

G679 4695

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



BM FORM

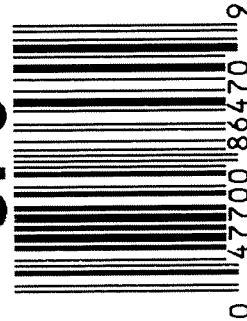
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794695

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794695

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-4-08	SP
430	ASSEMBLE TO STOCK		11-4-08	SP
440	PROOF		11-4-08	SP
460	CHECK HEADSPACE		11-4-08	SP
470	DIS-ASSEMBLE ACTION		11-4-08	SP
472	SERIALIZE BOLT HANDLE		11-5-08	Rsn
475	DRILL AND TAP SIGHT HOLES		11-5-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	11/6/08	
490	MAGNAFLUX BOLT		11/6/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/9/08	DK
542	APPLY COATINGS (BARREL ACTION)		11-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-24-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-24-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-24-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-20-09	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

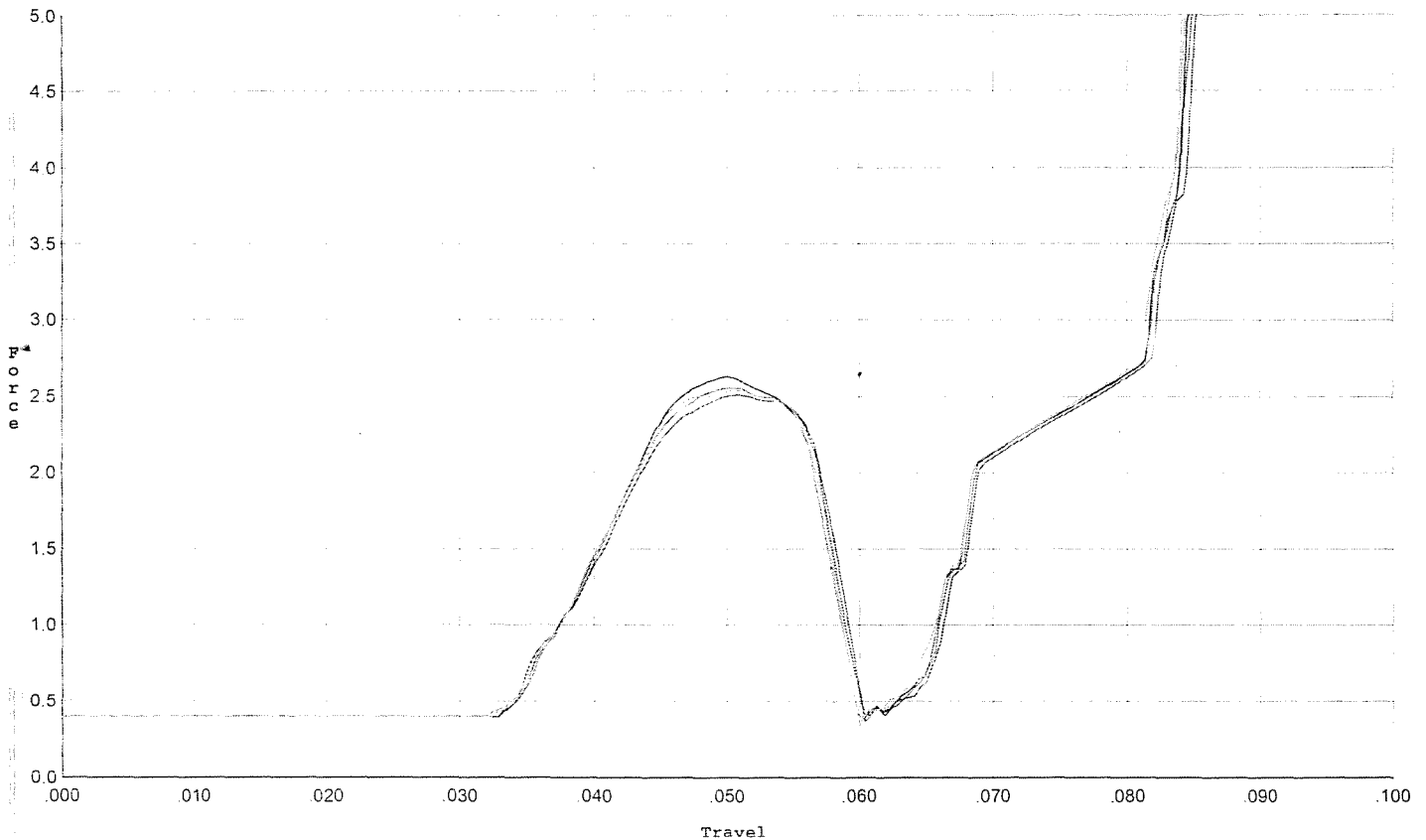
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.9</u> <u>4.9</u> <u>3.9</u>	2-5-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	2-5-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.033</u> <u>.033</u> <u>.033</u>	2-5-09	LN
	J) ASSEMBLE STOCK		1-20-09	RGN
	K) ASSEMBLE SWIVEL STUDS		2-5-09	LN
	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	1-28-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-28-09	WV
670	FINAL INSPECTION A) HEADSPACE		2-5-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>3.64</u> <u>3.74</u> <u>3.59</u> <u>2.63</u>	2-2-09	WV
	C) FUNCTION		2-5-09	LN
690	PACK		2-19-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



