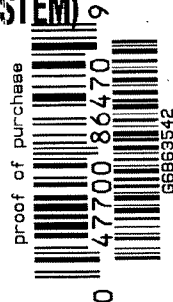


G686 3542

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



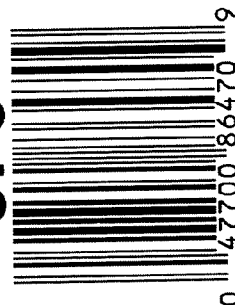
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6863542

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6863542

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SP
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5-21-09	RP
470	DIS-ASSEMBLE ACTION		5-21-09	RP
472	SERIALIZE BOLT HANDLE		5-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(H)</u>	5/29/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RP
510	DRILL AND TAP SIGHT HOLES		5-22-09	SP
520	GOFF BLAST BBL / REC		5/29/09	SP
540	APPLY COATINGS (BARREL ACTION)		6/1	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-1-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-1-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-1-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-2-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

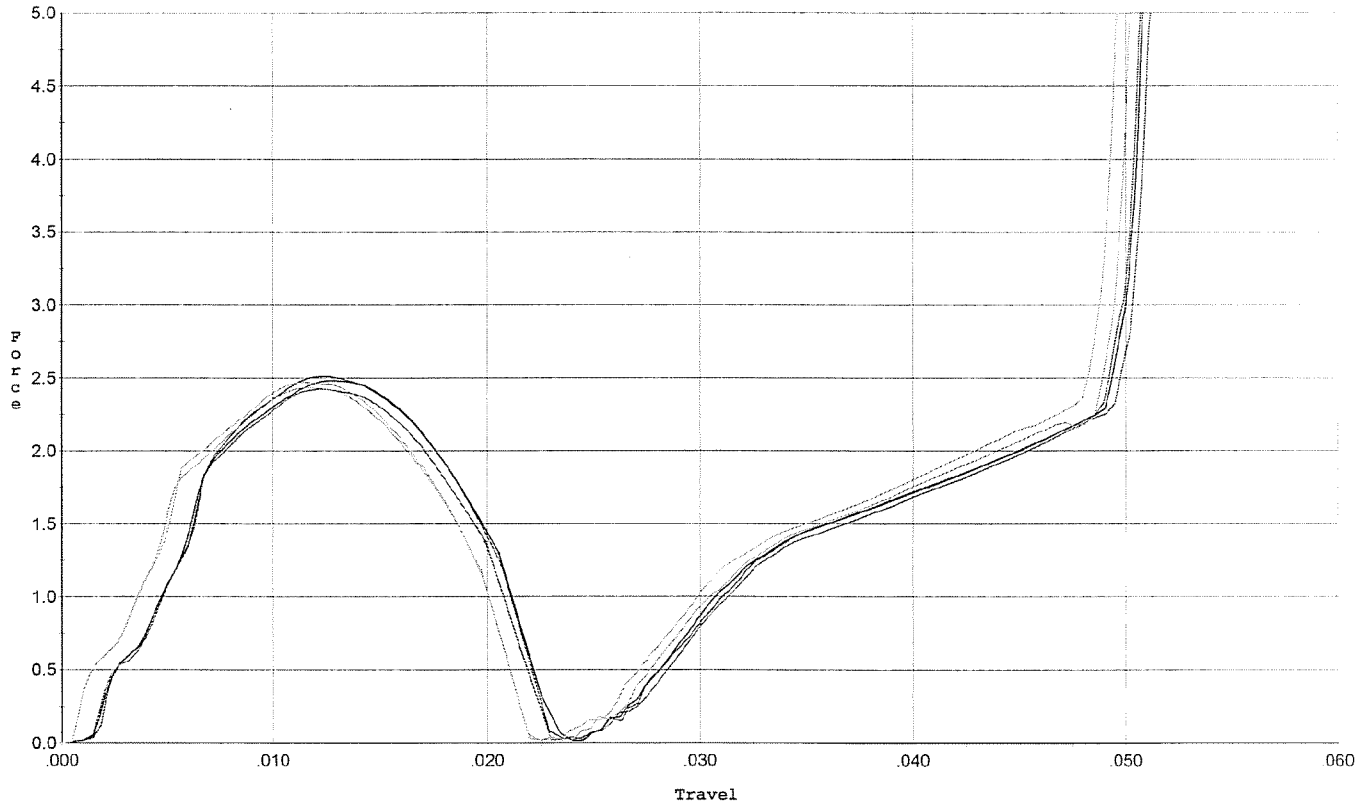
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-16-09	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	6-16-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	6-16-09	RJ
	J) ASSEMBLE STOCK		6-2-09	RJ
	K) ASSEMBLE SWIVEL STUDS		6-16-09	RJ
	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	6/15/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/15/09	TJR
670	FINAL INSPECTION A) HEADSPACE		6-16-09	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>280</u> <u>281</u> <u>283</u> <u>283</u> <u>284</u>	6-16-09	RTZ
	C) FUNCTION		6-16-09	RJ
690	PACK		7/10/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



