

G6778951

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

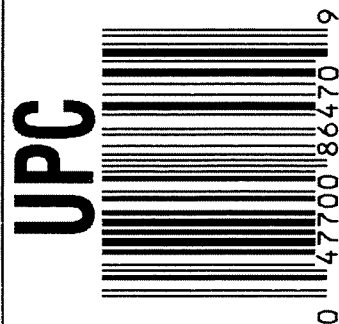


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6778951



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

2

GUN SERIAL # G 6778951

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-19-08	SP
430	ASSEMBLE TO STOCK		8-19-08	SP
440	PROOF		8-19-08	SP
460	CHECK HEADSPACE		8-19-08	SP
470	DIS-ASSEMBLE ACTION		8-19-08	SP
472	SERIALIZE BOLT HANDLE		8-20-08	RJZ
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX AUG 21 2008	8-20-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>BH</u>	8/21/08	BH
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	
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		9-2-08	RJZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

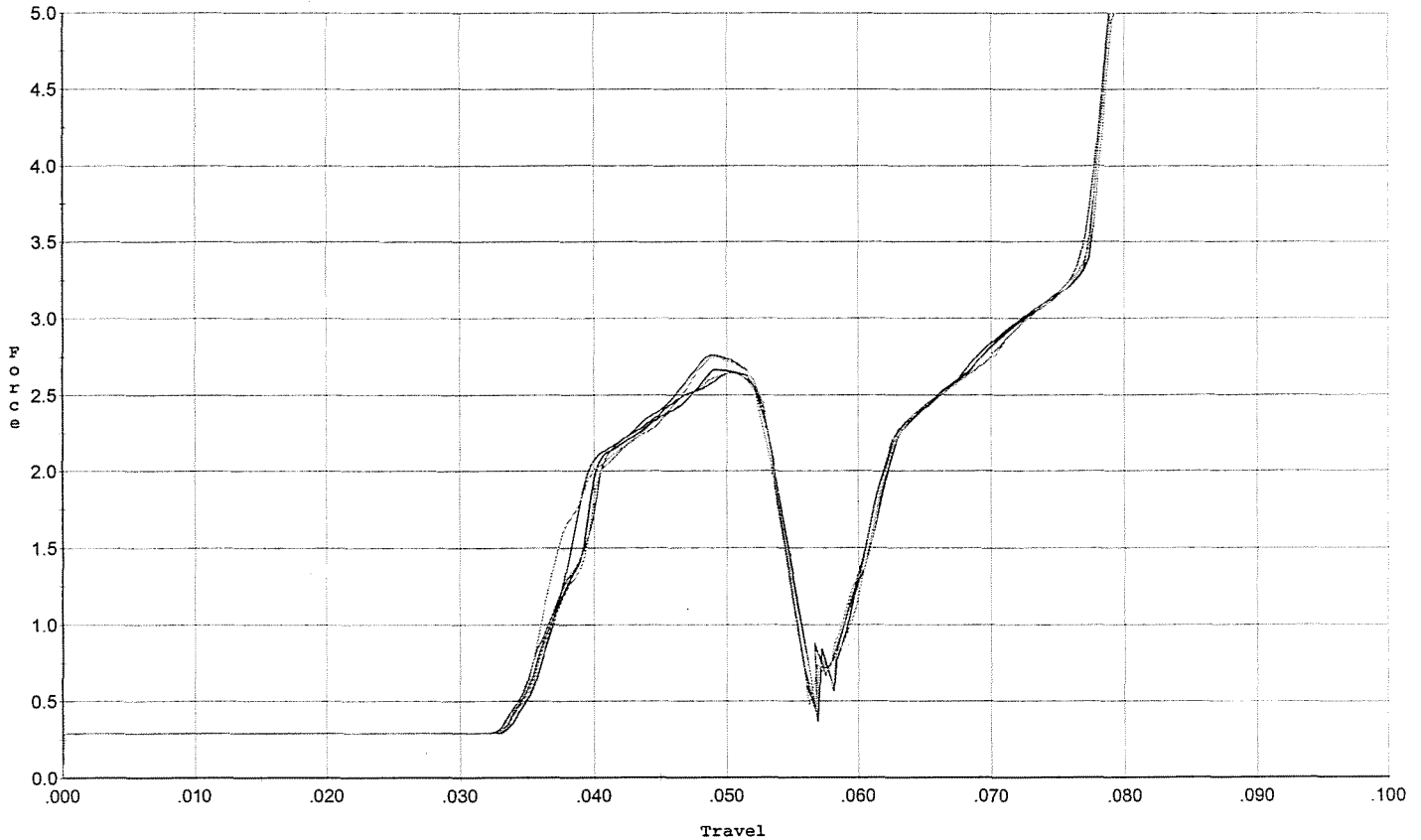
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-9-08	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.5</u> <u>6</u> <u>6</u>	9-9-08	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	9-9-08	TL
	J) ASSEMBLE STOCK		9-2-08	RTL
	K) ASSEMBLE SWIVEL STUDS		9-9-08	TL
	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	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-8-08	FR
670	FINAL INSPECTION A) HEADSPACE		9-9-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.09</u> <u>2.03</u> <u>2.22</u> <u>2.10</u>	9-8-08	ESW
	C) FUNCTION		9-9-08	TL
690	PACK		9/2/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



