

66774515

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

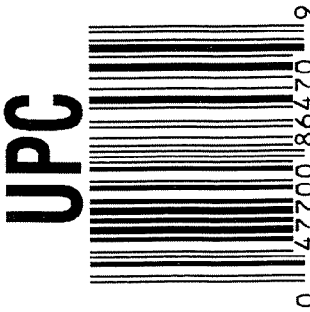


BM FORM

ORDER NO. **86470**

BARREL LENGTH	24"
CAPACITY	6

G6774515



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6774515

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-31-08	SPD
430	ASSEMBLE TO STOCK		7-31-08	SP
440	PROOF		7-31-08	SPD
460	CHECK HEADSPACE		7-31-08	SPD
470	DIS-ASSEMBLE ACTION		7-31-08	SPD
472	SERIALIZE BOLT HANDLE		8-1-08	SPD
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX AUG 06 2008	8-6-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>BM</u>	8/6	BM
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/6/08	RT
520	GOFF BLAST BBL / REC		8/7/08	Bay
542	APPLY COATINGS (BARREL ACTION)		8/6	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-18-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-08	BM
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

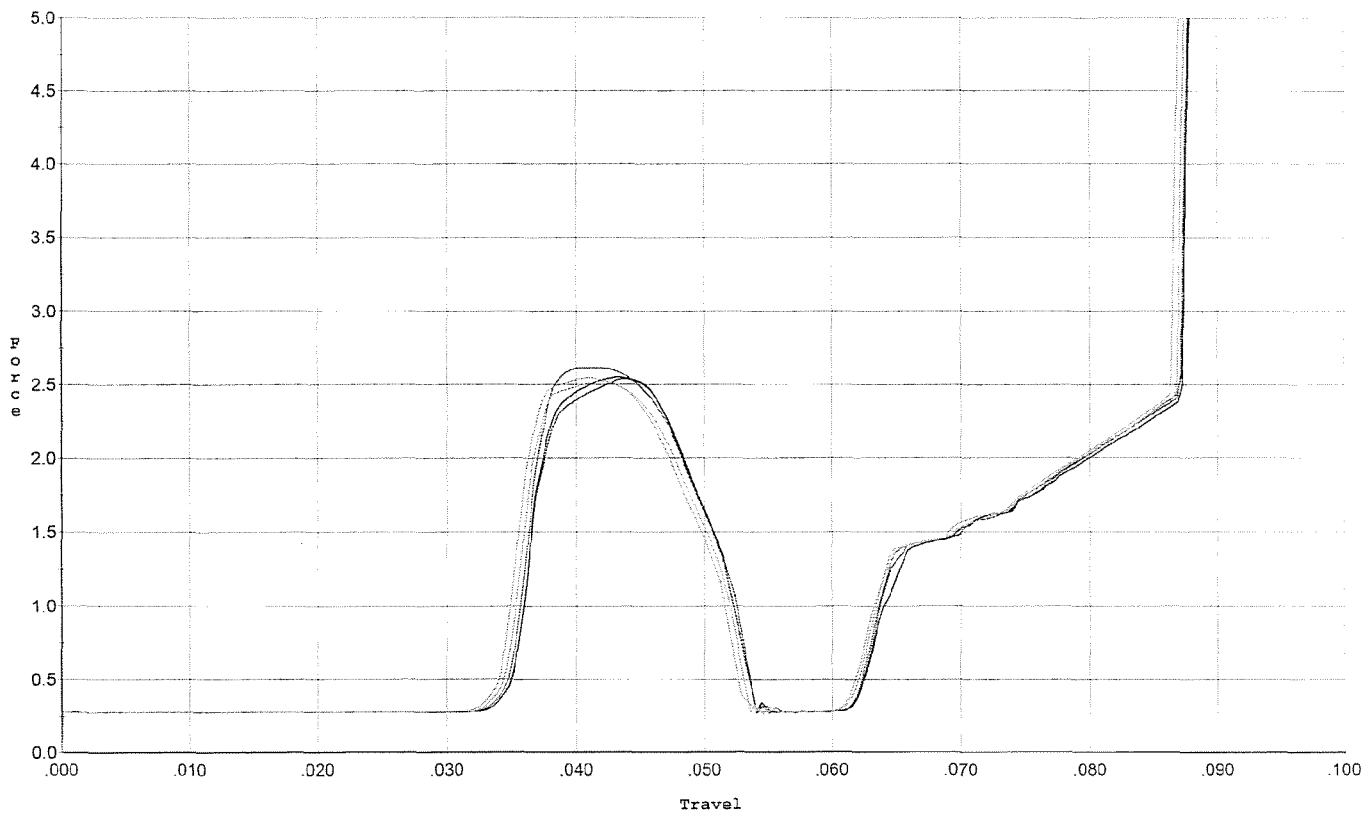
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2</u> <u>2</u> <u>2</u>	9-17-08	TL
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>3.5</u>	9-17-08	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	9-17-08	TL
	J) ASSEMBLE STOCK		8-25-08	BSW
	K) ASSEMBLE SWIVEL STUDS		9-17-08	TL
	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	9-4-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-4-08	FM
670	FINAL INSPECTION A) HEADSPACE		9-17-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.11</u> <u>2.11</u> <u>2.10</u> <u>2.11</u> <u>2.19</u>	9-12-08	TL
	C) FUNCTION		9-17-08	TL
690	PACK		10/24/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/16/08

