

G6784592

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

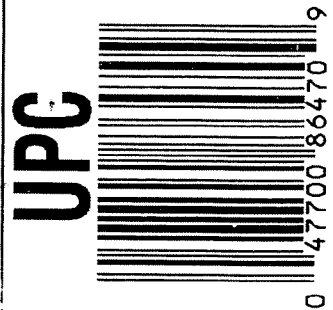


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6784592



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6784592

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8/29/08	RT
420	ASSEMBLE ACTION		8-28-08	SP
430	ASSEMBLE TO STOCK		8-28-08	SP
440	PROOF		8-28-08	SP
460	CHECK HEADSPACE		8-28-08	SP
470	DIS-ASSEMBLE ACTION		8-28-08	SP
480	MAGNAFLUX BBL ACTION		9-2-08	BT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/3/08	RT
510	DRILL AND TAP SIGHT HOLES		8-29-08	SP
520	GOFF BLAST BBL / REC		9/4/08	DC
530 & 540	APPLY COATINGS (BARREL ACTION)		9/8	uc
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-13-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-13-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-13-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-15-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

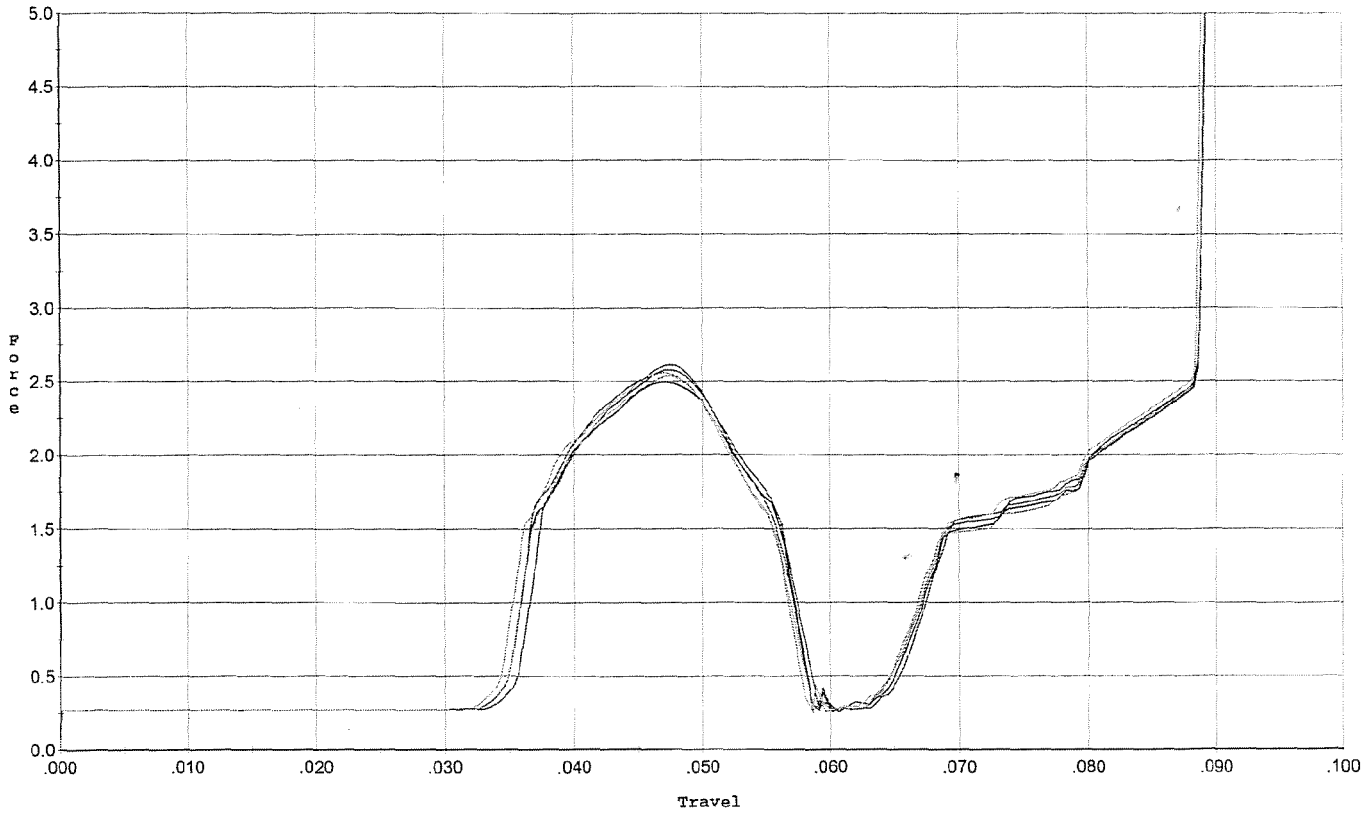
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-22-08	TC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.5</u> <u>6.5</u> <u>7</u>	9-22-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	9-22-08	TC
	J) ASSEMBLE STOCK		9-15-08	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		9-22-08	TC
	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	9-16-08	FM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-16-08	AA
670	FINAL INSPECTION A) HEADSPACE		9-22-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u> <u>2.43</u> <u>2.40</u> <u>2.34</u> <u>2.39</u>	9-18-08	TC
	C) FUNCTION		9-22-08	TC
690	PACK		10/13/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/19/08

