

G6794741

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

- INSTRUCTION BOOK 3518

BM FORM

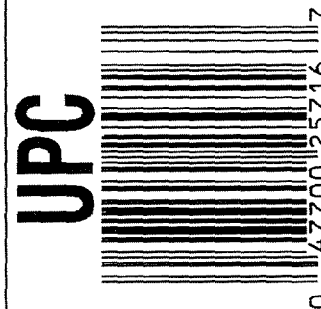


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794741



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794741

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-11-09	RJZ
430	ASSEMBLE TO STOCK		3-11-09	RJZ
440	PROOF		3-11-09	TL
460	CHECK HEADSPACE		3-11-09	TL
470	DIS-ASSEMBLE ACTION		3-11-09	RJZ
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-11-09	RJZ
475	DRILL AND TAP SIGHT HOLES		3-11-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/13/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-21-09	X NJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

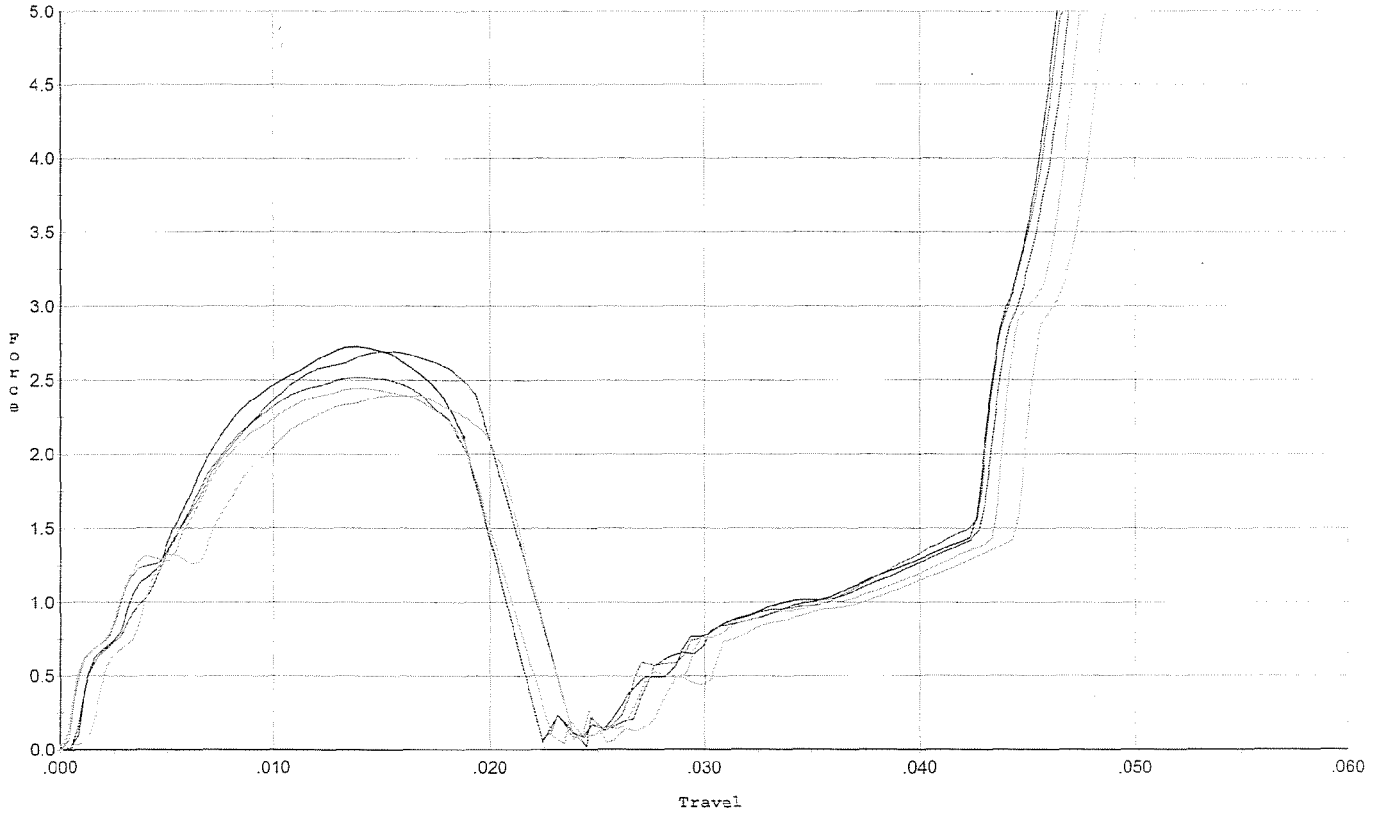
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	5-7-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	5-7-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-7-09	LJ
	J) ASSEMBLE STOCK		4-21-09	RP
	K) ASSEMBLE SWIVEL STUDS		5-7-09	LJ
	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	4-21-09	RP
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-21-09	RP
670	FINAL INSPECTION A) HEADSPACE		5-7-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.75</u> <u>2.79</u> <u>2.65</u> <u>2.65</u>	4-22-09	WW
	C) FUNCTION		5-7-09	LJ
690	PACK		5/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



