

G6845818

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

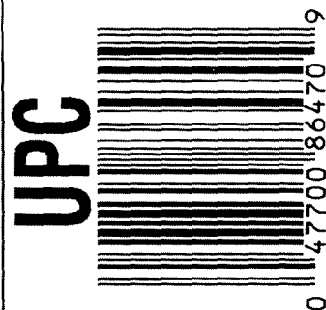


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6845818

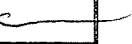


BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 684 5818

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-20-09	SP
430	ASSEMBLE TO STOCK		4-20-09	RP
440	PROOF		4-20-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	4-20-09	RP
470	DIS-ASSEMBLE ACTION		4-20-09	RP
472	SERIALIZE BOLT HANDLE		4-21-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	4-24-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/27/09	RT
510	DRILL AND TAP SIGHT HOLES		4-21-09	SP
520	GOFF BLAST BBL / REC		4/28	non
540	APPLY COATINGS (BARREL ACTION)		5-7	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-7-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-7-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-7-09	JP
	D) OIL FIRING PIN ASSEMBLY		5-7-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

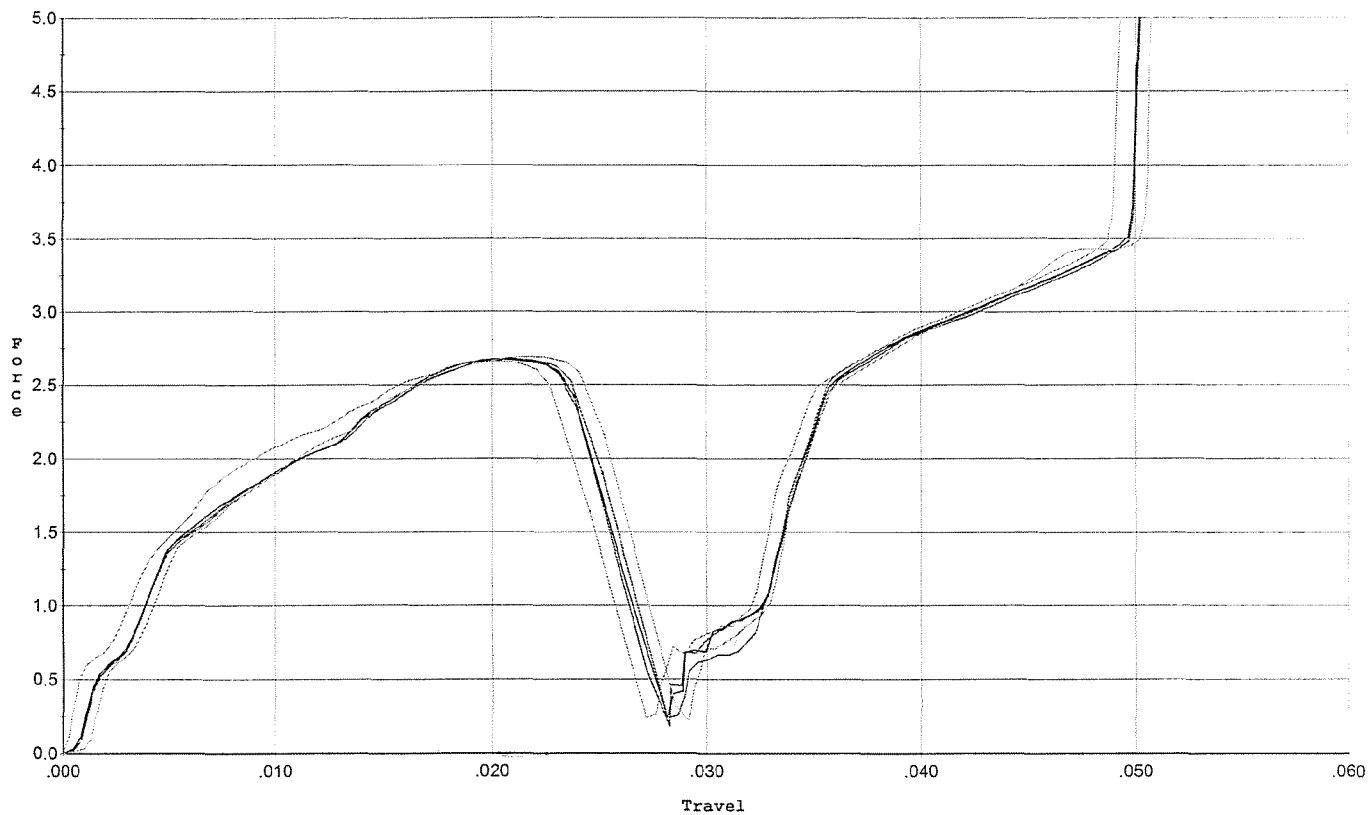
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	5-14-09	RPD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	5-14-09	RPD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.027</u>	5-14-09	RPD
	J) ASSEMBLE STOCK		5-7-09	RPD
	K) ASSEMBLE SWIVEL STUDS		5-14-09	RPD
	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	5/11/09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-11-09	WR
670	FINAL INSPECTION A) HEADSPACE		5-14-09	RPD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>245</u> <u>252</u> <u>255</u> <u>250</u> <u>262</u>	5-12-09	RTZ
	C) FUNCTION		5-14-09	RPD
690	PACK		7/17/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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	2.672	0.024	0.00	0.031	0.043		Set Trigger
2	2.678	0.024	0.00	0.031	0.043		Set Trigger
3	2.674	0.025	0.00	0.031	0.046		Set Trigger
4	2.687	0.025	0.00	0.031	0.046		Set Trigger
5	2.659	0.025	0.00	0.031	0.046		Set Trigger

