

G6778896

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

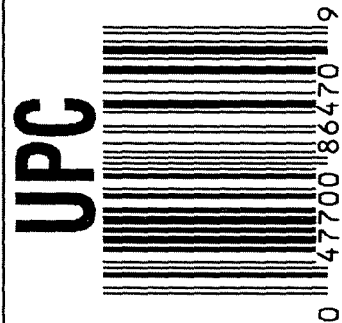


ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6778896



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

2

GUN SERIAL # G 6778896

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-19-08	SPD
430	ASSEMBLE TO STOCK		8-19-08	SP
440	PROOF		8-19-08	SPD
460	CHECK HEADSPACE		8-19-08	SPD
470	DIS-ASSEMBLE ACTION		8-19-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-20-08	KTC
475	DRILL AND TAP SIGHT HOLES	AUG 21 2008	8-20-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BM	8-21-08	BM
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC		8/25/08	DG
542	APPLY COATINGS (BARREL ACTION)		8-26-08	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-27-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-27-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-27-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-29-08	KTC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

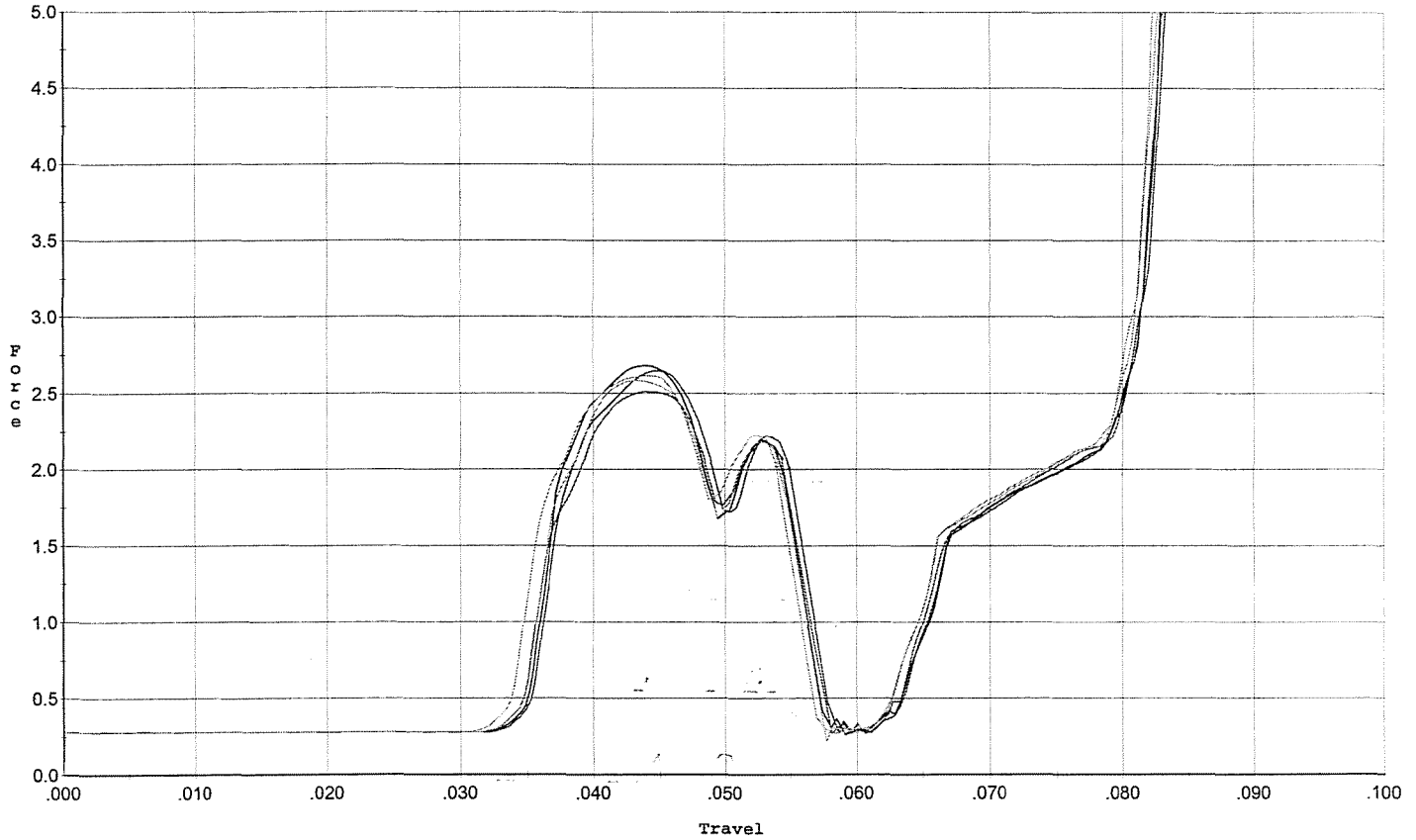
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	9-11-08	TC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>7</u> <u>7</u> <u>7</u>	9-11-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	9-11-08	TC
	J) ASSEMBLE STOCK		8-29-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		9-11-08	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	9-8-08	Fm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N.A.		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-8-08	TRW
670	FINAL INSPECTION A) HEADSPACE		9-11-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>242</u> <u>248</u> <u>248</u> <u>240</u> <u>242</u>	9-8-08	BSW
	C) FUNCTION		9-11-08	TC
690	PACK		10/20/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