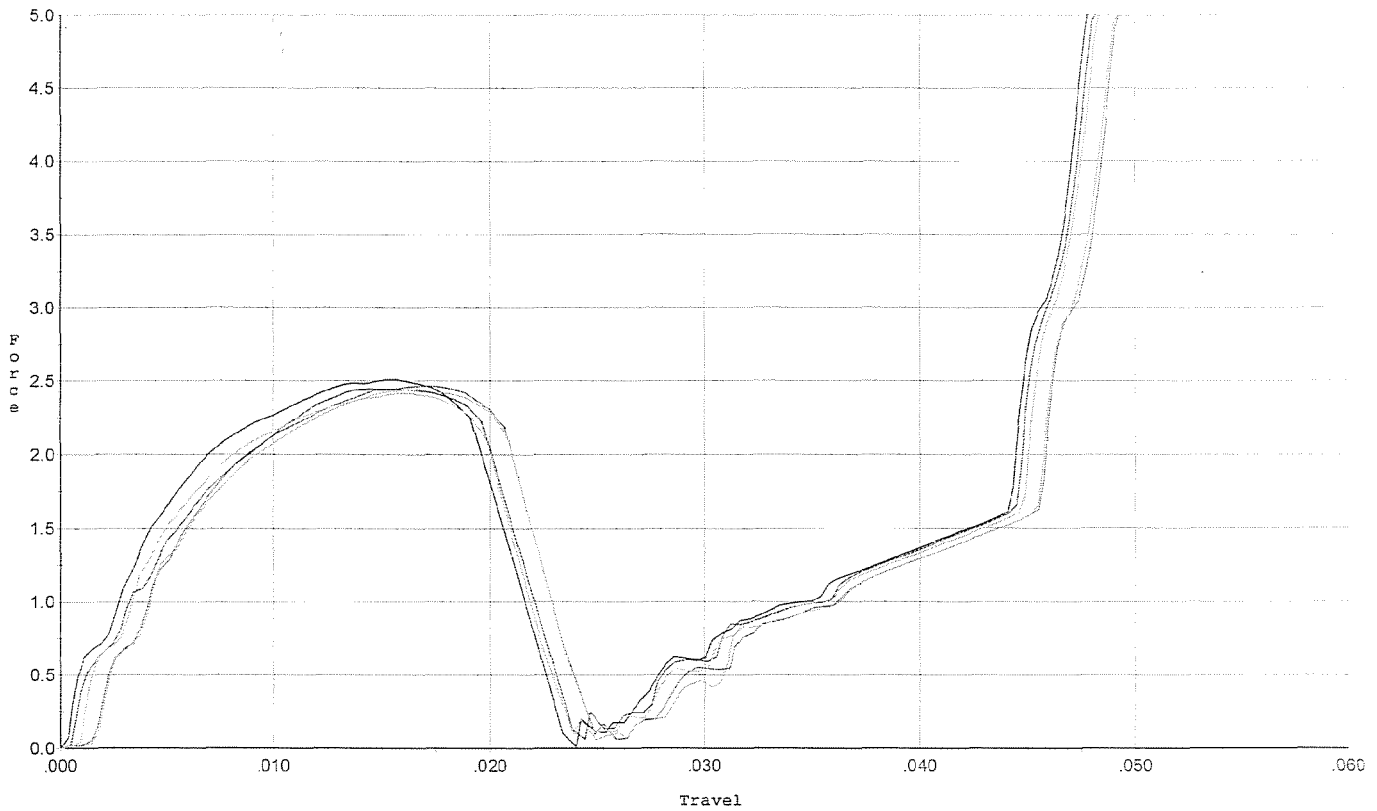
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.689	0.021	0.00	0.032	0.039		Set Trigger
2	2.726	0.019	0.00	0.033	0.035		Set Trigger
3	2.517	0.019	0.00	0.033	0.034		Set Trigger
4	2.397	0.021	0.007	0.034	0.033		Set Trigger
5	2.442	0.019	0.005	0.034	0.033		Set Trigger

