

G6784631

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



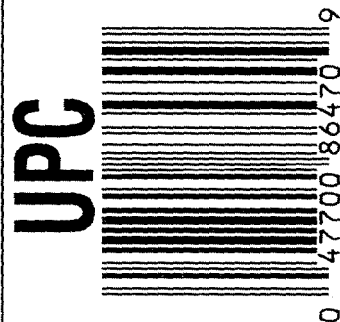
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6784631



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6784631

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-5-08	SPD
430	ASSEMBLE TO STOCK		9-6-08	TC
440	PROOF		9-6-08	TC
460	CHECK HEADSPACE		9-6-08	TC
470	DIS-ASSEMBLE ACTION		9-6-08	SPD
472	SERIALIZE BOLT HANDLE		9-8-08	RTZ
475	DRILL AND TAP SIGHT HOLES		9-8-08	SP
480	MAGNAFLUX BBL ACTION		9-8-08	SP
490	MAGNAFLUX BOLT		9/6/08	MR2
500	ROLLMARK CALIBER		9/9/08	RT
520	GOFF BLAST BBL / REC		9/10/08	DS
542	APPLY COATINGS (BARREL ACTION)		9/13	cm
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-14-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-14-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-14-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-27-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

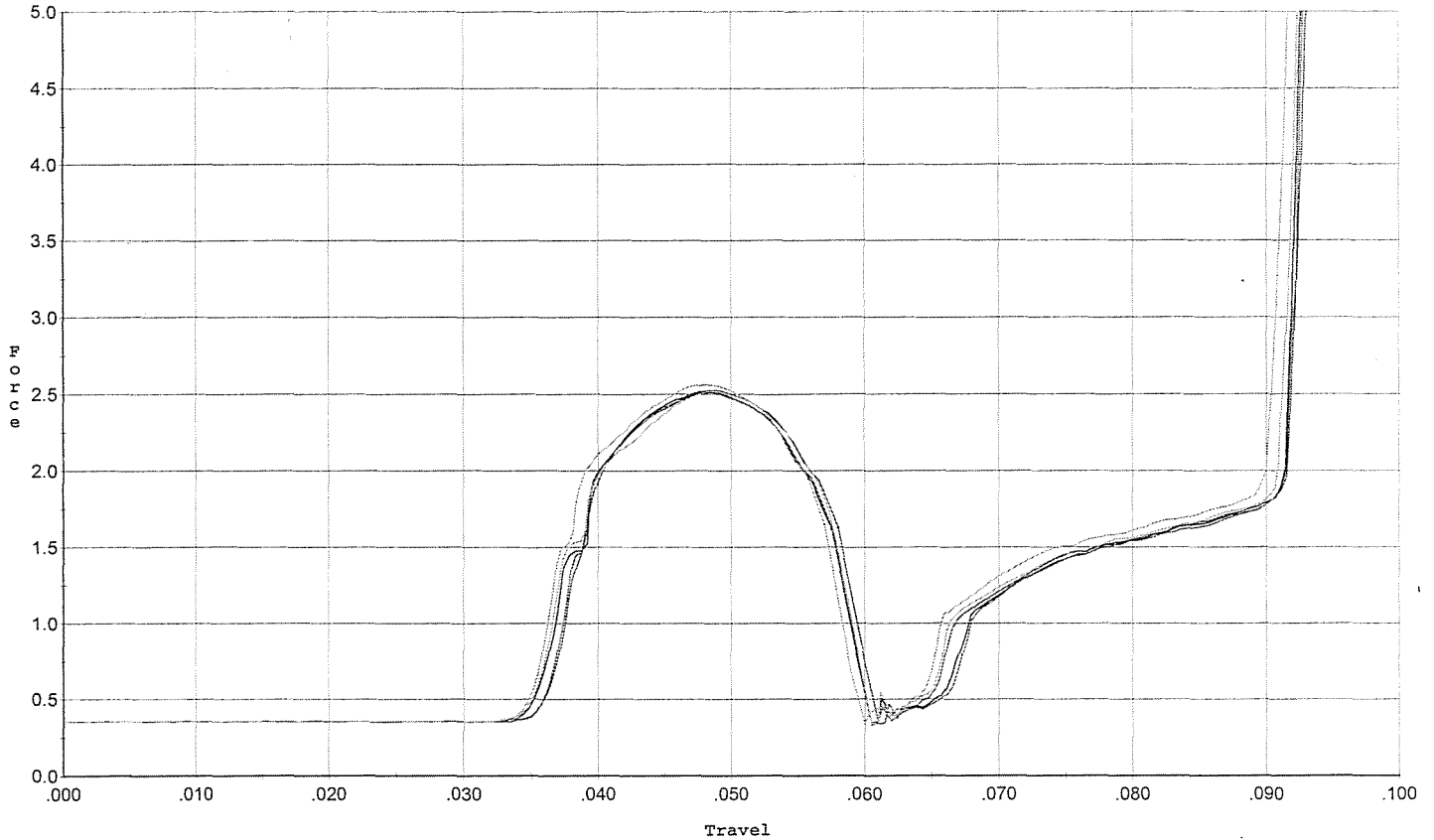
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3.0</u>	<u>3.0</u>	<u>3.0</u>	10-8-08	L. J.		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.0</u>	<u>3.0</u>	10-8-08	L. J.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	10-8-08	L. J.		
	J) ASSEMBLE STOCK					9-27-08	L.P.D.		
	K) ASSEMBLE SWIVEL STUDS					10-8-08	L. J.		
	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		9-30-08	L. J.		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					9-30-08	TC		
670	FINAL INSPECTION A) HEADSPACE					10-8-08	L. J.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.10</u>	<u>2.18</u>	<u>2.06</u>	<u>2.10</u>	<u>2.11</u>	9/30/08	Fm
	C) FUNCTION					10-8-08	L. J.		
690	PACK					12-8-08	LSW		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/25/08

