

G6845811

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



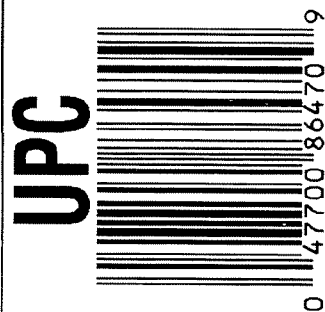
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6845811



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6845811

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-16-09	SPD
430	ASSEMBLE TO STOCK		4-16-09	RP
440	PROOF		4-16-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	4-16-09	RP
470	DIS-ASSEMBLE ACTION		4-16-09	RP
472	SERIALIZE BOLT HANDLE		4-17-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	4-18-09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-20-09	RT
510	DRILL AND TAP SIGHT HOLES		4-17-09	SP
520	GOFF BLAST BBL / REC		4-21-09	L.M
540	APPLY COATINGS (BARREL ACTION)		4-22	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

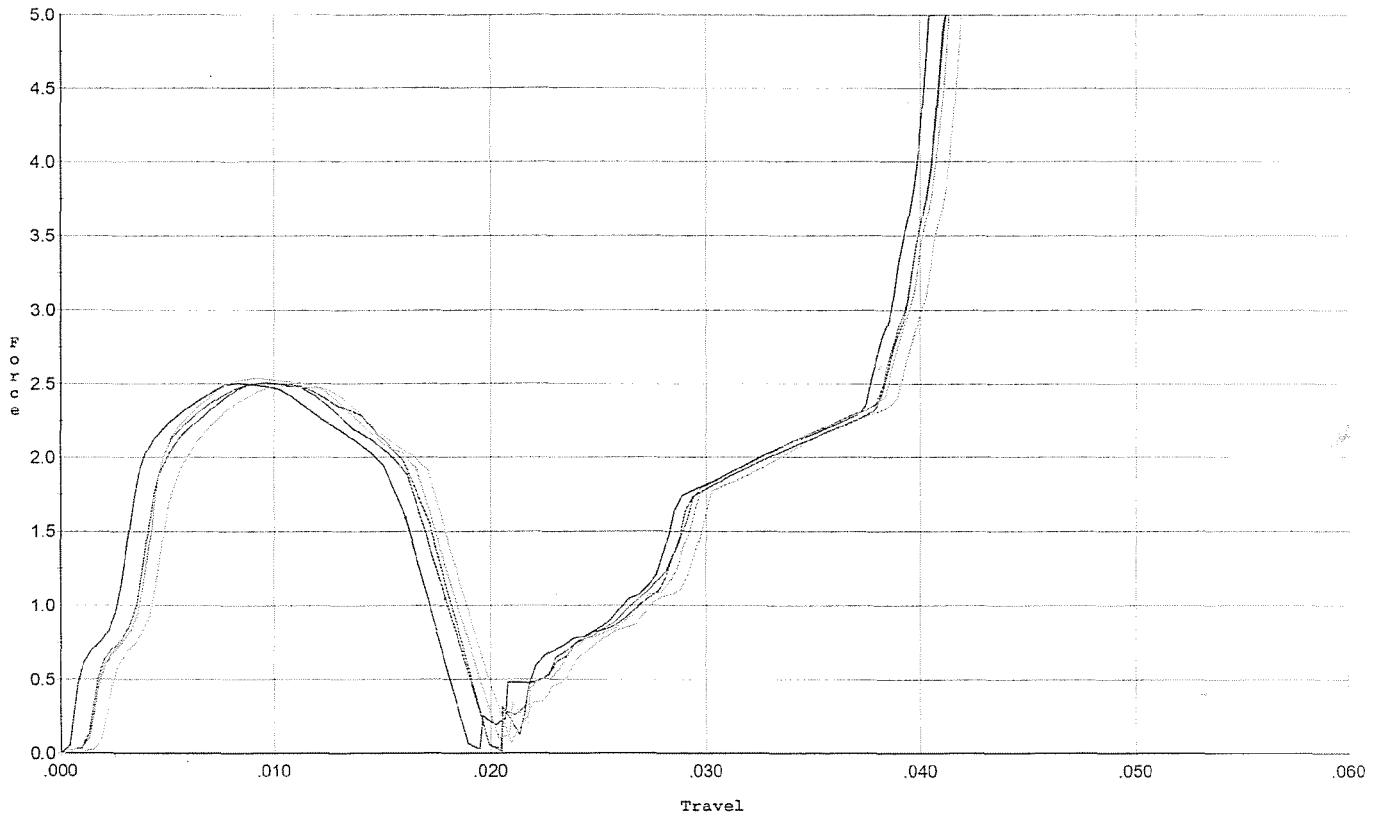
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-8-09	LJL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	5-8-09	LJL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.034</u> <u>.034</u> <u>.034</u>	5-8-09	LJL
	J) ASSEMBLE STOCK		4-28-09	LJL
	K) ASSEMBLE SWIVEL STUDS		5-8-09	RAL
	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	5-1-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-1-09	TQR
670	FINAL INSPECTION A) HEADSPACE		5-8-09	LJL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>238</u> <u>237</u> <u>249</u> <u>250</u> <u>252</u>	5-7-09	RTZ
	C) FUNCTION		5-8-09	LJL
690	PACK		6/1/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



