

64764999



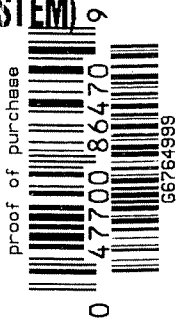
No 153L

UPC 10330

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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

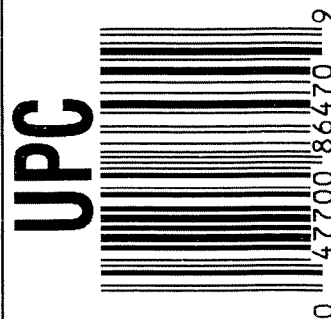


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6764999



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 676 4999

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-15-08	LSN
430	ASSEMBLE TO STOCK		7-15-08	JP
440	PROOF		7-15-08	L.P.D.
460	CHECK HEADSPACE		7-15-08	L.P.D.
470	DIS-ASSEMBLE ACTION	MAGNA - FLUX JUL 25 2008 OPERATOR <u>RT</u>	7-16-08	RT
472	SERIALIZE BOLT HANDLE		7-16-08	RT
475	DRILL AND TAP SIGHT HOLES		7-19-08	JP
480	MAGNAFLUX BBL ACTION		7/25/08	BM
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7/25/08	RT
520	GOFF BLAST BBL / REC		7/28/08	DG
542	APPLY COATINGS (BARREL ACTION)		7-31	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-4-08	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-1-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-4-08	JP
	D) OIL FIRING PIN ASSEMBLY		8-5-08	LSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

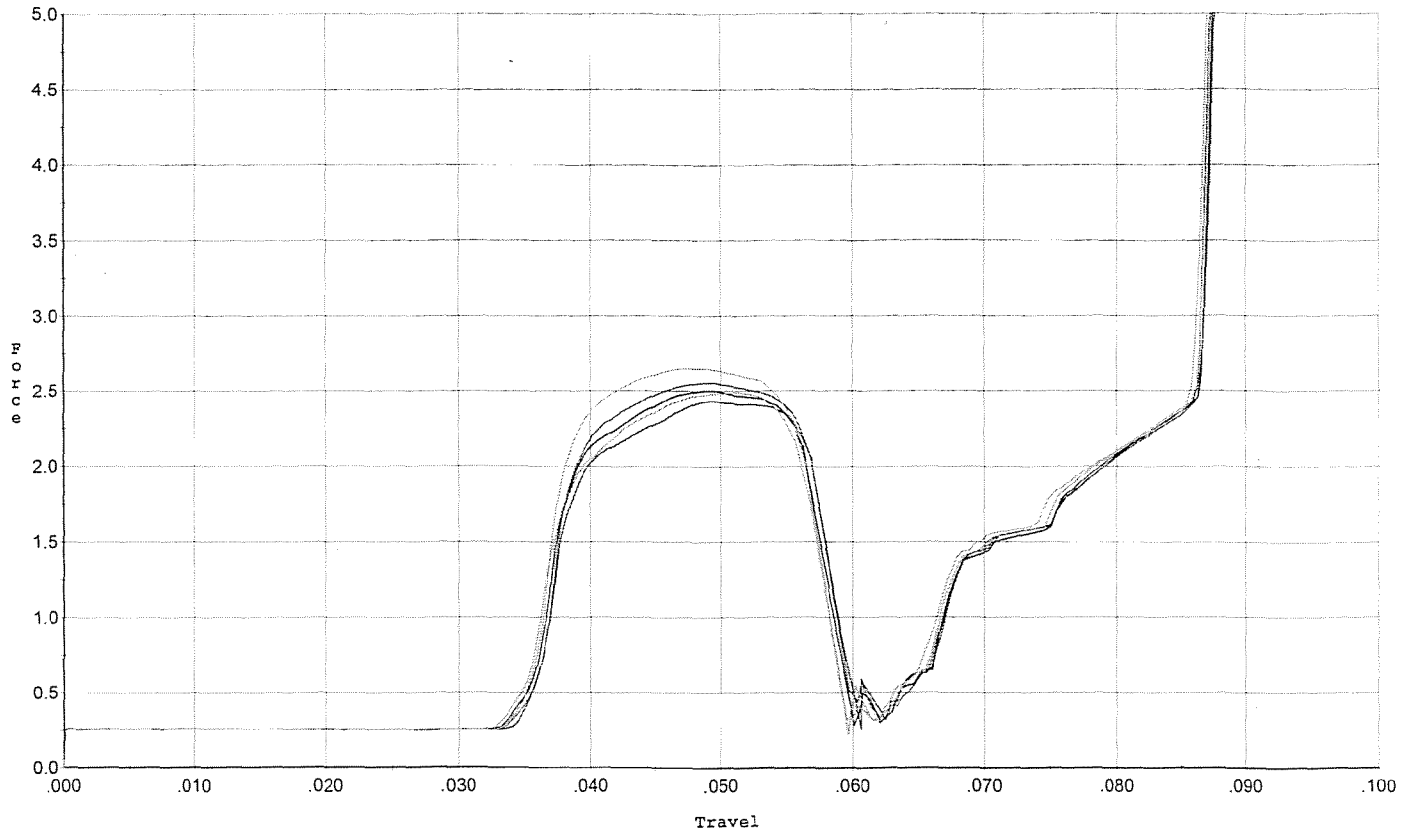
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4 LBS</u> <u>4 LBS</u> <u>4 LBS</u>	8-13-08	SPD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 1/2 LBS</u> <u>2 1/2 LBS</u> <u>2 1/2 LBS</u>	8-13-08	SPD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.020</u> <u>.020</u> <u>.020</u>	8-13-08	SPD
	J) ASSEMBLE STOCK		8-5-08	RSN
	K) ASSEMBLE SWIVEL STUDS		8-13-08	SPD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-13-08	SPD
	M) IRON SIGHT ALIGNMENT		8-13-08	SPD
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-13-08	SPD
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-6-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-6-08	TL
670	FINAL INSPECTION A) HEADSPACE		8-13-08	SPD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.12</u> <u>2.39</u> <u>2.13</u> <u>2.17</u> <u>2.12</u>	8-7-08	TRW
	C) FUNCTION		8-13-08	SPD
690	PACK		8-22-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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