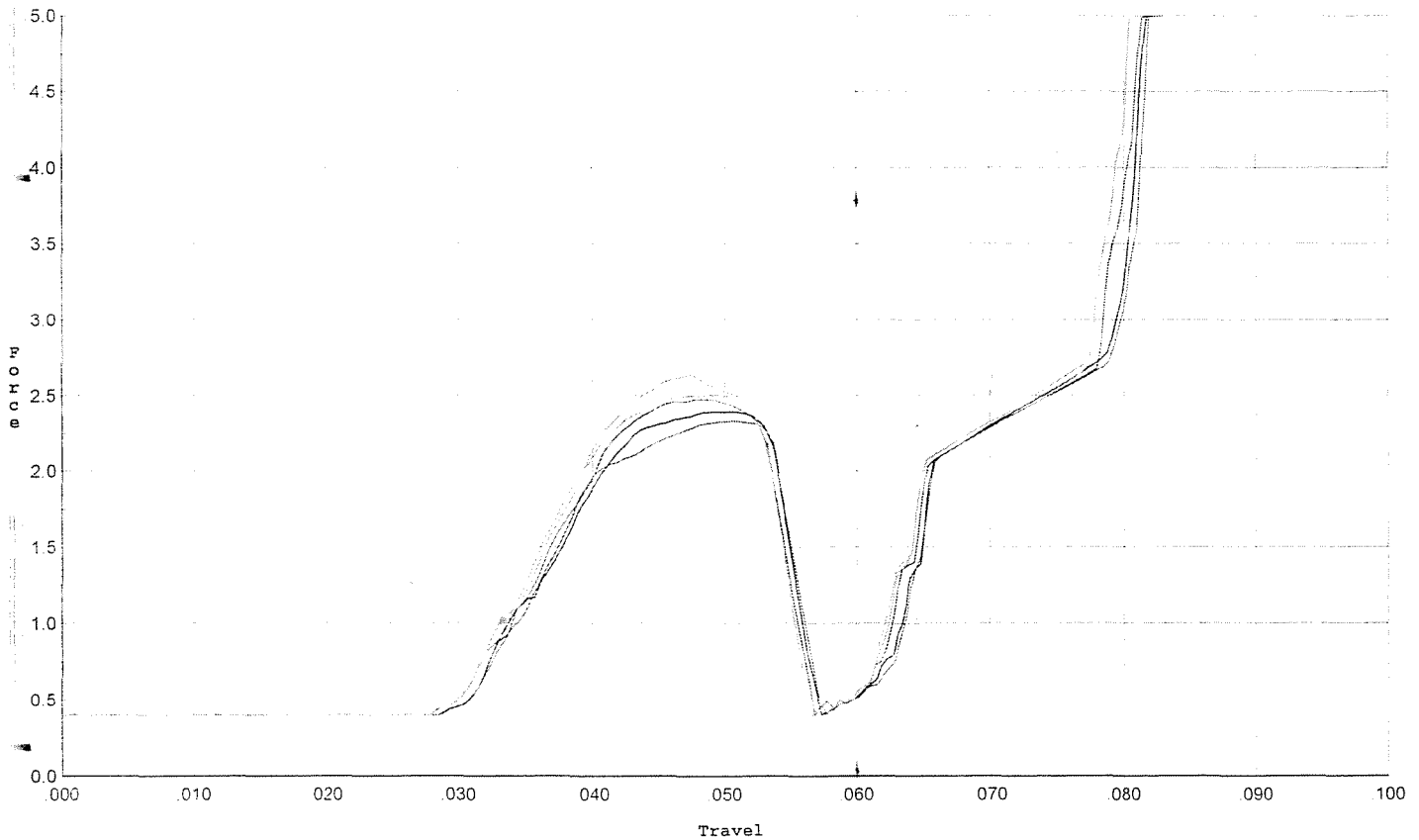
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.058	0.035	0.034	0.059		Set Trigger
2	2.631	0.058	0.035	0.034	0.060		Set Trigger
3	2.558	0.057	0.035	0.034	0.058		Set Trigger
4	2.536	0.057	0.035	0.033	0.058		Set Trigger
5	2.557	0.058	0.035	0.034	0.059		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



