

G6845875

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

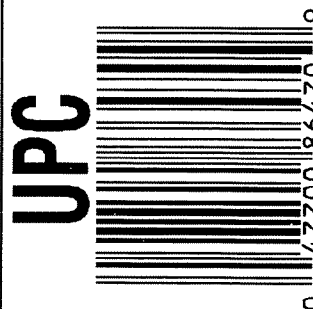


ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6845875



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G684 5875

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	SPD
470	DIS-ASSEMBLE ACTION		4-16-09	SPD
472	SERIALIZE BOLT HANDLE		4-16-09	SPD
480	MAGNAFLUX BBL ACTION	OPERATOR	4-18-09	(D)
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		4-16-09	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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

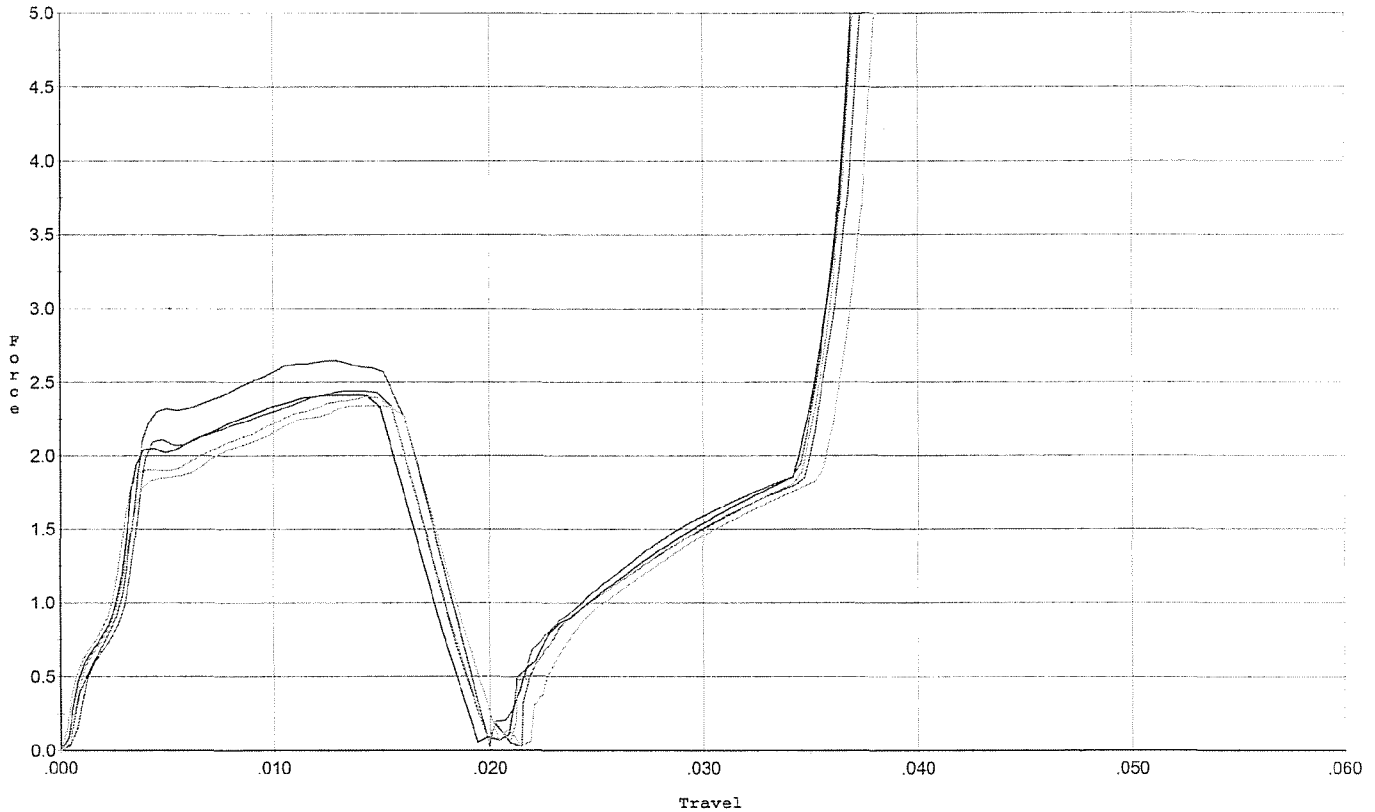
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>30</u> <u>30</u>	5-11-09	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	5-11-09	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-11-09	RJ
	J) ASSEMBLE STOCK		4-28-09	RP
	K) ASSEMBLE SWIVEL STUDS		5-11-09	RJ
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	5-1-09	RJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-1-09	TJR
670	FINAL INSPECTION A) HEADSPACE		5-11-09	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u> <u>2.42</u> <u>2.20</u> <u>2.26</u> <u>2.22</u>	5-7-09	RP
	C) FUNCTION		5-11-09	RJ
690	PACK		7/7/09	FJ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/28/2009

