

G6807809

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

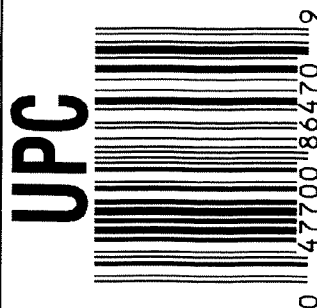


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807809



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66807809

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-12-09	SPD
430	ASSEMBLE TO STOCK		2-12-09	SP
440	PROOF		2-12-09	SPD
460	CHECK HEADSPACE		2-12-09	SPD
470	DIS-ASSEMBLE ACTION		2-12-09	SPD
472	SERIALIZE BOLT HANDLE		2-13-09	RTZ
475	DRILL AND TAP SIGHT HOLES		2-13-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/18/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		2/19/09	RT
520	GOFF BLAST BBL / REC		19 Feb. 09	ing
542	APPLY COATINGS (BARREL ACTION)		3/4	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-4-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-4-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-4-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-6-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

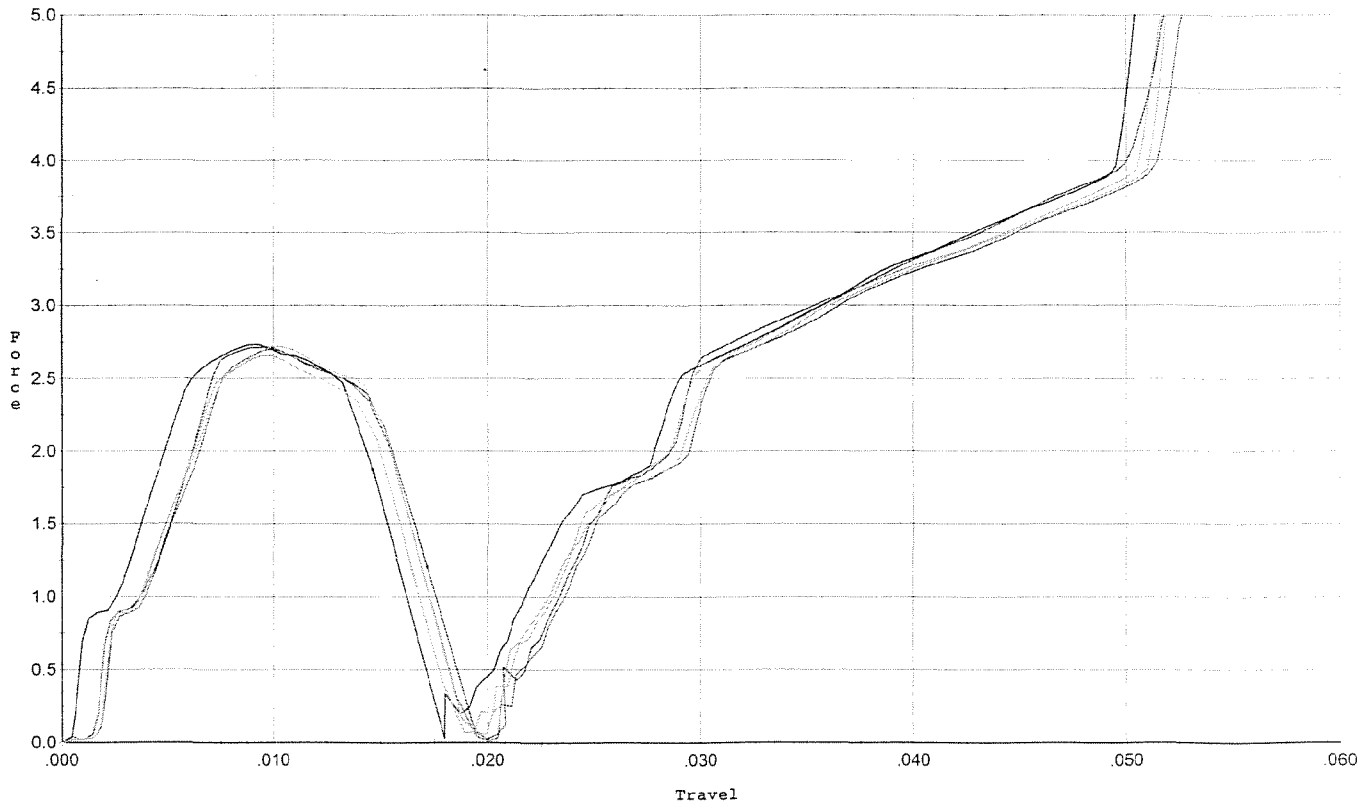
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-12-09	WV
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-12-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-12-09	WV
	J) ASSEMBLE STOCK			3-6-09	RP
	K) ASSEMBLE SWIVEL STUDS			3-12-09	WV
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	3-6-09	RP
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION N/A		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			3-6-09	RP
670	FINAL INSPECTION A) HEADSPACE			3-12-09	WV
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.63</u> <u>2.62</u> <u>2.37</u> <u>2.35</u>	3-9-09	WV
	C) FUNCTION			3-12-09	WV
690	PACK			3-12-09	WV

