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

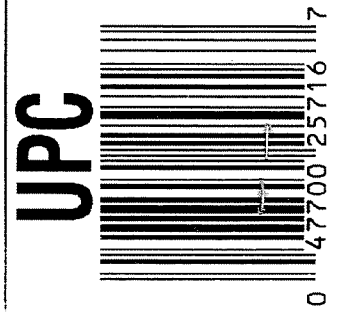
– INSTUCTION BOOK 3518

DD FORM

ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6591563



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.

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591563

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	BLC
420	ASSEMBLE ACTION		10-7-06	BLC
430	ASSEMBLE TO STOCK		10-7-06	BLC
440	PROOF	MAGNA-FLUX INSPECTED OCT 12 2006	10-7-06	TRW
460	CHECK HEADSPACE		10-7-06	TRW
470	DIS-ASSEMBLE ACTION		10-9-06	RTL
480	MAGNAFLUX BBL ACTION	OPERATOR	10/12/06	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	CW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-13-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION) (BOLT)		10/16	HF
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-20-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-20-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-20-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-30-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

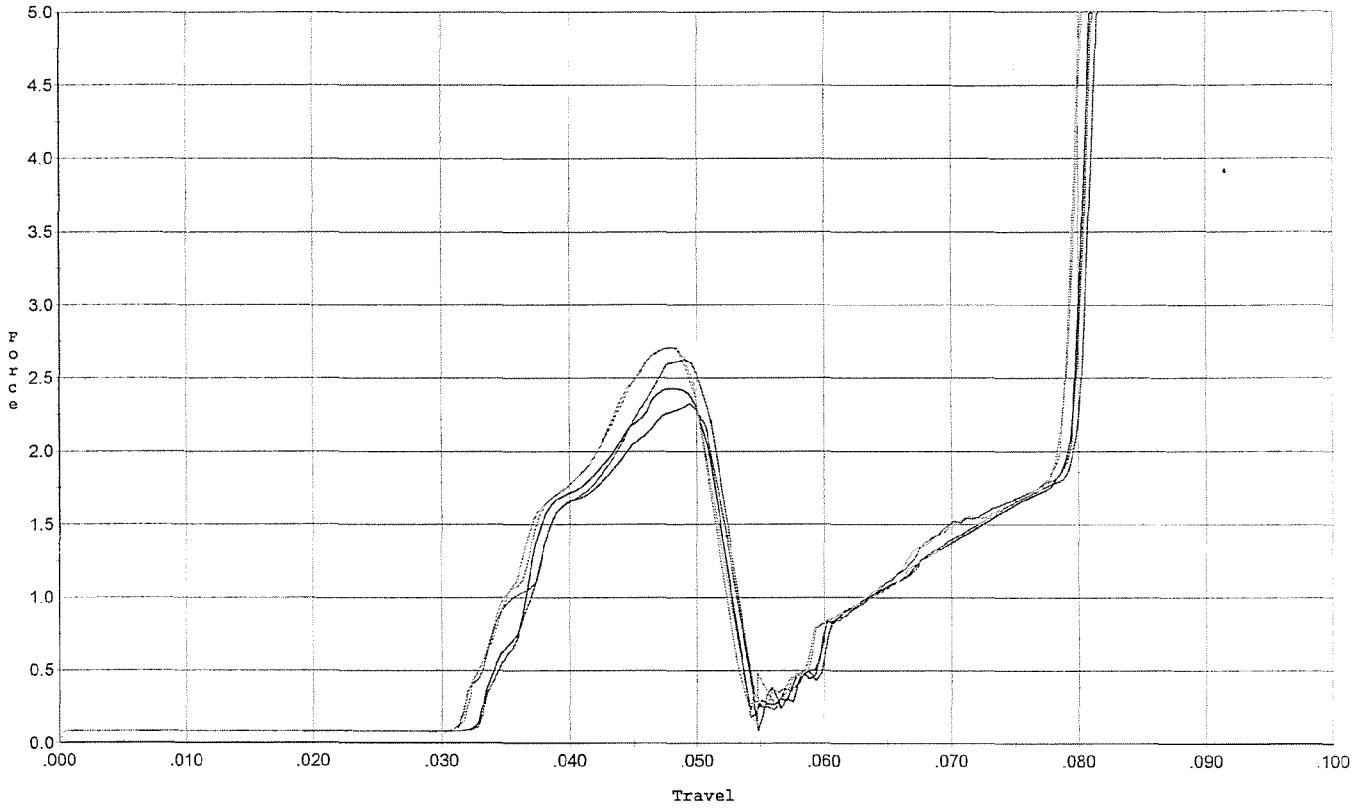
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	5# 5# 5#	11-4-06	SD
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	8# 7# 7#	11-4-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.024 .024 .024	11-4-06	SD
	J) ASSEMBLE STOCK		10-30-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-14-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-30-06	BLG
	M) IRON SIGHT ALIGNMENT		10-30-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-30-06	BLG
640 & 650	FUNCTION TEST AND TARGET	(PASS) FAIL / (PASS) FAIL	10-31-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/31/06	WK
670	FINAL INSPECTION A) HEADSPACE		11-14-06	L.P.D.
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.78 2.79 2.82 2.87 2.80	11/11/06	mjm
	C) FUNCTION		11-14-06	L.P.D.
690	PACK		12506	DA

N/A

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini.
Note:	R. Putch 10/23/06		