A-2-SS

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



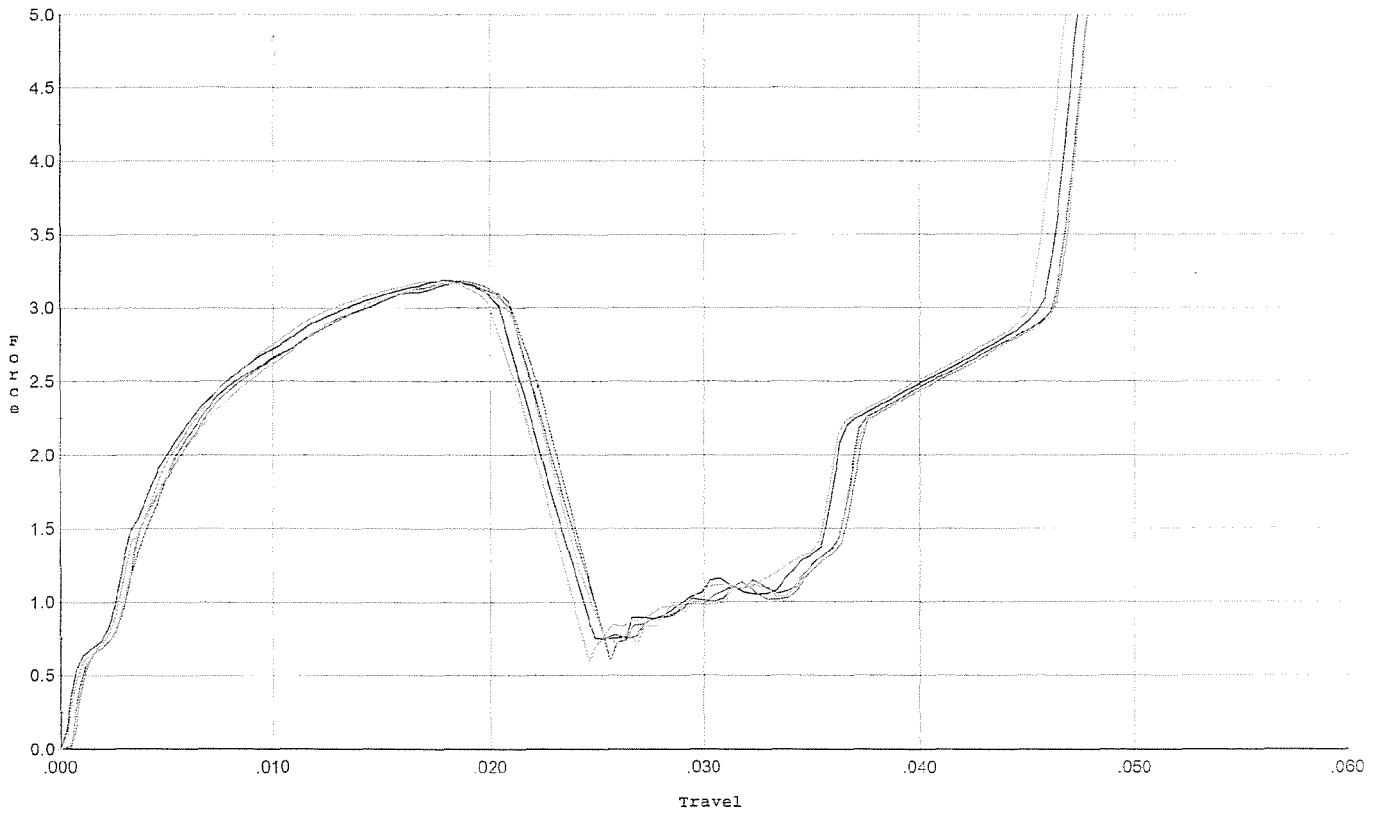
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.020	0.00	0.034	0.034		Set Trigger
2	2.508	0.021	0.00	0.033	0.038		Set Trigger
3	2.464	0.021	0.00	0.034	0.035		Set Trigger
4	2.416	0.020	0.00	0.034	0.034		Set Trigger
5	2.436	0.021	0.00	0.034	0.035		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



