G 659 1584

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)

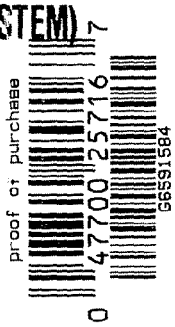
UPC

SERIAL NO.

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

– INSTUCTION BOOK 3518

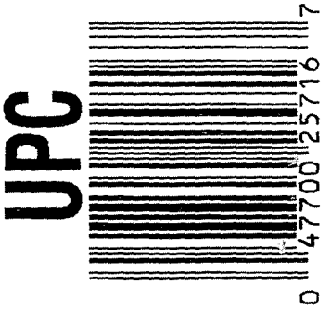
DD FORM



ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6591584



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591584

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-26-06	RTL
420	ASSEMBLE ACTION		9-28-06	RTL
430	ASSEMBLE TO STOCK		10-2-06	SD
440	PROOF	MAGNA-FLUX INSPECTED OCT 03 2006	10-2-06	TRW
460	CHECK HEADSPACE		10-2-06	TRW
470	DIS-ASSEMBLE ACTION		10-2-06	RTL
480	MAGNAFLUX BBL ACTION		10/3/06	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/3/06	
510	DRILL AND TAP SIGHT HOLES		10-3-06	SD
520	GOFF BLAST BBL / REC		10-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/6/06	
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-06	DA
	D) OIL FIRING PIN ASSEMBLY		10-17-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

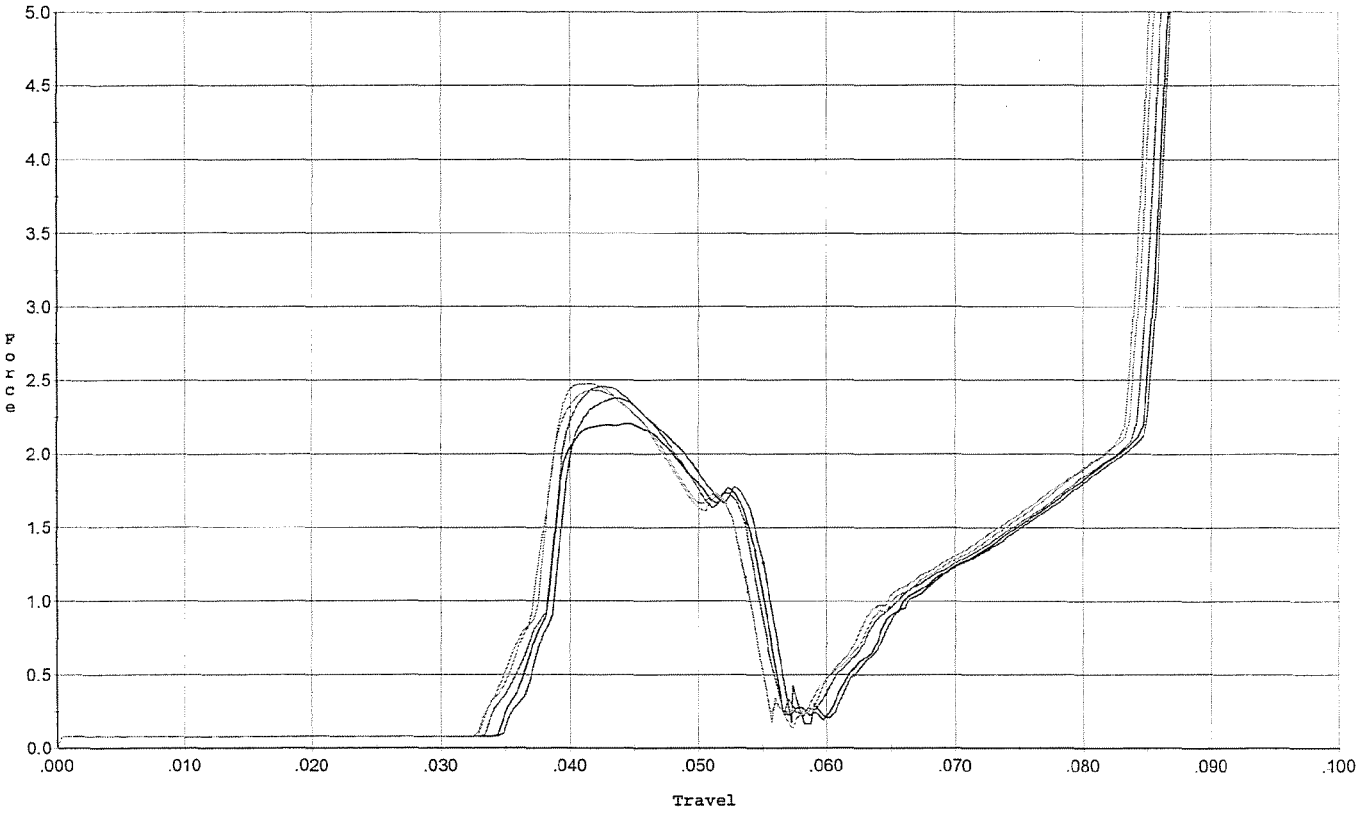
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	6.0 6.0 6.0	11-11-06	L.P.D.
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 3.0 3.0	11-11-06	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.025 .0245 .0245	11-11-06	L.P.D.
	J) ASSEMBLE STOCK		10-19-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-16-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-17-06	BLG
	M) IRON SIGHT ALIGNMENT		10-17-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-17-06	BLG
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	10-26-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/26/06	W.R.
670	FINAL INSPECTION A) HEADSPACE		11-16-06	L.P.D.
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.65 2.29 2.26 2.61 2.61	11/16/06	MSW
	C) FUNCTION		11-16-06	L.P.D.
690	PACK		11/18/06	DM

F004 REV 5/2006

Trigger Profile [lbs,inch]

