

G6852311

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



BM FORM

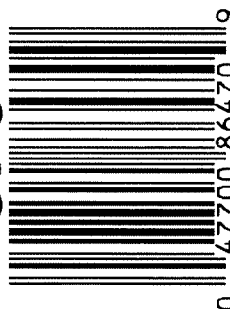
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6852311

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6852311

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-15-09	SPD
430	ASSEMBLE TO STOCK		4-15-09	RP
440	PROOF		4-15-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	4-15-09	SPD
470	DIS-ASSEMBLE ACTION		4-15-09	SPD
472	SERIALIZE BOLT HANDLE		4-16-09	LT
480	MAGNAFLUX BBL ACTION	OPERATOR (19)	4-18-09	(19)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/20/09	RT
510	DRILL AND TAP SIGHT HOLES		4-16-09	SP
520	GOFF BLAST BBL / REC		4/21/09	CJ
540	APPLY COATINGS (BARREL ACTION)		4-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-29-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-29-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-29-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-1-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

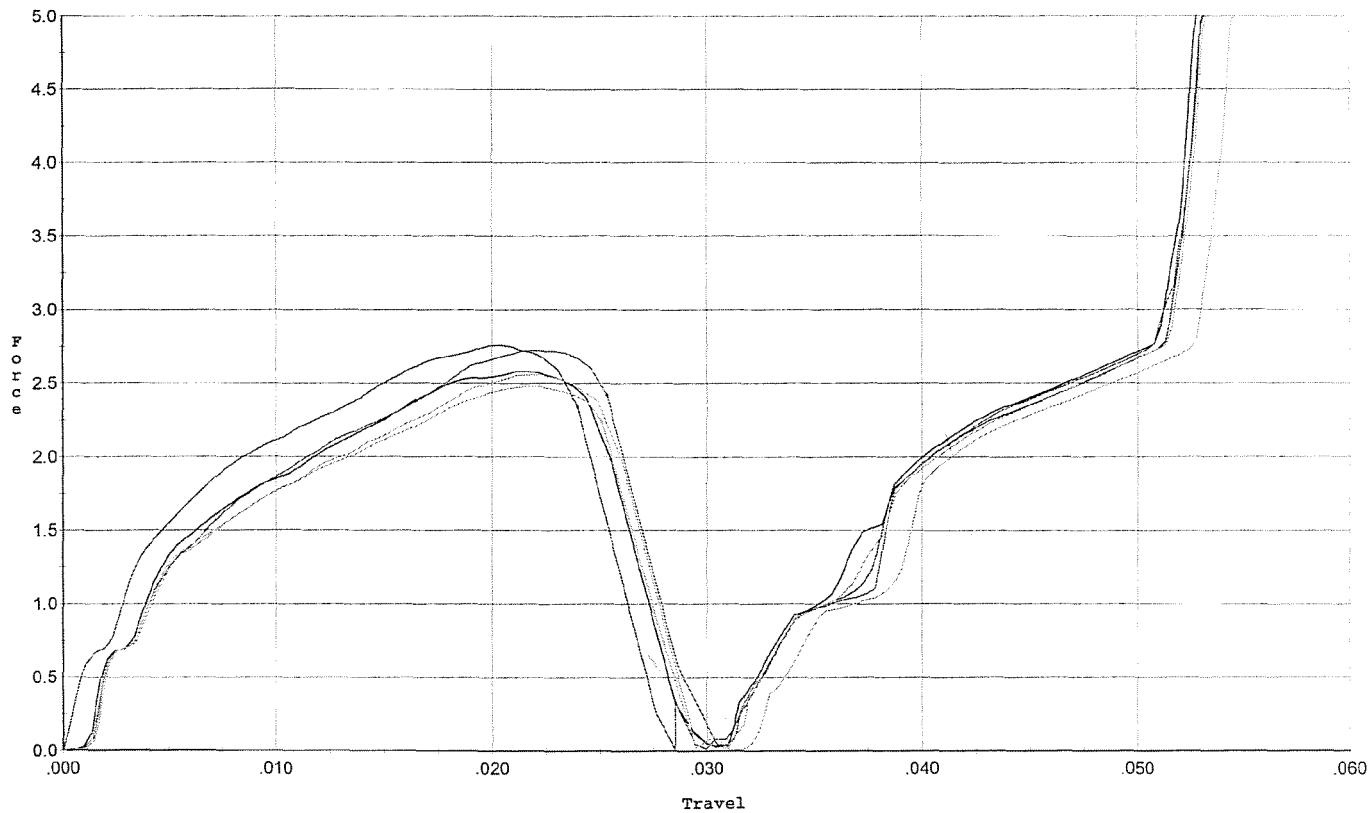
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-13-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	5-13-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	5-13-09	L.N.
	J) ASSEMBLE STOCK		5-1-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		5-13-09	L.N.
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	5-8-09	W/V
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-8-09	TGR
670	FINAL INSPECTION A) HEADSPACE		5-13-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>234</u> <u>228</u> <u>209</u> <u>202</u> <u>203</u>	5-8-09	RTZ
	C) FUNCTION		5-13-09	L.N.
690	PACK		4/18/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/8/2009

