

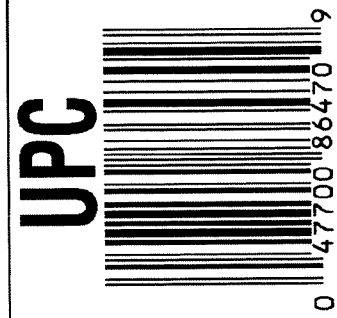
C6863660

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

G6863660



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6863660

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SPD
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SPD
460	CHECK HEADSPACE	MAGNA FLUX	6-10-09	SPD
470	DIS-ASSEMBLE ACTION		6-10-09	SPD
472	SERIALIZE BOLT HANDLE		6-11-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (R)	6/13/09	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/16/09	KRM
540	APPLY COATINGS (BARREL ACTION)		6/24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-26-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-26-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-26-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-7-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

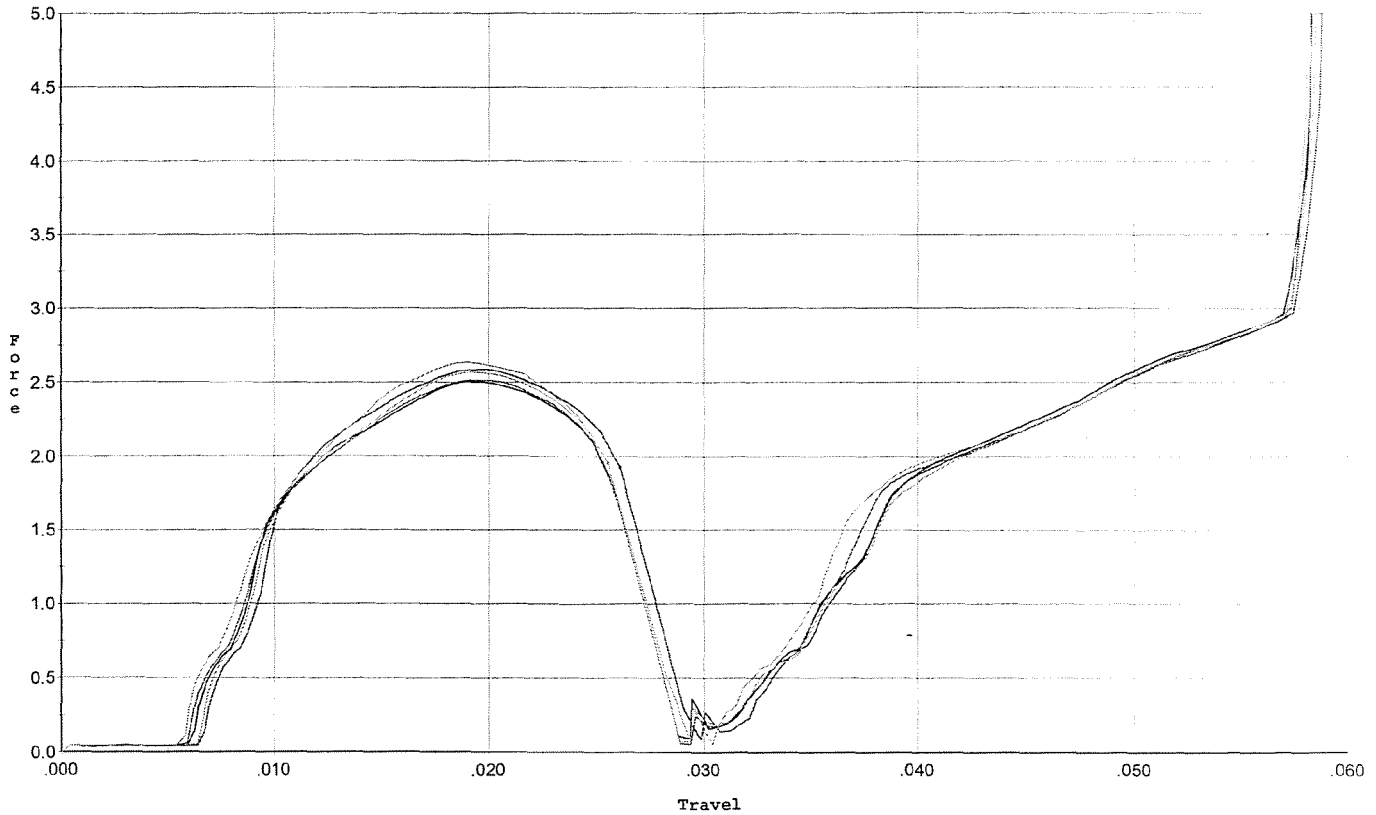
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>024</u> <u>024</u> <u>024</u>	8-14-09	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>250</u> <u>275</u> <u>250</u>	8-14-09	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>675</u> <u>675</u> <u>675</u>	8-14-09	RTZ
	J) ASSEMBLE STOCK		8-7-09	APPD
	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	8/11/09	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/11/09	TOR
670	FINAL INSPECTION A) HEADSPACE		8-14-09	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>272</u> <u>275</u> <u>280</u> <u>278</u> <u>277</u>	8-14-09	2022
	C) FUNCTION		8-14-09	RTZ
690	PACK		8/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