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



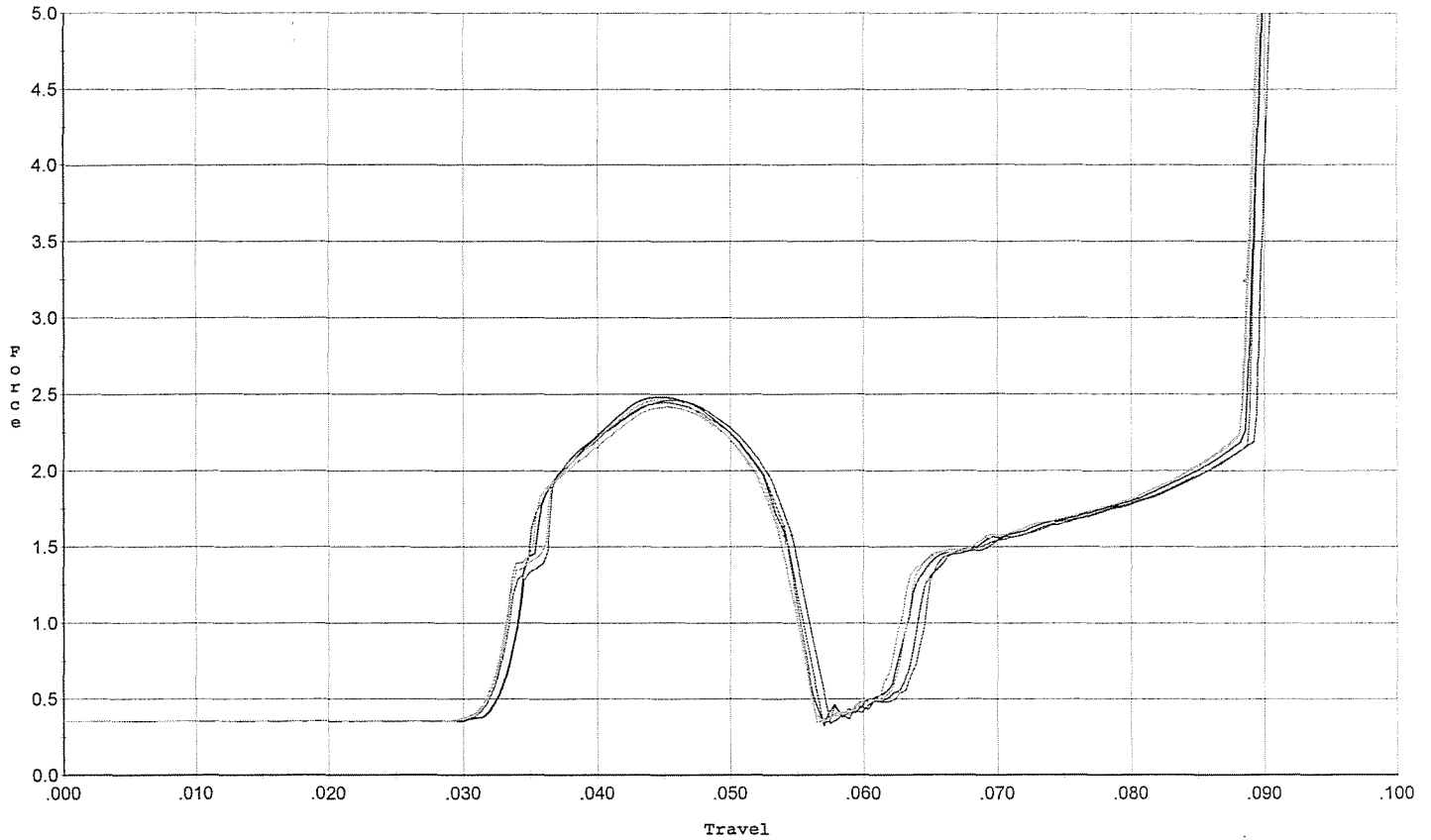
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.058	0.036	0.040	0.059		Set Trigger
2	2.510	0.058	0.035	0.040	0.058		Set Trigger
3	2.524	0.058	0.036	0.040	0.058		Set Trigger
4	2.523	0.059	0.035	0.039	0.060		Set Trigger
5	2.564	0.057	0.035	0.039	0.059		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



