

66875767

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



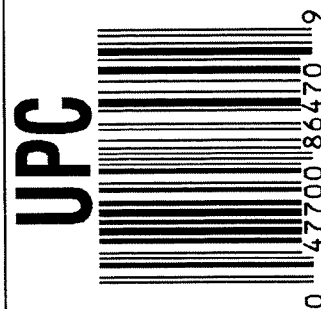
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6875767



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6875767

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-14-09	SPD
430	ASSEMBLE TO STOCK		8-15-09	SP
440	PROOF		8-14-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	8-14-09	SPD
470	DIS-ASSEMBLE ACTION		8-14-09	SPD
472	SERIALIZE BOLT HANDLE		8-15-09	RTE
480	MAGNAFLUX BBL ACTION	OPERATOR 	8/19/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/19/09	DLW
510	DRILL AND TAP SIGHT HOLES		8-17-09	SP
520	GOFF BLAST BBL / REC		8-21-09	ms
540	APPLY COATINGS (BARREL ACTION)		8/24	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-1-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-1-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	9-1-09	SP
	D) OIL FIRING PIN ASSEMBLY		9-10-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

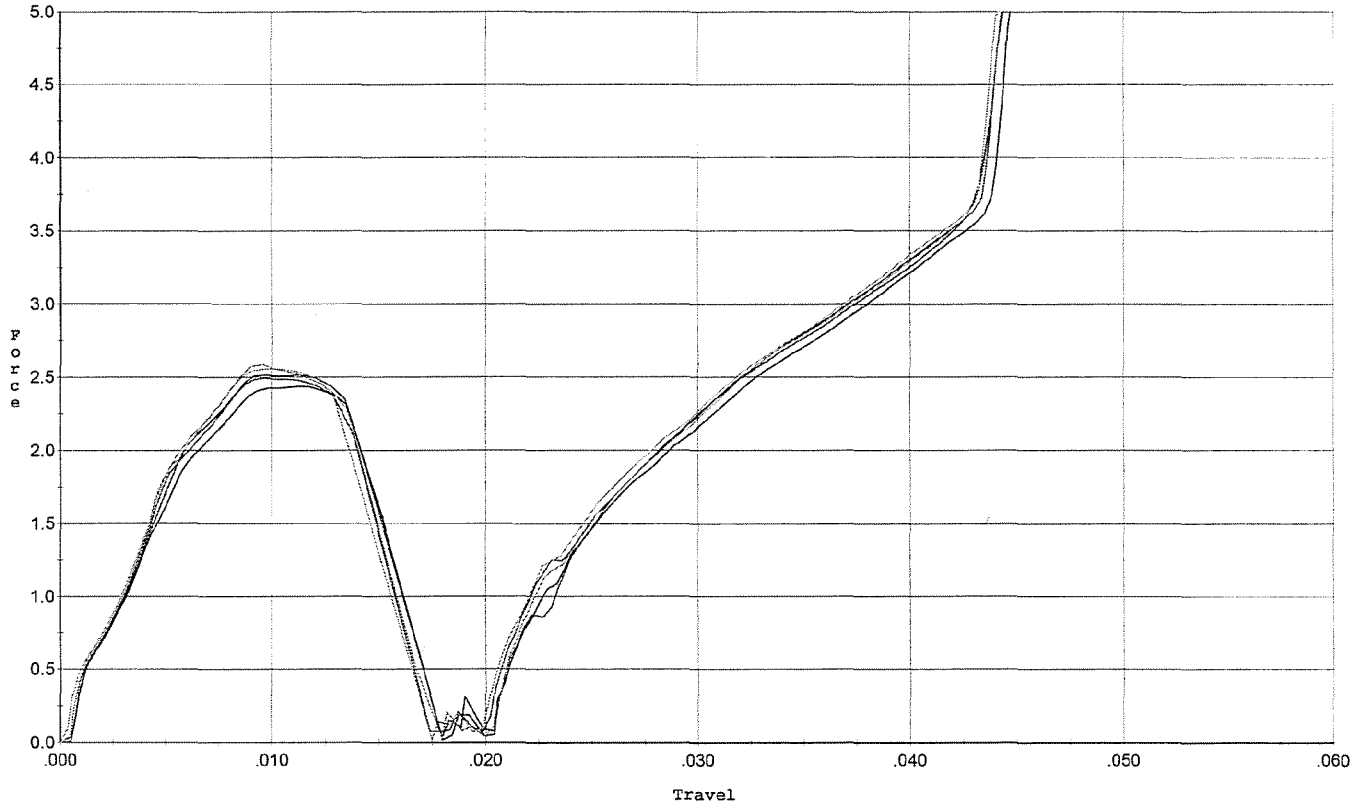
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	9/21/09	LB
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>6°</u> <u>6°</u> <u>6°</u>	9/21/09	LB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	9/21/09	LB
	J) ASSEMBLE STOCK			9-10-09	LB
	K) ASSEMBLE SWIVEL STUDS			9/21/09	LB
	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	9-17-09	LB
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			9-17-09	RP
670	FINAL INSPECTION A) HEADSPACE			9/21/09	LB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.25</u> <u>2.24</u> <u>2.34</u> <u>2.39</u>	9-21-09	TC
	C) FUNCTION			9/21/09	LB
690	PACK			9/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