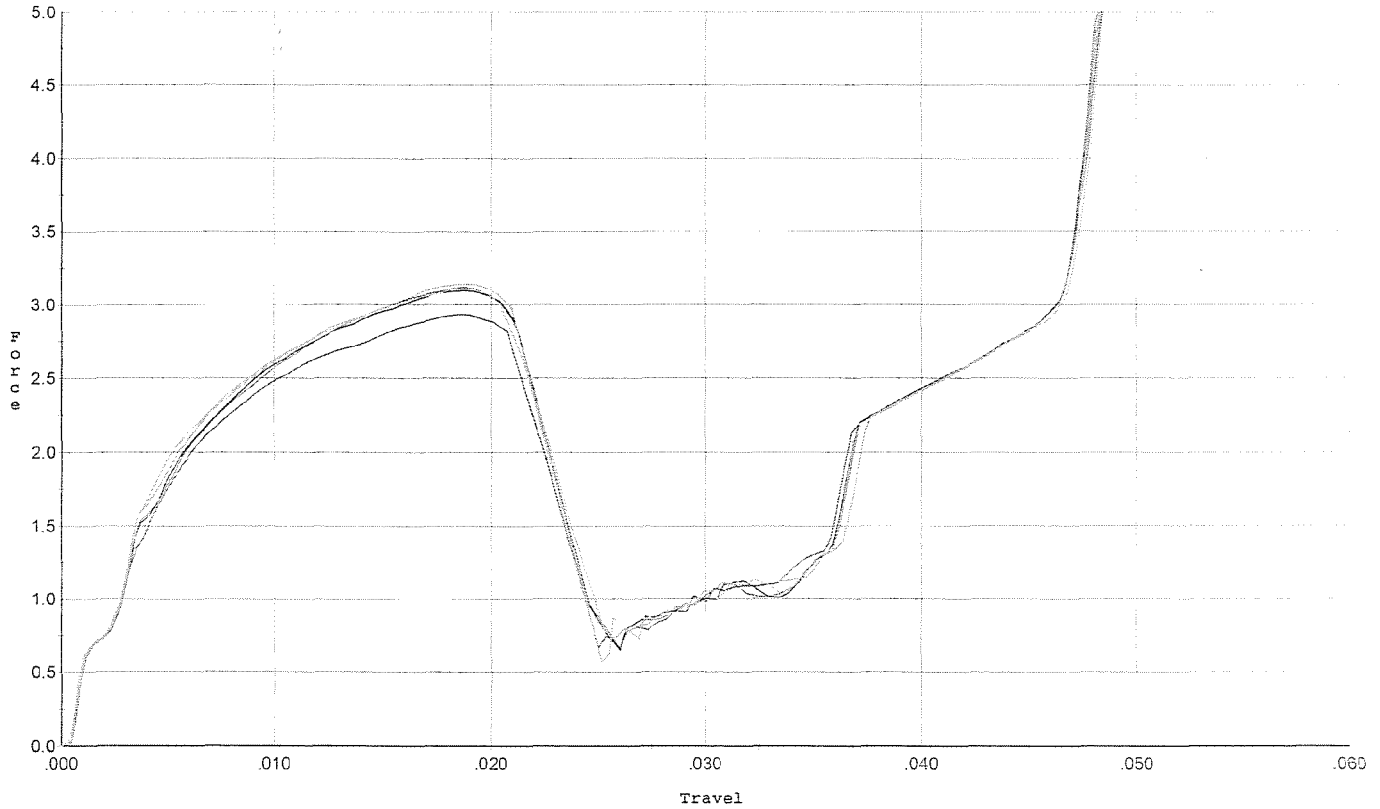
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.021	0.00	0.031	0.047		Set Trigger
2	3.185	0.020	0.00	0.031	0.046		Set Trigger
3	3.186	0.022	0.00	0.030	0.050		Set Trigger
4	3.172	0.021	0.00	0.031	0.047		Set Trigger
5	3.181	0.021	0.00	0.030	0.048		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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	2.934	0.023	0.00	0.031	0.047		Set Trigger
2	3.099	0.021	0.00	0.031	0.046		Set Trigger
3	3.119	0.021	0.00	0.031	0.046		Set Trigger
4	3.110	0.022	0.00	0.031	0.048		Set Trigger
5	3.141	0.021	0.00	0.031	0.046		Set Trigger

