

676 4995

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

**BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD**



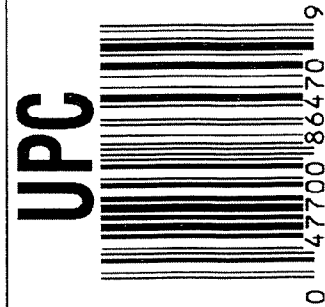
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6764995



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6764995

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-15-08	PSW
430	ASSEMBLE TO STOCK		7-15-08	SP
440	PROOF		7-15-08	PPD
460	CHECK HEADSPACE	MAGNA - FLUX	7-15-08	PPD
470	DIS-ASSEMBLE ACTION	JUL 21 2008	7-16-08	LR
472	SERIALIZE BOLT HANDLE		7-16-08	LR
475	DRILL AND TAP SIGHT HOLES	OPERATOR B H	7-17-08	SP
480	MAGNAFLUX BBL ACTION		7-21-08	B H
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7/21/08	PT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		7-25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-29-08	TC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-29-08	TC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-29-08	TC
	D) OIL FIRING PIN ASSEMBLY		7-29-08	PSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

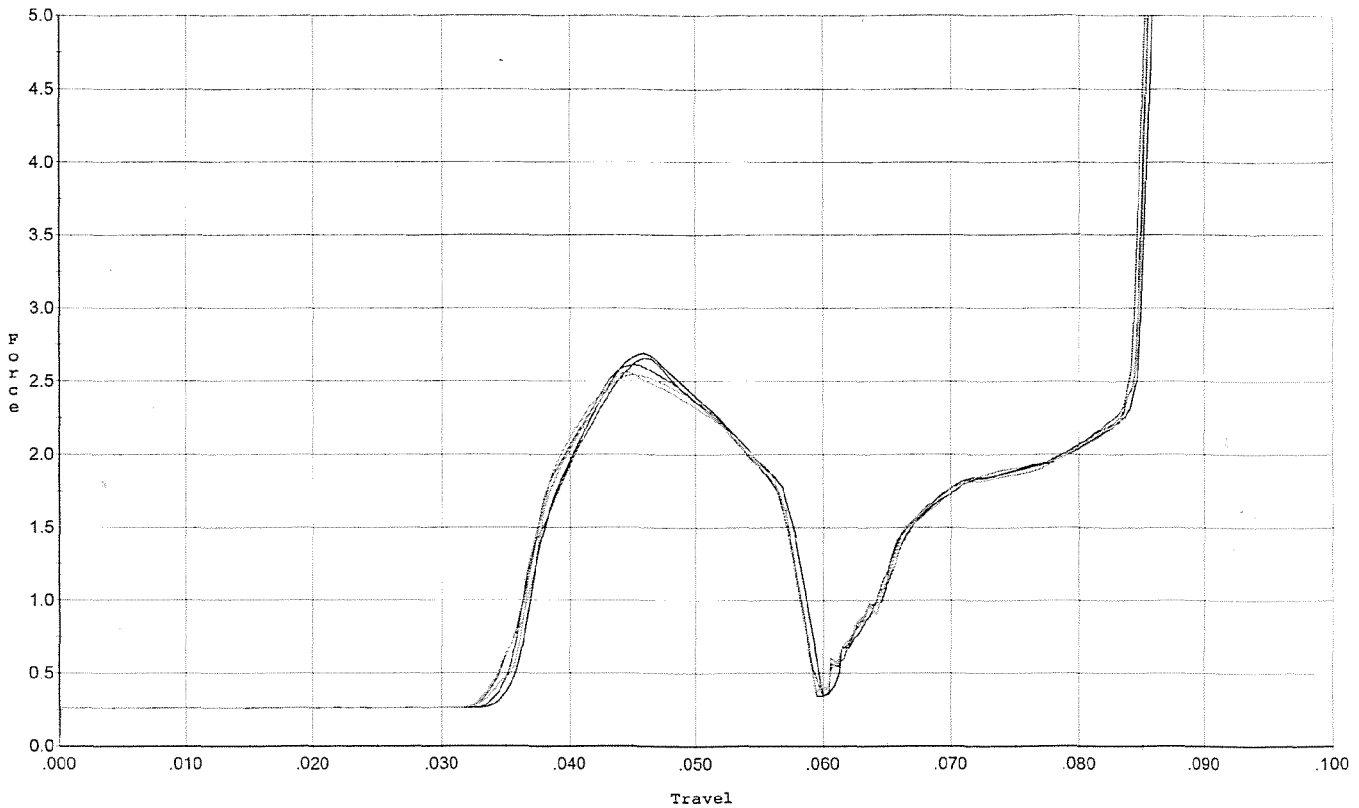
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	8-4	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.5</u> <u>6</u> <u>6.5</u>	8-4	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-4	TL
	J) ASSEMBLE STOCK		7-29-08	ESW
	K) ASSEMBLE SWIVEL STUDS		8-5-08	G.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-5-08	G.P.D.
	M) IRON SIGHT ALIGNMENT		8-5-08	G.P.D.
	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	8-1-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-1-08	
670	FINAL INSPECTION A) HEADSPACE		8-5-08	G.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>267</u> <u>260</u> <u>263</u> <u>255</u> <u>261</u>	8-4-08	ESW
	C) FUNCTION		8-5-08	G.P.D.
690	PACK		8/8/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/24/08

