

66863614

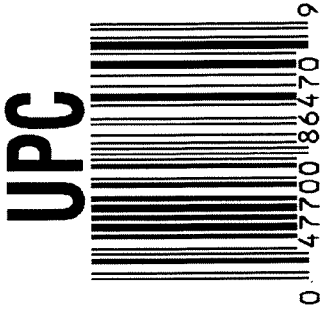
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6863614



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863614

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SPD
430	ASSEMBLE TO STOCK		6-10-09	SPD
440	PROOF		6-10-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	6-10-09	RP
470	DIS-ASSEMBLE ACTION		6-10-09	RP
472	SERIALIZE BOLT HANDLE		6-10-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(D)</u>	6/13/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/16/09	RTW
540	APPLY COATINGS (BARREL ACTION)		2/2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-7-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-7-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-7-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

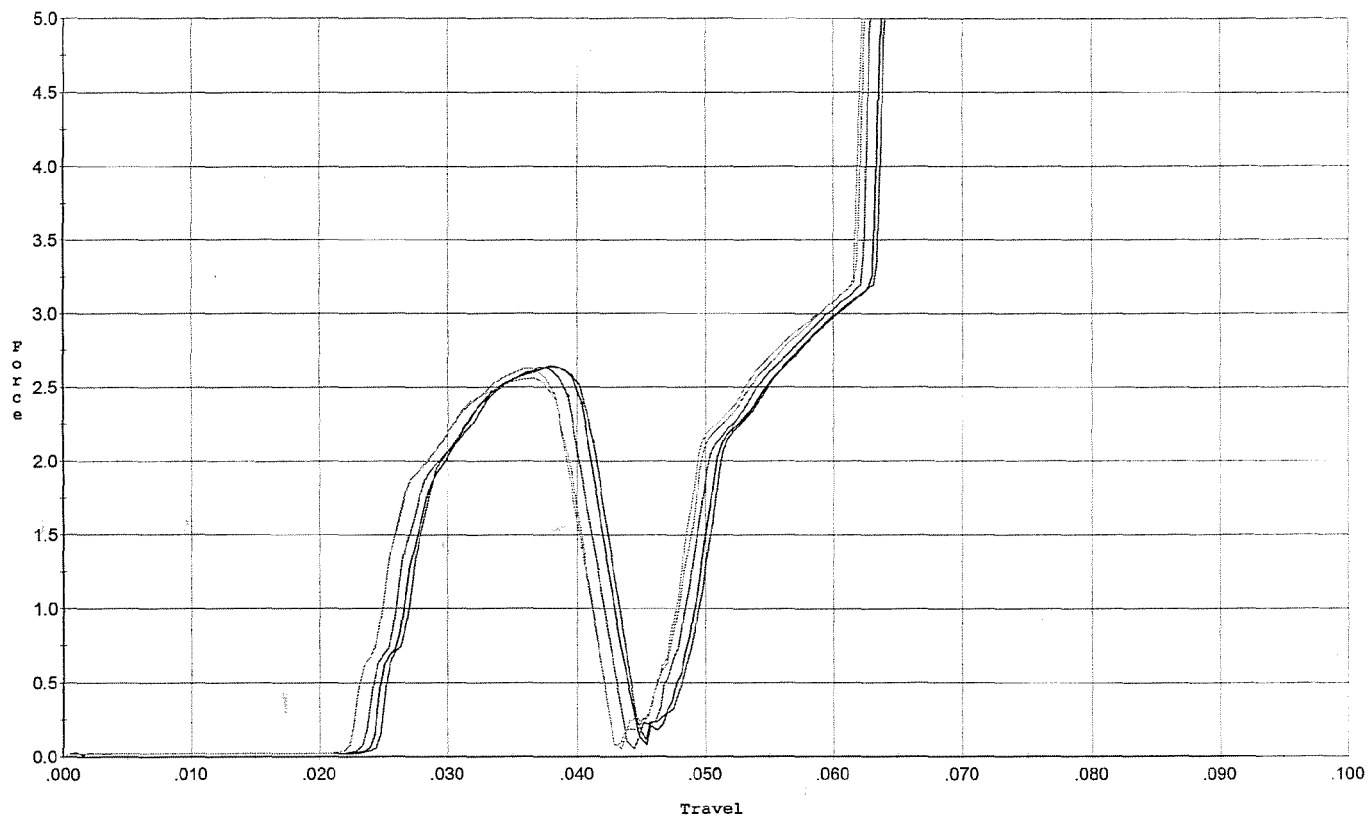
OP #	OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2°</u>	<u>2°</u>	<u>2°</u>	8/28/09	RB		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>7°</u>	<u>7°</u>	<u>7°</u>	8/28/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	8/28/09	RB		
	J) ASSEMBLE STOCK					8-25-09	R.P.D.		
	K) ASSEMBLE SWIVEL STUDS					8/28/09	RL		
	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		8-26-09 R.P.D.			
			<u>PASS</u>	FAIL					
	MALFUNCTION		N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					8-26-09	RP		
670	FINAL INSPECTION A) HEADSPACE					8/28/09	RL		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u>	<u>2.79</u>	<u>2.78</u>	<u>2.40</u>	<u>2.80</u>	8/27/09	RP
	C) FUNCTION					8/28/09	RL		
690	PACK					8-28-09	TL		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