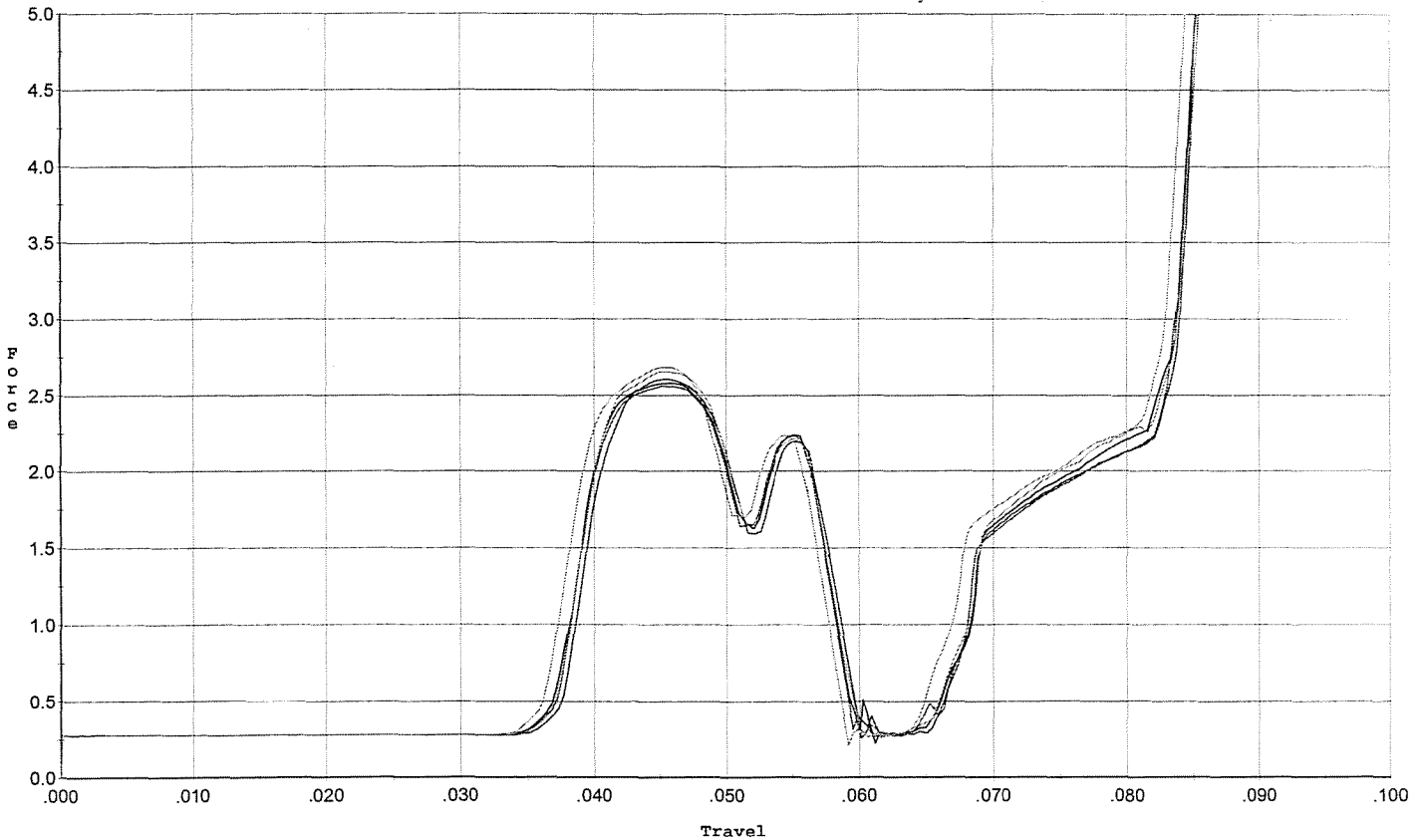
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.648	0.055	0.035	0.034	0.053		Set Trigger
2	2.681	0.054	0.035	0.035	0.052		Set Trigger
3	2.512	0.054	0.035	0.035	0.051		Set Trigger
4	2.584	0.055	0.035	0.034	0.052		Set Trigger
5	2.616	0.054	0.034	0.034	0.053		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