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/5/2009

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



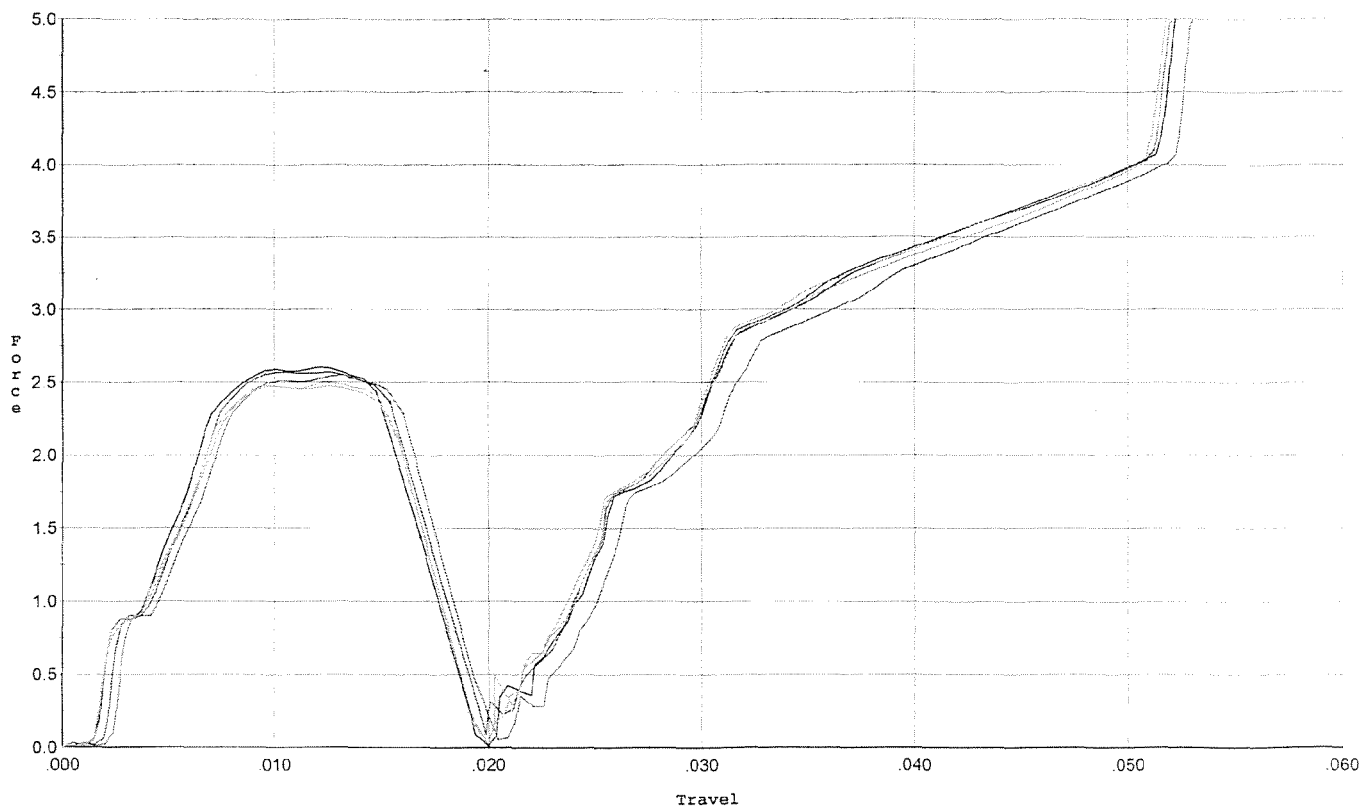
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.715	0.017	0.00	0.038	0.030		Set Trigger
2	2.731	0.015	0.00	0.038	0.028		Set Trigger
3	2.701	0.015	0.002	0.039	0.026		Set Trigger
4	2.718	0.015	0.002	0.039	0.026		Set Trigger
5	2.656	0.015	0.00	0.039	0.025		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