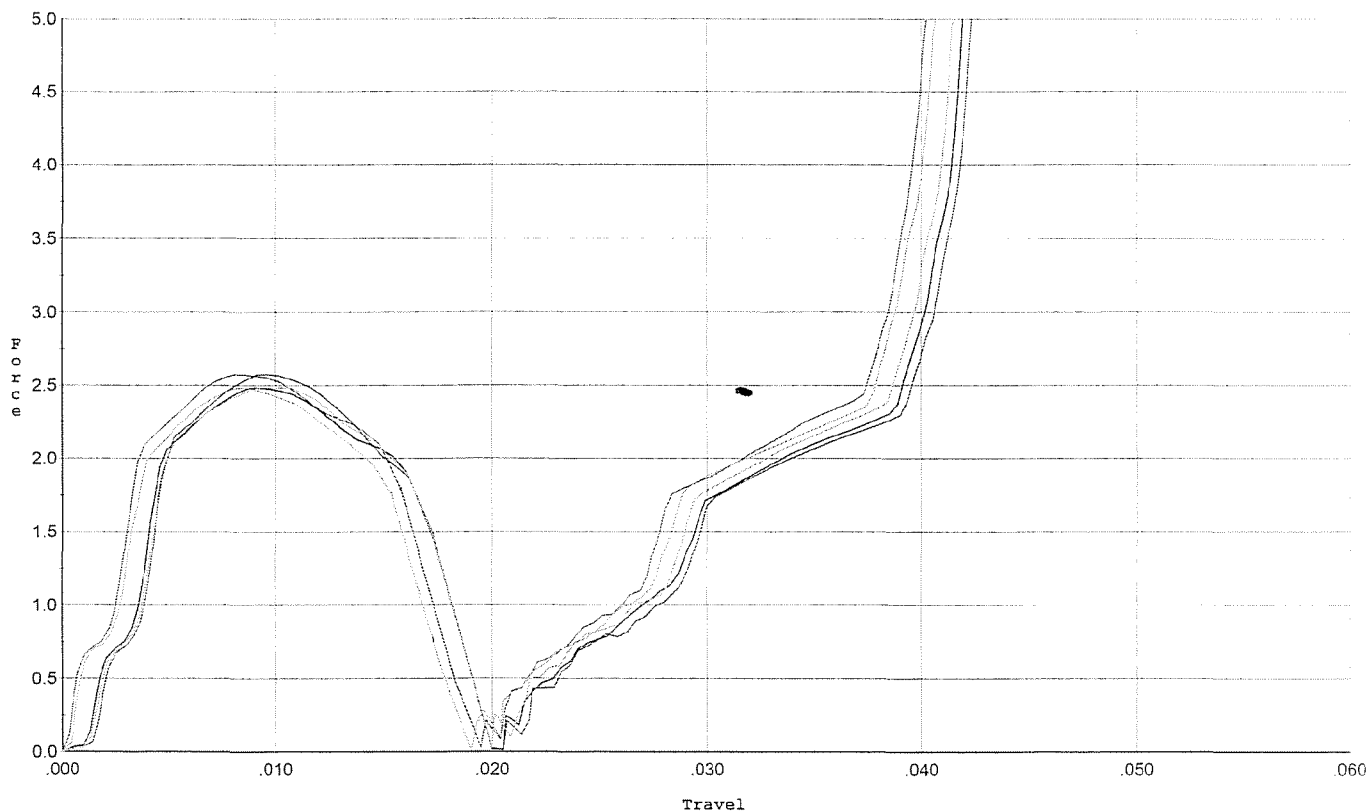
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.018	0.00	0.029	0.030		Set Trigger
2	2.501	0.016	0.00	0.029	0.029		Set Trigger
3	2.502	0.017	0.00	0.029	0.030		Set Trigger
4	2.482	0.017	0.00	0.030	0.028		Set Trigger
5	2.542	0.017	0.00	0.029	0.029		Set Trigger

