

G6810418

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



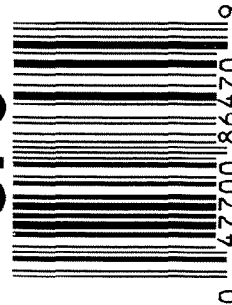
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810418

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6810418

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-9-09	SPD
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		2-9-09	SPD
460	CHECK HEADSPACE		2-9-09	SPD
470	DIS-ASSEMBLE ACTION		2-9-09	SPD
472	SERIALIZE BOLT HANDLE		2-9-09	RT
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	2/13/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		2/14/09	RT
520	GOFF BLAST BBL / REC		16 Feb 09	SPD
542	APPLY COATINGS (BARREL ACTION)		2/27	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-4-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

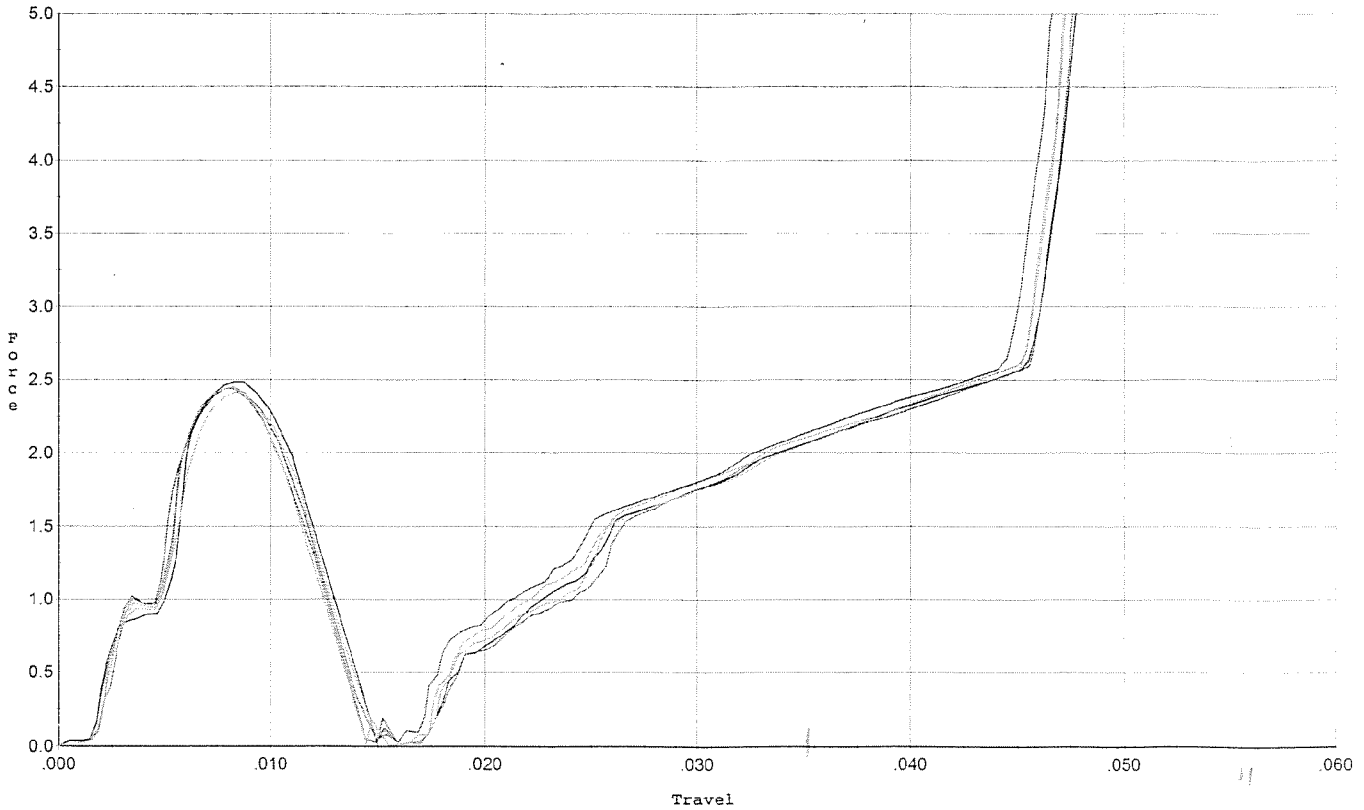
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-12-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-12-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	3-12-09	WV
	J) ASSEMBLE STOCK		3-4-09	WV
