G6591519. __ 0

TARGET NUMBER: 1

FILE DATE: 11/08/2006

FILE TIME: 13:25

X CENTROID: 0.022

Y CENTROID: -0.005

POA TO CENTROID: 0.023

HORZ SPREAD: 1.323

VERT SPREAD: 1.499

GROUP SPREAD: 1.705

MIN RADIUS: 0.155

MAX RADIUS: 1.026

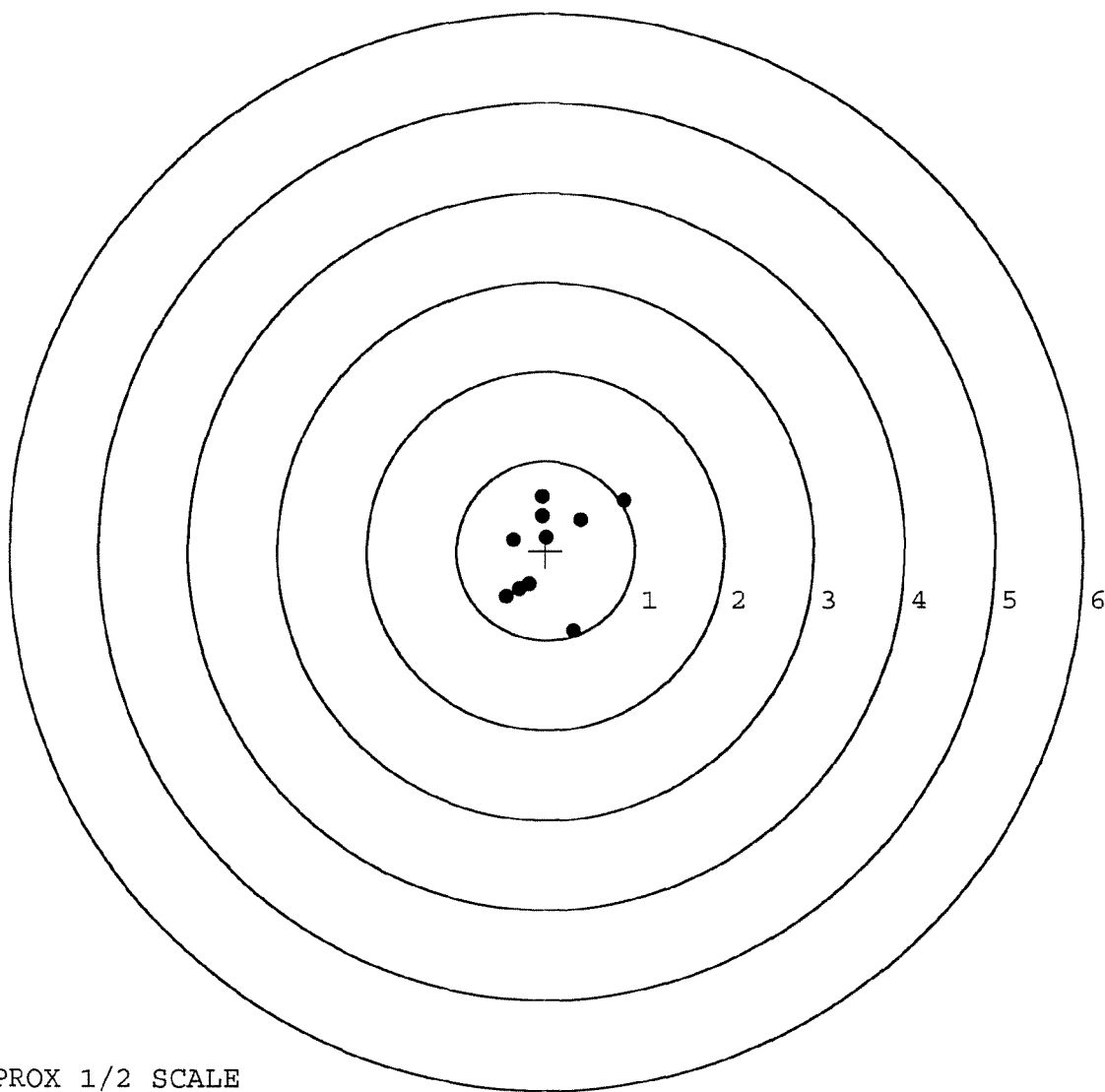
MEAN RADIUS: 0.571

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.879	0.560
2:	0.313	-0.899
3:	-0.444	-0.516
4:	-0.182	-0.378
5:	0.392	0.353
6:	-0.042	0.600
7:	-0.367	0.126
8:	0.013	0.150
9:	-0.043	0.393
10:	-0.298	-0.436



