

56794523

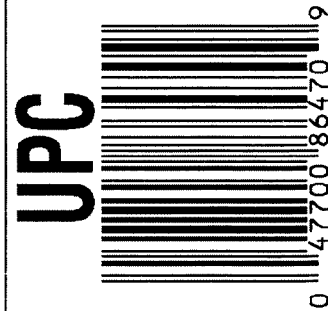
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6794523



GUN SERIAL #

G 6794523

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SPD
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SPD
460	CHECK HEADSPACE		11-3-08	SPD
470	DIS-ASSEMBLE ACTION		11-3-08	SPD
472	SERIALIZE BOLT HANDLE		11-4-08	Rgn
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	(B)
490	MAGNAFLUX BOLT		11/3/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/8	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-21-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

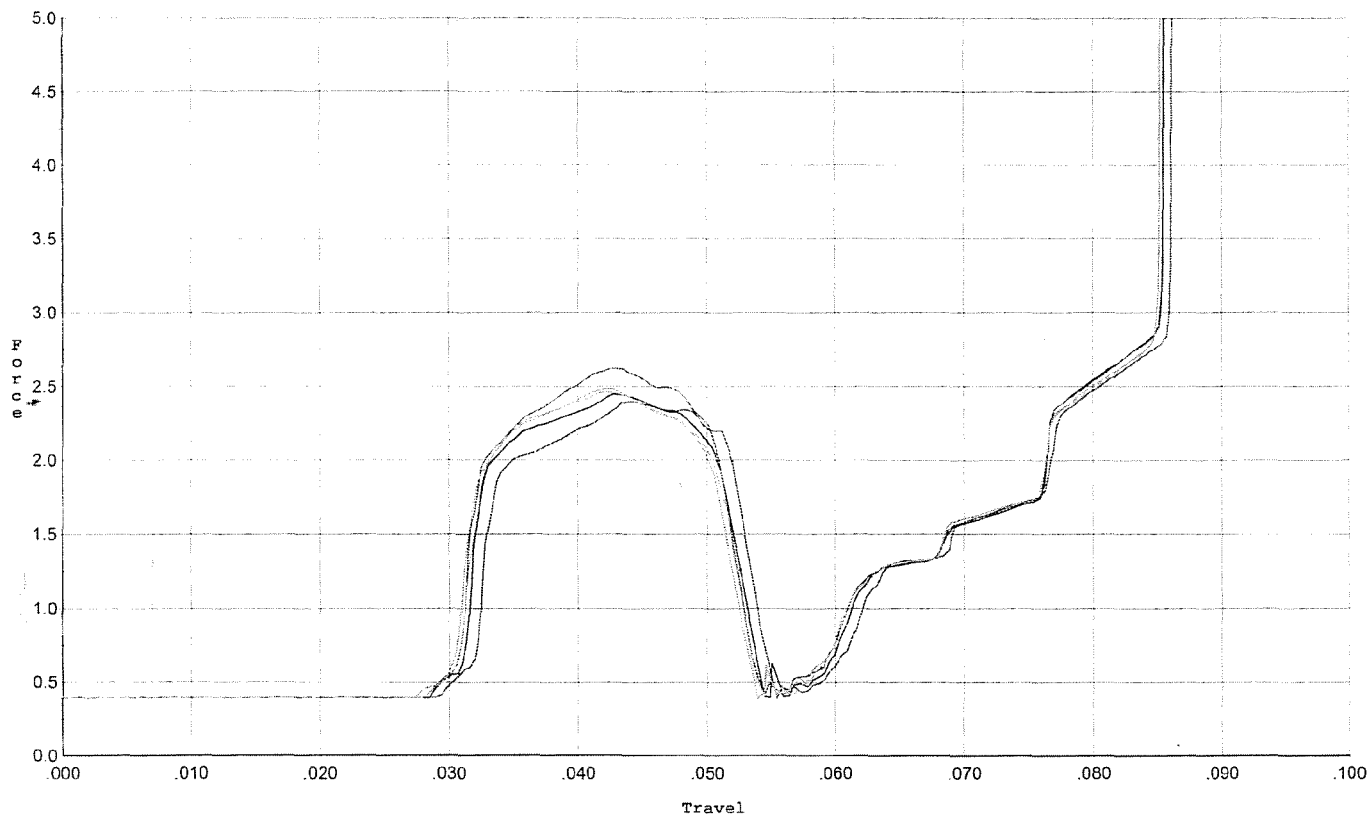
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	12-16-08	RJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>59</u> <u>50</u> <u>50</u>	12-16-08	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	12-16-08	RJ
	J) ASSEMBLE STOCK		12-21-08	RJ
	K) ASSEMBLE SWIVEL STUDS		12-16-08	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	12-15-08	RJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION <u>A</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-15-08	TE
670	FINAL INSPECTION A) HEADSPACE		12-16-08	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.79</u> <u>2.77</u> <u>2.84</u> <u>2.67</u>	12-15-08	TE
	C) FUNCTION		12-16-08	RJ
690	PACK		12-18-08	RJ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/18/2008

