

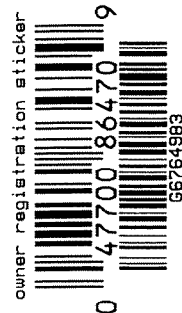
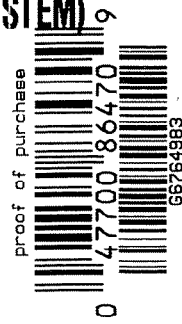
6676 4983



No. 2-153L-3
UPC 10337

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

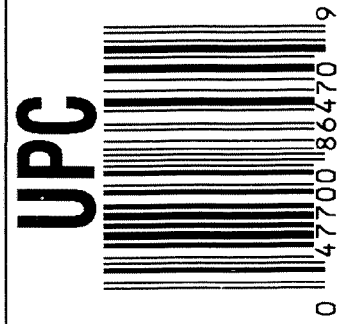


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6764983



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6764983

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-18-08	SP
430	ASSEMBLE TO STOCK		6-18-08	SP
440	PROOF		6-18-08	SD
460	CHECK HEADSPACE	MAGNA - FLUX	6-18-08	SD
470	DIS-ASSEMBLE ACTION		6-18-08	SP
472	SERIALIZE BOLT HANDLE	JUN 2 2008	6-20-08	SP
475	DRILL AND TAP SIGHT HOLES	OPERATOR WMS	6-23-08	SD
480	MAGNAFLUX BBL ACTION		6-24-08	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-24-08	RT
520	GOFF BLAST BBL / REC		6-24	BT
542	APPLY COATINGS (BARREL ACTION)		7-8	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-9	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-9	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-9	SP
	D) OIL FIRING PIN ASSEMBLY		7-15-08	PSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

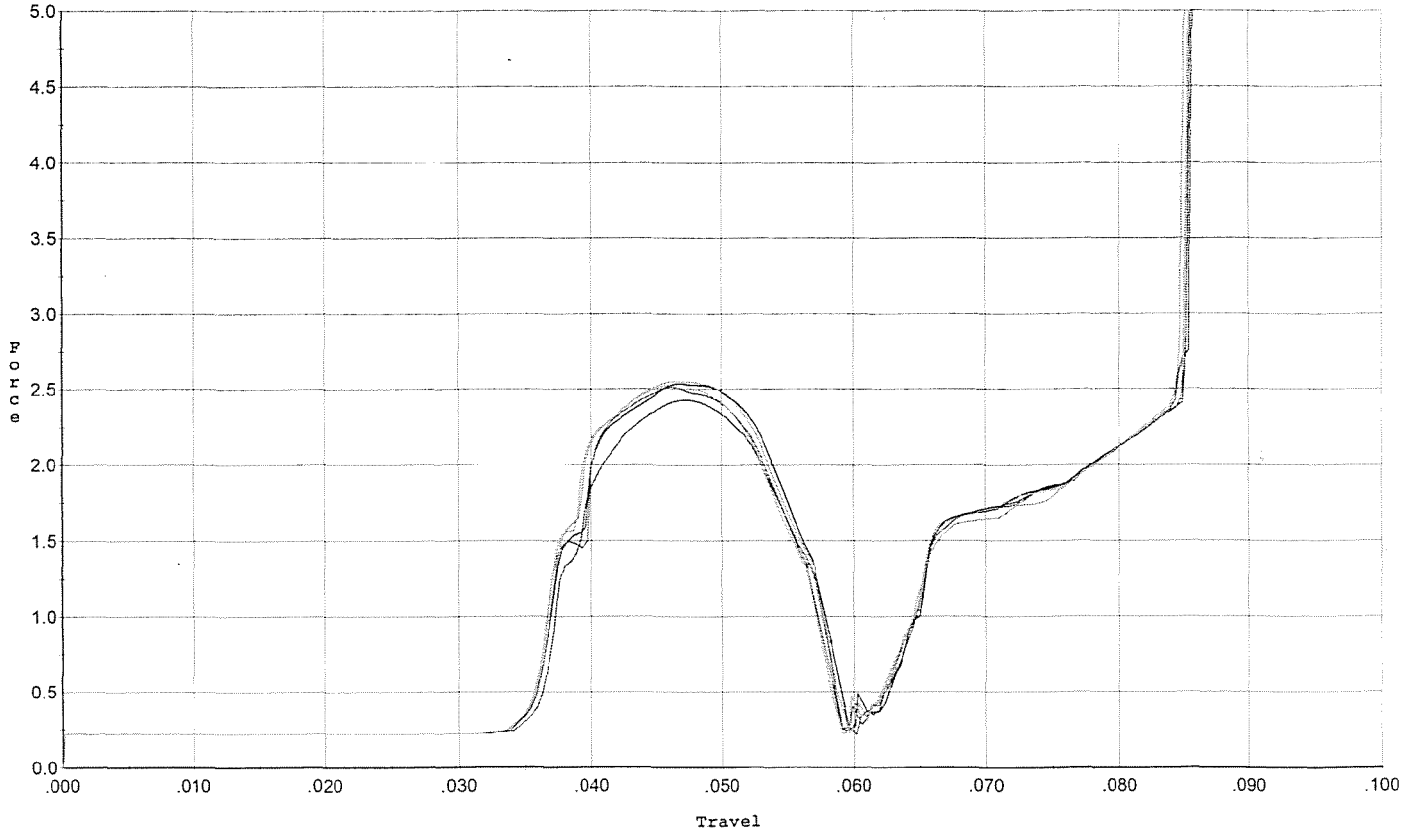
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8</u> <u>7</u> <u>7</u>	7-22	TC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5</u> <u>5</u> <u>5</u>	7-22	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	7-22	TC
	J) ASSEMBLE STOCK		7-15-08	RSW
	K) ASSEMBLE SWIVEL STUDS		7-30-08	RT
	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	PASS FAIL PASS FAIL	7-16-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-16-08	MEH
670	FINAL INSPECTION A) HEADSPACE		7-30-08	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.48</u> <u>2.48</u> <u>2.45</u> <u>2.44</u>	7/22/08	FM
	C) FUNCTION		7-30-08	RT
690	PACK		7/20/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



