

66784705

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

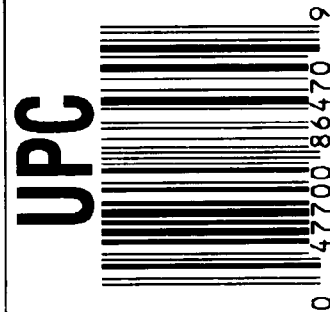


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6784705



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6784705

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-25-08	S.P.D.
430	ASSEMBLE TO STOCK		8-25-08	SP
440	PROOF		8-25-08	S.P.D.
460	CHECK HEADSPACE		8-25-08	S.P.D.
470	DIS-ASSEMBLE ACTION		8-25-08	S.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-26-08	BN
475	DRILL AND TAP SIGHT HOLES	AUG 28 2008	8-26-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BN	8-28-08	BN
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/28/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8/31	c
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-6-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-6-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-6-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-11-08	S.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

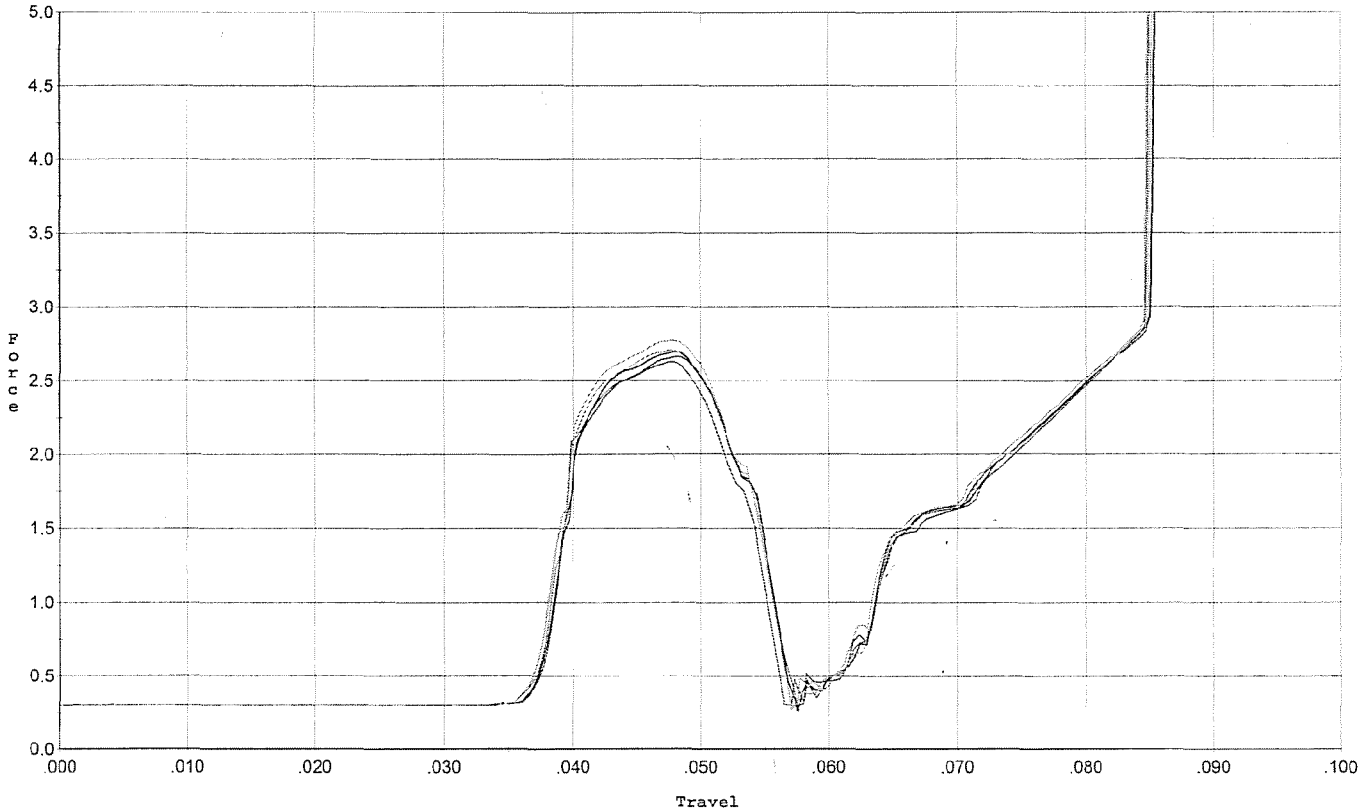
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	9-18-08	TC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5</u> <u>4.5</u> <u>4.5</u>	9-18-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.026</u> <u>.025</u>	9-18-08	TC
	J) ASSEMBLE STOCK		9-11-08	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		9-18-08	TC
	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	9-12-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-12-08	FM
670	FINAL INSPECTION A) HEADSPACE		9-18-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.17</u> <u>2.04</u> <u>2.05</u> <u>2.46</u>	9-16-08	TRW
	C) FUNCTION		9-18-08	TC
690	PACK		10/14/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