A. 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



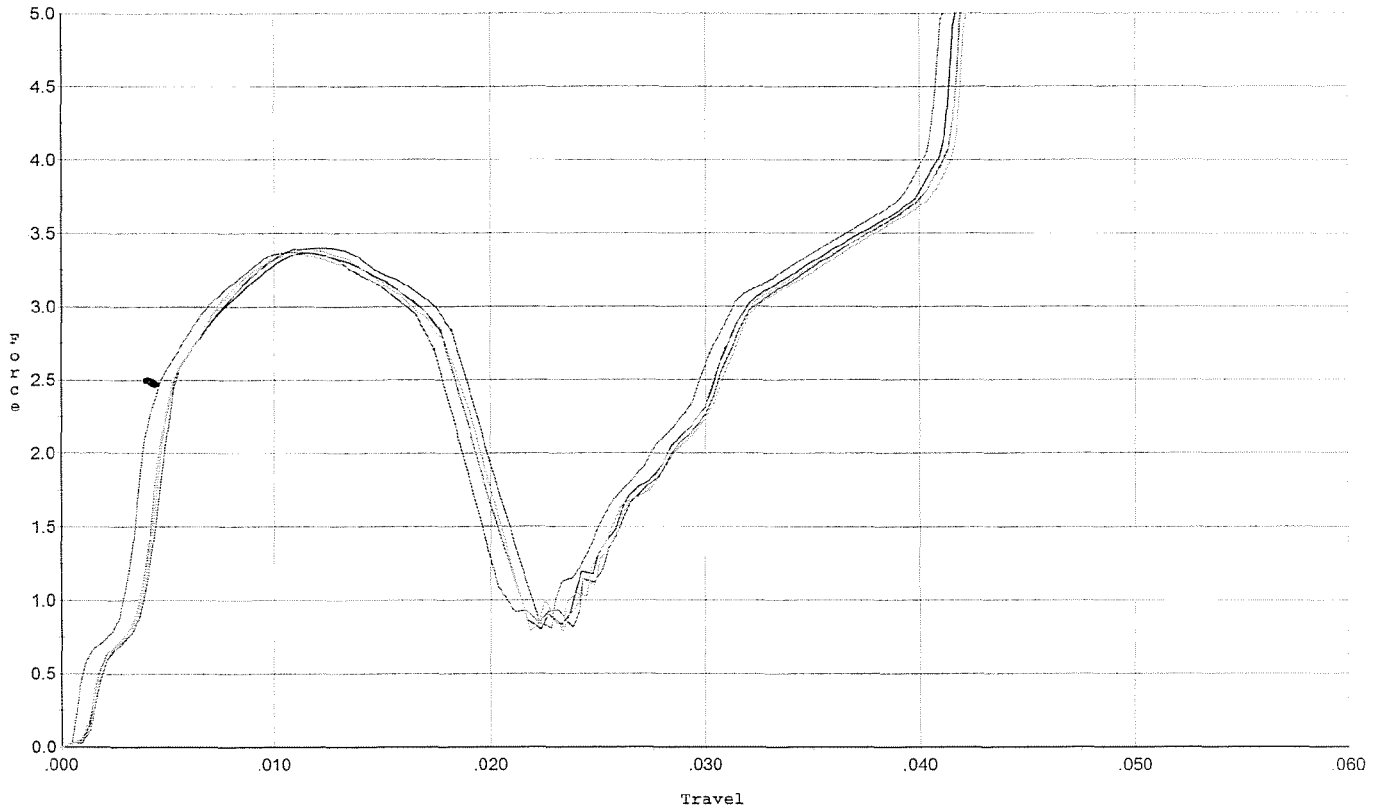
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.017	0.00	0.030	0.029		Set Trigger
2	2.484	0.017	0.00	0.030	0.030		Set Trigger
3	2.572	0.016	0.00	0.029	0.029		Set Trigger
4	2.485	0.017	0.00	0.029	0.029		Set Trigger
5	2.483	0.015	0.00	0.030	0.027		Set Trigger