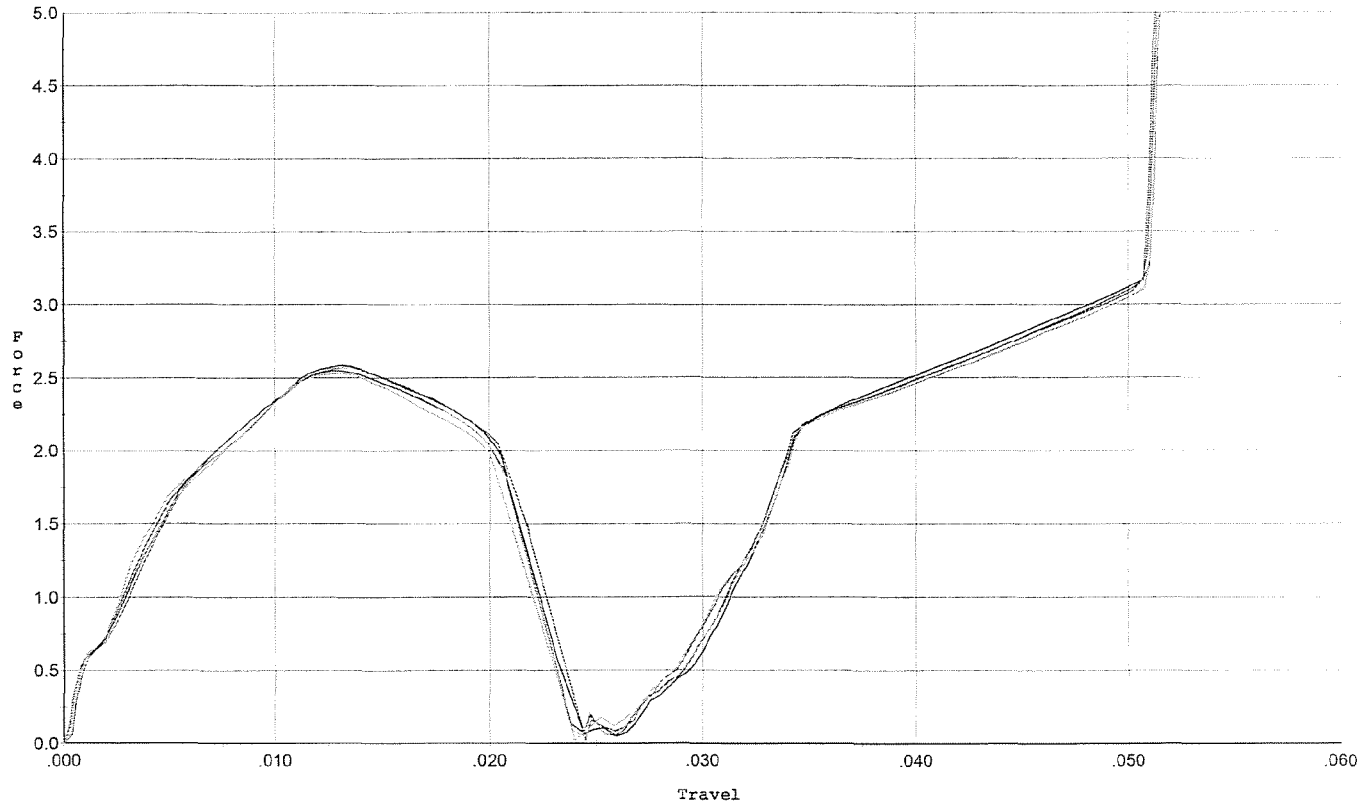
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.021	0.00	0.036	0.033		Set Trigger
2	2.482	0.021	0.00	0.036	0.033		Set Trigger
3	2.424	0.020	0.00	0.037	0.031		Set Trigger
4	2.471	0.020	0.00	0.036	0.033		Set Trigger
5	2.435	0.020	0.00	0.036	0.032		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



