

66801416

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

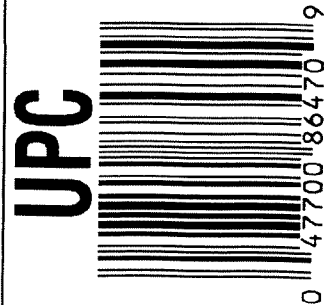


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801416



BM FORM

GUN SERIAL # G680 1416

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-15-09	RTZ
430	ASSEMBLE TO STOCK		5-19-09	WV
440	PROOF		5-19-09	WV
460	CHECK HEADSPACE		5-19-09	WV
470	DIS-ASSEMBLE ACTION		5-19-09	RTZ
472	SERIALIZE BOLT HANDLE		5-19-09	RTZ
480	MAGNAFLUX BBL ACTION		5/29/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-19-09	JP
520	GOFF BLAST BBL / REC		5-19-09	WV
540	APPLY COATINGS (BARREL ACTION)		6/2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-2-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-2-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-2-09	JP
	D) OIL FIRING PIN ASSEMBLY		6-3-09	WV
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

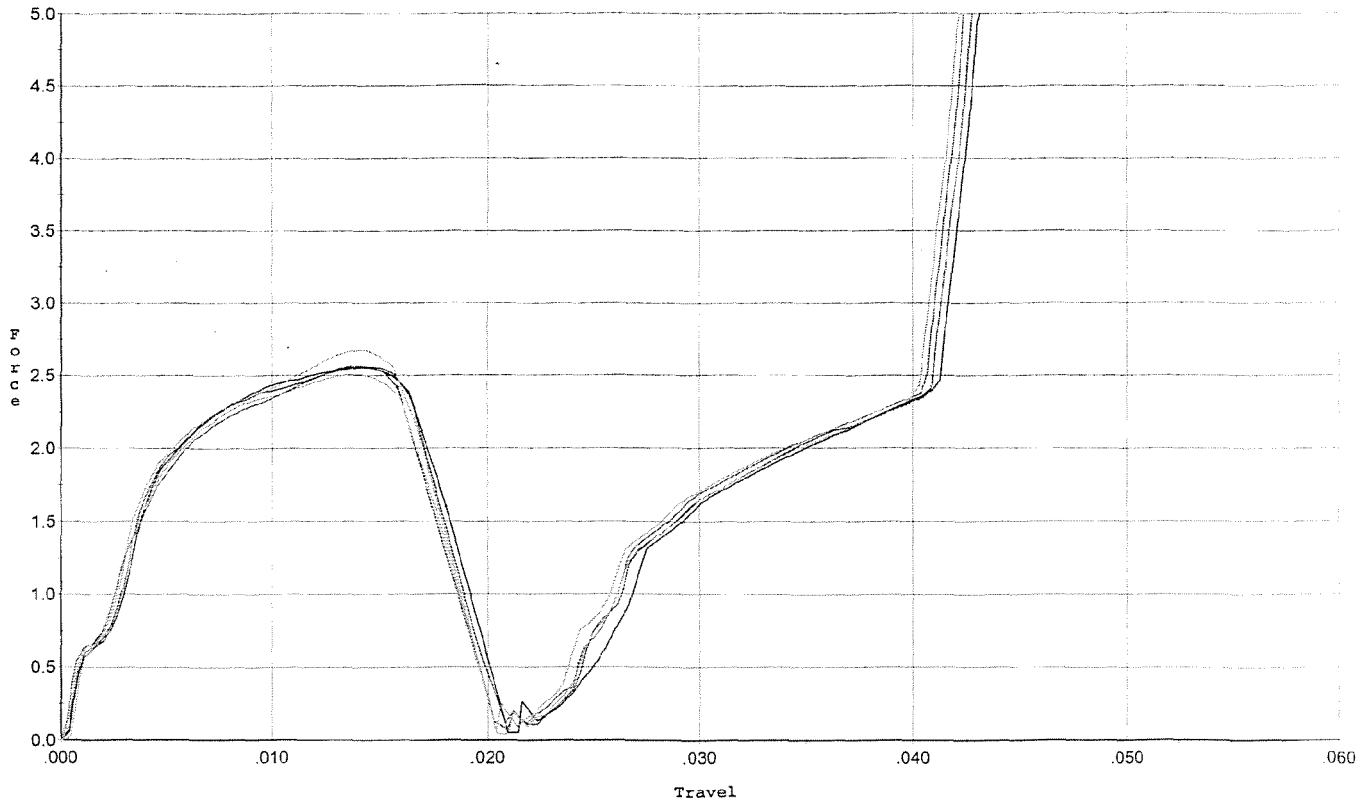
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>30</u> <u>30</u>	6-19-09	RJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-19-09	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.033</u> <u>.033</u> <u>.033</u>	6-19-09	RJ
	J) ASSEMBLE STOCK		6-3-09	RJ
	K) ASSEMBLE SWIVEL STUDS		6-19-09	RJ
	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	6/16/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TJR
670	FINAL INSPECTION A) HEADSPACE		6-19-09	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.71</u> <u>2.75</u> <u>2.71</u> <u>2.75</u>	6-18-09	RJ
	C) FUNCTION		6-19-09	RJ
690	PACK		7/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