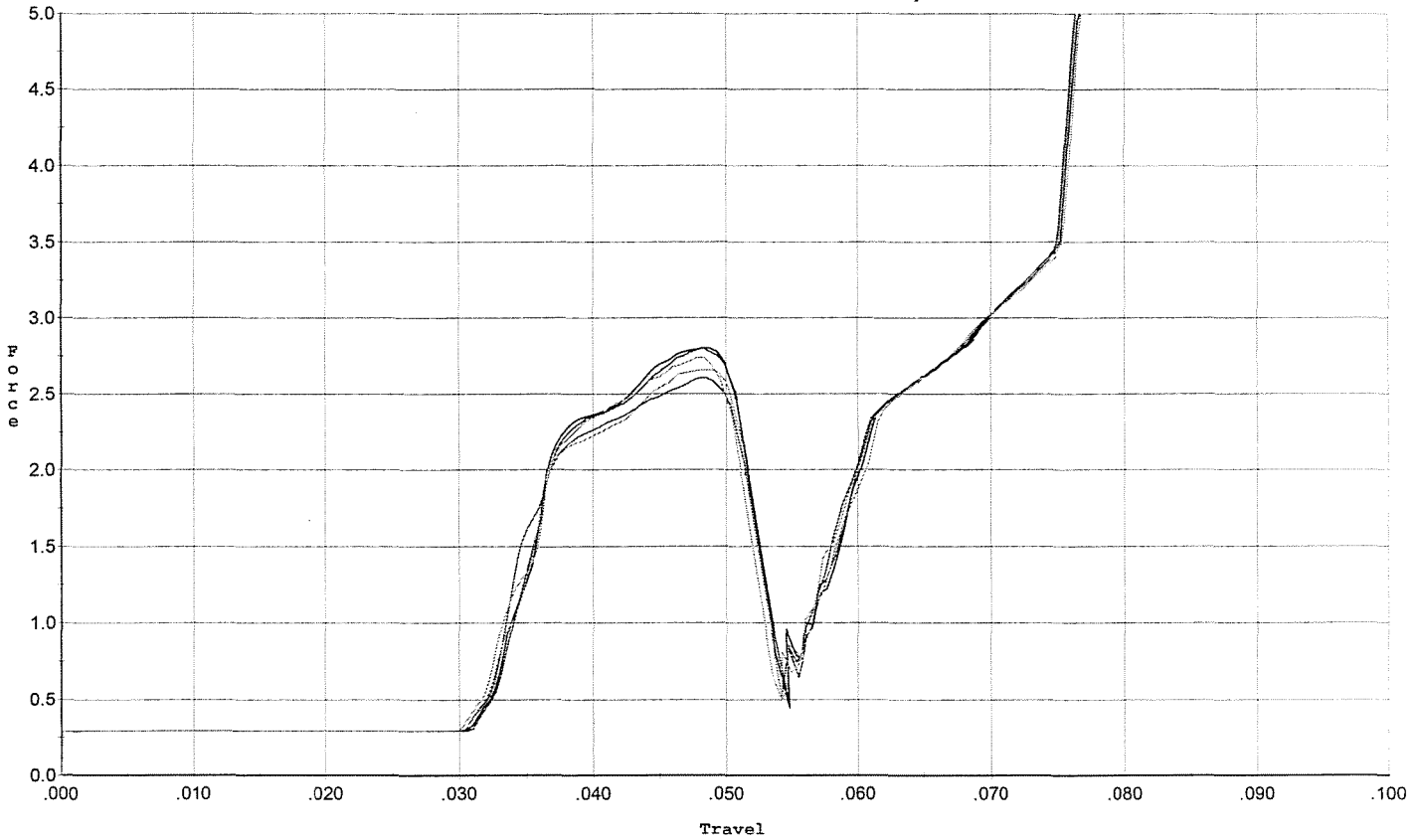
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.649	0.053	0.034	0.033	0.050		Set Trigger
2	2.663	0.055	0.034	0.032	0.051		Set Trigger
3	2.759	0.053	0.033	0.032	0.050		Set Trigger
4	2.747	0.053	0.034	0.033	0.049		Set Trigger
5	2.643	0.053	0.033	0.033	0.050		Set Trigger

