

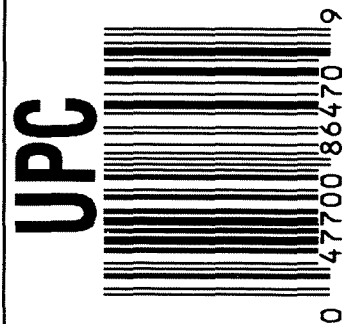
G680 1436

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

G6801436



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6801436

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SPH
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SPH
460	CHECK HEADSPACE	MAGNA - FLUX	5-21-09	SPH
470	DIS-ASSEMBLE ACTION	MAY 20 2009	5-21-09	SPH
472	SERIALIZE BOLT HANDLE		5-22-09	SPH
480	MAGNAFLUX BBL ACTION	OPERATOR <u>SPH</u>	5-29-09	SPH
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-22-09	SP
520	GOFF BLAST BBL / REC		5/29/09	SPH
540	APPLY COATINGS (BARREL ACTION)		6/9	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-9-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-9-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-9-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-17-09	SPH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

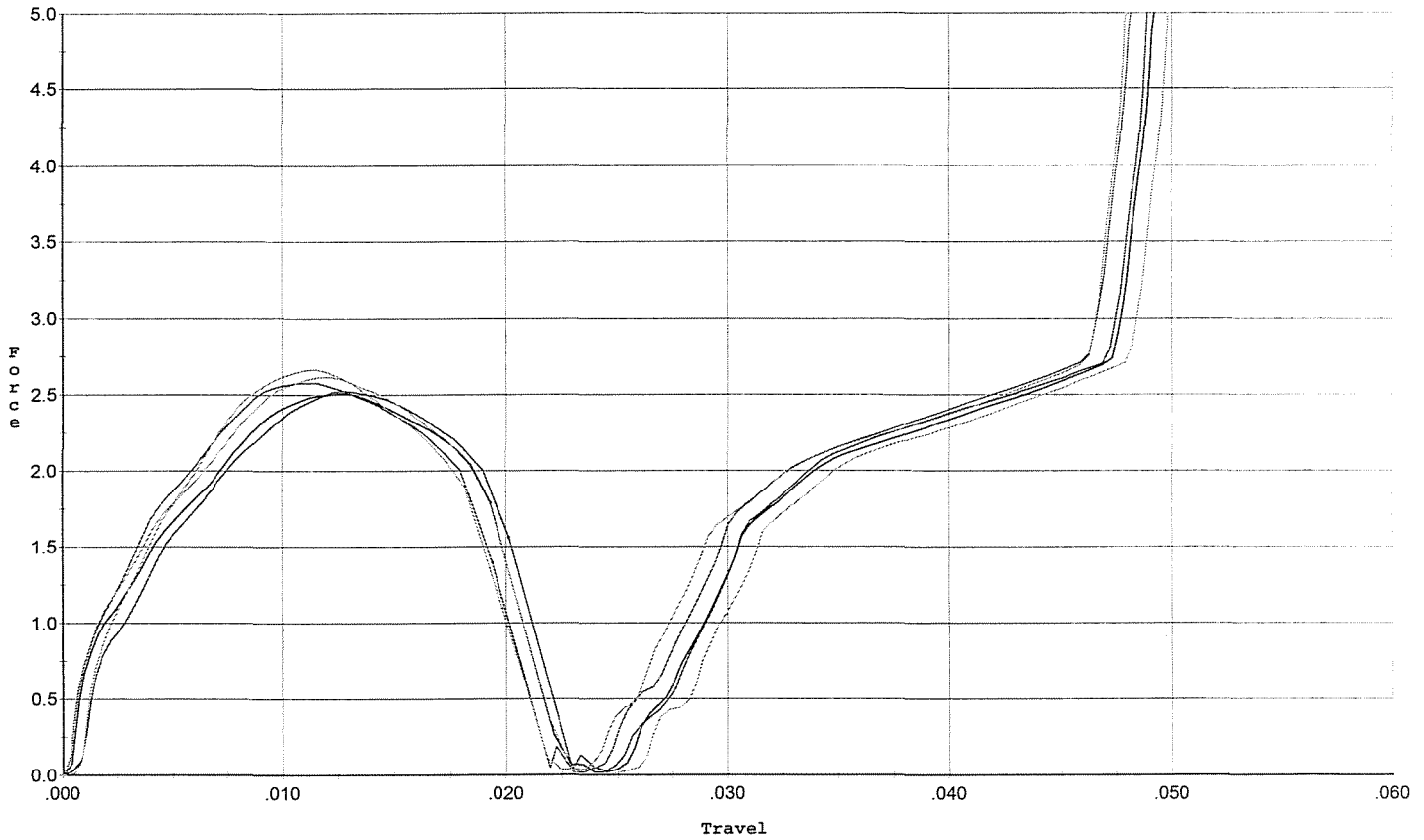
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>5.0</u>	7-24-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>8.0</u> <u>8.0</u> <u>8.0</u>	7-24-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	7-24-09	LN
	J) ASSEMBLE STOCK		6-17-09	LN
	K) ASSEMBLE SWIVEL STUDS		7-24-09	LN
	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	PASS FAIL PASS FAIL	7/23	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/23	TQR
670	FINAL INSPECTION A) HEADSPACE		7-24-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>258</u> <u>246</u> <u>261</u> <u>263</u> <u>246</u>	7-24-09	LN
	C) FUNCTION		7-24-09	LN
690	PACK		7/31/09	Em