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



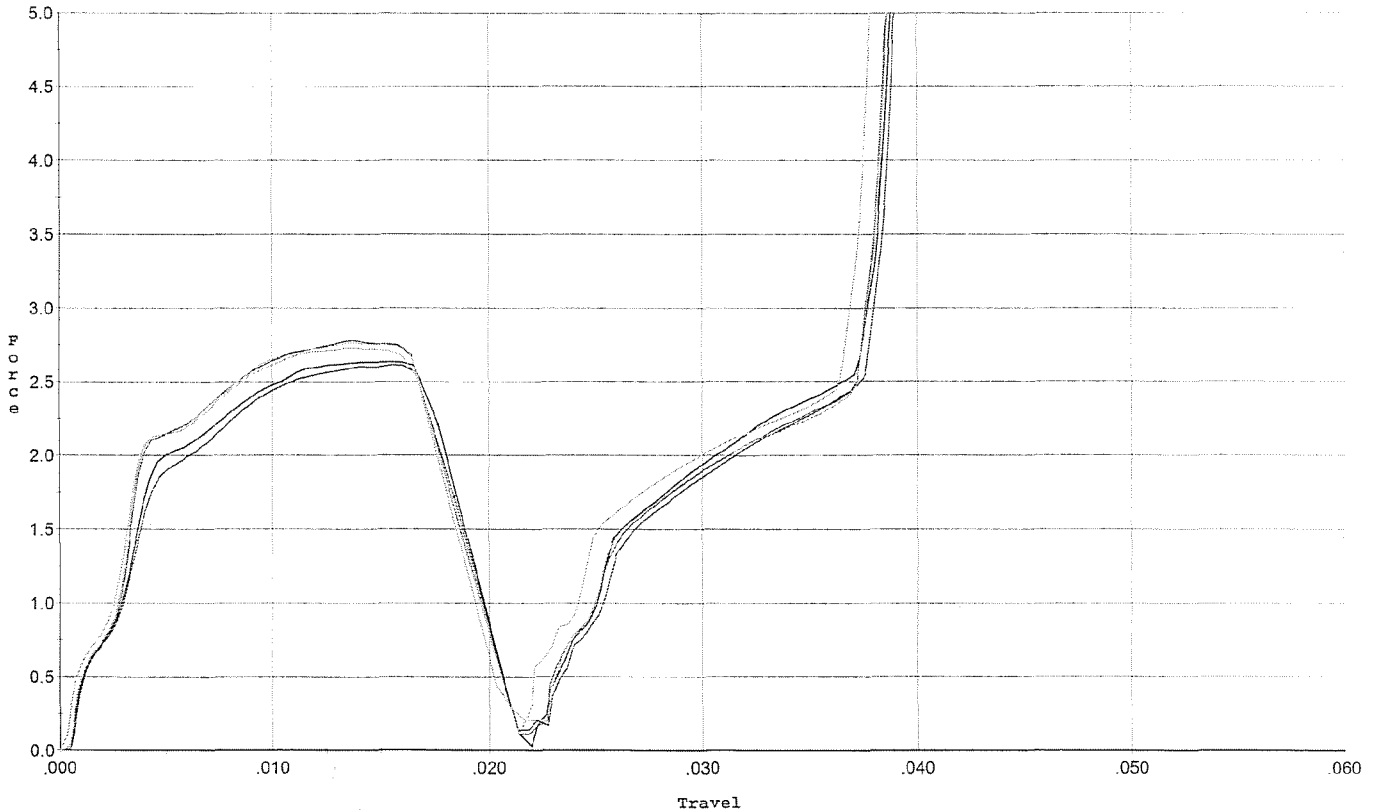
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.646	0.016	0.00	0.026	0.031		Set Trigger
2	2.414	0.015	0.00	0.026	0.027		Set Trigger
3	2.441	0.015	0.00	0.026	0.027		Set Trigger
4	2.341	0.016	0.00	0.027	0.028		Set Trigger
5	2.404	0.015	0.00	0.026	0.027		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/28/2009

