

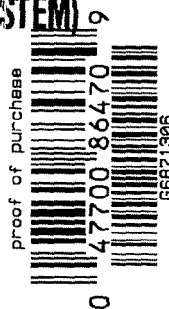
G 6871306

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE

24" BARREL 7.62 NATO

WITH BIPOD

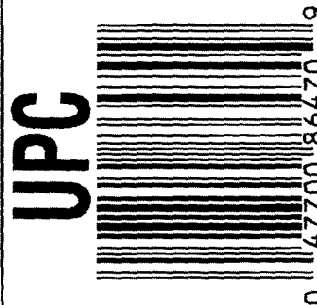


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6871306



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6871306

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-14-09	SPD
430	ASSEMBLE TO STOCK		7-14-09	SP
440	PROOF		7-14-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	7-14-09	SPD
470	DIS-ASSEMBLE ACTION	2009	7-14-09	SPD
472	SERIALIZE BOLT HANDLE		7-15-09	KTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	7/18/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-21-09	AWO
510	DRILL AND TAP SIGHT HOLES		7-15-09	SP
520	GOFF BLAST BBL / REC		7-21-09	1/11
540	APPLY COATINGS (BARREL ACTION)		8/1	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-12-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

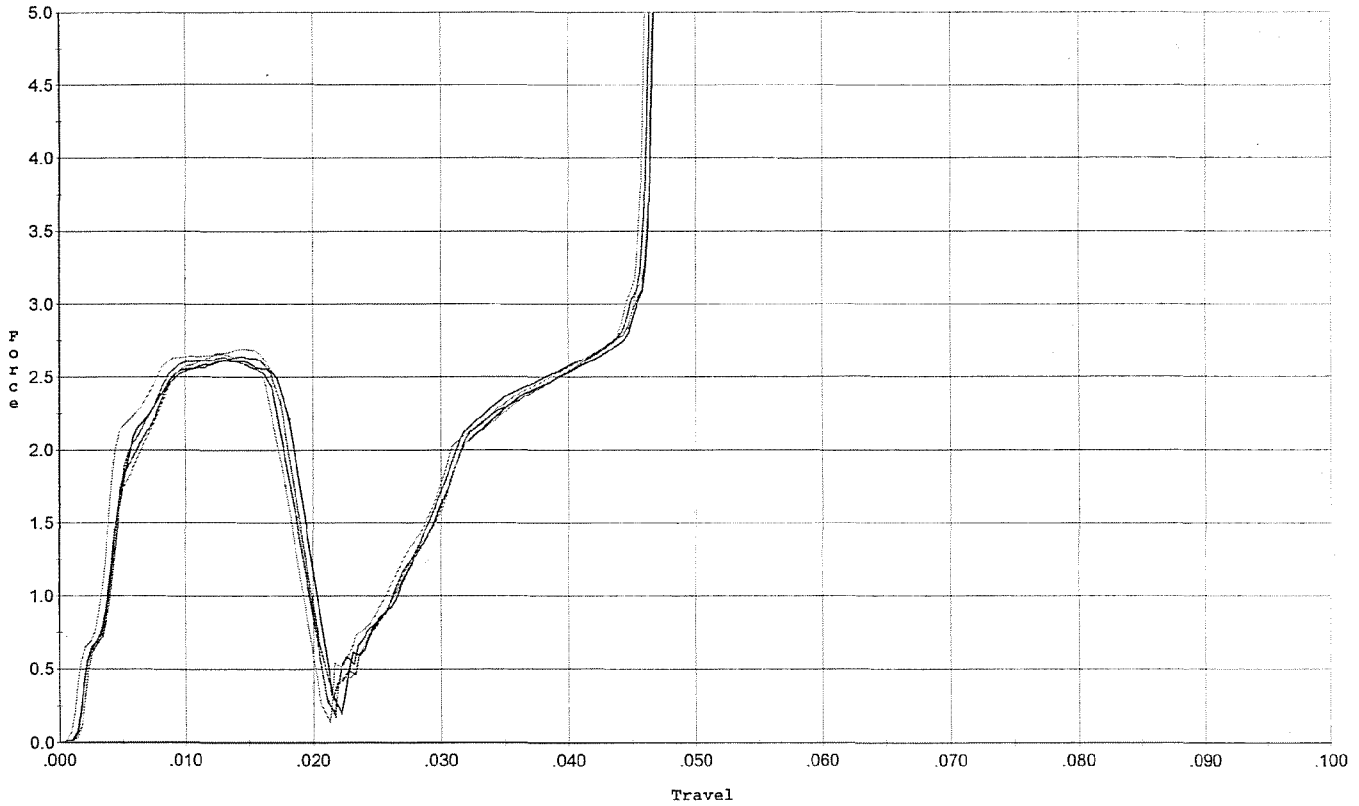
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7²</u> <u>7²</u> <u>7²</u>	8-14-09	RTZ
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>3²</u> <u>3²</u> <u>2.75</u>	8-14-09	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY				RTZ
	I) FIRING PIN INDENT	.020 MIN	<u>026</u> <u>026</u> <u>026</u>	8-14-09	
	J) ASSEMBLE STOCK			8-12-09	291
	K) ASSEMBLE SWIVEL STUDS			8-14-09	RTZ
	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		PASS FAIL PASS FAIL	8/13/09	RB
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			8/17/09	TAK
670	FINAL INSPECTION A) HEADSPACE			8-14-09	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.63</u> <u>2.57</u> <u>2.52</u> <u>2.66</u>	8-14-09	291
	C) FUNCTION			8-14-09	RTZ
690	PACK			8/17/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