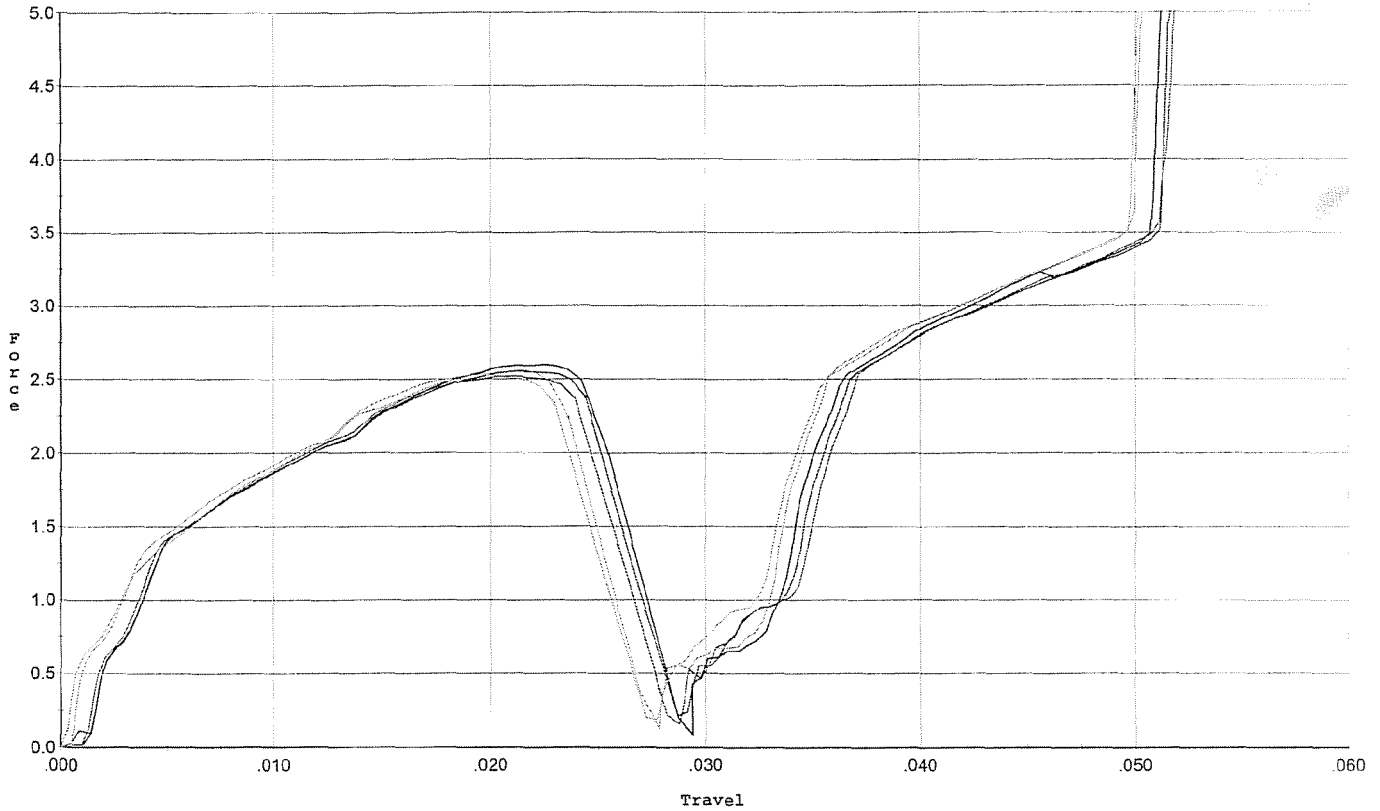
A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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