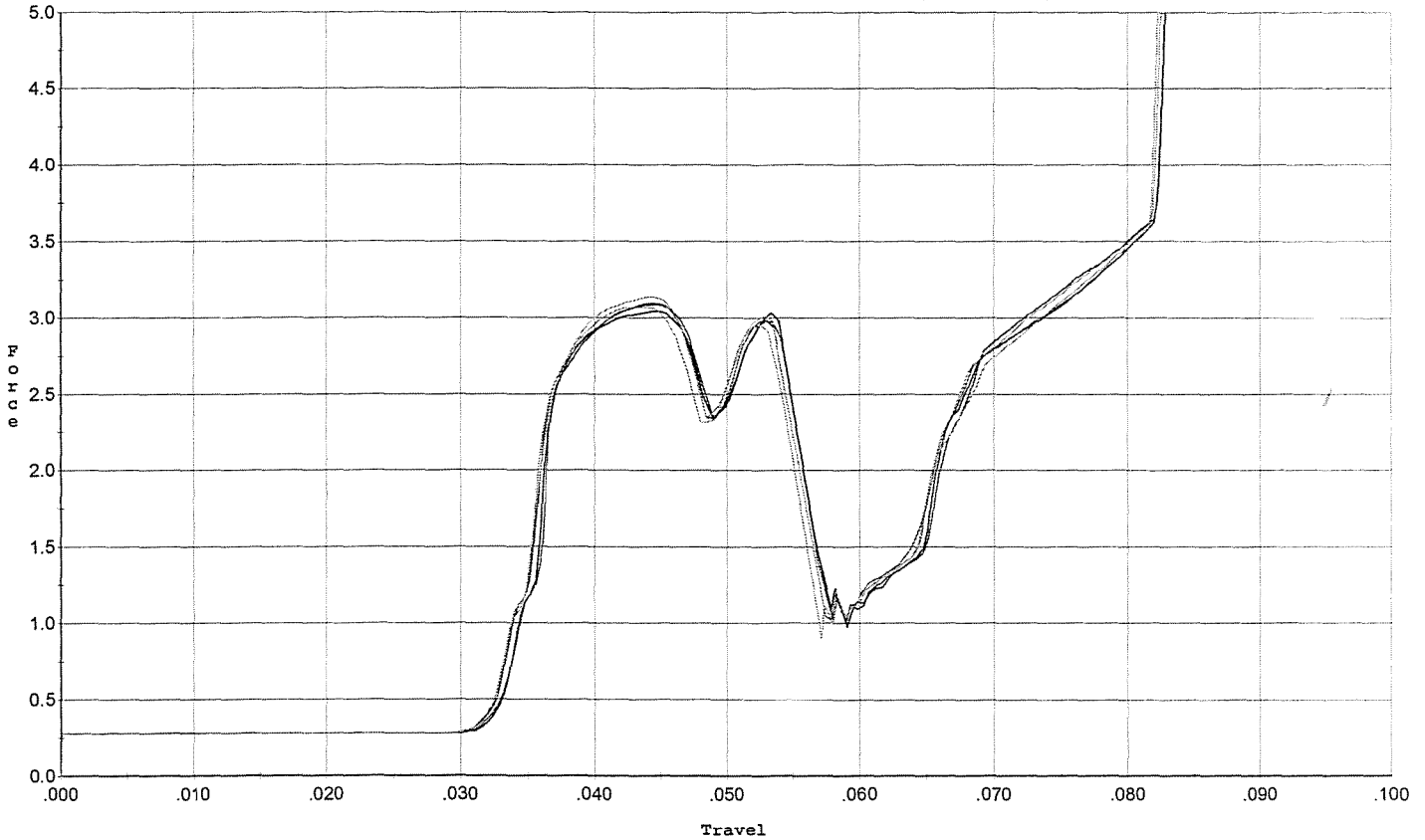
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.058	0.038	0.035	0.052		Set Trigger
2	2.579	0.056	0.037	0.035	0.052		Set Trigger
3	2.561	0.057	0.037	0.035	0.052		Set Trigger
4	2.658	0.056	0.037	0.035	0.052		Set Trigger
5	2.685	0.056	0.036	0.035	0.053		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



