

66863660

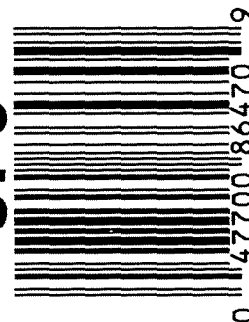
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6863666

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6863666

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SP
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SP
460	CHECK HEADSPACE		6-10-09	SP
470	DIS-ASSEMBLE ACTION		6-10-09	SP
472	SERIALIZE BOLT HANDLE		6-11-09	SP
480	MAGNAFLUX BBL ACTION		6-13-09	RT
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	RT
540	APPLY COATINGS (BARREL ACTION)		6-24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-11-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

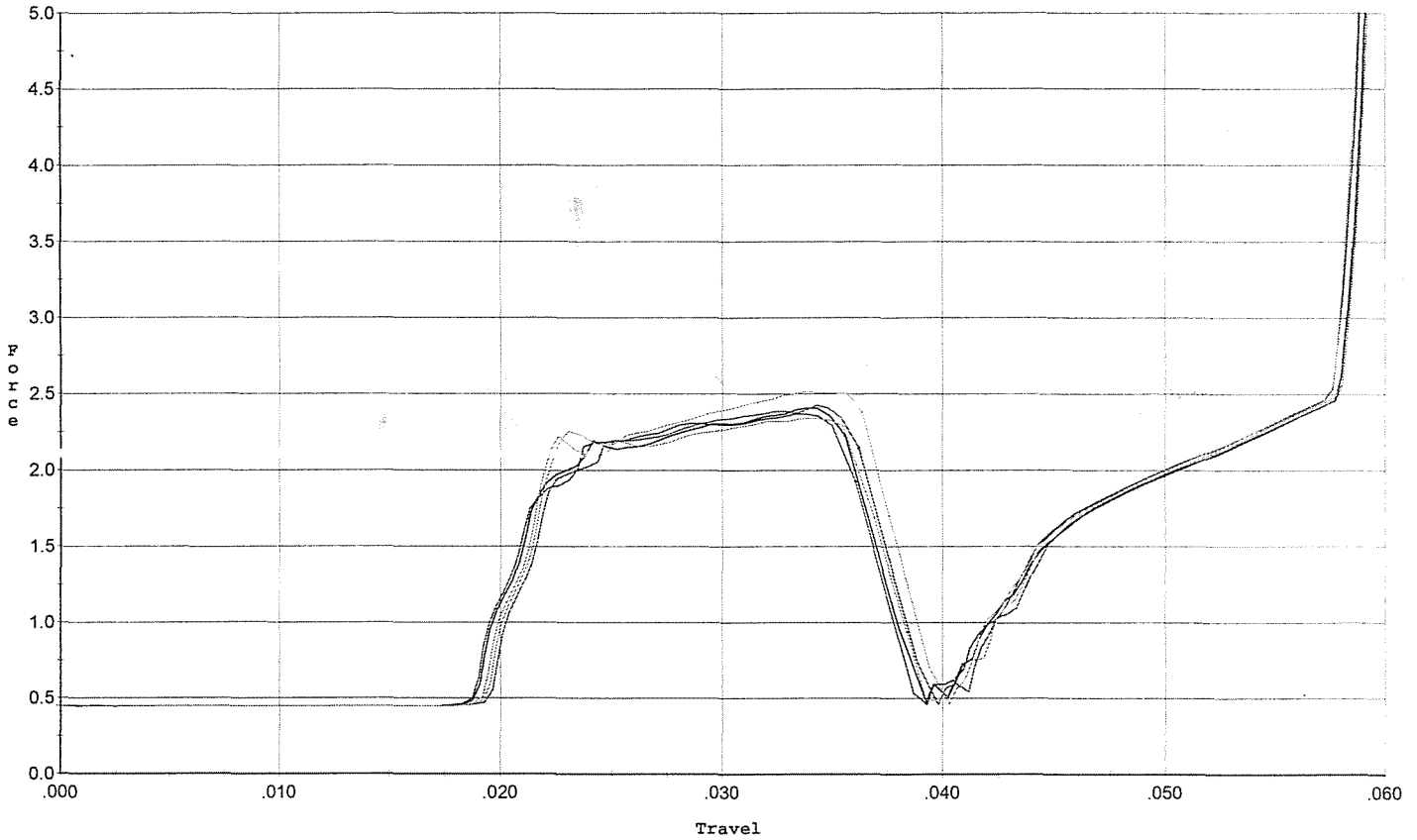
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	8/20/09	RB
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	8/20/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>023</u> <u>023</u> <u>023</u>	8/20/09	RB
	J) ASSEMBLE STOCK		8-11-09	SN
	K) ASSEMBLE SWIVEL STUDS		8/20/09	RB
	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	8-18-09 8-18-09	SN SN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-18-09	SN
670	FINAL INSPECTION A) HEADSPACE		8/20/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.71</u> <u>2.52</u> <u>2.46</u> <u>2.48</u>	8-20-09	RB
	C) FUNCTION		8/20/09	RB
690	PACK		8/21/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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