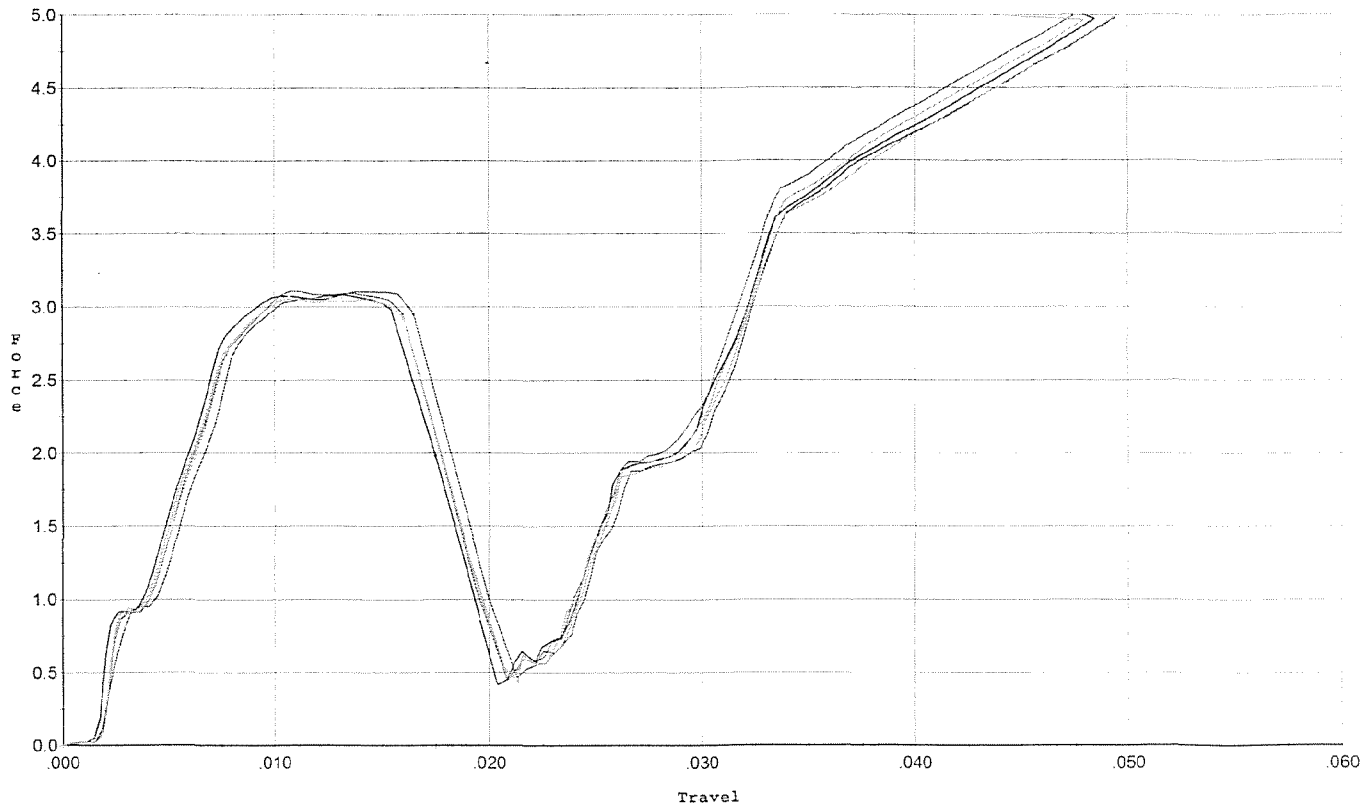
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.015	0.00	0.038	0.026		Set Trigger
2	2.601	0.017	0.00	0.038	0.029		Set Trigger
3	2.547	0.016	0.00	0.039	0.026		Set Trigger
4	2.495	0.016	0.00	0.038	0.026		Set Trigger
5	2.484	0.016	0.00	0.038	0.026		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