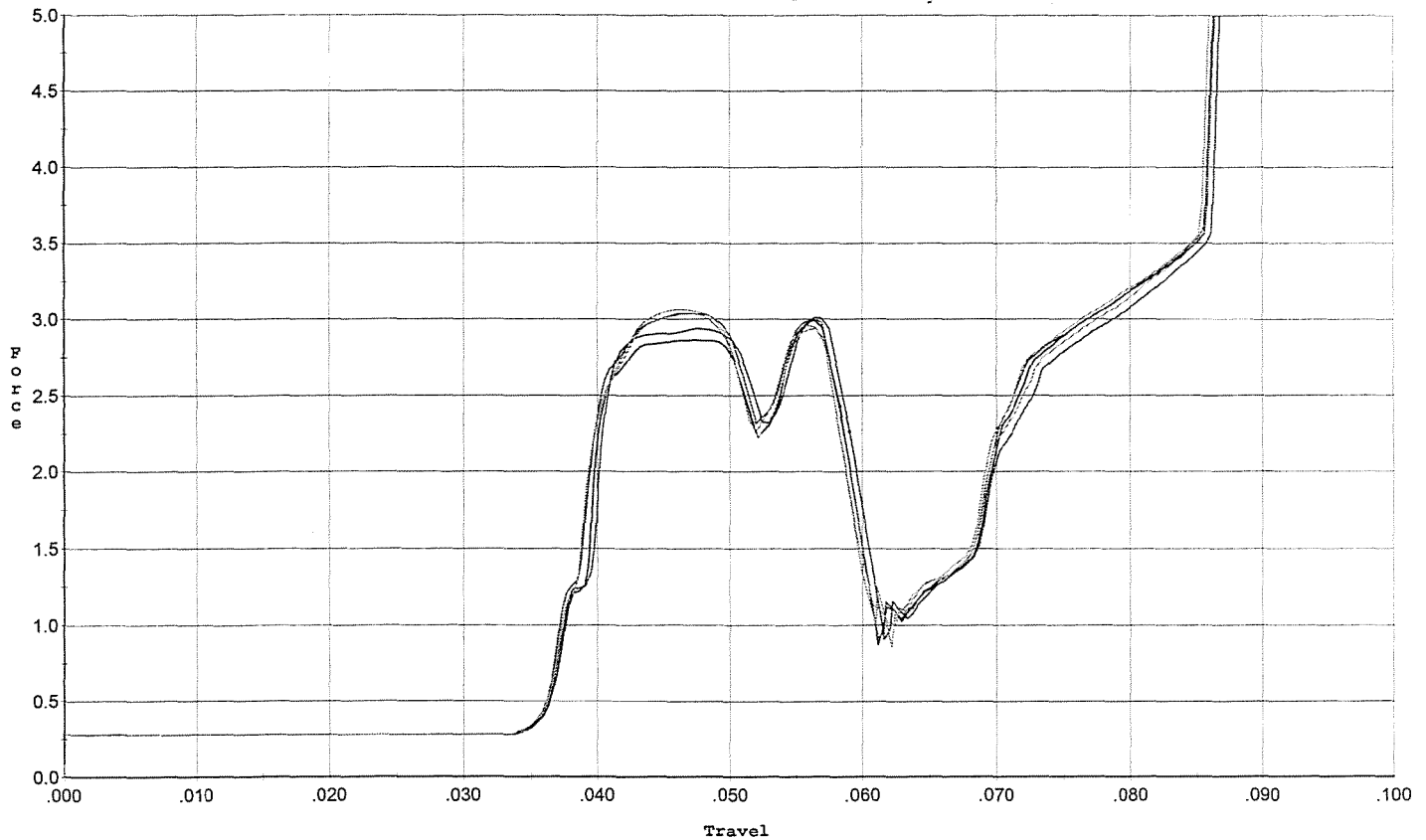
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.088	0.054	0.033	0.034	0.065		Set Trigger
2	3.042	0.054	0.033	0.034	0.065		Set Trigger
3	3.097	0.055	0.033	0.033	0.067		Set Trigger
4	3.141	0.055	0.032	0.033	0.068		Set Trigger
5	3.073	0.054	0.032	0.033	0.065		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



