

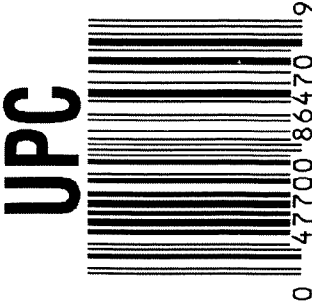
6801404

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

G6801404



BM FORM

GUN SERIAL #

G 6801404

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE		10-22-08	BN
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/24/08	RA
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/24/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-30-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

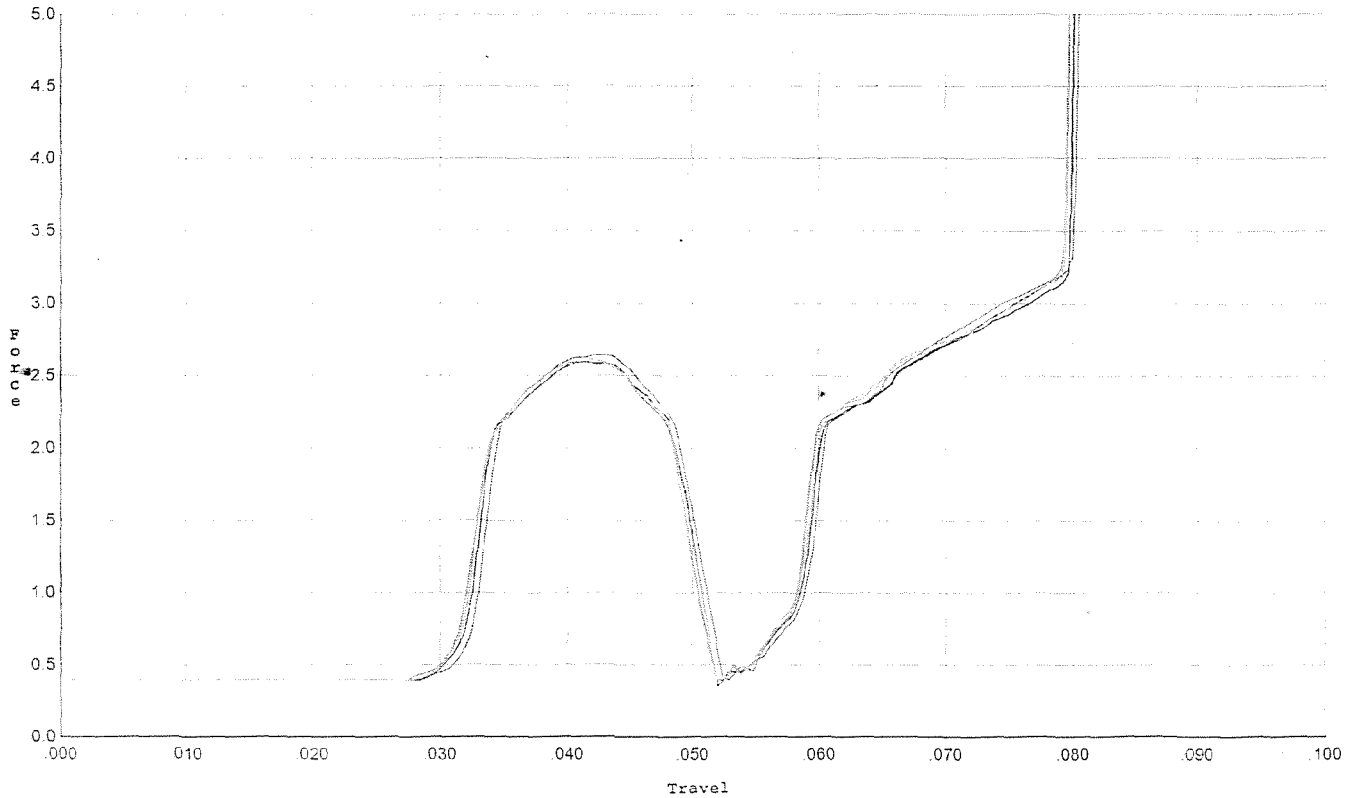
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>5.0</u>	1-16-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	1-16-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	1-16-09	L.N.
	J) ASSEMBLE STOCK		1-8-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		1-16-09	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	1-15-09	L.N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-15-09	TC
670	FINAL INSPECTION A) HEADSPACE		1-16-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.37</u> <u>2.24</u> <u>2.36</u> <u>2.43</u>	1-16-09	TC
	C) FUNCTION		1-16-09	L.N.
690	PACK		1/20/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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



