

66794601

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



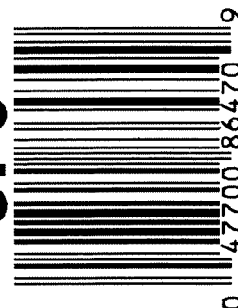
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794601

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794601

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE		10-1-08	ESN
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX JUL 02 2008 OPERATOR 17	10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/2/08	17
490	MAGNAFLUX BOLT		10-2-08	MR
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	TL
542	APPLY COATINGS (BARREL ACTION)		10-4	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-15-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

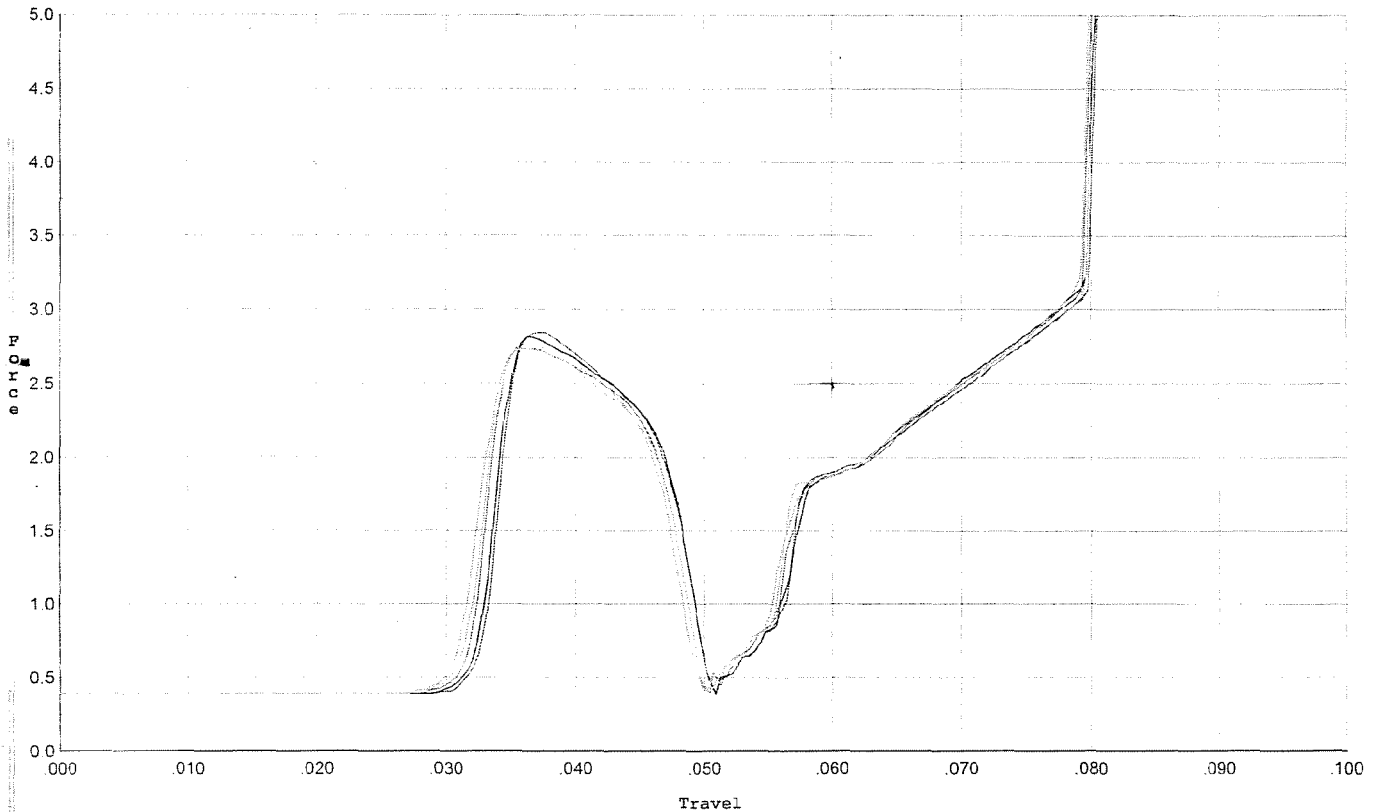
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	1-22	WN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>3.5</u> <u>4</u>	1-22	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>023</u> <u>024</u> <u>022</u>	1-22	WN
	J) ASSEMBLE STOCK		1-15-09	RT
	K) ASSEMBLE SWIVEL STUDS		1-22	WN
	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	1-20-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-20-09	WN
670	FINAL INSPECTION A) HEADSPACE		1-22	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.44</u> <u>2.53</u> <u>2.53</u> <u>2.43</u>	1-21	WN
	C) FUNCTION		1-22	WN
690	PACK		1-23-09	WN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