Aug. 2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



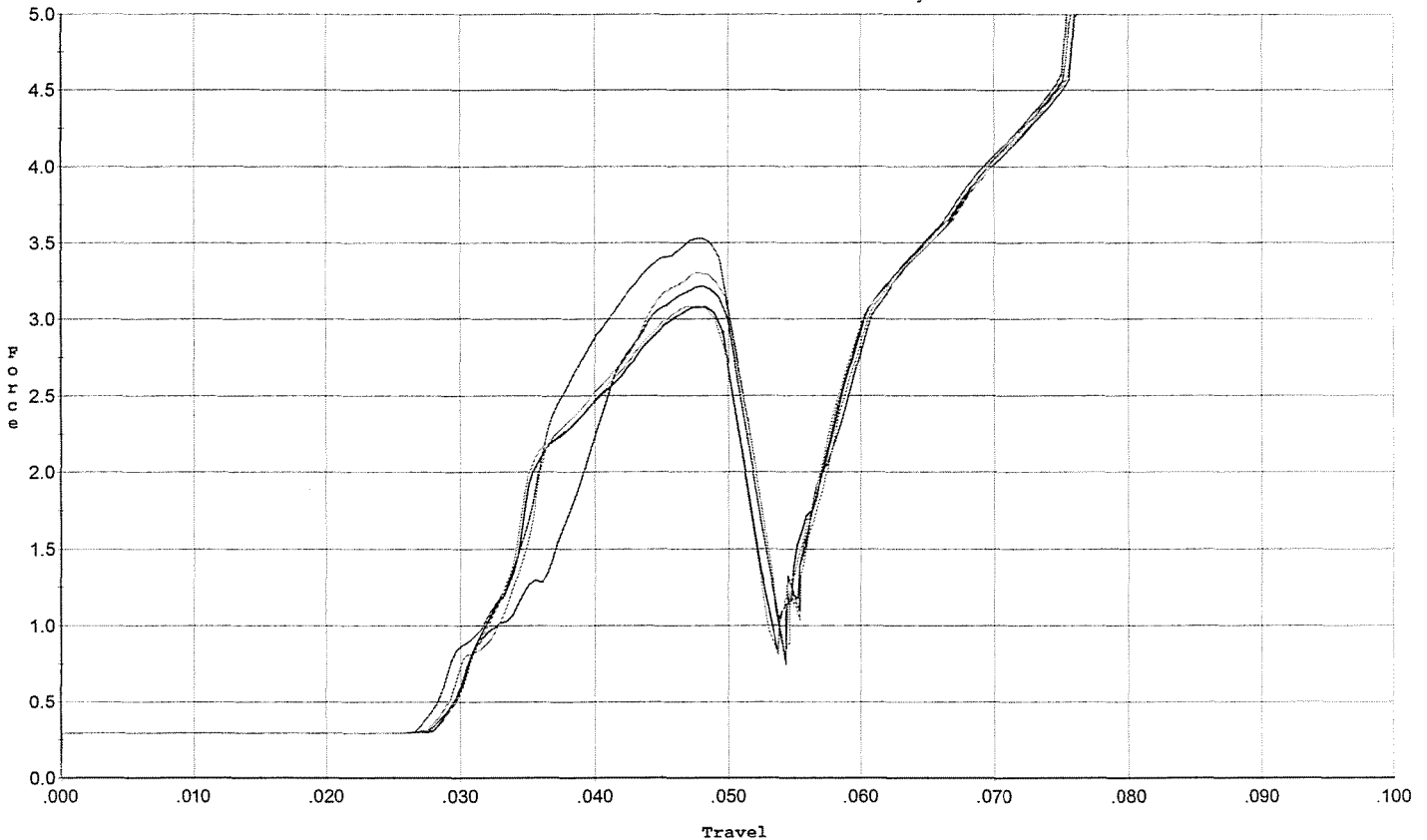
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.804	0.051	0.031	0.031	0.051		Set Trigger
2	2.803	0.051	0.031	0.032	0.052		Set Trigger
3	2.607	0.051	0.031	0.031	0.051		Set Trigger
4	2.739	0.050	0.031	0.032	0.051		Set Trigger
5	2.659	0.051	0.031	0.032	0.051		Set Trigger