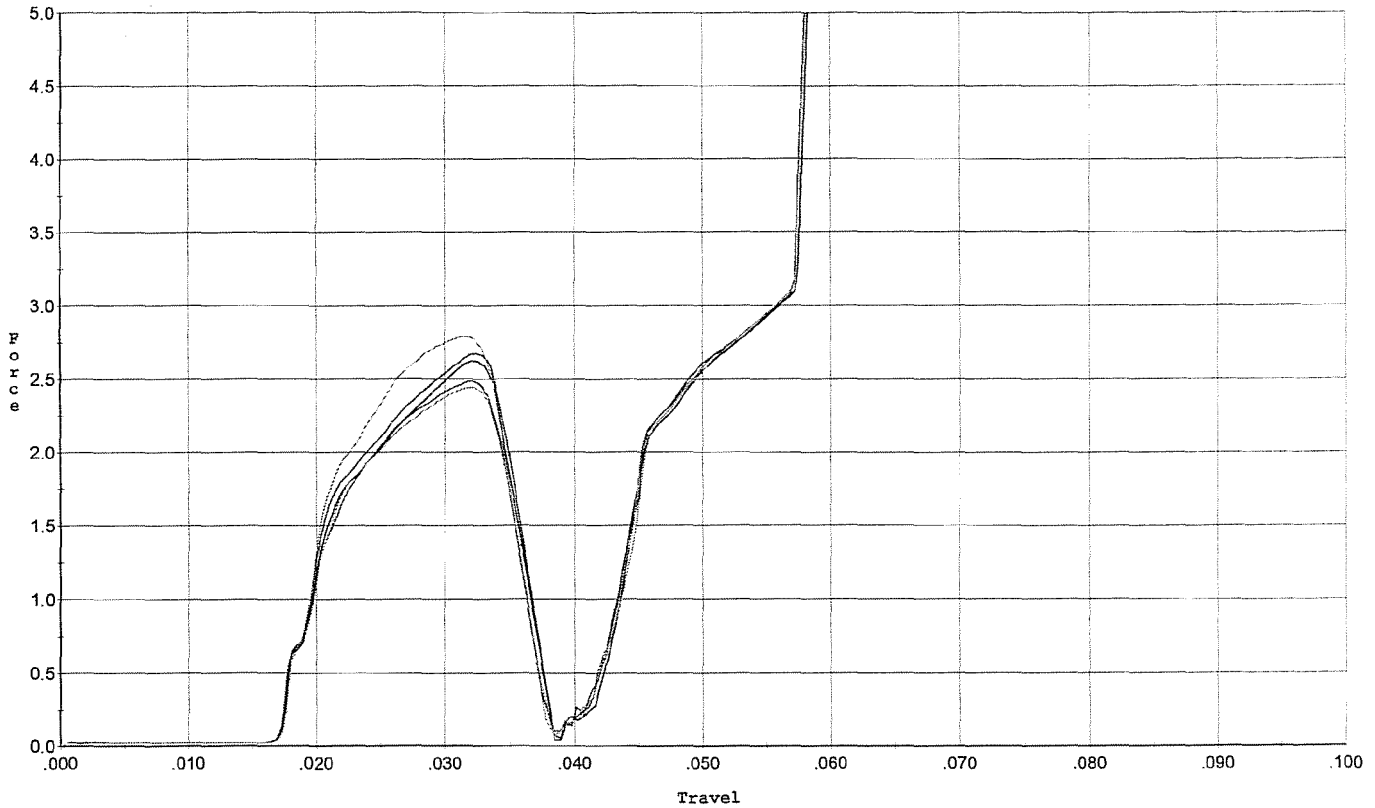
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.640	0.041	0.025	0.027	0.036		Set Trigger
2	2.647	0.040	0.024	0.027	0.035		Set Trigger
3	2.635	0.039	0.024	0.027	0.034		Set Trigger
4	2.563	0.040	0.023	0.027	0.035		Set Trigger
5	2.627	0.040	0.023	0.027	0.036		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