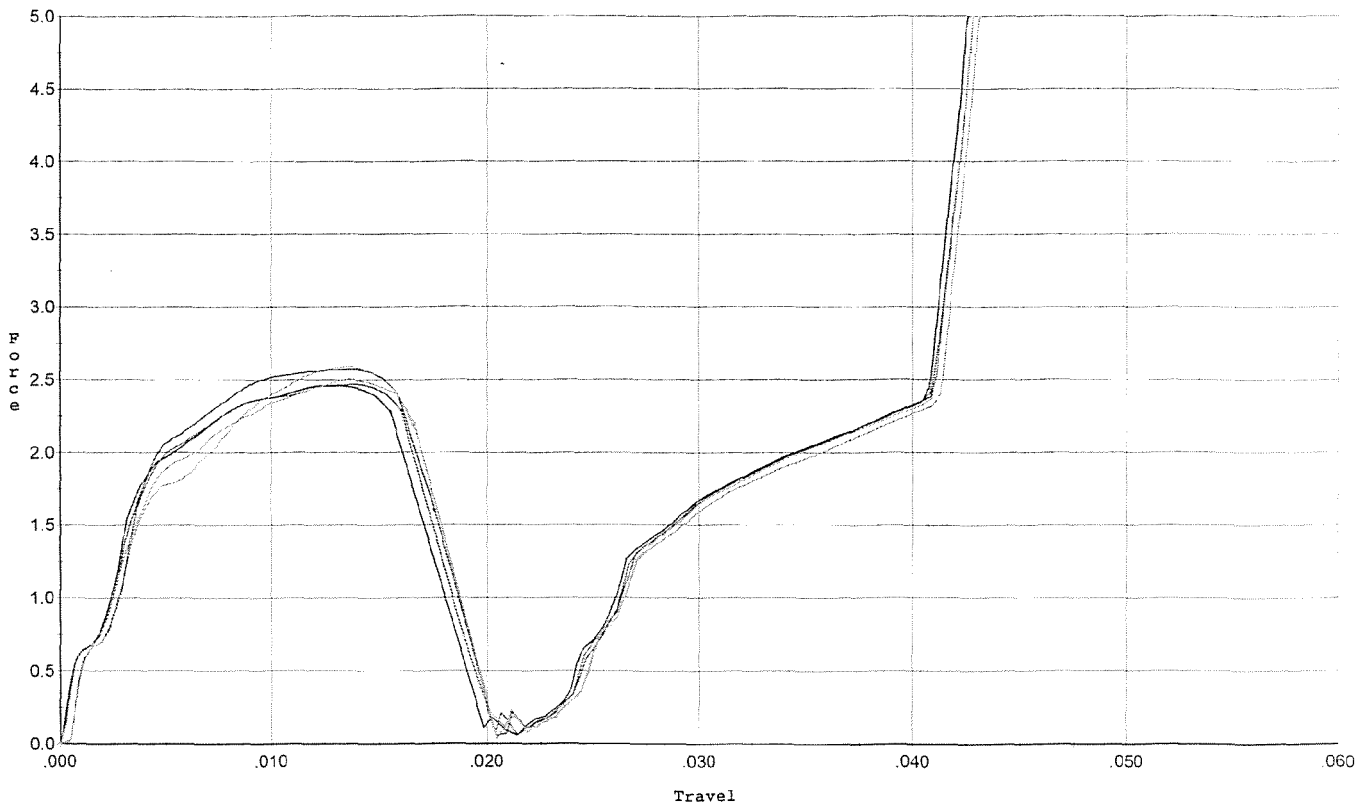
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.560	0.016	0.00	0.030	0.030		Set Trigger
2	2.556	0.018	0.00	0.030	0.033		Set Trigger
3	2.566	0.016	0.00	0.030	0.029		Set Trigger
4	2.507	0.018	0.00	0.030	0.031		Set Trigger
5	2.673	0.017	0.00	0.029	0.032		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