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



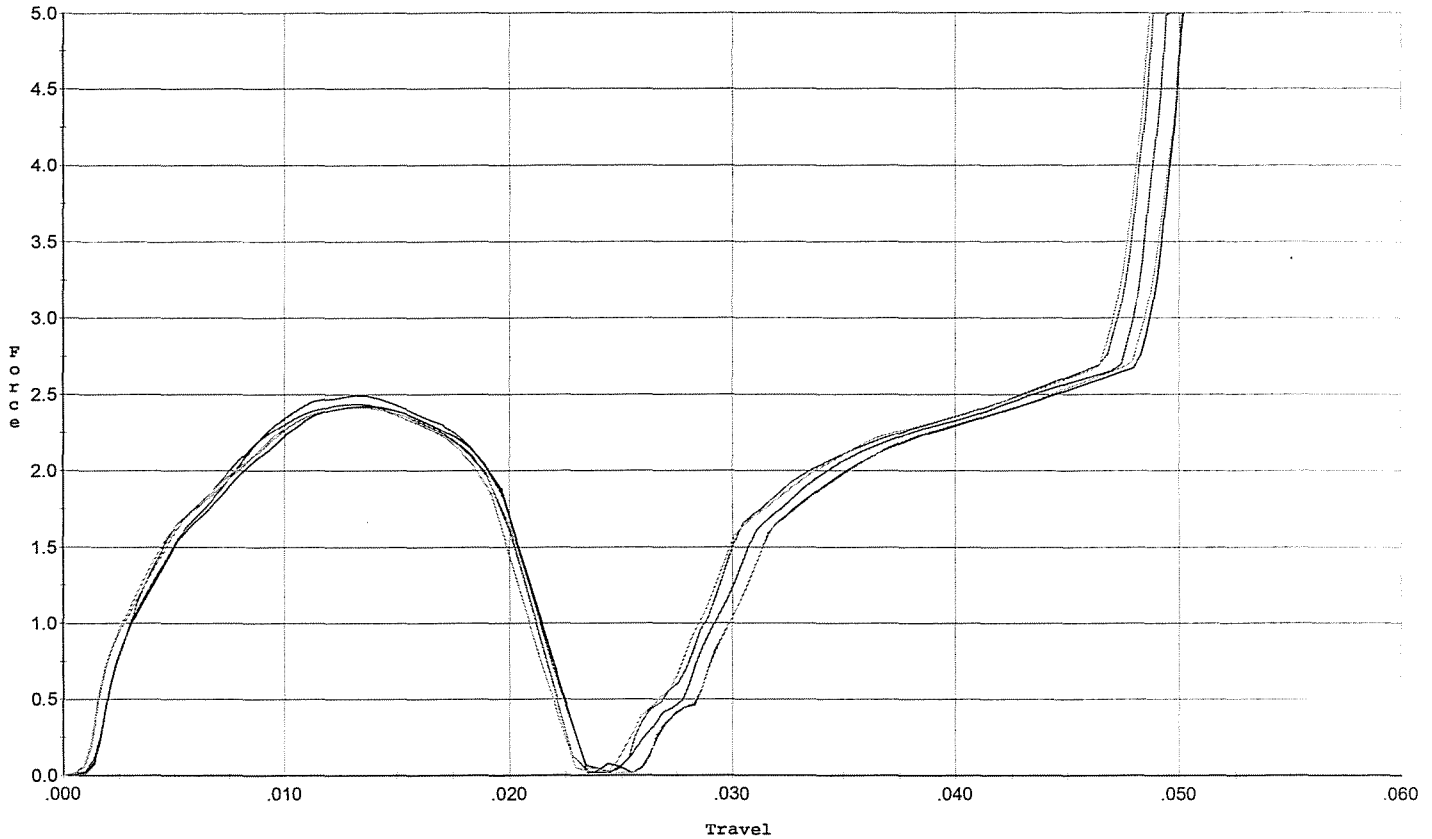
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.020	0.00	0.033	0.036		Set Trigger
2	2.510	0.019	0.00	0.034	0.035		Set Trigger
3	2.578	0.019	0.00	0.033	0.037		Set Trigger
4	2.616	0.019	0.00	0.035	0.036		Set Trigger
5	2.666	0.020	0.00	0.033	0.037		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



