

G684 8396

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

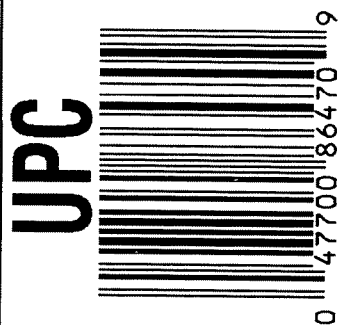


ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6848396



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6848396

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-5-09	RP
430	ASSEMBLE TO STOCK		5-5-09	SP
440	PROOF		5-5-09	RP
460	CHECK HEADSPACE		5-5-09	RP
470	DIS-ASSEMBLE ACTION		5-5-09	RP
472	SERIALIZE BOLT HANDLE		5-6-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/8/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/12/09	RT
510	DRILL AND TAP SIGHT HOLES		5-6-09	SP
520	GOFF BLAST BBL / REC		5/12/09	RCM
540	APPLY COATINGS (BARREL ACTION)		5/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

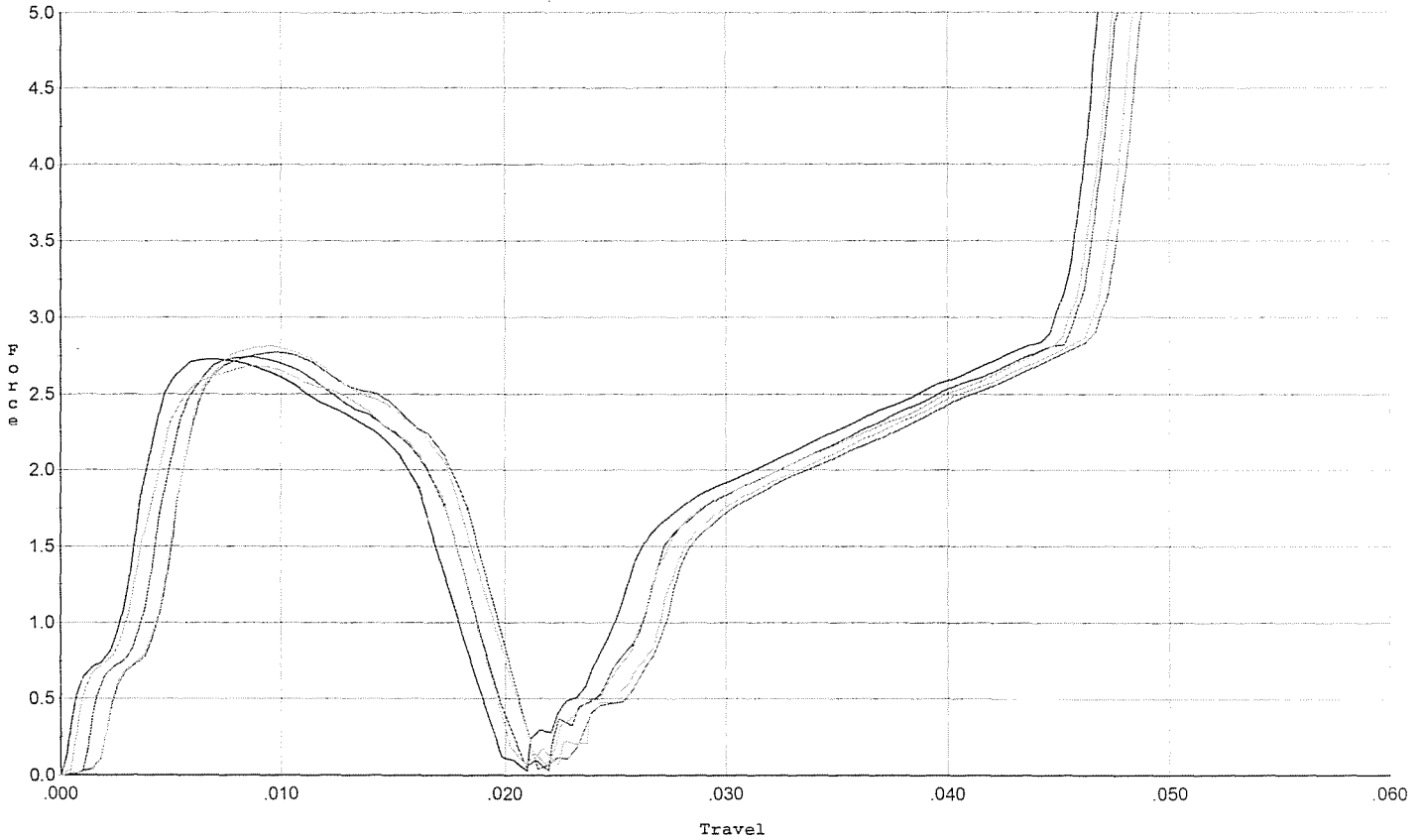
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-16-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-16-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	6-16-09	LN
	J) ASSEMBLE STOCK		5-26-09	MM
	K) ASSEMBLE SWIVEL STUDS		6-16-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	6/10/09	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/10/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-16-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>291</u> <u>273</u> <u>267</u> <u>277</u> <u>268</u>	6-15-09	RTZ
	C) FUNCTION		6-16-09	LN
690	PACK		7/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