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



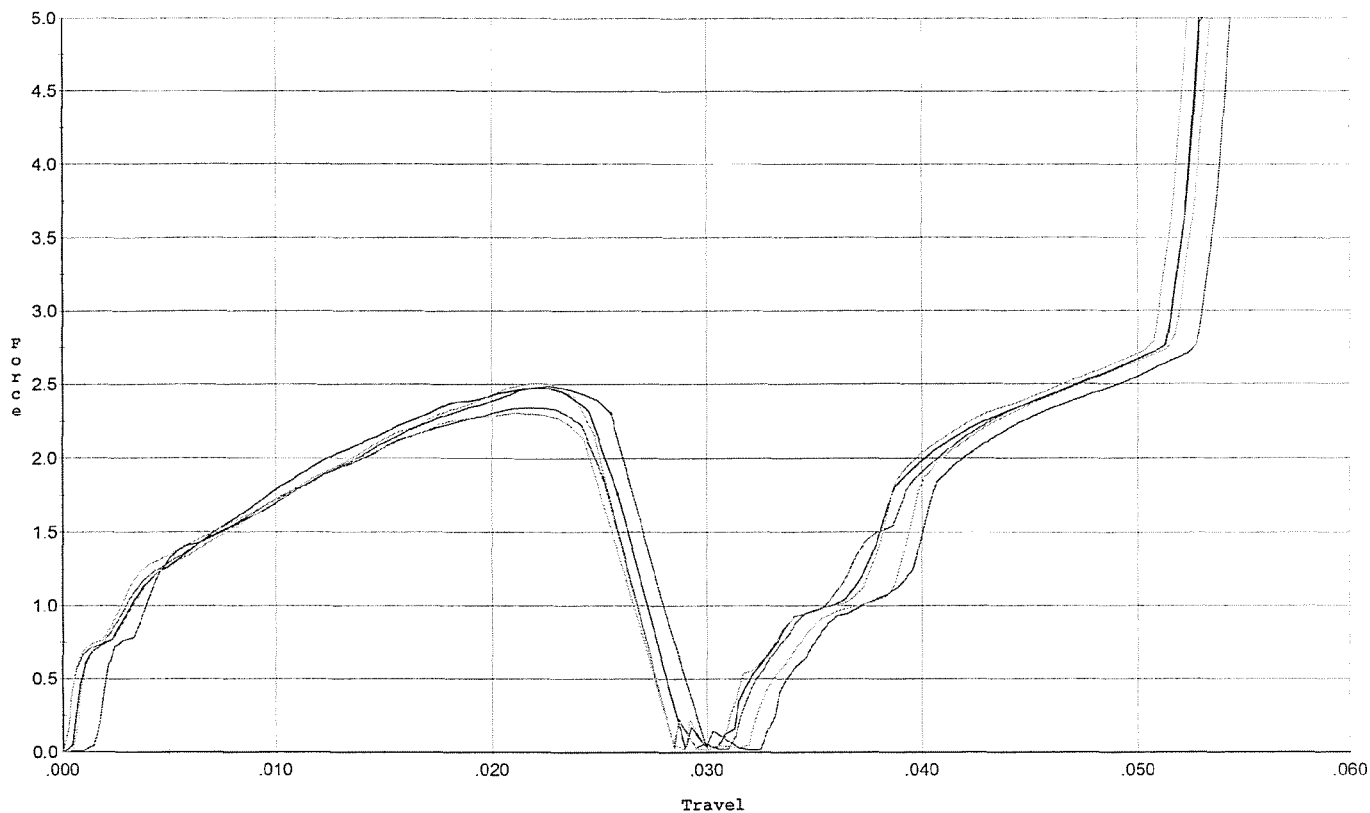
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.759	0.024	0.00	0.034	0.047		Set Trigger
2	2.582	0.025	0.00	0.033	0.045		Set Trigger
3	2.725	0.025	0.00	0.033	0.046		Set Trigger
4	2.483	0.025	0.00	0.035	0.042		Set Trigger
5	2.558	0.026	0.00	0.033	0.045		Set Trigger

