

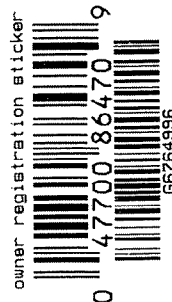
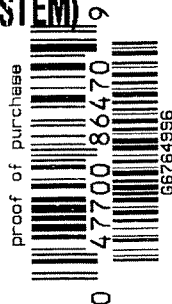
G 676 4996



No. 153L

UPC 10330

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

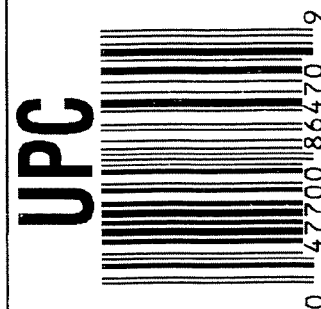


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6764996



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 676 4996

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-19-08	J.P.D.
430	ASSEMBLE TO STOCK		6-19-08	SP
440	PROOF		6-19-08	SD
460	CHECK HEADSPACE		6-19-08	SD
470	DIS-ASSEMBLE ACTION		6-19-08	J.P.D.
472	SERIALIZE BOLT HANDLE		6-20-08	J.P.D.
475	DRILL AND TAP SIGHT HOLES	2008	6-23-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR WMS	6/24/08	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/24/08	RT
520	GOFF BLAST BBL / REC		6-24	B-L
542	APPLY COATINGS (BARREL ACTION)		6-26	W
545	(BOLT)			
560	RE-ASSEMBLE ACTION		6/27/08	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6/27/08	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6/27/08	RP
	D) OIL FIRING PIN ASSEMBLY		7/3/08	J.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

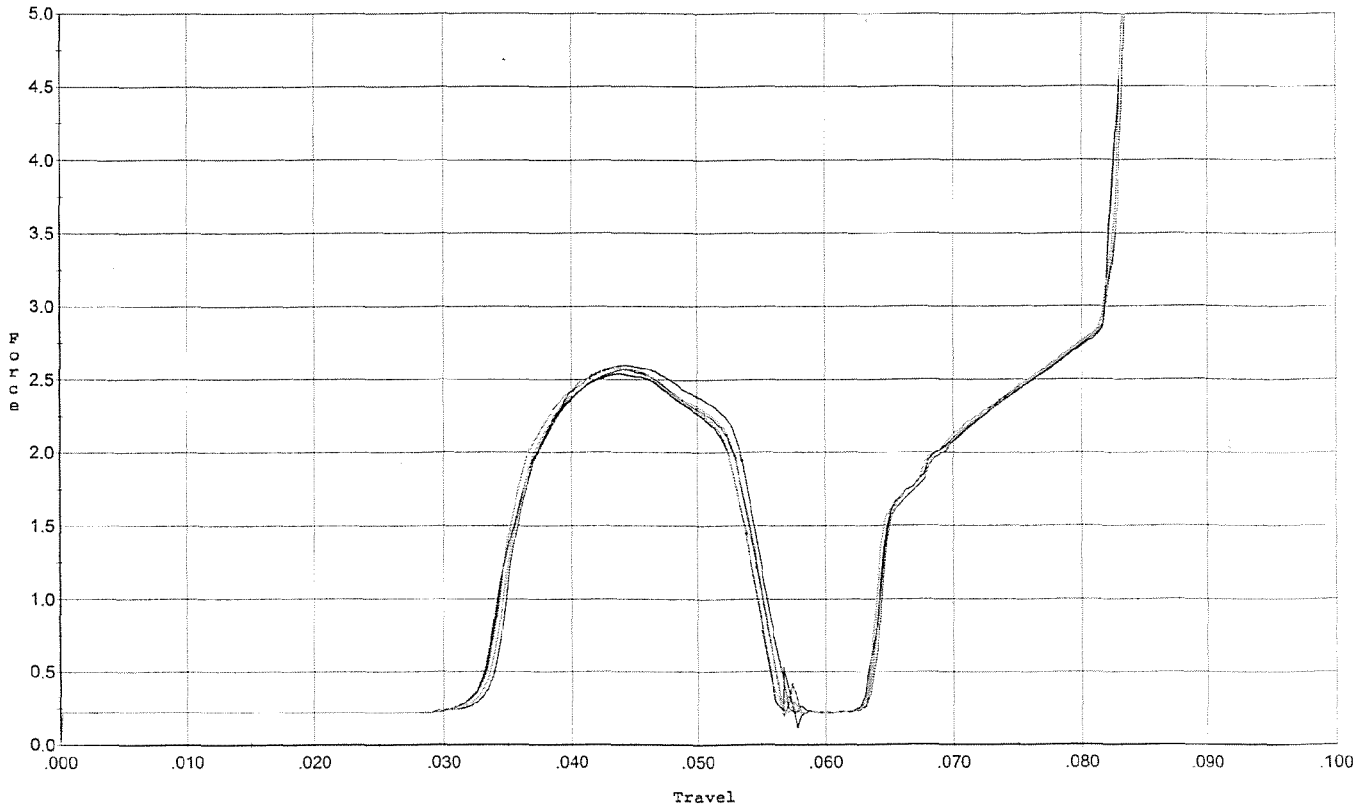
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>5</u> <u>5.5</u>	7/16/08	Fm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>4.5</u>	7/16/08	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	7/16/08	Fm
	J) ASSEMBLE STOCK		7/3/08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		8-7-08	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-7-08	L.P.D.
	M) IRON SIGHT ALIGNMENT		8-7-08	L.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	7/16/08	MED
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-10-08	TKW
670	FINAL INSPECTION A) HEADSPACE		8-7-08	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.46</u> <u>2.42</u> <u>2.38</u> <u>2.46</u>	7/10/08	Fm
	C) FUNCTION		8-7-08	L.P.D.
690	PACK		8/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/18/08

