

66794676

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



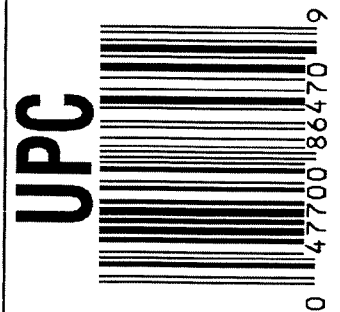
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794676



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794676

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-11-08	SPD
430	ASSEMBLE TO STOCK		11-11-08	SP
440	PROOF		11-11-08	SPD
460	CHECK HEADSPACE		11-11-08	SPD
470	DIS-ASSEMBLE ACTION		11-11-08	SPD
472	SERIALIZE BOLT HANDLE		11-12-08	RBN
475	DRILL AND TAP SIGHT HOLES		11-12-08	SP
480	MAGNAFLUX BBL ACTION	(R)	11-17-08	(R)
490	MAGNAFLUX BOLT		11/17/08	MT
500	ROLLMARK CALIBER		11/17/08	RT
520	GOFF BLAST BBL / REC		11/17/08	DG
542	APPLY COATINGS (BARREL ACTION)		1/20	~
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-14-09	RBN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

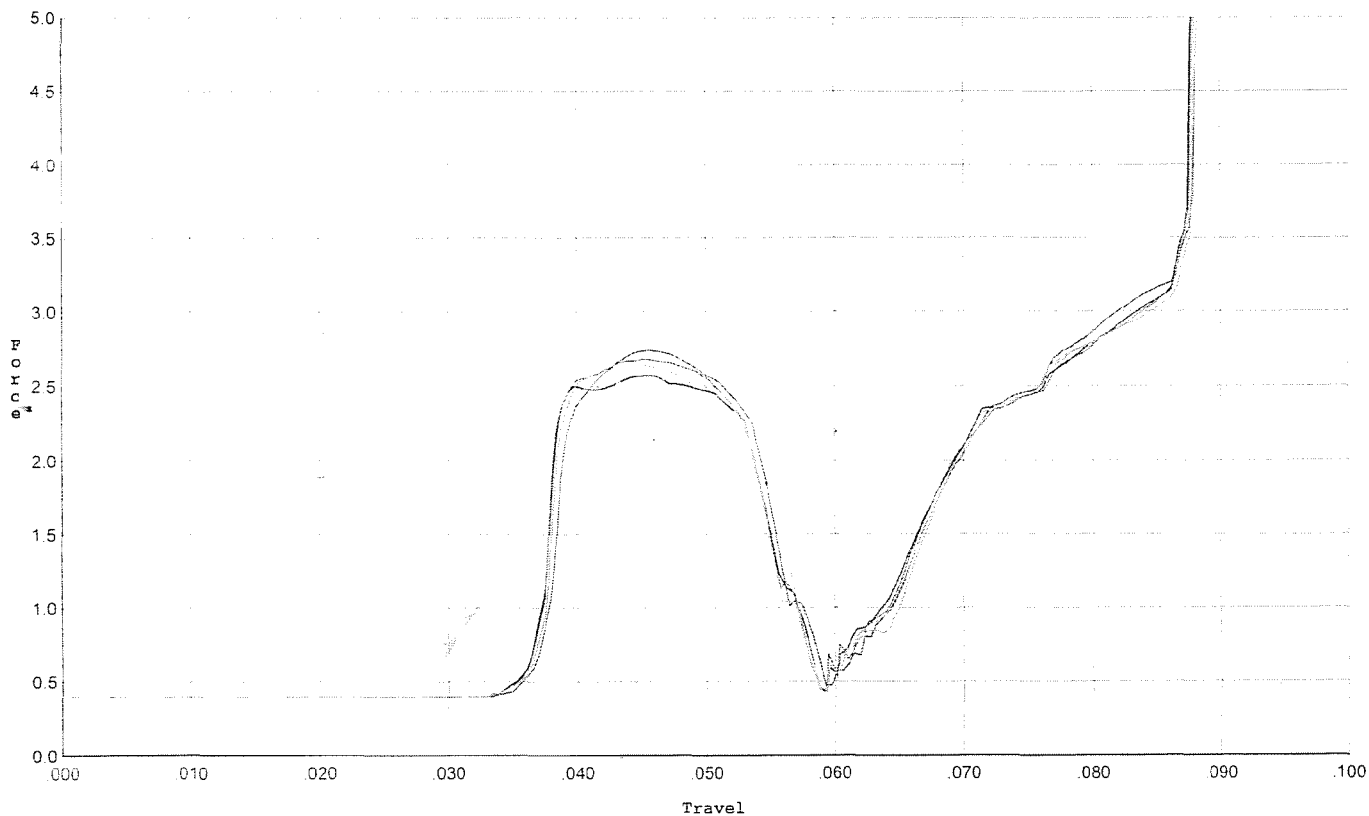
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-26-09	RN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	1-26-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-26-09	RN
	J) ASSEMBLE STOCK		1-14-09	BSW
	K) ASSEMBLE SWIVEL STUDS		1-26-09	RN
	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	RN
670	FINAL INSPECTION A) HEADSPACE		1-26-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.38</u> <u>2.42</u> <u>2.41</u> <u>2.42</u>	1-26-09	RN
	C) FUNCTION		1-26-09	RN
690	PACK		1/28/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/8/2008