Avg 2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



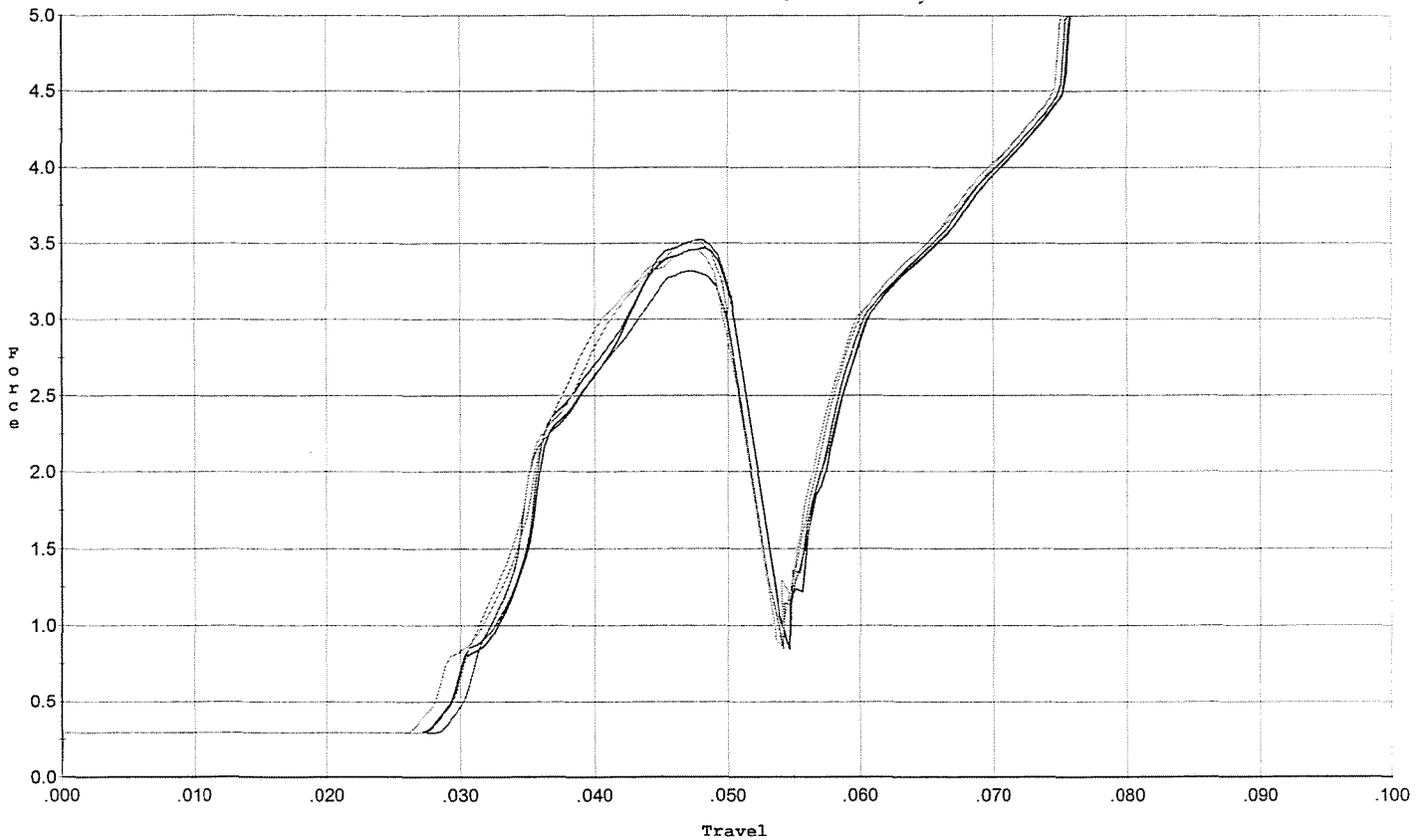
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.220	0.050	0.030	0.030	0.054		Set Trigger
2	3.082	0.050	0.030	0.031	0.055		Set Trigger
3	3.528	0.051	0.029	0.029	0.065		Set Trigger
4	3.089	0.050	0.030	0.031	0.056		Set Trigger
5	3.302	0.052	0.029	0.030	0.060		Set Trigger