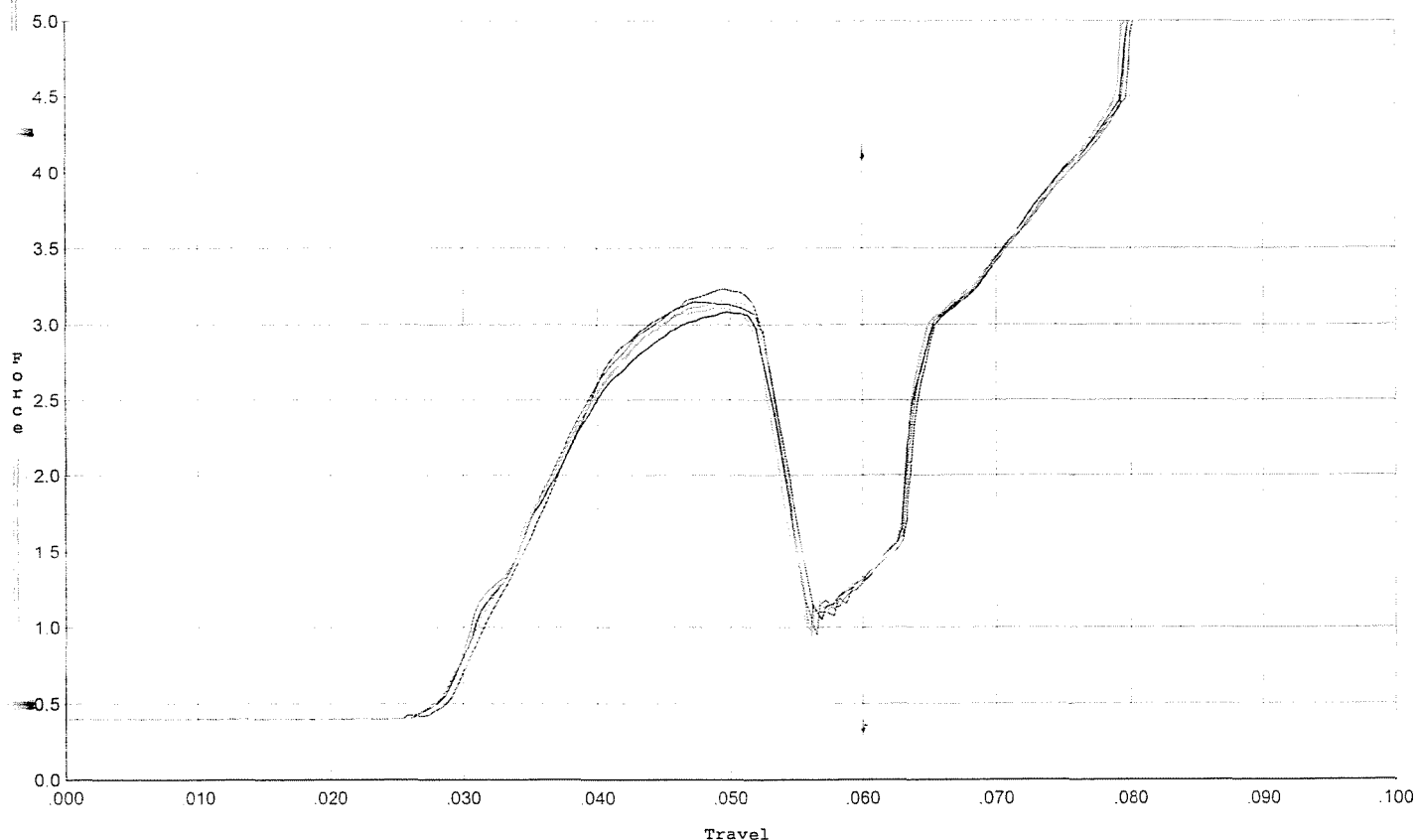
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.053	0.031	0.034	0.056		Set Trigger
2	2.397	0.054	0.032	0.033	0.055		Set Trigger
3	2.331	0.054	0.032	0.033	0.055		Set Trigger
4	2.641	0.053	0.031	0.033	0.058		Set Trigger
5	2.509	0.053	0.031	0.032	0.057		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