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



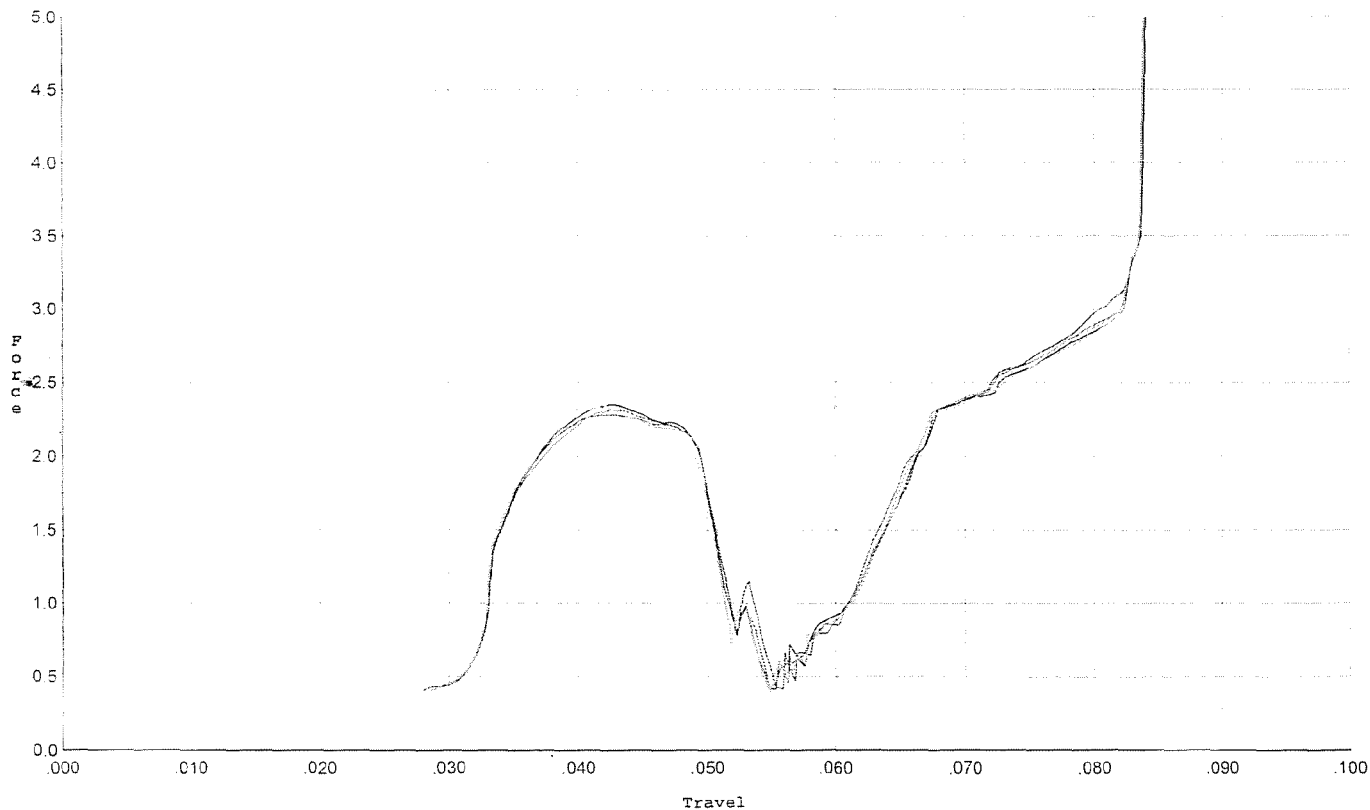
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.738	0.055	0.037	0.038	0.057		Set Trigger
2	2.572	0.054	0.036	0.038	0.056		Set Trigger
3	2.682	0.054	0.036	0.038	0.057		Set Trigger
4	2.544	0.057	0.037	0.038	0.059		Set Trigger
5	2.663	0.054	0.037	0.038	0.056		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/8/2008