A.2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



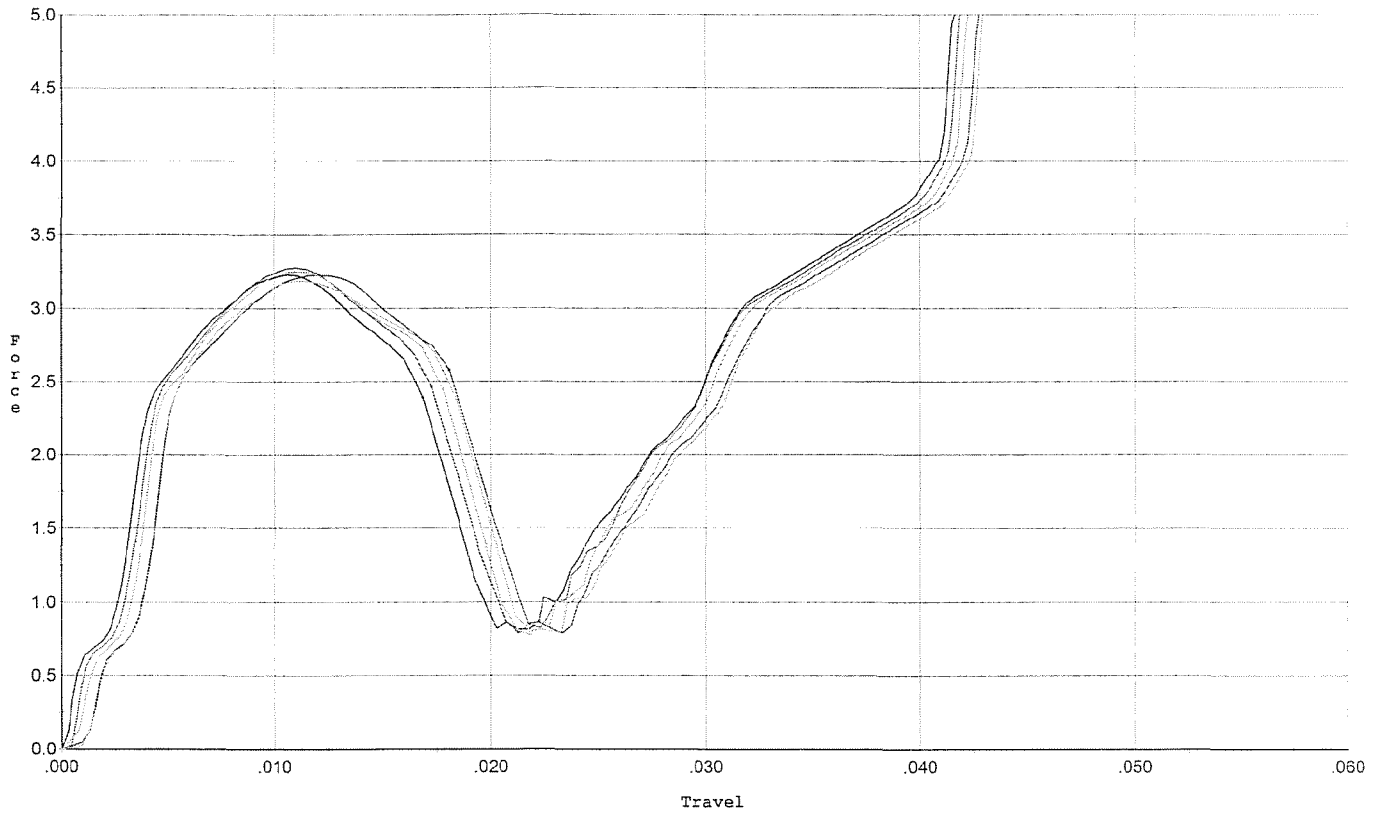
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.404	0.018	0.00	0.027	0.042		Set Trigger
2	3.367	0.018	0.00	0.027	0.040		Set Trigger
3	3.373	0.017	0.00	0.027	0.041		Set Trigger
4	3.357	0.018	0.00	0.027	0.040		Set Trigger
5	3.398	0.019	0.00	0.027	0.043		Set Trigger