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



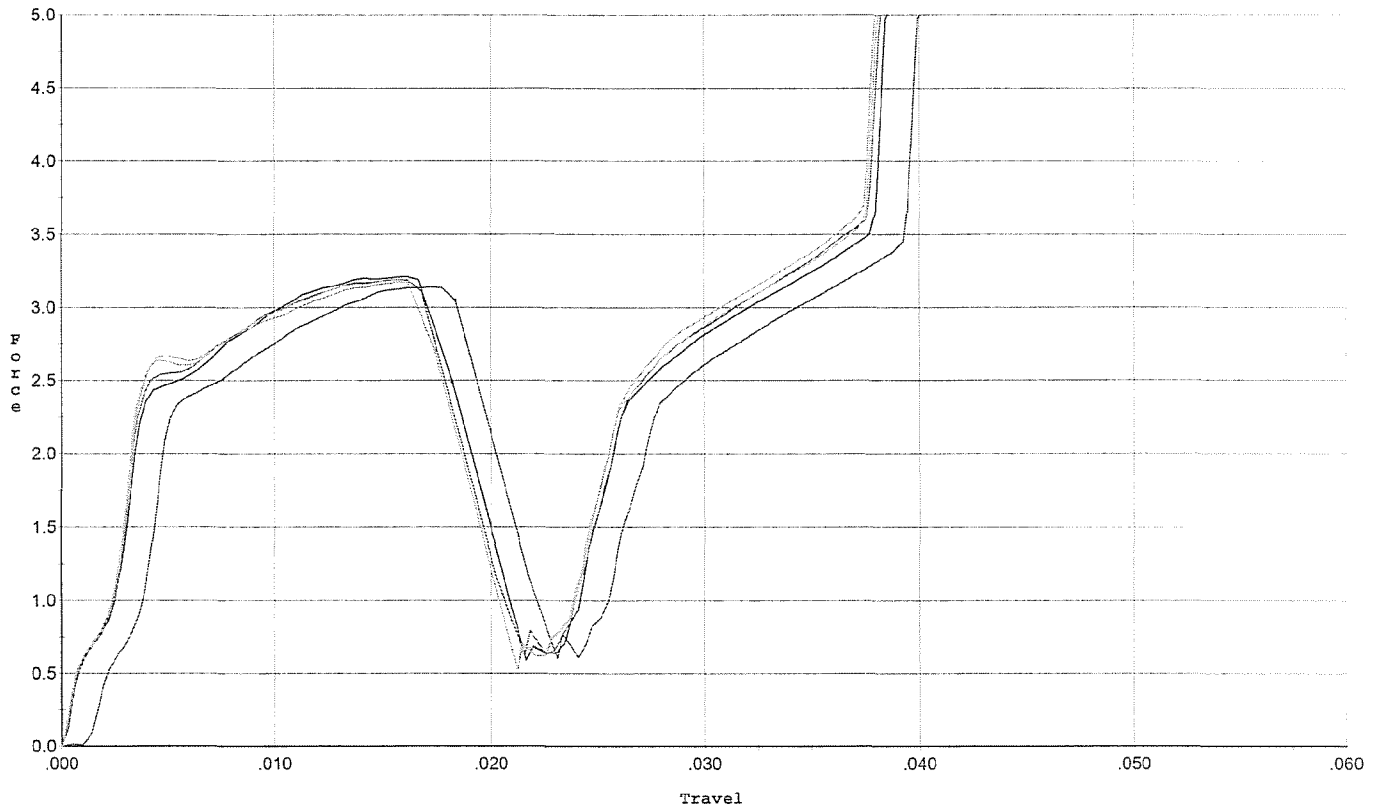
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.614	0.018	0.00	0.026	0.034		Set Trigger
2	2.634	0.018	0.00	0.026	0.034		Set Trigger
3	2.781	0.016	0.00	0.026	0.033		Set Trigger
4	2.729	0.017	0.00	0.025	0.033		Set Trigger
5	2.766	0.016	0.00	0.026	0.033		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/28/2009

