

66785040

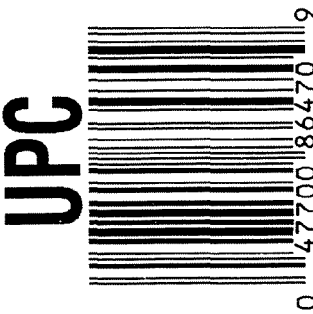
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6785040



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6785040

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-22-08	SPD
430	ASSEMBLE TO STOCK		9-22-08	SP
440	PROOF		9-22-08	SPD
460	CHECK HEADSPACE		9-22-08	SPD
470	DIS-ASSEMBLE ACTION		9-22-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-23-08	BSN
475	DRILL AND TAP SIGHT HOLES	SEP 23 2008	9-23-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (HB)	9/30/08	(HB)
490	MAGNAFLUX BOLT		9/30/08	RT
500	ROLLMARK CALIBER		9/30/08	RT
520	GOFF BLAST BBL / REC		10/11/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-21-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

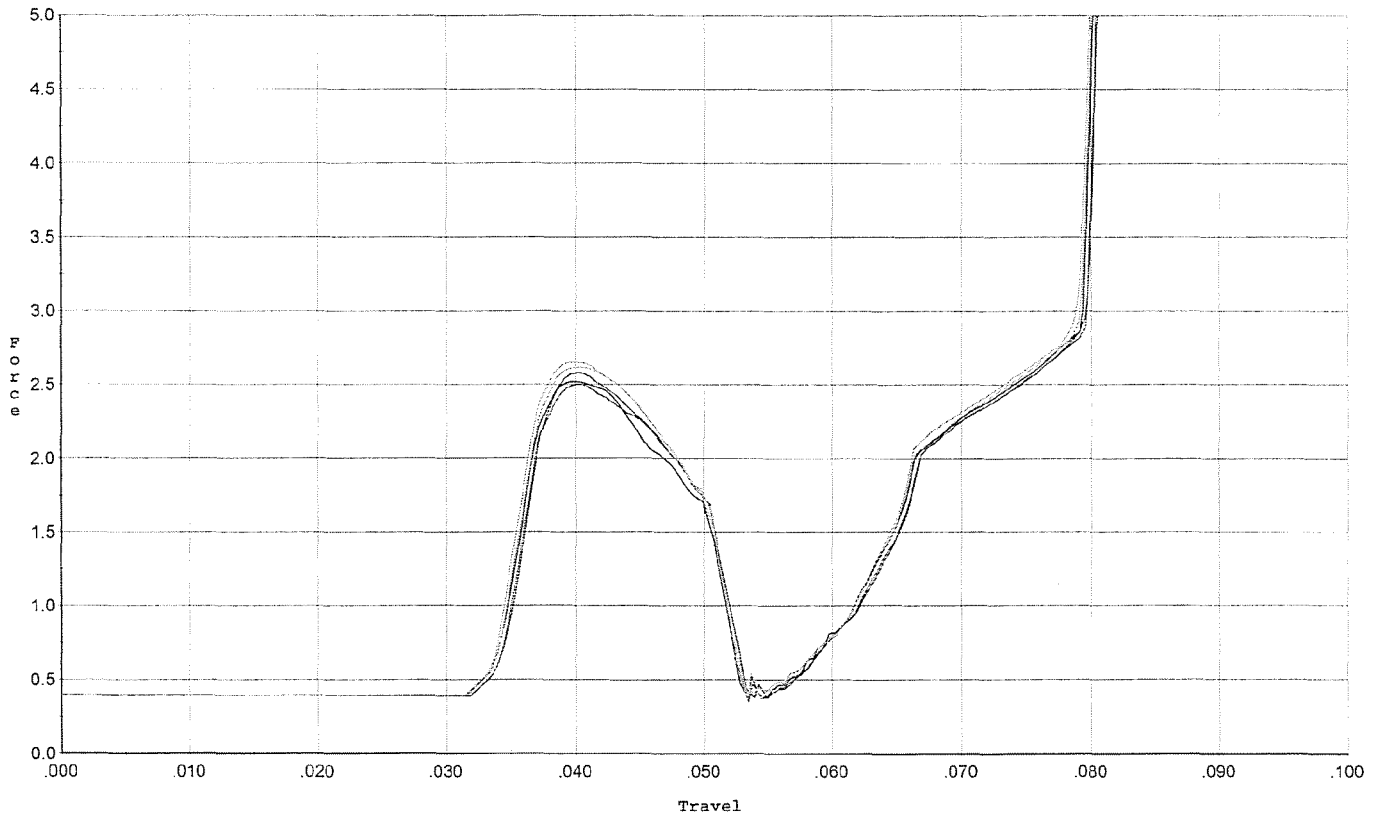
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>4.0</u> <u>3.0</u>	12-8-08	R. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-8-08	R. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-8-08	R. J.
	J) ASSEMBLE STOCK		10-21-08	R. J.
	K) ASSEMBLE SWIVEL STUDS		12-8-08	R. 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 <u>PASS</u> FAIL	11-24-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-24-08	J. S.
670	FINAL INSPECTION A) HEADSPACE		12-8-08	R. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.62</u> <u>2.61</u> <u>2.66</u> <u>2.66</u>	12-5-08	R. J.
	C) FUNCTION		12-8-08	R. J.
690	PACK		12-18-08	R. J.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