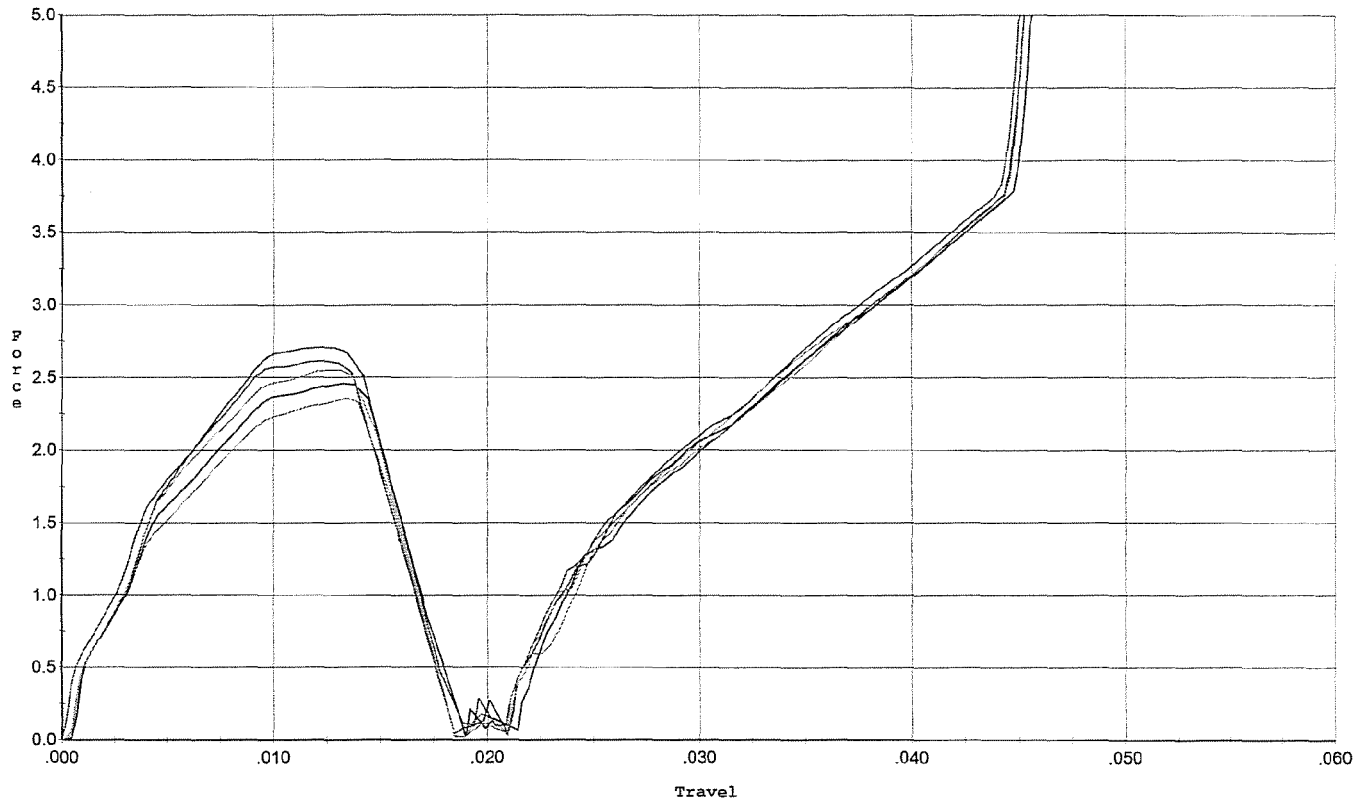
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.015	0.00	0.033	0.026		Set Trigger
2	2.437	0.015	0.00	0.033	0.025		Set Trigger
3	2.493	0.014	0.00	0.033	0.023		Set Trigger
4	2.555	0.015	0.00	0.033	0.026		Set Trigger
5	2.588	0.014	0.00	0.033	0.023		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