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



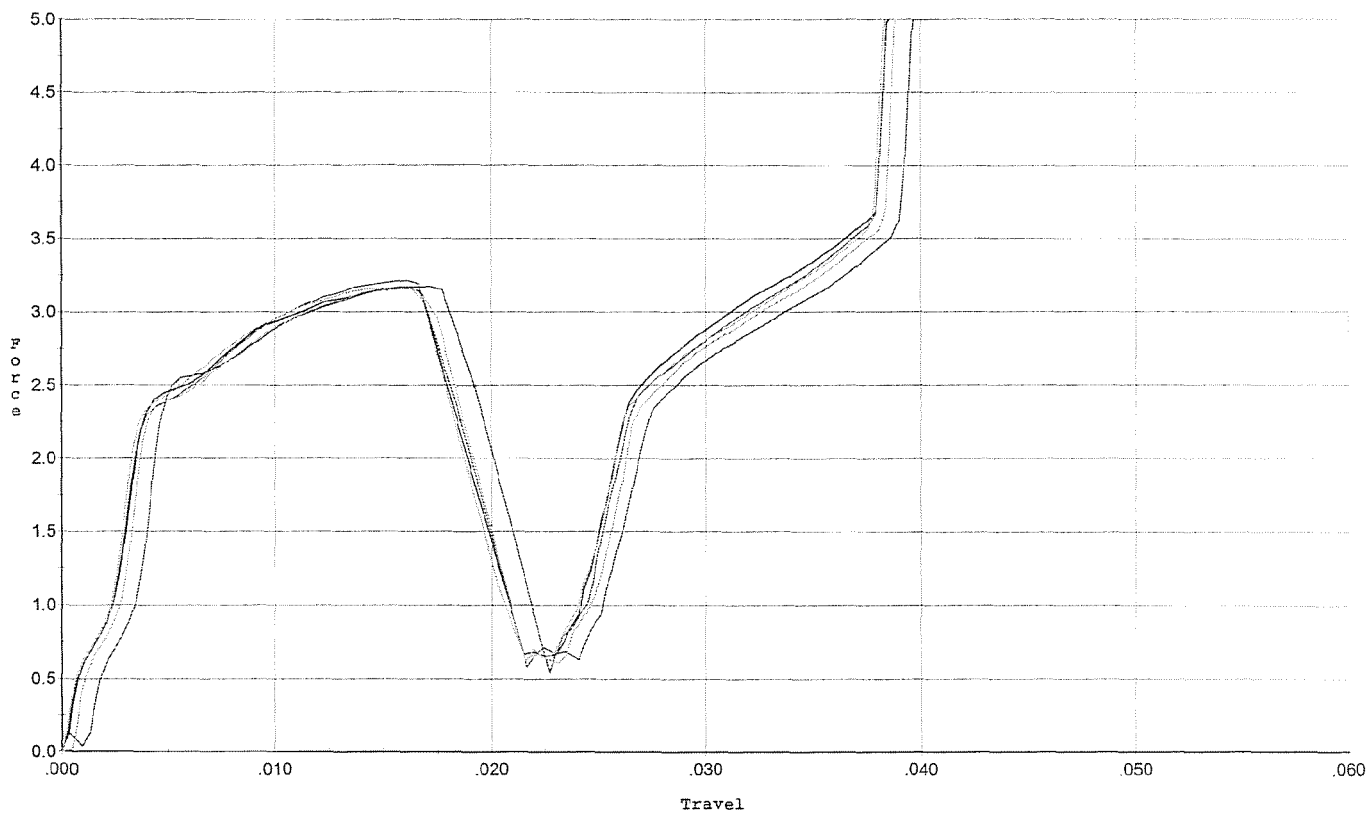
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.139	0.018	0.00	0.025	0.039		Set Trigger
2	3.211	0.018	0.00	0.025	0.042		Set Trigger
3	3.189	0.017	0.00	0.025	0.039		Set Trigger
4	3.185	0.017	0.00	0.024	0.040		Set Trigger
5	3.174	0.017	0.00	0.024	0.040		Set Trigger