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



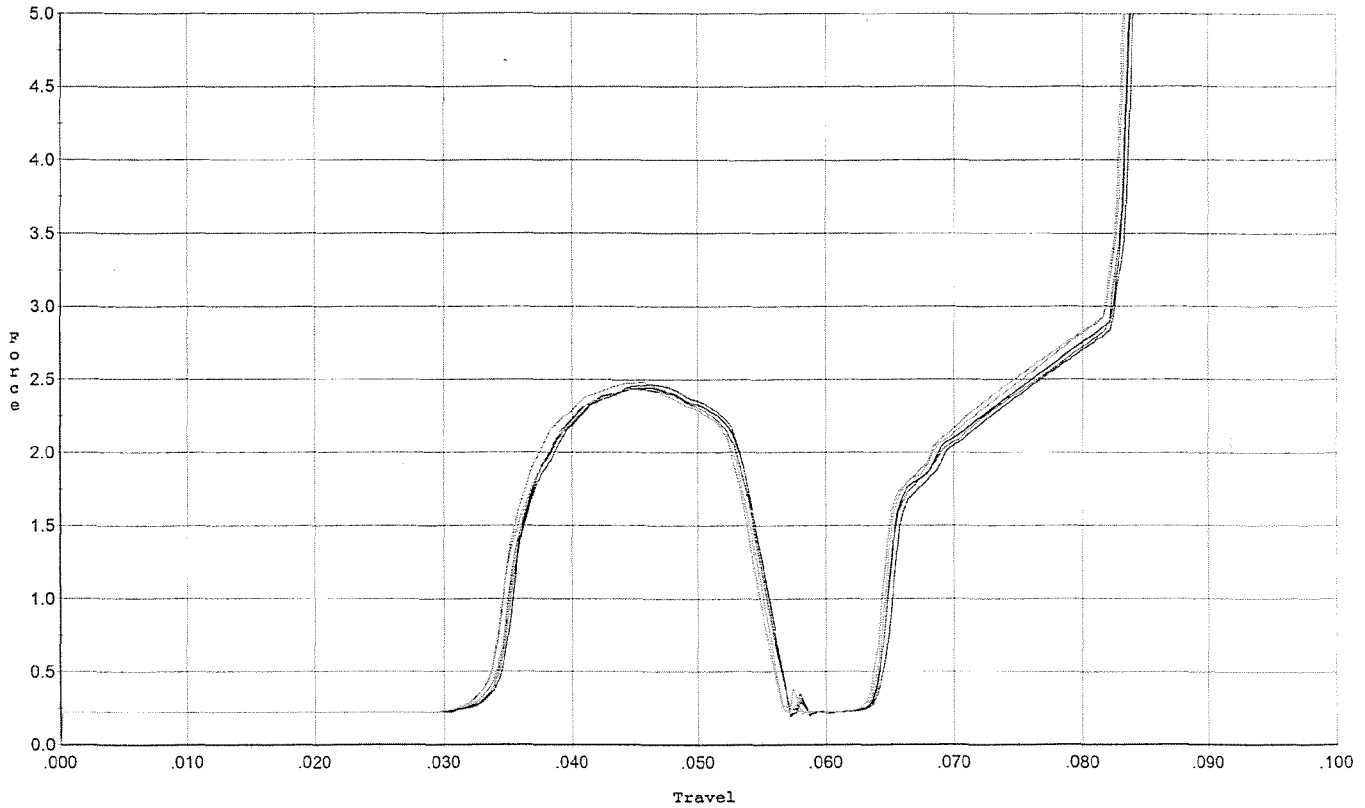
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.596	0.054	0.033	0.035	0.052		Set Trigger
2	2.539	0.054	0.033	0.035	0.051		Set Trigger
3	2.566	0.055	0.033	0.035	0.053		Set Trigger
4	2.577	0.054	0.033	0.035	0.052		Set Trigger
5	2.587	0.054	0.033	0.035	0.052		Set Trigger

