

G6784618

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

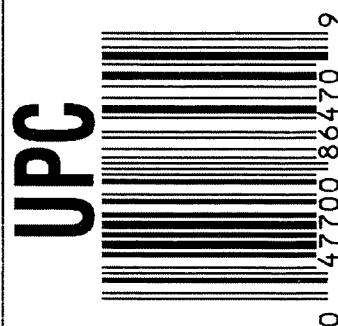


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6784618



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6784618

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SPD
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SPD
460	CHECK HEADSPACE		9-9-08	SPD
470	DIS-ASSEMBLE ACTION		9-9-08	SPD
472	SERIALIZE BOLT HANDLE		9-10-08	PSN
475	DRILL AND TAP SIGHT HOLES		9-11-08	SP
480	MAGNAFLUX BBL ACTION		9-12-08	PSN
490	MAGNAFLUX BOLT		9-12-08	M/L
500	ROLLMARK CALIBER		9-12-08	RT
520	GOFF BLAST BBL / REC		9-12-08	DG
542	APPLY COATINGS (BARREL ACTION)		9-17	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-23-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-23-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-23-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-7-08	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

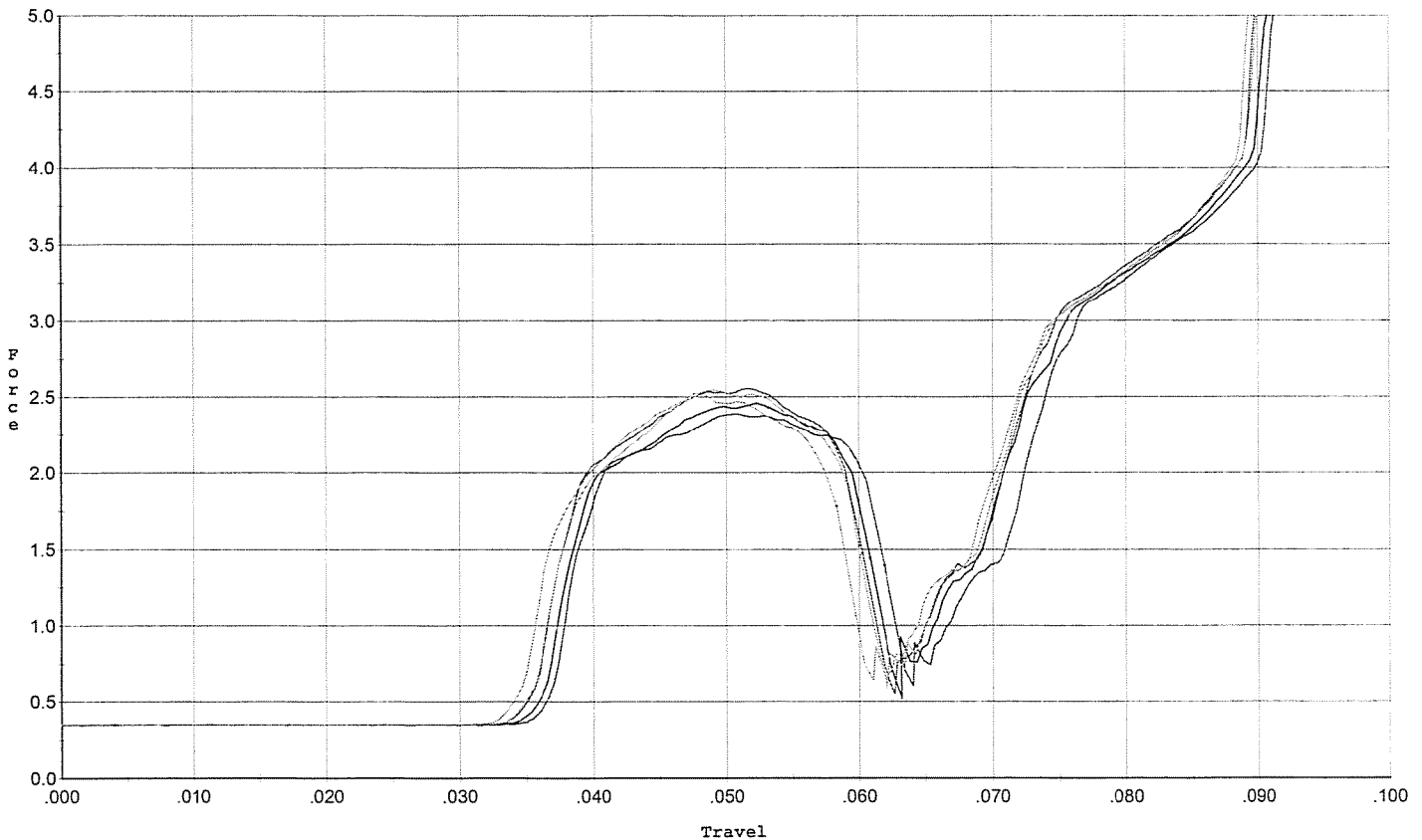
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>4.0</u> <u>4.5</u>	12-11-08	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	12-11-08	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-11-08	RN
	J) ASSEMBLE STOCK		10-7-08	RSN
	K) ASSEMBLE SWIVEL STUDS		12-11-08	RN
	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	PASS FAIL PASS FAIL	11-25-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-25-08	JS
670	FINAL INSPECTION A) HEADSPACE		12-11-08	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>247</u> <u>249</u> <u>251</u> <u>250</u> <u>244</u>	12-10-08	RN
	C) FUNCTION		12-11-08	RN
690	PACK		12-18-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