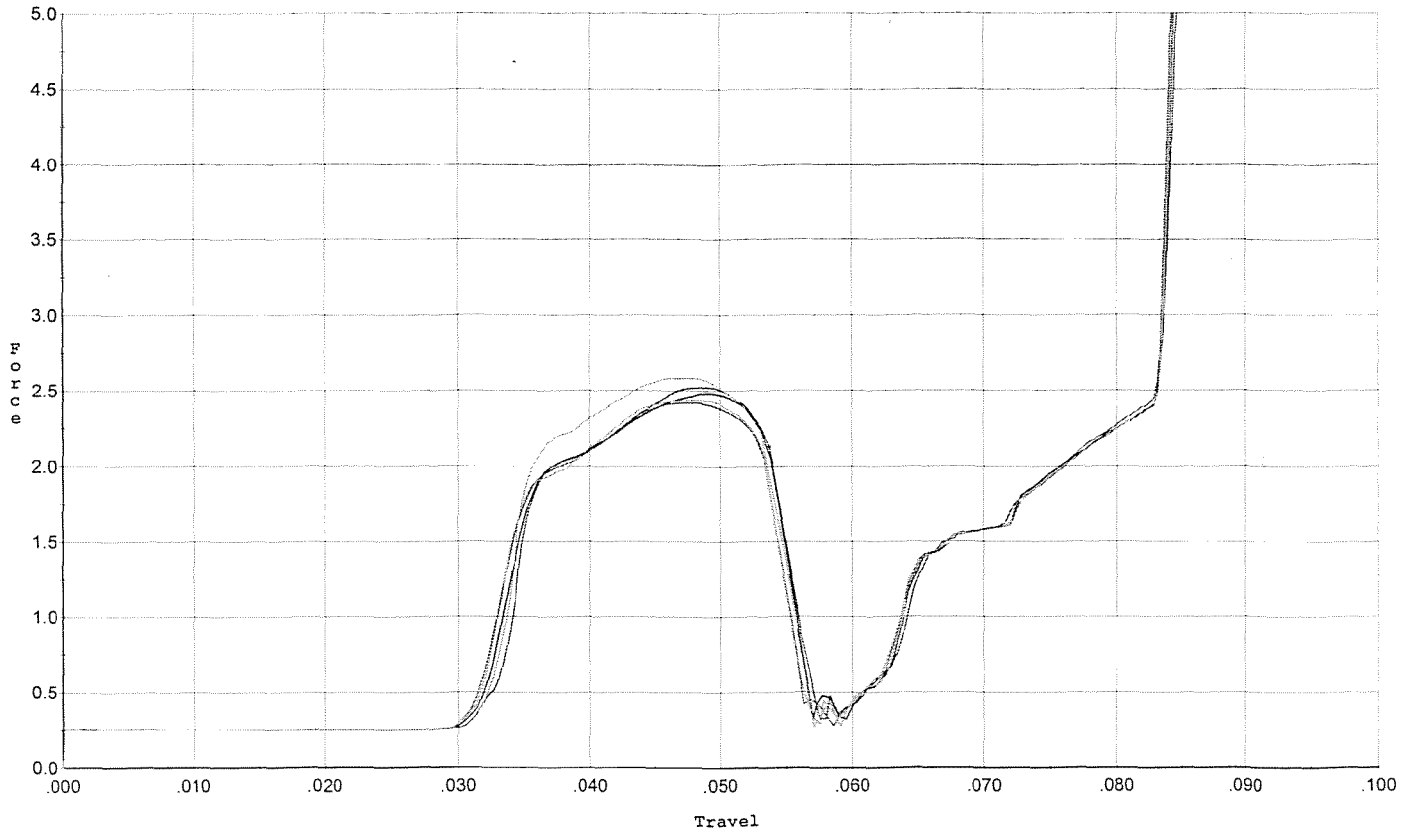
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.434	0.057	0.035	0.036	0.055		Set Trigger
2	2.502	0.056	0.034	0.036	0.056		Set Trigger
3	2.552	0.057	0.035	0.036	0.058		Set Trigger
4	2.648	0.056	0.035	0.036	0.059		Set Trigger
5	2.488	0.057	0.034	0.036	0.056		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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



