

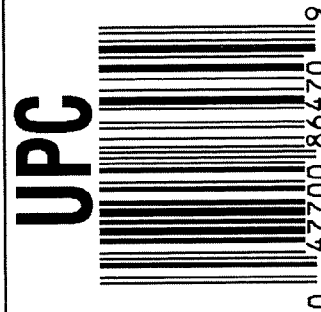
G6774451

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

G6774451



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6774451

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-31-08	SP
430	ASSEMBLE TO STOCK		7-31-08	SP
440	PROOF		7-31-08	SP
460	CHECK HEADSPACE		7-31-08	SP
470	DIS-ASSEMBLE ACTION		7-31-08	SP
472	SERIALIZE BOLT HANDLE		8-1-08	SP
475	DRILL AND TAP SIGHT HOLES		8-04-08	SP
480	MAGNAFLUX BBL ACTION	MAGNA FLUX AUG 05 2008 OPERATOR B.M.	8/5	B.M.
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/5/08	RT
520	GOFF BLAST BBL / REC		8/6/08	DR
542	APPLY COATINGS (BARREL ACTION)		8/13	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-14-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-14-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-14-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-20-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

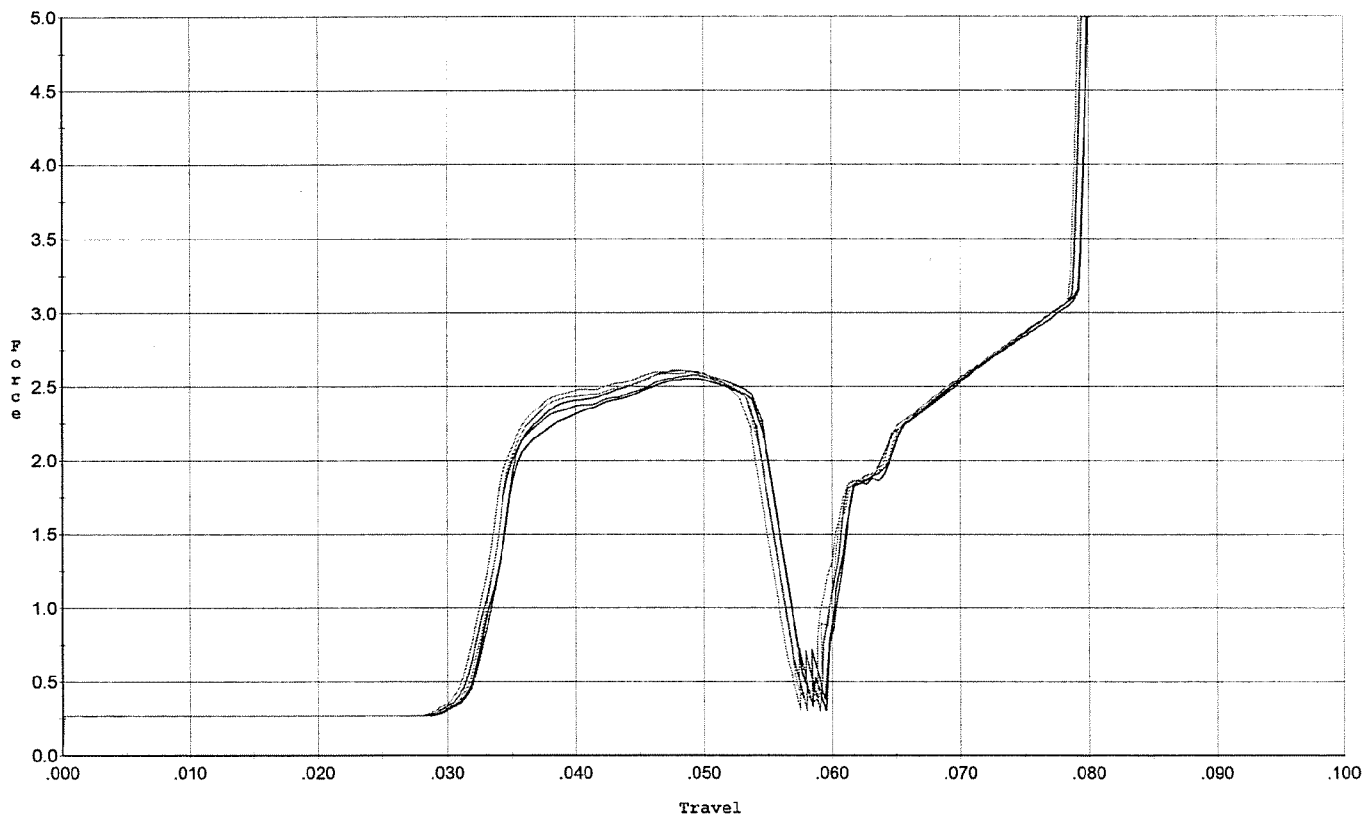
OP #	OPERATION NAME		READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4</u>	<u>3.5</u>	<u>4</u>	9-8-08	TC
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6</u>	<u>5.5</u>	<u>6</u>	9-8-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.024</u>	<u>.024</u>	9-8-08	TC
	J) ASSEMBLE STOCK					8-20-08	PSW
	K) ASSEMBLE SWIVEL STUDS					9-8-08	TC
	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		8-21-08	TRW
	MALFUNCTION		N/A				
		CORRECTION					
	MALFUNCTION						
		CORRECTION					
	MALFUNCTION						
		CORRECTION				8/21/08	JL
660	INSPECT FOR LIVE AMMO					8-21-08	TC
670	FINAL INSPECTION A) HEADSPACE					9-8-08	TC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.05</u>	<u>2.07</u>	<u>2.27</u> <u>2.27</u> <u>2.22</u>	9-8-08	PSW
	C) FUNCTION					9-8-08	TC
690	PACK					10/13/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