50 CMS



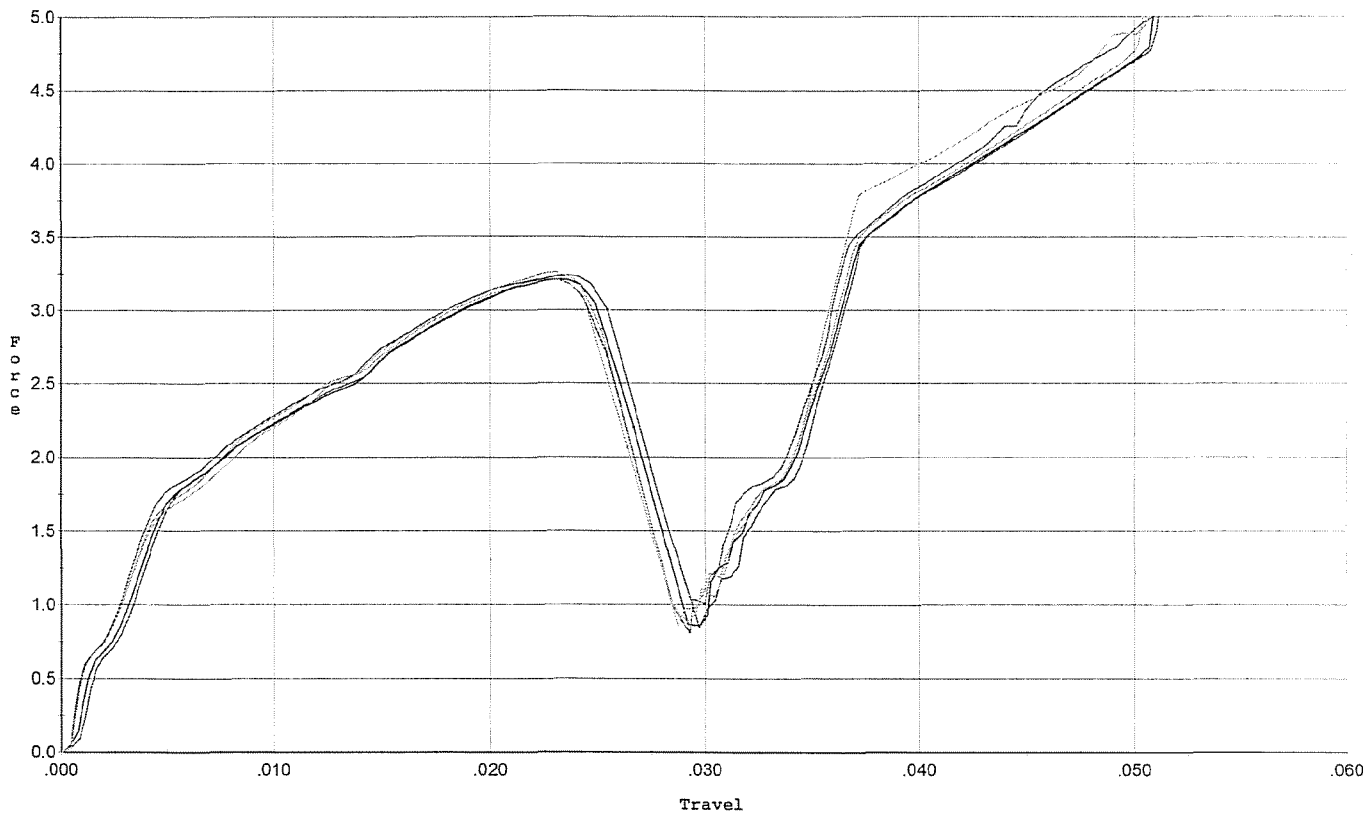
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.024	0.00	0.032	0.043		Set Trigger
2	2.597	0.025	0.00	0.032	0.045		Set Trigger
3	2.520	0.026	0.00	0.032	0.046		Set Trigger
4	2.530	0.023	0.00	0.032	0.041		Set Trigger
5	2.563	0.024	0.00	0.032	0.043		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



