

G6852333

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



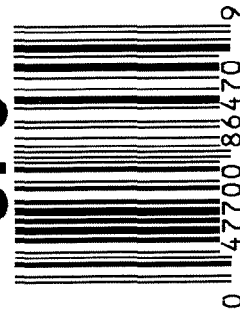
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6852333

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6852333

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		4-15-09	RP
470	DIS-ASSEMBLE ACTION		4-15-09	RP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	4-16-09	RT
475	DRILL AND TAP SIGHT HOLES	DATE: 4/16/09	4-16-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR: (Signature)	4-18-09	(Signature)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/20/09	RT
520	GOFF BLAST BBL / REC		4/31/09	L.M.
542	APPLY COATINGS (BARREL ACTION)		4/21	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-22-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-22-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-22-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

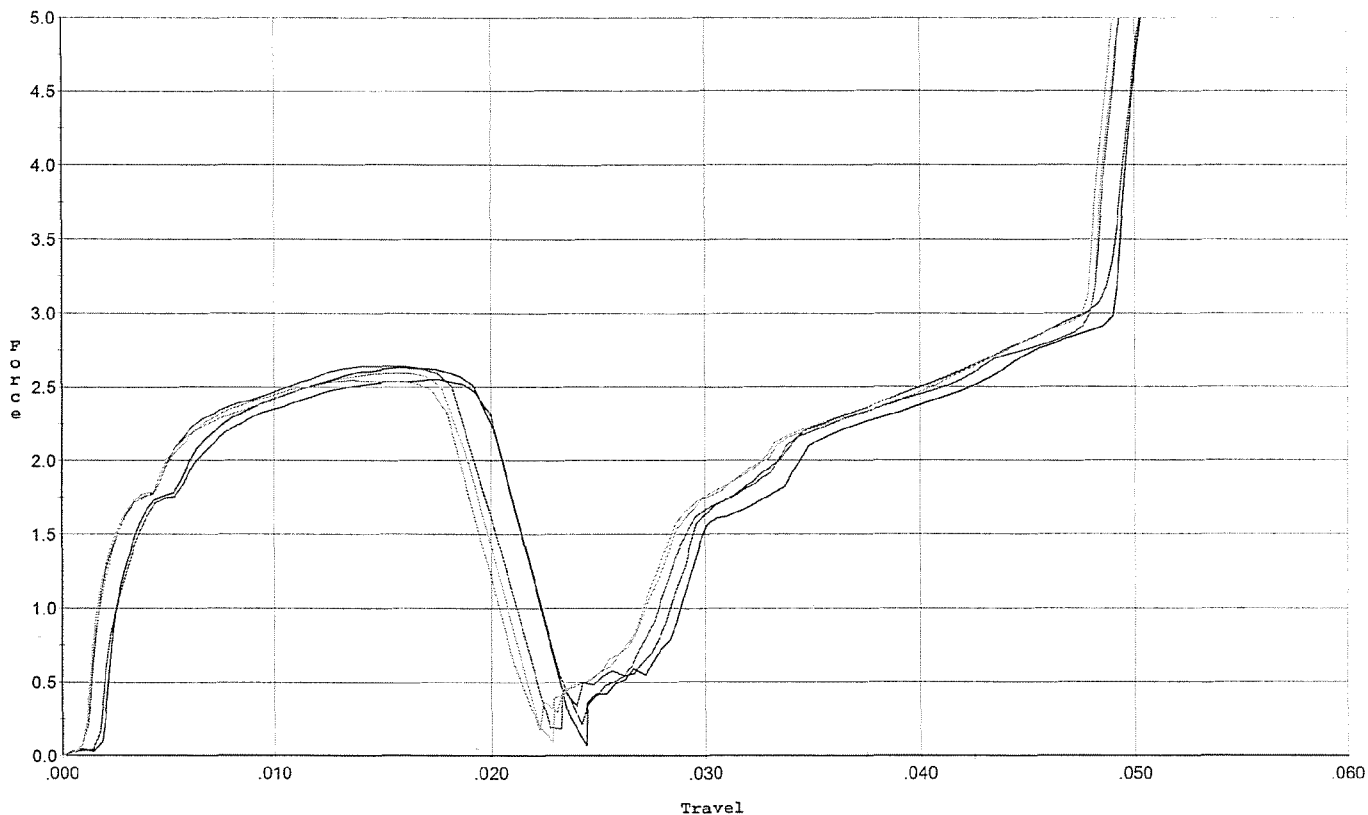
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-7-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>50</u>	5-7-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-7-09	LN