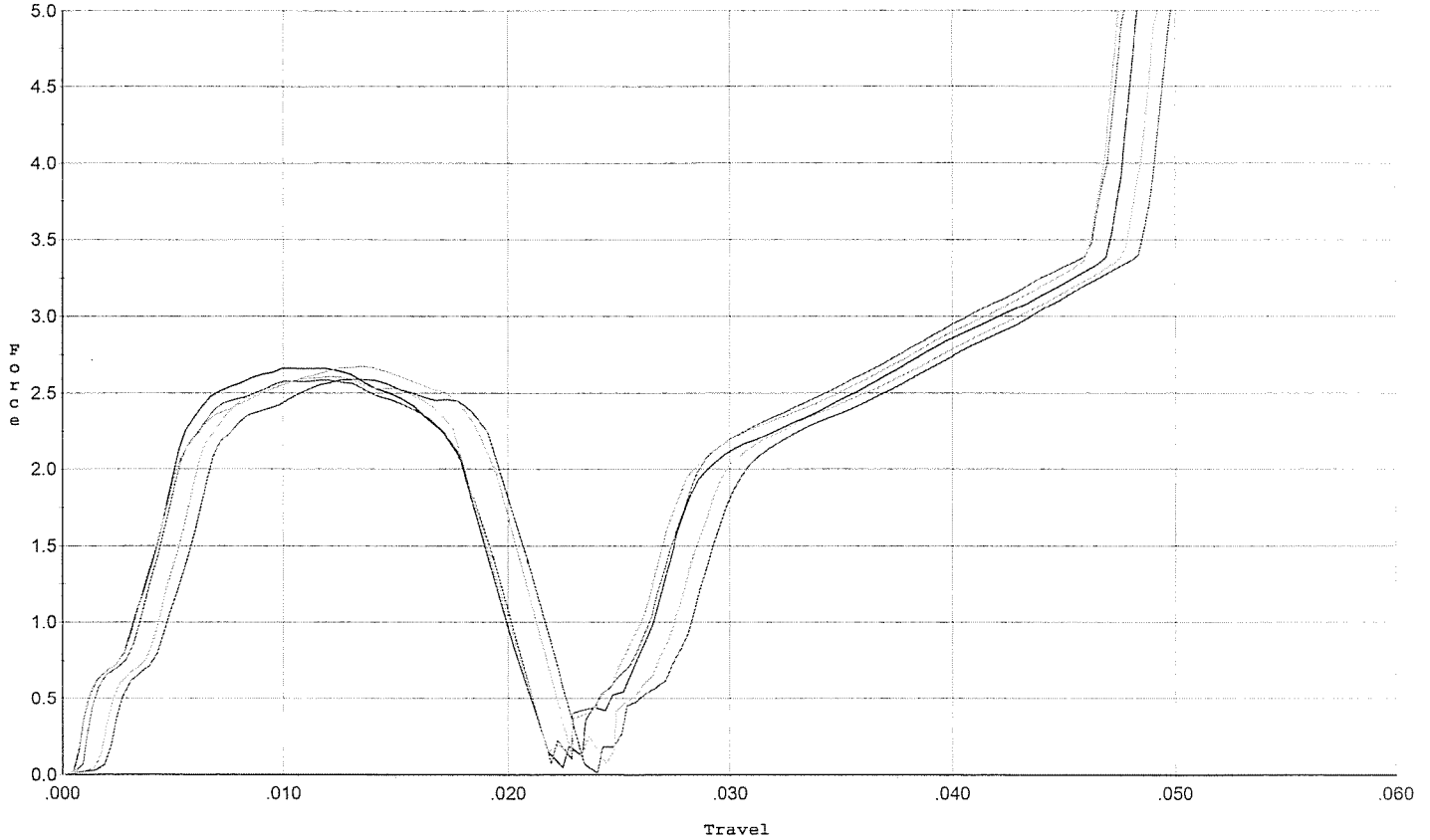
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.739	0.017	0.00	0.034	0.032		Set Trigger
2	2.728	0.016	0.00	0.034	0.031		Set Trigger
3	2.772	0.018	0.00	0.034	0.033		Set Trigger
4	2.811	0.017	0.00	0.035	0.032		Set Trigger
5	2.688	0.017	0.00	0.034	0.033		Set Trigger