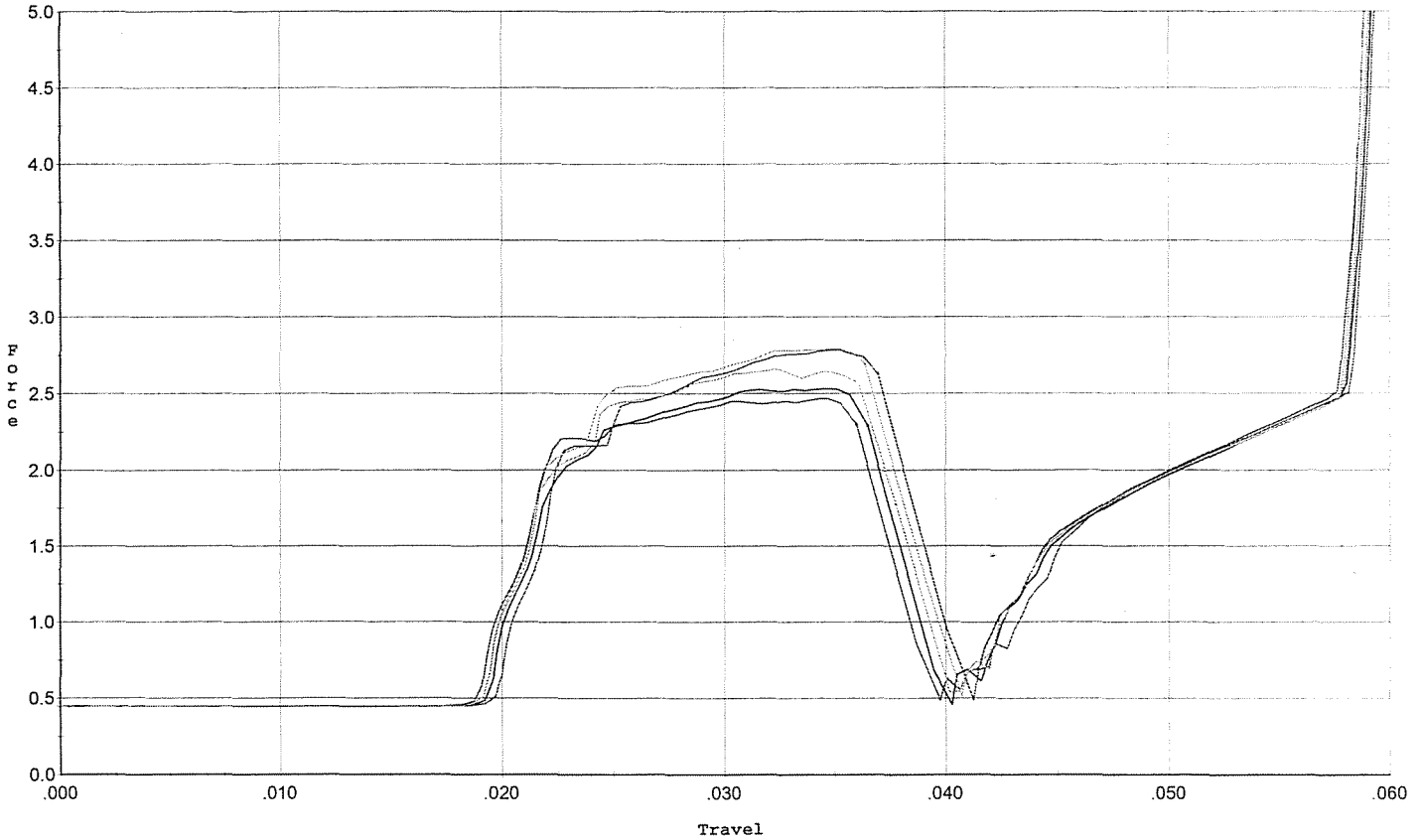
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.372	0.036	0.019	0.026	0.044		Set Trigger
2	2.409	0.036	0.019	0.027	0.043		Set Trigger
3	2.427	0.036	0.020	0.026	0.044		Set Trigger
4	2.513	0.036	0.020	0.026	0.046		Set Trigger
5	2.342	0.037	0.019	0.026	0.045		Set Trigger