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



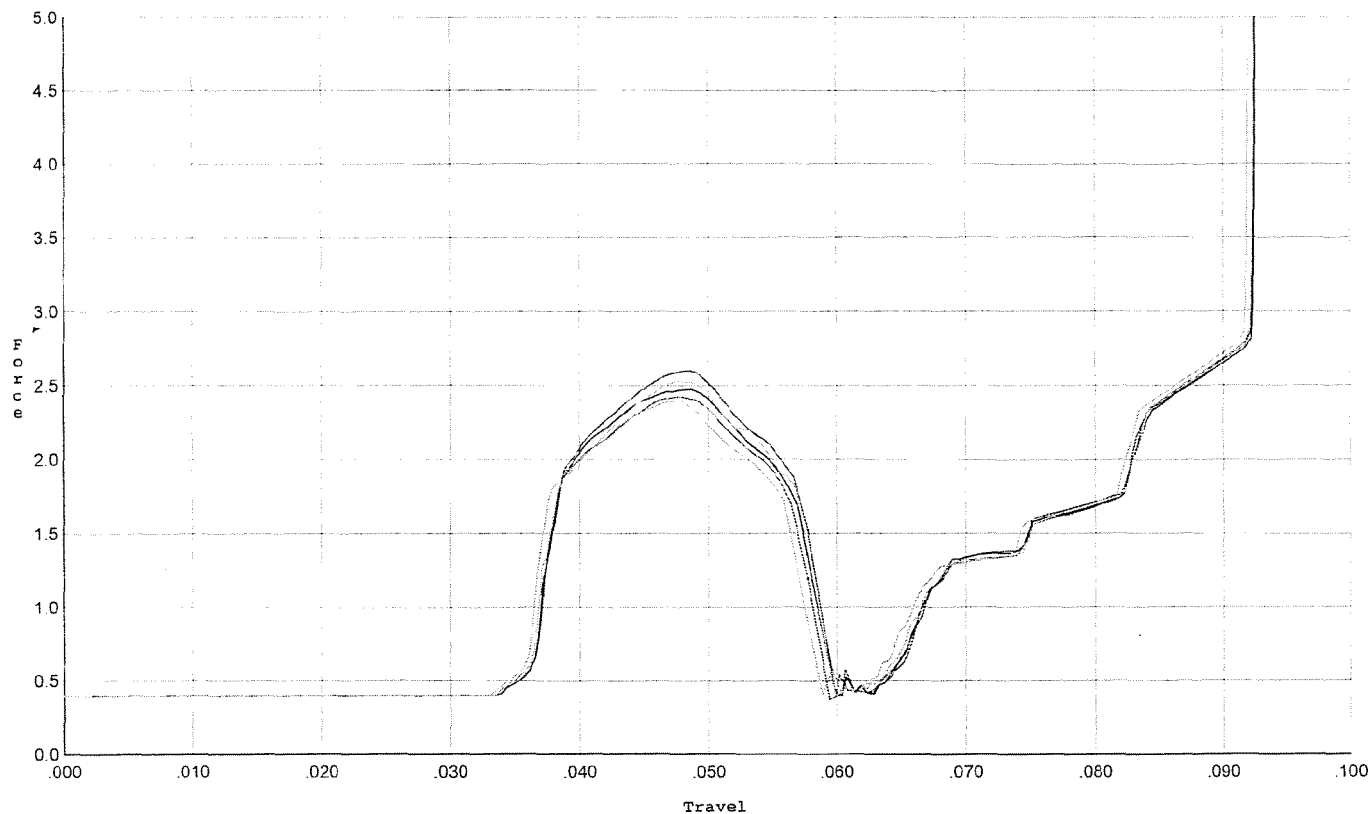
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.398	0.052	0.032	0.037	0.056		Set Trigger
2	2.447	0.053	0.029	0.037	0.058		Set Trigger
3	2.621	0.051	0.031	0.037	0.059		Set Trigger
4	2.464	0.051	0.031	0.037	0.057		Set Trigger
5	2.483	0.051	0.030	0.037	0.057		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