A 2.74

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



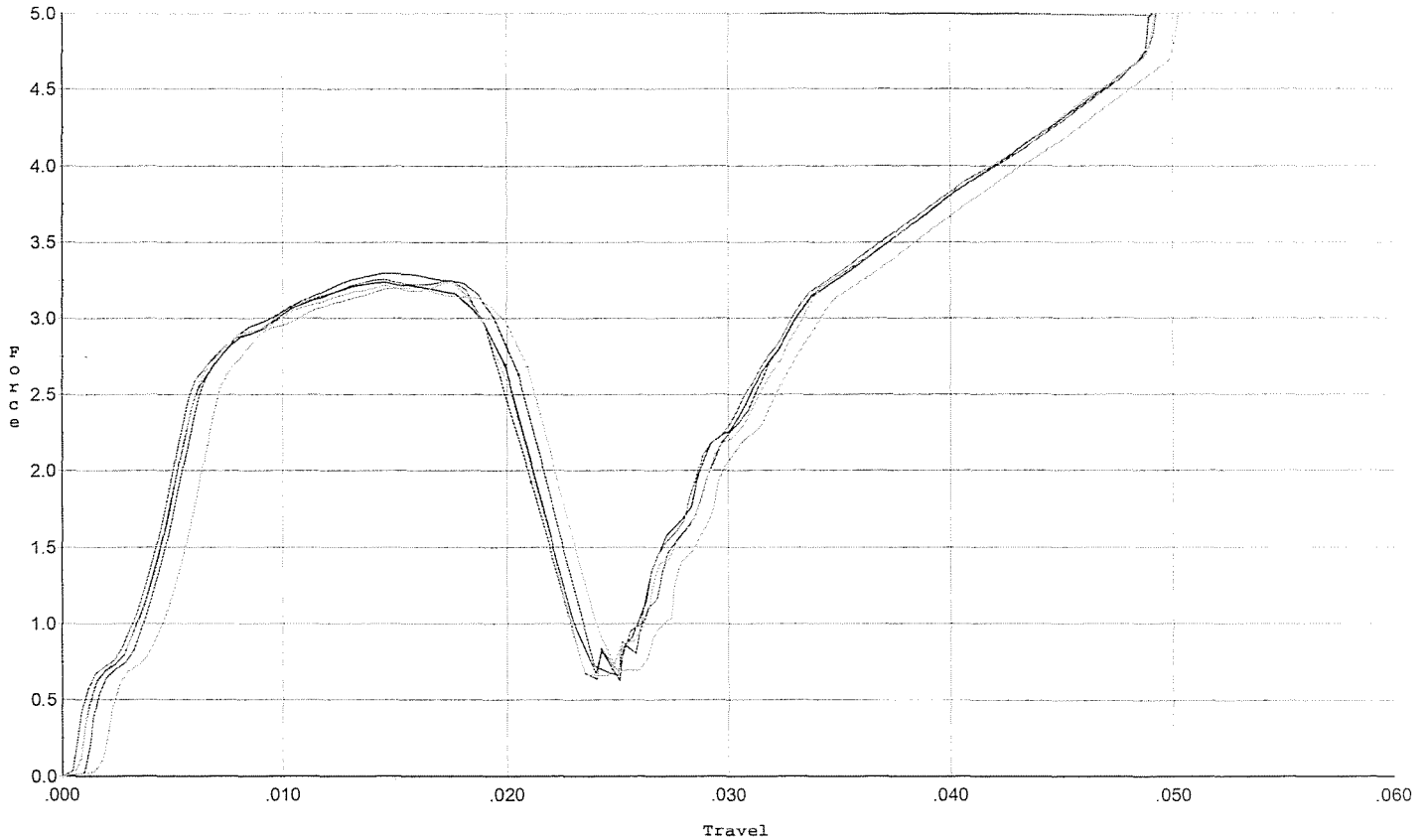
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.021	0.00	0.034	0.036		Set Trigger
2	2.662	0.018	0.00	0.034	0.034		Set Trigger
3	2.584	0.019	0.00	0.032	0.035		Set Trigger
4	2.673	0.020	0.00	0.033	0.036		Set Trigger
5	2.607	0.018	0.00	0.033	0.033		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



