

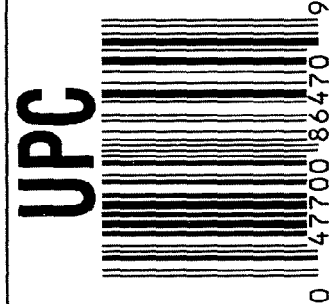
G6810454

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

G6810454



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6810454

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-5-09	SP
430	ASSEMBLE TO STOCK		2-5-09	SP
440	PROOF		2-5-09	SP
460	CHECK HEADSPACE		2-5-09	SP
470	DIS-ASSEMBLE ACTION		2-5-09	SP
472	SERIALIZE BOLT HANDLE		2-6-09	RTZ
475	DRILL AND TAP SIGHT HOLES		2-6-09	TS
480	MAGNAFLUX BBL ACTION	OPERATOR AS	2-7-09	AS
490	MAGNAFLUX BOLT		2-7-09	MR
500	ROLLMARK CALIBER		2-9-09	RT
520	GOFF BLAST BBL / REC		9 Feb. 09	RTZ
542	APPLY COATINGS (BARREL ACTION)		2-11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-11-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-12-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

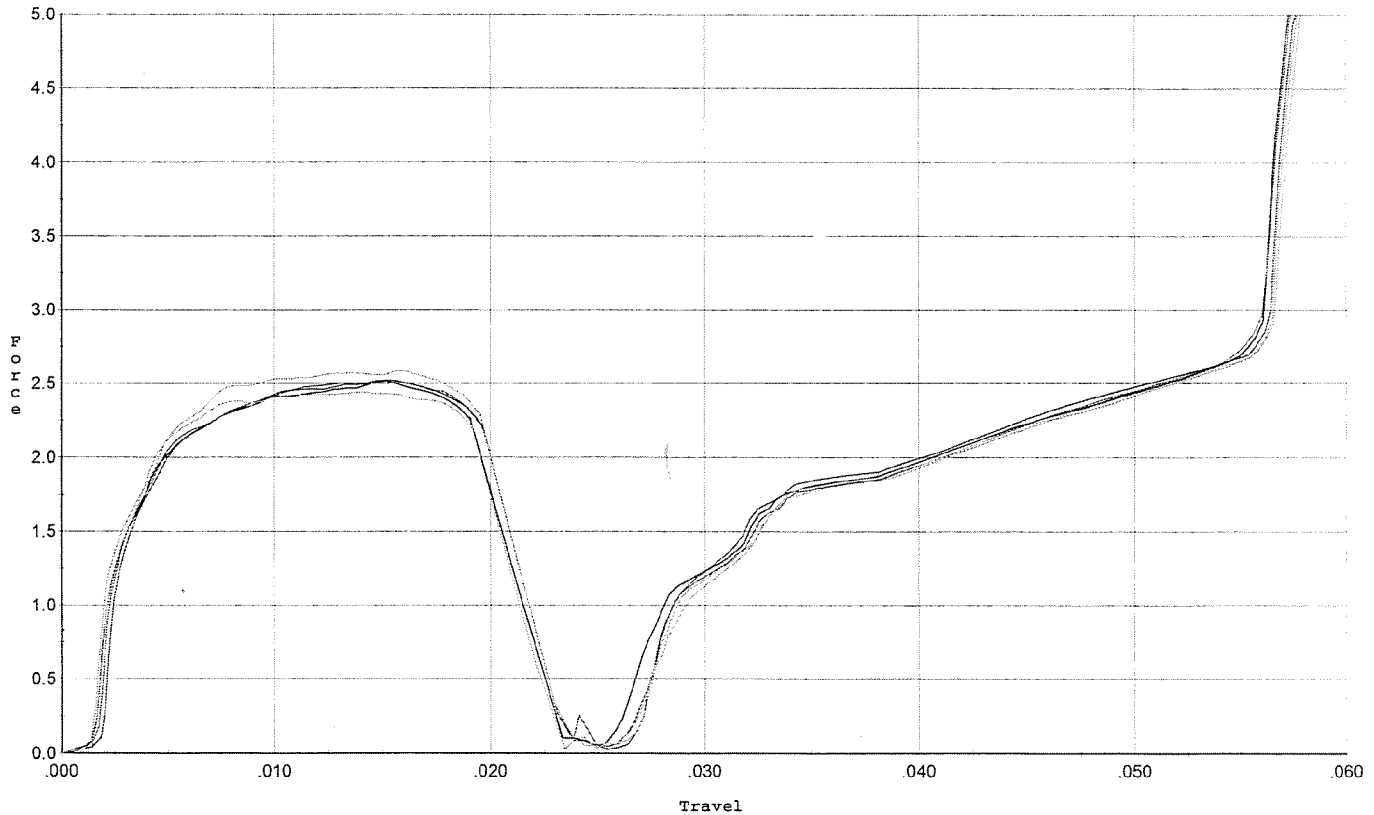
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	2-25-09	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6°</u> <u>6°</u> <u>6°</u>	2-25-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.034</u> <u>.034</u> <u>.034</u>	2-25-09	RN
	J) ASSEMBLE STOCK		2-12-09	LR
	K) ASSEMBLE SWIVEL STUDS		2-25-09	RN
	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	2-19-09	APD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-19-09	SP
670	FINAL INSPECTION A) HEADSPACE		2-25-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.49</u> <u>2.49</u> <u>2.56</u> <u>2.42</u>	2-20-09	NV
	C) FUNCTION		2-25-09	RN
690	PACK		2/25/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