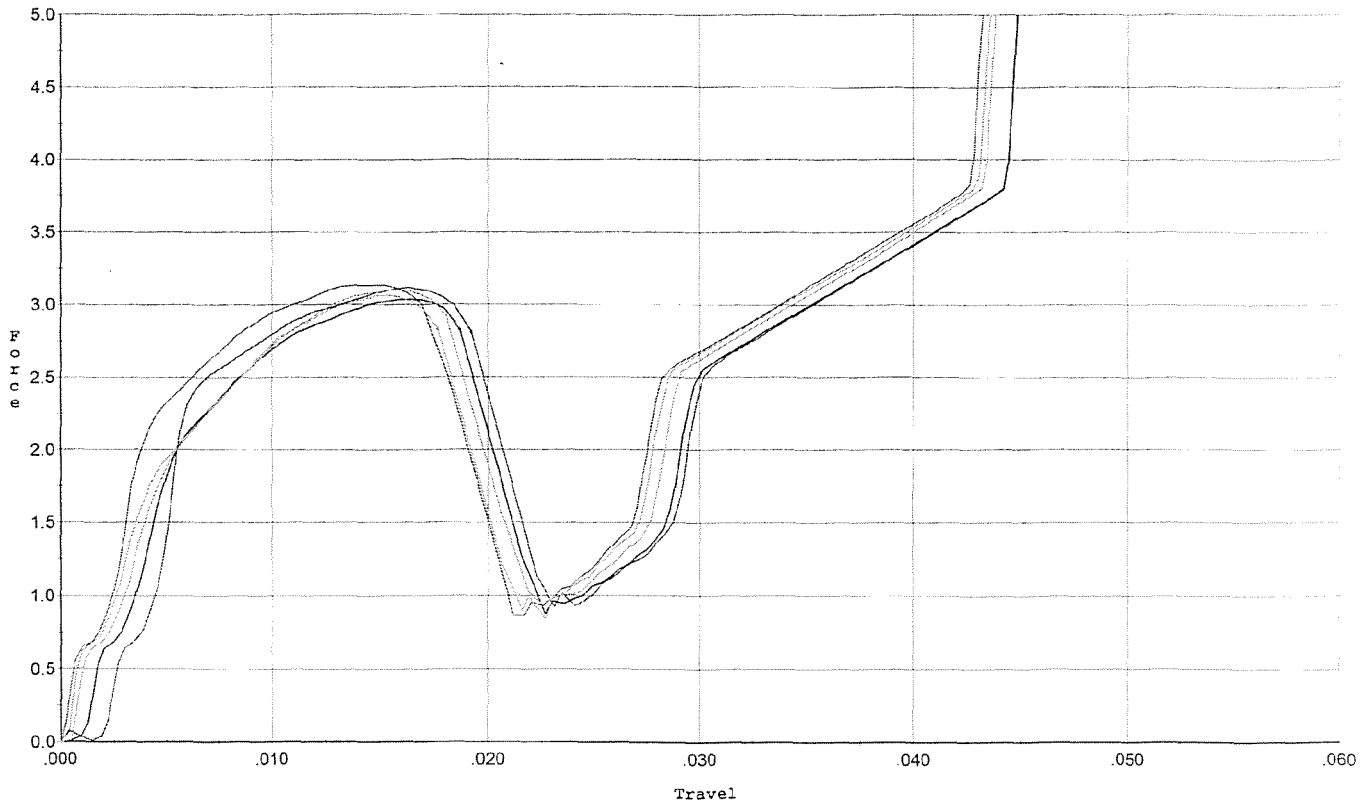
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.018	0.00	0.030	0.033		Set Trigger
2	2.459	0.016	0.00	0.031	0.028		Set Trigger
3	2.466	0.016	0.00	0.031	0.029		Set Trigger
4	2.506	0.017	0.00	0.030	0.030		Set Trigger
5	2.589	0.017	0.00	0.031	0.030		Set Trigger