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



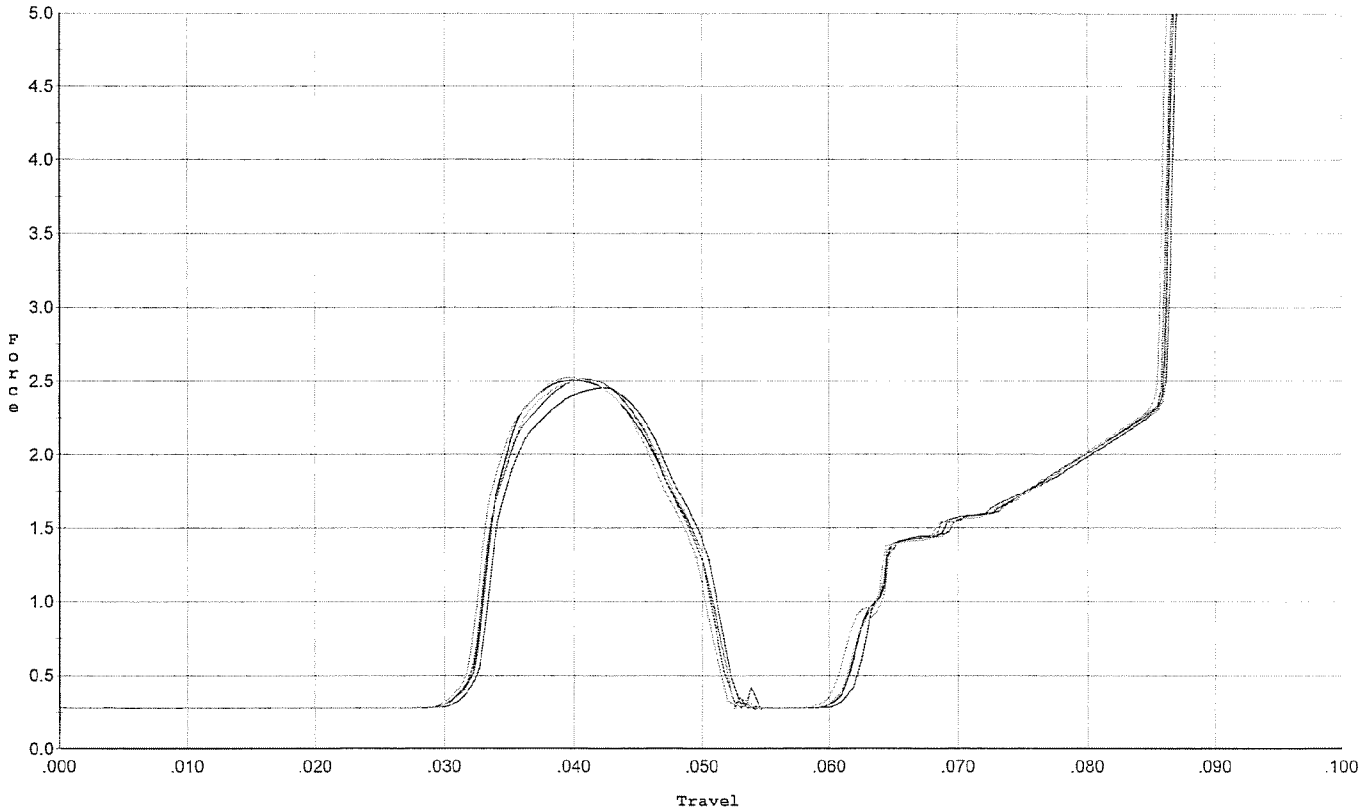
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.540	0.052	0.035	0.040	0.045		Set Trigger
2	2.551	0.052	0.035	0.040	0.044		Set Trigger
3	2.615	0.053	0.035	0.040	0.047		Set Trigger
4	2.523	0.052	0.034	0.040	0.045		Set Trigger
5	2.548	0.051	0.034	0.040	0.045		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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