17-2.41

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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



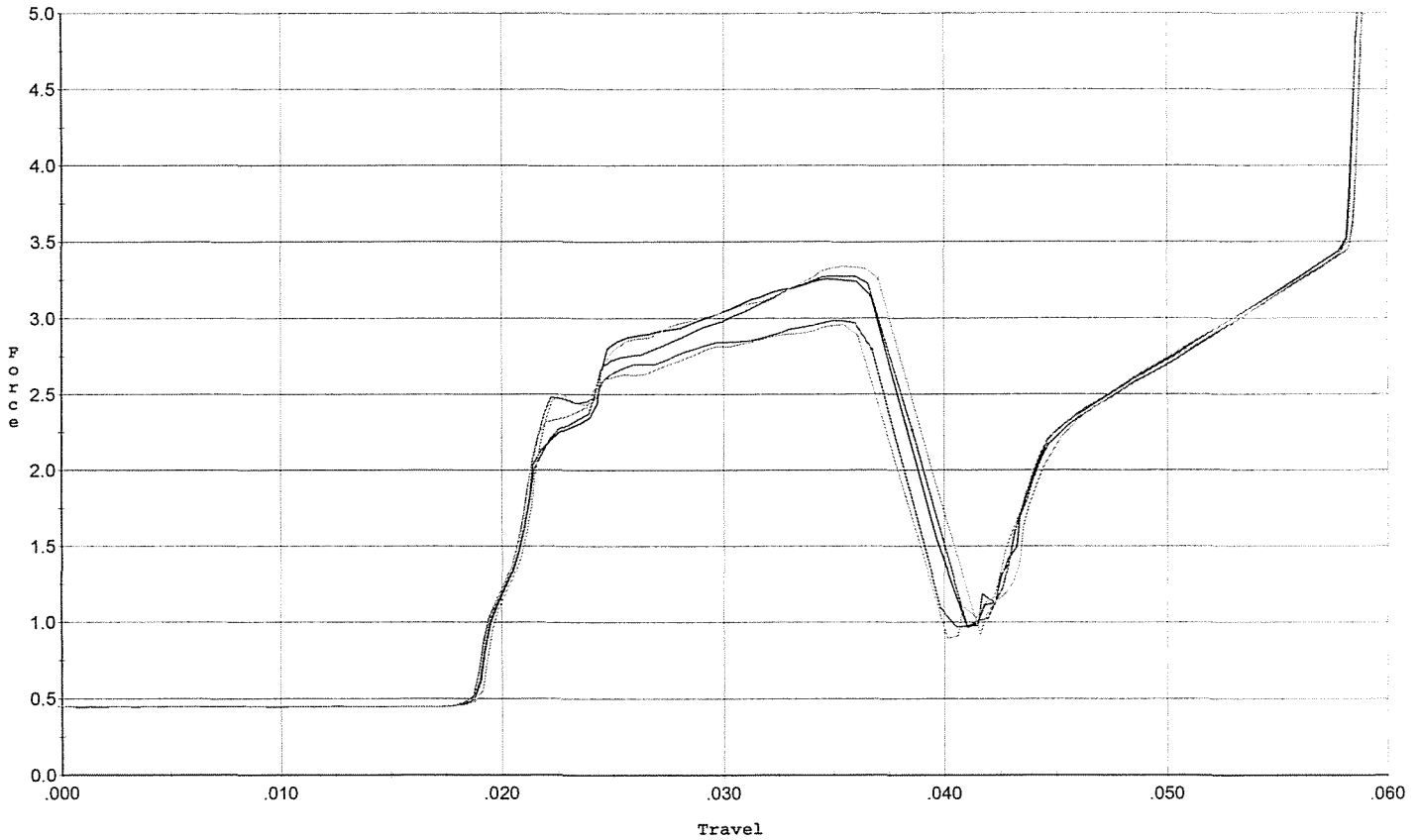
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.465	0.036	0.019	0.025	0.046		Set Trigger
2	2.531	0.037	0.020	0.025	0.046		Set Trigger
3	2.780	0.037	0.020	0.025	0.050		Set Trigger
4	2.793	0.036	0.019	0.024	0.050		Set Trigger
5	2.661	0.038	0.019	0.024	0.050		Set Trigger

