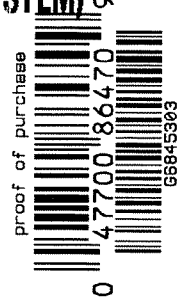
G684 5303

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

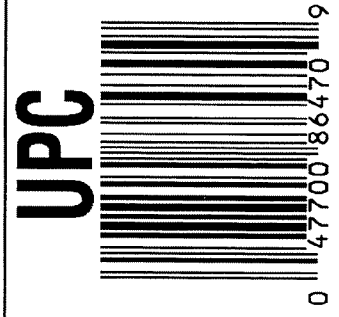


BM FORM

ORDER NO. 86470

BARREL LENGTH	24"
CAPACITY	6

G6845303



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6845303

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-4-09	RP
430	ASSEMBLE TO STOCK		5-4-09	JP
440	PROOF		5-4-09	RP
460	CHECK HEADSPACE	MAGNA-FLUX	5-4-09	RP
470	DIS-ASSEMBLE ACTION	GUN	5-4-09	RP
472	SERIALIZE BOLT HANDLE		5-5-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR (N)	5/6/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/7/09	RT
510	DRILL AND TAP SIGHT HOLES		5-5-09	JP
520	GOFF BLAST BBL / REC		5/7/09	KEM
540	APPLY COATINGS (BARREL ACTION)		5/14	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		5/14-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-14-09	JP
	D) OIL FIRING PIN ASSEMBLY		5-21-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

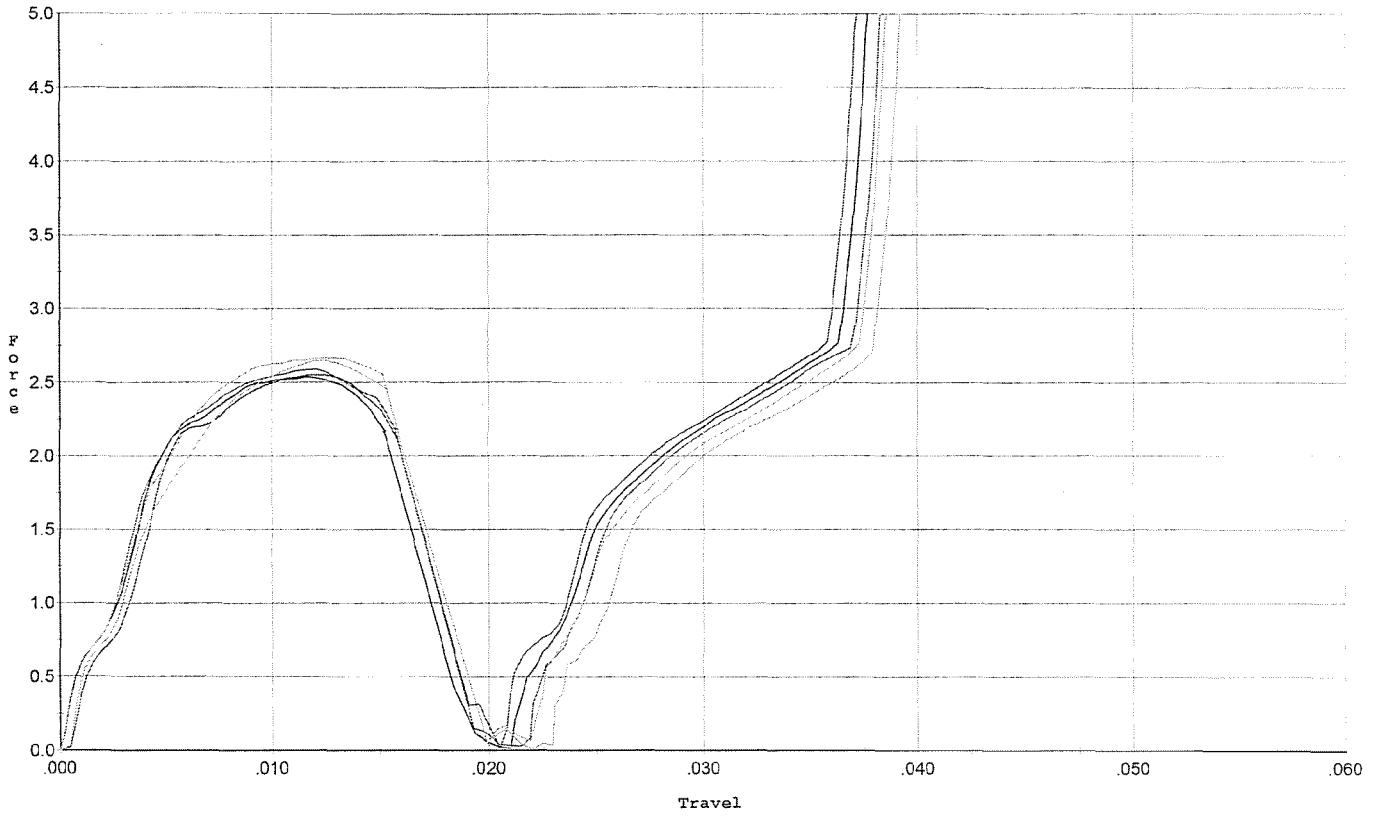
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	4.0 4.0 4.0	6-24-09	[illegible]
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	5.0 5.0 5.0	6-24-09	[illegible]
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.023 .023 .022	6-24-09	[illegible]
	J) ASSEMBLE STOCK		5-21-09	[illegible]
	K) ASSEMBLE SWIVEL STUDS		6-24-09	[illegible]
	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	6/10/09	[illegible]
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/10/09	TQR
670	FINAL INSPECTION A) HEADSPACE		6-24-09	[illegible]
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.29 2.30 2.39 2.27 2.30	6-24-09	[illegible]
	C) FUNCTION		6-24-09	[illegible]
690	PACK		7/22/09	[illegible]

