

66858448

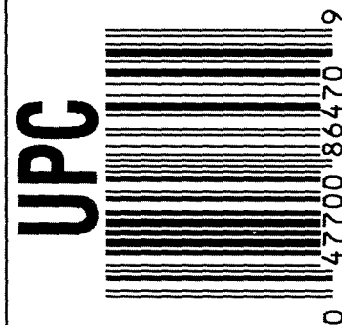
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6858448



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6858448

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5/27/09	SP
430	ASSEMBLE TO STOCK		5-27-09	SP
440	PROOF		5/27/09	SP
460	CHECK HEADSPACE	MAGNA FLUX	5/27/09	RP
470	DIS-ASSEMBLE ACTION		5/27/09	RP
472	SERIALIZE BOLT HANDLE		5-28-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (N)	5/30/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/1/09	RT
510	DRILL AND TAP SIGHT HOLES		5-28-09	SP
520	GOFF BLAST BBL / REC		6-1-09	RDW
540	APPLY COATINGS (BARREL ACTION)		6/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		7-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

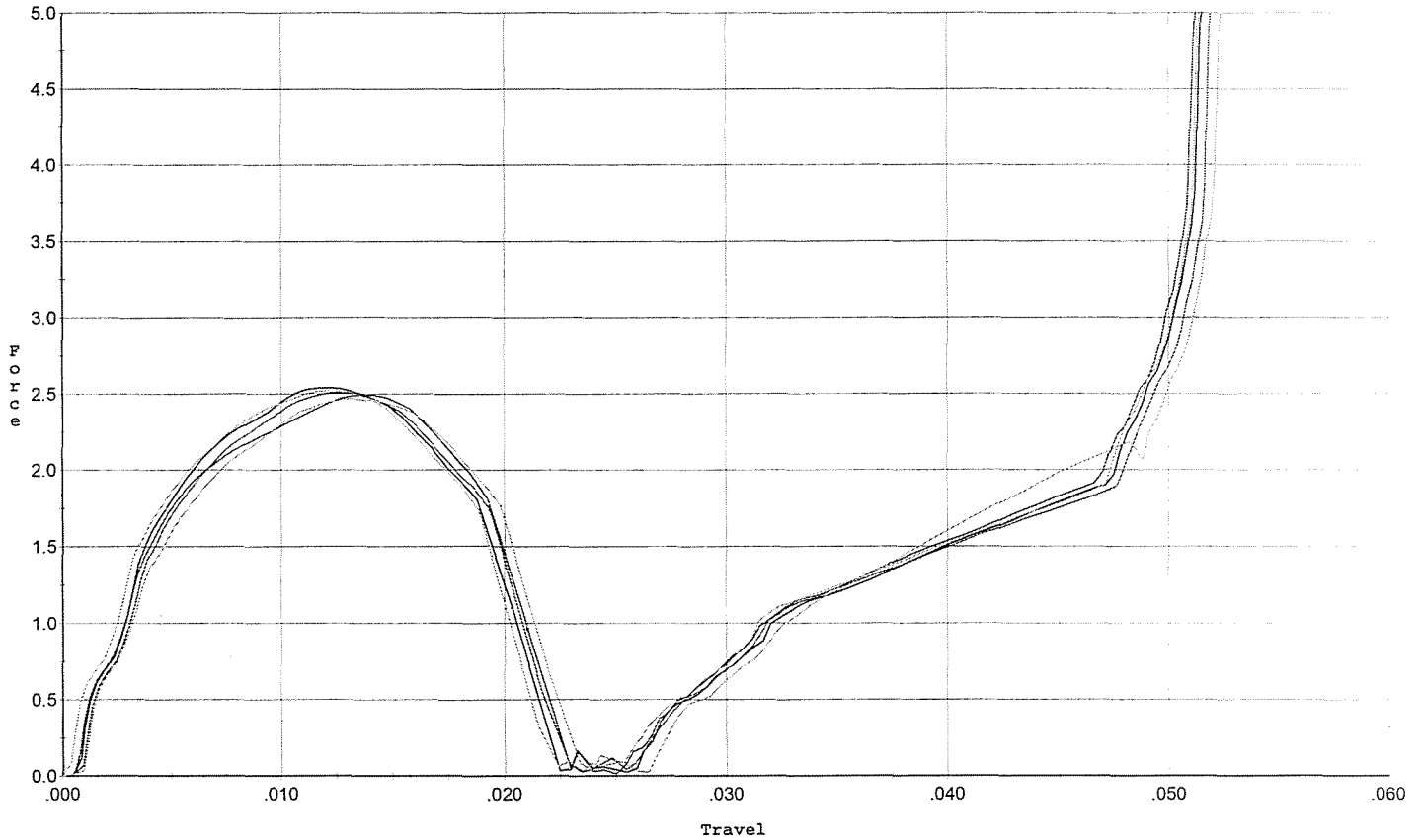
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	8-5-09	LN
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6°</u> <u>6°</u> <u>6°</u>	8-5-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-5-09	LN
	J) ASSEMBLE STOCK			7-13-09	RP
	K) ASSEMBLE SWIVEL STUDS			8-5-09	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	7-31-09	RP
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			7/31/09	RP
670	FINAL INSPECTION A) HEADSPACE			8-5-09	LN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>245</u> <u>255</u> <u>258</u> <u>251</u> <u>248</u>	8-5-09	LN
	C) FUNCTION			8-5-09	LN
690	PACK			8/14/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