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



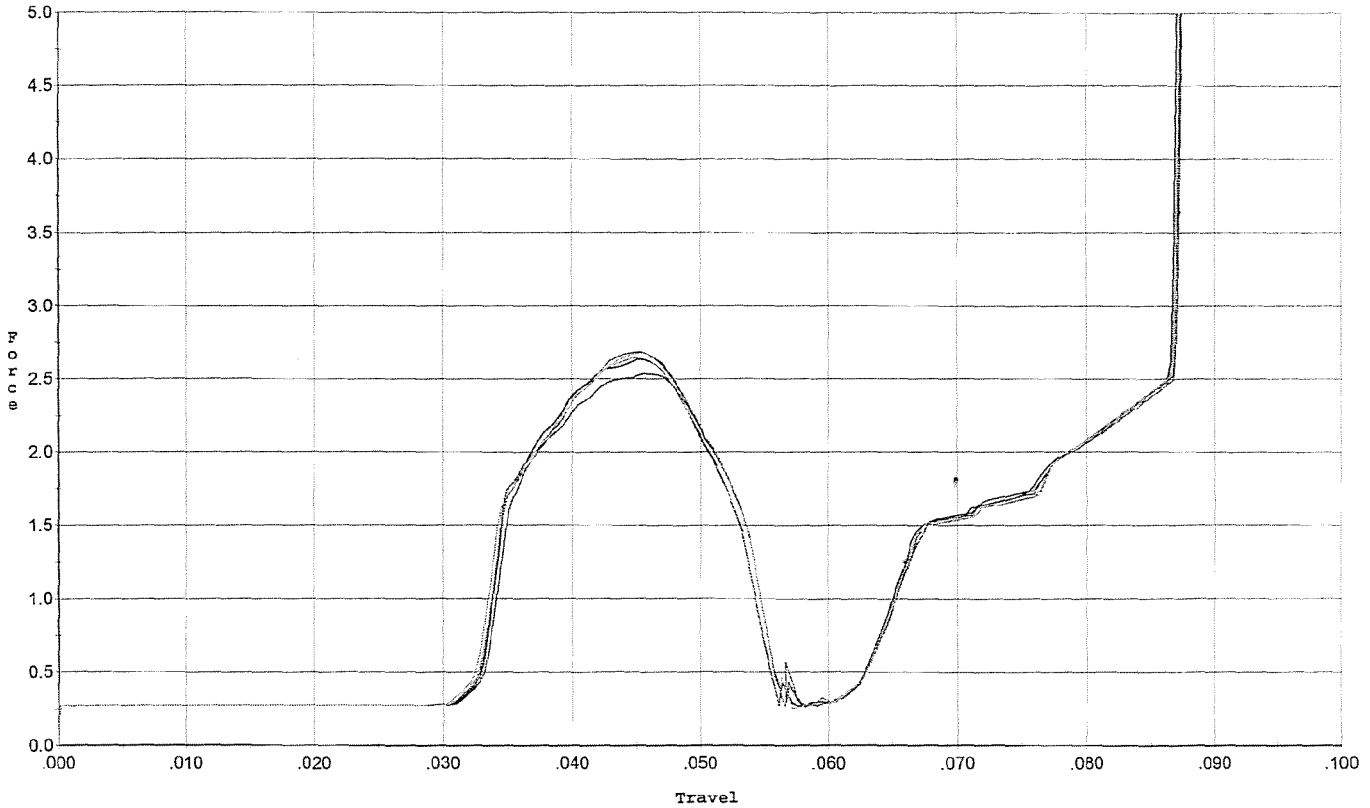
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.575	0.056	0.036	0.038	0.053		Set Trigger
2	2.494	0.056	0.035	0.038	0.053		Set Trigger
3	2.615	0.057	0.035	0.038	0.054		Set Trigger
4	2.535	0.056	0.035	0.038	0.052		Set Trigger
5	2.555	0.056	0.034	0.038	0.053		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/19/08