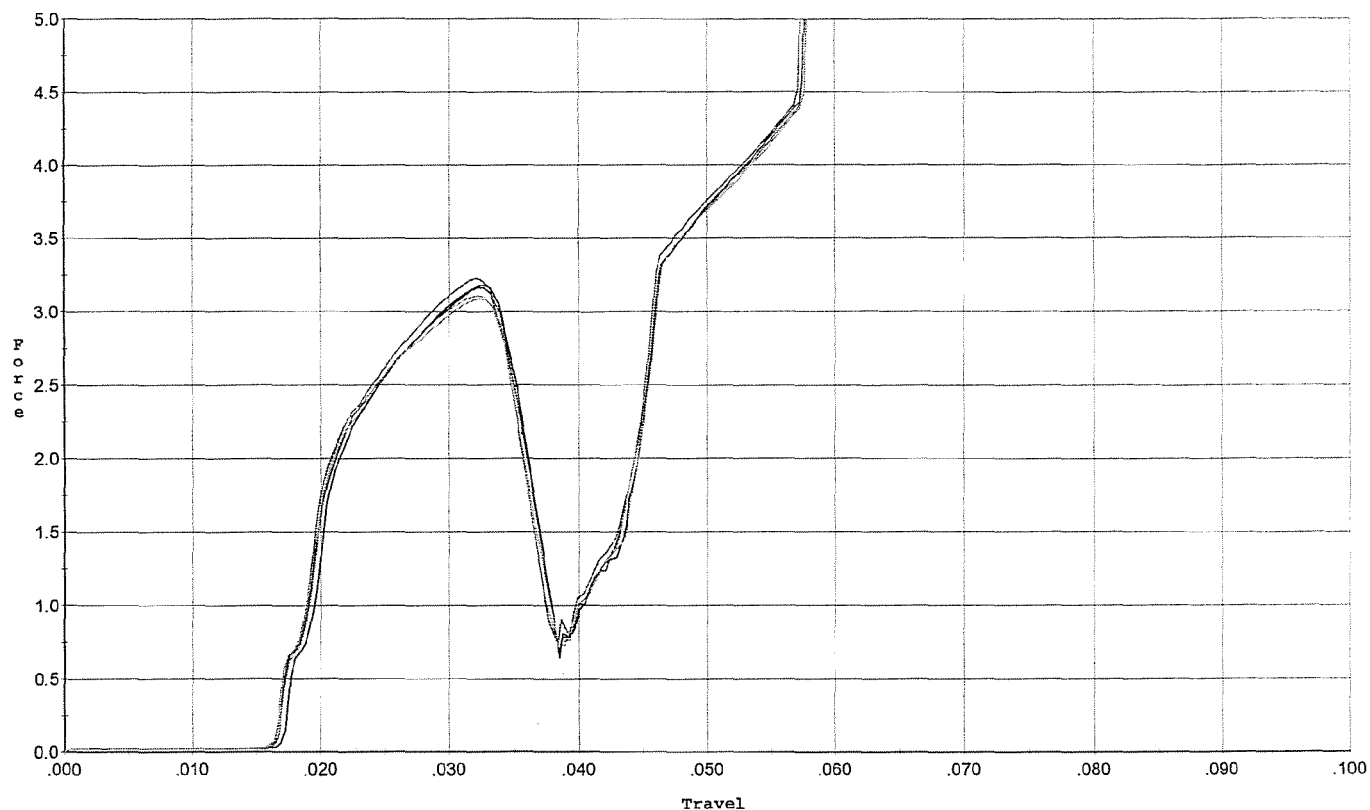
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.035	0.017	0.027	0.036		Set Trigger
2	2.622	0.036	0.017	0.027	0.036		Set Trigger
3	2.487	0.034	0.017	0.027	0.033		Set Trigger
4	2.443	0.035	0.018	0.027	0.033		Set Trigger
5	2.791	0.034	0.017	0.027	0.036		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