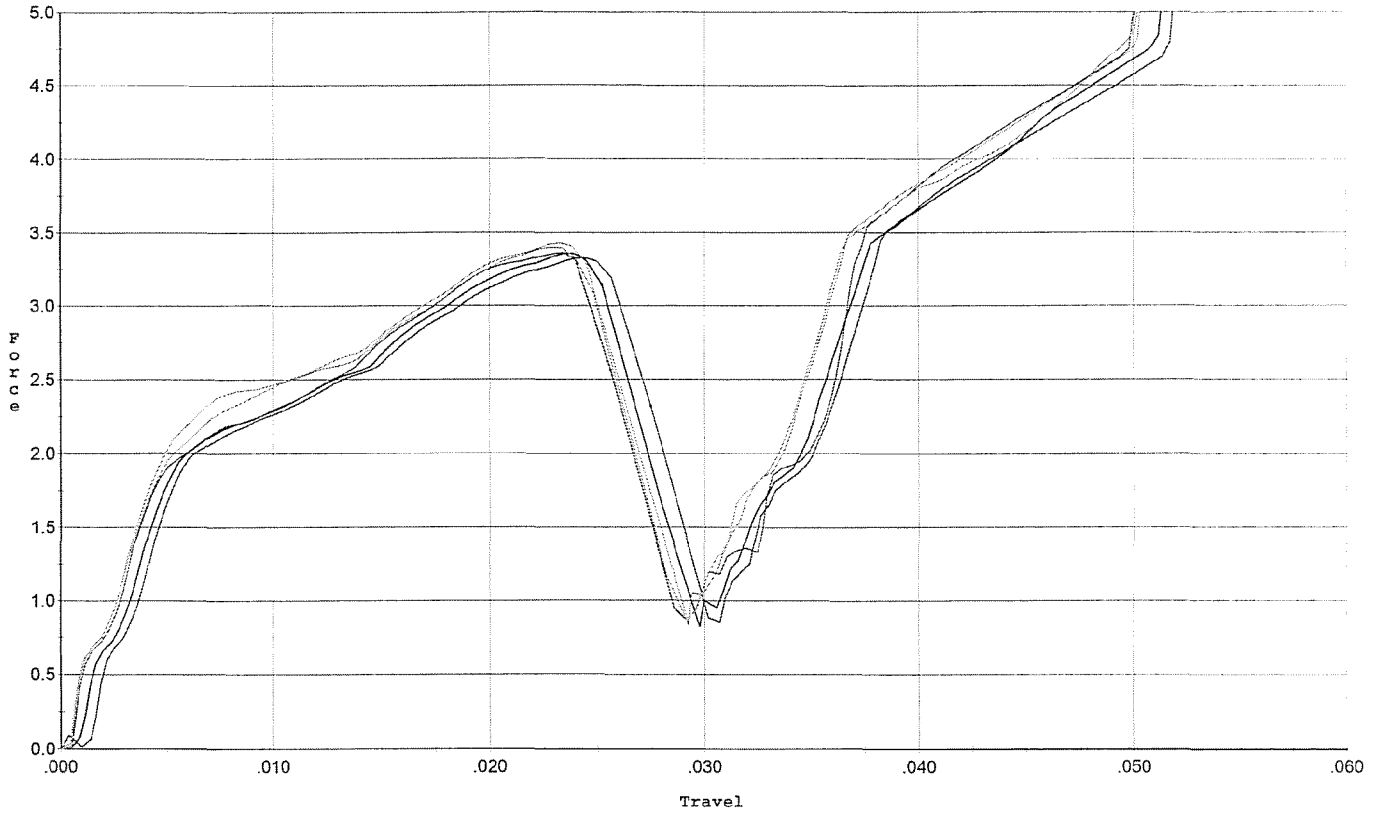
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.239	0.025	0.00	0.030	0.055		Set Trigger
2	3.211	0.027	0.00	0.029	0.058		Set Trigger
3	3.215	0.025	0.00	0.029	0.056		Set Trigger
4	3.211	0.026	0.00	0.030	0.057		Set Trigger
5	3.259	0.025	0.00	0.029	0.055		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