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



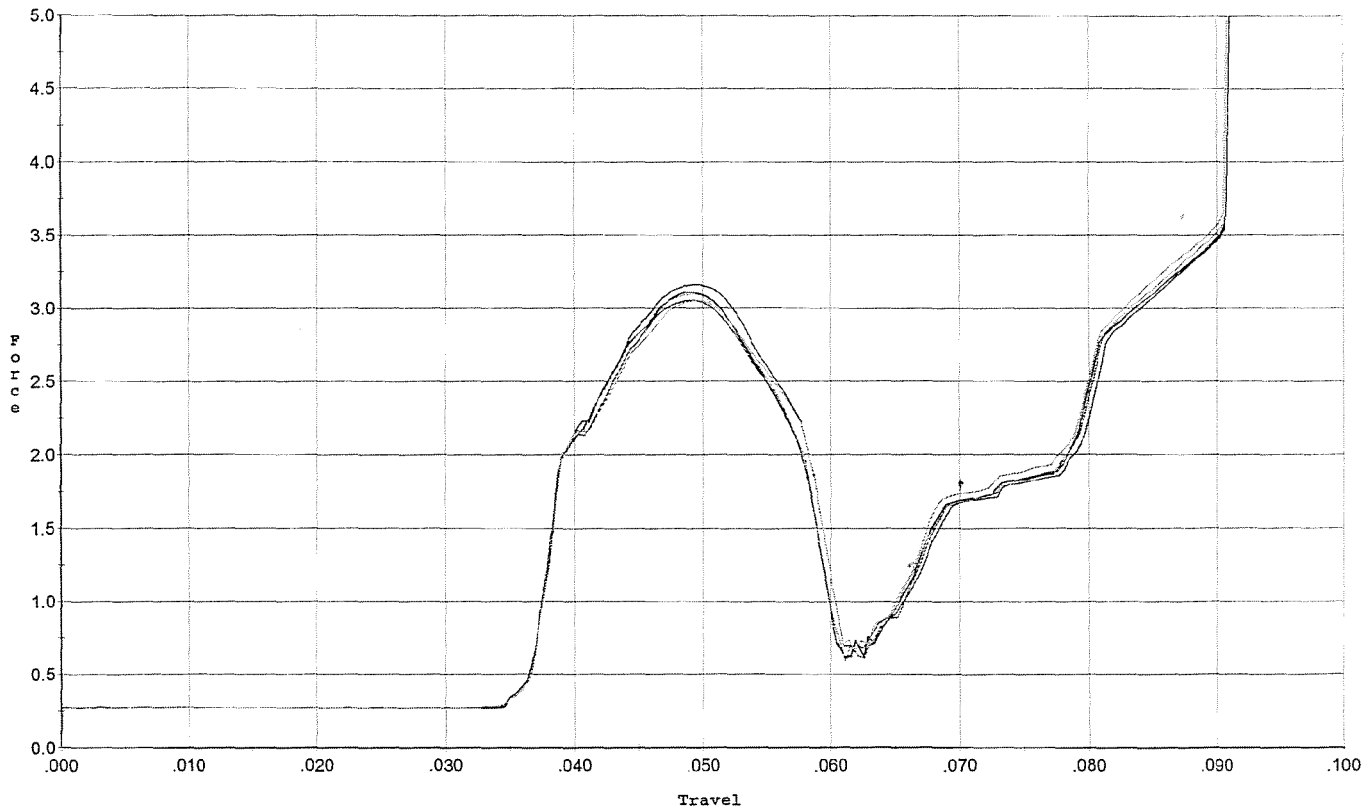
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.533	0.054	0.033	0.038	0.052		Set Trigger
2	2.632	0.053	0.033	0.038	0.052		Set Trigger
3	2.684	0.054	0.033	0.038	0.054		Set Trigger
4	2.677	0.054	0.033	0.038	0.054		Set Trigger
5	2.645	0.053	0.033	0.038	0.053		Set Trigger

