

66868448

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



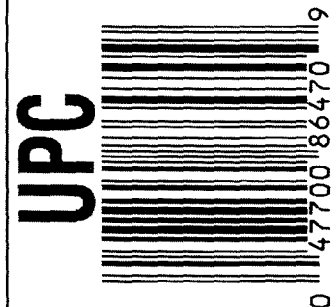
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6868448



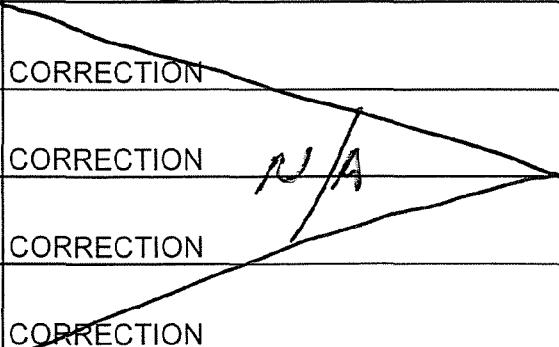
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 686 8448

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-09	SPD
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SPD
460	CHECK HEADSPACE		7-28-09	SPD
470	DIS-ASSEMBLE ACTION		7-28-09	SPD
472	SERIALIZE BOLT HANDLE		7-29-09	FTC
480	MAGNAFLUX BBL ACTION		7/31/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	DWO
510	DRILL AND TAP SIGHT HOLES		7-29-09	SP
520	GOFF BLAST BBL / REC		7/31/09	ML
540	APPLY COATINGS (BARREL ACTION)		8/11	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-24-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

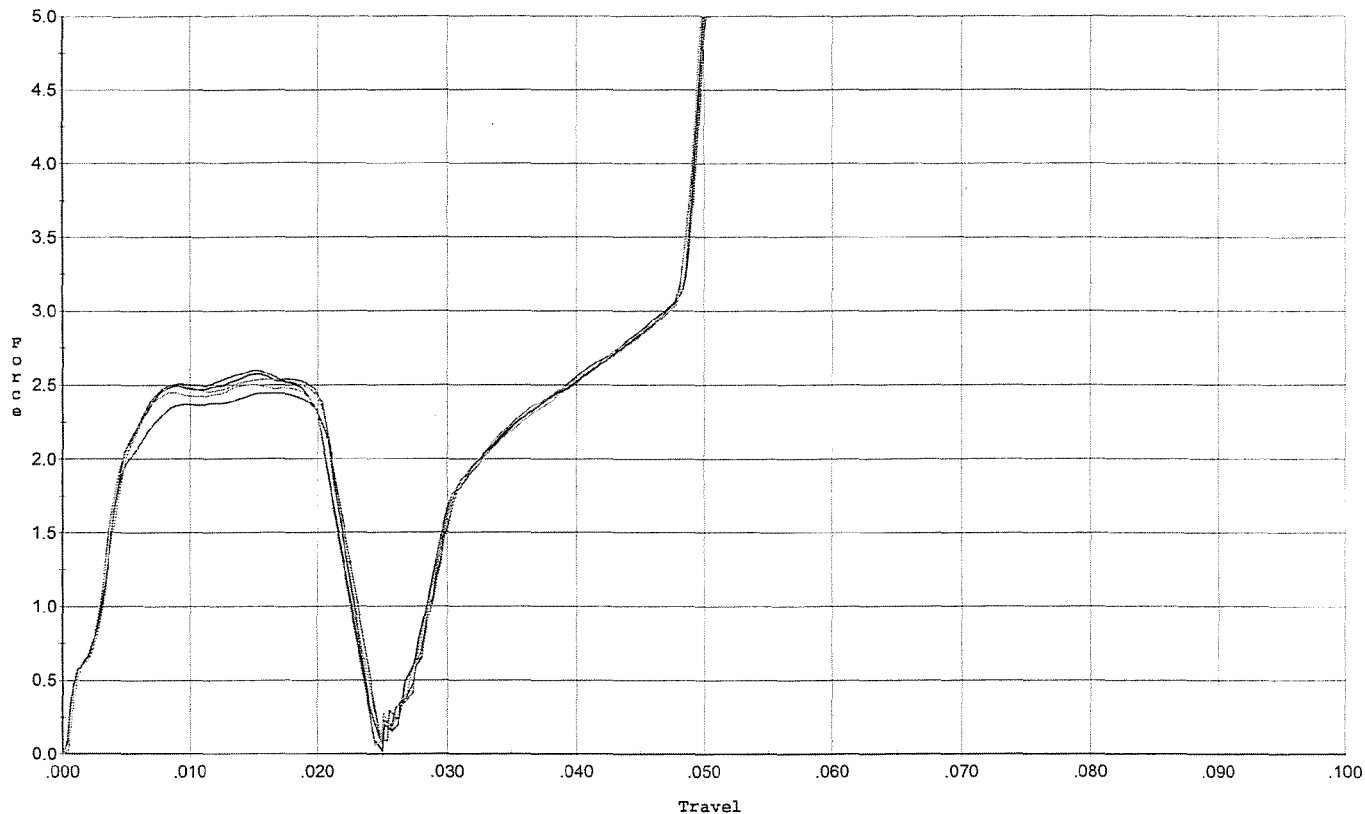
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2°</u>	<u>2°</u>	<u>2°</u>	8/27/09	RB		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>1°</u>	<u>1°</u>	<u>1°</u>	8/27/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	8/27/09	RB		
	J) ASSEMBLE STOCK					8/24/09	R.P.A.		
	K) ASSEMBLE SWIVEL STUDS					8/27/09	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		8/26/09	RB		
			<u>PASS</u>	FAIL					
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					8/26/09	TAR		
670	FINAL INSPECTION A) HEADSPACE					8/27/09	RB		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u>	<u>2.72</u>	<u>2.66</u>	<u>2.51</u>	<u>2.50</u>	8/26/09	RB
	C) FUNCTION					8/27/09	RB		
690	PACK					8-27-09	TL		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: Profile1
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