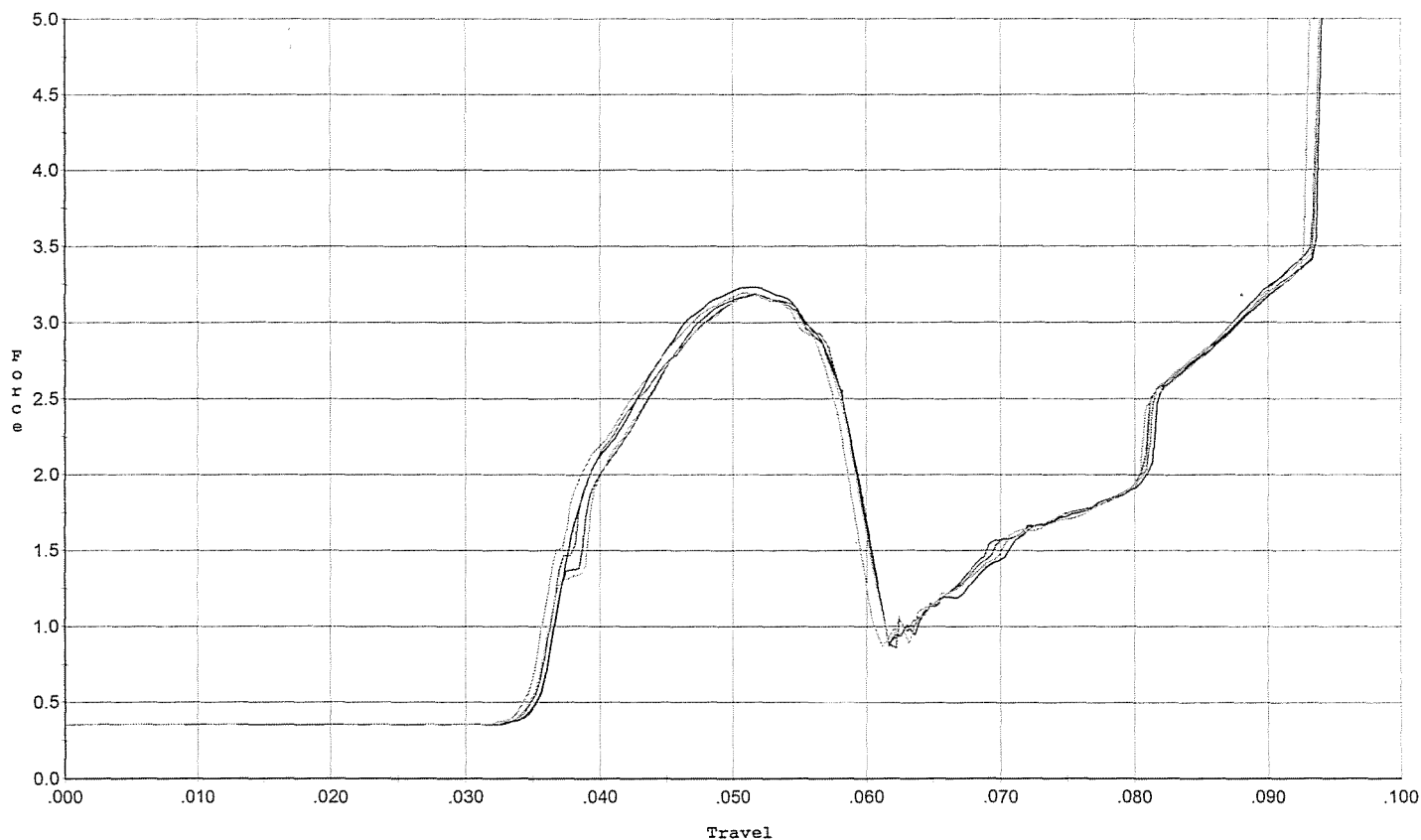
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.055	0.032	0.040	0.056		Set Trigger
2	2.482	0.054	0.032	0.040	0.056		Set Trigger
3	2.447	0.054	0.032	0.040	0.056		Set Trigger
4	2.421	0.054	0.032	0.040	0.055		Set Trigger
5	2.474	0.055	0.032	0.039	0.057		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