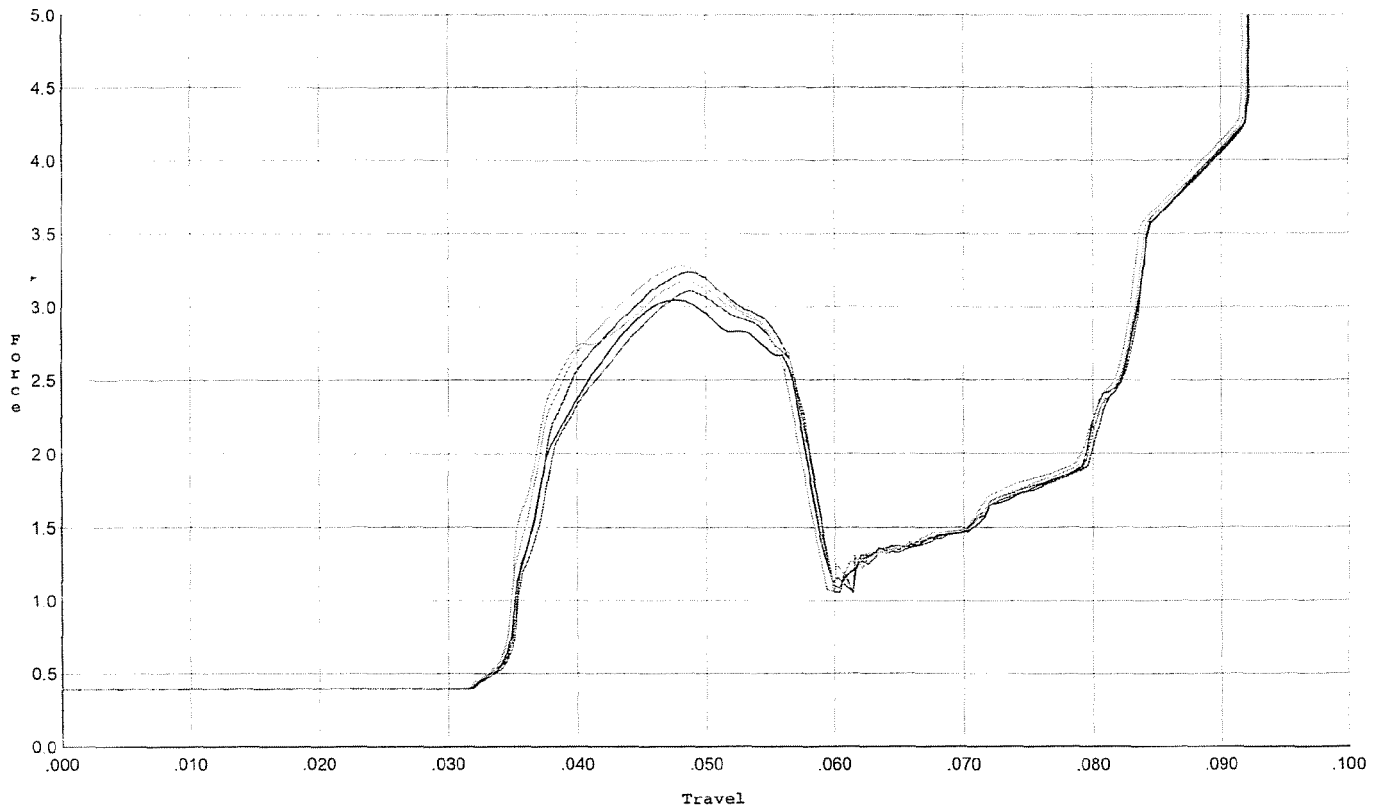
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.058	0.037	0.039	0.061		Set Trigger
2	2.474	0.057	0.037	0.039	0.058		Set Trigger
3	2.426	0.058	0.036	0.040	0.058		Set Trigger
4	2.530	0.057	0.036	0.040	0.058		Set Trigger
5	2.399	0.056	0.036	0.040	0.056		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