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



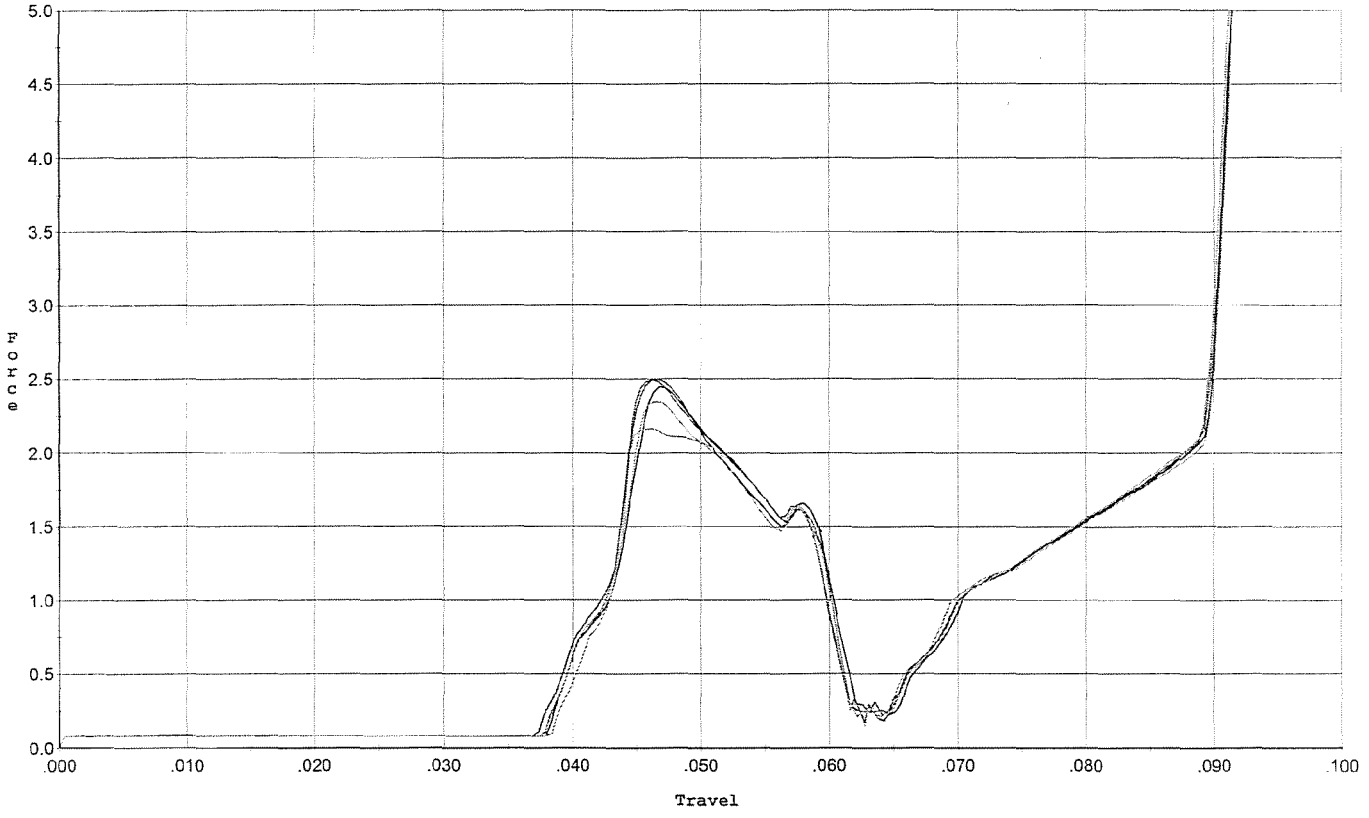
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.379	0.055	0.035	0.039	0.038		Set Trigger
2	2.207	0.054	0.035	0.038	0.036		Set Trigger
3	2.456	0.054	0.034	0.038	0.037		Set Trigger
4	2.430	0.054	0.033	0.038	0.037		Set Trigger
5	2.475	0.054	0.033	0.038	0.038		Set Trigger

AVG 2.38

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:24:45 AM

Trigger Profile [lbs,inch]

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



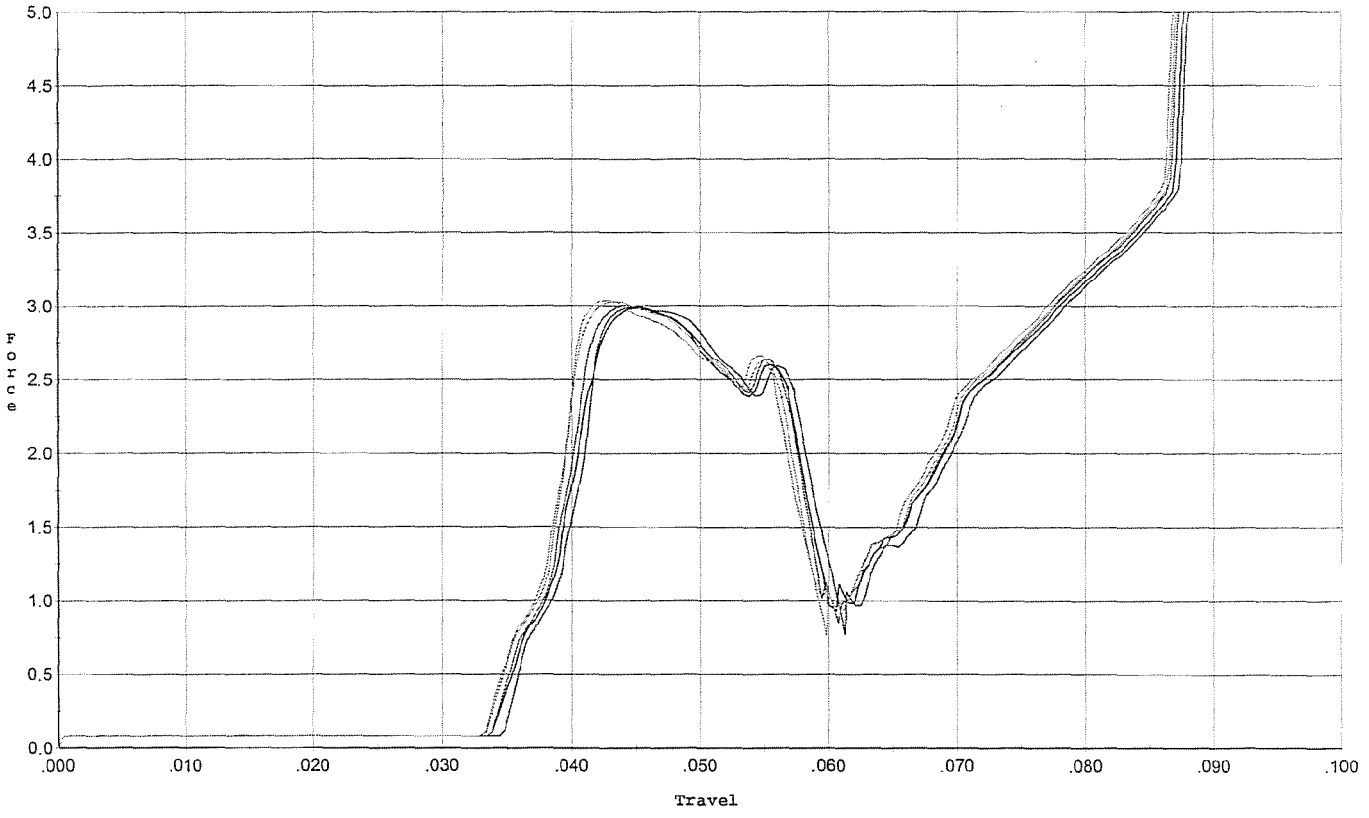
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.498	0.059	0.038	0.039	0.039		Set Trigger
2	2.446	0.059	0.038	0.039	0.038		Set Trigger
3	2.496	0.059	0.038	0.039	0.038		Set Trigger
4	2.161	0.060	0.039	0.039	0.037		Set Trigger
5	2.344	0.059	0.038	0.039	0.036		Set Trigger

AUG 2.38

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:26:52 AM

Trigger Profile [lbs,inch]