A. 2.64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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	3.274	0.039	0.019	0.023	0.060		Set Trigger
2	3.255	0.037	0.019	0.023	0.057		Set Trigger
3	2.985	0.037	0.019	0.024	0.054		Set Trigger
4	3.336	0.037	0.019	0.023	0.059		Set Trigger
5	2.955	0.036	0.019	0.024	0.052		Set Trigger

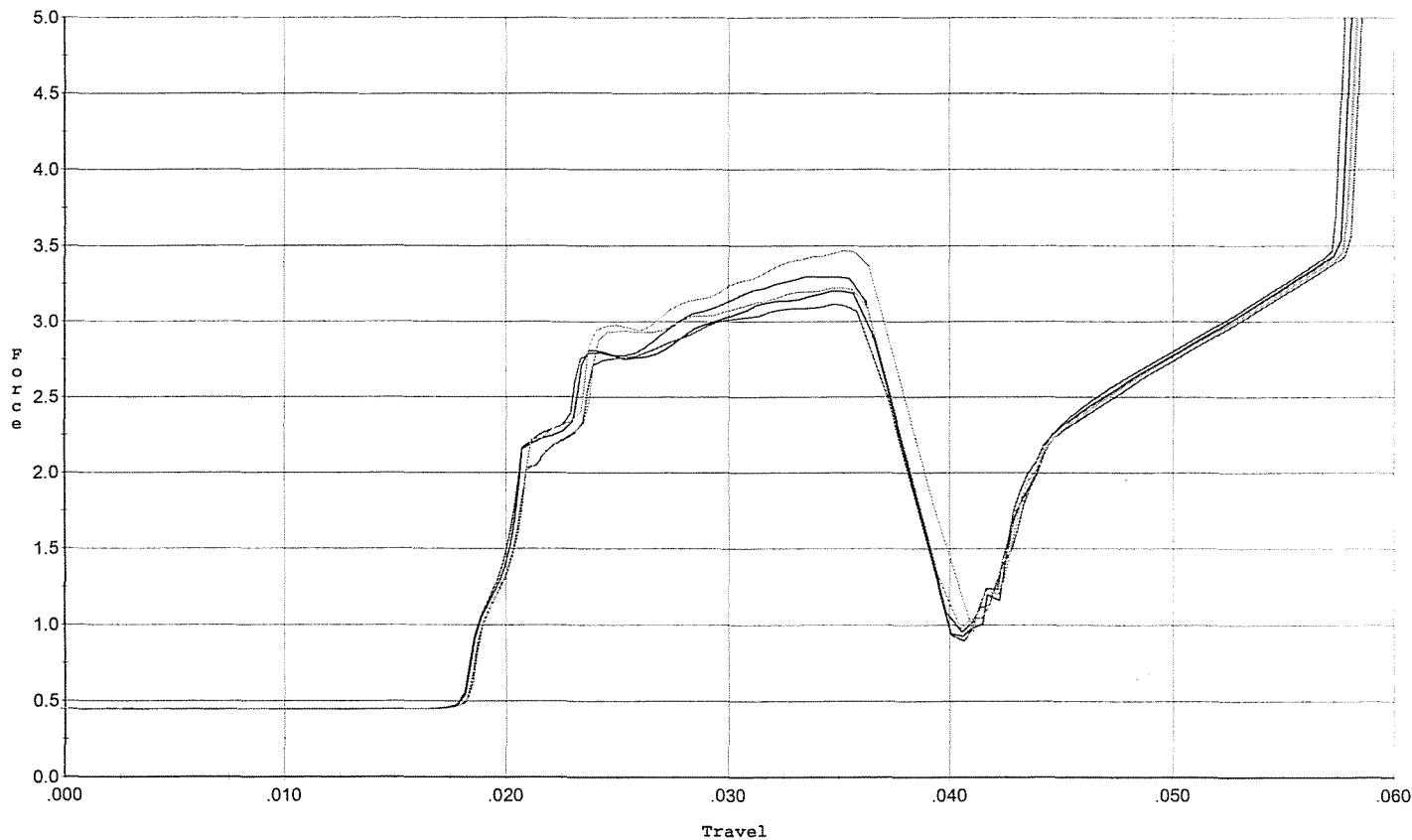
A3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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