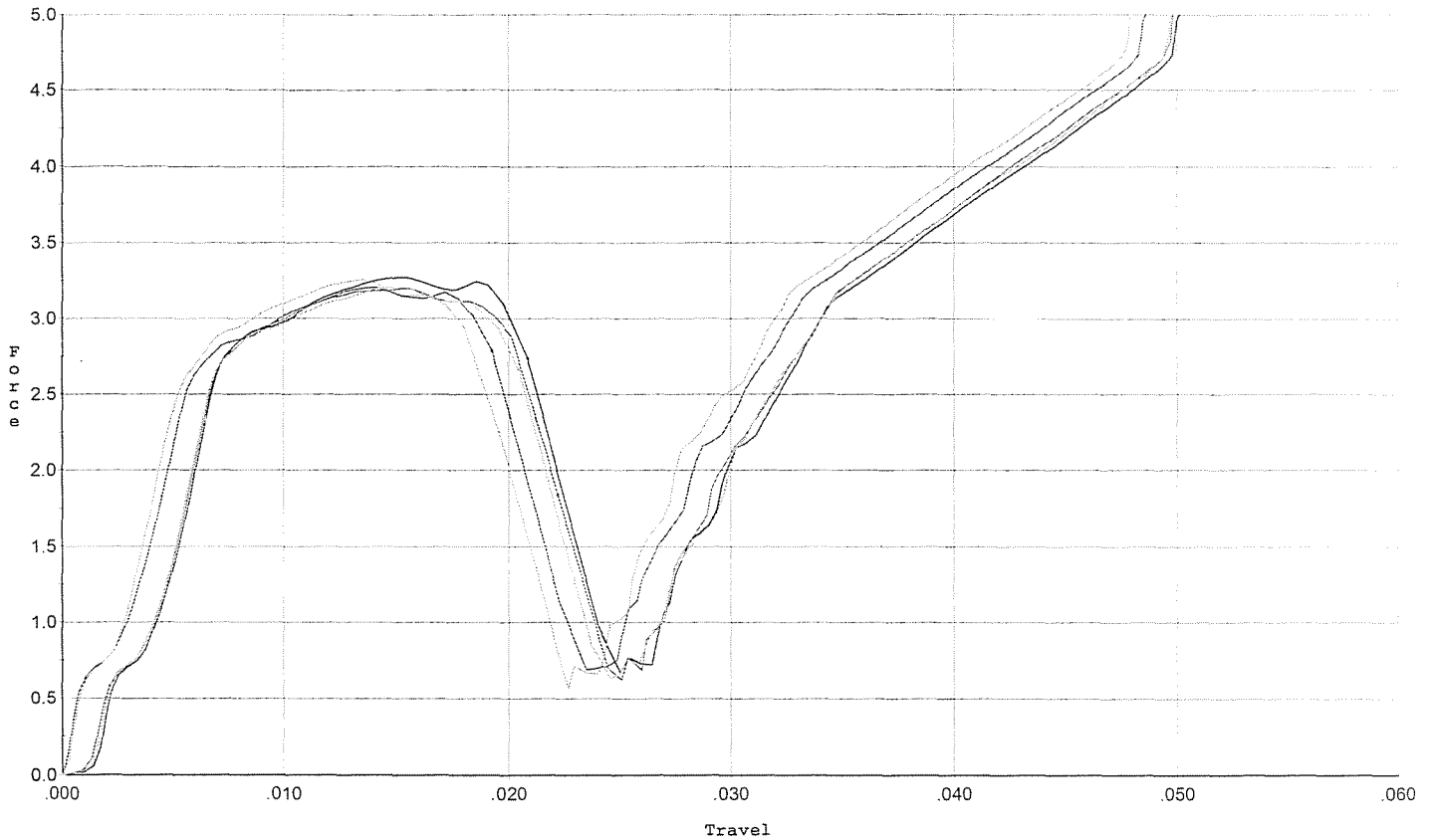
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.298	0.020	0.00	0.031	0.047		Set Trigger
2	3.239	0.020	0.00	0.031	0.045		Set Trigger
3	3.258	0.021	0.00	0.031	0.048		Set Trigger
4	3.242	0.020	0.00	0.031	0.046		Set Trigger
5	3.204	0.021	0.00	0.031	0.045		Set Trigger