A-3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/28/2009

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



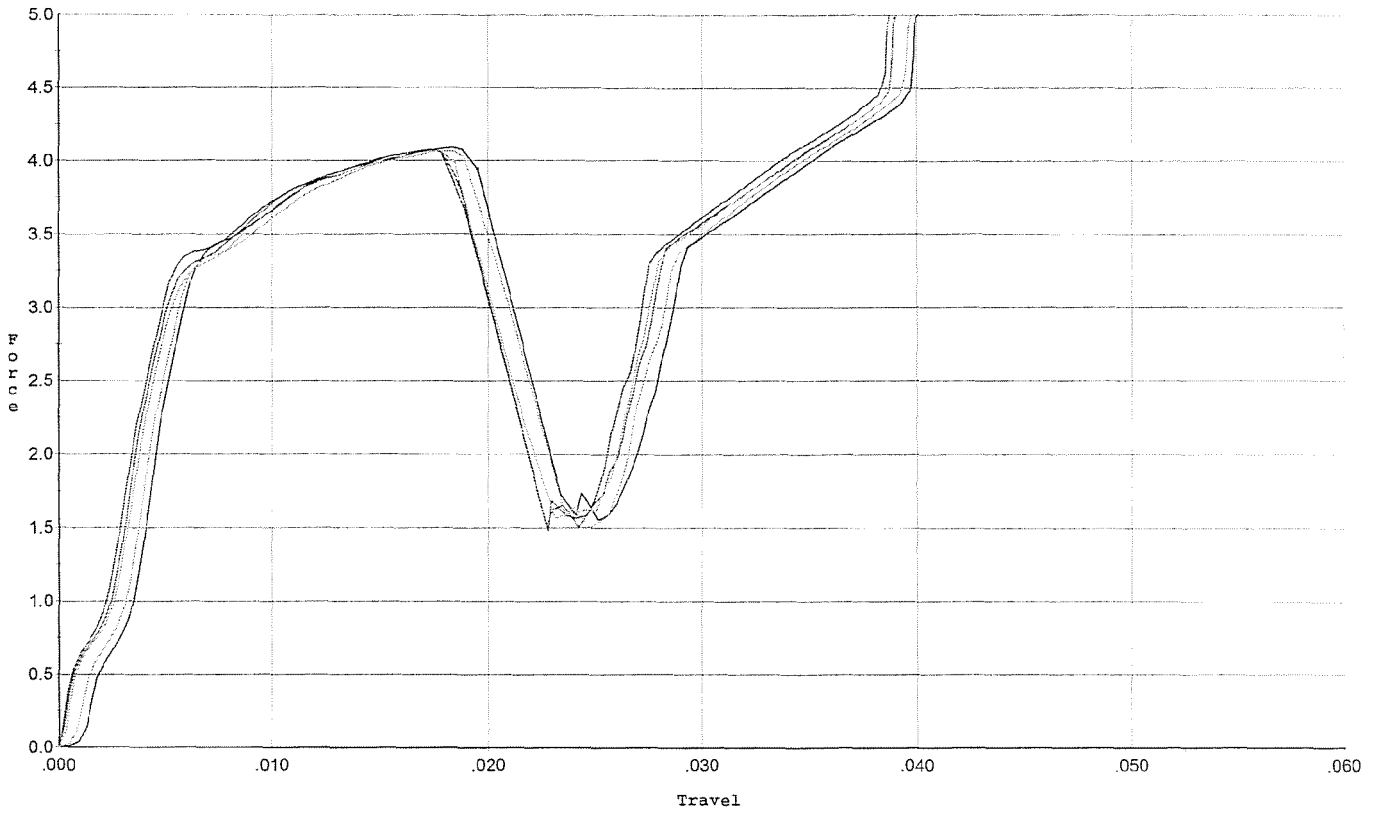
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.019	0.00	0.025	0.043		Set Trigger
2	3.175	0.017	0.00	0.025	0.038		Set Trigger
3	3.215	0.019	0.00	0.024	0.042		Set Trigger
4	3.174	0.017	0.00	0.025	0.039		Set Trigger
5	3.163	0.018	0.00	0.025	0.039		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/28/2009