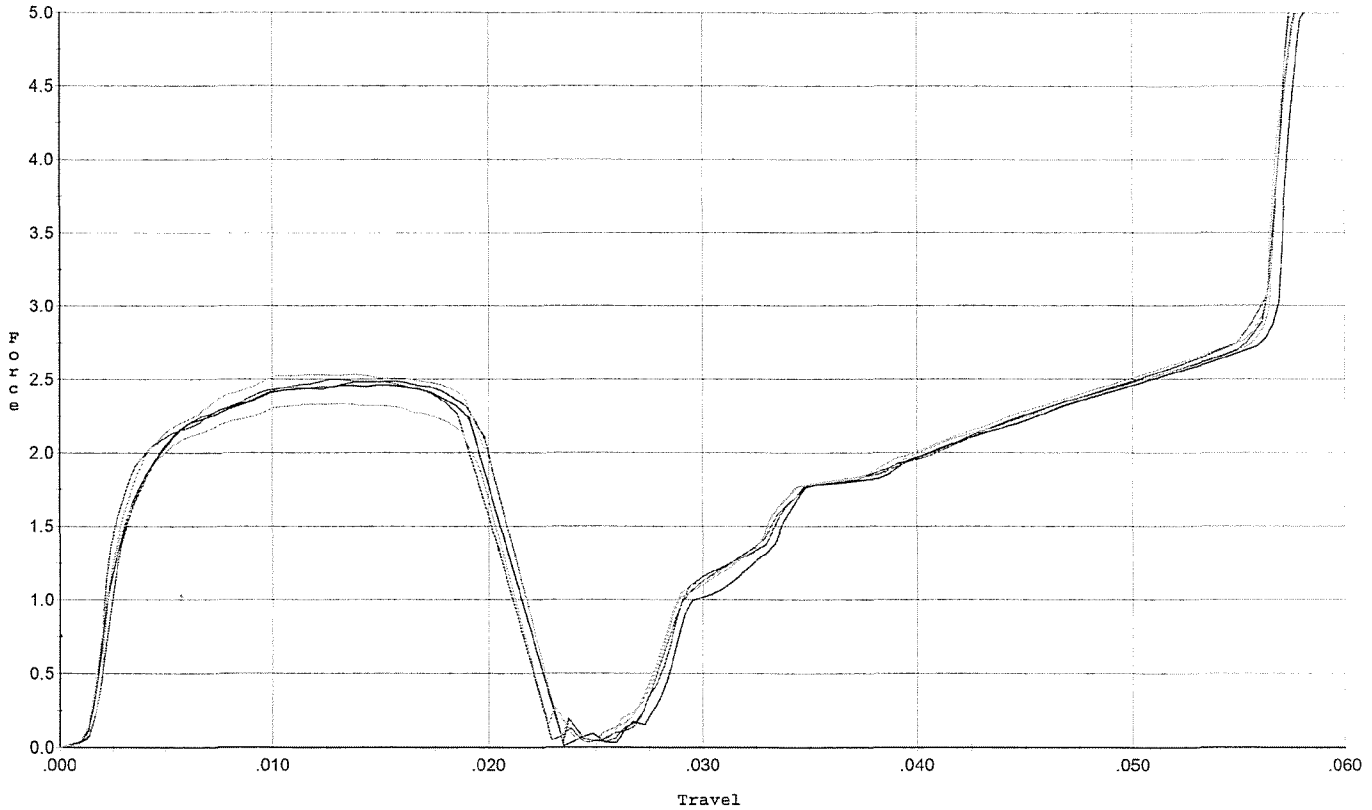
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.521	0.020	0.00	0.041	0.037		Set Trigger
2	2.516	0.019	0.00	0.041	0.036		Set Trigger
3	2.509	0.020	0.00	0.041	0.038		Set Trigger
4	2.439	0.019	0.00	0.042	0.037		Set Trigger
5	2.582	0.020	0.00	0.041	0.039		Set Trigger

