

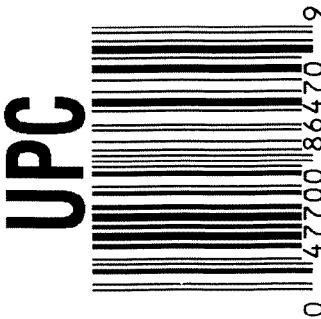
6680 1412

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

G6801412



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 1412

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	10-22-08	RSN
475	DRILL AND TAP SIGHT HOLES	4006	10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/24/08	SP
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/24/08	PG
542	APPLY COATINGS (BARREL ACTION)		10 28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-29-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-9-09	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

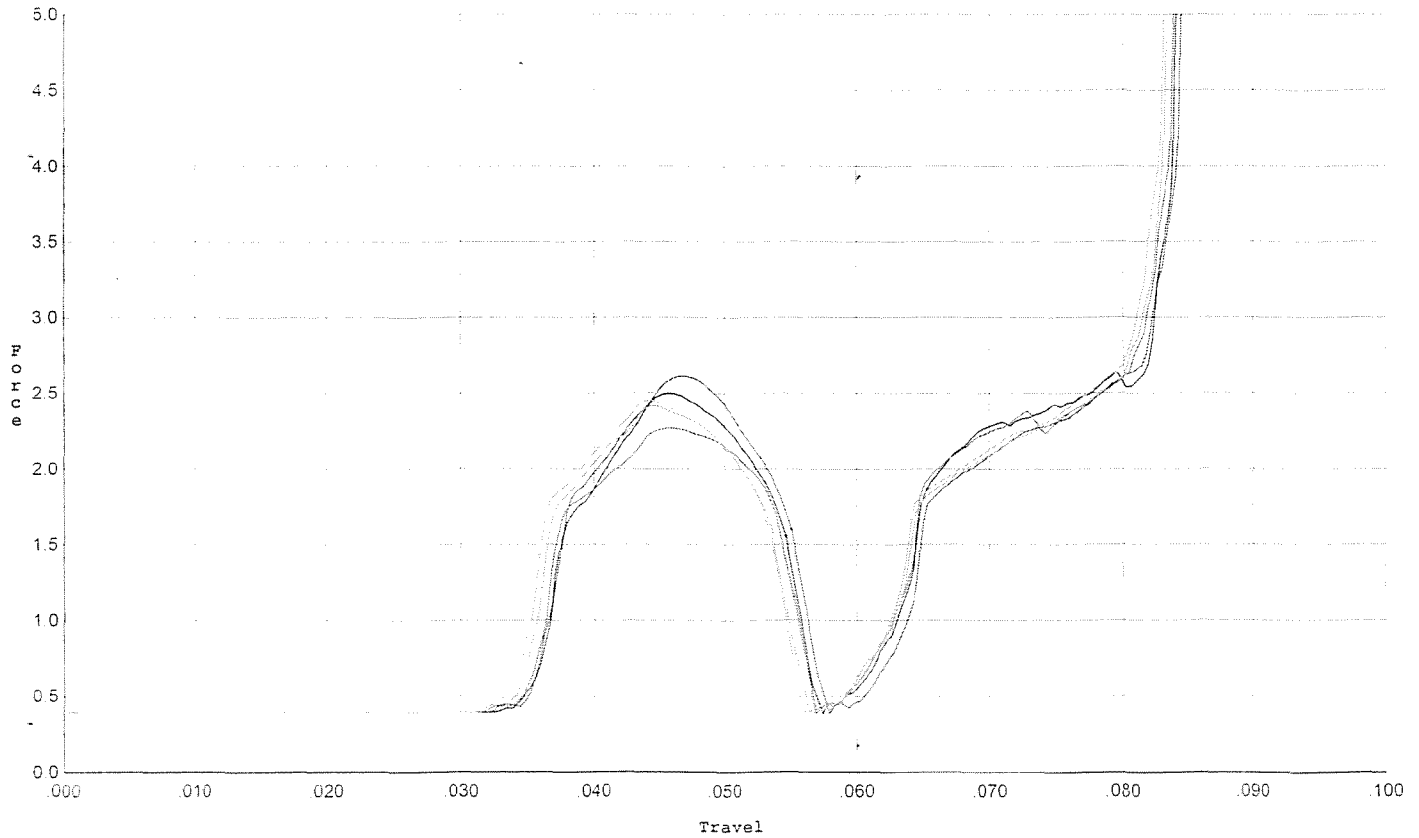
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	1-14-09	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6°</u> <u>6°</u> <u>5°</u>	1-14-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	1-14-09	R.N.
	J) ASSEMBLE STOCK		1-9-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-14-09	R.N.
	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	1-12-09	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-12-09	RP
670	FINAL INSPECTION A) HEADSPACE		1-14-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>296</u> <u>260</u> <u>274</u> <u>274</u> <u>270</u>	1-13-09	R.N.
	C) FUNCTION		1-14-09	R.N.
690	PACK		1/16/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