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



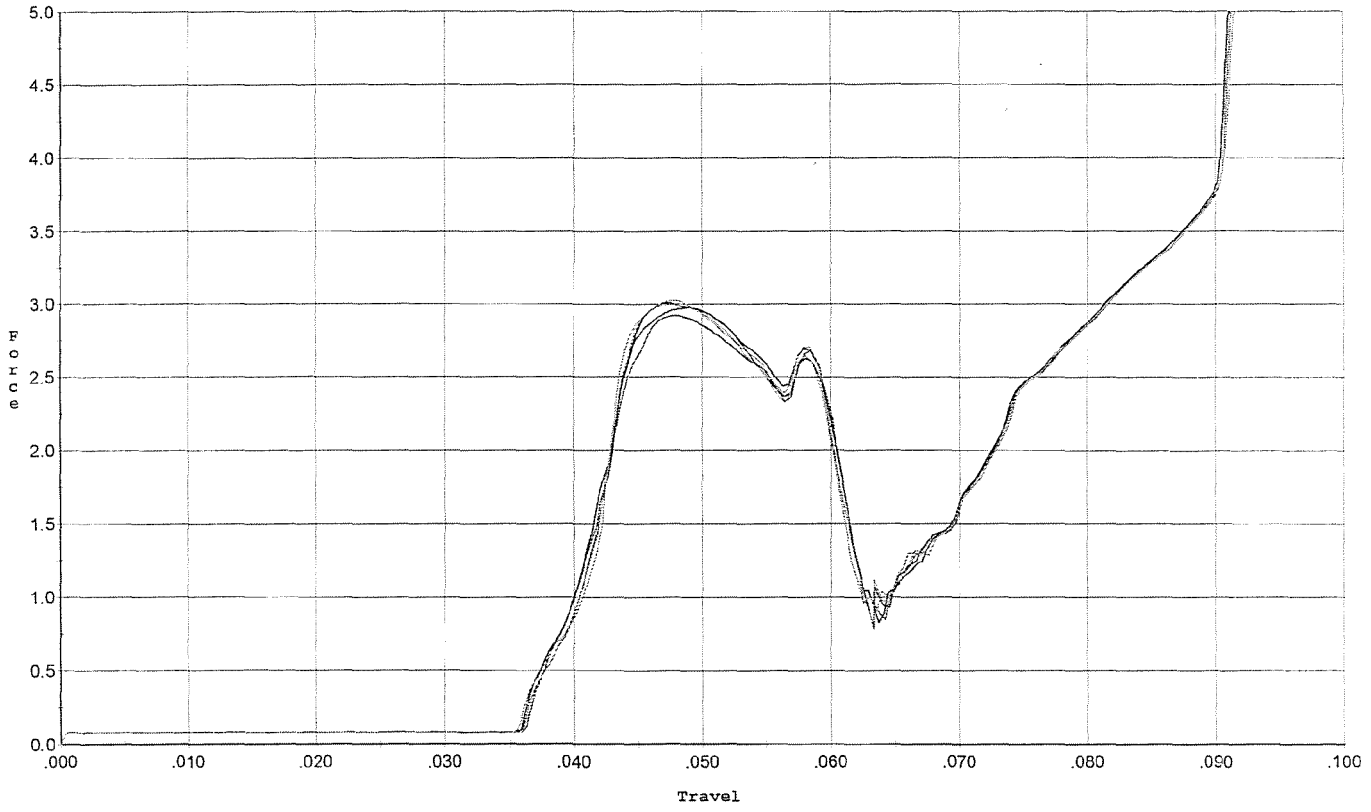
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.996	0.057	0.035	0.036	0.055		Set Trigger
2	2.988	0.057	0.034	0.036	0.054		Set Trigger
3	3.004	0.057	0.034	0.036	0.056		Set Trigger
4	3.027	0.056	0.034	0.036	0.056		Set Trigger
5	3.039	0.056	0.034	0.036	0.055		Set Trigger

AVG 3.01

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:30:03 AM

Trigger Profile [lbs,inch]

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



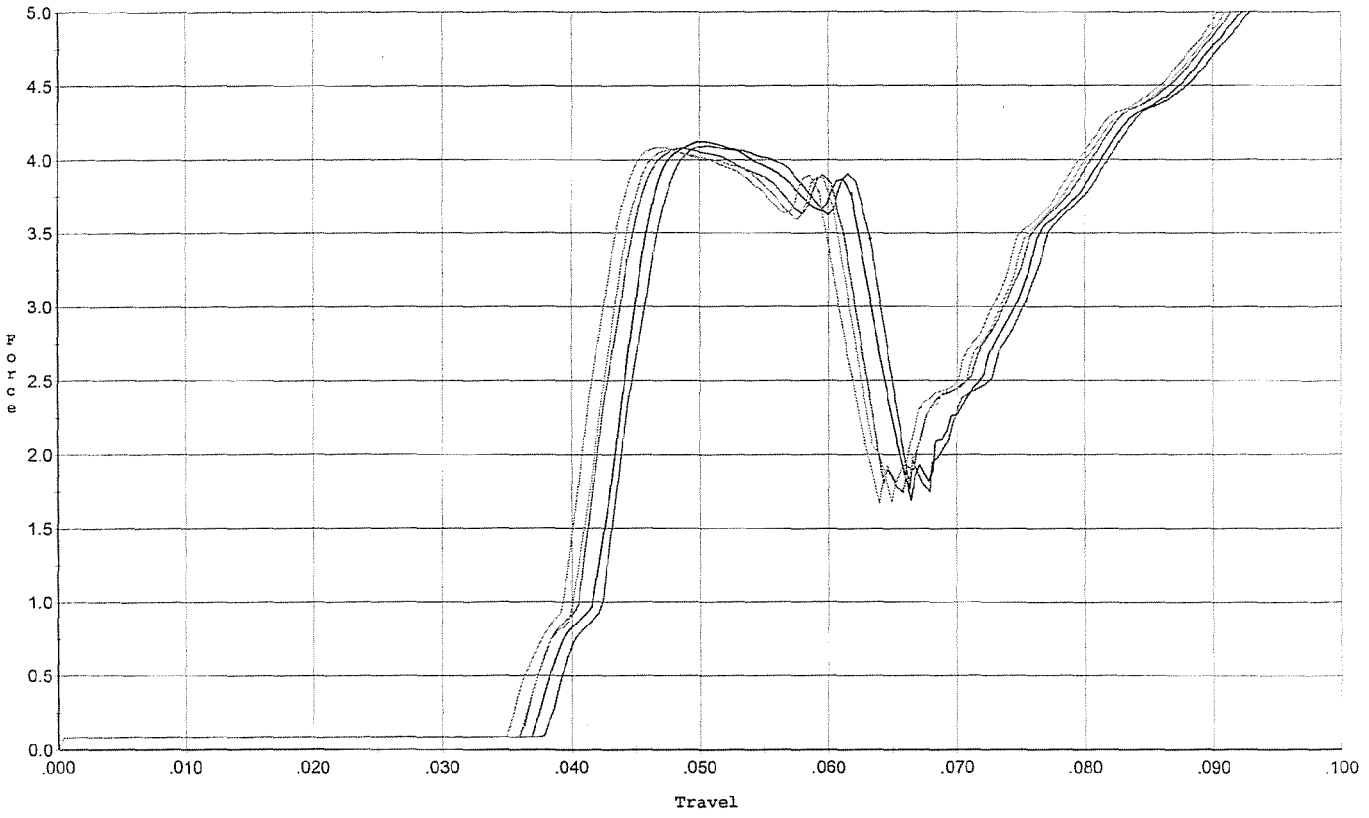
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.976	0.059	0.037	0.037	0.055		Set Trigger
2	3.011	0.060	0.036	0.037	0.058		Set Trigger
3	2.920	0.060	0.036	0.037	0.056		Set Trigger
4	3.025	0.059	0.037	0.037	0.056		Set Trigger
5	2.996	0.059	0.036	0.038	0.055		Set Trigger