A-2-S1

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



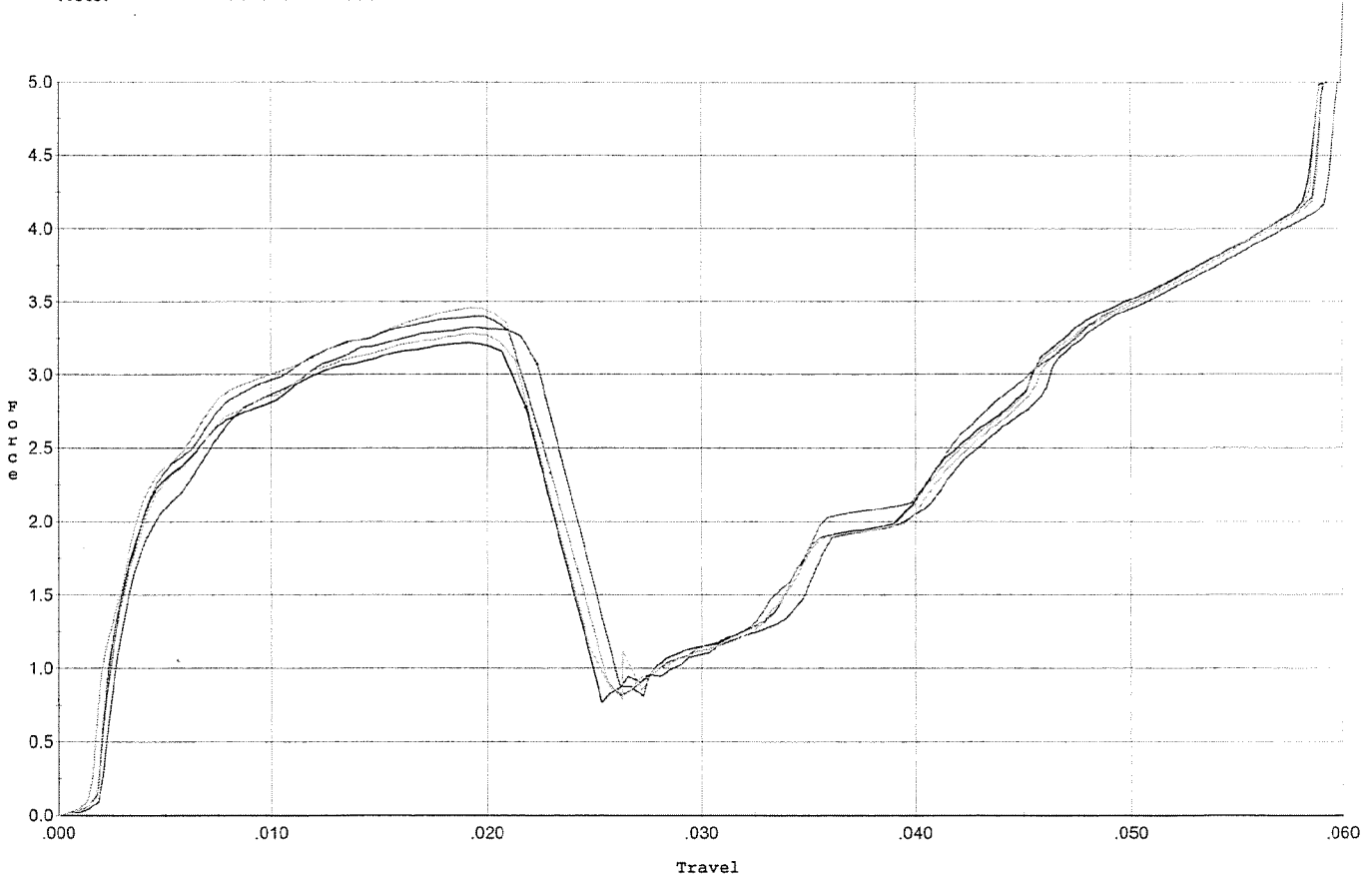
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.487	0.020	0.00	0.041	0.038		Set Trigger
2	2.461	0.019	0.00	0.042	0.036		Set Trigger
3	2.499	0.020	0.00	0.042	0.039		Set Trigger
4	2.531	0.020	0.00	0.041	0.039		Set Trigger
5	2.333	0.020	0.00	0.042	0.036		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