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



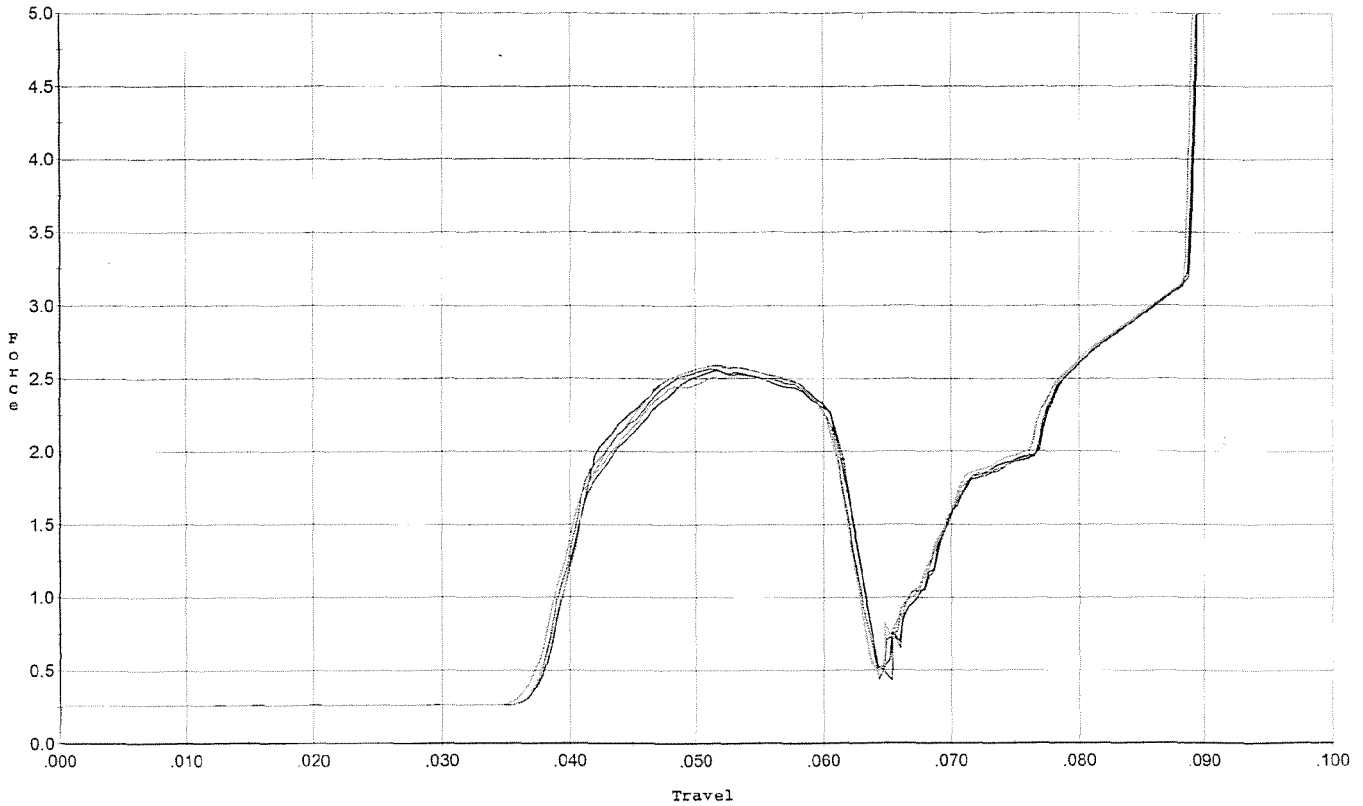
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.656	0.057	0.035	0.035	0.055		Set Trigger
2	2.691	0.058	0.035	0.035	0.056		Set Trigger
3	2.615	0.057	0.034	0.035	0.056		Set Trigger
4	2.541	0.057	0.034	0.035	0.055		Set Trigger
5	2.564	0.057	0.036	0.035	0.055		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/24/08

