

G678 4704

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM) 9
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



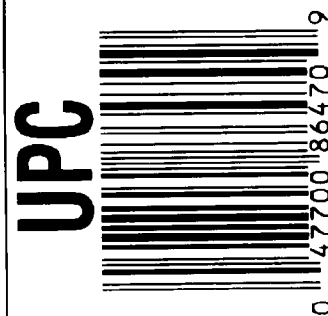
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6784704



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6784704

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SPD
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SPD
460	CHECK HEADSPACE		9-19-08	SPD
470	DIS-ASSEMBLE ACTION		9-19-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX SEP 20 2008	9-20-08	SP
475	DRILL AND TAP SIGHT HOLES		9-20-08	JP
480	MAGNAFLUX BBL ACTION	OPERATOR BHT	9-22-08	BA
490	MAGNAFLUX BOLT		9/22/08	MR
500	ROLLMARK CALIBER		9/22/08	RT
520	GOFF BLAST BBL / REC		9/23/08	DG
542	APPLY COATINGS (BARREL ACTION)		9-24-08	u
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-16-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

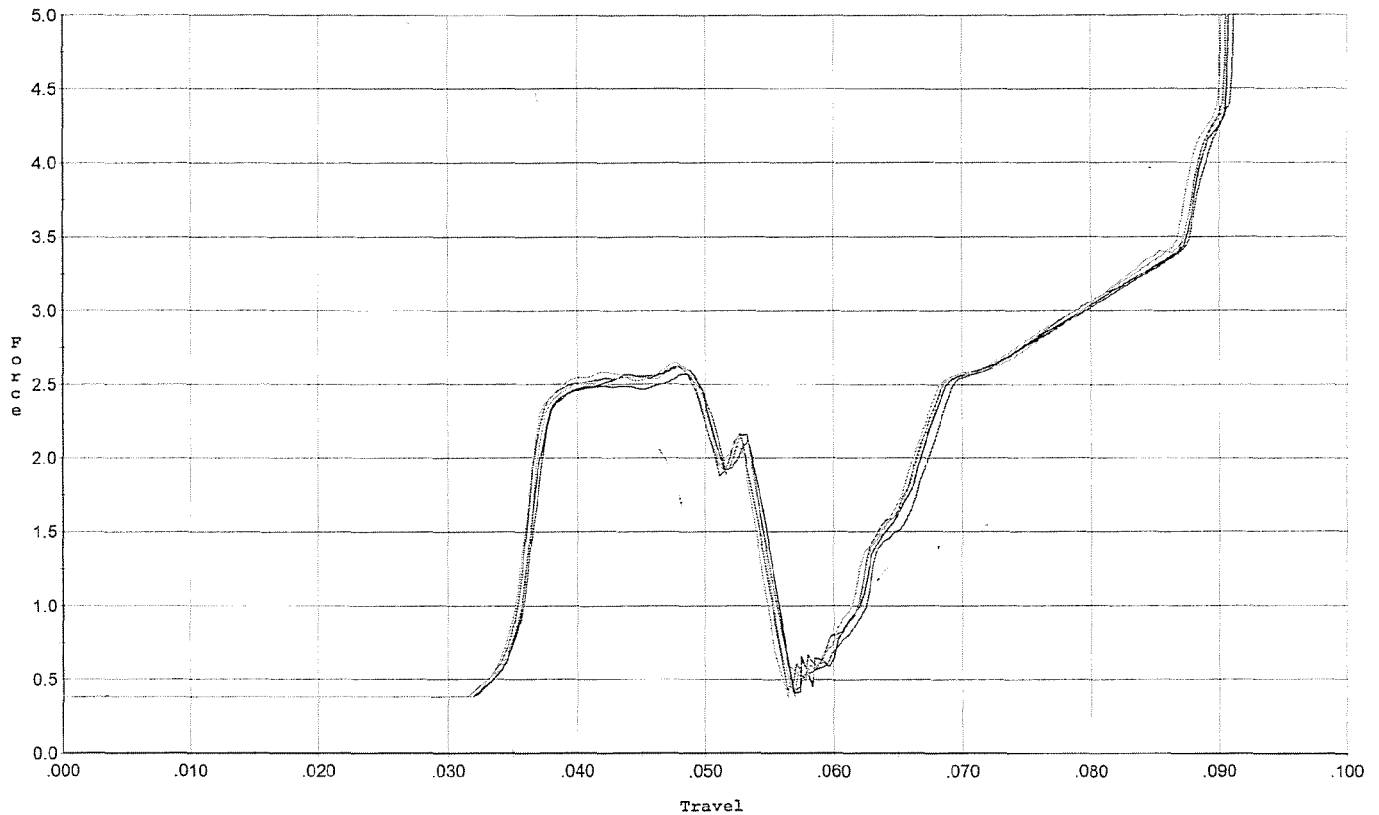
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>35</u> <u>35</u> <u>35</u>	12-8-08	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	12-8-08	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	12-8-08	LH
	J) ASSEMBLE STOCK		10-16-08	PPD
	K) ASSEMBLE SWIVEL STUDS		12-8-08	LH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	11-24-08	TL
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-24-08	JS
670	FINAL INSPECTION A) HEADSPACE		12-8-08	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>269</u> <u>263</u> <u>274</u> <u>267</u> <u>273</u>	12-8-08	LH
	C) FUNCTION		12-8-08	LH
690	PACK		1-13-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/11/08