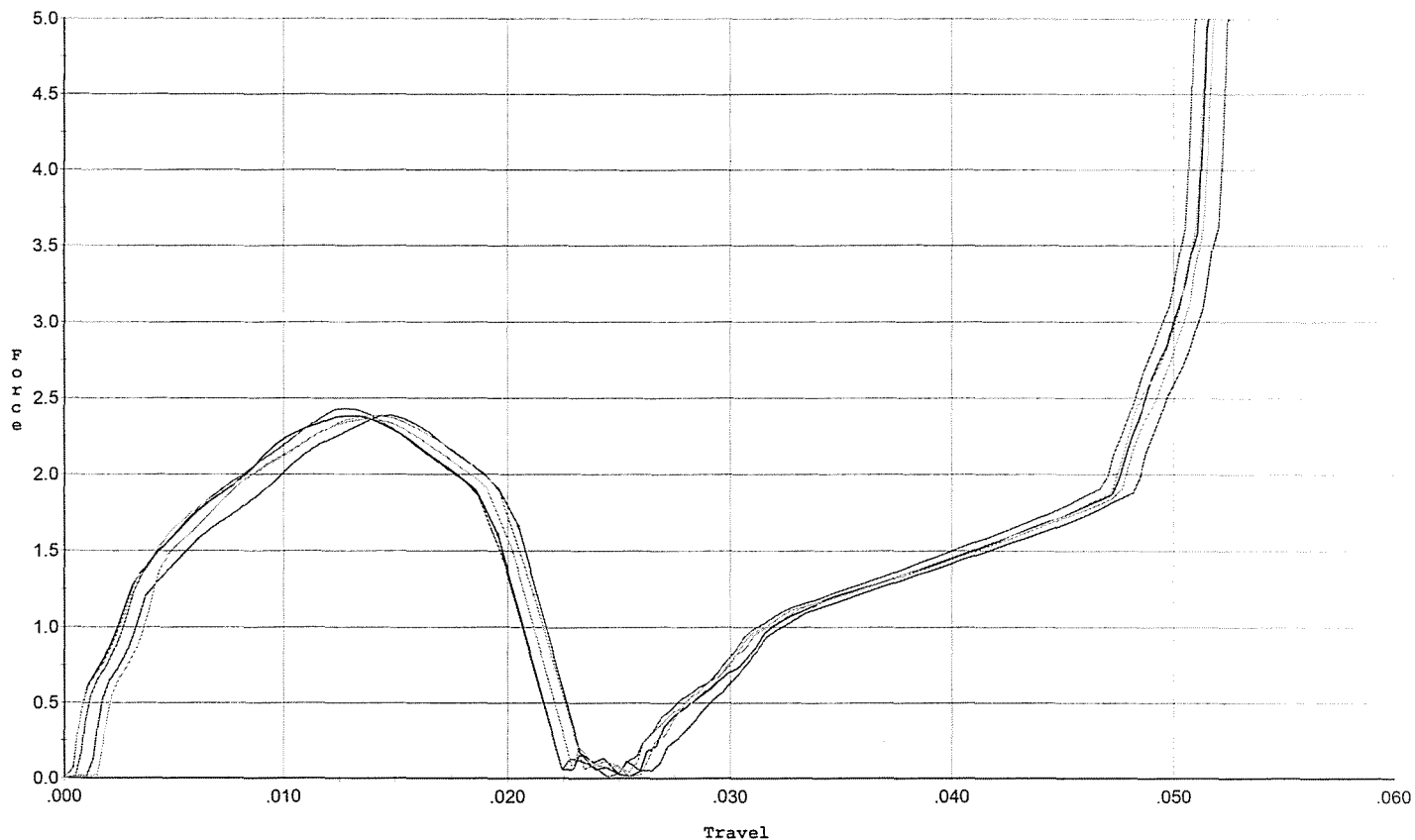
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.490	0.021	0.00	0.036	0.037		Set Trigger
2	2.539	0.020	0.00	0.037	0.036		Set Trigger
3	2.507	0.019	0.00	0.037	0.034		Set Trigger
4	2.520	0.019	0.00	0.037	0.035		Set Trigger
5	2.468	0.020	0.00	0.037	0.035		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