A-3.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



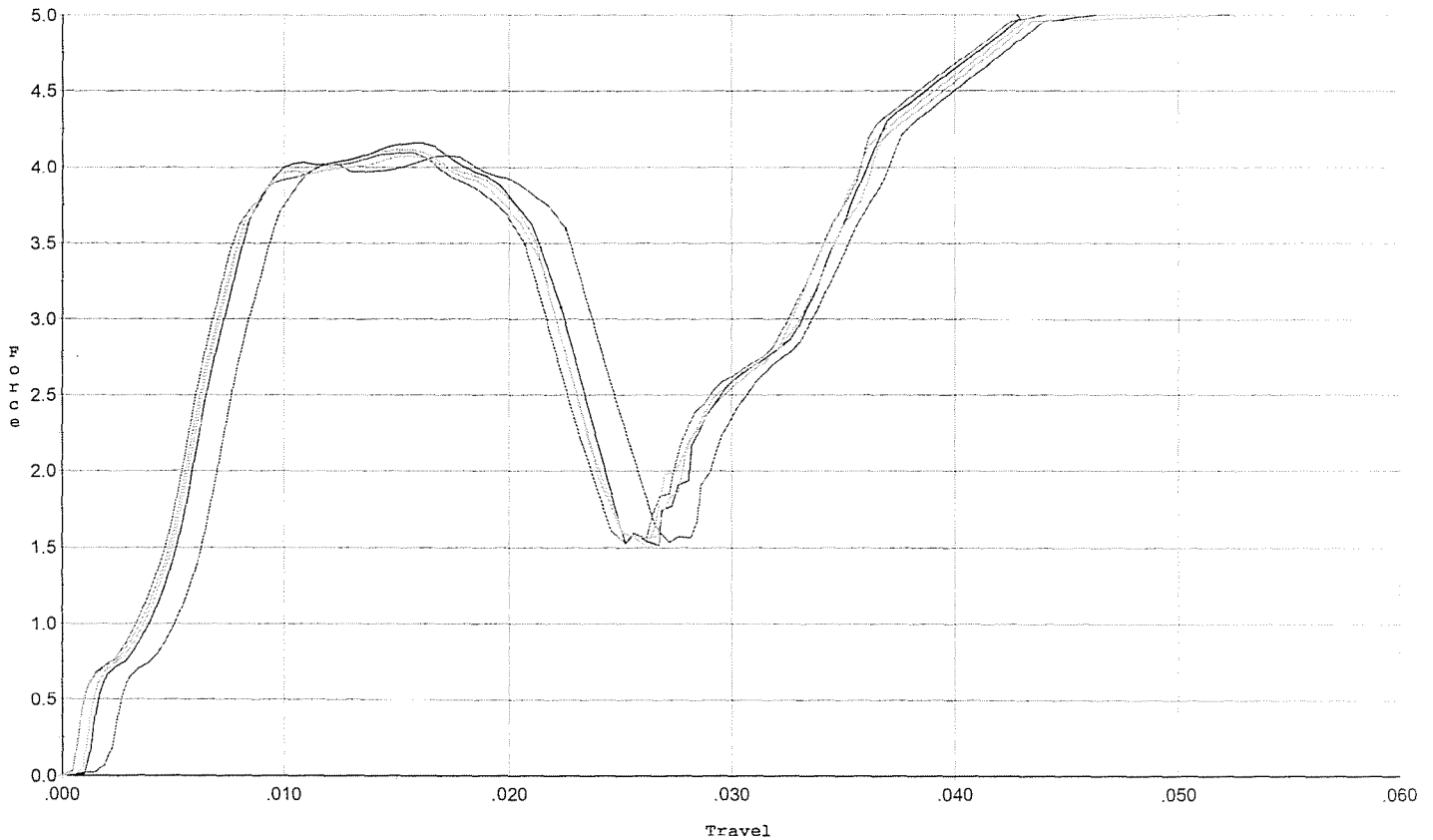
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.207	0.019	0.00	0.031	0.045		Set Trigger
2	3.274	0.021	0.00	0.031	0.047		Set Trigger
3	3.200	0.022	0.00	0.031	0.049		Set Trigger
4	3.211	0.020	0.00	0.031	0.045		Set Trigger
5	3.259	0.020	0.00	0.031	0.046		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