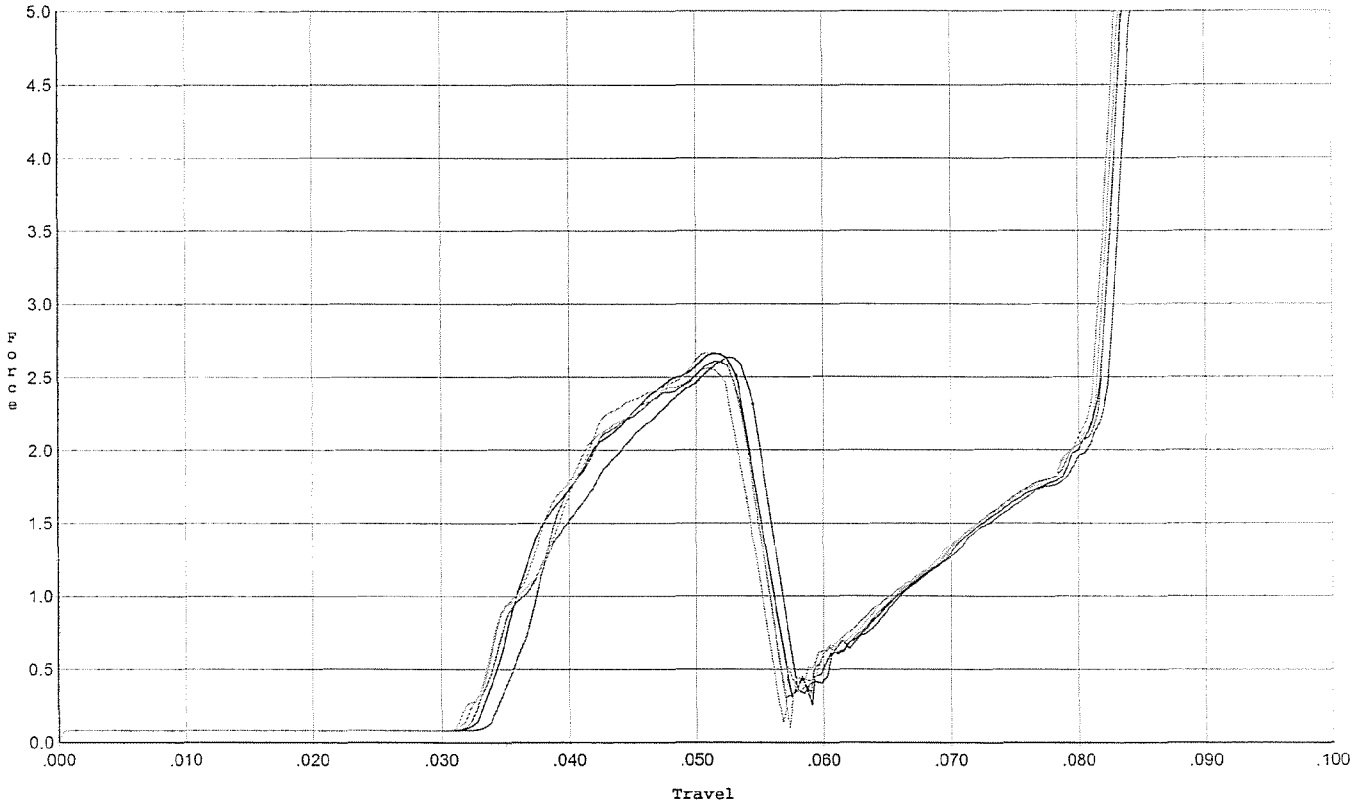
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.326	0.052	0.033	0.036	0.035		Set Trigger
2	2.430	0.051	0.033	0.036	0.035		Set Trigger
3	2.628	0.051	0.032	0.035	0.037		Set Trigger
4	2.705	0.050	0.032	0.035	0.037		Set Trigger
5	2.709	0.050	0.032	0.035	0.037		Set Trigger

Avg 2.56

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 8:40:47 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles
Note:	R. Putch 10/23/06		



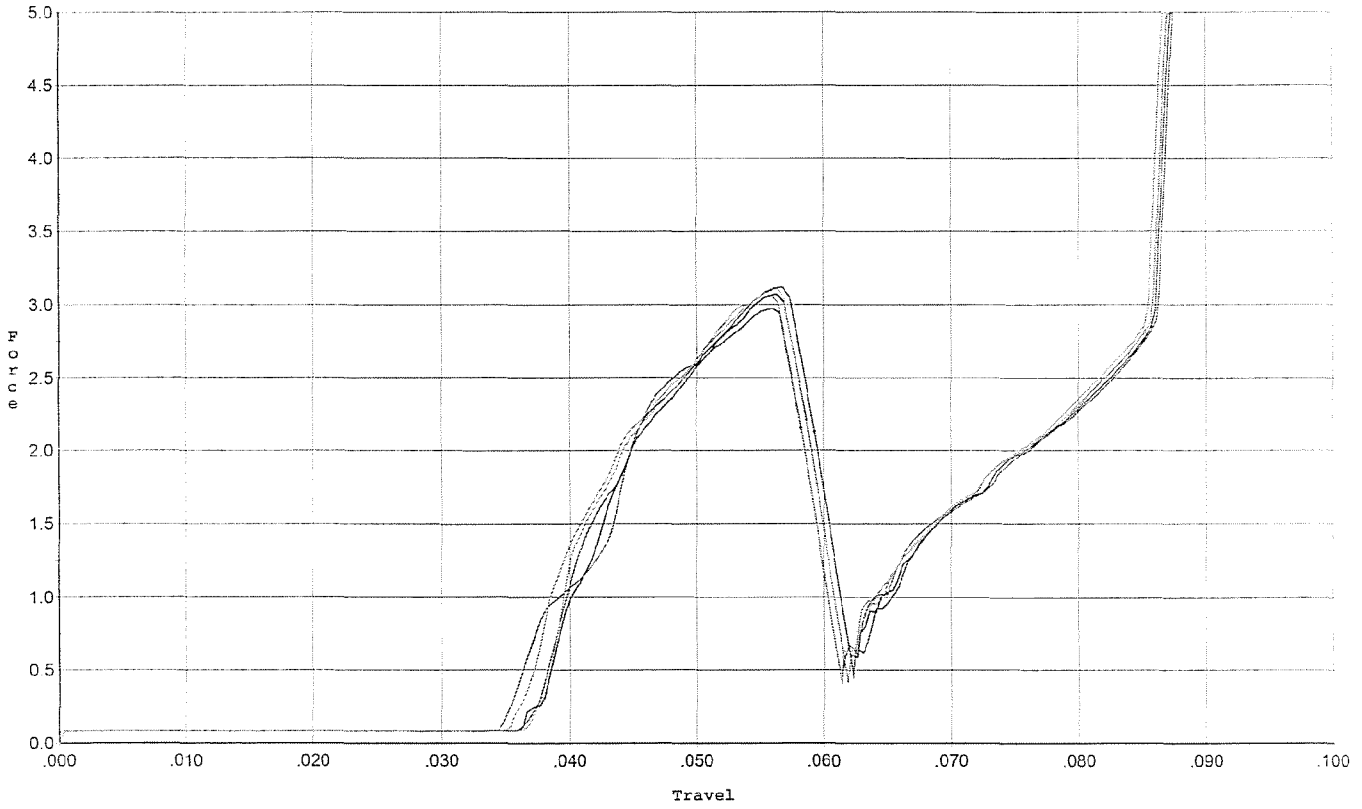
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.635	0.054	0.034	0.035	0.042		Set Trigger
2	2.661	0.053	0.033	0.035	0.043		Set Trigger
3	2.609	0.054	0.033	0.035	0.043		Set Trigger
4	2.667	0.054	0.032	0.035	0.044		Set Trigger
5	2.562	0.054	0.032	0.035	0.043		Set Trigger

Avg 2.62

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 8:50:04 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini.
Note:	R. Putch 10/23/06		