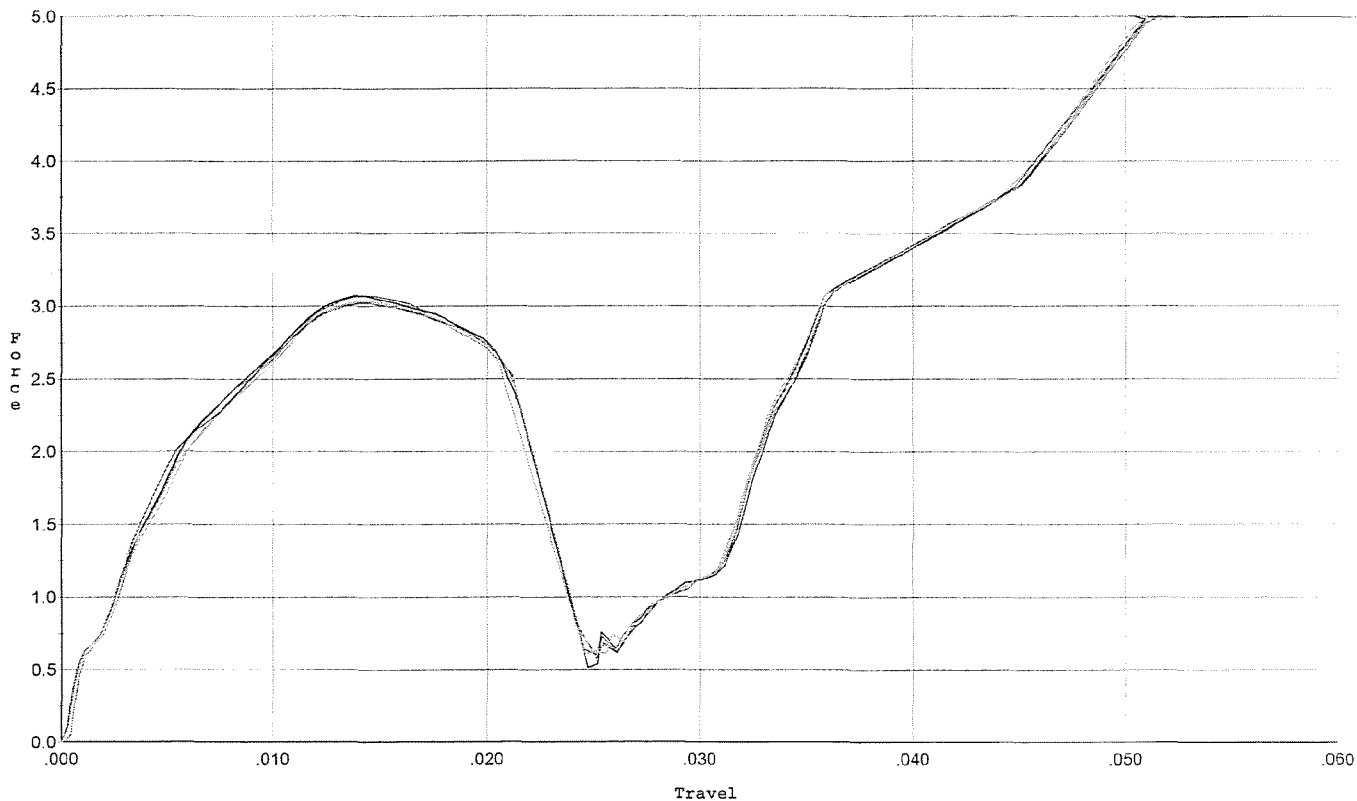
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.547	0.021	0.00	0.034	0.038		Set Trigger
2	2.585	0.020	0.00	0.034	0.038		Set Trigger
3	2.566	0.022	0.00	0.034	0.040		Set Trigger
4	2.531	0.022	0.00	0.034	0.039		Set Trigger
5	2.571	0.021	0.00	0.034	0.038		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



