

G6810435

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

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



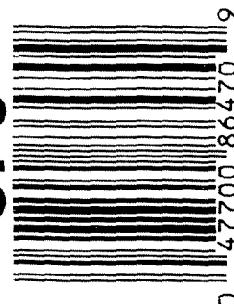
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6810435

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6810435

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 (15)	2/13/09	(15)
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DC
542	APPLY COATINGS (BARREL ACTION)		2/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-19-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

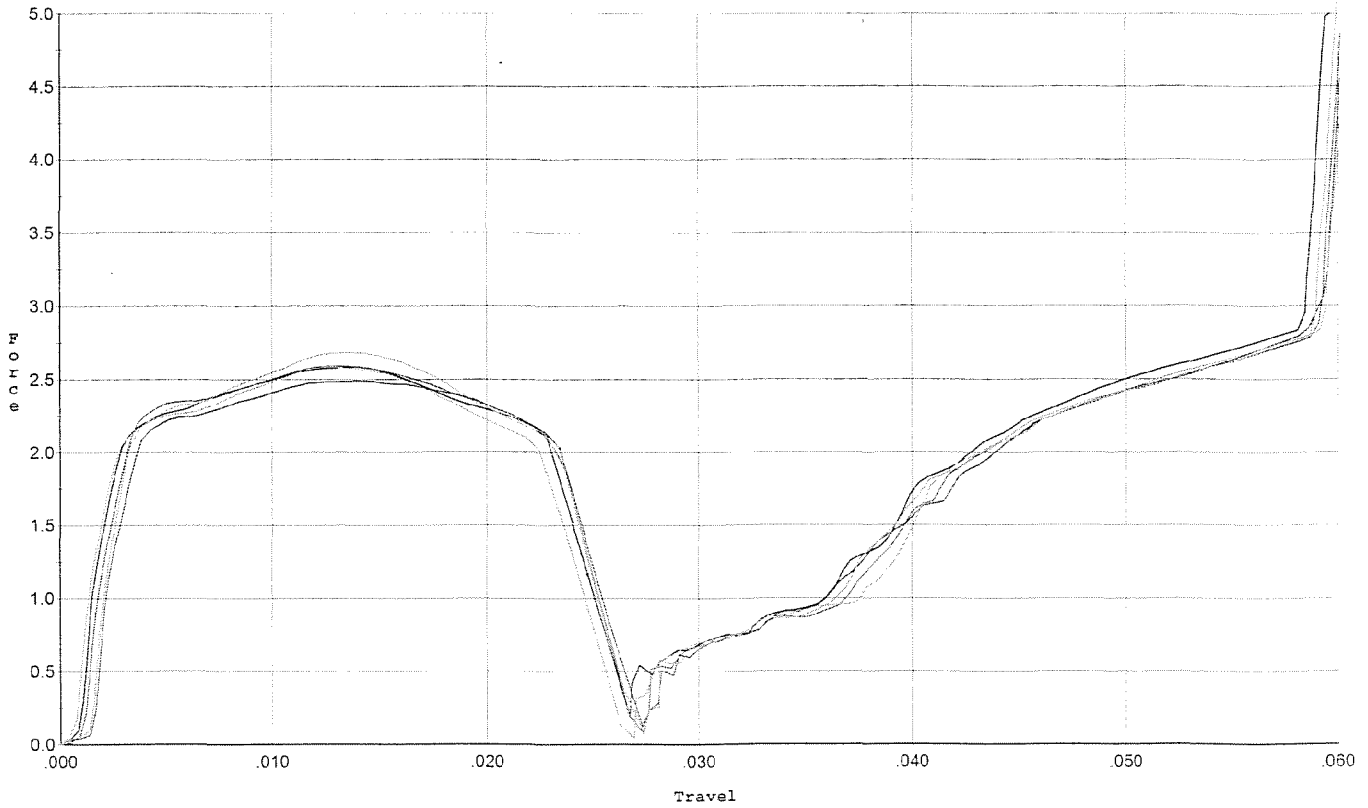
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-25-09	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-25-09	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.002</u> <u>.002</u> <u>.002</u>	2-25-09	L. J.
	J) ASSEMBLE STOCK		2-19-09	RT
	K) ASSEMBLE SWIVEL STUDS		2-25-09	L. J.
	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	2-23-09	L. J.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-23-09	RP
670	FINAL INSPECTION A) HEADSPACE		2-25-09	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.41</u> <u>2.54</u> <u>2.43</u> <u>2.74</u>	2-24-09	W. V.
	C) FUNCTION		2-25-09	L. J.
690	PACK		2/25/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