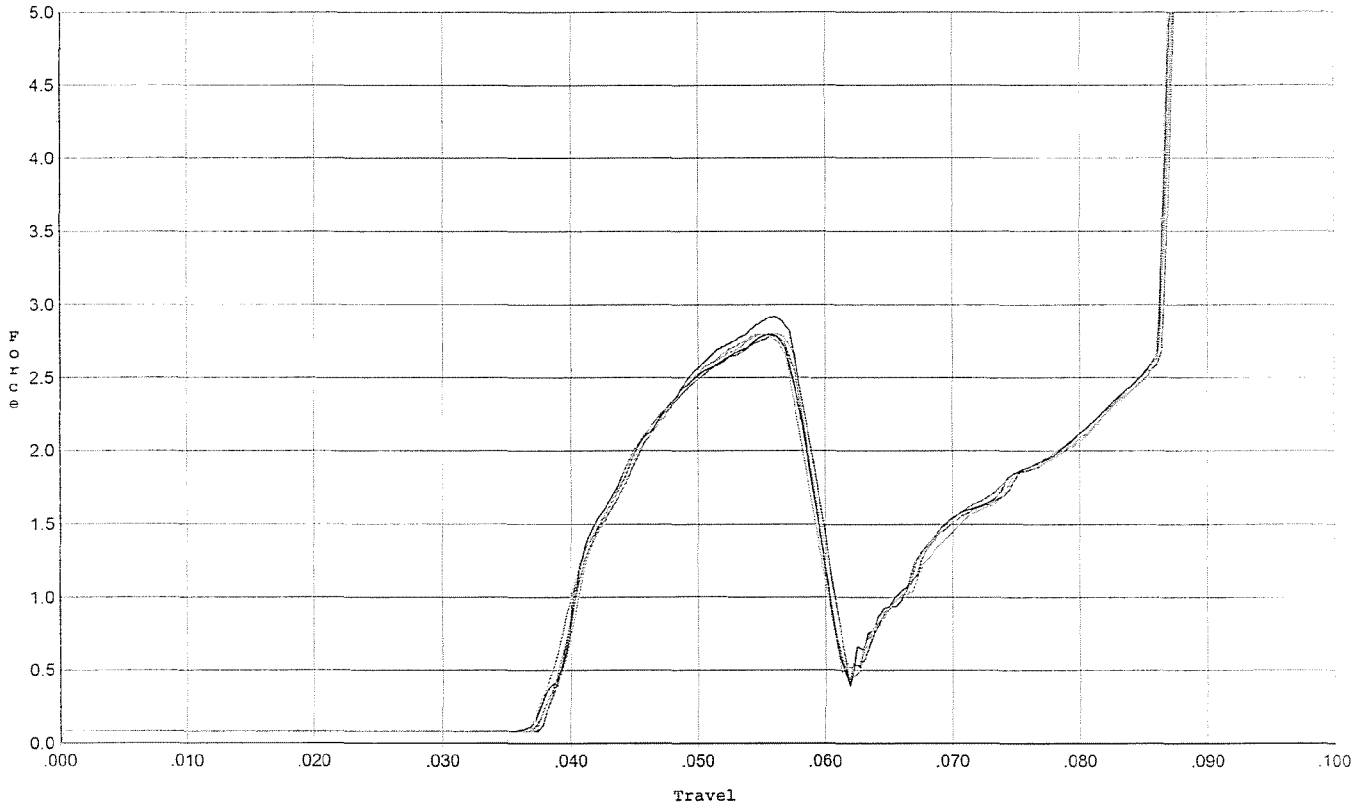
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.059	0.037	0.035	0.052		Set Trigger
2	3.070	0.059	0.037	0.035	0.050		Set Trigger
3	2.975	0.058	0.035	0.035	0.050		Set Trigger
4	3.119	0.059	0.037	0.035	0.051		Set Trigger
5	3.066	0.058	0.036	0.035	0.052		Set Trigger

Avg 3.07

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 8:55:45 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles
Note:	R. Putch 10/23/06		



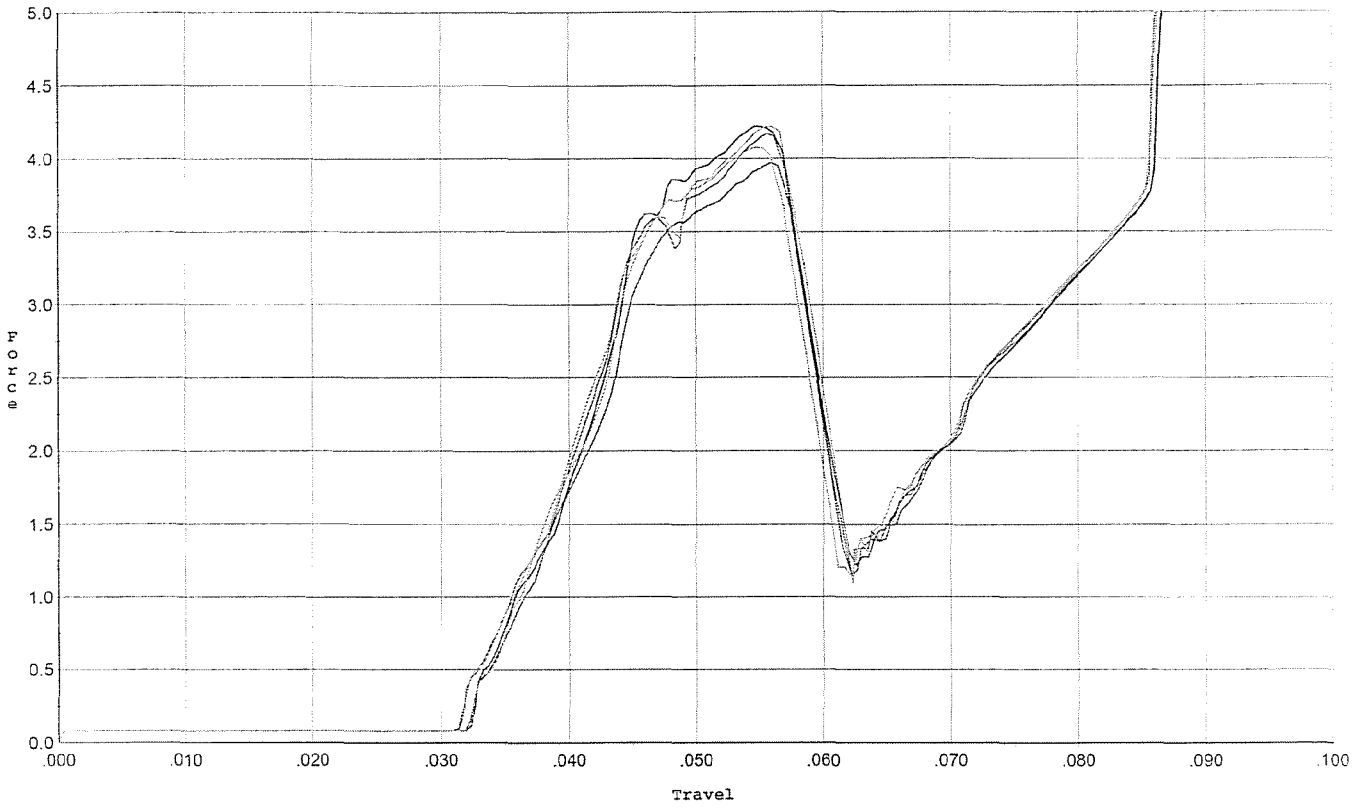
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.920	0.059	0.038	0.035	0.049		Set Trigger
2	2.798	0.058	0.037	0.035	0.047		Set Trigger
3	2.789	0.058	0.038	0.035	0.046		Set Trigger
4	2.804	0.057	0.038	0.035	0.046		Set Trigger
5	2.802	0.057	0.037	0.035	0.045		Set Trigger

Avg 2.82

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 8:58:22 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini.
Note:	R. Putch 10/23/06		