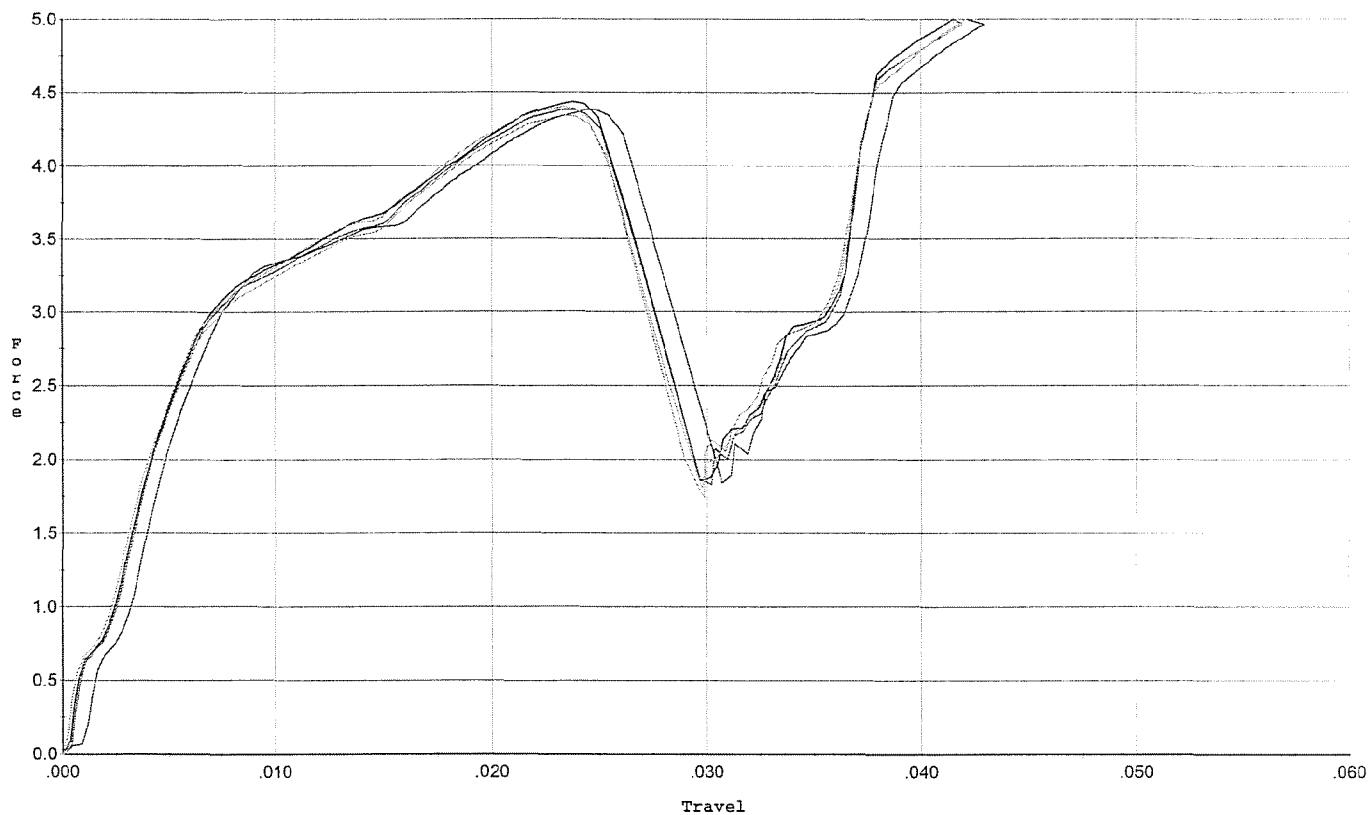
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.330	0.027	0.00	0.026	0.061		Set Trigger
2	3.356	0.025	0.00	0.030	0.056		Set Trigger
3	3.364	0.026	0.00	0.029	0.058		Set Trigger
4	3.428	0.024	0.00	0.029	0.058		Set Trigger
5	3.400	0.025	0.00	0.029	0.057		Set Trigger