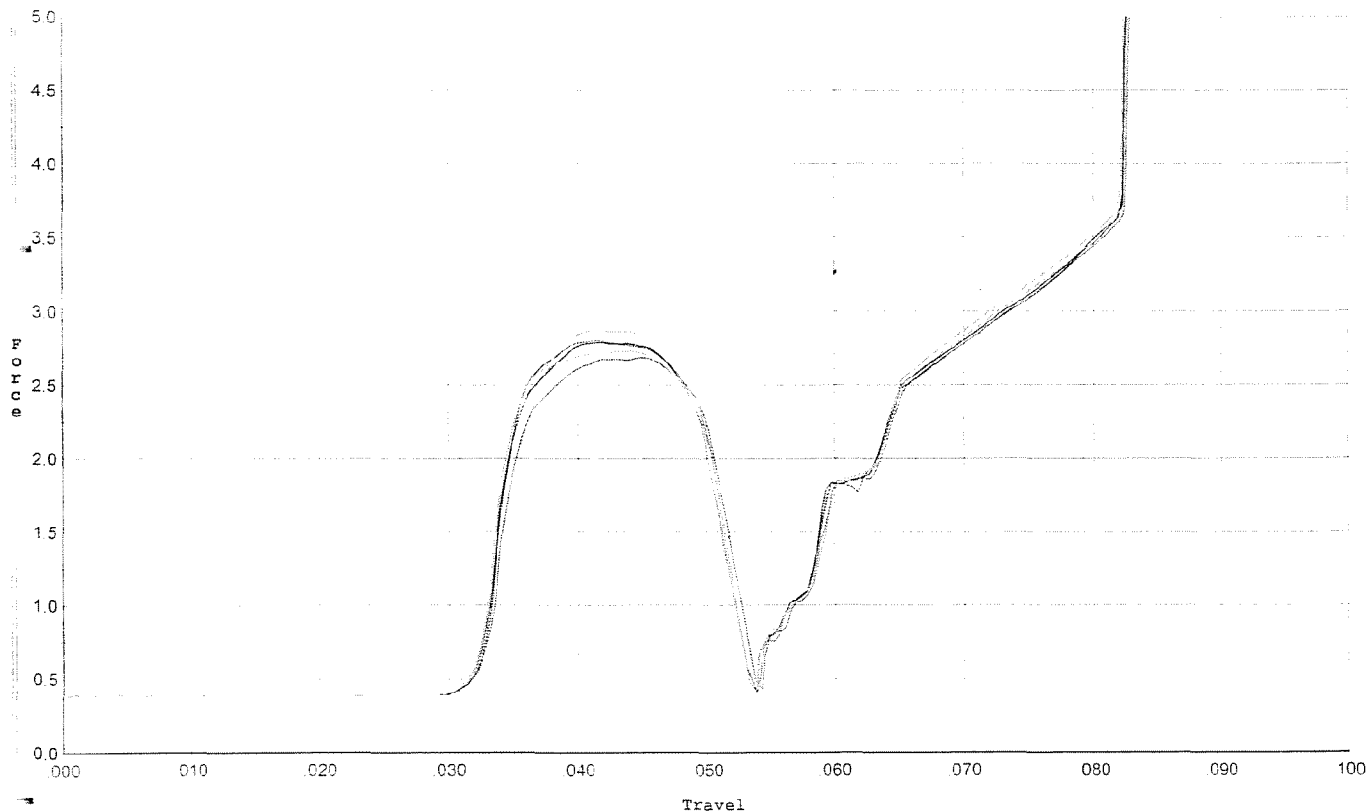
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.841	0.048	0.032	0.036	0.049		Set Trigger
2	2.814	0.048	0.032	0.035	0.049		Set Trigger
3	2.742	0.048	0.032	0.036	0.049		Set Trigger
4	2.743	0.048	0.031	0.036	0.050		Set Trigger
5	2.736	0.047	0.031	0.036	0.049		Set Trigger