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



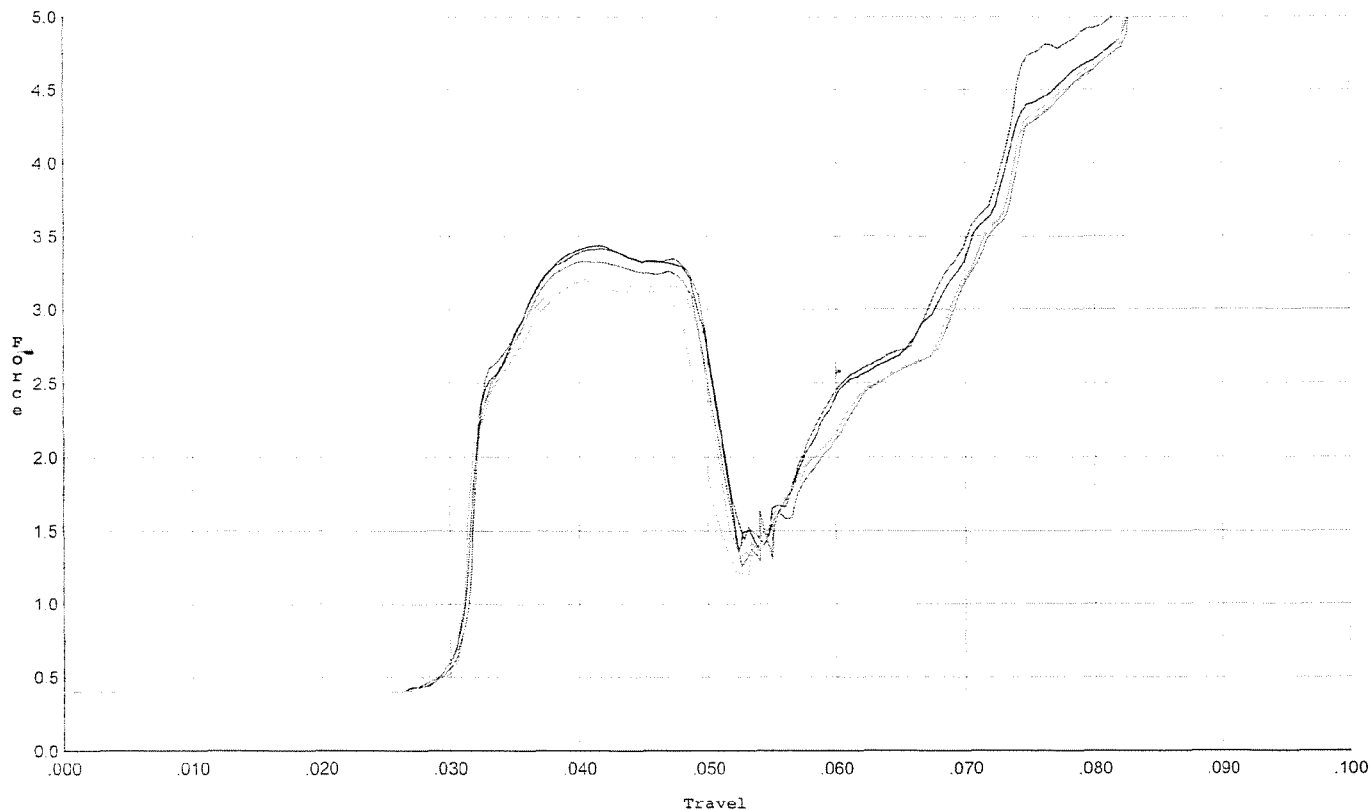
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.282	0.049	0.032	0.038	0.049		Set Trigger
2	2.348	0.049	0.032	0.038	0.049		Set Trigger
3	2.315	0.051	0.032	0.037	0.050		Set Trigger
4	2.329	0.050	0.032	0.038	0.049		Set Trigger
5	2.351	0.050	0.032	0.038	0.049		Set Trigger