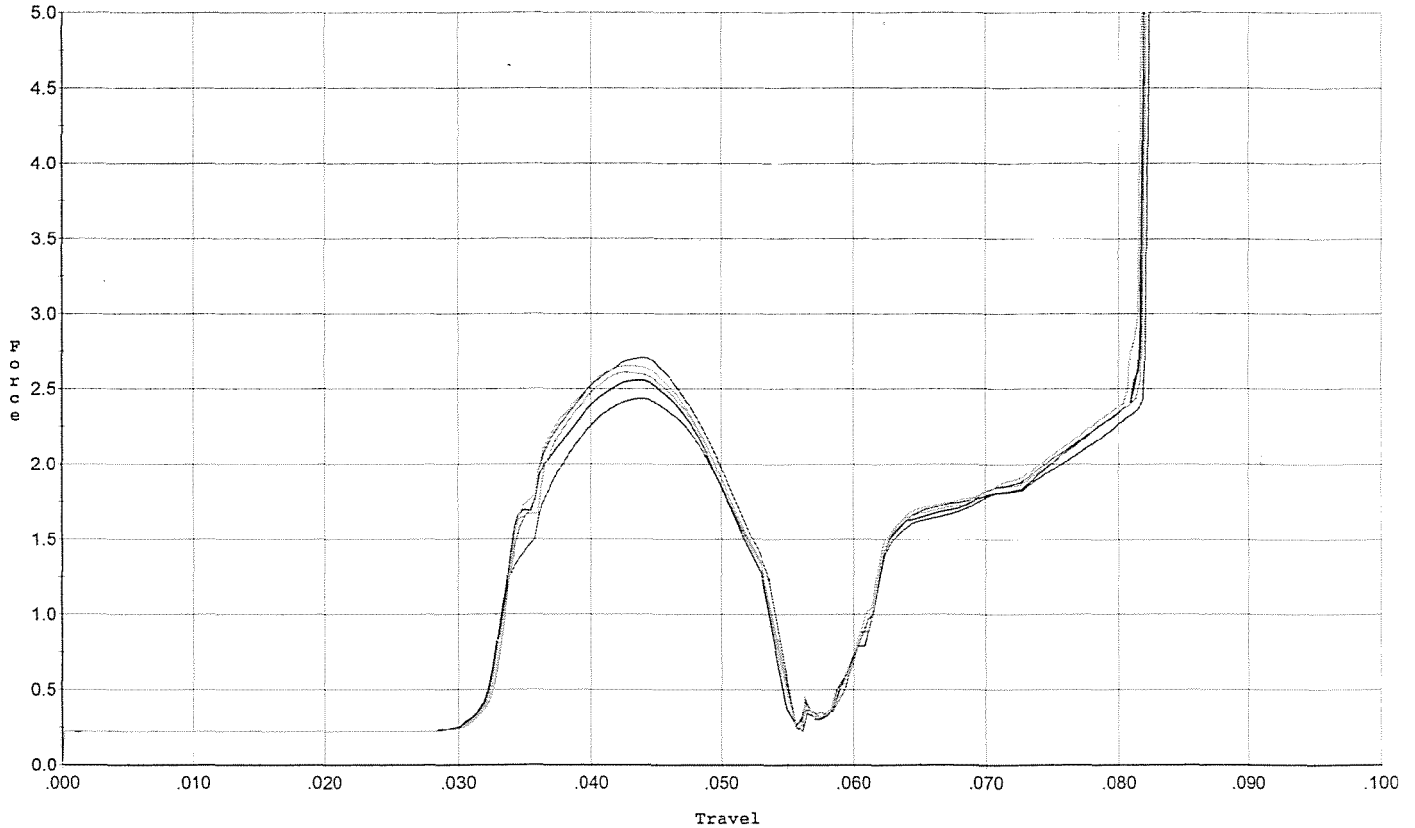
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.057	0.036	0.035	0.049		Set Trigger
2	2.535	0.058	0.036	0.035	0.053		Set Trigger
3	2.512	0.056	0.035	0.036	0.050		Set Trigger
4	2.521	0.057	0.035	0.035	0.051		Set Trigger
5	2.550	0.057	0.036	0.035	0.052		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