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



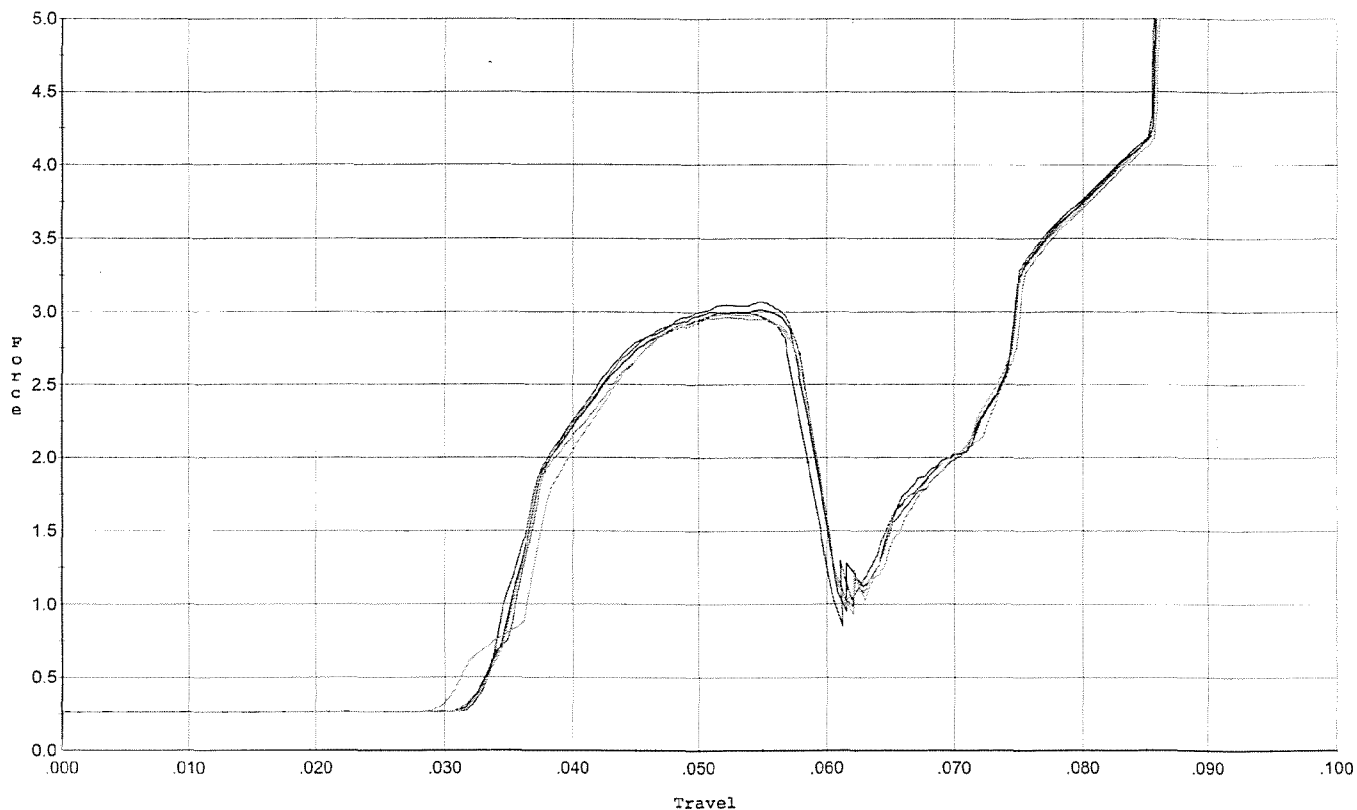
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.557	0.062	0.038	0.034	0.061		Set Trigger
2	2.598	0.062	0.038	0.034	0.063		Set Trigger
3	2.566	0.061	0.037	0.035	0.061		Set Trigger
4	2.591	0.061	0.037	0.035	0.061		Set Trigger
5	2.514	0.061	0.037	0.035	0.061		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/24/08