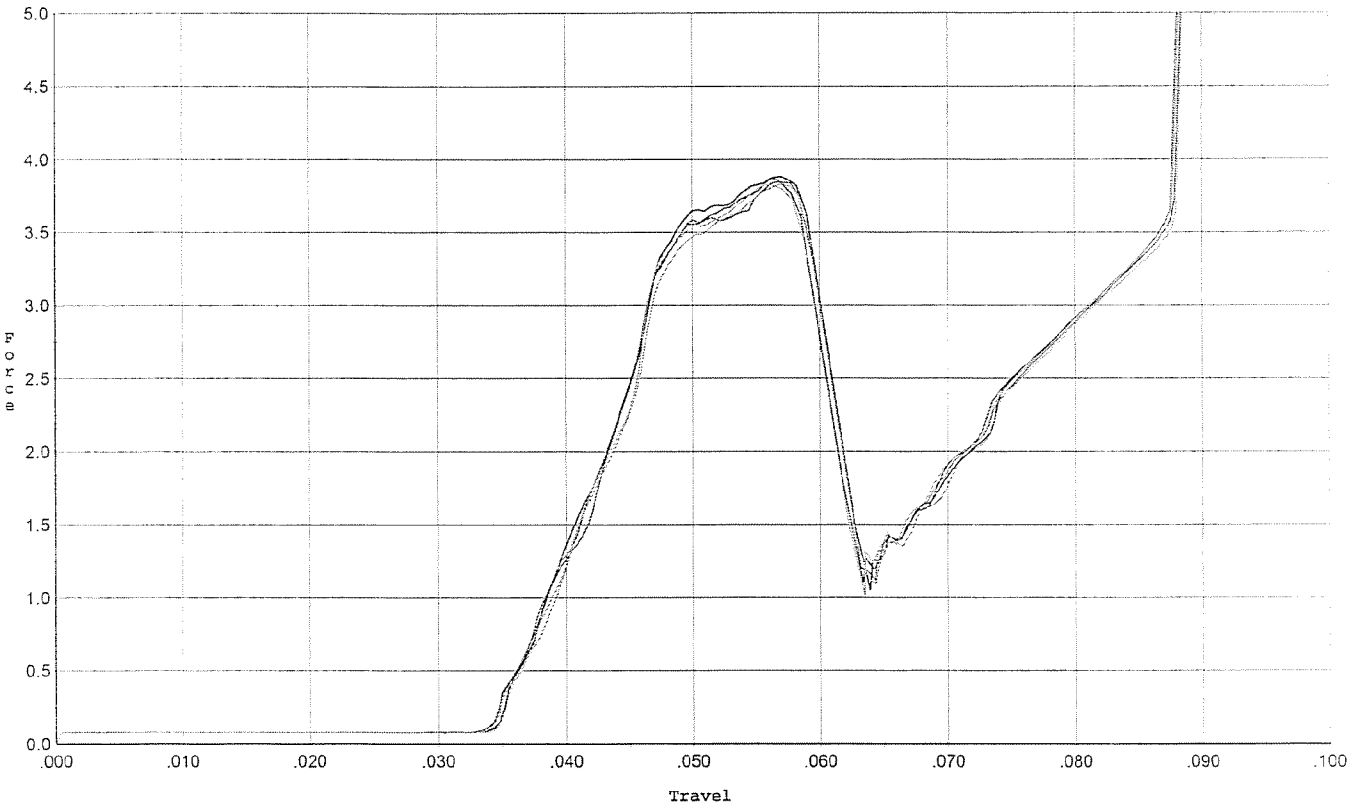
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.973	0.057	0.032	0.033	0.071		Set Trigger
2	4.219	0.057	0.033	0.033	0.075		Set Trigger
3	4.171	0.057	0.032	0.032	0.075		Set Trigger
4	4.078	0.057	0.032	0.033	0.074		Set Trigger
5	4.219	0.059	0.033	0.032	0.077		Set Trigger

Avg 4.13

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 9:24:03 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles
Note:	R. Putch 10/23/06		



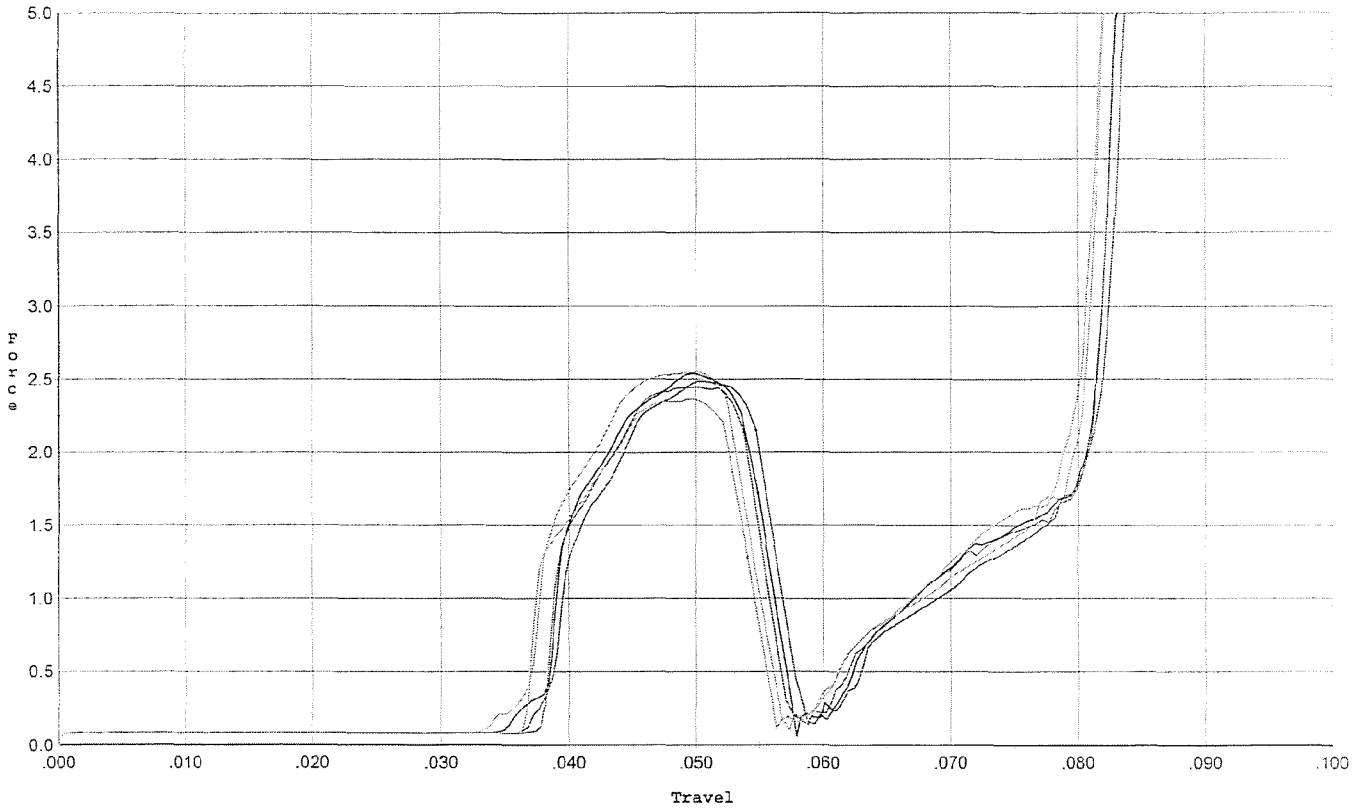
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.866	0.058	0.035	0.034	0.068		Set Trigger
2	3.880	0.059	0.035	0.033	0.070		Set Trigger
3	3.846	0.059	0.035	0.033	0.070		Set Trigger
4	3.826	0.059	0.035	0.034	0.067		Set Trigger
5	3.833	0.059	0.035	0.033	0.068		Set Trigger