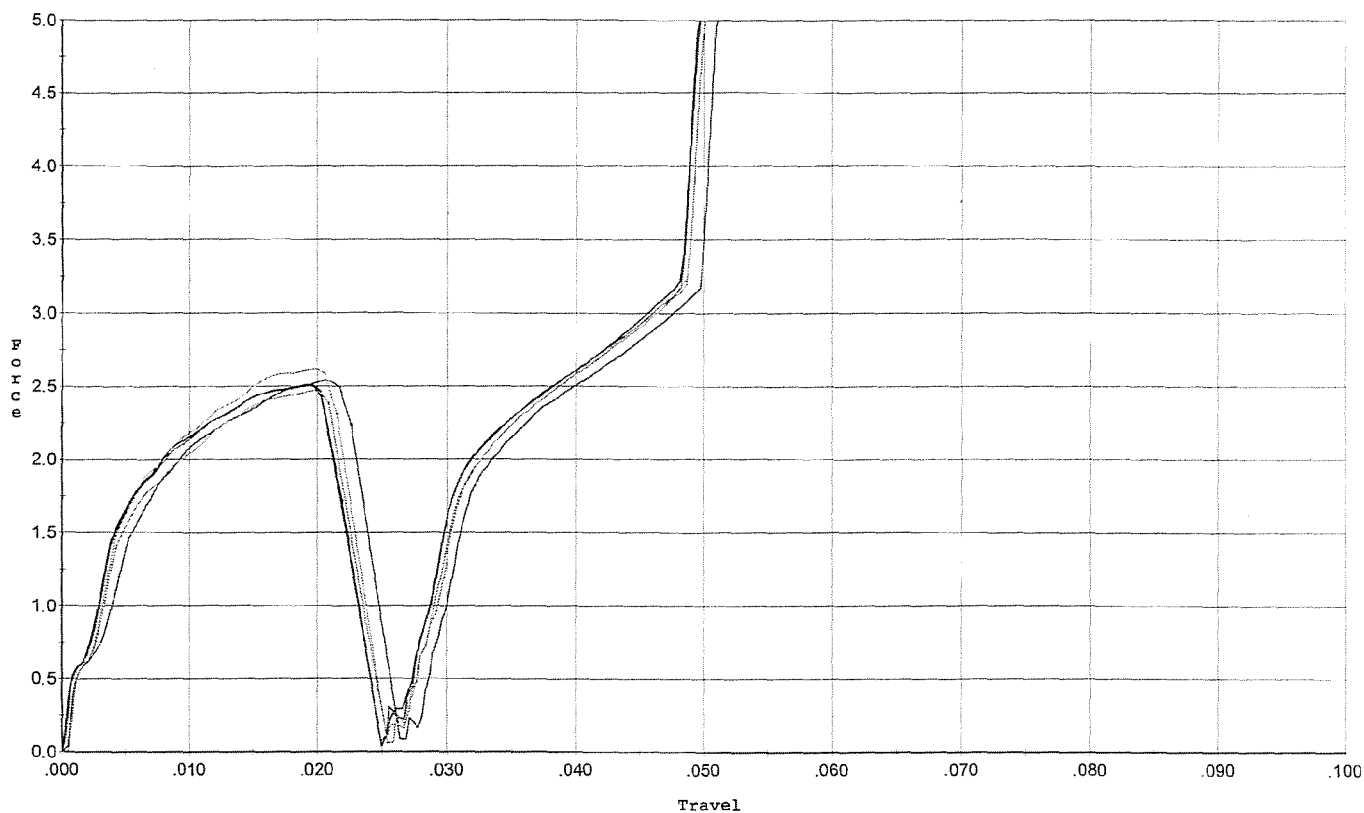
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.443	0.021	0.00	0.033	0.039		Single Action
2	2.572	0.022	0.00	0.033	0.043		Single Action
3	2.598	0.023	0.00	0.032	0.045		Single Action
4	2.504	0.020	0.00	0.033	0.039		Single Action
5	2.537	0.020	0.00	0.033	0.040		Single Action