A-2-77

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



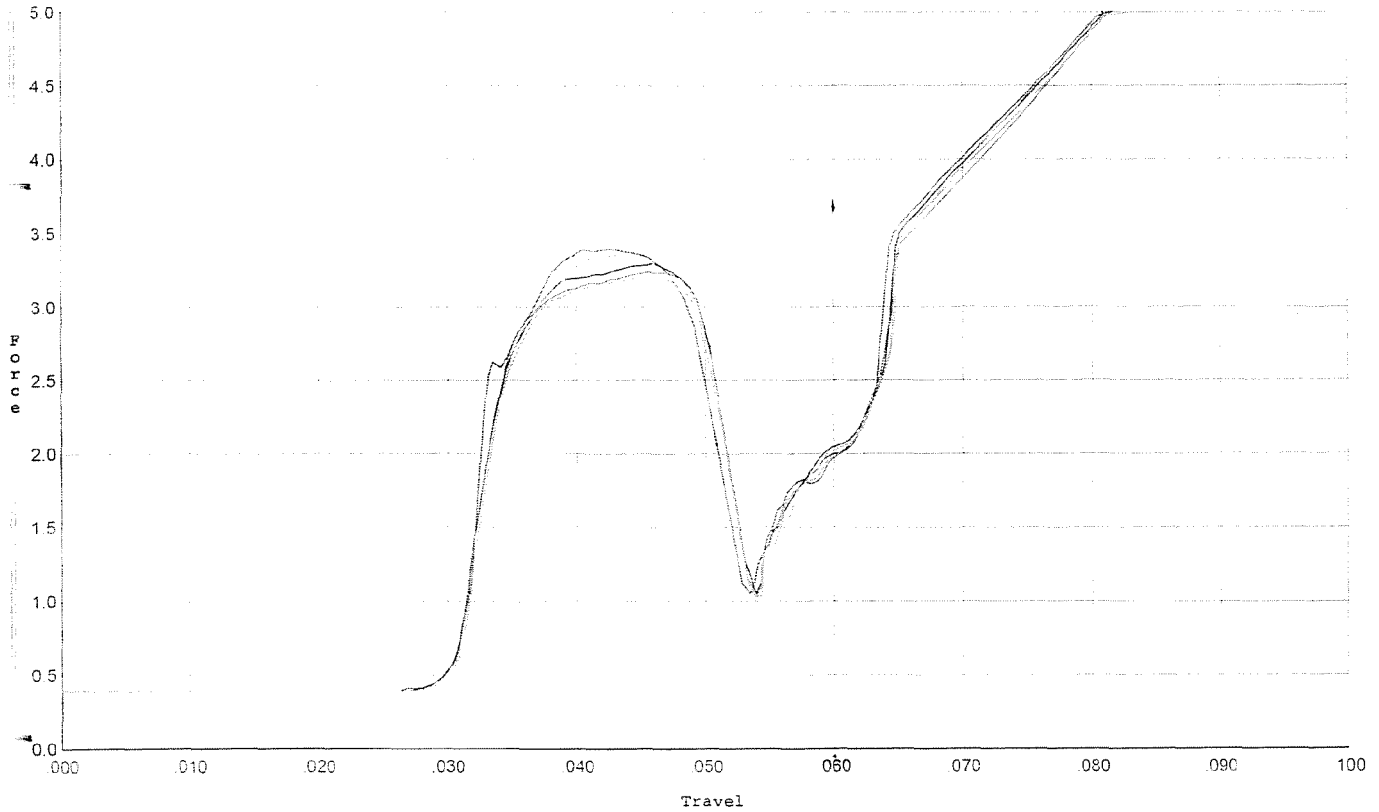
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.807	0.050	0.032	0.035	0.057		Set Trigger
2	2.793	0.051	0.032	0.036	0.058		Set Trigger
3	2.685	0.052	0.033	0.035	0.057		Set Trigger
4	2.733	0.050	0.032	0.035	0.057		Set Trigger
5	2.879	0.051	0.032	0.035	0.059		Set Trigger