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



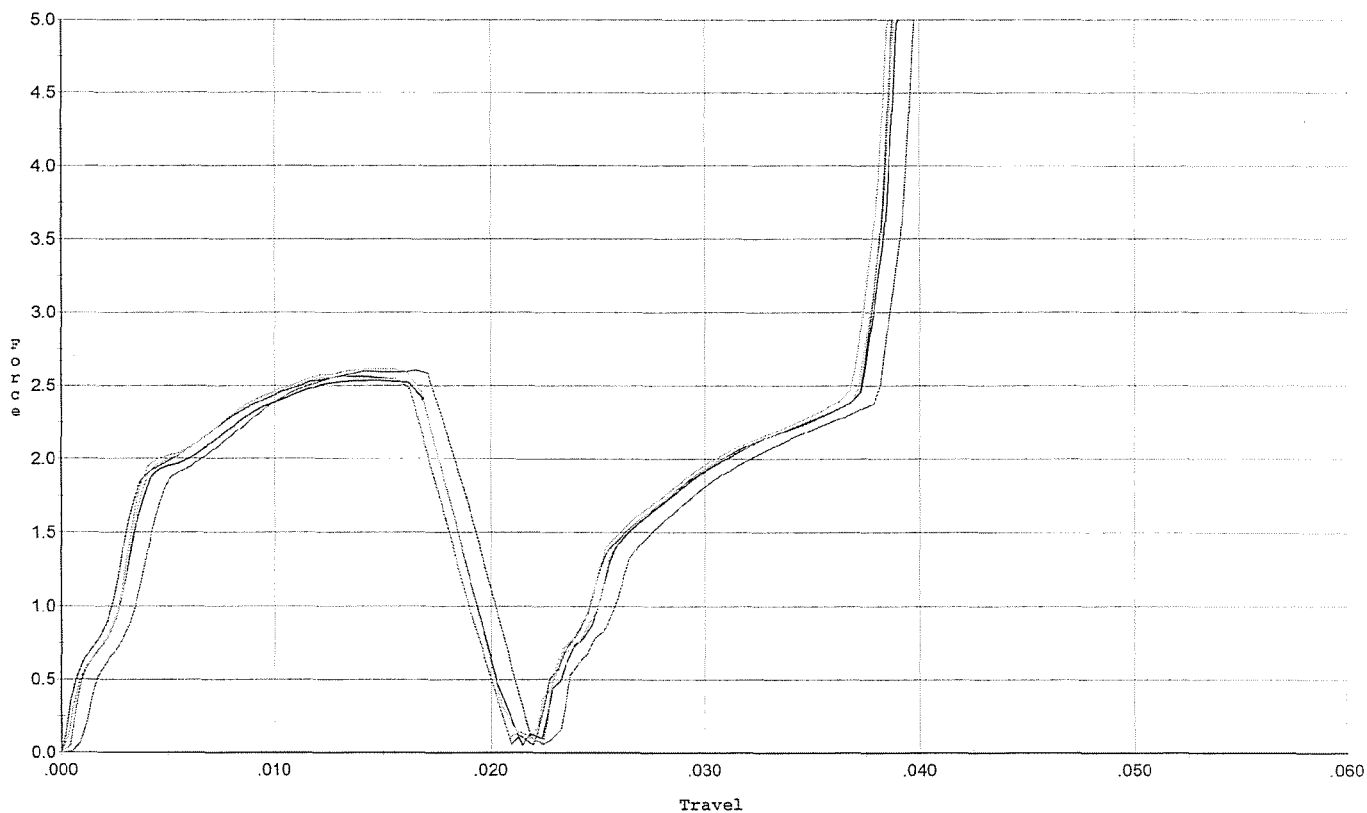
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.074	0.019	0.00	0.018	0.055		Set Trigger
2	4.089	0.019	0.00	0.018	0.054		Set Trigger
3	4.077	0.019	0.00	0.018	0.053		Set Trigger
4	4.063	0.018	0.00	0.018	0.052		Set Trigger
5	4.066	0.021	0.00	0.018	0.058		Set Trigger