Avg 3.85

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 9:26:01 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 for final test
Note:	R. Putch 10/23/06		



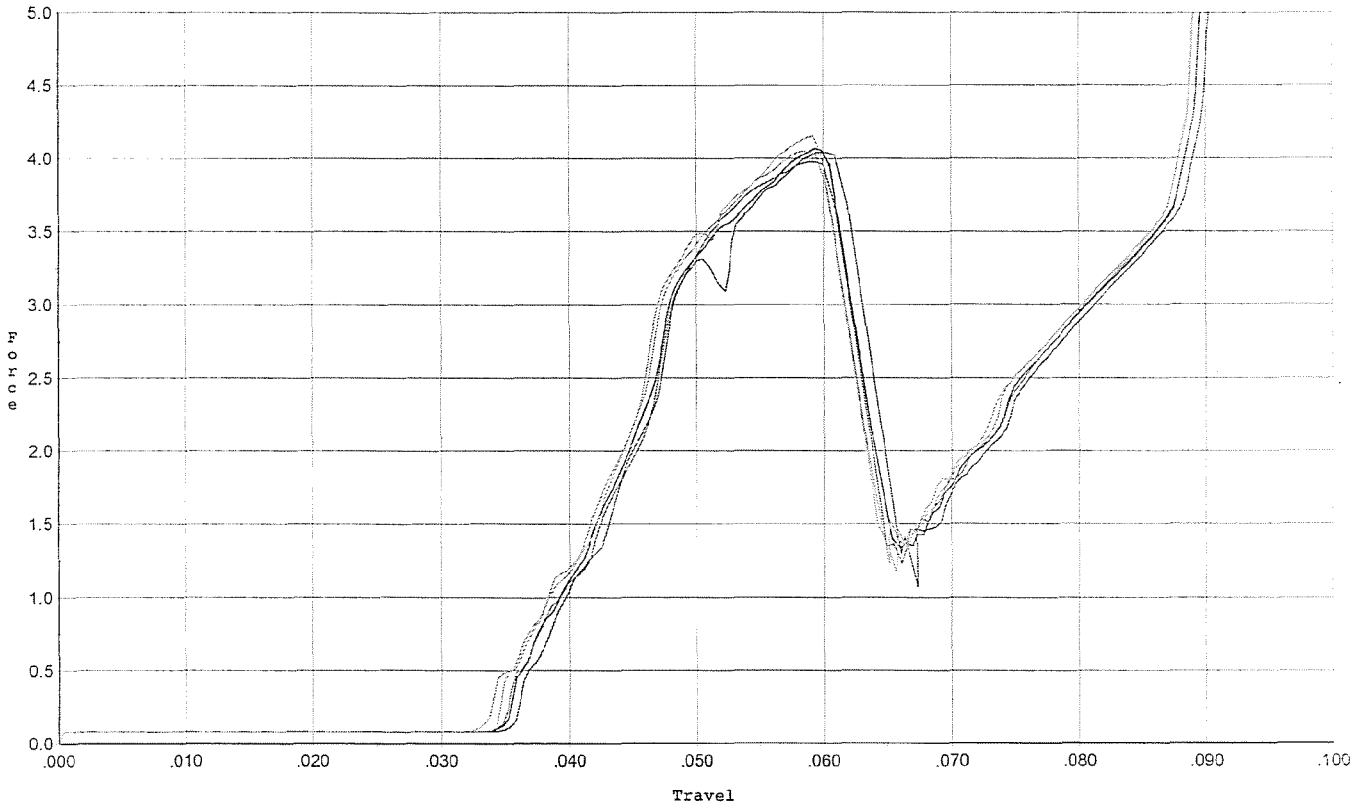
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.055	0.037	0.035	0.038		Set Trigger
2	2.542	0.055	0.036	0.035	0.039		Set Trigger
3	2.447	0.054	0.038	0.036	0.037		Set Trigger
4	2.555	0.052	0.034	0.036	0.039		Set Trigger
5	2.364	0.054	0.037	0.036	0.036		Set Trigger

Avg 2.47

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 9:30:06 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	ser to 4.0 for target & accuracy
Note:	R. Putch 10/23/06		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.038	0.062	0.036	0.032	0.075		Set Trigger
2	4.066	0.060	0.035	0.033	0.073		Set Trigger
3	3.978	0.061	0.035	0.033	0.073		Set Trigger
4	4.049	0.060	0.035	0.033	0.074		Set Trigger
5	4.154	0.060	0.034	0.033	0.075		Set Trigger

Avg 4.05

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/23/2006 9:33:04 AM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591563.__0
FILE DATE AND TIME: 11/01/2006 06:20