	J) ASSEMBLE STOCK		4-27-09	LN
	K) ASSEMBLE SWIVEL STUDS		5-7-09	LN
	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	4-27-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-27-09	SR
670	FINAL INSPECTION A) HEADSPACE		5-7-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.54</u> <u>2.60</u> <u>2.53</u> <u>2.56</u>	4-28-09	WV
	C) FUNCTION		5-7-09	LN
690	PACK		5/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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



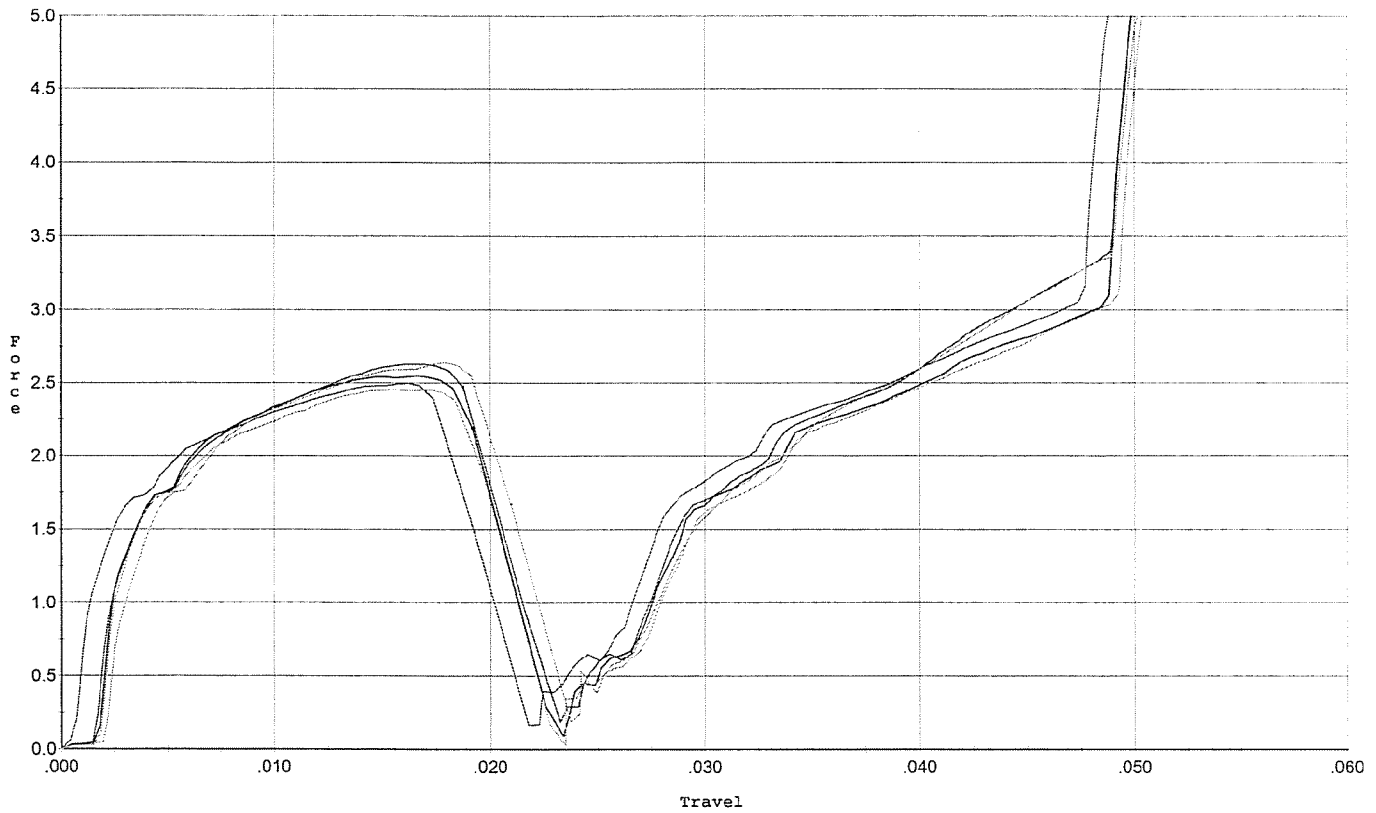
