

5680 1386

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

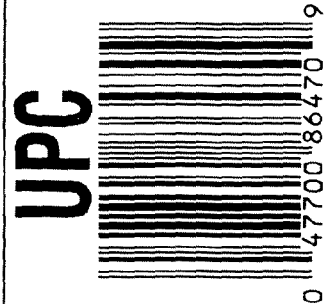


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801386



BM FORM

GUN SERIAL #

G 680 1386

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SPD
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SPD
460	CHECK HEADSPACE		10-21-08	SPD
470	DIS-ASSEMBLE ACTION		10-21-08	SPD
472	SERIALIZE BOLT HANDLE		10-22-08	SPD
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION		10/24/08	(RB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-29-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-13-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

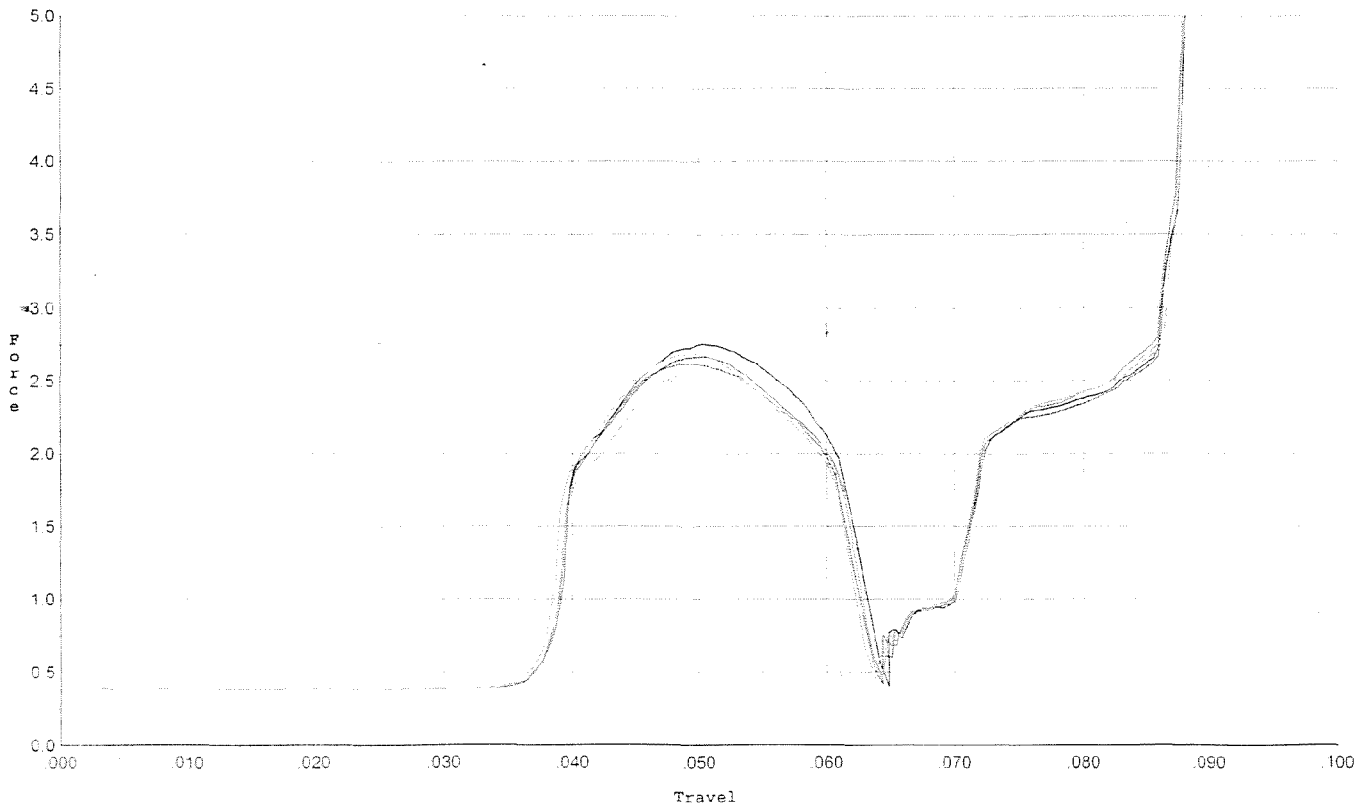
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>35</u> <u>35</u> <u>3.0</u>	1-20-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	1-20-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-20-09	L.H.
	J) ASSEMBLE STOCK		1-13-09	Ran
	K) ASSEMBLE SWIVEL STUDS		1-20-09	L.N.
	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	1-19-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-19-09	W/H
670	FINAL INSPECTION A) HEADSPACE		1-20-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>244</u> <u>235</u> <u>242</u> <u>236</u> <u>240</u>	1-20-09	L.P.
	C) FUNCTION		1-20-09	L.P.
690	PACK		1-21-09	RSN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/12/2009