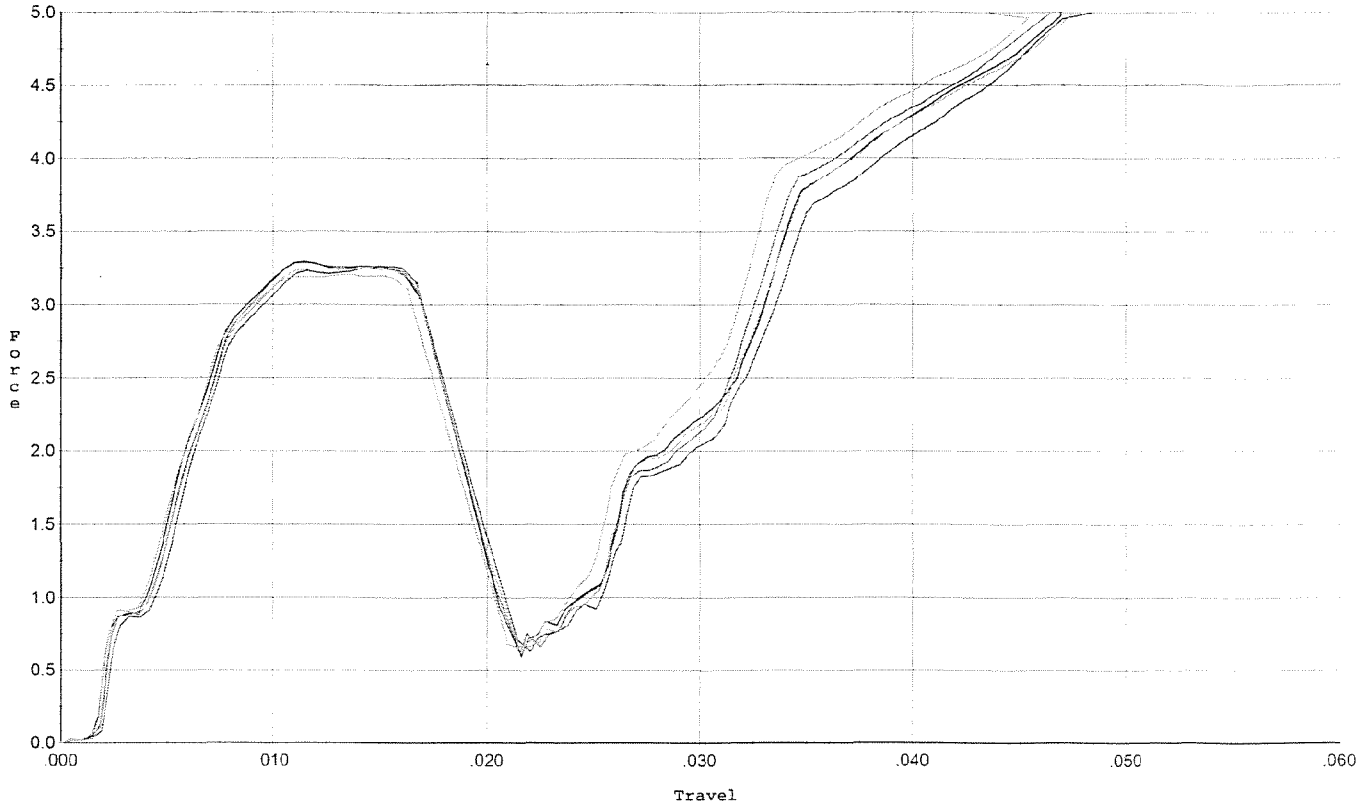
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.103	0.017	0.00	0.036	0.033		Set Trigger
2	3.082	0.017	0.00	0.036	0.035		Set Trigger
3	3.108	0.016	0.002	0.036	0.032		Set Trigger
4	3.077	0.016	0.00	0.036	0.032		Set Trigger
5	3.057	0.016	0.002	0.036	0.032		Set Trigger