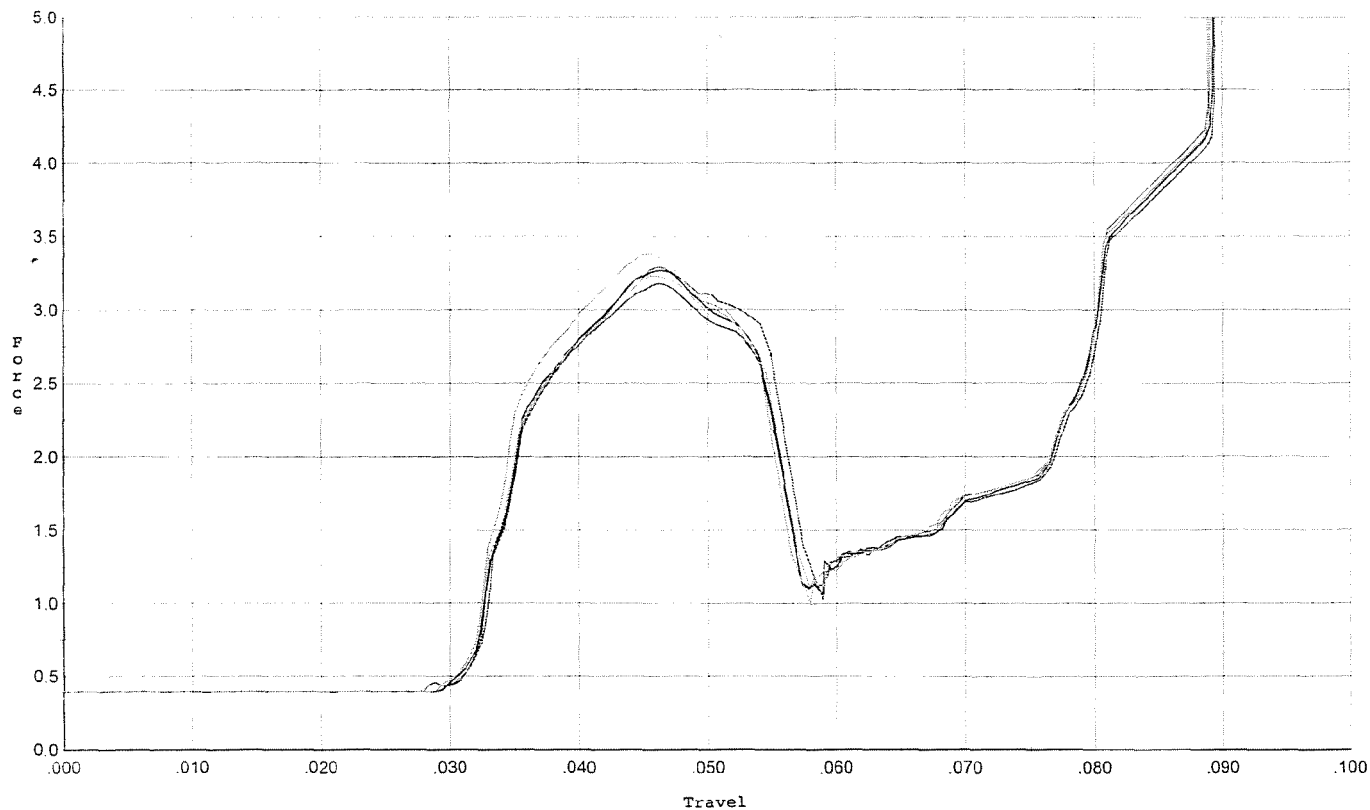
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.241	0.058	0.035	0.038	0.076		Set Trigger
2	3.047	0.057	0.035	0.038	0.071		Set Trigger
3	3.109	0.058	0.035	0.038	0.072		Set Trigger
4	3.176	0.056	0.034	0.037	0.075		Set Trigger
5	3.282	0.056	0.034	0.038	0.074		Set Trigger