A-3-38

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



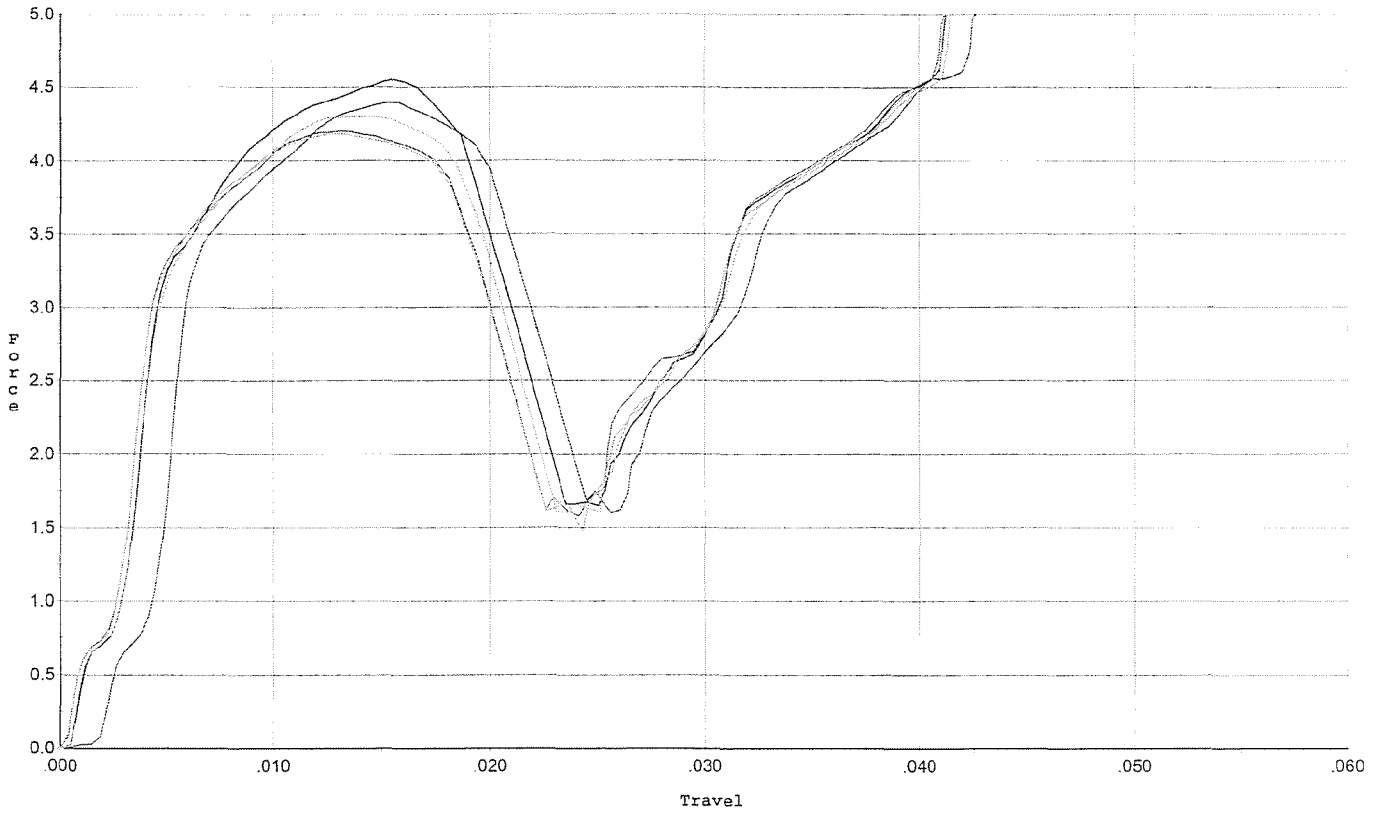
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.018	0.00	0.028	0.039		Set Trigger
2	3.231	0.017	0.00	0.028	0.038		Set Trigger
3	3.277	0.017	0.00	0.028	0.039		Set Trigger
4	3.188	0.018	0.00	0.028	0.039		Set Trigger
5	3.252	0.018	0.00	0.028	0.039		Set Trigger