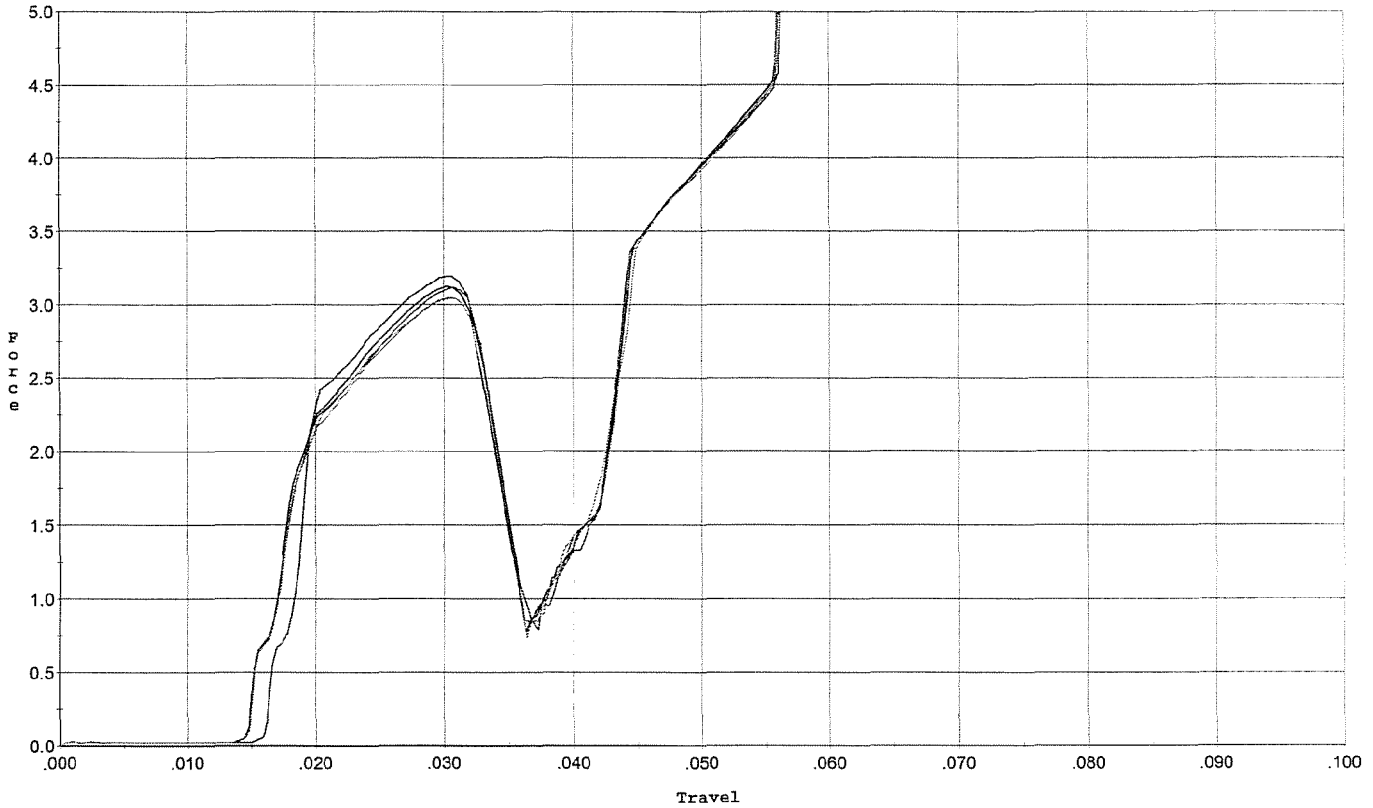
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.164	0.036	0.017	0.025	0.045		Set Trigger
2	3.180	0.035	0.017	0.025	0.044		Set Trigger
3	3.226	0.034	0.017	0.025	0.044		Set Trigger
4	3.108	0.034	0.017	0.025	0.043		Set Trigger
5	3.088	0.034	0.017	0.025	0.042		Set Trigger