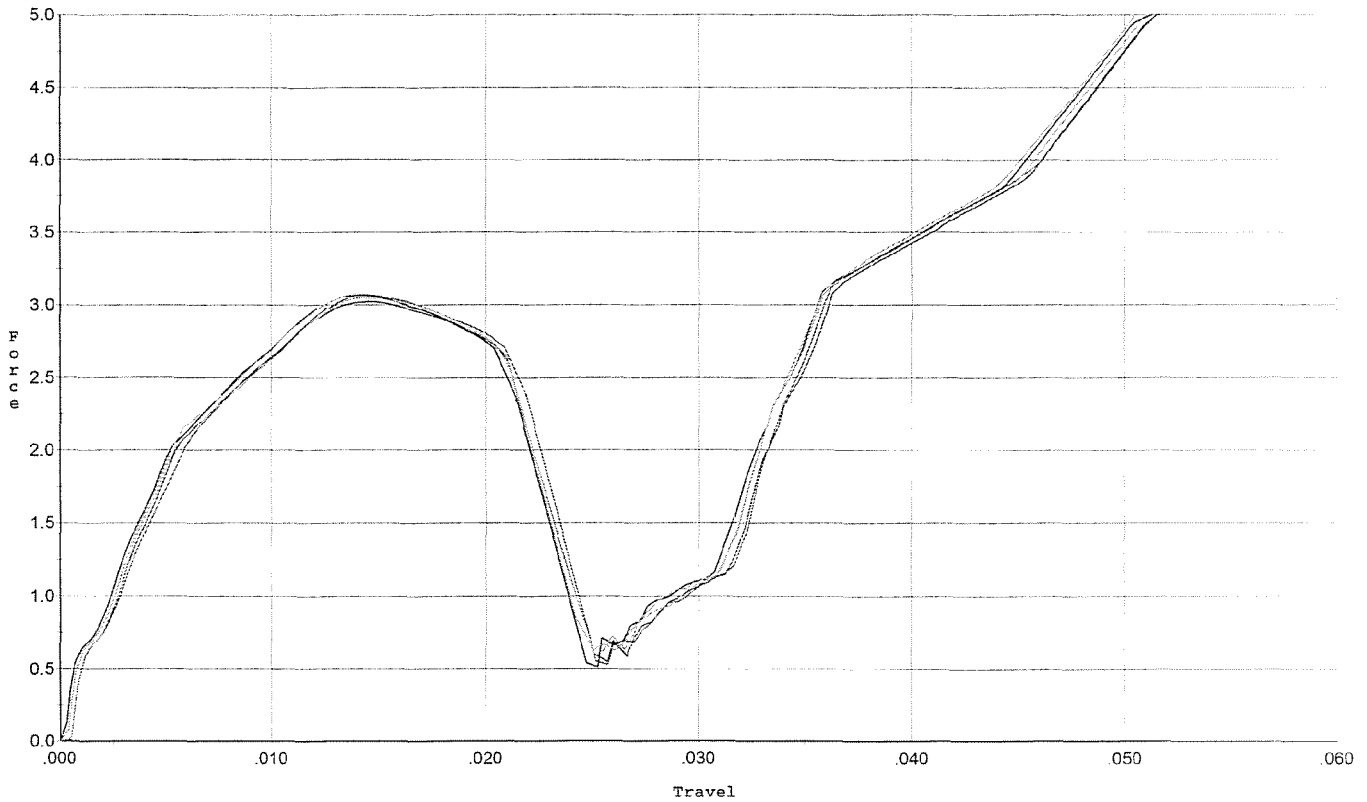
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.018	0.021	0.00	0.033	0.046		Set Trigger
2	3.070	0.021	0.00	0.033	0.047		Set Trigger
3	3.072	0.021	0.00	0.033	0.046		Set Trigger
4	3.031	0.021	0.00	0.033	0.045		Set Trigger
5	3.026	0.020	0.00	0.033	0.044		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