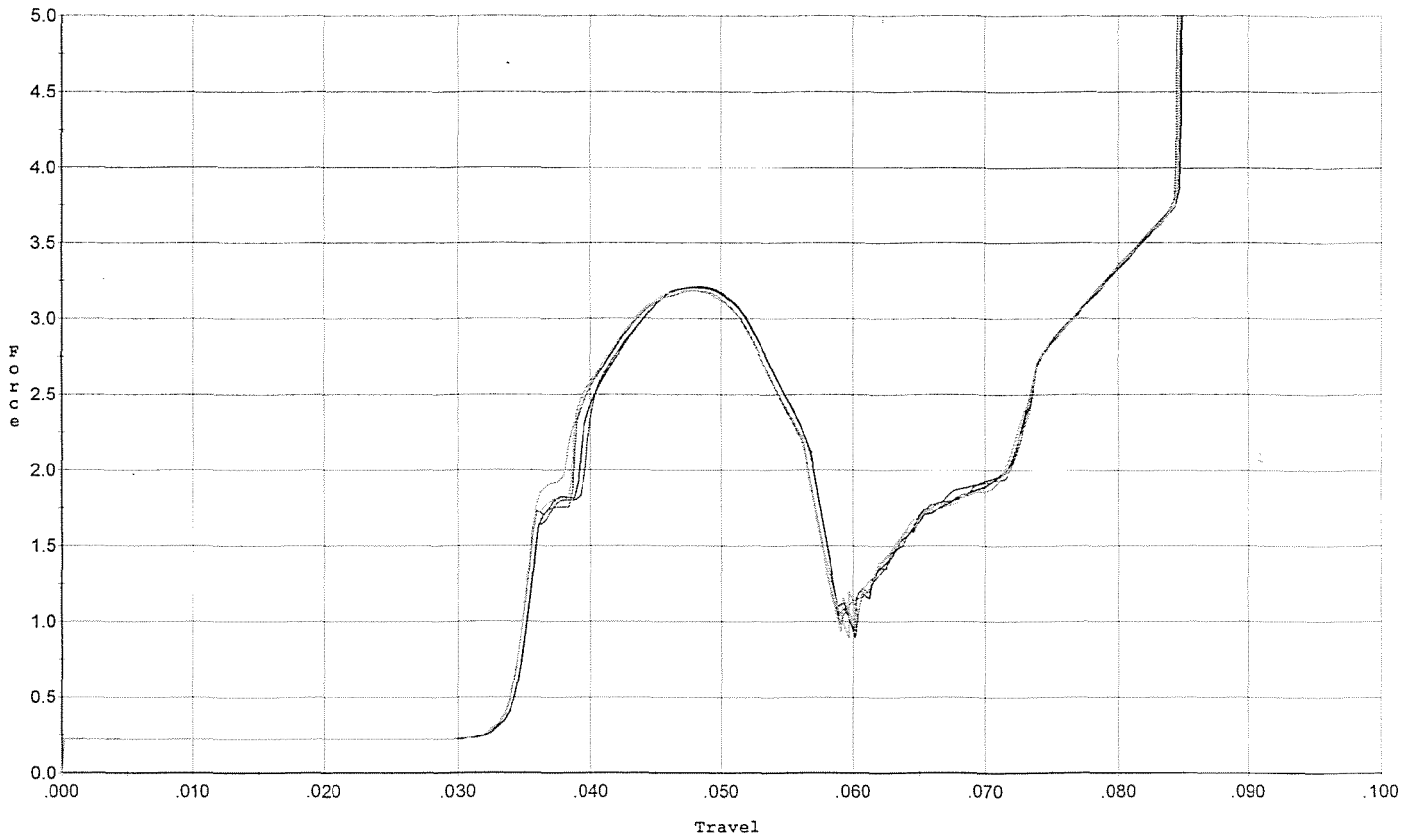
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.054	0.032	0.034	0.049		Set Trigger
2	2.557	0.053	0.032	0.034	0.050		Set Trigger
3	2.708	0.054	0.032	0.034	0.052		Set Trigger
4	2.653	0.053	0.032	0.034	0.051		Set Trigger
5	2.611	0.053	0.032	0.034	0.050		Set Trigger