7-2-67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/8/2009

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



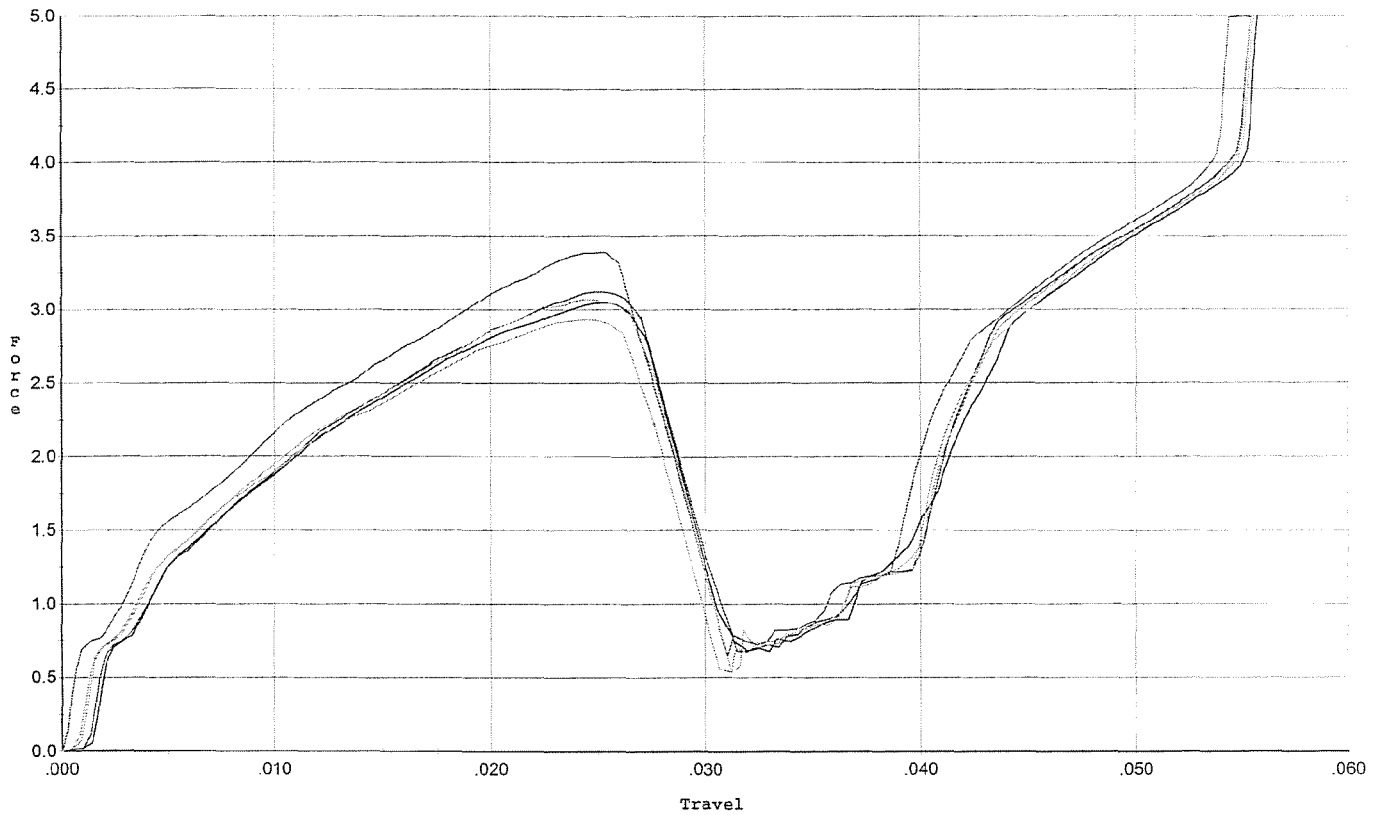
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.483	0.025	0.00	0.035	0.043		Set Trigger
2	2.472	0.026	0.00	0.033	0.045		Set Trigger
3	2.338	0.025	0.00	0.034	0.042		Set Trigger
4	2.505	0.025	0.00	0.034	0.043		Set Trigger
5	2.304	0.026	0.00	0.033	0.043		Set Trigger

