

G6669 3274

**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL WITH MARS RAIL
COMPLETE SYSTEM - LE/EXPORT**

98606 - M-24 OPERATORS MANUAL
98229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB
96082 SCOPE RING ASSEMBLY
400061 SCOPE RING ASSEMBLY 306-09

BM FORM 1692

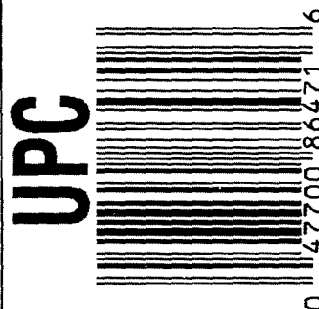


ORDER NO. 86471

BARREL LENGTH 24"

CAPACITY 6

G6693274



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C669 3274

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		12-5-07	RTZ
420	ASSEMBLE ACTION		12-5-07	RTZ
430	ASSEMBLE TO STOCK		12-5-07	RTZ
440	PROOF		12-6-07	TRW
460	CHECK HEADSPACE		12-6-07	TRW
470	DIS-ASSEMBLE ACTION		12-6-07	RTZ
480	MAGNAFLUX BBL ACTION		12-10-07	JB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		12-7-07	CW
510	DRILL AND TAP SIGHT HOLES		12-7-07	FM
520	GOFF BLAST BBL / REC		12-11-07	BY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/14/07	JB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-19-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-19-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-19-07	DA
	D) OIL FIRING PIN ASSEMBLY		12-20-07	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	1/5/08	mm
F004 REV 5/2006				

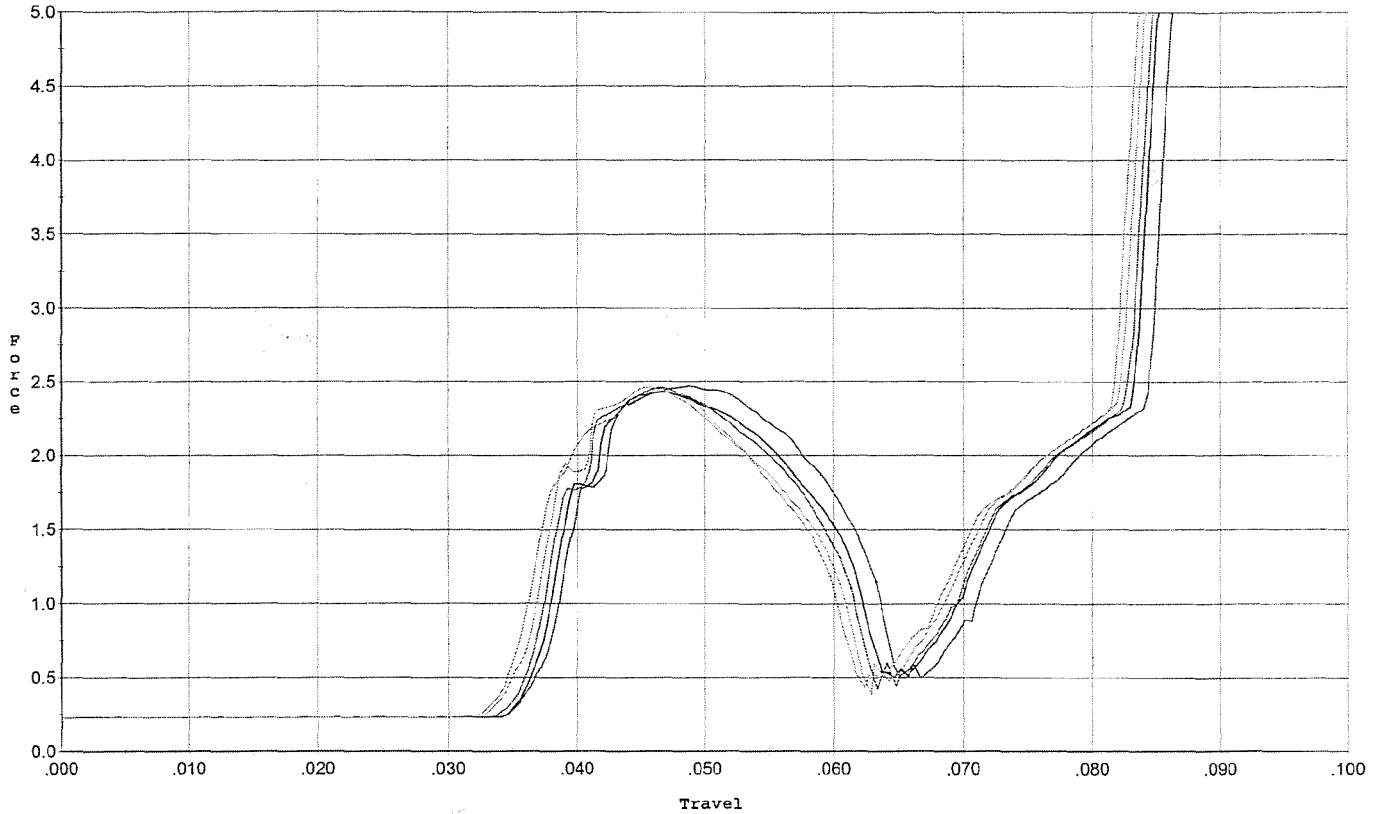
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>5.75</u>	<u>1/4/08</u>	<u>mm</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.25</u> <u>4.0</u>	<u>1/4/08</u>	<u>mm</u>
	H) TRIGGER PULL TEST AND RETAINABILITY		<u>1/8/08</u>	<u>mm</u>
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	<u>1/4/08</u>	<u>mm</u>
	J) ASSEMBLE STOCK		<u>12-20-07</u>	<u>FTZ</u>
	K) ASSEMBLE SWIVEL STUDS		<u>1/8/08</u>	<u>mm</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>1/8/08</u>	<u>mm</u>
	M) IRON SIGHT ALIGNMENT		<u>1/8/08</u>	<u>mm</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>1/8/08</u>	<u>mm</u>
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	<u>1/3/08</u>	<u>mm</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>1-3-08</u>	<u>SD</u>
670	FINAL INSPECTION A) HEADSPACE		<u>1/8/08</u>	<u>mm</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.58</u> <u>2.69</u> <u>2.73</u> <u>2.80</u>	<u>1/4/08</u>	<u>mm</u>
	C) FUNCTION		<u>1/8/08</u>	<u>mm</u>
690	PACK		<u>6/26/08</u>	<u>Fm</u>

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: M. McKinney 12/19/07

Model: M/24
 Serial No: Form #F005.
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