Avg 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



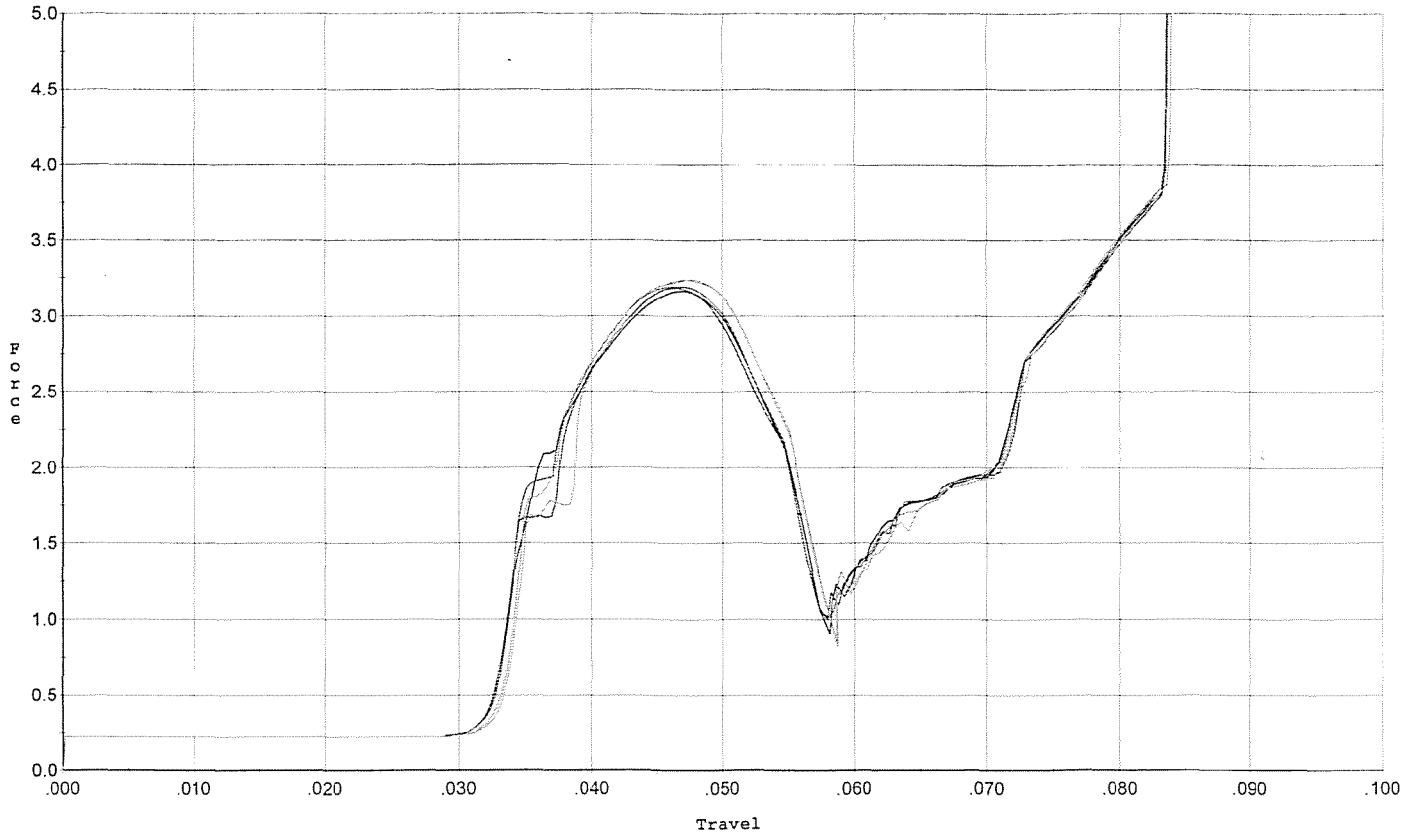
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.057	0.034	0.034	0.066		Set Trigger
2	3.202	0.057	0.034	0.034	0.066		Set Trigger
3	3.187	0.056	0.034	0.034	0.065		Set Trigger
4	3.186	0.056	0.034	0.034	0.066		Set Trigger
5	3.185	0.056	0.034	0.034	0.065		Set Trigger