A-2-53

Trigger Profile [lbs,inch]

Profile Profile1
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



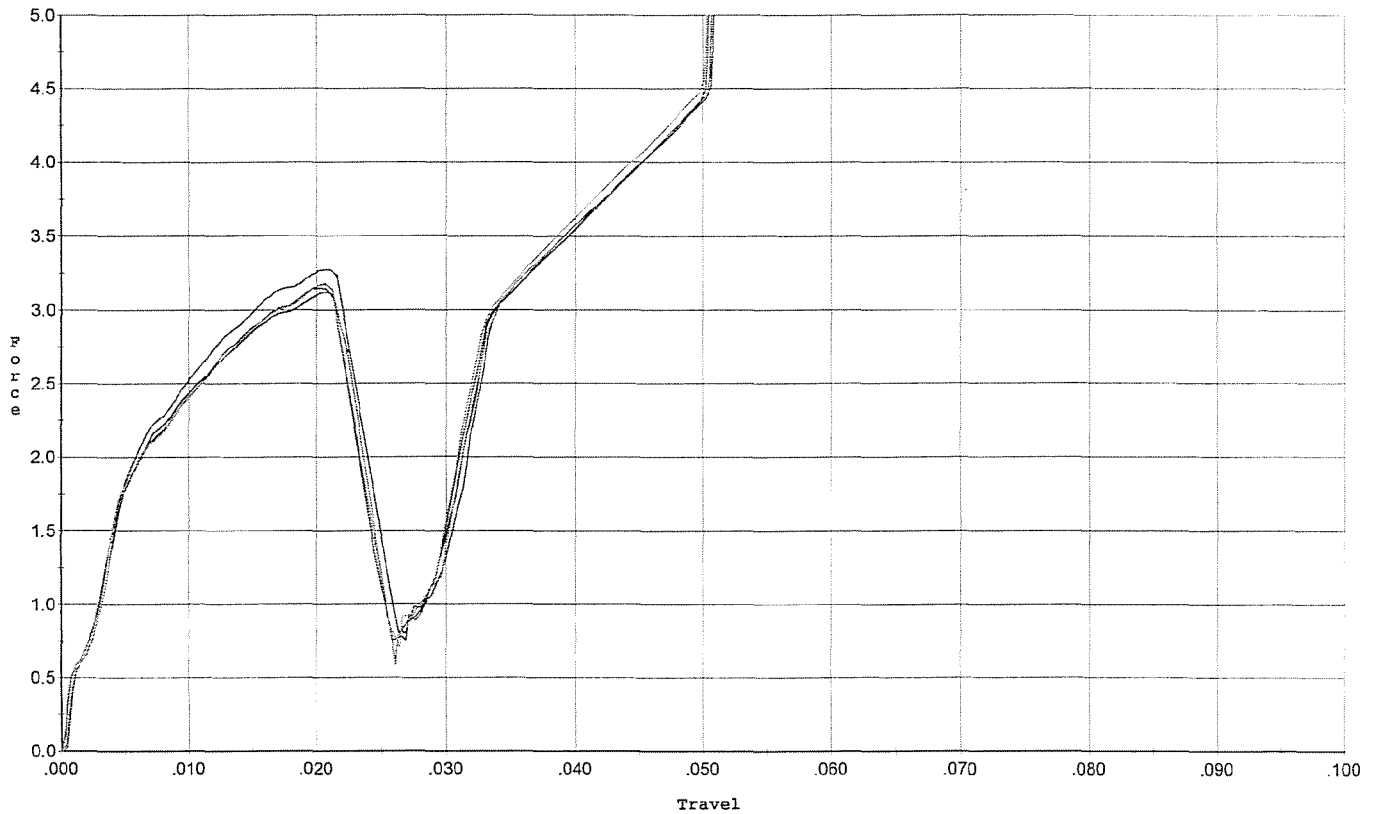
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.023	0.00	0.032	0.041		Single Action
2	2.512	0.022	0.00	0.032	0.040		Single Action
3	2.509	0.022	0.00	0.032	0.040		Single Action
4	2.618	0.021	0.00	0.032	0.040		Single Action
5	2.471	0.021	0.00	0.032	0.037		Single Action