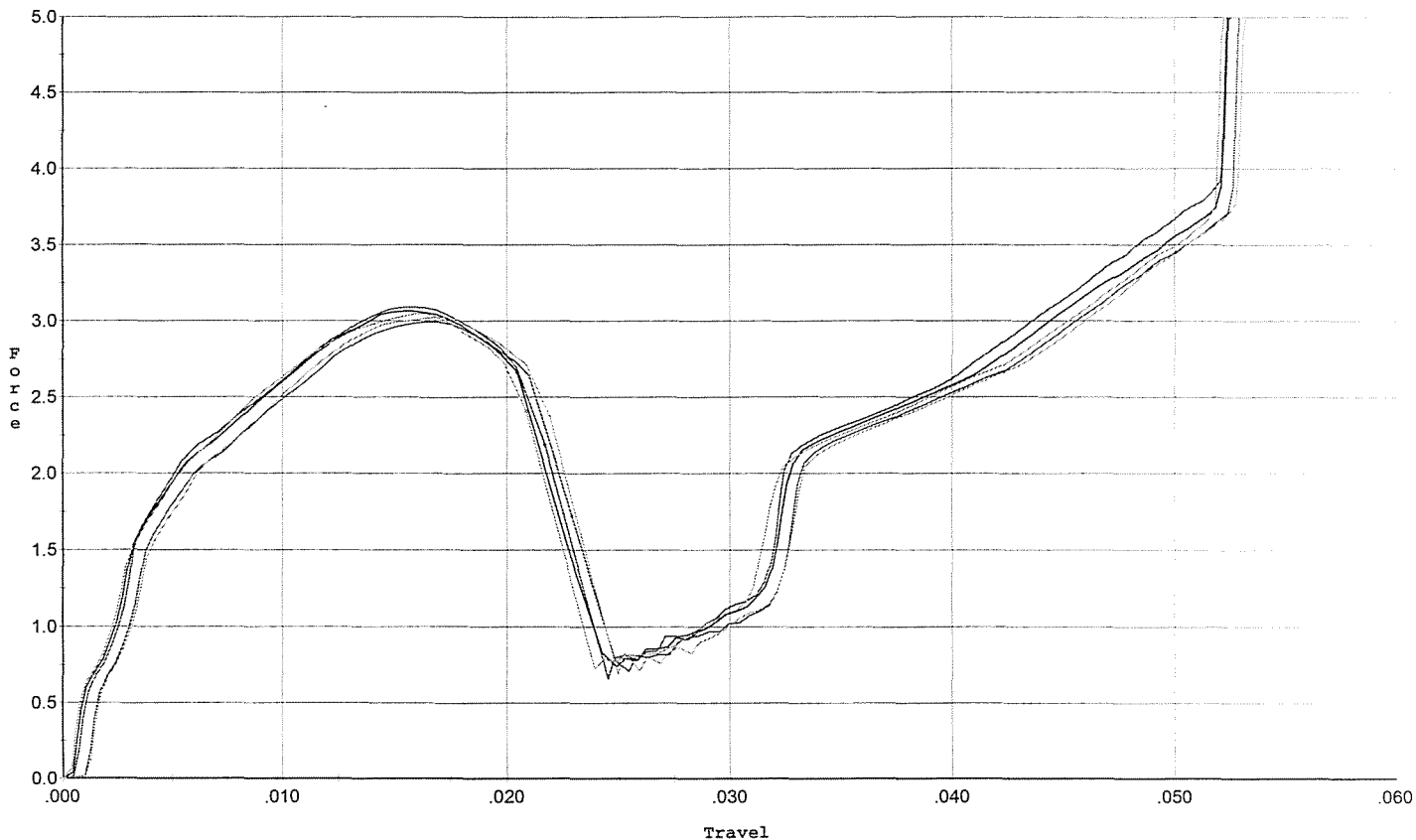
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.391	0.020	0.00	0.037	0.033		Set Trigger
2	2.384	0.020	0.00	0.037	0.034		Set Trigger
3	2.432	0.020	0.00	0.037	0.034		Set Trigger
4	2.364	0.020	0.00	0.037	0.035		Set Trigger
5	2.387	0.021	0.00	0.037	0.035		Set Trigger