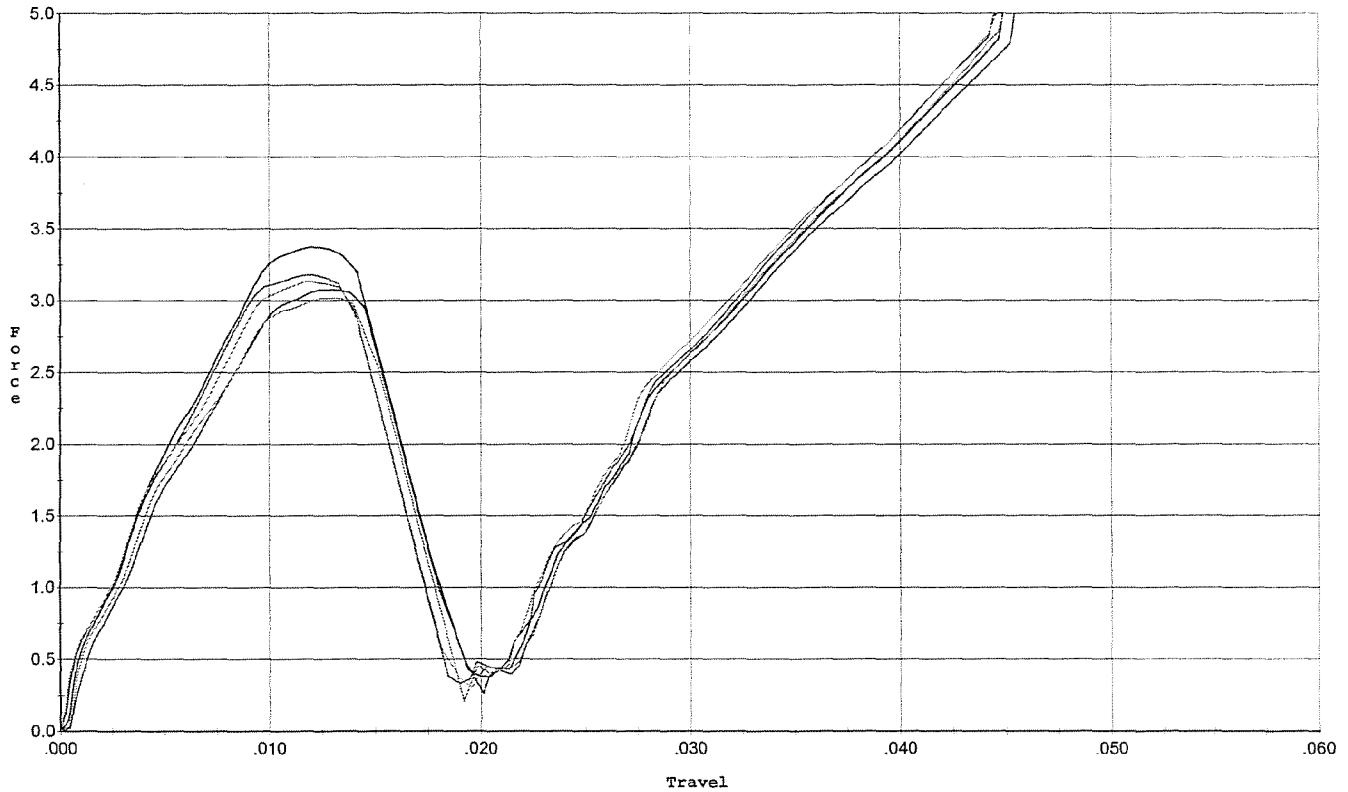
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.708	0.014	0.00	0.033	0.025		Set Trigger
2	2.458	0.014	0.00	0.034	0.024		Set Trigger
3	2.612	0.016	0.00	0.033	0.028		Set Trigger
4	2.553	0.015	0.00	0.033	0.025		Set Trigger
5	2.358	0.015	0.00	0.033	0.024		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