AVG 2.63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/19/08

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



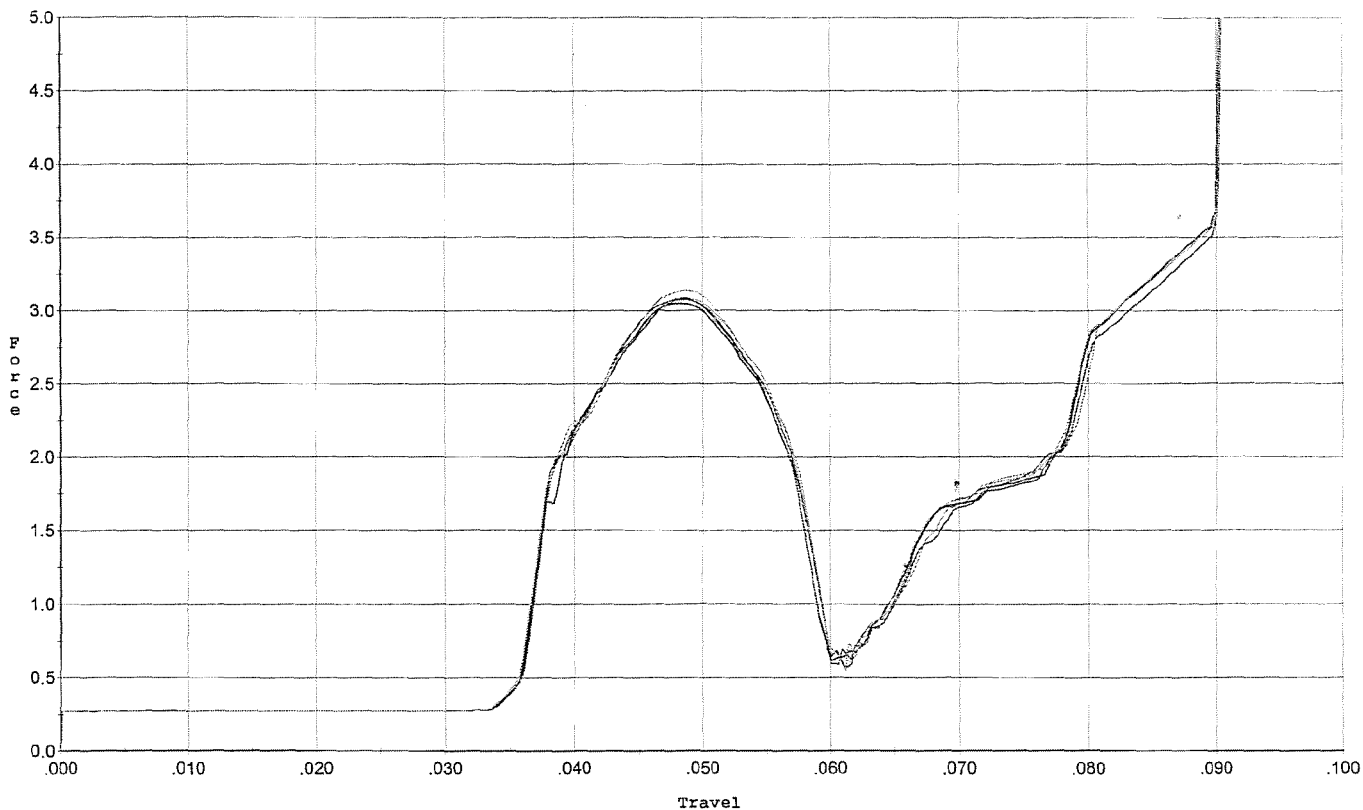
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.059	0.035	0.037	0.066		Set Trigger
2	3.109	0.058	0.037	0.038	0.064		Set Trigger
3	3.055	0.058	0.035	0.038	0.063		Set Trigger
4	3.055	0.059	0.037	0.038	0.064		Set Trigger
5	3.098	0.058	0.037	0.038	0.064		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/19/08