Avg 2.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



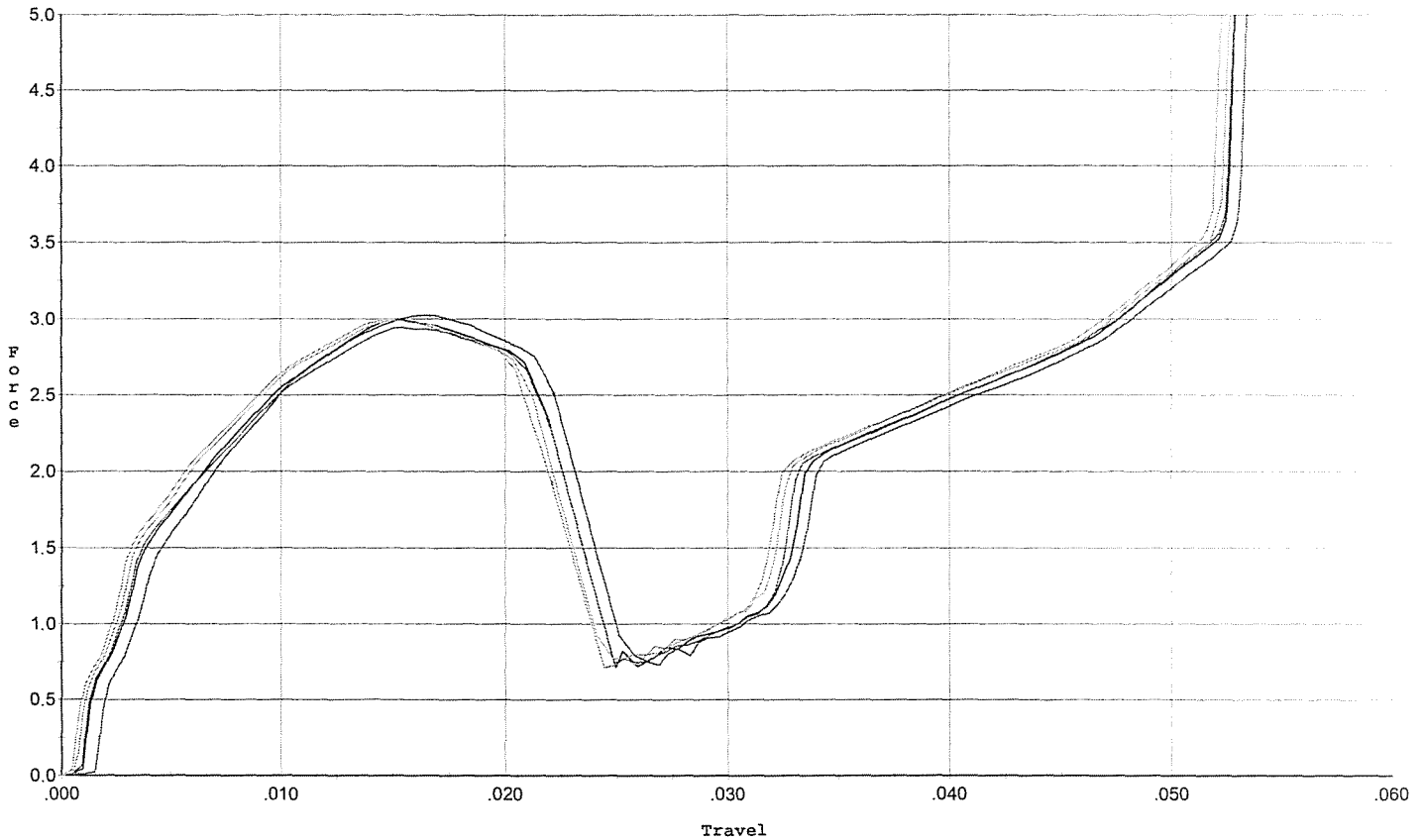
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.089	0.022	0.00	0.034	0.047		Set Trigger
2	3.064	0.020	0.00	0.034	0.045		Set Trigger
3	2.992	0.023	0.00	0.034	0.048		Set Trigger
4	3.020	0.022	0.00	0.034	0.046		Set Trigger
5	3.046	0.021	0.00	0.034	0.045		Set Trigger

