

G6785084

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE

24" BARREL 7.62 NATO

WITH BIPOD

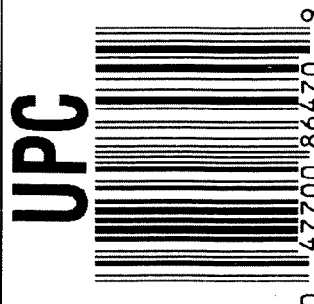


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6785084



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # Q 6785084

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	MAGNA-FLUX	9-8-08	LSN
475	DRILL AND TAP SIGHT HOLES		9-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BJA	9-10-08	BJA
490	MAGNAFLUX BOLT		9/6/08	MR
500	ROLLMARK CALIBER		9/10/08	RT
520	GOFF BLAST BBL / REC		9/10/08	DG
542	APPLY COATINGS (BARREL ACTION)		9/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-23-08	LSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

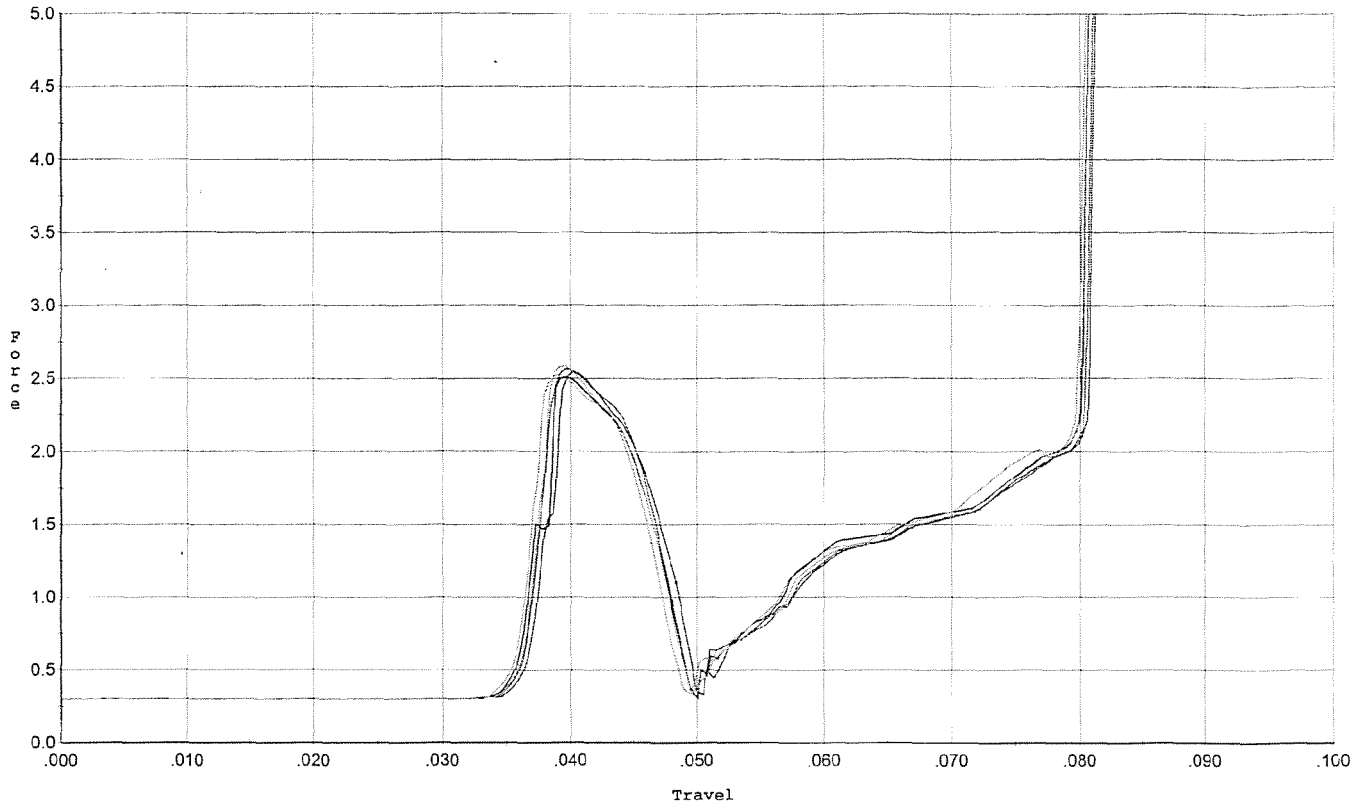
OP #	OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.0</u>	<u>4.0</u>	<u>4.5</u>	10-15-08	L.N.		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	10-15-08	L.N.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	10-15-08	L.N.		
	J) ASSEMBLE STOCK					9-23-08	R.N.		
	K) ASSEMBLE SWIVEL STUDS					10-15-08	L.N.		
	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		10-3-08	L.N.		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					10-3-08	TC		
670	FINAL INSPECTION A) HEADSPACE					10-15-08	L.N.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u>	<u>2.31</u>	<u>2.33</u>	<u>2.42</u>	<u>2.45</u>	10/6/08	Fm
	C) FUNCTION					10-15-08	L.N.		
690	PACK					12-3-08	R.N.		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