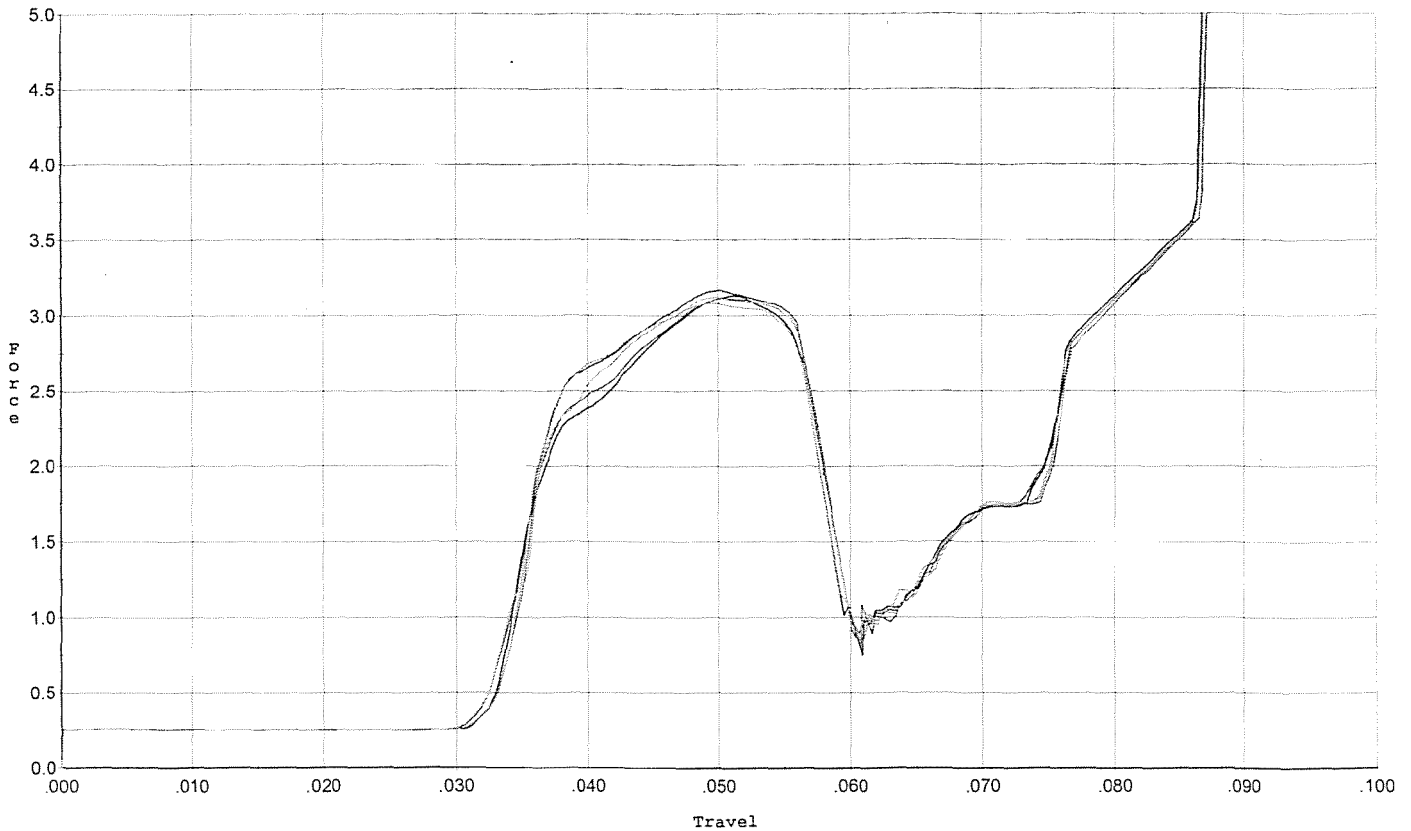
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.522	0.054	0.032	0.035	0.054		Set Trigger
2	2.482	0.054	0.032	0.035	0.055		Set Trigger
3	2.420	0.053	0.031	0.035	0.054		Set Trigger
4	2.442	0.053	0.031	0.035	0.054		Set Trigger
5	2.582	0.055	0.032	0.035	0.057		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/23/08