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



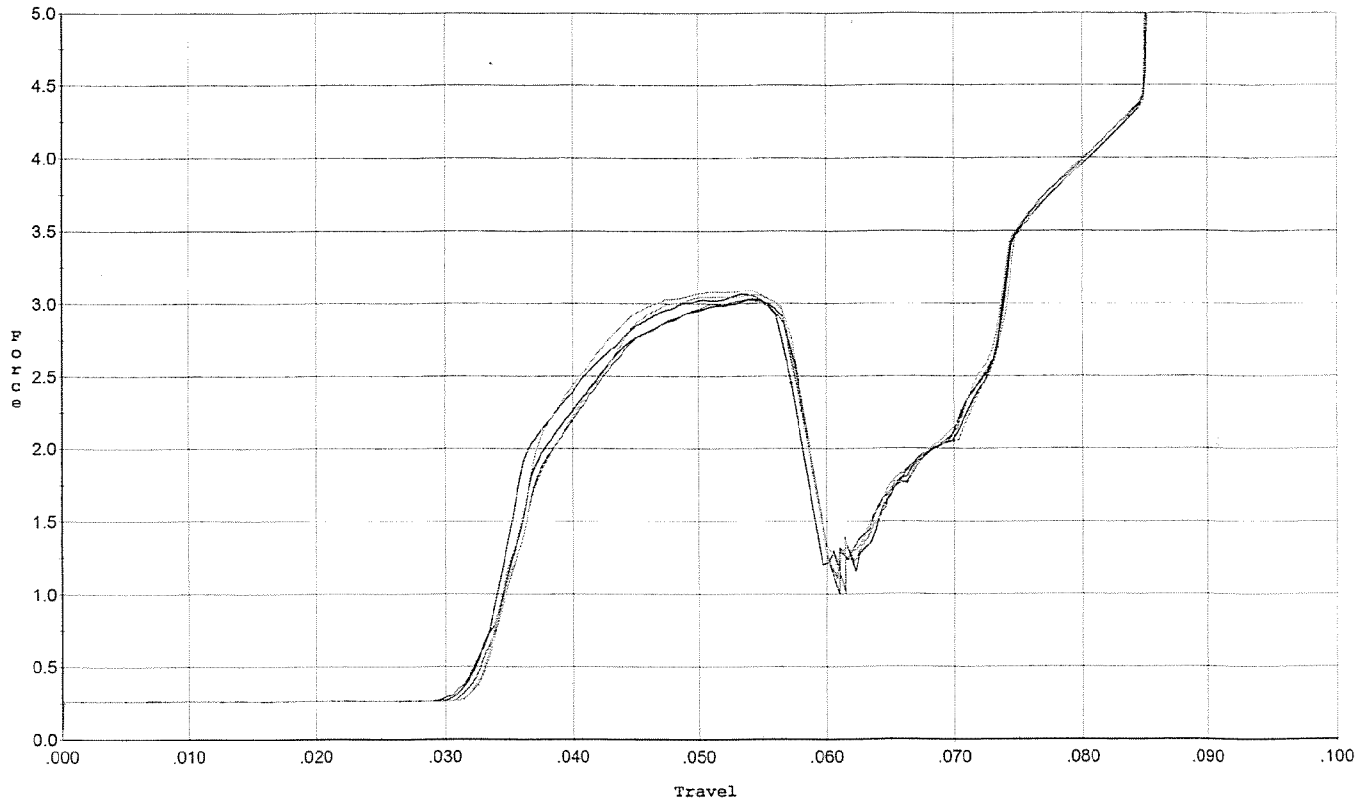
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.003	0.059	0.033	0.033	0.070		Set Trigger
2	3.016	0.059	0.033	0.033	0.071		Set Trigger
3	3.070	0.058	0.033	0.033	0.071		Set Trigger
4	2.962	0.058	0.031	0.032	0.069		Set Trigger
5	2.982	0.058	0.033	0.033	0.069		Set Trigger