A-3.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



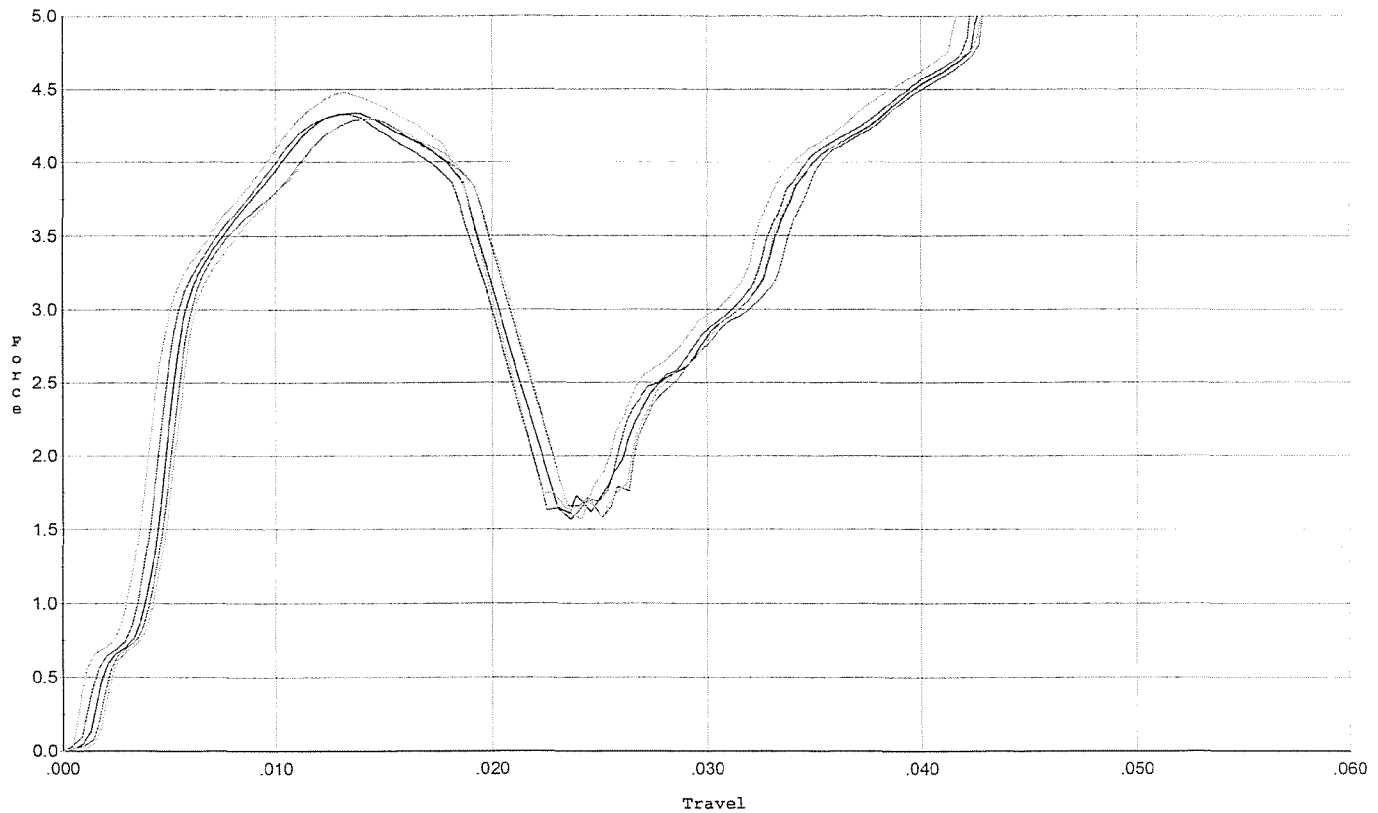
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.396	0.022	0.00	0.020	0.064		Set Trigger
2	4.553	0.021	0.00	0.021	0.064		Set Trigger
3	4.199	0.019	0.00	0.024	0.058		Set Trigger
4	4.303	0.020	0.00	0.024	0.059		Set Trigger
5	4.183	0.020	0.00	0.024	0.058		Set Trigger