A-2.77

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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



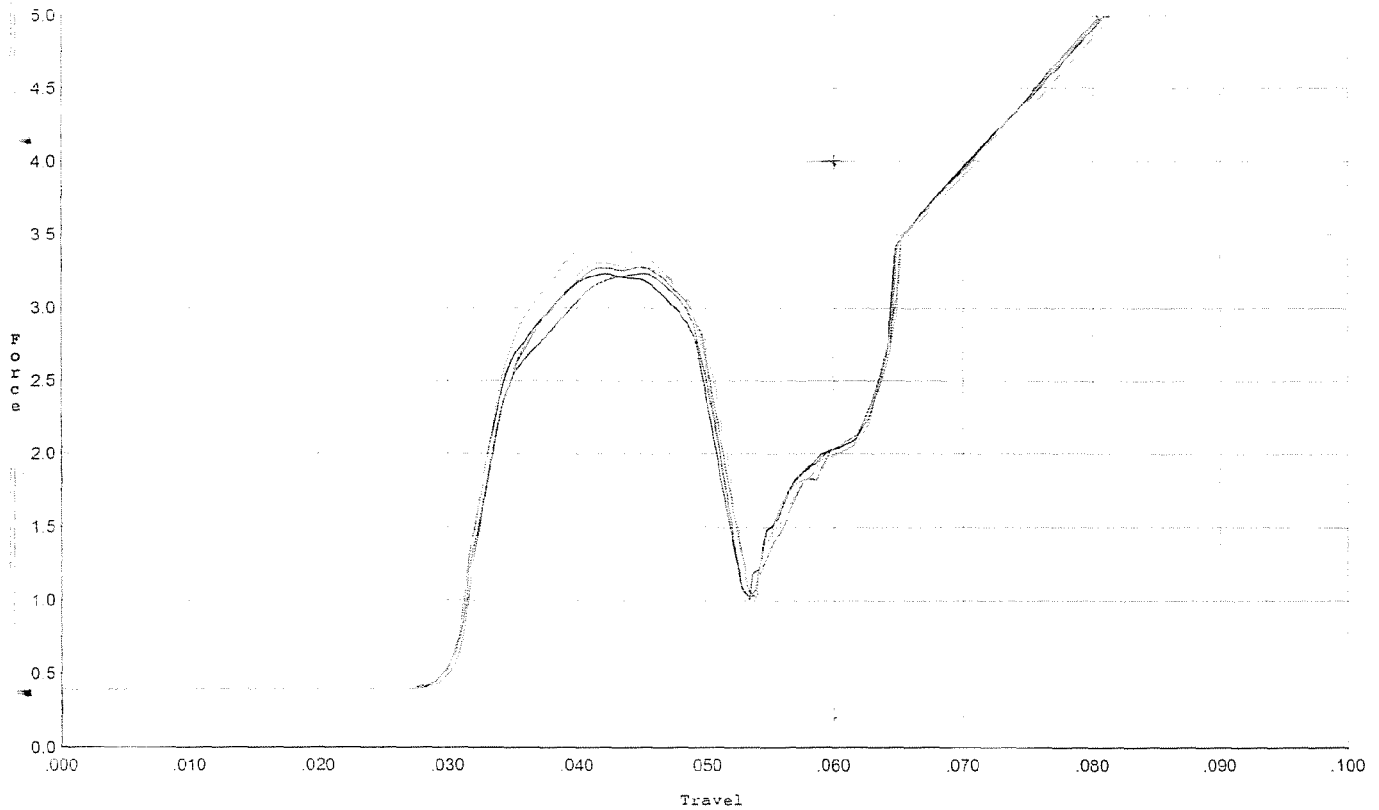
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.391	0.051	0.031	0.033	0.070		Set Trigger
2	3.293	0.050	0.031	0.034	0.069		Set Trigger
3	3.236	0.050	0.031	0.034	0.069		Set Trigger
4	3.353	0.051	0.031	0.034	0.069		Set Trigger
5	3.212	0.050	0.031	0.034	0.068		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