AVG 2.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/18/08

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



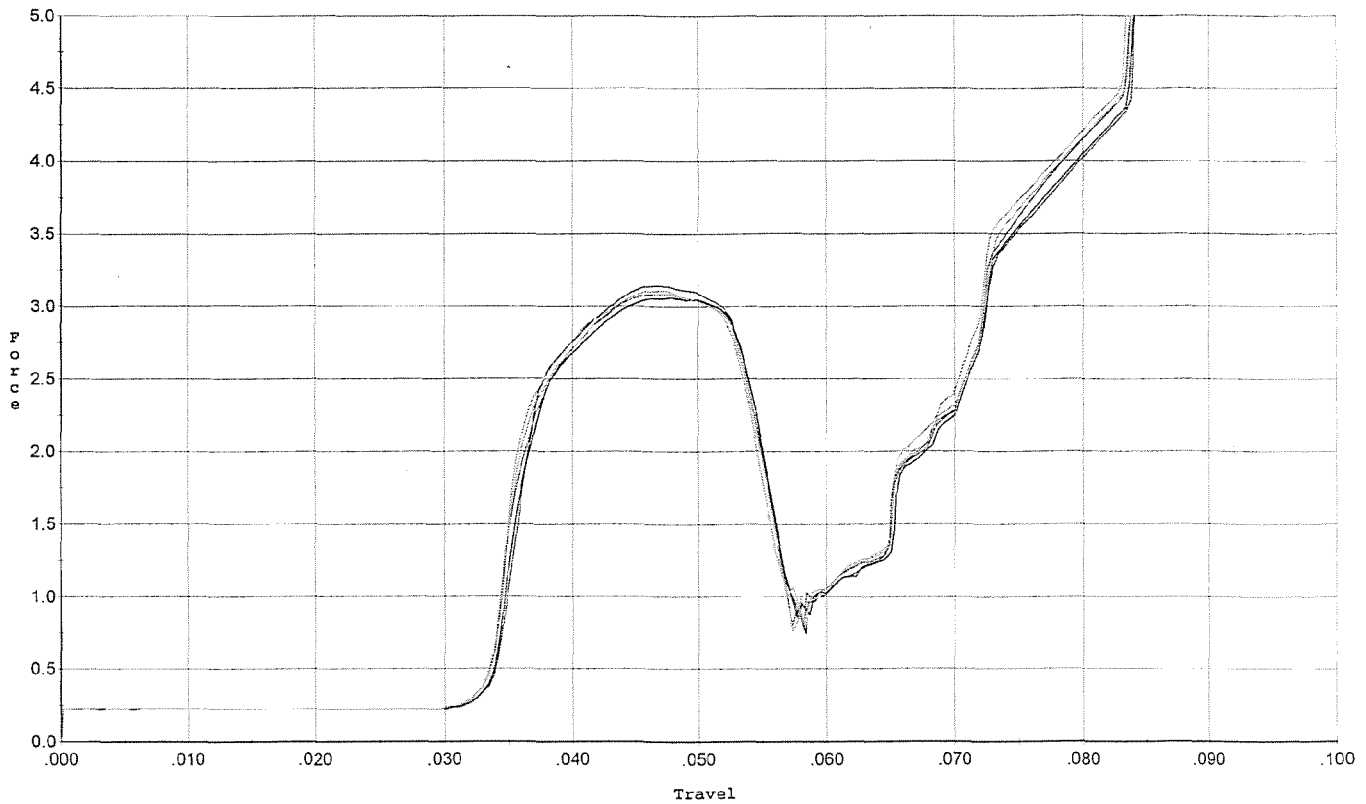
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.435	0.054	0.034	0.036	0.049		Set Trigger
2	2.444	0.055	0.034	0.035	0.051		Set Trigger
3	2.464	0.055	0.034	0.035	0.052		Set Trigger
4	2.430	0.055	0.033	0.035	0.051		Set Trigger
5	2.475	0.053	0.034	0.035	0.050		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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