AUG 2.98

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:32:02 AM

Trigger Profile [lbs,inch]

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

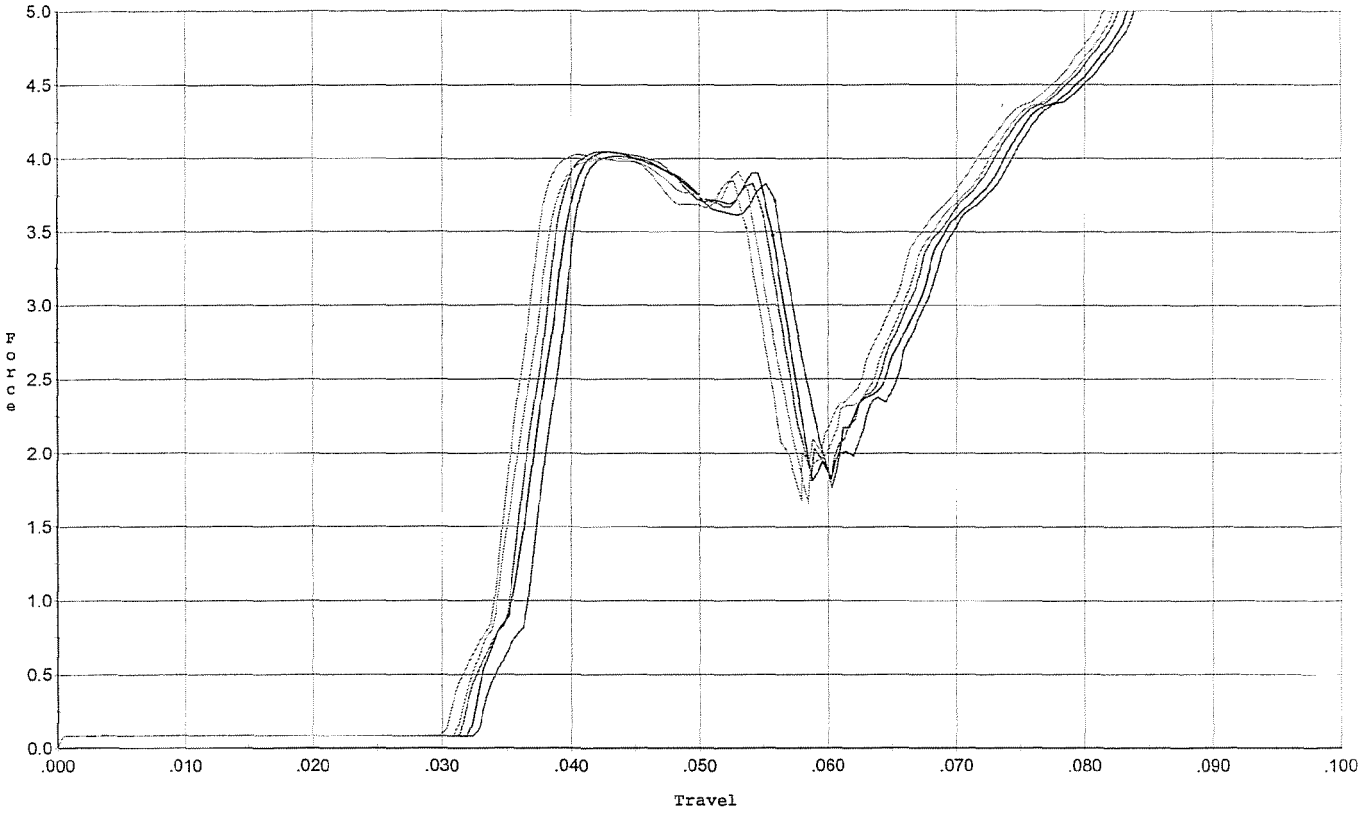


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.063	0.038	0.034	0.084		Set Trigger
2	4.126	0.062	0.037	0.035	0.082		Set Trigger
3	4.074	0.061	0.036	0.035	0.083		Set Trigger
4	4.063	0.060	0.036	0.035	0.081		Set Trigger
5	4.082	0.059	0.035	0.035	0.081		Set Trigger

AUG 4.08

Trigger Profile [lbs,inch]

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

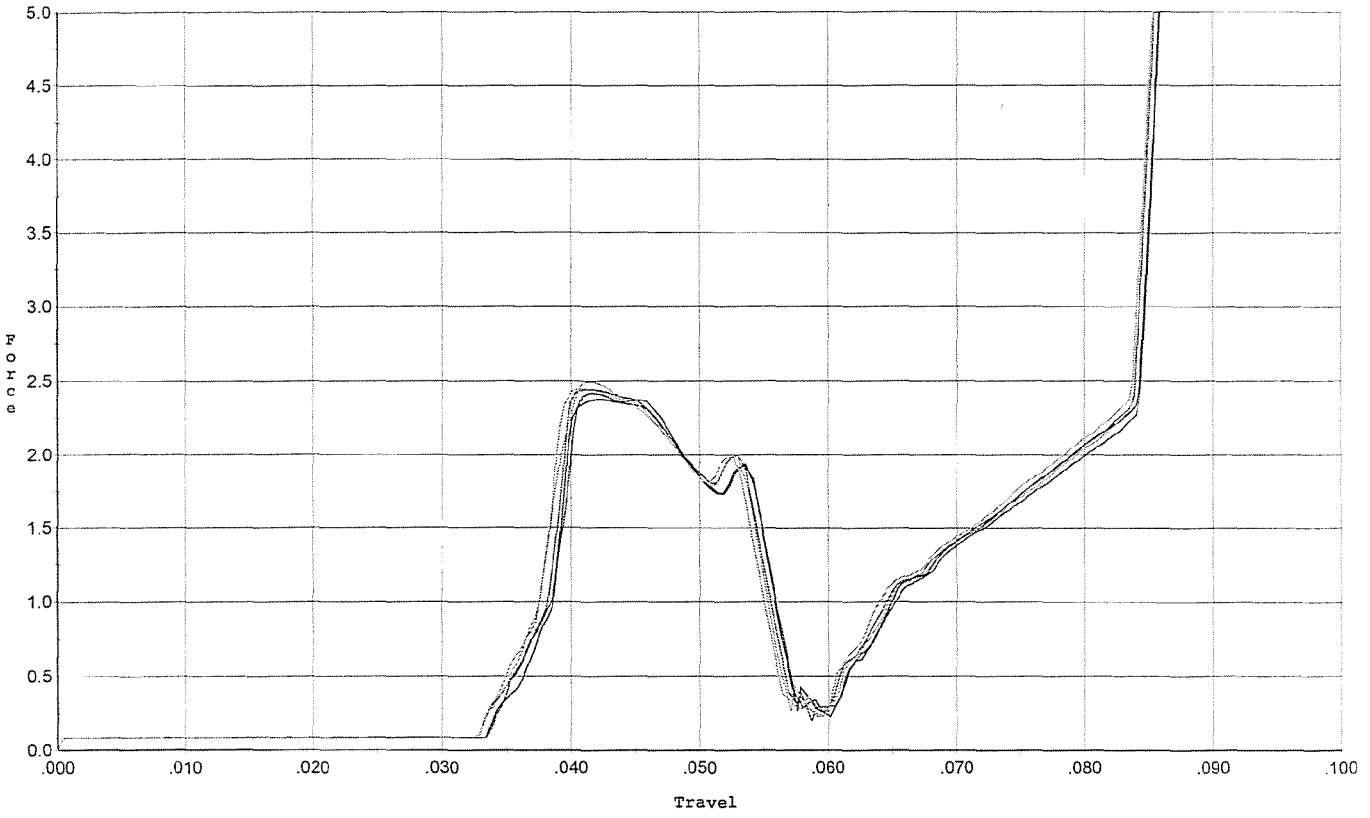


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.016	0.056	0.033	0.032	0.077		Set Trigger
2	4.045	0.056	0.032	0.032	0.079		Set Trigger
3	4.047	0.055	0.032	0.032	0.079		Set Trigger
4	4.002	0.054	0.031	0.032	0.077		Set Trigger
5	4.027	0.054	0.031	0.032	0.077		Set Trigger