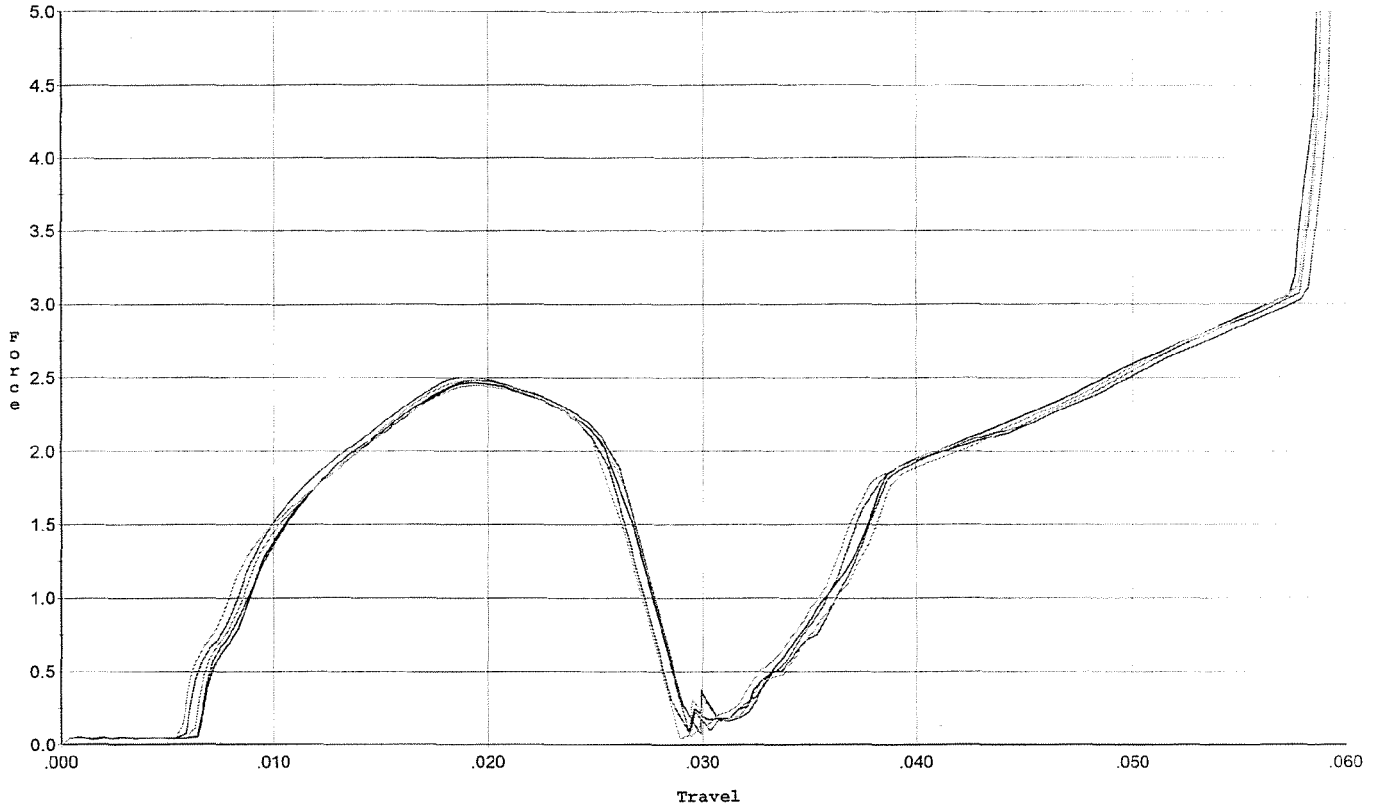
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.026	0.007	0.038	0.039		Set Trigger
2	2.505	0.026	0.006	0.037	0.038		Set Trigger
3	2.516	0.026	0.006	0.037	0.038		Set Trigger
4	2.566	0.026	0.007	0.038	0.038		Set Trigger
5	2.635	0.026	0.006	0.037	0.040		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