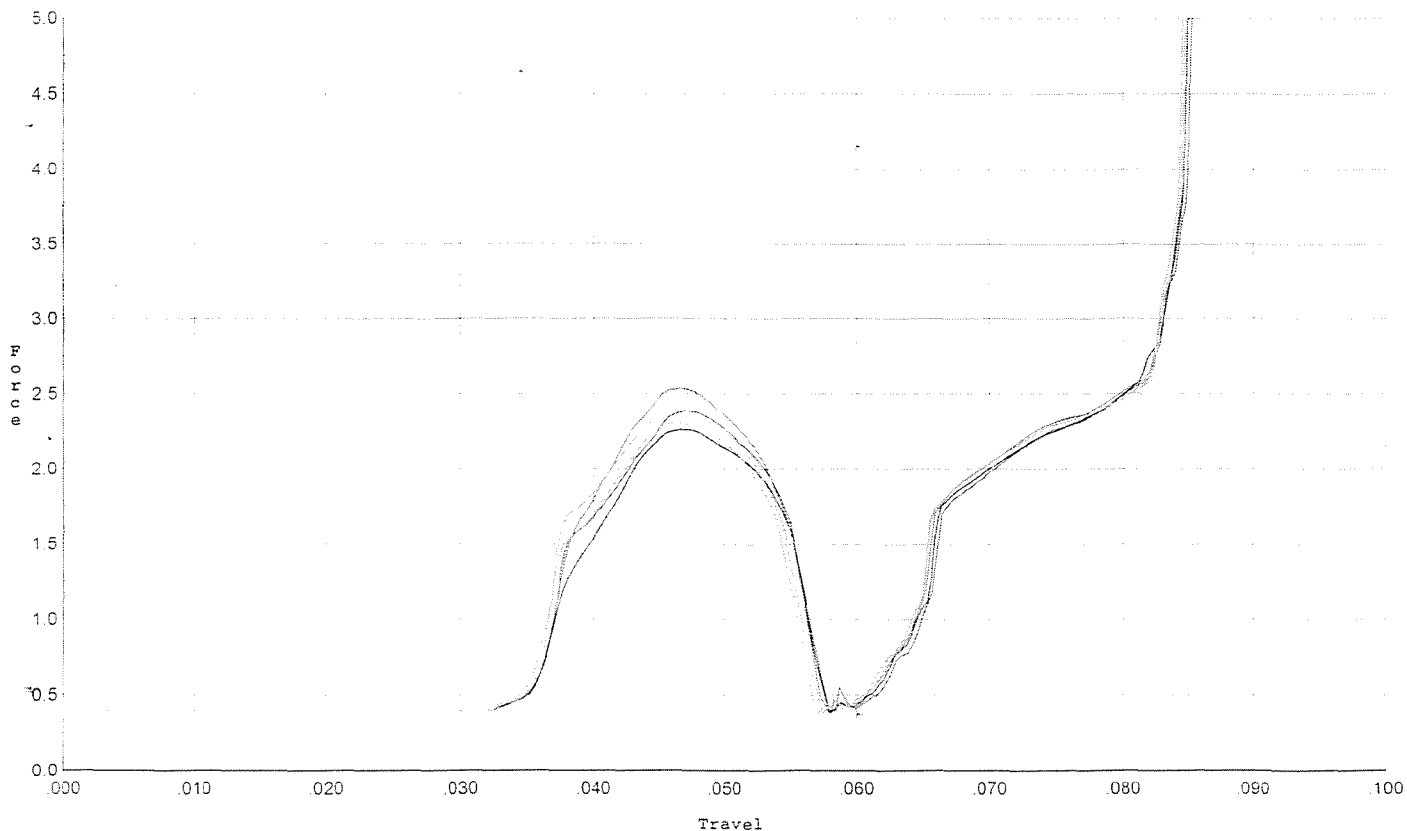
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.055	0.035	0.036	0.055		Set Trigger
2	2.499	0.055	0.036	0.036	0.053		Set Trigger
3	2.269	0.055	0.035	0.035	0.052		Set Trigger
4	2.453	0.054	0.034	0.035	0.053		Set Trigger
5	2.418	0.054	0.035	0.036	0.052		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