A-2-S1

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



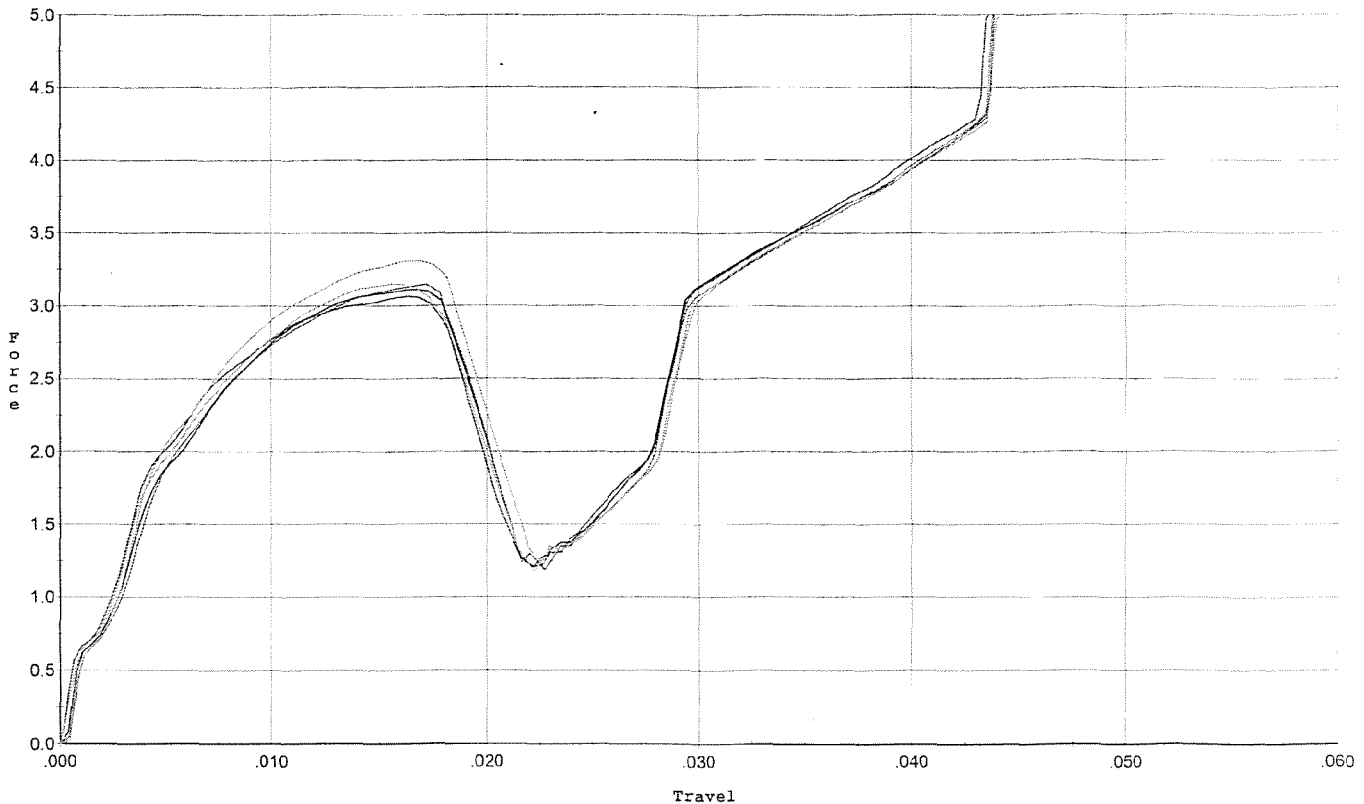
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.019	0.002	0.029	0.040		Set Trigger
2	3.037	0.019	0.00	0.029	0.039		Set Trigger
3	3.136	0.018	0.00	0.028	0.041		Set Trigger
4	3.068	0.018	0.00	0.028	0.037		Set Trigger
5	3.104	0.018	0.00	0.028	0.038		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