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs ini +/- .50 lb
Note:	C Schults 4/22/2009		



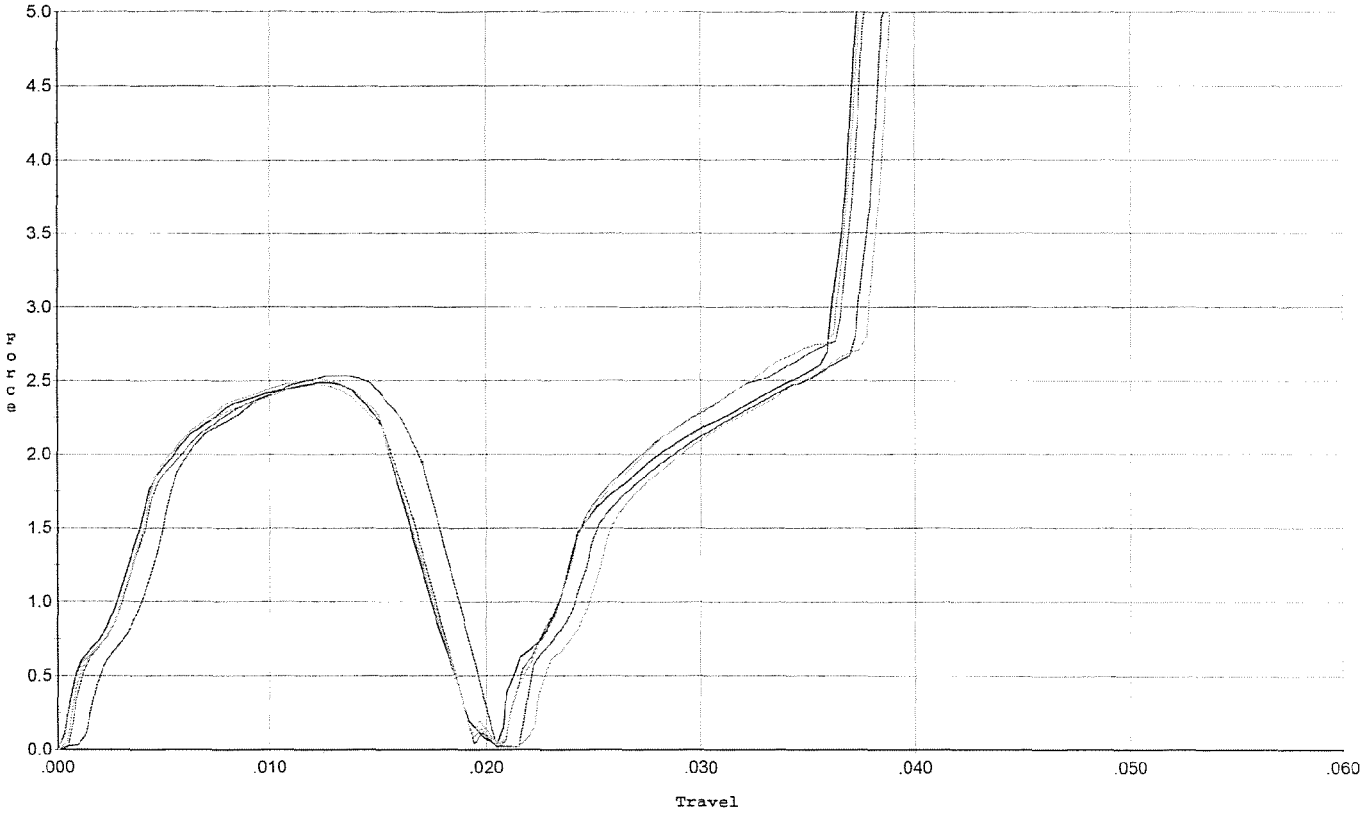
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.016	0.00	0.025	0.028		Set Trigger
2	2.539	0.015	0.00	0.026	0.028		Set Trigger
3	2.591	0.016	0.00	0.026	0.029		Set Trigger
4	2.650	0.015	0.00	0.027	0.028		Set Trigger
5	2.669	0.015	0.00	0.027	0.029		Set Trigger

