G 66452 84

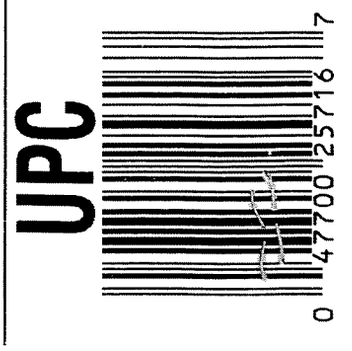
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6645284



BM FORM

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 # G6645284

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		7-17-07	L.P.D.
420	ASSEMBLE ACTION		6-19-07	L.P.D.
430	ASSEMBLE TO STOCK		6-21-07	TRW
440	PROOF	MAGNA-FLUX JUL 19 2007 OPERATOR	6-21-07	TRW
460	CHECK HEADSPACE		6-21-07	TRW
470	DIS-ASSEMBLE ACTION		7-18-07	L.P.D.
480	MAGNAFLUX BBL ACTION		7/19/07	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-19-07	CW
510	DRILL AND TAP SIGHT HOLES		7-17-07	SD
520	GOFF BLAST BBL / REC		7-19-07	LY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		7/23/07	TRW
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		7/24/07	
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7/24/07	
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7/24/07	
	D) OIL FIRING PIN ASSEMBLY		7-25-07	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8/24/07	

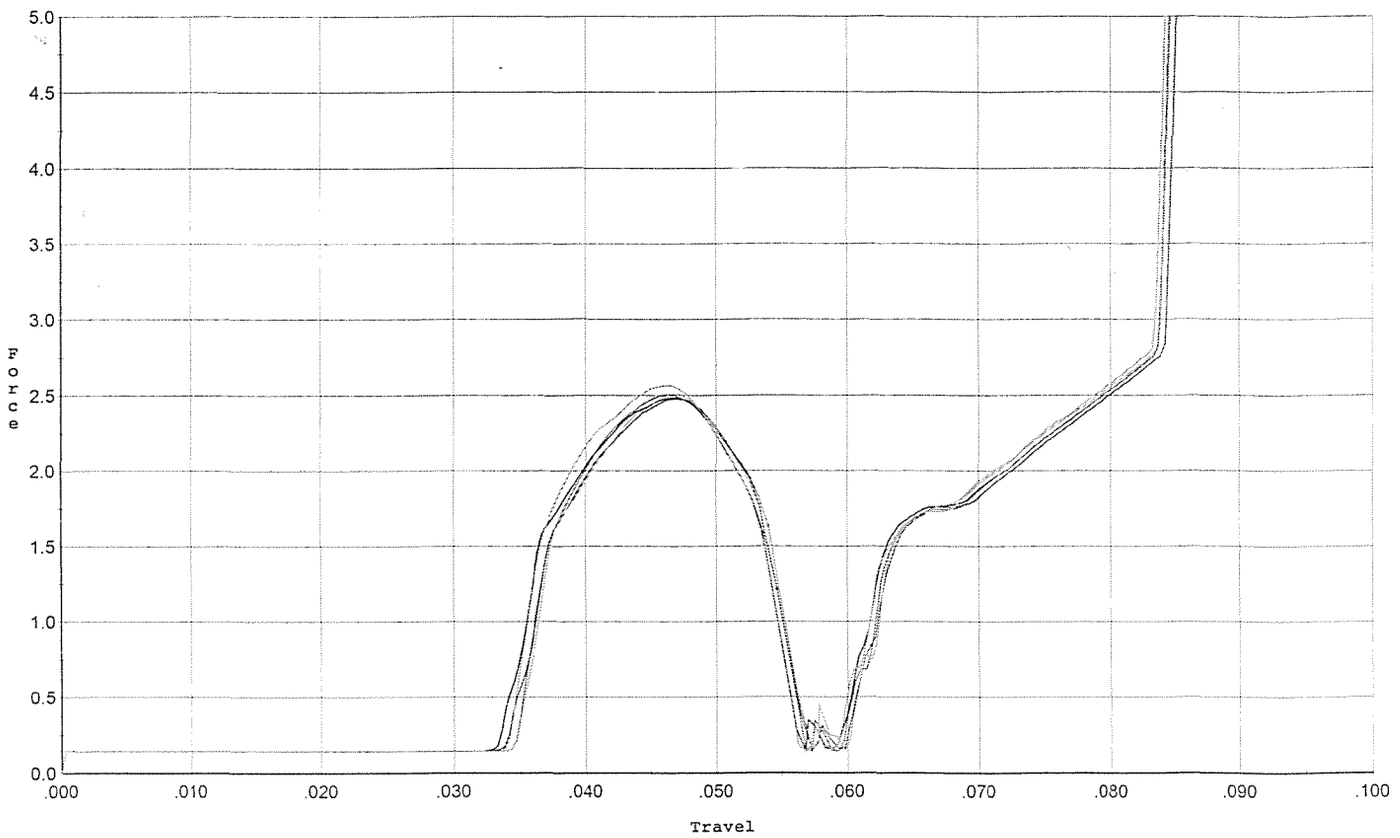
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	6.0 6.0 5.75	8/9/07	
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	5.0 5.25 4.75	8/9/07	
	H) TRIGGER PULL TEST AND RETAINABILITY		8/9/07	
	I) FIRING PIN INDENT (.020 MIN)	.024 .024 .025	8/9/07	
	J) ASSEMBLE STOCK		7-24-07	
	K) ASSEMBLE SWIVEL STUDS		8/9/07	
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8/24/07	
	M) IRON SIGHT ALIGNMENT		8/24/07	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8/24/07	
640 &	FUNCTION TEST AND	(PASS) FAIL		
650	TARGET	(PASS) FAIL	7/31/07	
	MALFUNCTION OH	CORRECTION OK	8/9/07	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-31-07	SD
670	FINAL INSPECTION A) HEADSPACE		8/9/07	
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	254 247 267 261 262	8/2/07	
	C) FUNCTION		8/9/07	
690	PACK		8-25-07	

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.+/ ~~lbs~~. .50 LBS
Note:	R. Putch 7/19/07		