A-2-42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/8/2009

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



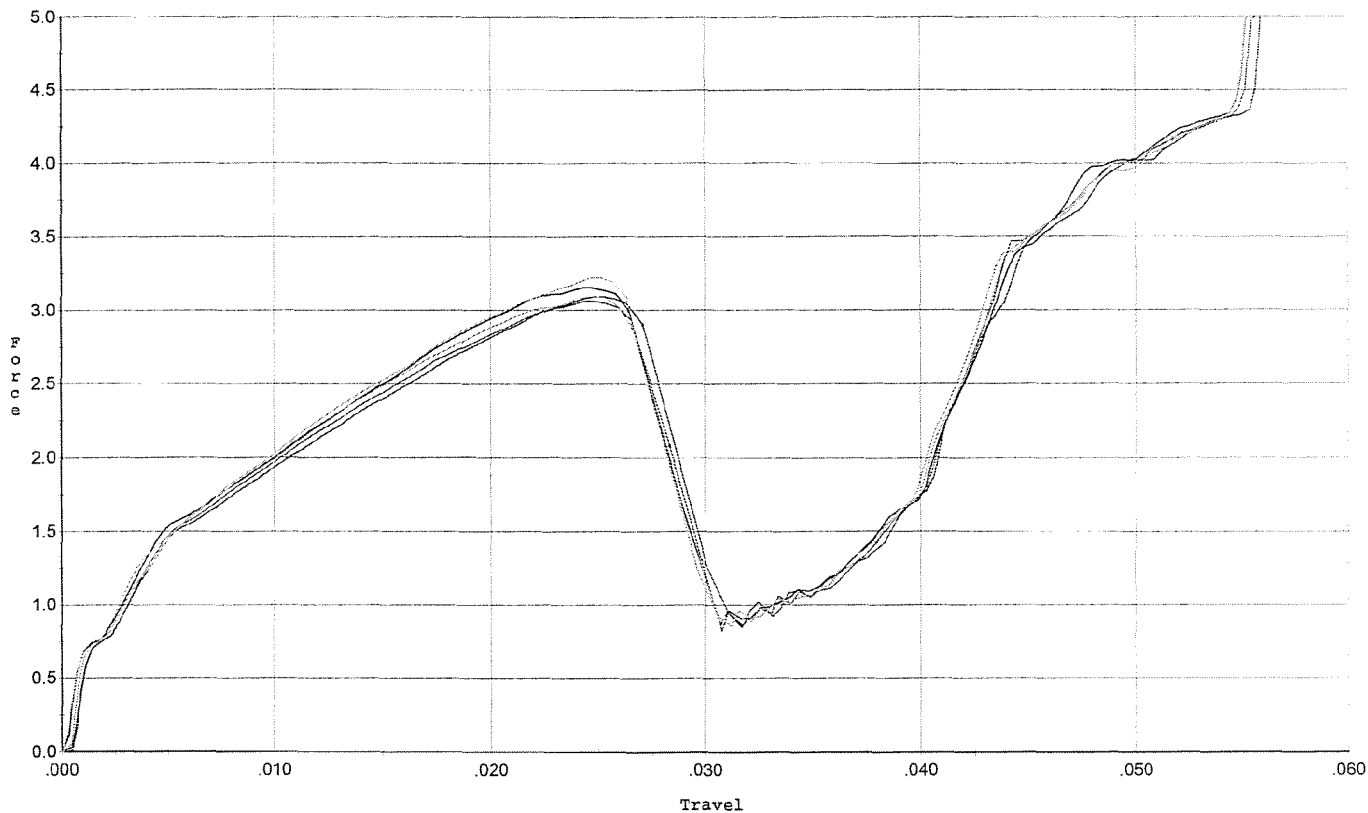
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.027	0.00	0.033	0.055		Set Trigger
2	3.049	0.027	0.00	0.033	0.054		Set Trigger
3	3.391	0.028	0.00	0.032	0.063		Set Trigger
4	3.069	0.028	0.00	0.033	0.056		Set Trigger
5	2.934	0.028	0.00	0.033	0.054		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/8/2009