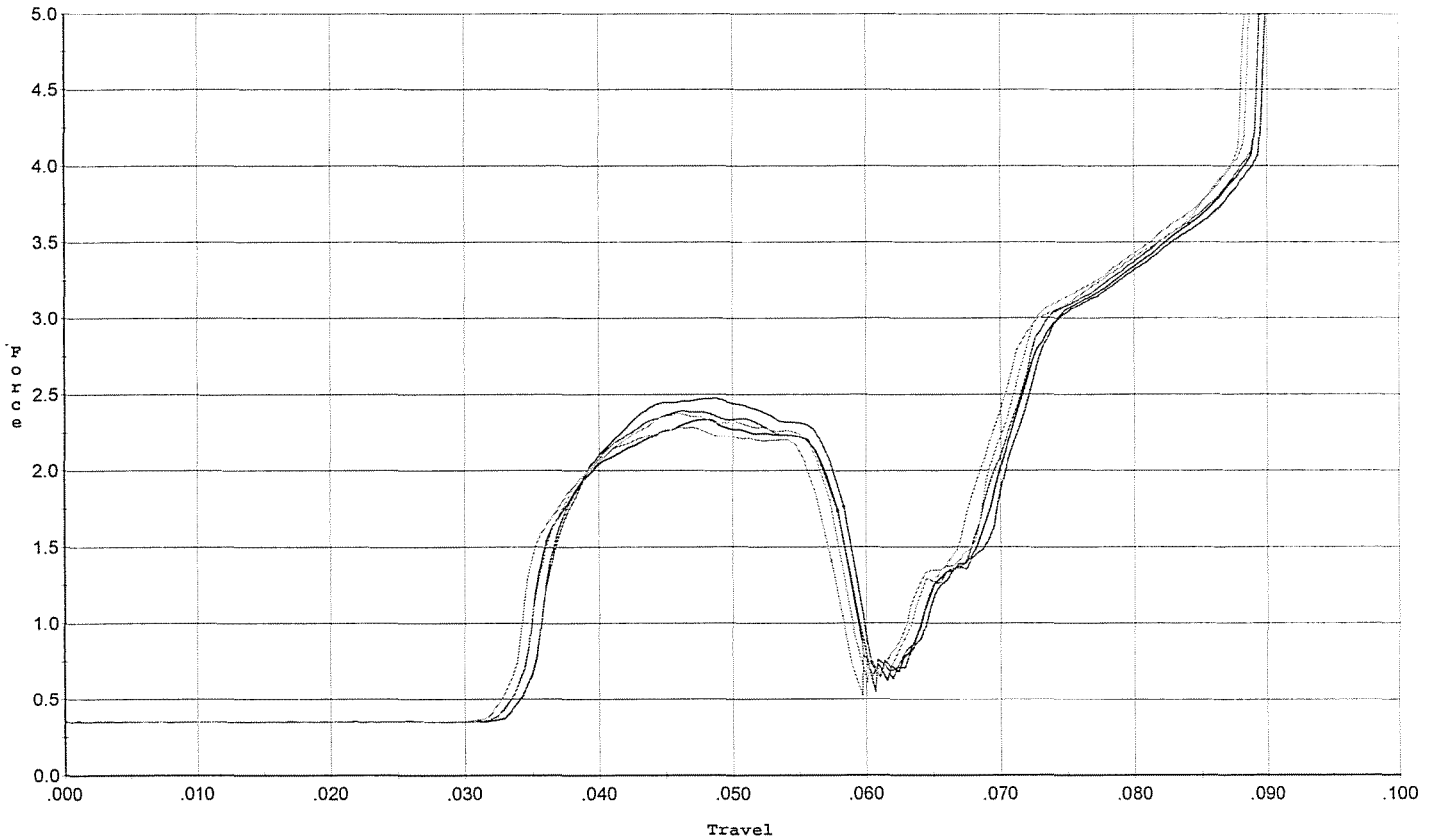
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.388	0.062	0.037	0.037	0.065		Set Trigger
2	2.459	0.061	0.036	0.037	0.064		Set Trigger
3	2.554	0.060	0.036	0.036	0.066		Set Trigger
4	2.546	0.059	0.035	0.036	0.064		Set Trigger
5	2.524	0.058	0.035	0.036	0.063		Set Trigger