A-3.08

Trigger Scan 2.01 ,SN 10337, printed by Remington Arms Co., Inc.. 4/13/2009 10:33:34 AM

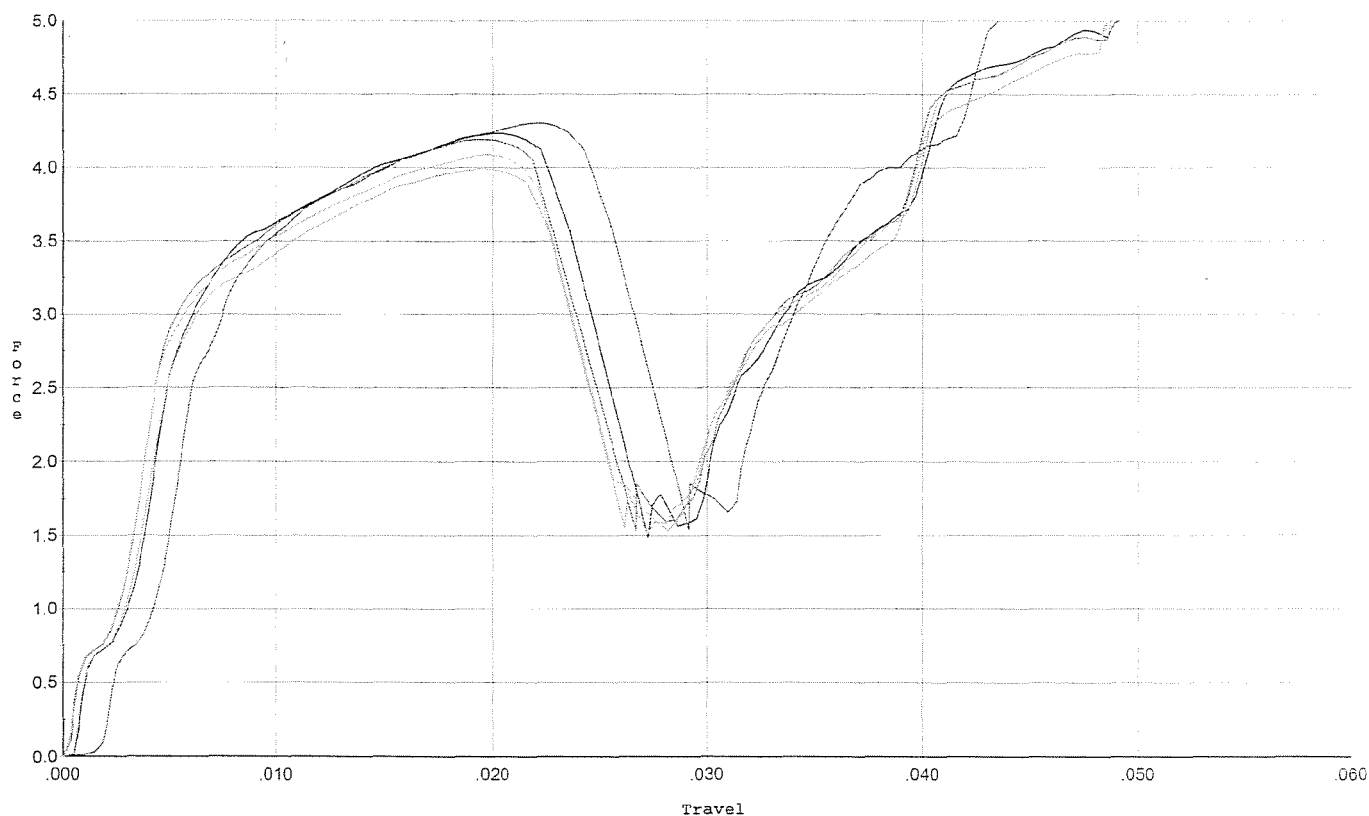
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400074987