A-3-08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



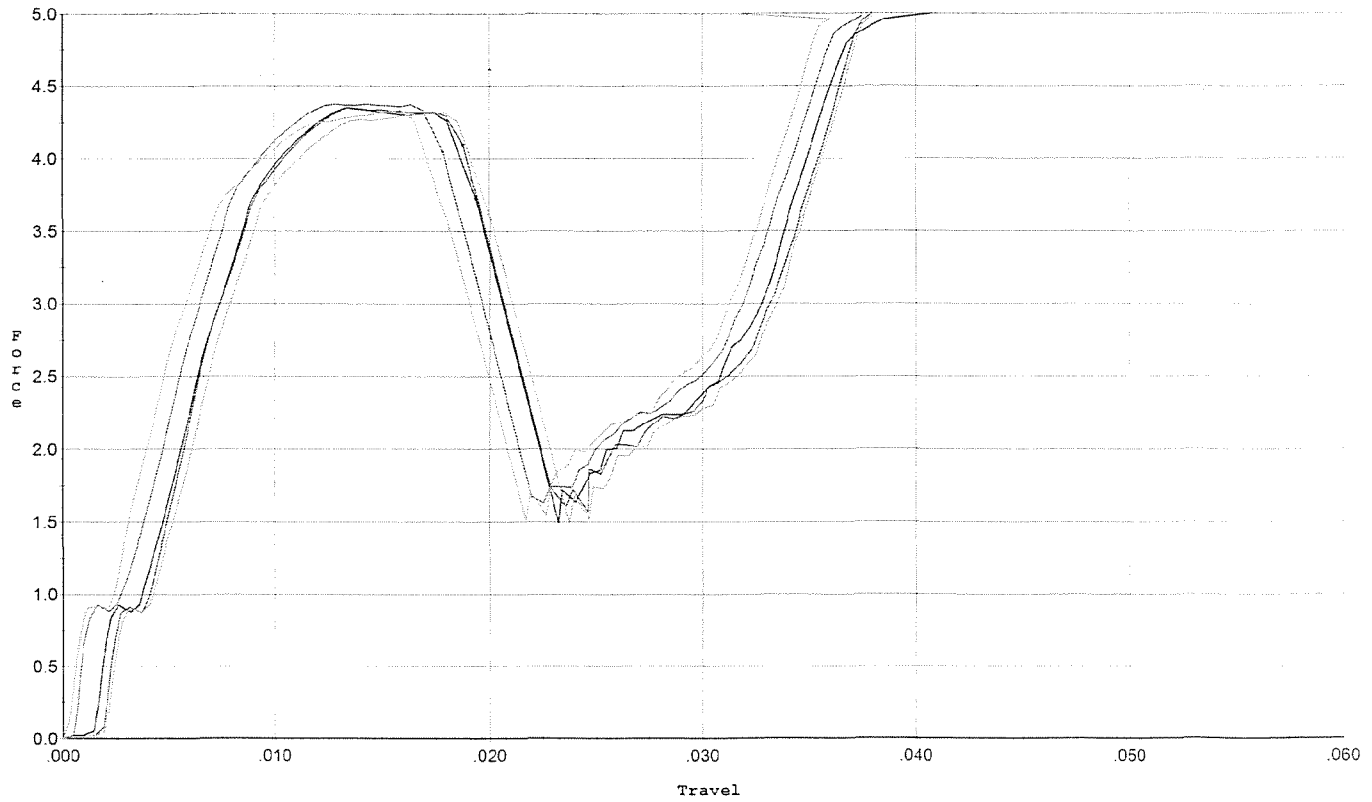
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.261	0.017	0.00	0.036	0.035		Set Trigger
2	3.293	0.017	0.00	0.036	0.036		Set Trigger
3	3.285	0.017	0.00	0.036	0.036		Set Trigger
4	3.247	0.017	0.00	0.036	0.035		Set Trigger
5	3.209	0.016	0.00	0.035	0.034		Set Trigger