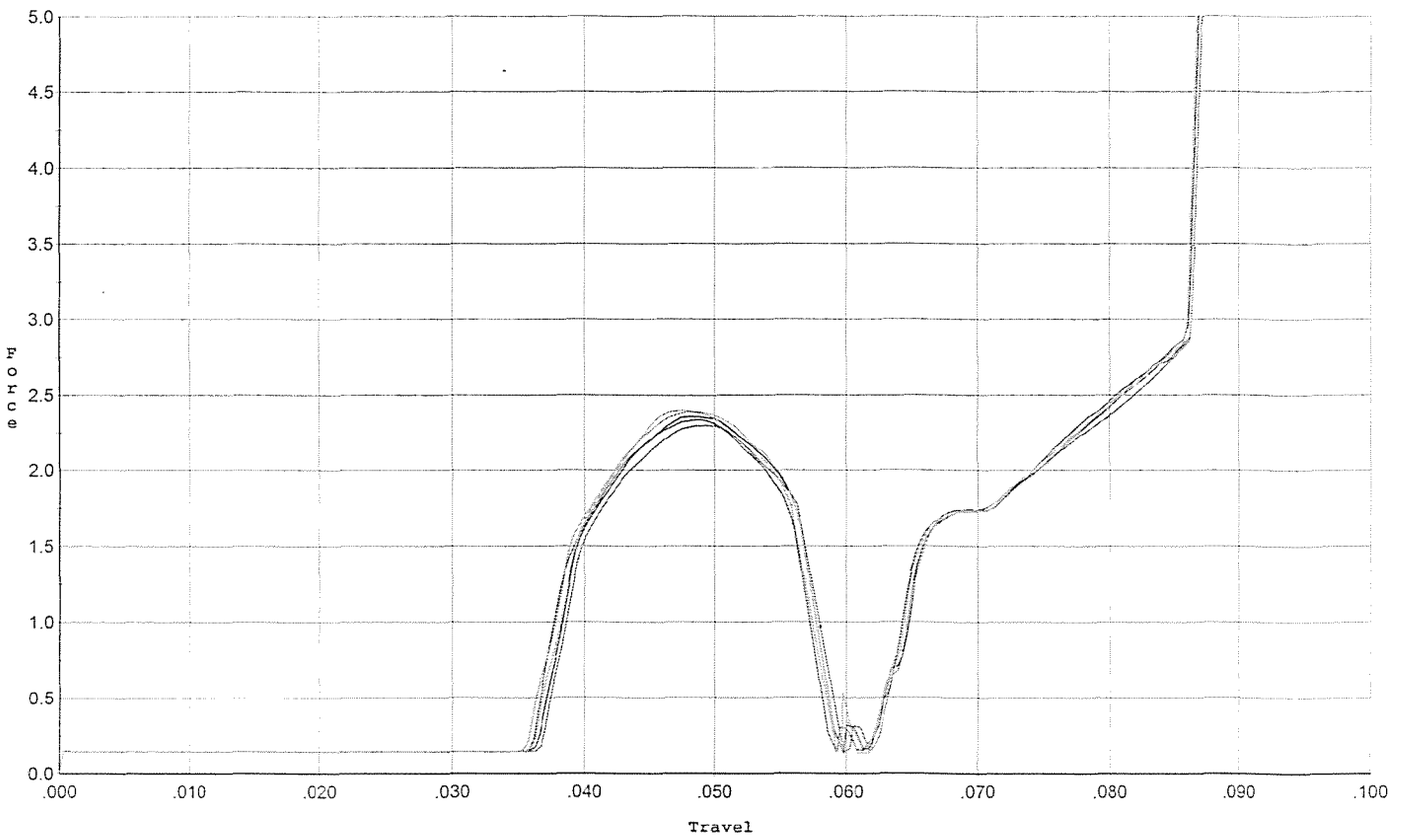
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.476	0.054	0.034	0.037	0.044		Set Trigger
2	2.484	0.054	0.034	0.036	0.044		Set Trigger
3	2.505	0.055	0.035	0.036	0.045		Set Trigger
4	2.509	0.054	0.035	0.036	0.044		Set Trigger
5	2.564	0.054	0.034	0.036	0.045		Set Trigger

Avg 2.50

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc. 7/19/2007 3:58:58 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cyycles
Note:	R. Putch 7/19/07		



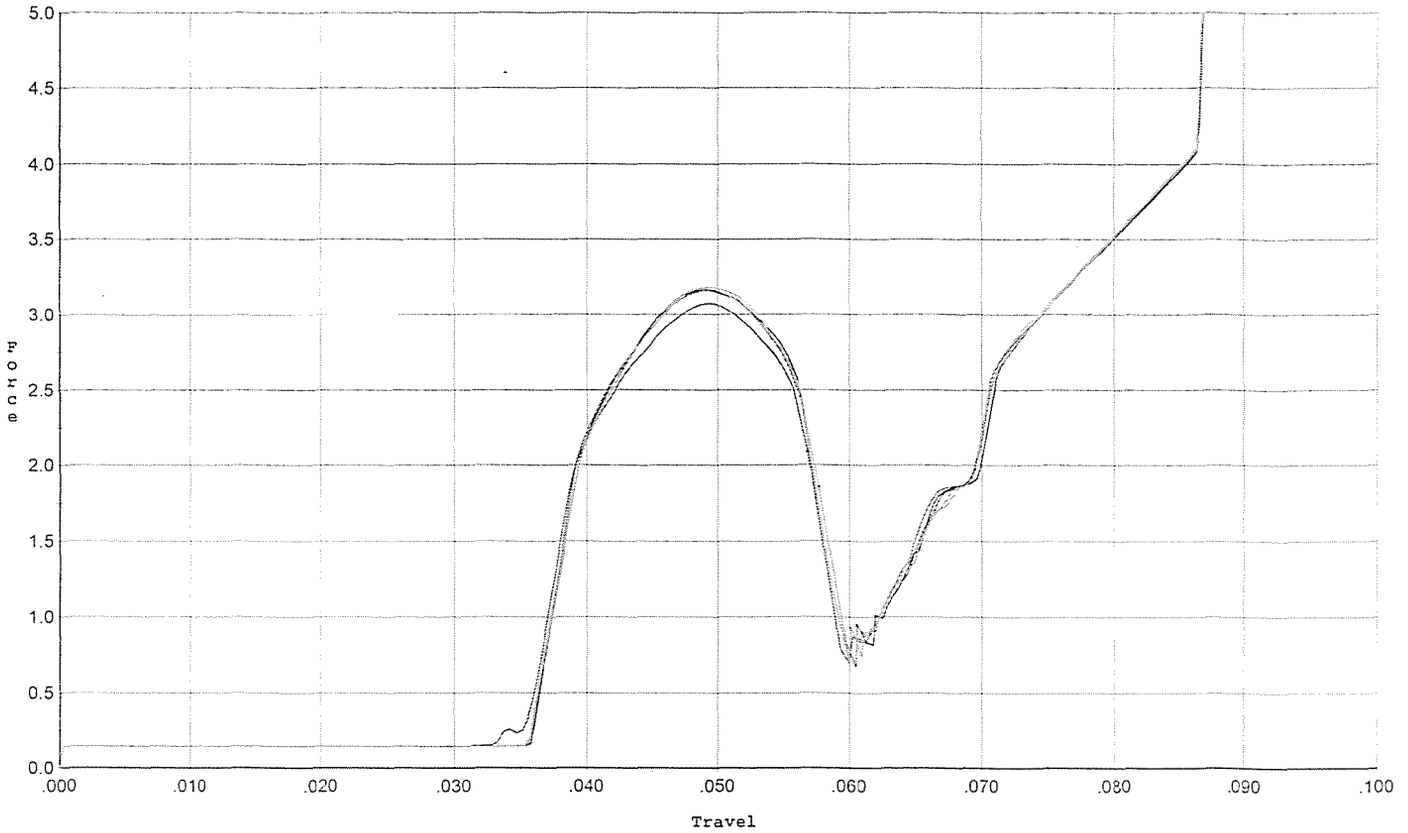
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.336	0.056	0.036	0.037	0.044		Set Trigger
2	2.357	0.056	0.037	0.037	0.044		Set Trigger
3	2.301	0.058	0.037	0.037	0.044		Set Trigger
4	2.396	0.056	0.036	0.037	0.045		Set Trigger
5	2.388	0.056	0.036	0.037	0.044		Set Trigger

Avg 2.35

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/19/2007 4:03:01 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 7/19/07		