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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	4.303	0.026	0.00	0.022	0.074		Set Trigger
2	4.234	0.024	0.00	0.027	0.070		Set Trigger
3	4.193	0.024	0.00	0.027	0.072		Set Trigger
4	4.088	0.022	0.00	0.028	0.065		Set Trigger
5	3.991	0.022	0.00	0.028	0.064		Set Trigger

A-4-16

Trigger Scan 2.01 ,SN 10337, printed by Remington Arms Co., Inc.. 4/13/2009 10:35:28 AM

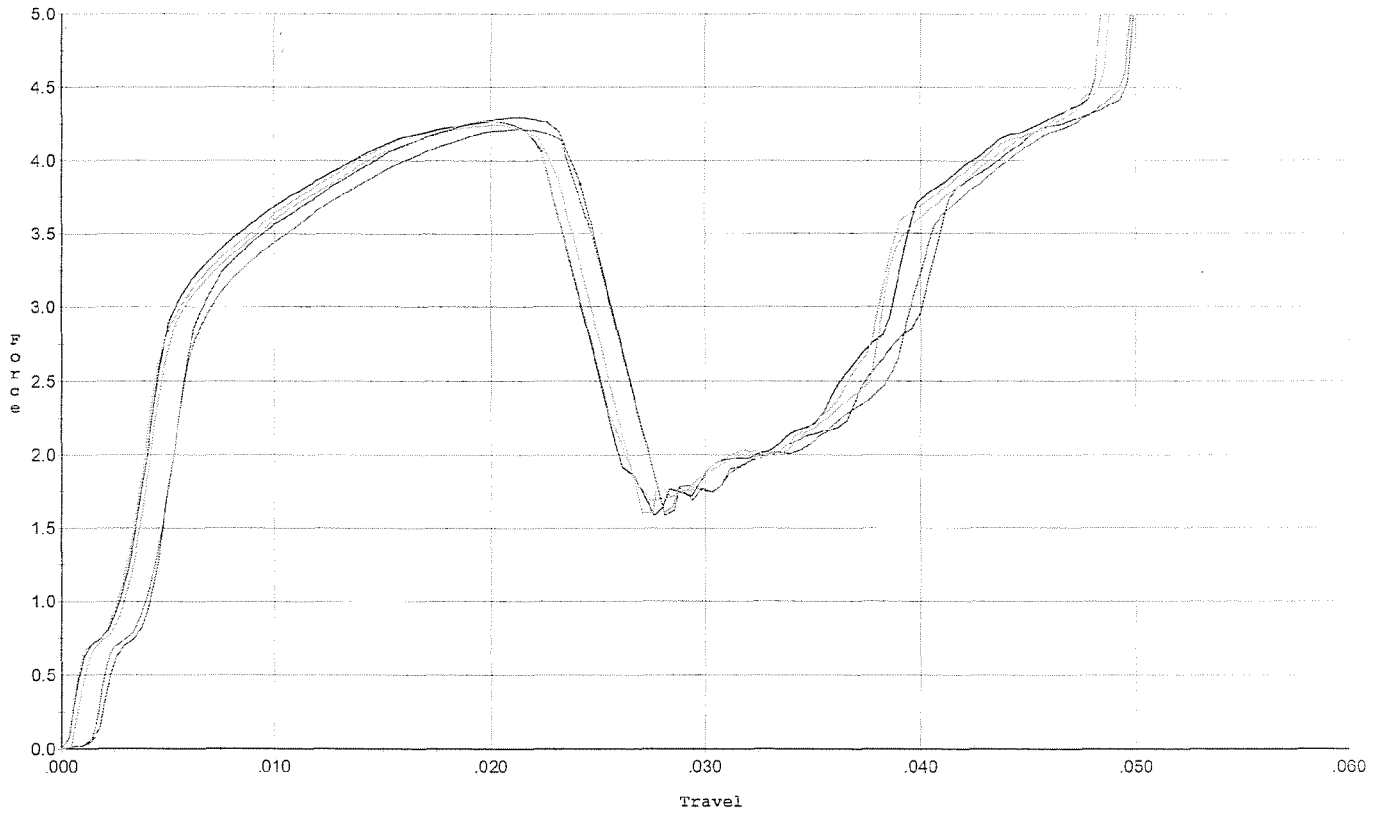
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400074988