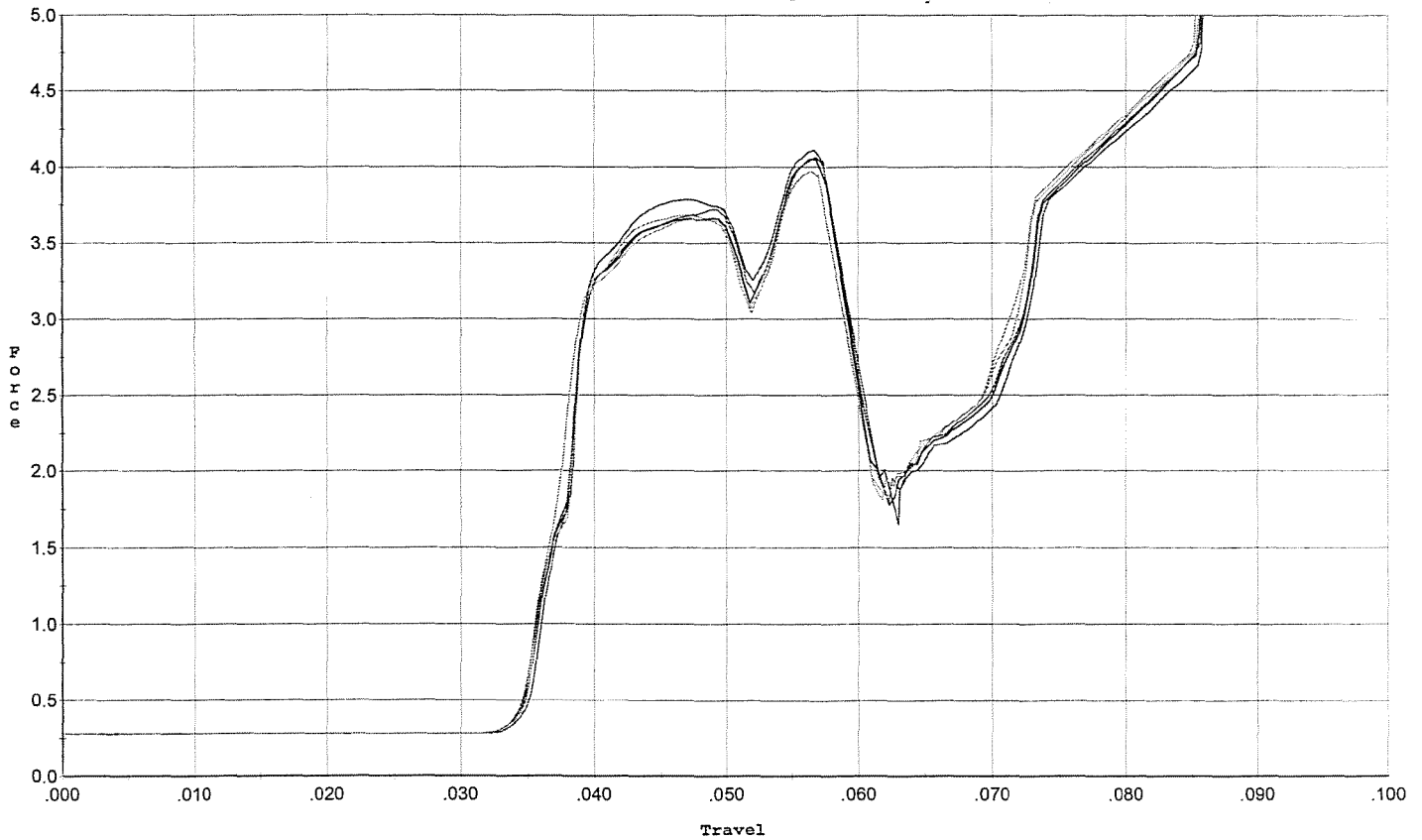
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.009	0.059	0.036	0.034	0.067		Set Trigger
2	2.993	0.058	0.036	0.034	0.065		Set Trigger
3	3.037	0.058	0.036	0.034	0.068		Set Trigger
4	3.042	0.057	0.036	0.034	0.065		Set Trigger
5	3.069	0.057	0.036	0.034	0.065		Set Trigger