Aug. 2.419

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



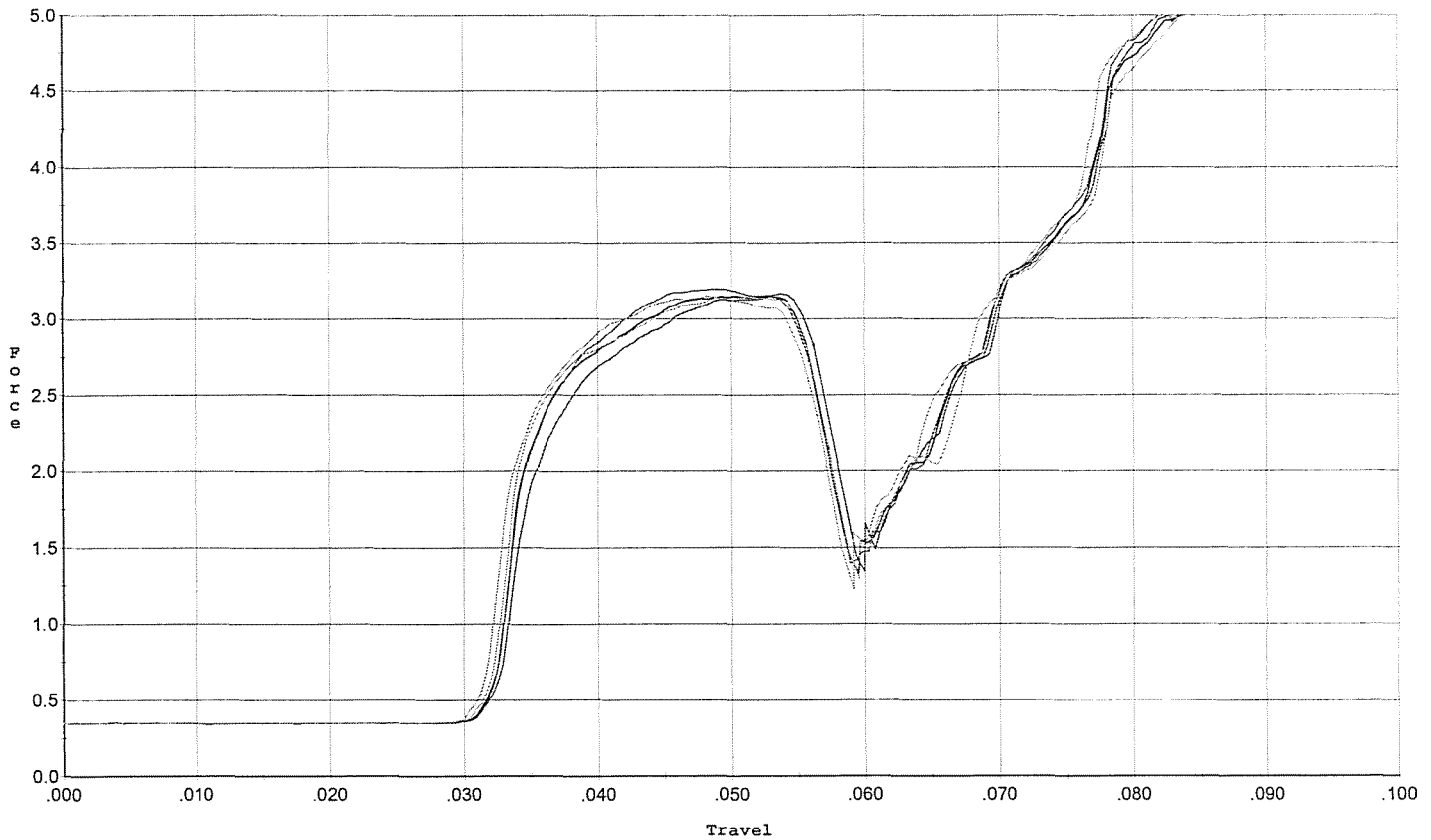
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.476	0.058	0.035	0.037	0.063		Set Trigger
2	2.336	0.058	0.034	0.037	0.061		Set Trigger
3	2.394	0.058	0.034	0.037	0.061		Set Trigger
4	2.377	0.057	0.033	0.036	0.061		Set Trigger
5	2.286	0.057	0.033	0.036	0.060		Set Trigger