Aug. 3-24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



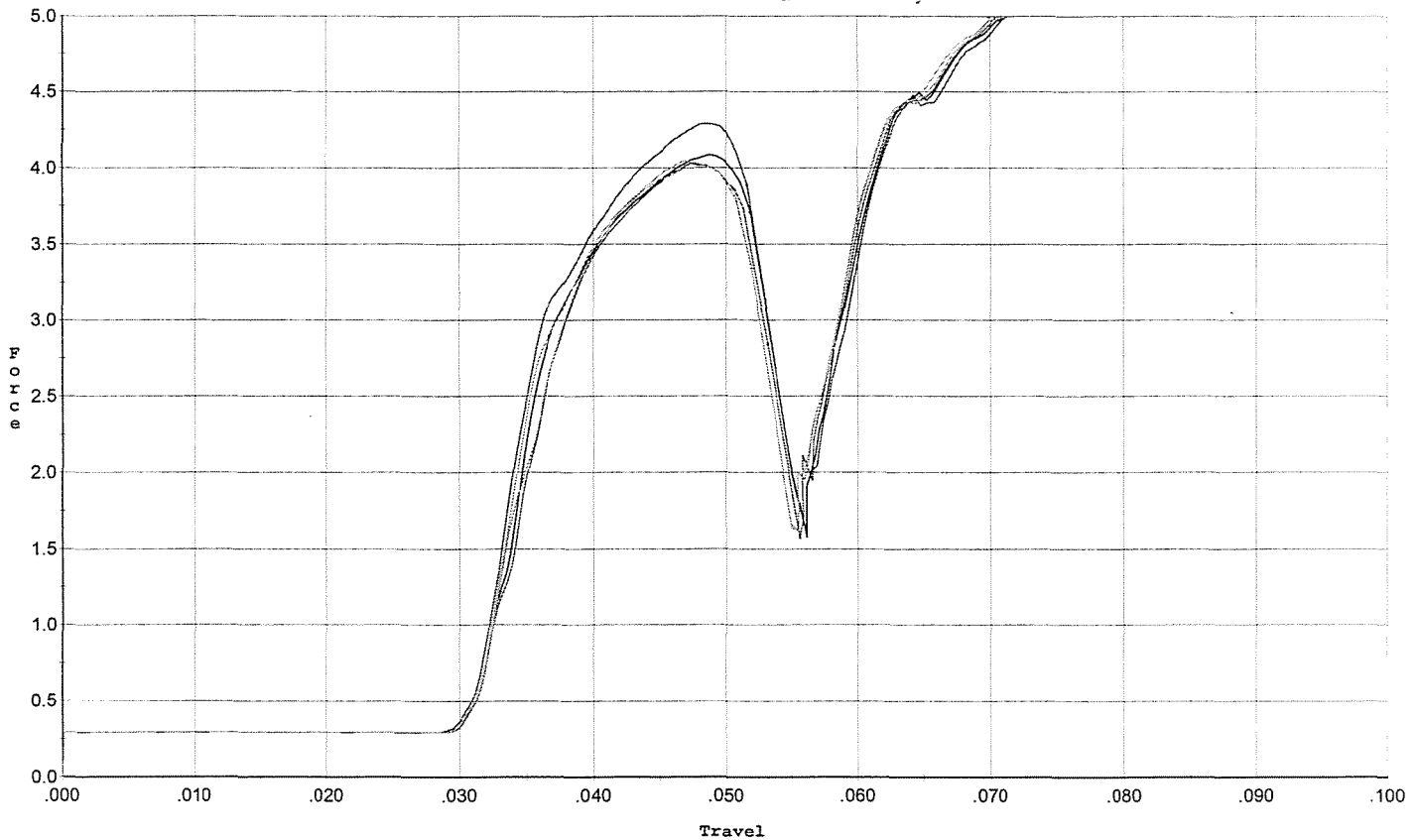
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.522	0.050	0.028	0.030	0.062		Set Trigger
2	3.470	0.050	0.030	0.030	0.061		Set Trigger
3	3.318	0.050	0.030	0.031	0.059		Set Trigger
4	3.460	0.050	0.030	0.030	0.062		Set Trigger
5	3.521	0.050	0.028	0.030	0.062		Set Trigger