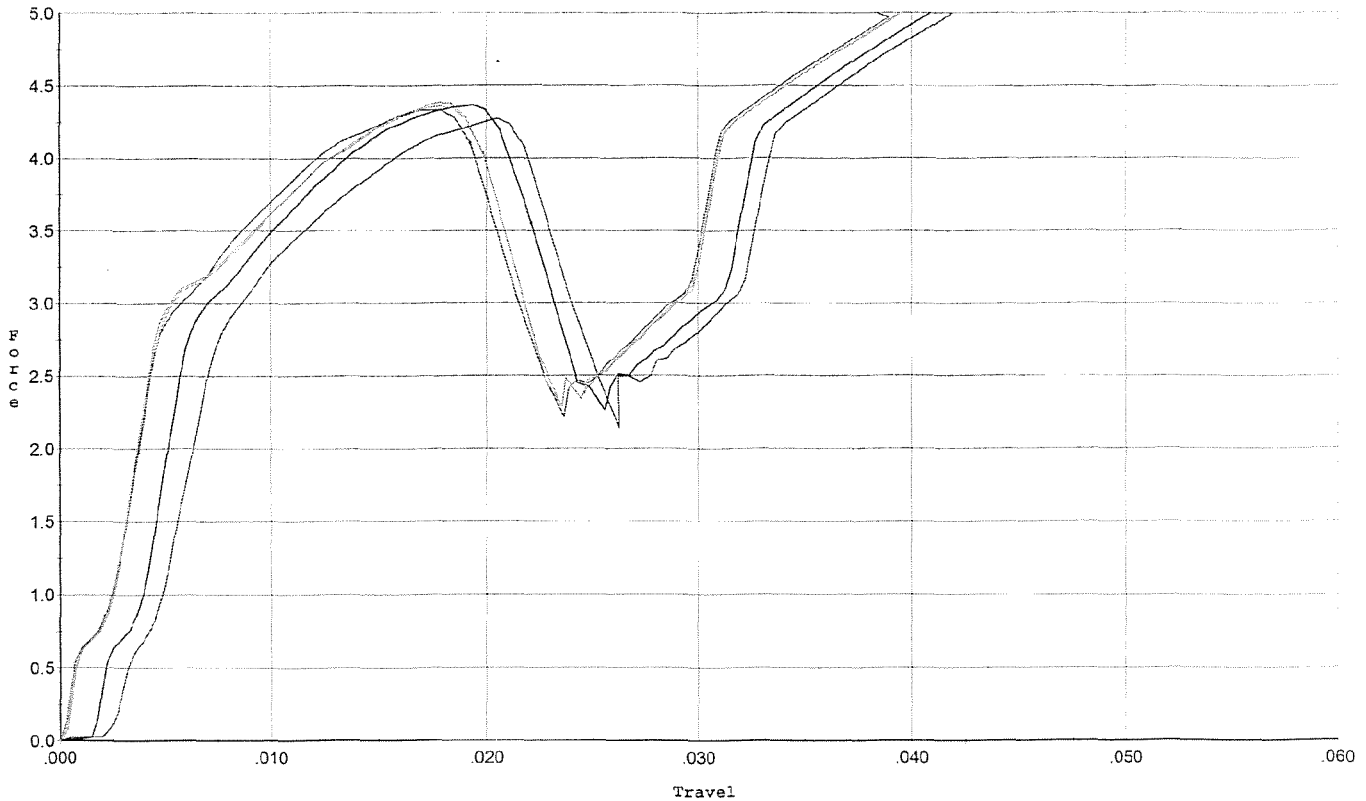
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.064	0.018	0.00	0.028	0.040		Set Trigger
2	3.110	0.019	0.00	0.028	0.042		Set Trigger
3	3.145	0.019	0.00	0.028	0.041		Set Trigger
4	3.150	0.018	0.00	0.028	0.039		Set Trigger
5	3.309	0.018	0.00	0.028	0.041		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