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.551	0.020	0.00	0.033	0.038		Set Trigger
2	2.634	0.020	0.00	0.034	0.039		Set Trigger
3	2.642	0.020	0.00	0.034	0.040		Set Trigger
4	2.593	0.019	0.00	0.034	0.037		Set Trigger
5	2.545	0.018	0.00	0.035	0.035		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



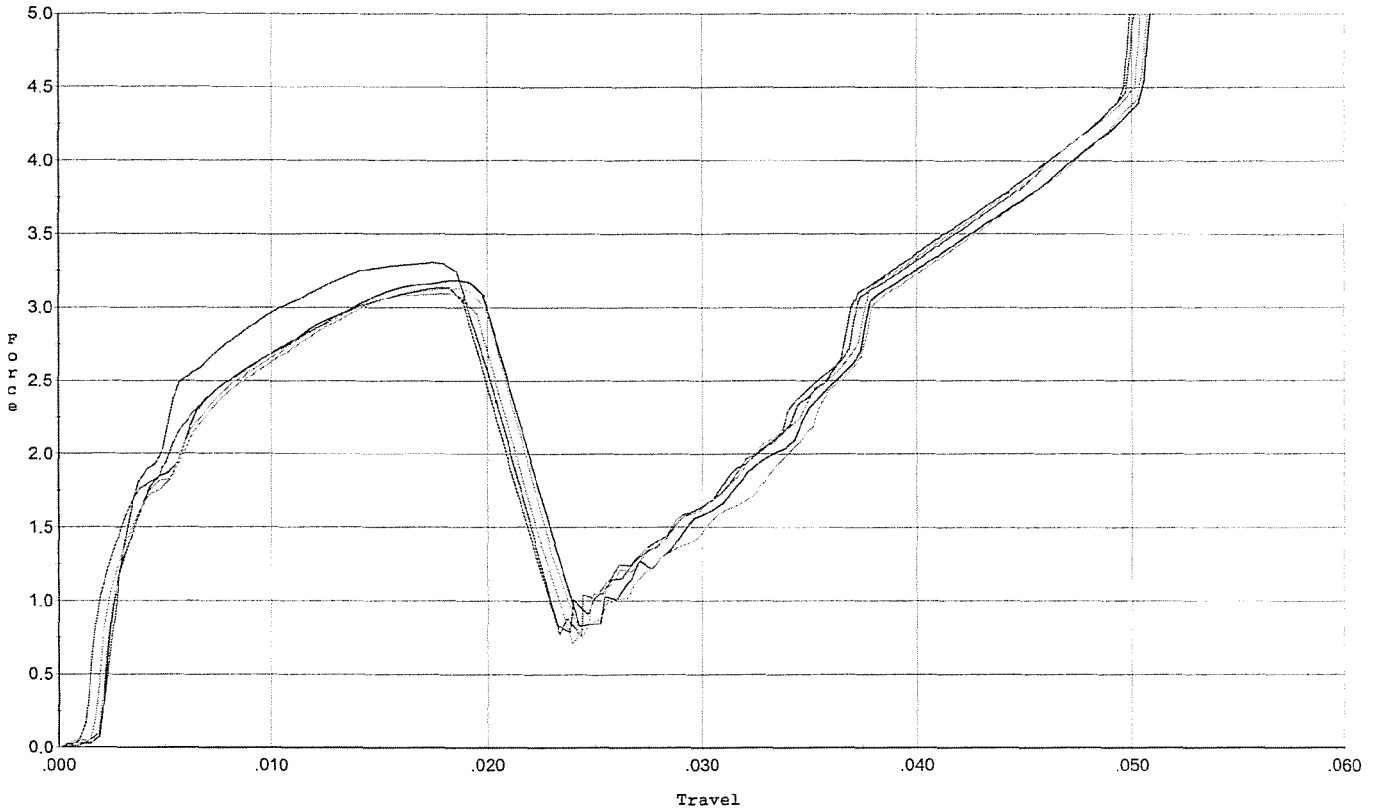
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.629	0.019	0.00	0.034	0.035		Set Trigger
2	2.550	0.019	0.002	0.034	0.036		Set Trigger
3	2.498	0.019	0.00	0.034	0.036		Set Trigger
4	2.452	0.020	0.002	0.035	0.035		Set Trigger