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



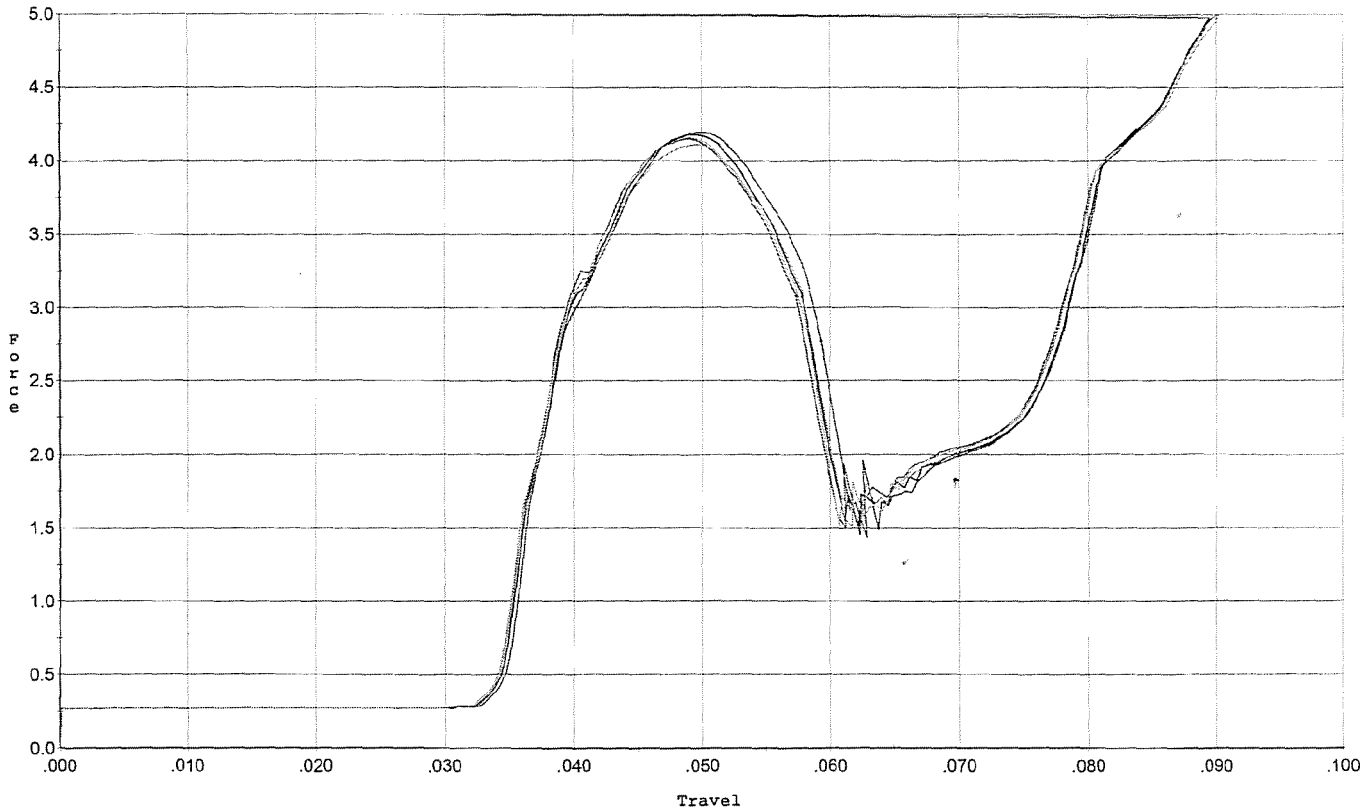
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.058	0.036	0.037	0.064		Set Trigger
2	3.050	0.057	0.036	0.038	0.062		Set Trigger
3	3.075	0.057	0.036	0.038	0.063		Set Trigger
4	3.091	0.058	0.036	0.037	0.065		Set Trigger
5	3.139	0.058	0.036	0.037	0.064		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/19/08