Aug 2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



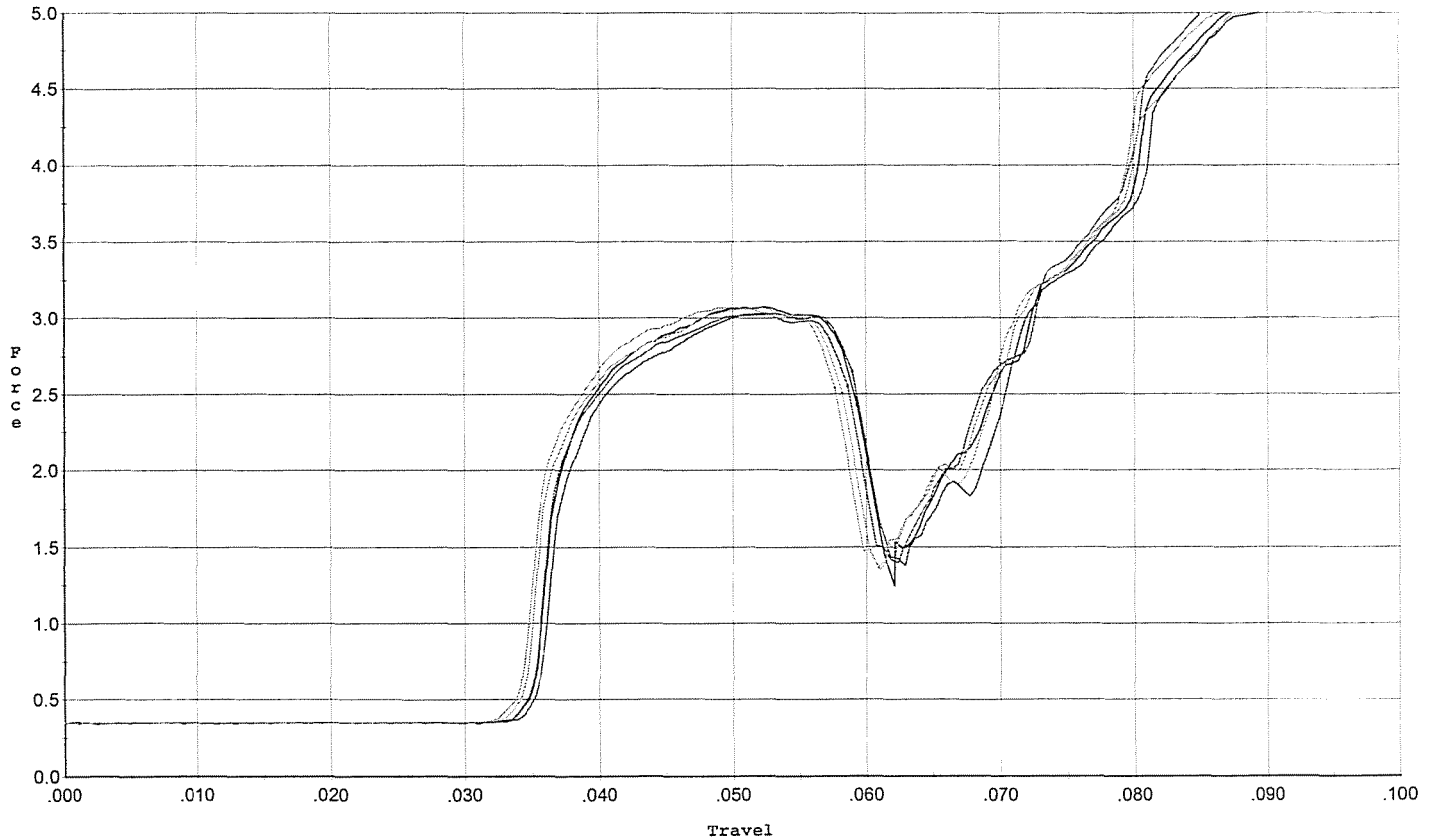
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.166	0.056	0.032	0.035	0.076		Set Trigger
2	3.150	0.057	0.031	0.034	0.080		Set Trigger
3	3.196	0.056	0.031	0.034	0.078		Set Trigger
4	3.145	0.057	0.032	0.034	0.080		Set Trigger
5	3.150	0.056	0.030	0.034	0.080		Set Trigger