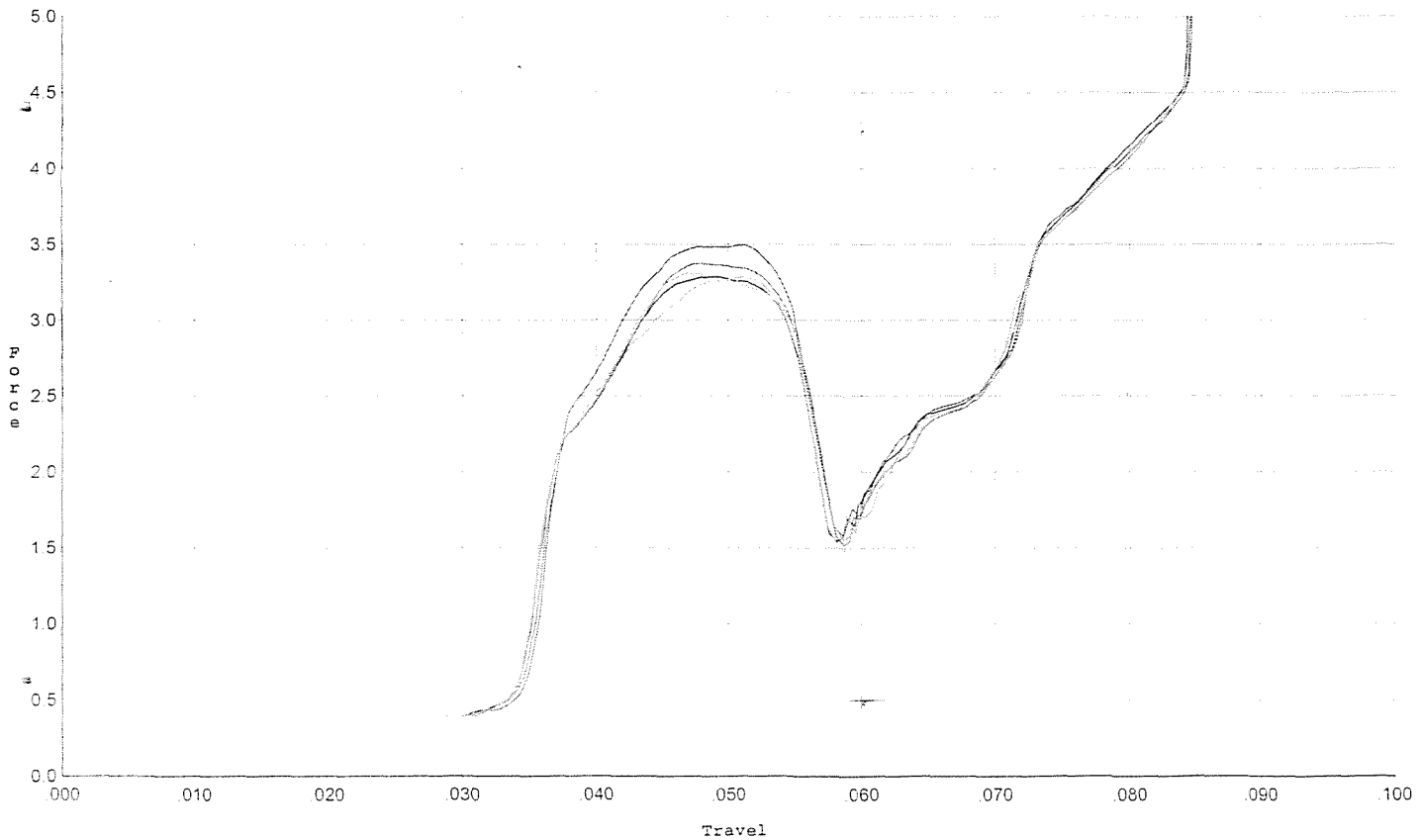
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.386	0.055	0.036	0.036	0.052		Set Trigger
2	2.261	0.055	0.036	0.036	0.050		Set Trigger
3	2.533	0.055	0.036	0.036	0.054		Set Trigger
4	2.398	0.055	0.036	0.036	0.052		Set Trigger
5	2.307	0.055	0.035	0.036	0.051		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