AVG 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



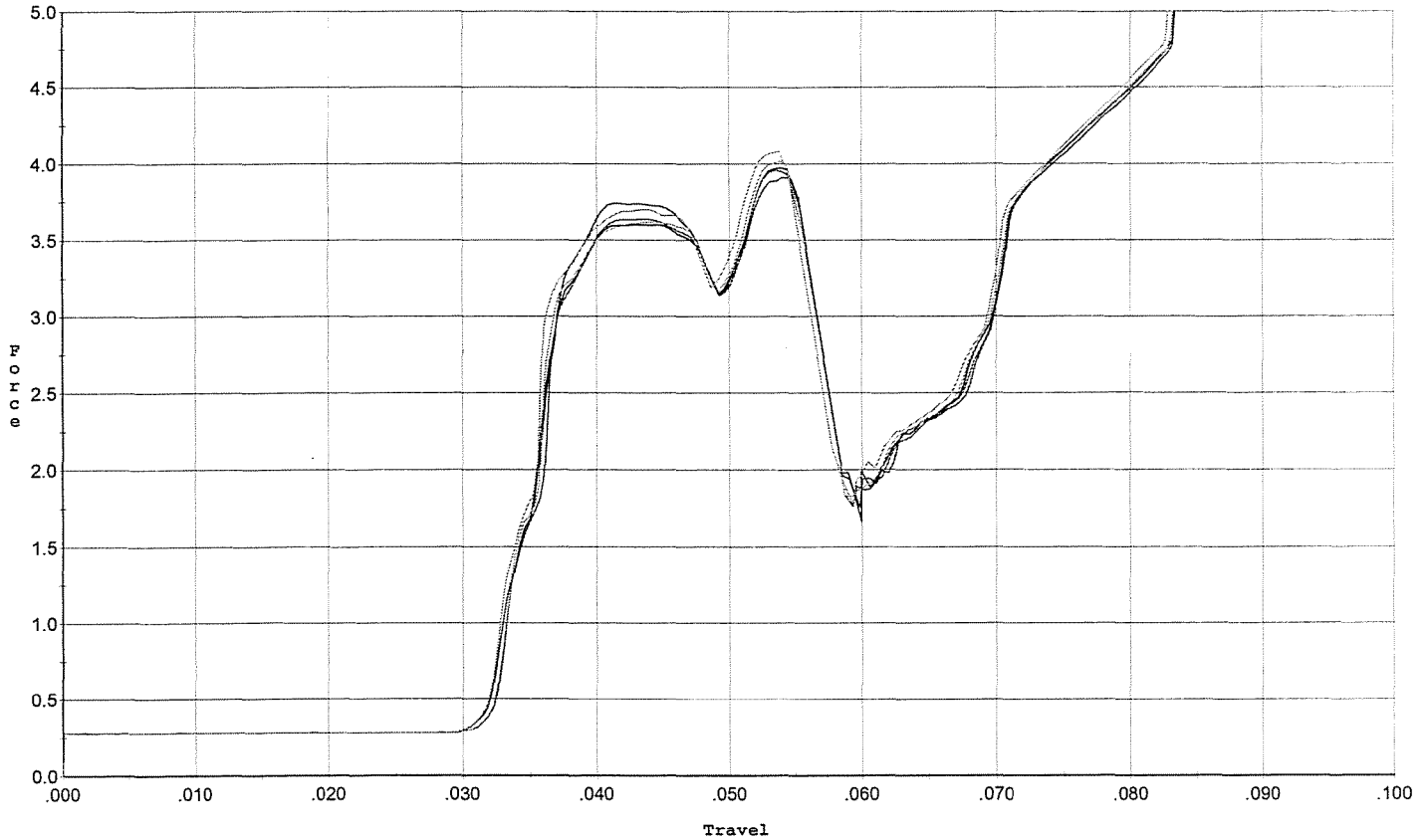
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.110	0.057	0.034	0.032	0.088		Set Trigger
2	4.049	0.058	0.035	0.032	0.086		Set Trigger
3	4.062	0.057	0.035	0.032	0.086		Set Trigger
4	3.971	0.059	0.035	0.032	0.087		Set Trigger
5	3.973	0.057	0.035	0.032	0.085		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