A-2-53

Trigger Profile [lbs,inch]

Profile: Profile1
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



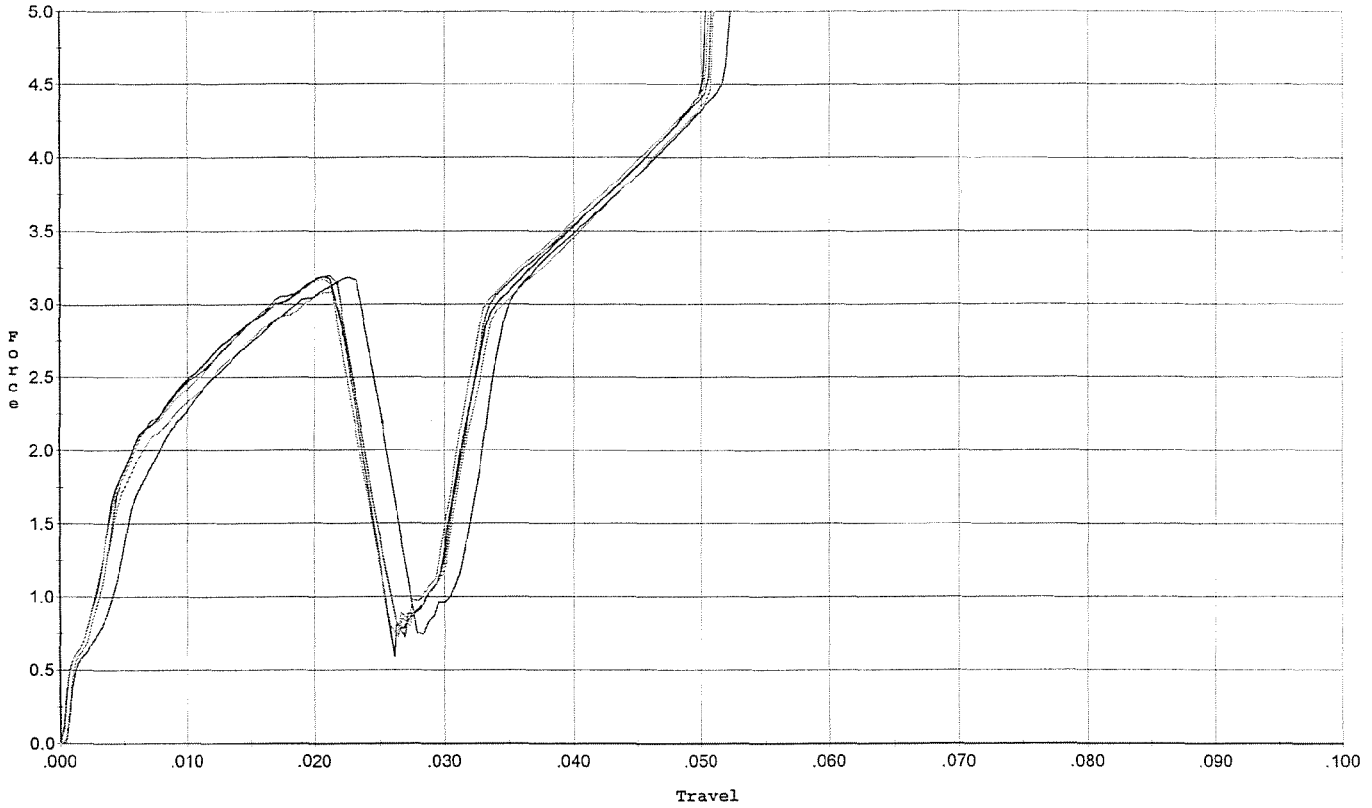
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.273	0.022	0.00	0.031	0.048		Single Action
2	3.121	0.022	0.00	0.031	0.048		Single Action
3	3.148	0.021	0.00	0.031	0.046		Single Action
4	3.171	0.022	0.00	0.031	0.048		Single Action
5	3.180	0.021	0.00	0.031	0.046		Single Action