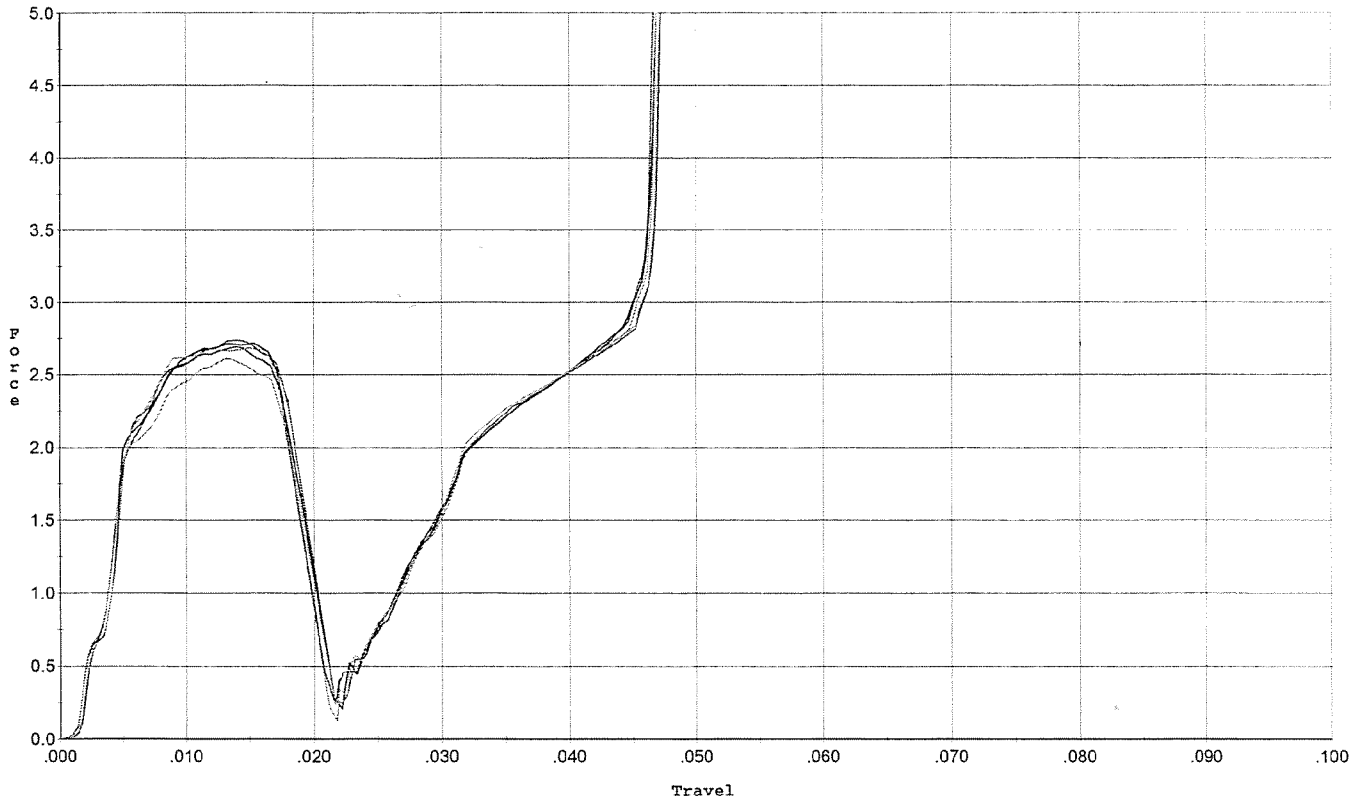
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.019	0.00	0.032	0.033		Set Trigger
2	2.617	0.018	0.00	0.032	0.033		Set Trigger
3	2.639	0.017	0.00	0.032	0.032		Set Trigger
4	2.653	0.018	0.00	0.032	0.034		Set Trigger
5	2.688	0.017	0.00	0.032	0.032		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