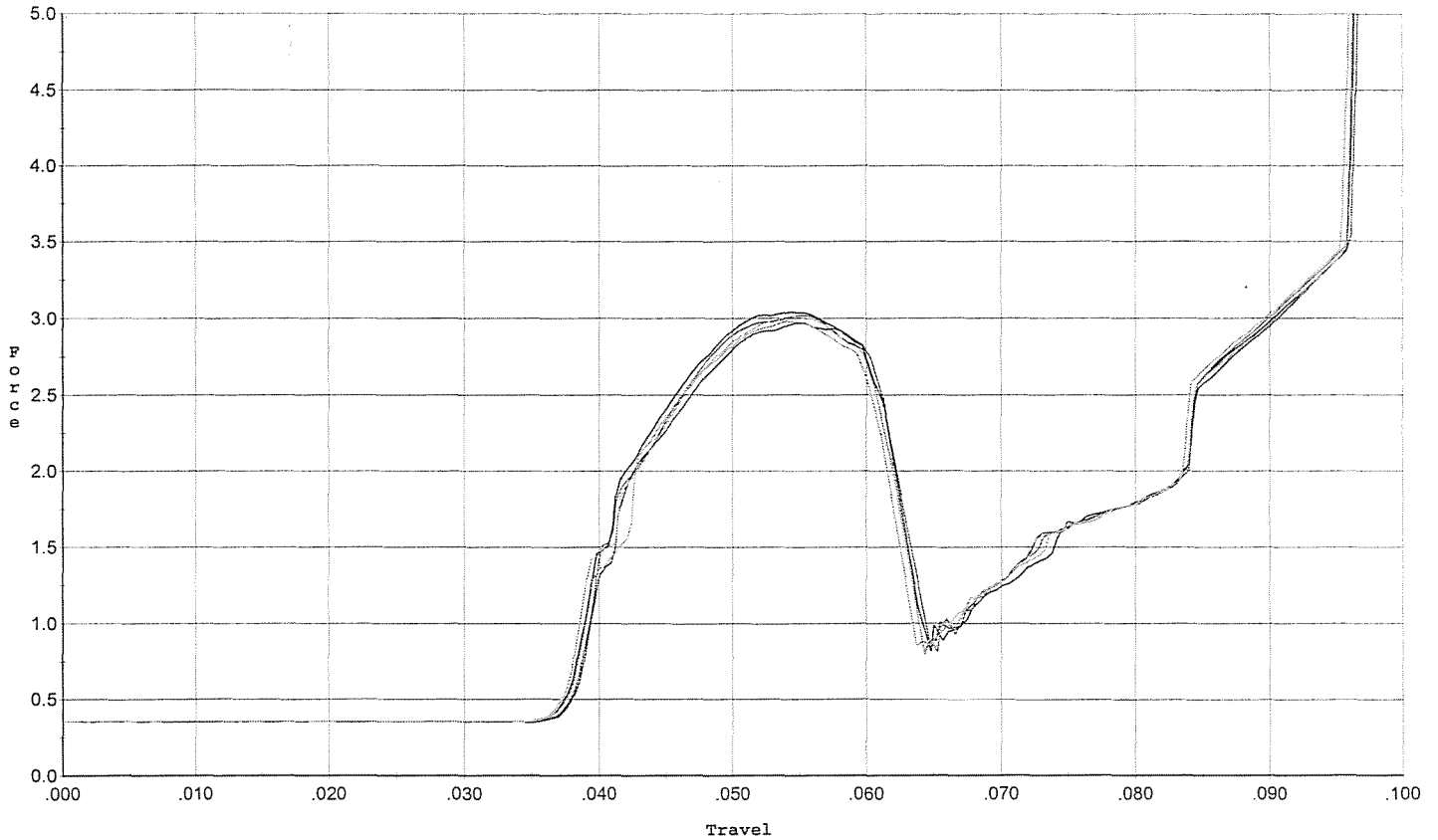
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.183	0.060	0.035	0.039	0.073		Set Trigger
2	3.231	0.058	0.036	0.039	0.072		Set Trigger
3	3.180	0.058	0.035	0.039	0.072		Set Trigger
4	3.193	0.058	0.035	0.039	0.071		Set Trigger
5	3.191	0.058	0.034	0.038	0.072		Set Trigger