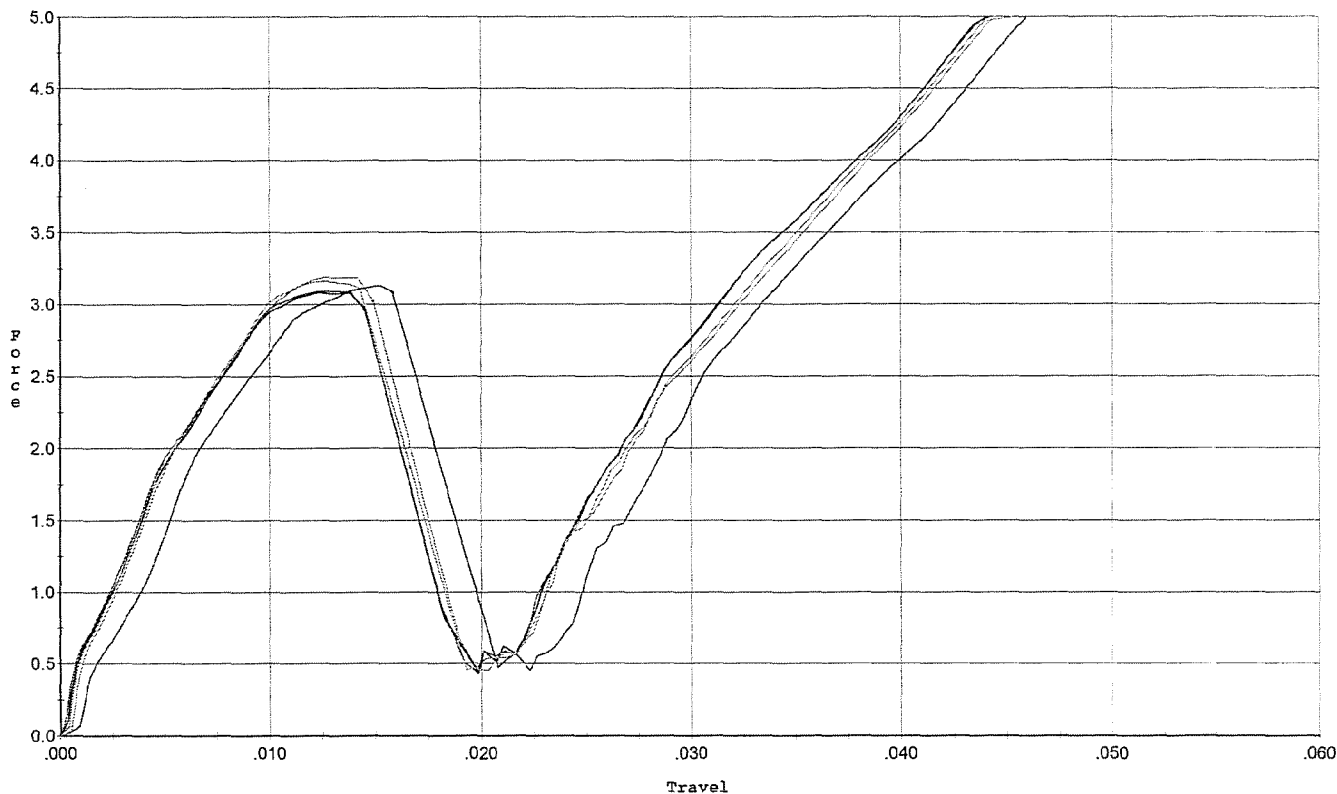
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.075	0.015	0.00	0.032	0.028		Set Trigger
2	3.372	0.014	0.00	0.031	0.030		Set Trigger
3	3.179	0.014	0.00	0.032	0.029		Set Trigger
4	3.134	0.014	0.00	0.032	0.028		Set Trigger
5	3.018	0.015	0.00	0.032	0.029		Set Trigger