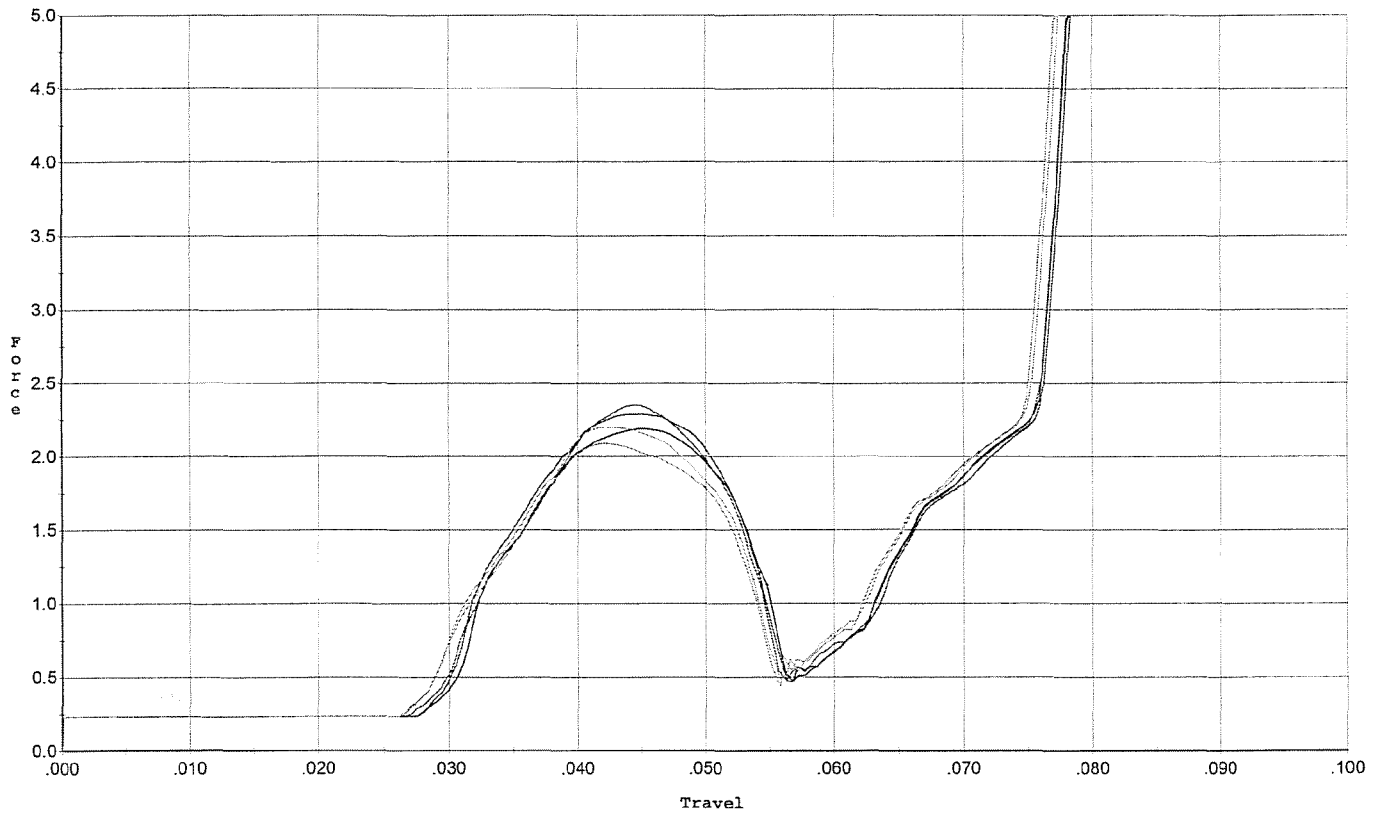
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.474	0.063	0.036	0.031	0.061		Set Trigger
2	2.431	0.062	0.036	0.031	0.058		Set Trigger
3	2.461	0.061	0.035	0.031	0.058		Set Trigger
4	2.466	0.061	0.035	0.031	0.057		Set Trigger
5	2.453	0.060	0.034	0.032	0.056		Set Trigger

2.46 Avg.

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

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



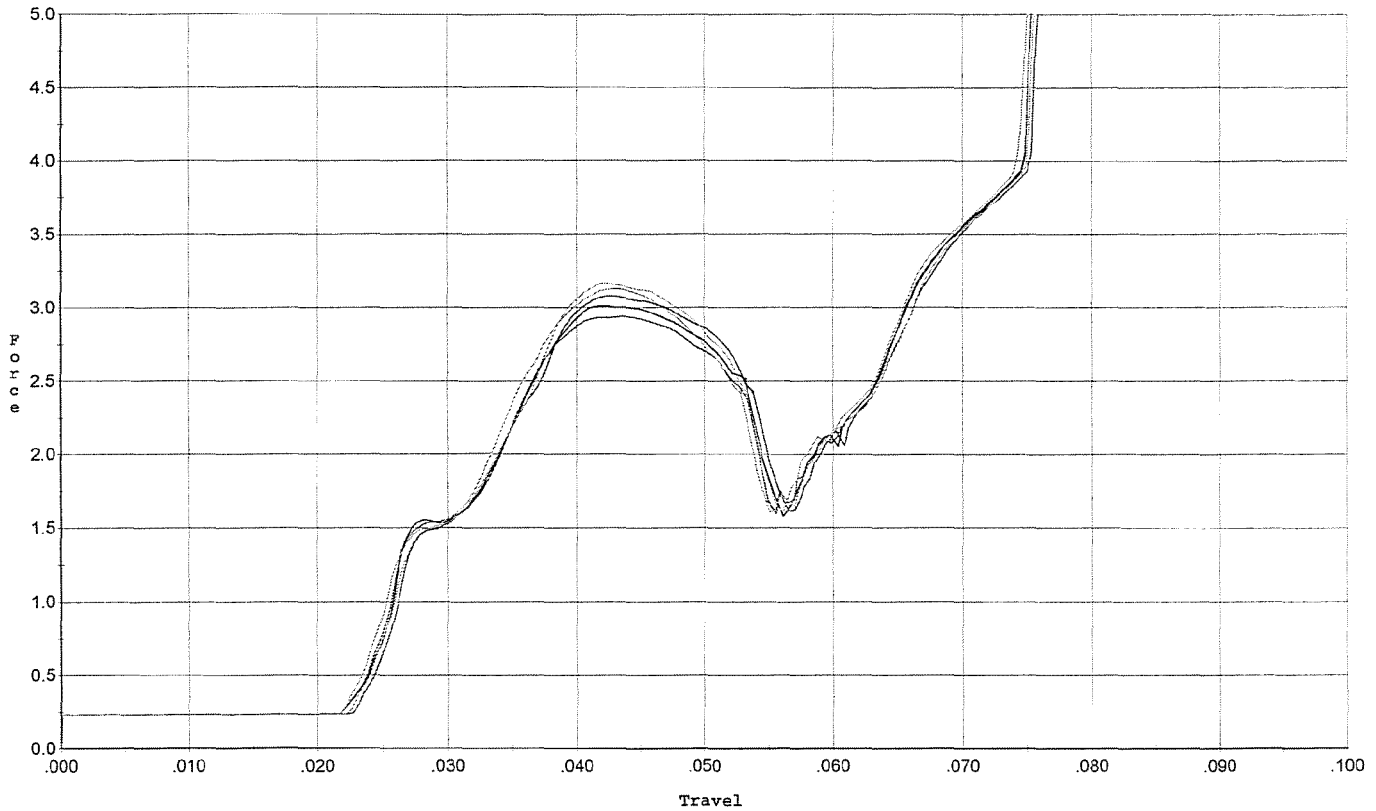
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.288	0.054	0.030	0.031	0.051		Set Trigger
2	2.190	0.055	0.031	0.031	0.049		Set Trigger
3	2.350	0.054	0.030	0.031	0.050		Set Trigger
4	2.199	0.054	0.029	0.031	0.049		Set Trigger
5	2.088	0.054	0.029	0.030	0.047		Set Trigger