Aug. 3.16

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



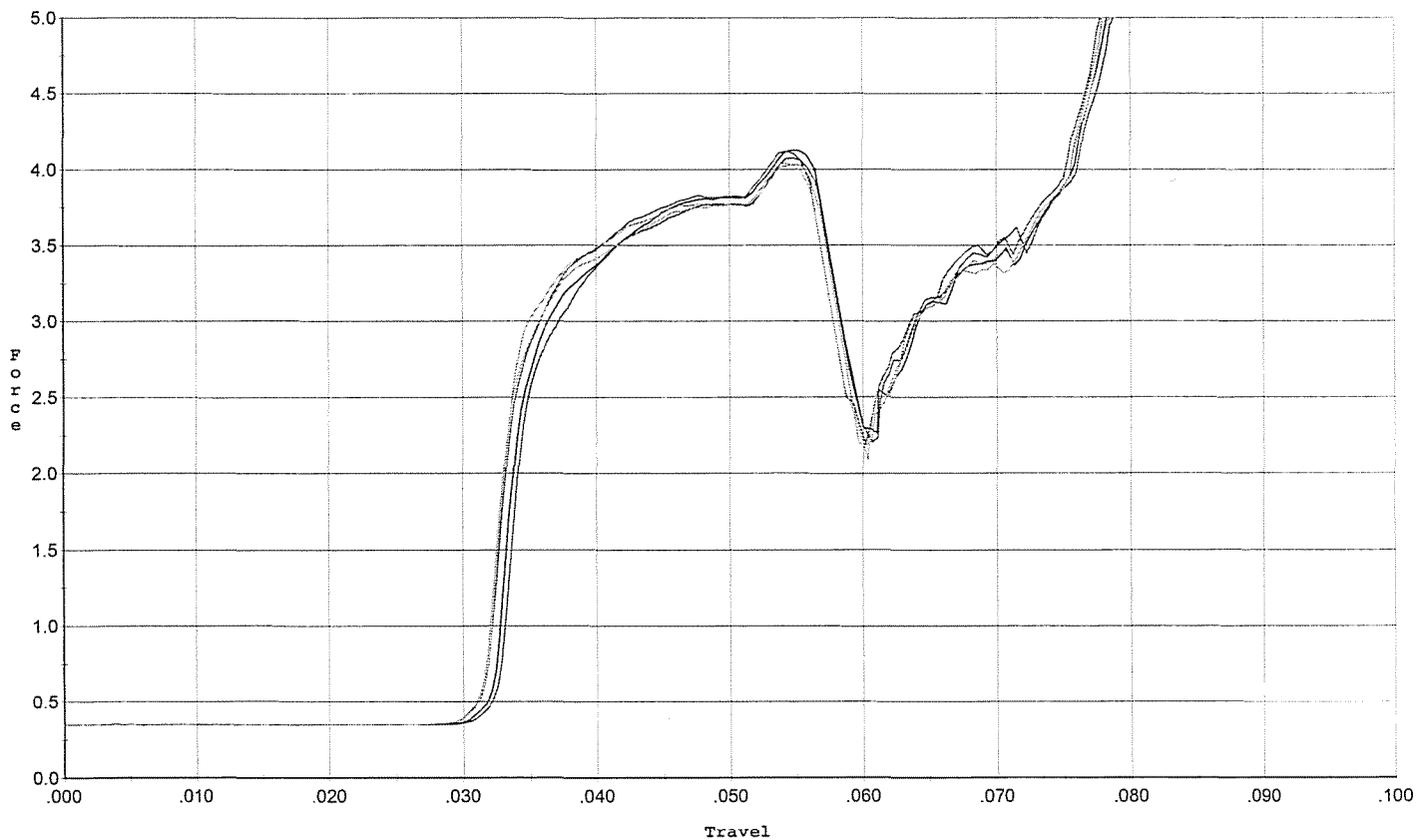
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.059	0.035	0.036	0.076		Set Trigger
2	3.072	0.059	0.035	0.036	0.078		Set Trigger
3	3.028	0.059	0.035	0.036	0.076		Set Trigger
4	3.069	0.058	0.034	0.035	0.077		Set Trigger
5	3.069	0.058	0.034	0.035	0.076		Set Trigger