Avg 3.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/24/08

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



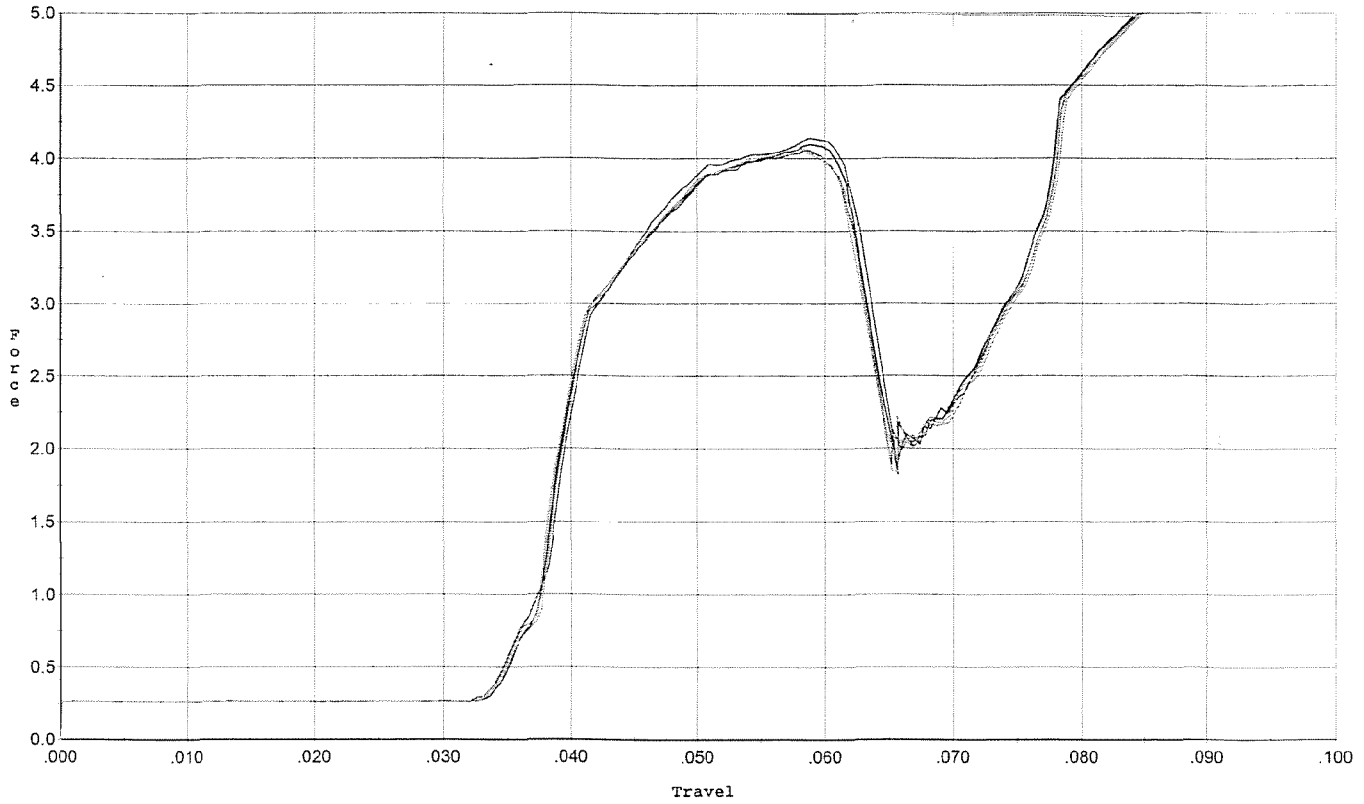
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.057	0.032	0.033	0.071		Set Trigger
2	3.034	0.058	0.032	0.033	0.070		Set Trigger
3	3.028	0.058	0.032	0.033	0.070		Set Trigger
4	3.061	0.057	0.033	0.033	0.070		Set Trigger
5	3.089	0.058	0.033	0.033	0.073		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/24/08