2.22 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



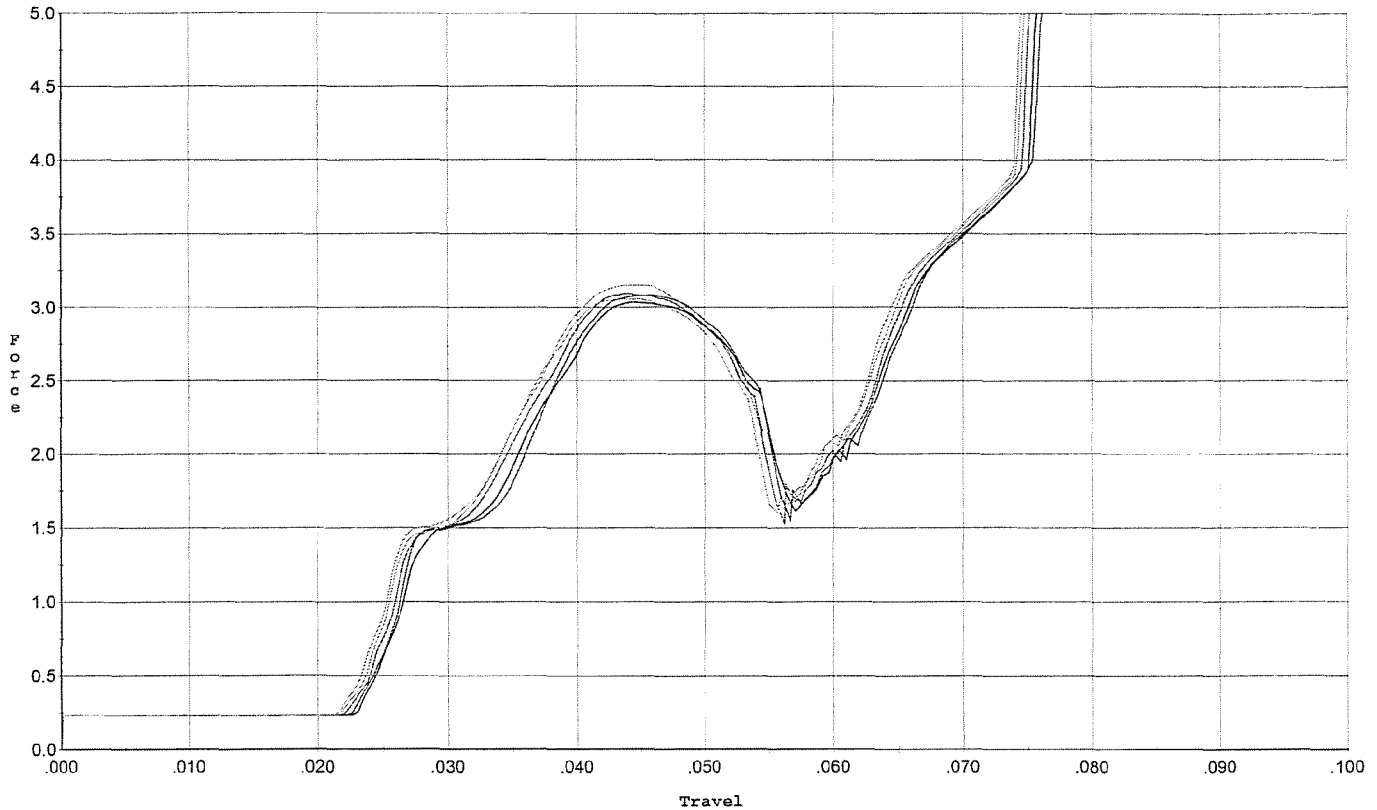
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.078	0.054	0.023	0.027	0.075		Set Trigger
2	3.010	0.053	0.023	0.026	0.073		Set Trigger
3	2.939	0.053	0.022	0.026	0.073		Set Trigger
4	3.166	0.053	0.023	0.027	0.075		Set Trigger
5	3.127	0.053	0.022	0.026	0.074		Set Trigger

3.06 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles. +/- .75 lbs.



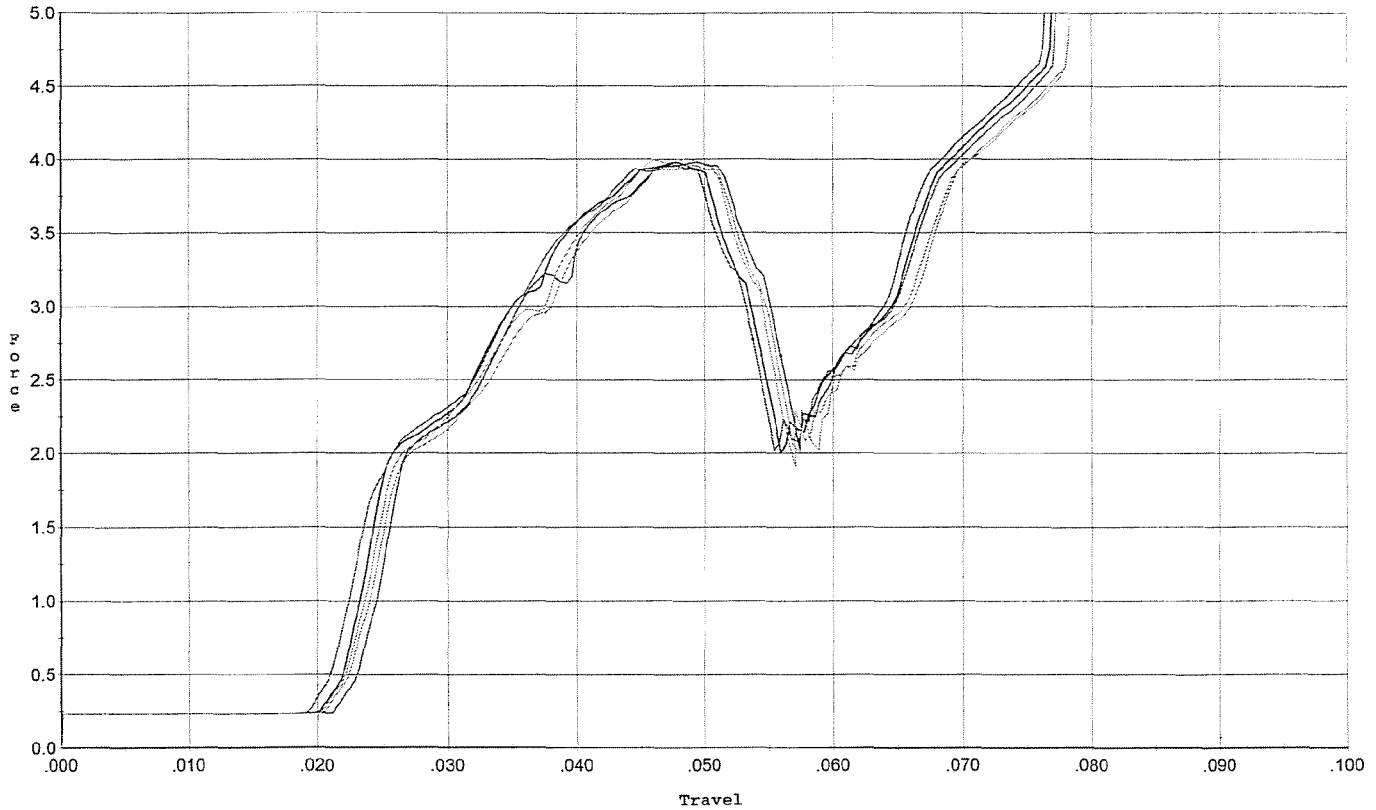
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.054	0.023	0.026	0.074		Set Trigger
2	3.034	0.054	0.023	0.026	0.073		Set Trigger
3	3.093	0.054	0.023	0.026	0.074		Set Trigger
4	3.058	0.053	0.022	0.026	0.074		Set Trigger
5	3.149	0.054	0.024	0.025	0.076		Set Trigger