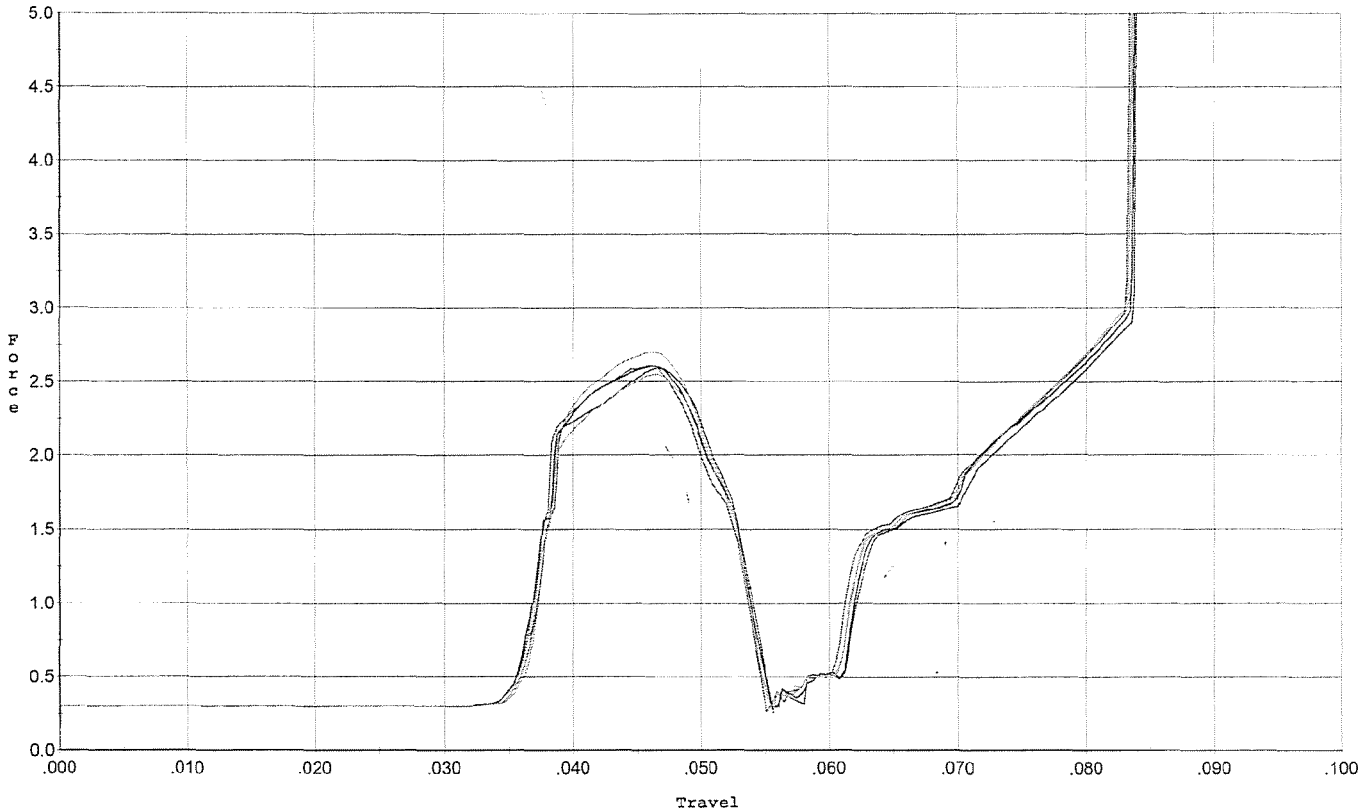
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.054	0.037	0.037	0.049		Set Trigger
2	2.696	0.054	0.037	0.037	0.049		Set Trigger
3	2.625	0.054	0.037	0.037	0.048		Set Trigger
4	2.770	0.055	0.037	0.037	0.051		Set Trigger
5	2.707	0.055	0.037	0.037	0.050		Set Trigger

Avg 2.69

Trigger Profile [lbs,inch]

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

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



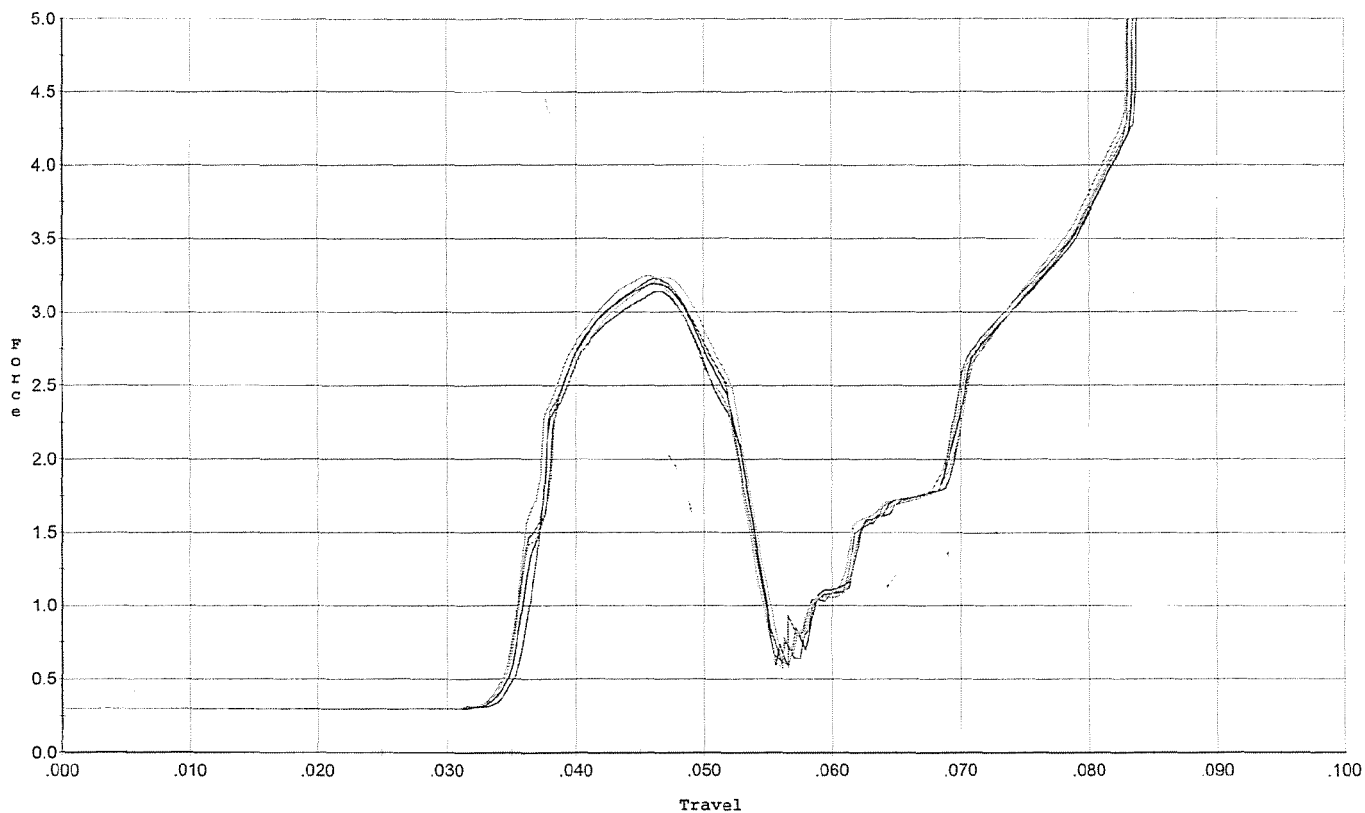
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.054	0.036	0.037	0.048		Set Trigger
2	2.605	0.053	0.036	0.037	0.047		Set Trigger
3	2.612	0.053	0.036	0.037	0.047		Set Trigger
4	2.548	0.053	0.036	0.037	0.046		Set Trigger
5	2.703	0.053	0.036	0.037	0.047		Set Trigger

AVG 2.61

Trigger Profile [lbs,inch]

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

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



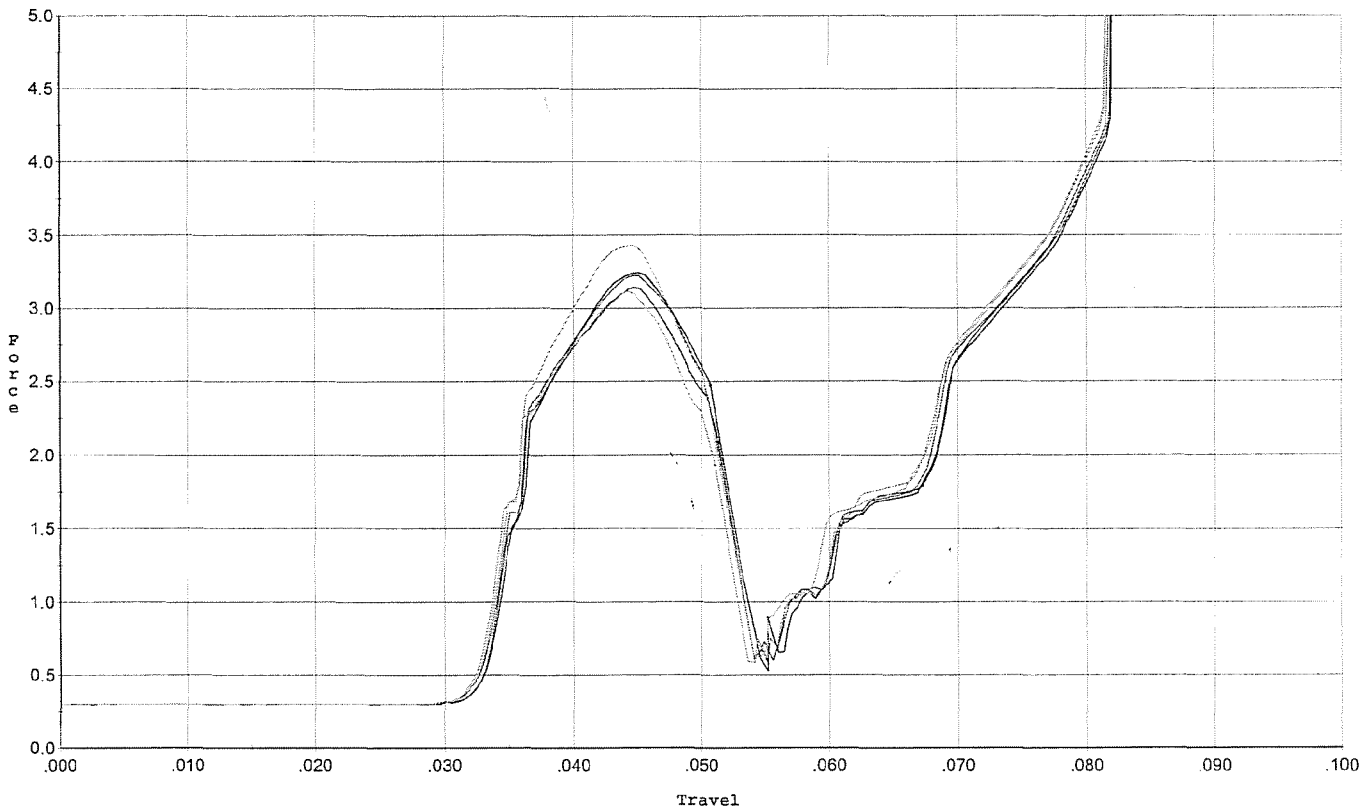
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.141	0.053	0.035	0.036	0.056		Set Trigger
2	3.196	0.053	0.035	0.036	0.057		Set Trigger
3	3.228	0.052	0.034	0.035	0.056		Set Trigger
4	3.239	0.052	0.034	0.036	0.057		Set Trigger
5	3.252	0.052	0.034	0.035	0.057		Set Trigger

Avg 3.21

Trigger Profile [lbs,inch]

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

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



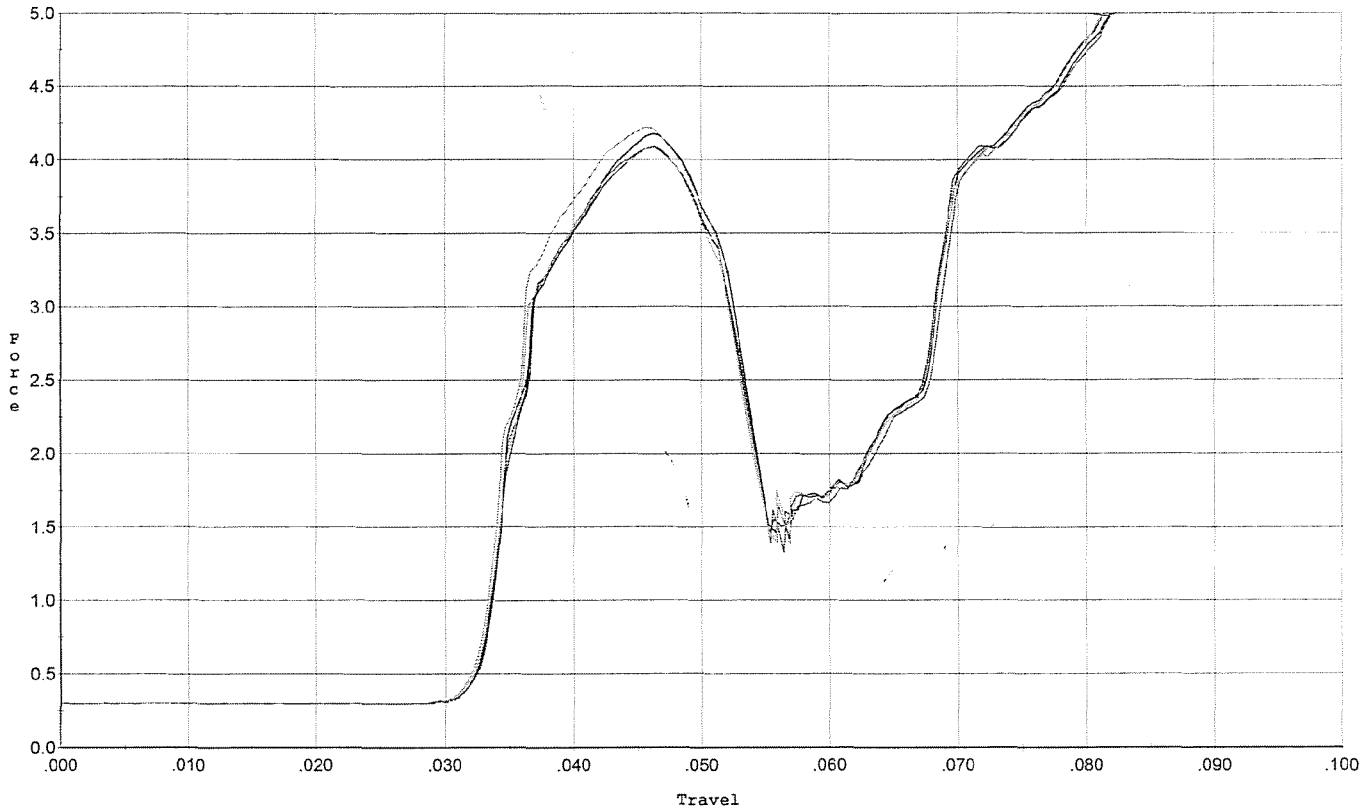
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.143	0.051	0.033	0.035	0.056		Set Trigger
2	3.245	0.051	0.033	0.035	0.056		Set Trigger
3	3.223	0.052	0.033	0.035	0.057		Set Trigger
4	3.427	0.052	0.033	0.034	0.060		Set Trigger
5	3.117	0.051	0.033	0.035	0.055		Set Trigger

Avg (4.23) RP
3.23

Trigger Profile [lbs,inch]

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

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



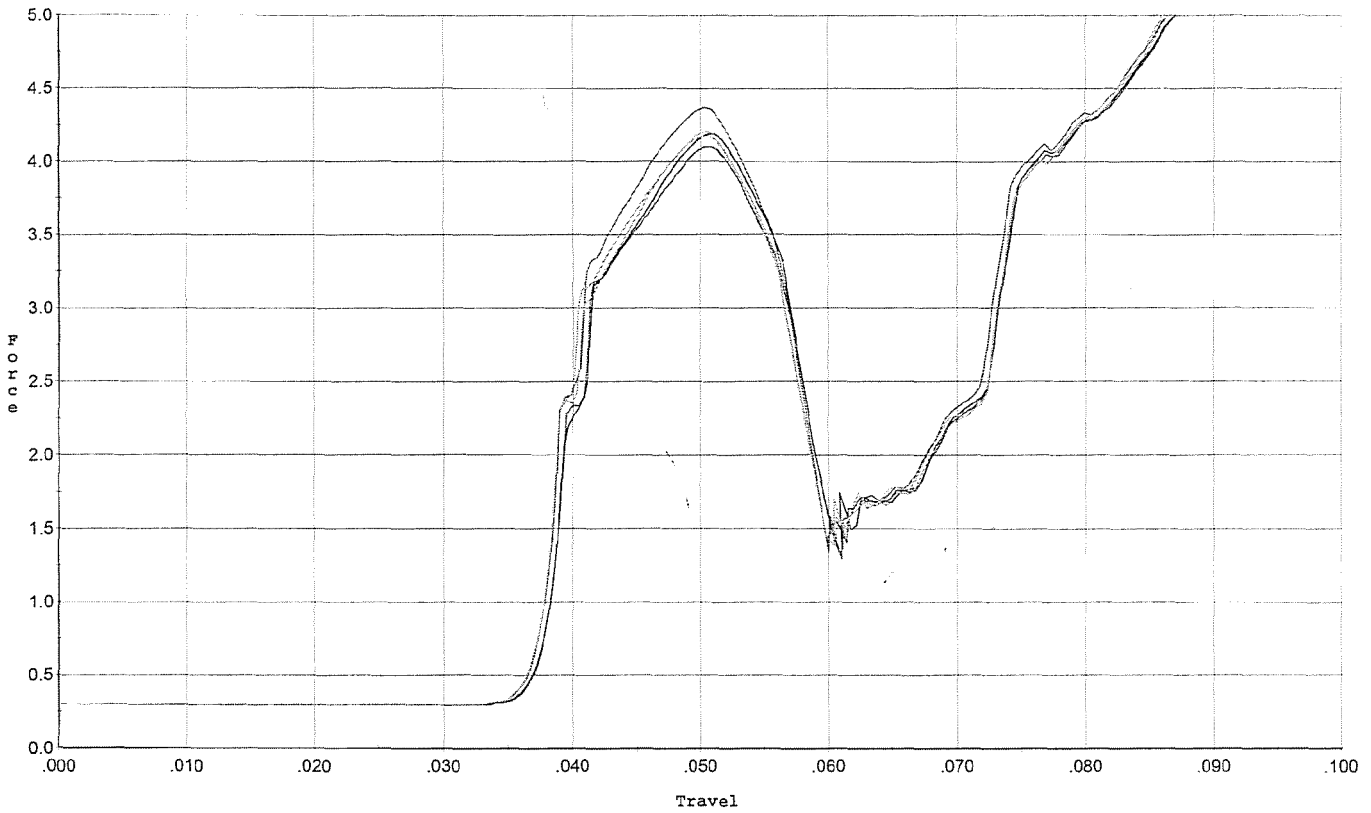
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.083	0.053	0.032	0.034	0.076		Set Trigger
2	4.174	0.052	0.032	0.034	0.076		Set Trigger
3	4.083	0.053	0.033	0.034	0.076		Set Trigger
4	4.090	0.052	0.032	0.034	0.074		Set Trigger
5	4.218	0.051	0.032	0.033	0.076		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

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

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



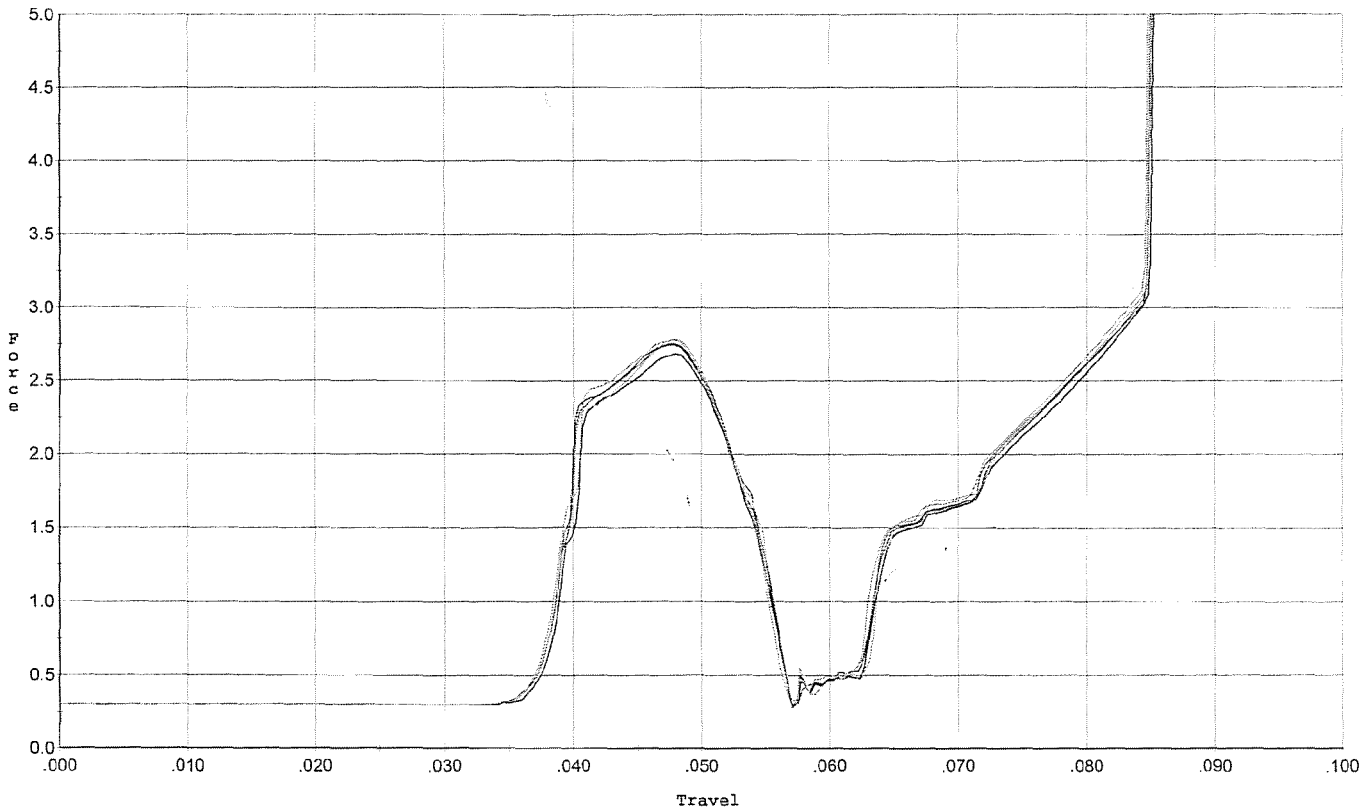
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.100	0.057	0.037	0.035	0.077		Set Trigger
2	4.187	0.056	0.037	0.035	0.077		Set Trigger
3	4.369	0.057	0.036	0.035	0.082		Set Trigger
4	4.206	0.056	0.036	0.035	0.077		Set Trigger
5	4.175	0.056	0.036	0.035	0.078		Set Trigger

Avg 4.20

Trigger Profile [lbs,inch]

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

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



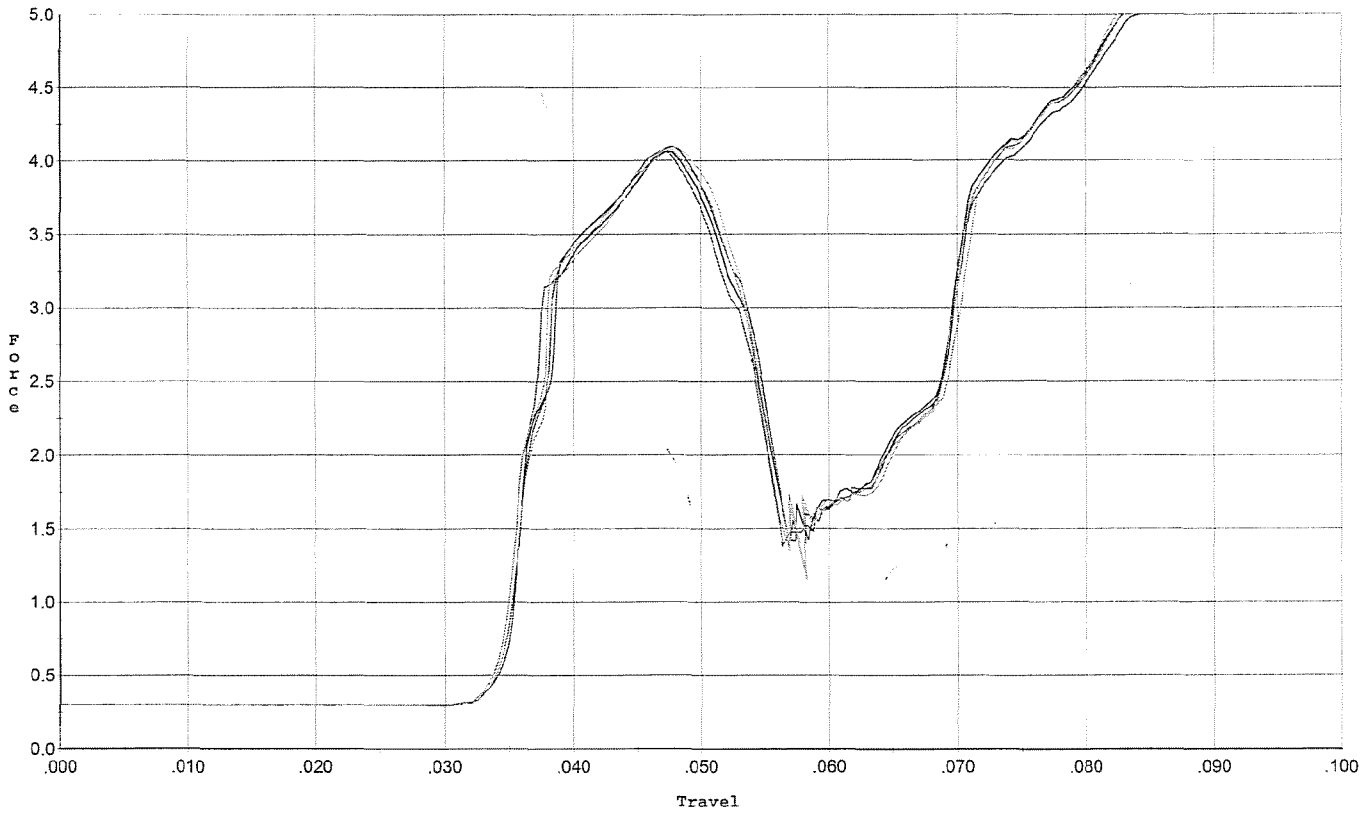
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.752	0.055	0.038	0.037	0.050		Set Trigger
2	2.683	0.055	0.037	0.037	0.048		Set Trigger
3	2.744	0.056	0.037	0.037	0.050		Set Trigger
4	2.786	0.055	0.037	0.037	0.050		Set Trigger
5	2.780	0.054	0.037	0.037	0.049		Set Trigger

Avg 2.74

Trigger Profile [lbs,inch]

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

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	4.095	0.054	0.034	0.034	0.076		Set Trigger
2	4.061	0.053	0.034	0.035	0.074		Set Trigger
3	4.065	0.054	0.034	0.034	0.075		Set Trigger
4	4.089	0.055	0.034	0.034	0.077		Set Trigger
5	4.074	0.053	0.034	0.034	0.075		Set Trigger

Avg 4.07