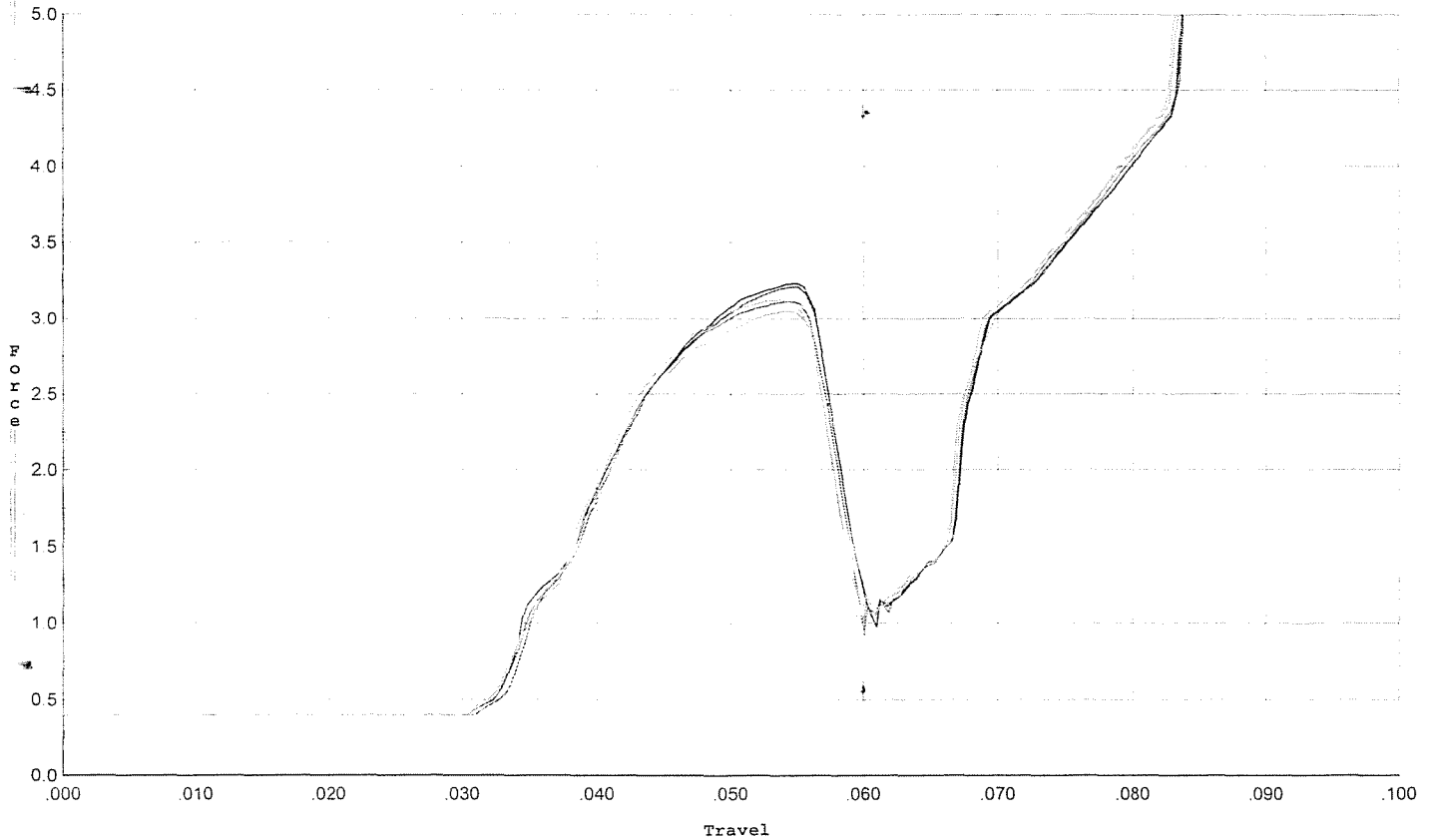
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.053	0.030	0.032	0.068		Set Trigger
2	3.084	0.053	0.029	0.031	0.068		Set Trigger
3	3.233	0.053	0.029	0.031	0.069		Set Trigger
4	3.109	0.052	0.029	0.031	0.067		Set Trigger
5	3.156	0.053	0.029	0.031	0.068		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