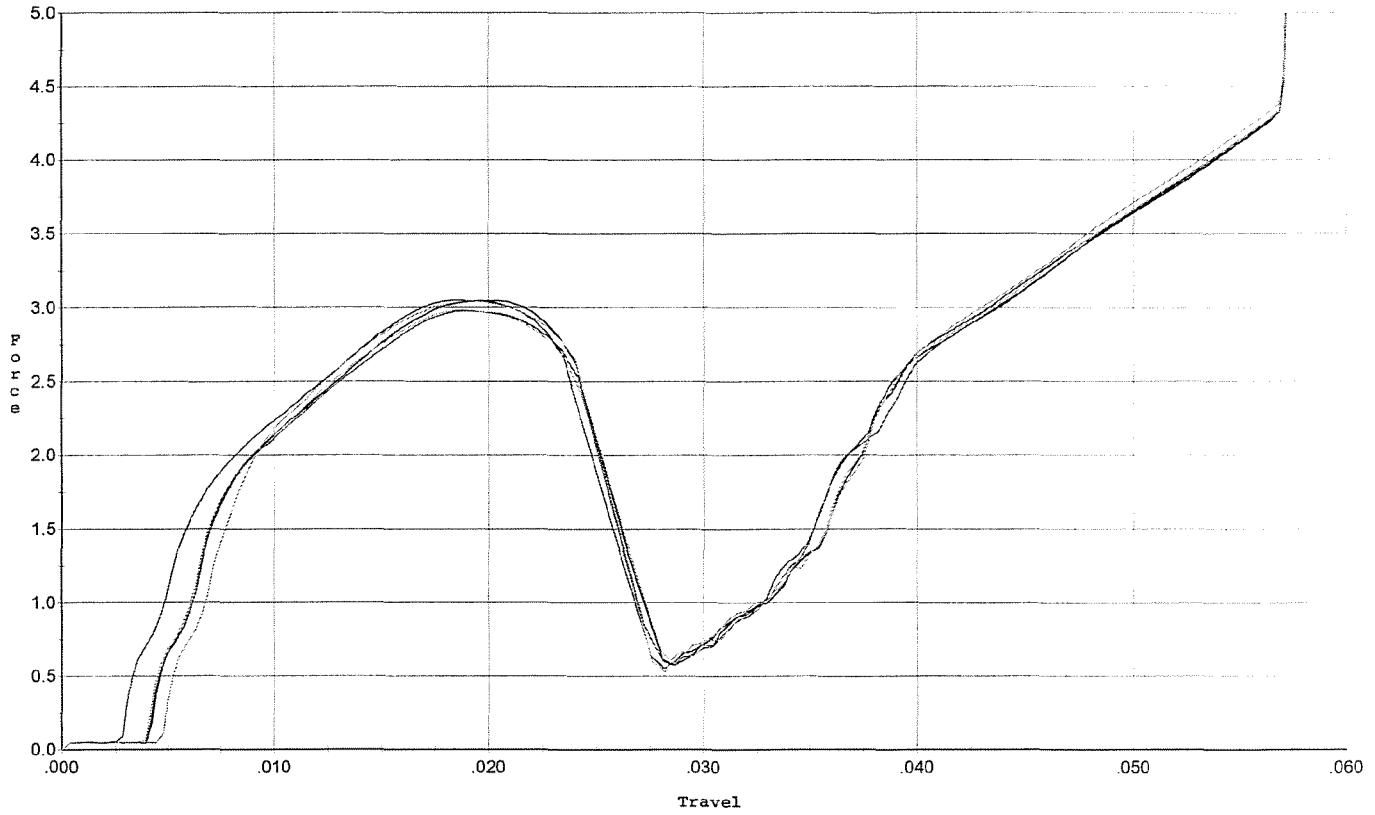
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.481	0.026	0.007	0.038	0.037		Set Trigger
2	2.466	0.027	0.007	0.037	0.038		Set Trigger
3	2.501	0.026	0.006	0.038	0.037		Set Trigger
4	2.445	0.026	0.006	0.038	0.037		Set Trigger
5	2.482	0.026	0.006	0.037	0.038		Set Trigger