A-3-17

Trigger Profile [lbs,inch]

Profile: Profile1
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



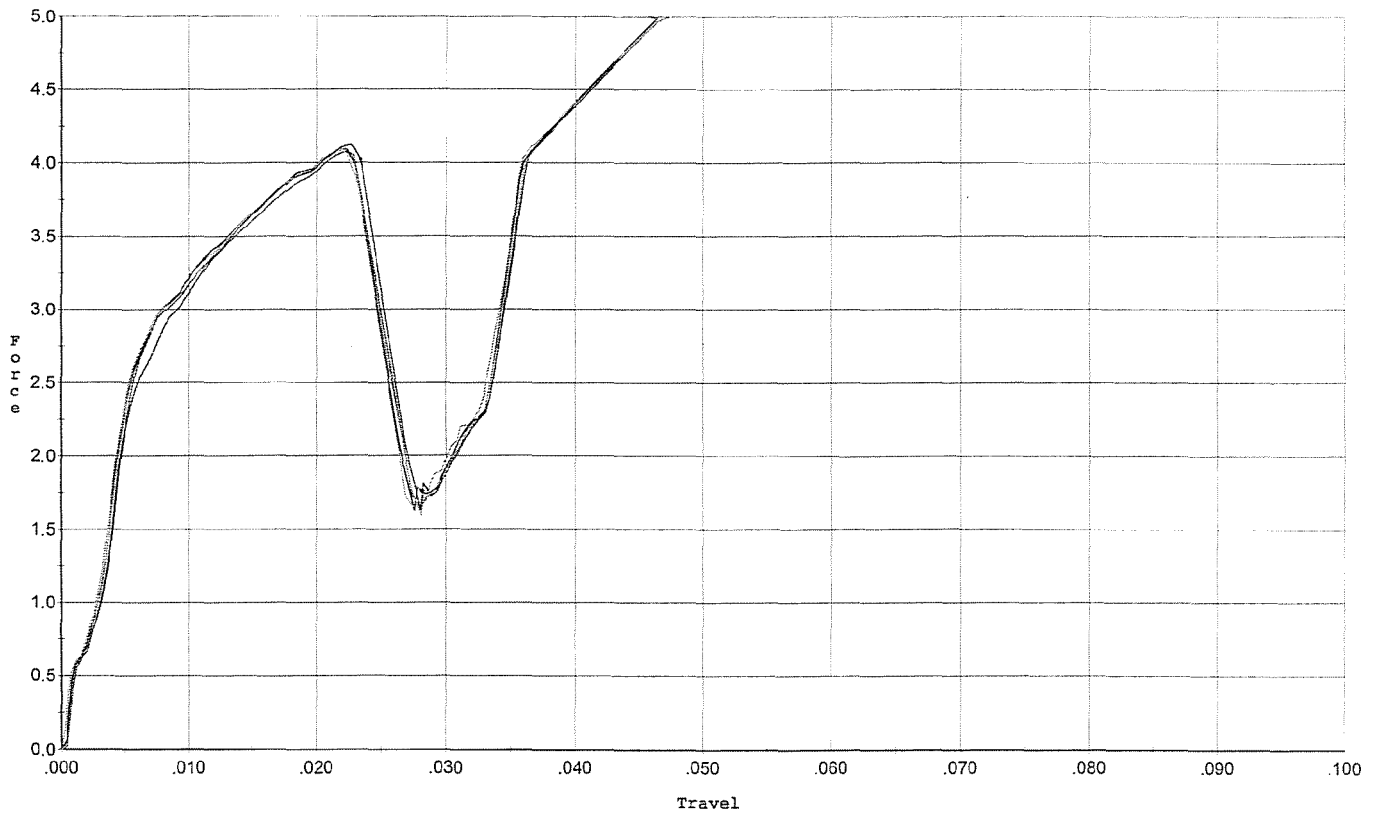
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.187	0.025	0.00	0.032	0.053		Single Action
2	3.193	0.022	0.00	0.031	0.049		Single Action
3	3.200	0.022	0.00	0.031	0.047		Single Action
4	3.083	0.022	0.00	0.031	0.046		Single Action
5	3.174	0.021	0.00	0.031	0.046		Single Action