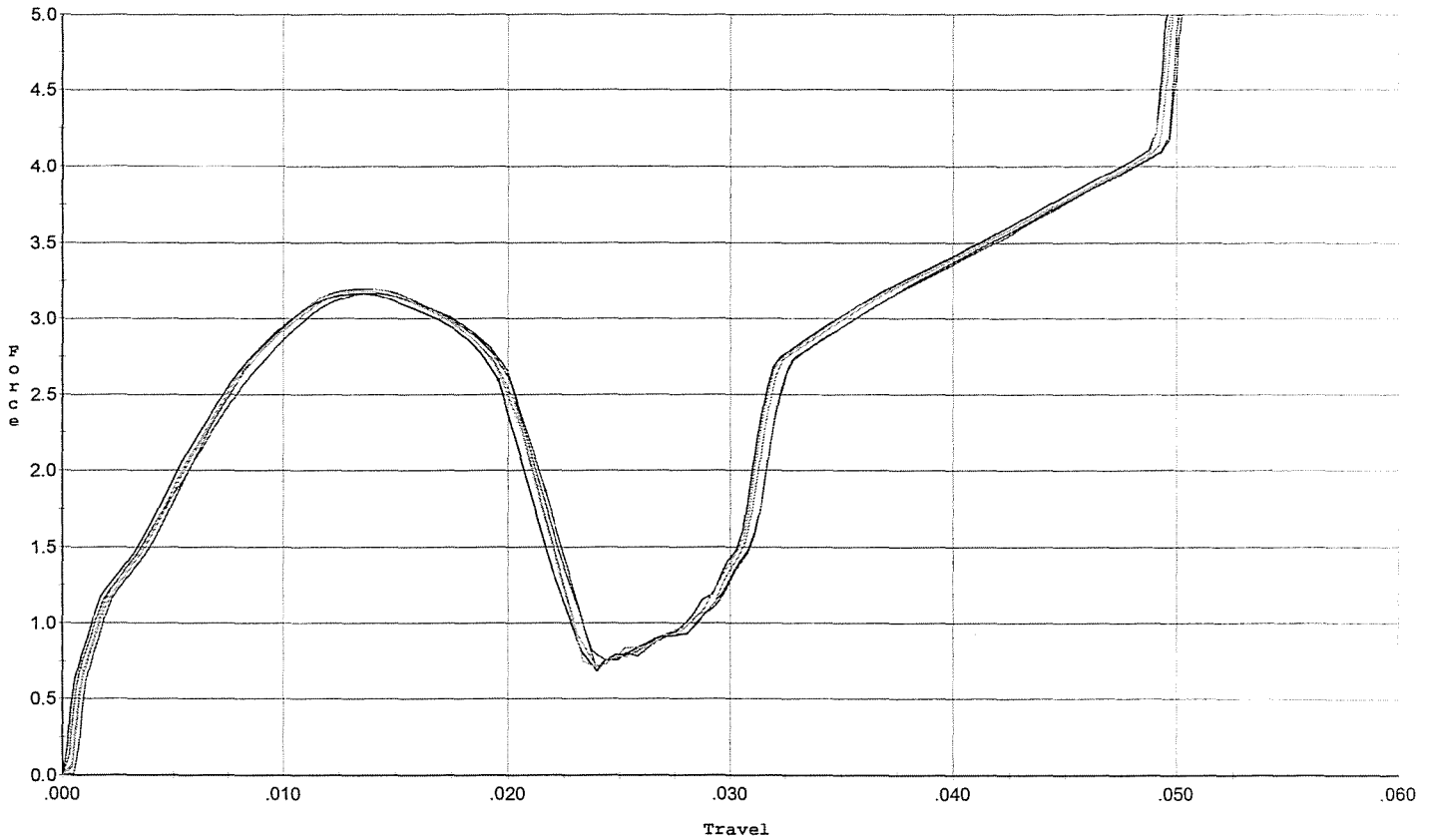
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.020	0.00	0.034	0.034		Set Trigger
2	2.423	0.020	0.00	0.035	0.033		Set Trigger
3	2.437	0.020	0.00	0.033	0.035		Set Trigger
4	2.418	0.019	0.00	0.033	0.033		Set Trigger
5	2.415	0.020	0.00	0.035	0.035		Set Trigger