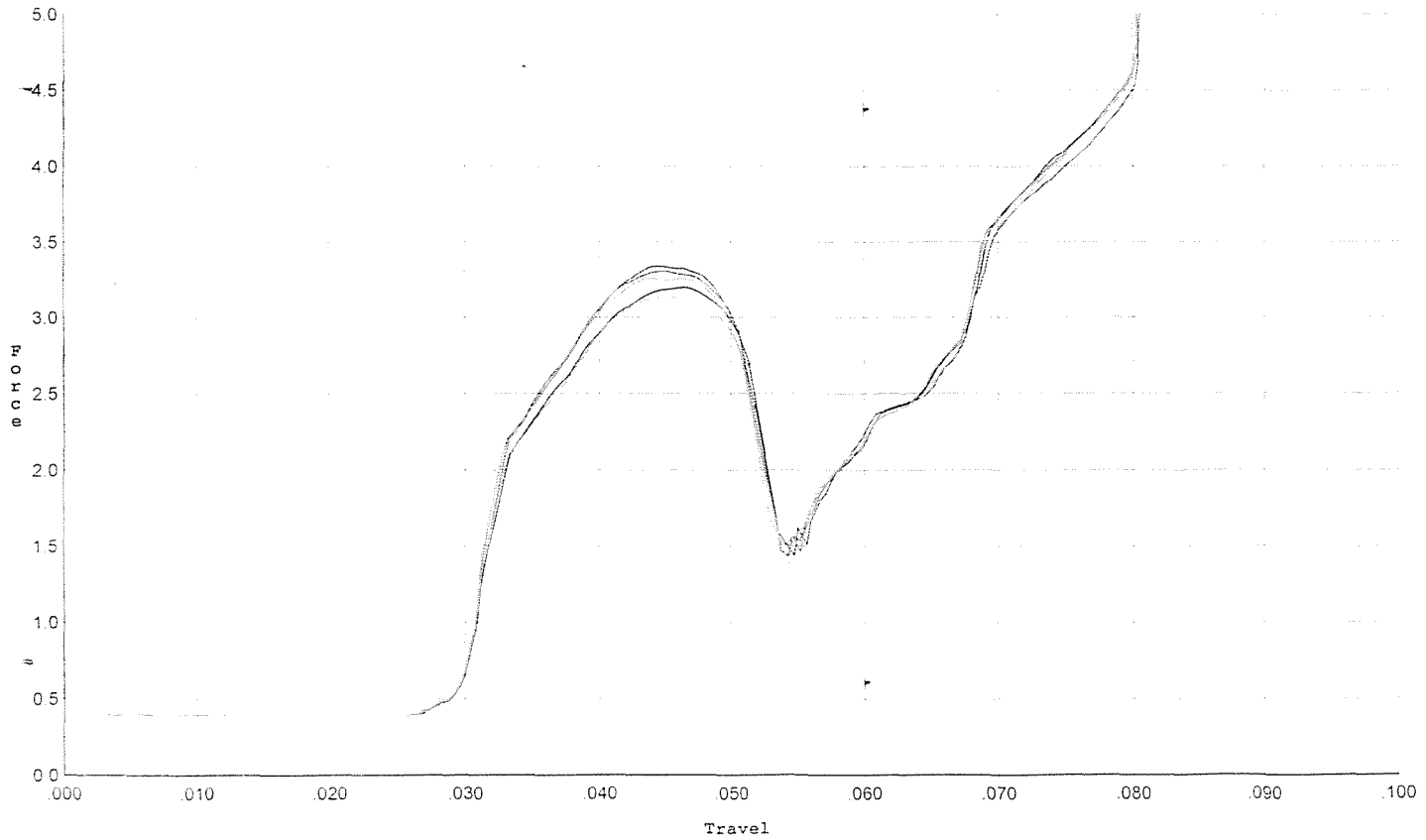
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.494	0.056	0.035	0.034	0.077		Set Trigger
2	3.288	0.055	0.034	0.034	0.073		Set Trigger
3	3.372	0.055	0.035	0.034	0.073		Set Trigger
4	3.312	0.055	0.034	0.034	0.073		Set Trigger
5	3.284	0.056	0.034	0.033	0.074		Set Trigger