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



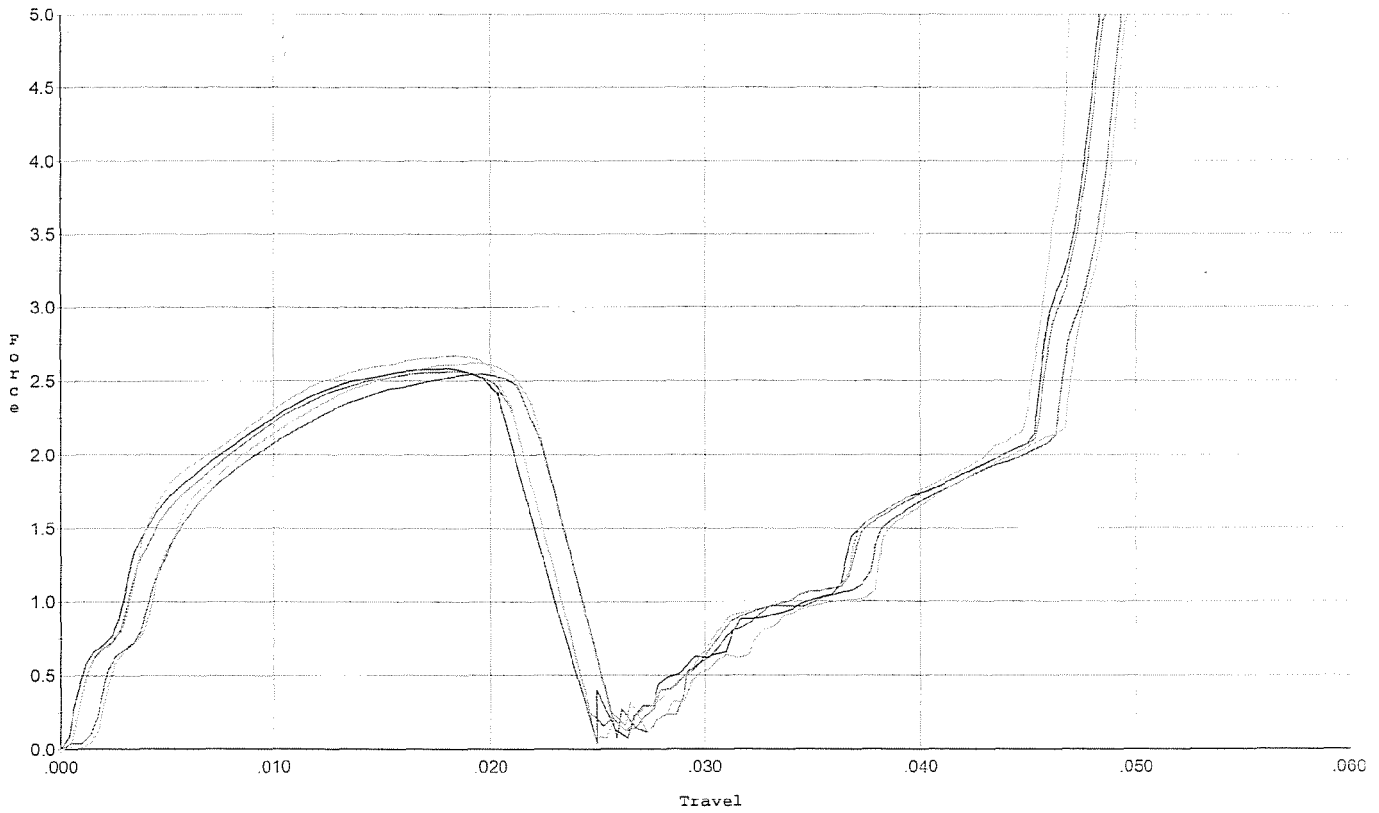
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.296	0.024	0.00	0.024	0.071		Set Trigger
2	4.267	0.022	0.00	0.028	0.068		Set Trigger
3	4.210	0.025	0.00	0.023	0.071		Set Trigger
4	4.264	0.022	0.00	0.027	0.067		Set Trigger
5	4.241	0.023	0.00	0.027	0.069		Set Trigger