Avg 3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/14/08

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



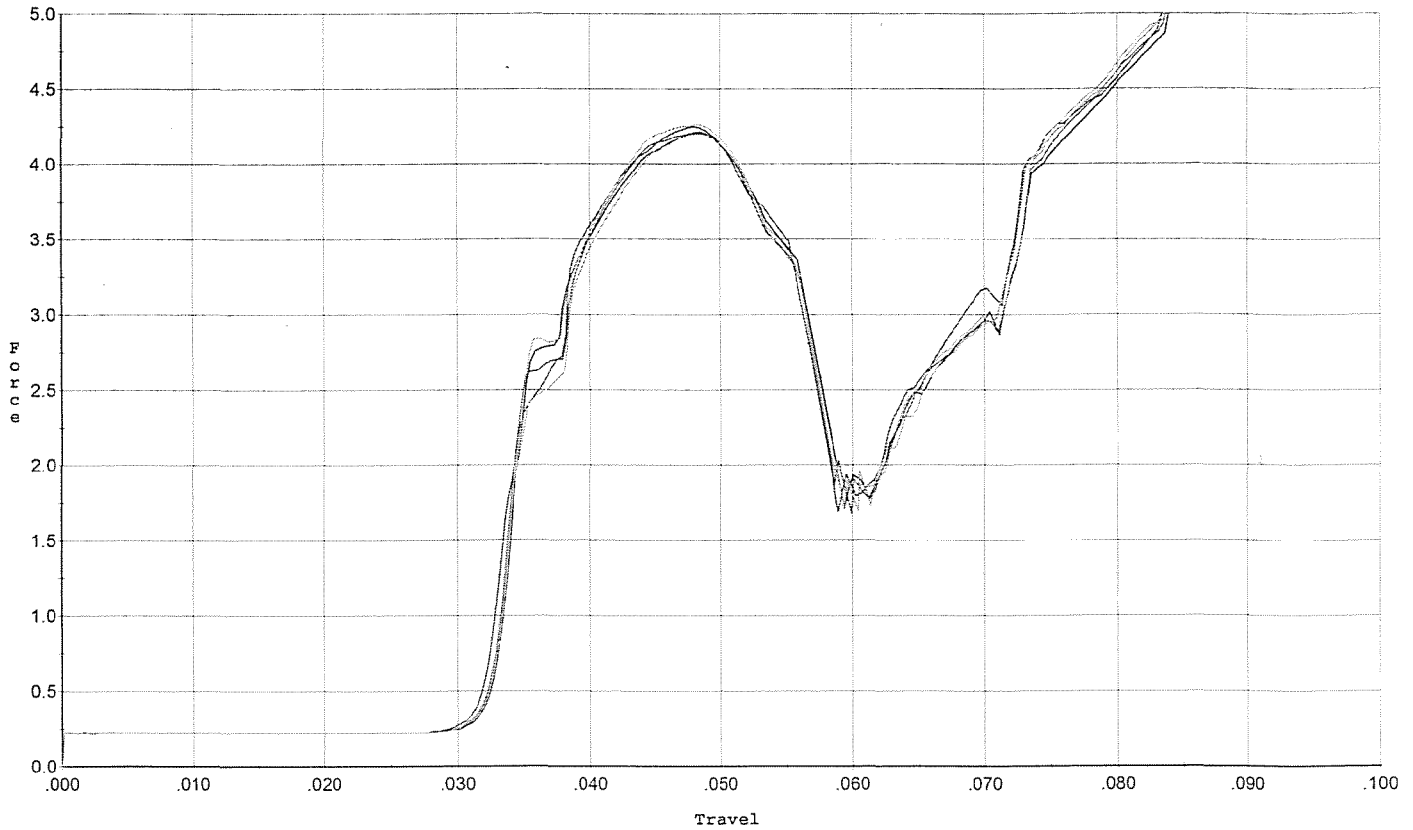
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.184	0.055	0.032	0.034	0.063		Set Trigger
2	3.163	0.056	0.032	0.033	0.065		Set Trigger
3	3.192	0.055	0.032	0.034	0.064		Set Trigger
4	3.238	0.055	0.033	0.034	0.064		Set Trigger
5	3.240	0.055	0.033	0.034	0.066		Set Trigger