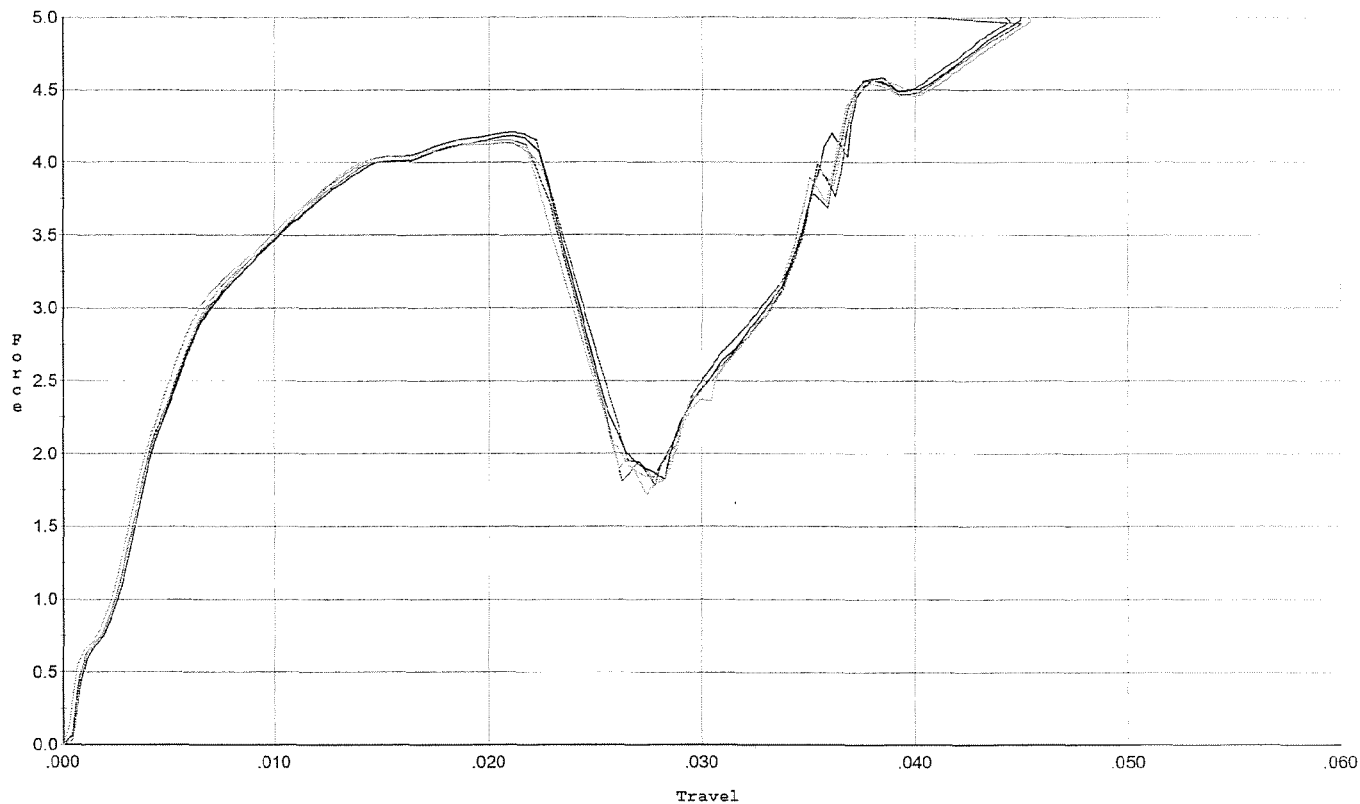
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.022	0.021	0.00	0.033	0.045		Set Trigger
2	3.065	0.021	0.00	0.033	0.047		Set Trigger
3	3.071	0.022	0.00	0.033	0.047		Set Trigger
4	3.074	0.021	0.00	0.033	0.046		Set Trigger
5	3.051	0.021	0.00	0.033	0.045		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