5	2.640	0.021	0.00	0.033	0.038		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



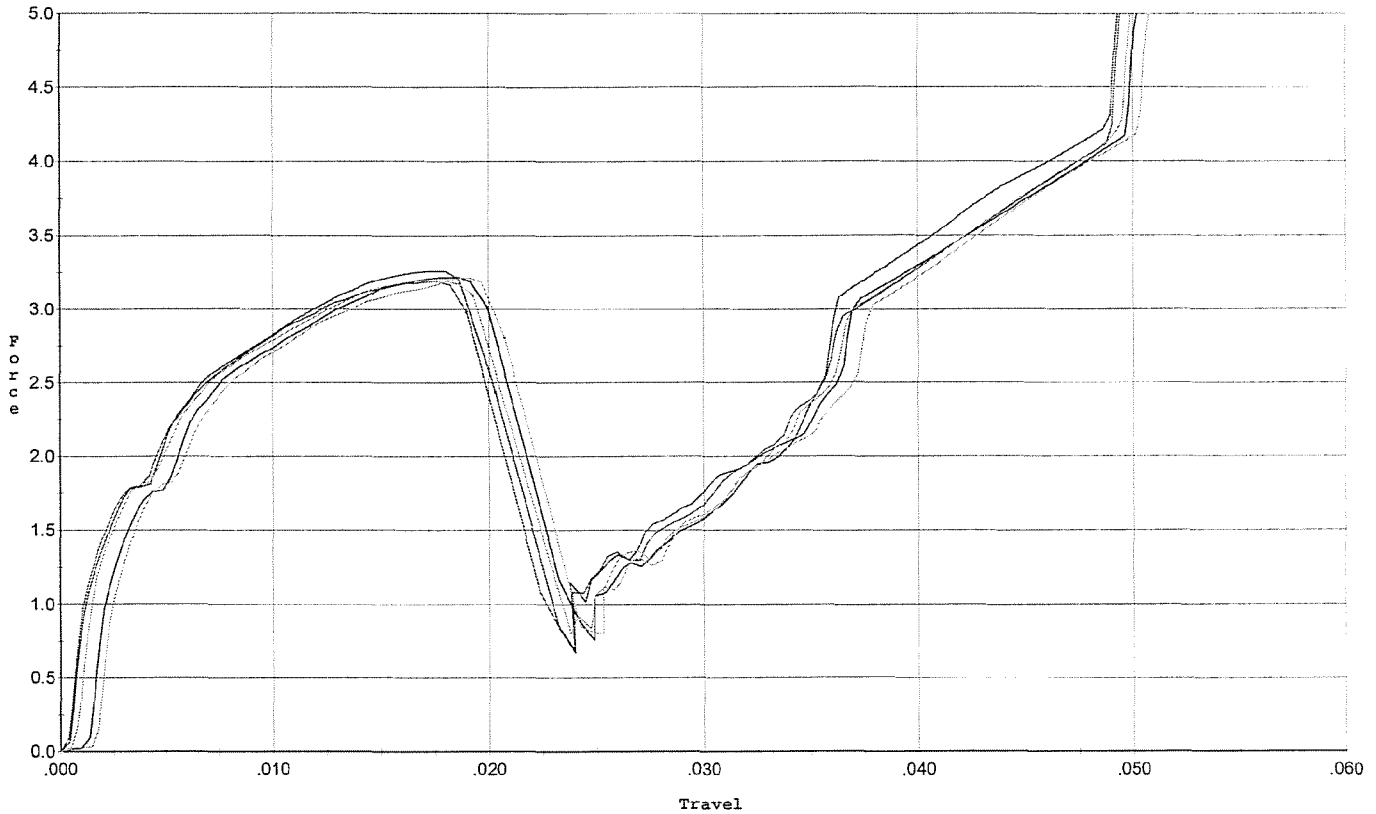
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.307	0.020	0.00	0.033	0.047		Set Trigger
2	3.185	0.020	0.002	0.033	0.043		Set Trigger
3	3.133	0.019	0.00	0.033	0.041		Set Trigger
4	3.129	0.020	0.002	0.033	0.043		Set Trigger
5	3.093	0.019	0.00	0.033	0.042		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



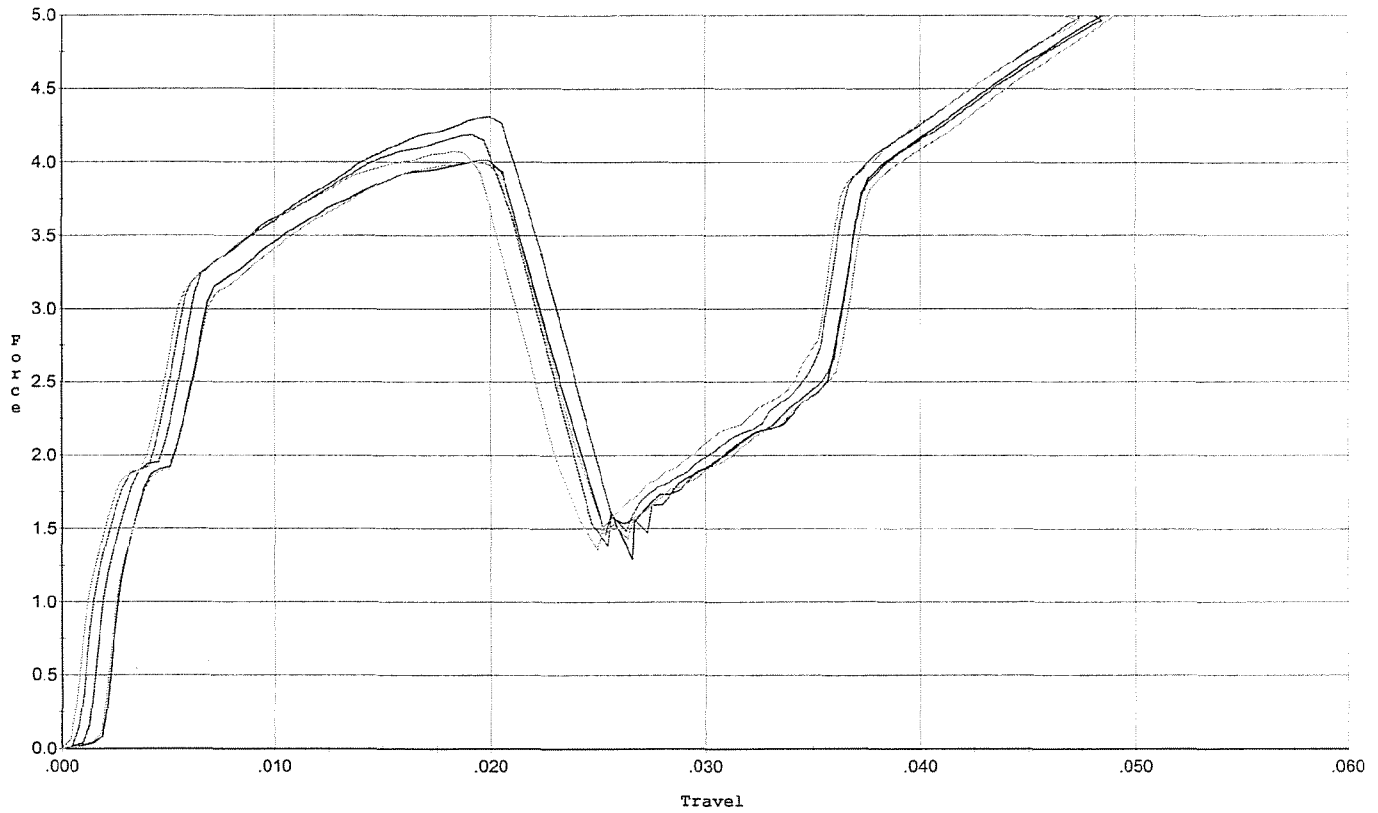
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.260	0.020	0.00	0.032	0.048		Set Trigger