Aug 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



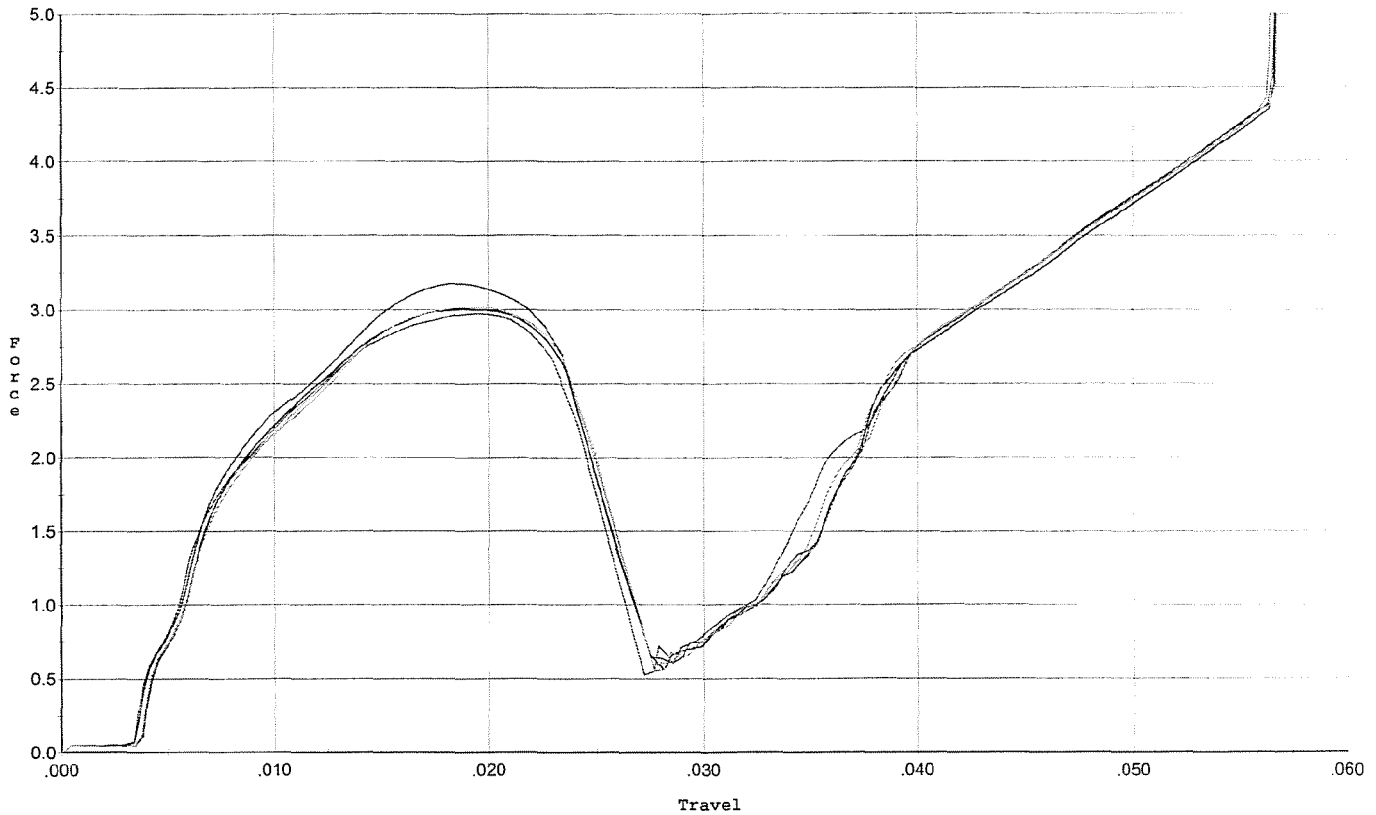
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.050	0.023	0.003	0.037	0.046		Set Trigger
2	3.047	0.024	0.004	0.036	0.045		Set Trigger
3	2.980	0.024	0.004	0.036	0.045		Set Trigger
4	2.985	0.024	0.004	0.036	0.046		Set Trigger
5	3.045	0.024	0.005	0.036	0.044		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