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591519. 0

TARGET NUMBER: 2

FILE DATE: 11/08/2006

FILE TIME: 13:25

X CENTROID: -0.201

Y CENTROID: -0.048

POA TO CENTROID: 0.207

HORZ SPREAD: 1.955

VERT SPREAD: 1.736

GROUP SPREAD: 2.269

MIN RADIUS: 0.180

MAX RADIUS: 1.260

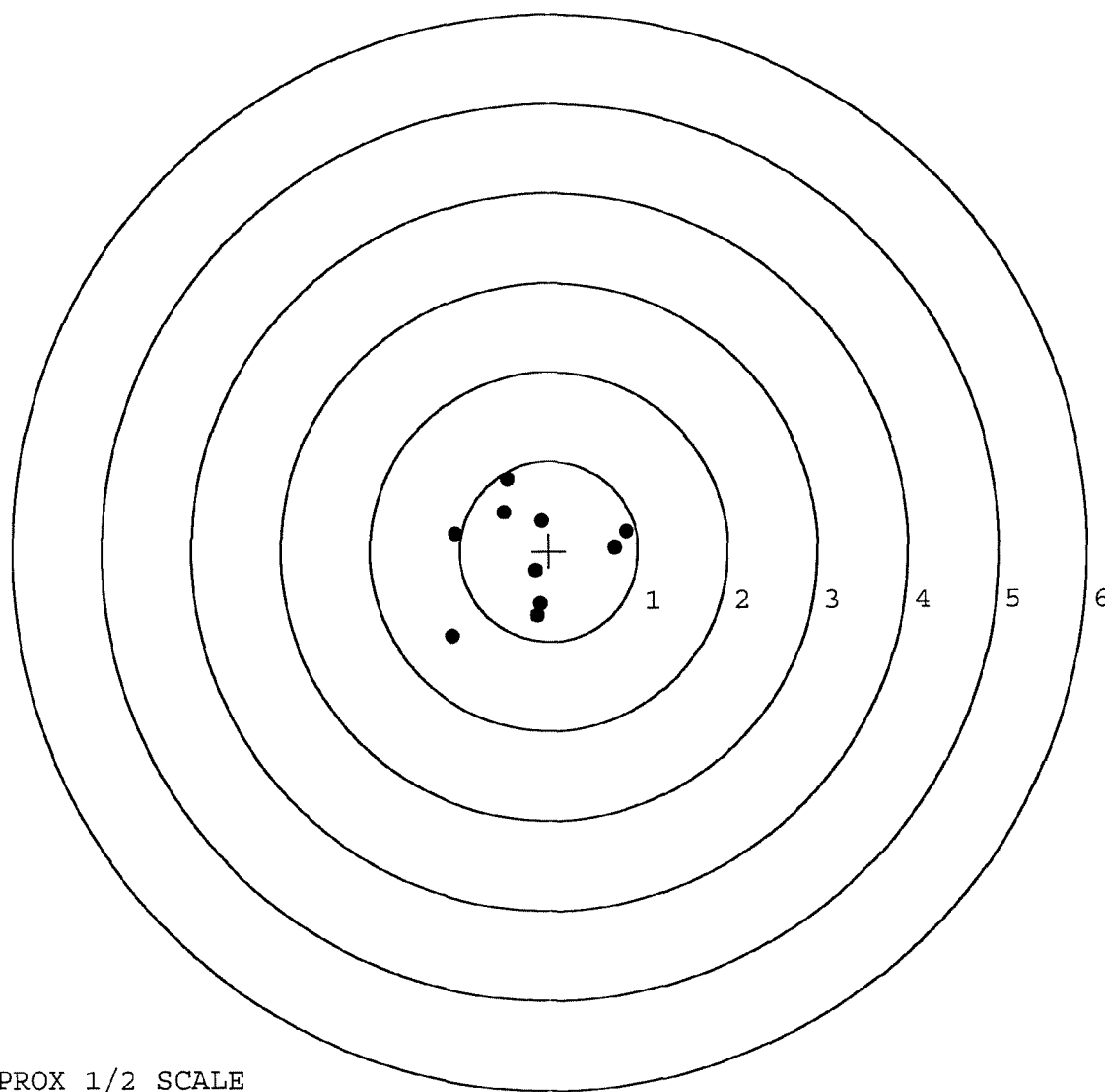
MEAN RADIUS: 0.745

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.864	0.210
2:	0.737	0.039
3:	-0.134	-0.725
4:	-0.105	-0.588
5:	-0.156	-0.222
6:	-0.088	0.330
7:	-0.513	0.431
8:	-0.468	0.795
9:	-1.059	0.190
10:	-1.091	-0.941