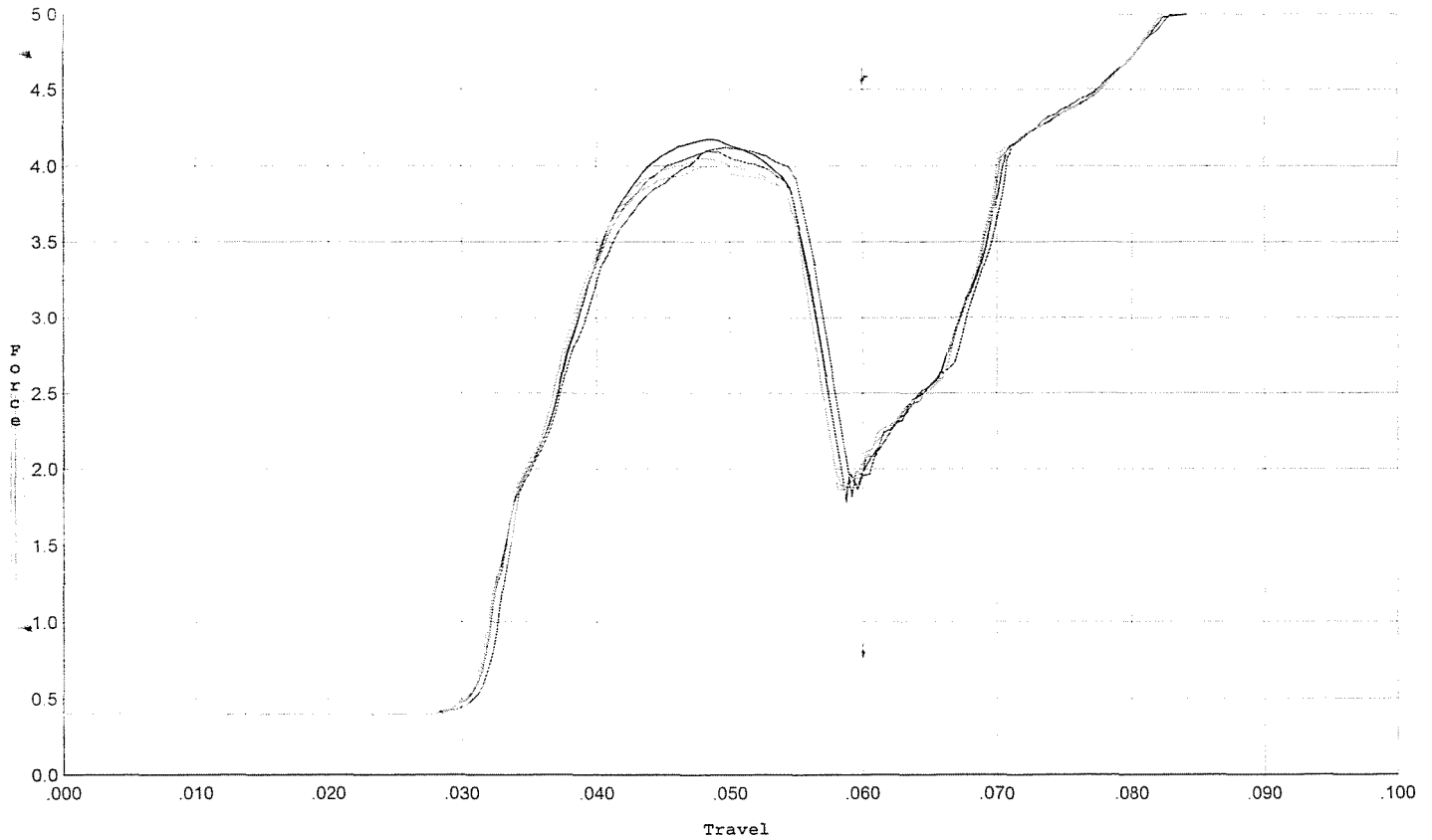
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.210	0.056	0.034	0.032	0.069		Set Trigger
2	3.231	0.056	0.033	0.032	0.070		Set Trigger
3	3.114	0.057	0.033	0.032	0.070		Set Trigger
4	3.050	0.056	0.033	0.032	0.067		Set Trigger
5	3.124	0.056	0.033	0.032	0.069		Set Trigger