	K) ASSEMBLE SWIVEL STUDS		3-12-09	WV
	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	3-5-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-5-09	BP
670	FINAL INSPECTION A) HEADSPACE		3-12-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u> <u>2.24</u> <u>2.22</u> <u>2.24</u> <u>2.22</u>	3-6-09	WV
	C) FUNCTION		3-12-09	WV
690	PACK		4/10/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



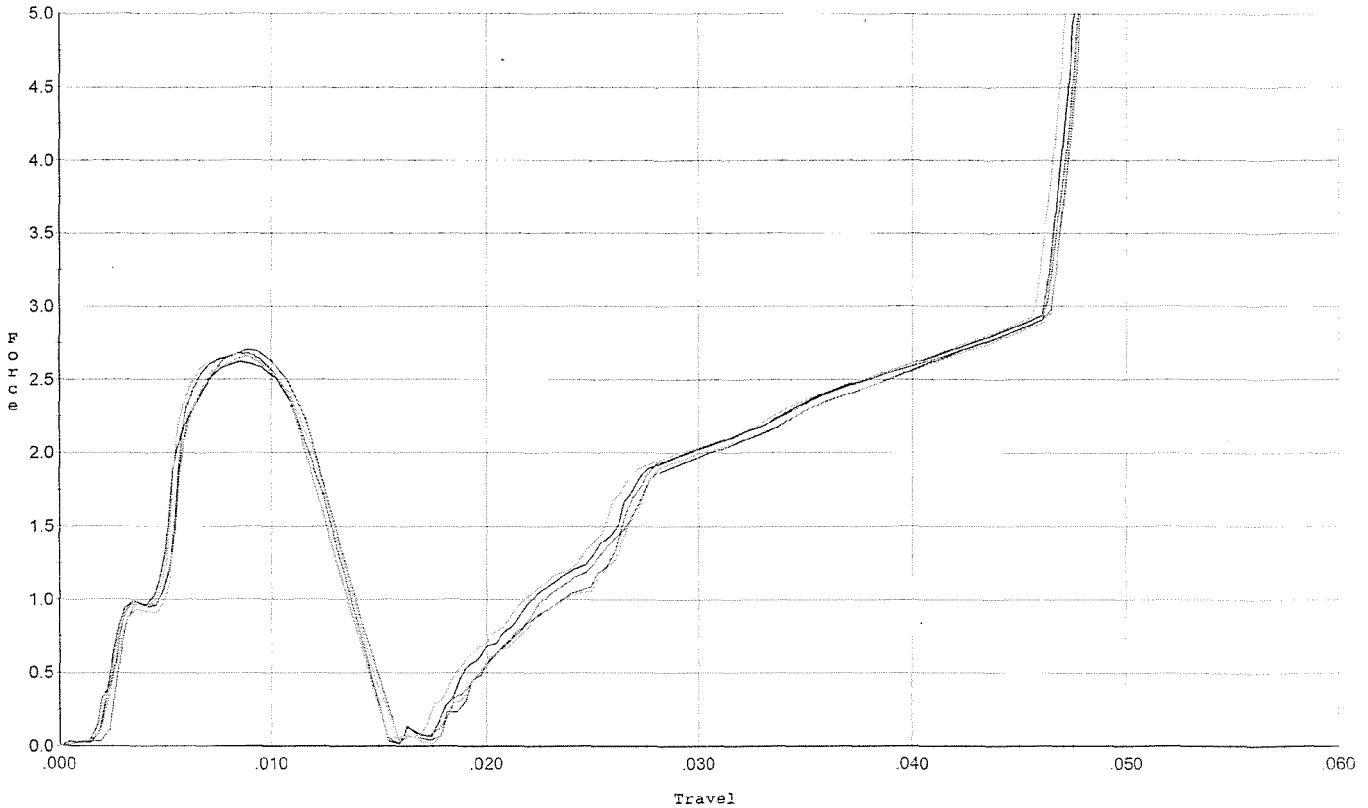
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.012	0.00	0.039	0.016		Set Trigger