A-3-25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



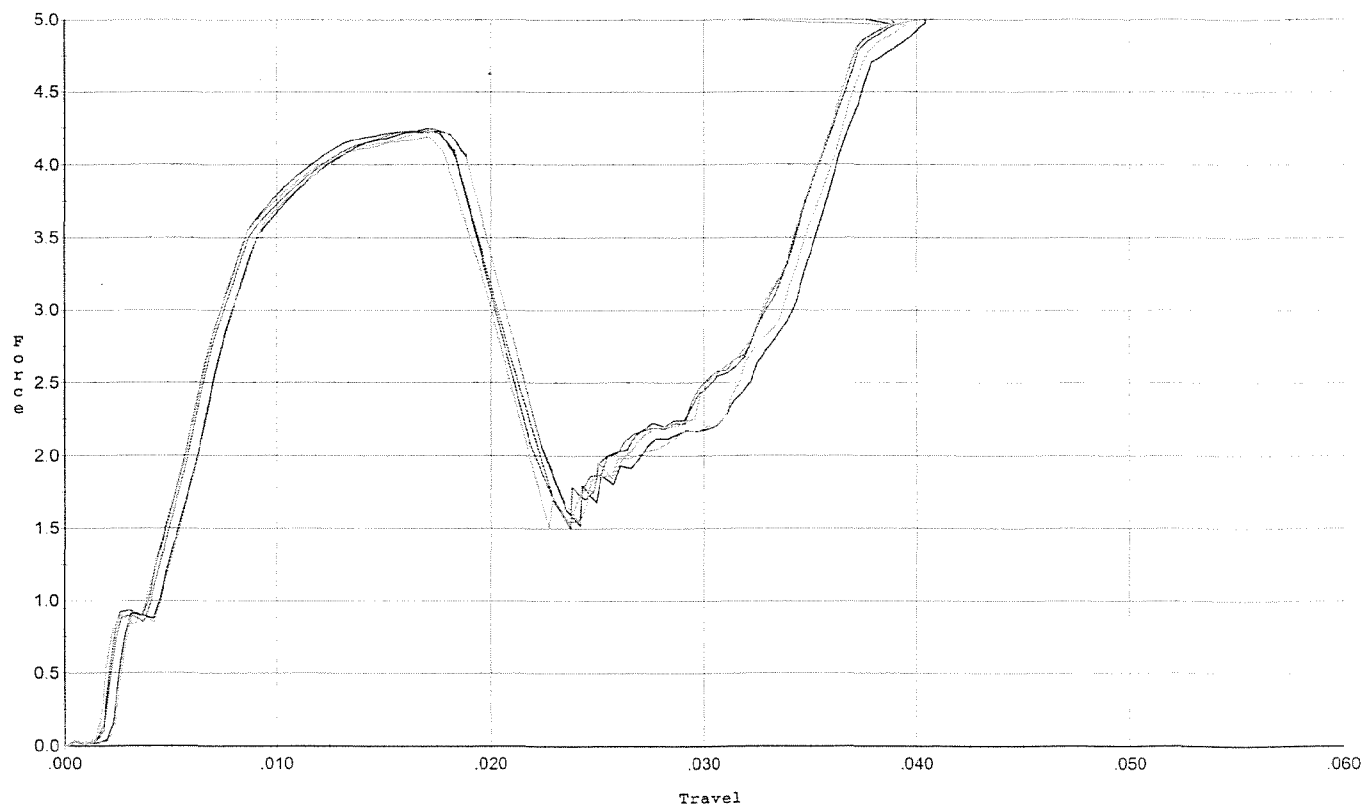
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.019	0.002	0.030	0.052		Set Trigger
2	4.350	0.019	0.00	0.031	0.054		Set Trigger
3	4.374	0.018	0.00	0.031	0.052		Set Trigger
4	4.336	0.018	0.00	0.030	0.053		Set Trigger
5	4.318	0.020	0.002	0.030	0.054		Set Trigger