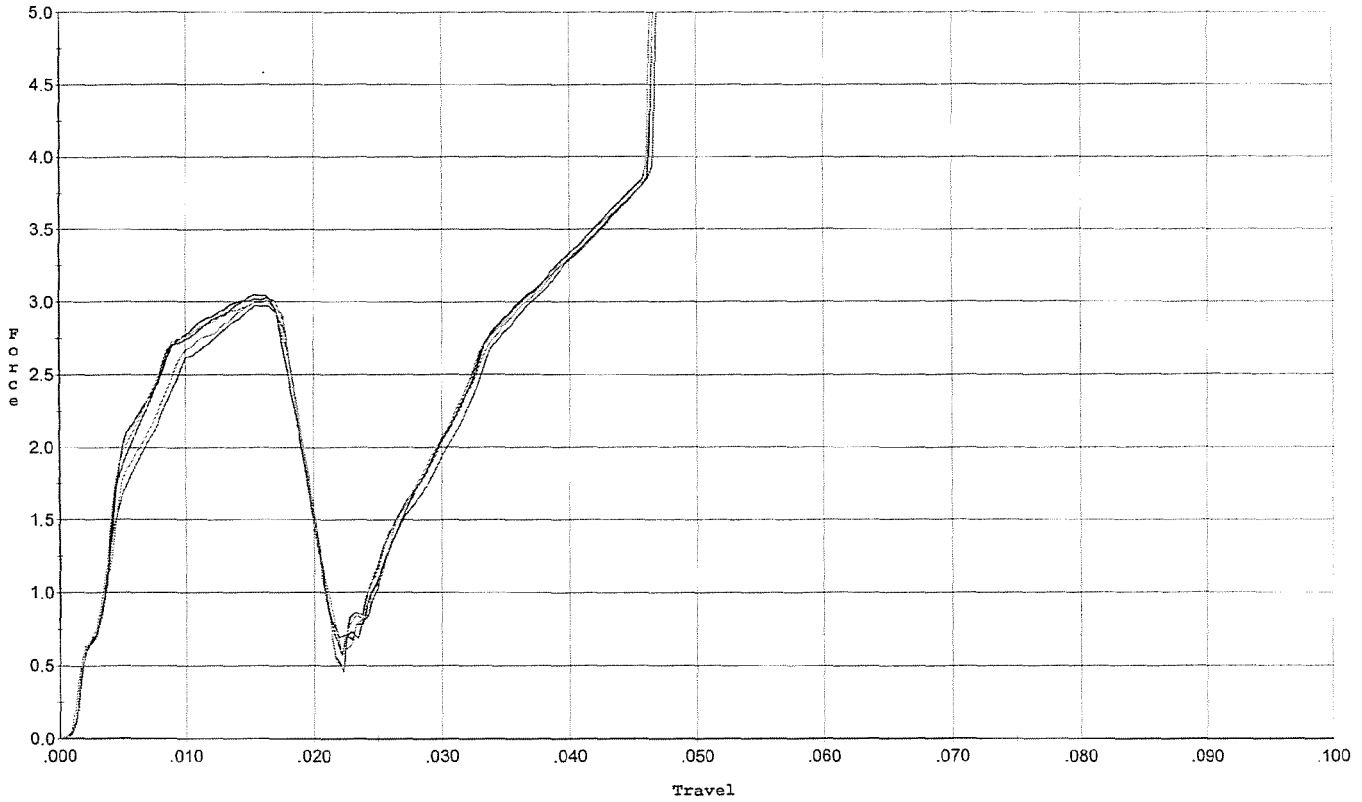
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.691	0.017	0.00	0.032	0.032		Set Trigger
2	2.717	0.019	0.00	0.032	0.035		Set Trigger
3	2.737	0.018	0.00	0.032	0.034		Set Trigger
4	2.685	0.017	0.00	0.033	0.032		Set Trigger
5	2.609	0.018	0.00	0.032	0.032		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/11/2009