Avg 2.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



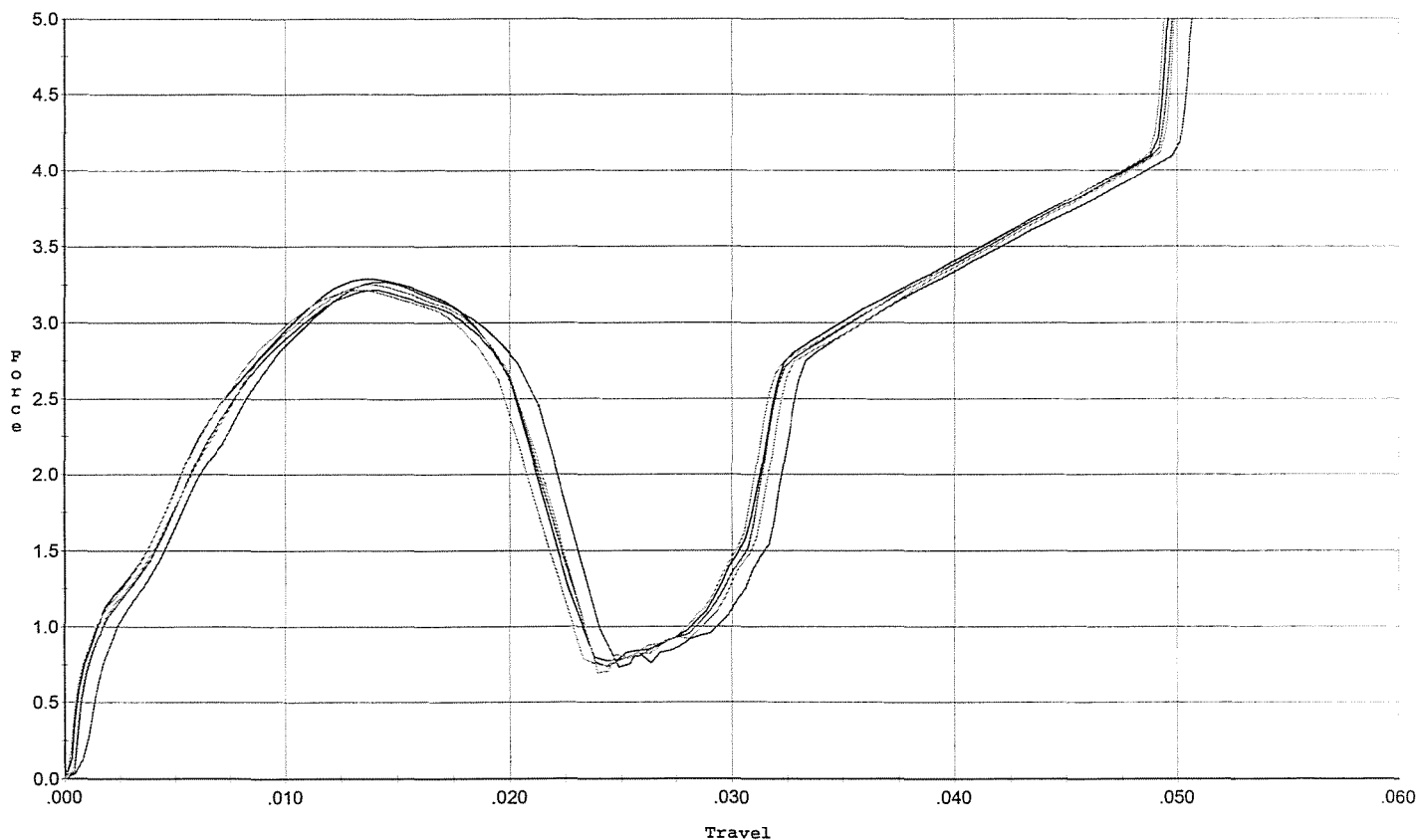
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.168	0.022	0.00	0.032	0.048		Set Trigger
2	3.167	0.020	0.00	0.032	0.044		Set Trigger
3	3.194	0.020	0.00	0.032	0.046		Set Trigger
4	3.203	0.020	0.00	0.032	0.046		Set Trigger
5	3.182	0.020	0.00	0.032	0.046		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