A-438

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



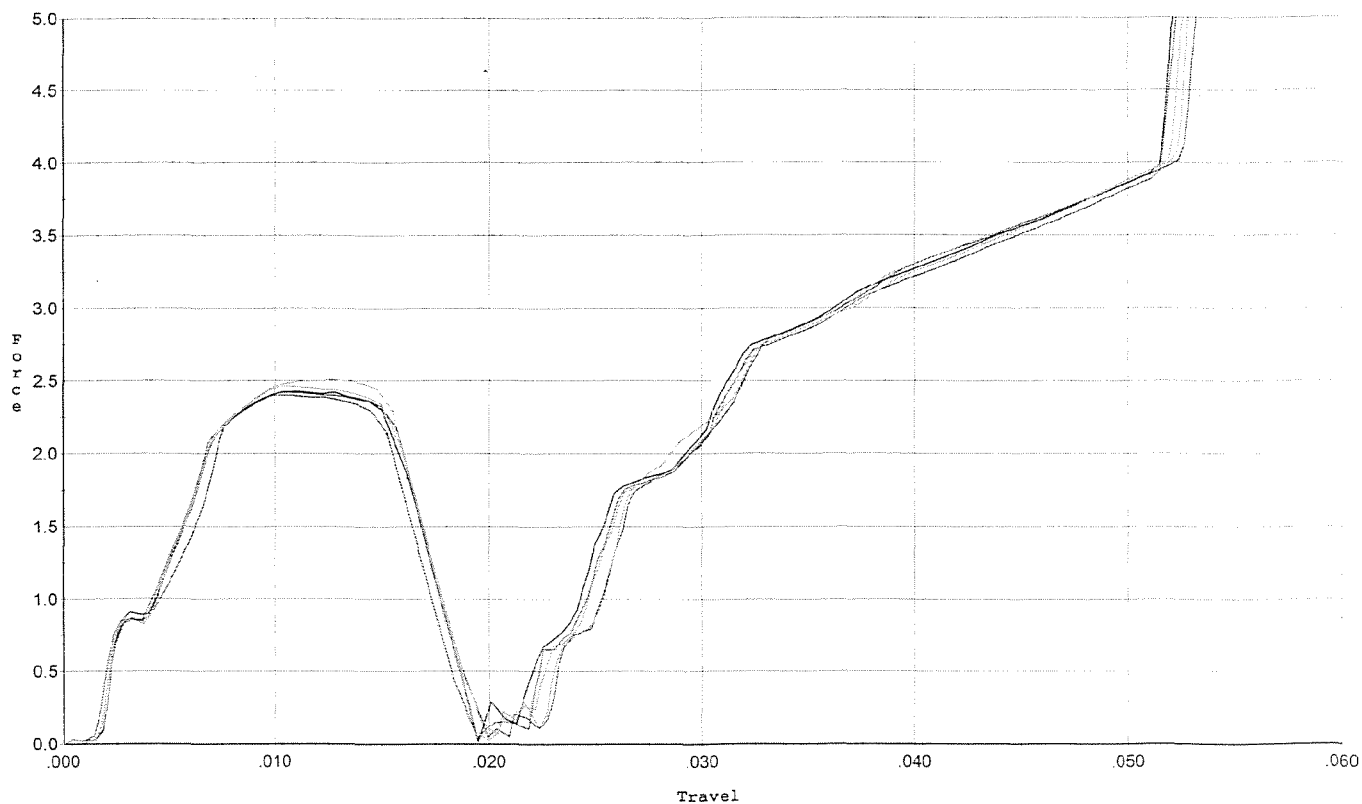
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.018	0.00	0.032	0.049		Set Trigger
2	4.228	0.019	0.002	0.032	0.049		Set Trigger
3	4.234	0.018	0.00	0.031	0.048		Set Trigger
4	4.242	0.019	0.002	0.031	0.049		Set Trigger
5	4.191	0.020	0.00	0.031	0.052		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