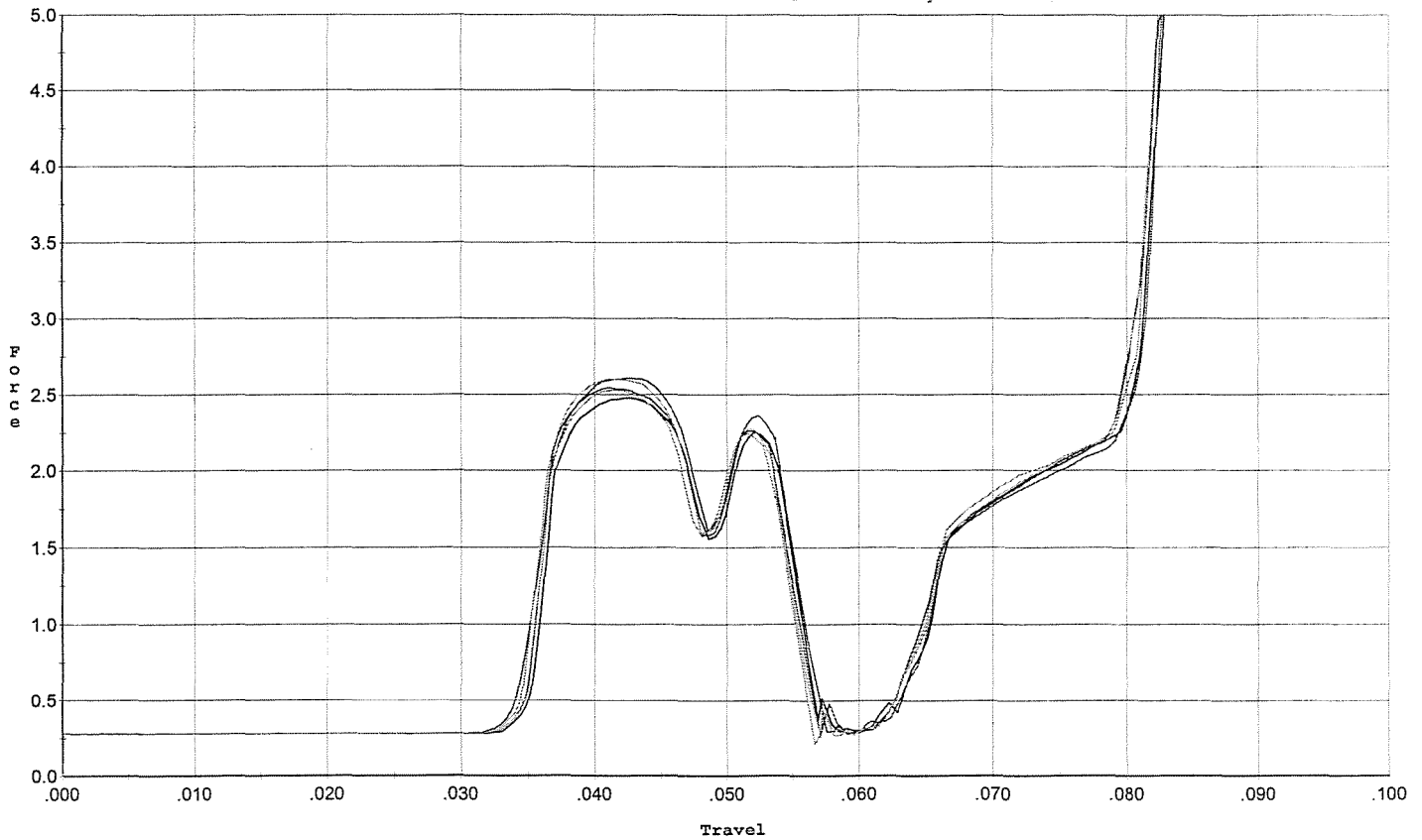
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.909	0.055	0.032	0.031	0.085		Set Trigger
2	3.973	0.055	0.032	0.031	0.084		Set Trigger
3	3.958	0.056	0.032	0.031	0.085		Set Trigger
4	4.018	0.056	0.032	0.031	0.086		Set Trigger
5	4.080	0.055	0.032	0.031	0.085		Set Trigger