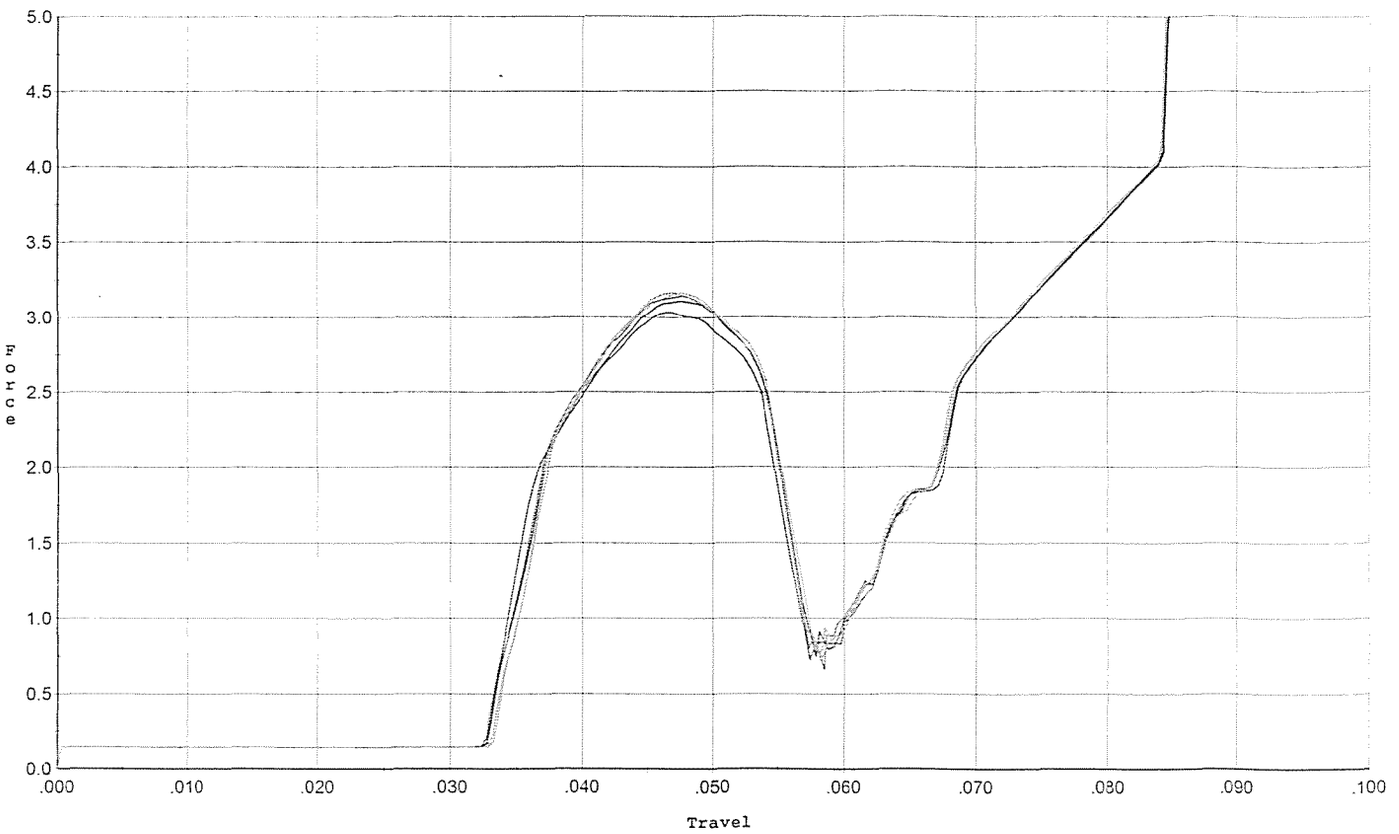


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.075	0.057	0.034	0.036	0.058		Set Trigger
2	3.164	0.058	0.036	0.036	0.060		Set Trigger
3	3.167	0.056	0.036	0.036	0.059		Set Trigger
4	3.182	0.058	0.036	0.036	0.061		Set Trigger
5	3.171	0.056	0.036	0.036	0.059		Set Trigger

Avg 3.15

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 7/19/07		



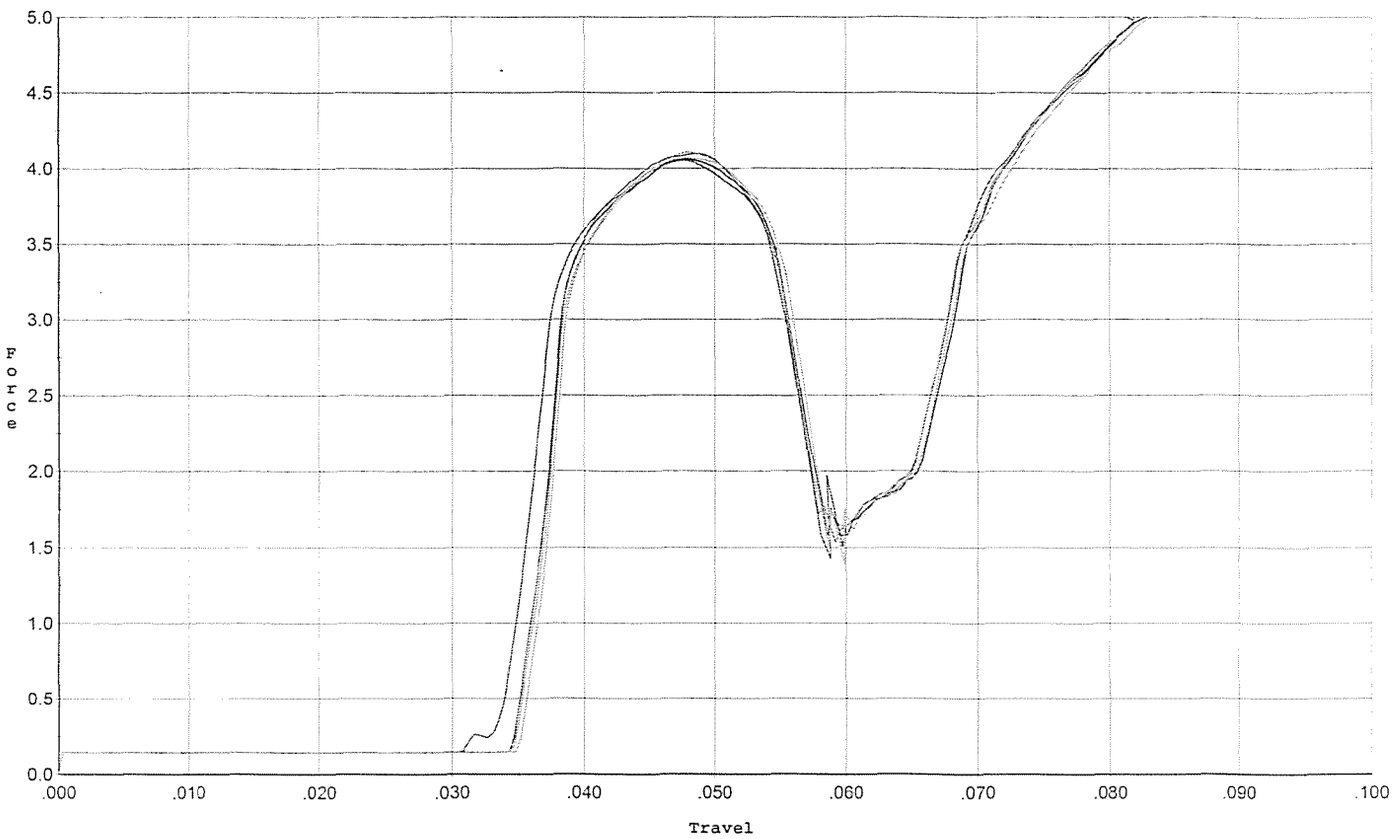
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.032	0.054	0.033	0.035	0.057		Set Trigger
2	3.104	0.054	0.033	0.035	0.058		Set Trigger
3	3.142	0.054	0.033	0.035	0.059		Set Trigger
4	3.162	0.054	0.034	0.035	0.058		Set Trigger
5	3.161	0.054	0.033	0.035	0.059		Set Trigger