Avg. 3.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



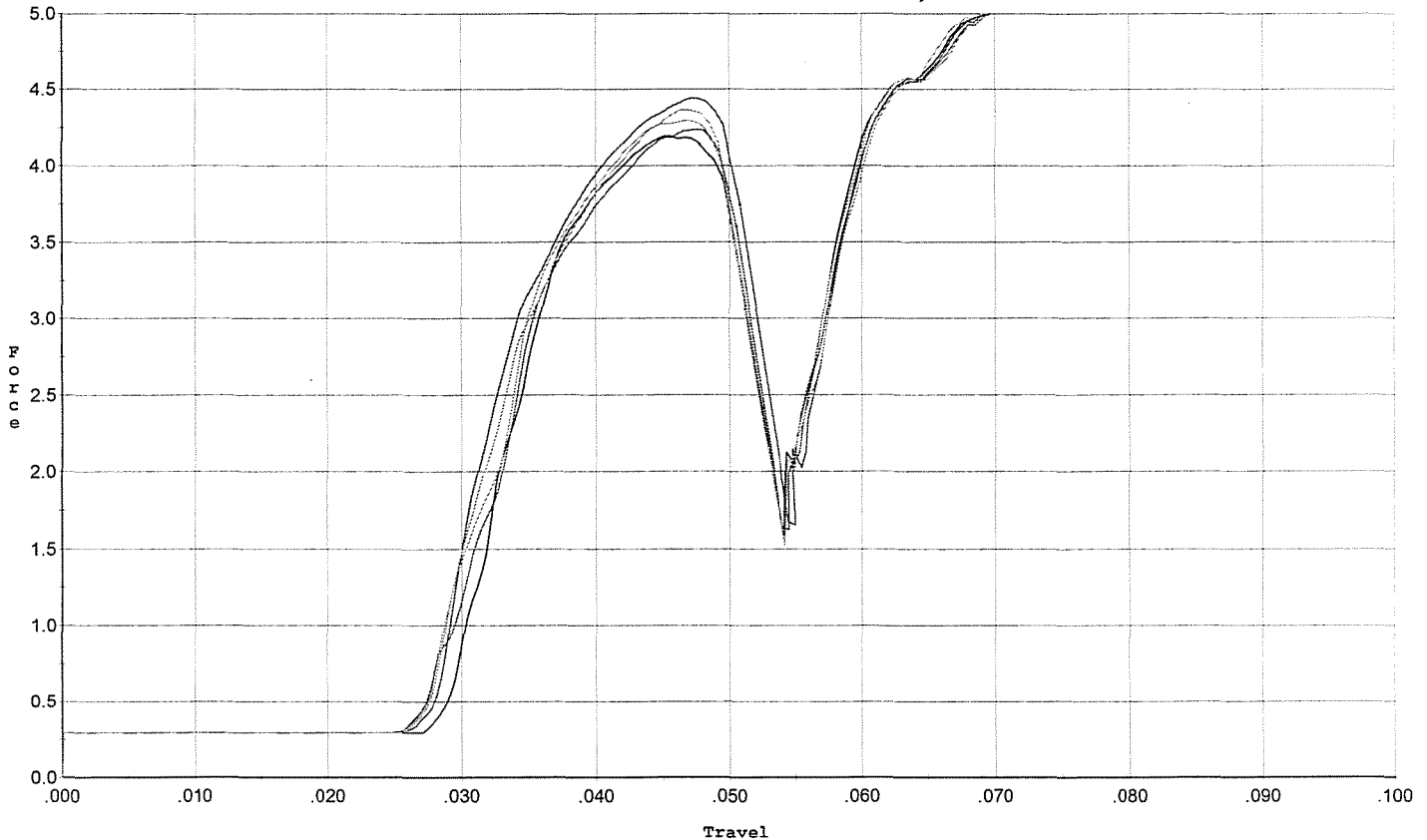
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.290	0.052	0.030	0.028	0.081		Set Trigger
2	4.085	0.052	0.030	0.028	0.078		Set Trigger
3	4.031	0.053	0.031	0.028	0.078		Set Trigger
4	4.009	0.052	0.030	0.028	0.077		Set Trigger
5	4.045	0.052	0.030	0.028	0.076		Set Trigger