3.08 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



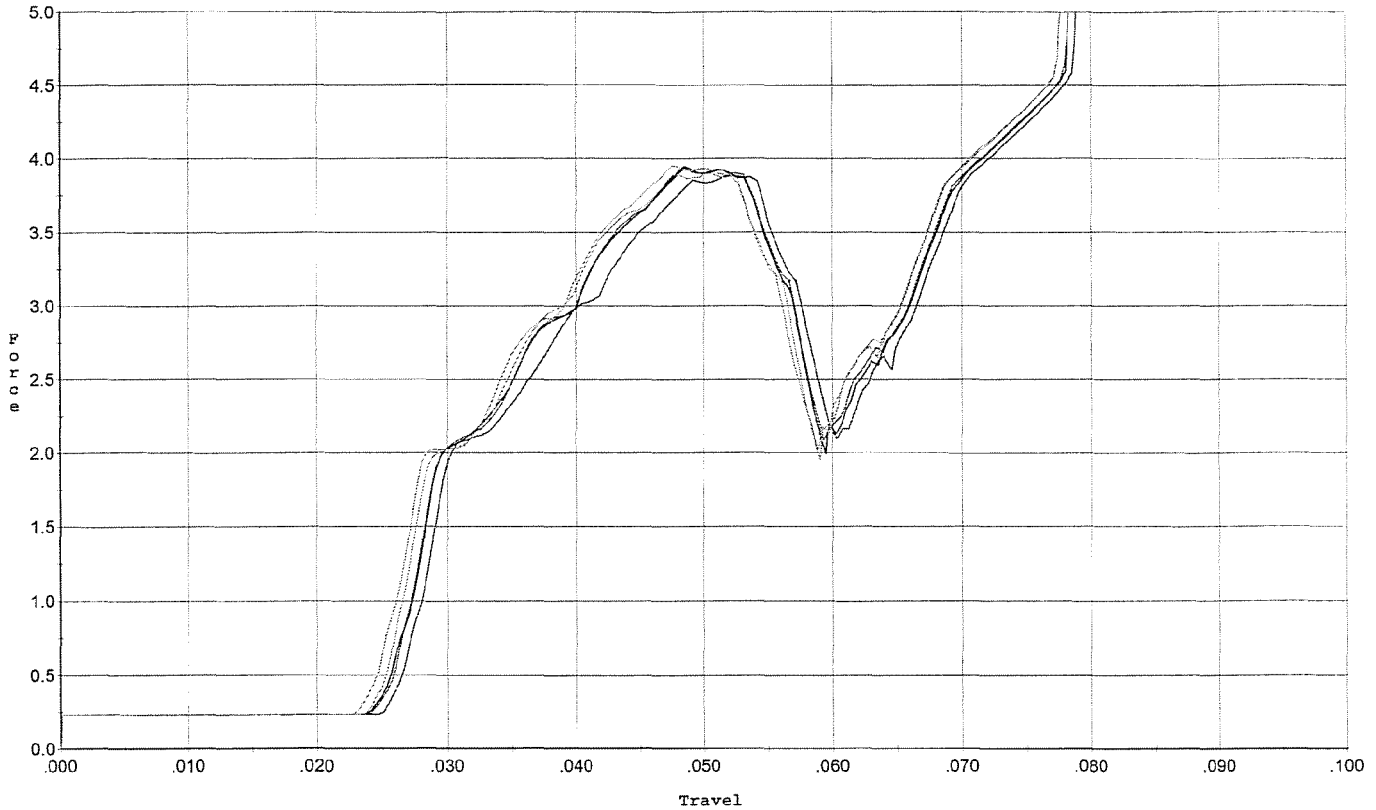
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.982	0.056	0.022	0.025	0.103		Set Trigger
2	3.977	0.054	0.021	0.026	0.101		Set Trigger
3	3.967	0.054	0.020	0.026	0.100		Set Trigger
4	4.003	0.054	0.021	0.026	0.100		Set Trigger
5	3.960	0.055	0.021	0.026	0.100		Set Trigger

3.98 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



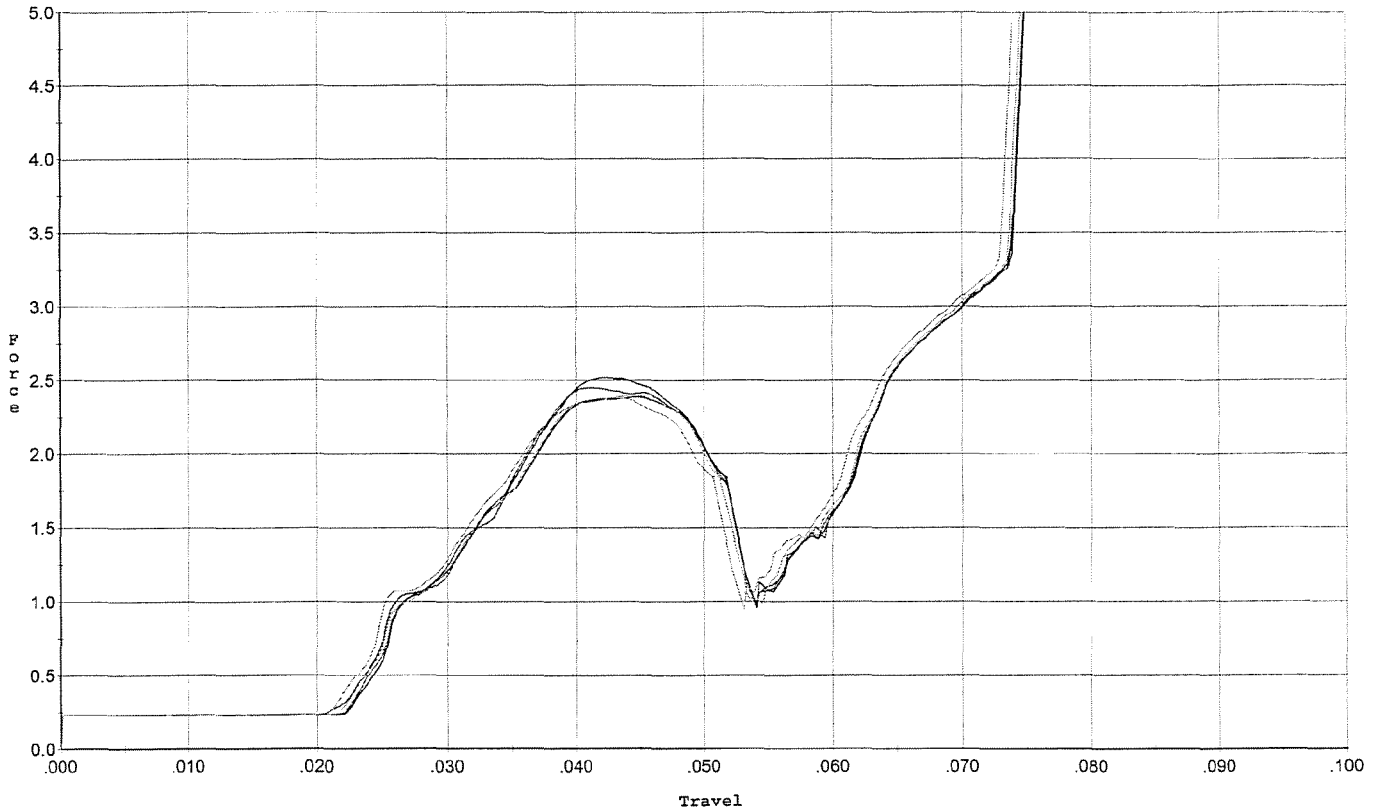
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.885	0.057	0.026	0.026	0.096		Set Trigger
2	3.947	0.057	0.025	0.026	0.098		Set Trigger
3	3.936	0.057	0.025	0.026	0.098		Set Trigger
4	3.900	0.056	0.024	0.026	0.097		Set Trigger
5	3.953	0.056	0.024	0.026	0.097		Set Trigger