2	3.217	0.020	0.00	0.033	0.045		Set Trigger
3	3.187	0.019	0.00	0.033	0.044		Set Trigger
4	3.214	0.021	0.00	0.033	0.046		Set Trigger
5	3.193	0.019	0.00	0.033	0.045		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



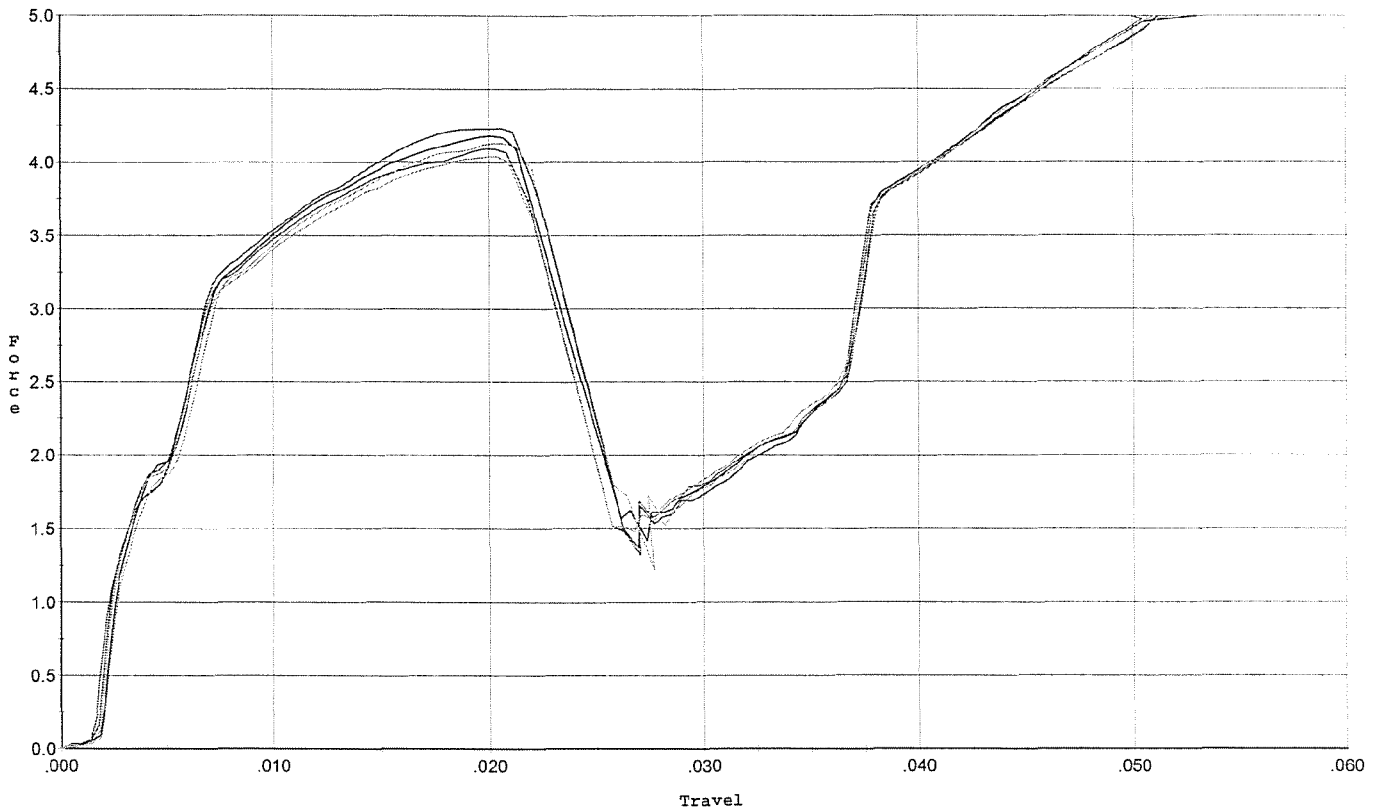
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.312	0.022	0.00	0.029	0.066		Set Trigger
2	4.013	0.021	0.00	0.031	0.056		Set Trigger
3	4.191	0.021	0.00	0.030	0.062		Set Trigger
4	4.078	0.020	0.00	0.030	0.057		Set Trigger