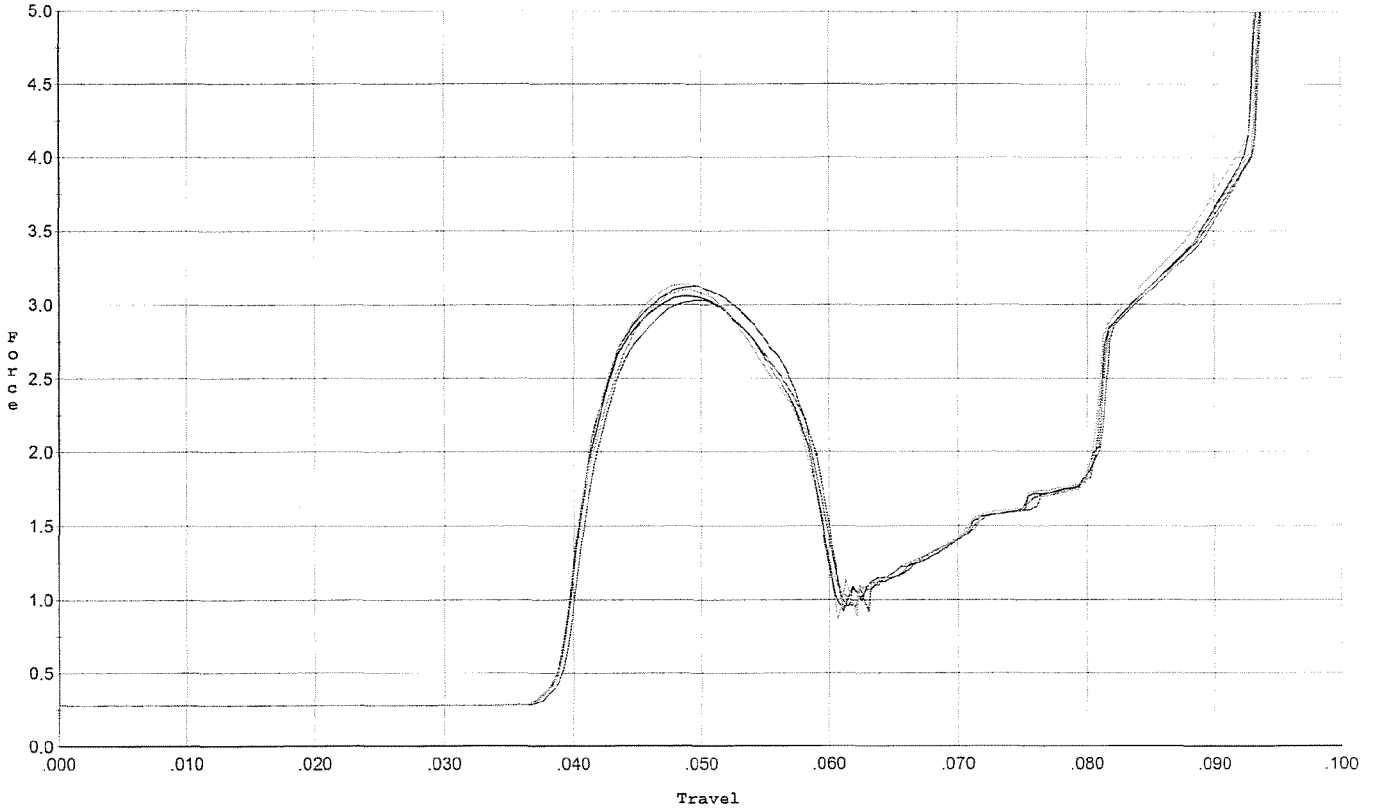
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.456	0.051	0.032	0.041	0.045		Set Trigger
2	2.507	0.051	0.032	0.040	0.047		Set Trigger
3	2.512	0.050	0.032	0.041	0.046		Set Trigger
4	2.521	0.051	0.032	0.040	0.047		Set Trigger
5	2.525	0.050	0.032	0.041	0.046		Set Trigger