Aug 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



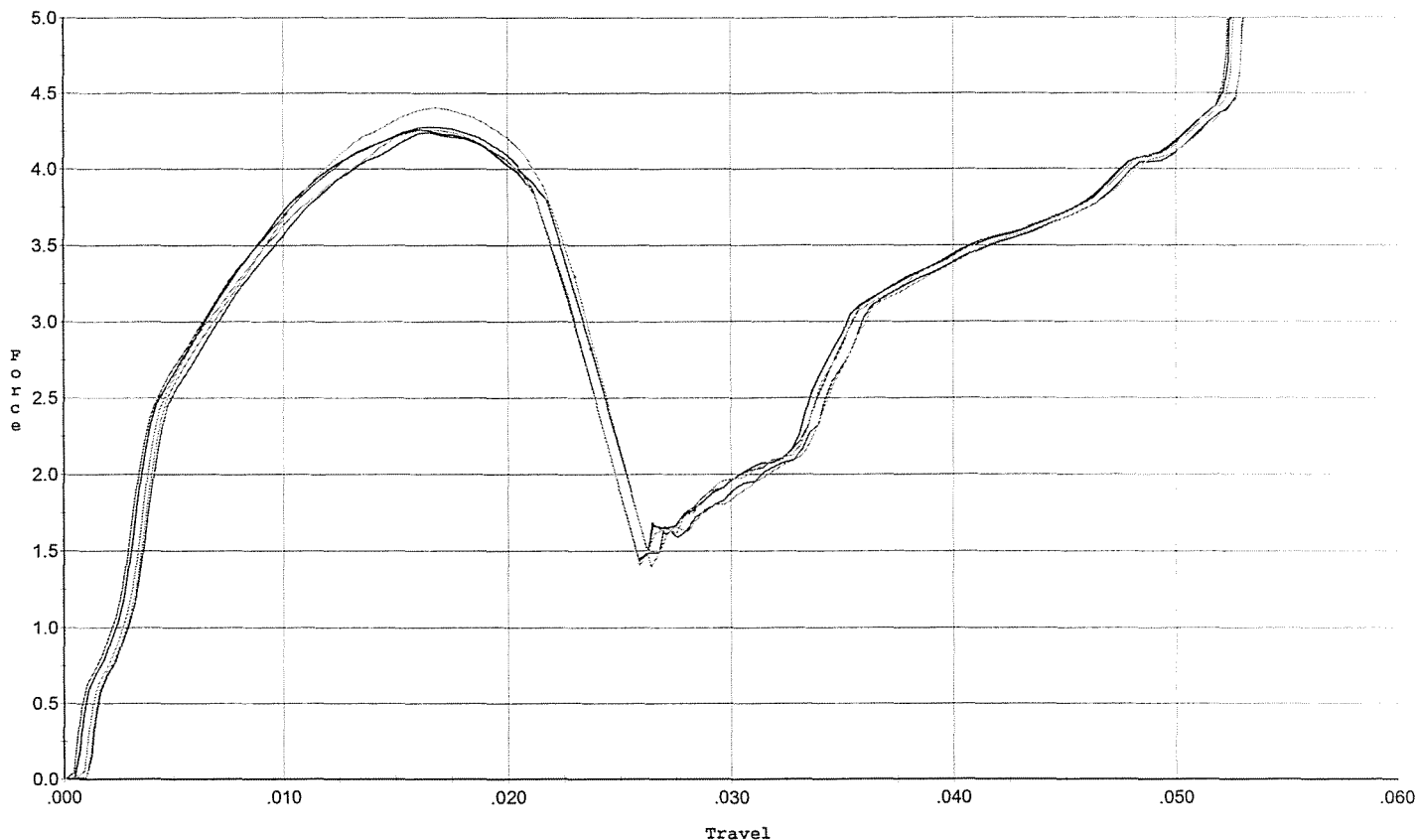
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.024	0.022	0.00	0.034	0.046		Set Trigger
2	2.995	0.022	0.00	0.034	0.046		Set Trigger
3	2.945	0.022	0.00	0.034	0.046		Set Trigger
4	2.989	0.021	0.00	0.034	0.045		Set Trigger
5	2.991	0.022	0.00	0.034	0.048		Set Trigger