AVG 4.02

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 10/10/06		



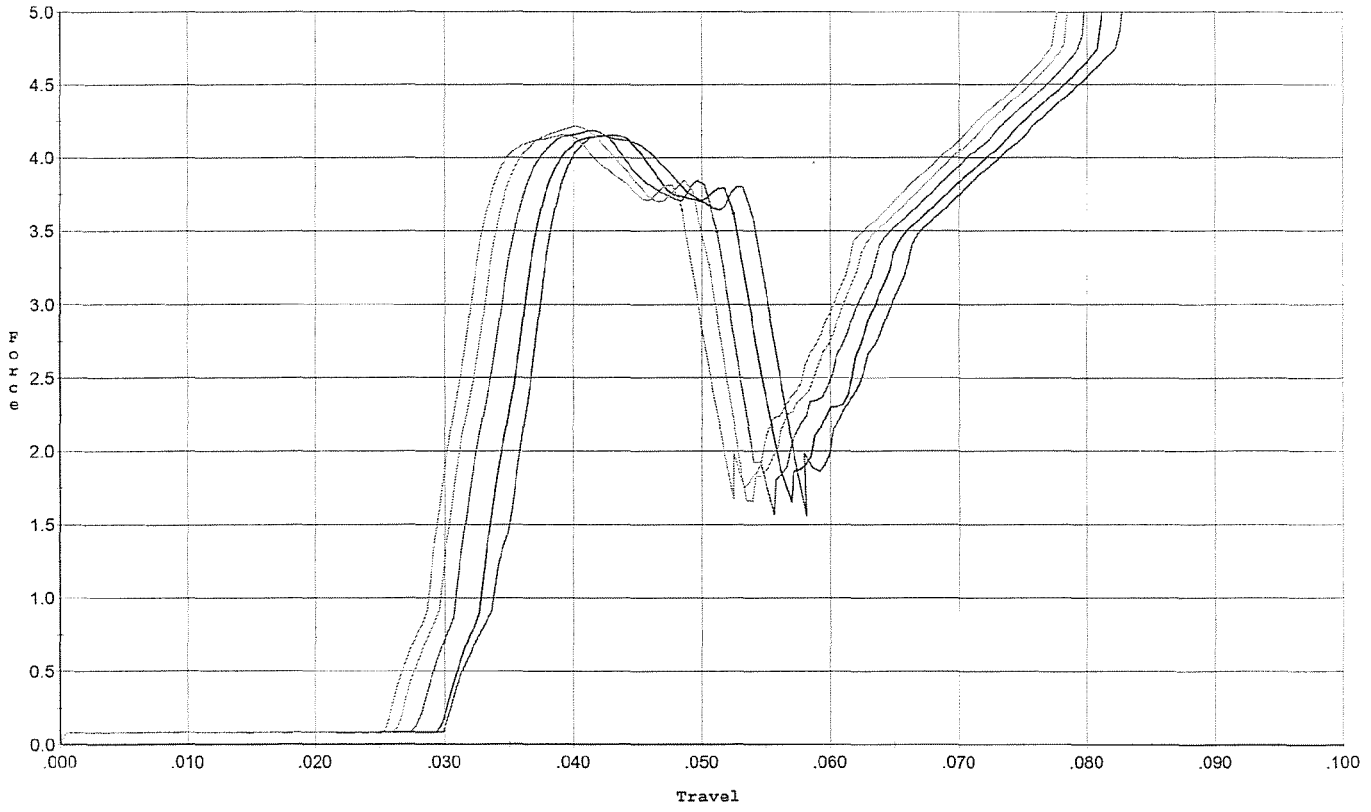
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.054	0.034	0.038	0.039		Set Trigger
2	2.376	0.054	0.034	0.038	0.039		Set Trigger
3	2.444	0.054	0.033	0.038	0.039		Set Trigger
4	2.449	0.053	0.033	0.037	0.039		Set Trigger
5	2.496	0.054	0.033	0.038	0.040		Set Trigger

AV6243

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:47:34 AM

Trigger Profile [lbs,inch]

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.154	0.054	0.030	0.032	0.079		Set Trigger
2	4.157	0.052	0.030	0.032	0.077		Set Trigger
3	4.188	0.051	0.028	0.031	0.078		Set Trigger
4	4.215	0.051	0.027	0.031	0.080		Set Trigger
5	4.160	0.048	0.026	0.030	0.077		Set Trigger

AVG 4.17

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/10/2006 8:49:52 AM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591584.__0
FILE DATE AND TIME: 10/28/2006 07:56