A 3.35

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



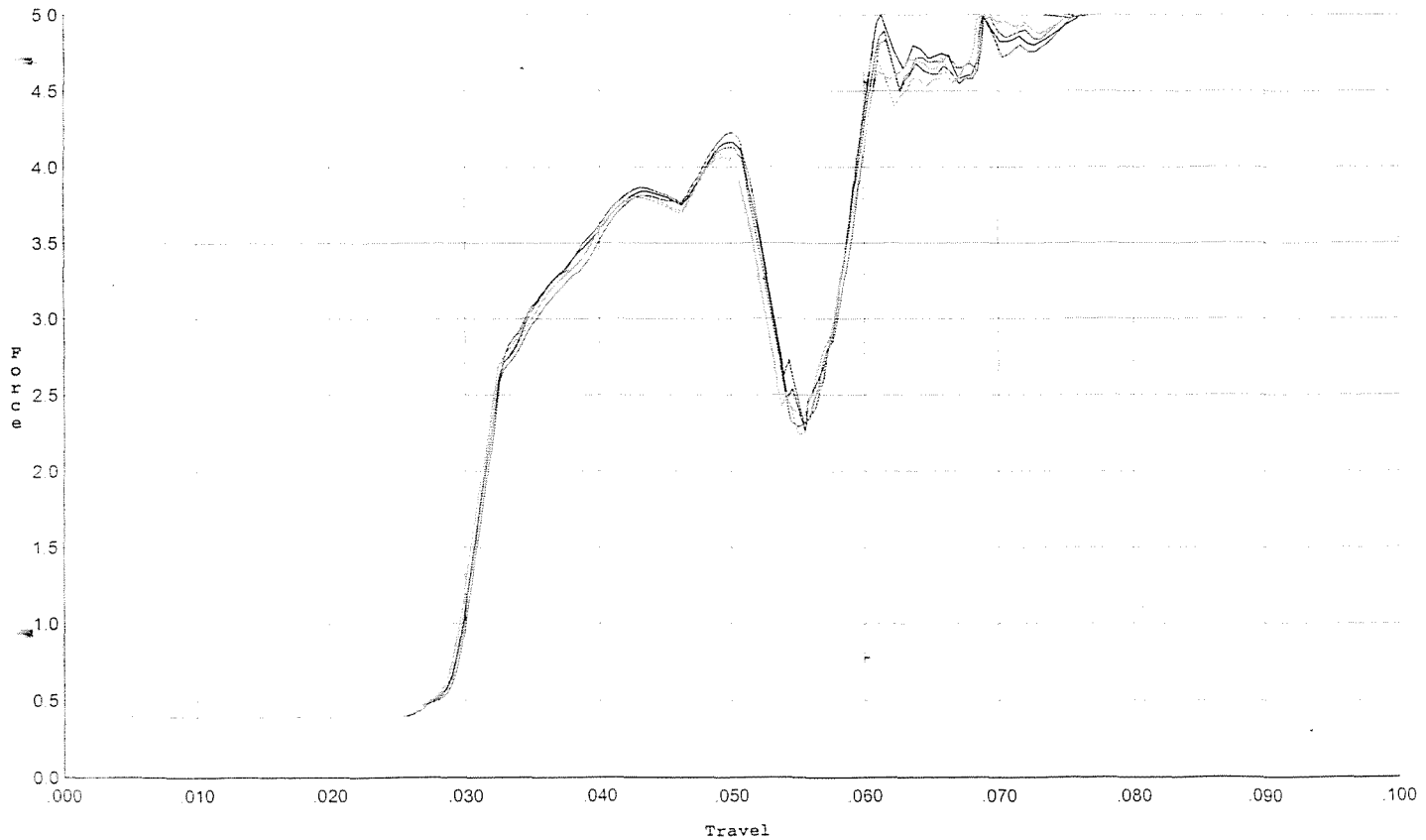
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.339	0.052	0.030	0.032	0.072		Set Trigger
2	3.197	0.051	0.030	0.032	0.069		Set Trigger
3	3.307	0.051	0.030	0.032	0.070		Set Trigger
4	3.257	0.051	0.030	0.032	0.070		Set Trigger
5	3.136	0.051	0.030	0.032	0.068		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