A 3.15

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/13/2009

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



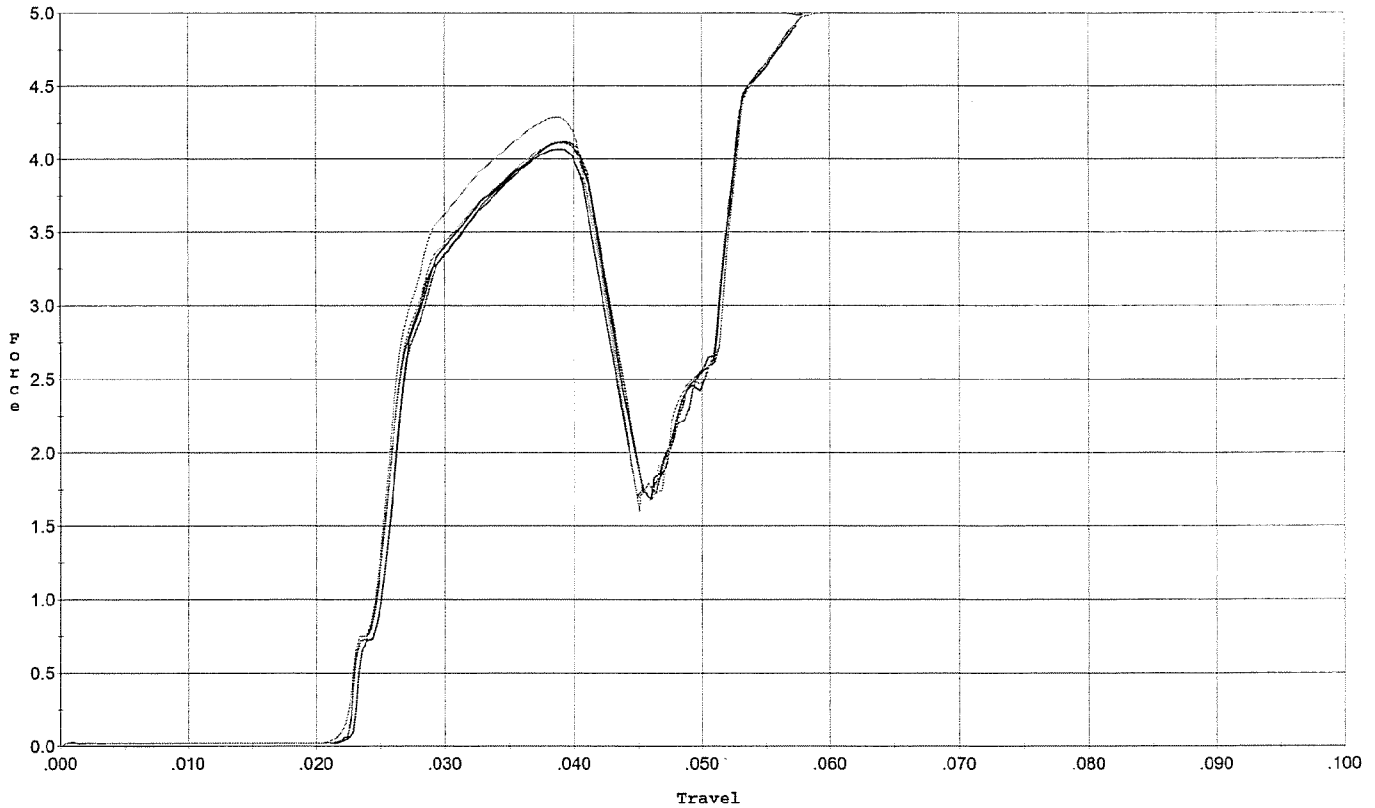
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.190	0.033	0.016	0.025	0.043		Set Trigger
2	3.125	0.034	0.015	0.024	0.045		Set Trigger
3	3.120	0.033	0.015	0.025	0.043		Set Trigger
4	3.042	0.034	0.015	0.024	0.043		Set Trigger
5	3.048	0.034	0.015	0.025	0.043		Set Trigger