Arg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/16/08

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



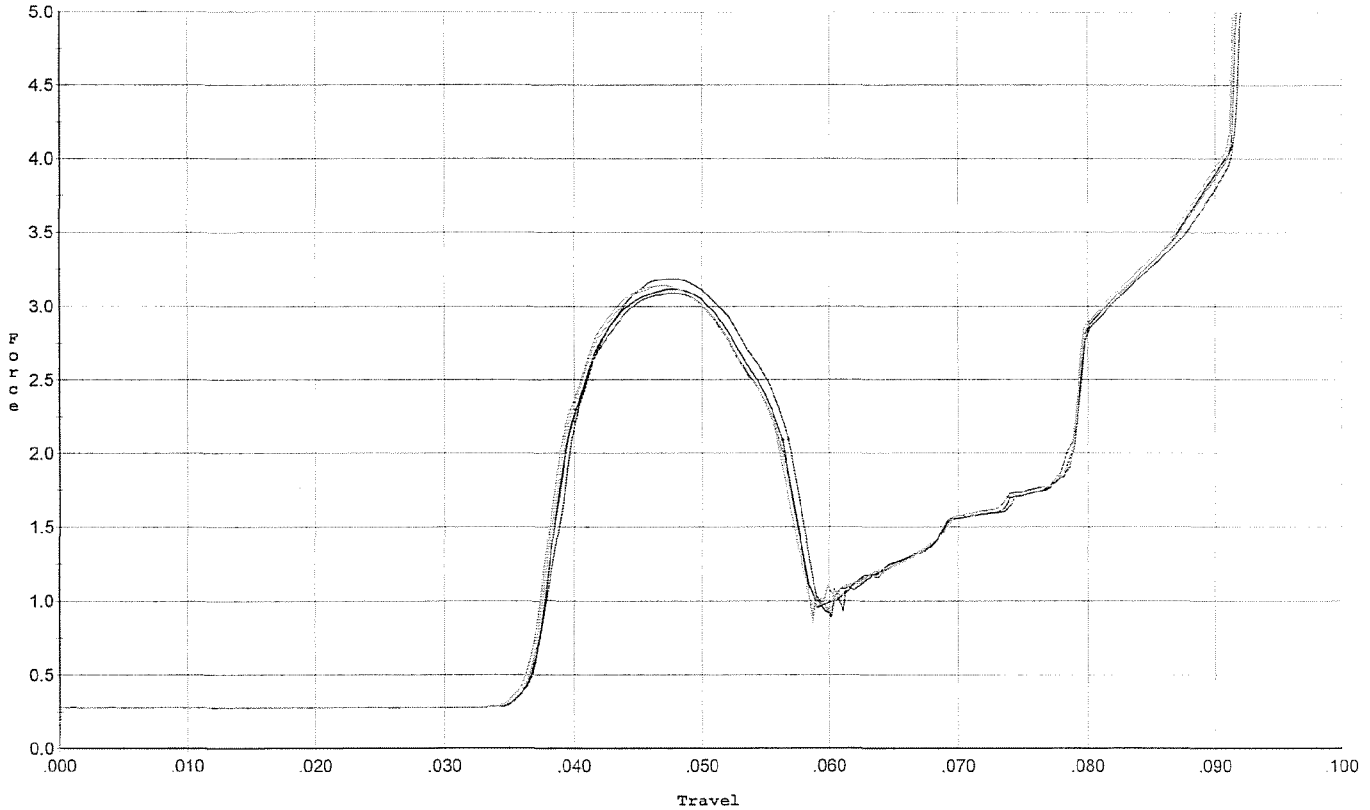
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.122	0.058	0.038	0.040	0.062		Set Trigger
2	3.058	0.058	0.039	0.040	0.061		Set Trigger
3	3.028	0.059	0.039	0.040	0.061		Set Trigger
4	3.139	0.059	0.039	0.040	0.062		Set Trigger
5	3.103	0.058	0.039	0.040	0.061		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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