AVG 3.12

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/19/2007 4:06:45 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 7/19/07		



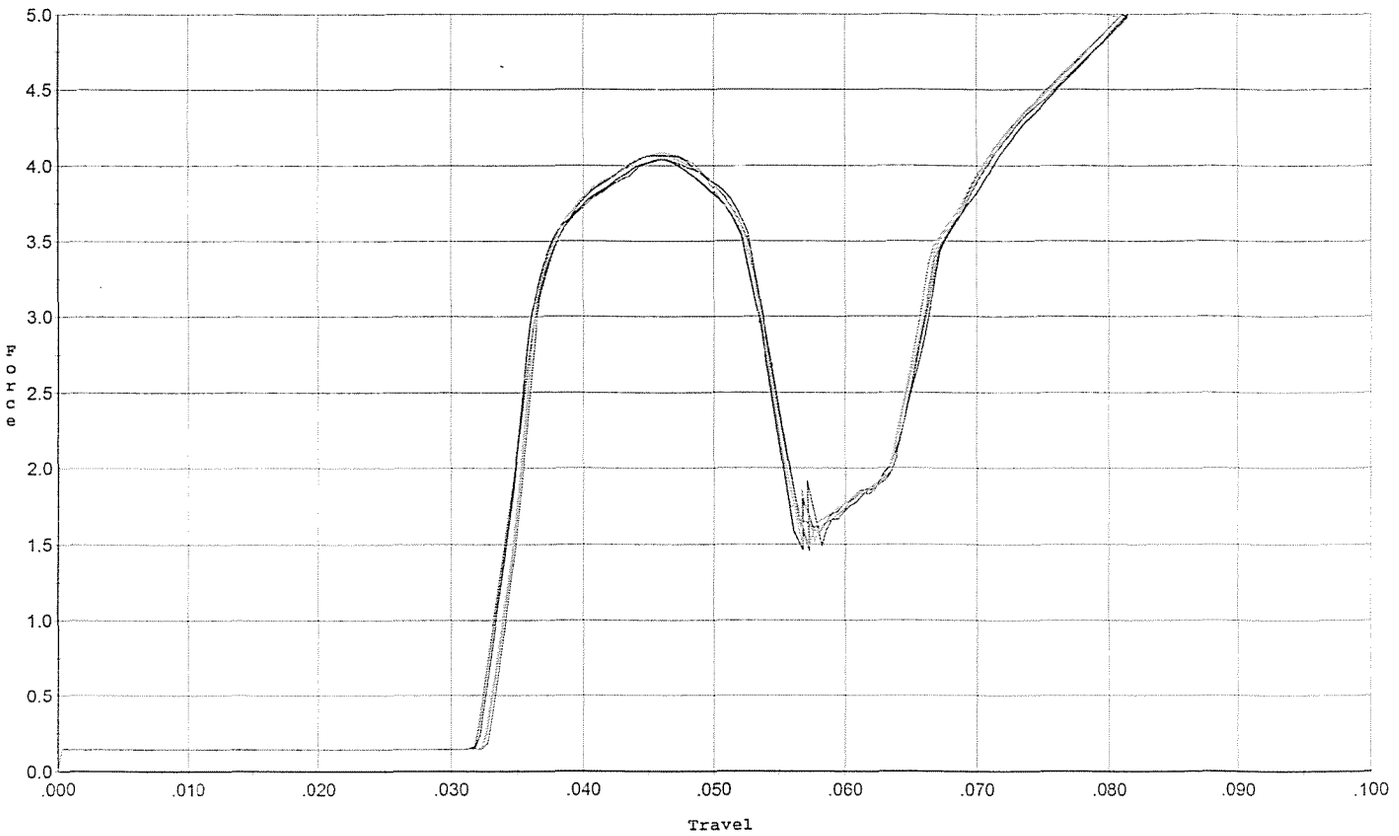
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.055	0.031	0.033	0.080		Set Trigger
2	4.062	0.055	0.035	0.034	0.076		Set Trigger
3	4.099	0.055	0.035	0.033	0.076		Set Trigger
4	4.103	0.055	0.035	0.033	0.077		Set Trigger
5	4.069	0.055	0.035	0.033	0.075		Set Trigger