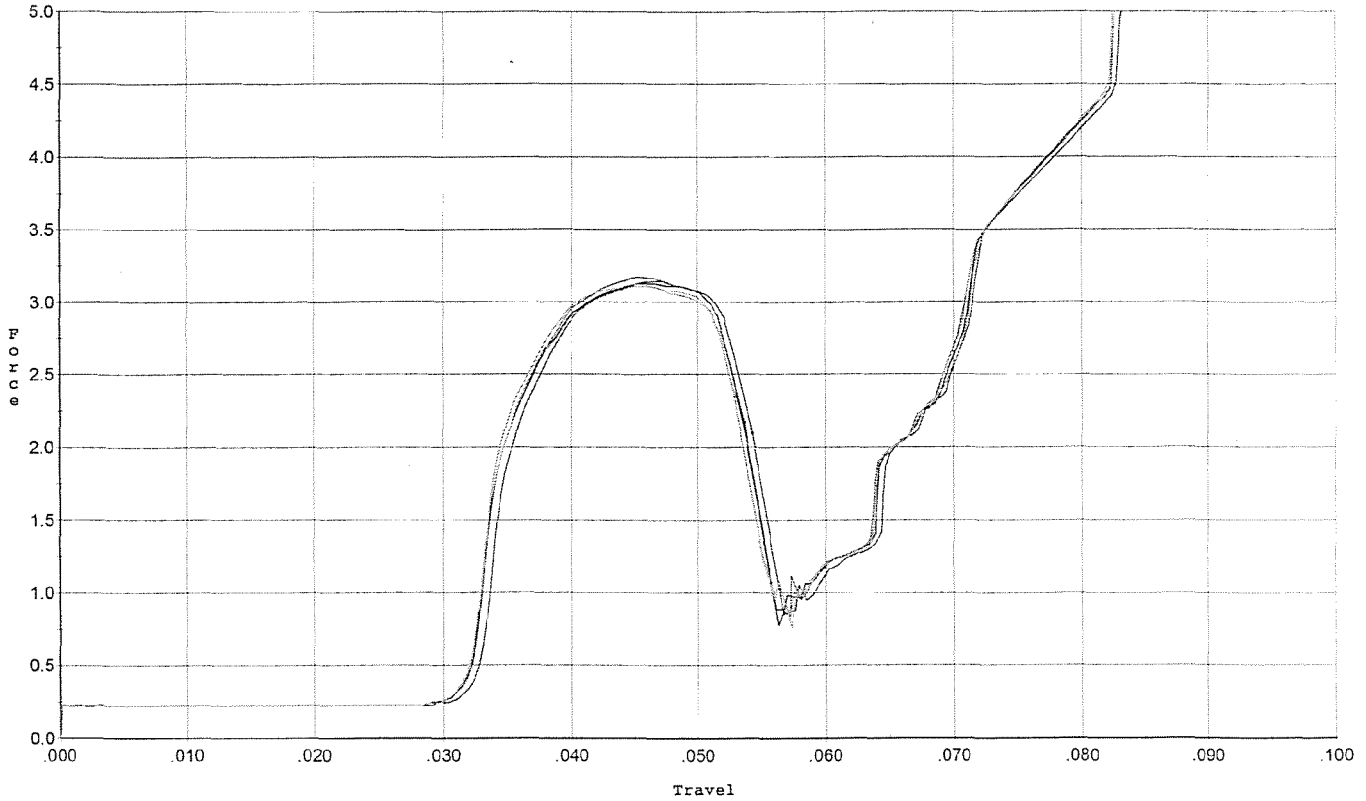
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.139	0.055	0.034	0.035	0.064		Set Trigger
2	3.060	0.055	0.034	0.035	0.063		Set Trigger
3	3.082	0.055	0.033	0.034	0.064		Set Trigger
4	3.082	0.055	0.033	0.034	0.064		Set Trigger
5	3.104	0.054	0.033	0.034	0.063		Set Trigger