Aug 3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



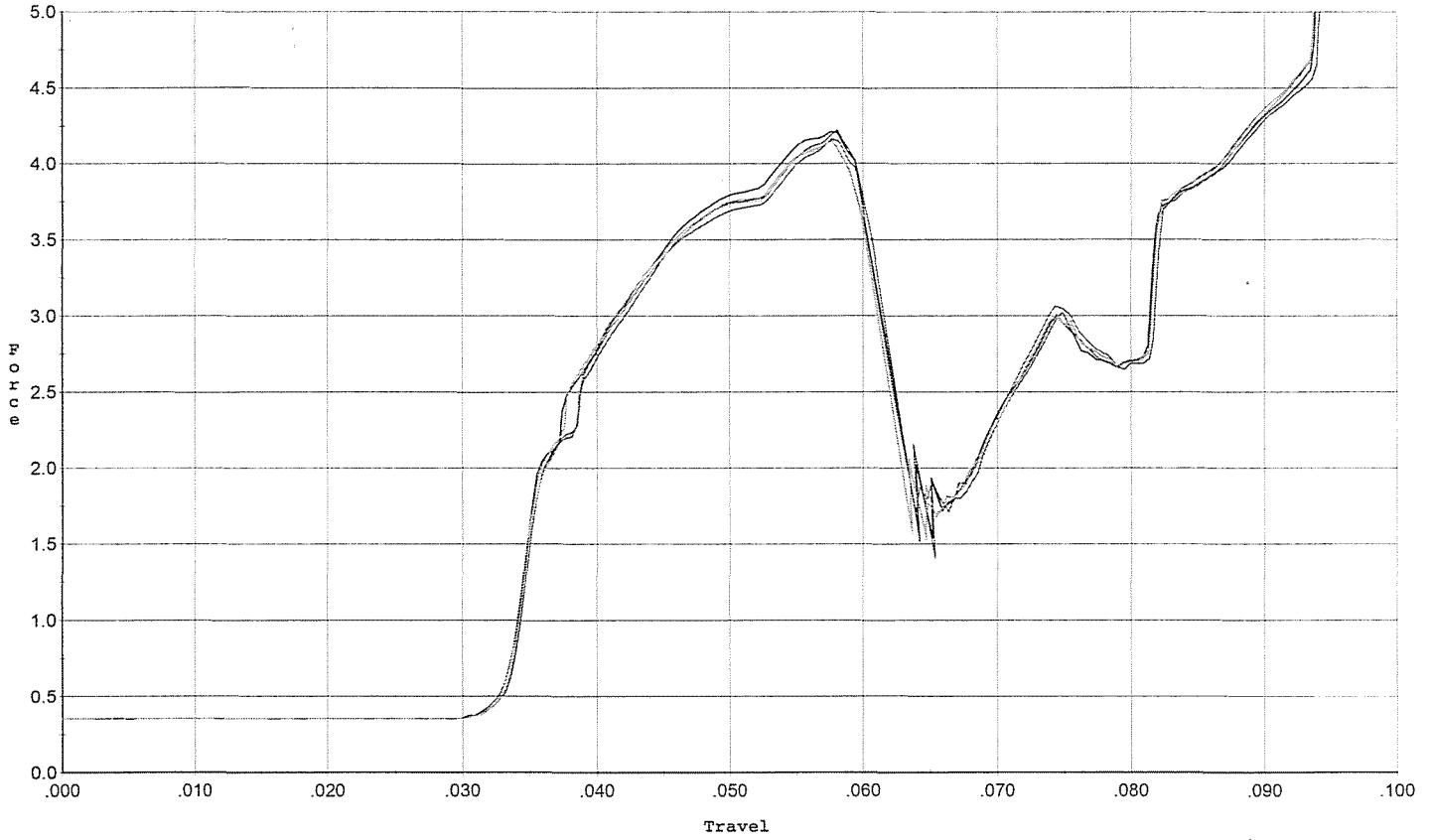
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.971	0.061	0.038	0.040	0.071		Set Trigger
2	3.042	0.061	0.037	0.039	0.073		Set Trigger
3	3.019	0.062	0.038	0.039	0.072		Set Trigger
4	3.015	0.062	0.037	0.039	0.073		Set Trigger
5	2.979	0.061	0.038	0.040	0.070		Set Trigger