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	3.092	0.027	0.00	0.033	0.056		Set Trigger
2	3.152	0.026	0.00	0.033	0.056		Set Trigger
3	3.062	0.028	0.00	0.033	0.058		Set Trigger
4	3.221	0.026	0.00	0.033	0.056		Set Trigger
5	3.095	0.027	0.00	0.033	0.056		Set Trigger

A-3-12

Trigger Scan 2.01 ,SN 10337, printed by Remington Arms Co., Inc.. 4/8/2009 11:05:11 AM

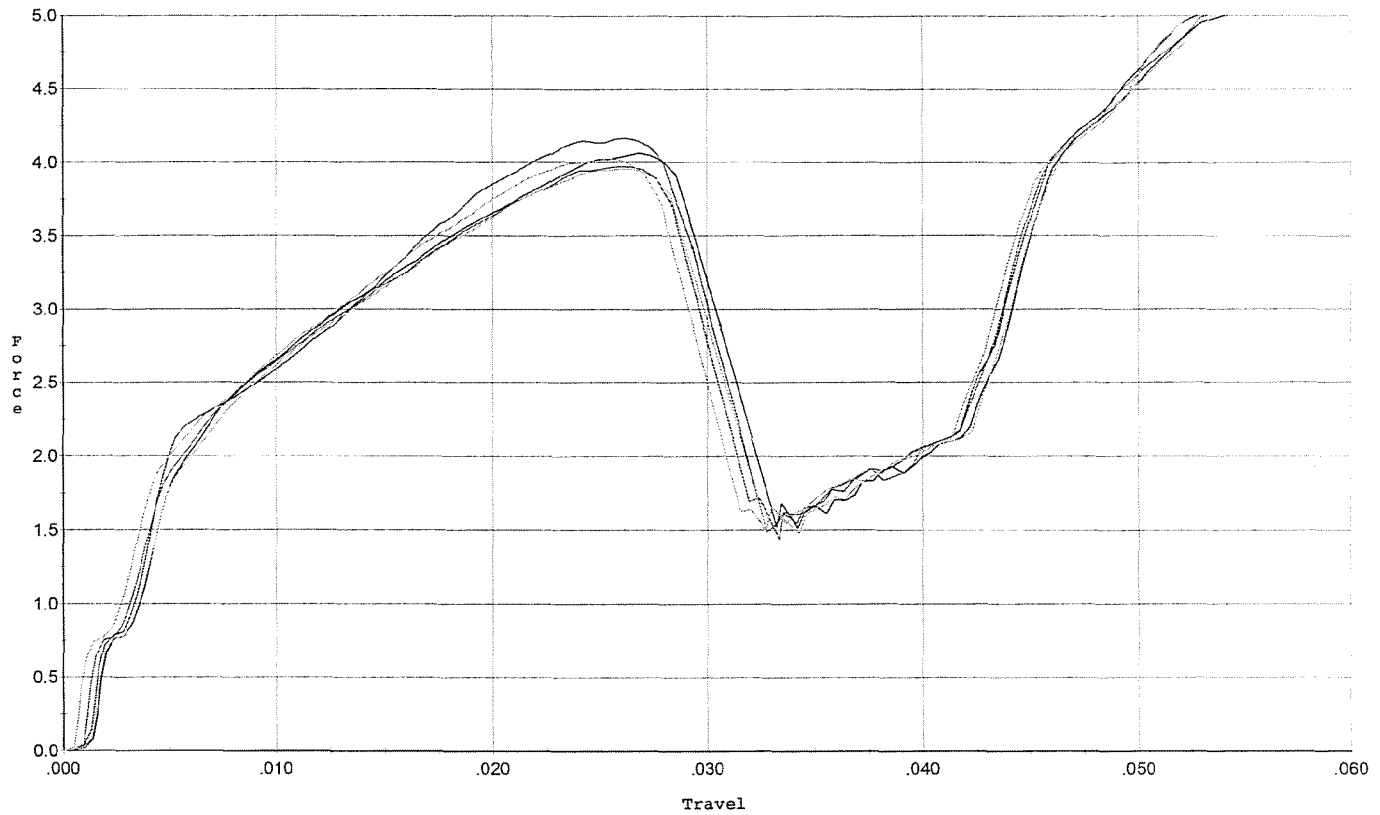
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400096585