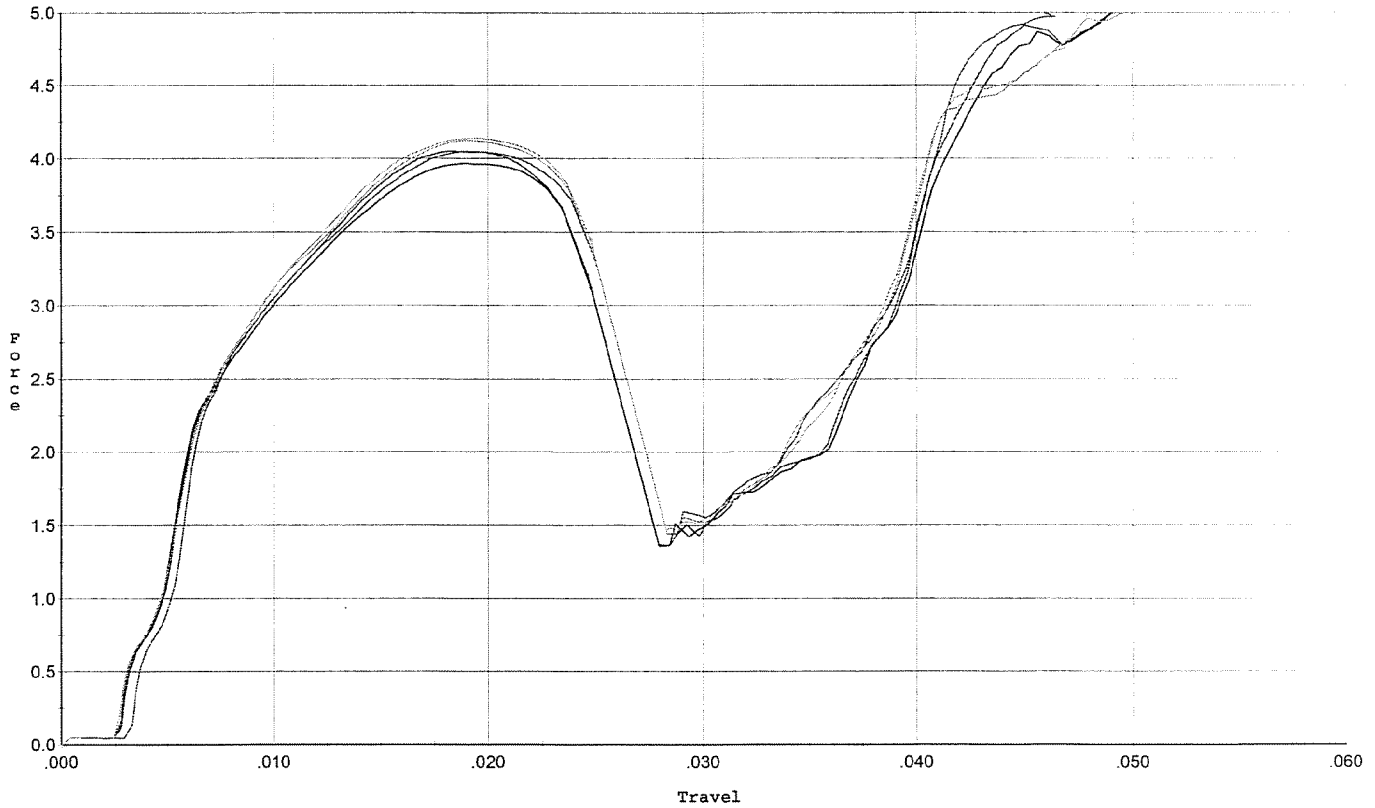
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.023	0.004	0.036	0.046		Set Trigger
2	3.009	0.024	0.004	0.036	0.045		Set Trigger
3	2.974	0.024	0.004	0.036	0.046		Set Trigger
4	3.018	0.025	0.004	0.036	0.047		Set Trigger
5	3.002	0.025	0.004	0.036	0.048		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