AVG 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



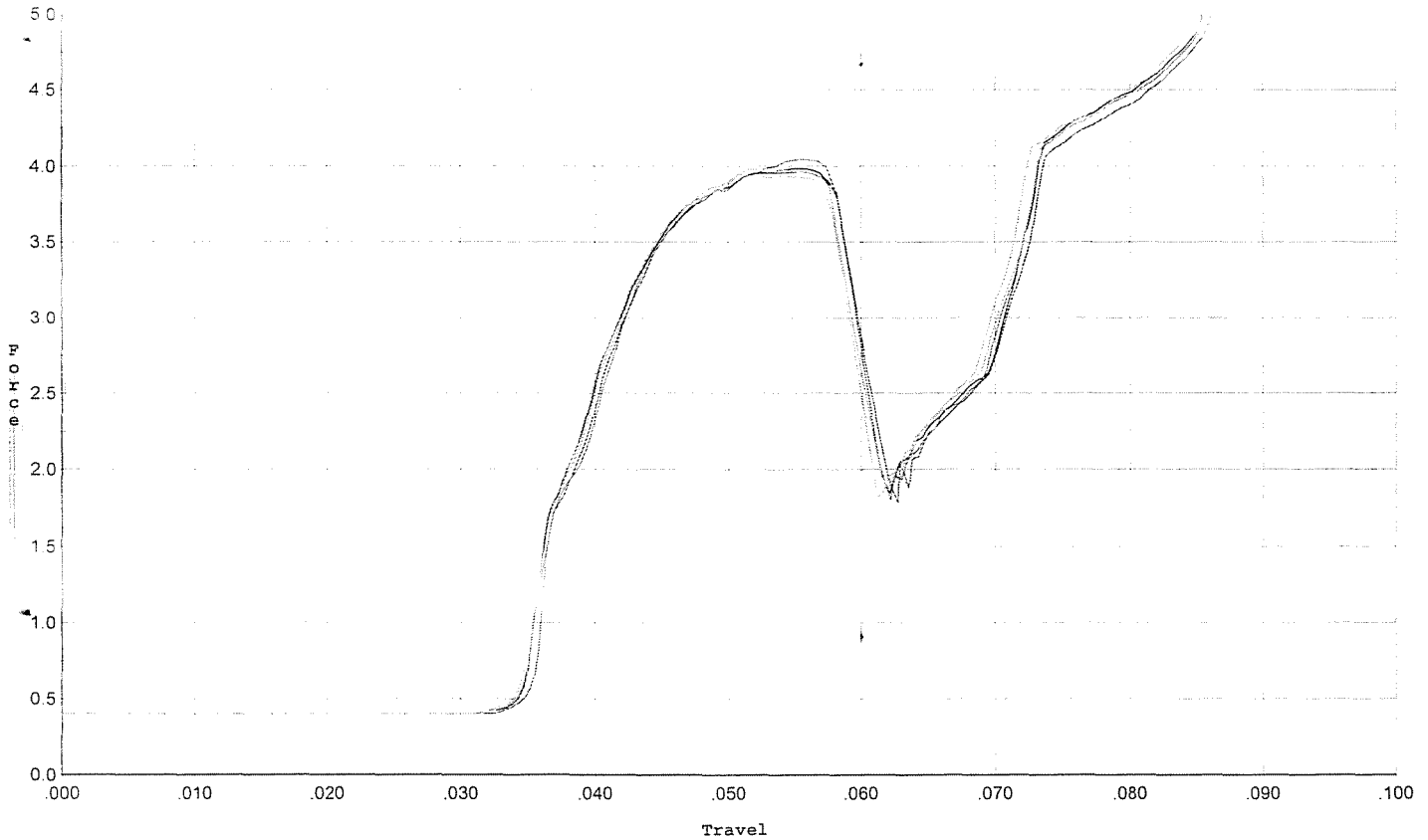
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.056	0.032	0.031	0.095		Set Trigger
2	4.175	0.056	0.031	0.031	0.095		Set Trigger
3	4.094	0.056	0.031	0.031	0.095		Set Trigger
4	4.051	0.055	0.031	0.031	0.092		
5	4.001	0.055	0.031	0.031	0.091		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