A. 4.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



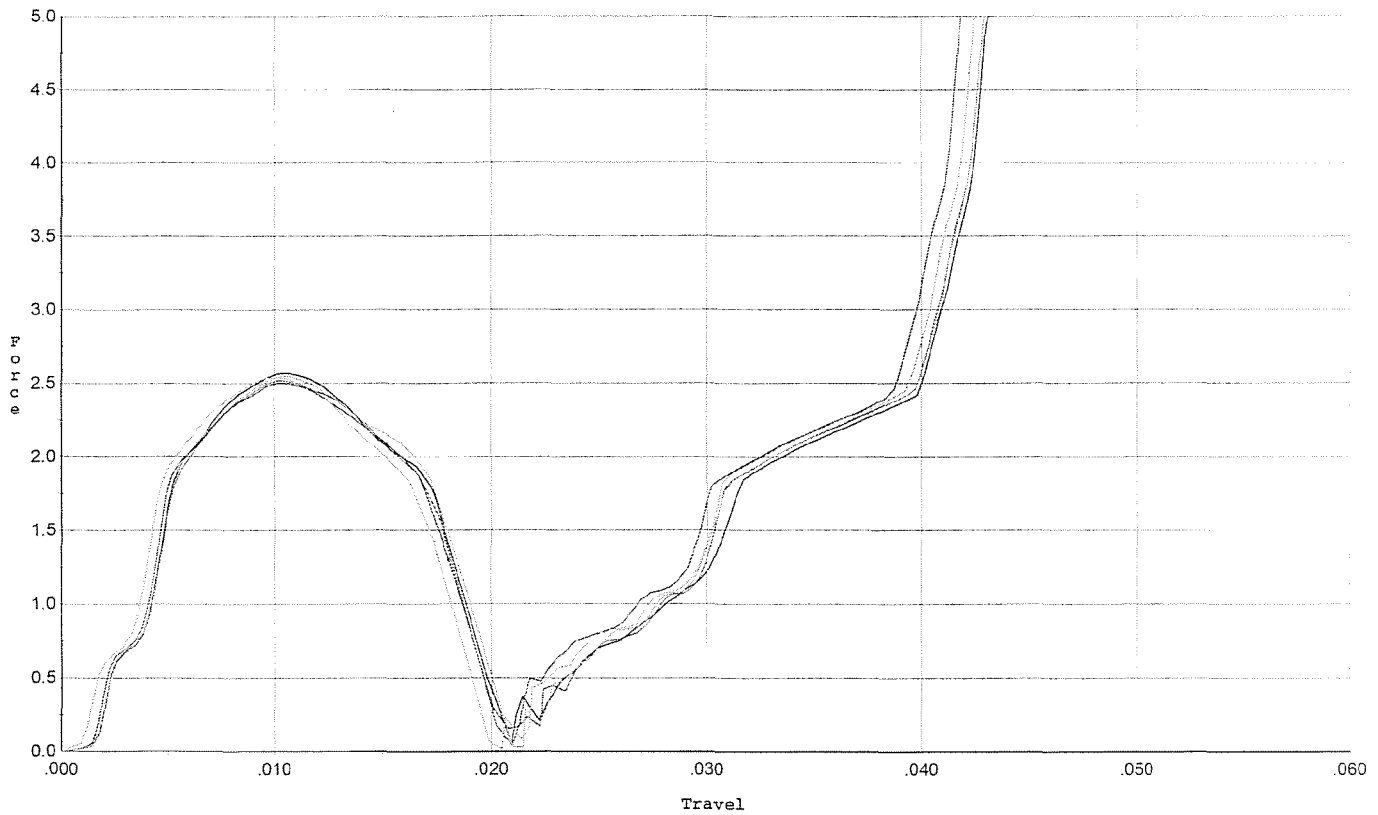
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.326	0.020	0.00	0.025	0.056		Set Trigger
2	4.334	0.019	0.00	0.025	0.052		Set Trigger
3	4.296	0.019	0.00	0.025	0.053		Set Trigger
4	4.303	0.021	0.00	0.024	0.057		Set Trigger
5	4.477	0.019	0.00	0.024	0.055		Set Trigger