Avg 3.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



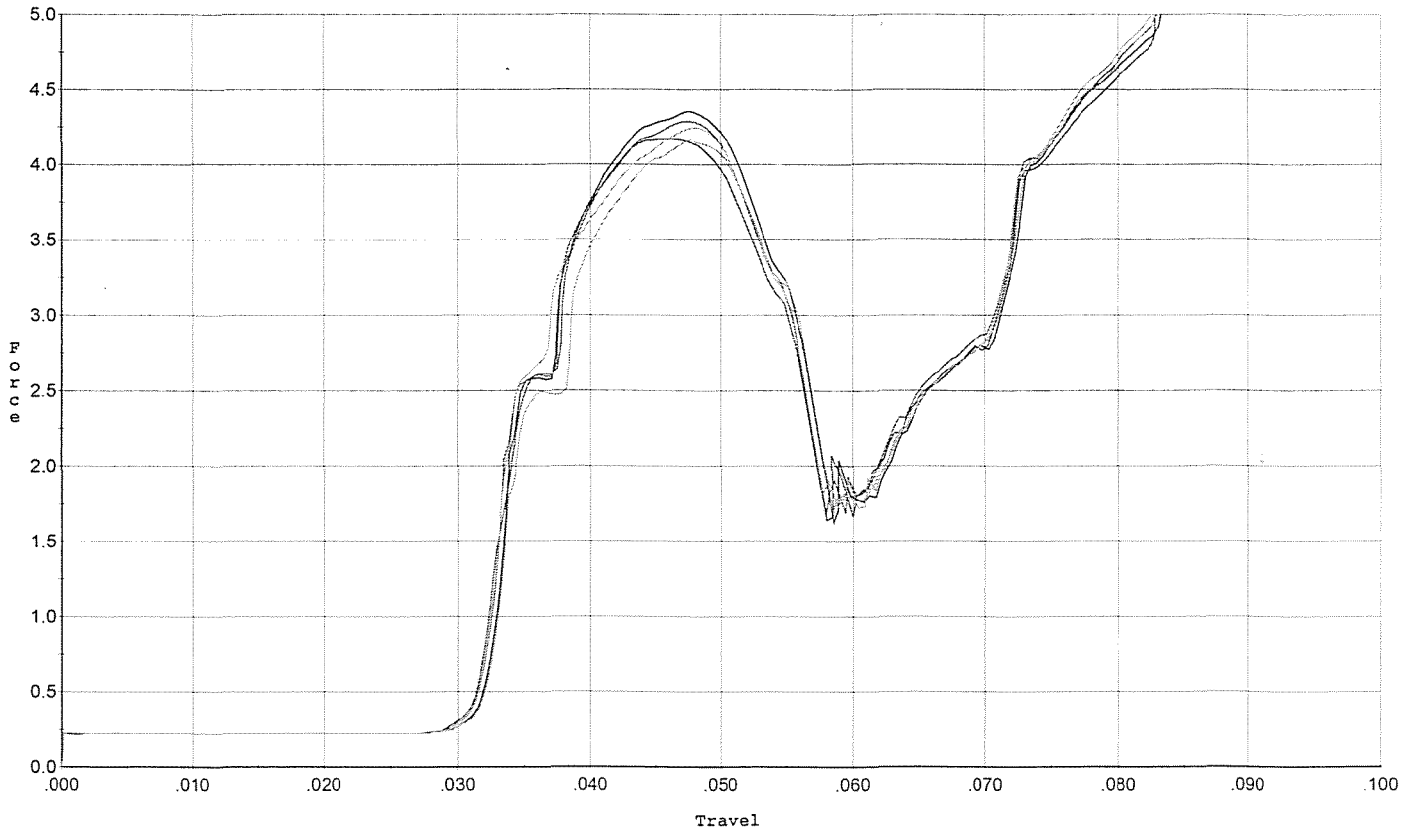
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.250	0.057	0.031	0.031	0.091		Set Trigger
2	4.208	0.058	0.032	0.032	0.092		Set Trigger
3	4.215	0.056	0.032	0.031	0.090		Set Trigger
4	4.261	0.056	0.032	0.031	0.090		Set Trigger
5	4.200	0.056	0.032	0.032	0.088		Set Trigger