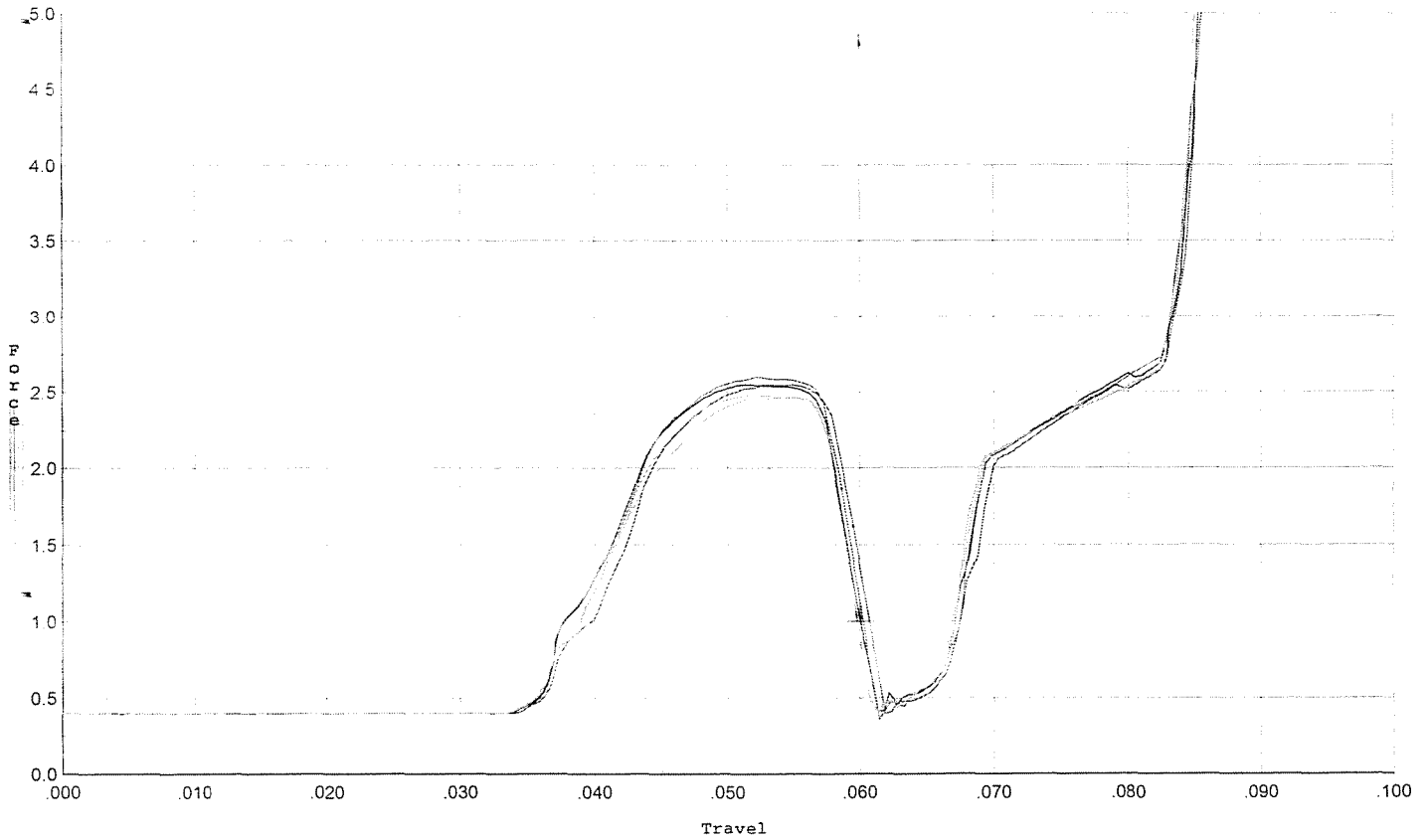
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.966	0.058	0.035	0.031	0.091		Set Trigger
2	3.986	0.058	0.035	0.031	0.091		Set Trigger
3	4.047	0.058	0.035	0.031	0.092		Set Trigger
4	3.980	0.058	0.035	0.031	0.091		Set Trigger
5	3.949	0.058	0.035	0.030	0.092		Set Trigger