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



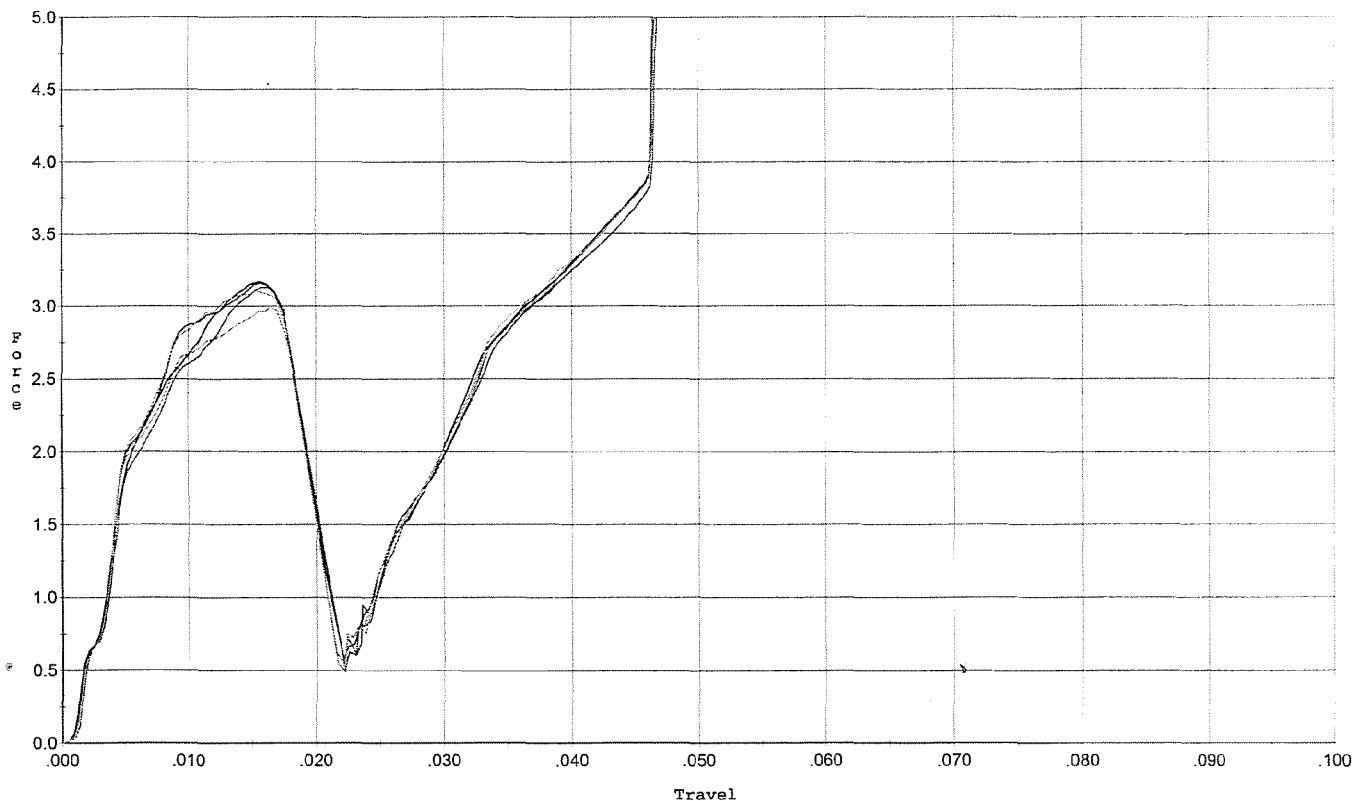
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.048	0.019	0.00	0.031	0.038		Set Trigger
2	3.030	0.018	0.00	0.031	0.036		Set Trigger
3	2.973	0.018	0.00	0.031	0.034		Set Trigger
4	3.004	0.018	0.00	0.031	0.037		Set Trigger
5	3.008	0.018	0.00	0.031	0.035		Set Trigger