Avg 2.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



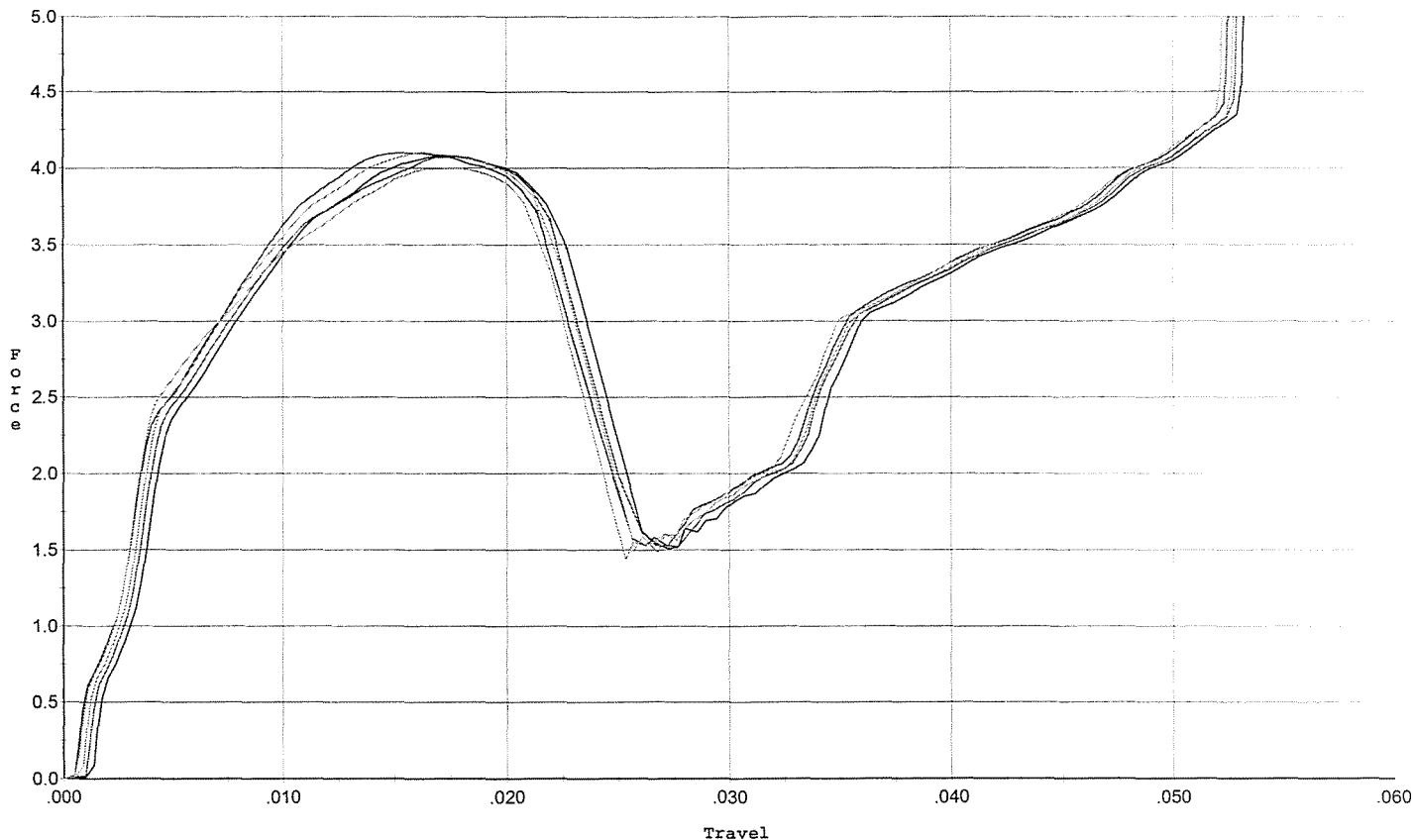
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.241	0.024	0.00	0.031	0.069		Set Trigger
2	4.261	0.023	0.00	0.031	0.068		Set Trigger
3	4.277	0.023	0.00	0.031	0.069		Set Trigger
4	4.261	0.023	0.00	0.032	0.066		Set Trigger
5	4.406	0.023	0.00	0.031	0.069		Set Trigger