Avg 4.07

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc. 7/19/2007 4:11:45 PM

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 7/19/07		

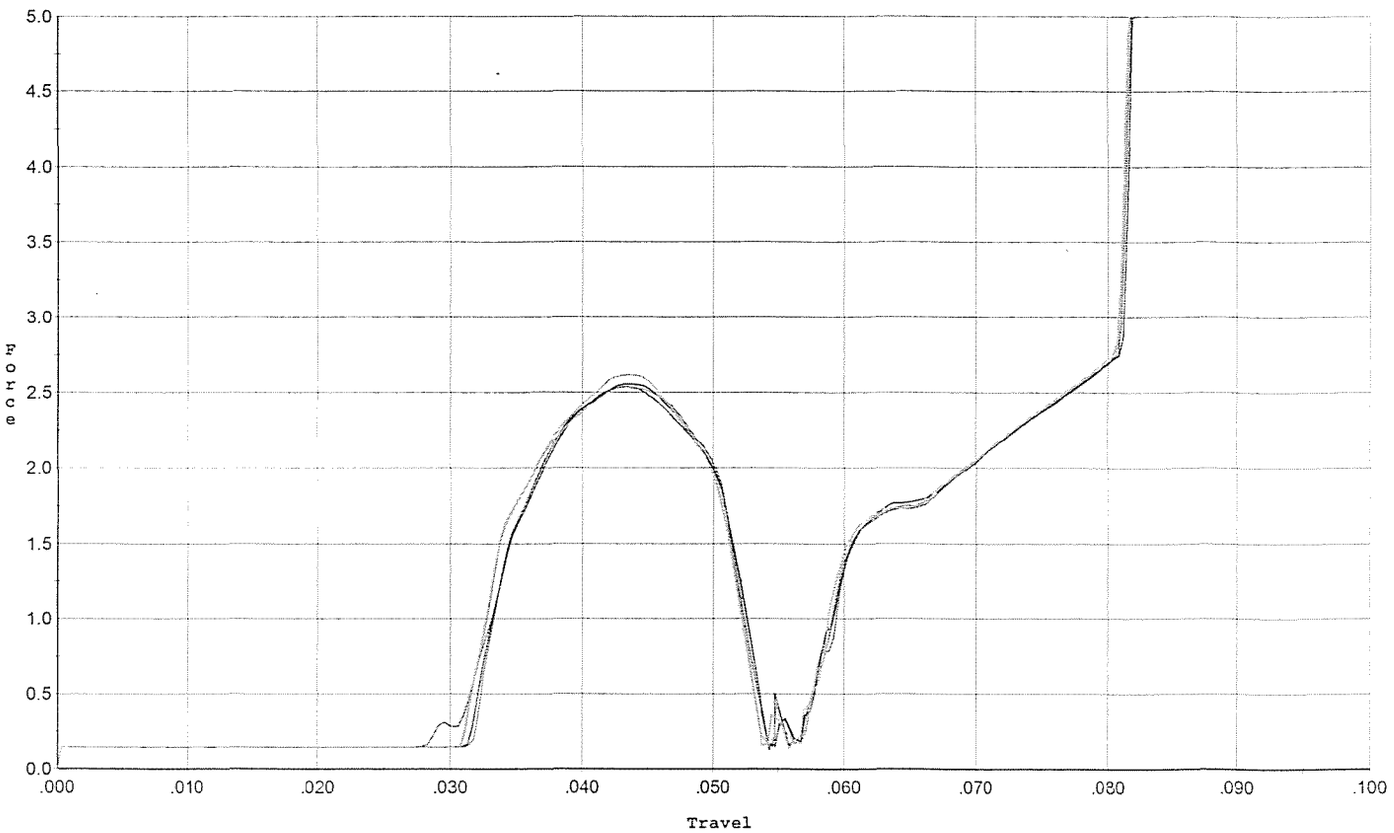


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.054	0.032	0.033	0.080		Set Trigger
2	4.042	0.053	0.032	0.033	0.077		Set Trigger
3	4.042	0.053	0.033	0.033	0.074		Set Trigger
4	4.084	0.053	0.033	0.033	0.076		Set Trigger
5	4.075	0.053	0.033	0.033	0.076		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs +/- .50 lbs. for final test
Note:	R. Putch 7/19/07		



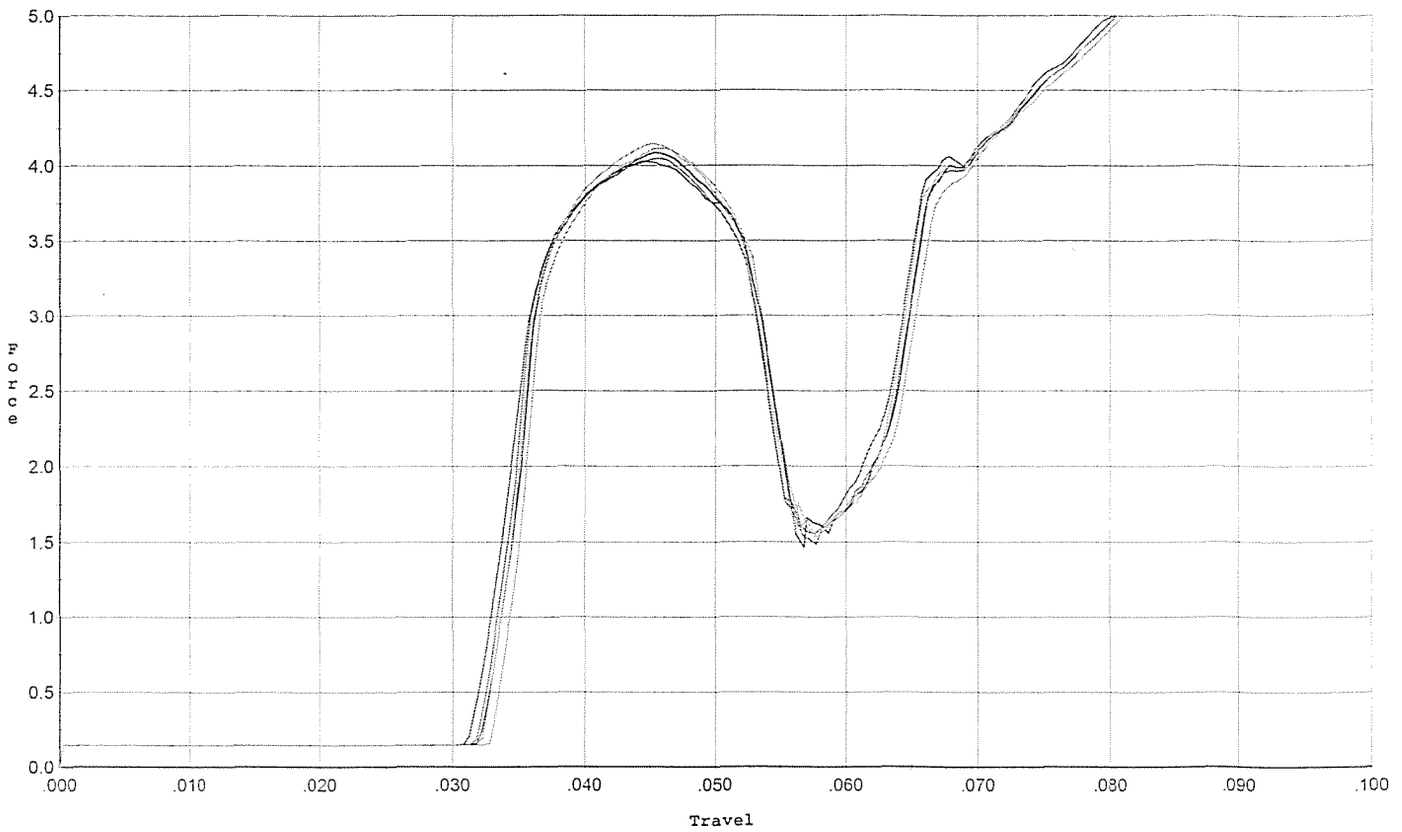
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.535	0.051	0.029	0.035	0.045		Set Trigger
2	2.557	0.052	0.032	0.035	0.046		Set Trigger
3	2.541	0.052	0.032	0.035	0.046		Set Trigger
4	2.535	0.051	0.031	0.035	0.045		Set Trigger
5	2.619	0.051	0.031	0.035	0.046		Set Trigger

Avg 2.55

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/19/2007 4:22:31 PM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 7/19/07		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.052	0.032	0.033	0.076		Set Trigger
2	4.086	0.053	0.032	0.033	0.077		Set Trigger
3	4.048	0.052	0.032	0.033	0.075		Set Trigger
4	4.145	0.052	0.032	0.033	0.075		Set Trigger
5	4.115	0.053	0.033	0.033	0.075		Set Trigger

Avg 4.08

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 7/19/2007 4:24:43 PM

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645284.__0
FILE DATE AND TIME: 07/31/2007 23:03