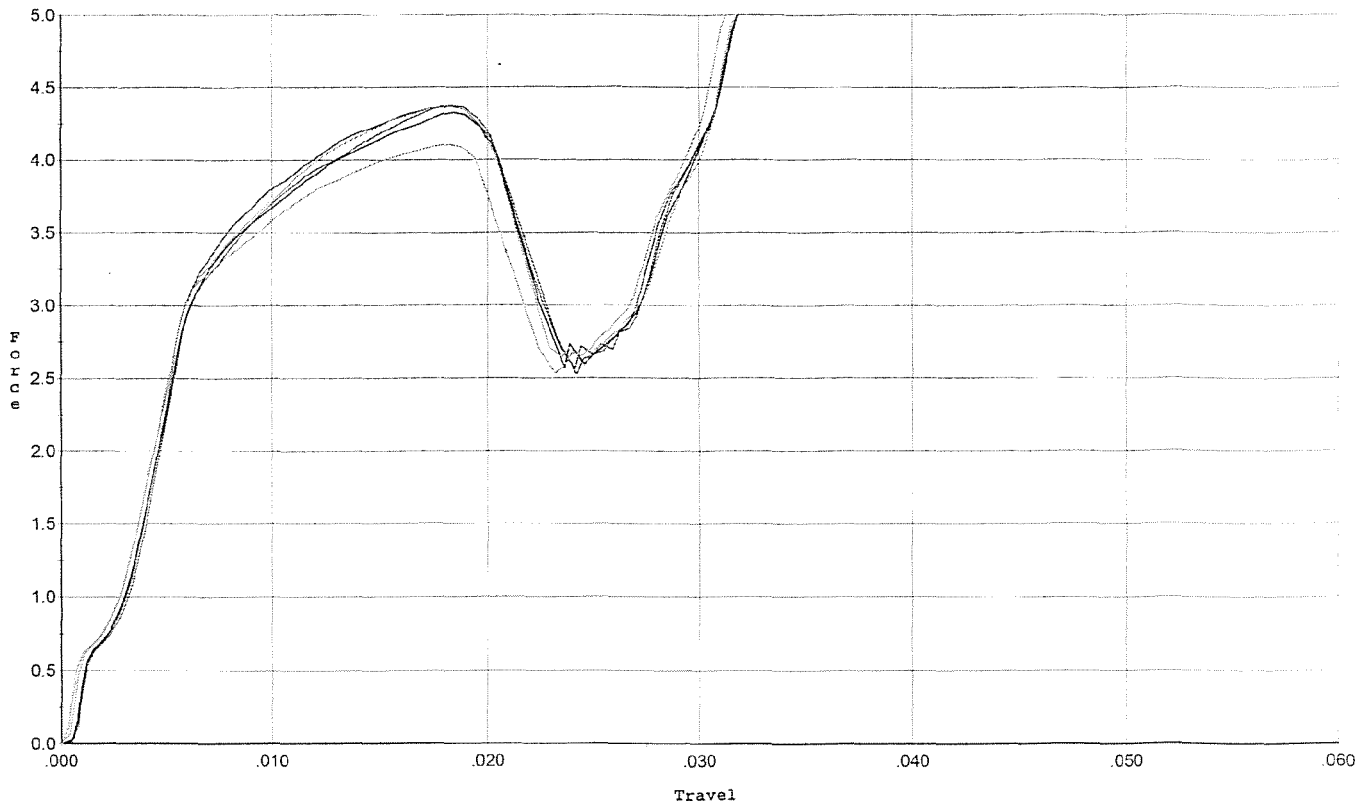
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.274	0.022	0.002	0.024	0.058		Set Trigger
2	4.366	0.022	0.00	0.025	0.062		Set Trigger
3	4.334	0.019	0.00	0.025	0.057		Set Trigger
4	4.358	0.020	0.00	0.025	0.059		Set Trigger
5	4.386	0.020	0.00	0.025	0.059		Set Trigger