A. 3.37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



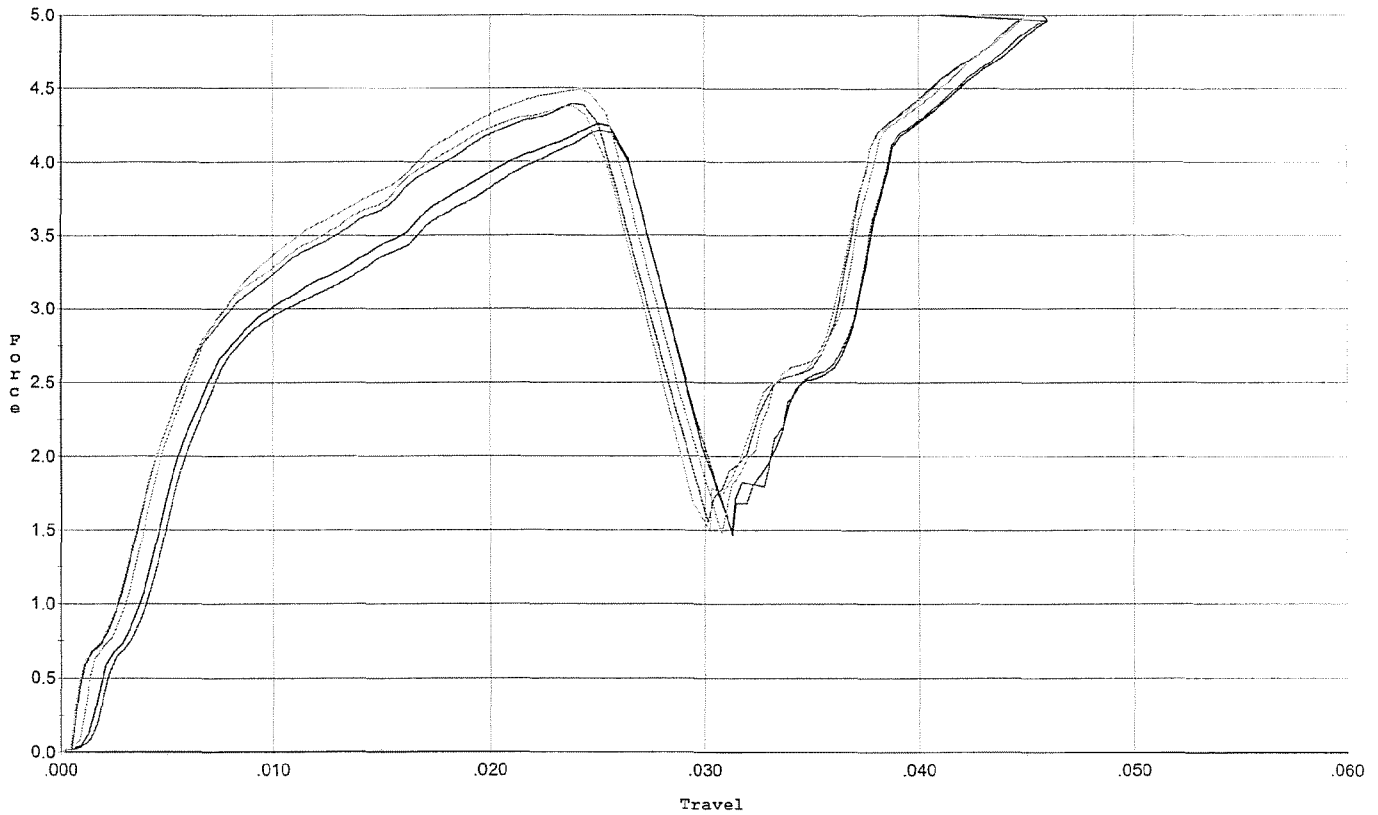
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.383	0.026	0.00	0.022	0.077		Set Trigger
2	4.439	0.027	0.00	0.022	0.081		Set Trigger
3	4.385	0.027	0.00	0.022	0.080		Set Trigger
4	4.344	0.025	0.00	0.022	0.075		Set Trigger
5	4.404	0.025	0.00	0.022	0.077		Set Trigger