A-260

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 5:59:11 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs after 50 cycles+/- .50 lb
Note:	C Schults 4/22/2009		



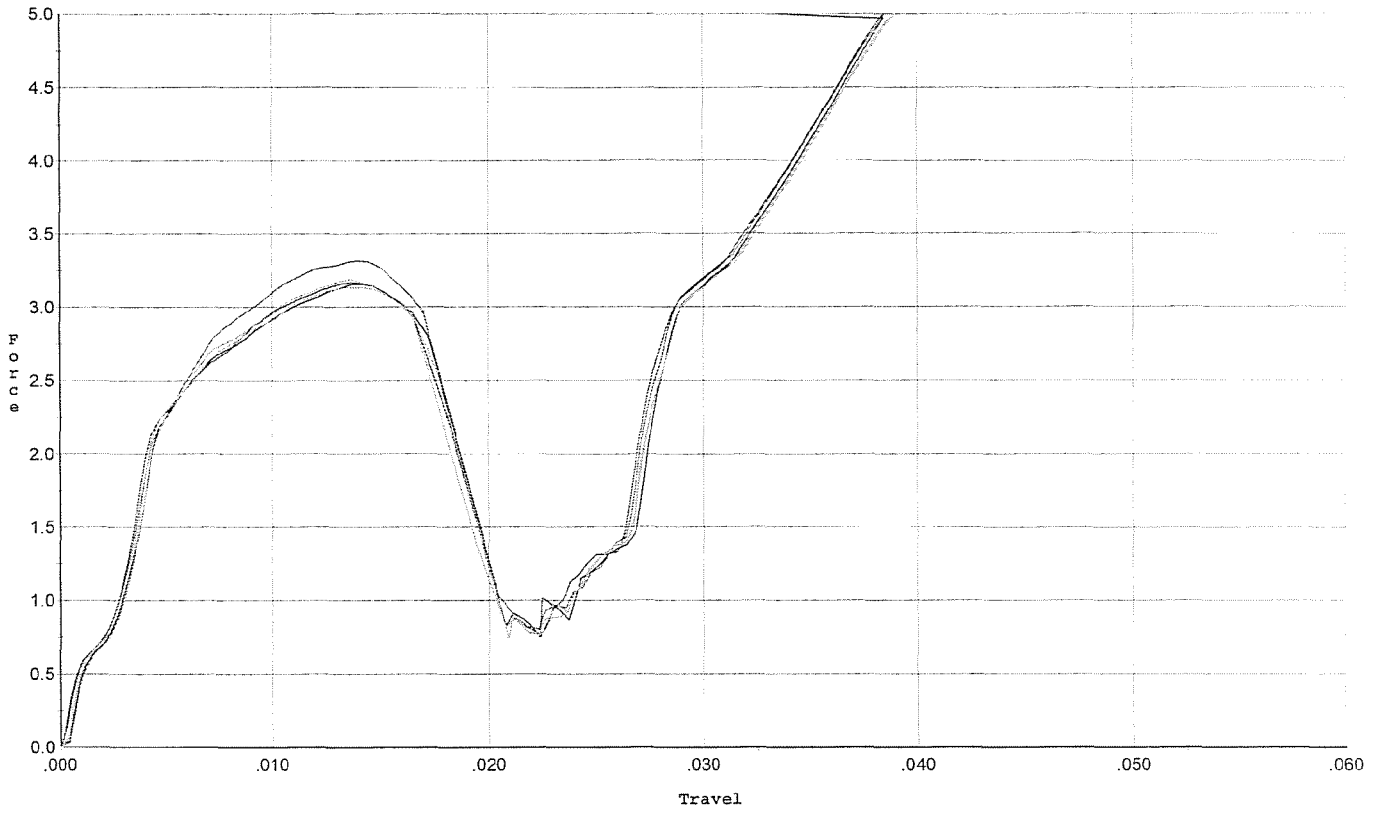
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.017	0.00	0.026	0.029		Set Trigger
2	2.488	0.015	0.00	0.026	0.027		Set Trigger
3	2.486	0.017	0.00	0.026	0.029		Set Trigger
4	2.515	0.015	0.00	0.026	0.027		Set Trigger
5	2.474	0.017	0.00	0.027	0.030		Set Trigger