A-4.34

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



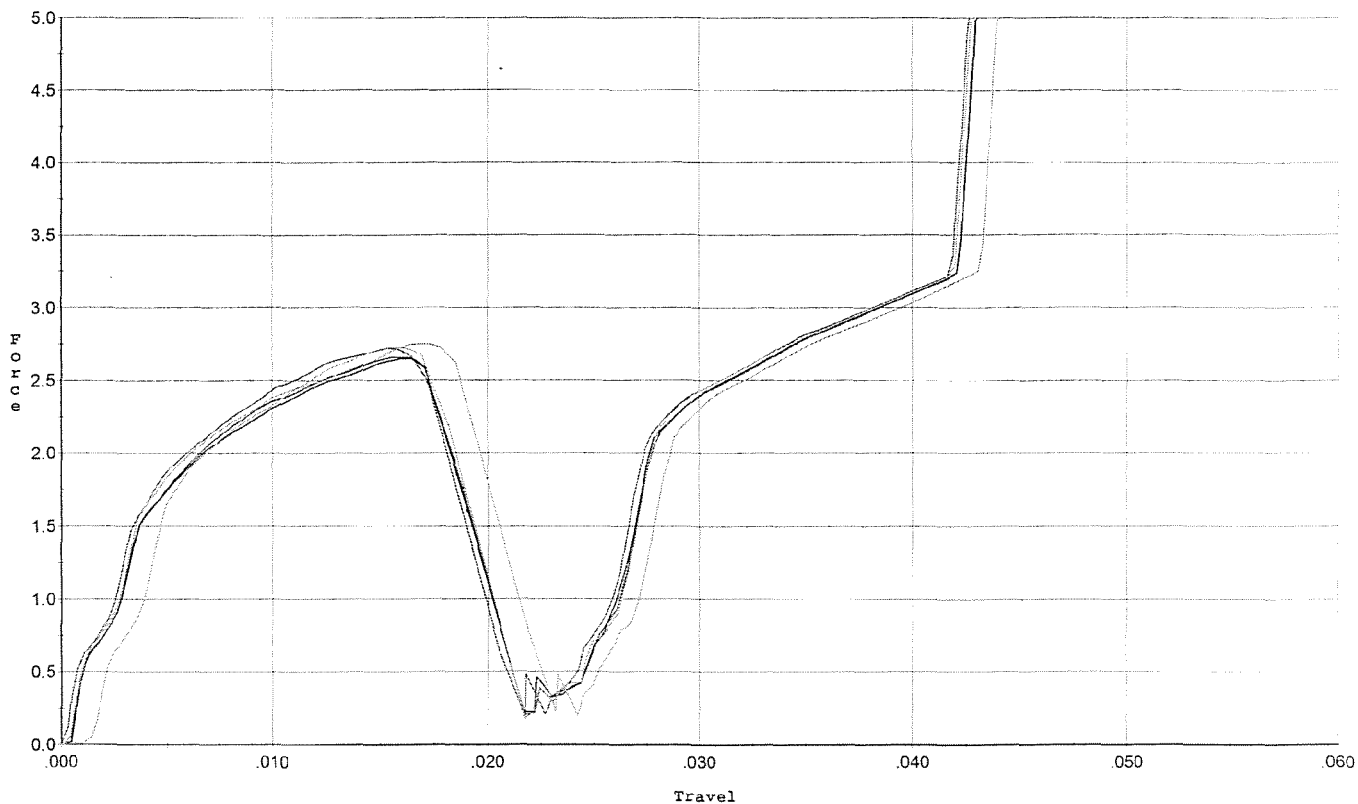
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.376	0.020	0.00	0.011	0.060		Set Trigger
2	4.328	0.020	0.00	0.011	0.059		Set Trigger
3	4.377	0.022	0.00	0.011	0.063		Set Trigger
4	4.382	0.020	0.00	0.011	0.060		Set Trigger
5	4.104	0.021	0.00	0.011	0.059		Set Trigger