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



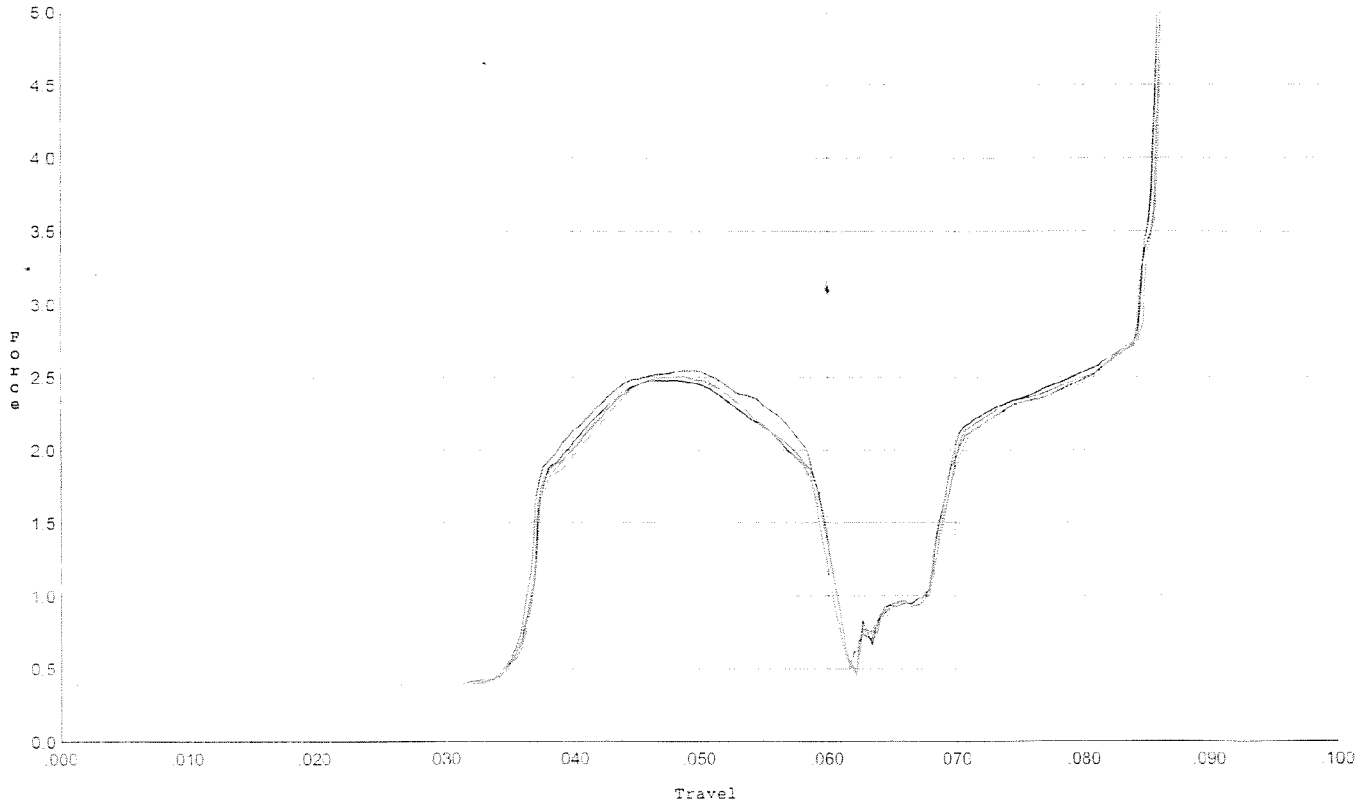
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.667	0.061	0.038	0.033	0.067		Set Trigger
2	2.757	0.062	0.038	0.032	0.071		Set Trigger
3	2.615	0.061	0.038	0.033	0.066		Set Trigger
4	2.564	0.061	0.038	0.033	0.066		Set Trigger
5	2.688	0.061	0.038	0.033	0.067		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/12/2009