9-232

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/8/2008

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

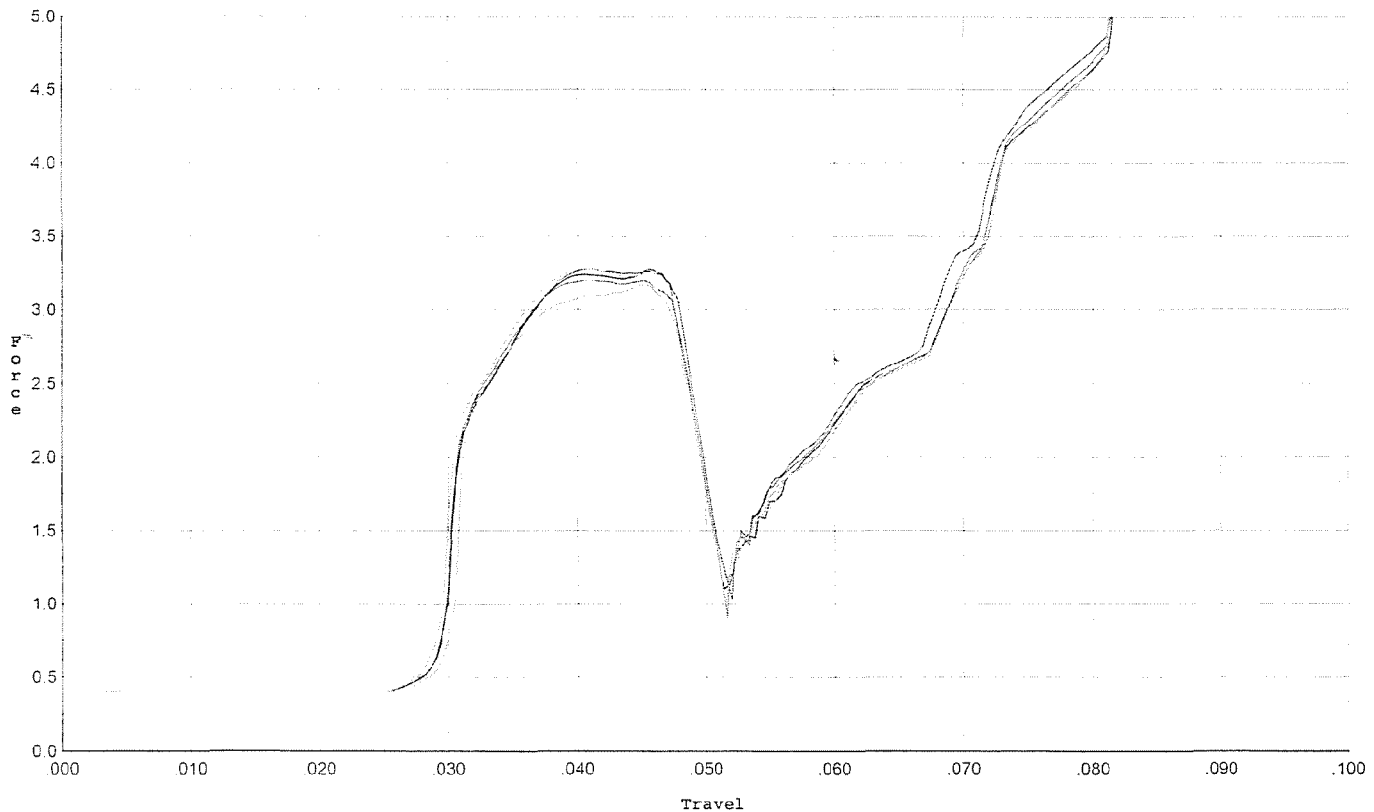


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.418	0.049	0.031	0.034	0.070		Set Trigger
2	3.435	0.050	0.030	0.034	0.071		Set Trigger
3	3.328	0.049	0.030	0.035	0.068		Set Trigger
4	3.191	0.048	0.031	0.035	0.063		Set Trigger
5	3.223	0.049	0.030	0.035	0.067		Set Trigger