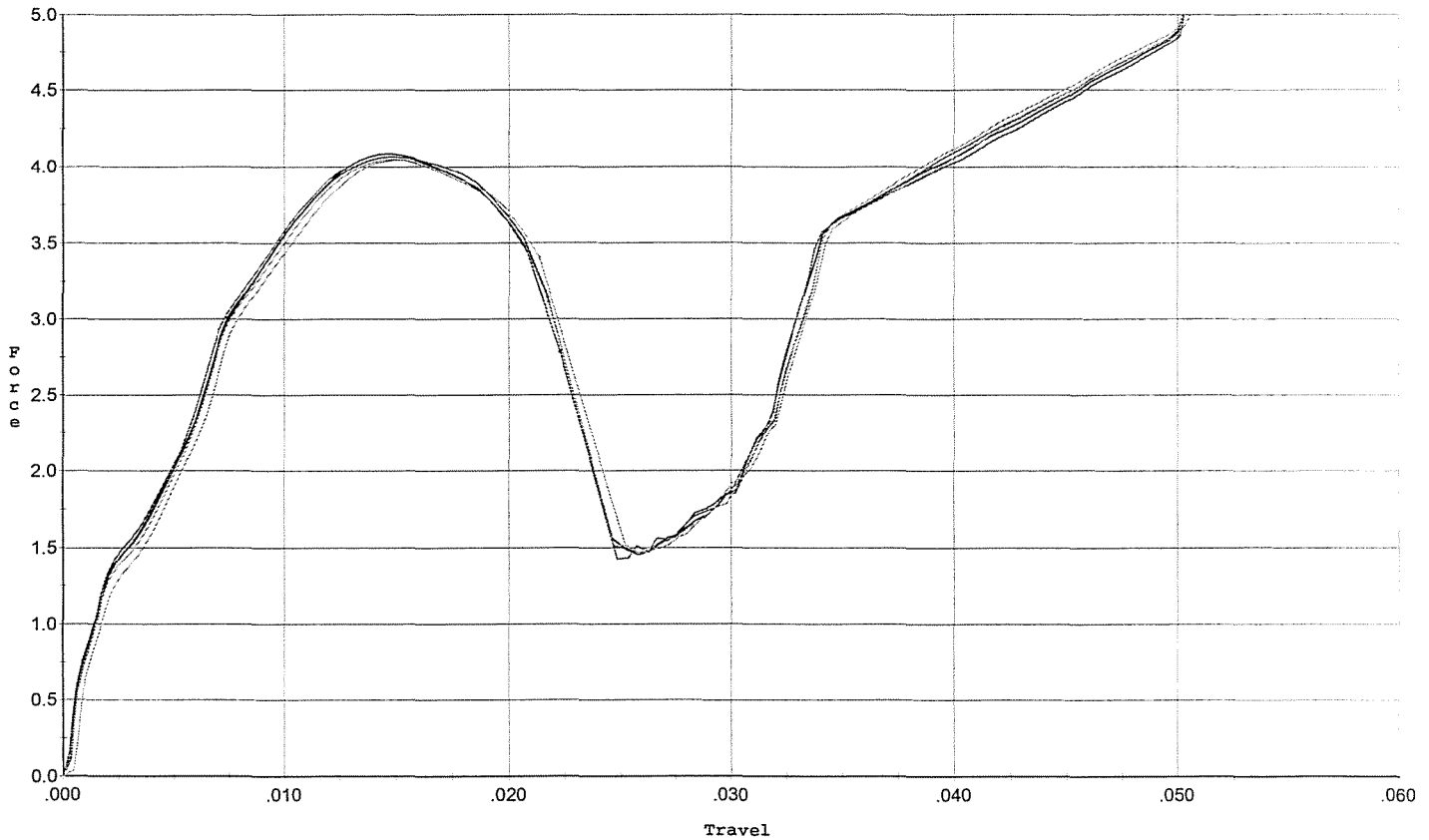
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.269	0.021	0.00	0.032	0.047		Set Trigger
2	3.288	0.020	0.00	0.032	0.046		Set Trigger
3	3.216	0.020	0.00	0.032	0.045		Set Trigger
4	3.251	0.022	0.00	0.032	0.049		Set Trigger
5	3.216	0.020	0.00	0.032	0.045		Set Trigger