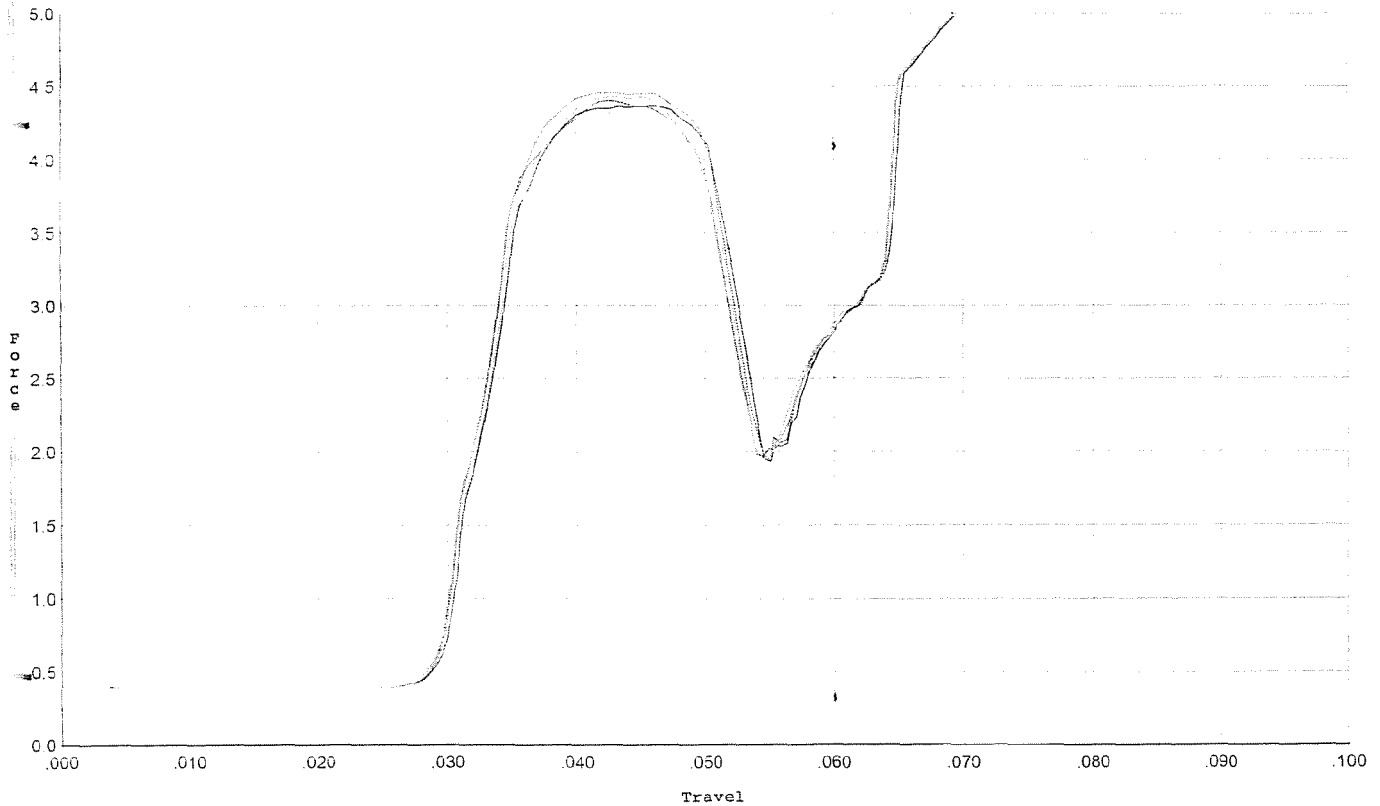
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.236	0.050	0.031	0.034	0.066		Set Trigger
2	3.233	0.049	0.031	0.034	0.065		Set Trigger
3	3.276	0.050	0.031	0.034	0.066		Set Trigger
4	3.307	0.051	0.031	0.034	0.068		Set Trigger
5	3.431	0.050	0.031	0.034	0.069		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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