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/8/2008

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



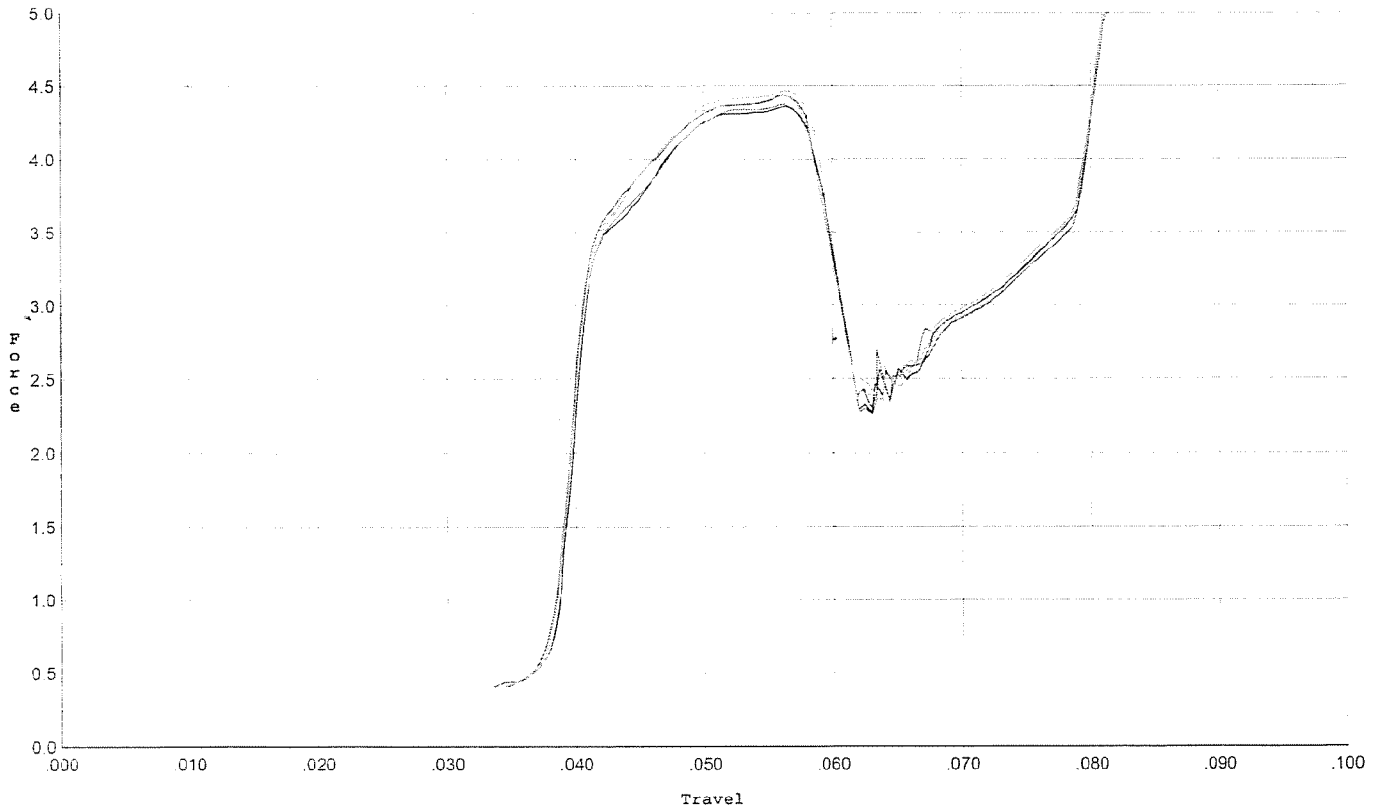
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.276	0.048	0.029	0.034	0.067		Set Trigger
2	3.260	0.049	0.029	0.034	0.068		Set Trigger
3	3.196	0.049	0.029	0.034	0.067		Set Trigger
4	3.272	0.048	0.029	0.034	0.068		Set Trigger
5	3.169	0.049	0.030	0.034	0.066		Set Trigger