A-3.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



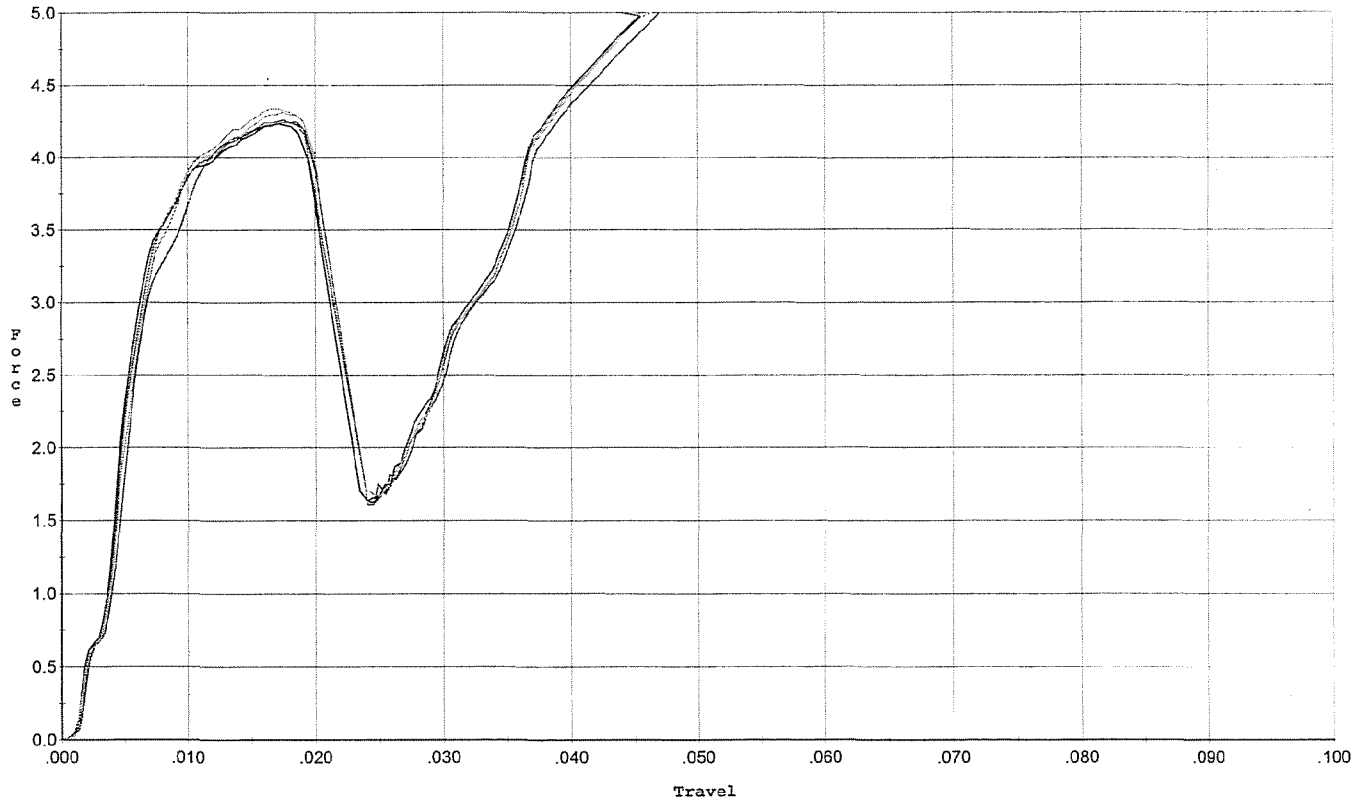
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.018	0.00	0.031	0.036		Set Trigger
2	3.169	0.018	0.00	0.031	0.036		Set Trigger
3	3.132	0.017	0.00	0.031	0.035		Set Trigger
4	3.103	0.018	0.00	0.031	0.037		Set Trigger
5	2.991	0.018	0.00	0.031	0.036		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