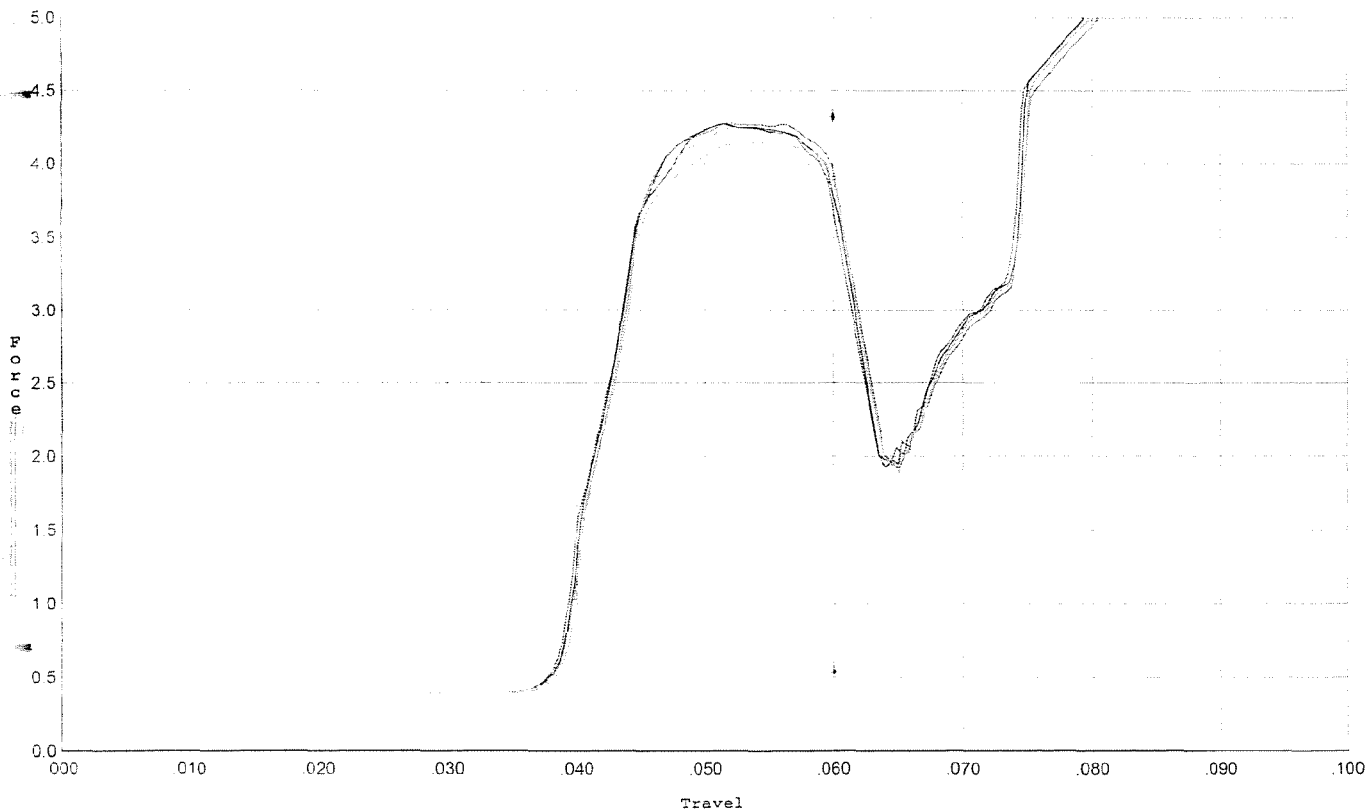
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.403	0.050	0.029	0.030	0.089		Set Trigger
2	4.371	0.052	0.030	0.029	0.093		Set Trigger
3	4.456	0.050	0.029	0.029	0.092		Set Trigger
4	4.350	0.051	0.029	0.029	0.091		Set Trigger
5	4.432	0.050	0.029	0.029	0.090		Set Trigger