Avg 3.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



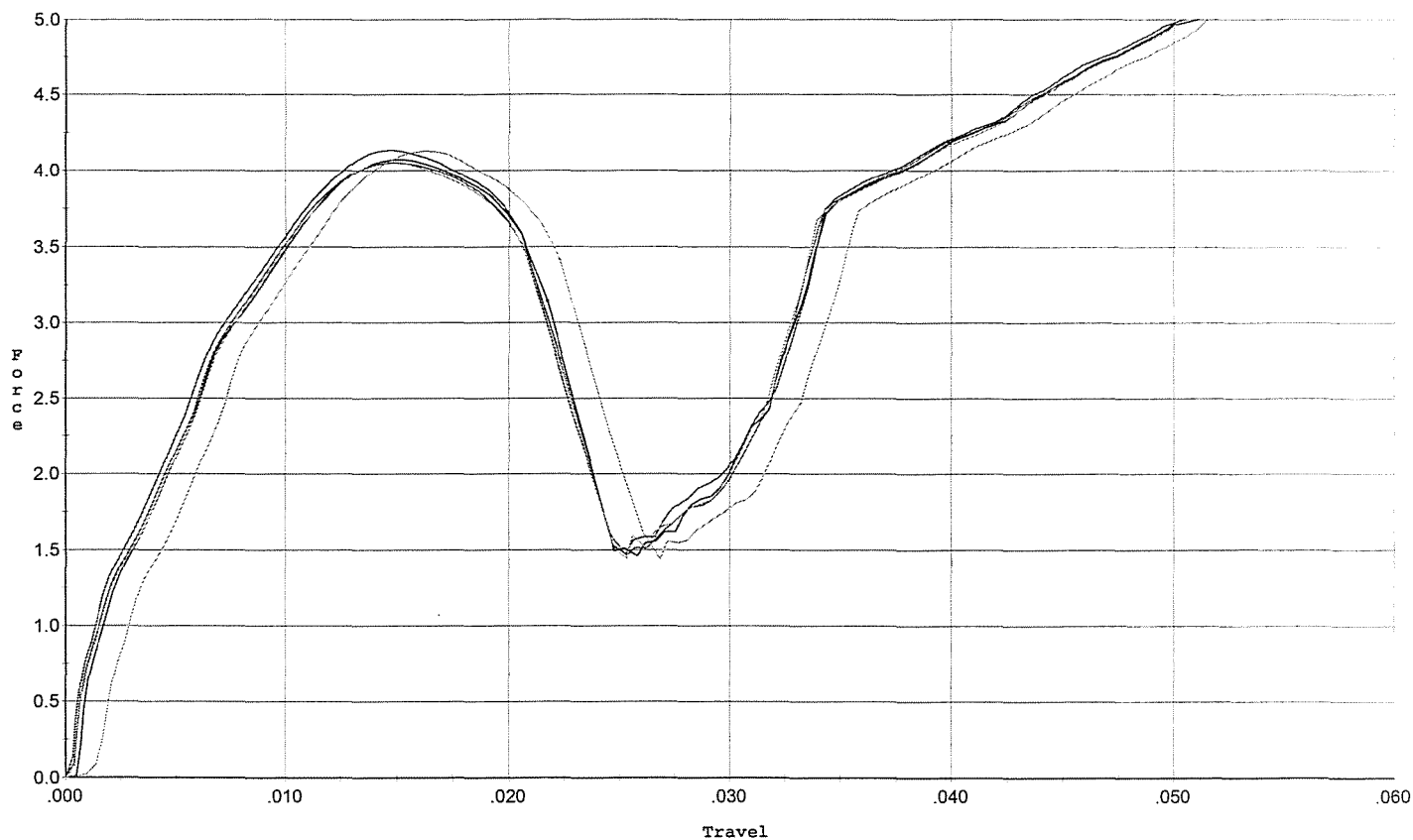
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.067	0.022	0.00	0.031	0.061		Set Trigger
2	4.088	0.022	0.00	0.030	0.061		Set Trigger
3	4.085	0.022	0.00	0.030	0.062		Set Trigger
4	4.053	0.022	0.00	0.031	0.060		Set Trigger
5	4.045	0.021	0.00	0.031	0.058		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