A. 3.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/13/2009

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



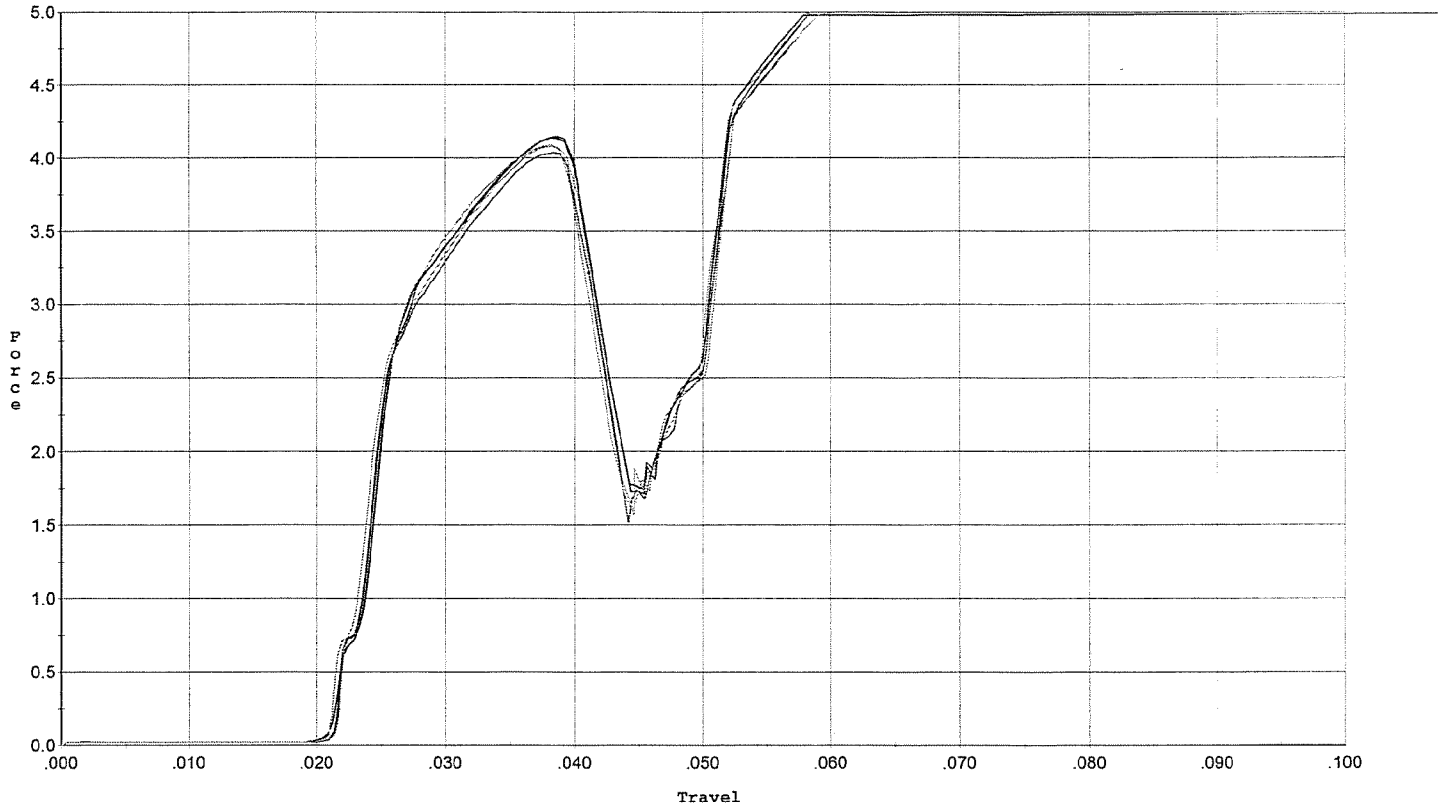
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.065	0.041	0.023	0.025	0.060		Set Trigger
2	4.113	0.041	0.023	0.025	0.061		Set Trigger
3	4.119	0.041	0.023	0.025	0.061		Set Trigger
4	4.285	0.042	0.022	0.025	0.066		Set Trigger
5	4.115	0.042	0.023	0.025	0.063		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