After 20 cycles



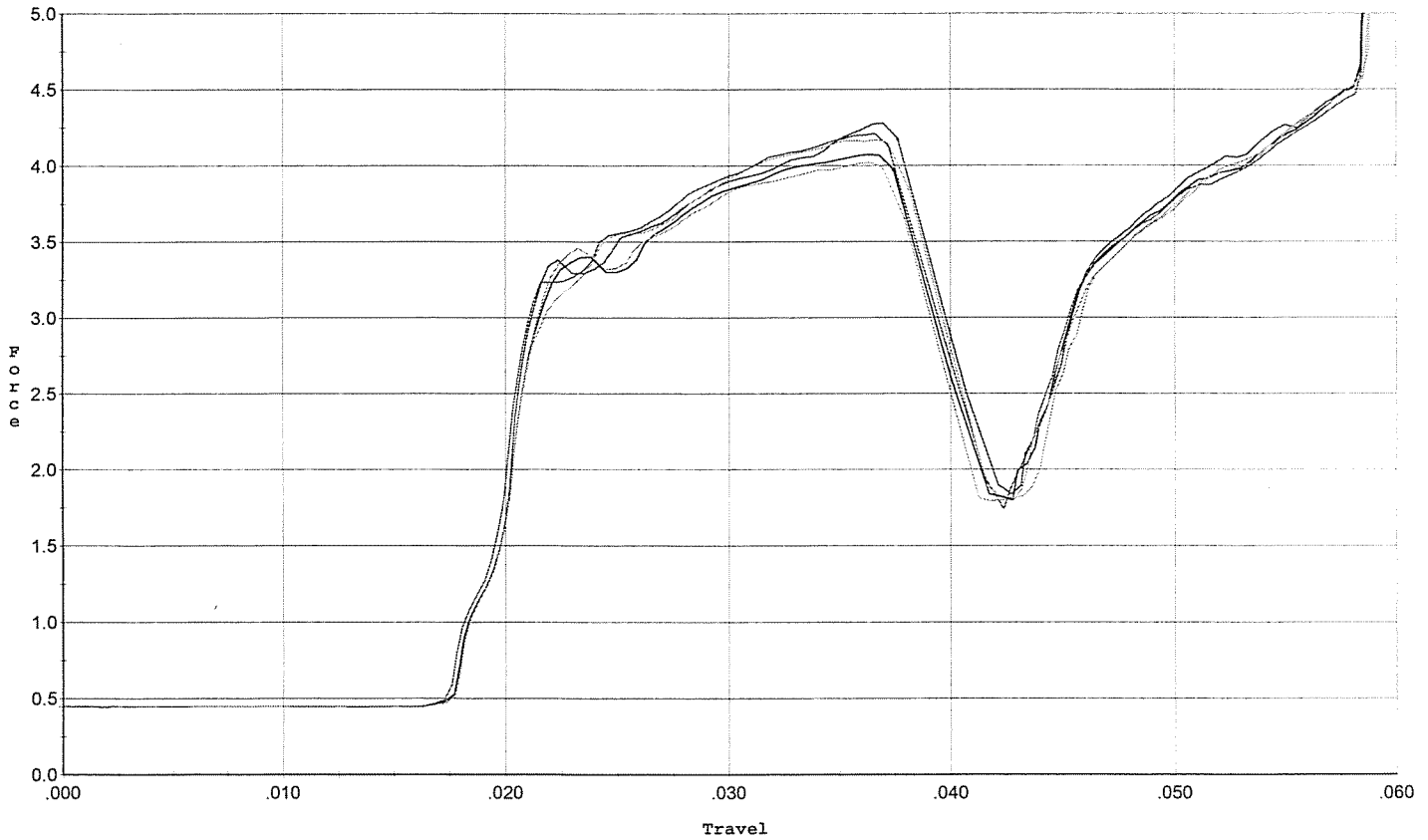
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.297	0.036	0.018	0.023	0.058		Set Trigger
2	3.202	0.037	0.018	0.023	0.057		Set Trigger
3	3.117	0.037	0.019	0.024	0.057		Set Trigger
4	3.469	0.036	0.019	0.023	0.060		Set Trigger
5	3.222	0.036	0.018	0.023	0.057		Set Trigger