3.92 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



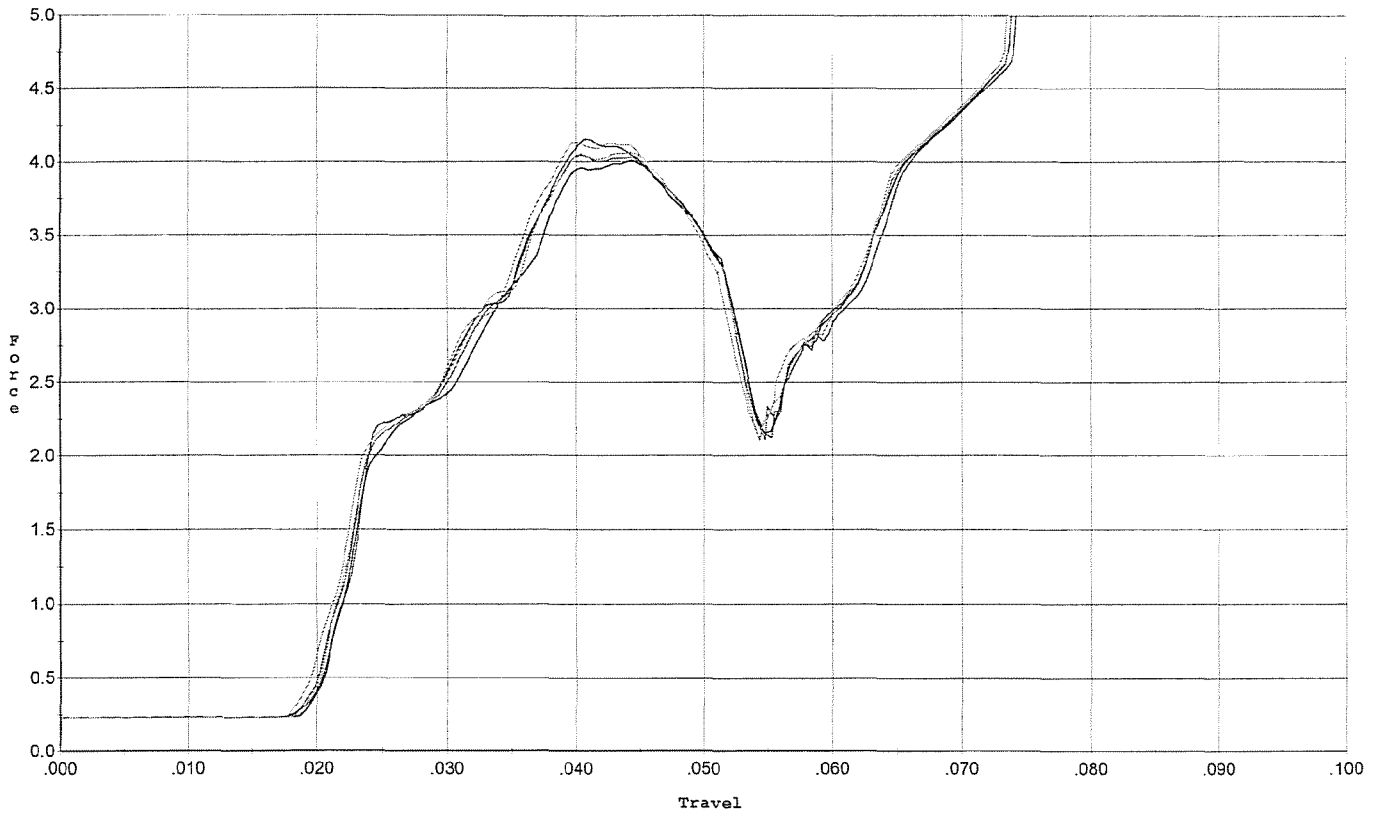
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.052	0.023	0.029	0.058		Set Trigger
2	2.385	0.052	0.023	0.029	0.056		Set Trigger
3	2.447	0.052	0.023	0.028	0.057		Set Trigger
4	2.397	0.051	0.022	0.029	0.055		Set Trigger
5	2.378	0.051	0.022	0.029	0.055		Set Trigger

2.43 Avg.

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: M. McKinney 12/19/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.053	0.020	0.024	0.102		Set Trigger
2	4.008	0.053	0.019	0.024	0.100		Set Trigger
3	4.051	0.052	0.019	0.024	0.099		Set Trigger
4	4.132	0.051	0.019	0.024	0.100		Set Trigger
5	4.062	0.052	0.019	0.024	0.100		Set Trigger