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



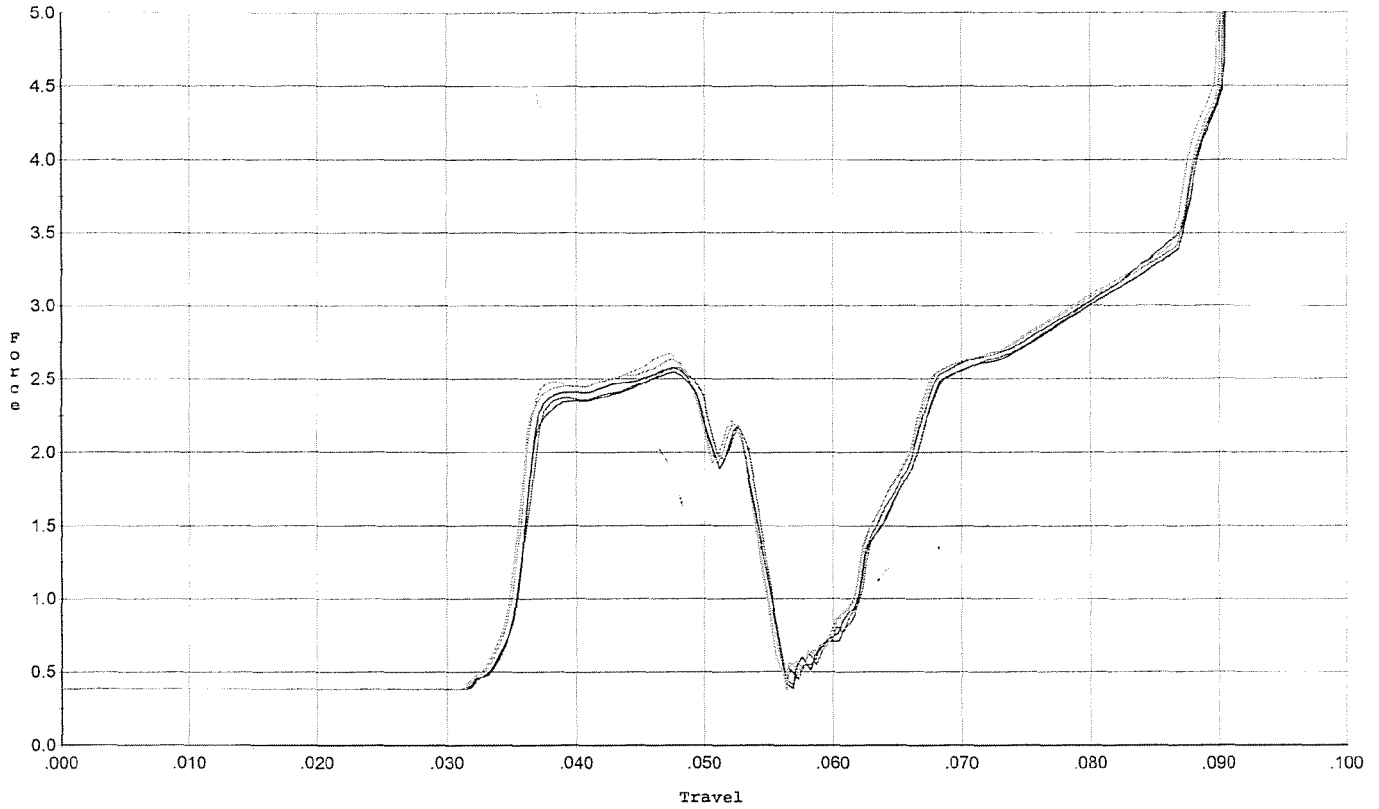
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.570	0.053	0.035	0.040	0.055		Set Trigger
2	2.632	0.055	0.035	0.040	0.058		Set Trigger
3	2.620	0.054	0.034	0.040	0.058		Set Trigger
4	2.627	0.053	0.035	0.040	0.056		Set Trigger
5	2.647	0.053	0.034	0.040	0.056		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/11/08

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



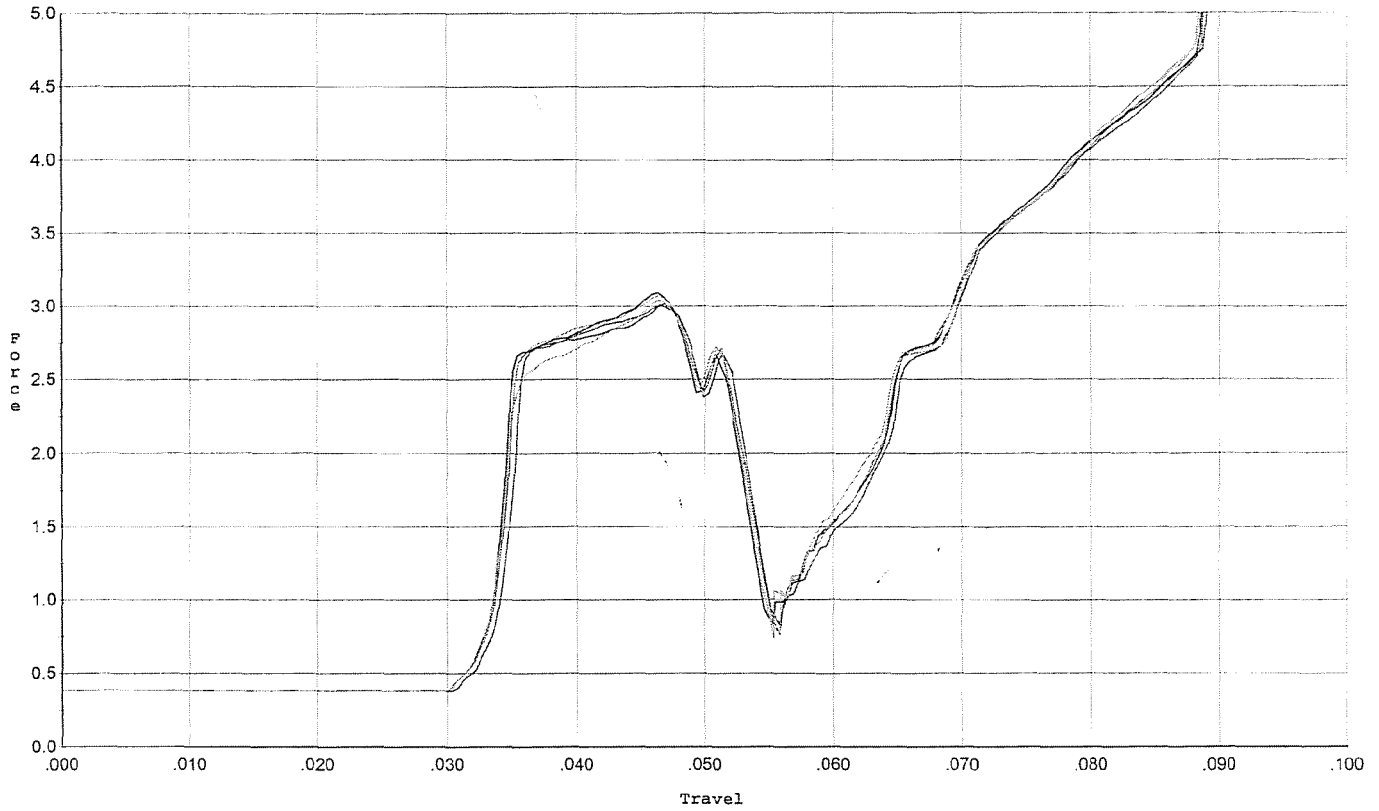
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.054	0.034	0.040	0.056		Set Trigger
2	2.577	0.054	0.034	0.040	0.057		Set Trigger
3	2.575	0.053	0.034	0.040	0.056		Set Trigger
4	2.676	0.053	0.032	0.040	0.057		Set Trigger
5	2.636	0.053	0.034	0.040	0.056		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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



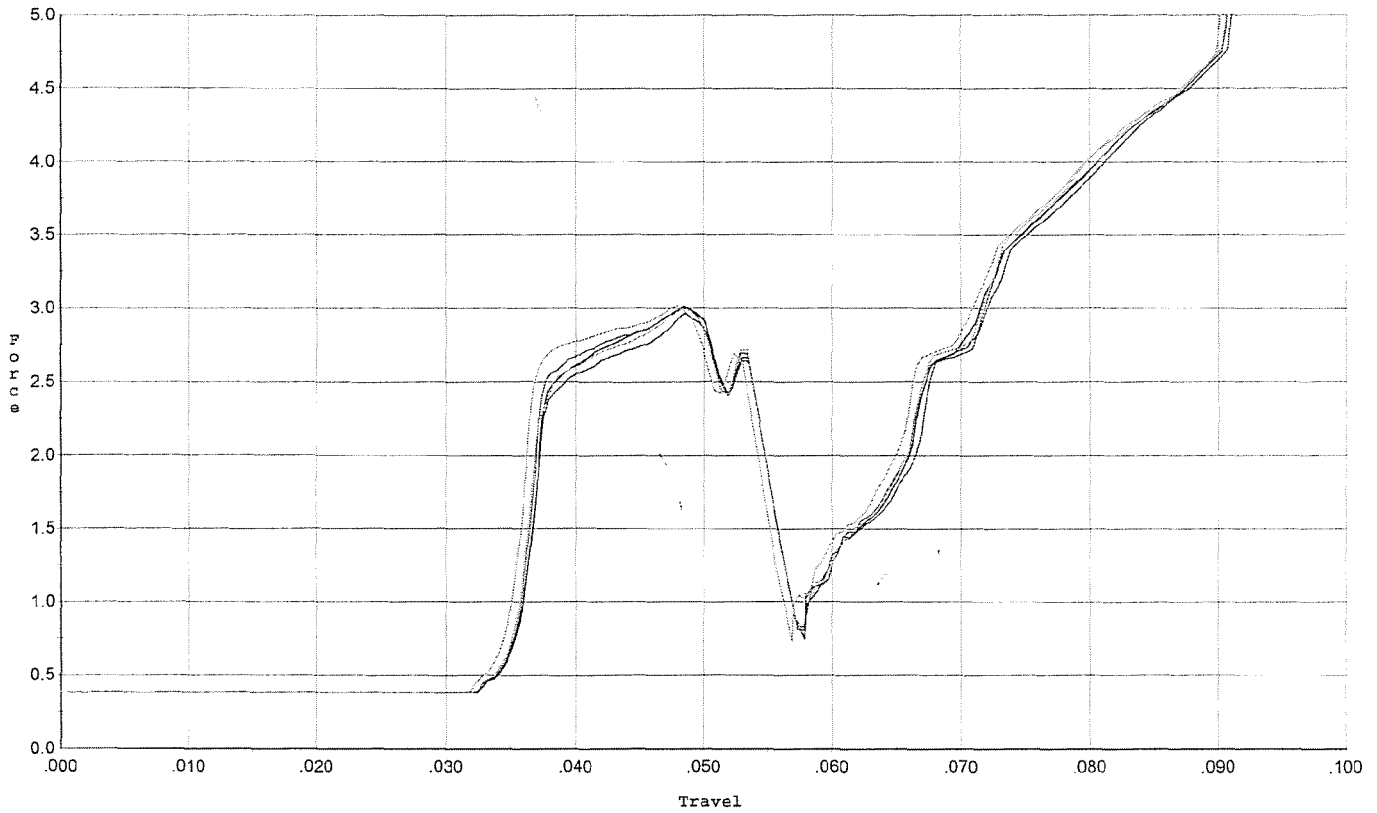
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.017	0.052	0.033	0.038	0.063		Set Trigger
2	3.094	0.052	0.032	0.039	0.064		Set Trigger
3	3.007	0.053	0.031	0.038	0.065		Set Trigger
4	3.042	0.051	0.031	0.038	0.062		Set Trigger
5	3.072	0.051	0.031	0.038	0.063		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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



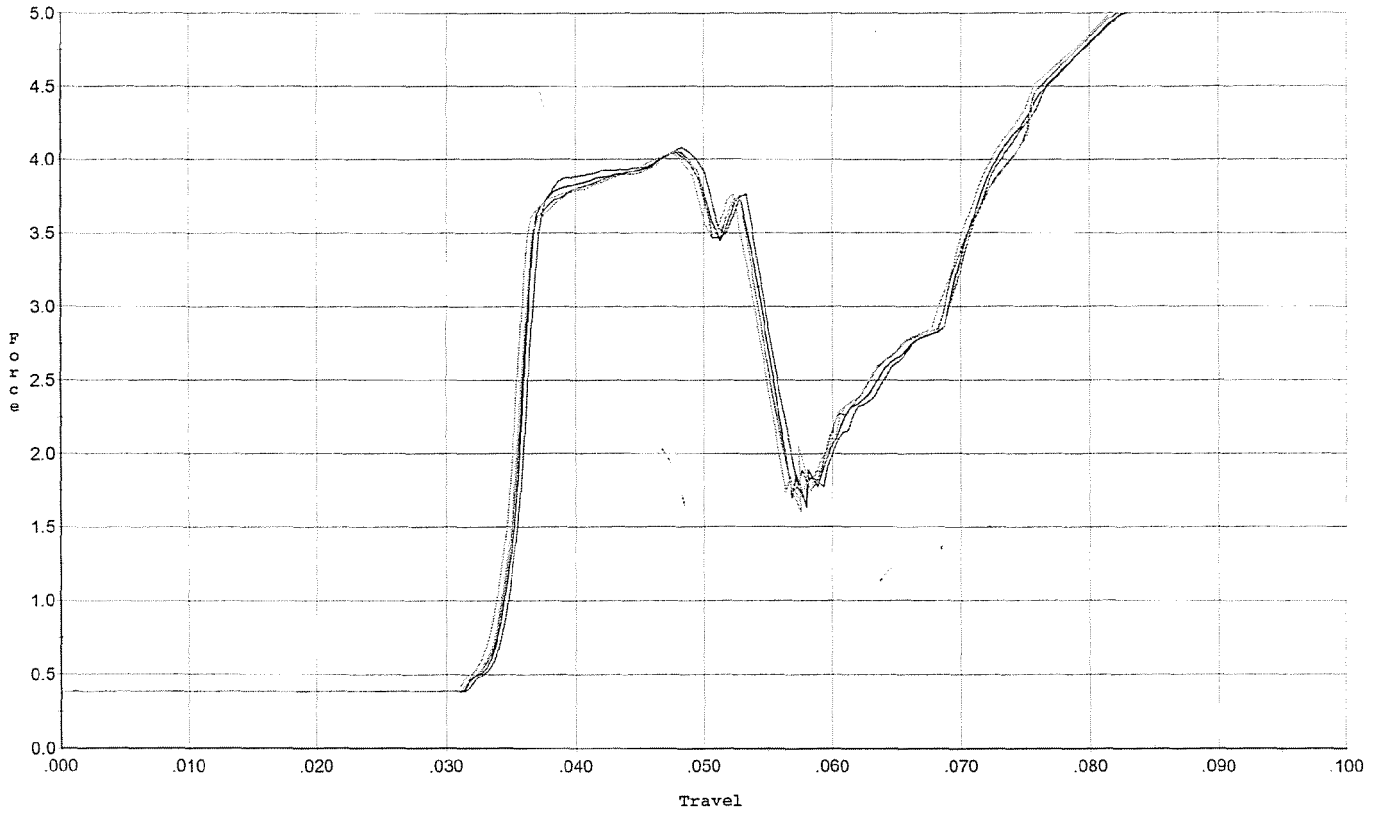
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.964	0.053	0.033	0.039	0.061		Set Trigger
2	3.009	0.053	0.035	0.039	0.062		Set Trigger
3	2.996	0.053	0.033	0.039	0.063		Set Trigger
4	2.994	0.053	0.033	0.039	0.062		Set Trigger
5	3.016	0.053	0.032	0.038	0.064		Set Trigger

Aug 299

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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



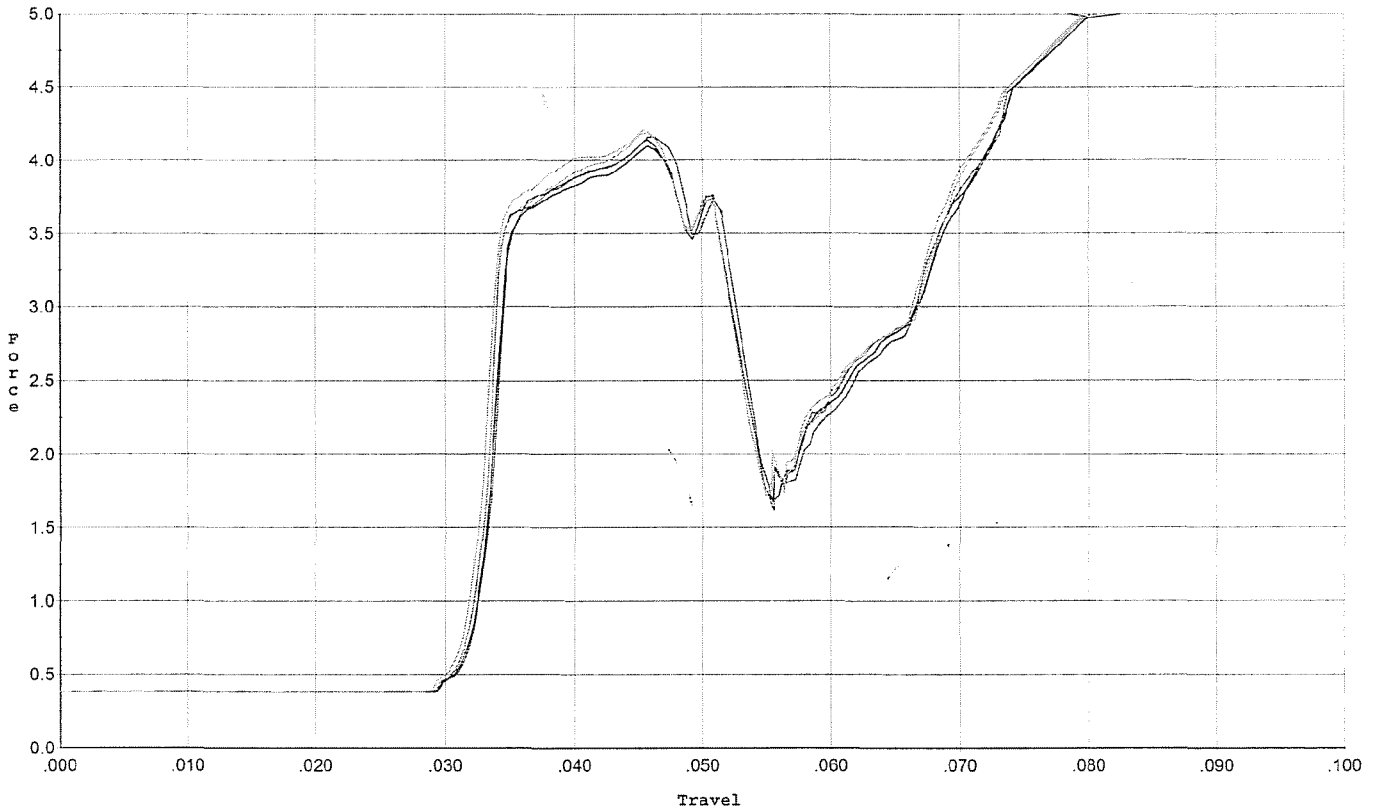
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.081	0.053	0.032	0.037	0.084		Set Trigger
2	4.055	0.054	0.032	0.036	0.086		Set Trigger
3	4.047	0.053	0.032	0.036	0.083		Set Trigger
4	4.059	0.053	0.033	0.036	0.083		Set Trigger
5	4.045	0.054	0.031	0.036	0.086		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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



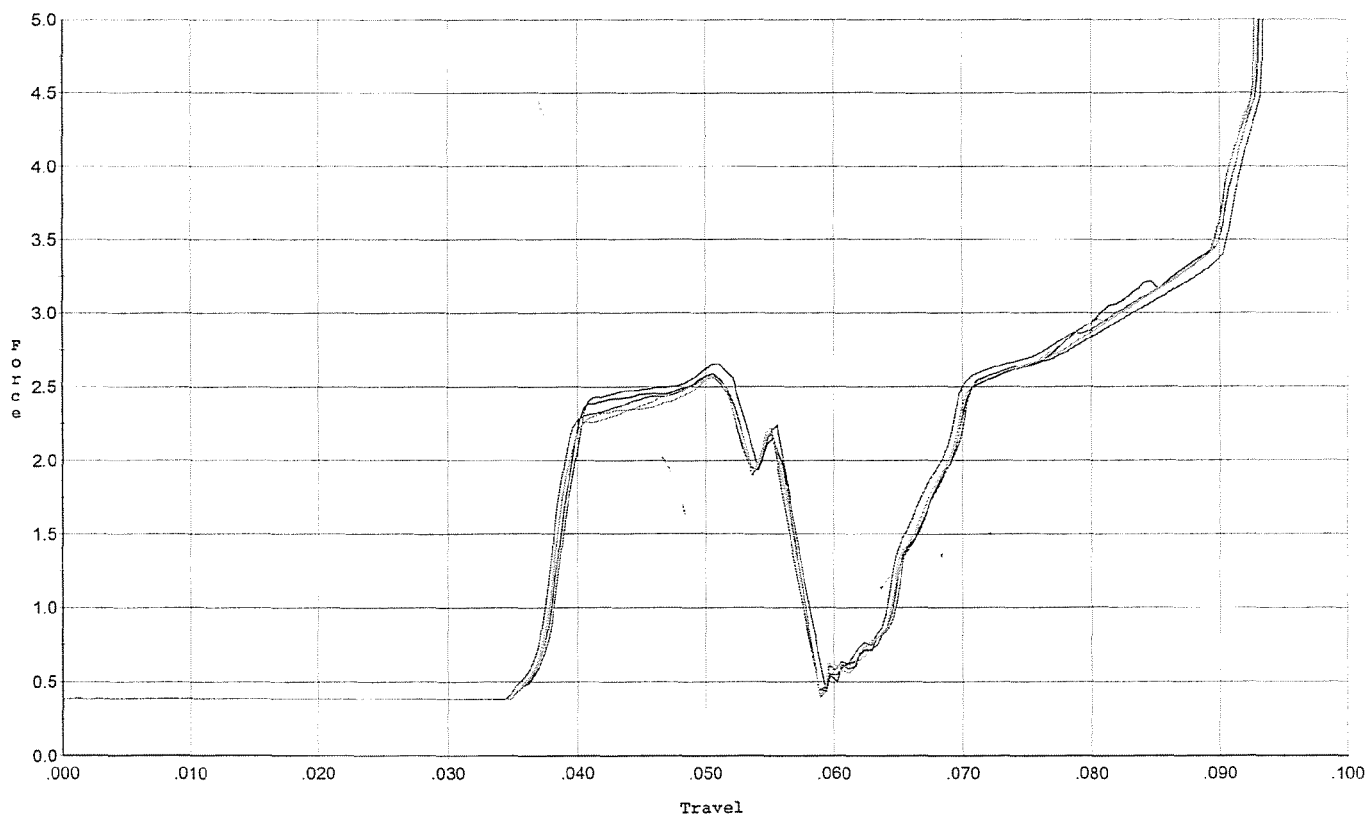
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.160	0.051	0.030	0.035	0.084		Set Trigger
2	4.099	0.051	0.030	0.036	0.081		Set Trigger
3	4.139	0.051	0.031	0.035	0.083		Set Trigger
4	4.188	0.051	0.031	0.035	0.083		Set Trigger
5	4.211	0.051	0.029	0.035	0.085		Set Trigger

Aug 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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



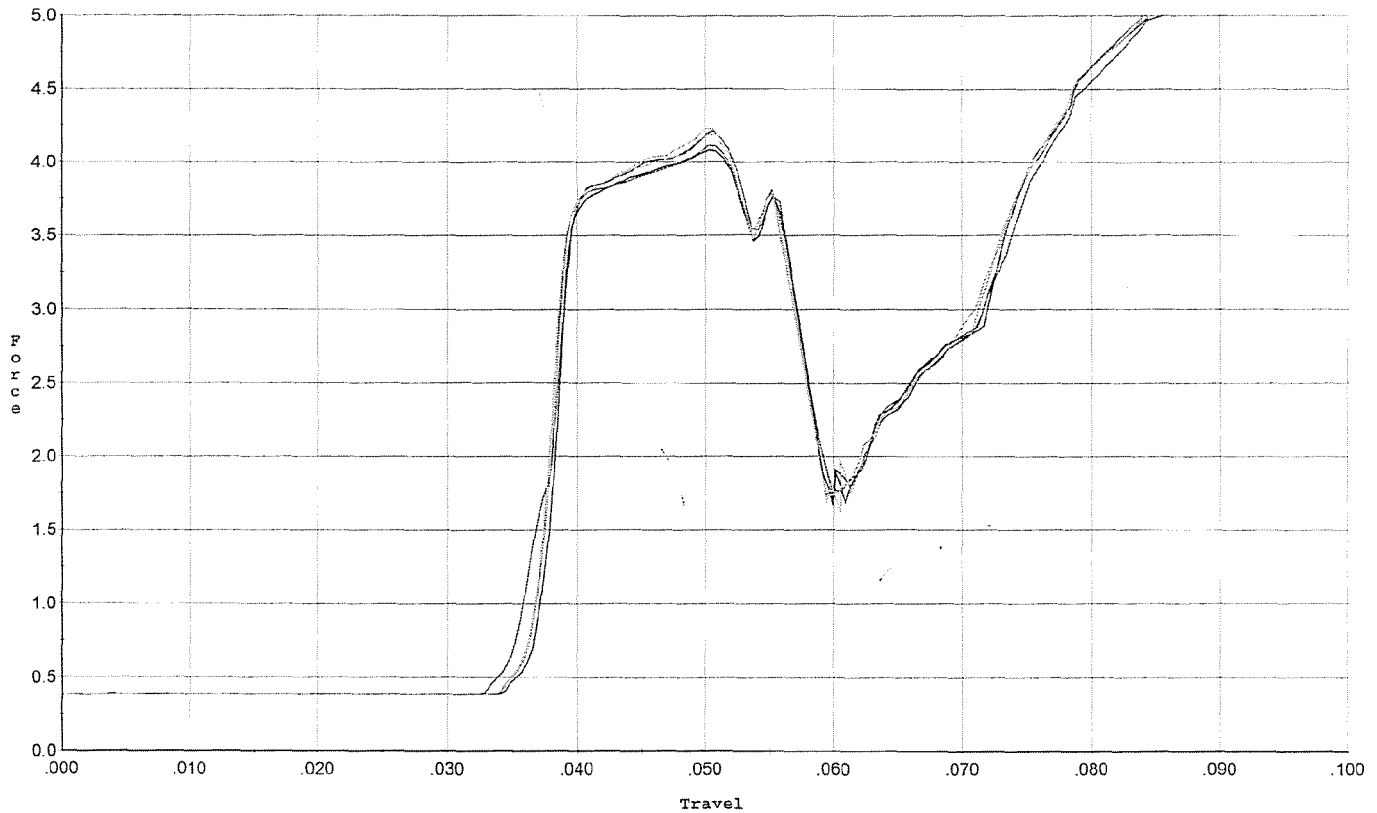
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.056	0.037	0.040	0.057		Set Trigger
2	2.591	0.056	0.037	0.040	0.057		Set Trigger
3	2.579	0.055	0.035	0.041	0.056		Set Trigger
4	2.564	0.056	0.037	0.040	0.057		Set Trigger
5	2.573	0.056	0.037	0.040	0.057		Set Trigger

Avg 2.579

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/11/08

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	4.212	0.056	0.033	0.038	0.088		Set Trigger
2	4.084	0.056	0.035	0.038	0.086		Set Trigger
3	4.114	0.056	0.036	0.038	0.087		Set Trigger
4	4.190	0.057	0.036	0.038	0.088		Set Trigger
5	4.230	0.057	0.034	0.037	0.090		Set Trigger

Avg 4.16