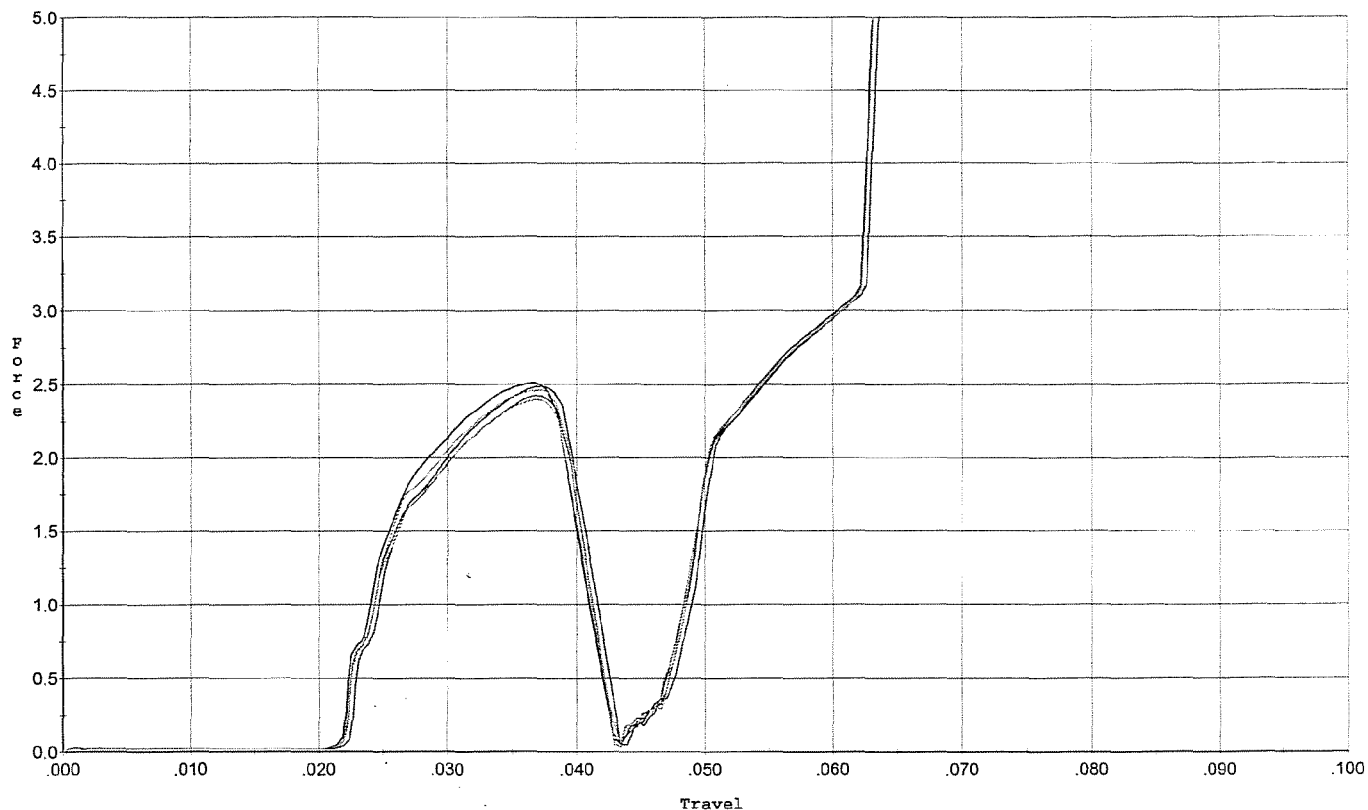
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.146	0.040	0.022	0.024	0.061		Set Trigger
2	4.138	0.040	0.021	0.025	0.061		Set Trigger
3	4.035	0.041	0.022	0.024	0.062		Set Trigger
4	4.080	0.040	0.022	0.024	0.061		Set Trigger
5	4.089	0.040	0.021	0.024	0.061		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/13/2009