A-4-07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/28/2009

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



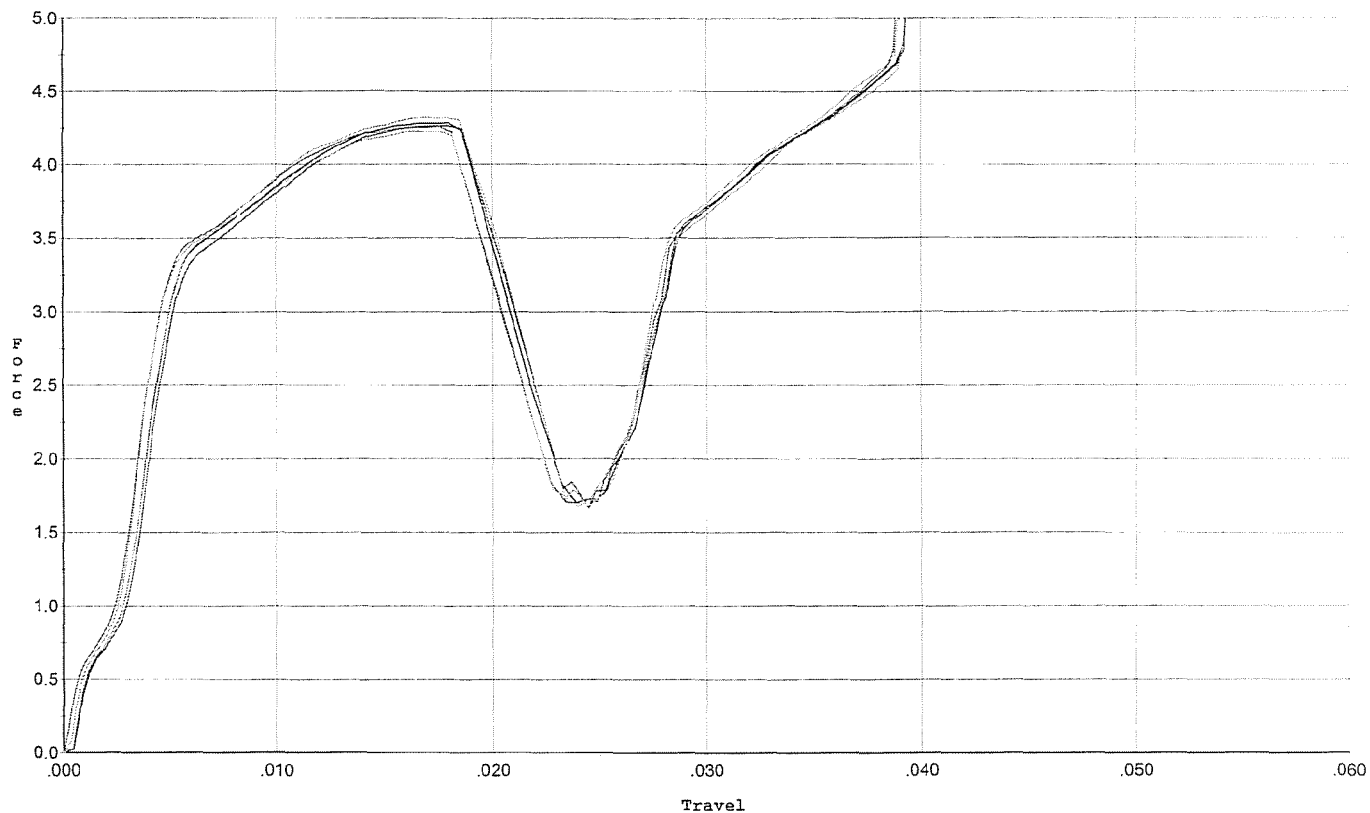
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.016	0.00	0.026	0.031		Set Trigger
2	2.536	0.017	0.00	0.026	0.031		Set Trigger
3	2.606	0.019	0.00	0.026	0.034		Set Trigger
4	2.618	0.017	0.00	0.025	0.032		Set Trigger
5	2.567	0.016	0.00	0.026	0.031		Set Trigger

A-2.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/28/2009

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	4.263	0.021	0.00	0.017	0.060		Set Trigger
2	4.280	0.019	0.00	0.017	0.055		Set Trigger
3	4.258	0.018	0.00	0.018	0.054		Set Trigger
4	4.228	0.020	0.00	0.017	0.060		Set Trigger
5	4.323	0.020	0.00	0.017	0.060		Set Trigger

A. 4.27