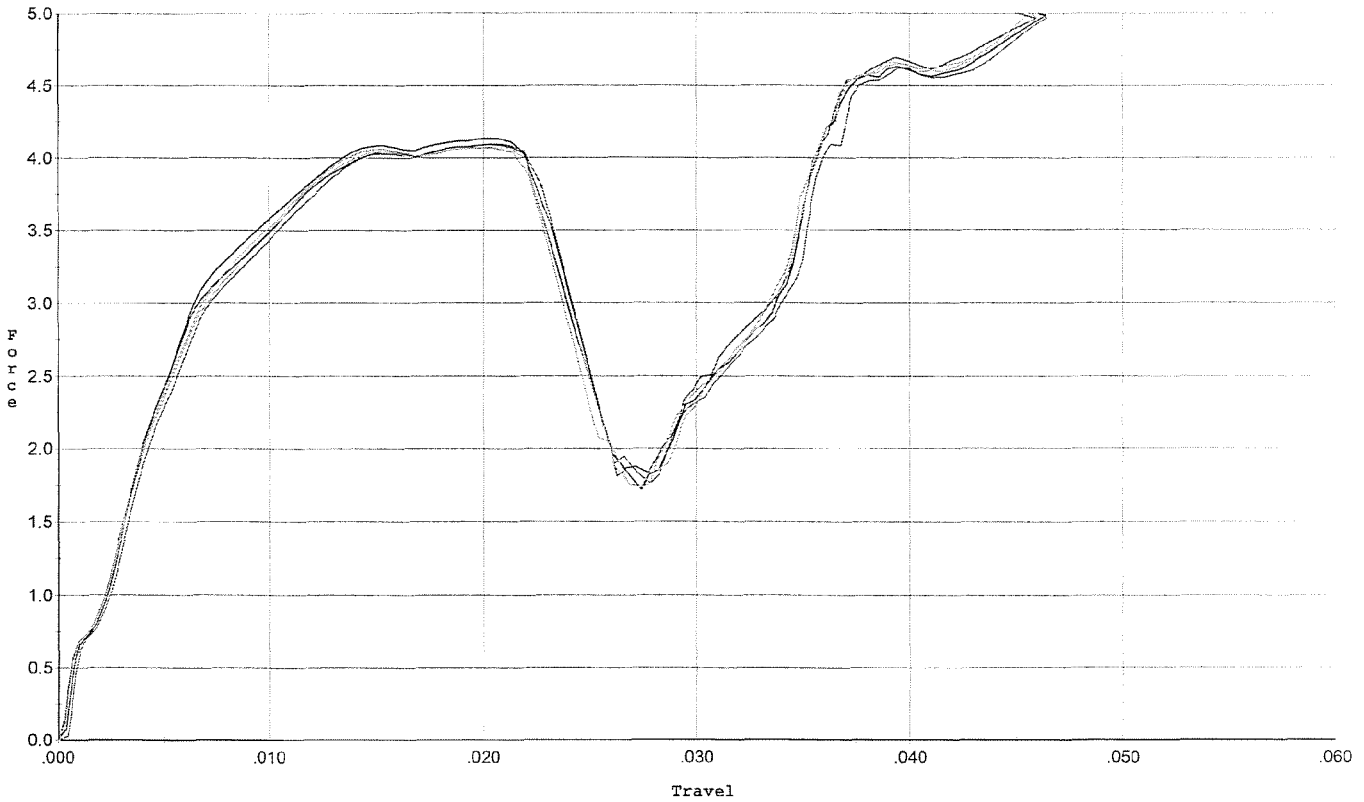
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.207	0.022	0.00	0.029	0.065		Set Trigger
2	4.181	0.022	0.00	0.029	0.065		Set Trigger
3	4.152	0.023	0.00	0.029	0.067		Set Trigger
4	4.147	0.022	0.00	0.030	0.064		Set Trigger
5	4.132	0.023	0.00	0.029	0.066		Set Trigger