4.3.23

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/8/2008

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



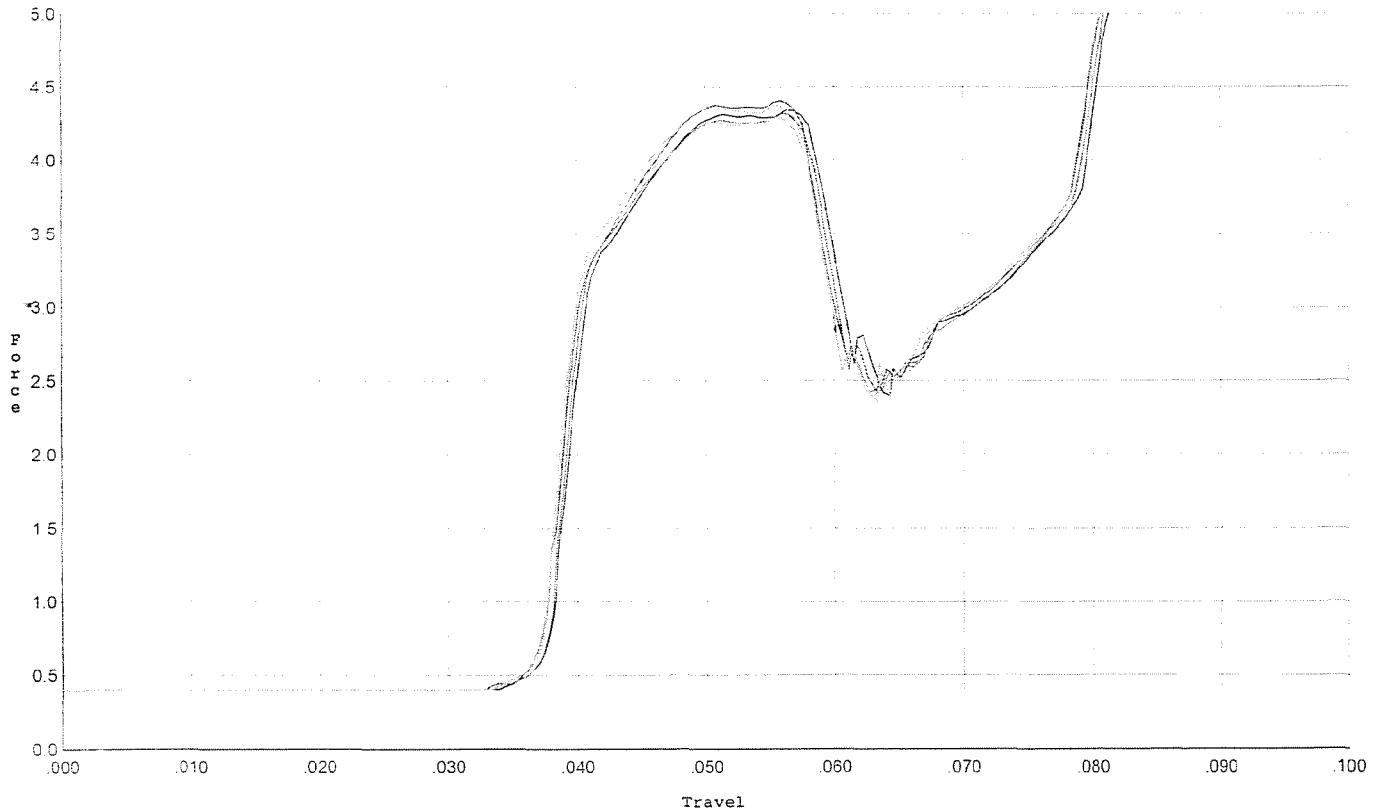
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.436	0.058	0.037	0.027	0.096		Set Trigger
2	4.364	0.059	0.038	0.026	0.097		Set Trigger
3	4.380	0.060	0.038	0.026	0.098		Se: Trigger
4	4.468	0.059	0.038	0.026	0.098		Se: Trigger
5	4.440	0.058	0.038	0.027	0.096		Set Trigger