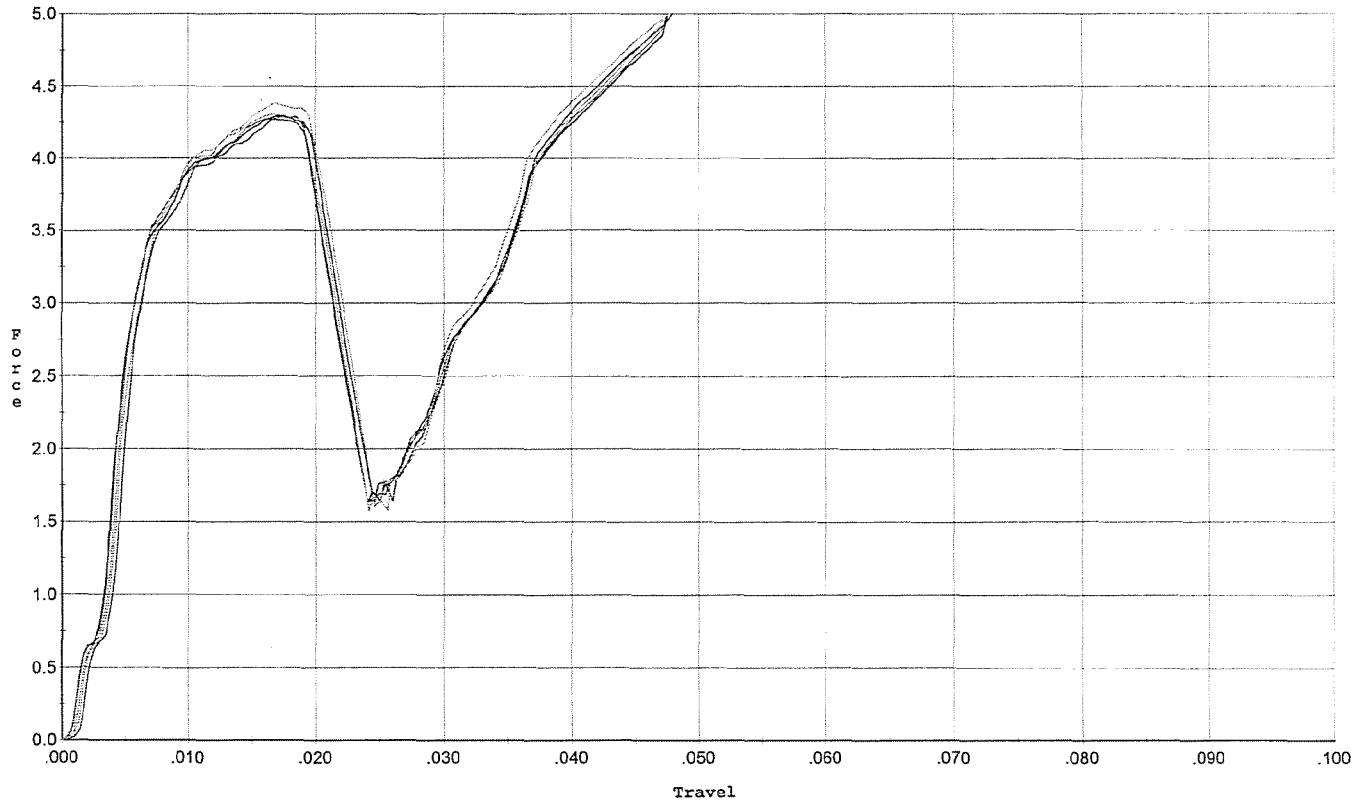
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.252	0.020	0.00	0.028	0.056		Set Trigger
2	4.235	0.019	0.00	0.028	0.055		Set Trigger
3	4.266	0.021	0.00	0.028	0.061		Set Trigger
4	4.312	0.020	0.00	0.028	0.057		Set Trigger
5	4.339	0.020	0.00	0.028	0.057		Set Trigger