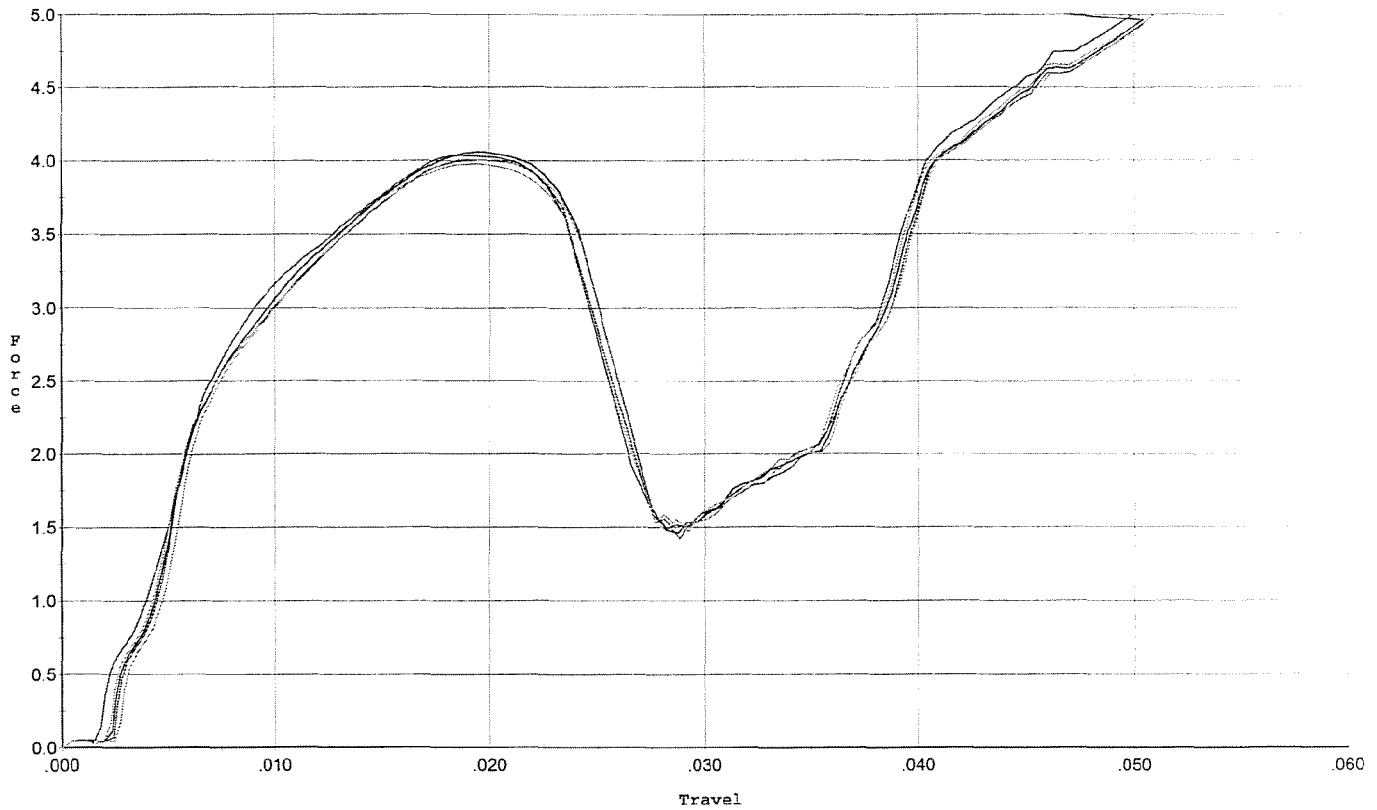
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.050	0.025	0.003	0.034	0.064		Set Trigger
2	3.967	0.025	0.003	0.034	0.064		Set Trigger
3	4.049	0.025	0.003	0.033	0.065		Set Trigger
4	4.136	0.025	0.003	0.033	0.066		Set Trigger
5	4.123	0.025	0.003	0.033	0.067		Set Trigger