5	3.999	0.021	0.00	0.031	0.056		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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



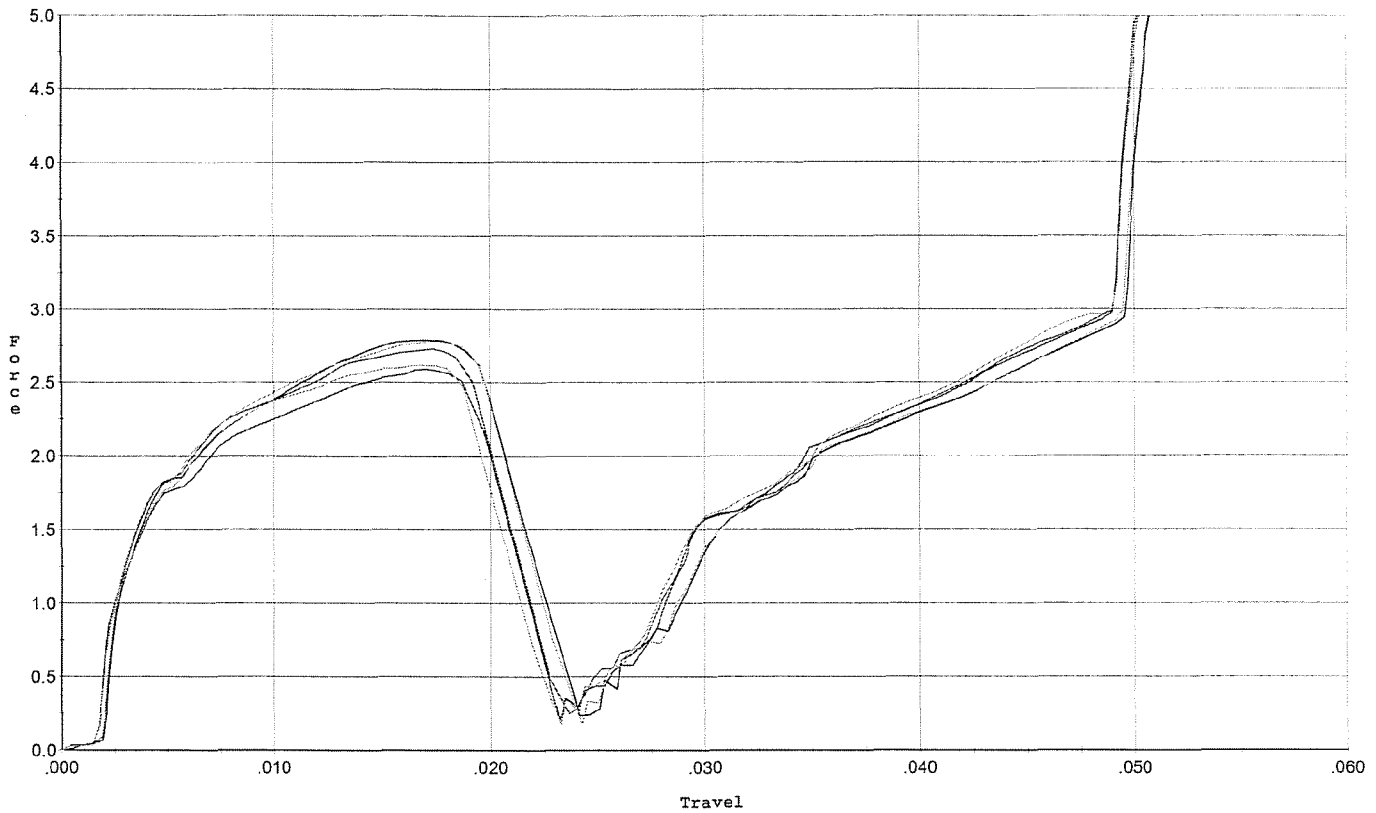
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.022	0.00	0.030	0.064		Set Trigger
2	4.181	0.021	0.00	0.031	0.060		Set Trigger
3	4.095	0.022	0.00	0.030	0.061		Set Trigger
4	4.129	0.022	0.00	0.030	0.061		Set Trigger
5	4.041	0.022	0.00	0.030	0.061		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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



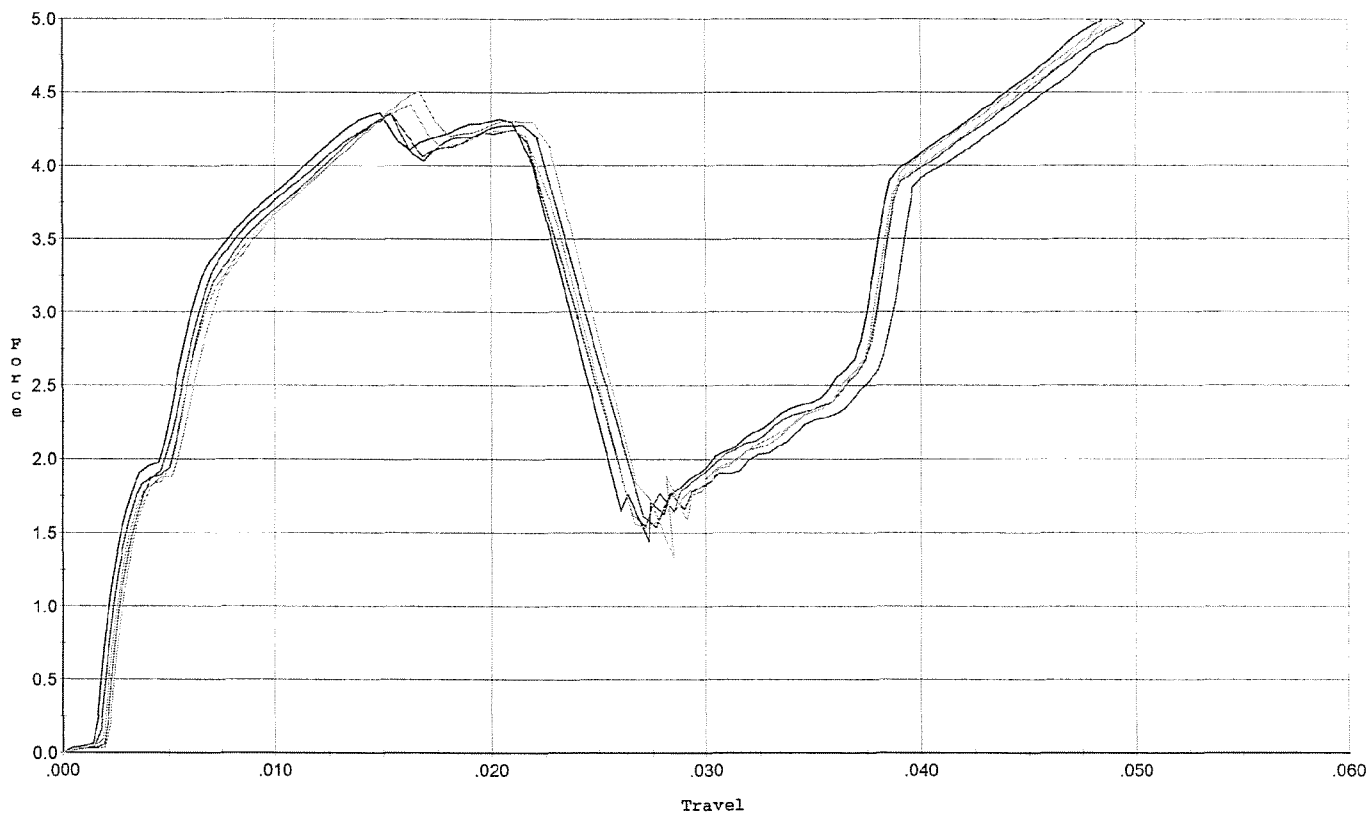
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.590	0.020	0.00	0.034	0.036		Set Trigger
2	2.787	0.020	0.00	0.034	0.038		Set Trigger
3	2.726	0.019	0.002	0.034	0.037		Set Trigger
4	2.777	0.020	0.00	0.034	0.039		Set Trigger
5	2.619	0.019	0.00	0.035	0.035		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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	4.343	0.022	0.00	0.031	0.066		Set Trigger
2	4.361	0.022	0.00	0.030	0.066		Set Trigger
3	4.356	0.024	0.00	0.030	0.070		Set Trigger
4	4.414	0.023	0.00	0.030	0.068		Set Trigger
5	4.508	0.023	0.00	0.030	0.068		Set Trigger

A-439