A-4-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



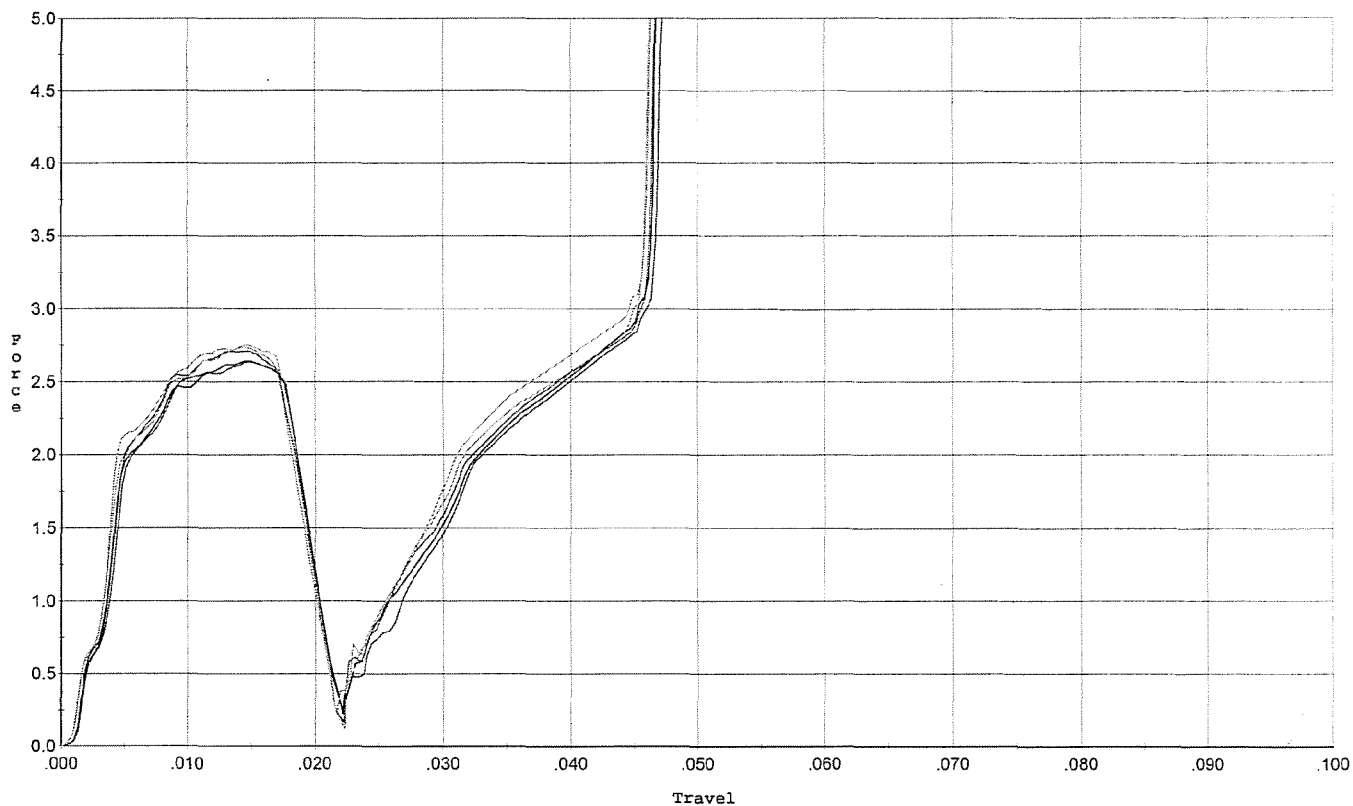
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.020	0.00	0.028	0.056		Set Trigger
2	4.295	0.019	0.00	0.028	0.055		Set Trigger
3	4.273	0.019	0.00	0.028	0.056		Set Trigger
4	4.385	0.021	0.00	0.028	0.061		Set Trigger
5	4.307	0.021	0.00	0.028	0.060		Set Trigger

A-431

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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