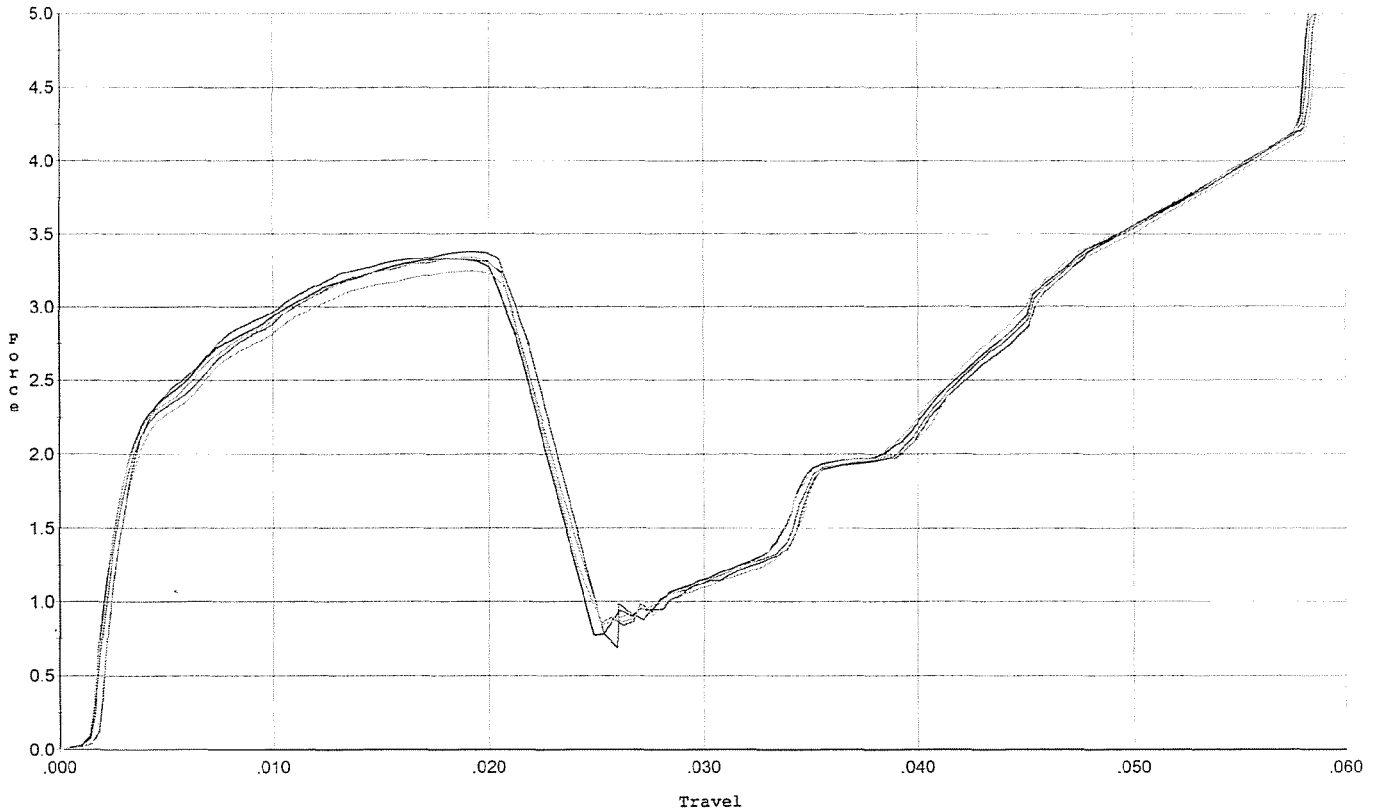
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.325	0.022	0.00	0.039	0.053		Set Trigger
2	3.217	0.022	0.00	0.040	0.051		Set Trigger
3	3.401	0.023	0.00	0.039	0.056		Set Trigger
4	3.279	0.021	0.00	0.040	0.051		Set Trigger
5	3.461	0.023	0.00	0.039	0.057		Set Trigger