A-3-16

Trigger Profile [lbs,inch]

Profile: Profile1
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



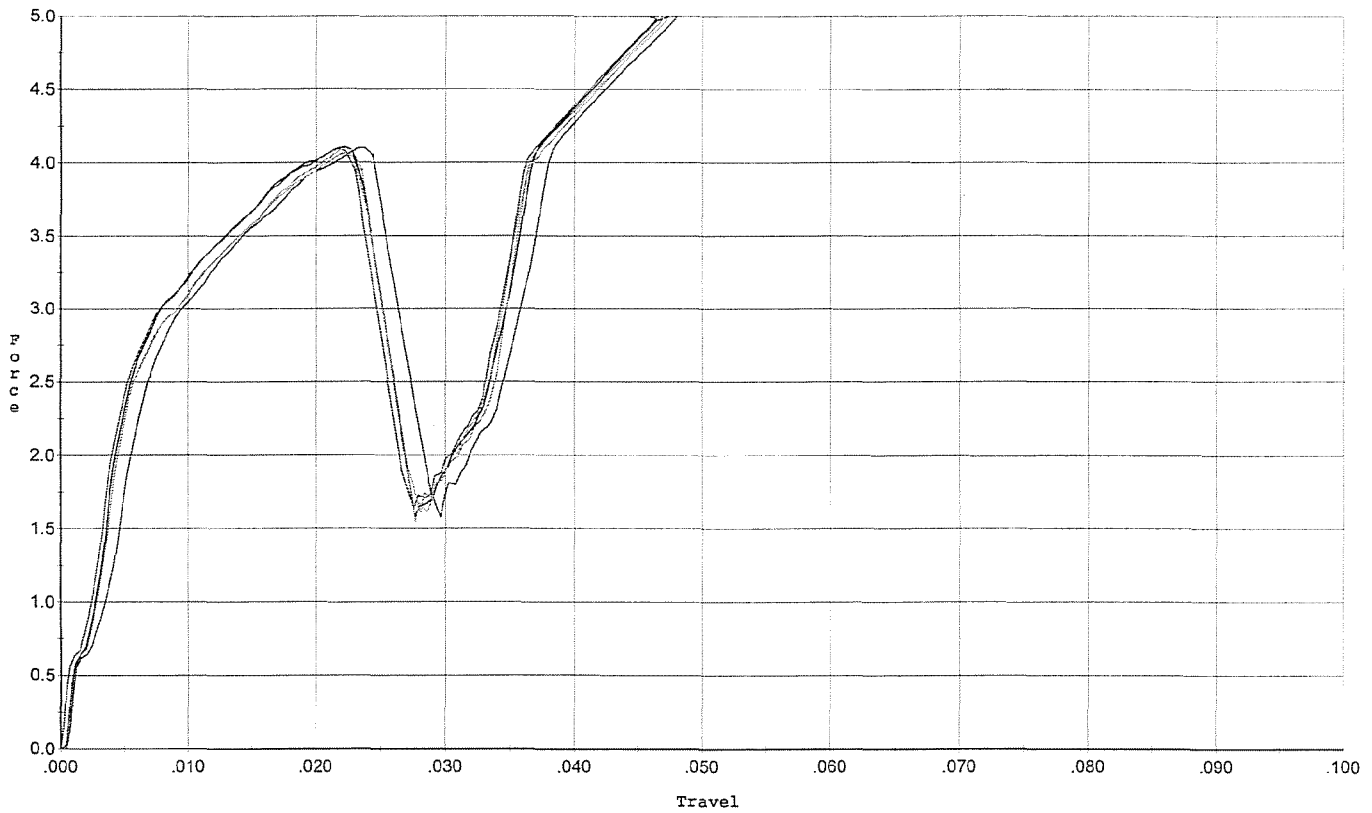
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.023	0.00	0.029	0.065		Single Action
2	4.093	0.023	0.00	0.029	0.064		Single Action
3	4.078	0.025	0.00	0.029	0.069		Single Action
4	4.080	0.023	0.00	0.029	0.065		Single Action
5	4.098	0.023	0.00	0.030	0.064		Single Action