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



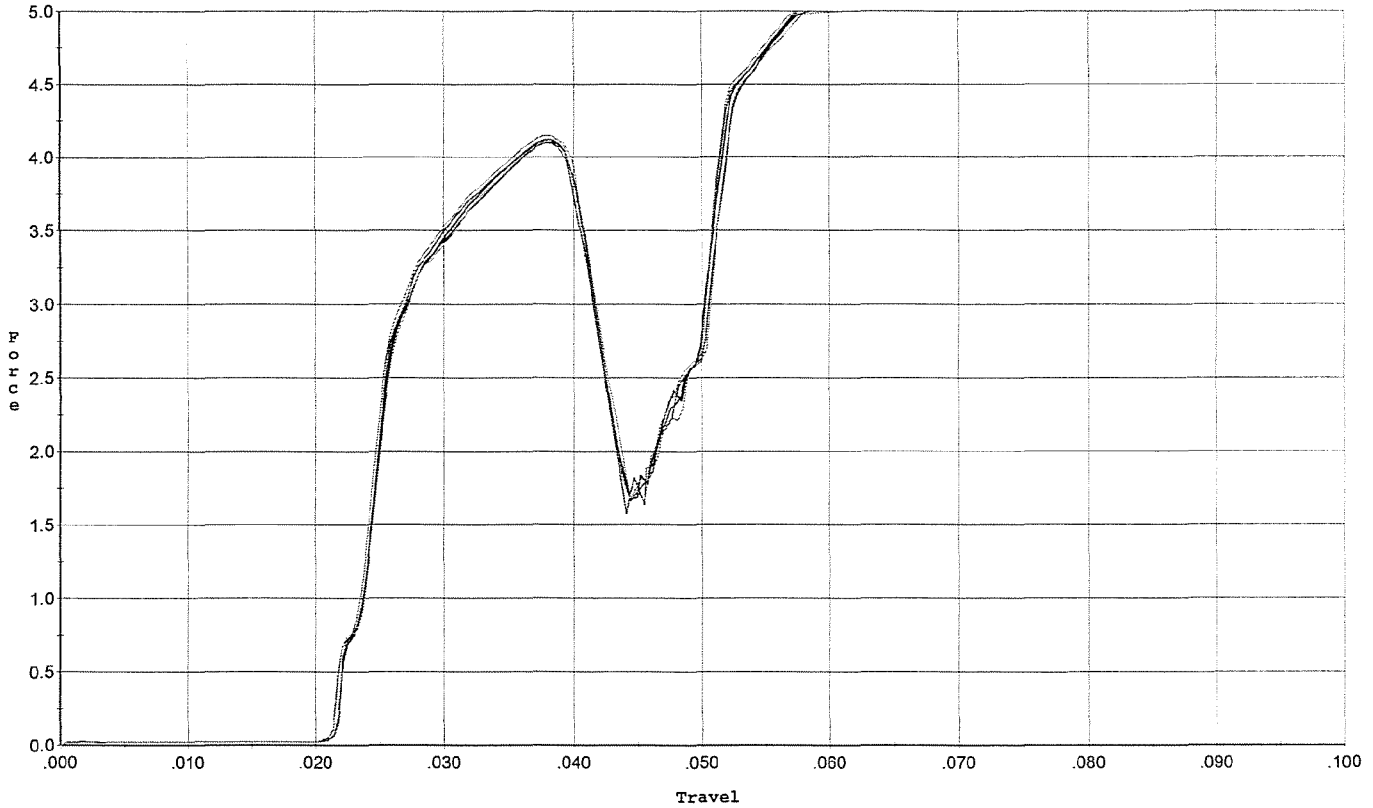
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.041	0.023	0.028	0.035		Set Trigger
2	2.510	0.038	0.022	0.028	0.034		Set Trigger
3	2.420	0.039	0.022	0.028	0.033		Set Trigger
4	2.464	0.039	0.022	0.028	0.034		Set Trigger
5	2.398	0.041	0.022	0.028	0.034		Set Trigger

A.2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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	4.104	0.040	0.022	0.025	0.062		Set Trigger
2	4.120	0.040	0.022	0.025	0.062		Set Trigger
3	4.096	0.041	0.021	0.024	0.063		Set Trigger
4	4.122	0.040	0.022	0.025	0.061		Set Trigger
5	4.150	0.040	0.021	0.024	0.063		Set Trigger

A-4.11