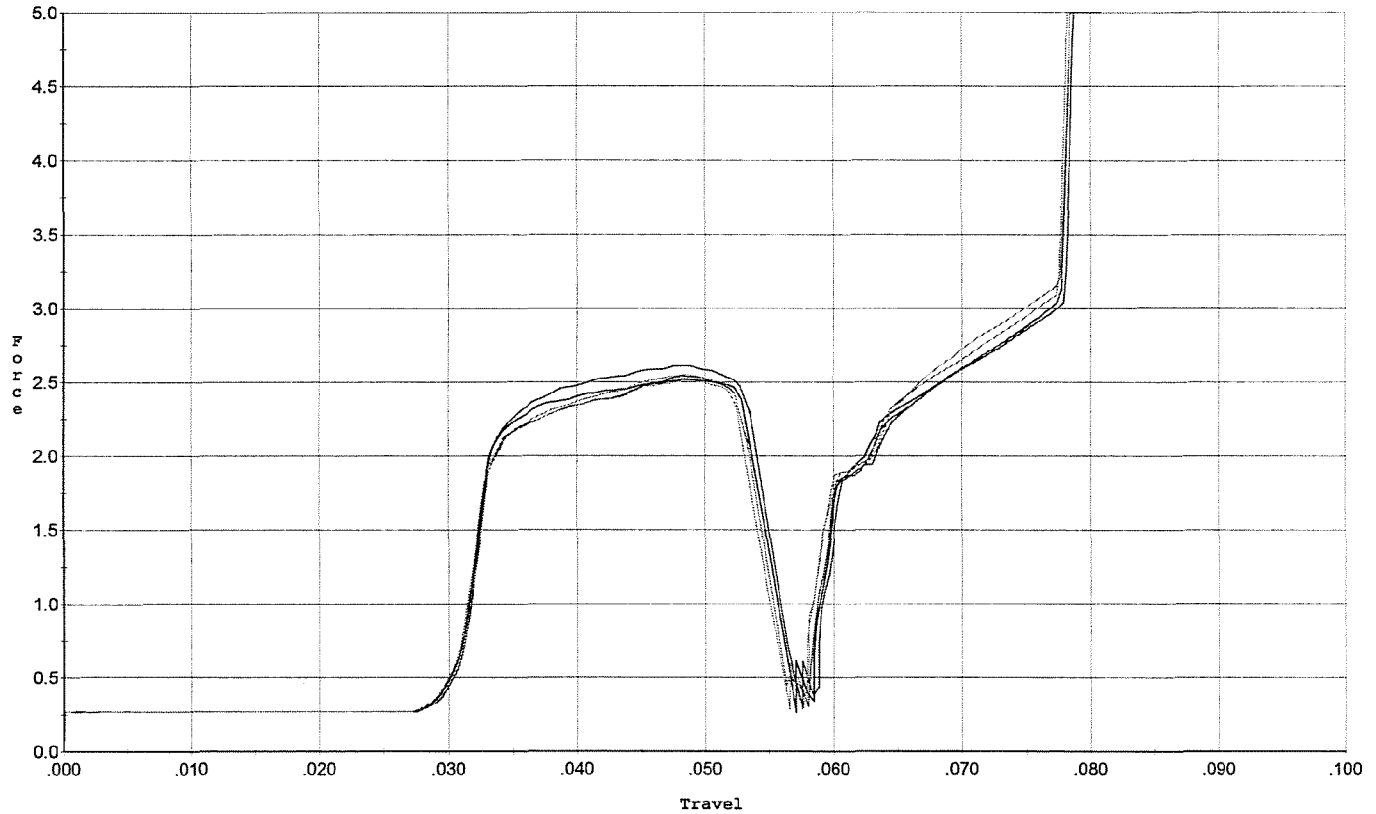
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.055	0.032	0.031	0.061		Set Trigger
2	2.555	0.055	0.032	0.031	0.060		Set Trigger
3	2.578	0.054	0.031	0.031	0.060		Set Trigger
4	2.601	0.054	0.032	0.031	0.061		Set Trigger
5	2.604	0.054	0.031	0.031	0.060		Set Trigger

Aug. 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



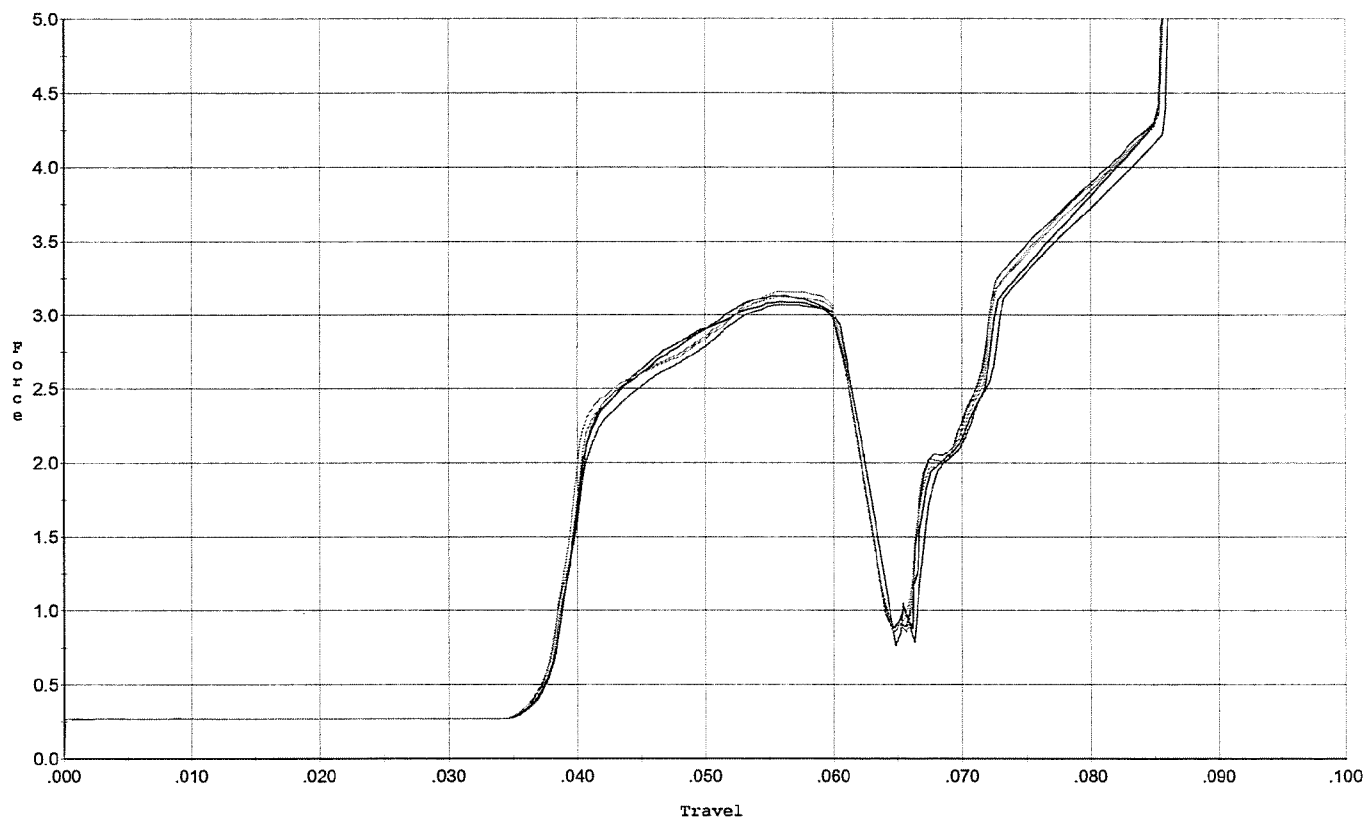
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.054	0.030	0.031	0.062		Set Trigger
2	2.521	0.055	0.030	0.030	0.062		Set Trigger
3	2.541	0.053	0.030	0.031	0.060		Set Trigger
4	2.547	0.053	0.030	0.031	0.060		Set Trigger
5	2.509	0.052	0.029	0.031	0.058		Set Trigger

Aug. 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



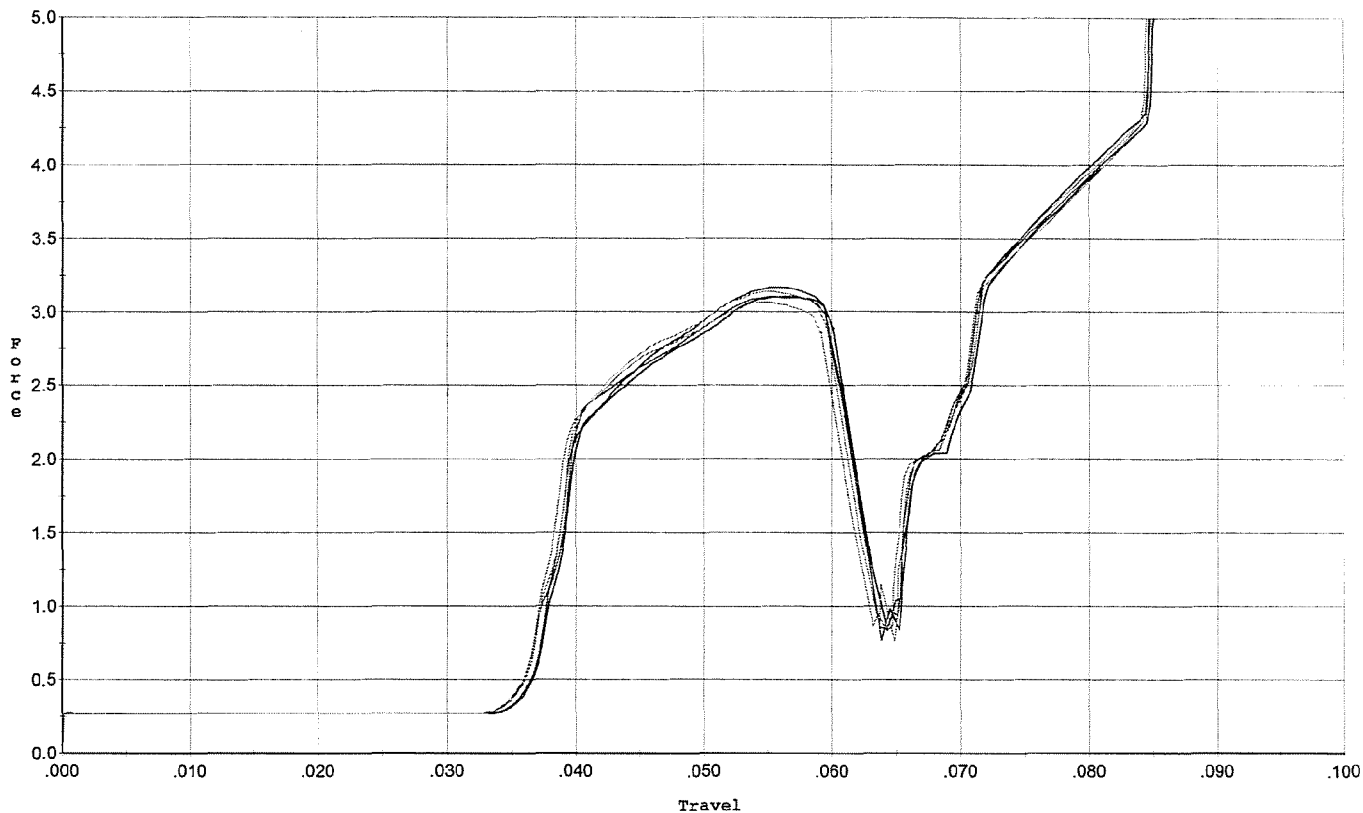
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.133	0.062	0.037	0.030	0.075		Set Trigger
2	3.089	0.061	0.037	0.030	0.073		Set Trigger
3	3.071	0.061	0.037	0.030	0.072		Set Trigger
4	3.161	0.061	0.037	0.030	0.074		Set Trigger
5	3.128	0.061	0.037	0.030	0.073		Set Trigger

Aug- 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



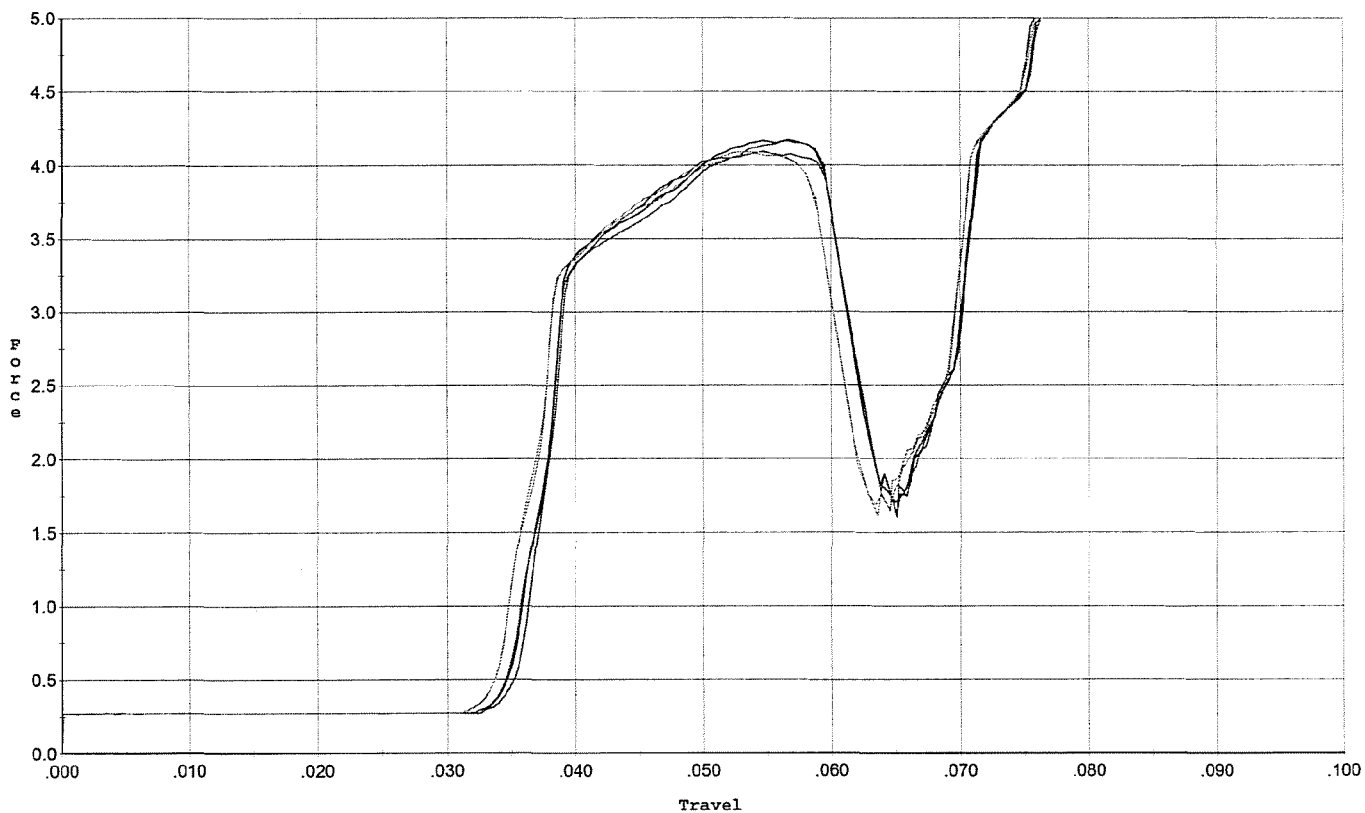
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.166	0.061	0.036	0.030	0.074		Set Trigger
2	3.100	0.060	0.036	0.030	0.072		Set Trigger
3	3.105	0.061	0.036	0.030	0.074		Set Trigger
4	3.139	0.060	0.036	0.030	0.073		Set Trigger
5	3.062	0.059	0.036	0.031	0.071		Set Trigger

Aug. 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



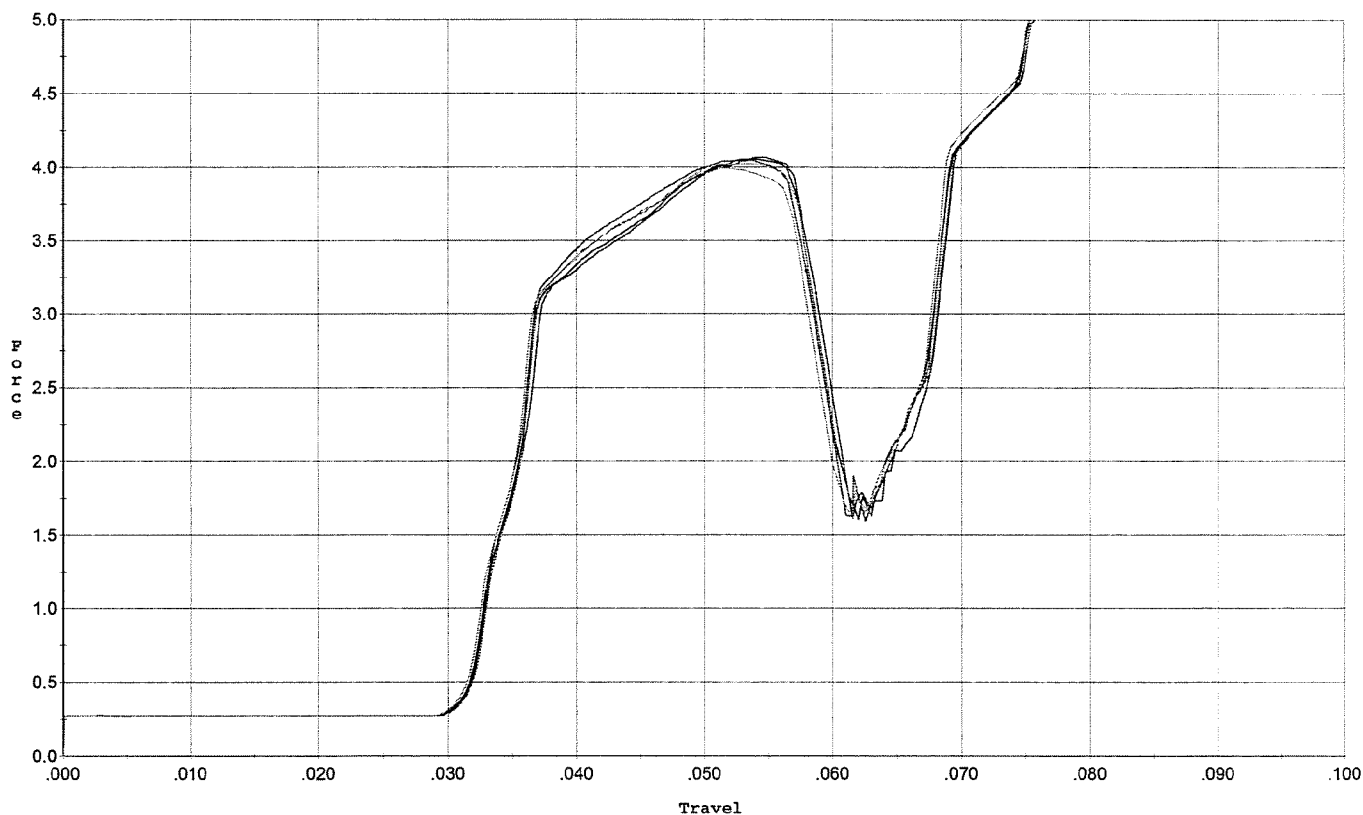
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.093	0.060	0.035	0.022	0.098		Set Trigger
2	4.173	0.060	0.034	0.022	0.099		Set Trigger
3	4.165	0.059	0.034	0.022	0.097		Set Trigger
4	4.091	0.059	0.033	0.023	0.097		Set Trigger
5	4.077	0.059	0.033	0.023	0.097		Set Trigger

Aug. 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

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



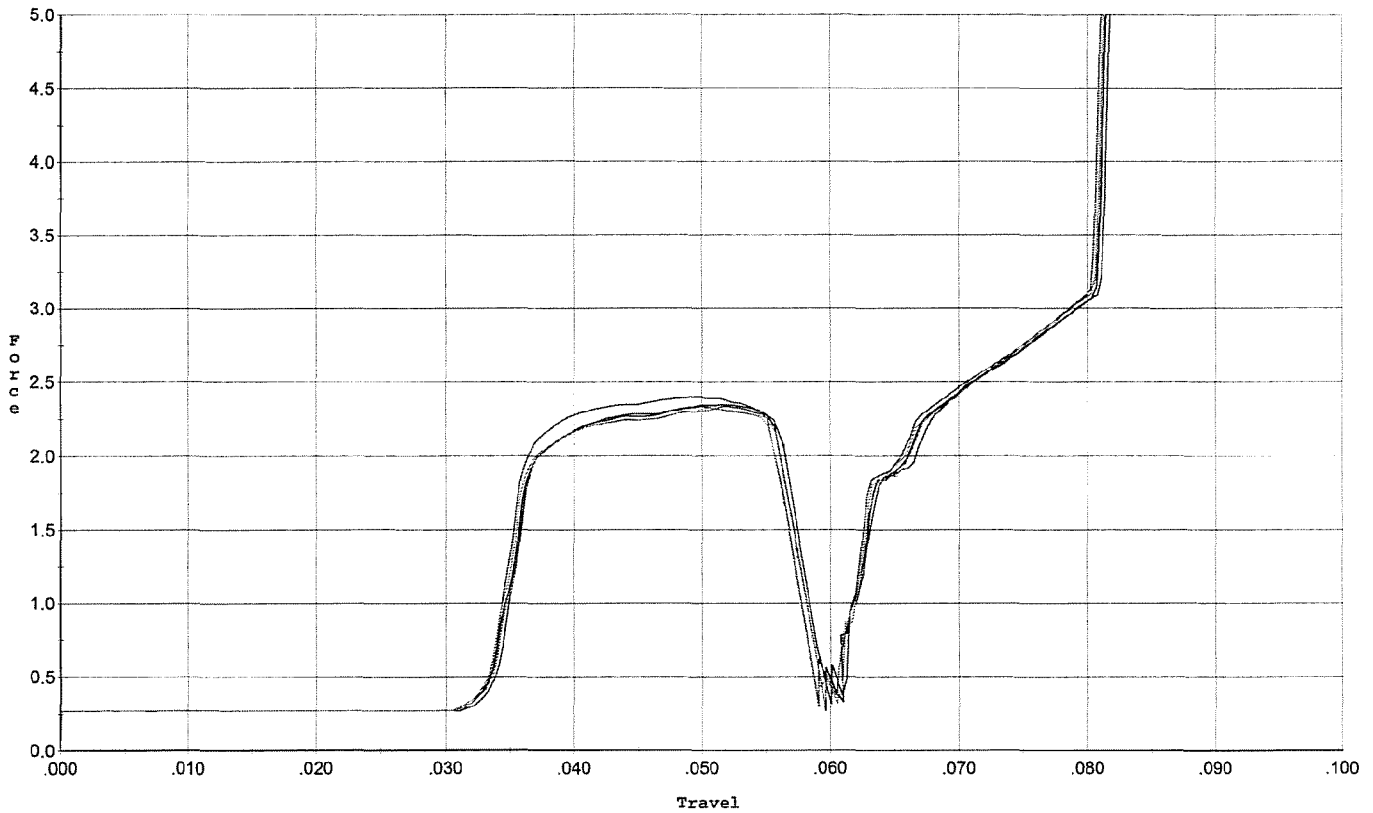
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.066	0.059	0.031	0.025	0.097		Set Trigger
2	4.055	0.057	0.031	0.025	0.095		Set Trigger
3	4.046	0.058	0.031	0.025	0.097		Set Trigger
4	4.022	0.057	0.032	0.025	0.095		Set Trigger
5	3.994	0.057	0.031	0.025	0.094		Set Trigger

Avg - 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 08/04/2008

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



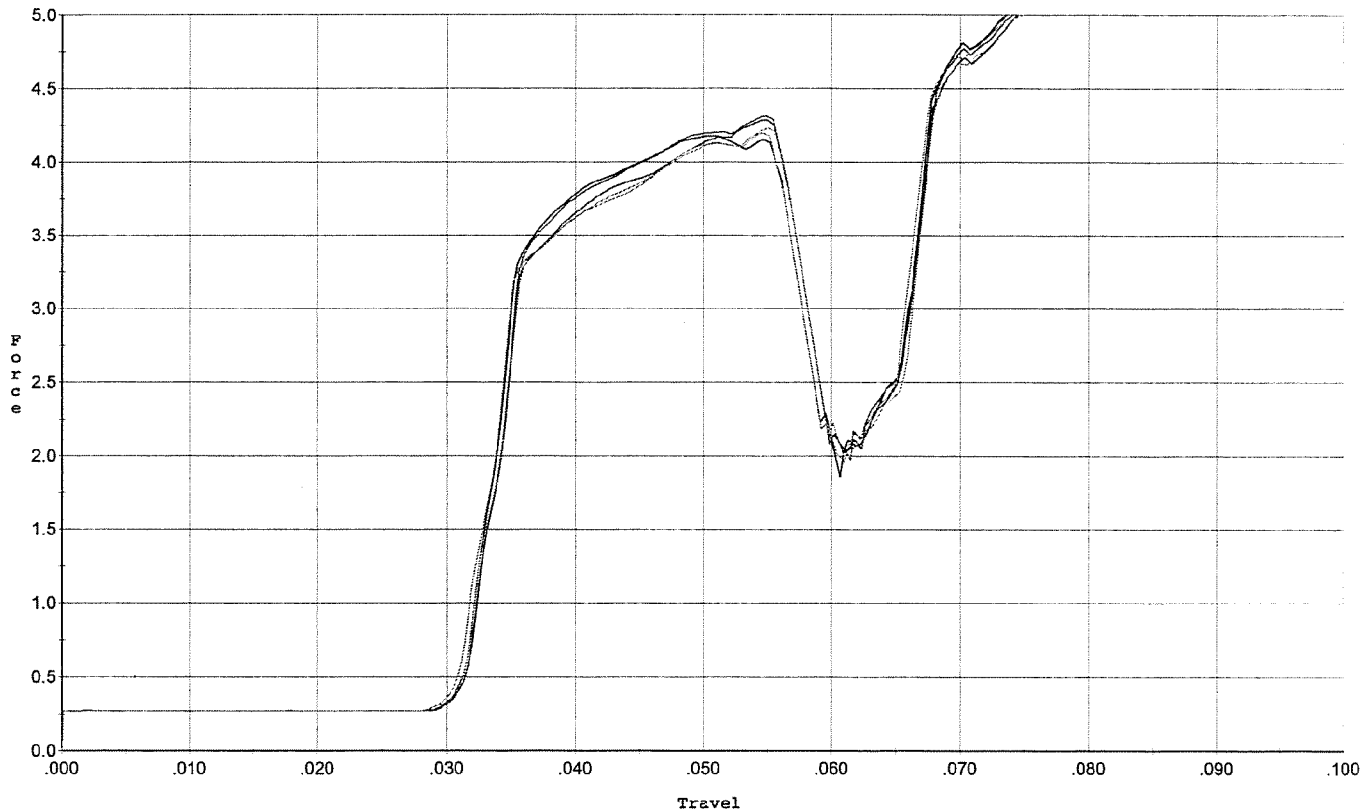
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.333	0.056	0.033	0.032	0.057		Set Trigger
2	2.344	0.057	0.033	0.031	0.059		Set Trigger
3	2.399	0.056	0.033	0.032	0.059		Set Trigger
4	2.324	0.056	0.033	0.032	0.057		Set Trigger
5	2.314	0.058	0.034	0.031	0.058		Set Trigger

Aug. 2.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 08/04/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 for target&accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.288	0.057	0.031	0.027	0.100		Set Trigger
2	4.177	0.056	0.031	0.028	0.100		Set Trigger
3	4.315	0.057	0.031	0.027	0.101		Set Trigger
4	4.231	0.057	0.031	0.027	0.099		Set Trigger
5	4.201	0.056	0.030	0.028	0.098		Set Trigger

Aug. 4.24