Avg 3.98

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



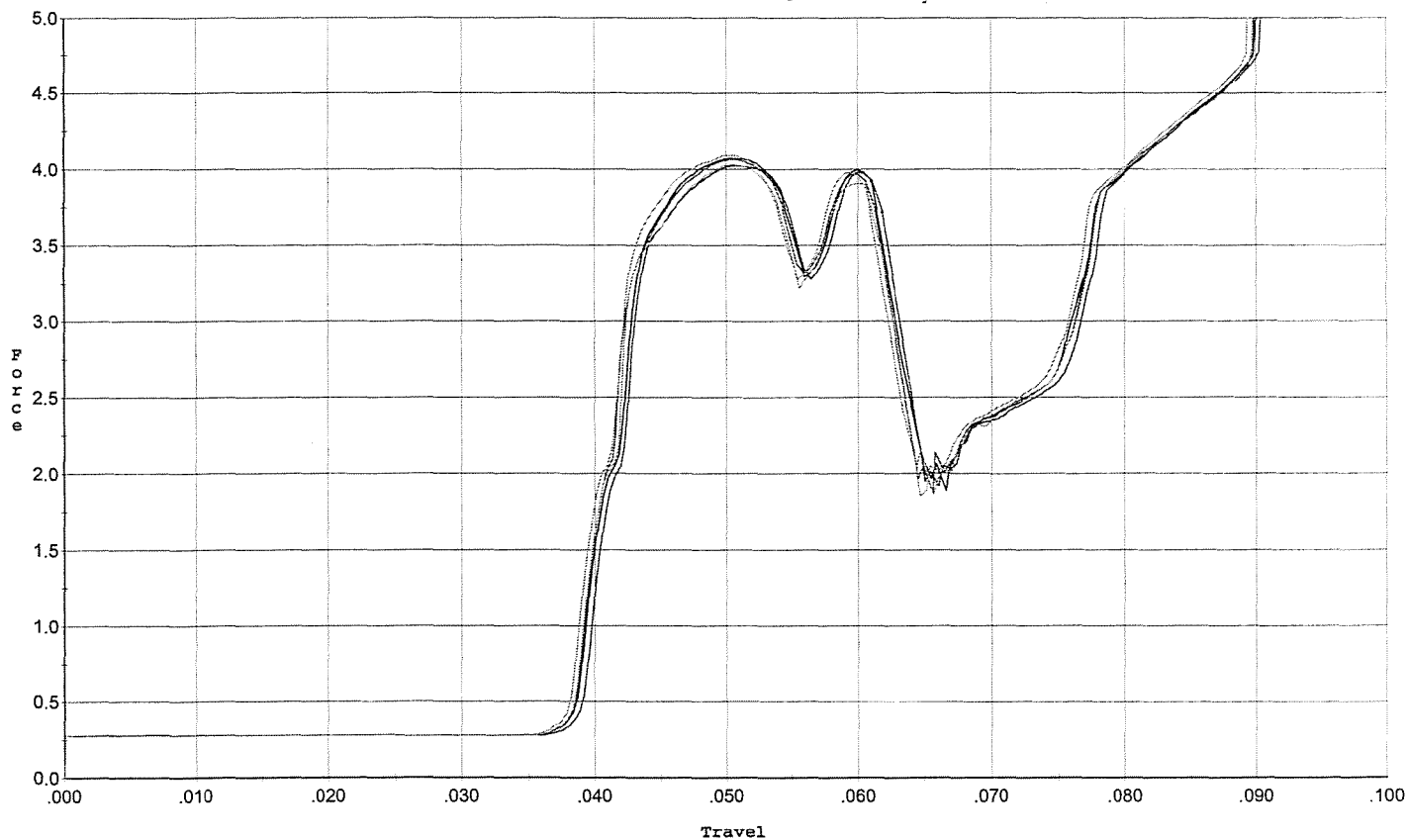
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.054	0.034	0.034	0.053		Set Trigger
2	2.479	0.054	0.035	0.035	0.050		Set Trigger
3	2.545	0.053	0.035	0.035	0.050		Set Trigger
4	2.604	0.053	0.034	0.035	0.051		Set Trigger
5	2.530	0.054	0.035	0.035	0.050		Set Trigger

Avg 2.55 ^{RP}
 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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	4.023	0.062	0.039	0.032	0.092		Set Trigger
2	4.072	0.061	0.038	0.032	0.091		Set Trigger
3	4.064	0.061	0.038	0.032	0.092		Set Trigger
4	4.029	0.062	0.038	0.032	0.092		Set Trigger
5	4.091	0.061	0.038	0.032	0.091		Set Trigger

Avg 4.05