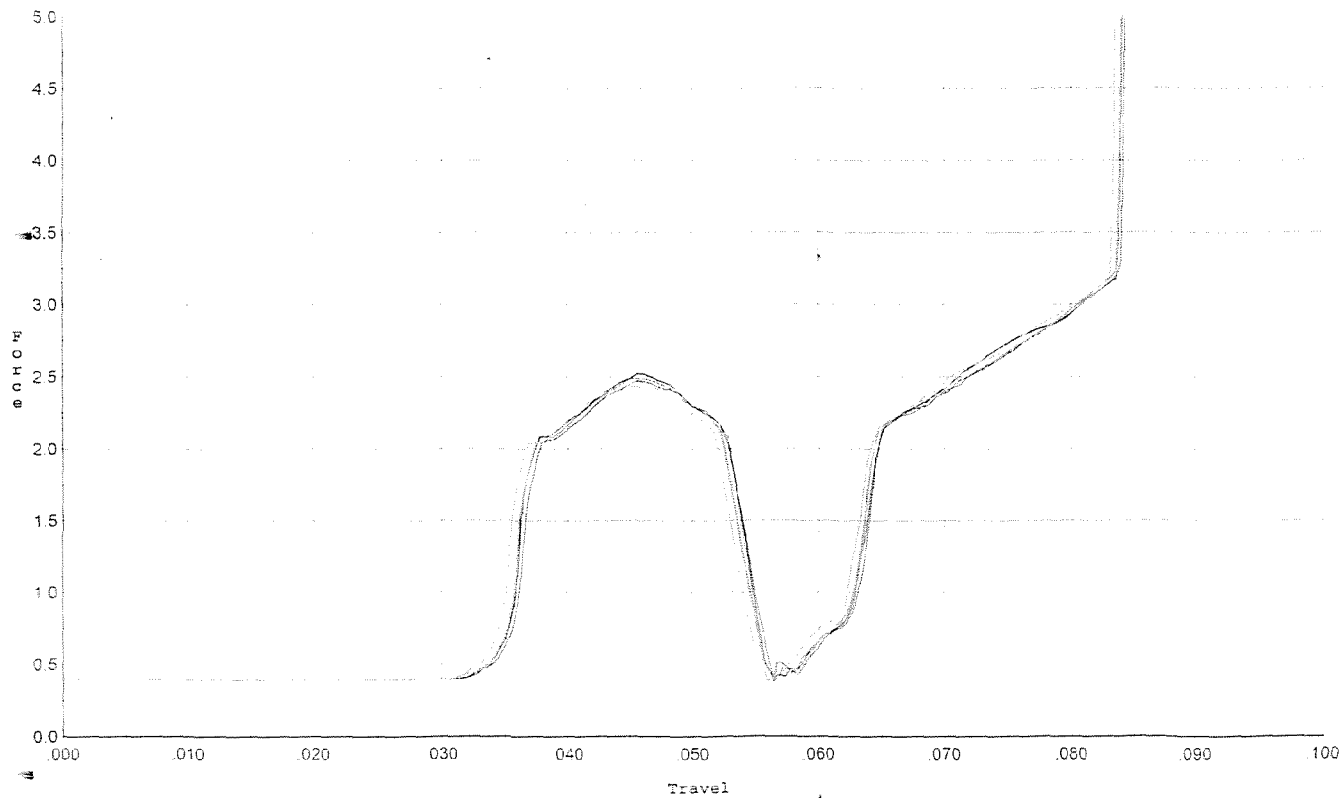
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.643	0.050	0.032	0.034	0.054		Set Trigger
2	2.595	0.049	0.032	0.034	0.053		Set Trigger
3	2.594	0.048	0.031	0.035	0.052		Set Trigger
4	2.596	0.050	0.031	0.034	0.053		Set Trigger
5	2.617	0.048	0.031	0.035	0.052		Set Trigger