A250

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:01:08 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs ini +/- .75 lb
Note:	C Schults 4/22/2009		



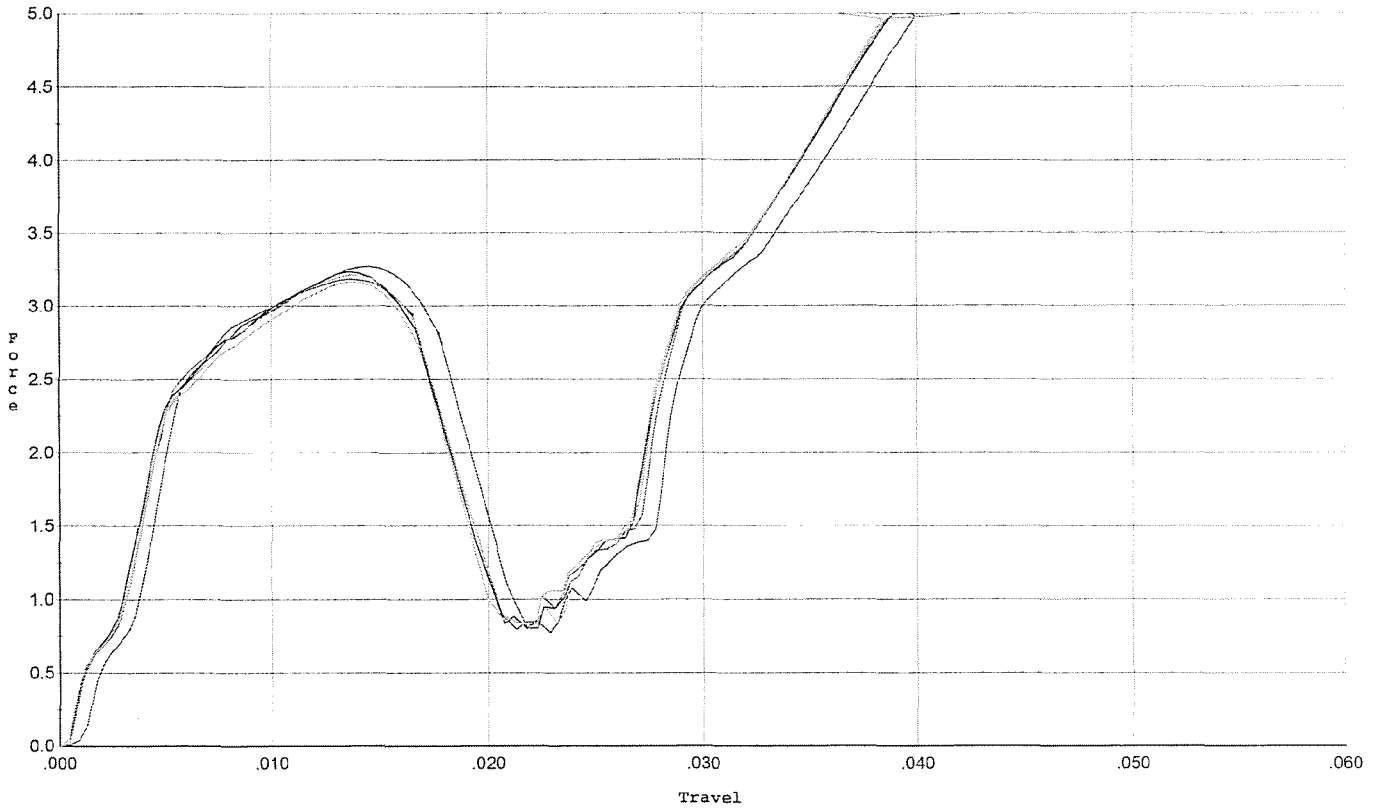
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.166	0.018	0.00	0.026	0.040		Set Trigger
2	3.155	0.017	0.00	0.026	0.038		Set Trigger
3	3.316	0.017	0.00	0.026	0.039		Set Trigger
4	3.134	0.017	0.00	0.027	0.036		Set Trigger
5	3.187	0.018	0.00	0.026	0.039		Set Trigger