A. 3-26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: CMS 8/10/2009

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



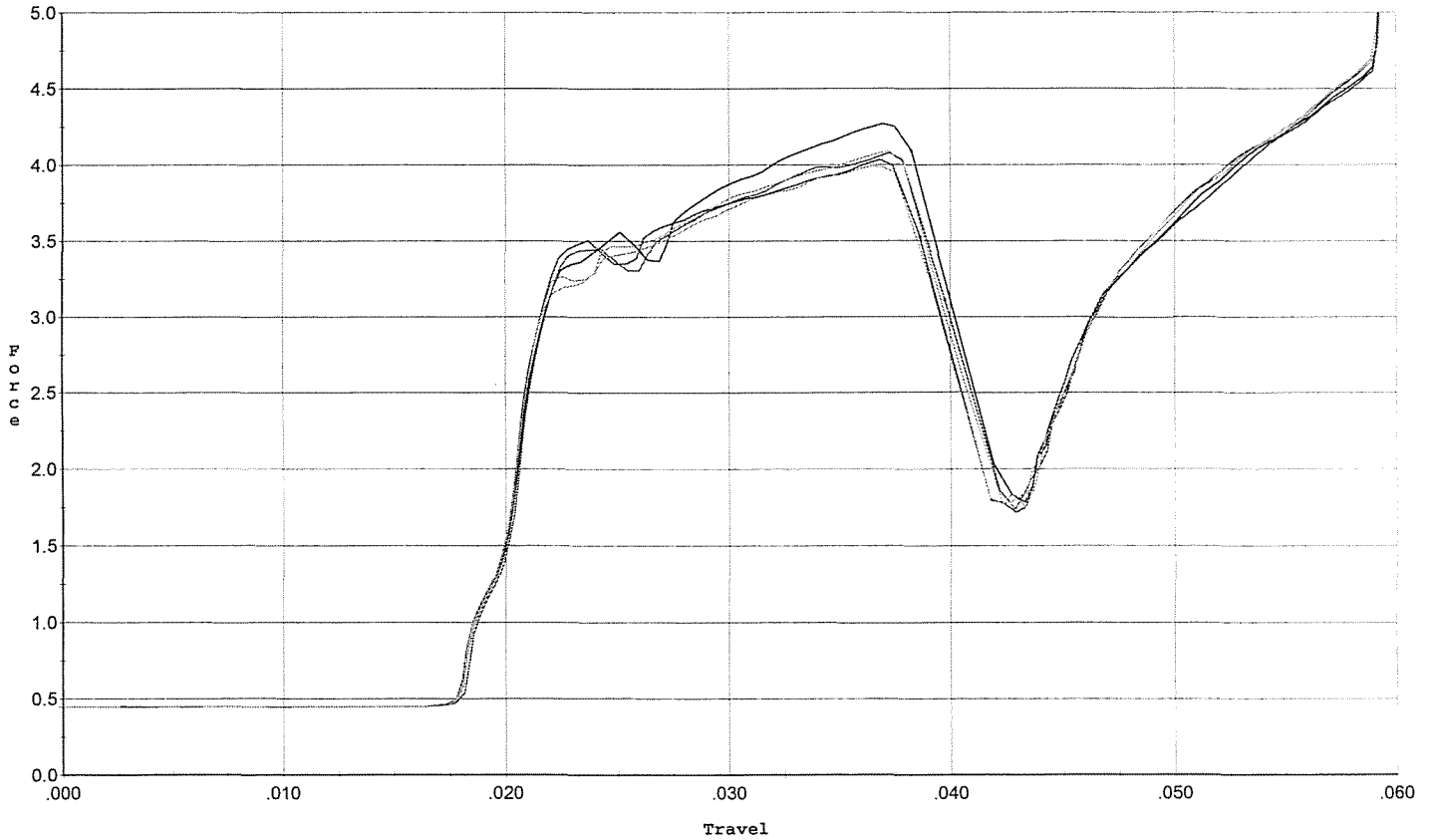
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.280	0.038	0.018	0.020	0.077		Set Trigger
2	4.073	0.037	0.018	0.021	0.075		Set Trigger
3	4.210	0.037	0.018	0.021	0.076		Set Trigger
4	4.169	0.038	0.018	0.021	0.078		Set Trigger
5	4.022	0.038	0.018	0.021	0.075		Set Trigger