A-4.09

Trigger Profile [lbs,inch]

Profile: Profile1
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



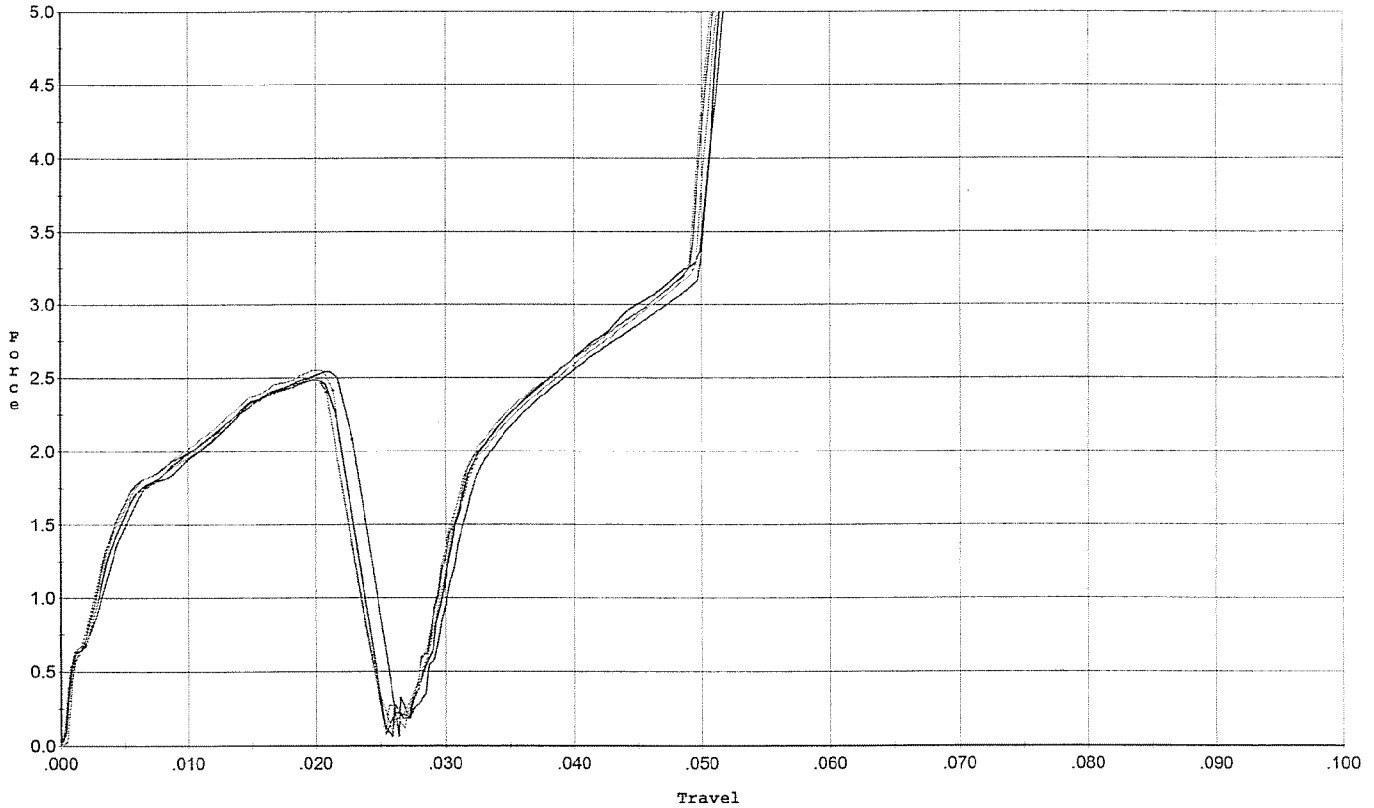
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.024	0.00	0.030	0.066		Single Action
2	4.107	0.024	0.00	0.030	0.067		Single Action
3	4.095	0.023	0.00	0.030	0.065		Single Action
4	4.099	0.023	0.00	0.030	0.065		Single Action
5	4.064	0.024	0.00	0.030	0.066		Single Action

A-4-09

Trigger Profile [lbs,inch]