A. 4.410

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



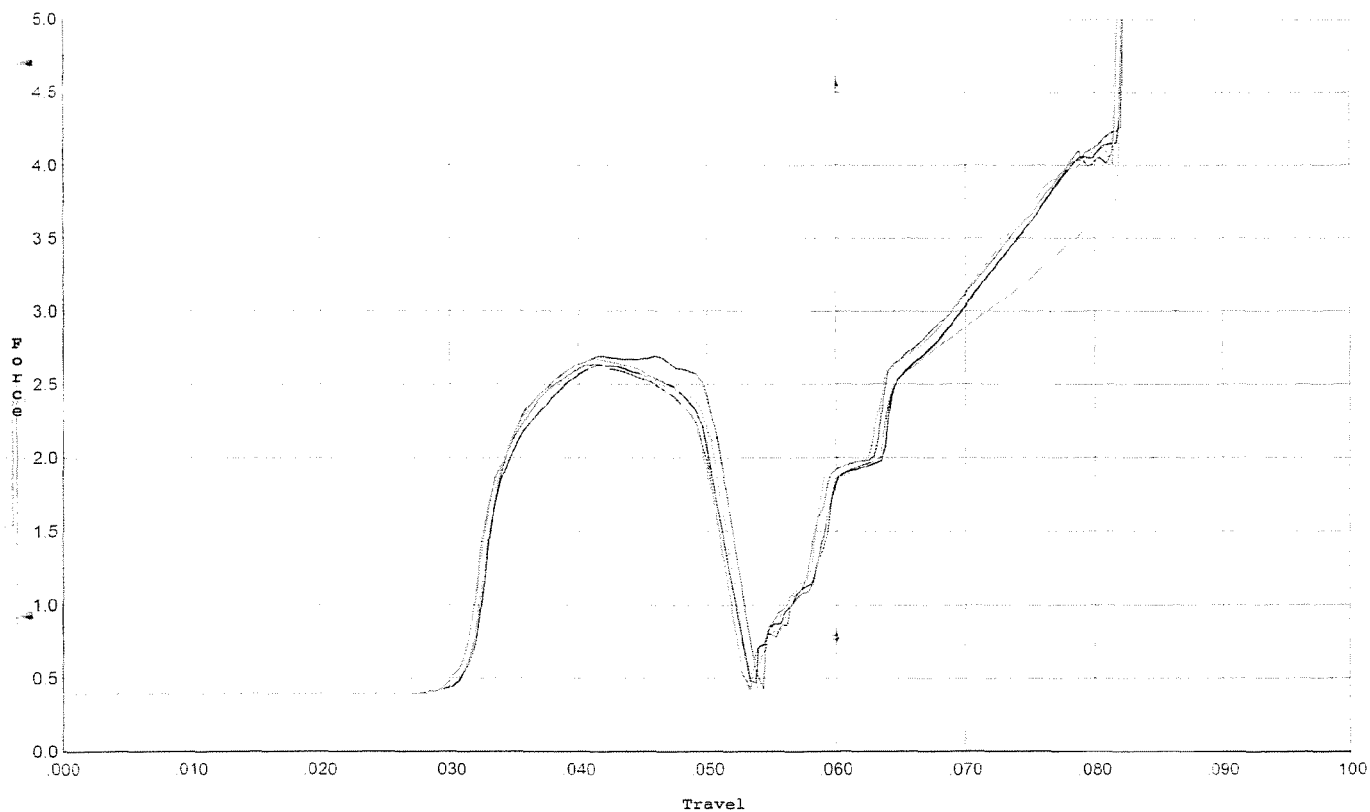
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.277	0.060	0.039	0.030	0.093		Set Trigger
2	4.278	0.061	0.039	0.029	0.095		Set Trigger
3	4.283	0.060	0.039	0.031	0.094		Set Trigger
4	4.238	0.060	0.039	0.029	0.094		Set Trigger
5	4.153	0.060	0.039	0.029	0.093		Set Trigger