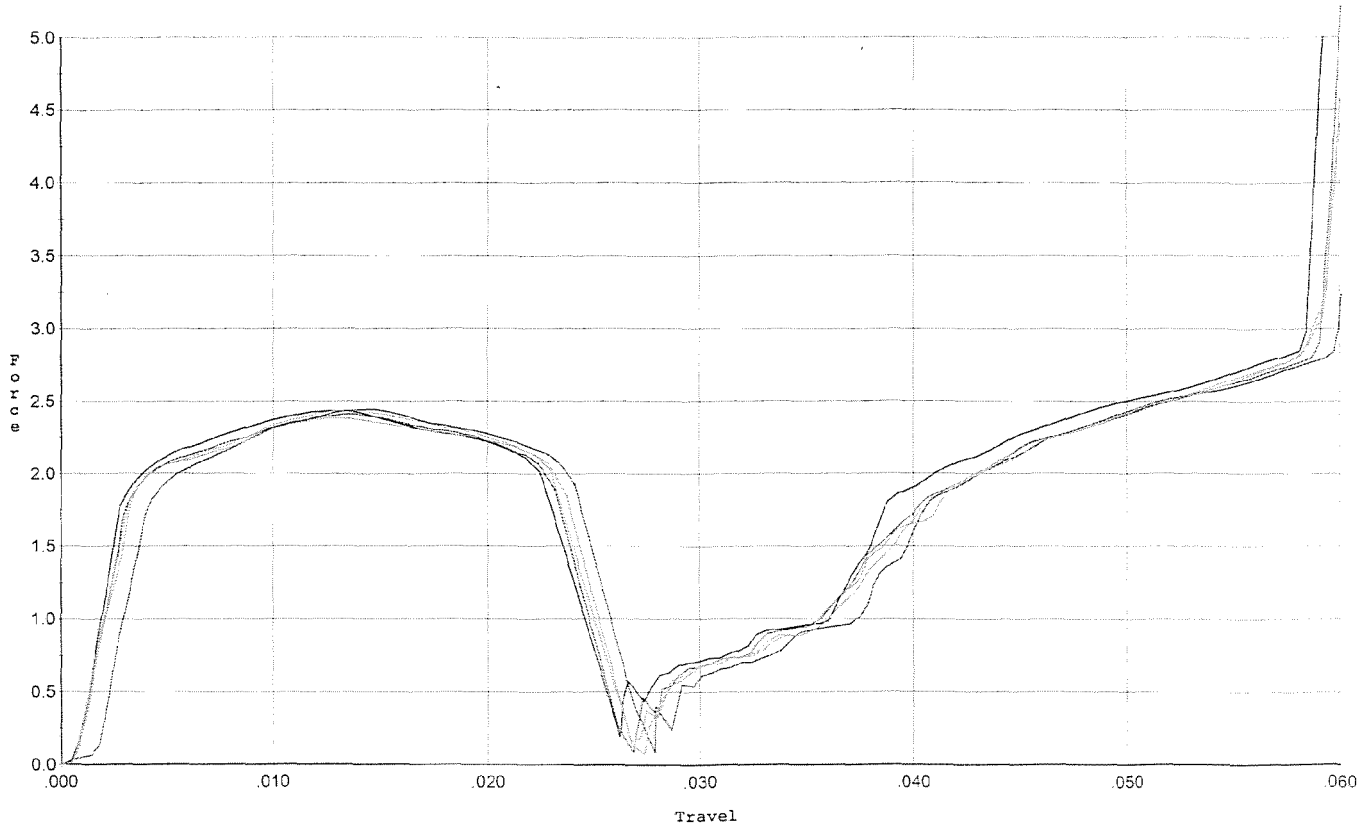
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.023	0.00	0.041	0.047		Set Trigger
2	2.584	0.025	0.00	0.040	0.051		Set Trigger
3	2.591	0.024	0.00	0.041	0.049		Set Trigger
4	2.685	0.024	0.00	0.041	0.049		Set Trigger
5	2.585	0.024	0.00	0.041	0.049		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