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



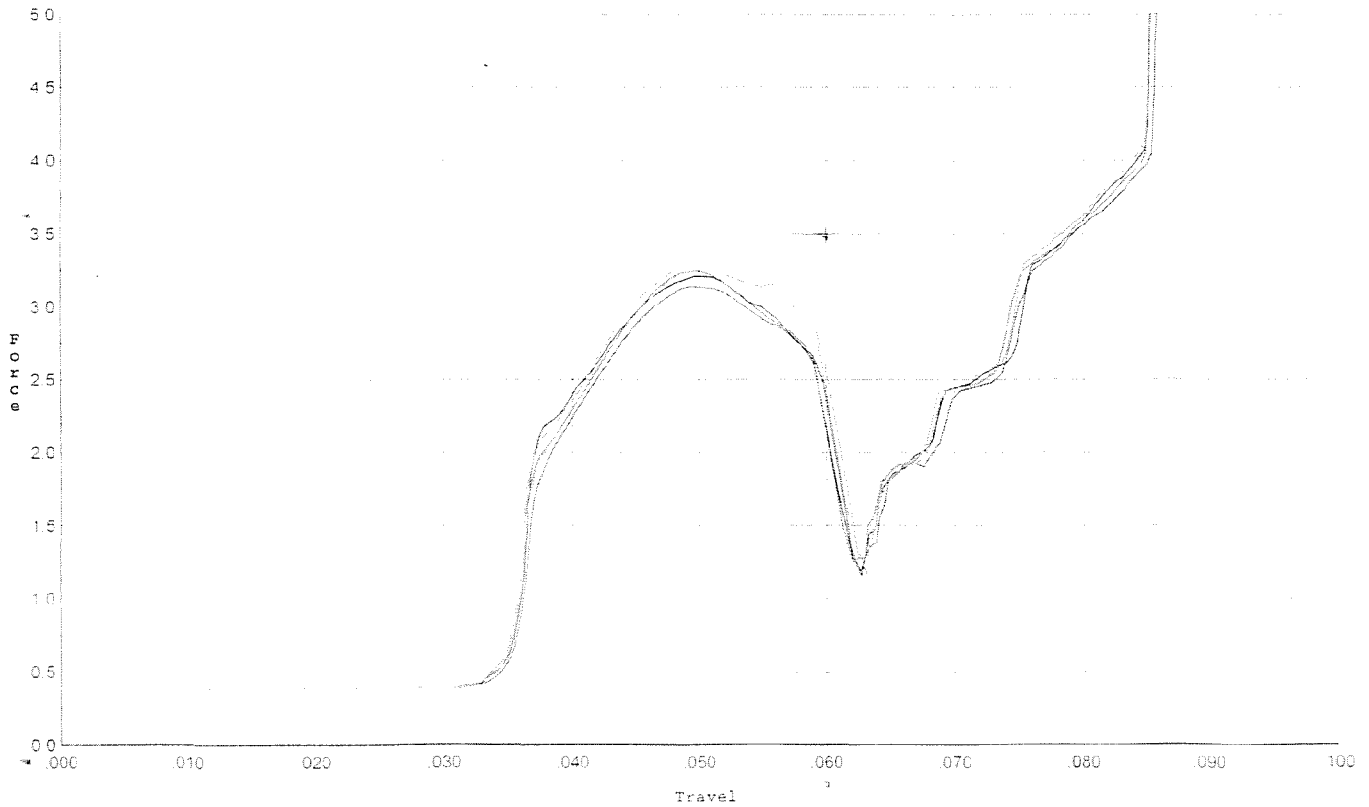
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.060	0.035	0.033	0.067		Set Trigger
2	2.479	0.059	0.036	0.033	0.064		Set Trigger
3	2.507	0.059	0.036	0.033	0.065		Set Trigger
4	2.526	0.059	0.036	0.033	0.064		Set Trigger
5	2.506	0.060	0.035	0.033	0.064		Set Trigger