4.4.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



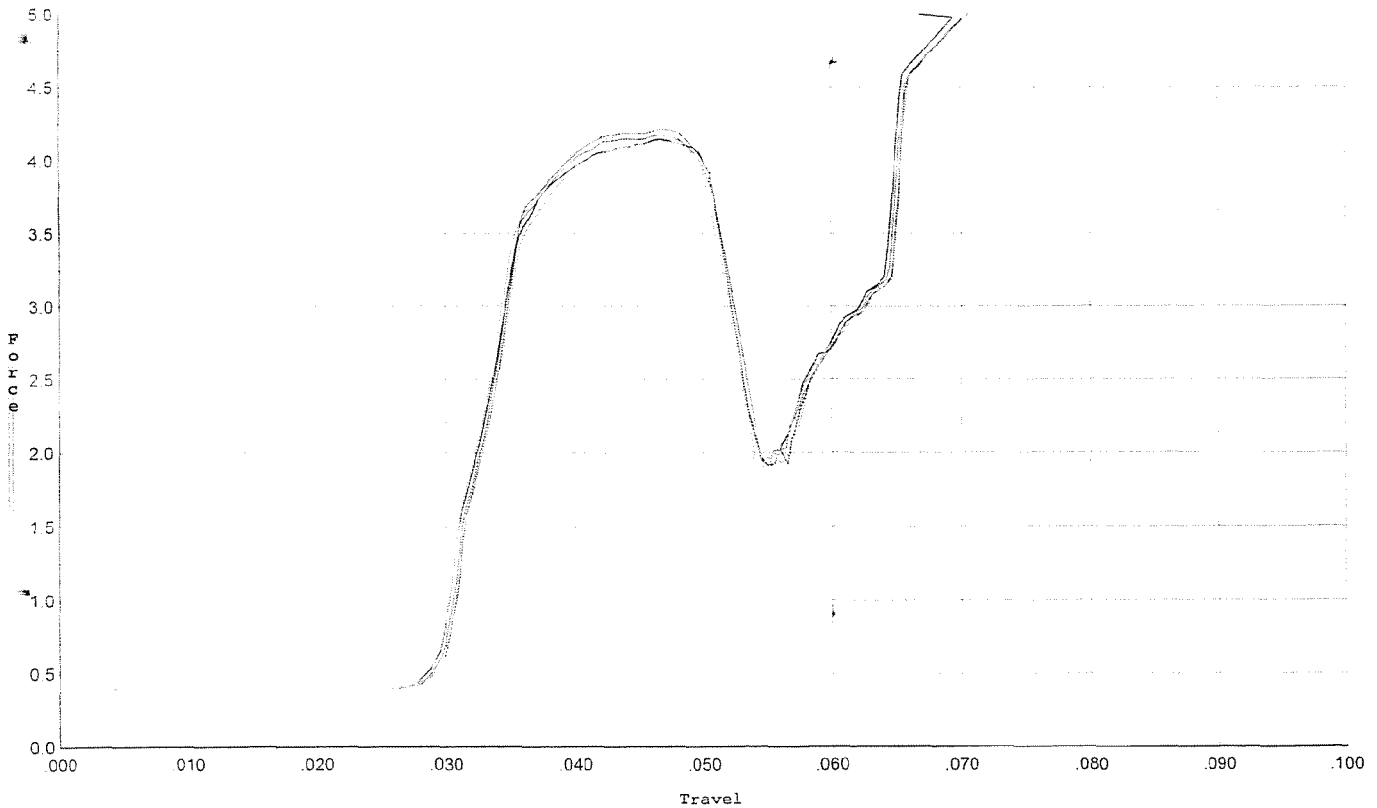
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.689	0.051	0.031	0.035	0.059		Set Trigger
2	2.630	0.050	0.031	0.036	0.054		Set Trigger
3	2.638	0.050	0.031	0.035	0.056		Set Trigger
4	2.626	0.050	0.032	0.035	0.056		Set Trigger
5	2.674	0.050	0.031	0.035	0.056		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.212	0.051	0.030	0.030	0.086		Set Trigger
2	4.145	0.051	0.030	0.029	0.087		Set Trigger
3	4.176	0.051	0.030	0.030	0.087		Set Trigger
4	4.177	0.052	0.029	0.029	0.089		Set Trigger
5	4.132	0.052	0.030	0.029	0.088		Set Trigger

A-4.16