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



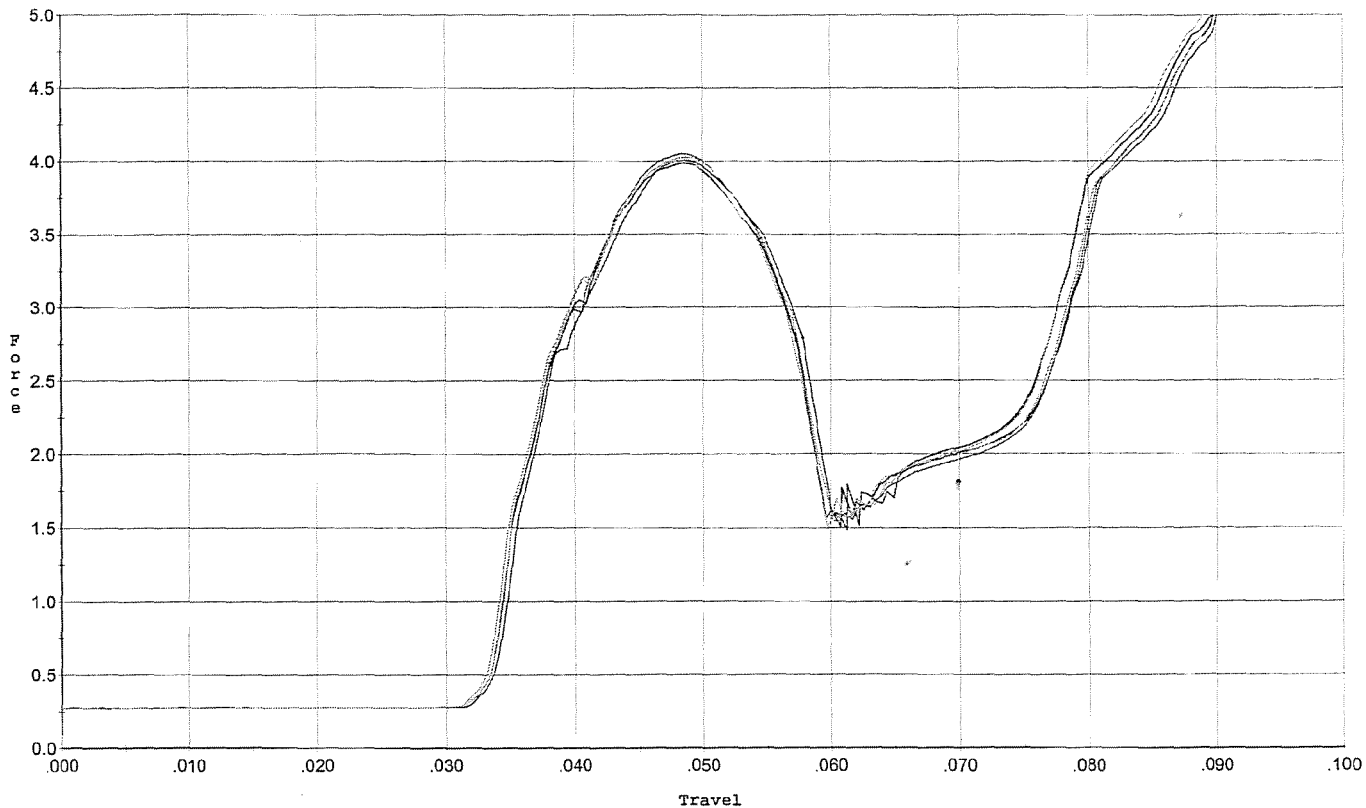
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.059	0.035	0.035	0.092		Set Trigger
2	4.179	0.058	0.034	0.036	0.088		Set Trigger
3	4.147	0.057	0.034	0.036	0.087		Set Trigger
4	4.157	0.058	0.034	0.036	0.089		Set Trigger
5	4.110	0.058	0.034	0.036	0.088		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/19/08