Avg 4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



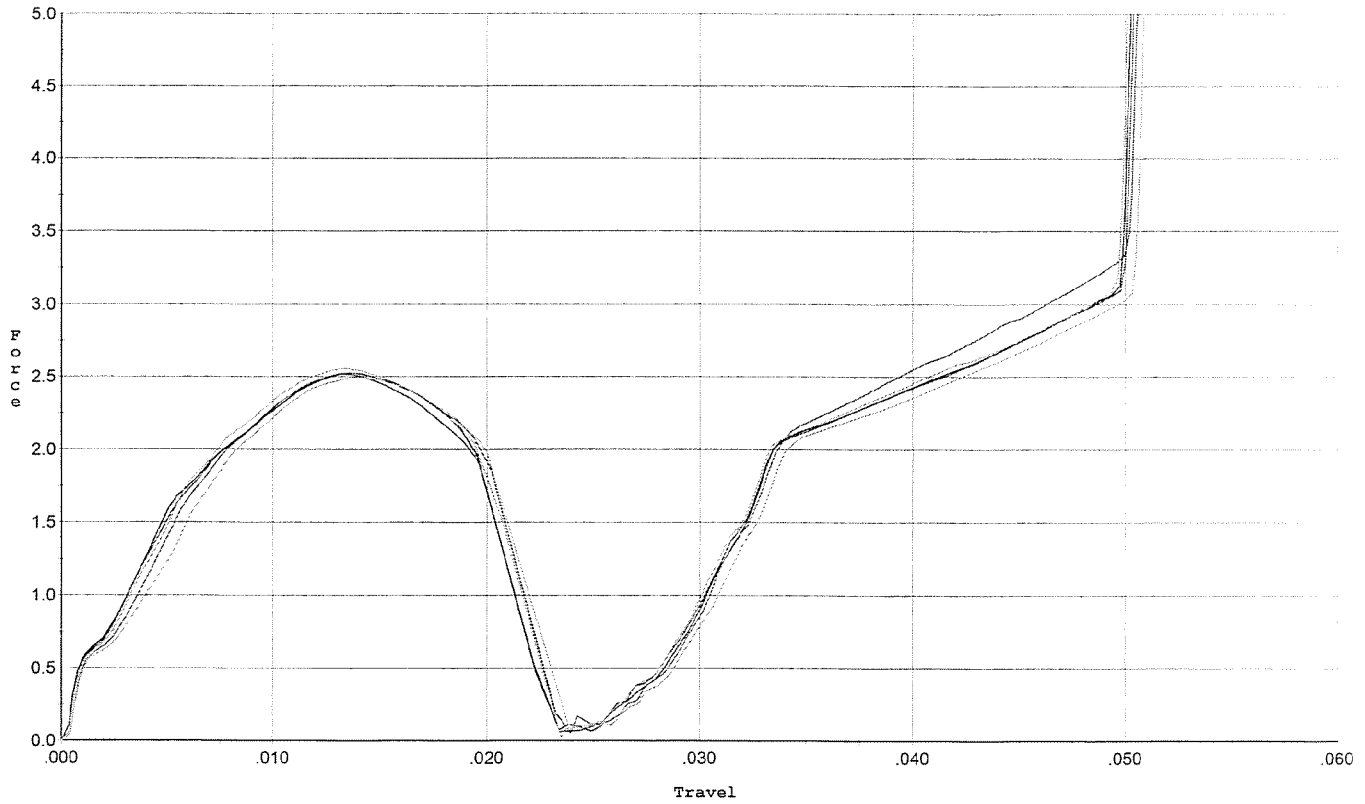
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.023	0.00	0.029	0.068		Set Trigger
2	4.135	0.022	0.00	0.029	0.065		Set Trigger
3	4.094	0.023	0.00	0.030	0.066		Set Trigger
4	4.074	0.024	0.00	0.029	0.070		Set Trigger
5	4.068	0.022	0.00	0.029	0.065		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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