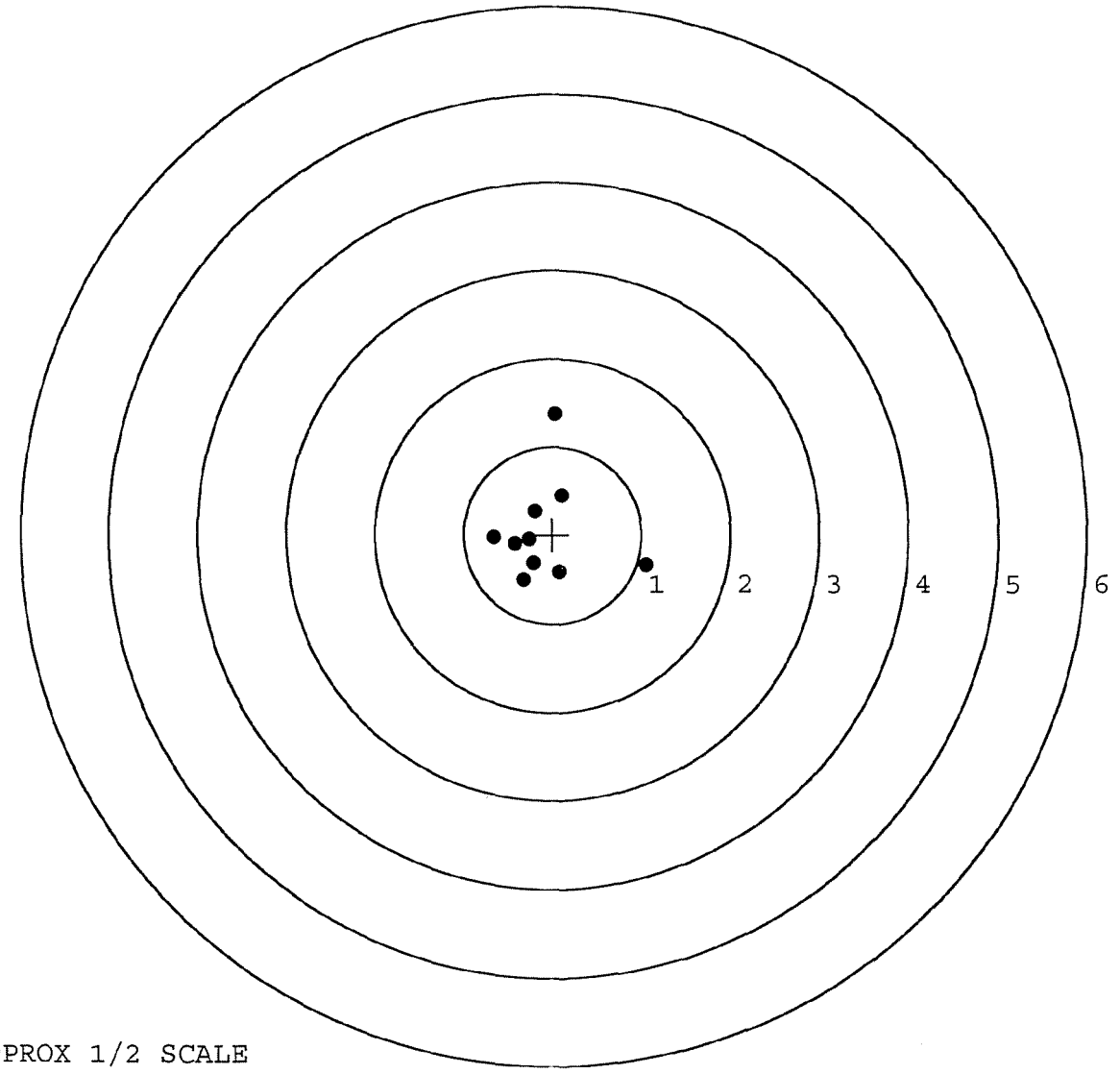
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.107
The Average Y Centroid of the Five Target Set:	0.165
The Average Point of Impact of the Five Target Set:	0.197
The Average Mean Radius of the Five Target Set:	0.637
The Distance from POA to Centroid Target #1:	0.089
The Distance from Centroid Target #2 to Centroid Target #1:	0.283
The Distance from Centroid Target #3 to Centroid Target #1:	0.081
The Distance from Centroid Target #4 to Centroid Target #1:	0.226
The Distance from Centroid Target #5 to Centroid Target #1:	0.178

SERIAL NUMBER: G6591584.__0
TARGET NUMBER: 1
FILE DATE: 10/28/2006
FILE TIME: 07:56

X CENTROID:	-0.084
Y CENTROID:	0.029
POA TO CENTROID:	0.089
HORZ SPREAD:	1.712
VERT SPREAD:	1.883
GROUP SPREAD:	2.001
MIN RADIUS:	0.199
MAX RADIUS:	1.347
MEAN RADIUS:	0.584
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.021	1.372
2:	0.105	0.441
3:	-0.204	0.260
4:	-0.661	-0.028
5:	-0.426	-0.101
6:	-0.263	-0.058
7:	-0.214	-0.325
8:	-0.329	-0.511
9:	0.077	-0.414
10:	1.051	-0.344

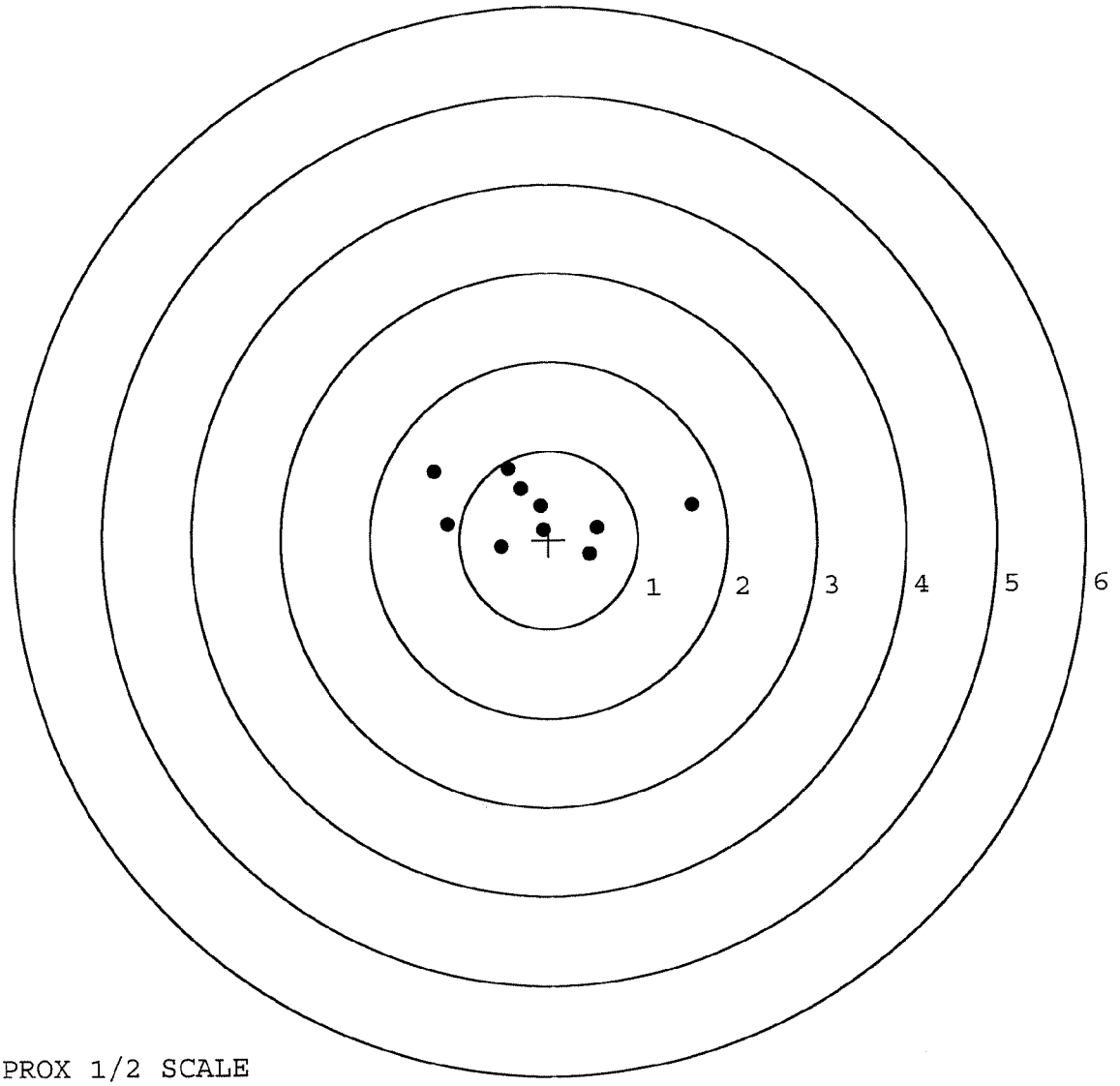


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591584.__0
TARGET NUMBER: 2
FILE DATE: 10/28/2006
FILE TIME: 07:56