Avg 3.00

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



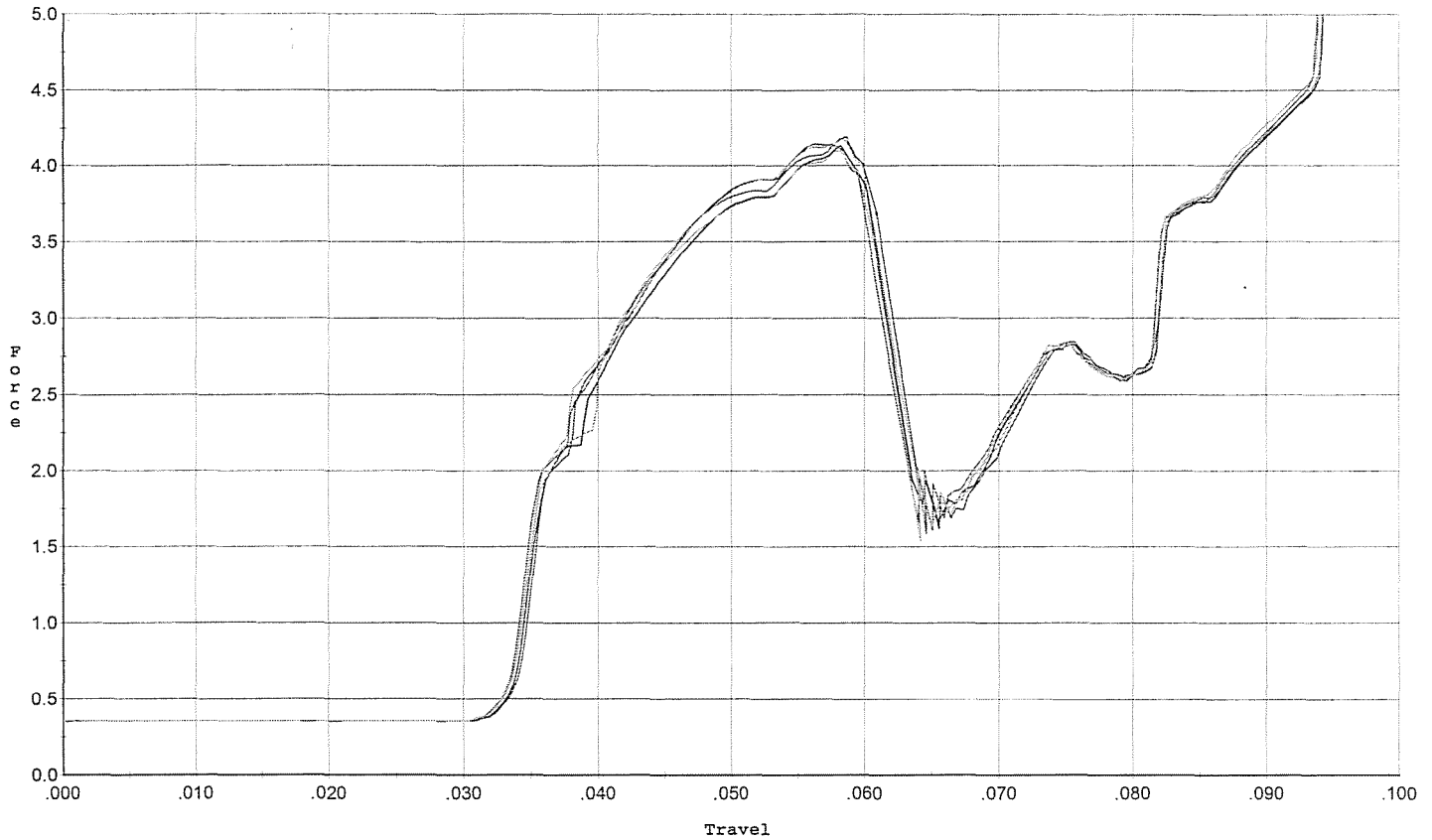
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.222	0.061	0.034	0.035	0.101		Set Trigger
2	4.215	0.062	0.033	0.035	0.105		Set Trigger
3	4.166	0.059	0.033	0.035	0.098		Set Trigger
4	4.154	0.060	0.033	0.035	0.100		Set Trigger
5	4.157	0.060	0.033	0.035	0.100		Set Trigger

Avg 4.18

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



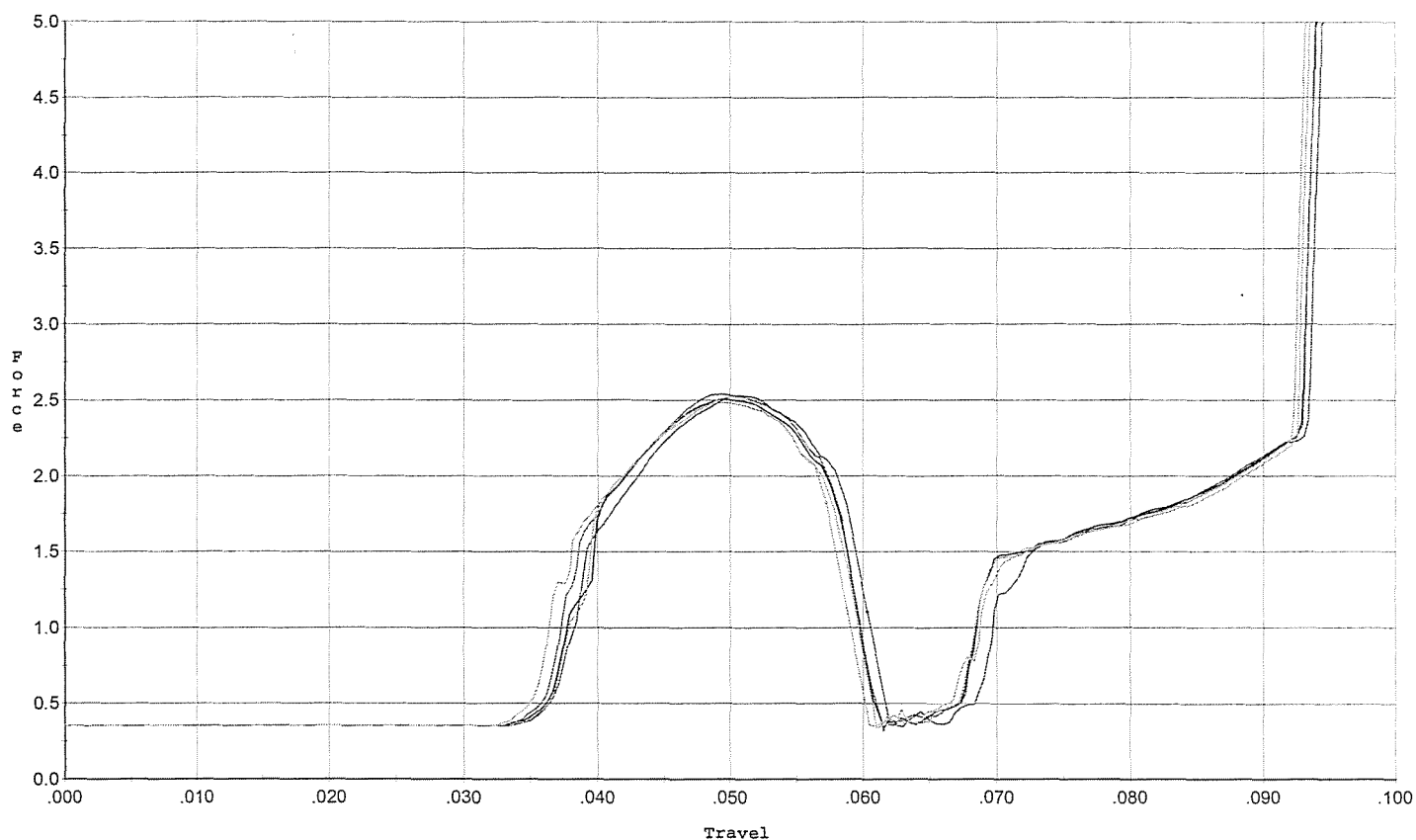
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.061	0.034	0.035	0.103		Set Trigger
2	4.135	0.060	0.034	0.035	0.099		Set Trigger
3	4.142	0.059	0.033	0.035	0.099		Set Trigger
4	4.188	0.060	0.033	0.035	0.101		Set Trigger
5	4.095	0.061	0.033	0.035	0.100		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/25/08

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



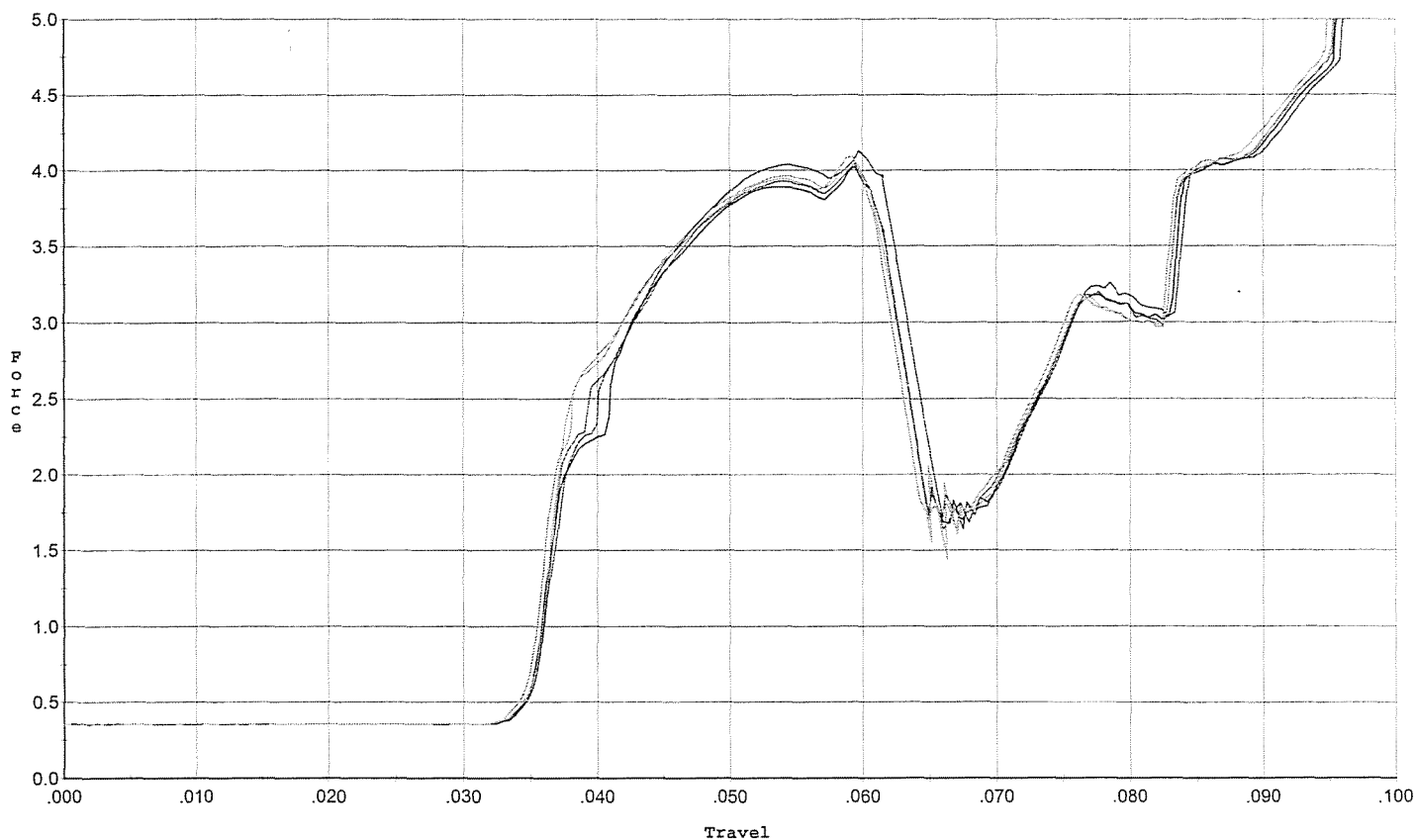
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.060	0.037	0.040	0.061		Set Trigger
2	2.504	0.058	0.037	0.040	0.058		Set Trigger
3	2.537	0.058	0.036	0.040	0.060		Set Trigger
4	2.521	0.059	0.037	0.040	0.059		Set Trigger
5	2.481	0.057	0.035	0.040	0.058		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/25/08

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	4.130	0.061	0.035	0.036	0.103		Set Trigger
2	4.024	0.062	0.035	0.036	0.100		Set Trigger
3	4.043	0.062	0.035	0.036	0.101		Set Trigger
4	4.072	0.062	0.035	0.036	0.104		Set Trigger
5	4.091	0.061	0.035	0.036	0.101		Set Trigger

Avg 4.07