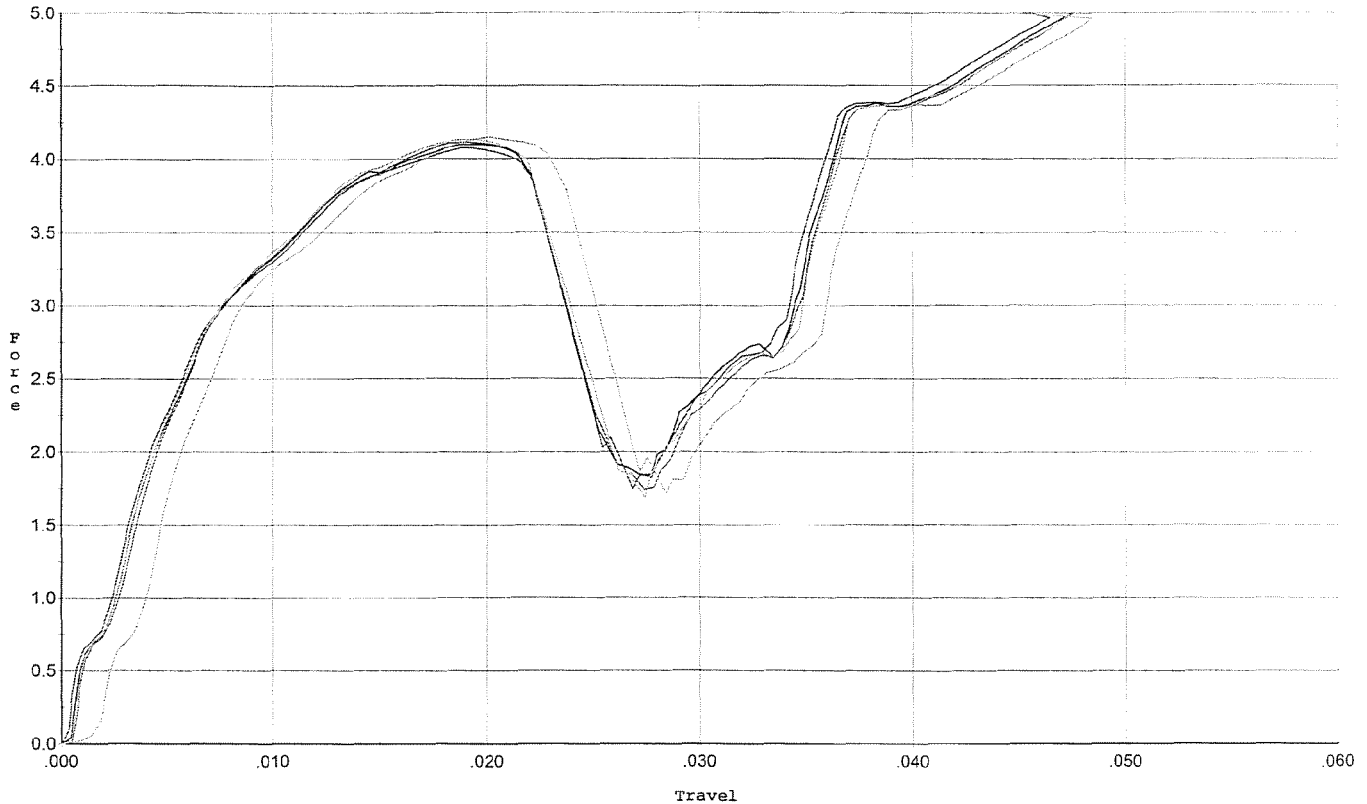
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.020	0.00	0.034	0.035		Set Trigger
2	2.525	0.020	0.00	0.034	0.035		Set Trigger
3	2.523	0.020	0.00	0.034	0.035		Set Trigger
4	2.494	0.020	0.00	0.034	0.034		Set Trigger
5	2.552	0.021	0.00	0.033	0.037		Set Trigger

Aug 252

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/13/09

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	4.113	0.022	0.00	0.029	0.063		Set Trigger
2	4.100	0.022	0.00	0.029	0.063		Set Trigger
3	4.078	0.022	0.00	0.030	0.062		Set Trigger
4	4.131	0.024	0.00	0.029	0.068		Set Trigger
5	4.147	0.024	0.00	0.030	0.065		Set Trigger

Avg 4.14