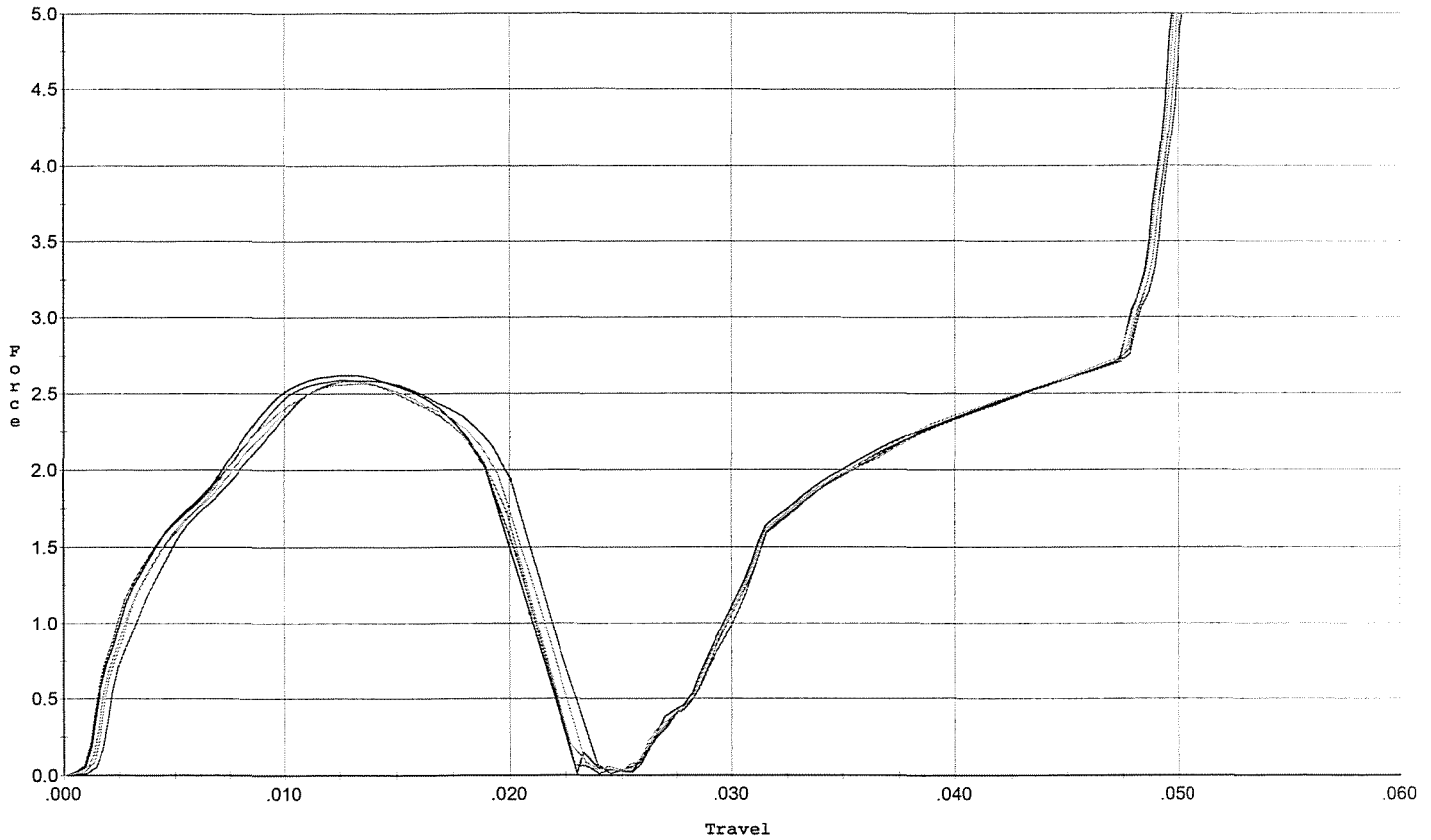
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.022	0.00	0.030	0.064		Set Trigger
2	4.074	0.022	0.00	0.030	0.060		Set Trigger
3	4.052	0.021	0.00	0.031	0.058		Set Trigger
4	4.058	0.022	0.00	0.030	0.062		Set Trigger
5	4.129	0.022	0.00	0.031	0.060		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