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/8/2009

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



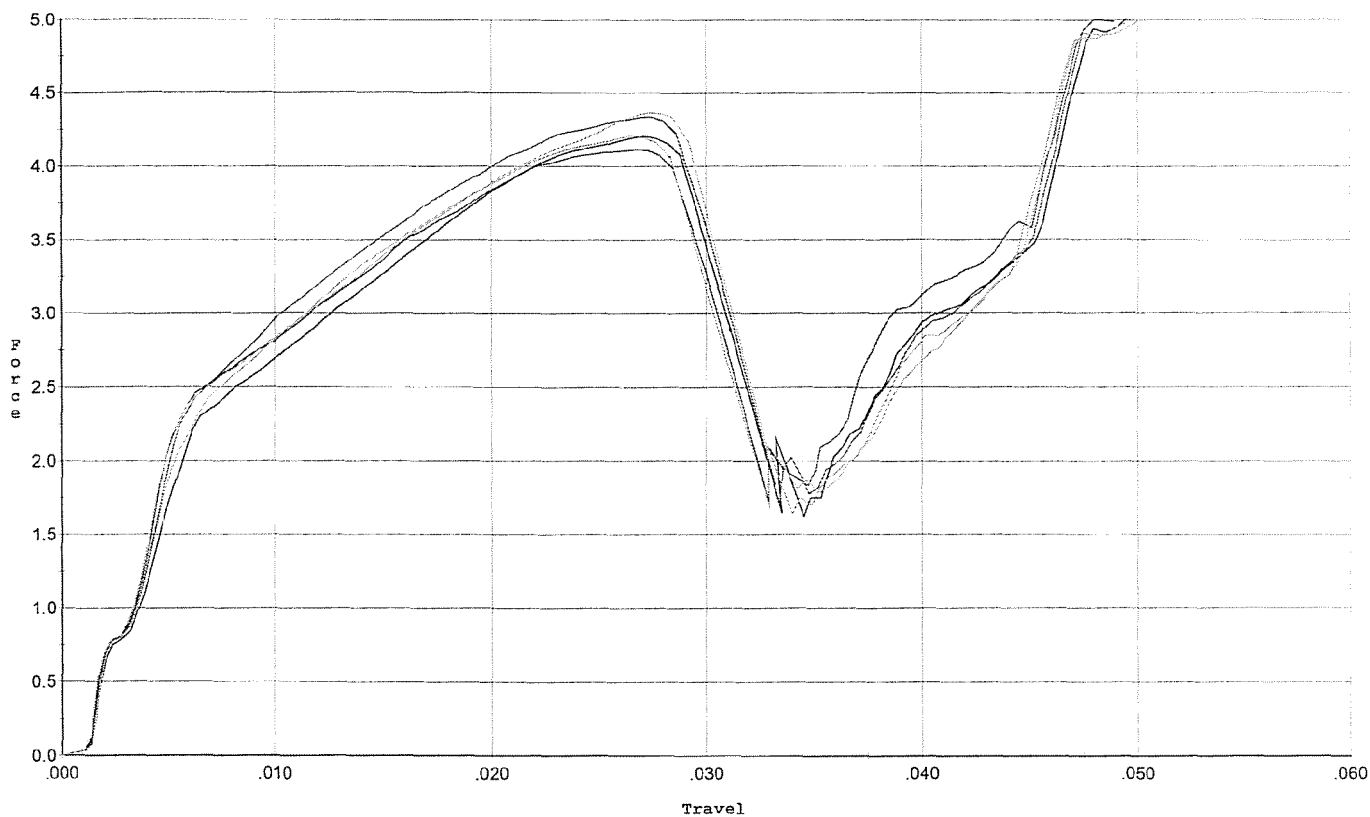
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.029	0.00	0.025	0.081		Set Trigger
2	4.063	0.031	0.00	0.025	0.083		Set Trigger
3	3.972	0.028	0.00	0.026	0.076		Set Trigger
4	3.955	0.030	0.00	0.026	0.080		Set Trigger
5	4.024	0.028	0.00	0.026	0.076		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/8/2009