4-4.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/8/2008

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



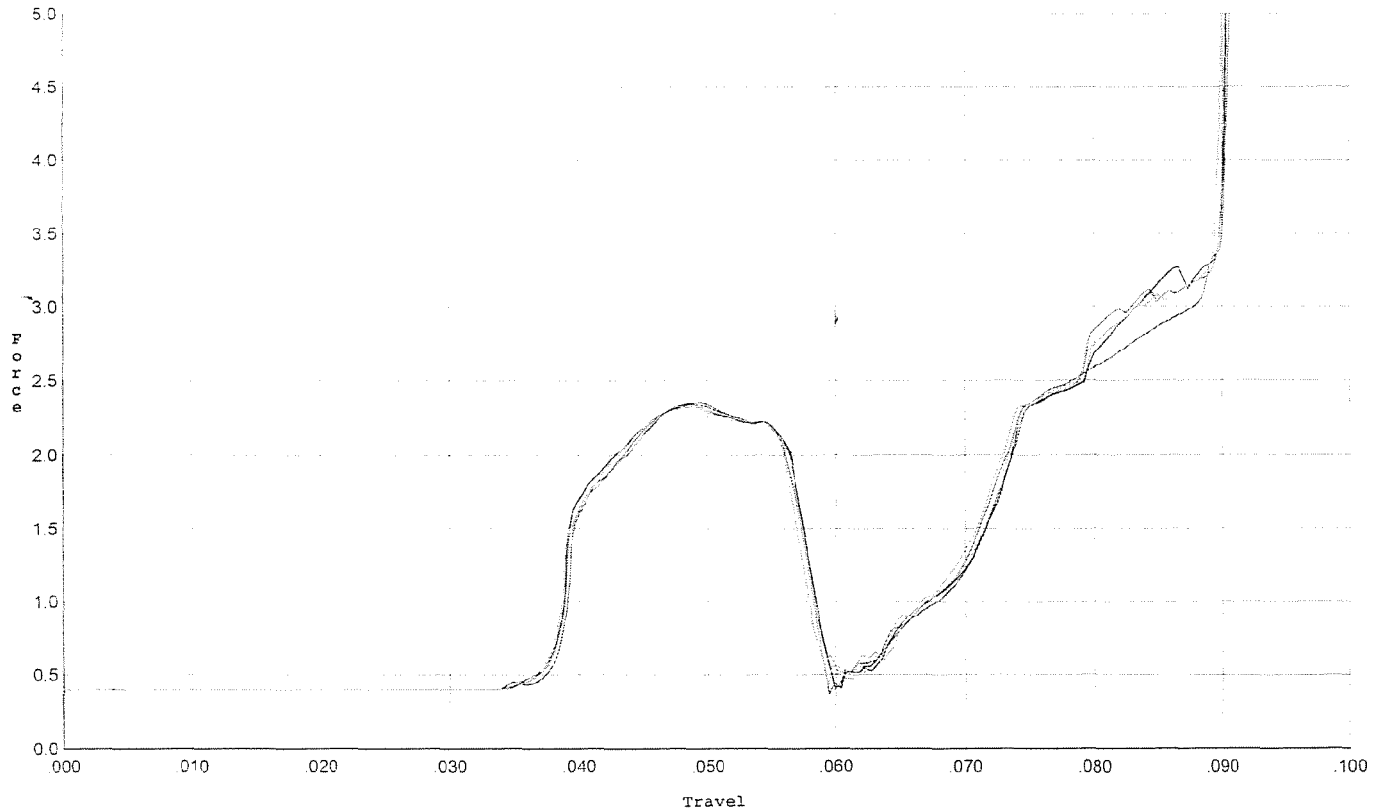
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.404	0.058	0.037	0.027	0.095		Set Trigger
2	4.345	0.059	0.037	0.027	0.098		Set Trigger
3	4.320	0.059	0.037	0.027	0.096		Set Trigger
4	4.296	0.058	0.037	0.027	0.095		Set Trigger
5	4.373	0.058	0.037	0.027	0.096		Set Trigger

