

G6784672

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

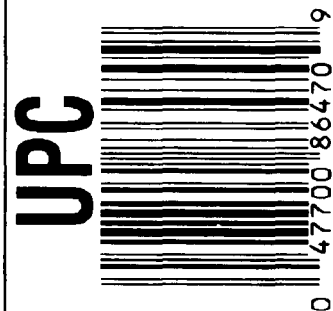


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

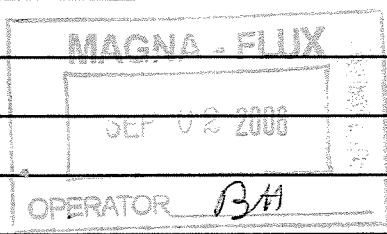
G6784672



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 678 4672

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-29-08	RTZ
420	ASSEMBLE ACTION		8-28-08	SP
430	ASSEMBLE TO STOCK		8-28-08	SP
440	PROOF		8-28-08	SP
460	CHECK HEADSPACE		8-28-08	SP
470	DIS-ASSEMBLE ACTION		8-28-08	SP
480	MAGNAFLUX BBL ACTION		9-2-08	BAH
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/3/08	RT
510	DRILL AND TAP SIGHT HOLES		8-29-08	SP
520	GOFF BLAST BBL / REC		9/4/08	DA
530 & 540	APPLY COATINGS (BARREL ACTION)		9/8	
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-16-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-16-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-16-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-25-08	ESM
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

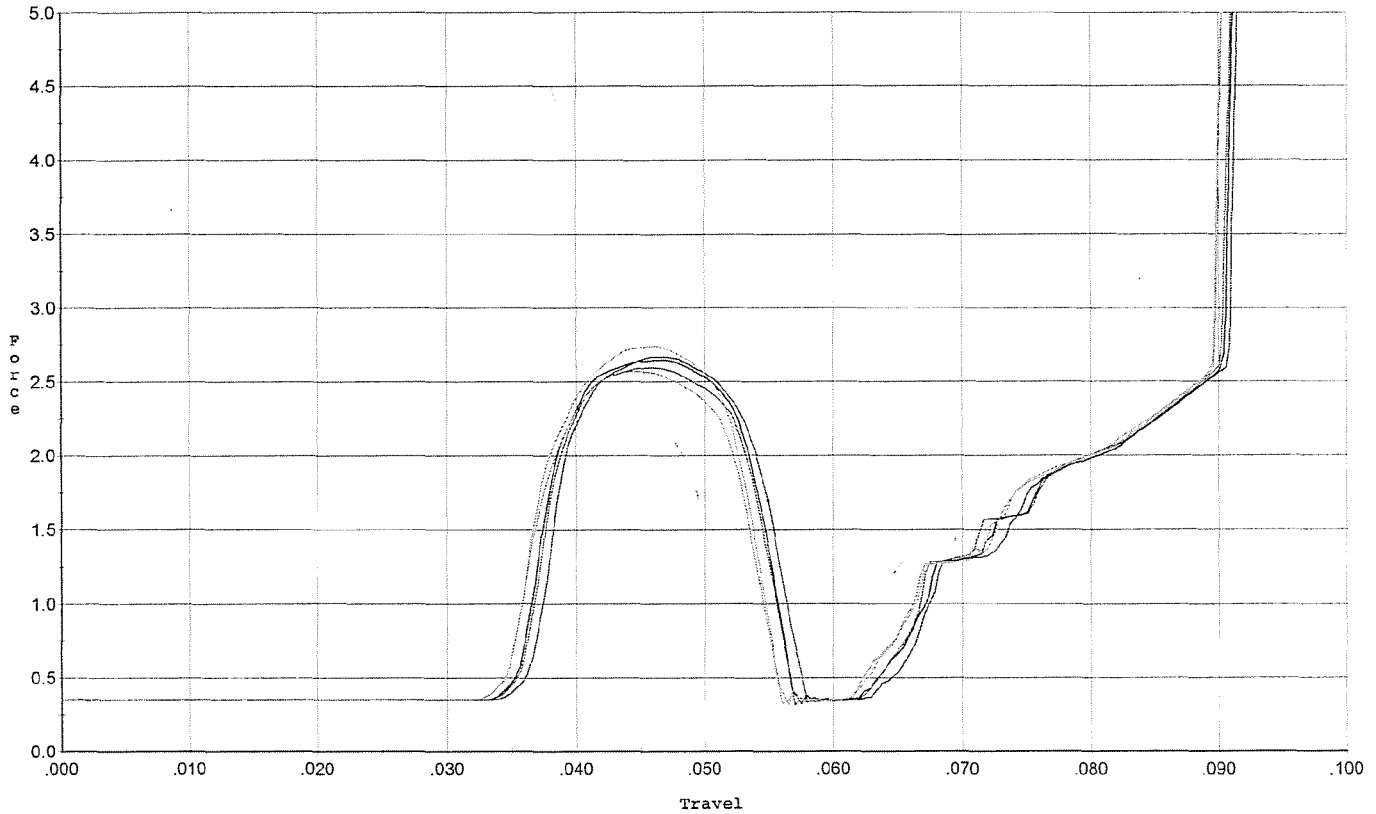
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-1-08	L.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-1-08	L.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	9-29-08	TL
	J) ASSEMBLE STOCK		9-26-08	BSN
	K) ASSEMBLE SWIVEL STUDS		9-29-08	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	9-26-08	TRC
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-26-08	L.D.
670	FINAL INSPECTION A) HEADSPACE		9-29-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.40</u> <u>2.44</u> <u>2.42</u> <u>2.44</u>	9-29-08	TL
	C) FUNCTION		9-29-08	TL
690	PACK		12-5-08	BSN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