A. 4.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



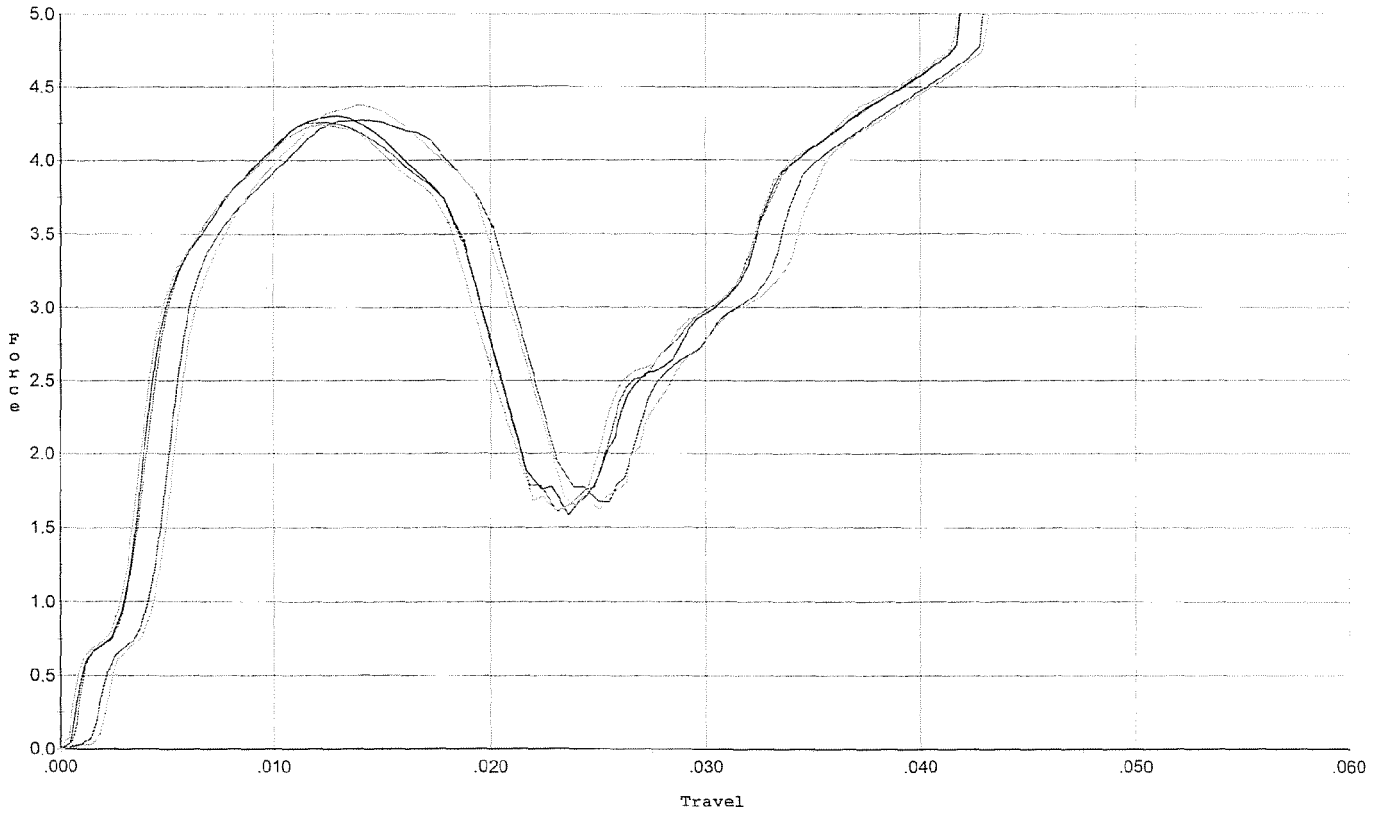
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.502	0.018	0.00	0.029	0.030		Set Trigger
2	2.569	0.017	0.00	0.031	0.029		Set Trigger
3	2.518	0.018	0.00	0.031	0.029		Set Trigger
4	2.537	0.017	0.00	0.030	0.029		Set Trigger
5	2.547	0.019	0.00	0.030	0.031		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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	4.272	0.020	0.00	0.025	0.056		Set Trigger
2	4.301	0.019	0.00	0.025	0.054		Set Trigger
3	4.258	0.019	0.00	0.025	0.054		Set Trigger
4	4.374	0.021	0.00	0.025	0.058		Set Trigger
5	4.237	0.018	0.00	0.025	0.052		Set Trigger

A-4.28