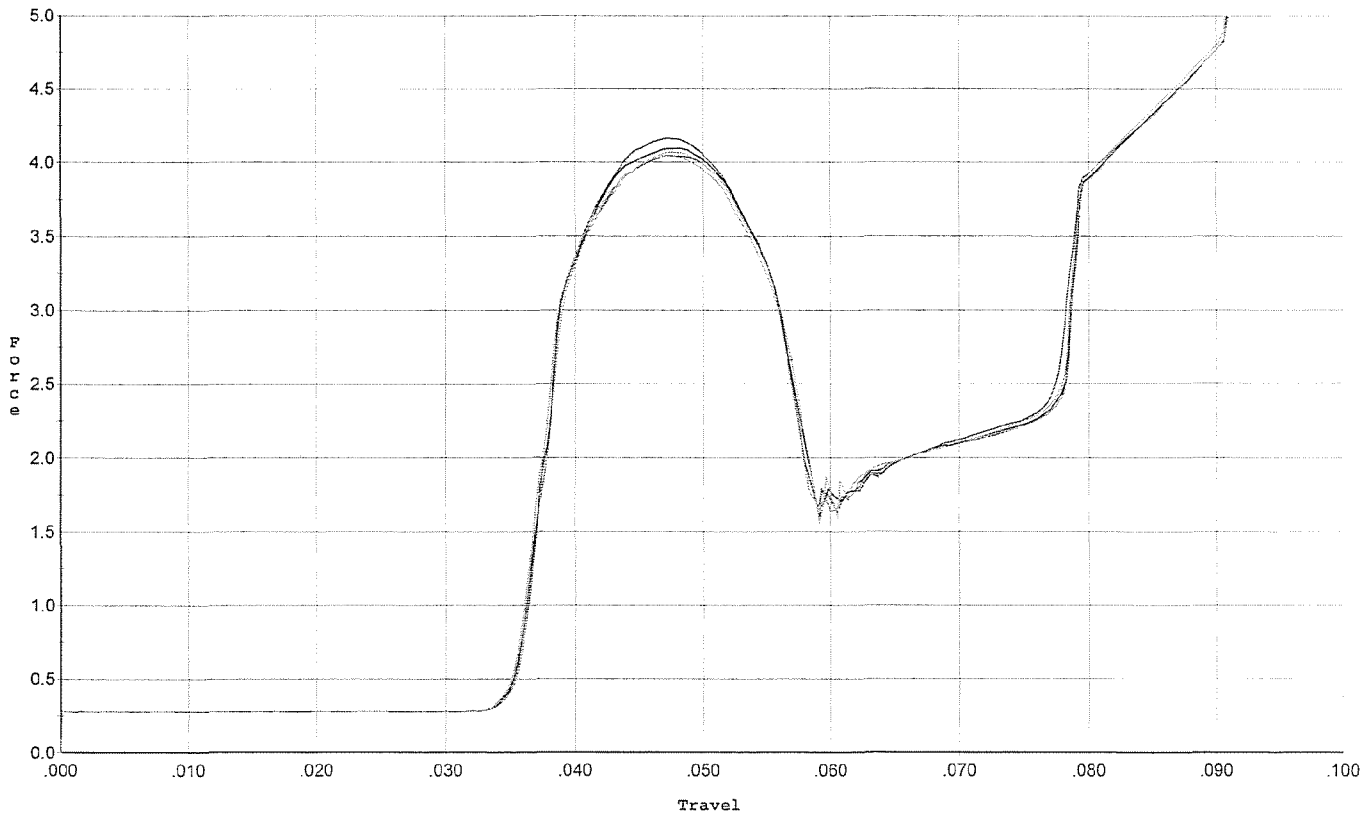
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.186	0.057	0.037	0.039	0.063		Set Trigger
2	3.115	0.056	0.037	0.039	0.061		Set Trigger
3	3.089	0.057	0.036	0.039	0.061		Set Trigger
4	3.144	0.057	0.036	0.039	0.062		Set Trigger
5	3.139	0.056	0.036	0.039	0.061		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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