Avg 4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



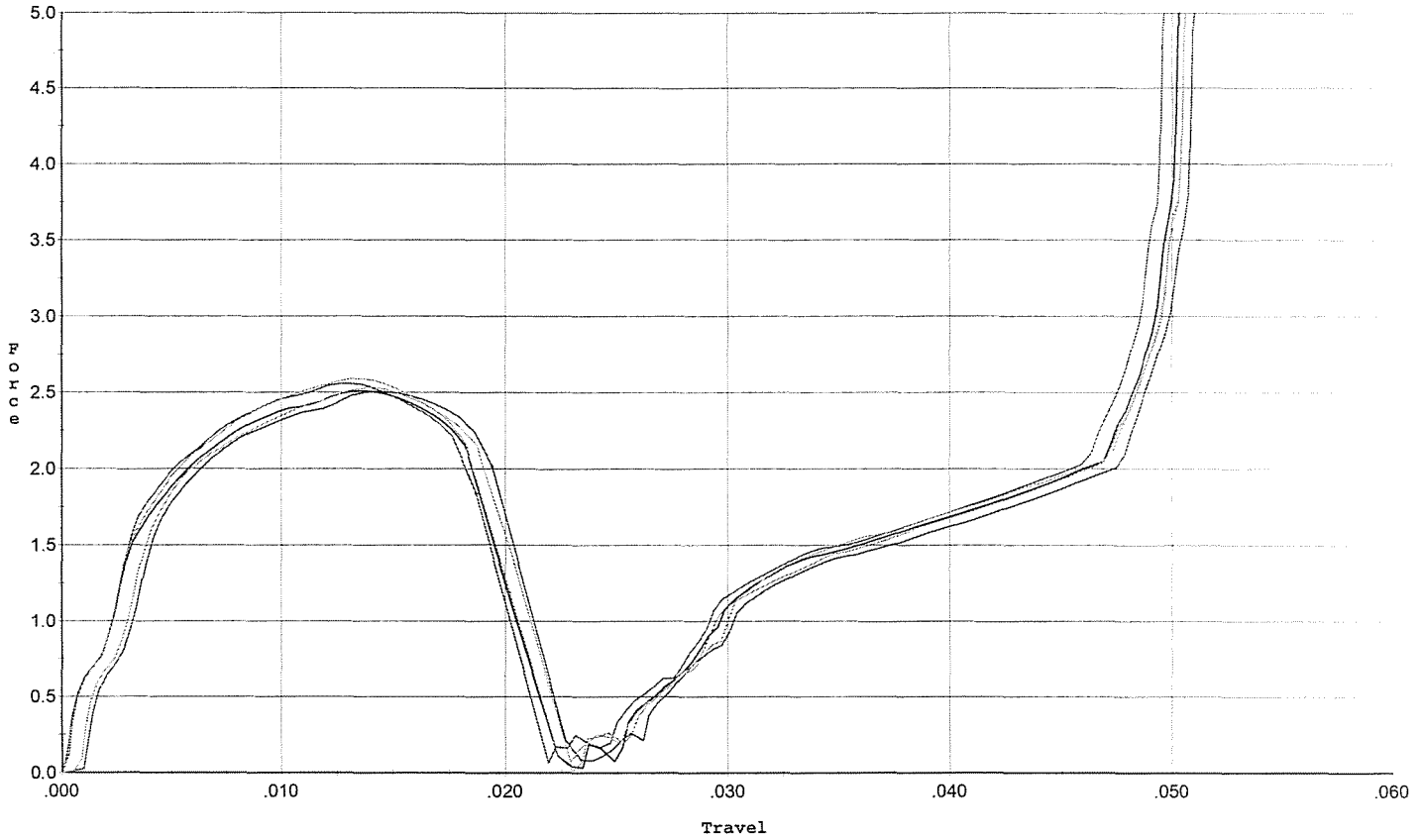
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.021	0.00	0.032	0.062		Set Trigger
2	4.080	0.023	0.00	0.032	0.064		Set Trigger
3	4.071	0.022	0.00	0.032	0.062		Set Trigger
4	4.103	0.022	0.00	0.032	0.064		Set Trigger
5	3.999	0.022	0.00	0.032	0.062		Set Trigger

Aug 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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