A-3-19

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:02:56 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs after 20 cycles+/- .75 lb
Note:	C Schults 4/22/2009		



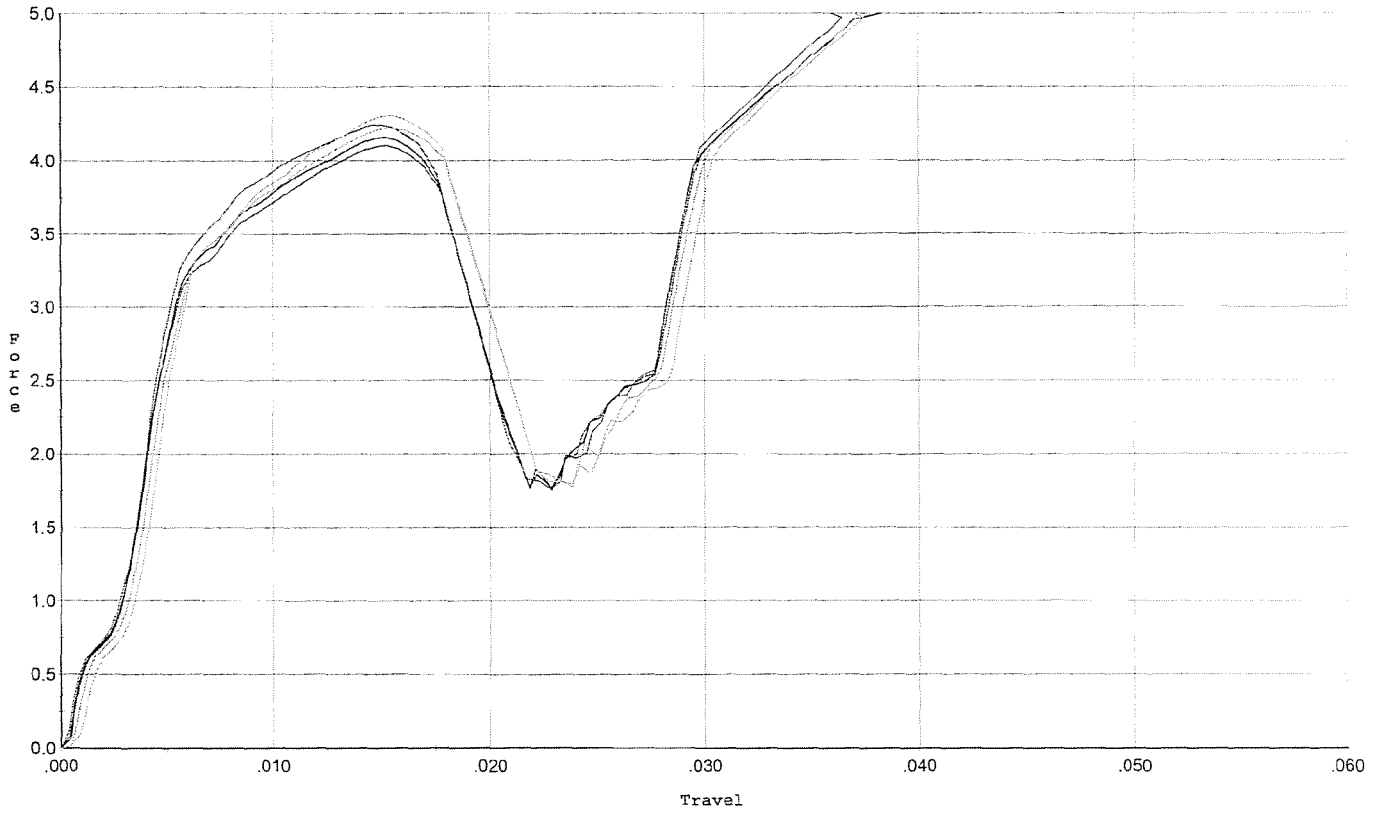
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.273	0.018	0.00	0.027	0.038		Set Trigger
2	3.236	0.017	0.00	0.027	0.037		Set Trigger
3	3.185	0.017	0.00	0.027	0.036		Set Trigger
4	3.168	0.017	0.00	0.027	0.036		Set Trigger
5	3.211	0.017	0.00	0.027	0.036		Set Trigger