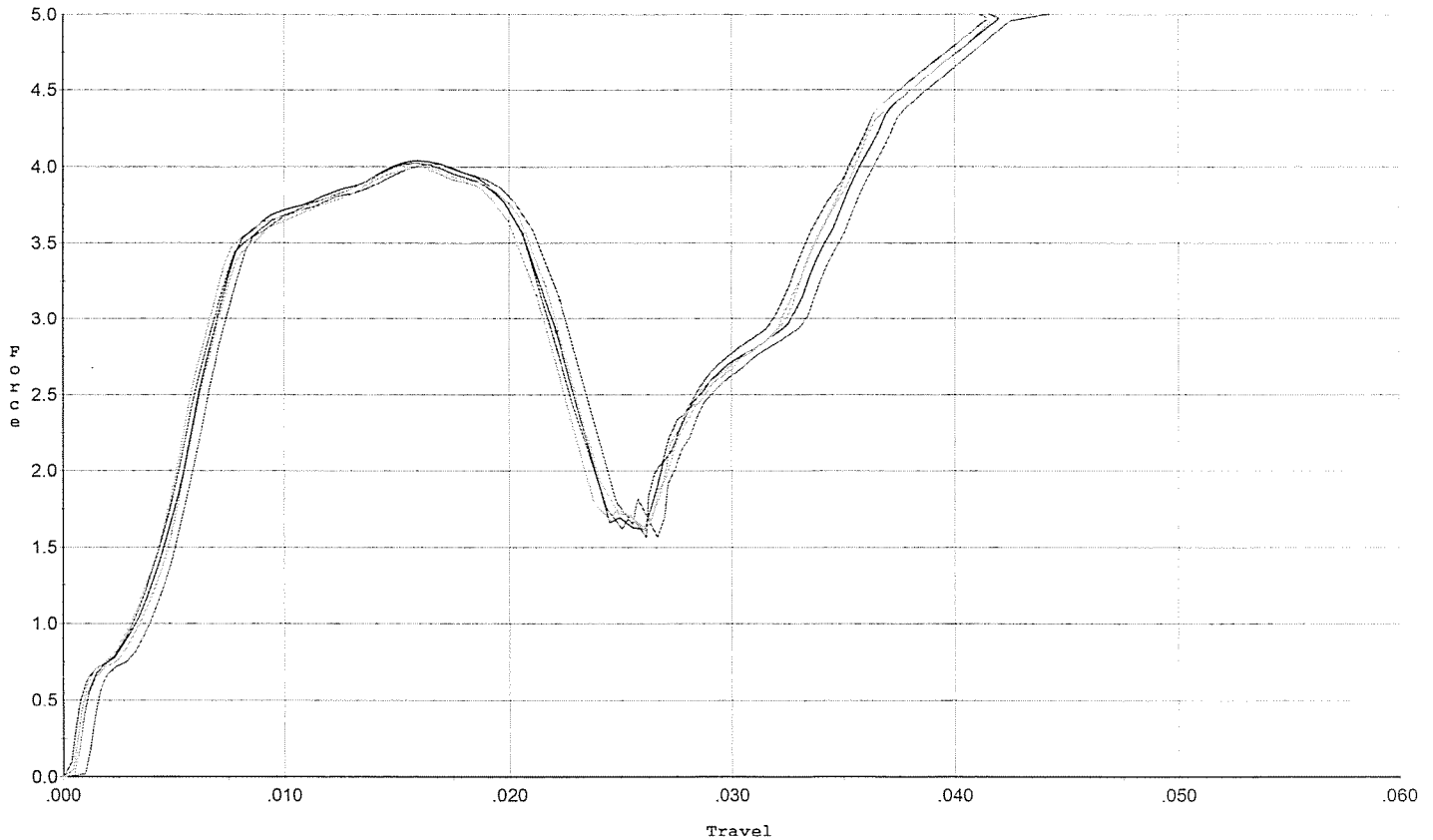
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.077	0.023	0.00	0.028	0.060		Set Trigger
2	4.157	0.022	0.00	0.028	0.062		Set Trigger
3	4.093	0.021	0.00	0.028	0.058		Set Trigger
4	4.074	0.021	0.00	0.028	0.059		Set Trigger
5	4.118	0.021	0.00	0.028	0.059		Set Trigger