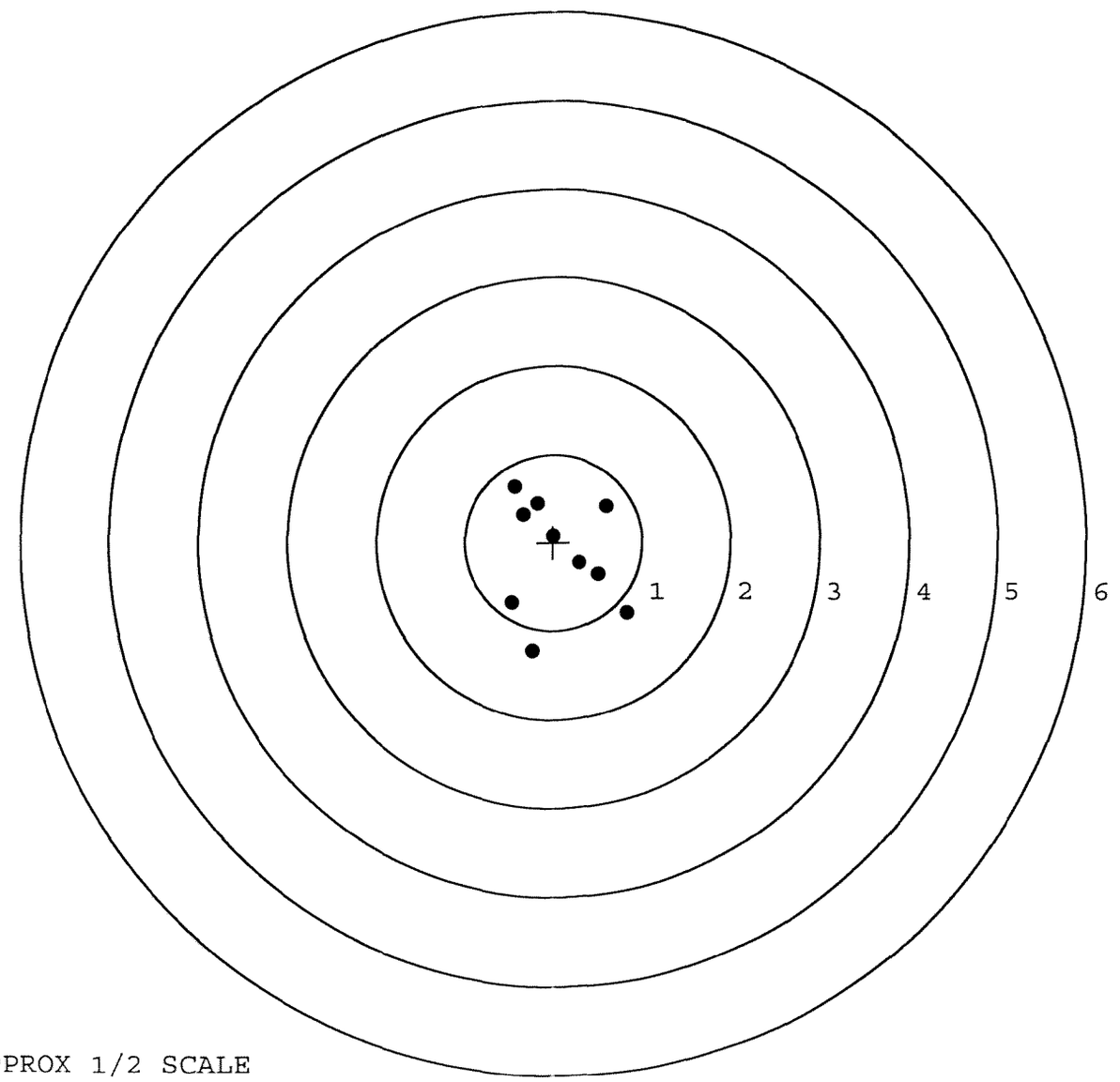
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	-0.121
The Average Point of Impact of the Five Target Set:	0.122
The Average Mean Radius of the Five Target Set:	0.576
The Distance from POA to Centroid Target #1:	0.156
The Distance from Centroid Target #2 to Centroid Target #1:	0.107
The Distance from Centroid Target #3 to Centroid Target #1:	0.121
The Distance from Centroid Target #4 to Centroid Target #1:	0.132
The Distance from Centroid Target #5 to Centroid Target #1:	0.031

SERIAL NUMBER: G6645284.__0
TARGET NUMBER: 1
FILE DATE: 07/31/2007
FILE TIME: 23:03

X CENTROID:	0.057
Y CENTROID:	-0.146
POA TO CENTROID:	0.156
HORZ SPREAD:	1.299
VERT SPREAD:	1.863
GROUP SPREAD:	1.874
MIN RADIUS:	0.222
MAX RADIUS:	1.121
MEAN RADIUS:	0.682
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.184	0.441
2:	-0.344	0.319
3:	-0.438	0.635
4:	0.003	0.070
5:	0.599	0.408
6:	0.296	-0.238
7:	0.510	-0.365
8:	0.830	-0.805
9:	-0.234	-1.228
10:	-0.469	-0.693

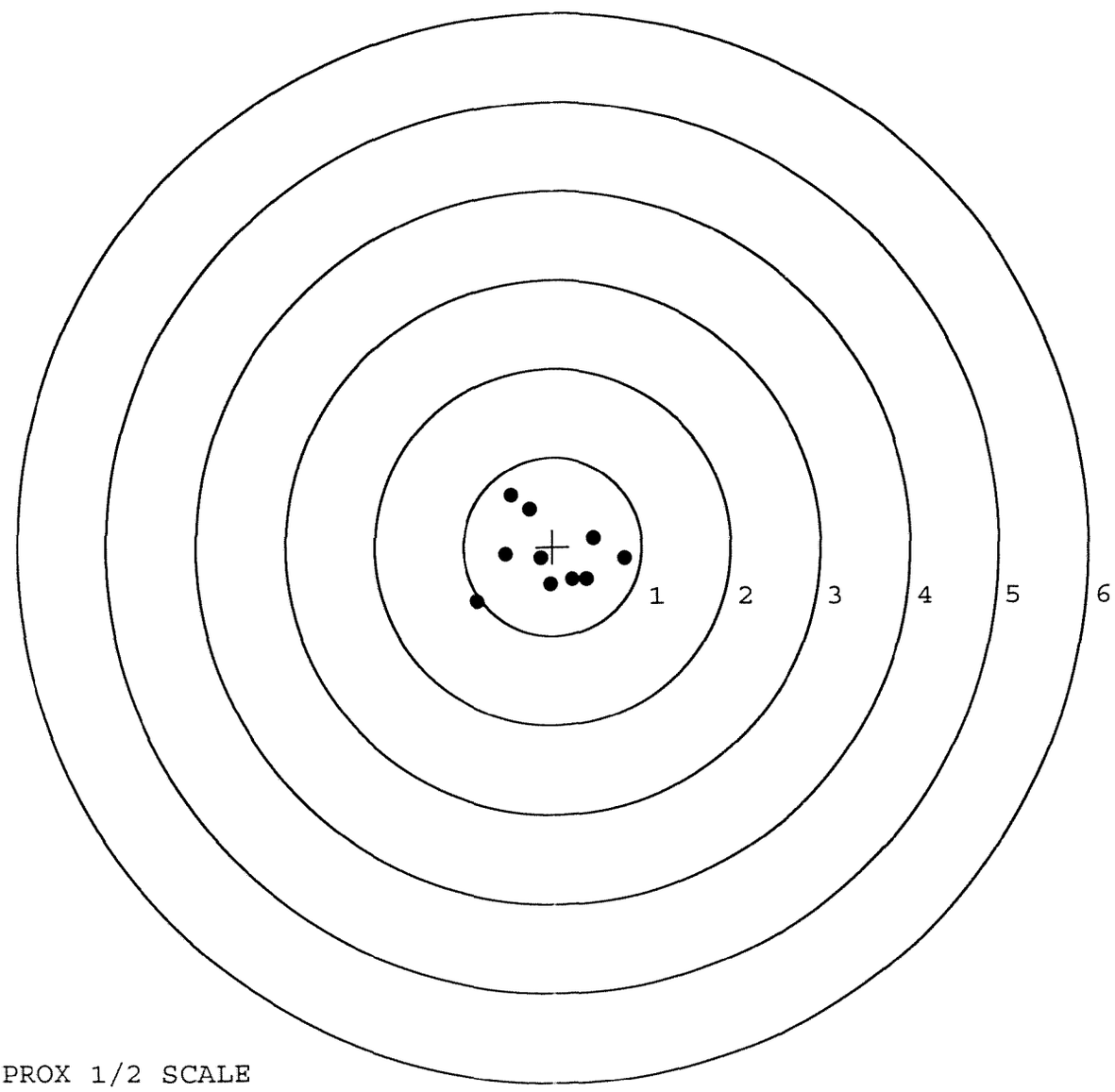


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645284.__0
TARGET NUMBER: 2
FILE DATE: 07/31/2007
FILE TIME: 23:03