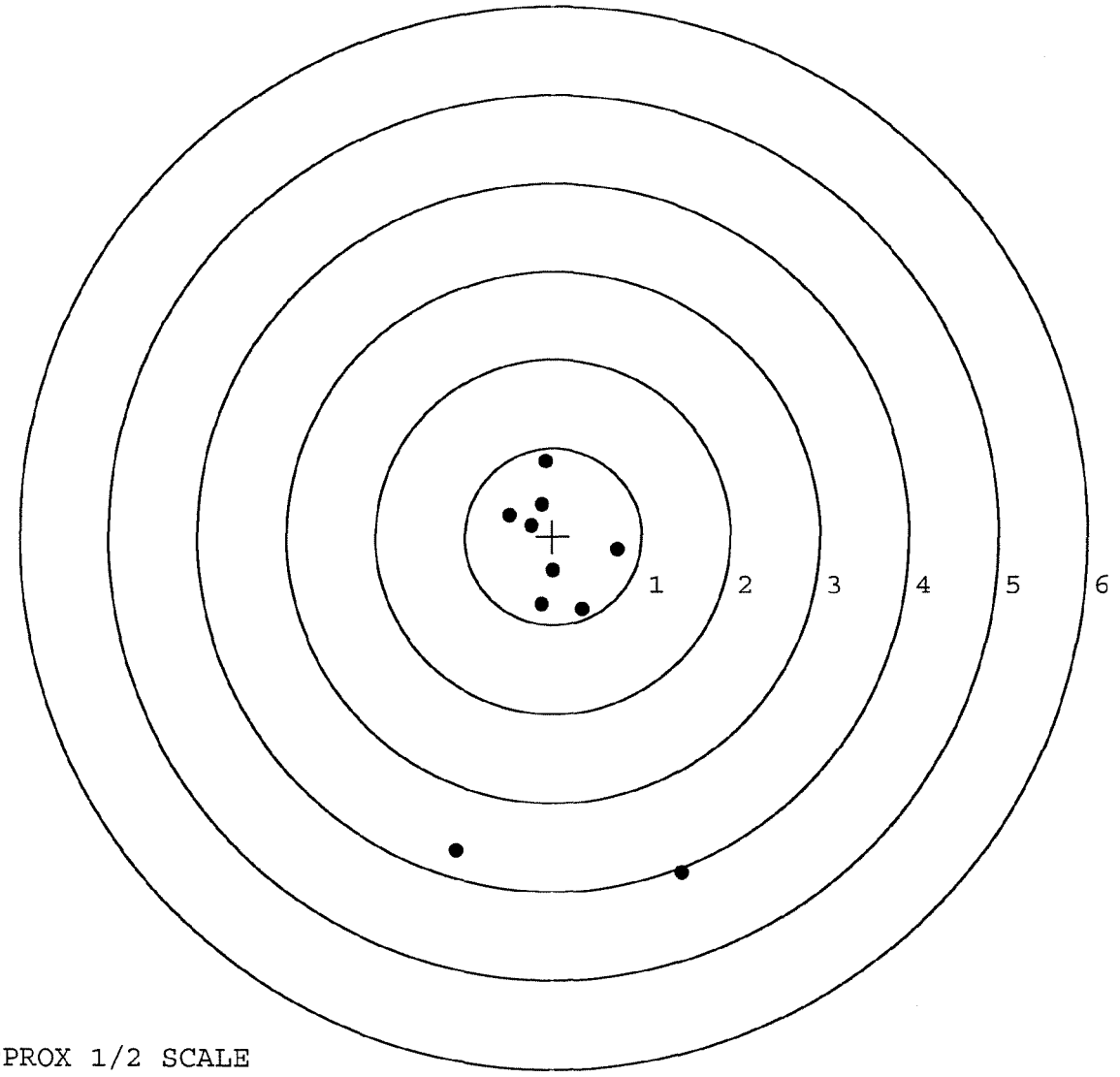
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.011
The Average Y Centroid of the Five Target Set:	-0.206
The Average Point of Impact of the Five Target Set:	0.207
The Average Mean Radius of the Five Target Set:	0.801
The Distance from POA to Centroid Target #1:	0.790
The Distance from Centroid Target #2 to Centroid Target #1:	0.774
The Distance from Centroid Target #3 to Centroid Target #1:	0.714
The Distance from Centroid Target #4 to Centroid Target #1:	0.631
The Distance from Centroid Target #5 to Centroid Target #1:	0.816

SERIAL NUMBER: G6591563.__0
TARGET NUMBER: 1
FILE DATE: 11/01/2006
FILE TIME: 06:20

X CENTROID:	0.033
Y CENTROID:	-0.790
POA TO CENTROID:	0.790
HORZ SPREAD:	2.551
VERT SPREAD:	4.640
GROUP SPREAD:	4.887
MIN RADIUS:	0.162
MAX RADIUS:	3.321
MEAN RADIUS:	1.304
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	-0.128	-0.776
2:	0.331	-0.827
3:	0.001	-0.388
4:	0.733	-0.149
5:	-0.250	0.123
6:	-0.499	0.244
7:	-0.130	0.365
8:	-0.081	0.849
9:	1.454	-3.791
10:	-1.097	-3.546

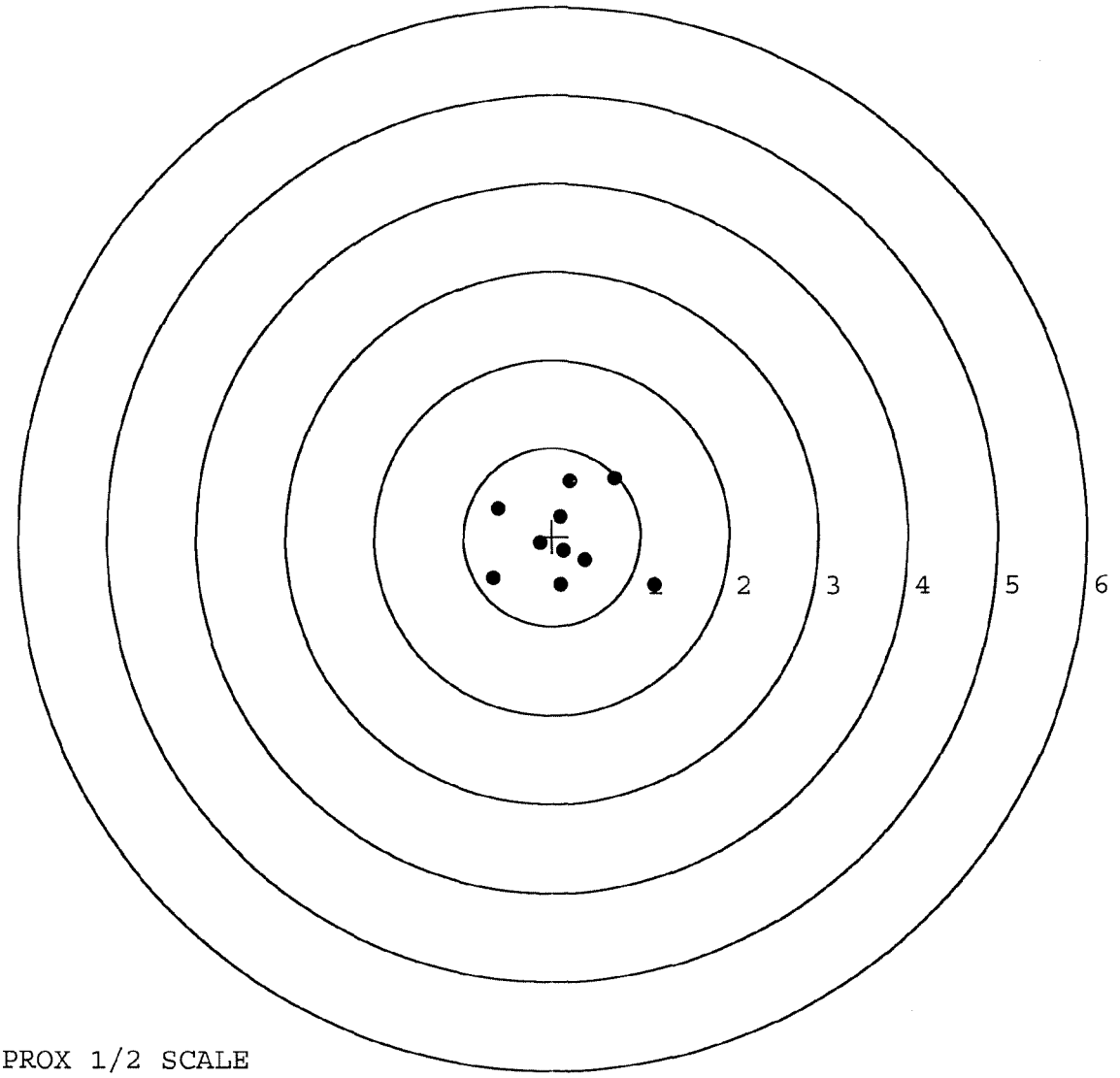


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591563.__0
TARGET NUMBER: 2
FILE DATE: 11/01/2006
FILE TIME: 06:20