X CENTROID:	-0.125
Y CENTROID:	0.309
POA TO CENTROID:	0.333
HORZ SPREAD:	2.883
VERT SPREAD:	0.974
GROUP SPREAD:	2.911
MIN RADIUS:	0.082
MAX RADIUS:	1.731
MEAN RADIUS:	0.720
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-1.278	0.779
2:	-1.130	0.180
3:	-0.448	0.805
4:	-0.311	0.575
5:	-0.090	0.383
6:	-0.064	0.111
7:	-0.530	-0.081
8:	0.457	-0.169
9:	0.543	0.127
10:	1.605	0.379

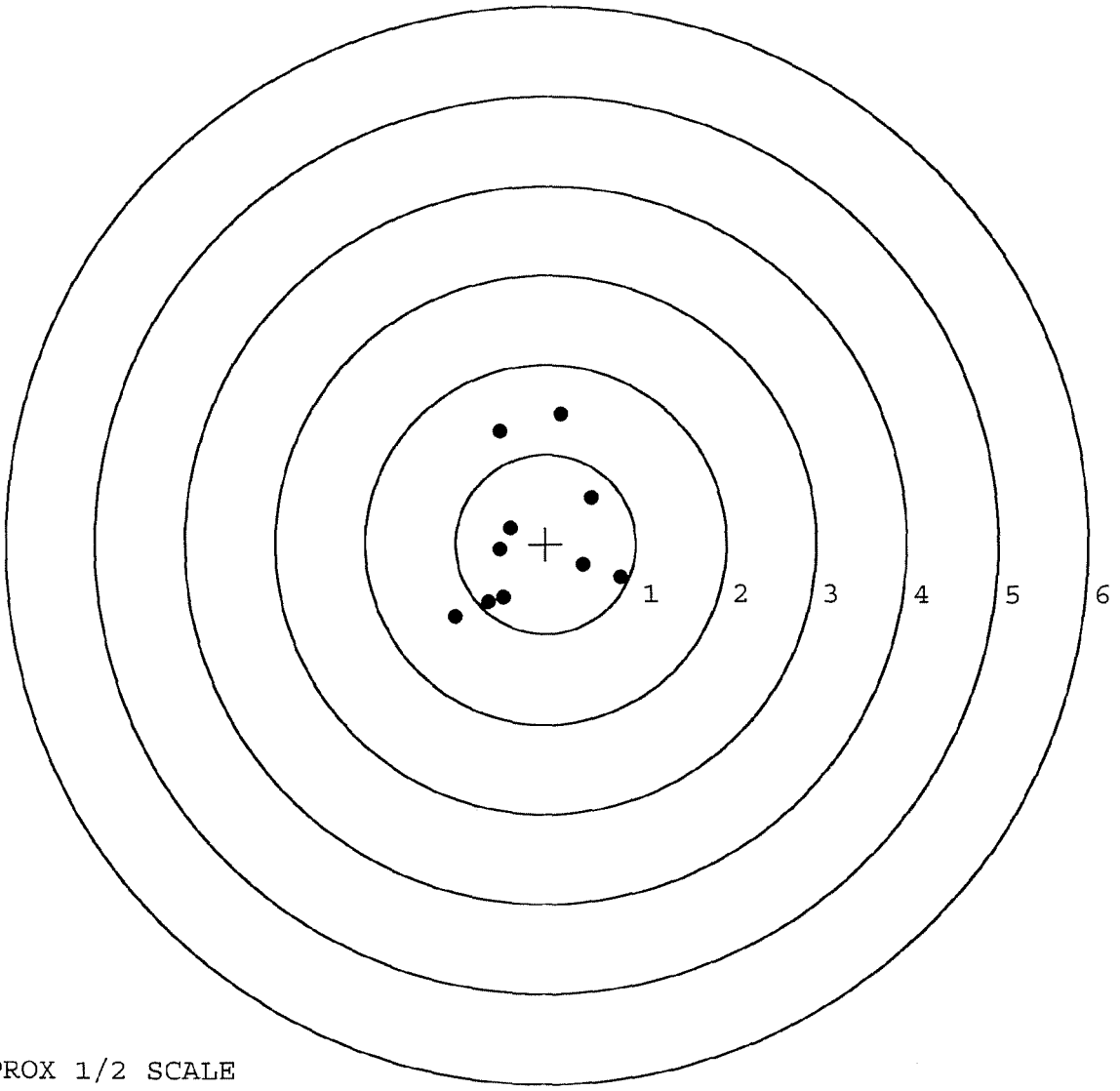


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591584.__0
TARGET NUMBER: 3
FILE DATE: 10/28/2006
FILE TIME: 07:56

X CENTROID:	-0.159
Y CENTROID:	0.061
POA TO CENTROID:	0.170
HORZ SPREAD:	1.835
VERT SPREAD:	2.278
GROUP SPREAD:	2.555
MIN RADIUS:	0.253
MAX RADIUS:	1.428
MEAN RADIUS:	0.868
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.161	1.452
2:	-0.518	1.252
3:	-0.389	0.167
4:	-0.511	-0.071
5:	-0.996	-0.826
6:	-0.637	-0.660
7:	-0.473	-0.612
8:	0.420	-0.234
9:	0.839	-0.379
10:	0.510	0.516