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



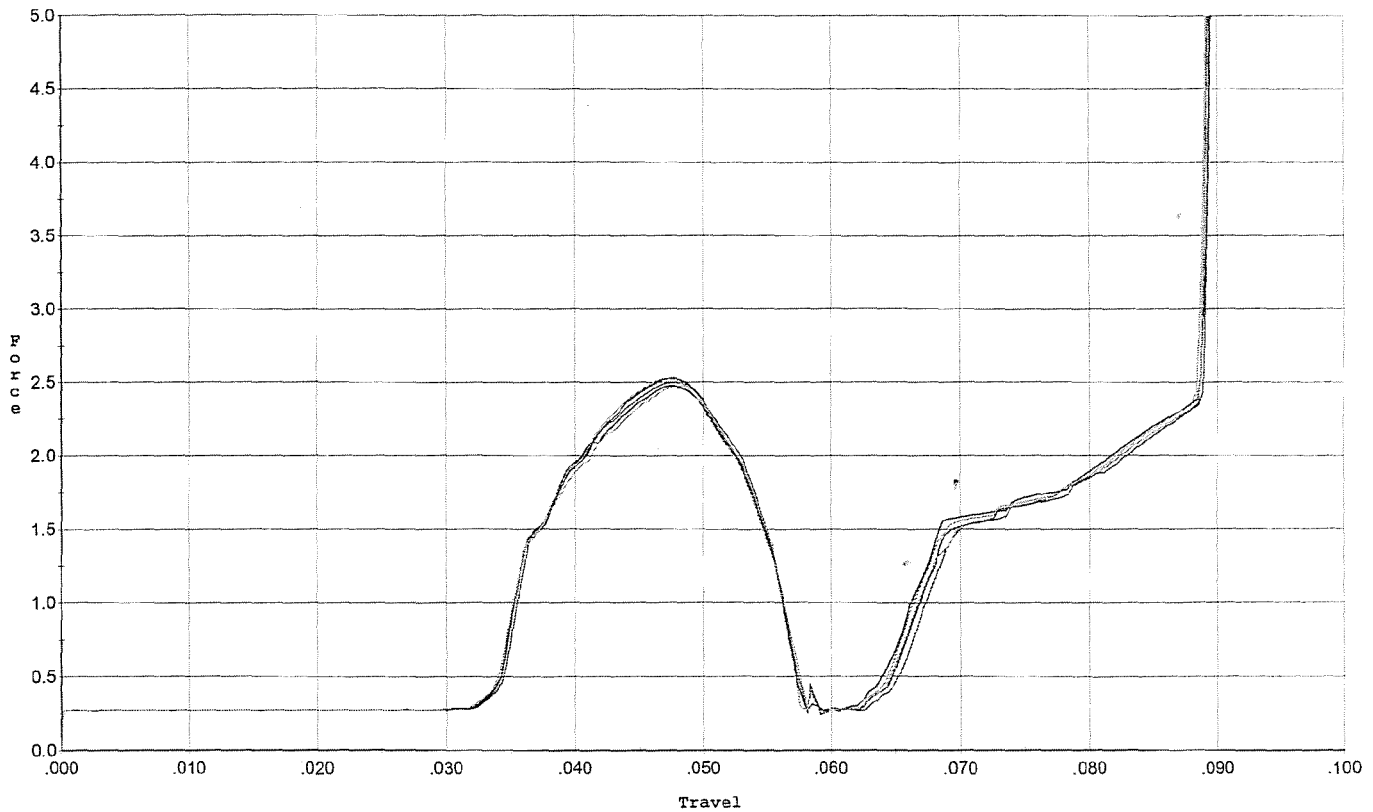
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.007	0.058	0.033	0.035	0.086		Set Trigger
2	3.990	0.057	0.033	0.035	0.085		Set Trigger
3	4.053	0.057	0.033	0.035	0.085		Set Trigger
4	4.004	0.058	0.033	0.035	0.086		Set Trigger
5	4.027	0.057	0.033	0.035	0.085		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/19/08