A 2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/12/2009

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



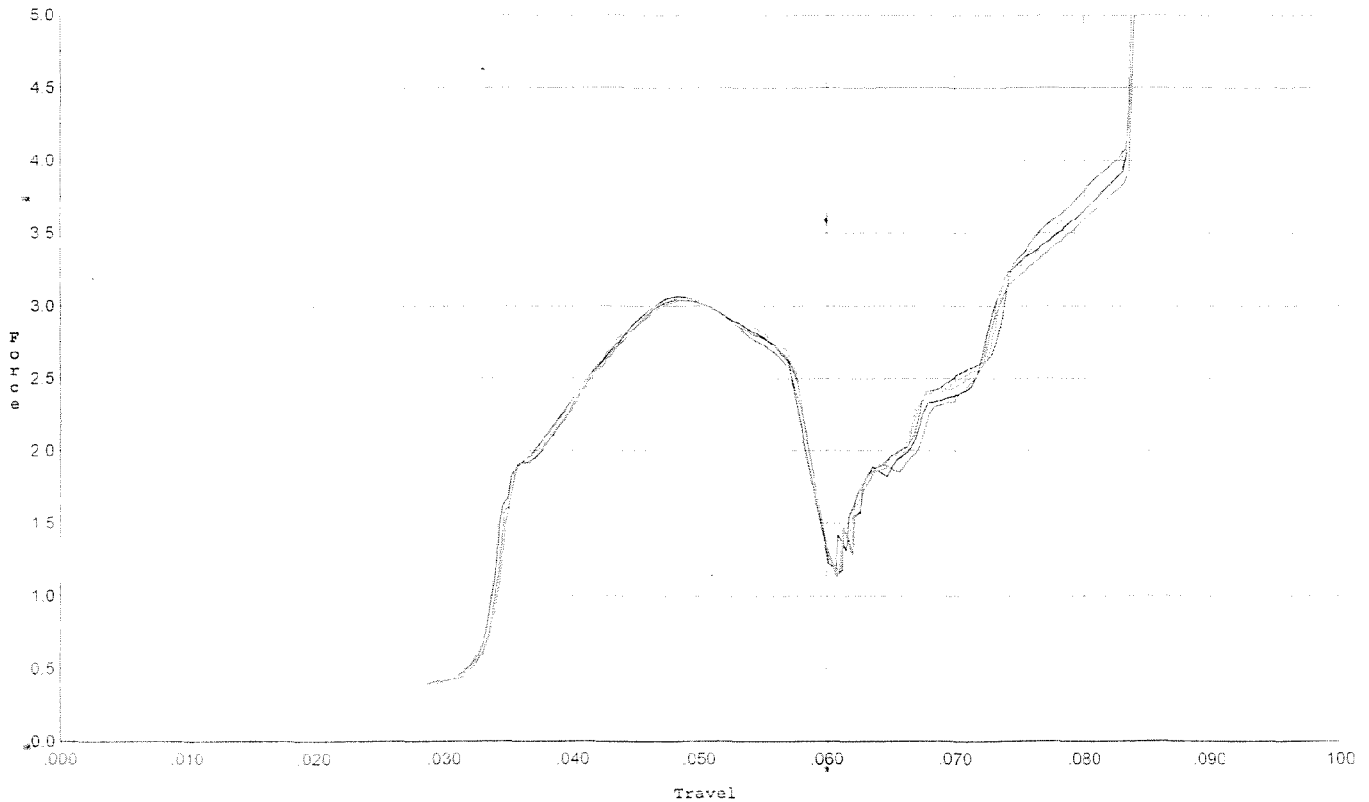
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.060	0.035	0.031	0.079		Set Trigger
2	3.208	0.059	0.035	0.031	0.079		Set Trigger
3	3.242	0.059	0.035	0.031	0.079		Set Trigger
4	3.251	0.059	0.035	0.031	0.081		Set Trigger
5	3.297	0.060	0.035	0.030	0.085		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/12/2009