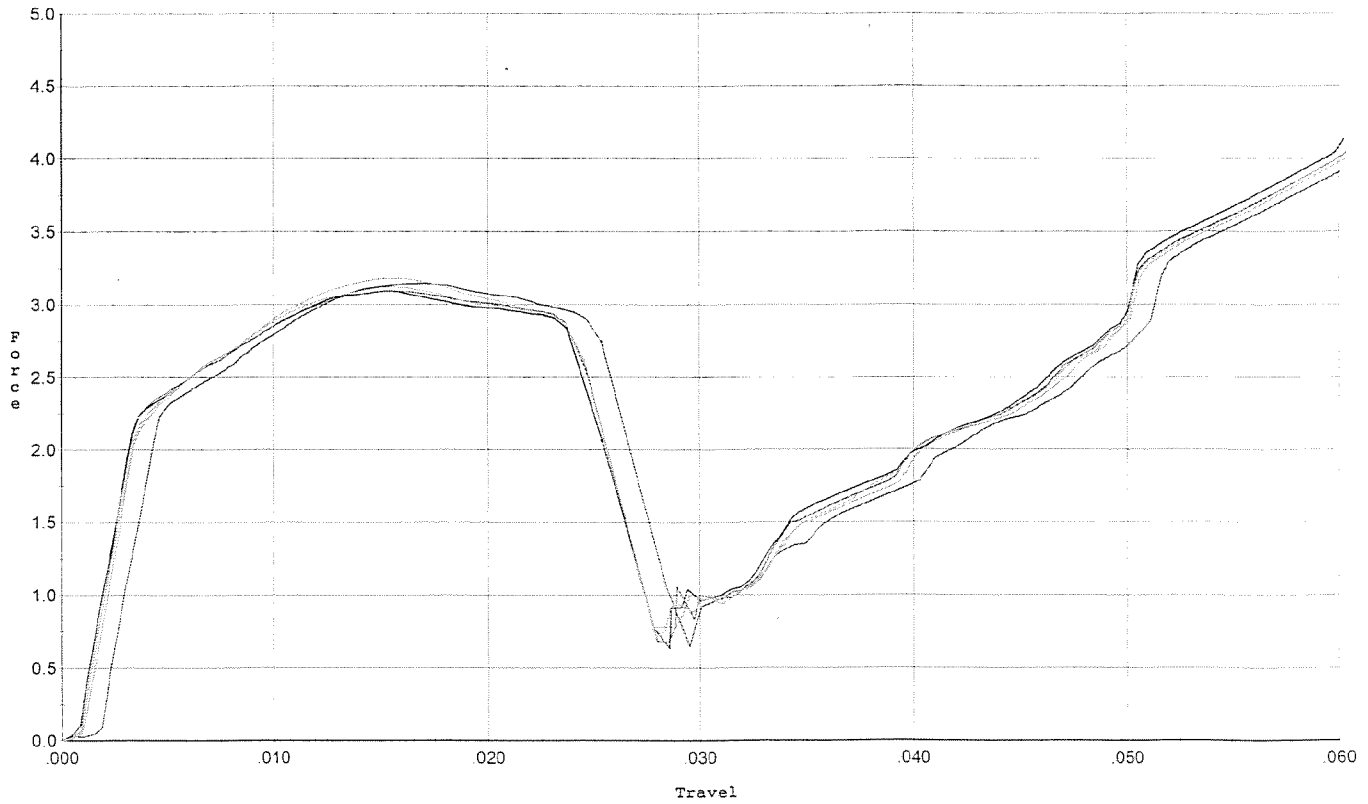
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.443	0.024	0.00	0.041	0.045		Set Trigger
2	2.434	0.024	0.00	0.040	0.047		Set Trigger
3	2.409	0.023	0.00	0.041	0.045		Set Trigger
4	2.436	0.023	0.00	0.041	0.044		Set Trigger
5	2.382	0.024	0.00	0.041	0.045		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