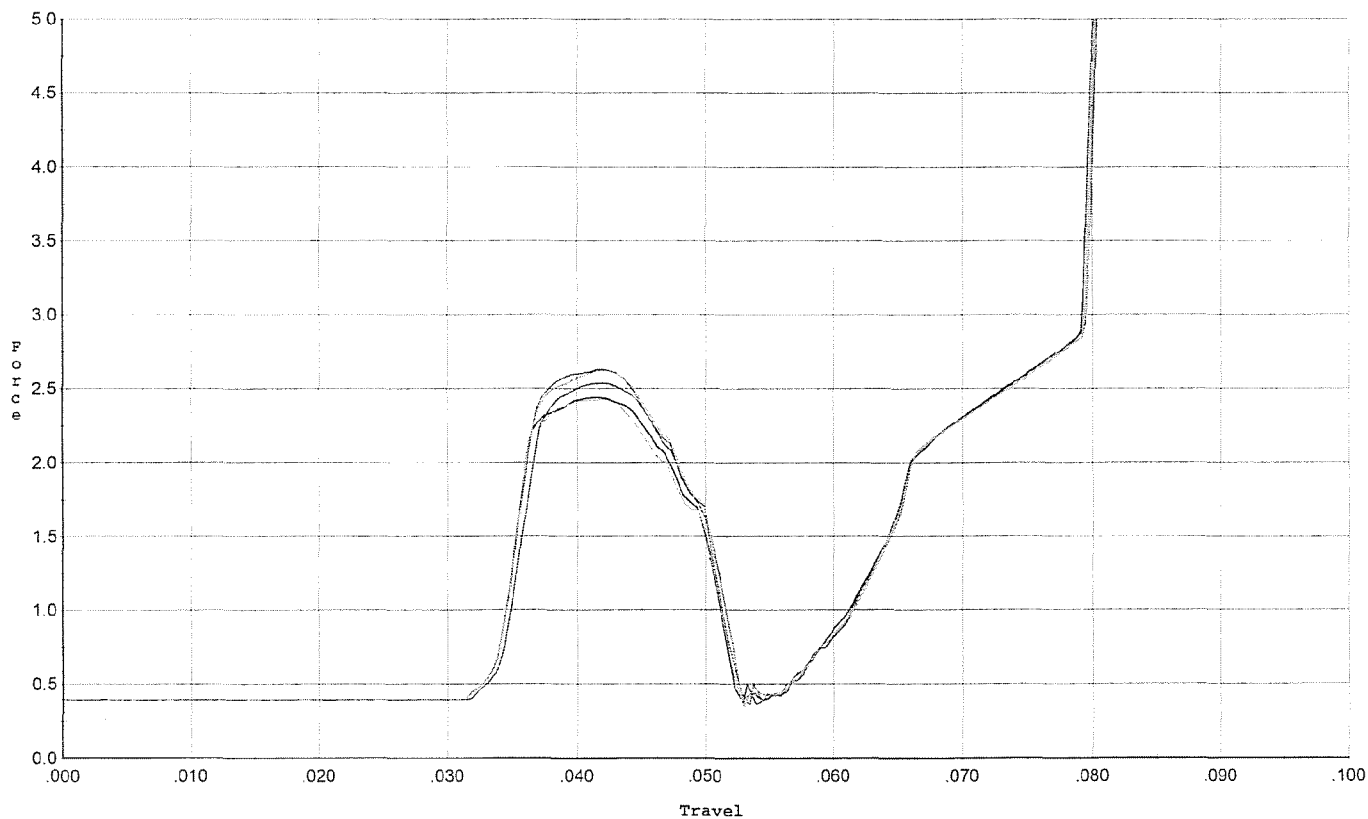
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.582	0.050	0.034	0.036	0.048		Set Trigger
2	2.520	0.051	0.034	0.035	0.048		Set Trigger
3	2.504	0.051	0.034	0.036	0.048		Set Trigger
4	2.620	0.050	0.034	0.035	0.049		Set Trigger
5	2.652	0.051	0.034	0.035	0.050		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/14/08