X CENTROID:	0.138
Y CENTROID:	-0.023
POA TO CENTROID:	0.140
HORZ SPREAD:	1.820
VERT SPREAD:	1.210
GROUP SPREAD:	1.970
MIN RADIUS:	0.139
MAX RADIUS:	1.148
MEAN RADIUS:	0.596
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.156	-0.553
2:	0.712	0.657
3:	0.201	0.628
4:	0.095	0.226
5:	0.379	-0.265
6:	0.105	-0.543
7:	0.137	-0.162
8:	-0.136	-0.079
9:	-0.608	0.324
10:	-0.664	-0.462

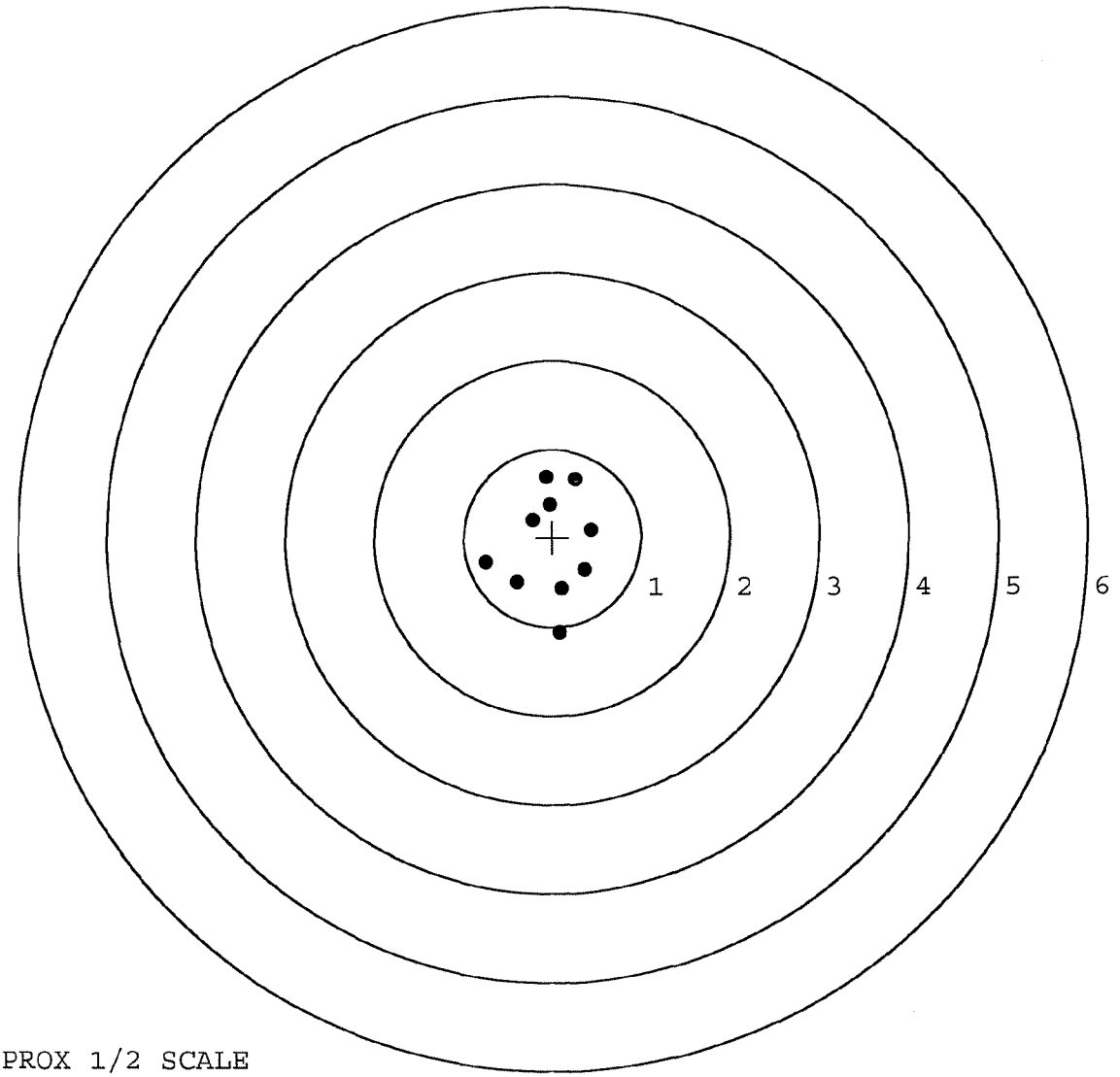


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591563.__0
TARGET NUMBER: 3
FILE DATE: 11/01/2006
FILE TIME: 06:20

X CENTROID:	-0.021
Y CENTROID:	-0.078
POA TO CENTROID:	0.081
HORZ SPREAD:	1.185
VERT SPREAD:	1.753
GROUP SPREAD:	1.759
MIN RADIUS:	0.340
MAX RADIUS:	0.995
MEAN RADIUS:	0.615
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.081	-1.068
2:	0.107	-0.576
3:	0.371	-0.360
4:	-0.400	-0.505
5:	-0.750	-0.274
6:	0.435	0.093
7:	0.266	0.663
8:	-0.069	0.685
9:	-0.031	0.367
10:	-0.222	0.196