A-3-21

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:05:29 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs ini +/- 1.0 lb
Note:	C Schults 4/22/2009		



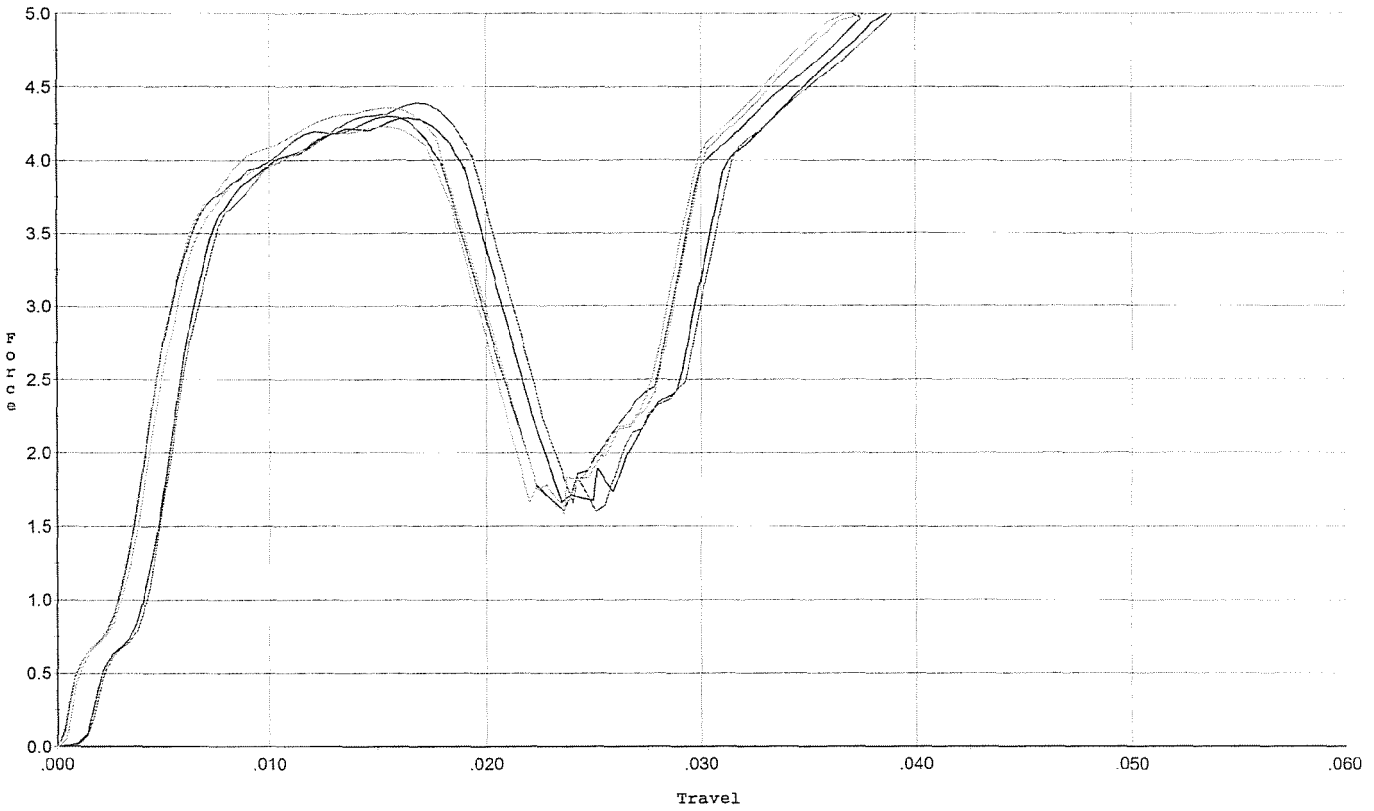
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.018	0.00	0.023	0.049		Set Trigger
2	4.158	0.018	0.00	0.024	0.049		Set Trigger
3	4.239	0.018	0.00	0.024	0.050		Set Trigger
4	4.219	0.020	0.00	0.024	0.056		Set Trigger
5	4.307	0.020	0.00	0.023	0.056		Set Trigger

A. 4.20

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs after 20 cycles+/- 1.0 lb
Note:	C Schults 4/22/2009		