A-4.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



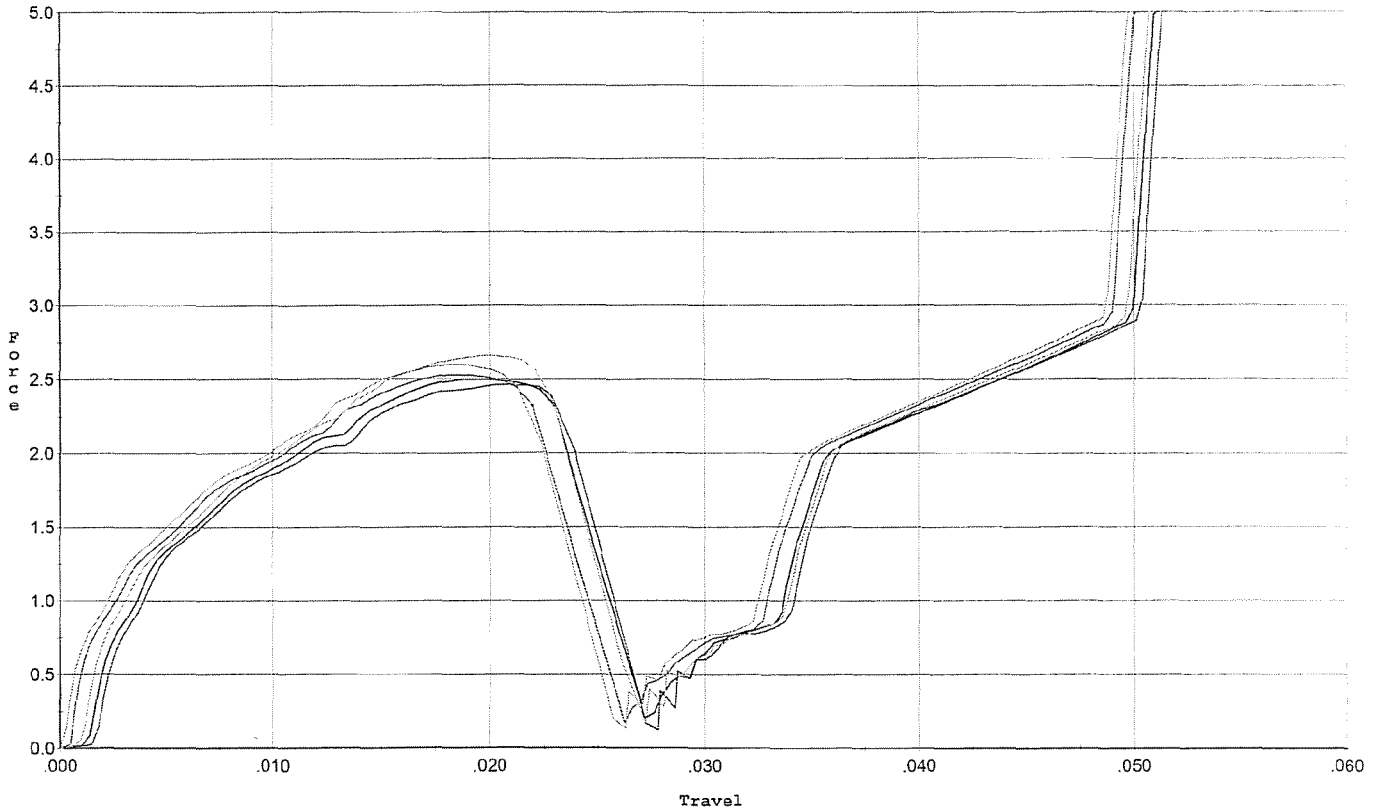
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.216	0.026	0.00	0.023	0.071		Set Trigger
2	4.261	0.026	0.00	0.023	0.073		Set Trigger
3	4.396	0.025	0.00	0.022	0.074		Set Trigger
4	4.380	0.025	0.00	0.022	0.076		Set Trigger
5	4.491	0.025	0.00	0.022	0.077		Set Trigger