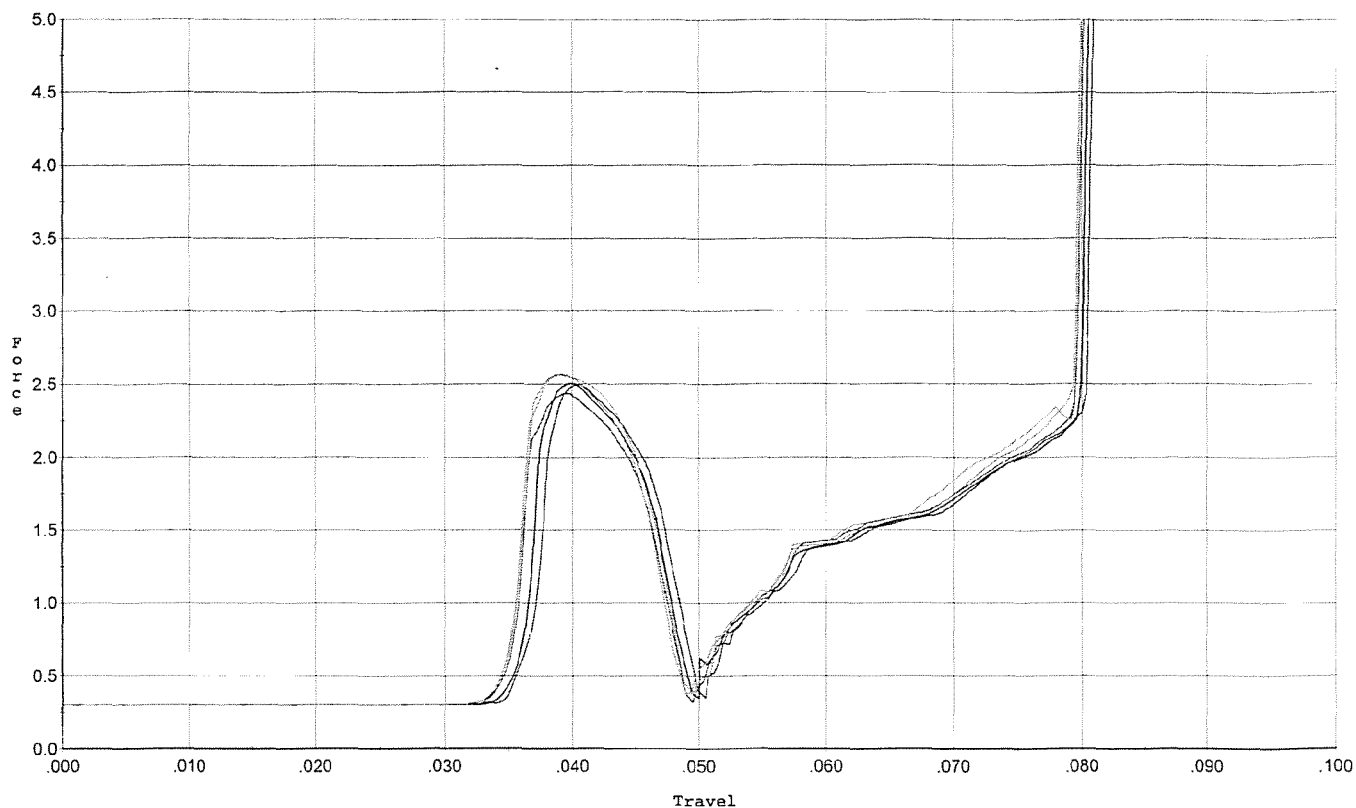
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.048	0.036	0.039	0.034		Set Trigger
2	2.512	0.048	0.035	0.038	0.034		Set Trigger
3	2.568	0.048	0.036	0.038	0.034		Set Trigger
4	2.587	0.047	0.036	0.038	0.033		Set Trigger
5	2.529	0.046	0.035	0.038	0.033		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



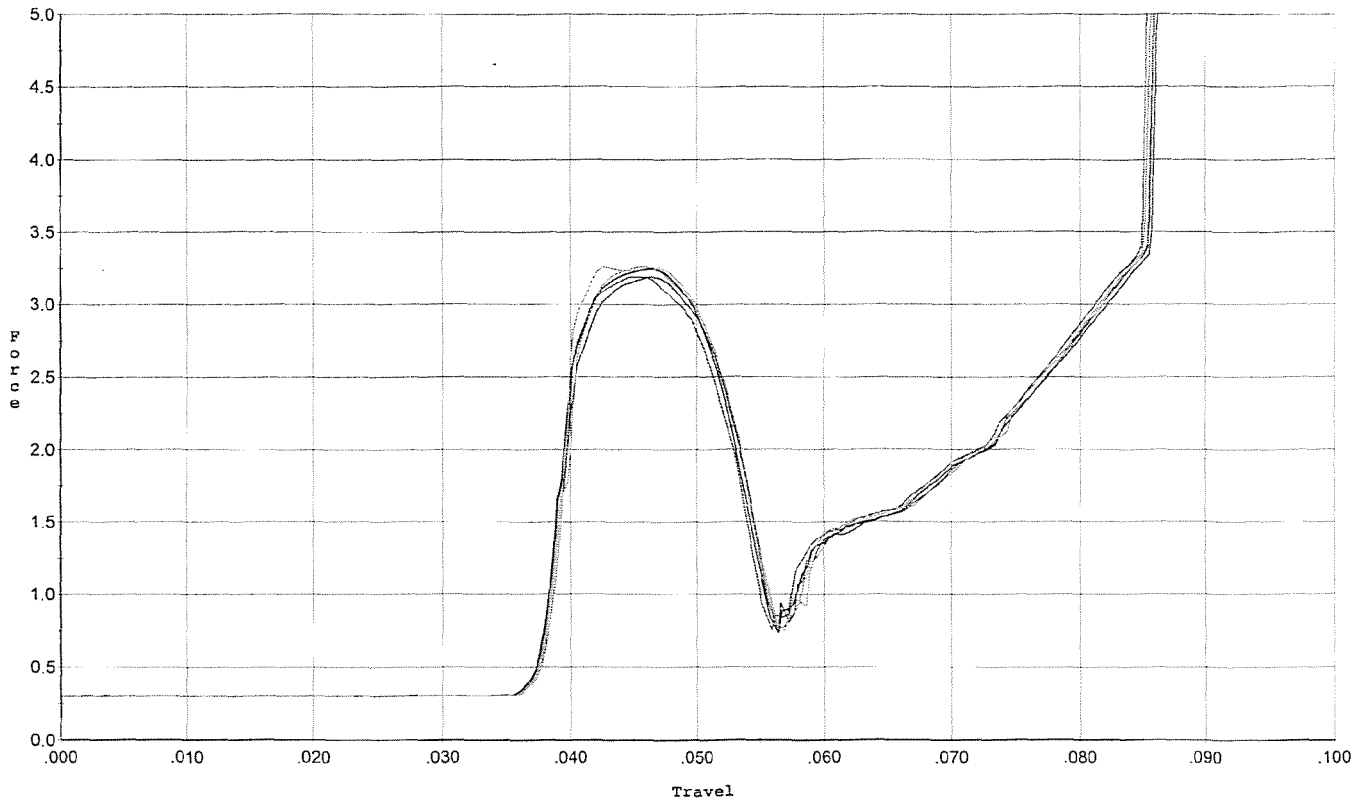
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.494	0.048	0.035	0.038	0.035		Set Trigger
2	2.504	0.047	0.035	0.038	0.034		Set Trigger
3	2.436	0.047	0.034	0.038	0.035		Set Trigger
4	2.567	0.047	0.034	0.037	0.037		Set Trigger
5	2.572	0.046	0.034	0.037	0.035		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



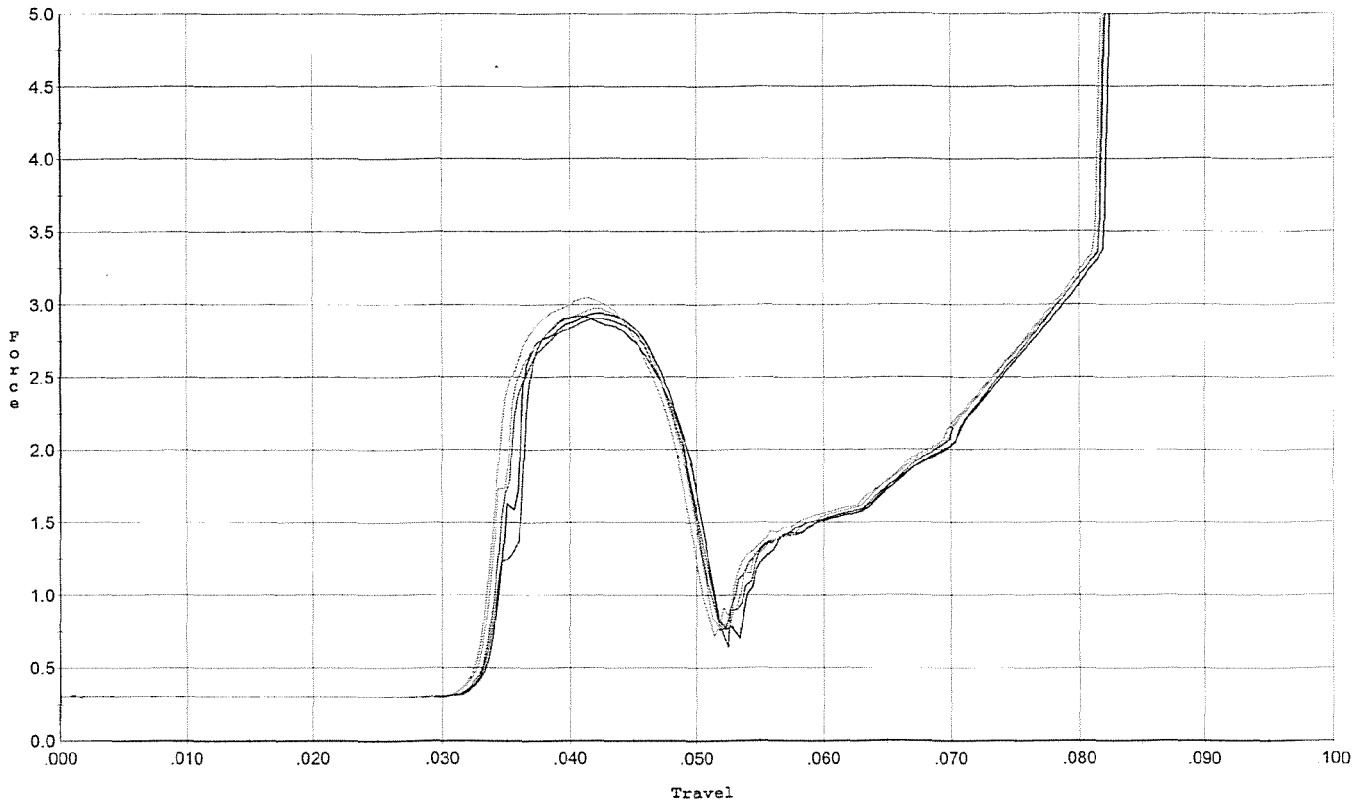
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.185	0.054	0.038	0.038	0.054		Set Trigger
2	3.246	0.053	0.037	0.038	0.054		Set Trigger
3	3.187	0.053	0.037	0.038	0.053		Set Trigger
4	3.255	0.053	0.038	0.038	0.054		Set Trigger
5	3.258	0.053	0.037	0.038	0.055		Set Trigger

Avg 3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



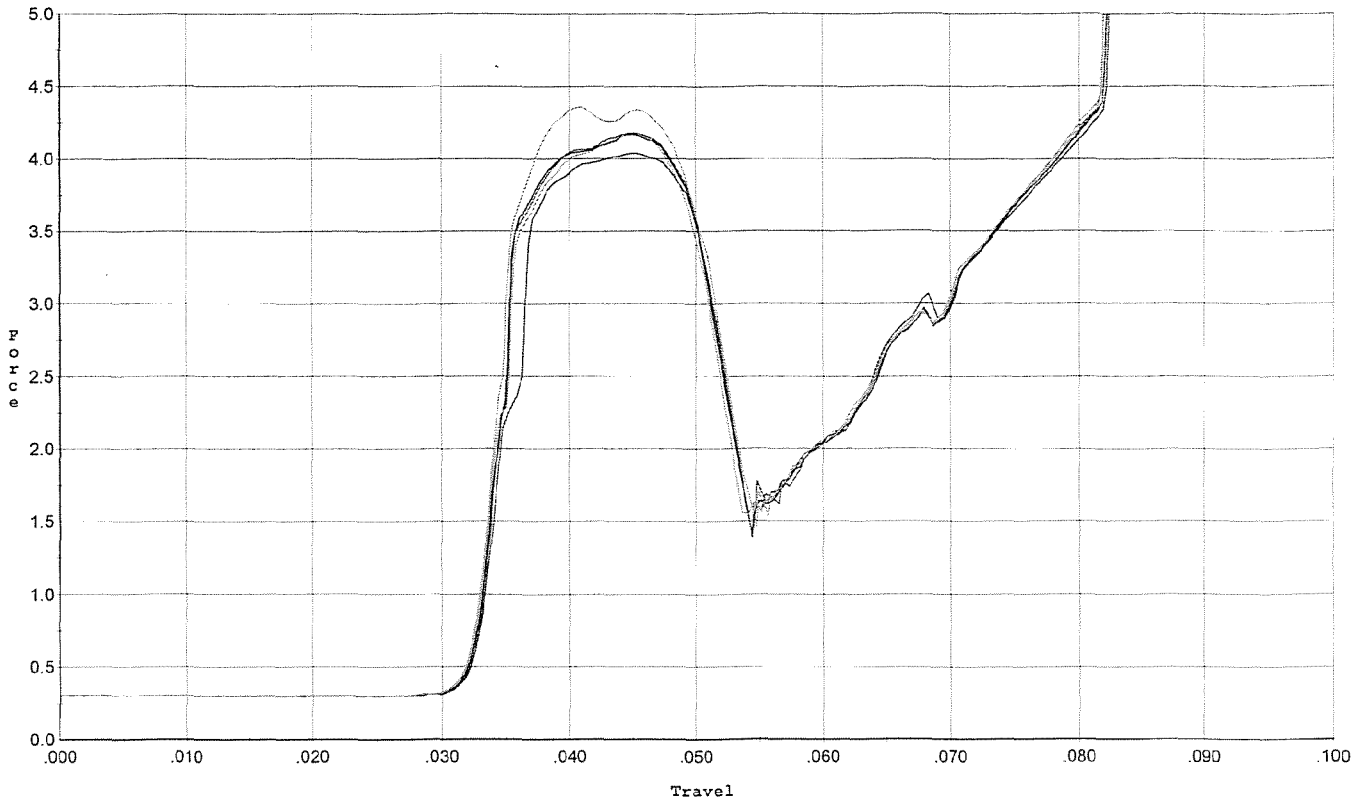
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.919	0.049	0.033	0.037	0.048		Set Trigger
2	2.938	0.050	0.033	0.036	0.050		Set Trigger
3	2.906	0.049	0.033	0.036	0.050		Set Trigger
4	2.971	0.049	0.033	0.036	0.051		Set Trigger
5	3.045	0.049	0.032	0.036	0.051		Set Trigger

Avg 2.95

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



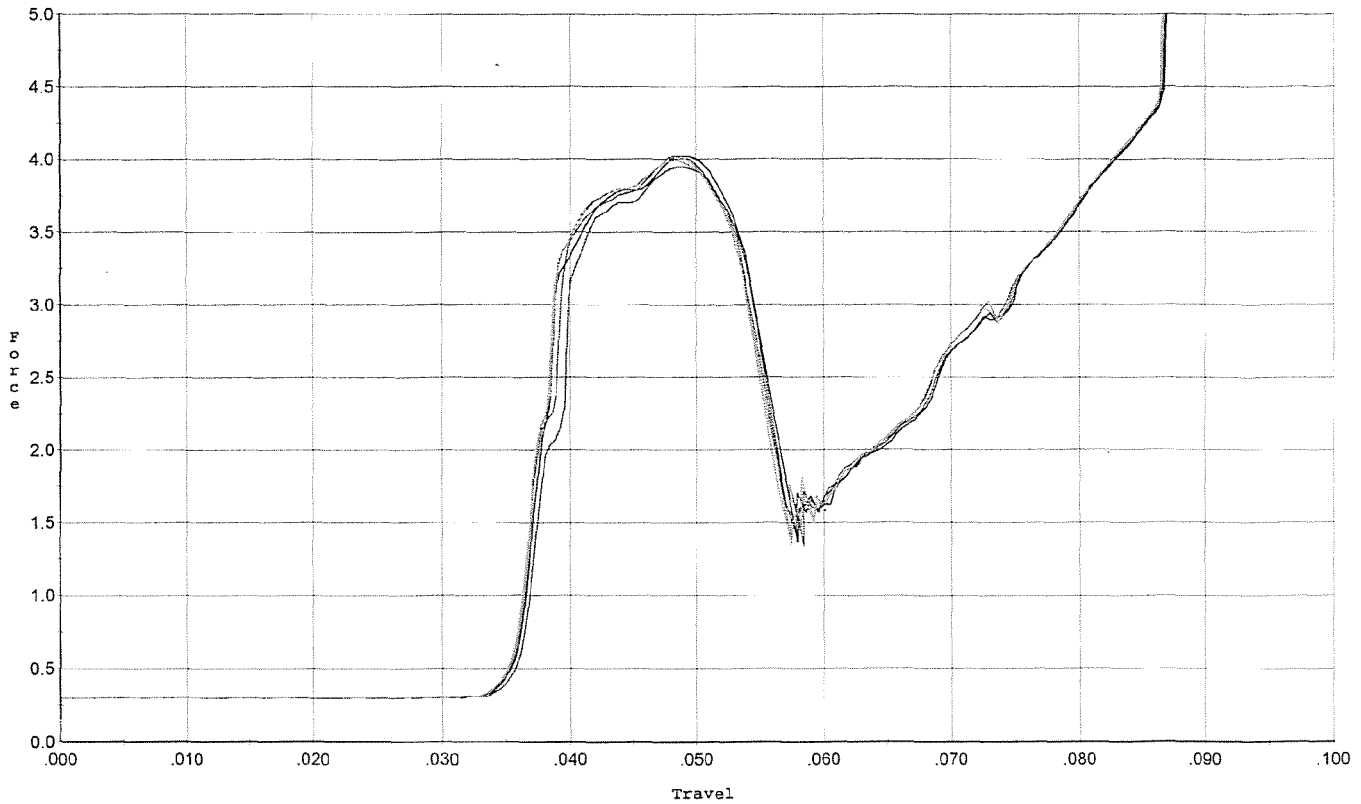
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.037	0.052	0.032	0.034	0.075		Set Trigger
2	4.166	0.050	0.032	0.034	0.076		Set Trigger
3	4.179	0.052	0.032	0.034	0.079		Set Trigger
4	4.172	0.051	0.032	0.034	0.076		Set Trigger
5	4.360	0.051	0.032	0.033	0.081		Set Trigger

Avg 4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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



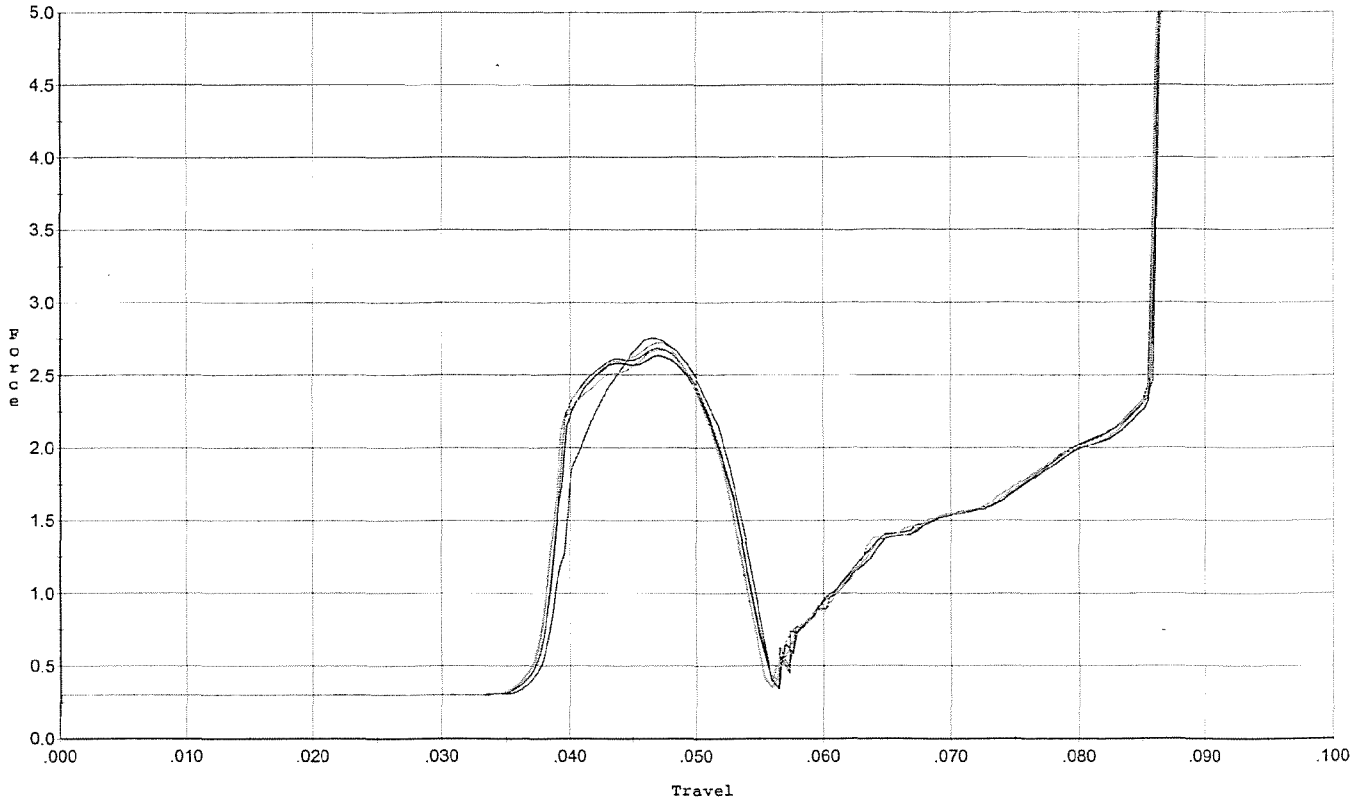
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.948	0.054	0.036	0.036	0.072		Set Trigger
2	4.023	0.054	0.035	0.036	0.075		Set Trigger
3	4.024	0.055	0.035	0.036	0.076		Set Trigger
4	4.016	0.053	0.035	0.036	0.074		Set Trigger
5	3.996	0.054	0.035	0.036	0.074		Set Trigger

Avg 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 9/12/08

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



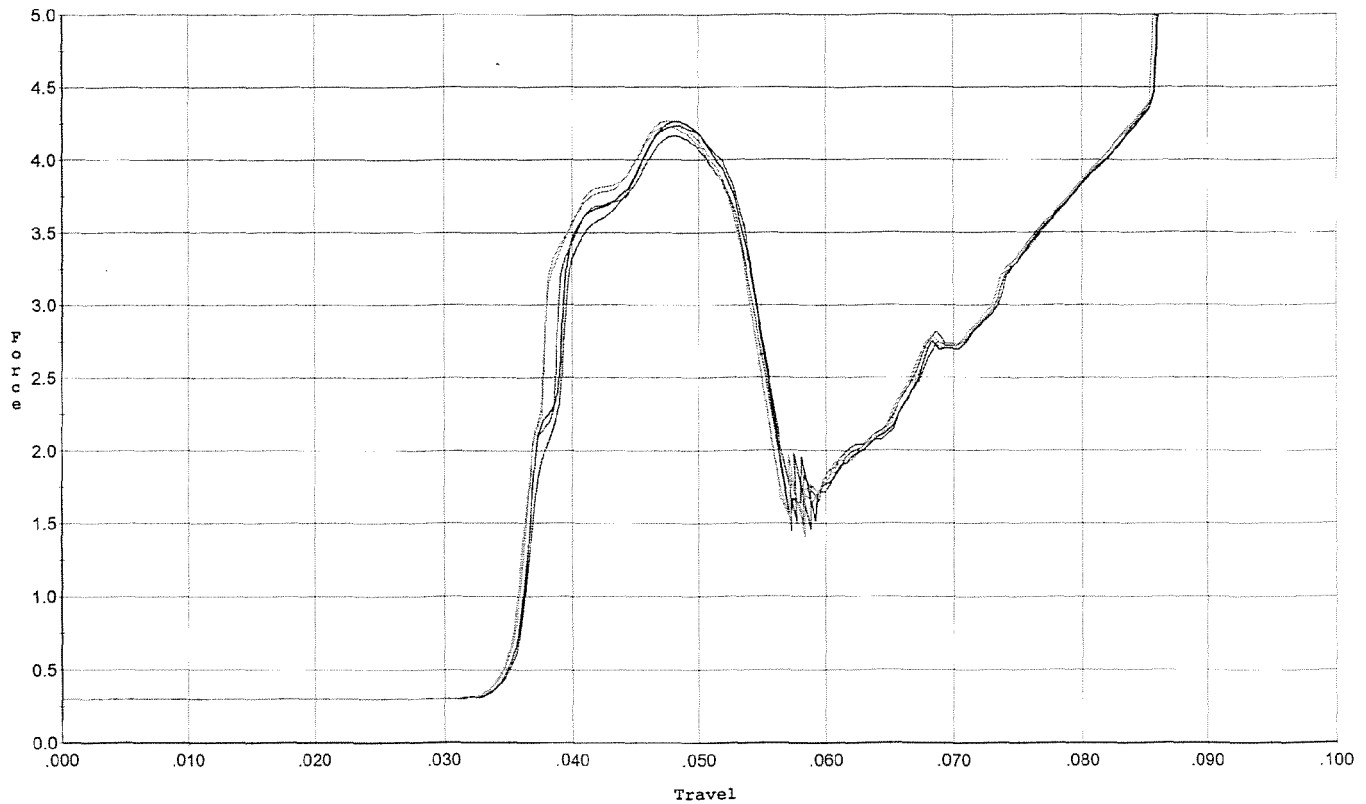
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.755	0.054	0.038	0.039	0.047		Set Trigger
2	2.634	0.053	0.037	0.039	0.047		Set Trigger
3	2.686	0.053	0.037	0.039	0.047		Set Trigger
4	2.672	0.054	0.037	0.038	0.047		Set Trigger
5	2.721	0.054	0.037	0.039	0.048		Set Trigger

AVG 2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/12/08

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	4.231	0.054	0.035	0.036	0.075		Set Trigger
2	4.259	0.054	0.035	0.036	0.077		Set Trigger
3	4.164	0.055	0.035	0.036	0.078		Set Trigger
4	4.228	0.053	0.035	0.036	0.077		Set Trigger
5	4.266	0.053	0.034	0.036	0.077		Set Trigger

AVG 4.23