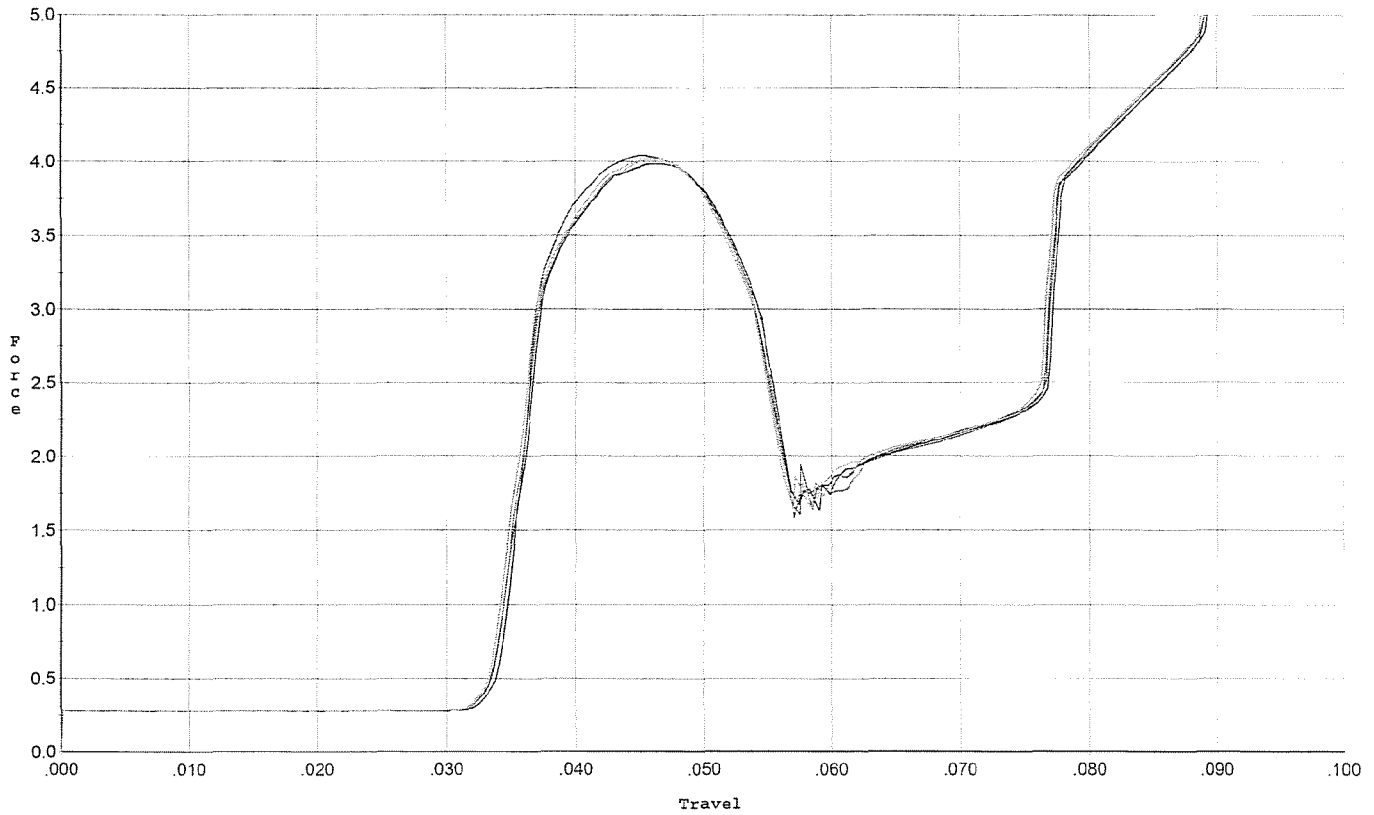
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.056	0.035	0.037	0.081		Set Trigger
2	4.095	0.056	0.035	0.037	0.081		Set Trigger
3	4.045	0.057	0.035	0.037	0.083		Set Trigger
4	4.068	0.057	0.035	0.037	0.082		Set Trigger
5	4.044	0.056	0.035	0.037	0.081		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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