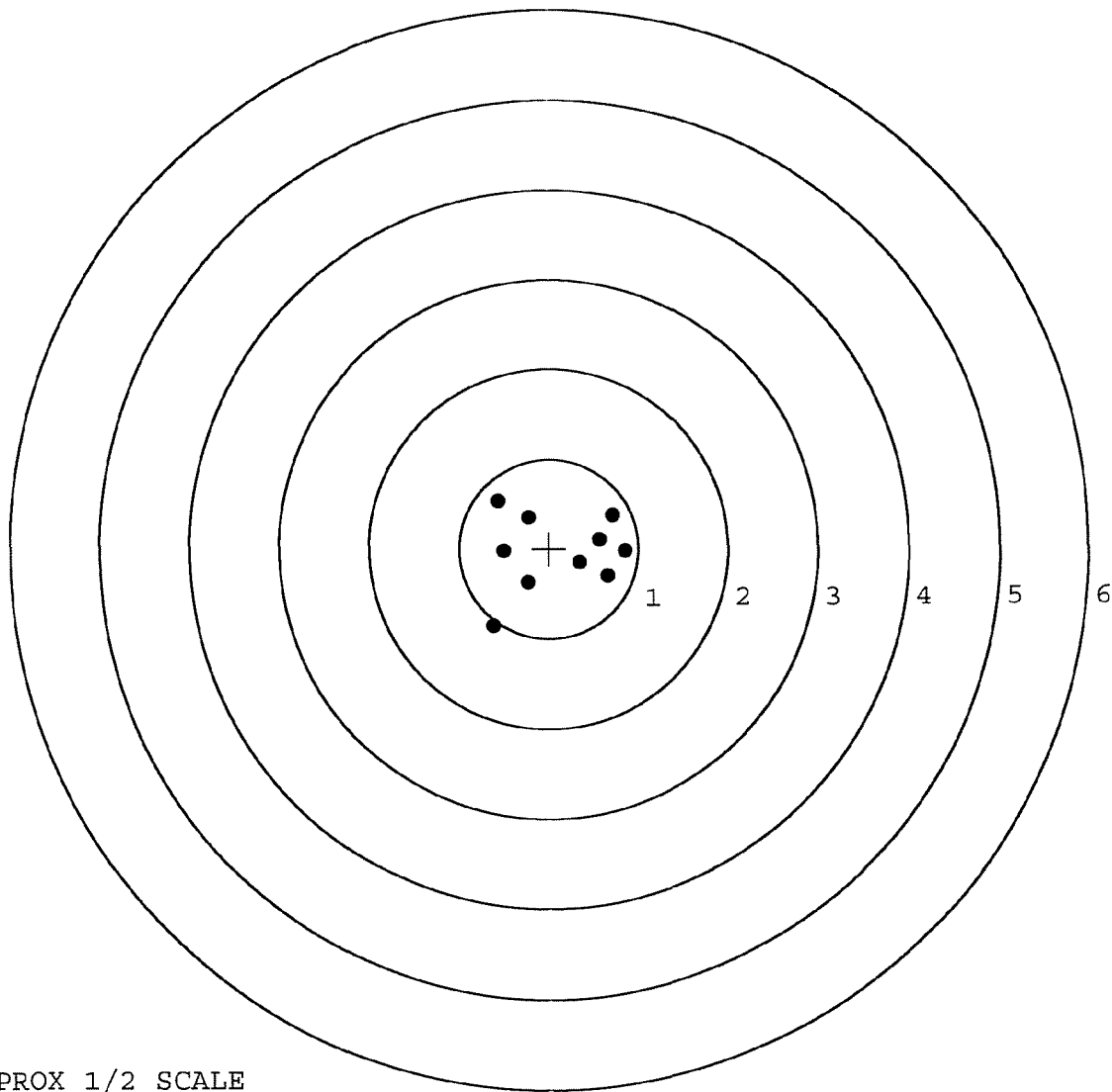


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591519. __0
TARGET NUMBER: 3
FILE DATE: 11/08/2006
FILE TIME: 13:25

X CENTROID: 0.098
Y CENTROID: -0.041
POA TO CENTROID: 0.106
HORZ SPREAD: 1.475
VERT SPREAD: 1.399
GROUP SPREAD: 1.827
MIN RADIUS: 0.269
MAX RADIUS: 1.095
MEAN RADIUS: 0.645
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.623	-0.865
2:	-0.236	-0.386
3:	-0.508	-0.027
4:	-0.225	0.350
5:	-0.563	0.534
6:	0.715	0.379
7:	0.852	-0.027
8:	0.569	0.104
9:	0.659	-0.313
10:	0.340	-0.159



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591519. __0

TARGET NUMBER: 4

FILE DATE: 11/08/2006

FILE TIME: 13:25

POINT#	X	Y
1:	1.353	0.397
2:	0.894	0.063
3:	0.516	0.239
4:	0.086	0.157
5:	-0.122	-0.128
6:	-0.118	-0.725
7:	-0.382	0.027
8:	-0.578	-0.059
9:	-0.538	0.581
10:	-1.239	0.528