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



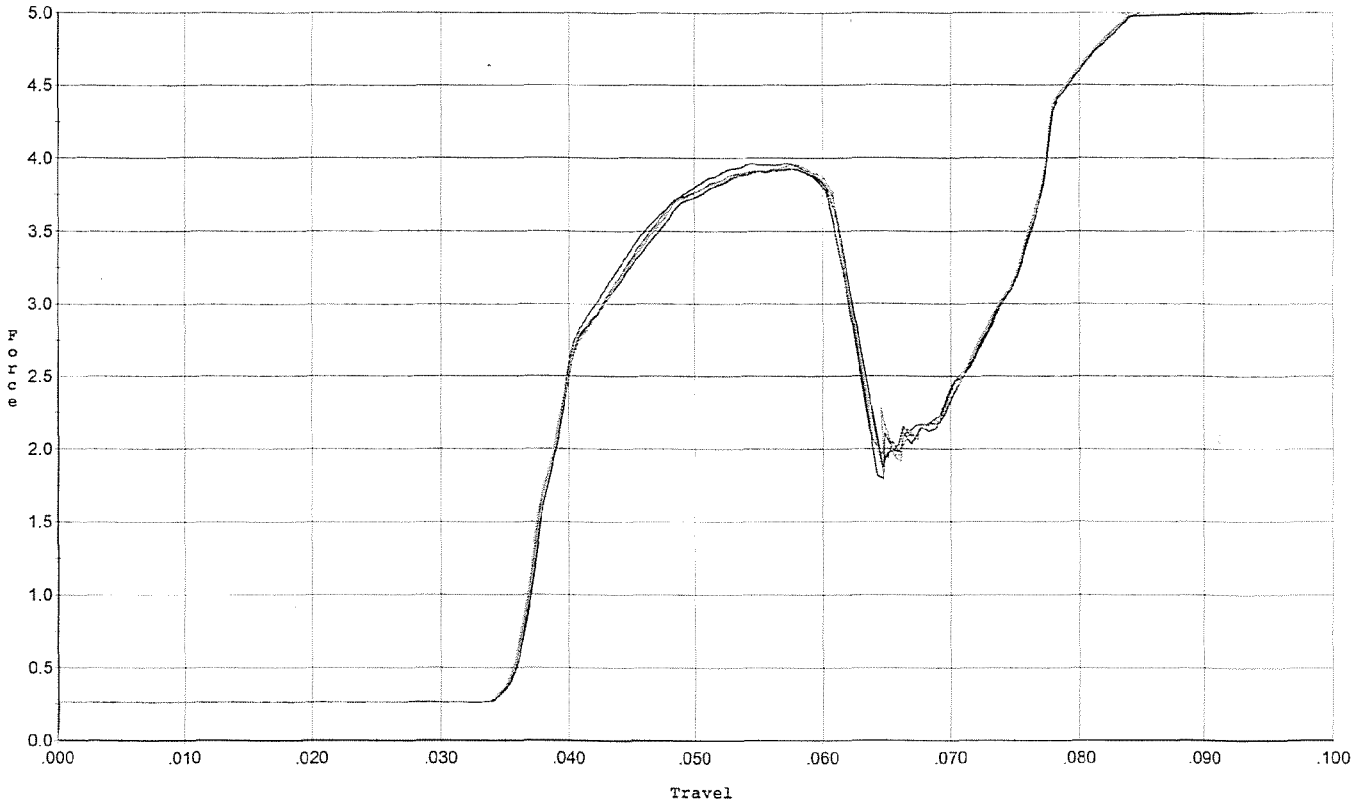
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.140	0.063	0.034	0.030	0.101		Set Trigger
2	4.096	0.062	0.035	0.031	0.098		Set Trigger
3	4.054	0.062	0.035	0.030	0.098		Set Trigger
4	4.066	0.063	0.034	0.031	0.100		Set Trigger
5	4.039	0.062	0.035	0.031	0.098		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/24/08

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



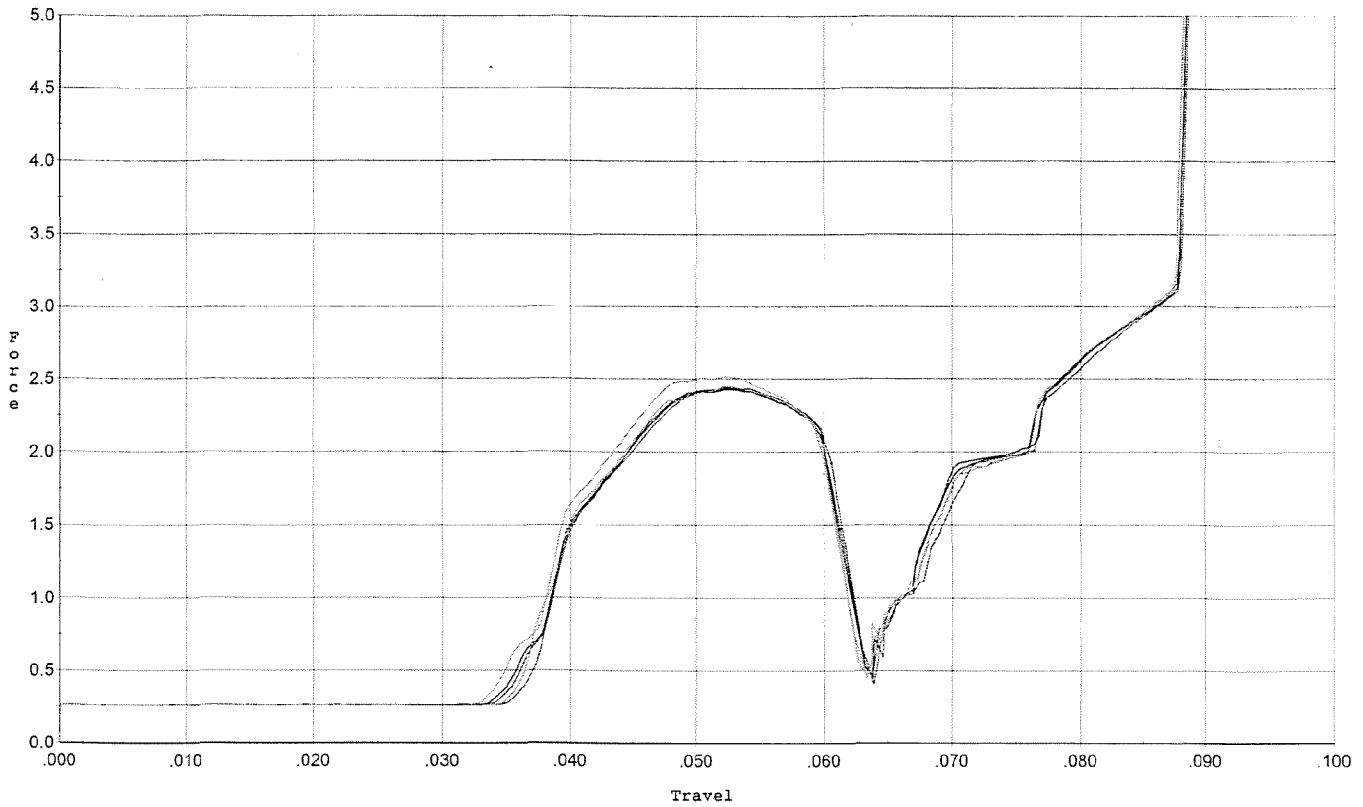
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.964	0.062	0.035	0.031	0.095		Set Trigger
2	3.926	0.061	0.036	0.031	0.093		Set Trigger
3	3.952	0.061	0.035	0.031	0.094		Set Trigger
4	3.955	0.061	0.035	0.031	0.094		Set Trigger
5	3.926	0.061	0.035	0.031	0.094		Set Trigger

AVG 3.94

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/24/08

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



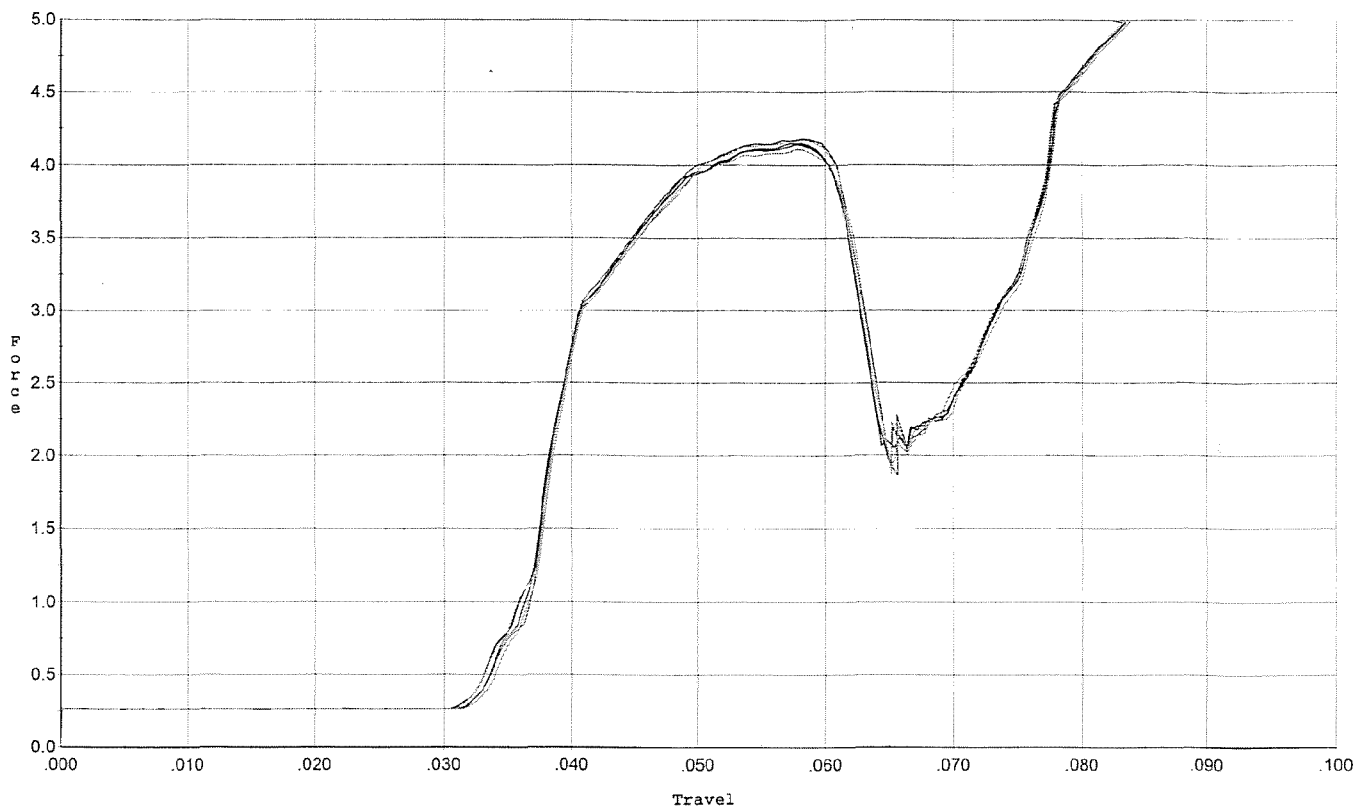
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.061	0.036	0.034	0.059		Set Trigger
2	2.435	0.060	0.035	0.034	0.058		Set Trigger
3	2.446	0.061	0.037	0.035	0.058		Set Trigger
4	2.516	0.060	0.034	0.034	0.060		Set Trigger
5	2.452	0.060	0.036	0.035	0.058		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/24/08

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	4.152	0.061	0.033	0.031	0.101		Set Trigger
2	4.143	0.061	0.033	0.031	0.101		Set Trigger
3	4.182	0.063	0.033	0.030	0.104		Set Trigger
4	4.110	0.061	0.033	0.031	0.100		Set Trigger
5	4.174	0.062	0.034	0.030	0.103		Set Trigger

Avg 4.15