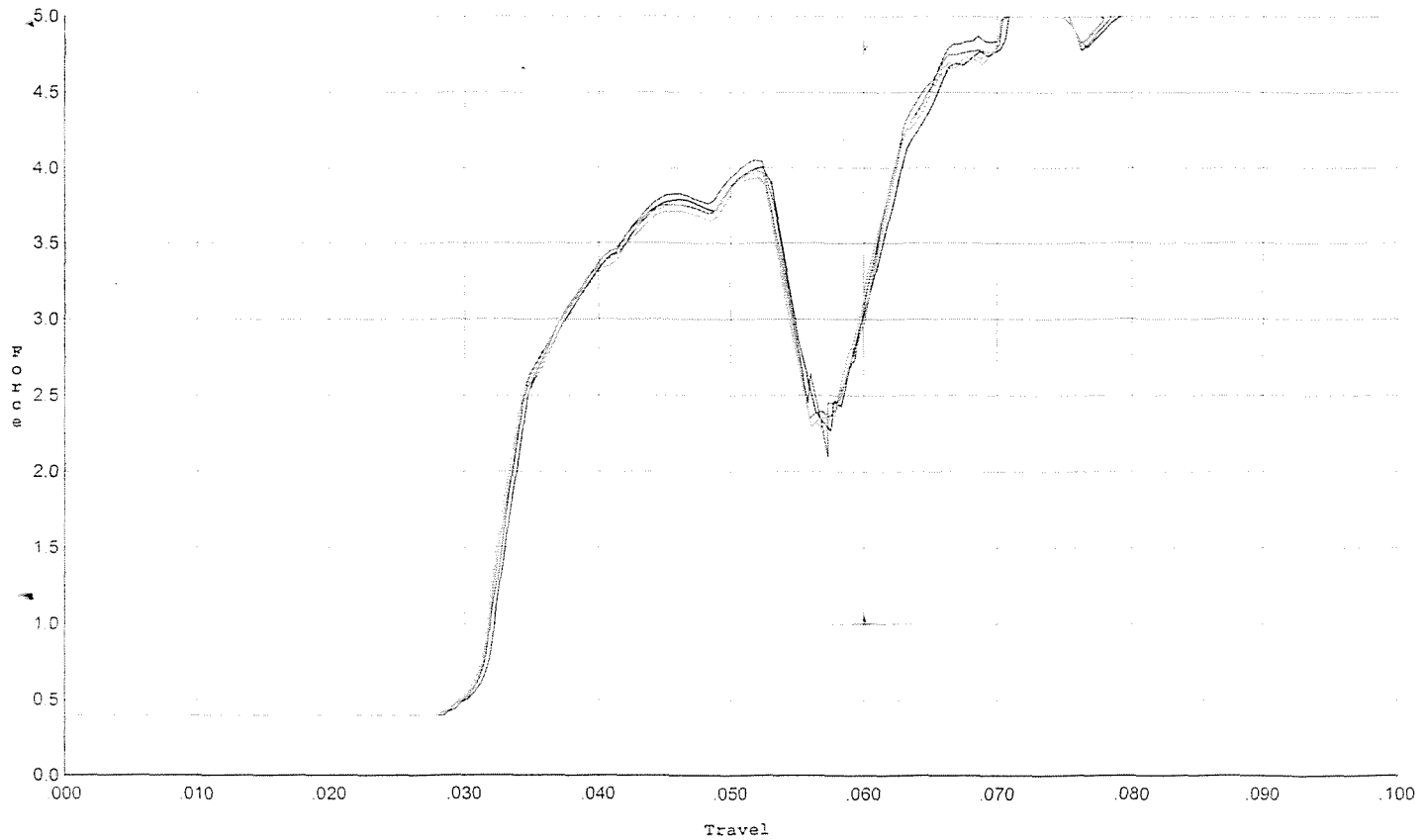
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.228	0.052	0.029	0.030	0.089		Set Trigger
2	4.165	0.052	0.029	0.030	0.089		Set Trigger
3	4.130	0.053	0.029	0.030	0.089		Set Trigger
4	4.091	0.052	0.029	0.030	0.087		Set Trigger
5	4.067	0.052	0.029	0.030	0.087		Set Trigger