Avg 4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



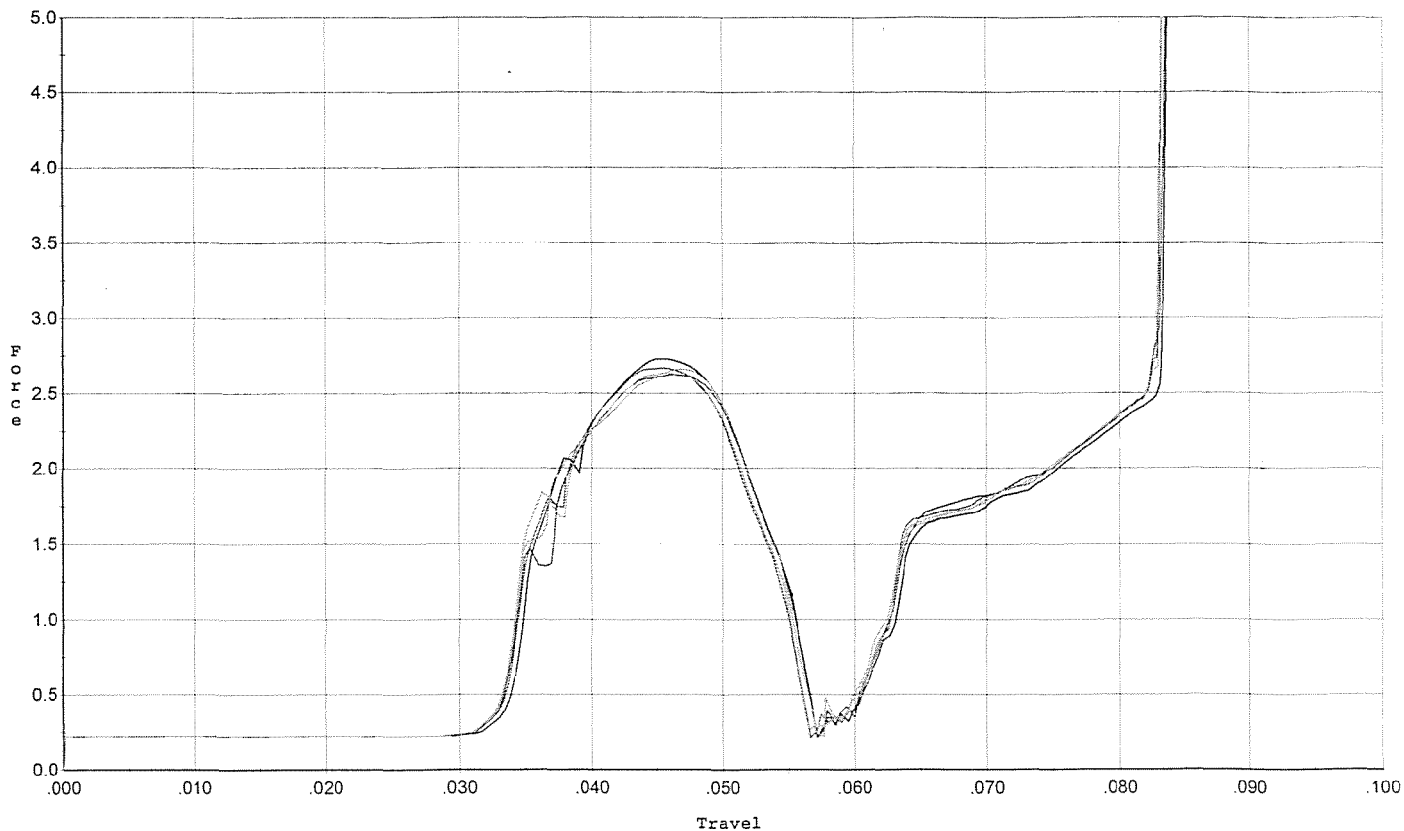
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.170	0.056	0.031	0.032	0.088		Set Trigger
2	4.352	0.056	0.032	0.031	0.091		Set Trigger
3	4.285	0.056	0.031	0.032	0.089		Set Trigger
4	4.244	0.055	0.031	0.032	0.089		Set Trigger
5	4.162	0.056	0.032	0.032	0.086		Set Trigger

Avg 4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



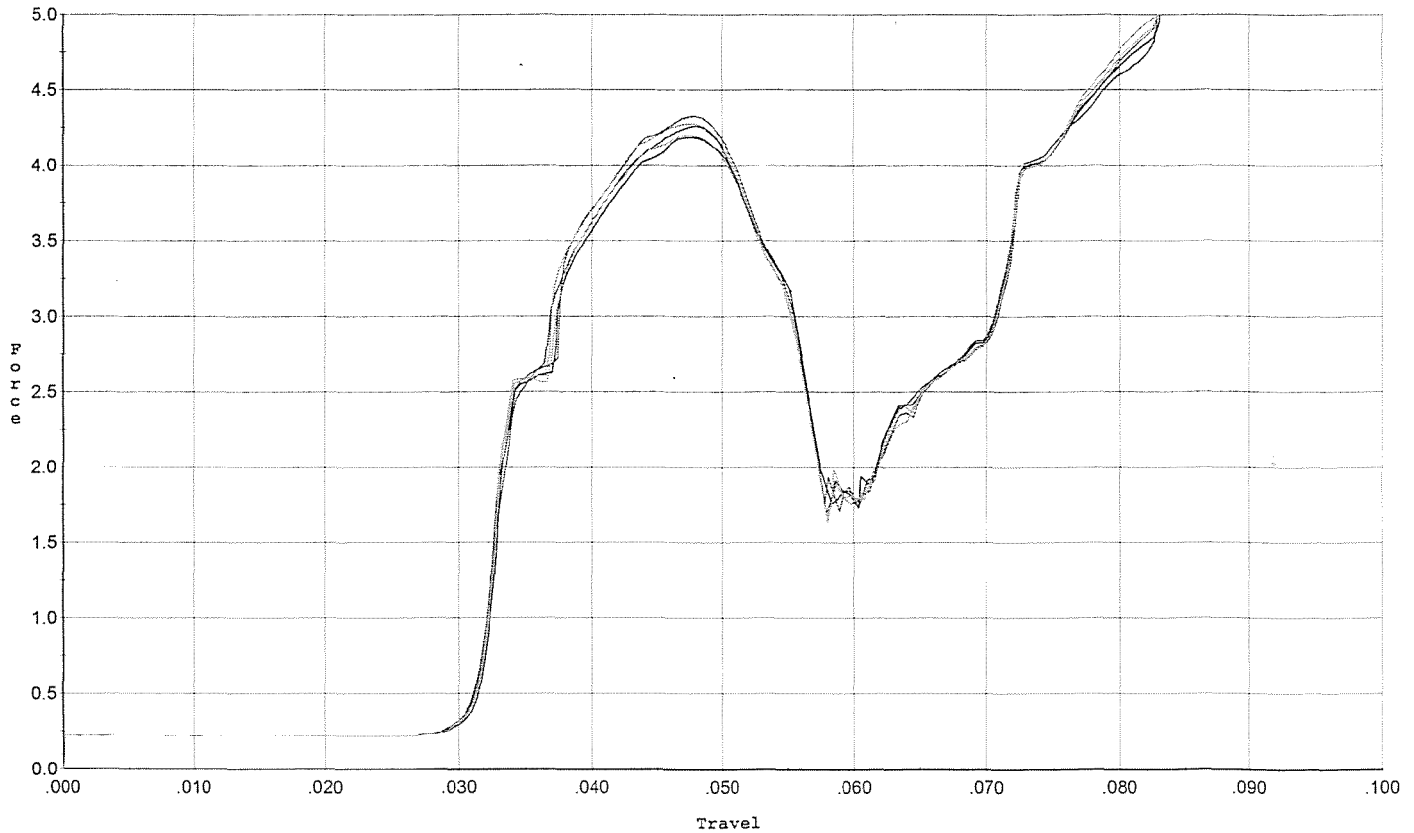
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.623	0.055	0.033	0.034	0.052		Set Trigger
2	2.727	0.055	0.034	0.035	0.053		Set Trigger
3	2.667	0.055	0.033	0.035	0.052		Set Trigger
4	2.631	0.055	0.033	0.035	0.052		Set Trigger
5	2.661	0.054	0.033	0.035	0.052		Set Trigger

AVG x 2.666

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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	4.263	0.055	0.031	0.032	0.089		Set Trigger
2	4.185	0.055	0.031	0.032	0.088		Set Trigger
3	4.325	0.055	0.031	0.031	0.090		Set Trigger
4	4.199	0.056	0.031	0.032	0.089		Set Trigger
5	4.275	0.056	0.031	0.032	0.091		Set Trigger

Avg 4.24