A-24.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



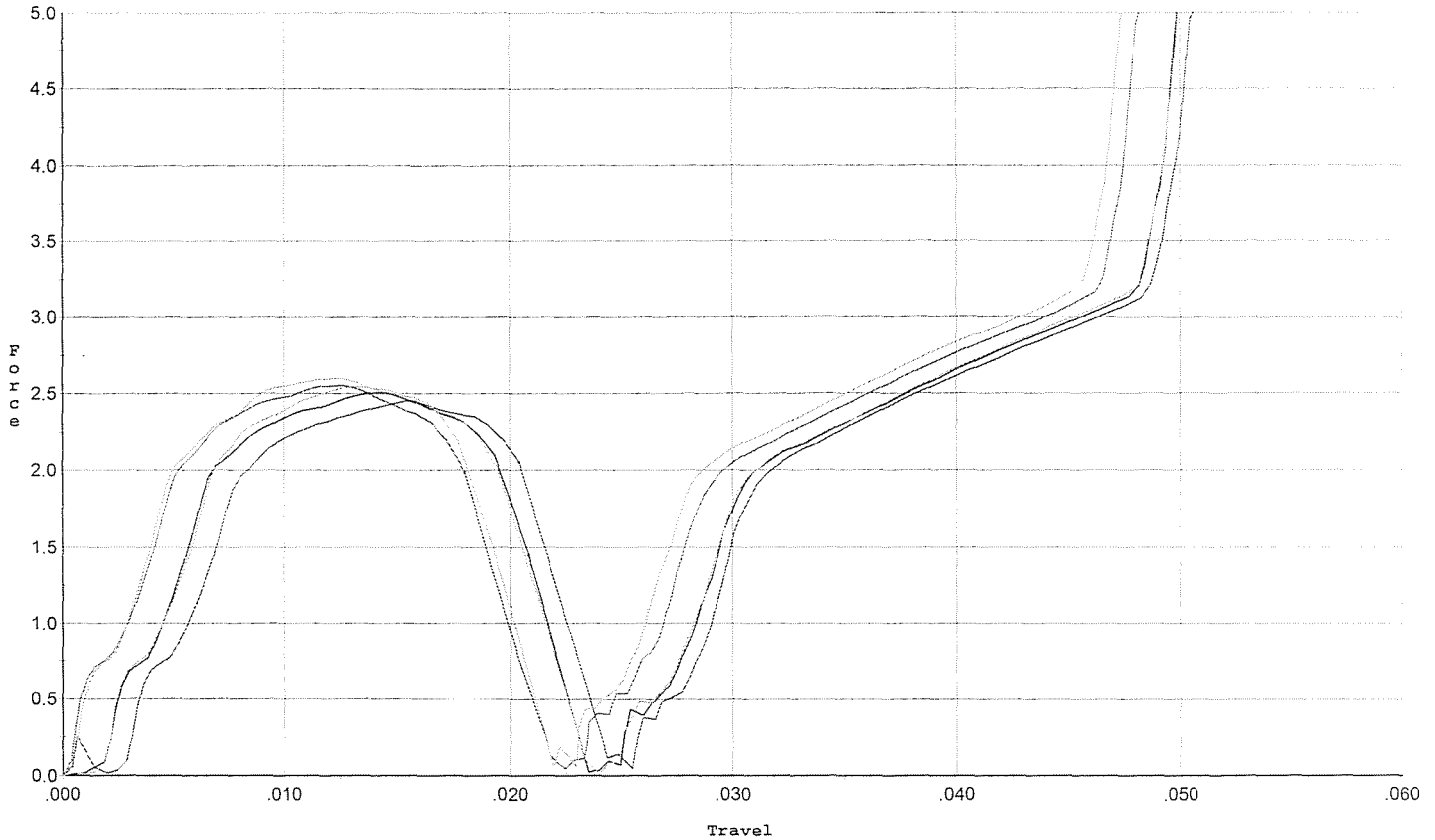
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.024	0.021	0.00	0.026	0.057		Set Trigger
2	4.039	0.022	0.00	0.026	0.060		Set Trigger
3	4.017	0.022	0.00	0.026	0.060		Set Trigger
4	3.998	0.022	0.00	0.025	0.059		Set Trigger
5	4.013	0.021	0.00	0.025	0.058		Set Trigger