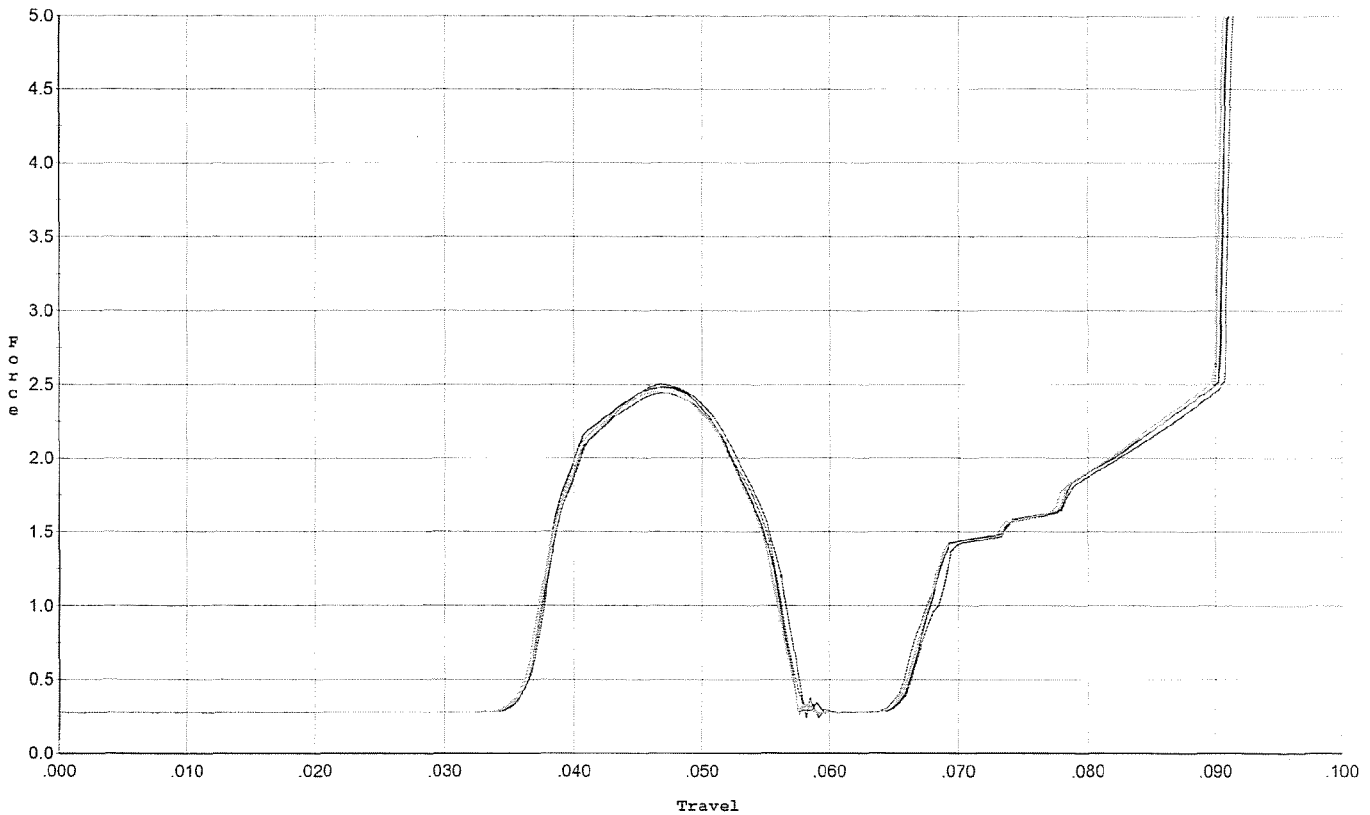
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.041	0.054	0.033	0.037	0.079		Set Trigger
2	3.985	0.055	0.034	0.036	0.080		Set Trigger
3	3.985	0.055	0.033	0.036	0.081		Set Trigger
4	4.026	0.054	0.033	0.036	0.079		Set Trigger
5	4.018	0.054	0.033	0.036	0.079		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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