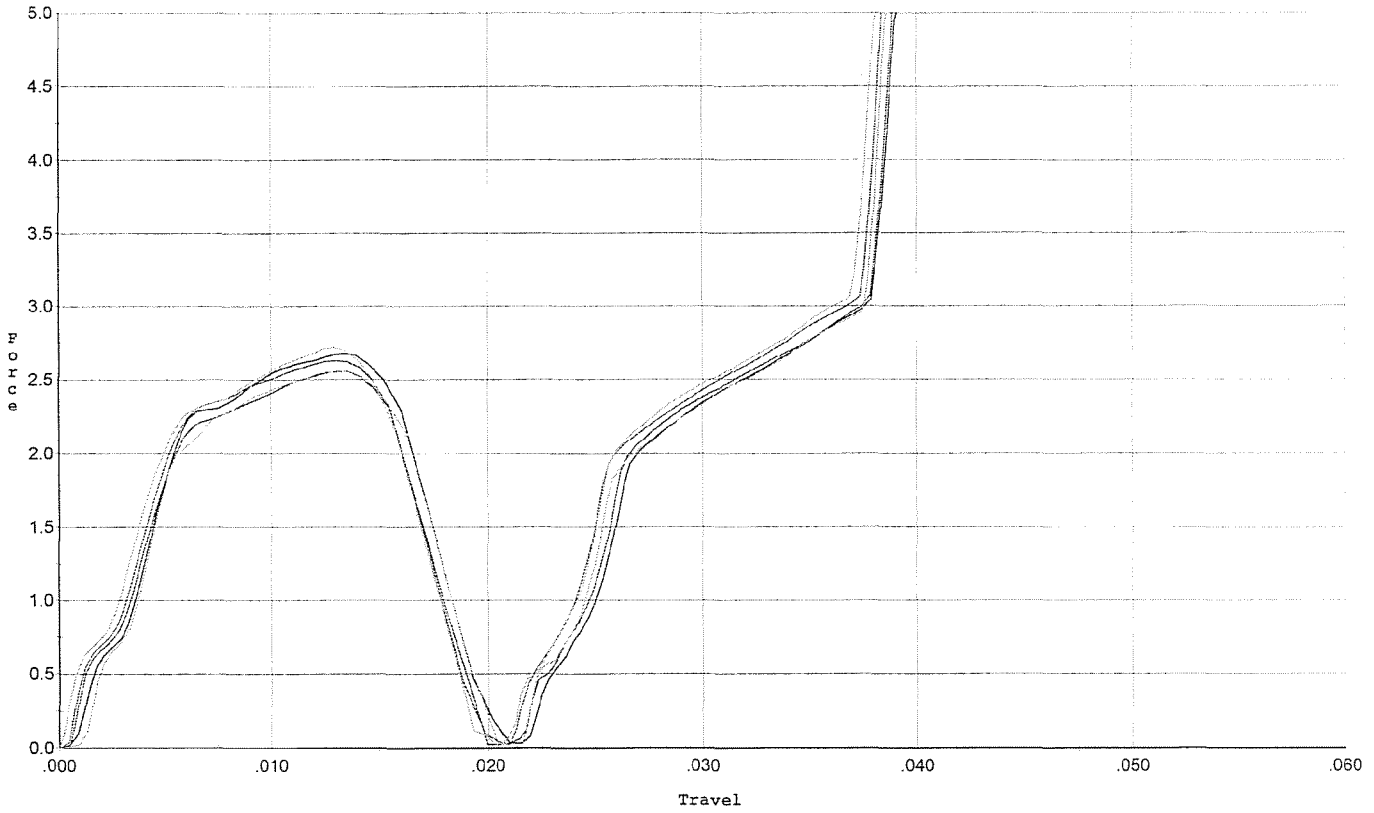
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.299	0.018	0.00	0.024	0.052		Set Trigger
2	4.287	0.019	0.00	0.024	0.053		Set Trigger
3	4.389	0.019	0.00	0.024	0.054		Set Trigger
4	4.226	0.018	0.00	0.024	0.053		Set Trigger
5	4.356	0.020	0.00	0.024	0.059		Set Trigger

4.431

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:09:57 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs +/- .50 lb for final test
Note:	C Schults 4/22/2009		