A-4.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



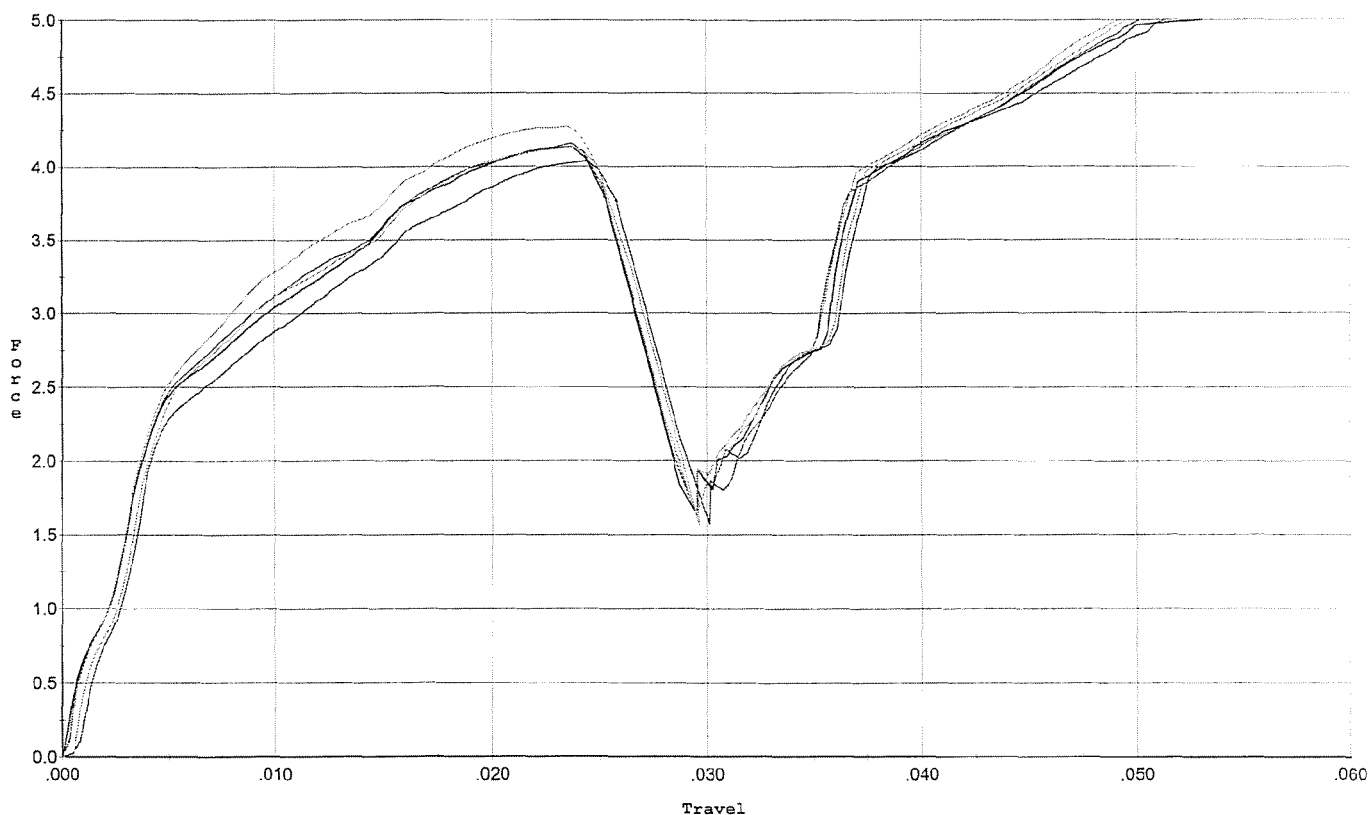
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.024	0.00	0.033	0.041		Set Trigger
2	2.499	0.023	0.00	0.033	0.040		Set Trigger
3	2.529	0.022	0.00	0.033	0.040		Set Trigger
4	2.661	0.023	0.00	0.033	0.042		Set Trigger
5	2.599	0.022	0.00	0.032	0.042		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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	4.039	0.026	0.00	0.023	0.071		Set Trigger
2	4.133	0.025	0.00	0.023	0.073		Set Trigger
3	4.158	0.025	0.00	0.023	0.073		Set Trigger
4	4.130	0.027	0.00	0.023	0.076		Set Trigger
5	4.276	0.025	0.00	0.023	0.075		Set Trigger

A-4.14