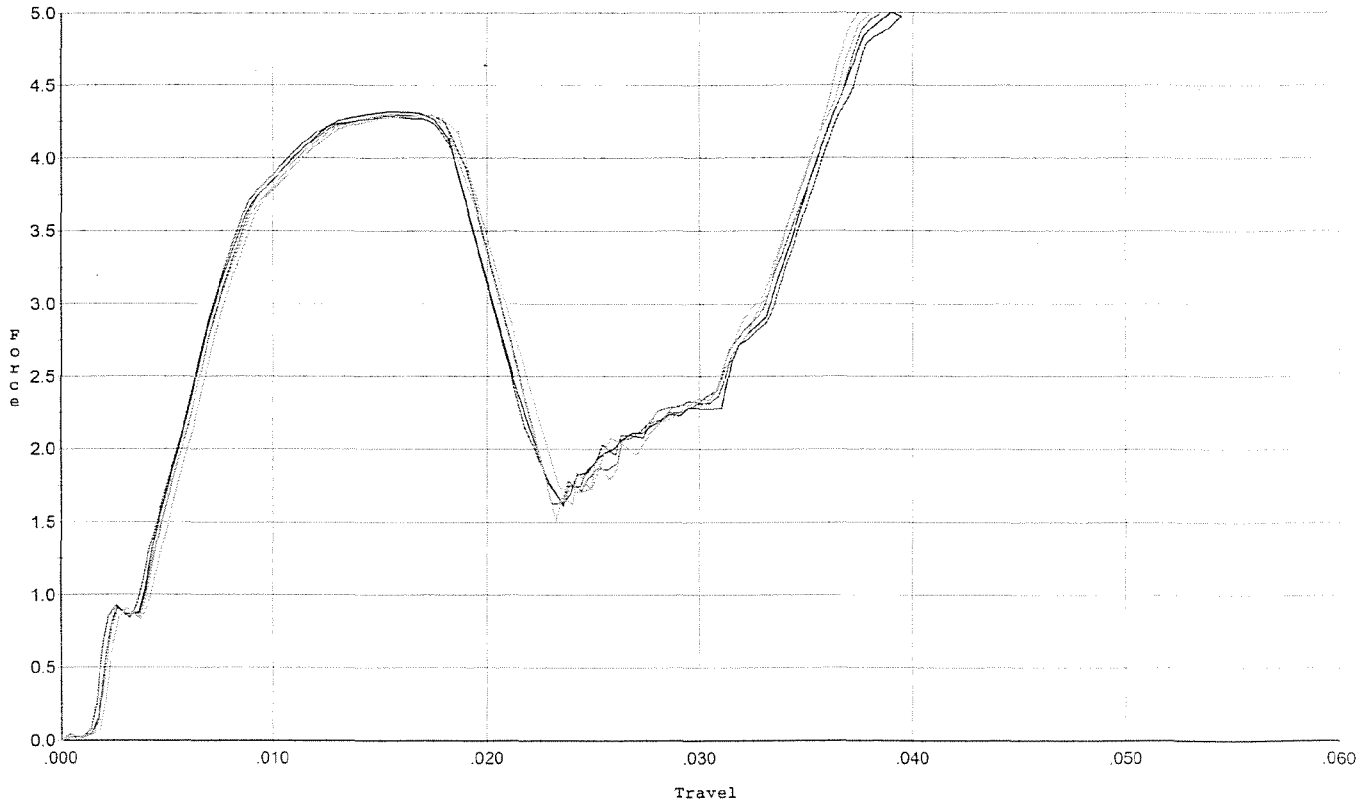
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.016	0.005	0.039	0.025		Set Trigger
2	2.423	0.016	0.002	0.038	0.026		Set Trigger
3	2.400	0.015	0.004	0.039	0.024		Set Trigger
4	2.461	0.016	0.00	0.039	0.026		Set Trigger
5	2.508	0.016	0.00	0.039	0.025		Set Trigger

A-2-44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/5/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.290	0.018	0.00	0.026	0.050		Set Trigger
2	4.318	0.018	0.00	0.027	0.050		Set Trigger
3	4.297	0.019	0.004	0.026	0.052		Set Trigger
4	4.291	0.019	0.004	0.026	0.053		Set Trigger
5	4.298	0.019	0.002	0.026	0.050		Set Trigger

A-4.29