X CENTROID: -0.013

Y CENTROID: 0.108

POA TO CENTROID: 0.109

HORZ SPREAD: 2.592

VERT SPREAD: 1.306

GROUP SPREAD: 2.595

MIN RADIUS: 0.110

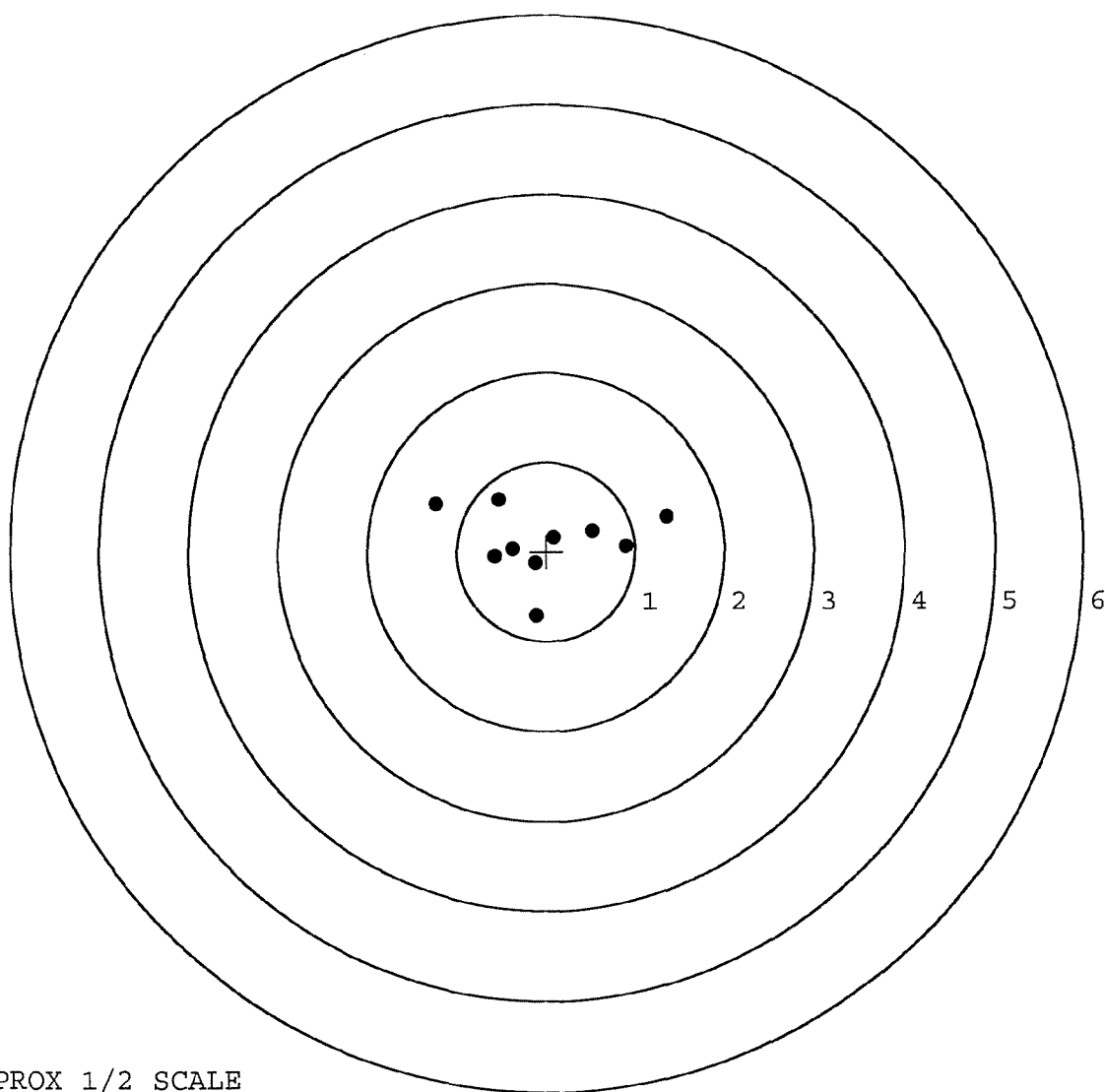
MAX RADIUS: 1.396

MEAN RADIUS: 0.703

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591519. __0

TARGET NUMBER: 5

FILE DATE: 11/08/2006

FILE TIME: 13:25

POINT#	X	Y
1:	0.653	-0.534
2:	1.023	0.193
3:	0.814	0.649
4:	0.157	0.306
5:	0.015	-0.602
6:	0.019	-0.390
7:	-0.360	-0.122
8:	-0.960	-0.197
9:	-0.715	0.256
10:	-1.272	0.376