Aug. 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



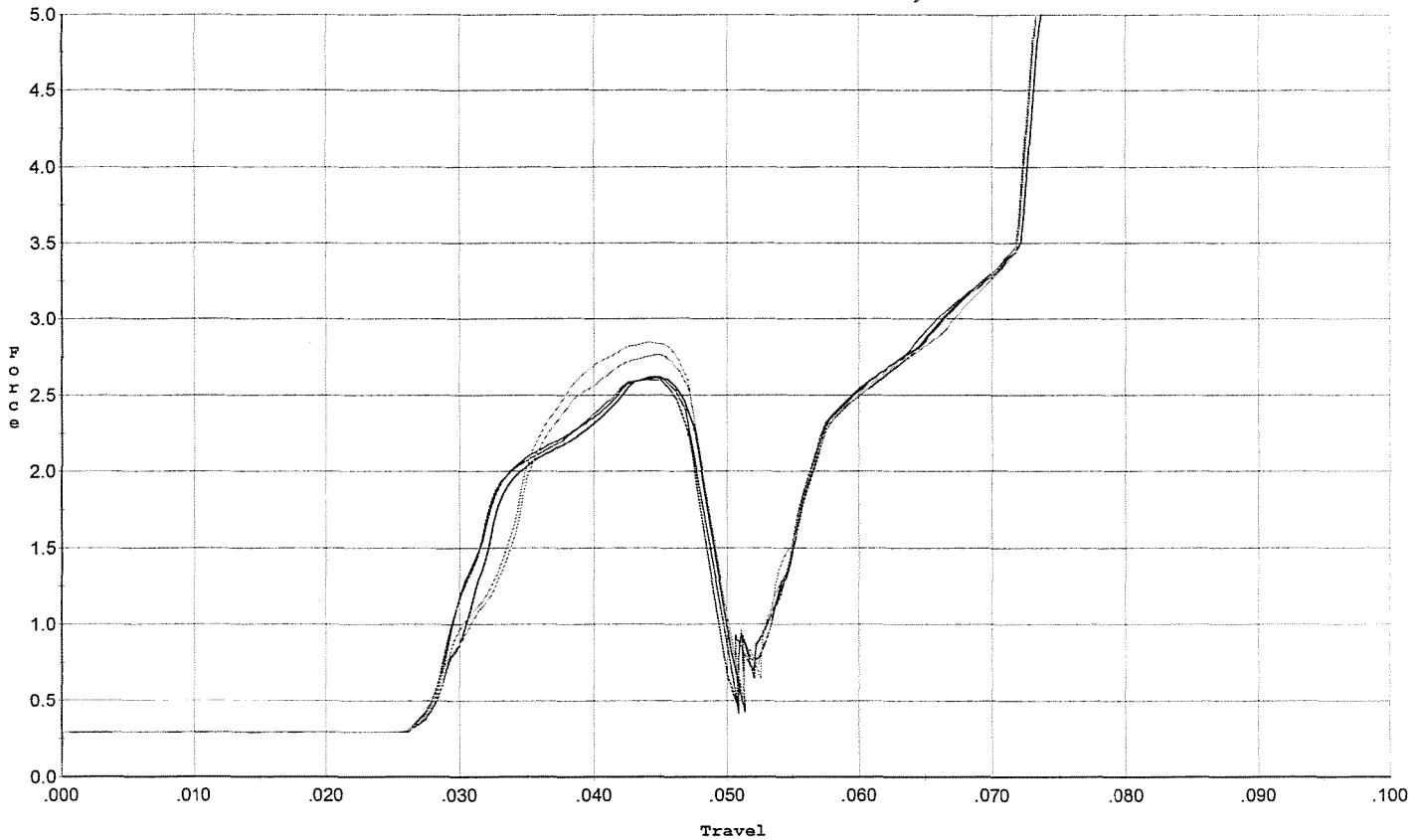
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.444	0.051	0.028	0.027	0.088		Set Trigger
2	4.193	0.050	0.029	0.028	0.078		Set Trigger
3	4.238	0.051	0.027	0.028	0.082		Set Trigger
4	4.295	0.049	0.028	0.028	0.081		Set Trigger
5	4.367	0.052	0.027	0.027	0.086		Set Trigger

Aug 4-30

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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