AVG 3.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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



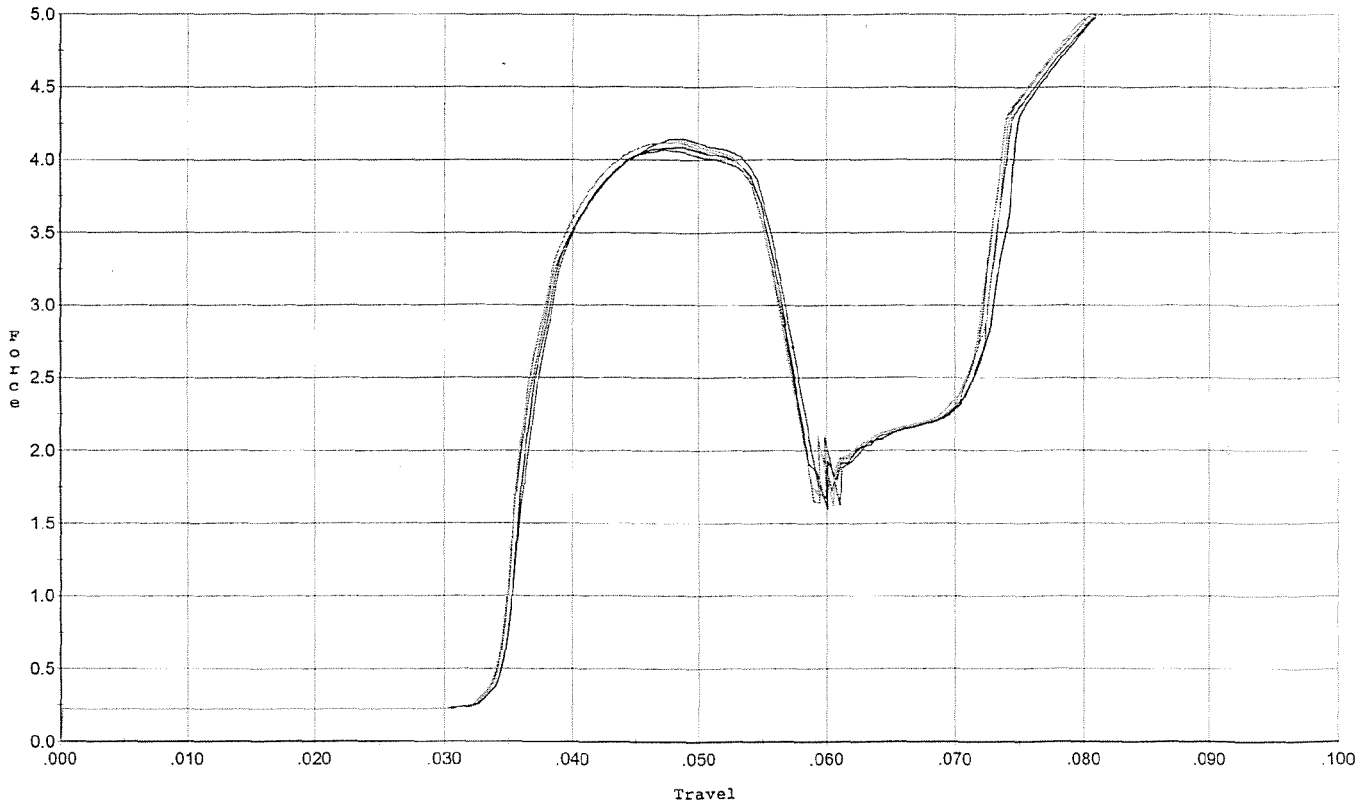
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.144	0.054	0.032	0.034	0.065		Set Trigger
2	3.125	0.054	0.032	0.033	0.065		Set Trigger
3	3.170	0.054	0.032	0.033	0.066		Set Trigger
4	3.104	0.053	0.032	0.034	0.064		Set Trigger
5	3.120	0.053	0.032	0.033	0.064		Set Trigger

AVG 3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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



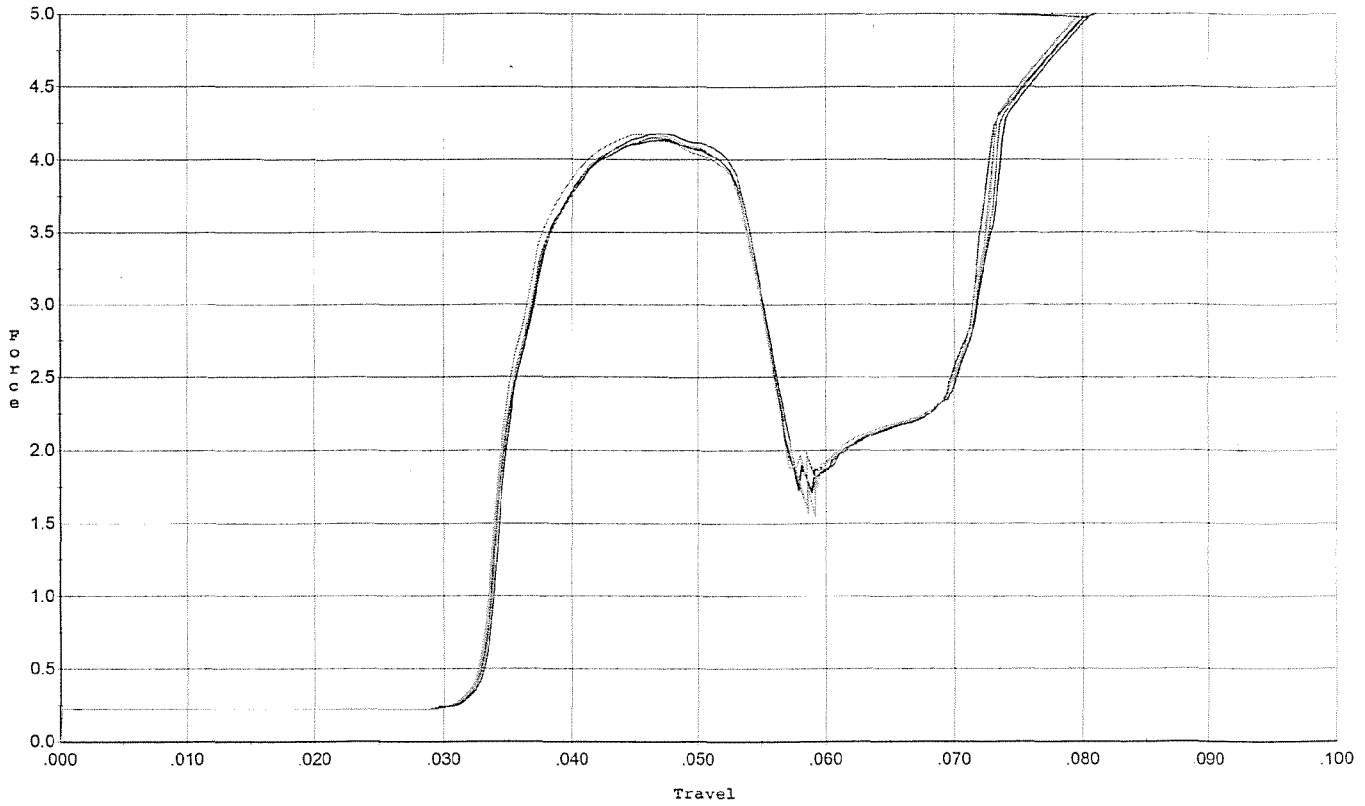
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.144	0.057	0.034	0.033	0.088		Set Trigger
2	4.084	0.056	0.034	0.033	0.085		Set Trigger
3	4.069	0.057	0.034	0.033	0.086		Set Trigger
4	4.128	0.057	0.034	0.033	0.088		Set Trigger
5	4.116	0.055	0.034	0.033	0.085		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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



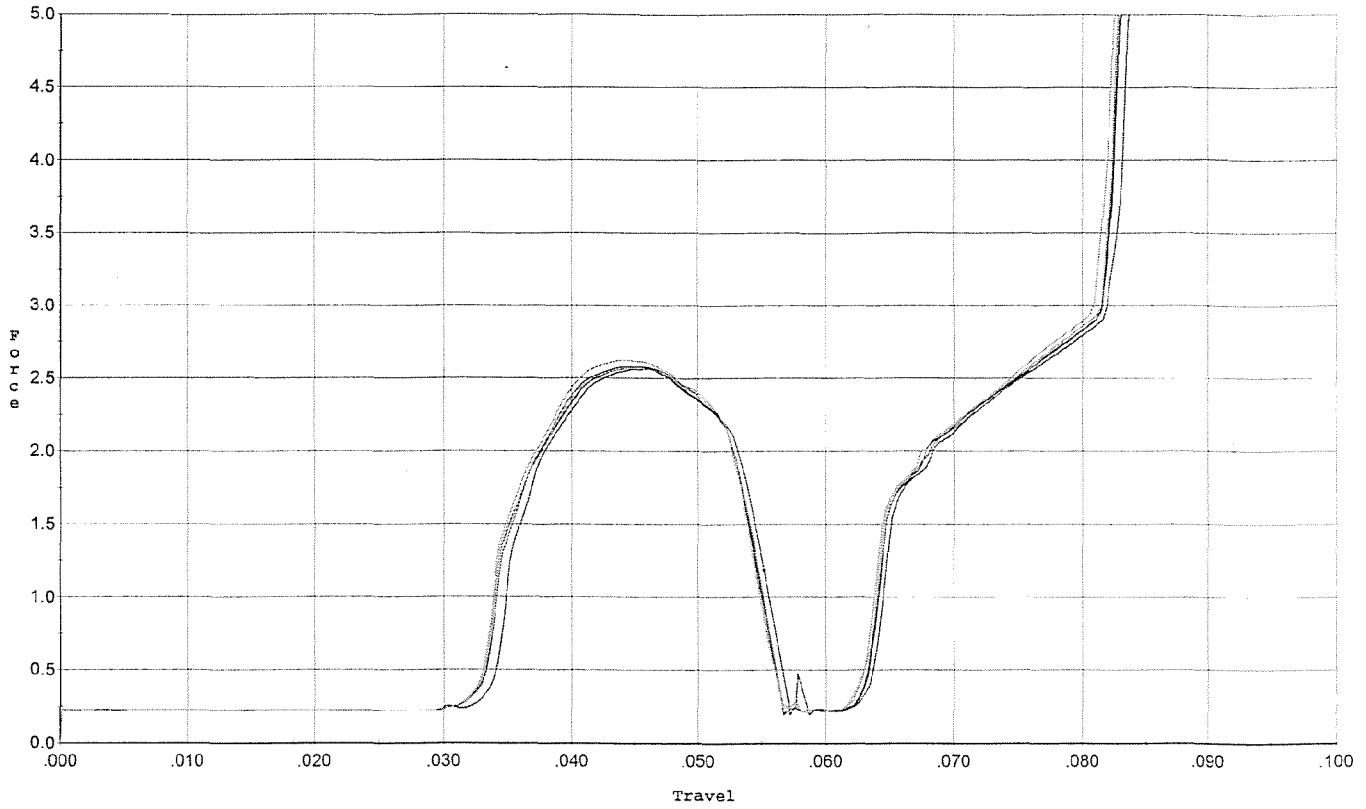
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.178	0.054	0.032	0.033	0.085		Set Trigger
2	4.135	0.055	0.033	0.033	0.085		Set Trigger
3	4.150	0.055	0.033	0.033	0.086		Set Trigger
4	4.173	0.055	0.032	0.033	0.087		Set Trigger
5	4.131	0.054	0.033	0.033	0.085		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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



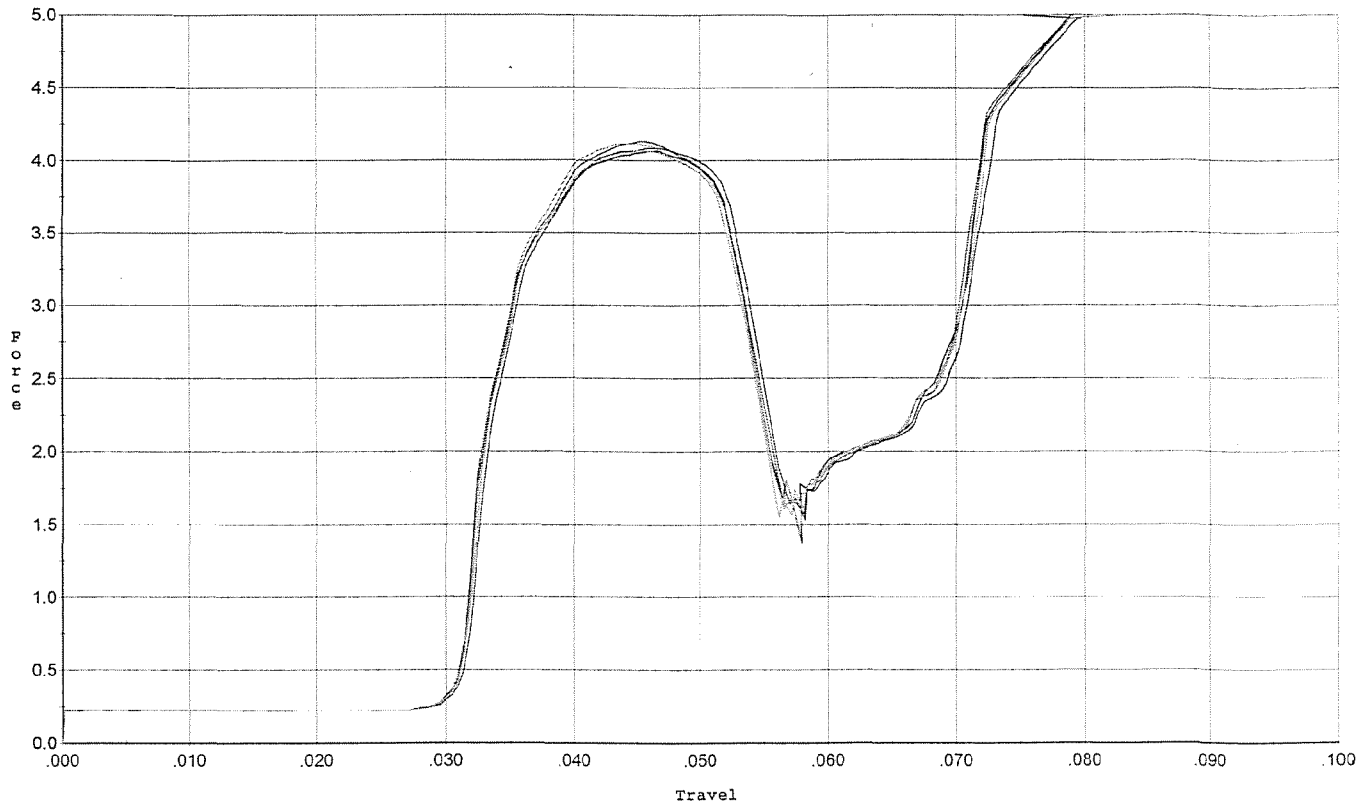
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.560	0.055	0.034	0.035	0.053		Set Trigger
2	2.569	0.055	0.033	0.034	0.053		Set Trigger
3	2.579	0.055	0.033	0.034	0.054		Set Trigger
4	2.569	0.054	0.033	0.034	0.053		Set Trigger
5	2.626	0.053	0.033	0.034	0.053		Set Trigger

AVG 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/18/08

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	4.085	0.054	0.031	0.032	0.086		Set Trigger
2	4.066	0.053	0.031	0.032	0.085		Set Trigger
3	4.134	0.053	0.031	0.032	0.085		Set Trigger
4	4.119	0.054	0.031	0.032	0.086		Set Trigger
5	4.071	0.053	0.031	0.032	0.084		Set Trigger

Avg 4.09