Ag 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



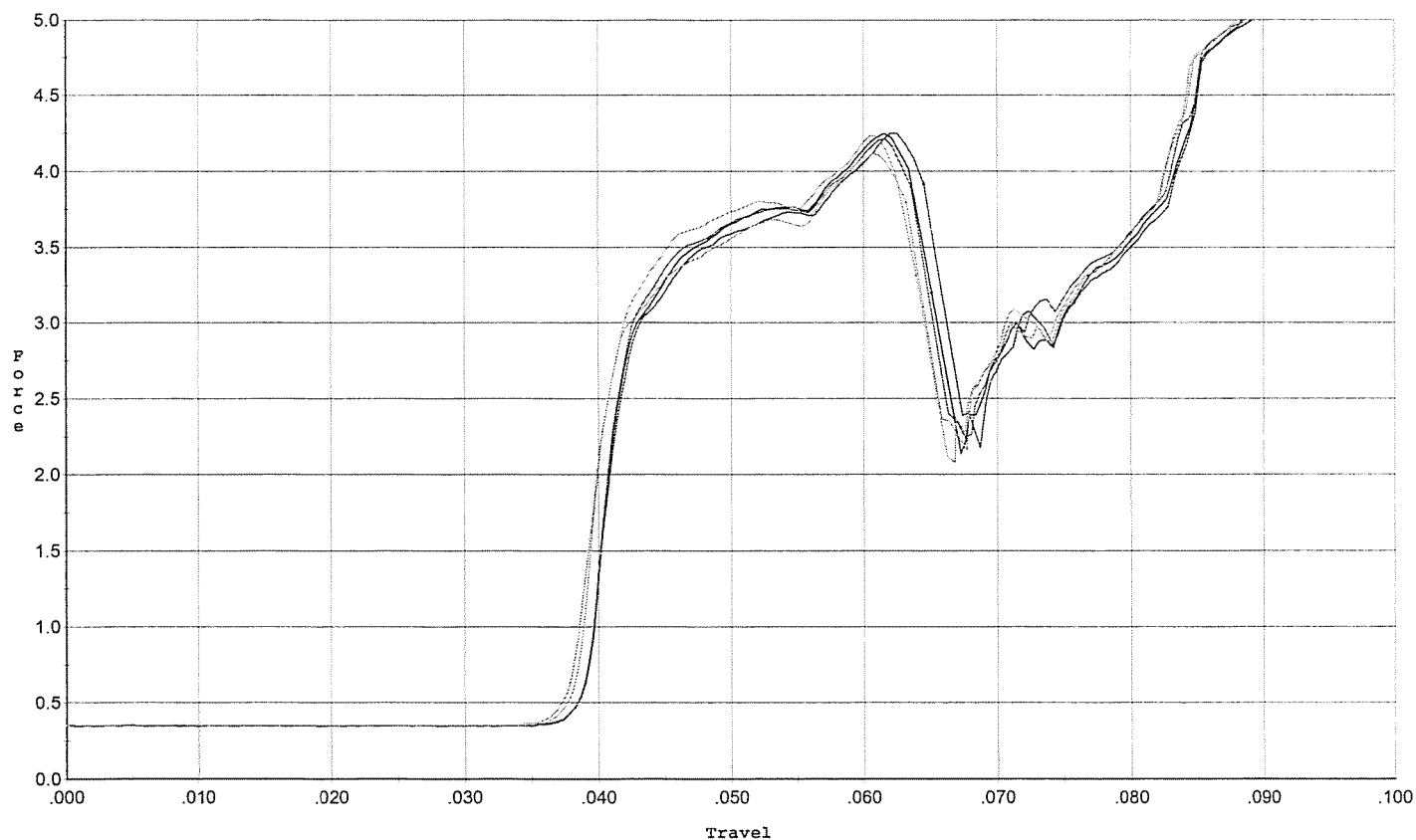
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.076	0.057	0.032	0.033	0.095		Set Trigger
2	4.126	0.056	0.032	0.033	0.097		Set Trigger
3	4.118	0.056	0.031	0.033	0.098		Set Trigger
4	4.037	0.056	0.031	0.033	0.097		Set Trigger
5	4.034	0.057	0.031	0.033	0.100		Set Trigger