AVG 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



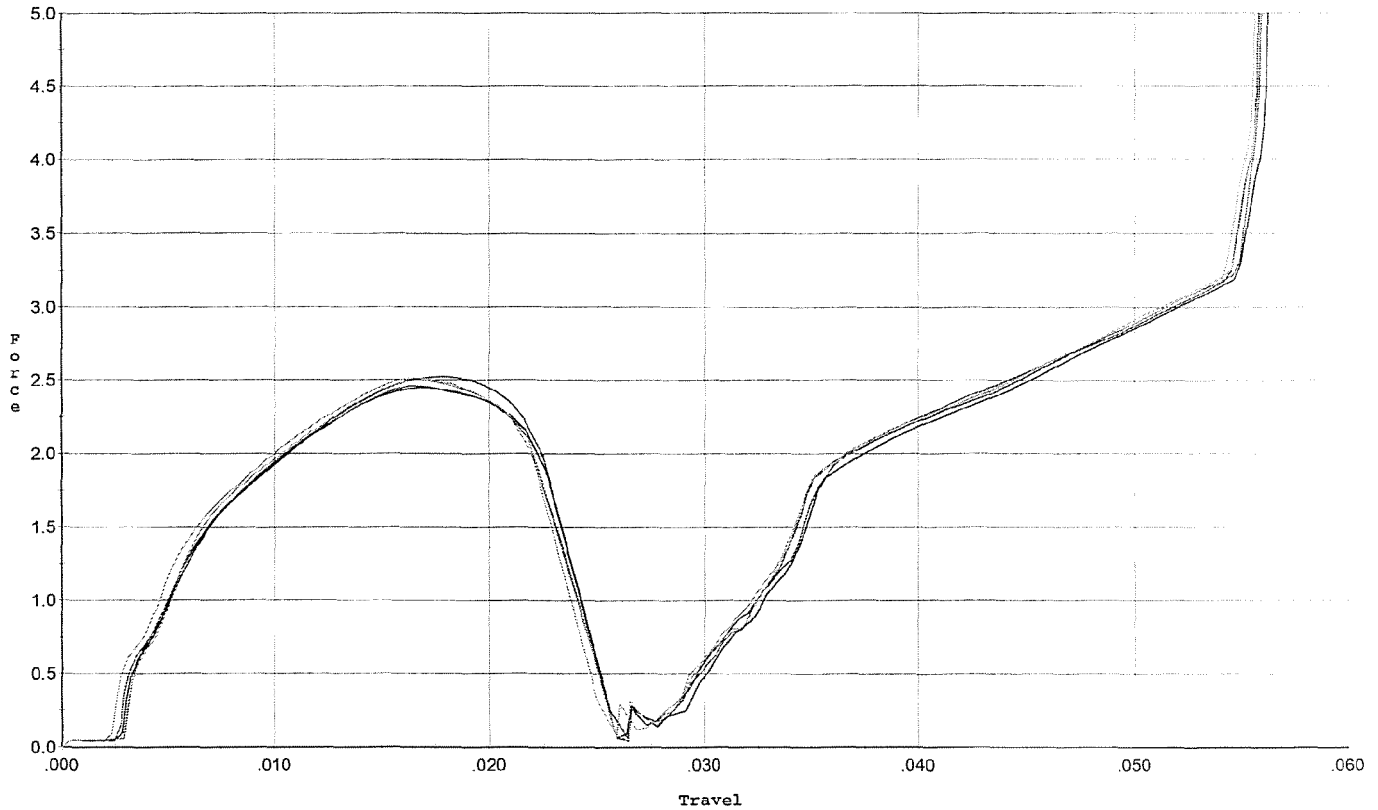
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.038	0.024	0.002	0.034	0.063		Set Trigger
2	4.056	0.024	0.002	0.033	0.064		Set Trigger
3	4.003	0.023	0.003	0.034	0.061		Set Trigger
4	4.009	0.024	0.003	0.033	0.063		Set Trigger
5	3.978	0.024	0.00	0.033	0.061		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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