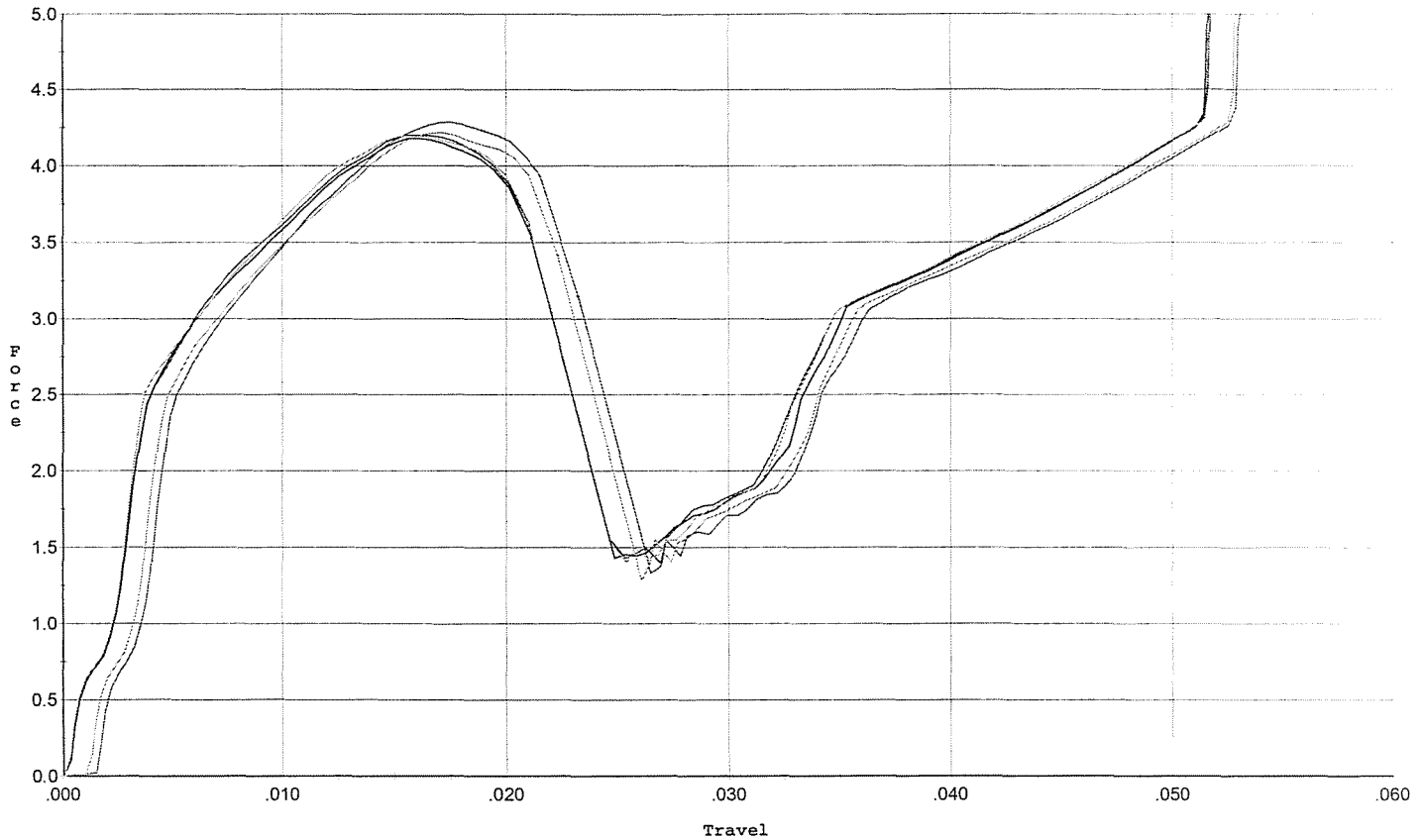
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.019	0.00	0.036	0.035		Set Trigger
2	2.510	0.018	0.00	0.036	0.034		Set Trigger
3	2.558	0.019	0.00	0.035	0.036		Set Trigger
4	2.534	0.020	0.00	0.035	0.037		Set Trigger
5	2.590	0.020	0.00	0.036	0.039		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/15/09

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	4.199	0.021	0.00	0.032	0.062		Set Trigger
2	4.180	0.021	0.00	0.032	0.062		Set Trigger
3	4.288	0.023	0.00	0.032	0.066		Set Trigger
4	4.195	0.021	0.00	0.032	0.062		Set Trigger
5	4.220	0.022	0.00	0.032	0.064		Set Trigger

Avg 4.21