Profile: Profile1
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



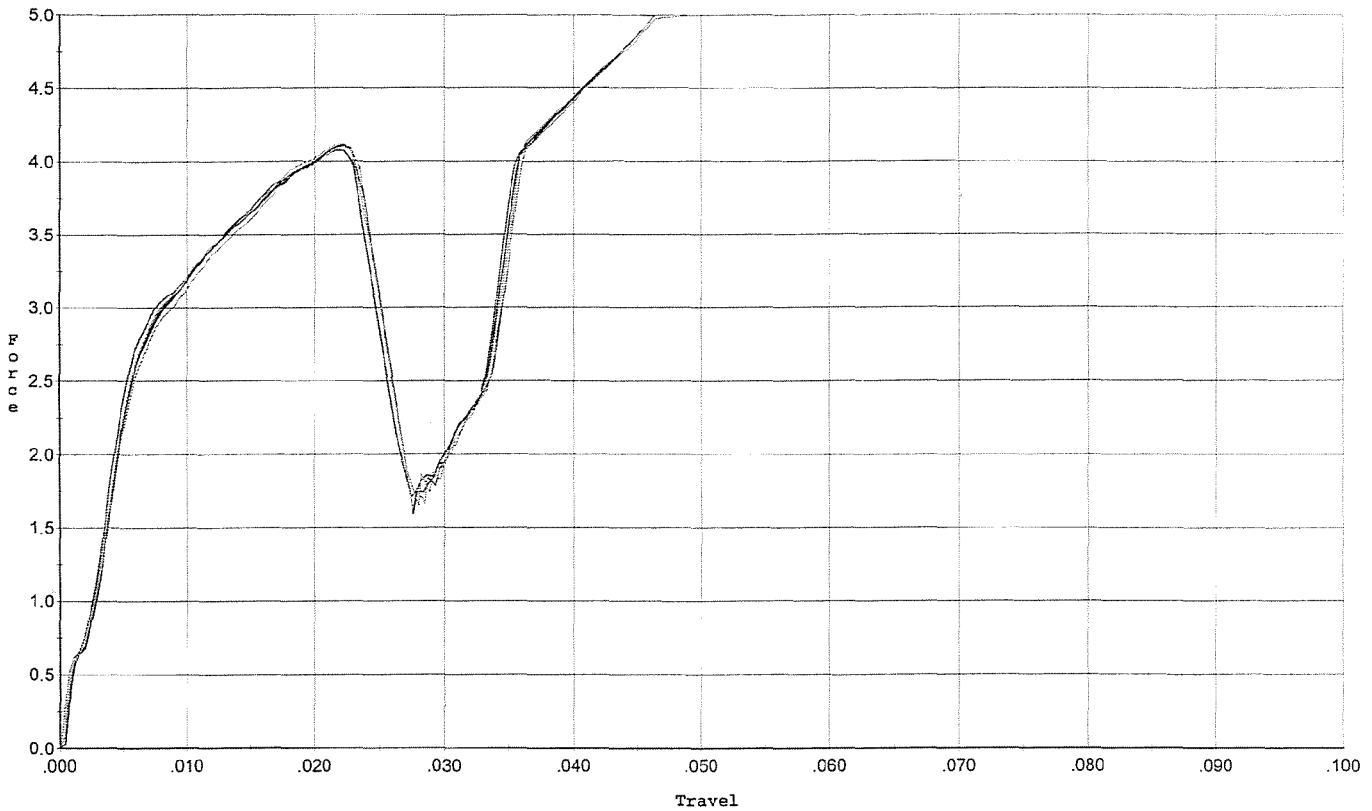
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.023	0.00	0.033	0.041		Single Action
2	2.483	0.022	0.00	0.033	0.038		Single Action
3	2.499	0.021	0.00	0.033	0.037		Single Action
4	2.553	0.021	0.00	0.033	0.039		Single Action
5	2.494	0.021	0.00	0.033	0.037		Single Action

A-2-51

Trigger Profile [lbs,inch]

Profile: Profile1
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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	4.080	0.023	0.00	0.029	0.065		Single Action
2	4.113	0.024	0.00	0.029	0.067		Single Action
3	4.103	0.024	0.00	0.029	0.067		Single Action
4	4.120	0.024	0.00	0.029	0.068		Single Action
5	4.104	0.023	0.00	0.029	0.065		Single Action

A-4.10