A. 4.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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



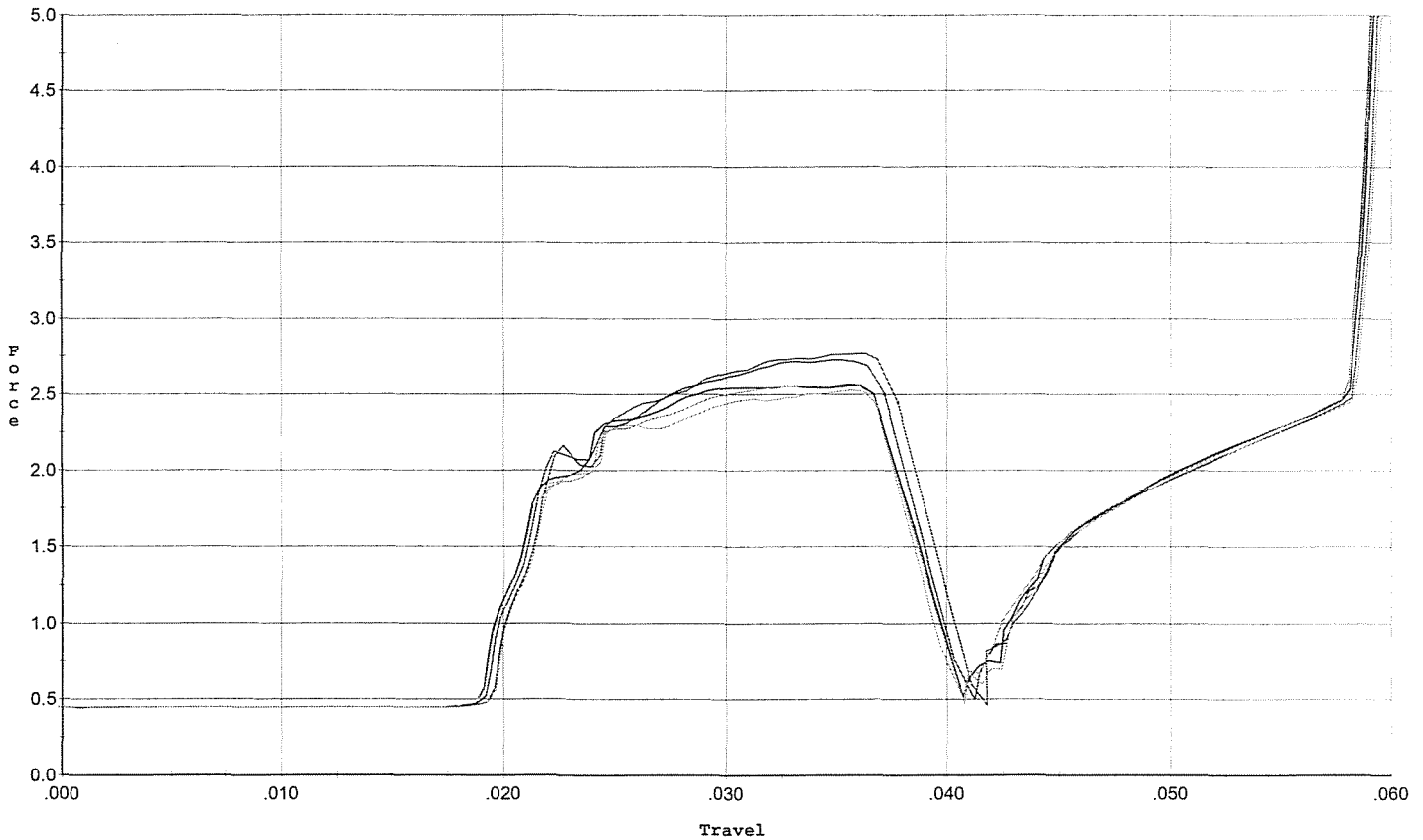
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.033	0.039	0.018	0.021	0.077		Set Trigger
2	4.269	0.038	0.018	0.021	0.078		Set Trigger
3	4.080	0.040	0.018	0.021	0.079		Set Trigger
4	4.091	0.038	0.018	0.021	0.075		Set Trigger
5	3.989	0.039	0.018	0.021	0.077		Set Trigger

A-4-09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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