43.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



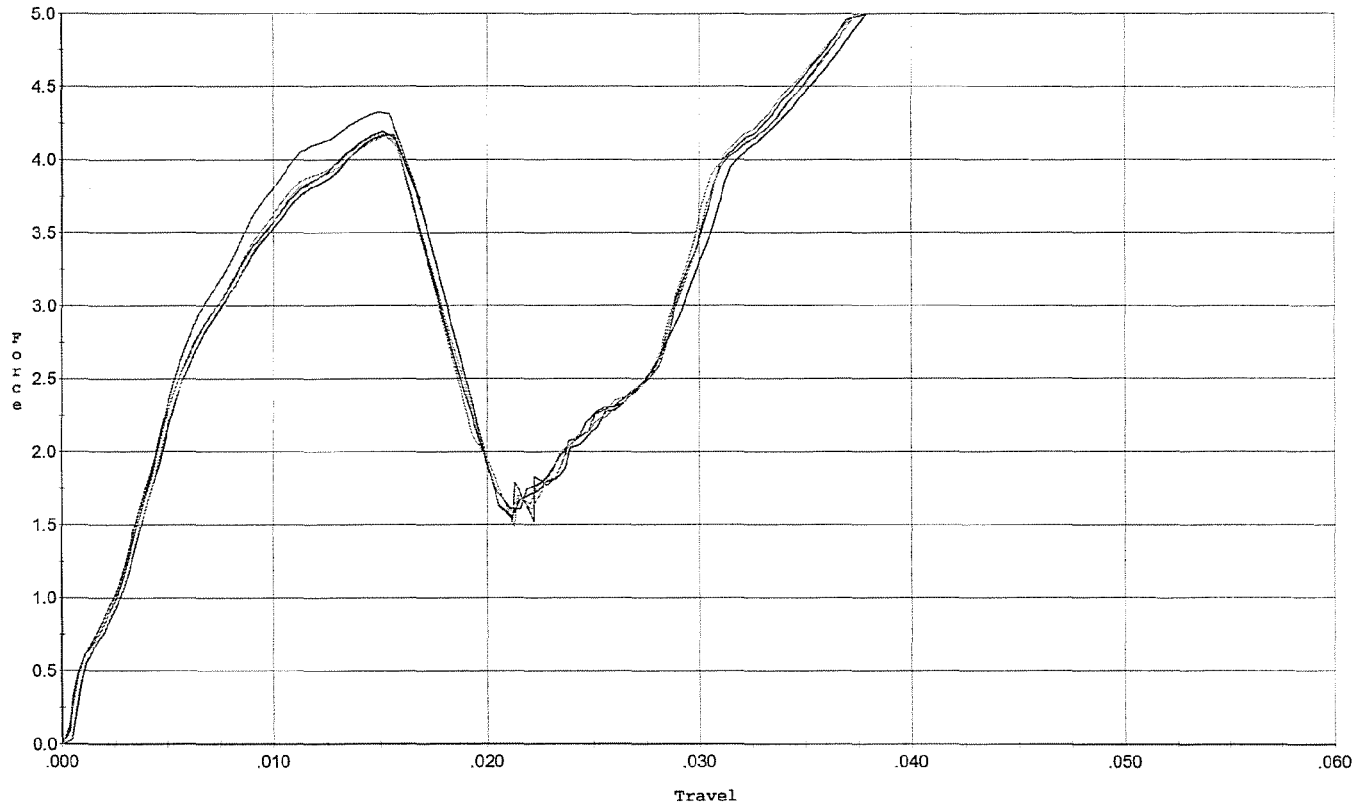
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.131	0.016	0.00	0.031	0.030		Set Trigger
2	3.082	0.014	0.00	0.031	0.029		Set Trigger
3	3.092	0.014	0.00	0.031	0.030		Set Trigger
4	3.161	0.017	0.00	0.030	0.034		Set Trigger
5	3.189	0.015	0.00	0.030	0.031		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