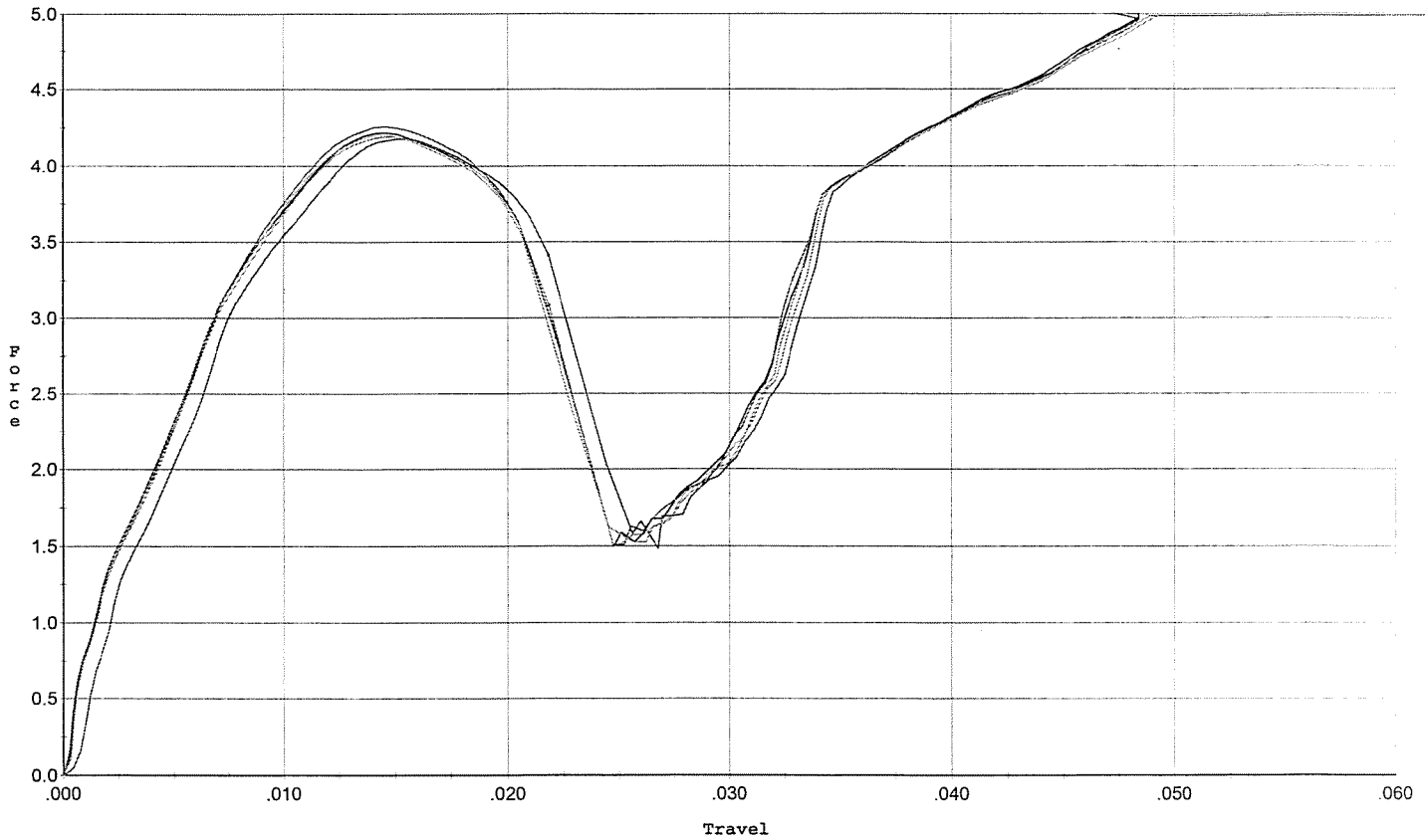
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.020	0.00	0.034	0.036		Set Trigger
2	2.621	0.021	0.00	0.034	0.038		Set Trigger
3	2.589	0.020	0.00	0.034	0.037		Set Trigger
4	2.564	0.021	0.00	0.034	0.038		Set Trigger
5	2.582	0.020	0.00	0.035	0.036		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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	4.178	0.022	0.00	0.030	0.061		Set Trigger
2	4.217	0.022	0.00	0.030	0.063		Set Trigger
3	4.258	0.022	0.00	0.030	0.065		Set Trigger
4	4.192	0.022	0.00	0.030	0.063		Set Trigger
5	4.202	0.021	0.00	0.030	0.060		Set Trigger

Aug 4.20