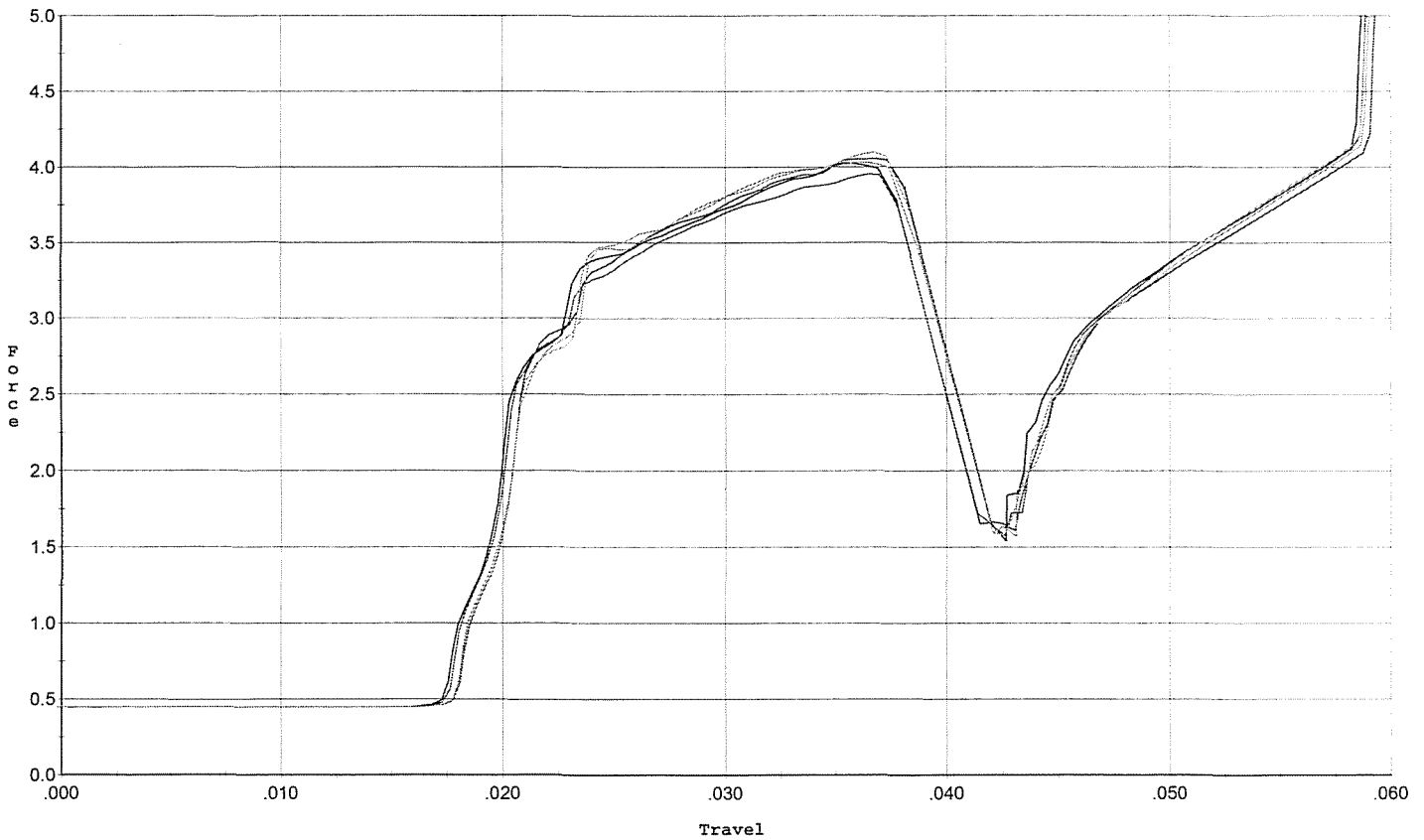
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.726	0.037	0.019	0.025	0.051		Set Trigger
2	2.559	0.039	0.019	0.024	0.051		Set Trigger
3	2.768	0.038	0.020	0.024	0.052		Set Trigger
4	2.529	0.037	0.020	0.026	0.047		Set Trigger
5	2.569	0.037	0.019	0.025	0.048		Set Trigger

A-2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: CMS 8/10/2009

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	4.055	0.038	0.018	0.021	0.075		Set Trigger
2	4.027	0.038	0.018	0.021	0.075		Set Trigger
3	3.955	0.038	0.018	0.021	0.074		Set Trigger
4	4.097	0.038	0.018	0.021	0.076		Set Trigger
5	4.031	0.039	0.018	0.021	0.077		Set Trigger

A-4.03