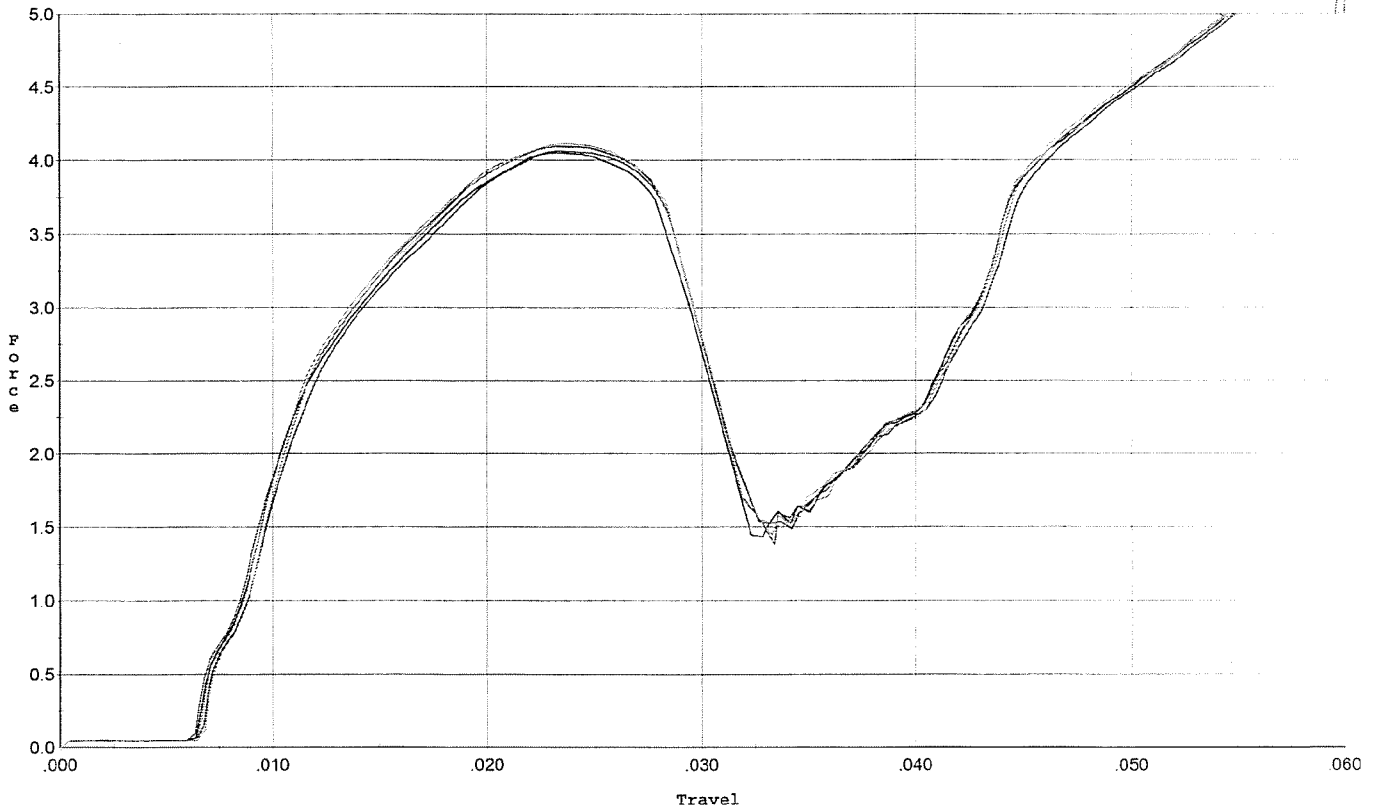
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.522	0.022	0.003	0.037	0.037		Set Trigger
2	2.450	0.023	0.003	0.037	0.037		Set Trigger
3	2.461	0.024	0.003	0.037	0.038		Set Trigger
4	2.500	0.024	0.003	0.037	0.038		Set Trigger
5	2.510	0.022	0.002	0.037	0.037		Set Trigger

Aug 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/23/09

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	4.065	0.028	0.007	0.034	0.065		Set Trigger
2	4.052	0.029	0.007	0.034	0.068		Set Trigger
3	4.093	0.028	0.007	0.034	0.067		Set Trigger
4	4.112	0.028	0.007	0.034	0.066		Set Trigger
5	4.100	0.029	0.007	0.034	0.067		Set Trigger

Avg 4.08