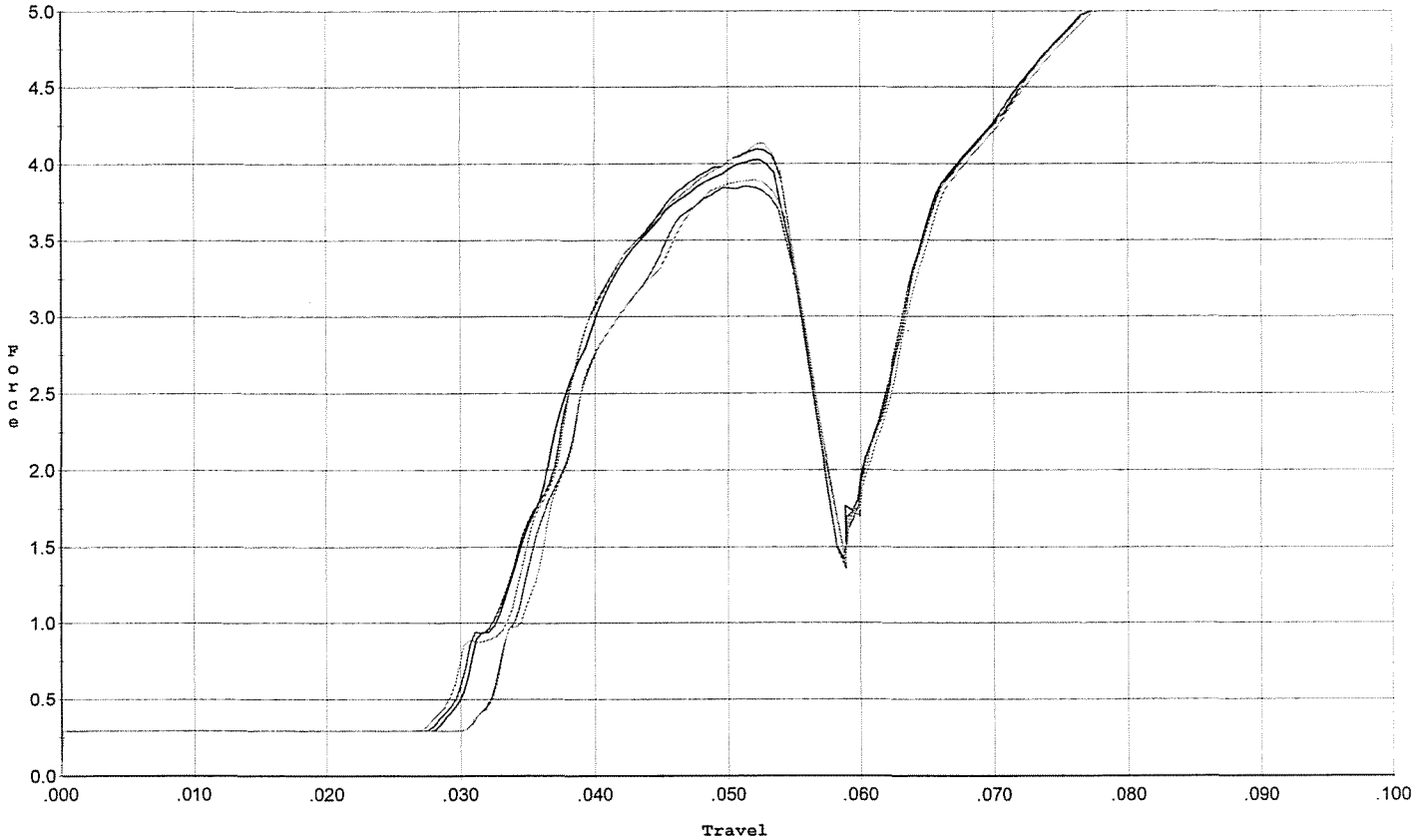
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.621	0.049	0.028	0.031	0.050		Set Trigger
2	2.614	0.048	0.028	0.031	0.048		Set Trigger
3	2.601	0.047	0.028	0.031	0.048		Set Trigger
4	2.845	0.047	0.028	0.031	0.050		Set Trigger
5	2.764	0.047	0.028	0.031	0.049		Set Trigger

Avg-2.68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 08/14/2008

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	4.096	0.054	0.030	0.029	0.083		Set Trigger
2	4.027	0.055	0.030	0.029	0.083		Set Trigger
3	3.849	0.055	0.032	0.029	0.077		Set Trigger
4	3.896	0.054	0.032	0.030	0.076		Set Trigger
5	4.134	0.054	0.029	0.029	0.082		Set Trigger

Avg 4.00