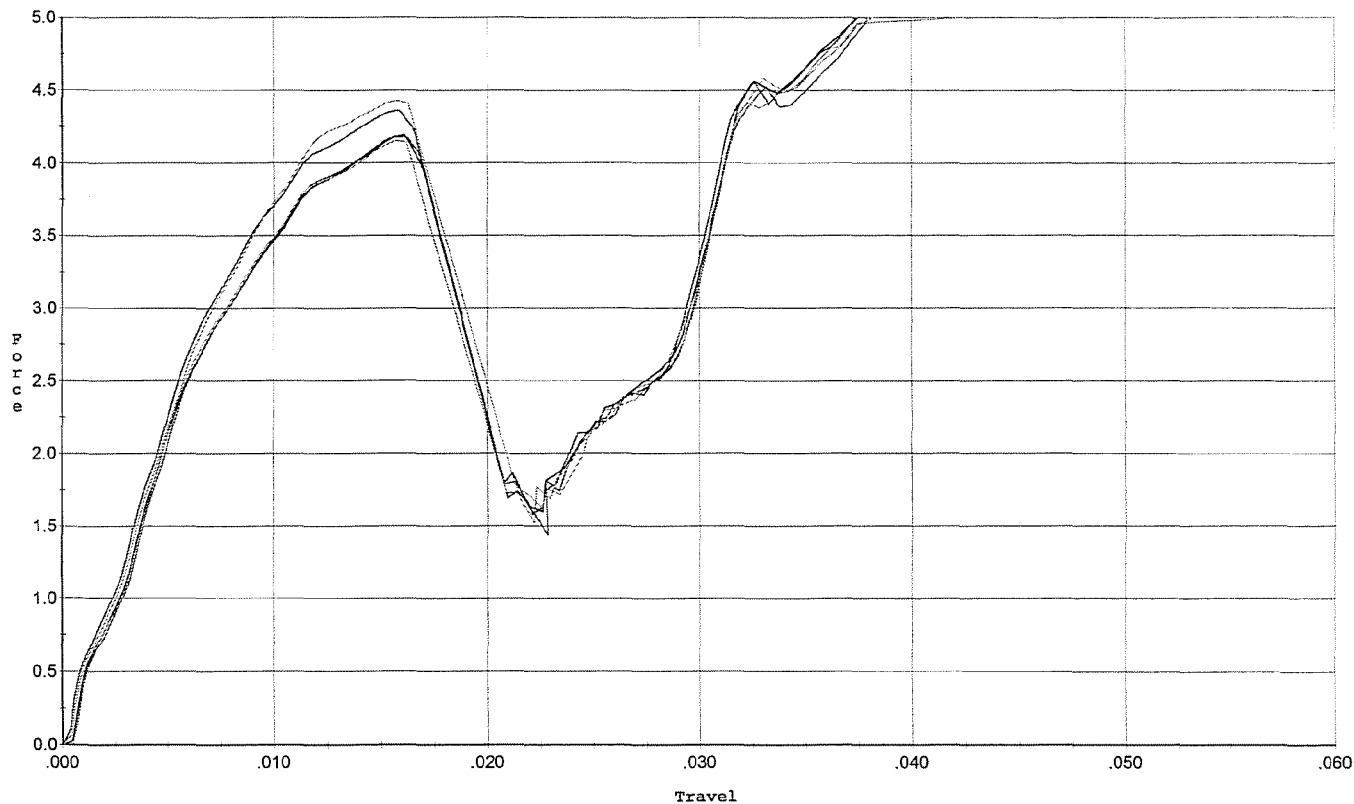
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.193	0.016	0.00	0.026	0.041		Set Trigger
2	4.169	0.017	0.00	0.026	0.044		Set Trigger
3	4.326	0.017	0.00	0.026	0.046		Set Trigger
4	4.158	0.016	0.00	0.026	0.040		Set Trigger
5	4.176	0.016	0.00	0.026	0.041		Set Trigger