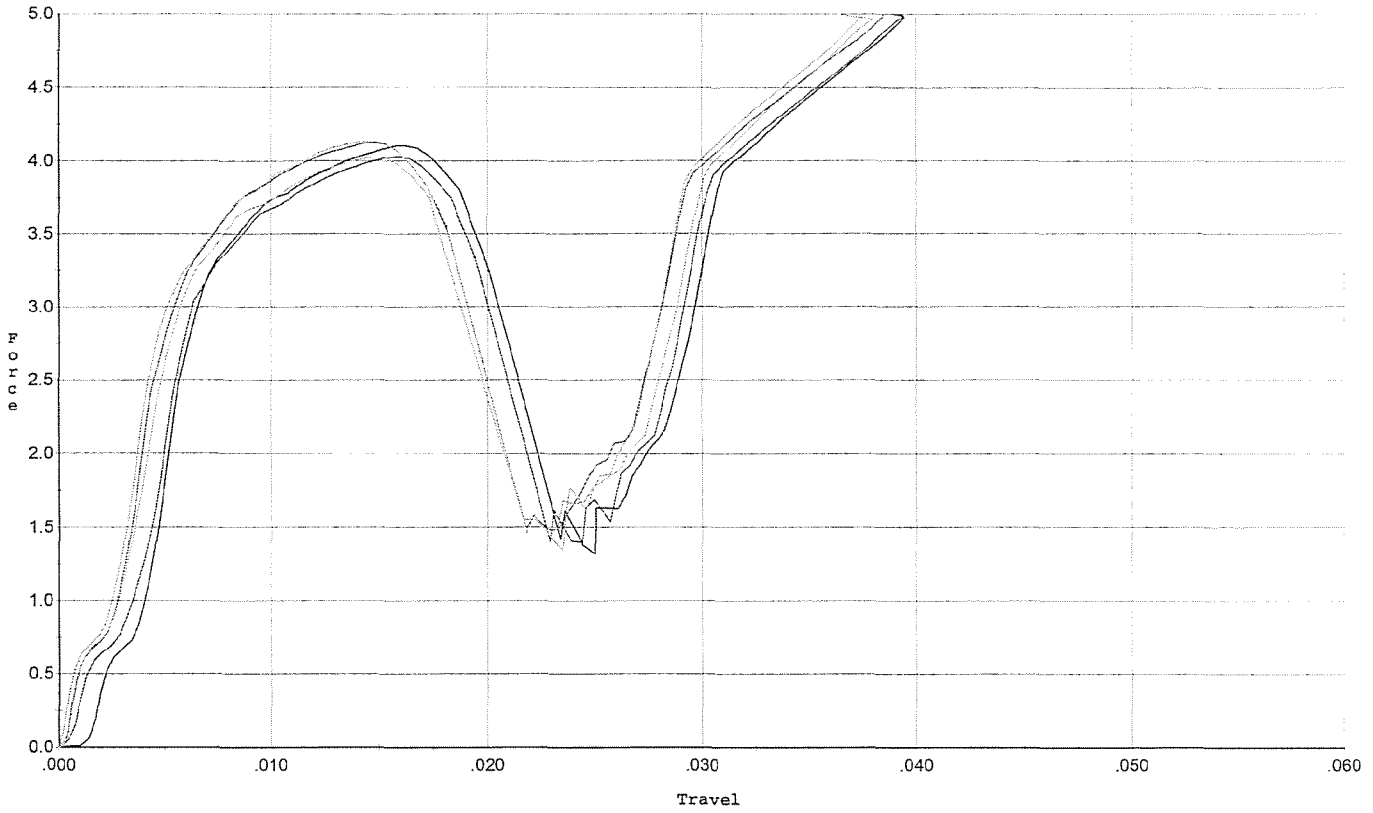
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.556	0.016	0.00	0.027	0.027		Set Trigger
2	2.679	0.016	0.00	0.027	0.029		Set Trigger
3	2.632	0.015	0.00	0.026	0.028		Set Trigger
4	2.720	0.016	0.00	0.026	0.030		Set Trigger
5	2.562	0.016	0.00	0.026	0.028		Set Trigger

A.2.63

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:12:31 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs +/- 1.0 lb for target & accuracy
Note:	C Schults 4/22/2009		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.029	0.019	0.00	0.025	0.052		Set Trigger
2	4.102	0.020	0.00	0.025	0.054		Set Trigger
3	4.124	0.018	0.00	0.024	0.051		Set Trigger
4	4.026	0.017	0.00	0.025	0.047		Set Trigger
5	4.137	0.018	0.00	0.024	0.052		Set Trigger

A. 4.08

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 4/22/2009 6:16:21 AM