2	2.482	0.013	0.00	0.040	0.017		Set Trigger
3	2.434	0.012	0.005	0.040	0.016		Set Trigger
4	2.413	0.011	0.002	0.039	0.015		Set Trigger
5	2.442	0.012	0.002	0.039	0.016		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



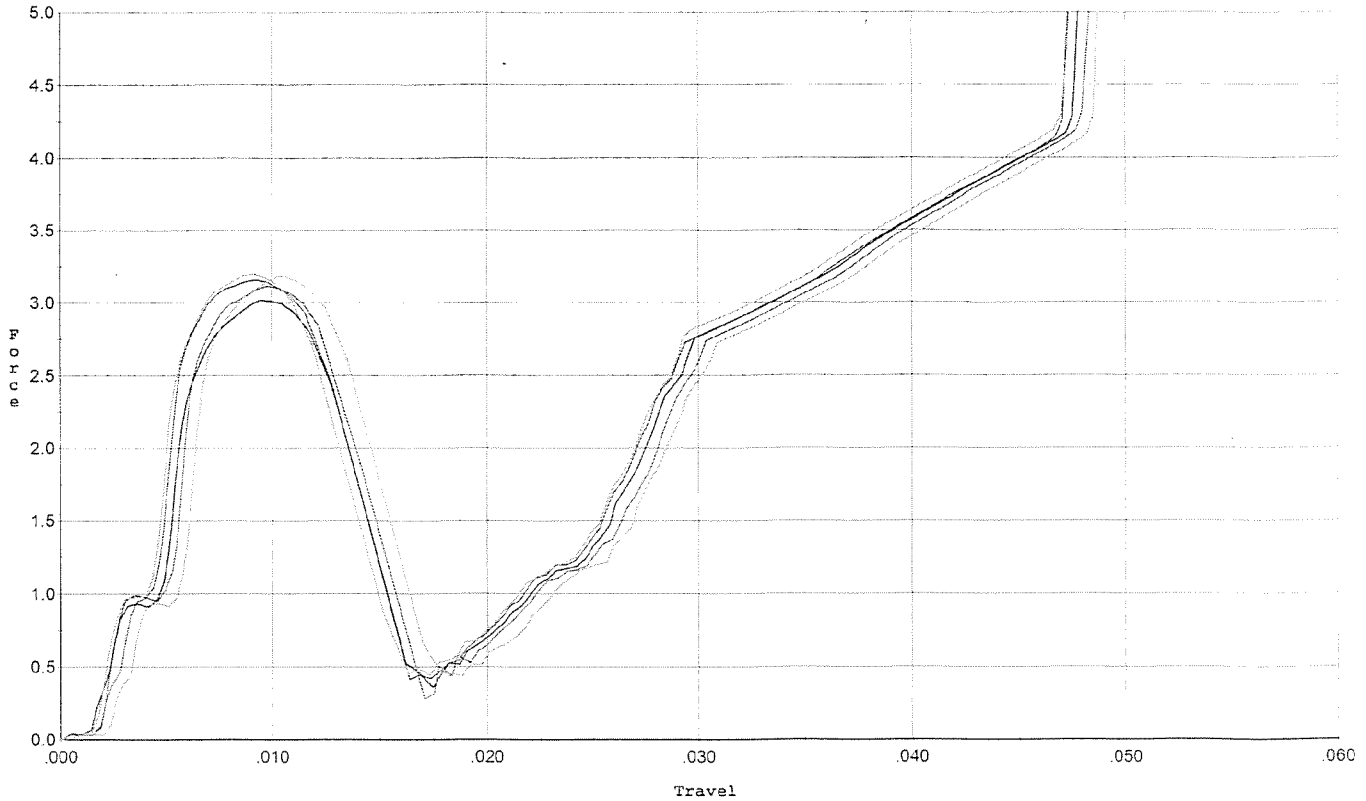
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.682	0.012	0.00	0.039	0.019		Set Trigger
2	2.623	0.011	0.00	0.039	0.016		Set Trigger
3	2.704	0.012	0.002	0.039	0.017		Set Trigger
4	2.656	0.012	0.005	0.039	0.018		Set Trigger