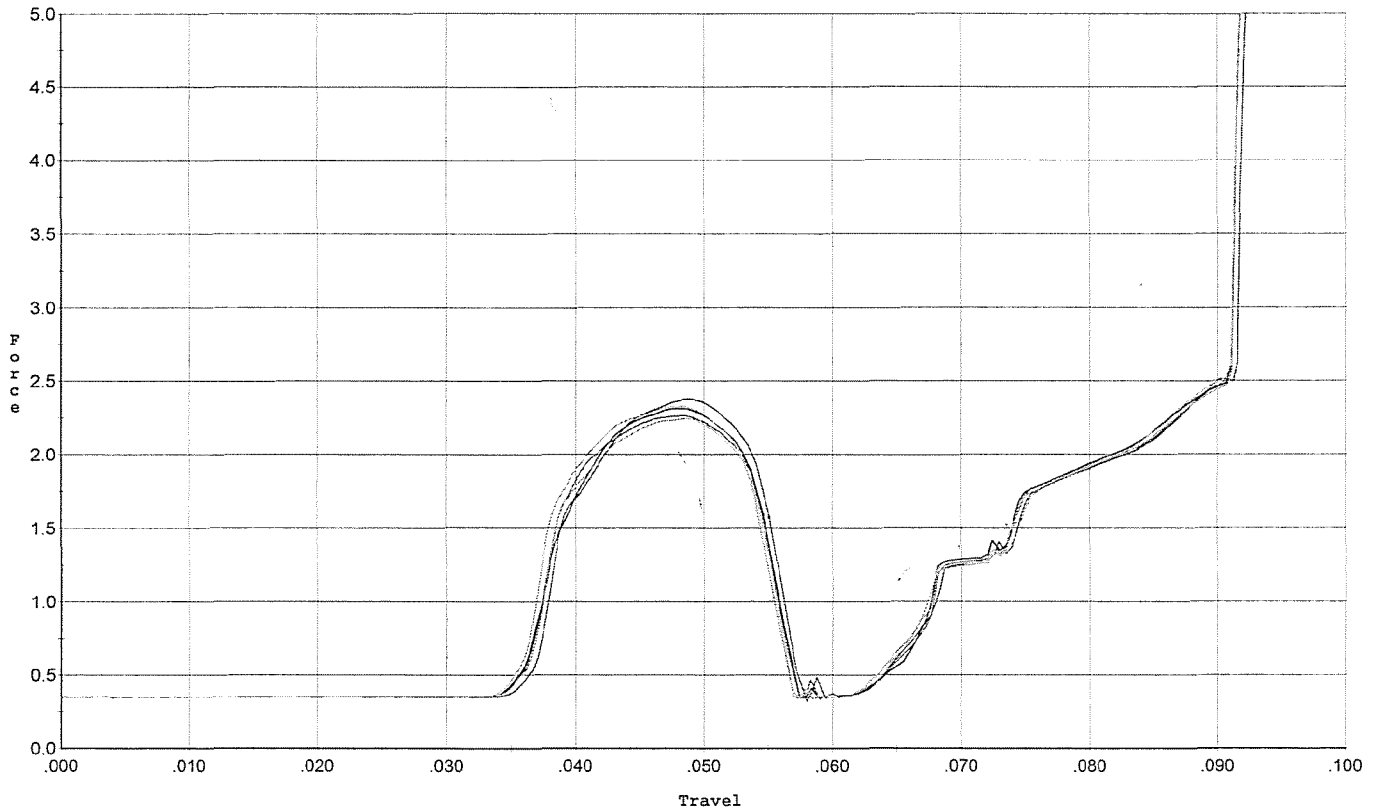
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.666	0.055	0.036	0.040	0.055		Set Trigger
2	2.646	0.055	0.036	0.040	0.056		Set Trigger
3	2.594	0.055	0.036	0.040	0.055		Set Trigger
4	2.739	0.053	0.035	0.040	0.055		Set Trigger
5	2.568	0.054	0.035	0.040	0.053		Set Trigger

Avg 2.64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



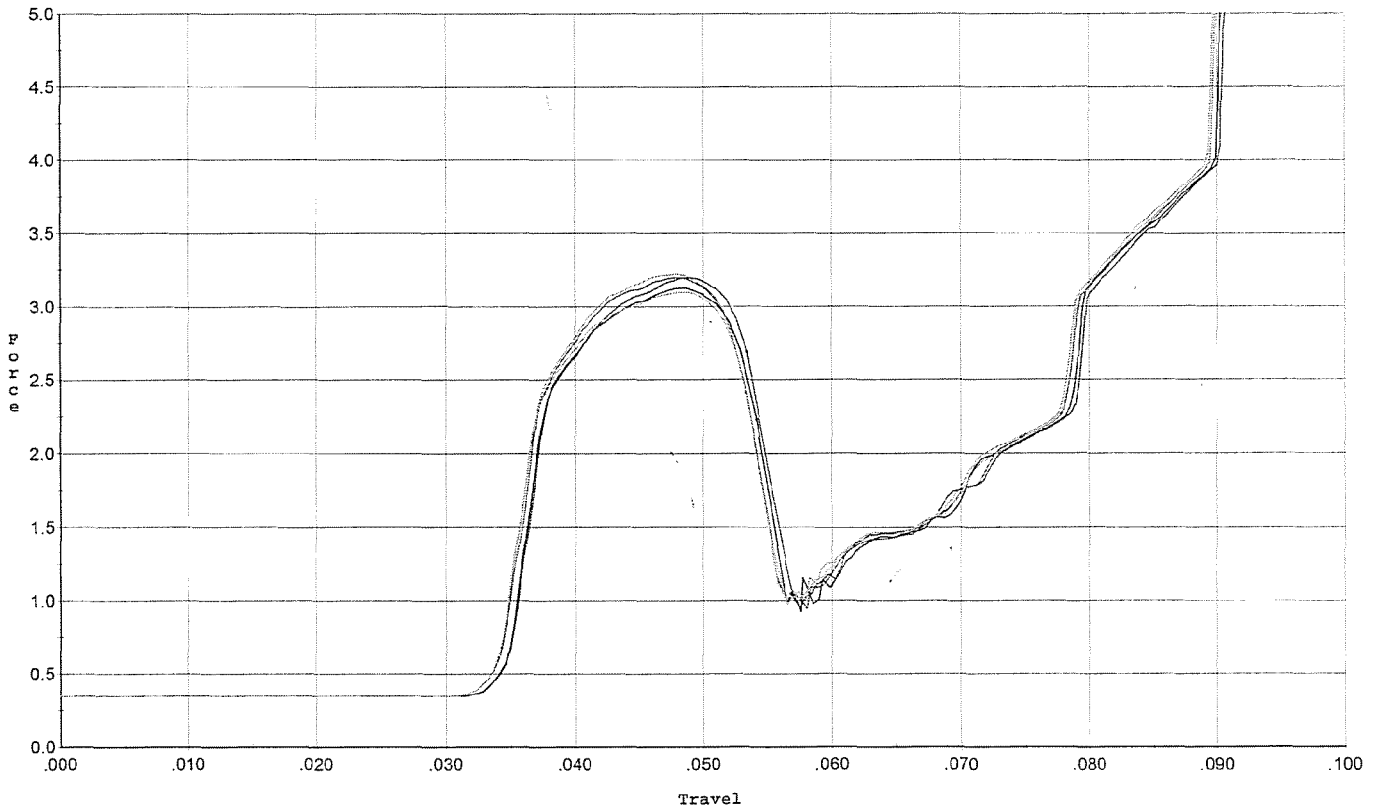
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.380	0.055	0.037	0.042	0.050		Set Trigger
2	2.313	0.055	0.036	0.042	0.049		Set Trigger
3	2.262	0.055	0.036	0.041	0.049		Set Trigger
4	2.246	0.055	0.037	0.042	0.048		Set Trigger
5	2.327	0.054	0.036	0.042	0.049		Set Trigger

Avg 2.30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



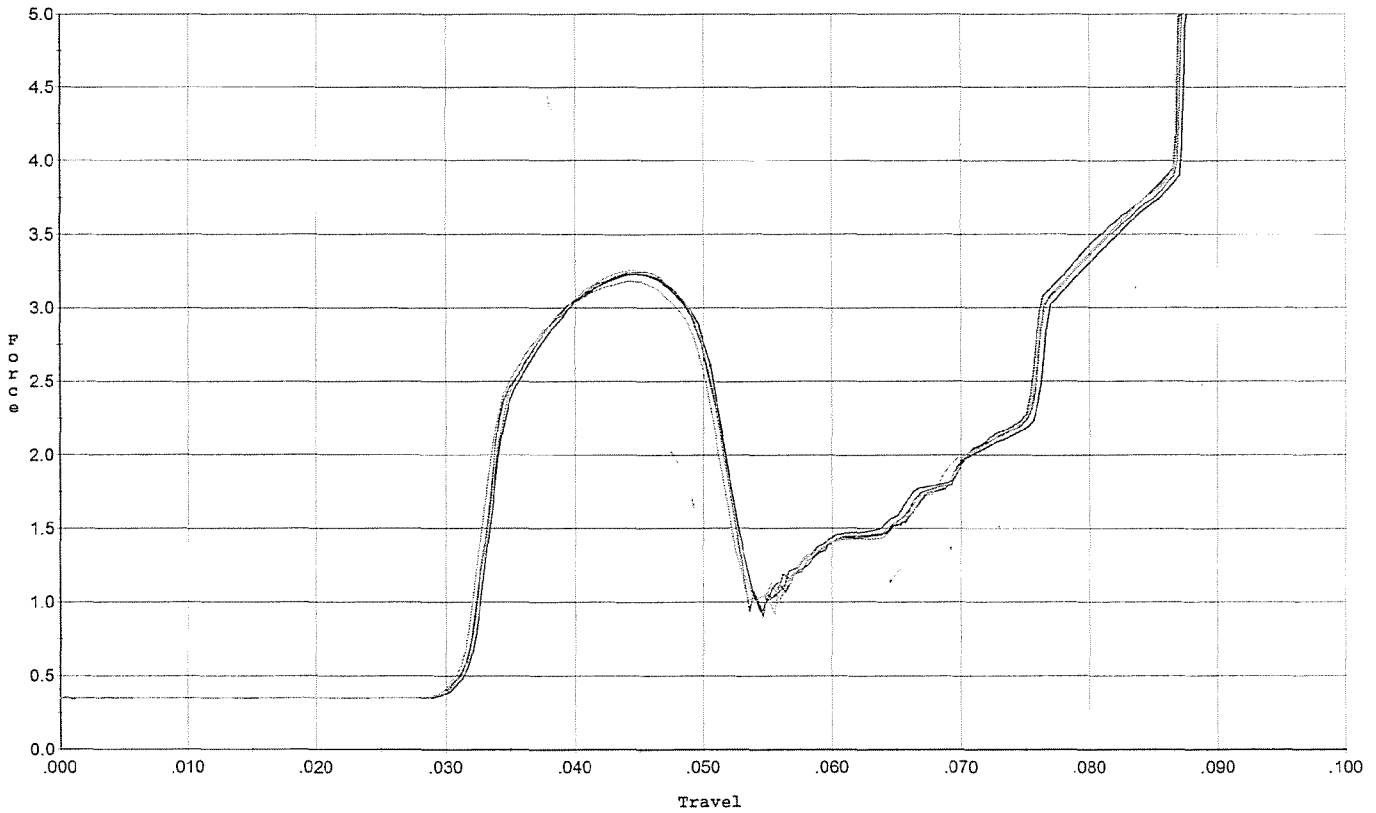
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.053	0.035	0.039	0.064		Set Trigger
2	3.126	0.054	0.035	0.039	0.064		Set Trigger
3	3.198	0.053	0.034	0.039	0.065		Set Trigger
4	3.101	0.053	0.034	0.039	0.064		Set Trigger
5	3.219	0.053	0.034	0.039	0.065		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



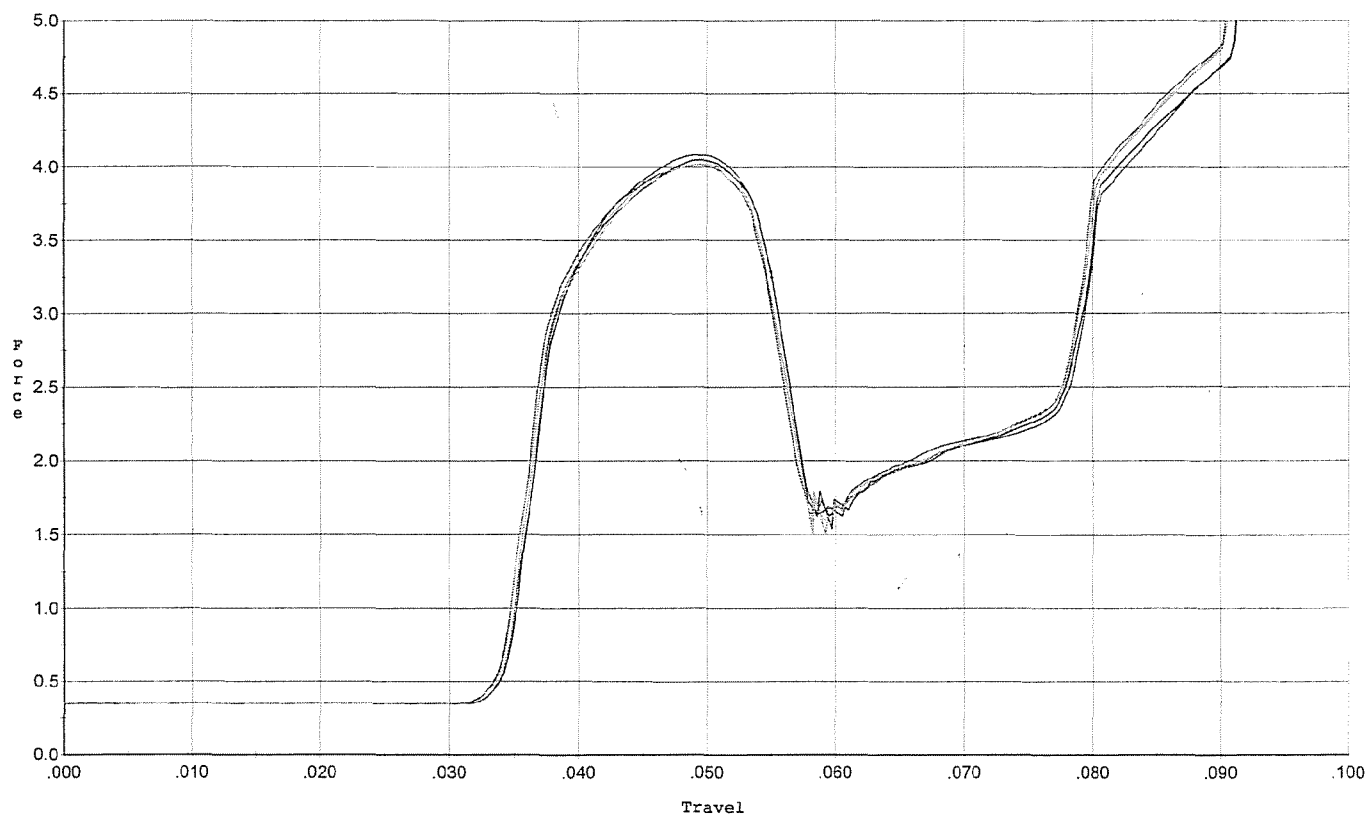
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.228	0.051	0.032	0.038	0.065		Set Trigger
2	3.232	0.051	0.032	0.039	0.063		Set Trigger
3	3.247	0.051	0.031	0.038	0.065		Set Trigger
4	3.261	0.051	0.032	0.038	0.064		Set Trigger
5	3.180	0.050	0.031	0.038	0.063		Set Trigger

AVG 3.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/19/08

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



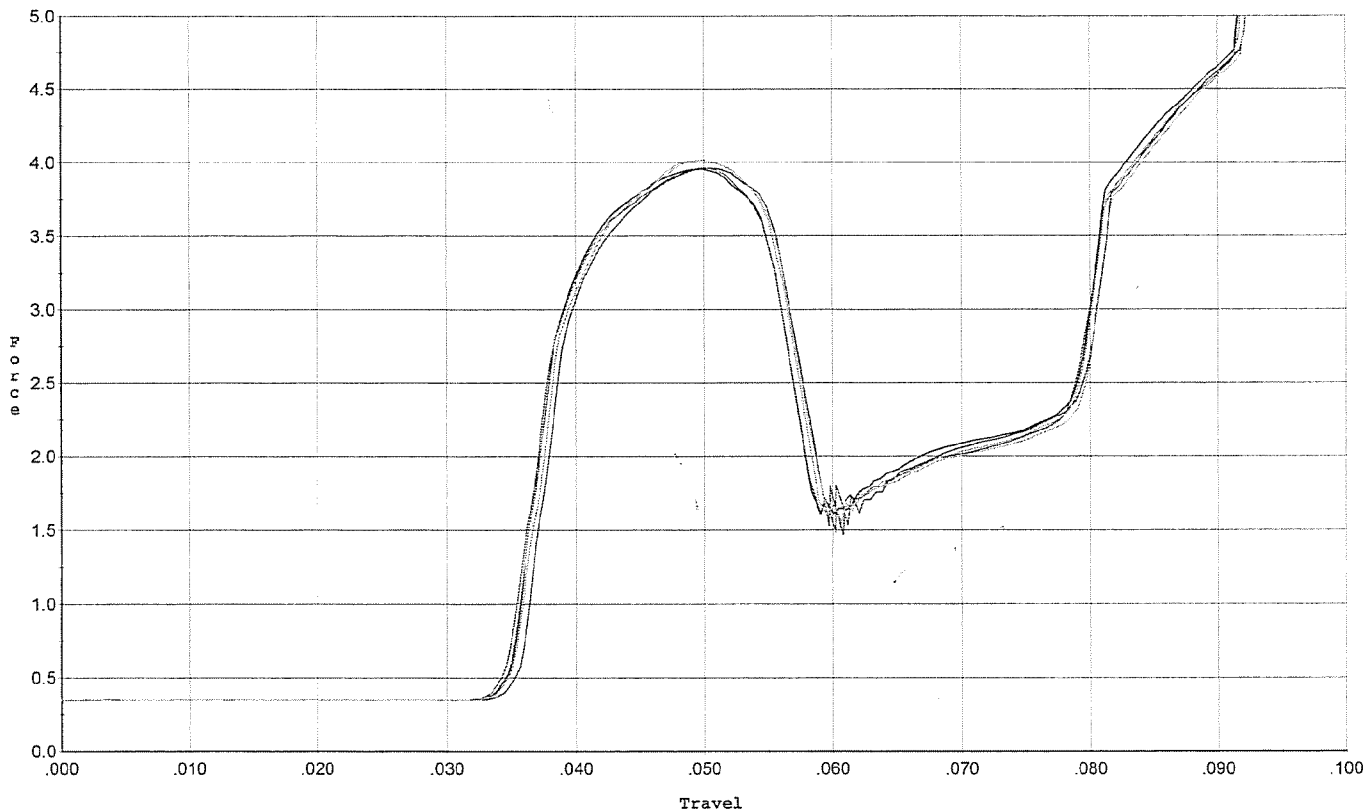
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.080	0.055	0.034	0.037	0.084		Set Trigger
2	4.048	0.055	0.034	0.037	0.083		Set Trigger
3	4.017	0.054	0.034	0.037	0.083		Set Trigger
4	4.015	0.056	0.034	0.037	0.085		Set Trigger
5	4.020	0.054	0.034	0.037	0.082		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



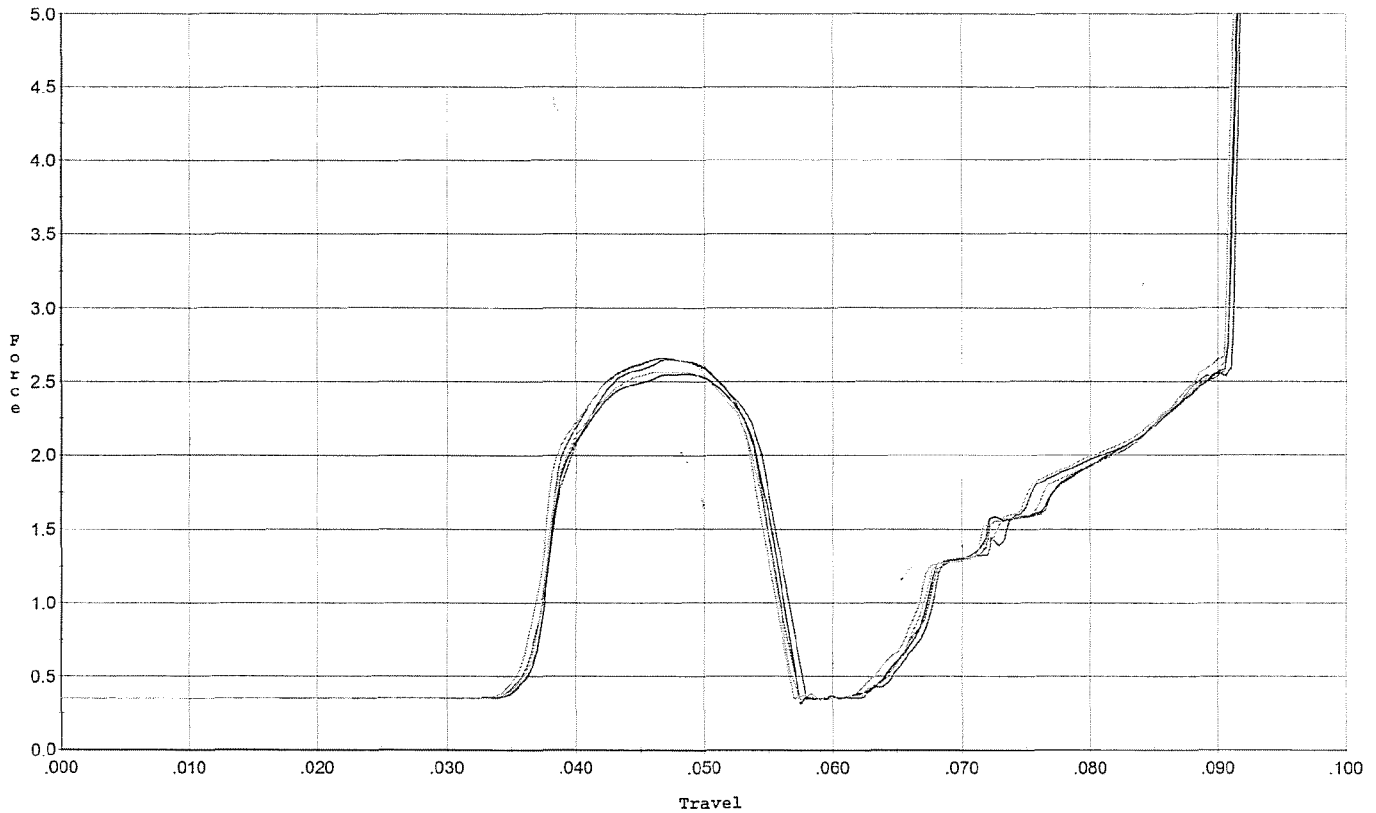
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.962	0.058	0.036	0.038	0.085		Set Trigger
2	3.955	0.056	0.035	0.038	0.083		Set Trigger
3	3.964	0.056	0.035	0.037	0.083		Set Trigger
4	4.004	0.056	0.035	0.038	0.084		Set Trigger
5	4.014	0.056	0.035	0.037	0.085		Set Trigger

Avg 3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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



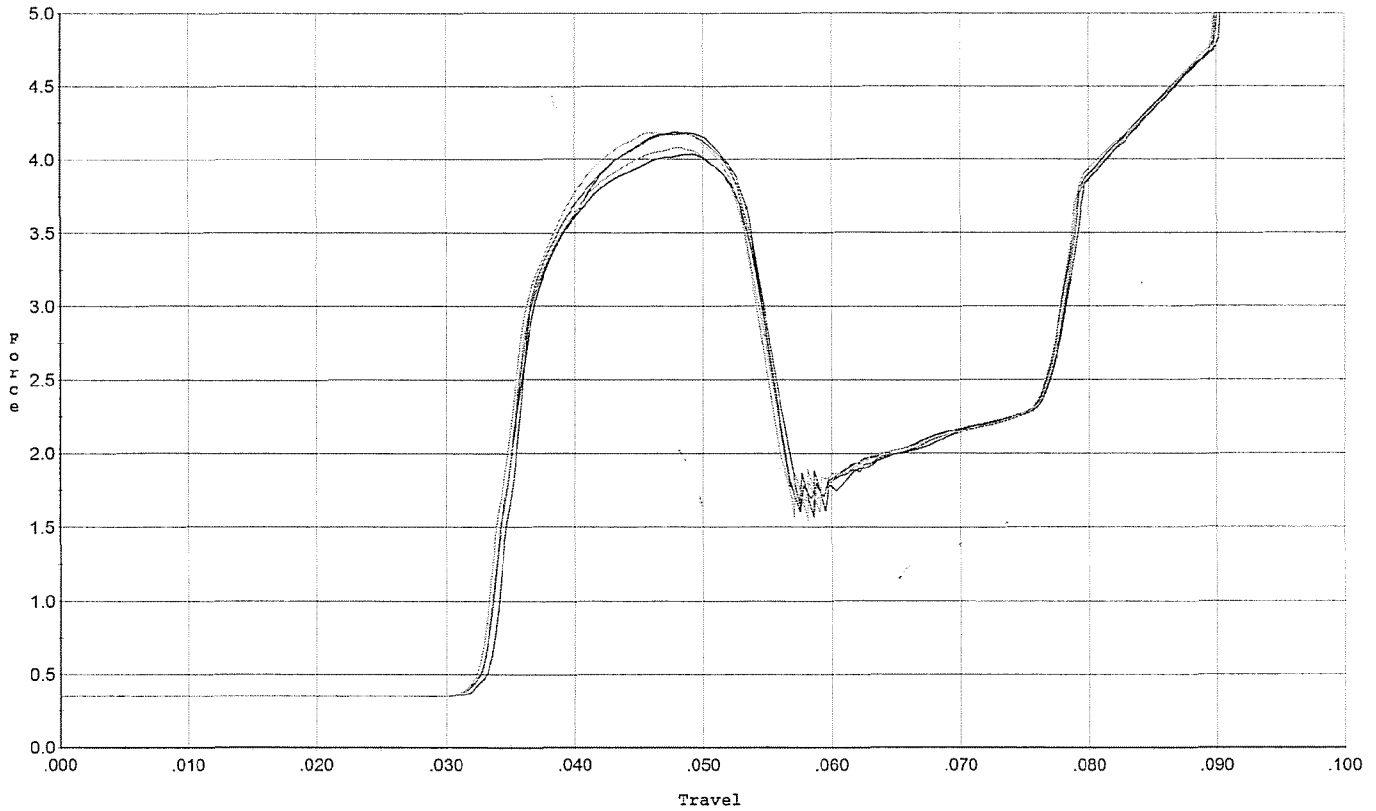
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.653	0.054	0.037	0.041	0.054		Set Trigger
2	2.550	0.055	0.037	0.041	0.054		Set Trigger
3	2.656	0.054	0.036	0.041	0.054		Set Trigger
4	2.566	0.054	0.037	0.041	0.053		Set Trigger
5	2.646	0.053	0.036	0.041	0.053		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/19/08

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	4.184	0.053	0.033	0.037	0.085		Set Trigger
2	4.036	0.054	0.033	0.036	0.085		Set Trigger
3	4.173	0.054	0.033	0.036	0.087		Set Trigger
4	4.188	0.053	0.033	0.036	0.086		Set Trigger
5	4.080	0.055	0.033	0.036	0.087		Set Trigger

Aug 4.13