A-4-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



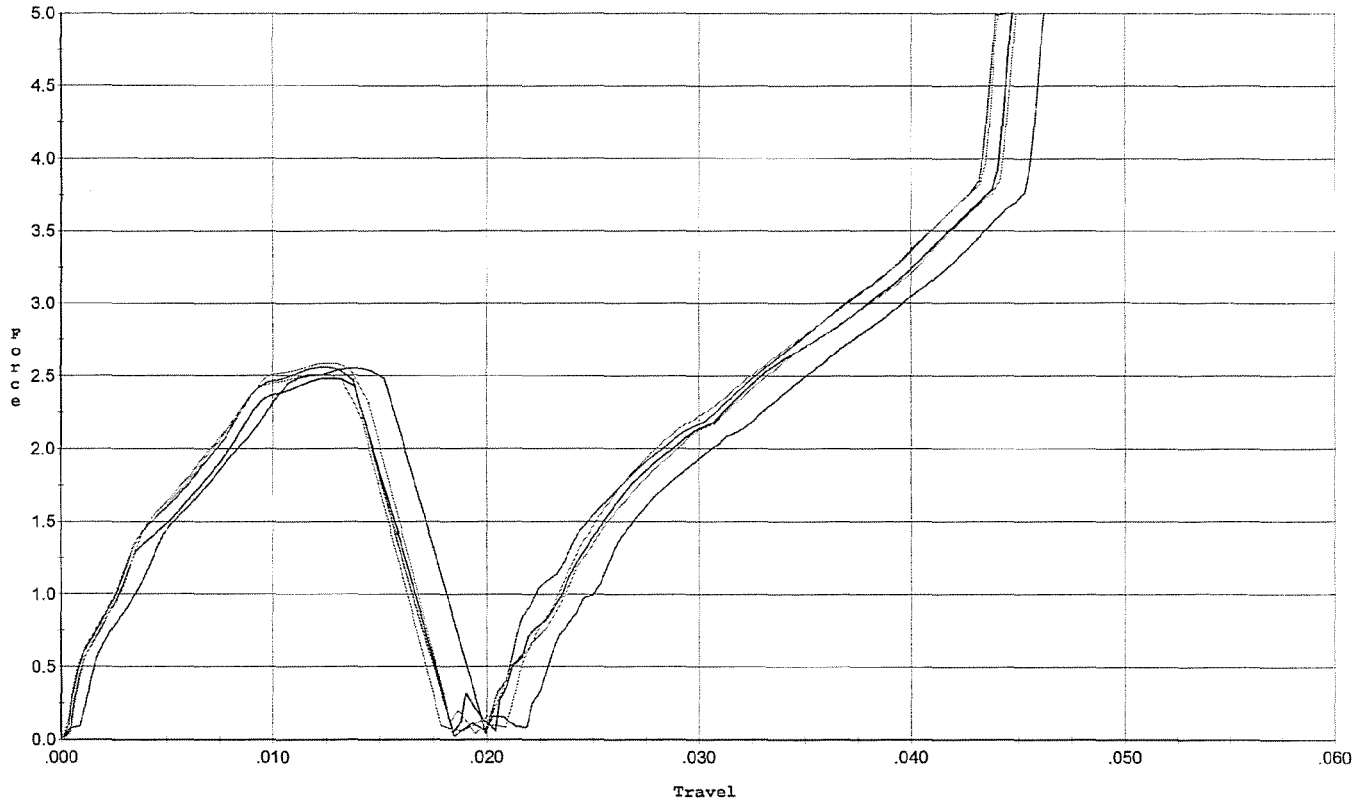
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.360	0.017	0.00	0.026	0.045		Set Trigger
2	4.184	0.017	0.00	0.026	0.044		Set Trigger
3	4.194	0.017	0.00	0.026	0.044		Set Trigger
4	4.428	0.019	0.00	0.026	0.051		Set Trigger
5	4.149	0.018	0.00	0.026	0.048		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