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



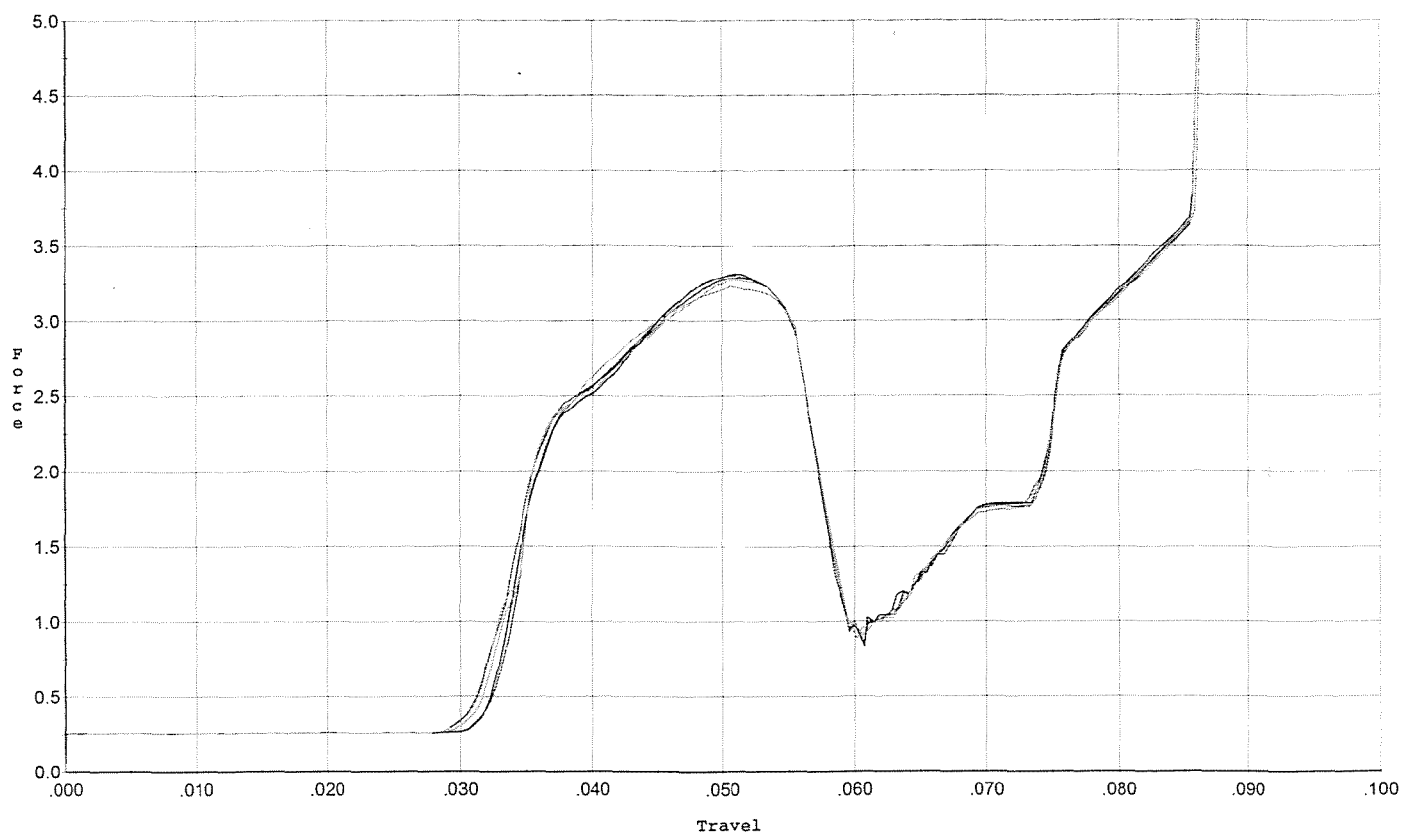
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.166	0.058	0.032	0.034	0.074		Set Trigger
2	3.131	0.056	0.033	0.034	0.069		Set Trigger
3	3.113	0.058	0.033	0.035	0.072		Set Trigger
4	3.122	0.058	0.032	0.034	0.073		Set Trigger
5	3.080	0.056	0.033	0.034	0.071		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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



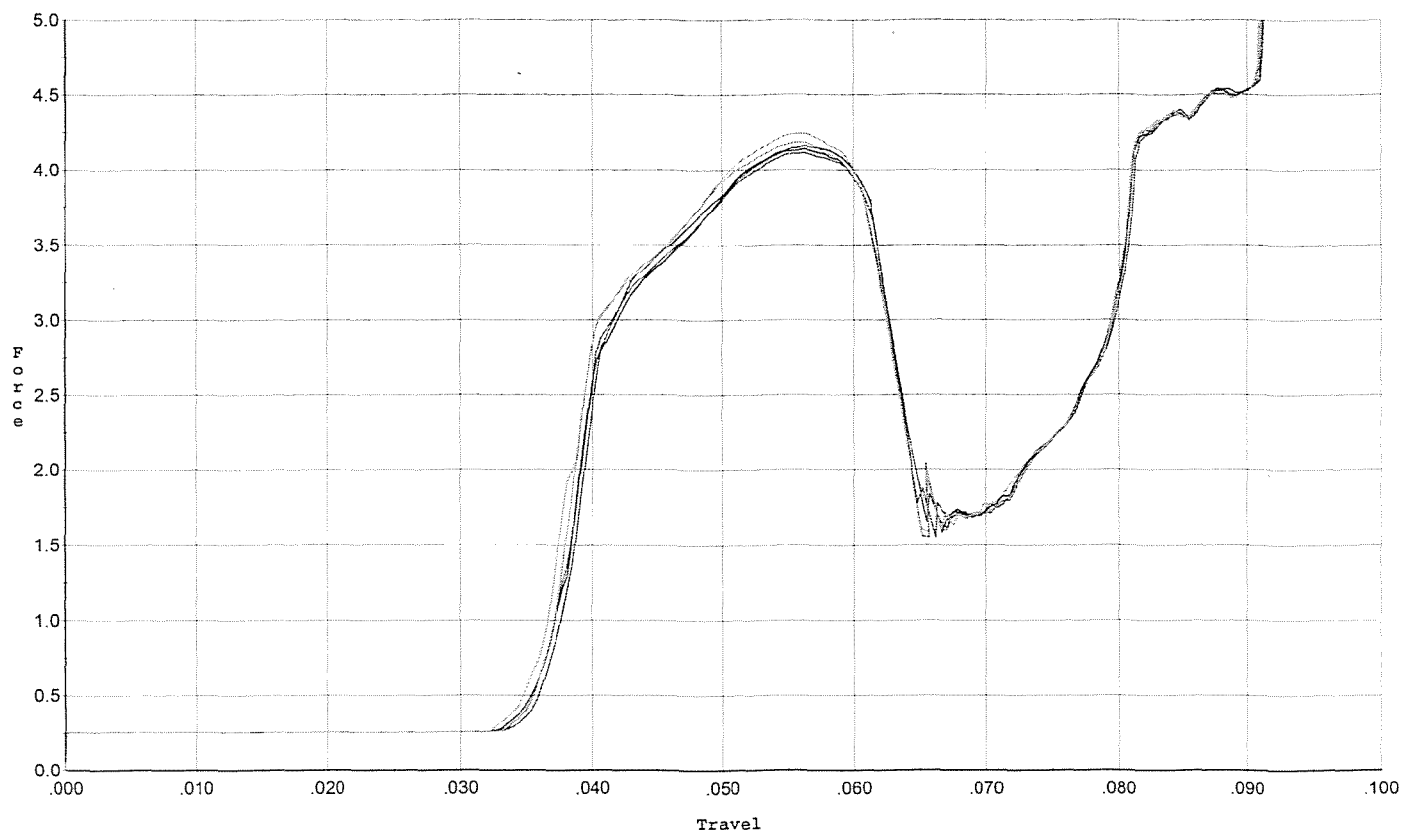
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.285	0.056	0.032	0.034	0.071		Set Trigger
2	3.312	0.056	0.032	0.034	0.072		Set Trigger
3	3.301	0.056	0.031	0.034	0.073		Set Trigger
4	3.273	0.055	0.031	0.034	0.072		Set Trigger
5	3.231	0.056	0.031	0.034	0.072		Set Trigger

Avg 3.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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	4.155	0.061	0.036	0.034	0.097		Set Trigger
2	4.135	0.062	0.035	0.033	0.098		Set Trigger
3	4.114	0.061	0.035	0.034	0.097		Set Trigger
4	4.183	0.062	0.035	0.033	0.101		Set Trigger
5	4.241	0.062	0.035	0.033	0.100		Set Trigger

Avg 4.16

Trigger Scan 2.01 ,SN 10337, printed by Remington Arms Co., Inc. 7/23/2008 4:16:04 PM

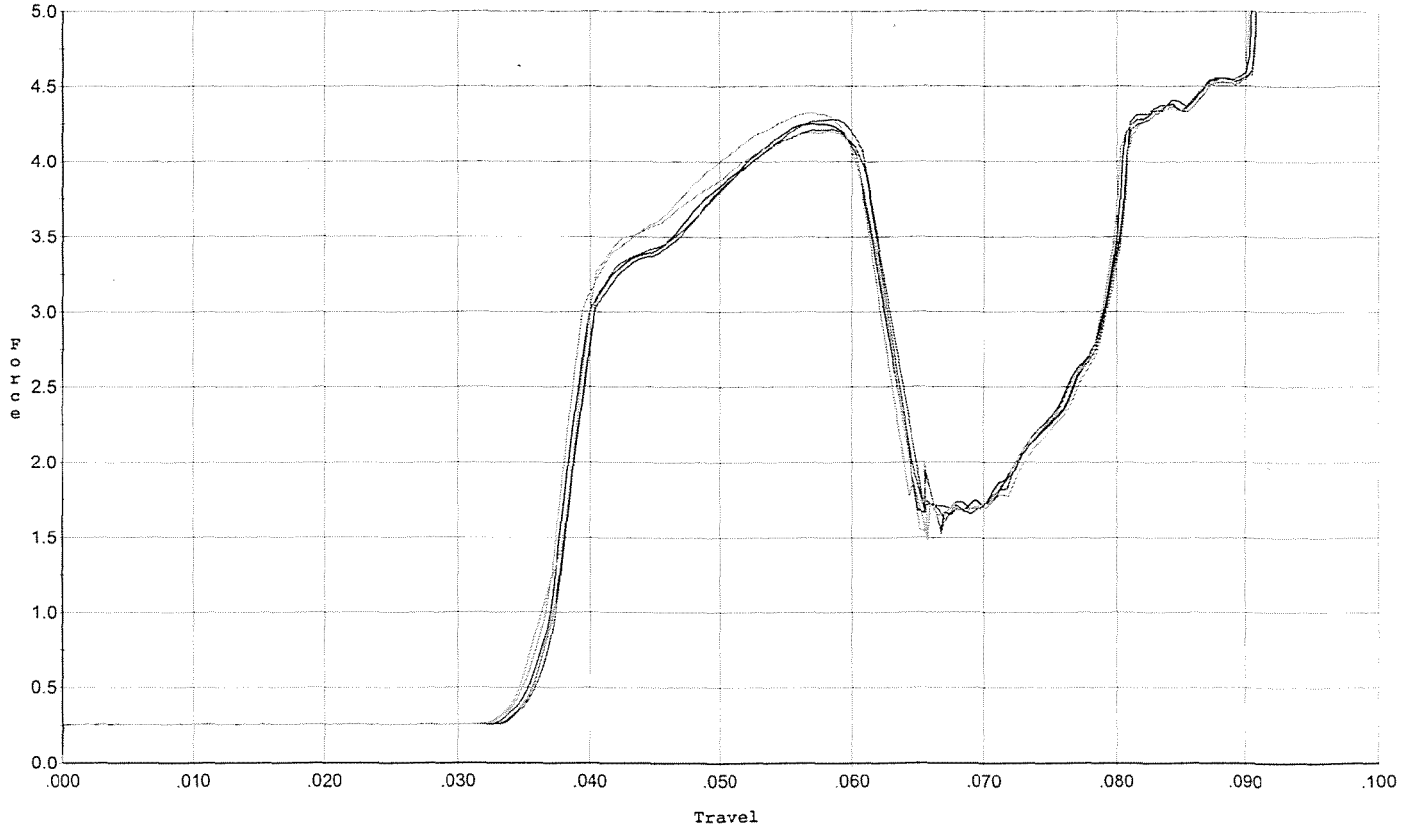
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400129681

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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



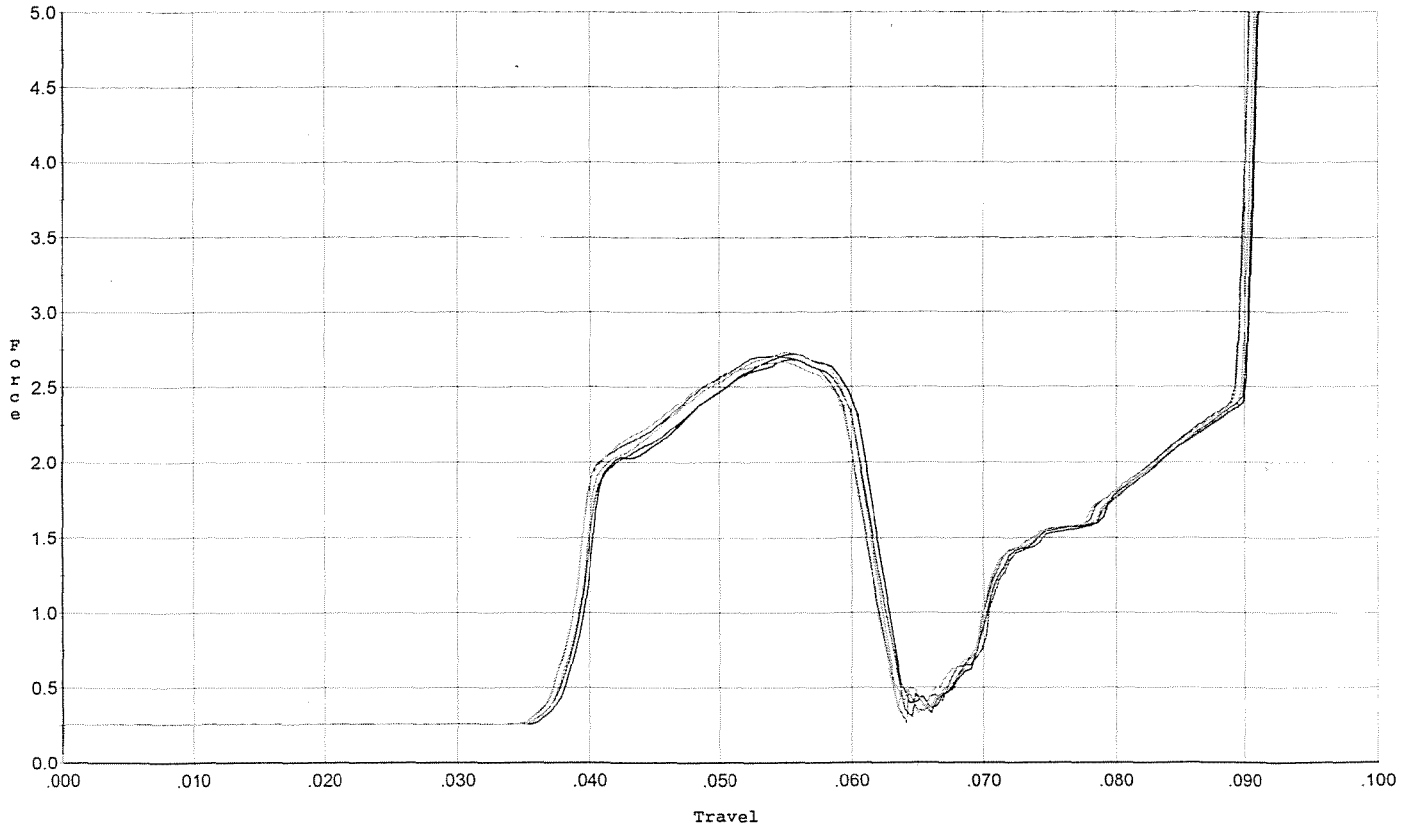
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.215	0.061	0.036	0.033	0.098		Set Trigger
2	4.251	0.062	0.035	0.033	0.101		Set Trigger
3	4.280	0.061	0.035	0.033	0.098		Set Trigger
4	4.199	0.062	0.034	0.033	0.102		Set Trigger
5	4.320	0.061	0.035	0.033	0.101		Set Trigger

AVG 4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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	2.681	0.060	0.037	0.036	0.060		Set Trigger
2	2.717	0.060	0.038	0.037	0.061		Set Trigger
3	2.707	0.059	0.037	0.036	0.061		Set Trigger
4	2.666	0.059	0.037	0.036	0.061		Set Trigger
5	2.727	0.060	0.037	0.036	0.061		Set Trigger

Avg 2.70

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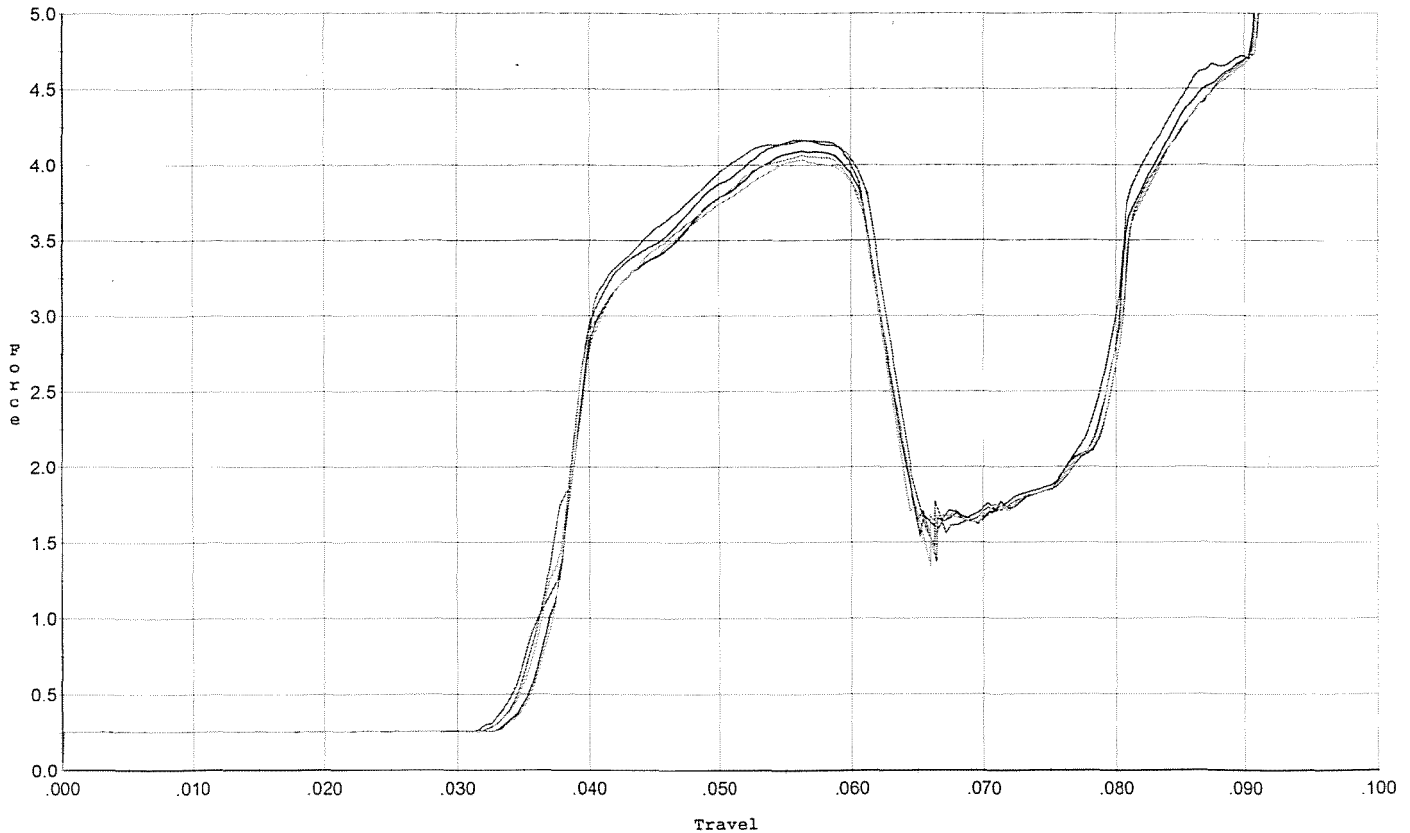
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400129683

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/23/08

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	4.164	0.061	0.034	0.033	0.098		Set Trigger
2	4.091	0.061	0.035	0.034	0.095		Set Trigger
3	4.160	0.061	0.034	0.033	0.101		Set Trigger
4	4.034	0.061	0.035	0.034	0.095		Set Trigger
5	4.064	0.061	0.035	0.033	0.097		Set Trigger

AVG 4.10