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



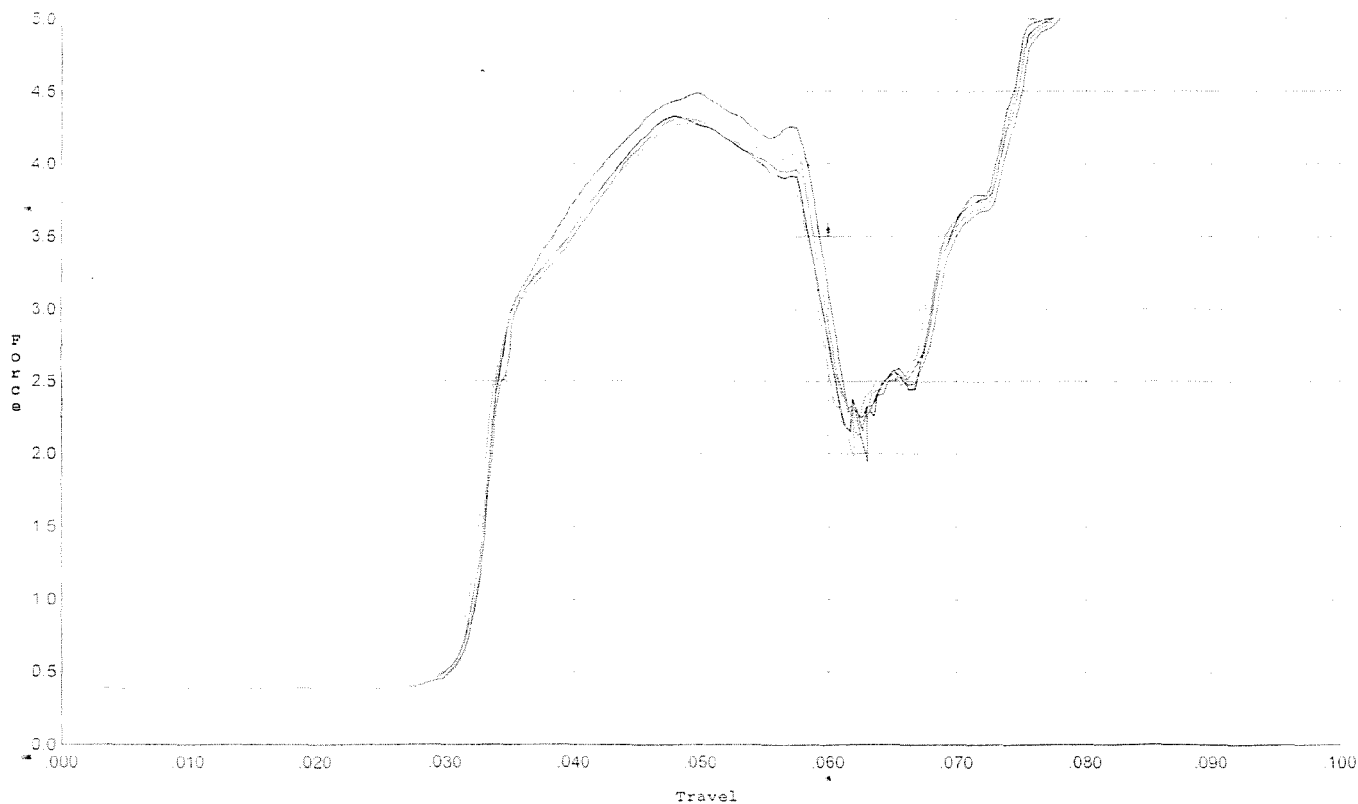
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.050	0.058	0.033	0.031	0.075		Set Trigger
2	3.066	0.057	0.033	0.032	0.075		Set Trigger
3	3.038	0.058	0.033	0.031	0.076		Set Trigger
4	3.045	0.058	0.033	0.031	0.075		
5	3.053	0.058	0.033	0.031	0.076		