Aug 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



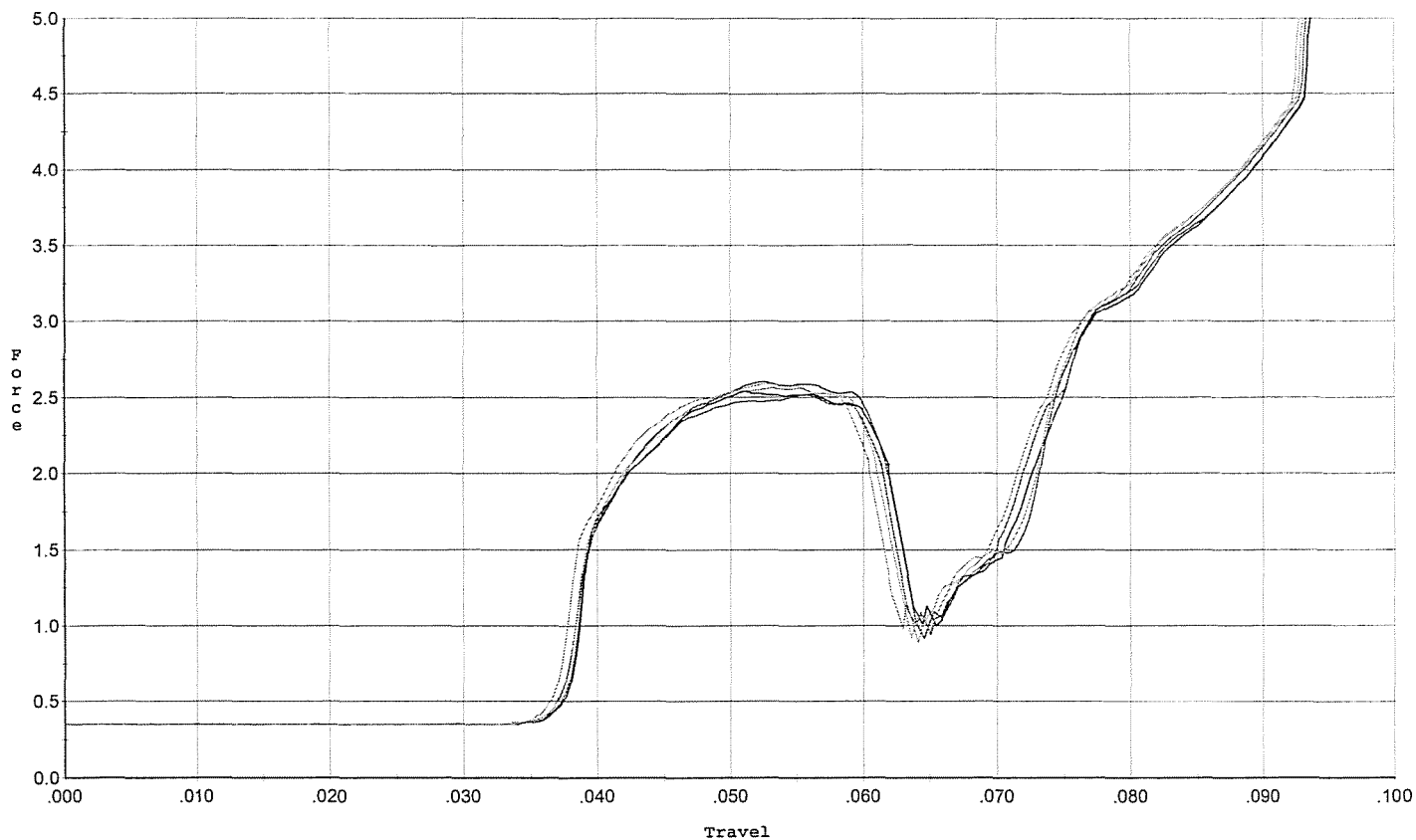
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.249	0.065	0.039	0.033	0.105		Set Trigger
2	4.247	0.065	0.039	0.034	0.105		Set Trigger
3	4.214	0.064	0.039	0.034	0.102		Set Trigger
4	4.235	0.064	0.038	0.034	0.104		Set Trigger
5	4.115	0.063	0.037	0.034	0.101		Set Trigger

Aug. 4. 12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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