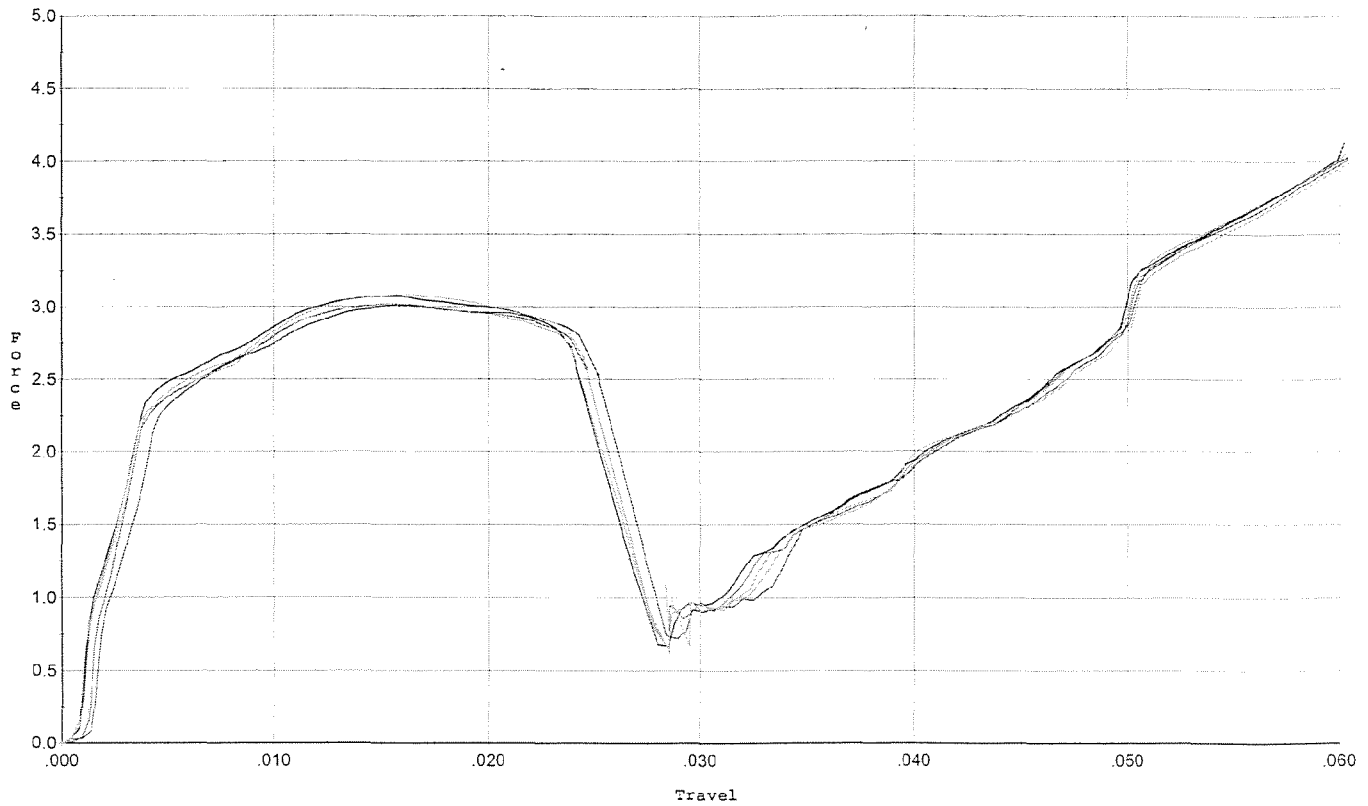
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.144	0.025	0.00	0.040	0.060		Set Trigger
2	3.093	0.025	0.00	0.039	0.061		Set Trigger
3	3.094	0.025	0.00	0.039	0.060		Set Trigger
4	3.120	0.025	0.00	0.040	0.060		Set Trigger
5	3.181	0.025	0.00	0.040	0.060		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