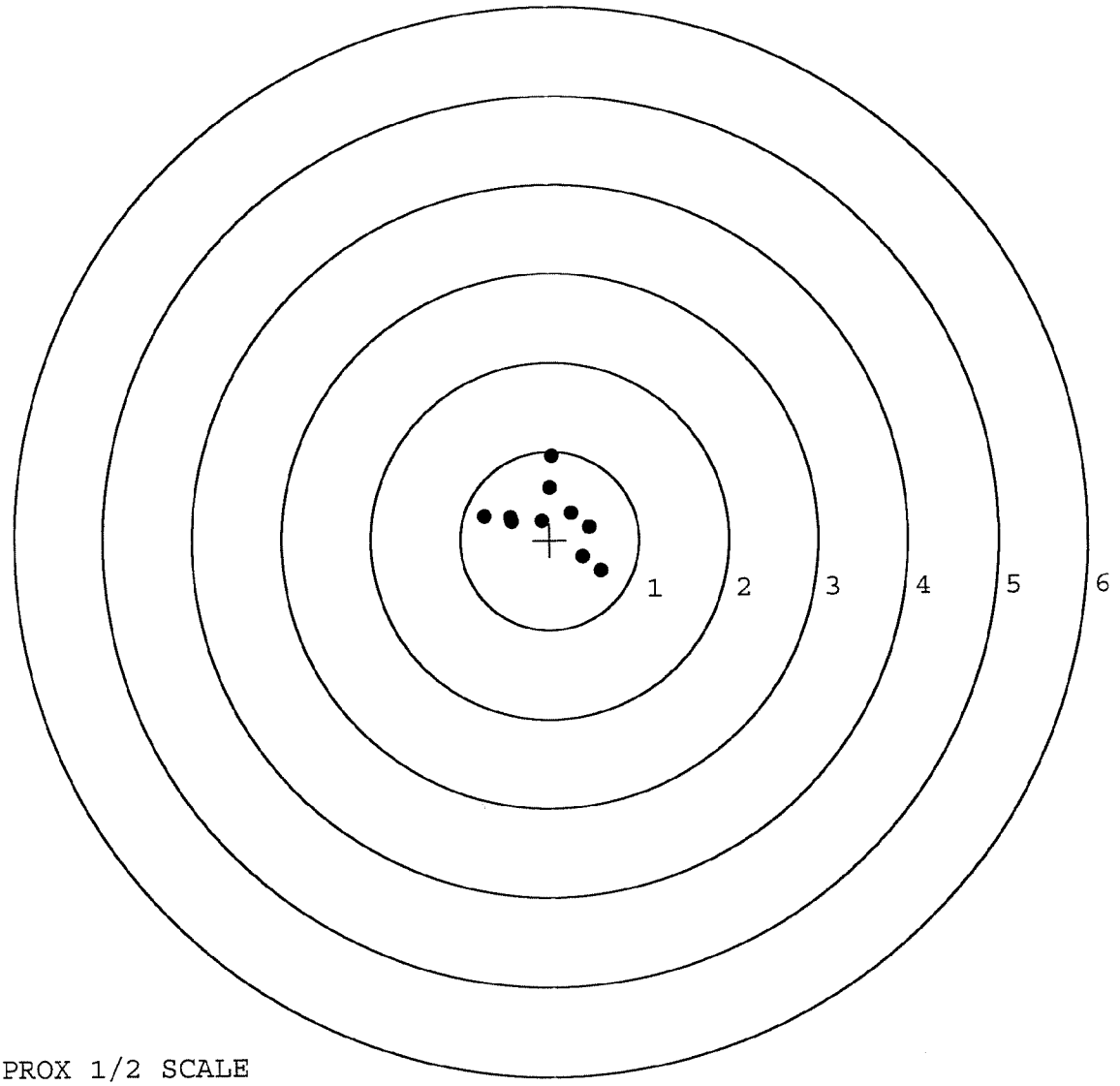


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591584.__0
TARGET NUMBER: 4
FILE DATE: 10/28/2006
FILE TIME: 07:56

X CENTROID:	-0.003
Y CENTROID:	0.240
POA TO CENTROID:	0.240
HORZ SPREAD:	1.301
VERT SPREAD:	1.304
GROUP SPREAD:	1.445
MIN RADIUS:	0.093
MAX RADIUS:	0.829
MEAN RADIUS:	0.485
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.027	0.947
2:	-0.005	0.590
3:	0.244	0.306
4:	0.444	0.145
5:	0.369	-0.197
6:	0.572	-0.357
7:	-0.093	0.217
8:	-0.421	0.213
9:	-0.729	0.272
10:	-0.438	0.260

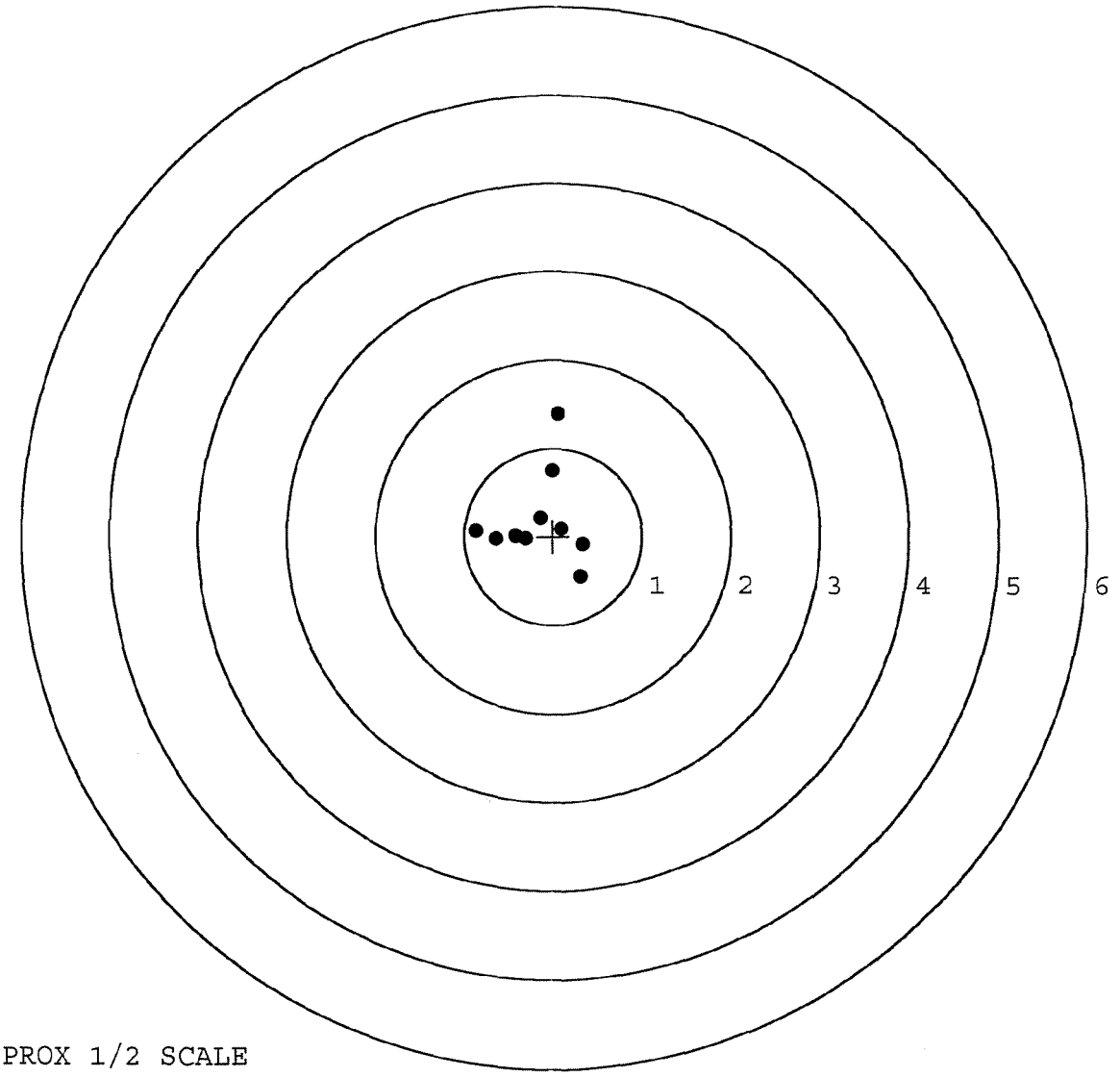


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591584.__0
TARGET NUMBER: 5
FILE DATE: 10/28/2006
FILE TIME: 07:56

X CENTROID:	-0.162
Y CENTROID:	0.189
POA TO CENTROID:	0.249
HORZ SPREAD:	1.206
VERT SPREAD:	1.845
GROUP SPREAD:	1.863
MIN RADIUS:	0.026
MAX RADIUS:	1.219
MEAN RADIUS:	0.529
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.049	1.390
2:	-0.017	0.740
3:	-0.867	0.063
4:	-0.642	-0.028
5:	-0.424	0.008
6:	-0.311	-0.030
7:	-0.152	0.213
8:	0.094	0.082
9:	0.339	-0.092
10:	0.307	-0.455



TARGET APPROX 1/2 SCALE