A. 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



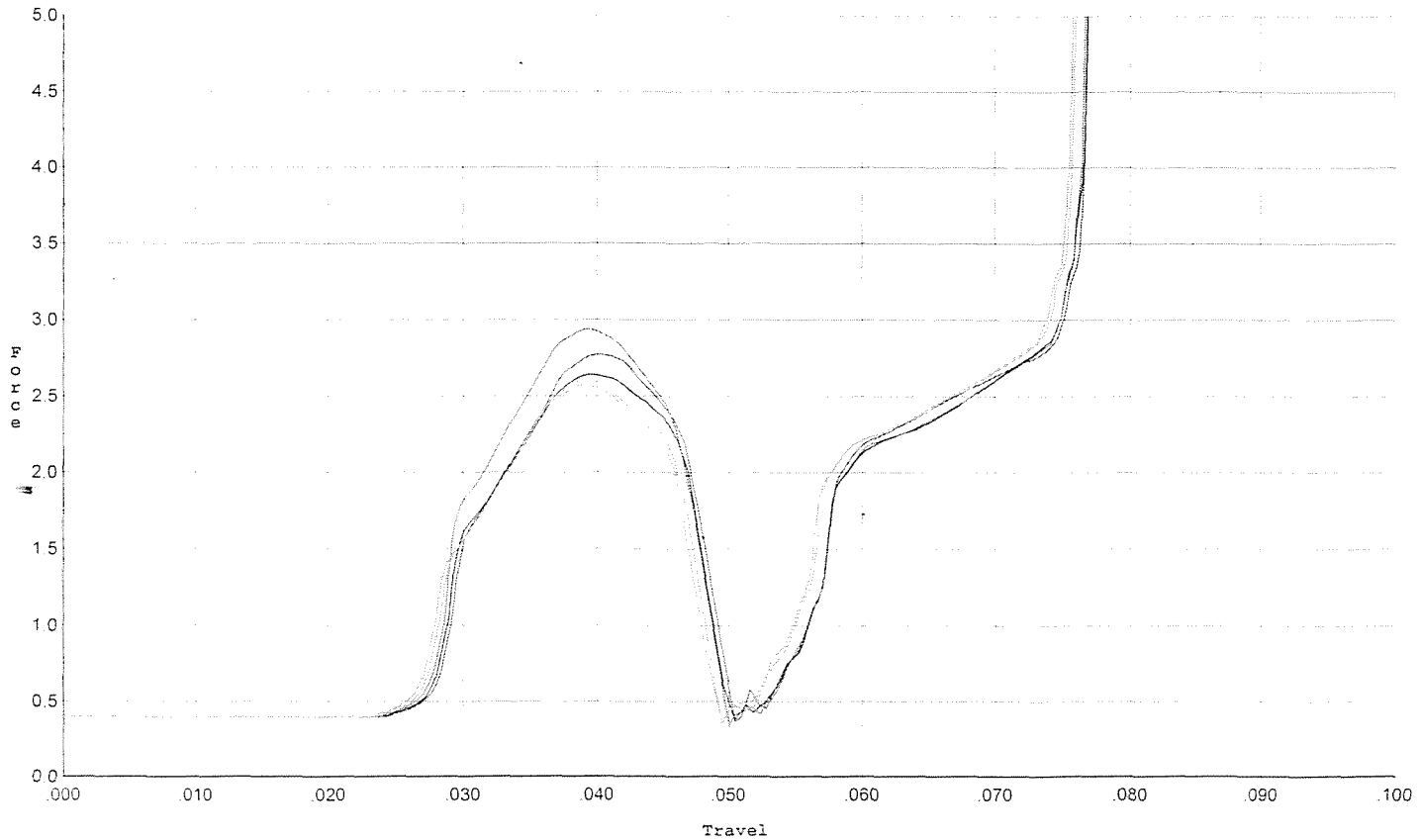
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.053	0.031	0.031	0.087		Set Trigger
2	4.006	0.053	0.031	0.031	0.085		Set Trigger
3	3.988	0.054	0.031	0.031	0.087		Set Trigger
4	3.972	0.053	0.031	0.031	0.084		Set Trigger
5	3.935	0.054	0.031	0.031	0.087		Set Trigger