X CENTROID:	-0.041
Y CENTROID:	-0.102
POA TO CENTROID:	0.110
HORZ SPREAD:	1.660
VERT SPREAD:	1.189
GROUP SPREAD:	1.729
MIN RADIUS:	0.100
MAX RADIUS:	0.955
MEAN RADIUS:	0.549
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.473	0.575
2:	-0.266	0.415
3:	-0.533	-0.084
4:	-0.847	-0.614
5:	-0.137	-0.130
6:	-0.031	-0.422
7:	0.380	-0.365
8:	0.225	-0.364
9:	0.457	0.095
10:	0.813	-0.129

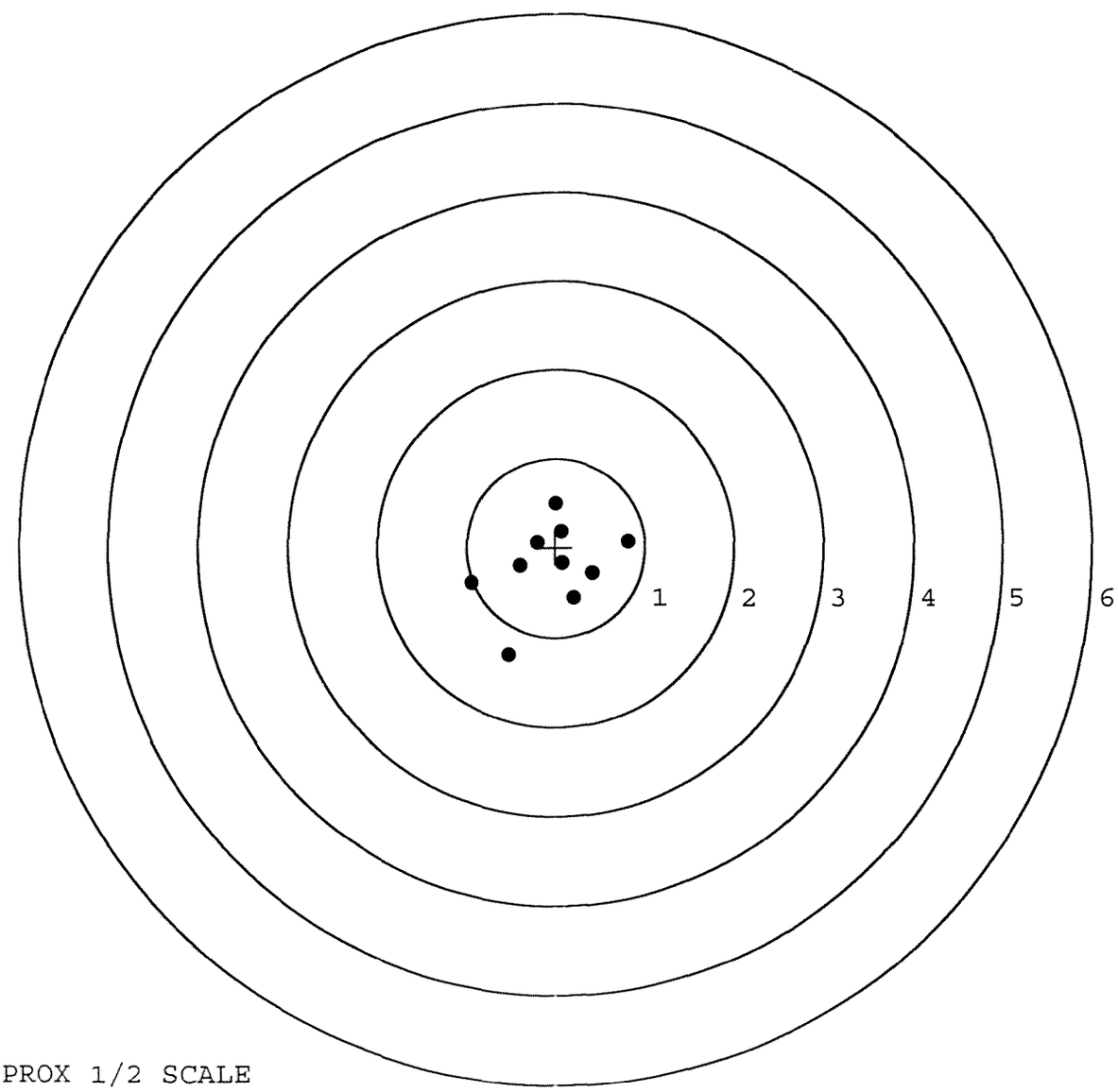


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645284.__0
TARGET NUMBER: 3
FILE DATE: 07/31/2007
FILE TIME: 23:03

X CENTROID:	-0.049
Y CENTROID:	-0.203
POA TO CENTROID:	0.209
HORZ SPREAD:	1.750
VERT SPREAD:	1.685
GROUP SPREAD:	1.840
MIN RADIUS:	0.131
MAX RADIUS:	1.102
MEAN RADIUS:	0.570
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.808	0.071
2:	0.418	-0.285
3:	0.203	-0.562
4:	-0.398	-0.206
5:	-0.942	-0.395
6:	-0.525	-1.197
7:	0.079	-0.178
8:	-0.200	0.057
9:	0.067	0.175
10:	-0.002	0.488