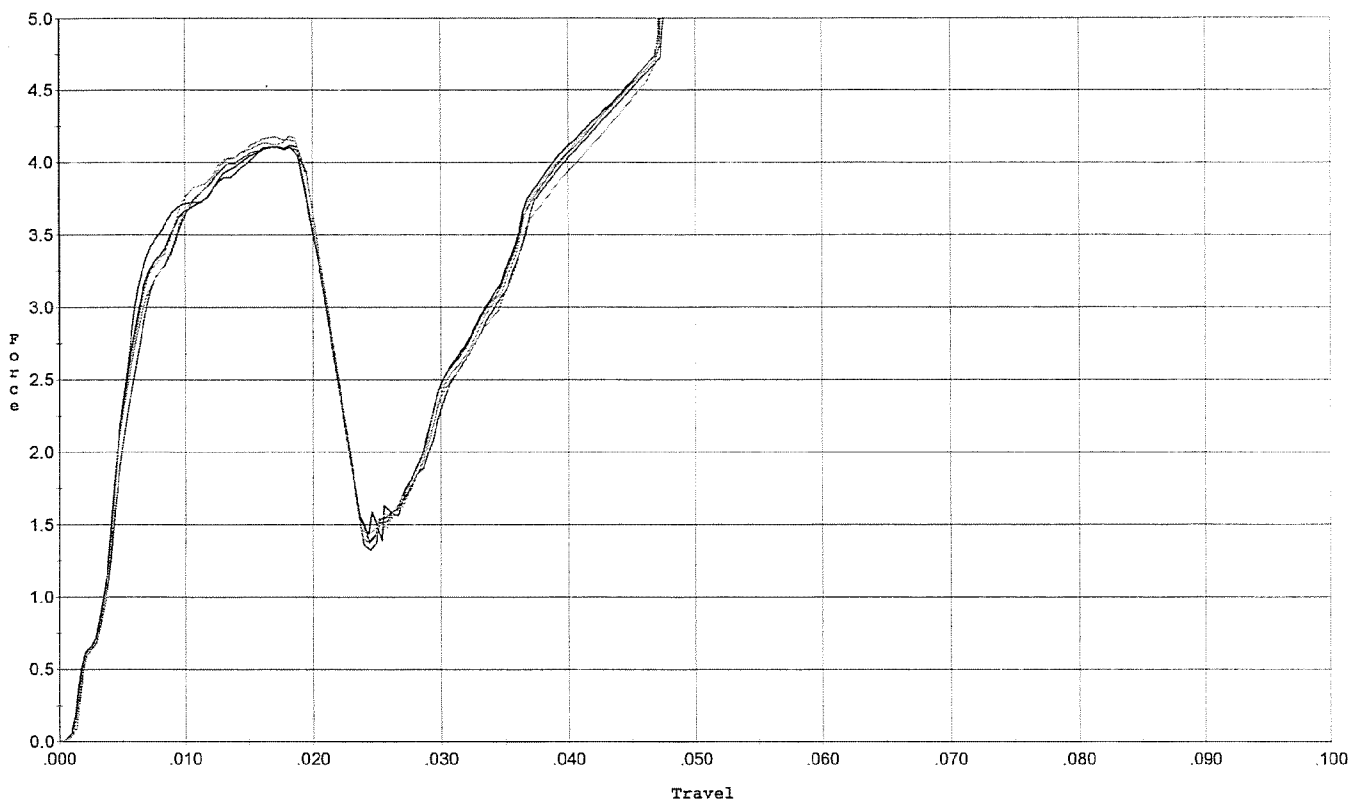
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.635	0.018	0.00	0.033	0.033		Set Trigger
2	2.645	0.018	0.00	0.032	0.033		Set Trigger
3	2.709	0.019	0.00	0.032	0.035		Set Trigger
4	2.751	0.018	0.00	0.031	0.035		Set Trigger
5	2.740	0.017	0.00	0.032	0.033		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/11/2009

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	4.108	0.021	0.00	0.029	0.057		Set Trigger
2	4.116	0.020	0.00	0.028	0.054		Set Trigger
3	4.103	0.020	0.00	0.028	0.053		Set Trigger
4	4.182	0.020	0.00	0.029	0.056		Set Trigger
5	4.178	0.020	0.00	0.029	0.054		Set Trigger

A-4-13