A-3-99

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



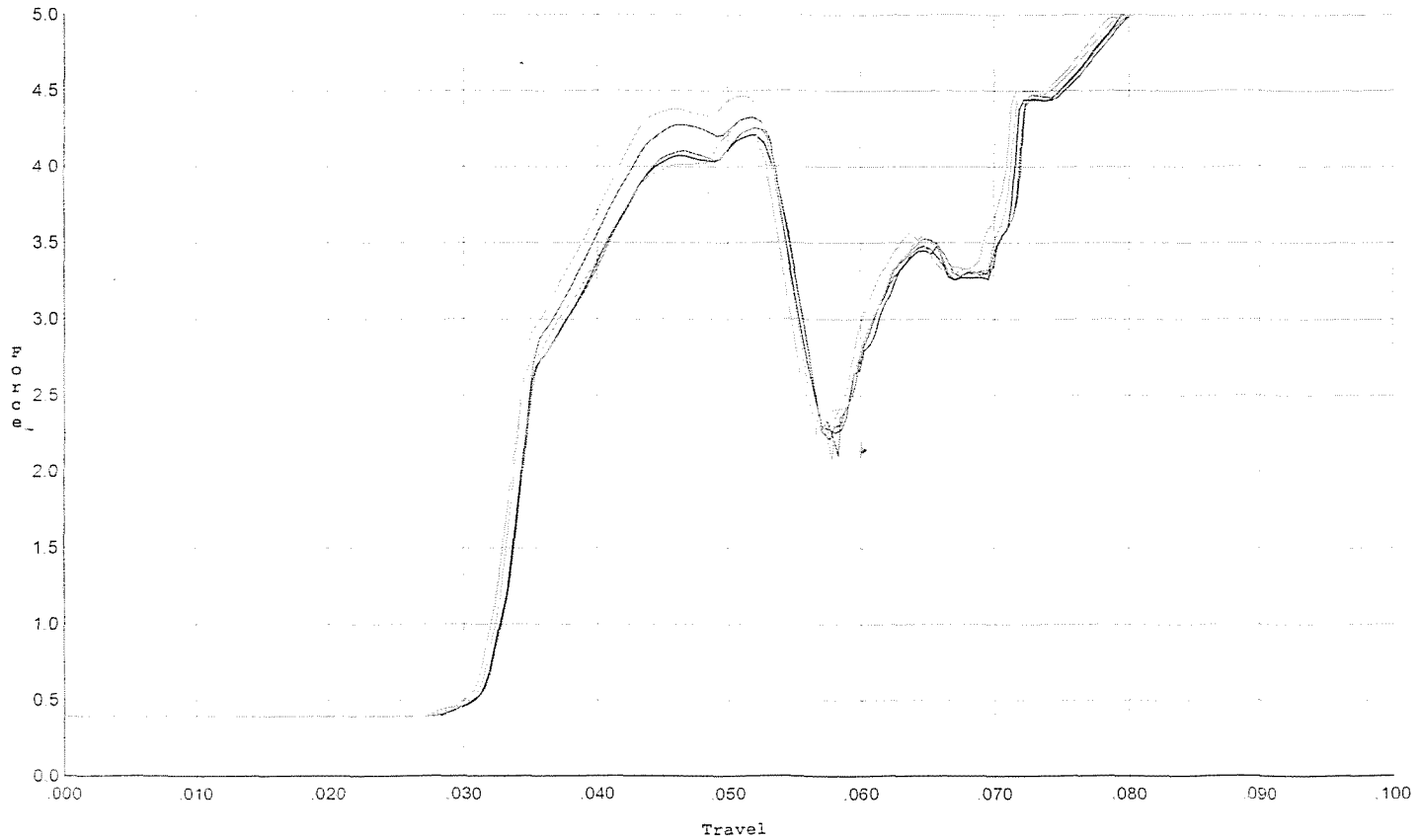
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.774	0.048	0.028	0.033	0.055		Set Trigger
2	2.642	0.047	0.028	0.033	0.053		Set Trigger
3	2.937	0.047	0.028	0.033	0.057		Set Trigger
4	2.604	0.047	0.027	0.033	0.052		Set Trigger
5	2.574	0.046	0.027	0.033	0.051		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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	4.323	0.055	0.032	0.032	0.095		Set Trigger
2	4.204	0.053	0.032	0.032	0.089		Set Trigger
3	4.253	0.055	0.032	0.032	0.091		Set Trigger
4	4.467	0.053	0.032	0.032	0.095		Set Trigger
5	4.282	0.053	0.031	0.031	0.089		Set Trigger

A-430