A-3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



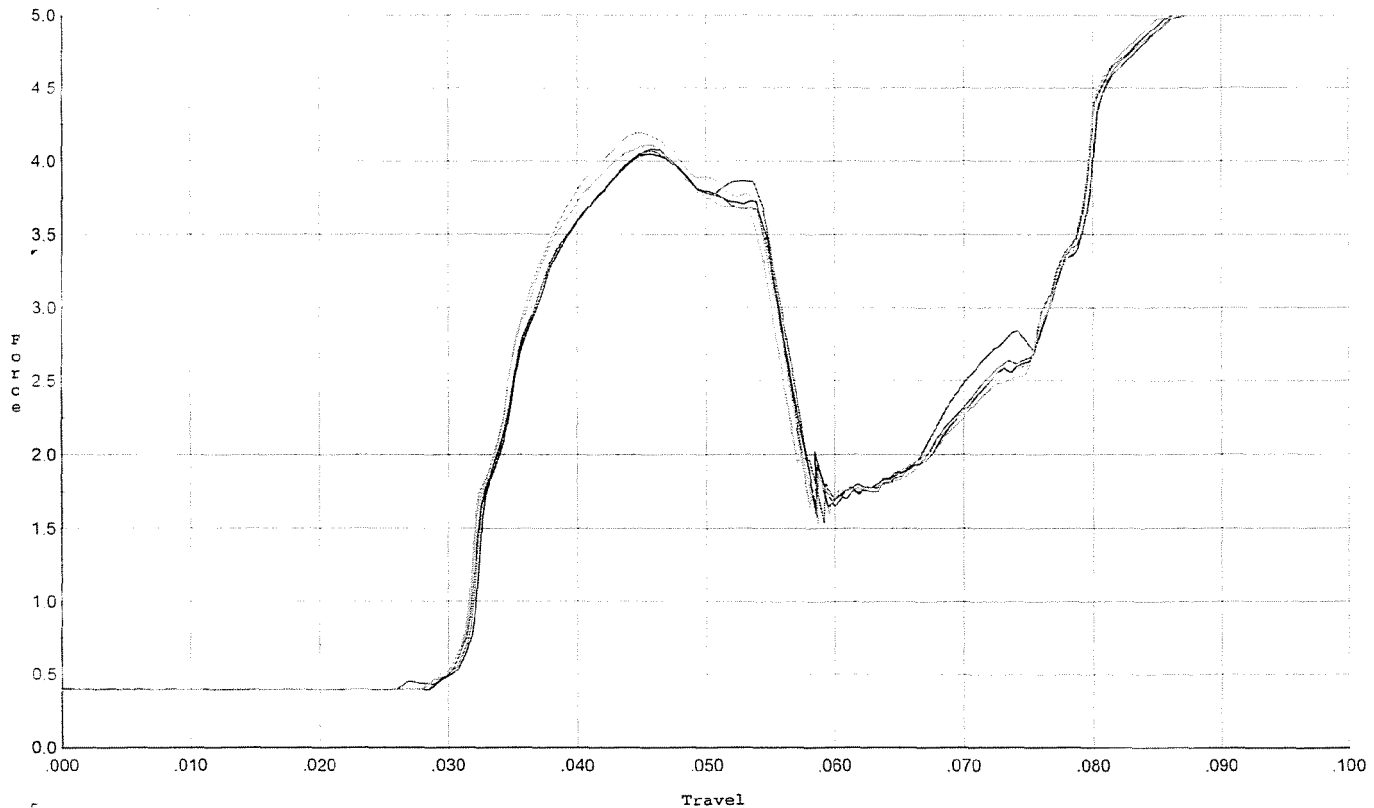
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.181	0.055	0.032	0.037	0.073		Set Trigger
2	3.269	0.055	0.032	0.036	0.074		Set Trigger
3	3.290	0.055	0.032	0.036	0.075		Set Trigger
4	3.231	0.055	0.032	0.036	0.074		Set Trigger
5	3.384	0.054	0.032	0.037	0.075		Set Trigger