A-4-25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



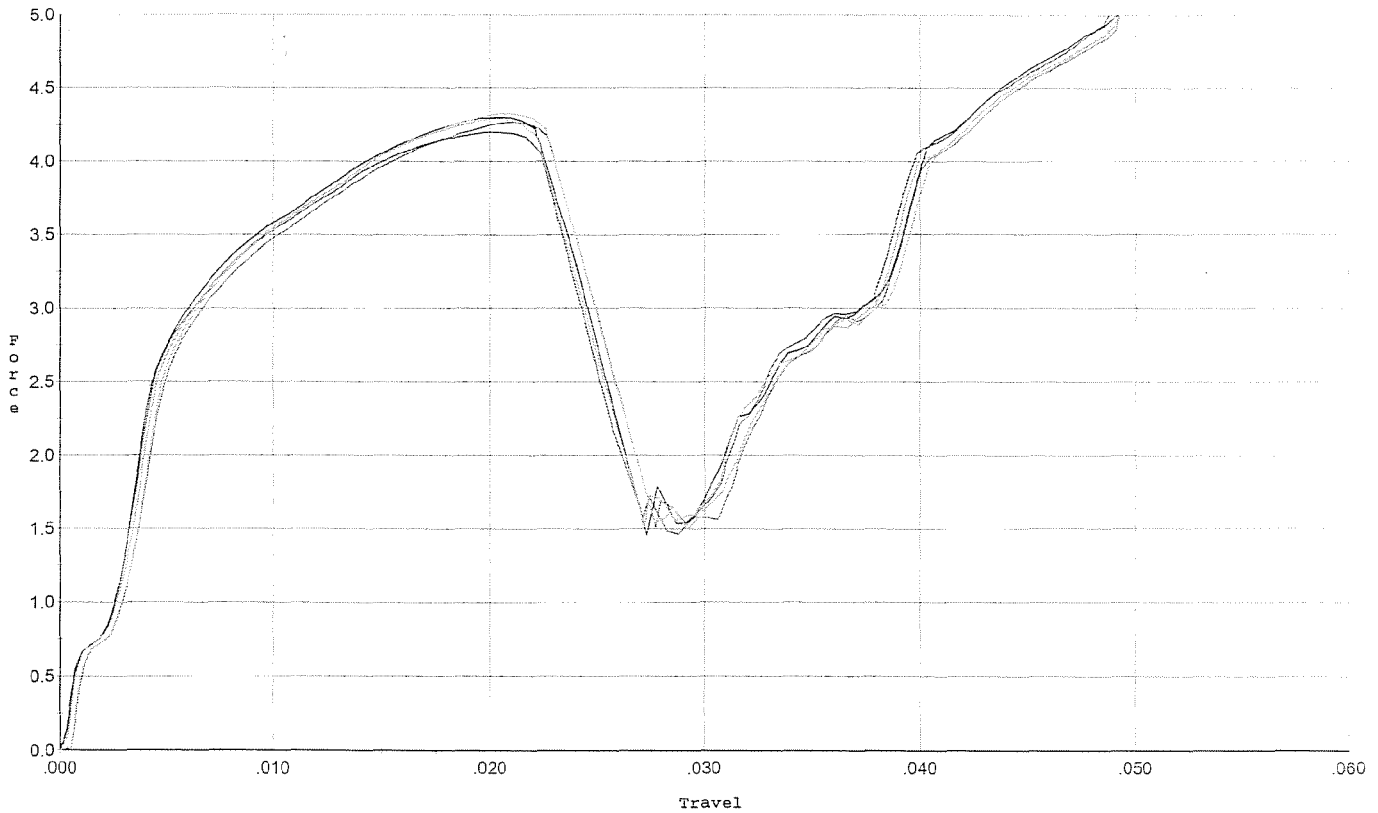
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.022	0.00	0.033	0.039		Set Trigger
2	2.583	0.020	0.00	0.033	0.038		Set Trigger
3	2.564	0.021	0.00	0.033	0.039		Set Trigger
4	2.672	0.021	0.00	0.031	0.040		Set Trigger
5	2.622	0.022	0.00	0.033	0.040		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.199	0.022	0.00	0.027	0.067		Set Trigger
2	4.299	0.024	0.00	0.028	0.073		Set Trigger
3	4.269	0.025	0.00	0.025	0.074		Set Trigger
4	4.328	0.023	0.00	0.028	0.068		Set Trigger
5	4.291	0.022	0.00	0.028	0.066		Set Trigger

A-4.27