5	2.677	0.011	0.00	0.039	0.017		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



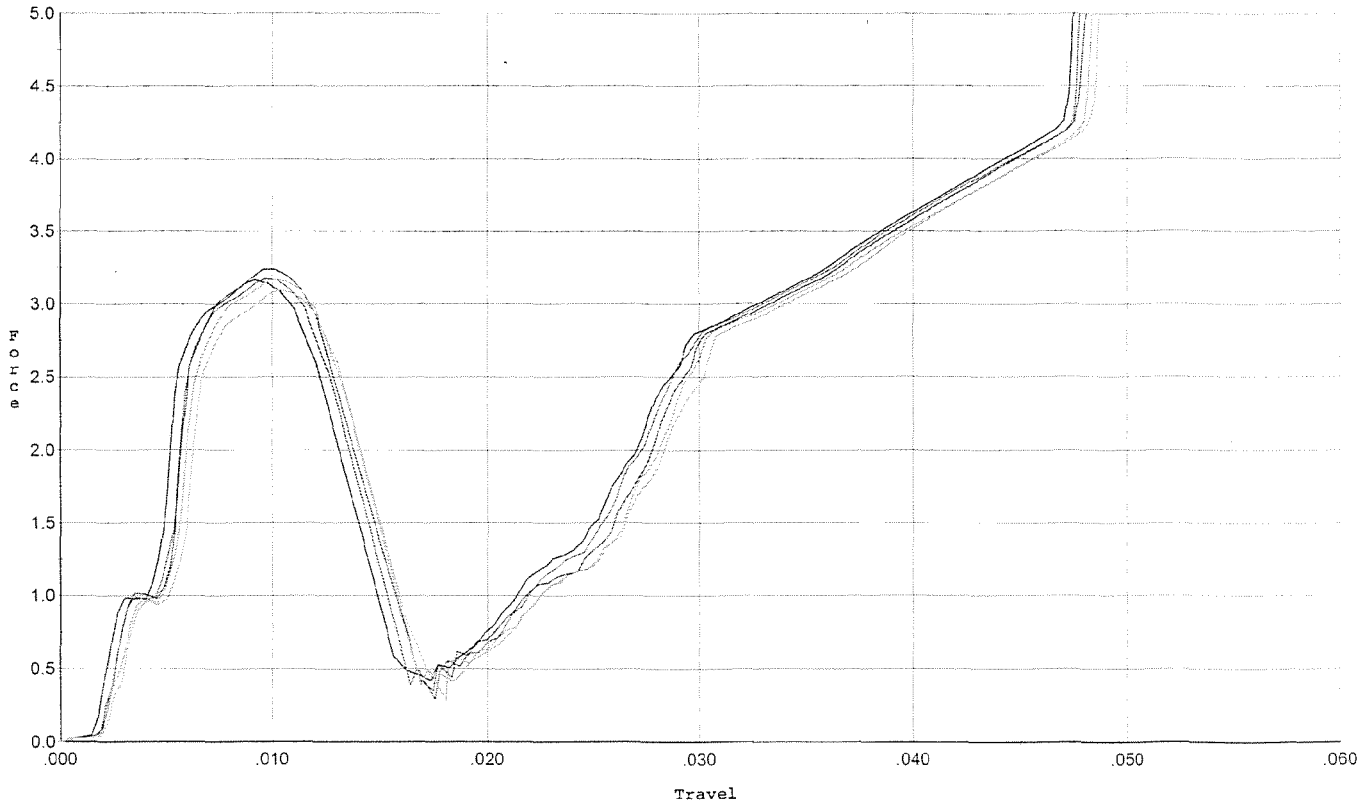
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.155	0.013	0.00	0.036	0.024		Set Trigger
2	3.014	0.013	0.00	0.036	0.022		Set Trigger
3	3.112	0.014	0.002	0.036	0.025		Set Trigger
4	3.182	0.014	0.002	0.036	0.023		Set Trigger
5	3.196	0.012	0.002	0.036	0.022		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



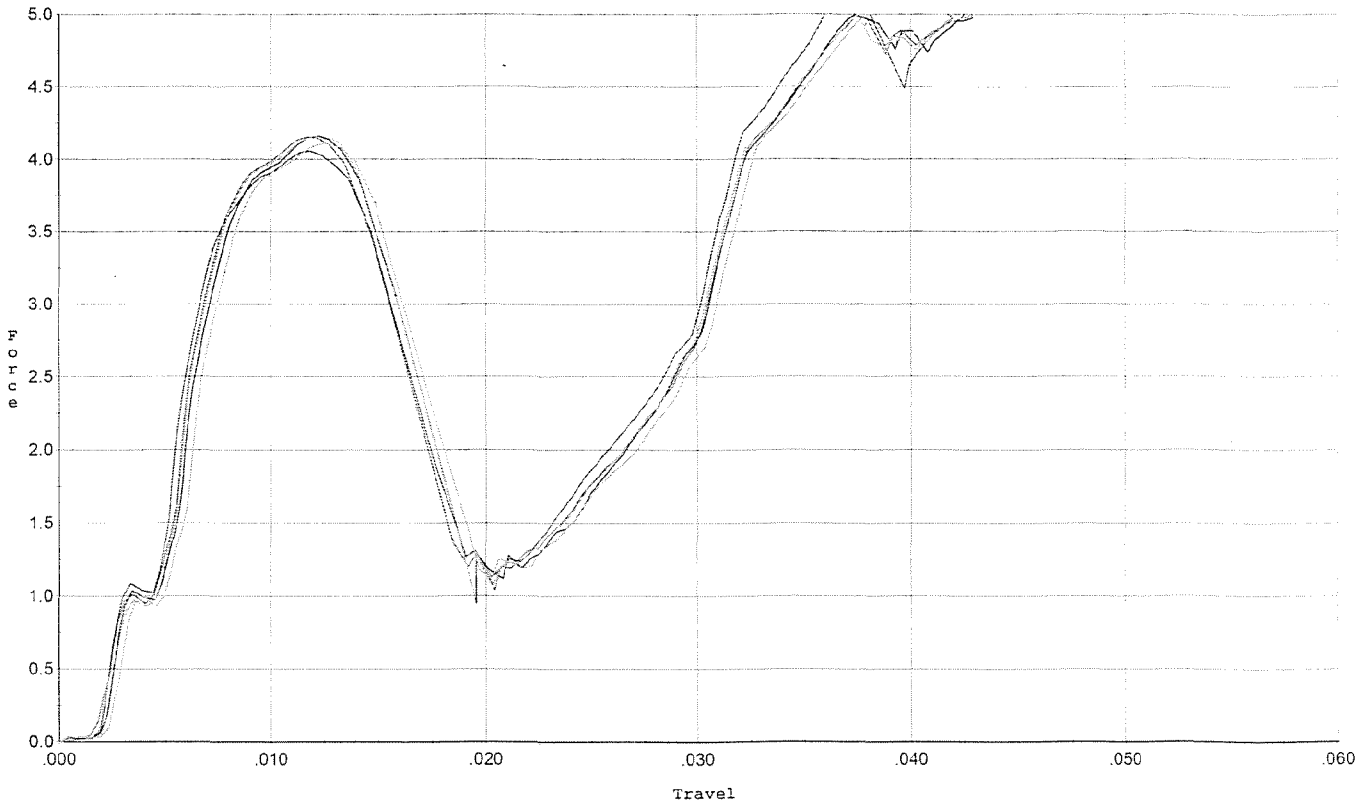
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.237	0.012	0.005	0.037	0.022		Set Trigger
2	3.164	0.012	0.004	0.036	0.022		Set Trigger
3	3.172	0.013	0.00	0.036	0.023		Set Trigger
4	3.094	0.013	0.00	0.037	0.022		Set Trigger
5	3.165	0.013	0.002	0.036	0.024		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



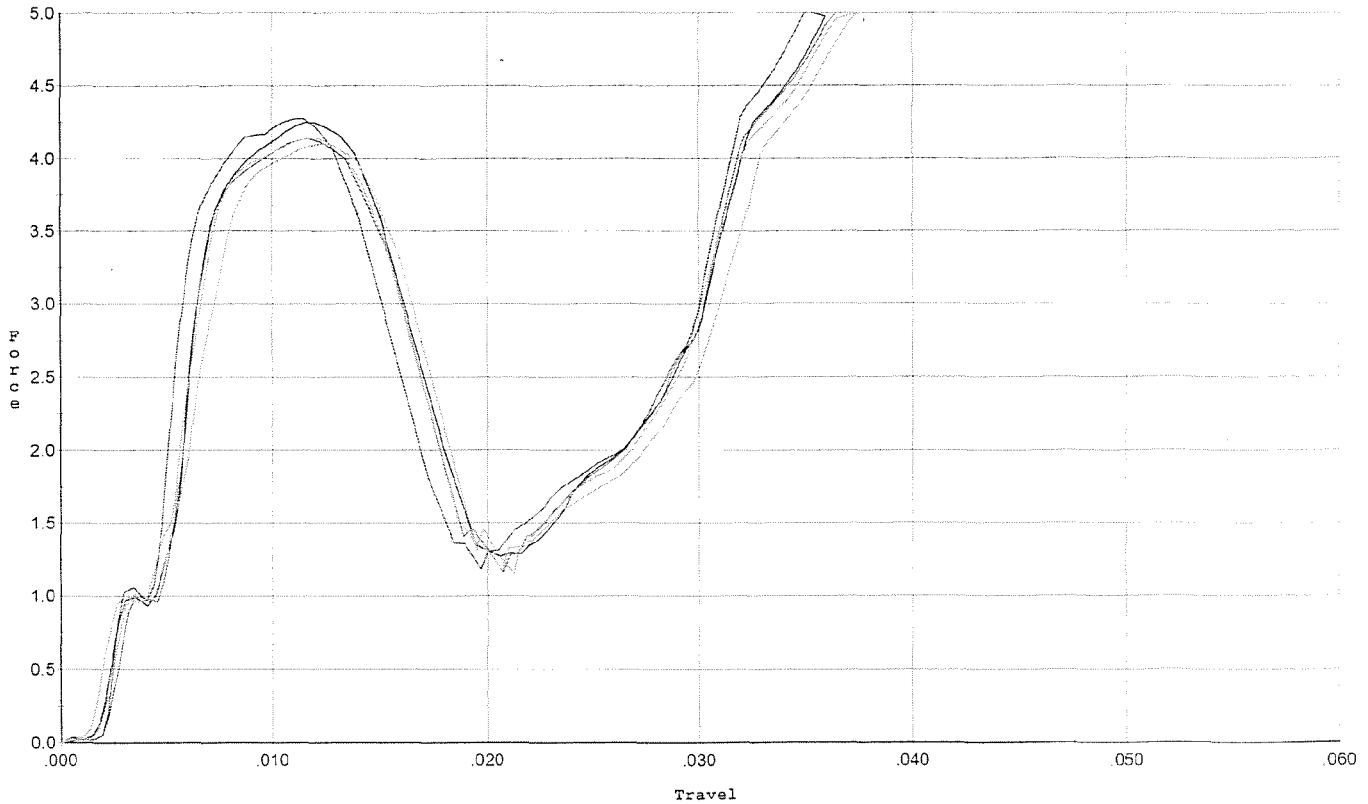
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.056	0.015	0.002	0.032	0.035		Set Trigger
2	4.162	0.016	0.005	0.032	0.037		Set Trigger
3	4.152	0.015	0.00	0.032	0.035		Set Trigger
4	4.165	0.016	0.002	0.032	0.037		Set Trigger
5	4.104	0.015	0.002	0.033	0.034		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



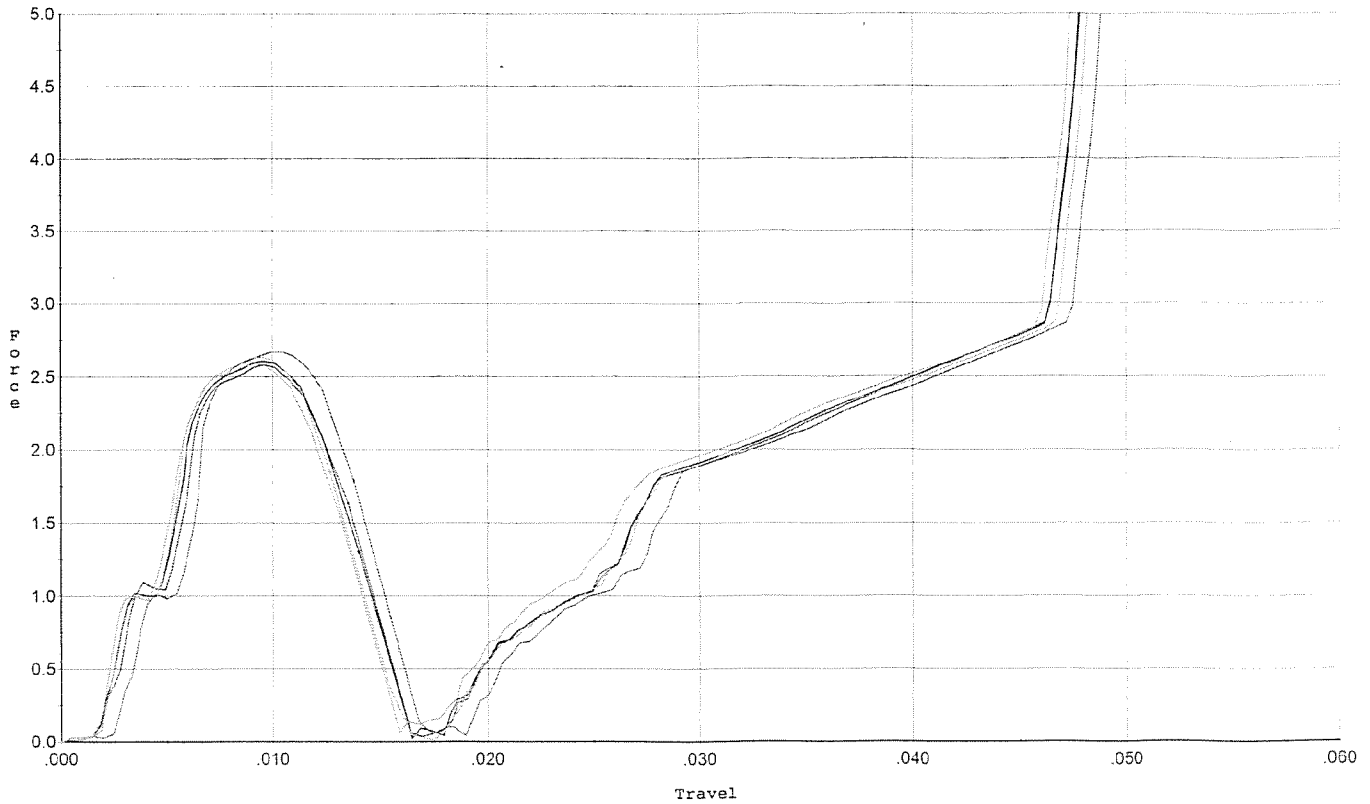
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.274	0.014	0.002	0.026	0.035		Set Trigger
2	4.247	0.015	0.00	0.028	0.037		Set Trigger
3	4.137	0.015	0.005	0.032	0.037		Set Trigger
4	4.140	0.015	0.00	0.032	0.038		Set Trigger
5	4.101	0.016	0.002	0.032	0.038		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



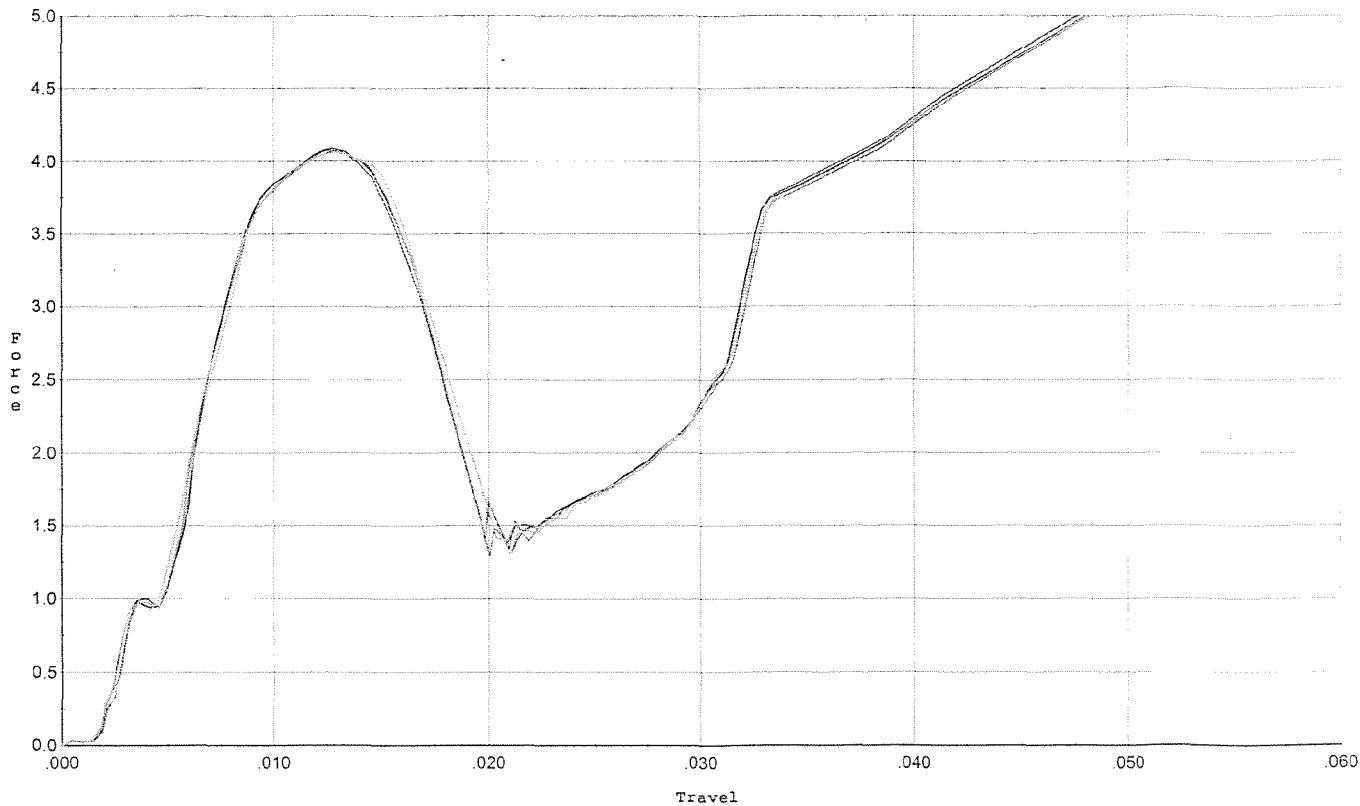
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.581	0.014	0.002	0.038	0.020		Set Trigger
2	2.603	0.014	0.002	0.038	0.021		Set Trigger
3	2.670	0.014	0.00	0.038	0.020		Set Trigger
4	2.632	0.013	0.00	0.039	0.020		Set Trigger
5	2.585	0.013	0.002	0.038	0.020		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.017	0.002	0.033	0.039		Set Trigger
2	4.089	0.016	0.002	0.033	0.039		Set Trigger
3	4.080	0.016	0.005	0.033	0.039		Set Trigger
4	4.060	0.016	0.00	0.033	0.039		Set Trigger
5	4.061	0.016	0.002	0.033	0.038		Set Trigger

A. 4.07