4.4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/8/2008

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



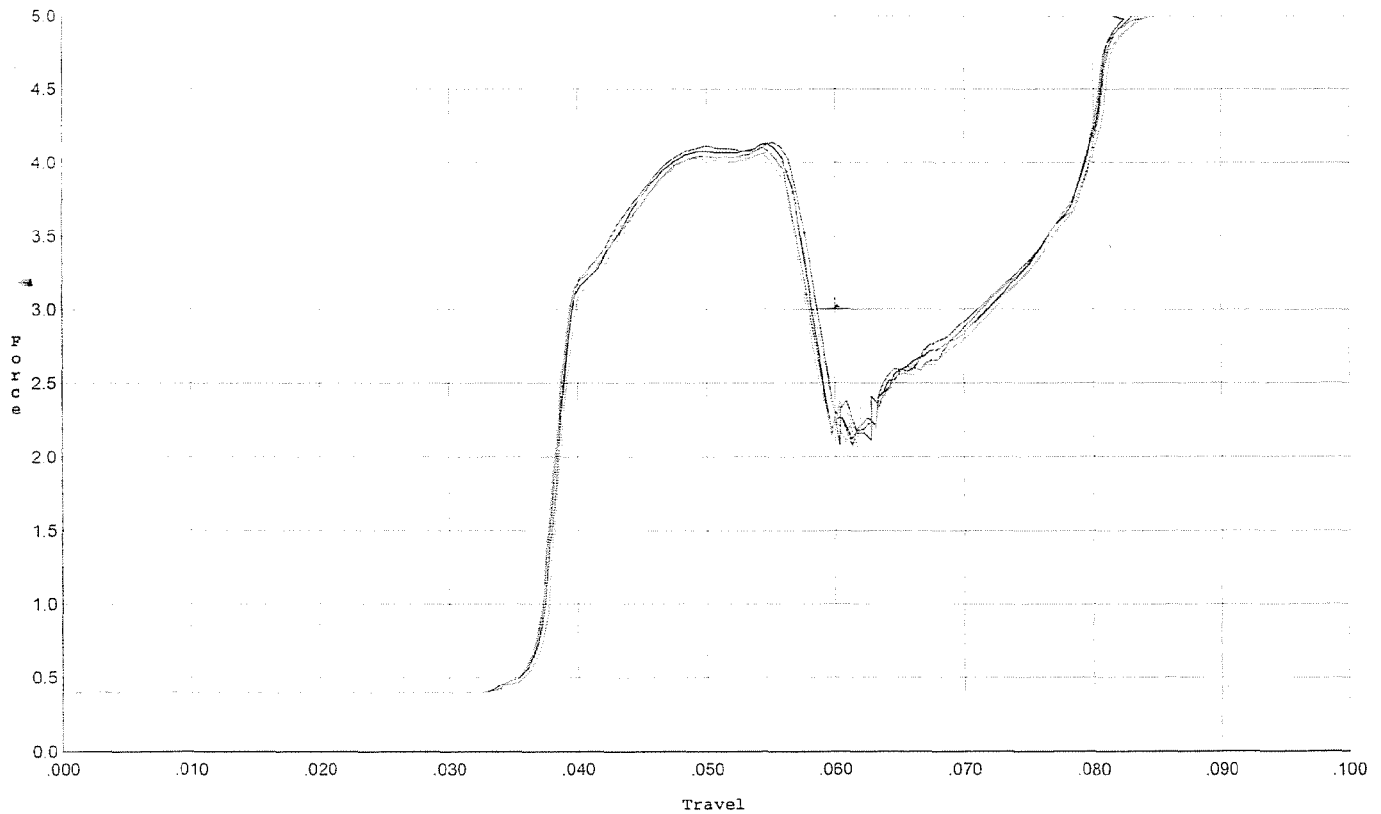
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.354	0.056	0.038	0.039	0.053		Set Trigger
2	2.328	0.056	0.038	0.039	0.054		Set Trigger
3	2.340	0.057	0.038	0.039	0.054		Set Trigger
4	2.331	0.057	0.038	0.039	0.054		Set Trigger
5	2.328	0.056	0.038	0.039	0.053		Set Trigger

12-2-33

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/8/2008

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.138	0.058	0.037	0.035	0.092		Set Trigger
2	4.130	0.057	0.037	0.035	0.089		Set Trigger
3	4.104	0.058	0.036	0.035	0.090		Set Trigger
4	4.062	0.056	0.037	0.036	0.087		Set Trigger
5	4.074	0.057	0.037	0.036	0.087		Set Trigger

4.4.10