4.08 Avg.

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6693274.__0

FILE DATE AND TIME: 01/04/2008 06:52

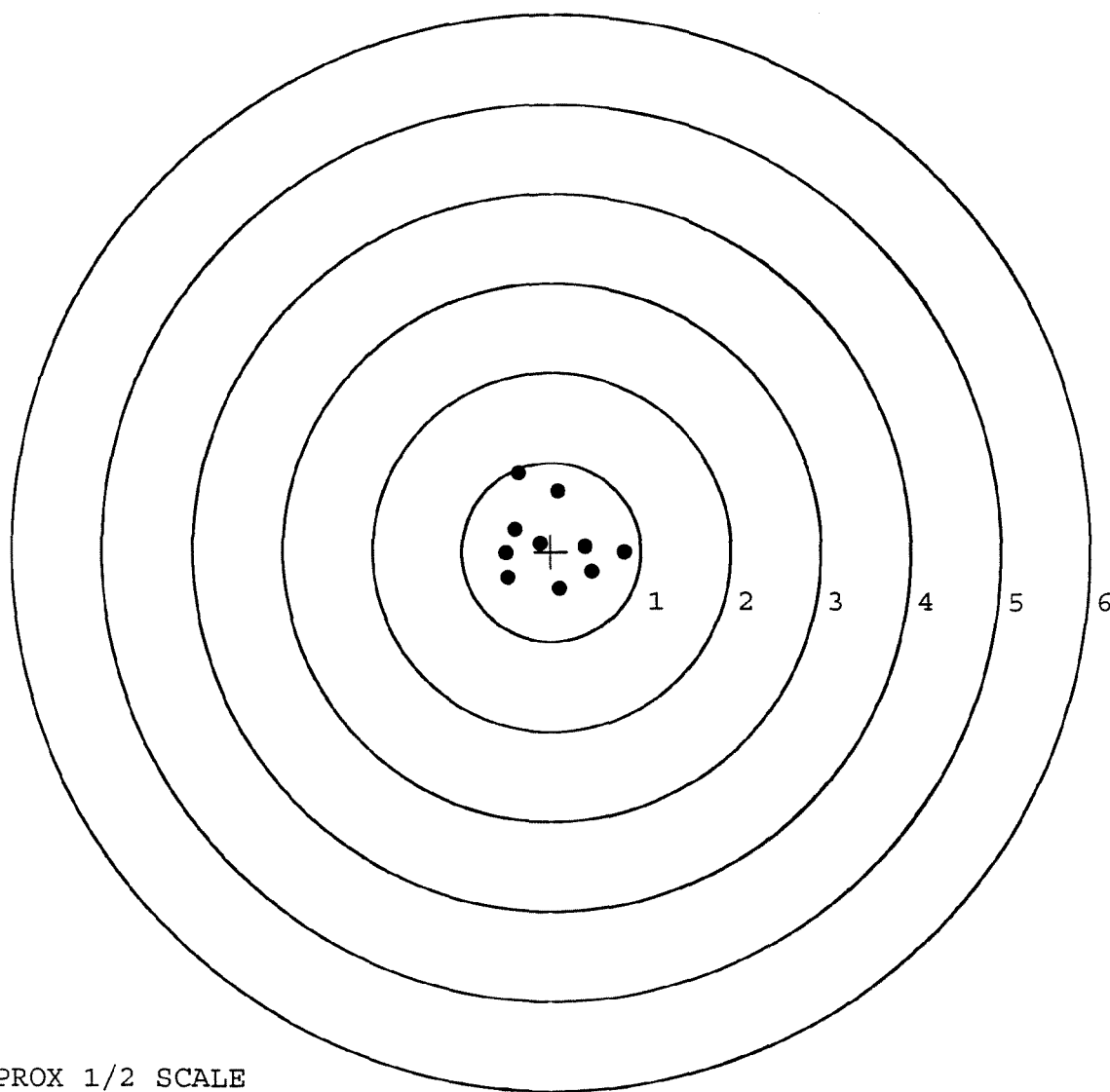
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.028
The Average Y Centroid of the Five Target Set:	-0.055
The Average Point of Impact of the Five Target Set:	0.061
The Average Mean Radius of the Five Target Set:	0.731
The Distance from POA to Centroid Target #1:	0.096
The Distance from Centroid Target #2 to Centroid Target #1:	0.358
The Distance from Centroid Target #3 to Centroid Target #1:	0.181
The Distance from Centroid Target #4 to Centroid Target #1:	0.135
The Distance from Centroid Target #5 to Centroid Target #1:	0.309

SERIAL NUMBER: G6693274. __0
TARGET NUMBER: 1
FILE DATE: 01/04/2008
FILE TIME: 06:52

POINT#	X	Y
1:	0.818	-0.004
2:	0.383	0.056
3:	0.456	-0.233
4:	0.099	-0.414
5:	-0.486	-0.299
6:	-0.505	-0.024
7:	-0.411	0.241
8:	-0.366	0.876
9:	0.080	0.674
10:	-0.121	0.088

X CENTROID: -0.005
Y CENTROID: 0.096
POA TO CENTROID: 0.096
HORZ SPREAD: 1.323
VERT SPREAD: 1.290
GROUP SPREAD: 1.475
MIN RADIUS: 0.116
MAX RADIUS: 0.859
MEAN RADIUS: 0.543
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



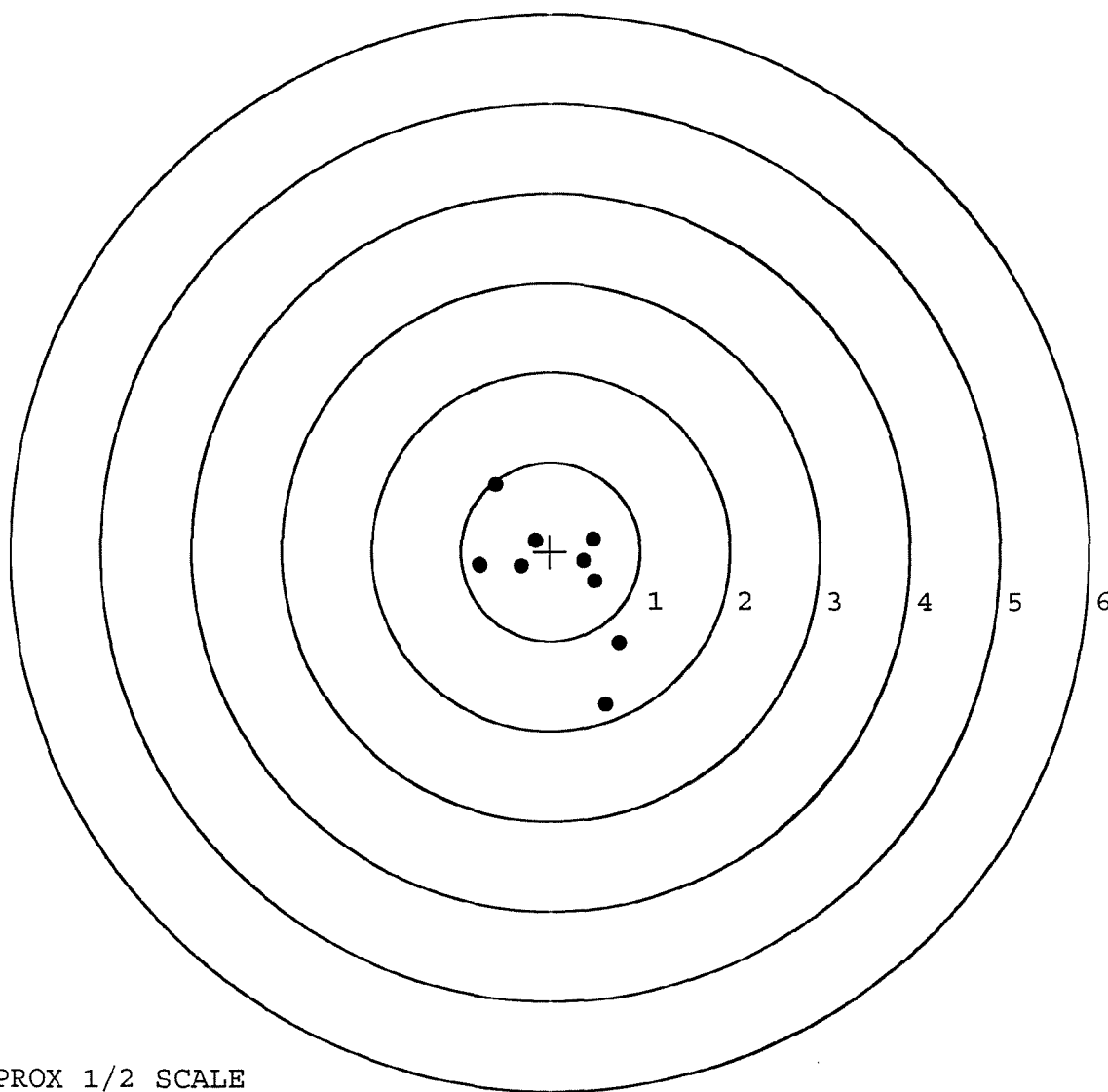
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693274. __0
TARGET NUMBER: 2
FILE DATE: 01/04/2008
FILE TIME: 06:52