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



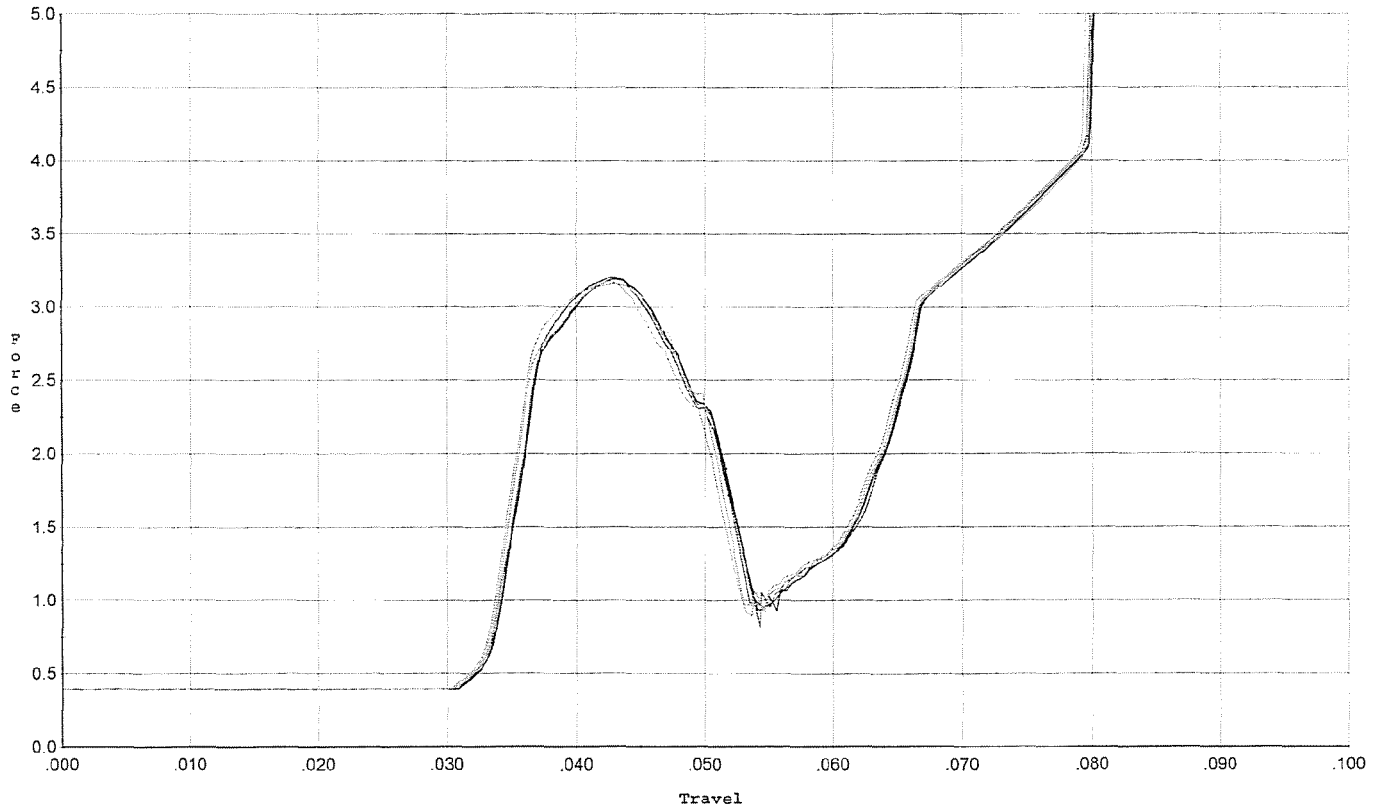
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.538	0.051	0.034	0.035	0.049		Set Trigger
2	2.440	0.050	0.034	0.035	0.048		Set Trigger
3	2.628	0.050	0.034	0.035	0.049		Set Trigger
4	2.623	0.051	0.034	0.035	0.050		Set Trigger
5	2.428	0.050	0.034	0.035	0.047		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



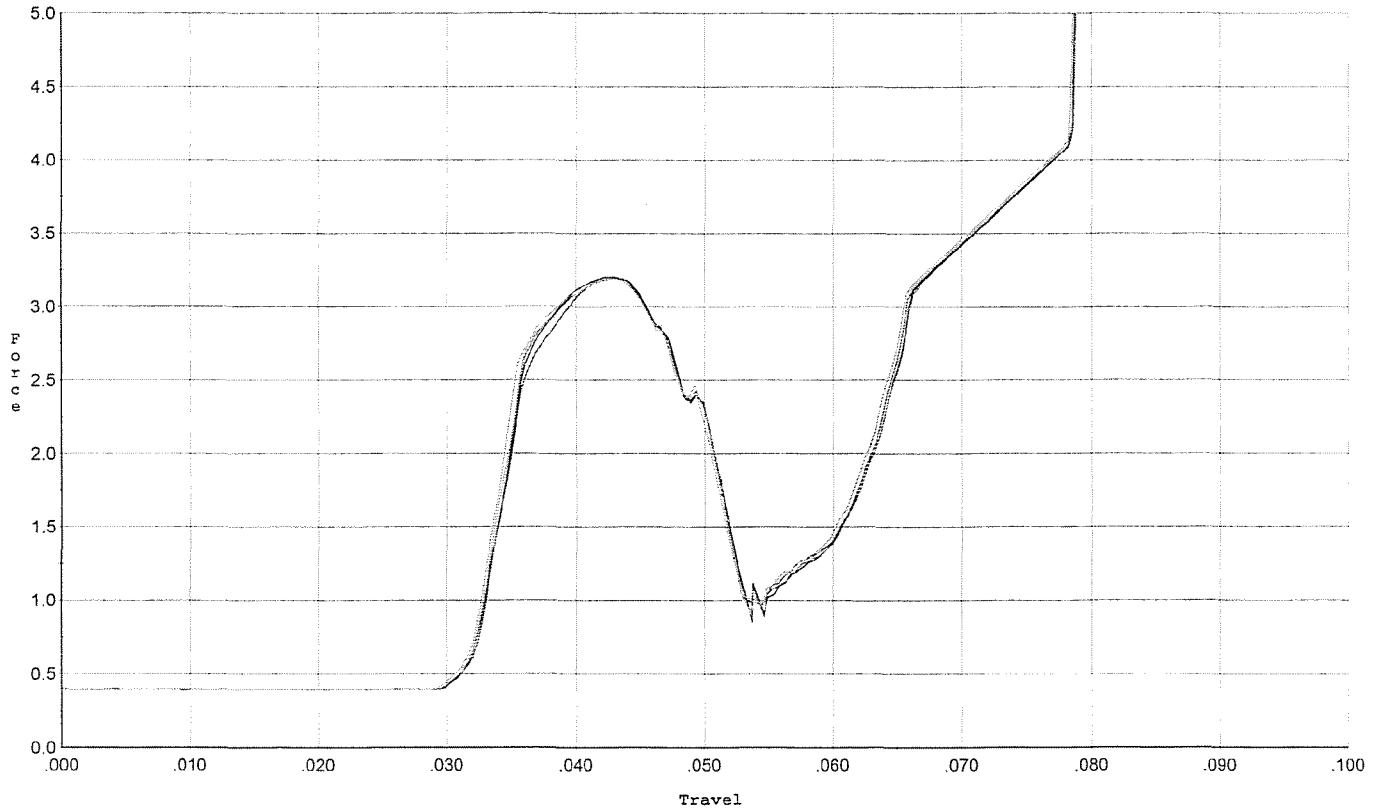
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.202	0.052	0.033	0.034	0.060		Set Trigger
2	3.187	0.052	0.033	0.034	0.060		Set Trigger
3	3.193	0.052	0.033	0.034	0.060		Set Trigger
4	3.155	0.051	0.033	0.034	0.060		Set Trigger
5	3.173	0.050	0.033	0.034	0.059		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



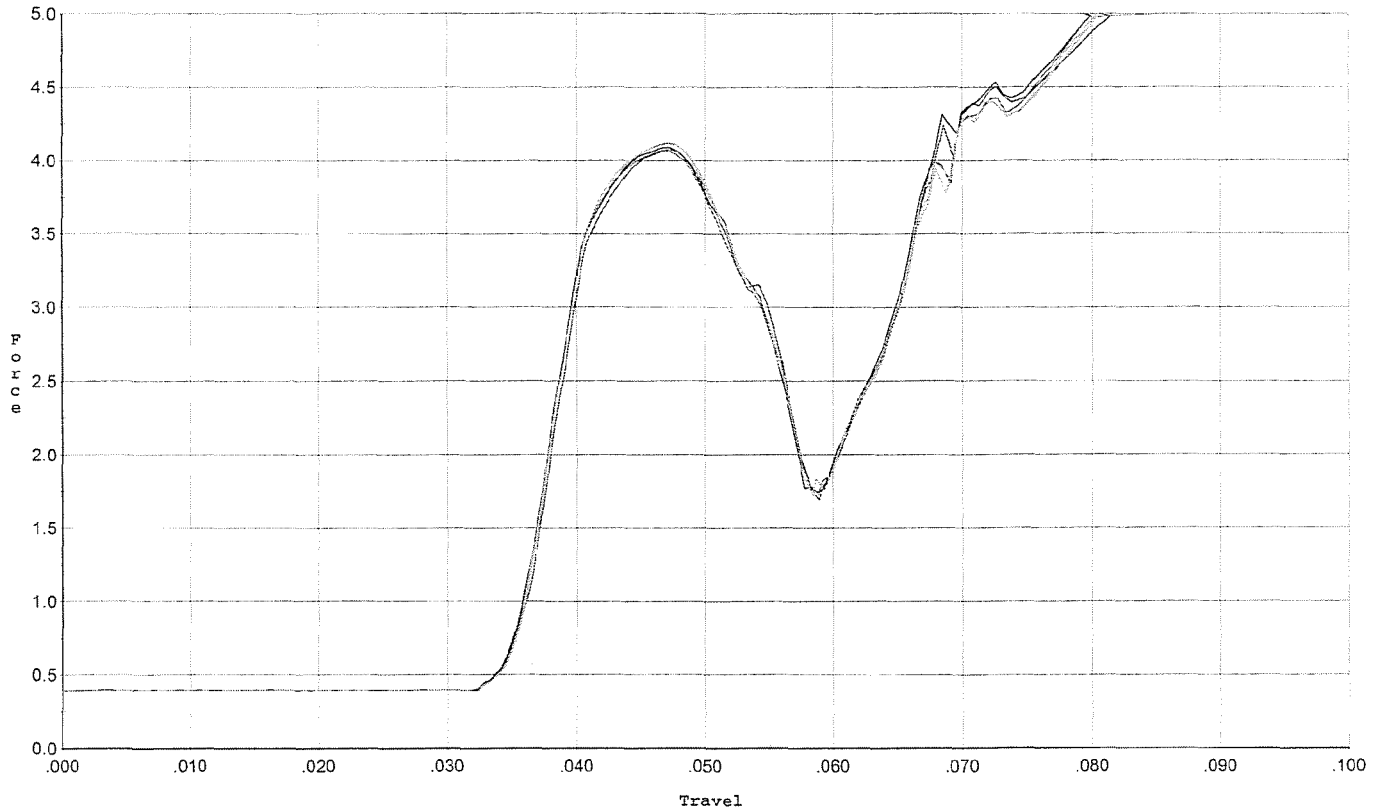
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.193	0.051	0.032	0.033	0.062		Set Trigger
2	3.200	0.051	0.032	0.033	0.062		Set Trigger
3	3.205	0.051	0.032	0.033	0.062		Set Trigger
4	3.187	0.050	0.032	0.033	0.061		Set Trigger
5	3.187	0.051	0.032	0.033	0.063		Set Trigger

Aug 3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



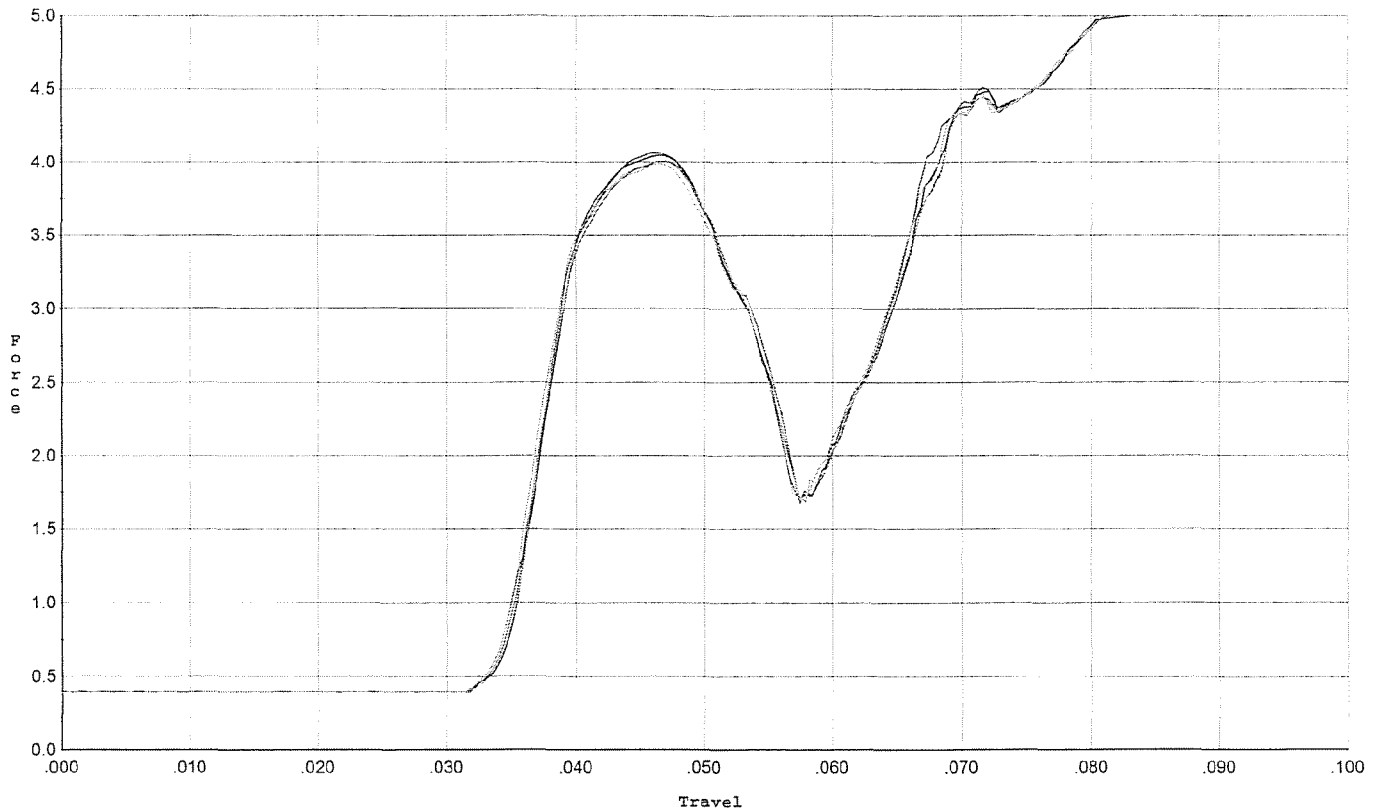
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.076	0.056	0.035	0.032	0.081		Set Trigger
2	4.089	0.056	0.035	0.031	0.082		Set Trigger
3	4.069	0.056	0.035	0.031	0.082		Set Trigger
4	4.122	0.056	0.035	0.031	0.082		Set Trigger
5	4.115	0.056	0.035	0.031	0.082		Set Trigger

Aug 409

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



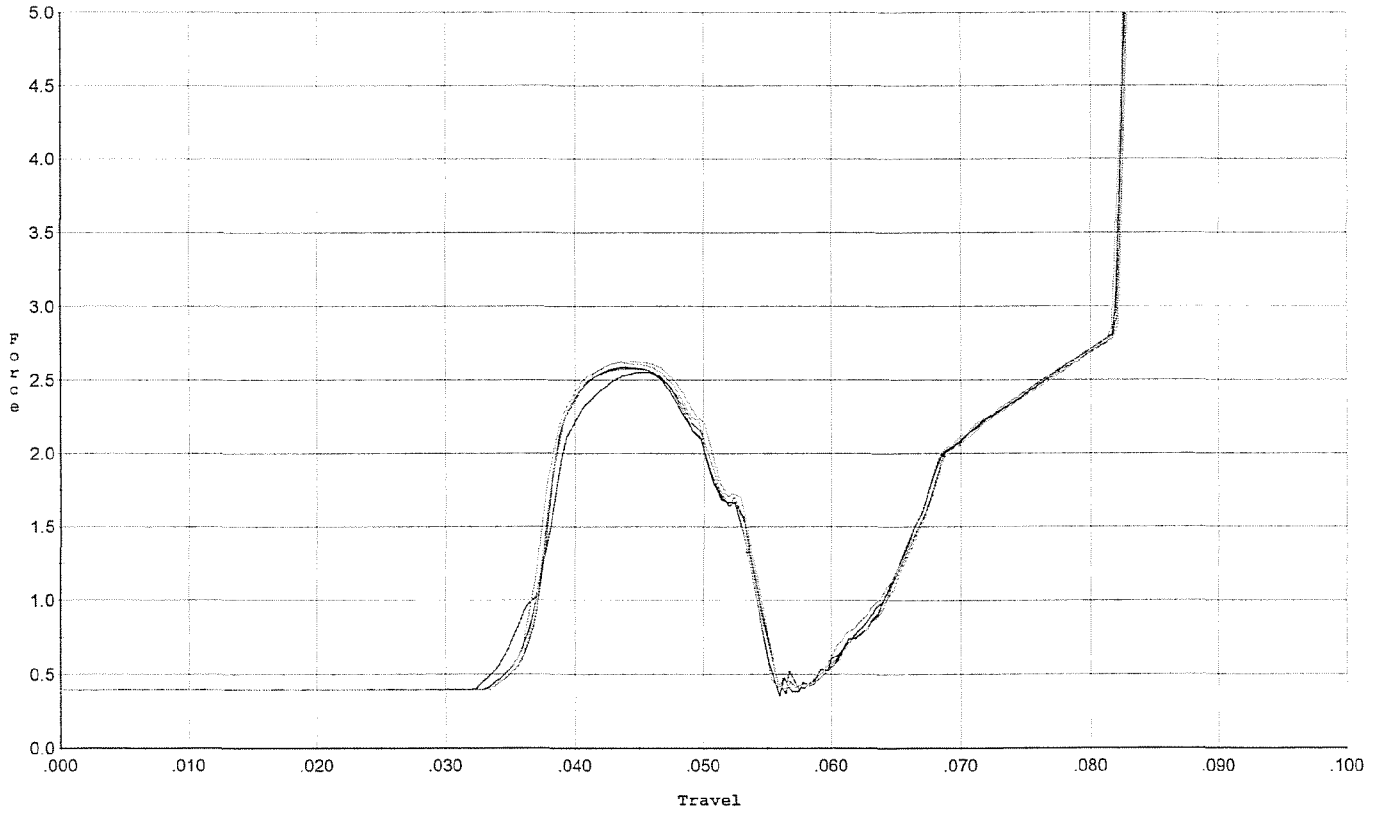
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.065	0.055	0.034	0.032	0.081		Set Trigger
2	4.045	0.055	0.034	0.032	0.080		Set Trigger
3	4.008	0.056	0.034	0.031	0.082		Set Trigger
4	4.009	0.055	0.034	0.032	0.080		Set Trigger
5	3.991	0.055	0.034	0.031	0.081		Set Trigger

Avg 4.02

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/14/08

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



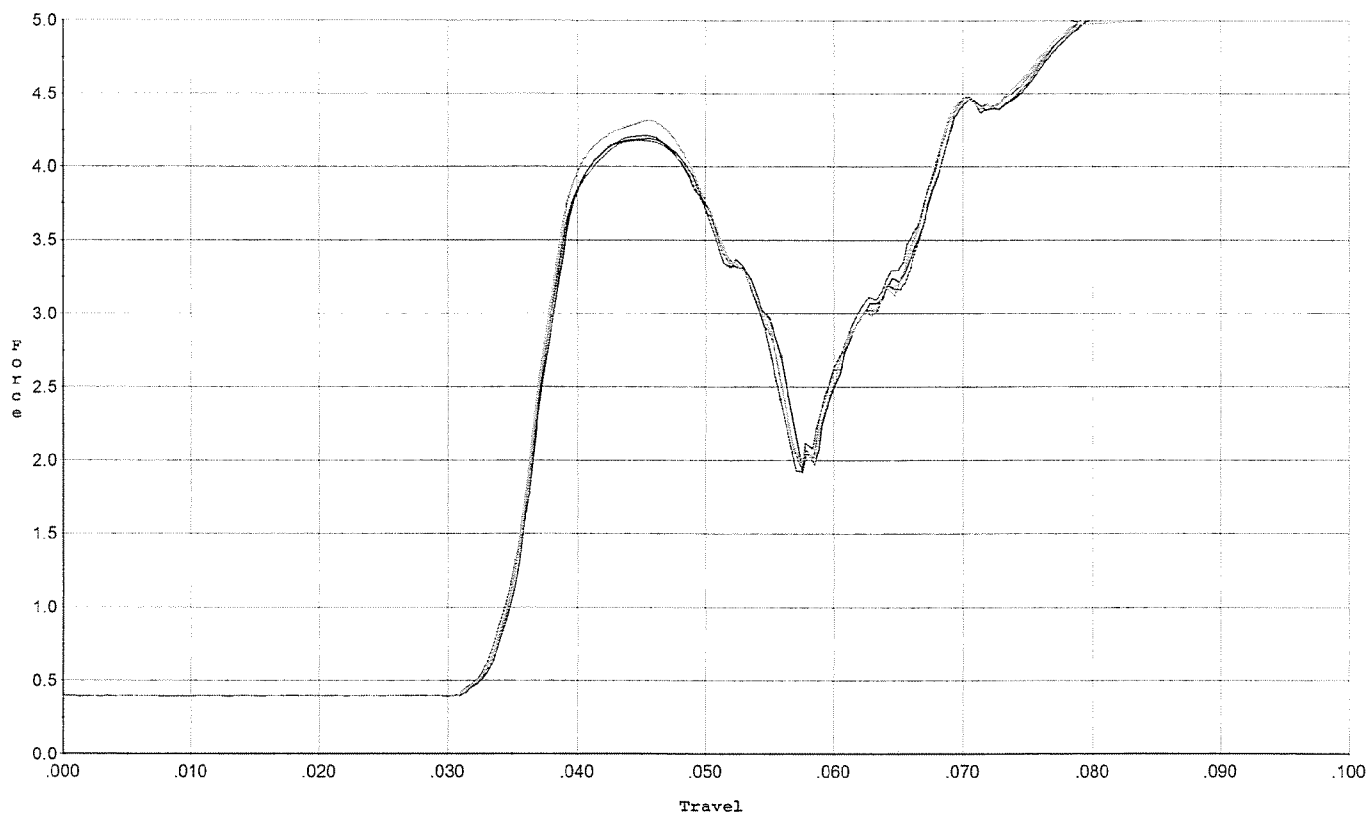
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.053	0.035	0.036	0.051		Set Trigger
2	2.585	0.053	0.036	0.036	0.051		Set Trigger
3	2.576	0.053	0.036	0.036	0.051		Set Trigger
4	2.630	0.054	0.036	0.036	0.053		Set Trigger
5	2.615	0.053	0.036	0.036	0.052		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/14/08

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	4.213	0.056	0.033	0.031	0.087		Set Trigger
2	4.193	0.056	0.034	0.031	0.087		Set Trigger
3	4.179	0.055	0.033	0.031	0.086		Set Trigger
4	4.318	0.055	0.033	0.031	0.087		Set Trigger
5	4.315	0.055	0.033	0.031	0.087		Set Trigger

Avg 4.24