A-3-33

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



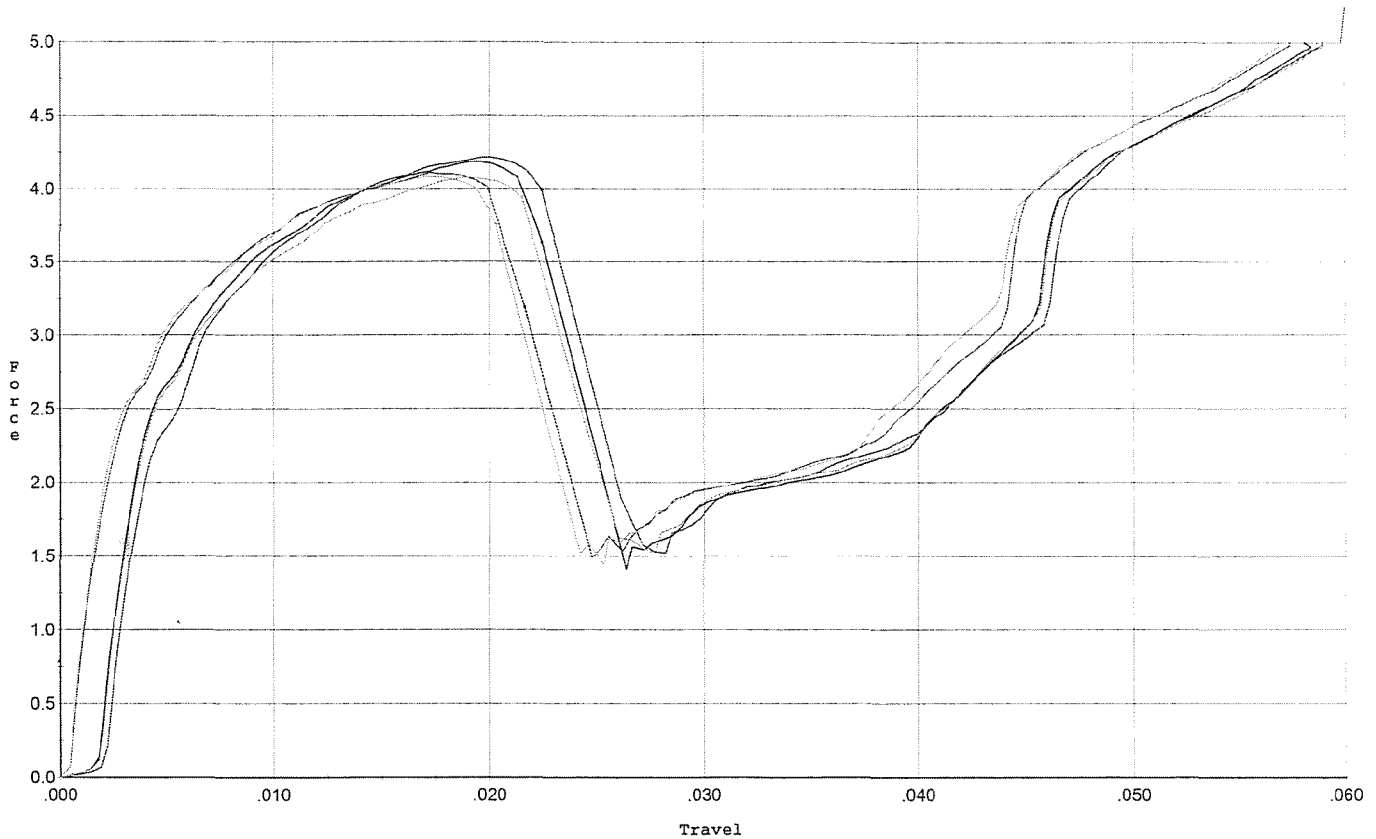
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.376	0.022	0.00	0.039	0.053		Set Trigger
2	3.331	0.021	0.00	0.040	0.052		Set Trigger
3	3.327	0.021	0.00	0.040	0.050		Set Trigger
4	3.342	0.021	0.00	0.039	0.050		Set Trigger
5	3.245	0.021	0.00	0.040	0.049		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