X CENTROID: 0.004
Y CENTROID: -0.262
POA TO CENTROID: 0.262
HORZ SPREAD: 1.554
VERT SPREAD: 2.459
GROUP SPREAD: 2.747
MIN RADIUS: 0.344
MAX RADIUS: 1.572
MEAN RADIUS: 0.772

POINT#	X	Y
1:	-0.610	0.748
2:	-0.792	-0.141
3:	-0.165	0.122
4:	-0.326	-0.164
5:	0.615	-1.711
6:	0.762	-1.026
7:	0.495	-0.333
8:	0.374	-0.102
9:	0.474	0.145
10:	-0.786	-0.159

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

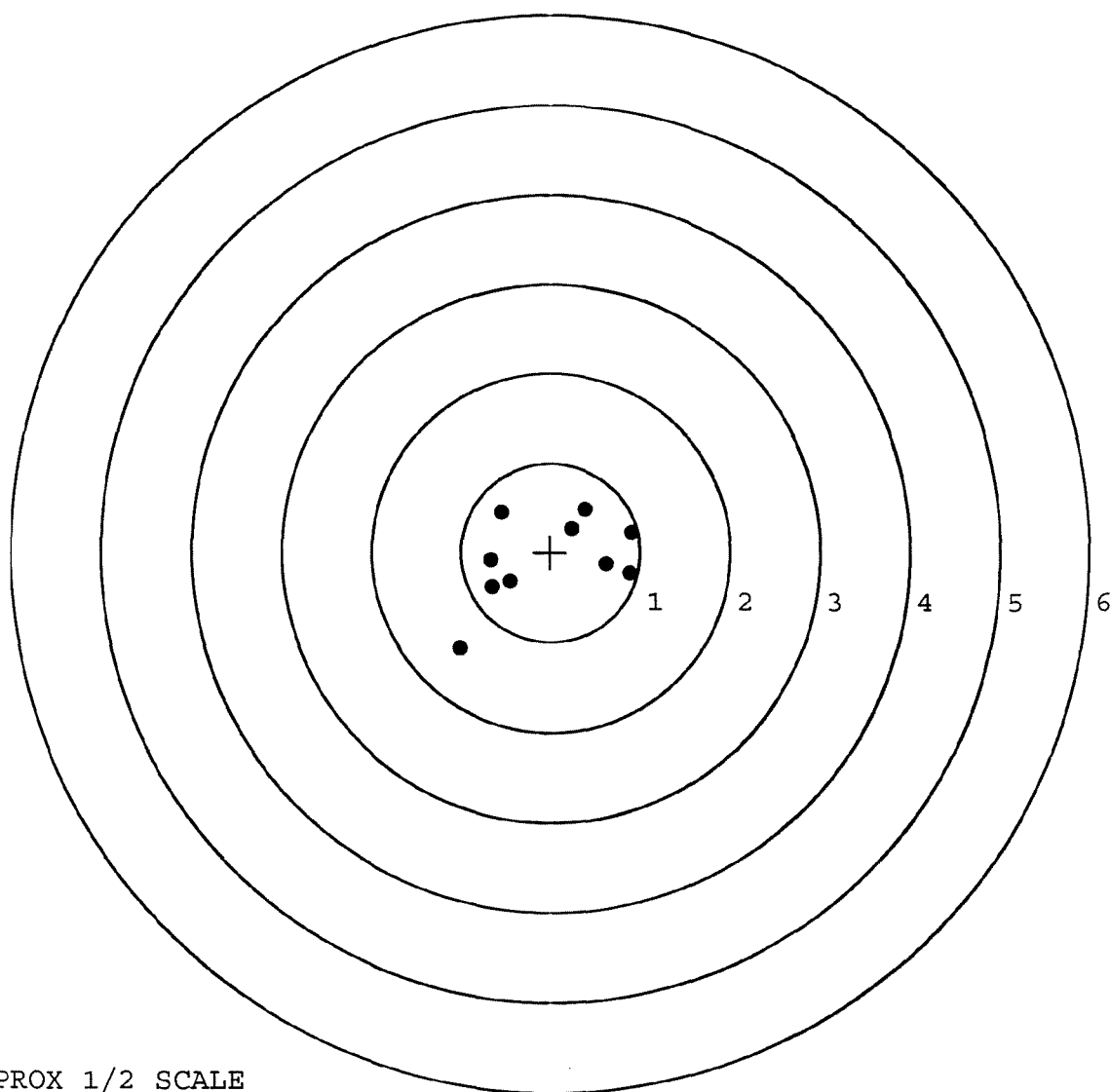


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693274. __0
TARGET NUMBER: 3
FILE DATE: 01/04/2008
FILE TIME: 06:52

POINT#	X	Y
1:	-1.007	-1.076
2:	-0.661	-0.088
3:	-0.650	-0.389
4:	-0.450	-0.333
5:	-0.548	0.447
6:	0.385	0.492
7:	0.237	0.260
8:	0.904	0.223
9:	0.890	-0.235
10:	0.621	-0.132

X CENTROID: -0.028
Y CENTROID: -0.083
POA TO CENTROID: 0.088
HORZ SPREAD: 1.911
VERT SPREAD: 1.568
GROUP SPREAD: 2.311
MIN RADIUS: 0.433
MAX RADIUS: 1.394
MEAN RADIUS: 0.766
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