A. 4.31

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



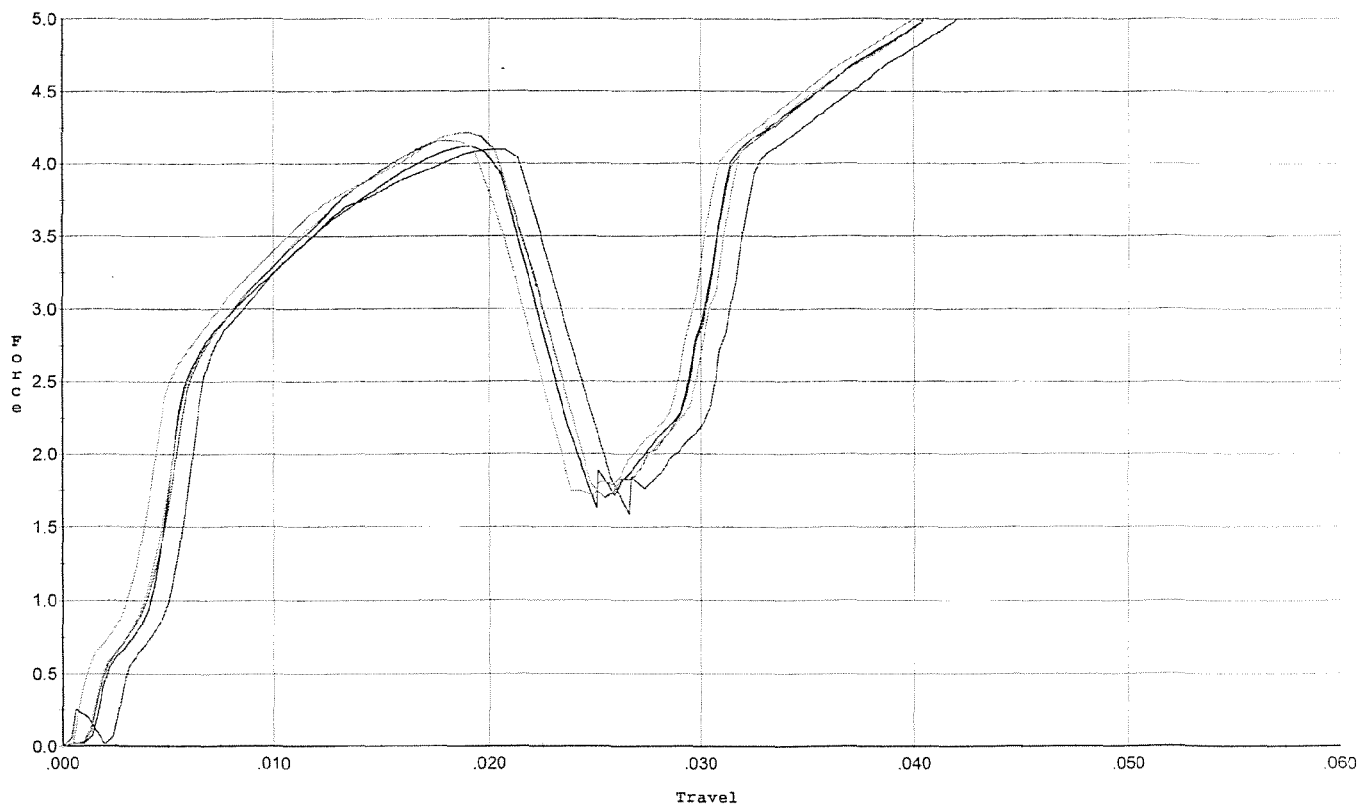
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.658	0.019	0.00	0.028	0.035		Set Trigger
2	2.650	0.019	0.00	0.028	0.035		Set Trigger
3	2.722	0.017	0.00	0.028	0.033		Set Trigger
4	2.726	0.018	0.00	0.028	0.035		Set Trigger
5	2.750	0.019	0.00	0.029	0.034		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.096	0.021	0.002	0.024	0.055		Set Trigger
2	4.117	0.021	0.00	0.025	0.054		Set Trigger
3	4.213	0.022	0.00	0.025	0.059		Set Trigger
4	4.215	0.022	0.00	0.025	0.059		Set Trigger
5	4.161	0.021	0.00	0.025	0.057		Set Trigger

A-4.16