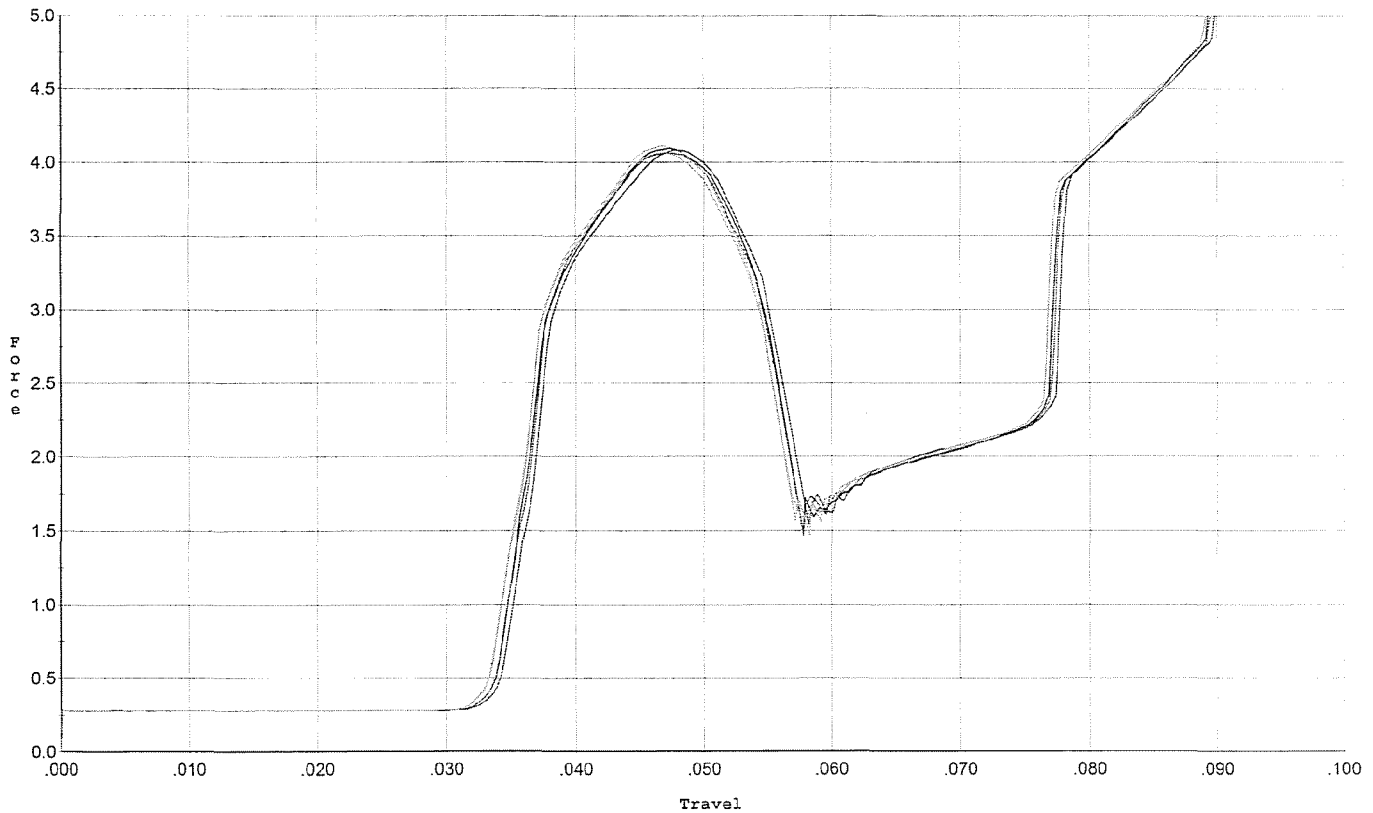
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.504	0.056	0.036	0.040	0.050		Set Trigger
2	2.480	0.056	0.036	0.040	0.049		Set Trigger
3	2.441	0.055	0.036	0.040	0.048		Set Trigger
4	2.450	0.056	0.036	0.040	0.049		Set Trigger
5	2.477	0.056	0.036	0.040	0.049		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/16/08

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	4.082	0.056	0.034	0.037	0.082		Set Trigger
2	4.093	0.055	0.034	0.036	0.081		Set Trigger
3	4.062	0.055	0.034	0.037	0.081		Set Trigger
4	4.113	0.054	0.033	0.037	0.080		Set Trigger
5	4.066	0.055	0.033	0.036	0.080		Set Trigger

Avg 4.08