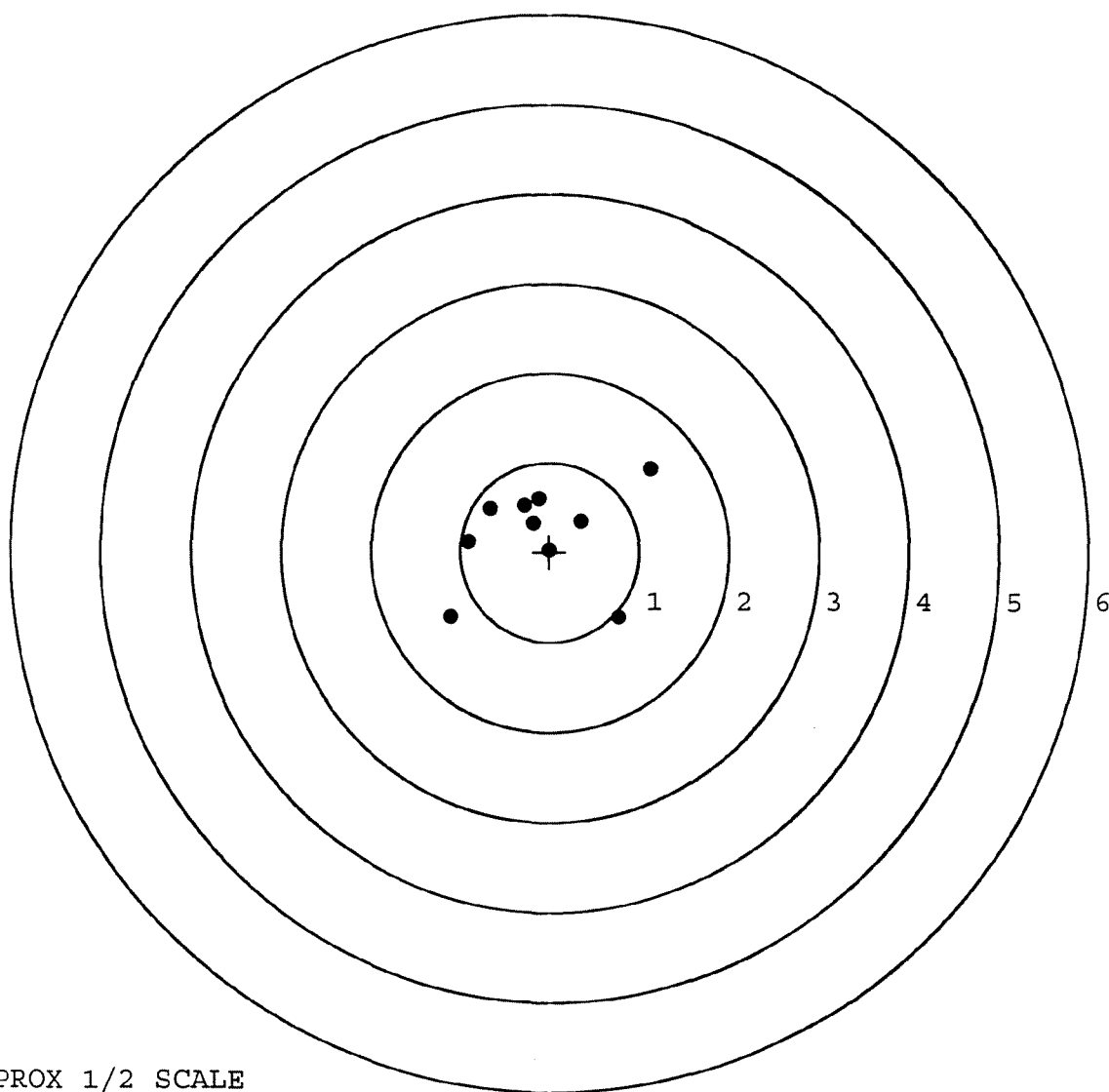


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693274. __0
TARGET NUMBER: 4
FILE DATE: 01/04/2008
FILE TIME: 06:52

POINT#	X	Y
1:	-1.107	-0.720
2:	0.767	-0.728
3:	1.122	0.933
4:	0.349	0.343
5:	-0.006	0.023
6:	-0.908	0.108
7:	-0.660	0.486
8:	-0.185	0.321
9:	-0.124	0.596
10:	-0.286	0.523

X CENTROID: -0.104
Y CENTROID: 0.188
POA TO CENTROID: 0.215
HORZ SPREAD: 2.229
VERT SPREAD: 1.661
GROUP SPREAD: 2.775
MIN RADIUS: 0.155
MAX RADIUS: 1.434
MEAN RADIUS: 0.711
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

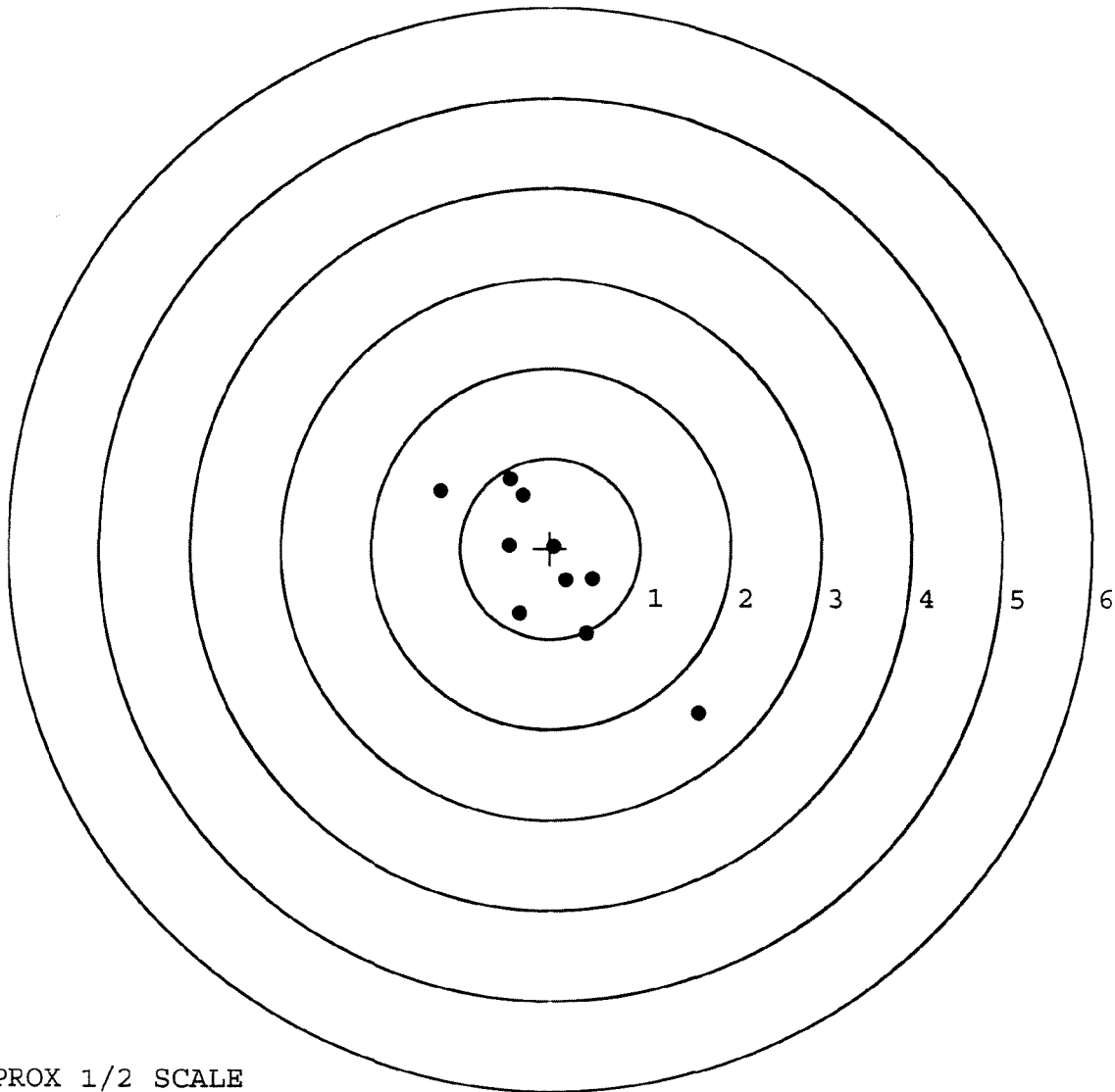


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6693274. 0
TARGET NUMBER: 5
FILE DATE: 01/04/2008
FILE TIME: 06:52

POINT#	X	Y
1:	-1.222	0.639
2:	-0.443	0.768
3:	-0.312	0.588
4:	-0.460	0.038
5:	0.040	0.025
6:	-0.343	-0.724
7:	0.177	-0.355
8:	0.471	-0.342
9:	0.405	-0.941
10:	1.641	-1.821

X CENTROID: -0.005
Y CENTROID: -0.212
POA TO CENTROID: 0.213
HORZ SPREAD: 2.863
VERT SPREAD: 2.589
GROUP SPREAD: 3.775
MIN RADIUS: 0.231
MAX RADIUS: 2.301
MEAN RADIUS: 0.865
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE