

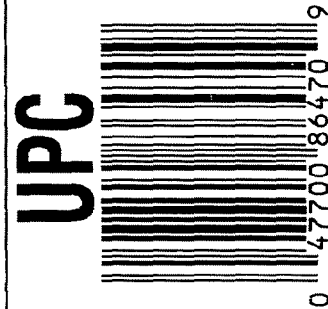
G6794584

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

G6794584



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794584

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	SPD
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	SPD
460	CHECK HEADSPACE		10-14-08	SPD
470	DIS-ASSEMBLE ACTION		10-14-08	SPD
472	SERIALIZE BOLT HANDLE		10-15-08	LTZ
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX UCI 17 2008	10-15-08	JP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/17/08	(H8)
490	MAGNAFLUX BOLT		10/17/08	mor
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DB
542	APPLY COATINGS (BARREL ACTION)		10-22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-23-08	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-23-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-23-08	JP
	D) OIL FIRING PIN ASSEMBLY		1-15-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

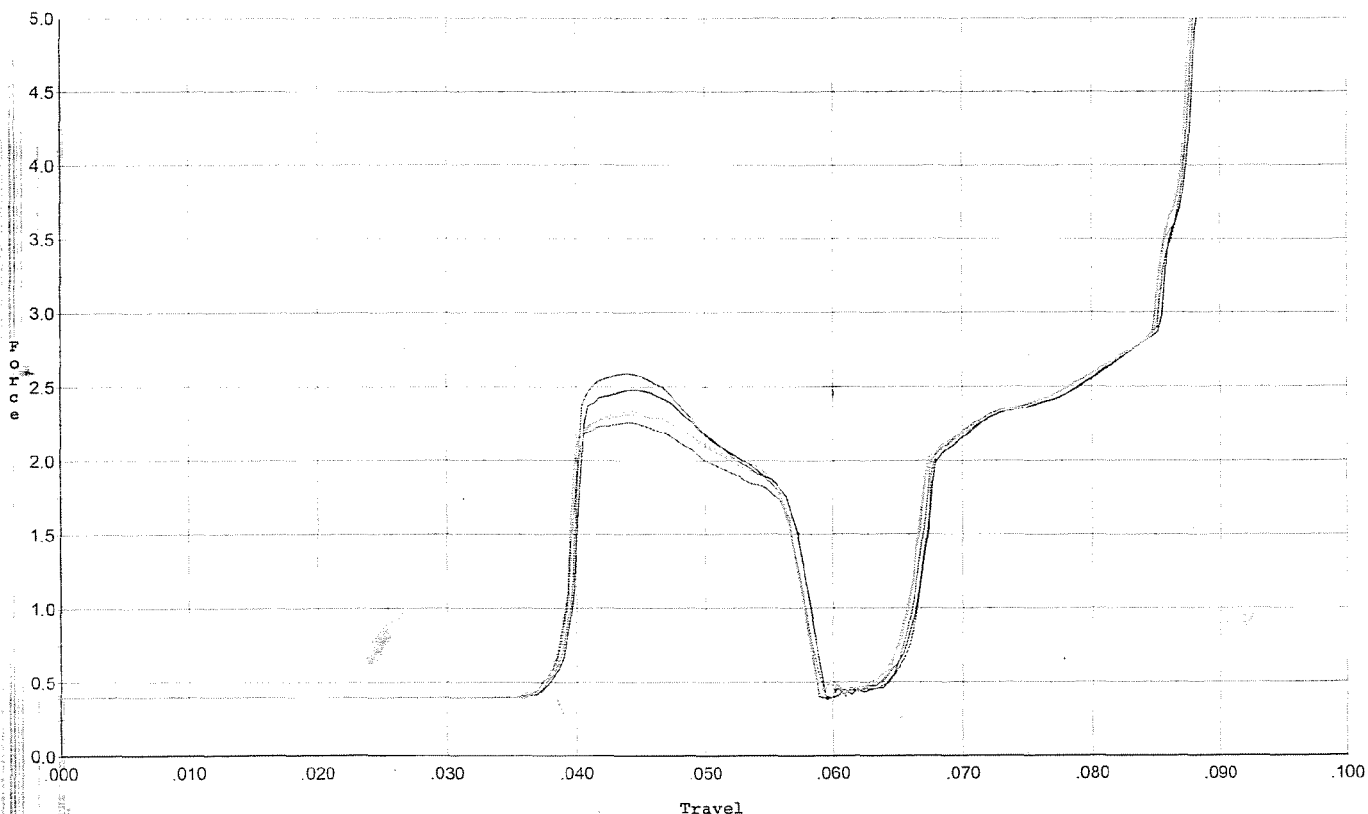
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-27-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	1-27-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	1-27-09	L.N.
	J) ASSEMBLE STOCK		1-15-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		1-27-09	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 <u>PASS</u> FAIL	1-26-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-26-09	W.N.
670	FINAL INSPECTION A) HEADSPACE		1-27-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.32</u> <u>2.40</u> <u>2.31</u> <u>2.43</u>	1-27-09	L.N.
	C) FUNCTION		1-27-09	L.N.
690	PACK		1/30/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 1/15/2009

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



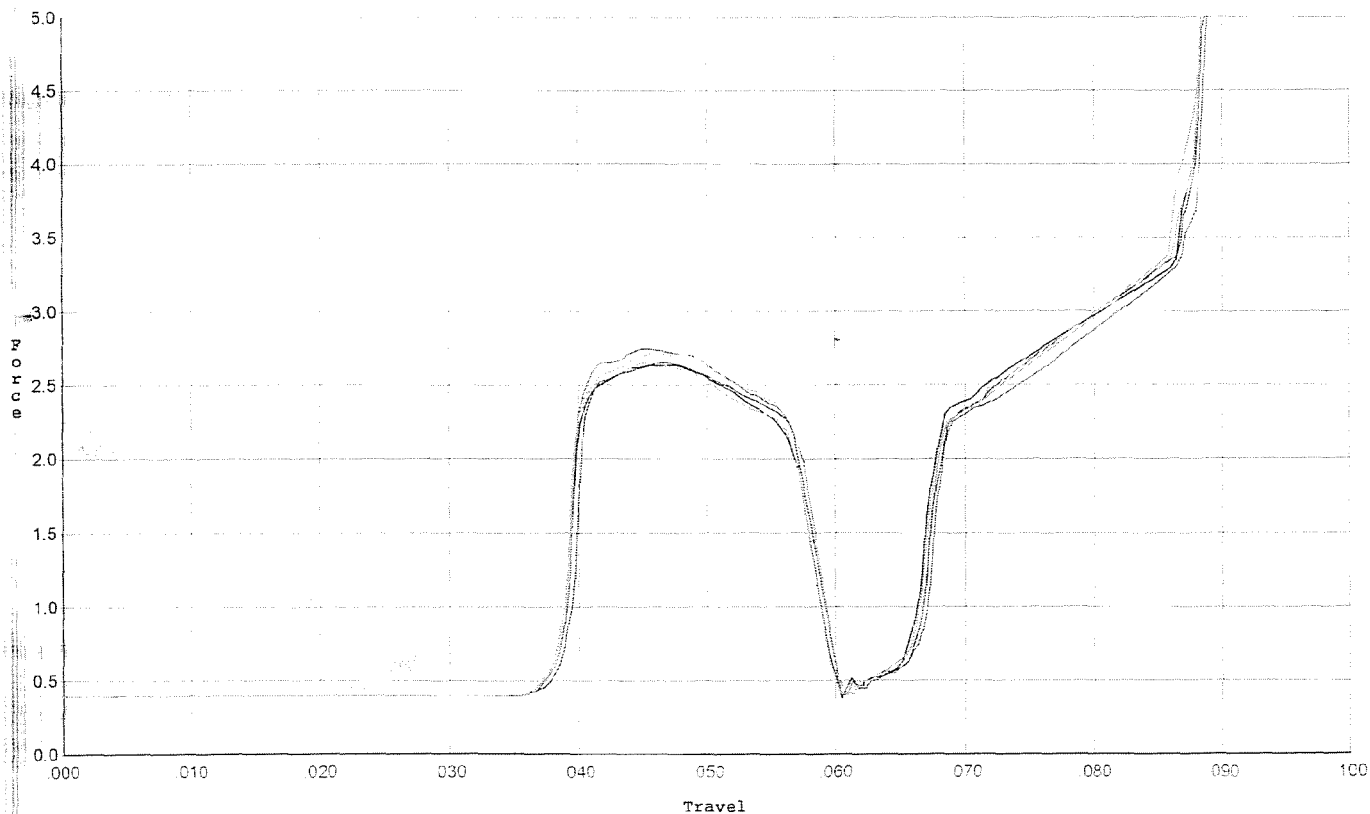
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.590	0.057	0.038	0.038	0.055		Set Trigger
2	2.477	0.057	0.039	0.038	0.054		Set Trigger
3	2.258	0.057	0.038	0.038	0.051		Set Trigger
4	2.313	0.057	0.039	0.038	0.052		Set Trigger
5	2.338	0.057	0.038	0.038	0.053		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 1/15/2009

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



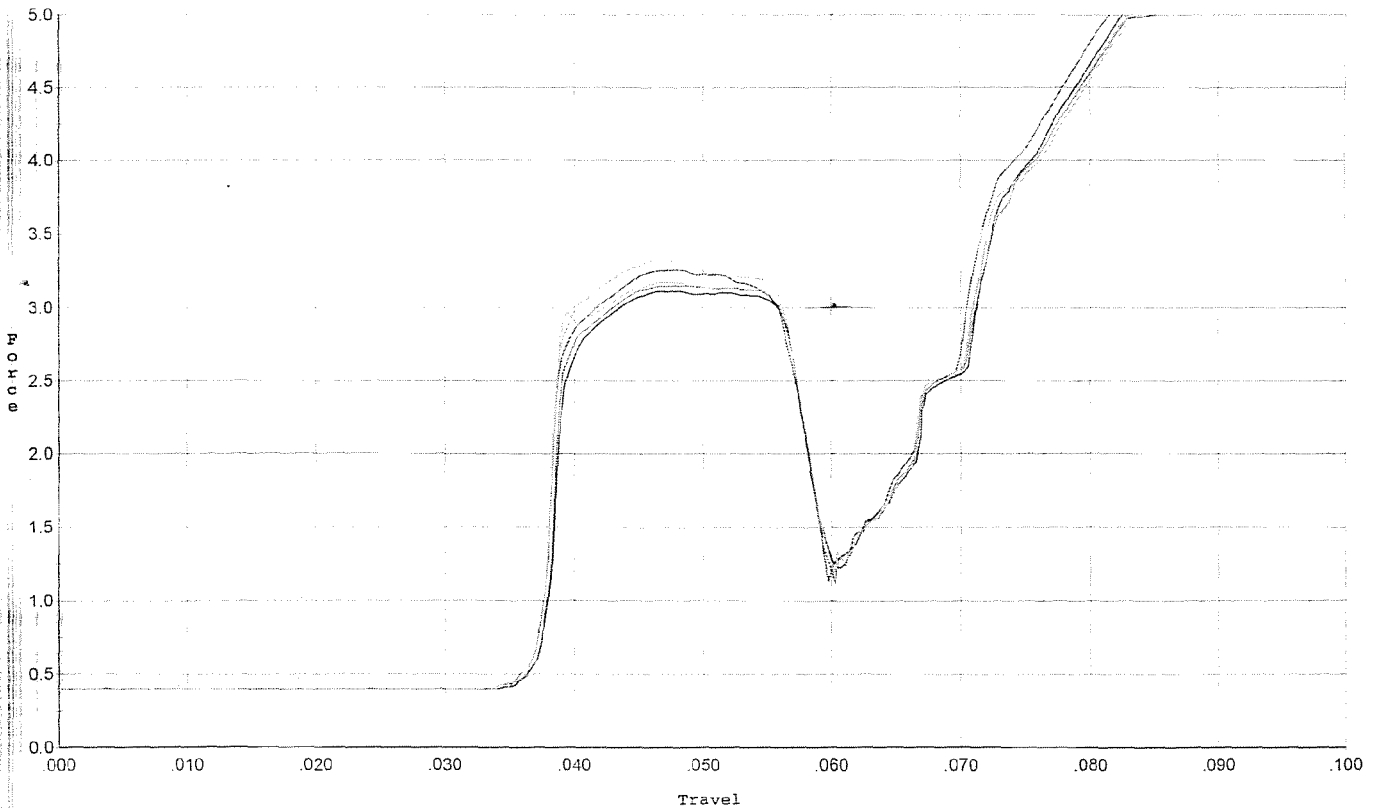
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.650	0.057	0.039	0.037	0.061		Set Trigger
2	2.635	0.057	0.037	0.038	0.060		Set Trigger
3	2.743	0.058	0.038	0.037	0.063		Set Trigger
4	2.718	0.058	0.038	0.037	0.063		Set Trigger
5	2.653	0.057	0.038	0.038	0.060		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

Model: M124
 Serial No: Form #F005
 Trigger: 3.0 lbs ini +/- .75 lb



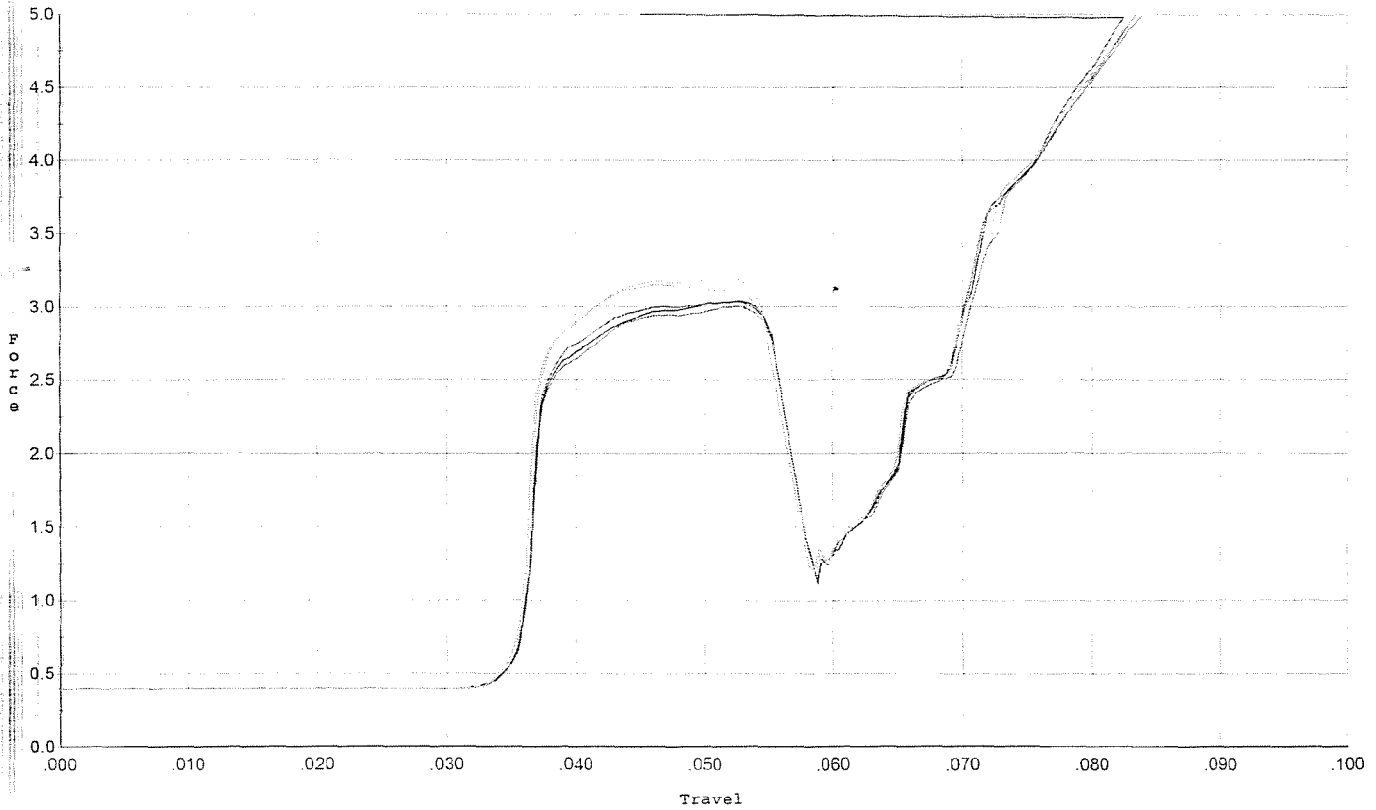
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.057	0.037	0.035	0.075		Set Trigger
2	3.112	0.057	0.037	0.035	0.072		Set Trigger
3	3.152	0.057	0.037	0.035	0.073		Set Trigger
4	3.173	0.057	0.037	0.035	0.074		Set Trigger
5	3.320	0.057	0.037	0.035	0.075		Set Trigger

7-3-20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



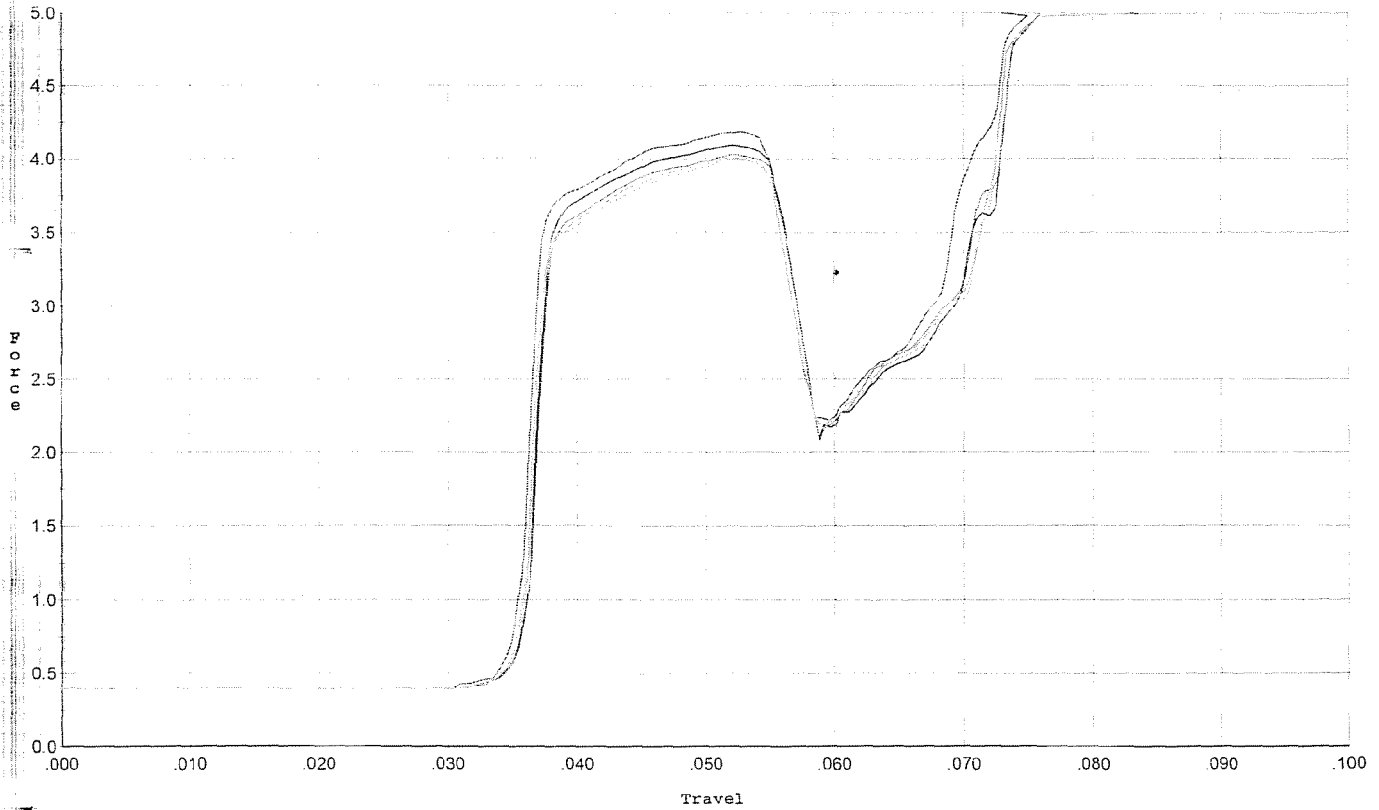
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.033	0.055	0.035	0.035	0.070		Set Trigger
2	3.034	0.055	0.035	0.035	0.070		Set Trigger
3	3.002	0.055	0.035	0.035	0.069		Set Trigger
4	3.192	0.054	0.035	0.035	0.072		Set Trigger
5	3.151	0.055	0.035	0.035	0.071		Set Trigger

A-3-08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



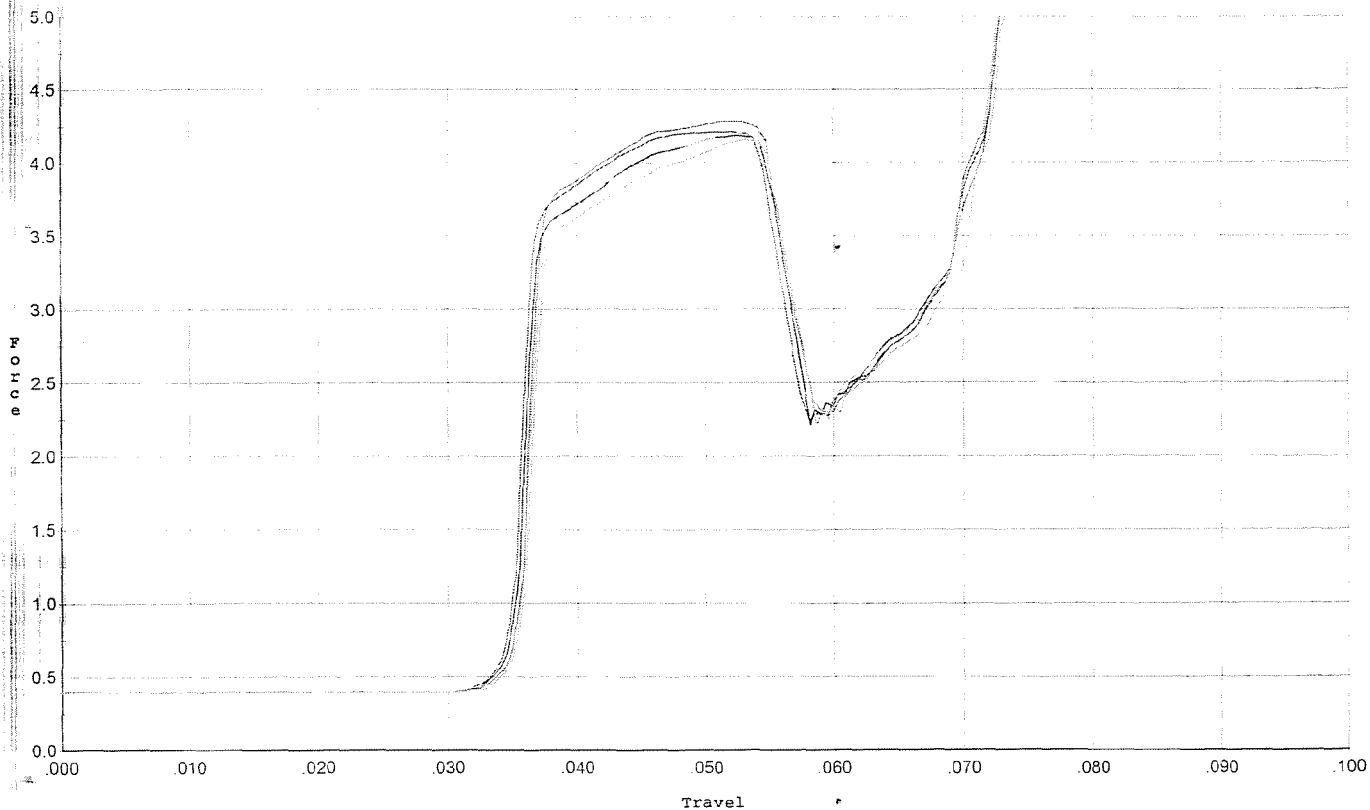
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.055	0.034	0.033	0.092		Set Trigger
2	4.091	0.056	0.035	0.033	0.092		Set Trigger
3	4.026	0.056	0.035	0.034	0.091		Set Trigger
4	3.996	0.055	0.035	0.034	0.088		Set Trigger
5	4.011	0.055	0.035	0.034	0.088		Set Trigger

7.4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



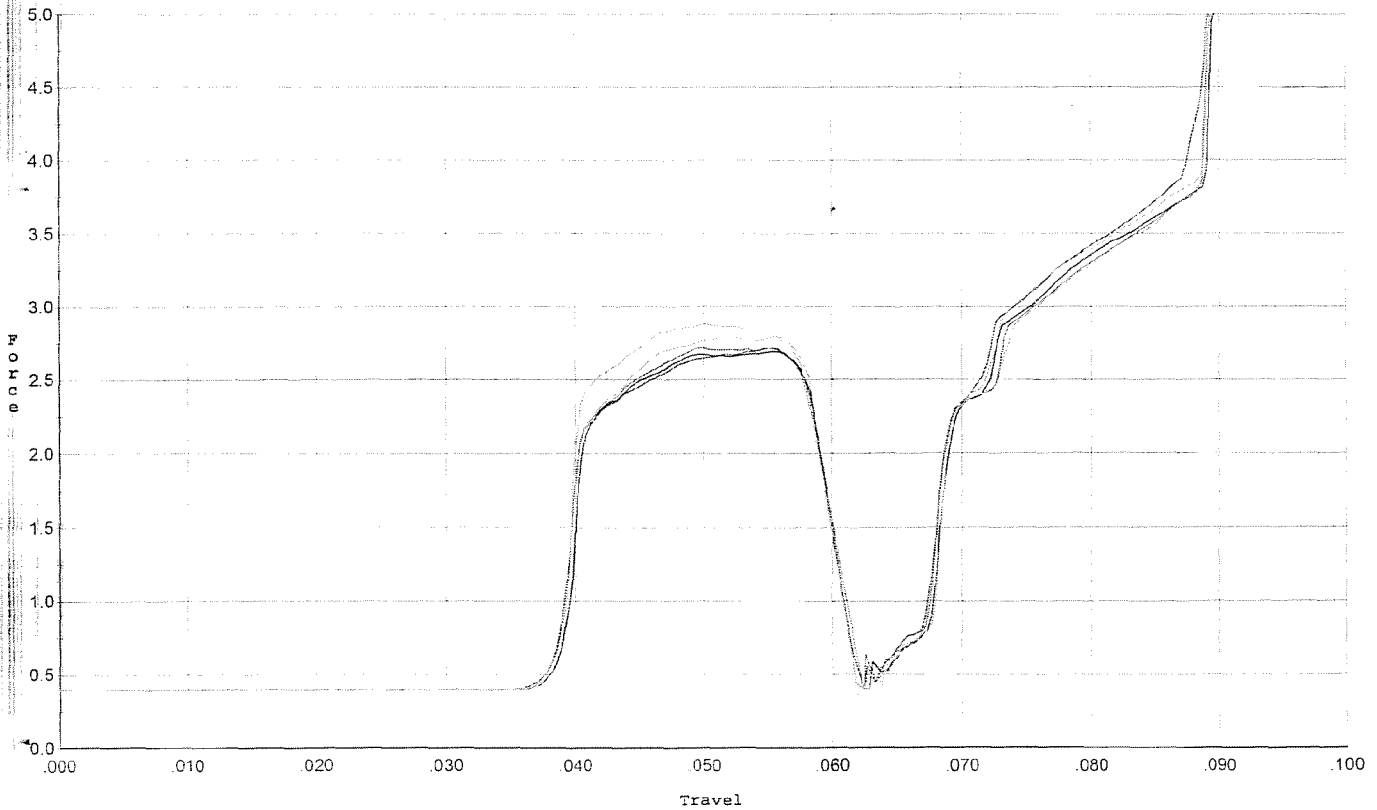
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.214	0.054	0.034	0.031	0.093		Set Trigger
2	4.186	0.055	0.035	0.030	0.093		Set Trigger
3	4.282	0.055	0.035	0.030	0.094		Set Trigger
4	4.199	0.055	0.035	0.030	0.091		Set Trigger
5	4.157	0.056	0.035	0.030	0.093		Set Trigger

A 4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 1/15/2009

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



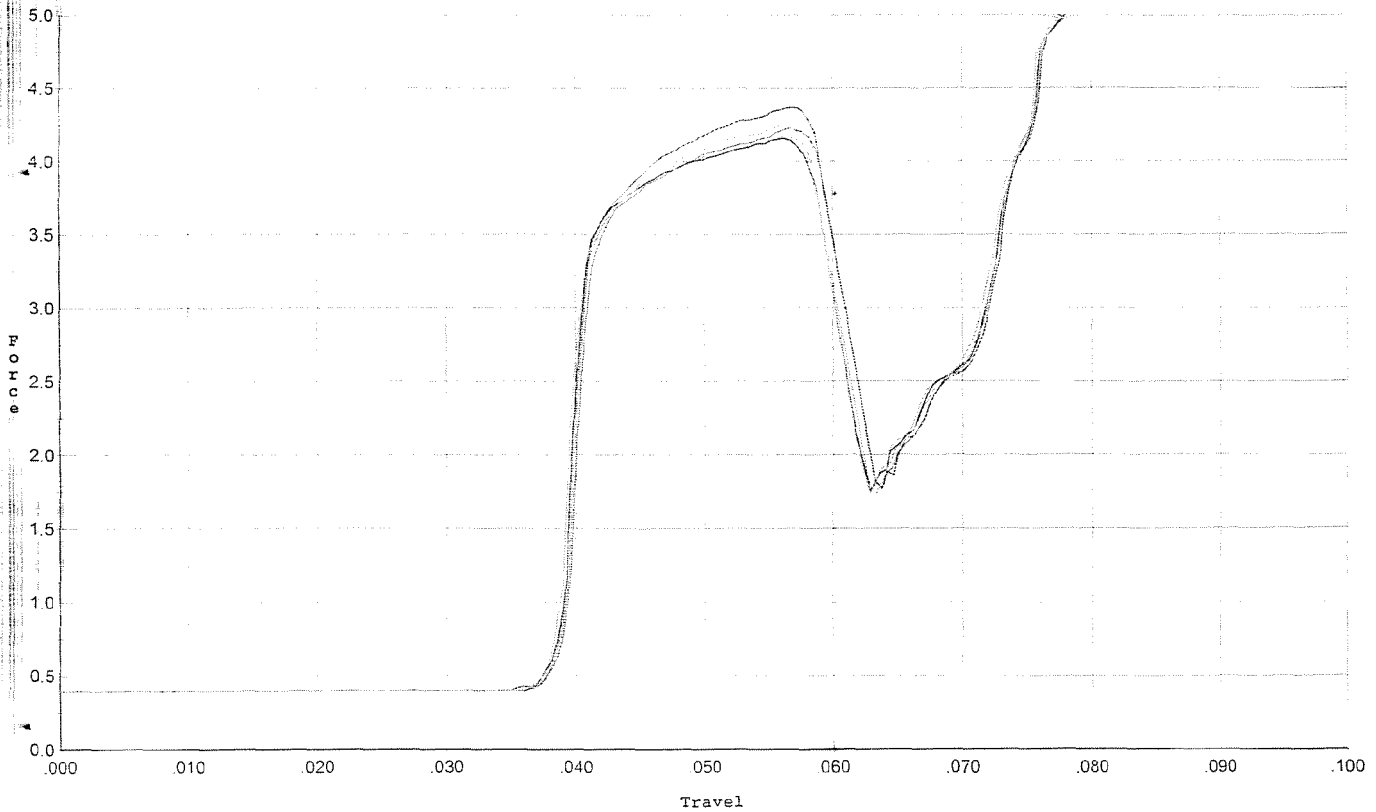
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.058	0.038	0.036	0.065		Set Trigger
2	2.692	0.058	0.039	0.037	0.064		Set Trigger
3	2.717	0.059	0.038	0.036	0.065		Set Trigger
4	2.797	0.058	0.039	0.036	0.066		Set Trigger
5	2.879	0.059	0.038	0.037	0.068		Set Trigger

A-2-76

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/15/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lb +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.372	0.059	0.038	0.033	0.096		Set Trigger
2	4.154	0.059	0.037	0.033	0.093		Set Trigger
3	4.226	0.061	0.038	0.032	0.098		Set Trigger
4	4.245	0.059	0.038	0.033	0.094		Set Trigger
5	4.172	0.058	0.038	0.033	0.093		Set Trigger

A-4.23