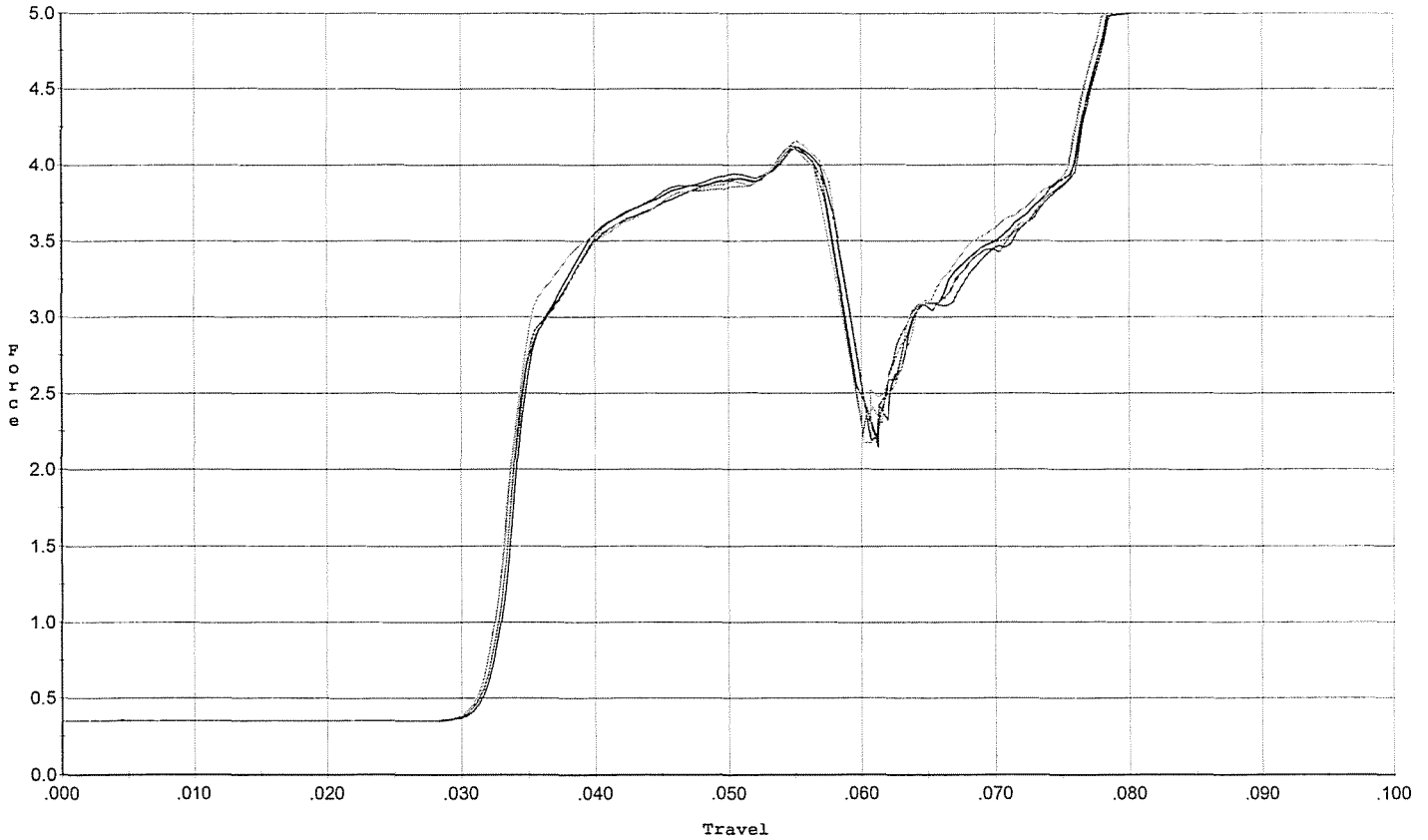
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.603	0.062	0.037	0.038	0.069		Set Trigger
2	2.541	0.062	0.038	0.038	0.068		Set Trigger
3	2.519	0.061	0.038	0.038	0.066		Set Trigger
4	2.564	0.061	0.037	0.038	0.066		Set Trigger
5	2.591	0.060	0.037	0.038	0.066		Set Trigger

Aug-2.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/2/2008

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	4.110	0.057	0.032	0.033	0.100		Set Trigger
2	4.117	0.058	0.032	0.032	0.102		Set Trigger
3	4.127	0.057	0.031	0.033	0.101		Set Trigger
4	4.117	0.058	0.031	0.032	0.102		Set Trigger
5	4.158	0.058	0.031	0.032	0.103		Set Trigger

Aug. 4.12