A-3-27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



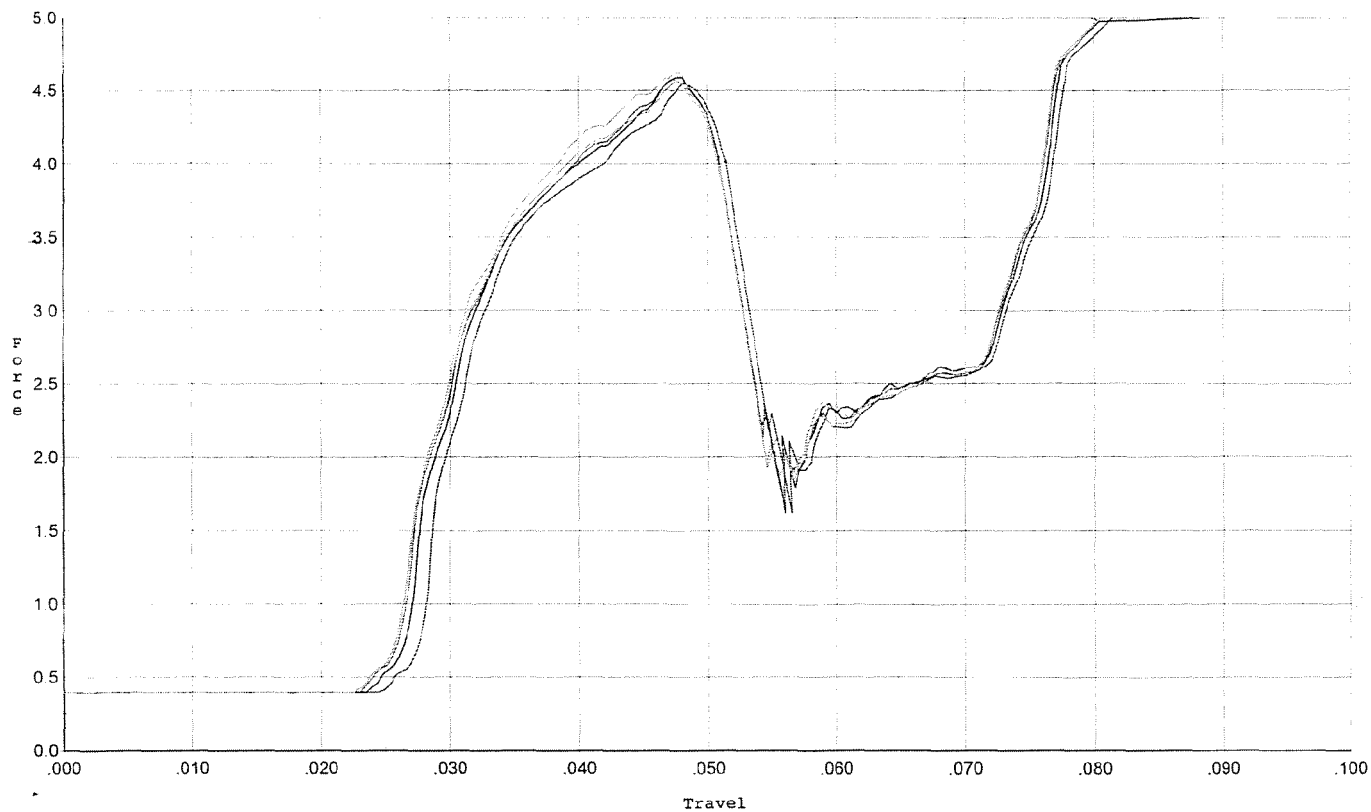
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.081	0.056	0.031	0.034	0.096		Set Trigger
2	4.045	0.055	0.031	0.035	0.092		Set Trigger
3	4.067	0.055	0.031	0.035	0.093		Set Trigger
4	4.110	0.054	0.031	0.035	0.093		Set Trigger
5	4.193	0.055	0.031	0.034	0.096		Set Trigger

A.4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/18/2008

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



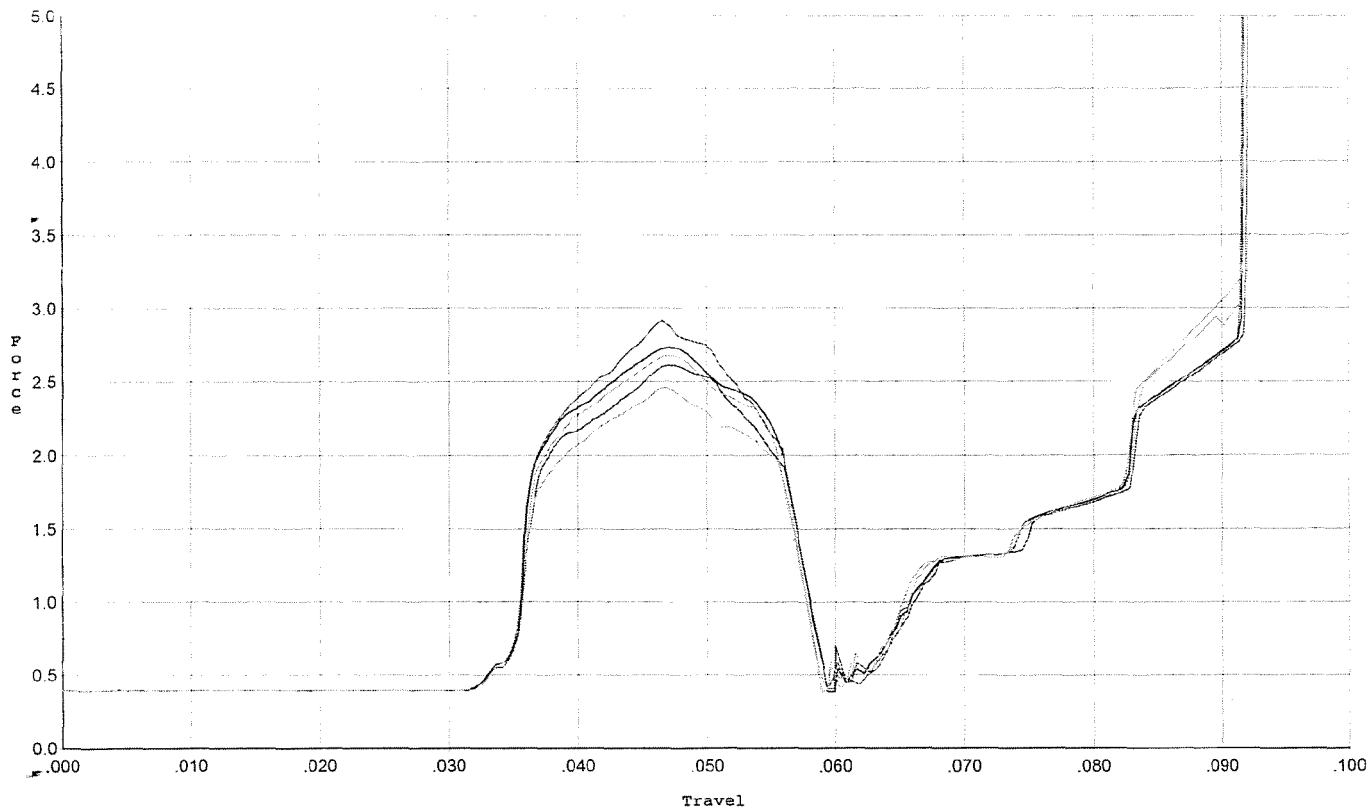
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.543	0.051	0.027	0.033	0.098		Set Trigger
2	4.585	0.051	0.025	0.033	0.099		Set Trigger
3	4.582	0.051	0.026	0.033	0.101		Set Trigger
4	4.622	0.051	0.024	0.033	0.103		Set Trigger
5	4.566	0.051	0.025	0.033	0.101		Set Trigger

A-4.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



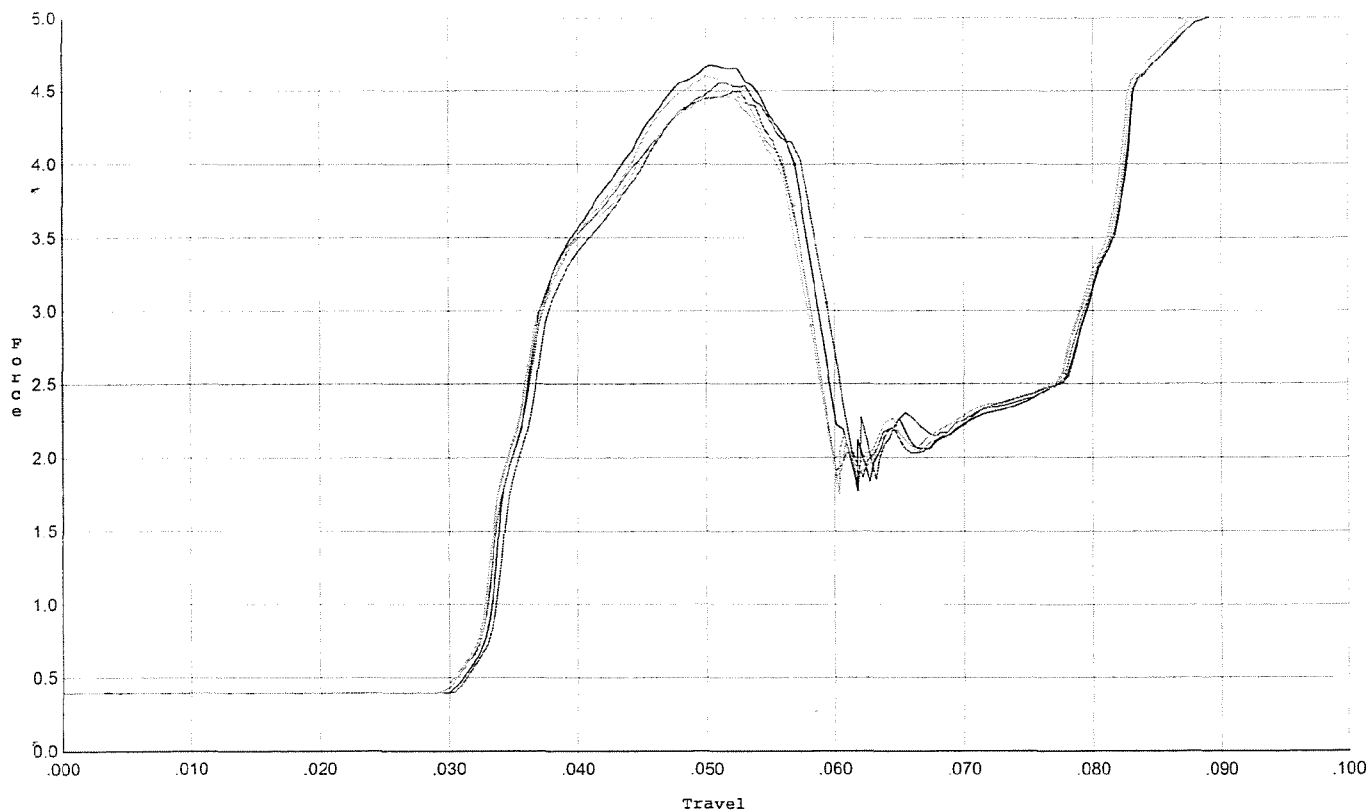
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.611	0.056	0.035	0.039	0.061		Set Trigger
2	2.733	0.056	0.035	0.039	0.064		Set Trigger
3	2.914	0.056	0.035	0.039	0.065		Set Trigger
4	2.676	0.057	0.035	0.039	0.063		Set Trigger
5	2.461	0.056	0.035	0.039	0.059		Set Trigger

A-267

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/18/2008

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	4.554	0.059	0.032	0.034	0.108		Set Trigger
2	4.677	0.057	0.032	0.035	0.106		Set Trigger
3	4.496	0.057	0.032	0.035	0.103		Set Trigger
4	4.464	0.058	0.032	0.035	0.104		Set Trigger
5	4.596	0.057	0.031	0.034	0.104		Set Trigger

A-21-SS