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



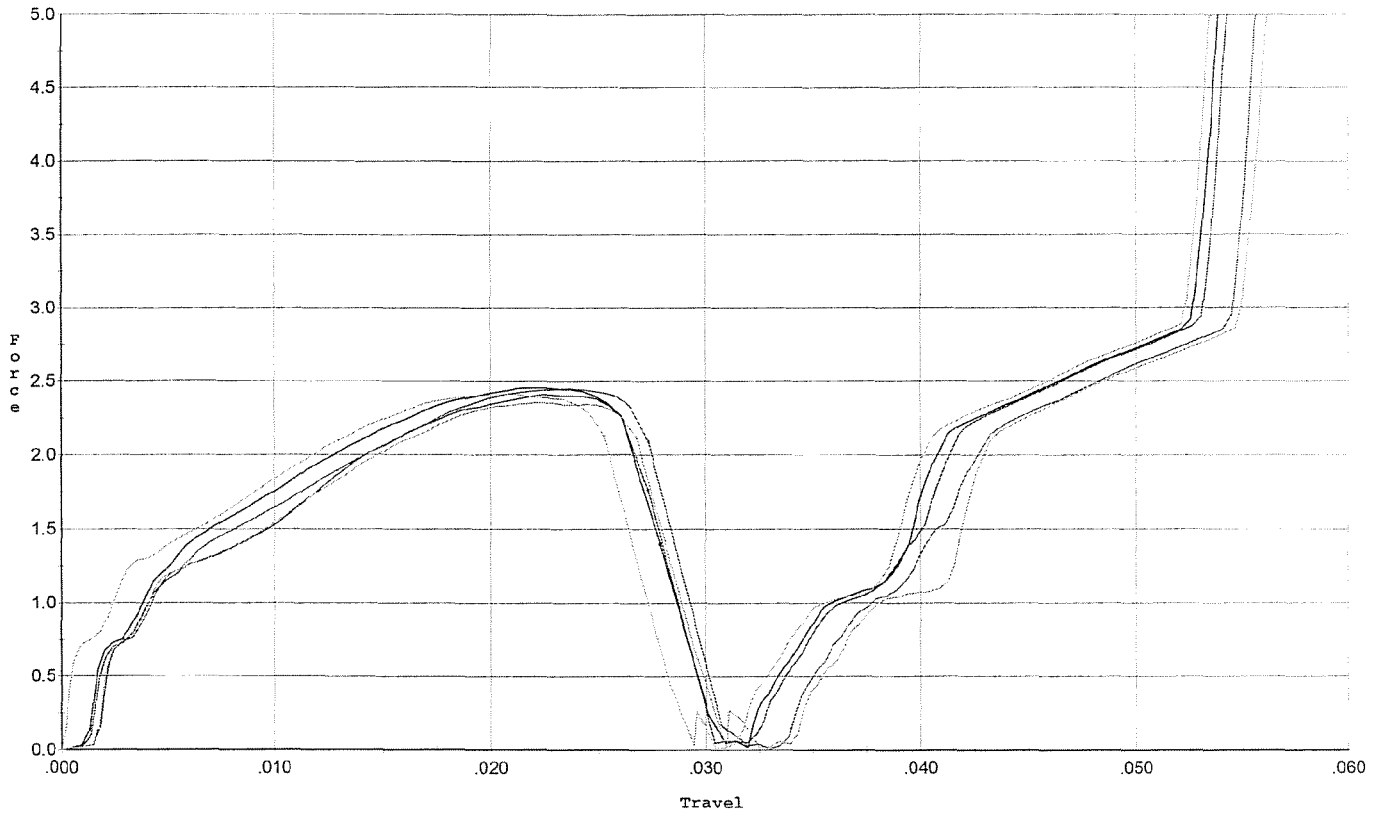
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.114	0.030	0.00	0.026	0.085		Set Trigger
2	4.204	0.031	0.00	0.026	0.087		Set Trigger
3	4.338	0.030	0.00	0.025	0.089		Set Trigger
4	4.366	0.029	0.00	0.025	0.084		Set Trigger
5	4.211	0.028	0.00	0.026	0.081		Set Trigger

A. 4.24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/8/2009

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	2.407	0.027	0.00	0.033	0.045		Set Trigger
2	2.454	0.028	0.00	0.033	0.048		Set Trigger
3	2.447	0.027	0.00	0.034	0.046		Set Trigger
4	2.413	0.025	0.00	0.034	0.045		Set Trigger
5	2.354	0.027	0.00	0.035	0.044		Set Trigger

A-2.41