Aug 3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



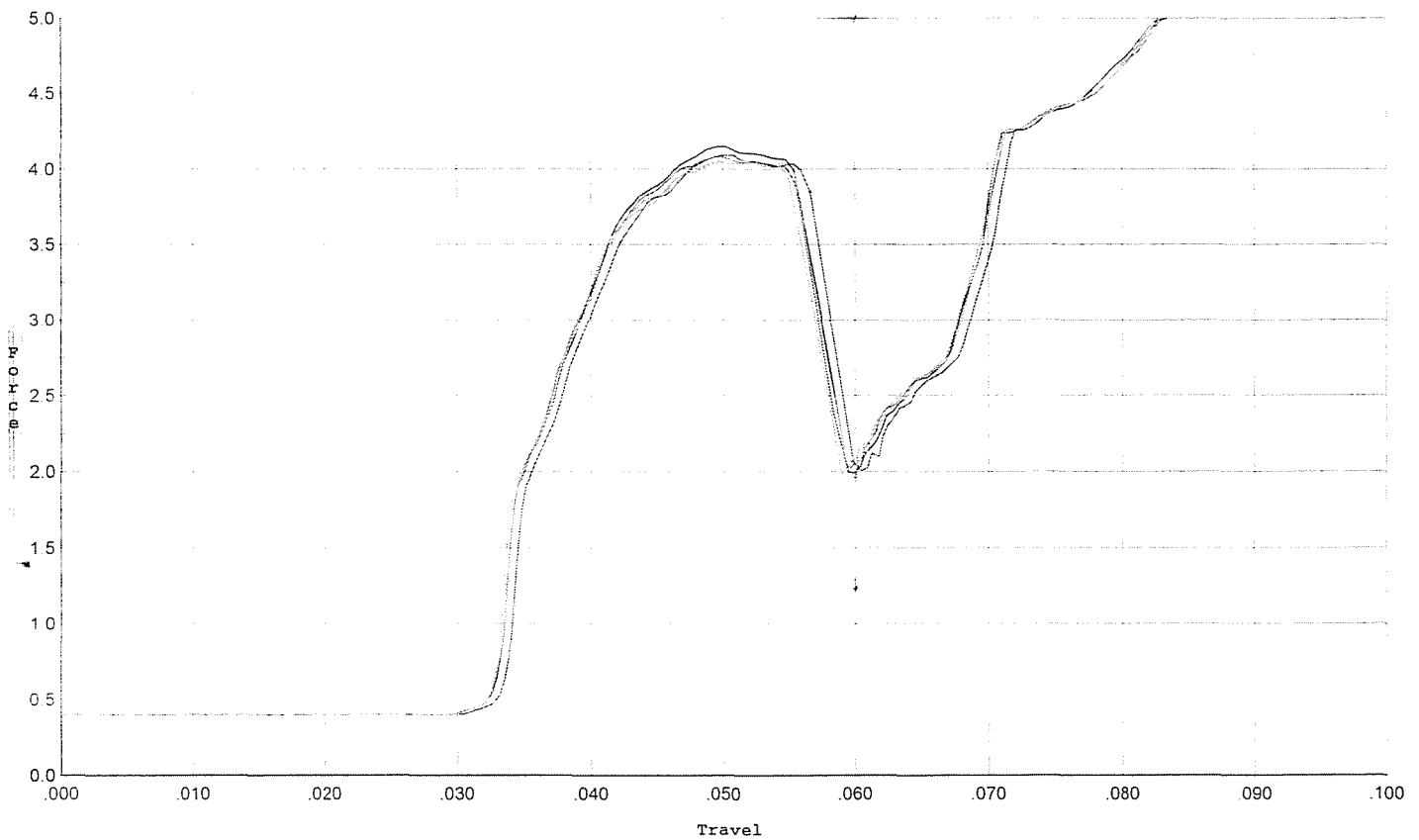
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.060	0.037	0.033	0.060		Set Trigger
2	2.550	0.057	0.037	0.034	0.059		Set Trigger
3	2.599	0.059	0.037	0.033	0.061		Set Trigger
4	2.461	0.058	0.036	0.033	0.057		Set Trigger
5	2.484	0.058	0.036	0.033	0.058		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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	4.091	0.057	0.034	0.030	0.094		Set Trigger
2	4.149	0.057	0.033	0.030	0.096		Set Trigger
3	4.082	0.056	0.033	0.031	0.093		Set Trigger
4	4.064	0.055	0.033	0.031	0.092		Set Trigger
5	4.048	0.057	0.033	0.030	0.094		Set Trigger

Avg 4.08