A. 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



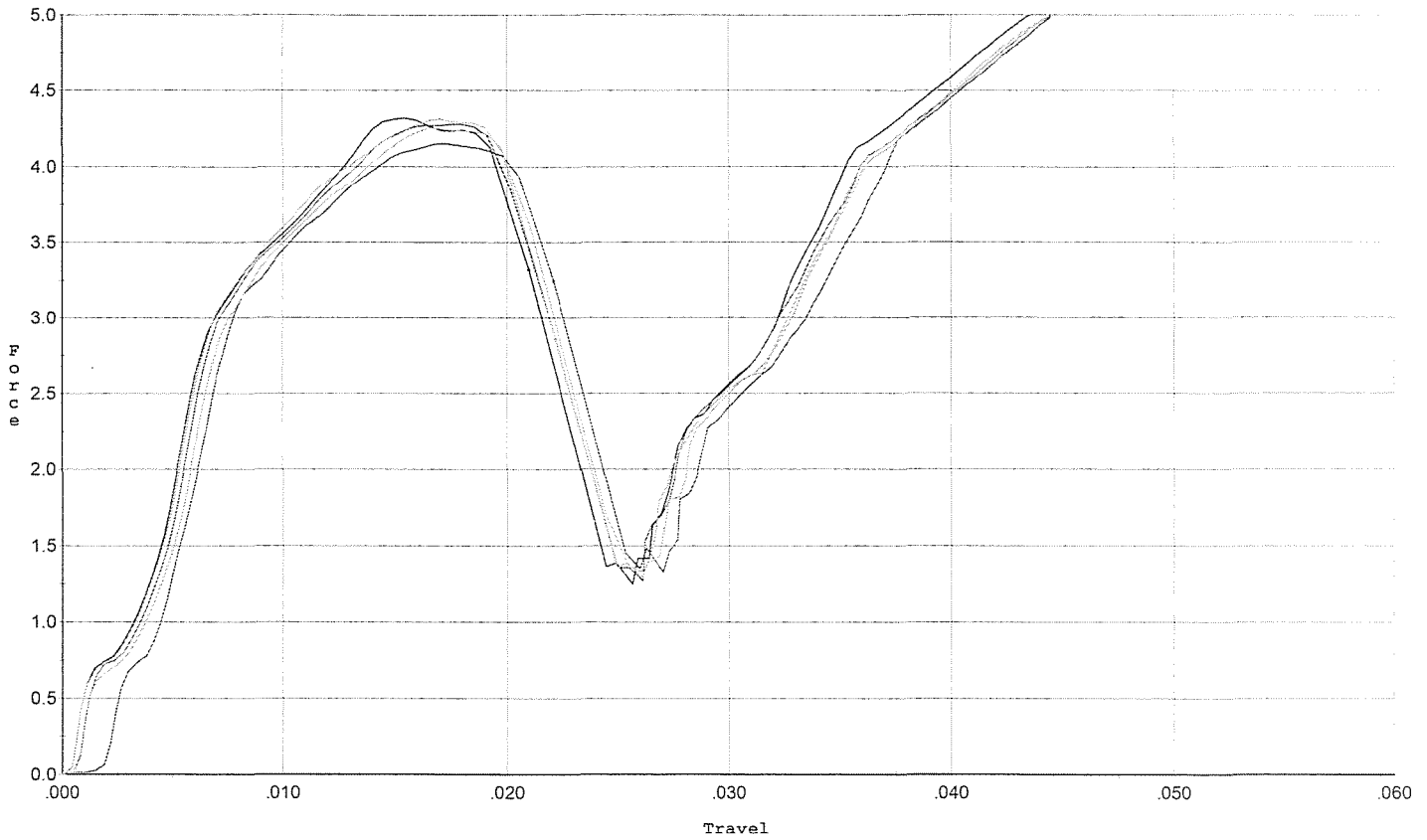
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.448	0.020	0.003	0.034	0.033		Set Trigger
2	2.506	0.021	0.00	0.034	0.035		Set Trigger
3	2.553	0.018	0.00	0.033	0.033		Set Trigger
4	2.601	0.019	0.00	0.032	0.036		Set Trigger
5	2.545	0.021	0.00	0.034	0.036		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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	4.153	0.022	0.00	0.030	0.058		Set Trigger
2	4.318	0.021	0.00	0.029	0.059		Set Trigger
3	4.277	0.022	0.00	0.029	0.061		Set Trigger
4	4.255	0.021	0.00	0.029	0.057		Set Trigger
5	4.312	0.022	0.00	0.029	0.062		Set Trigger

A. 4.26