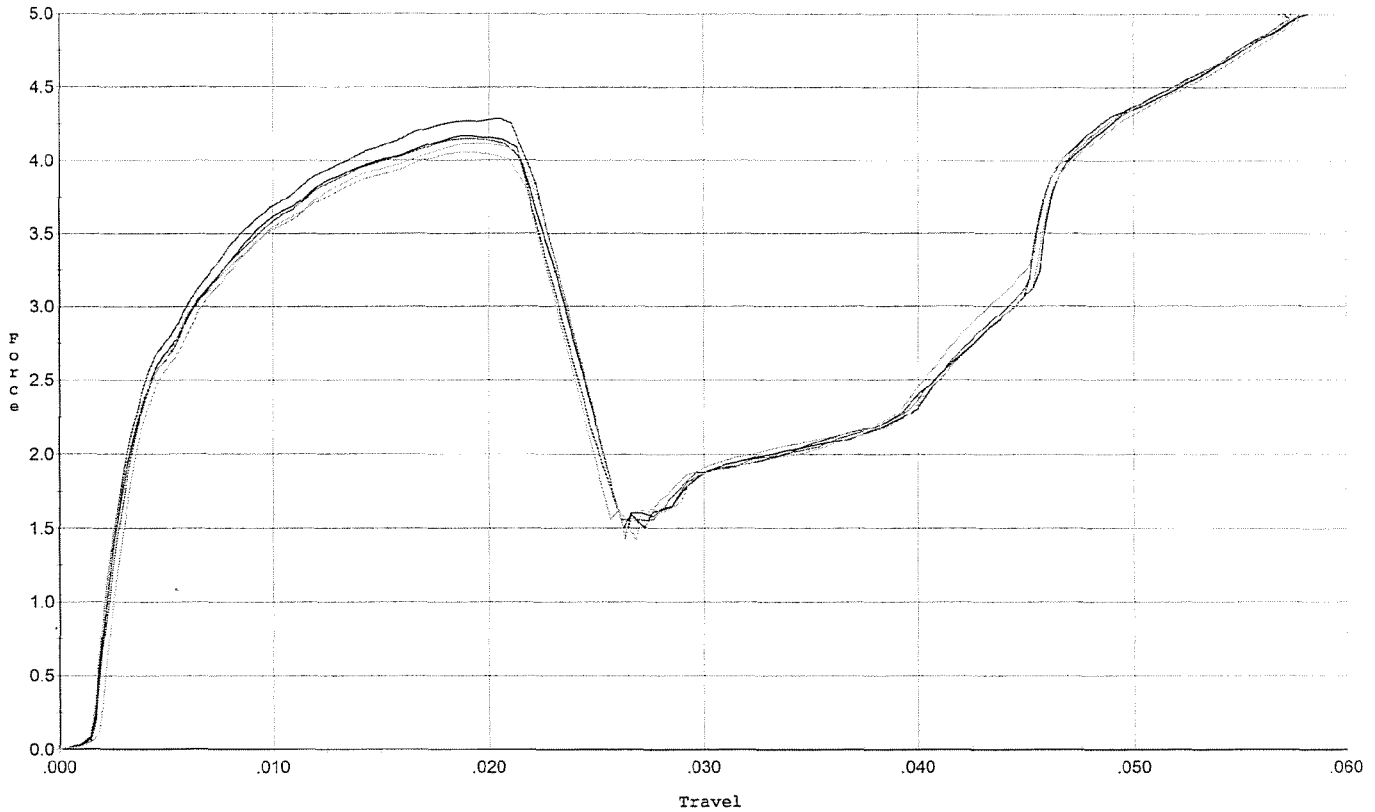
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.213	0.022	0.00	0.038	0.065		Set Trigger
2	4.185	0.022	0.00	0.038	0.066		Set Trigger
3	4.110	0.022	0.00	0.038	0.066		Set Trigger
4	4.082	0.020	0.00	0.038	0.062		Set Trigger
5	4.075	0.022	0.00	0.039	0.062		Set Trigger

A-4-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



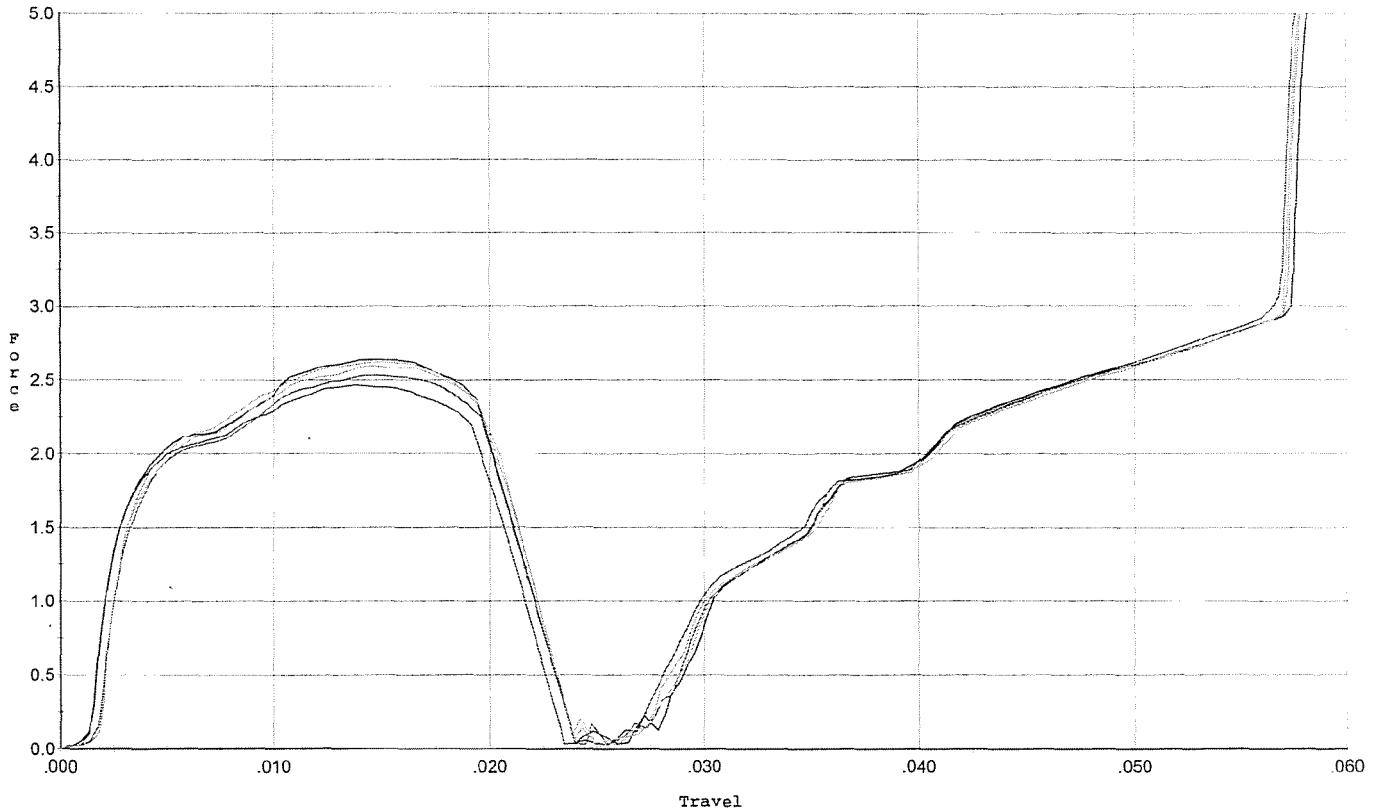
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.286	0.022	0.00	0.038	0.067		Set Trigger
2	4.166	0.023	0.00	0.038	0.068		Set Trigger
3	4.150	0.021	0.00	0.038	0.063		Set Trigger
4	4.119	0.022	0.00	0.038	0.065		Set Trigger
5	4.057	0.022	0.00	0.038	0.063		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



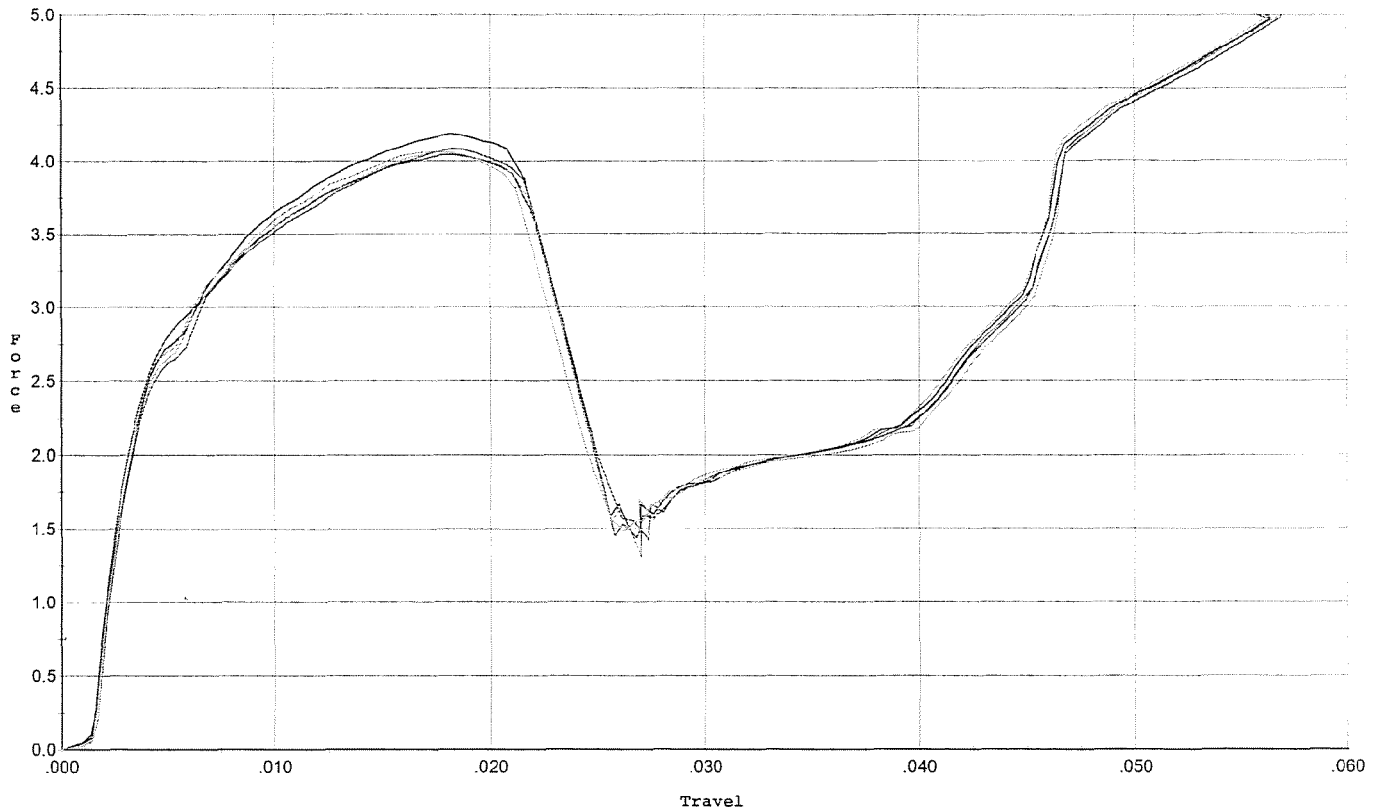
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.466	0.021	0.00	0.041	0.039		Set Trigger
2	2.636	0.022	0.00	0.041	0.042		Set Trigger
3	2.532	0.022	0.00	0.041	0.040		Set Trigger
4	2.593	0.020	0.00	0.041	0.039		Set Trigger
5	2.620	0.021	0.00	0.041	0.040		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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	4.047	0.022	0.00	0.038	0.064		Set Trigger
2	4.187	0.022	0.00	0.038	0.064		Set Trigger
3	4.085	0.022	0.00	0.038	0.062		Set Trigger
4	4.066	0.021	0.00	0.039	0.061		Set Trigger
5	4.067	0.022	0.00	0.038	0.064		Set Trigger

A-4.09