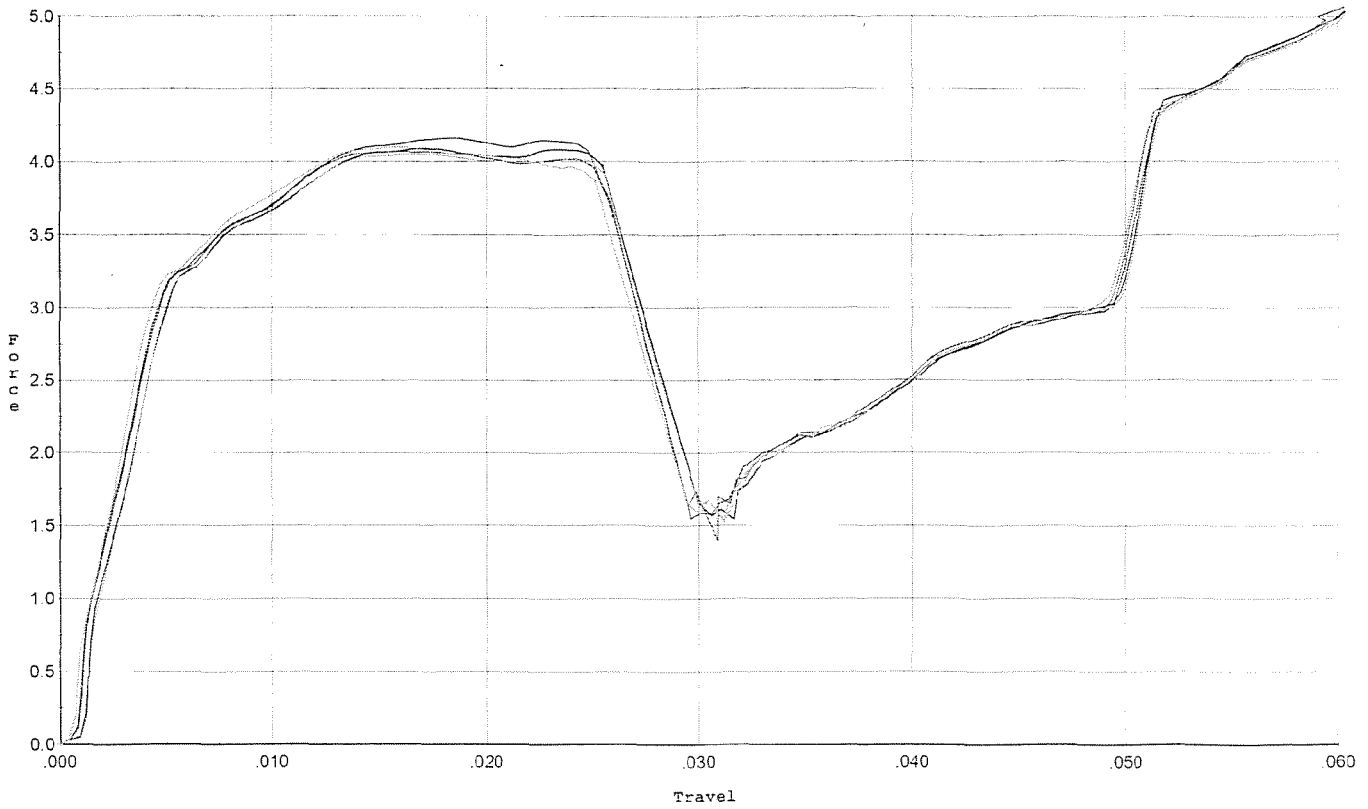
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.009	0.025	0.00	0.039	0.059		Set Trigger
2	3.074	0.024	0.00	0.040	0.058		Set Trigger
3	3.020	0.025	0.00	0.040	0.058		Set Trigger
4	3.084	0.024	0.00	0.040	0.059		Set Trigger
5	3.020	0.026	0.00	0.040	0.061		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



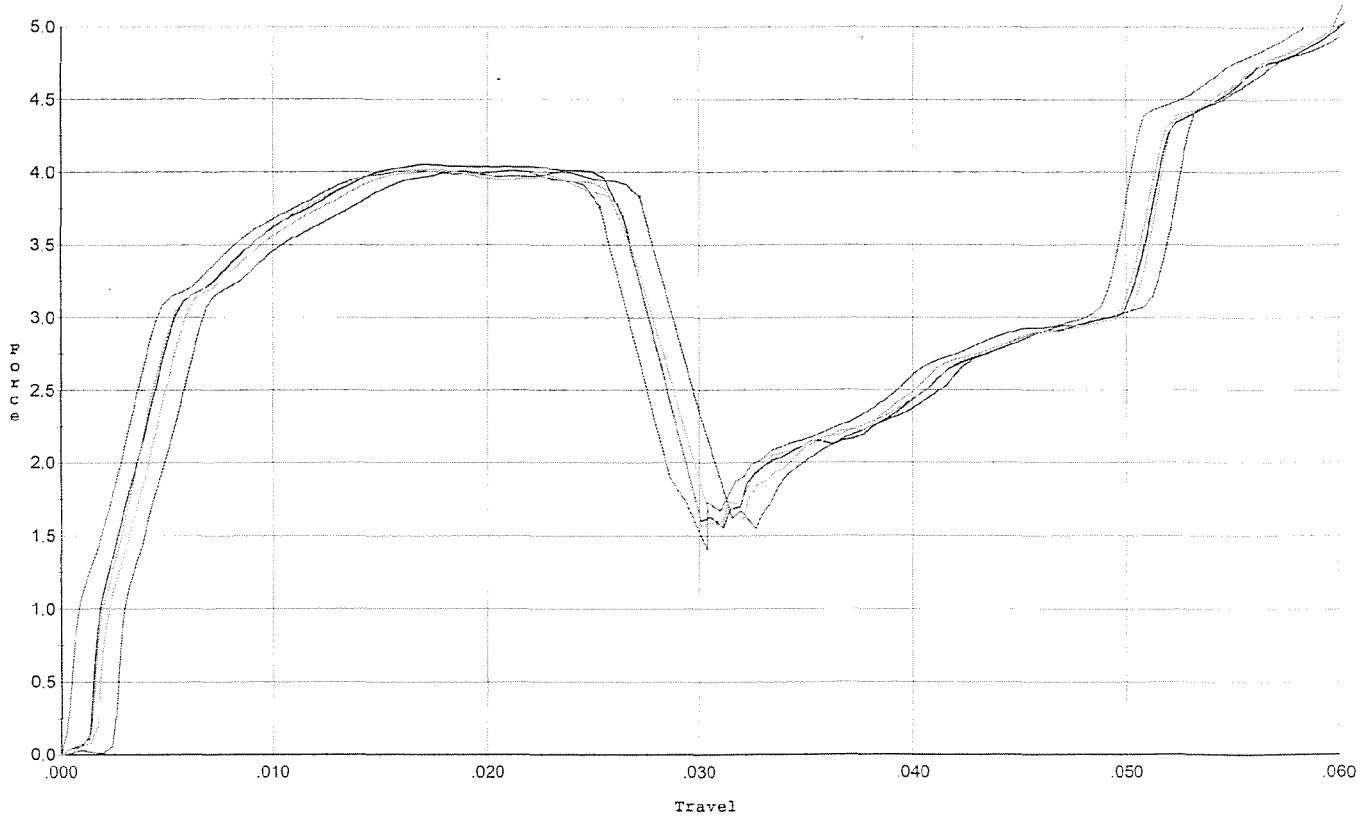
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.160	0.026	0.00	0.037	0.083		Set Trigger
2	4.088	0.025	0.00	0.037	0.080		Set Trigger
3	4.069	0.026	0.00	0.037	0.082		Set Trigger
4	4.047	0.026	0.00	0.037	0.080		Set Trigger
5	4.098	0.025	0.00	0.037	0.080		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



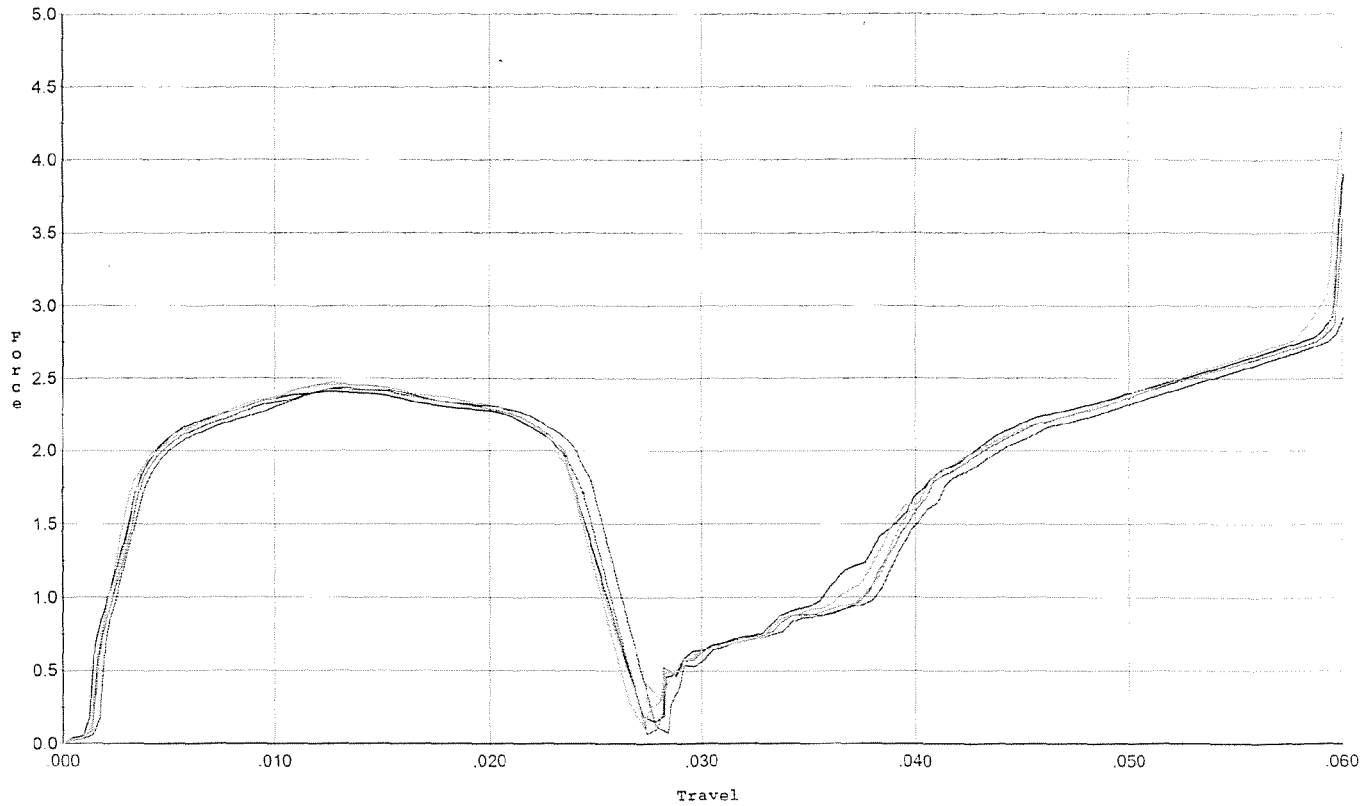
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.006	0.027	0.003	0.037	0.080		Set Trigger
2	4.053	0.026	0.00	0.037	0.082		Set Trigger
3	4.012	0.025	0.00	0.037	0.080		Set Trigger
4	4.008	0.028	0.00	0.037	0.085		Set Trigger
5	4.018	0.027	0.00	0.037	0.082		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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



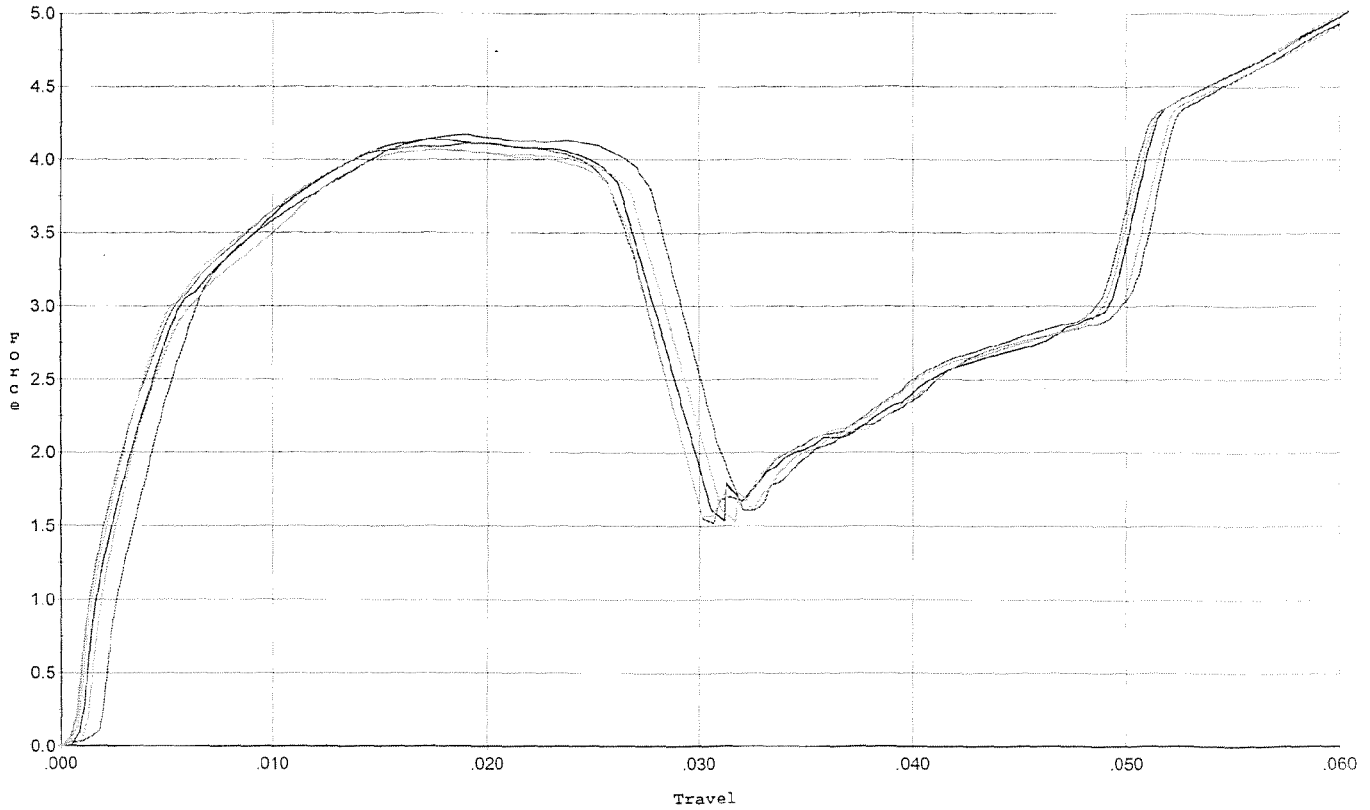
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.025	0.00	0.041	0.047		Set Trigger
2	2.407	0.024	0.00	0.041	0.046		Set Trigger
3	2.427	0.024	0.00	0.041	0.047		Set Trigger
4	2.457	0.024	0.00	0.041	0.046		Set Trigger
5	2.470	0.023	0.00	0.041	0.046		Set Trigger

Avg 2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/3/09

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	4.167	0.028	0.00	0.036	0.086		Set Trigger
2	4.138	0.028	0.00	0.036	0.088		Set Trigger
3	4.112	0.027	0.00	0.036	0.085		Set Trigger
4	4.087	0.027	0.00	0.036	0.084		Set Trigger
5	4.069	0.029	0.00	0.036	0.089		Set Trigger

Aug 4.11