A-3.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/12/2009

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



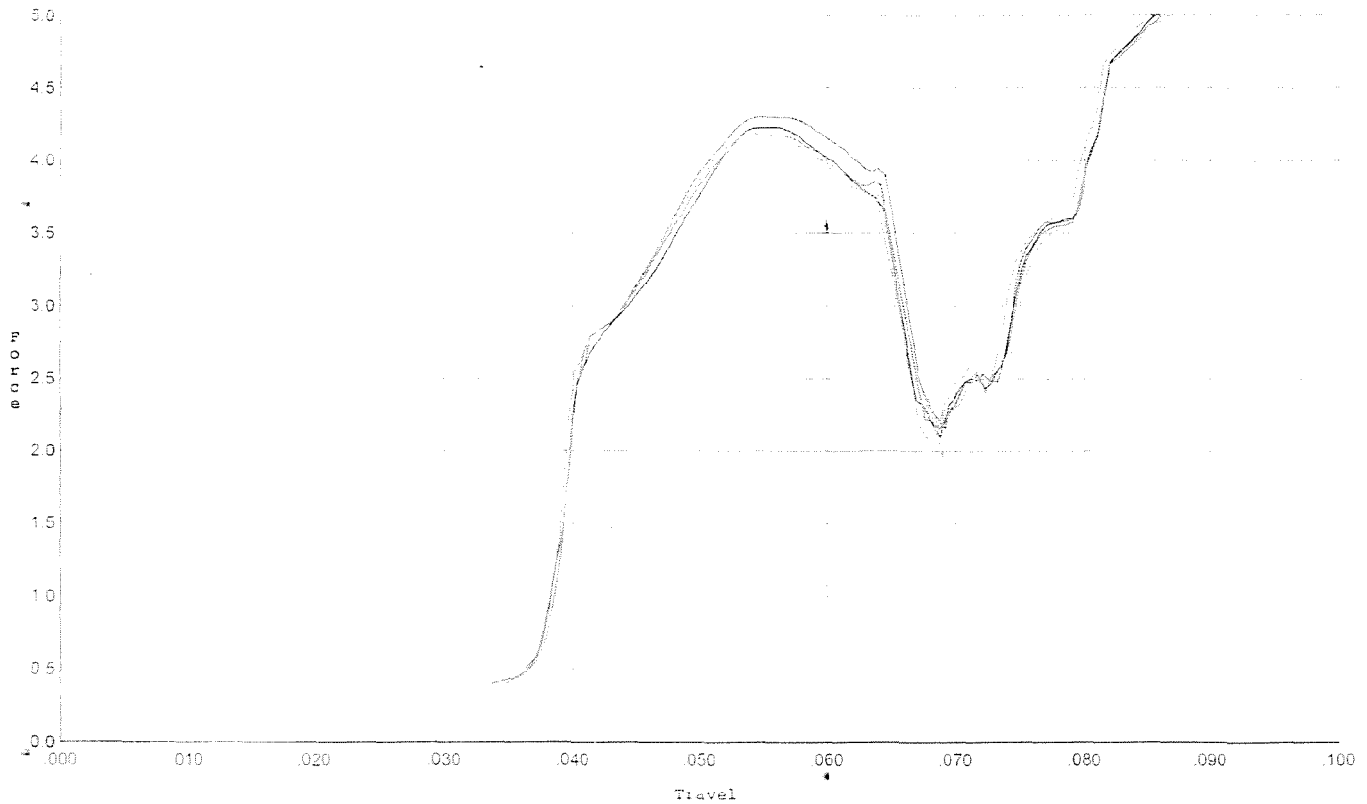
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.484	0.058	0.031	0.027	0.115		Set Trigger
2	4.327	0.059	0.031	0.028	0.112		Set Trigger
3	4.312	0.058	0.032	0.028	0.109		Set Trigger
4	4.312	0.058	0.031	0.028	0.109		Set Trigger
5	4.285	0.058	0.031	0.028	0.110		Set Trigger