X CENTROID: -0.063

Y CENTROID: -0.007

POA TO CENTROID: 0.063

HORZ SPREAD: 2.295

VERT SPREAD: 1.251

GROUP SPREAD: 2.302

MIN RADIUS: 0.319

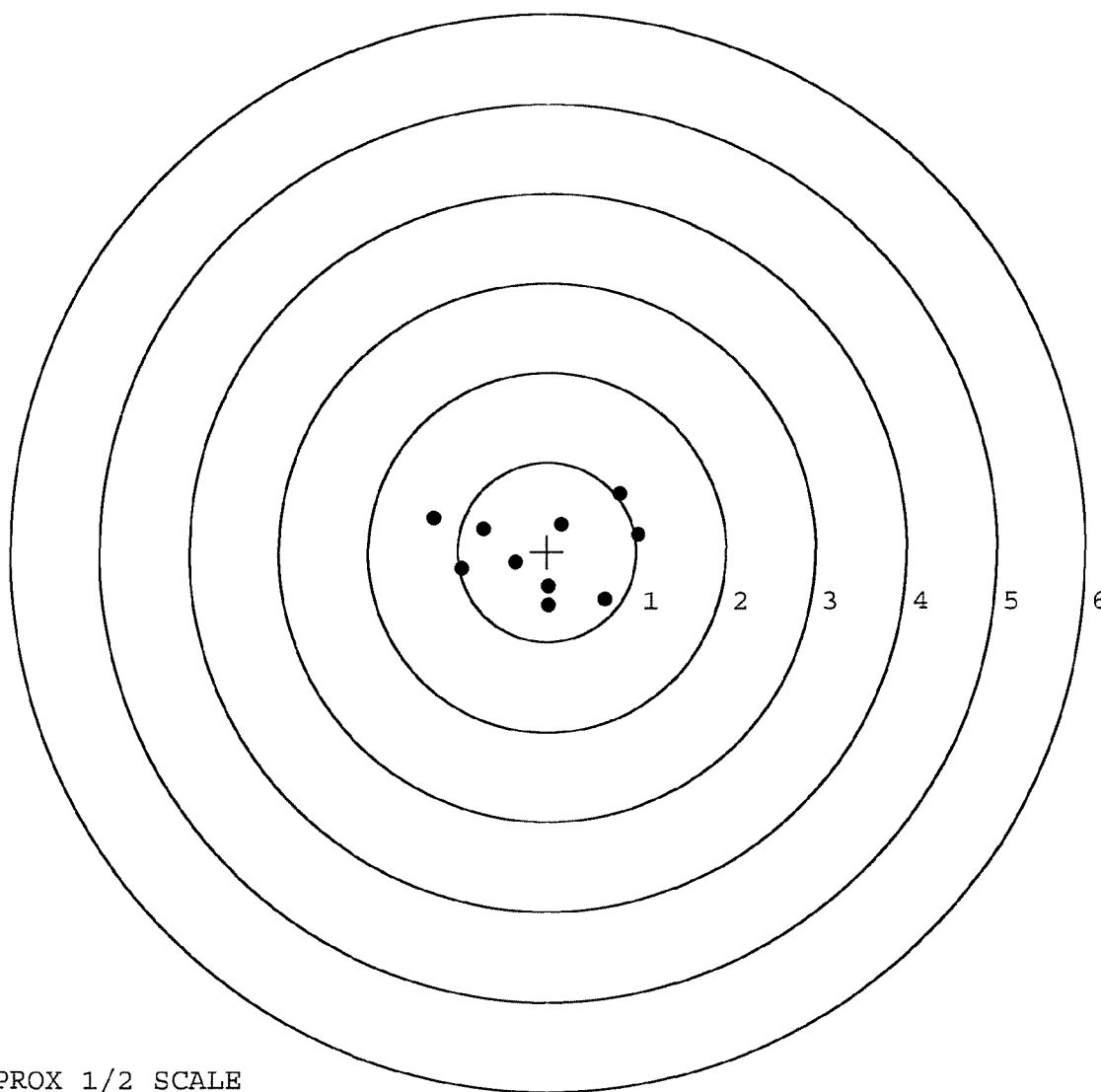
MAX RADIUS: 1.268

MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE