

G6778834

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



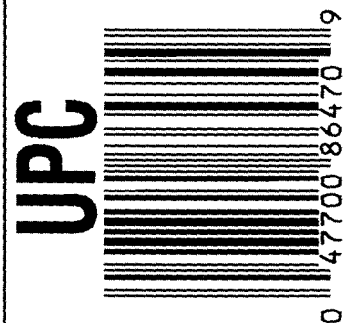
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6778834



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6778834

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-26-08	SP
430	ASSEMBLE TO STOCK		8-26-08	SP
440	PROOF		8-26-08	SP
460	CHECK HEADSPACE		8-26-08	SP
470	DIS-ASSEMBLE ACTION		8-26-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-29-08	PSN
475	DRILL AND TAP SIGHT HOLES	SEP 10 2008	9-5-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>BA</u>	9-10-08	BA
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/10/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		9/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-18-08	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

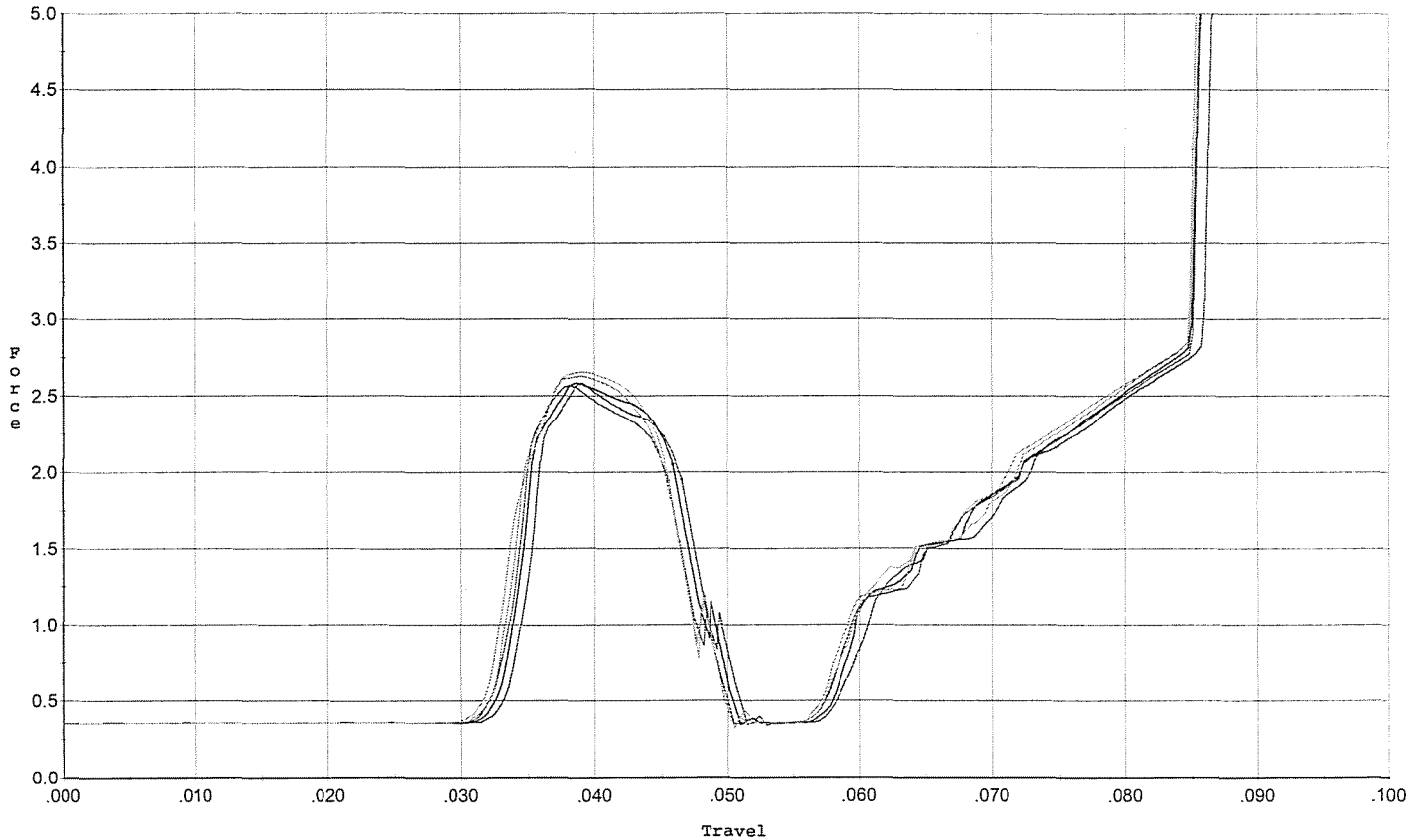
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>2.0</u> <u>2.0</u>	9-26-08	LH
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>40</u> <u>40</u>	9-26-08	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	9-26-08	LH
	J) ASSEMBLE STOCK		9-18-08	Rgn
	K) ASSEMBLE SWIVEL STUDS		9-26-08	LH
	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	9-19-08	Fm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-19-08	AA
670	FINAL INSPECTION A) HEADSPACE		9-26-08	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u> <u>2.66</u> <u>2.61</u> <u>2.74</u> <u>2.55</u>	9-25-08	LH
	C) FUNCTION		9-26-08	LH
690	PACK		10/21/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



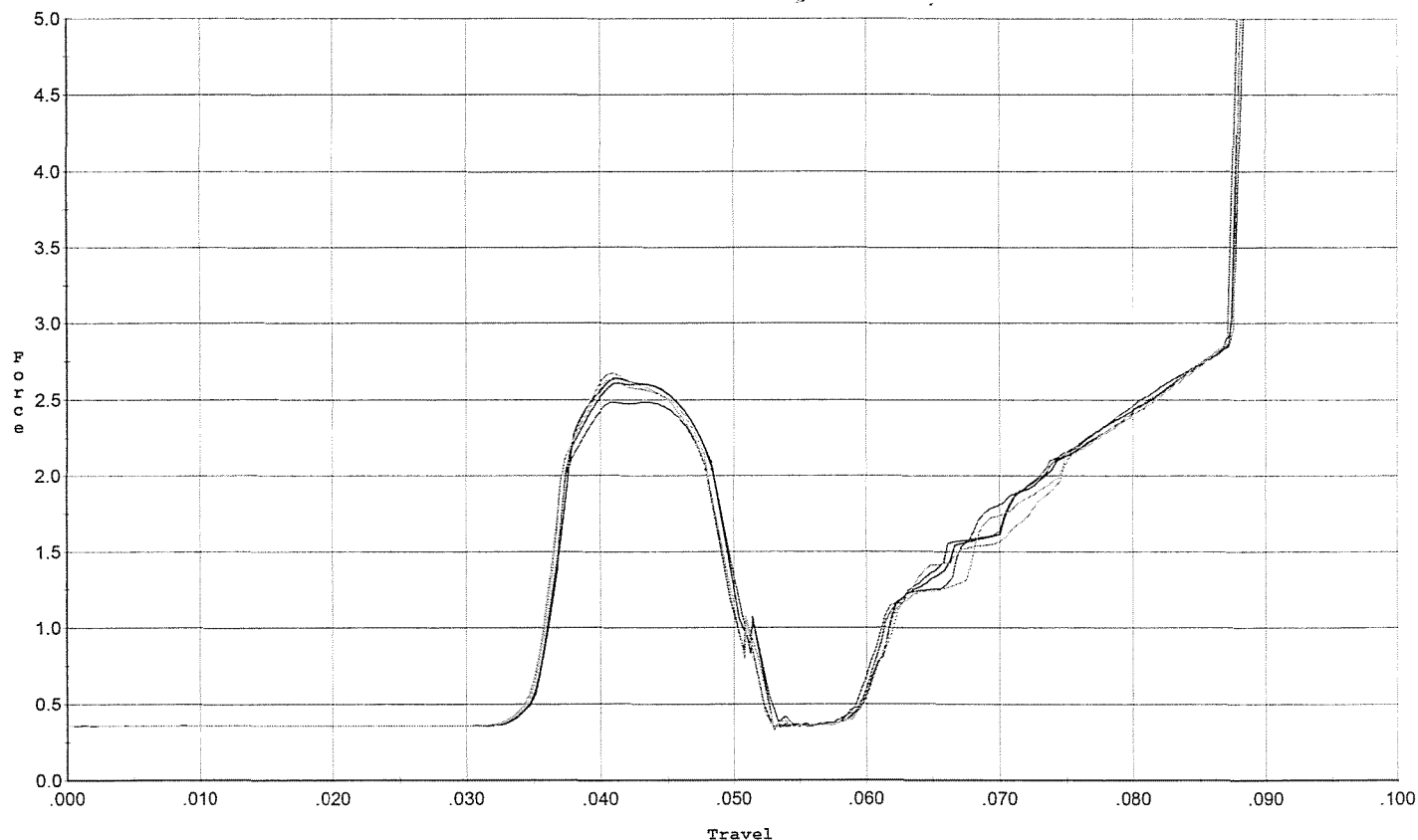
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.587	0.047	0.033	0.043	0.041		Set Trigger
2	2.585	0.046	0.032	0.043	0.041		Set Trigger
3	2.572	0.046	0.032	0.044	0.040		Set Trigger
4	2.659	0.045	0.032	0.043	0.042		Set Trigger
5	2.631	0.046	0.032	0.043	0.042		Set Trigger

AVG 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



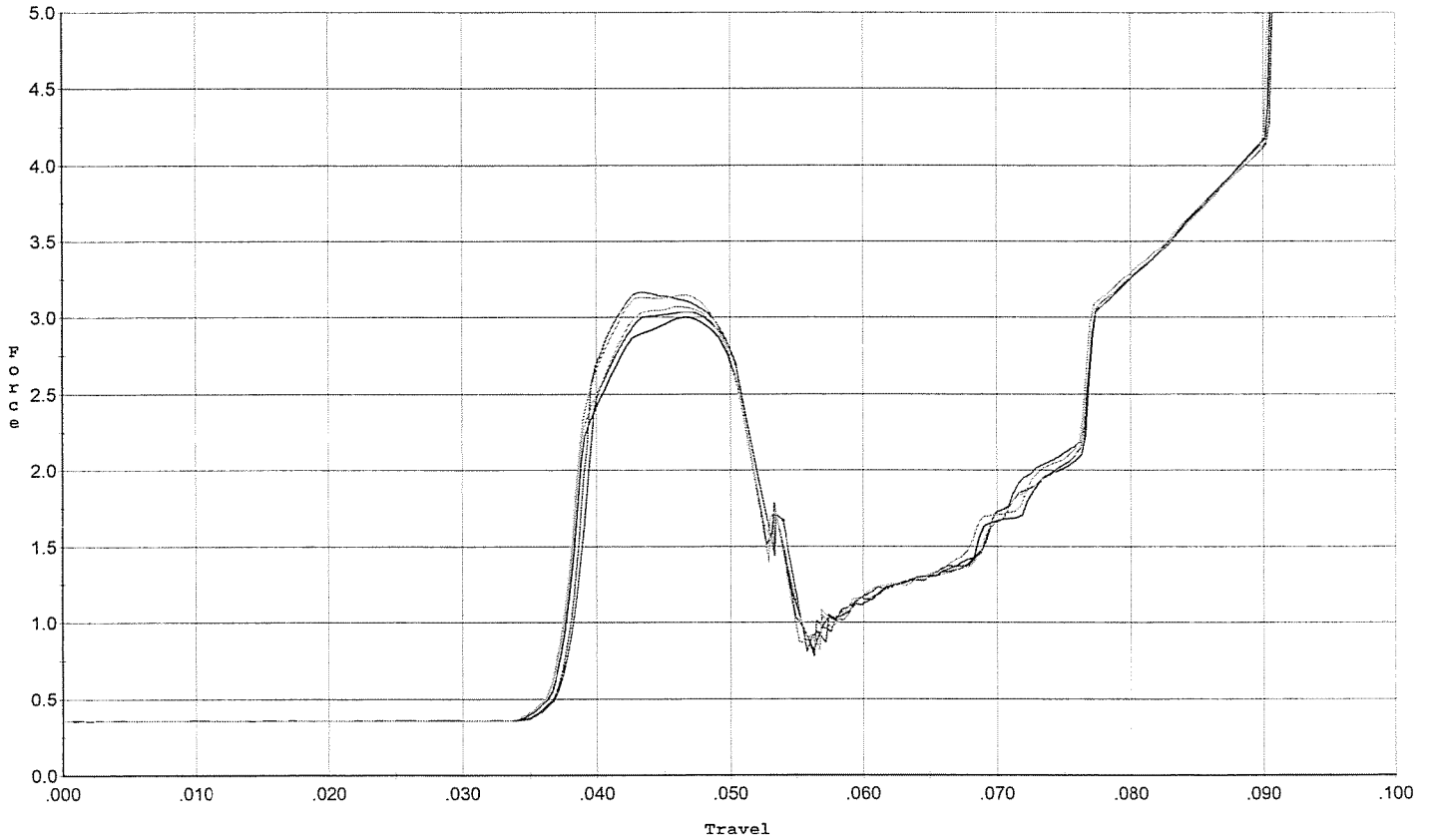
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.048	0.035	0.043	0.043		Set Trigger
2	2.645	0.048	0.035	0.043	0.043		Set Trigger
3	2.487	0.048	0.035	0.043	0.041		Set Trigger
4	2.634	0.048	0.035	0.043	0.042		Set Trigger
5	2.677	0.048	0.035	0.043	0.043		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



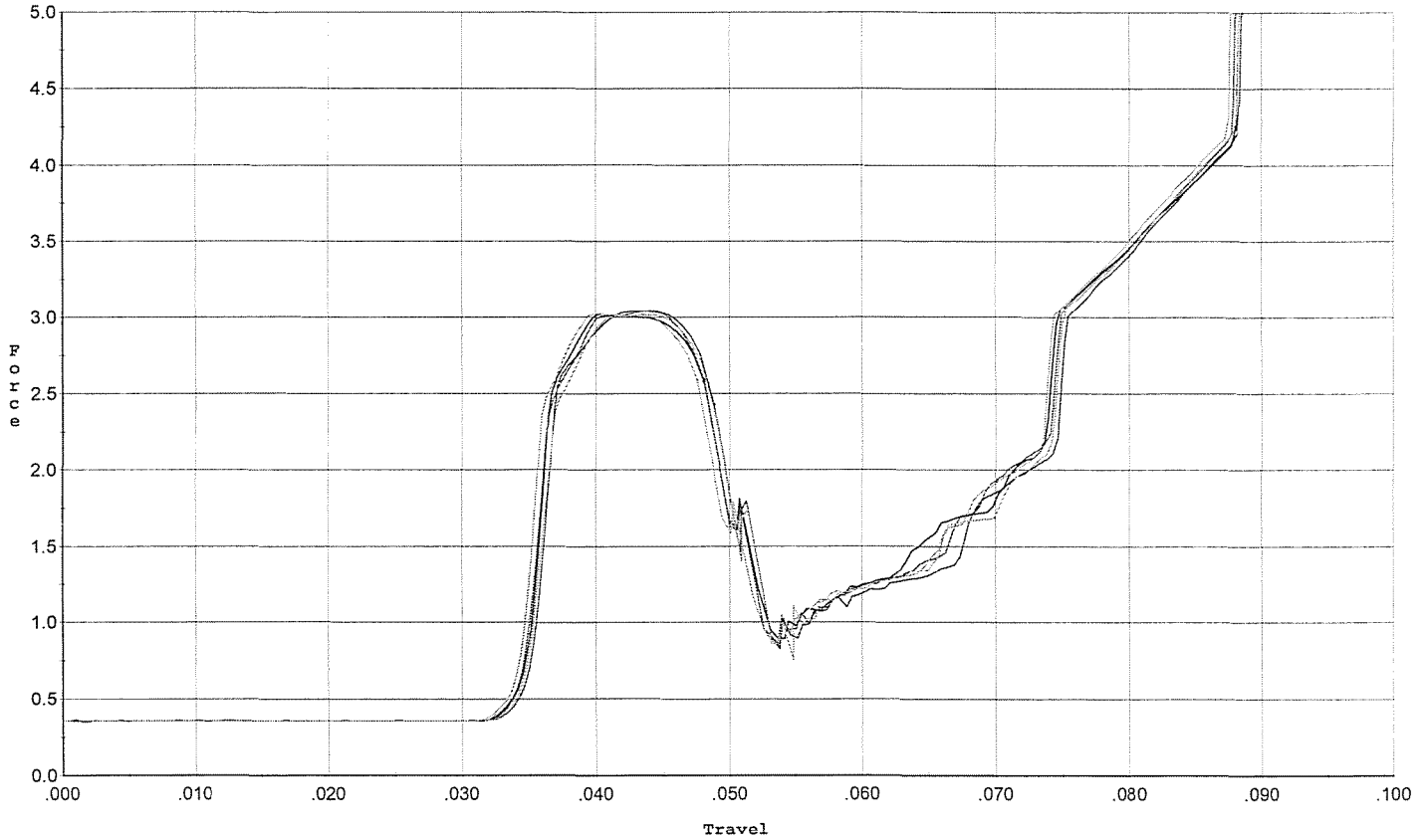
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.035	0.054	0.037	0.040	0.055		Set Trigger
2	2.999	0.051	0.037	0.041	0.050		Set Trigger
3	3.168	0.050	0.037	0.041	0.051		Set Trigger
4	3.071	0.051	0.037	0.042	0.051		Set Trigger
5	3.149	0.051	0.037	0.041	0.053		Set Trigger

Arg 3.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



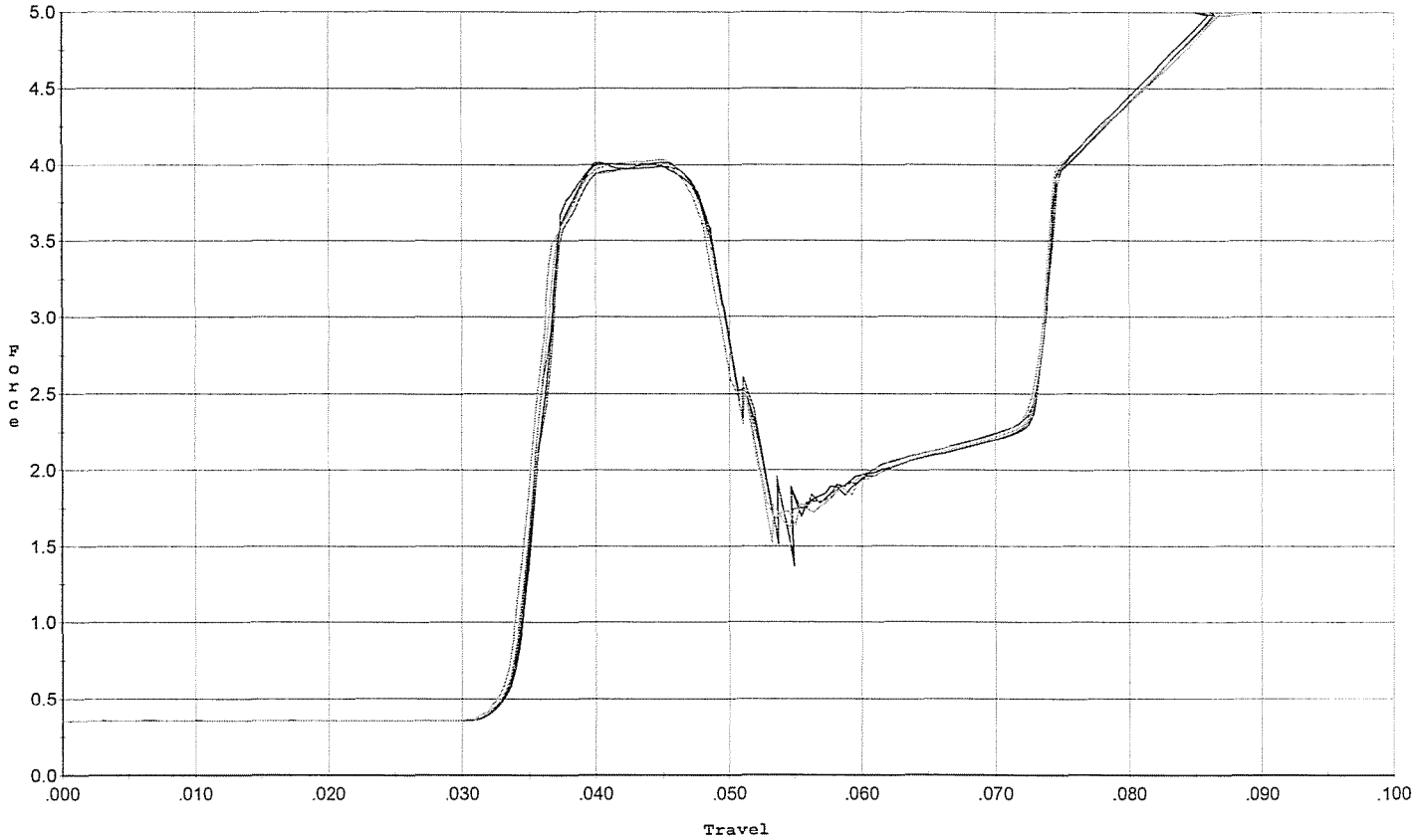
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.042	0.049	0.034	0.041	0.051		Set Trigger
2	3.025	0.048	0.034	0.041	0.050		Set Trigger
3	3.046	0.048	0.034	0.041	0.050		Set Trigger
4	3.018	0.049	0.034	0.041	0.051		Set Trigger
5	3.026	0.048	0.034	0.041	0.050		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/16/08

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



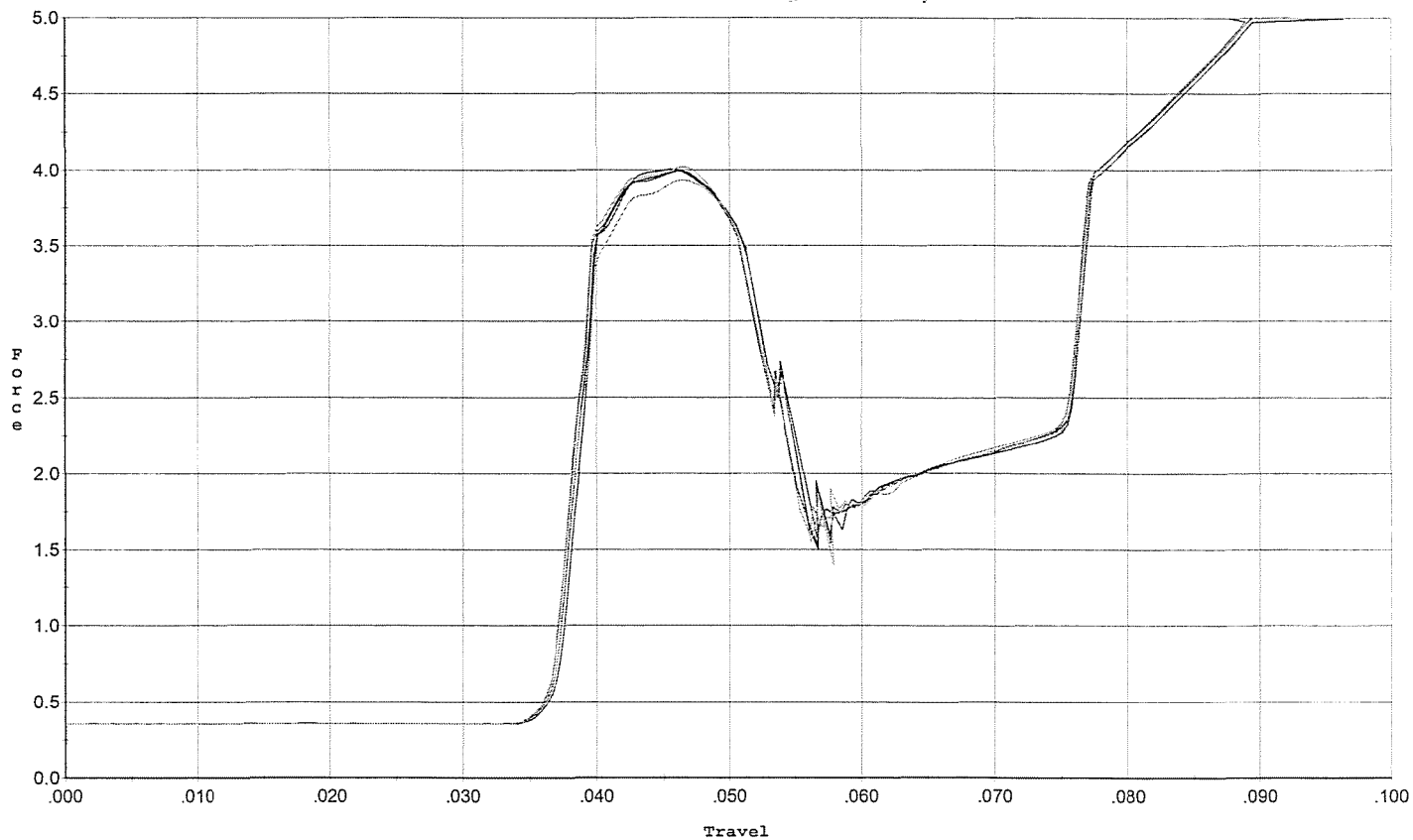
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.016	0.049	0.033	0.038	0.067		Set Trigger
2	4.015	0.049	0.034	0.038	0.066		Set Trigger
3	3.988	0.049	0.034	0.038	0.066		Set Trigger
4	4.034	0.049	0.033	0.038	0.068		Set Trigger
5	4.026	0.048	0.033	0.038	0.066		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



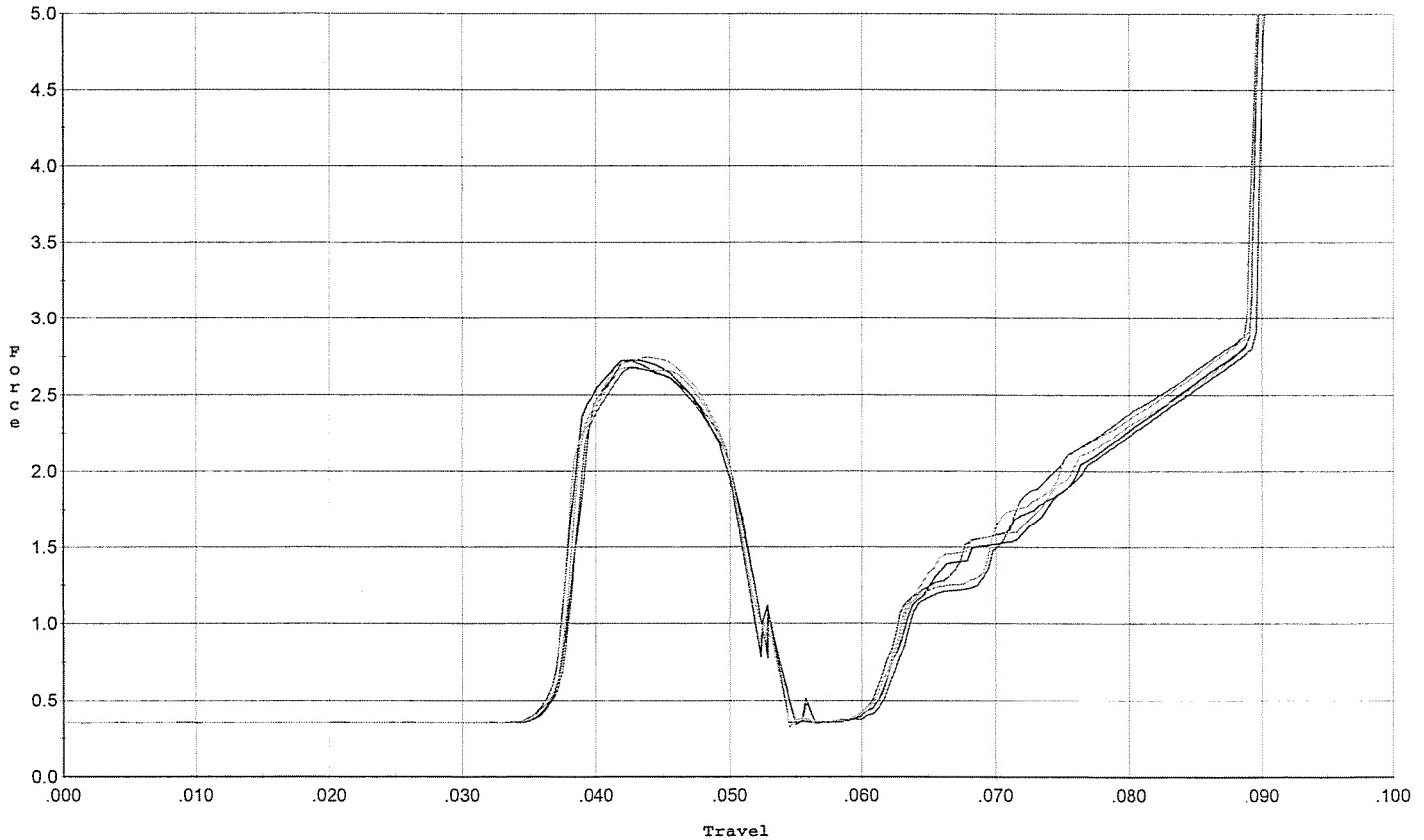
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.007	0.051	0.037	0.040	0.066		Set Trigger
2	3.992	0.054	0.037	0.039	0.071		Set Trigger
3	3.996	0.053	0.036	0.039	0.070		Set Trigger
4	3.933	0.054	0.037	0.039	0.071		Set Trigger
5	4.021	0.054	0.036	0.039	0.071		Set Trigger

Avg 3.99

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



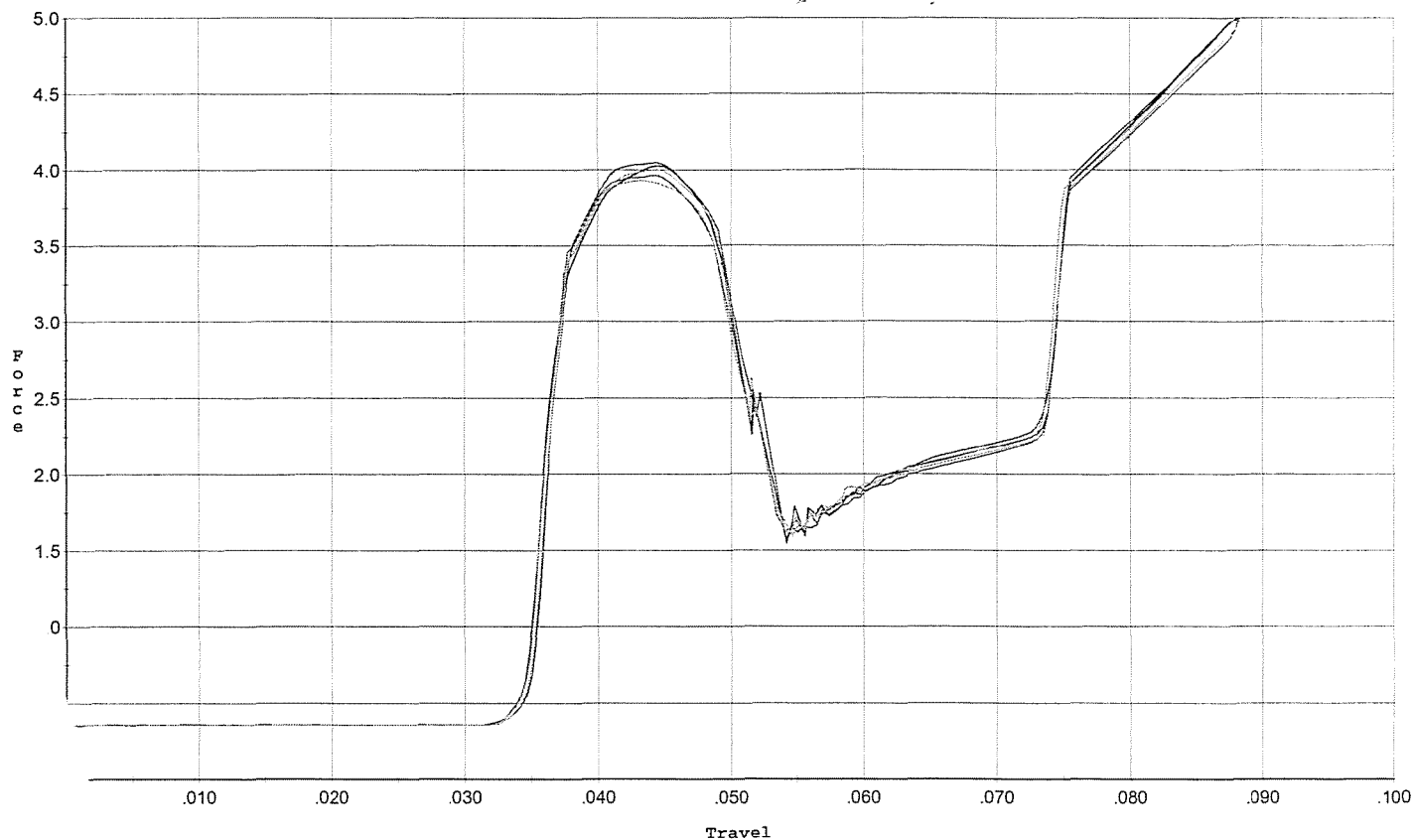
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.051	0.037	0.042	0.045		Set Trigger
2	2.725	0.050	0.036	0.042	0.045		Set Trigger
3	2.674	0.051	0.037	0.042	0.045		Set Trigger
4	2.684	0.050	0.037	0.042	0.045		Set Trigger
5	2.746	0.050	0.037	0.042	0.045		Set Trigger

AVG 2.71

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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

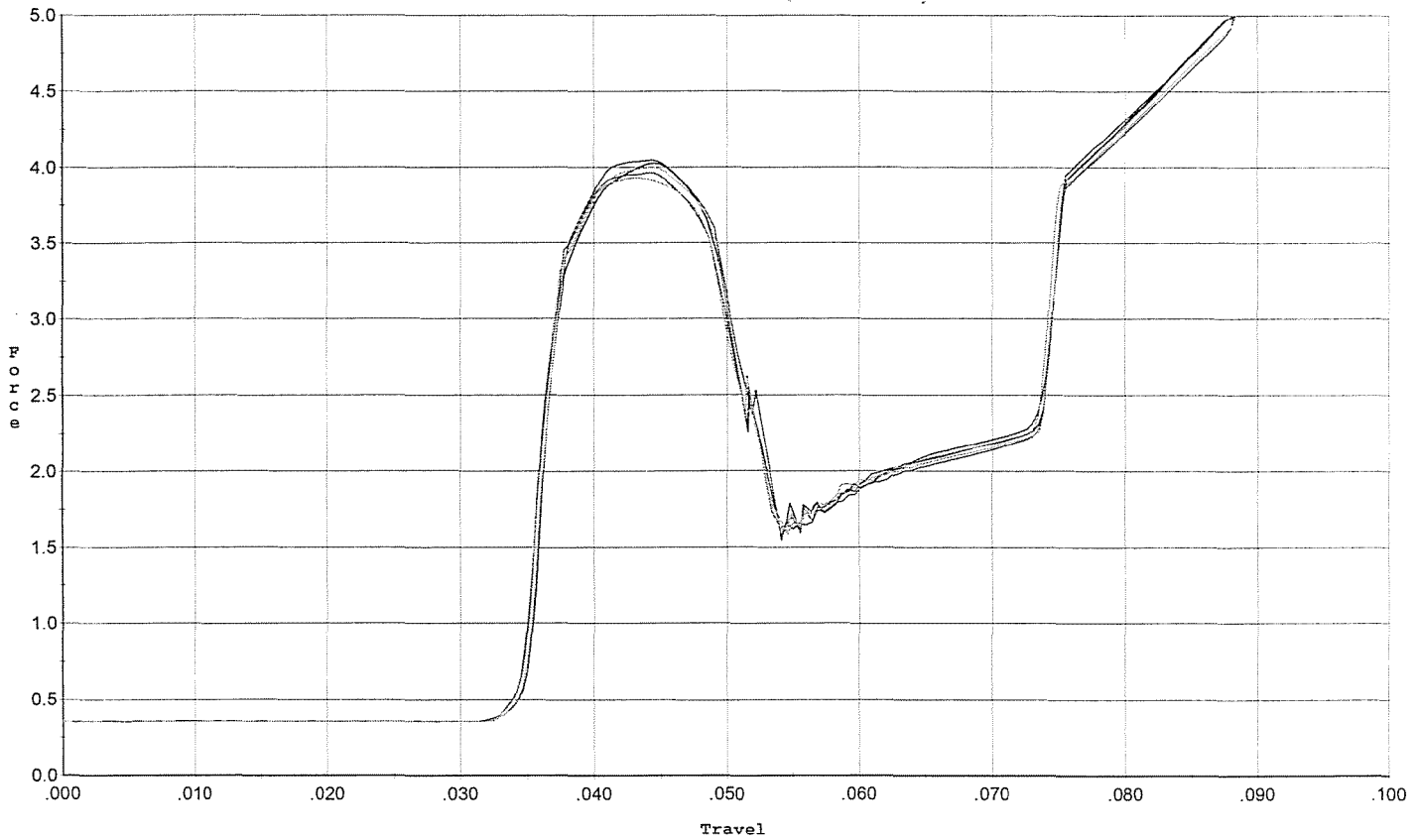


Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
147	0.052	0.035	0.038	0.071		Set Trigger
27	0.049	0.034	0.038	0.066		Set Trigger
5	0.052	0.034	0.037	0.070		Set Trigger
	0.049	0.035	0.038	0.065		Set Trigger
	0.052	0.034	0.037	0.069		Set Trigger

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/16/08

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.047	0.052	0.035	0.038	0.071		Set Trigger
2	4.027	0.049	0.034	0.038	0.066		Set Trigger
3	3.966	0.052	0.034	0.037	0.070		Set Trigger
4	4.001	0.049	0.035	0.038	0.065		Set Trigger
5	3.931	0.052	0.034	0.037	0.069		Set Trigger

Avg 3.99