A-434

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/12/2009

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



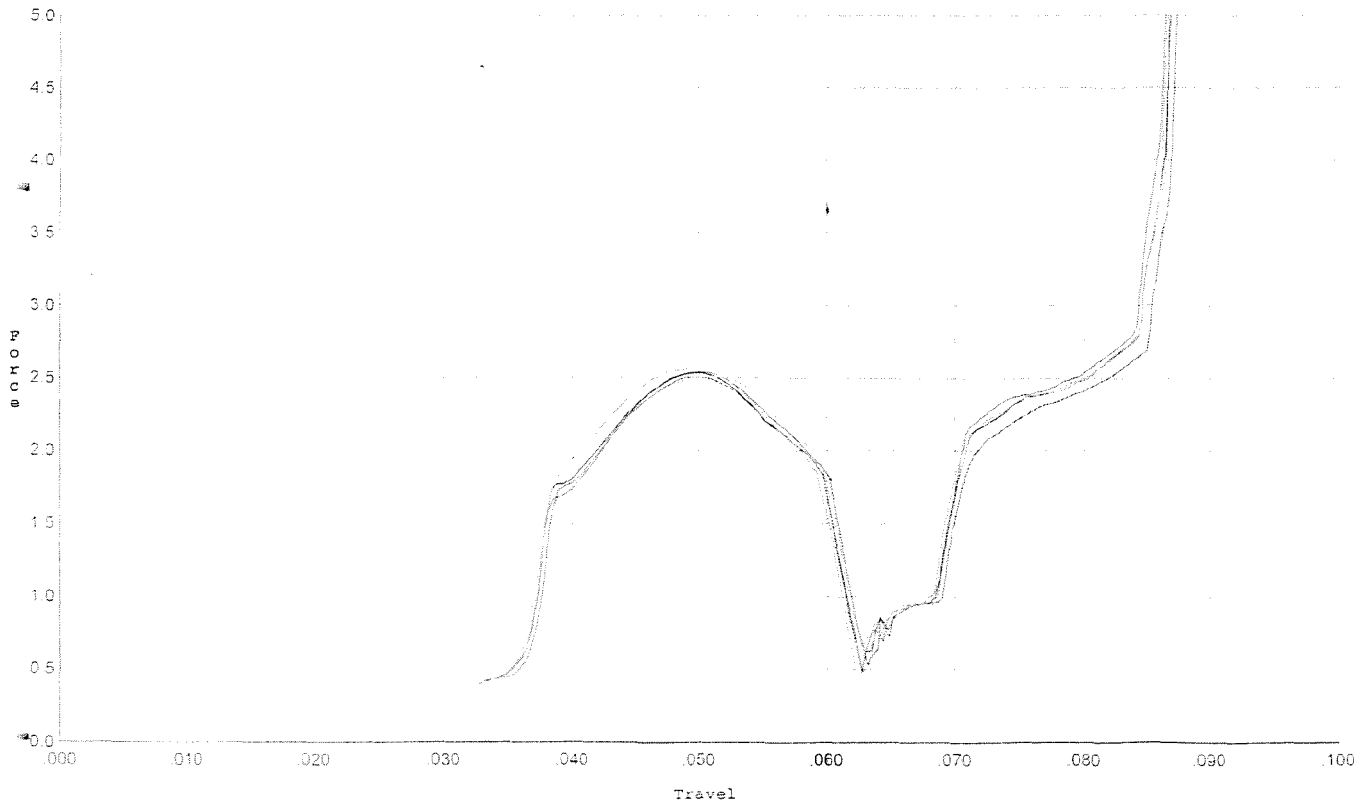
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.298	0.065	0.038	0.028	0.112		Set Trigger
2	4.221	0.064	0.037	0.029	0.109		Set Trigger
3	4.180	0.064	0.038	0.029	0.109		Set Trigger
4	4.154	0.064	0.038	0.029	0.109		Set Trigger
5	4.179	0.065	0.037	0.028	0.111		Set Trigger

A 4.20

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/12/2009

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



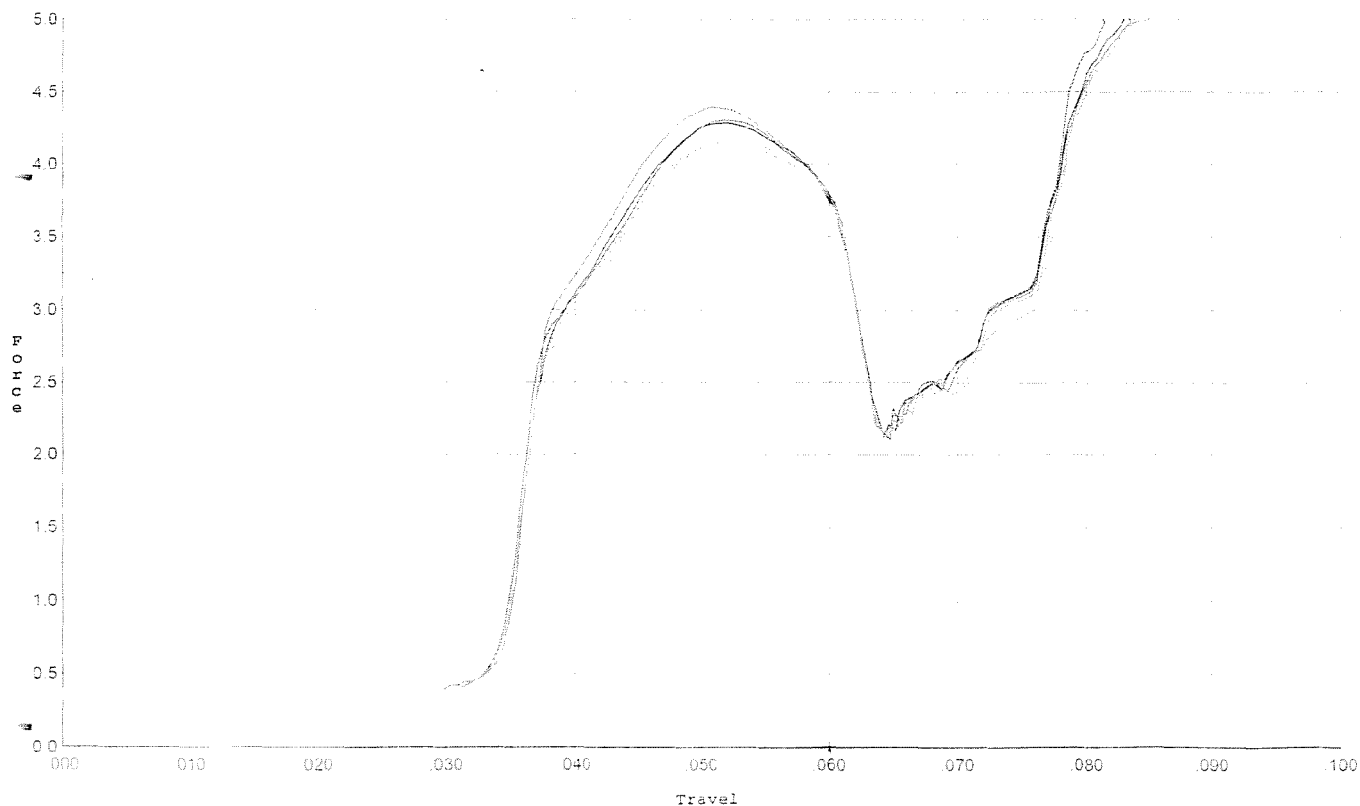
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.060	0.037	0.033	0.065		Set Trigger
2	2.534	0.060	0.036	0.033	0.064		Set Trigger
3	2.509	0.060	0.036	0.033	0.064		Set Trigger
4	2.514	0.061	0.036	0.033	0.065		
5	2.563	0.060	0.036	0.033	0.066		

A-2-S3

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/12/2009

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	4.304	0.061	0.034	0.029	0.111		Set Trigger
2	4.285	0.061	0.034	0.029	0.110		Set Trigger
3	4.394	0.061	0.034	0.029	0.112		Set Trigger
4	4.188	0.061	0.034	0.029	0.108		Set Trigger
5	4.163	0.061	0.034	0.029	0.108		Set Trigger

A-426