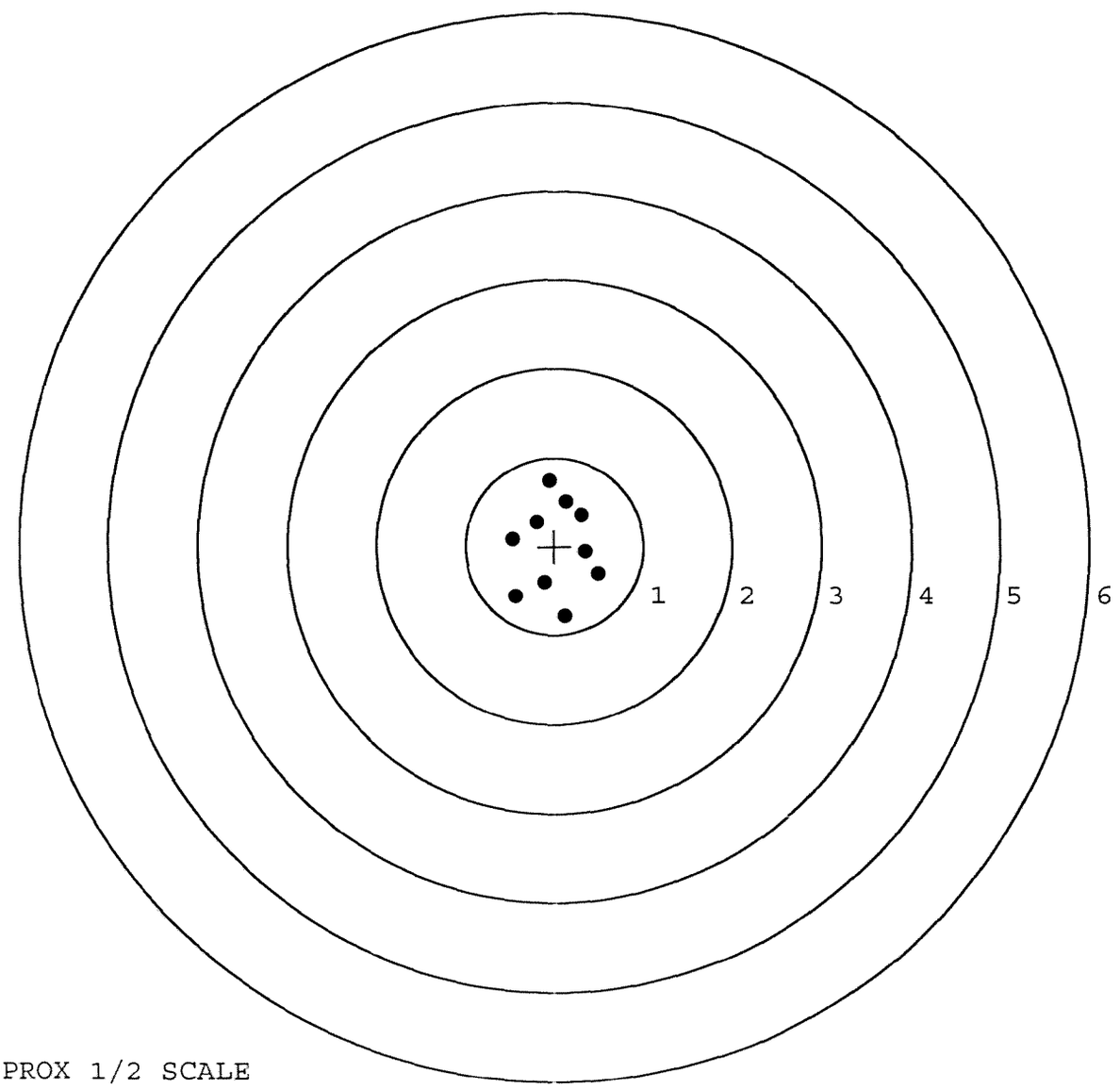


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645284.__0
TARGET NUMBER: 4
FILE DATE: 07/31/2007
FILE TIME: 23:03

X CENTROID:	0.012
Y CENTROID:	-0.021
POA TO CENTROID:	0.024
HORZ SPREAD:	0.967
VERT SPREAD:	1.539
GROUP SPREAD:	1.550
MIN RADIUS:	0.337
MAX RADIUS:	0.786
MEAN RADIUS:	0.545
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.469	0.081
2:	-0.204	0.269
3:	-0.440	-0.573
4:	-0.112	-0.415
5:	0.126	-0.799
6:	0.498	-0.310
7:	0.347	-0.061
8:	0.301	0.352
9:	0.132	0.506
10:	-0.057	0.740

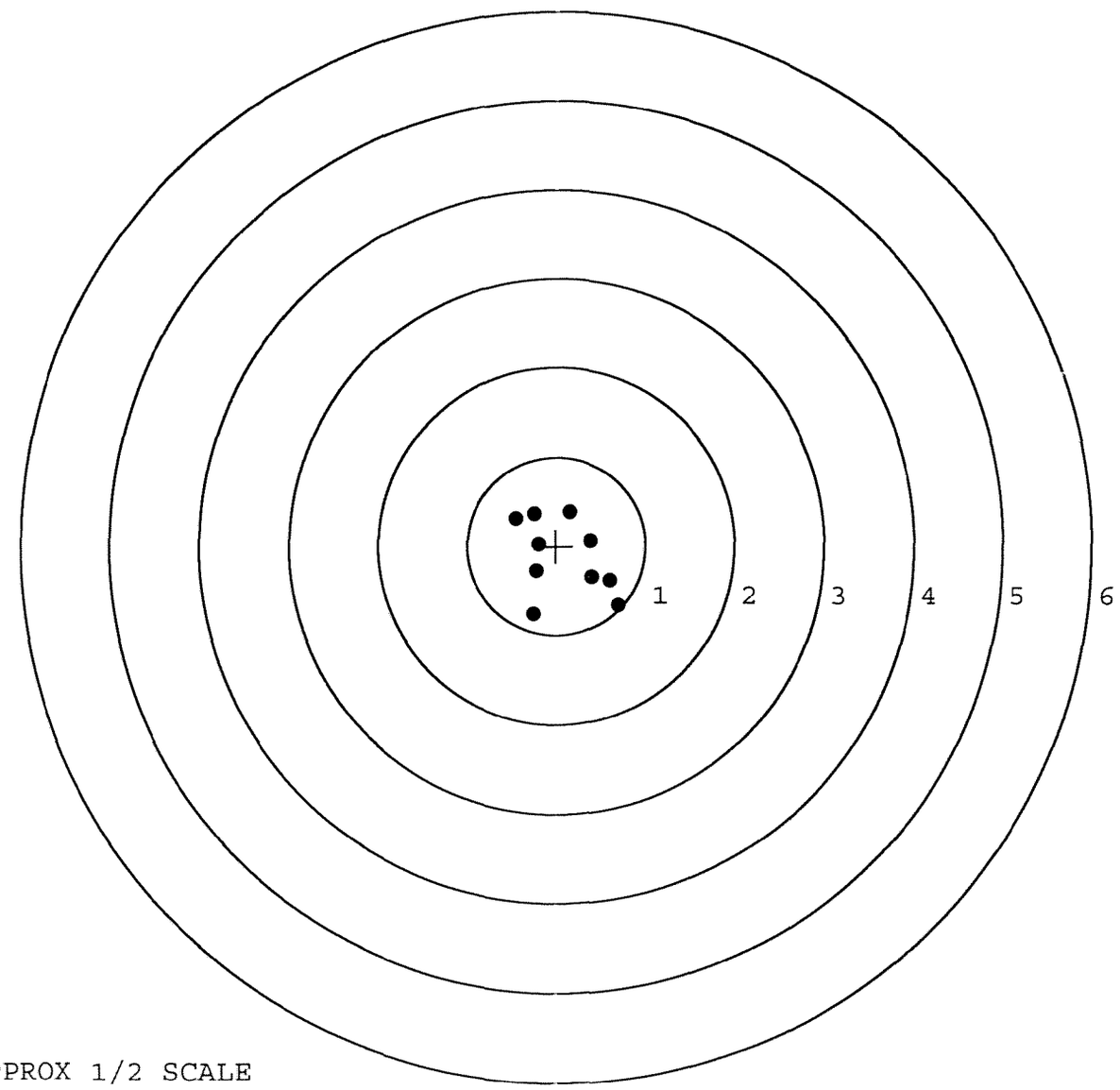


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645284.__0
TARGET NUMBER: 5
FILE DATE: 07/31/2007
FILE TIME: 23:03

X CENTROID:	0.086
Y CENTROID:	-0.133
POA TO CENTROID:	0.158
HORZ SPREAD:	1.151
VERT SPREAD:	1.154
GROUP SPREAD:	1.512
MIN RADIUS:	0.322
MAX RADIUS:	0.814
MEAN RADIUS:	0.534
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.455	0.308
2:	-0.252	0.364
3:	-0.195	0.025
4:	-0.223	-0.281
5:	-0.255	-0.772
6:	0.401	-0.350
7:	0.606	-0.393
8:	0.696	-0.672
9:	0.381	0.060
10:	0.152	0.382



TARGET APPROX 1/2 SCALE