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



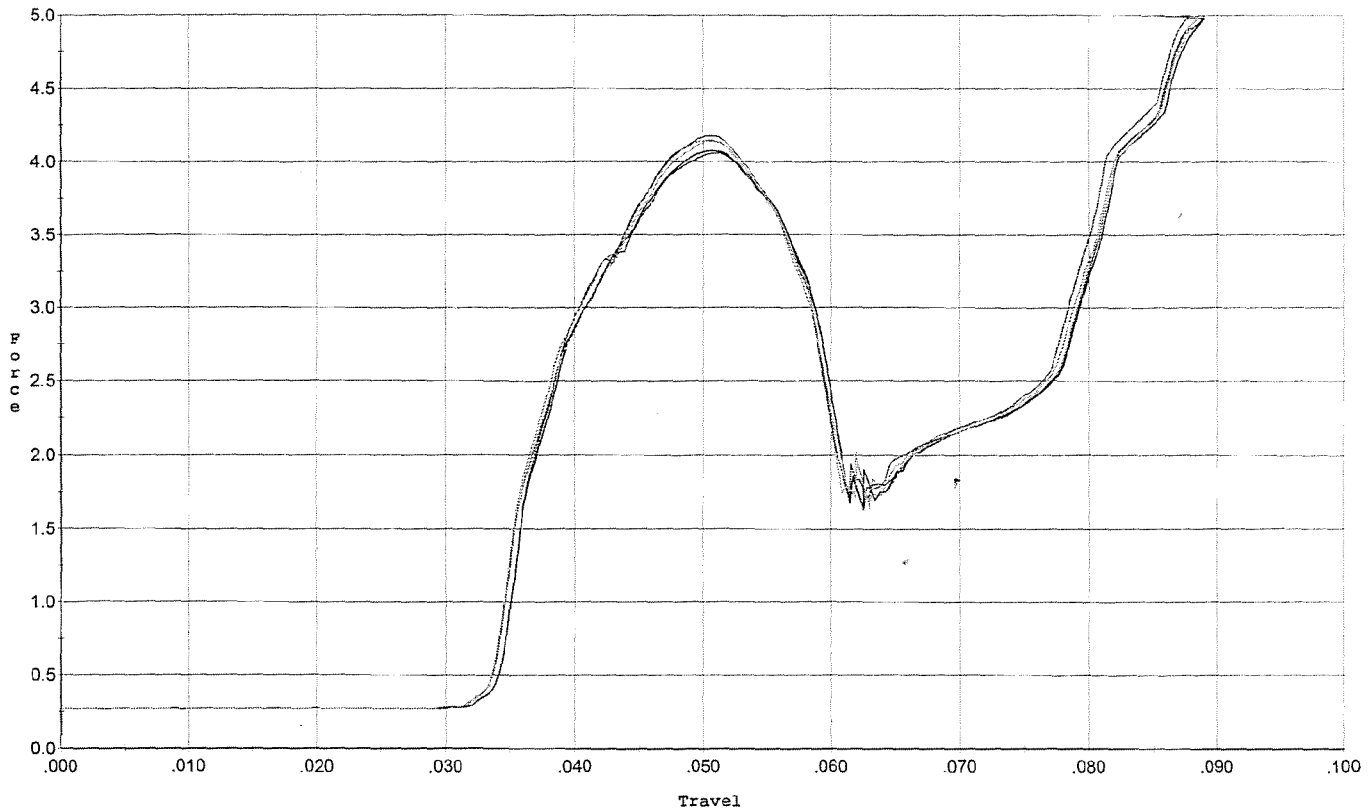
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.529	0.055	0.034	0.039	0.051		Set Trigger
2	2.474	0.056	0.034	0.039	0.051		Set Trigger
3	2.498	0.055	0.034	0.039	0.051		Set Trigger
4	2.477	0.055	0.034	0.038	0.051		Set Trigger
5	2.524	0.056	0.034	0.038	0.051		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/19/08

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	4.058	0.059	0.034	0.036	0.090		Set Trigger
2	4.074	0.059	0.034	0.036	0.091		Set Trigger
3	4.177	0.058	0.034	0.035	0.090		Set Trigger
4	4.139	0.058	0.034	0.036	0.090		Set Trigger
5	4.147	0.058	0.033	0.035	0.091		Set Trigger

Avg 4.11