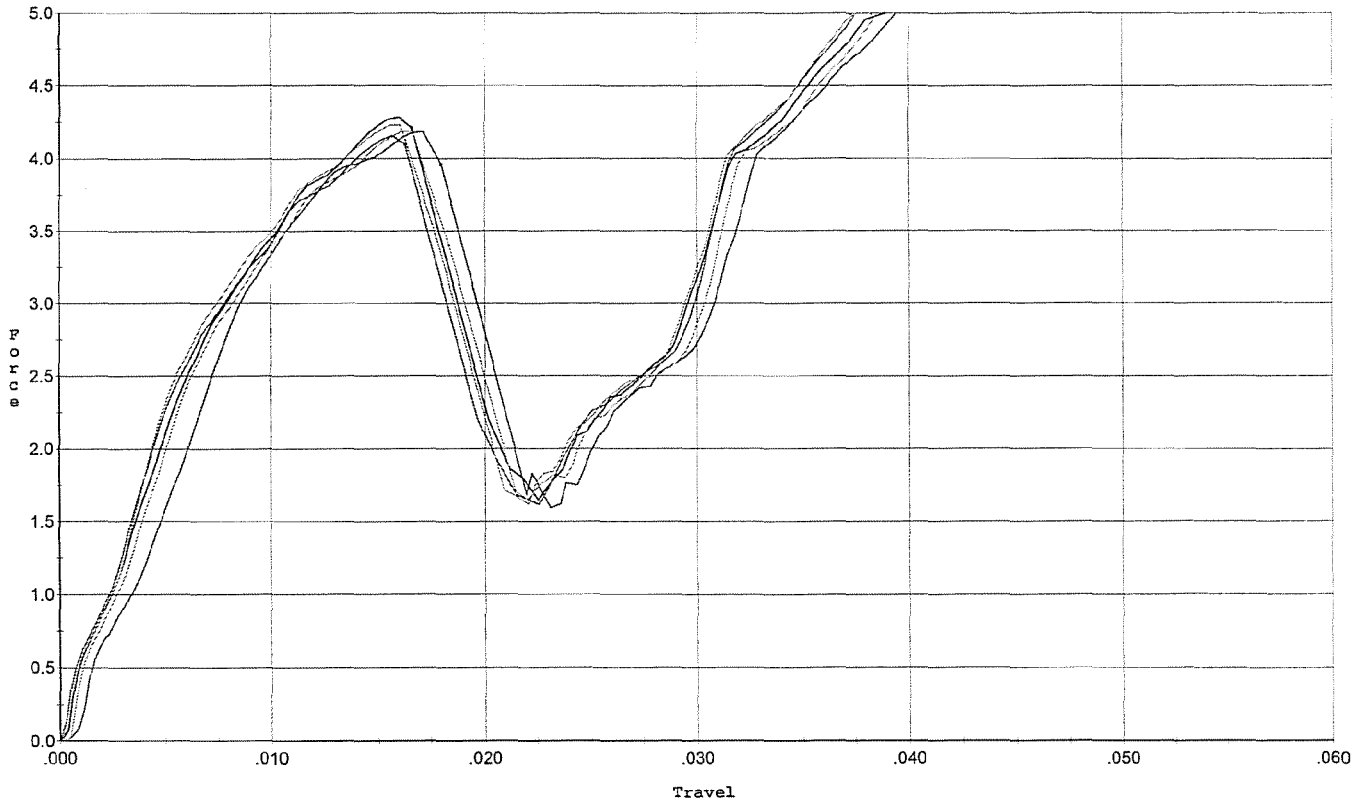
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.553	0.017	0.00	0.033	0.029		Set Trigger
2	2.482	0.016	0.00	0.033	0.026		Set Trigger
3	2.556	0.014	0.00	0.033	0.023		Set Trigger
4	2.586	0.014	0.00	0.033	0.025		Set Trigger
5	2.509	0.014	0.00	0.033	0.024		Set Trigger

A.2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 9/9/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.183	0.018	0.00	0.027	0.045		Set Trigger
2	4.285	0.017	0.00	0.027	0.044		Set Trigger
3	4.158	0.016	0.00	0.027	0.042		Set Trigger
4	4.187	0.018	0.00	0.026	0.047		Set Trigger
5	4.229	0.018	0.00	0.026	0.047		Set Trigger

A. 4.20