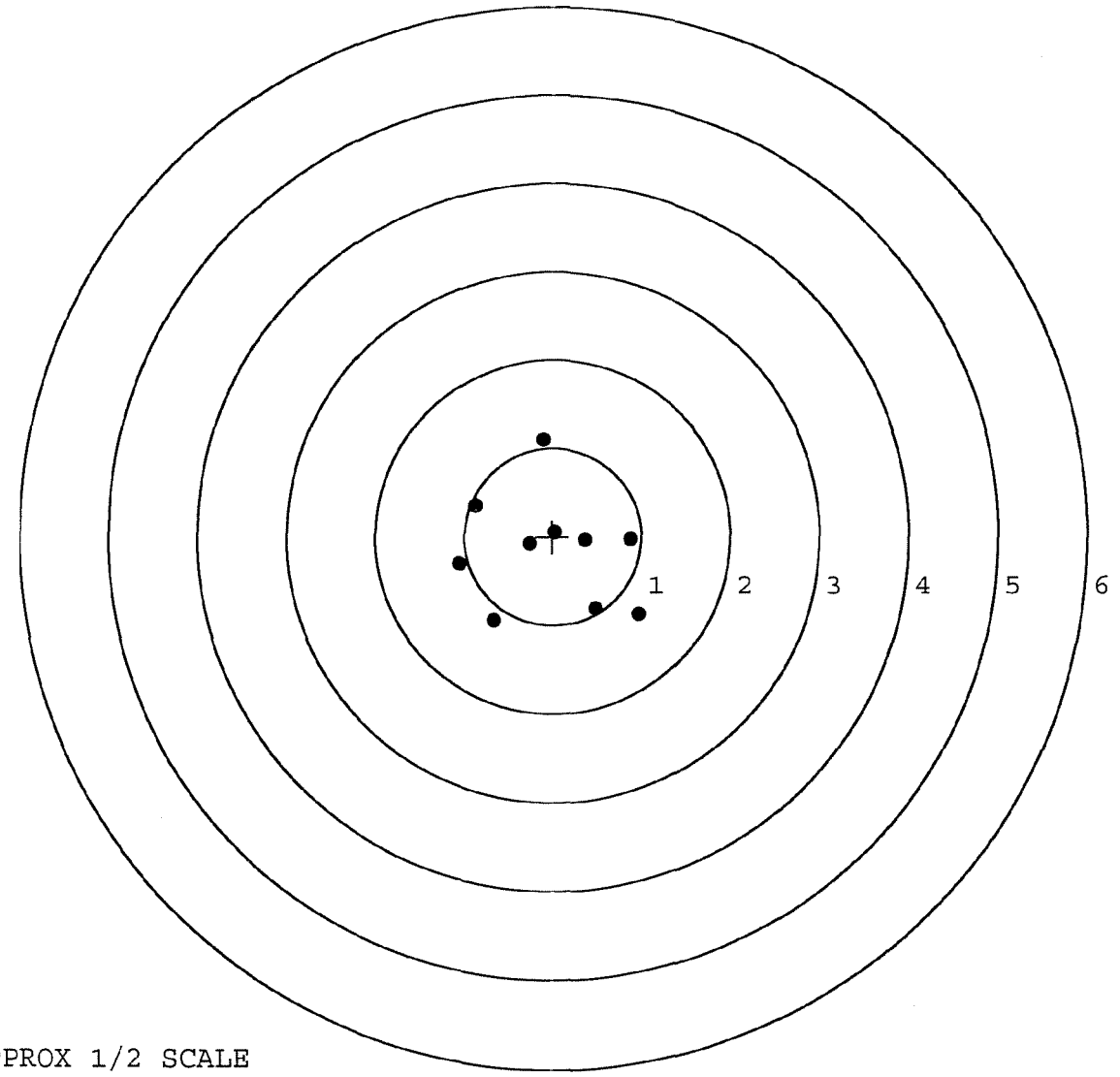


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591563.__0
TARGET NUMBER: 4
FILE DATE: 11/01/2006
FILE TIME: 06:20

X CENTROID:	-0.023
Y CENTROID:	-0.161
POA TO CENTROID:	0.163
HORZ SPREAD:	2.025
VERT SPREAD:	2.041
GROUP SPREAD:	2.246
MIN RADIUS:	0.216
MAX RADIUS:	1.257
MEAN RADIUS:	0.816
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.969	-0.881
2:	0.481	-0.819
3:	0.883	-0.031
4:	0.373	-0.039
5:	0.028	0.049
6:	-0.259	-0.081
7:	-0.668	-0.948
8:	-1.056	-0.312
9:	-0.874	0.356
10:	-0.103	1.093

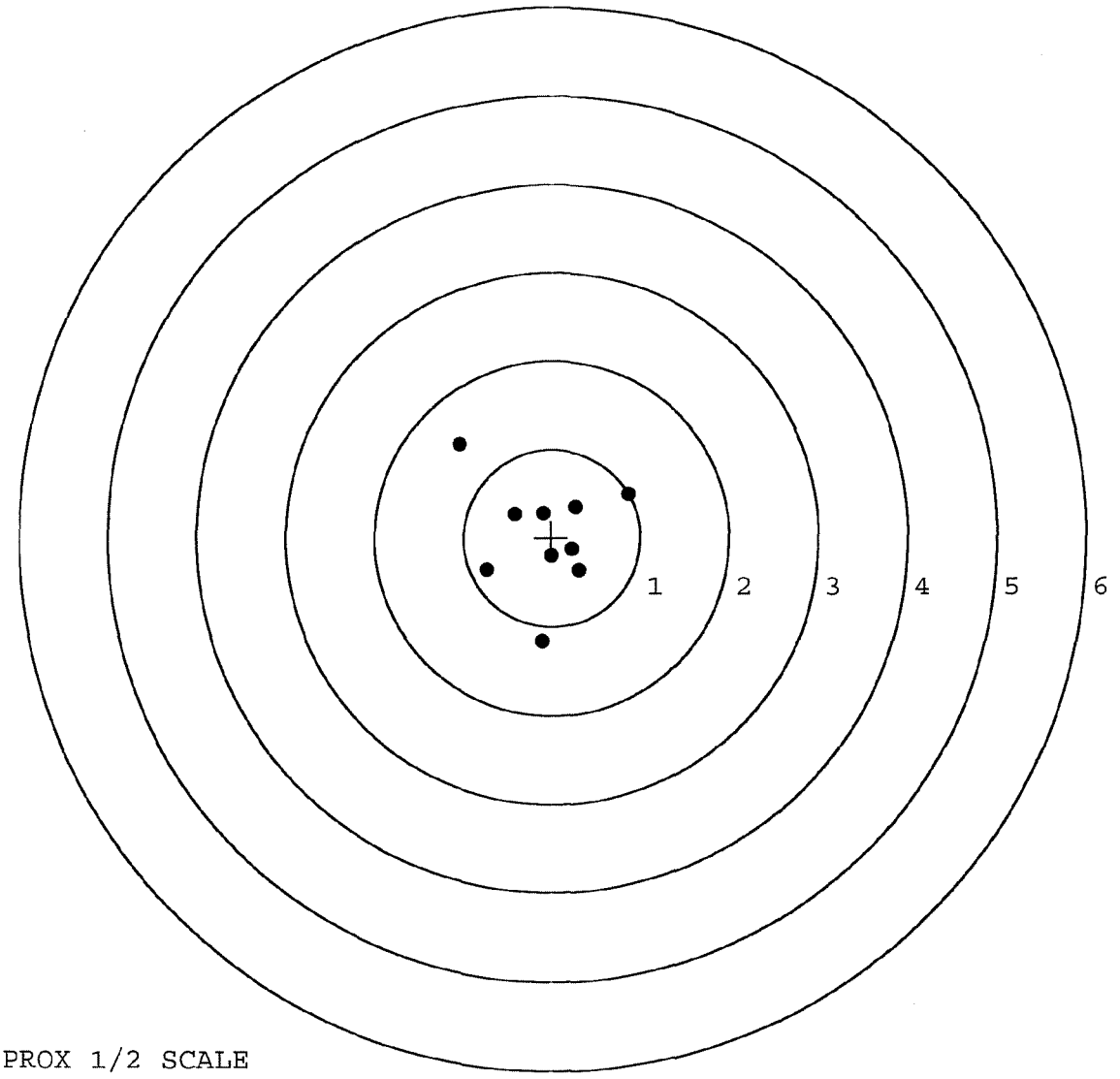


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591563.__0
TARGET NUMBER: 5
FILE DATE: 11/01/2006
FILE TIME: 06:20

X CENTROID:	-0.072
Y CENTROID:	0.020
POA TO CENTROID:	0.075
HORZ SPREAD:	1.912
VERT SPREAD:	2.230
GROUP SPREAD:	2.422
MIN RADIUS:	0.242
MAX RADIUS:	1.421
MEAN RADIUS:	0.672
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.100	-1.175
2:	0.308	-0.370
3:	0.231	-0.130
4:	0.004	-0.210
5:	0.866	0.496
6:	0.267	0.350
7:	-0.095	0.276
8:	-0.420	0.269
9:	-1.046	1.055
10:	-0.736	-0.363



TARGET APPROX 1/2 SCALE