A-2.60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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



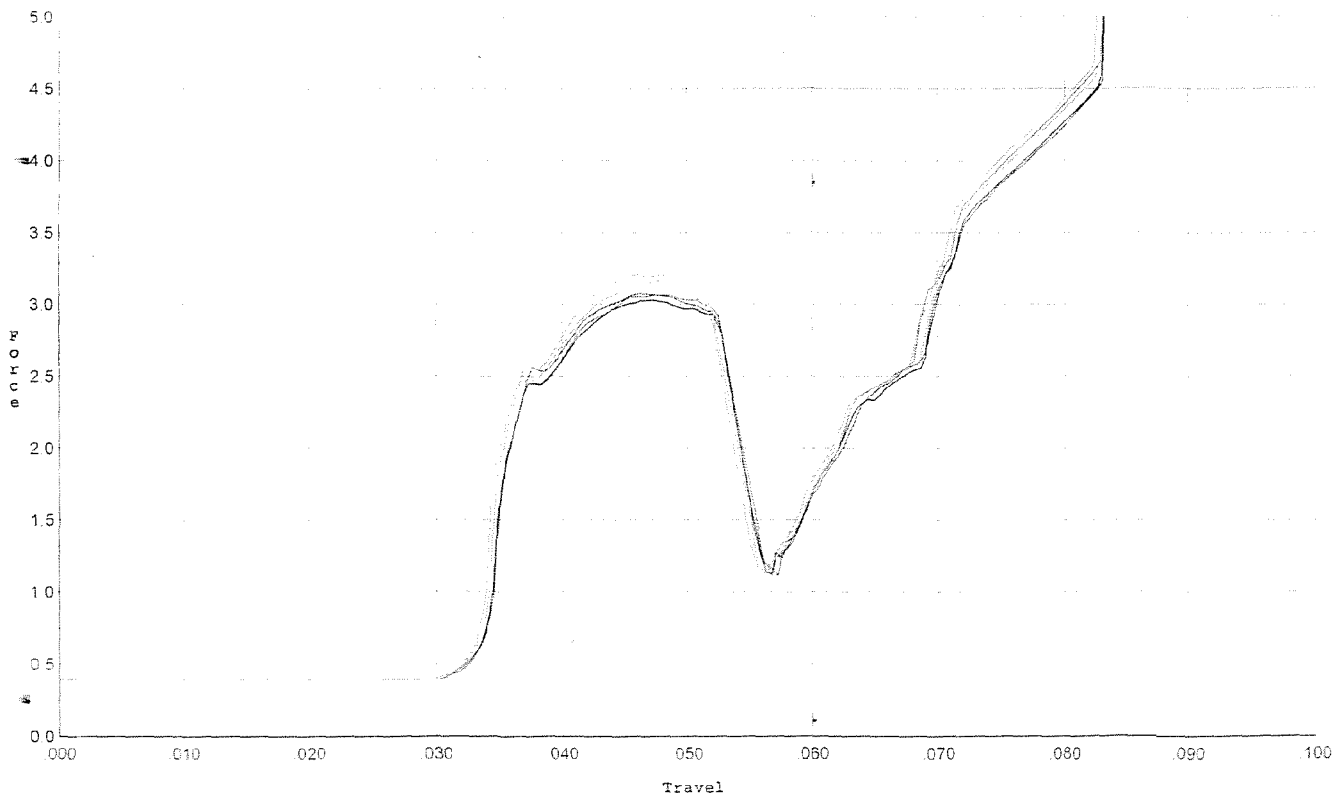
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.053	0.035	0.036	0.053		Set Trigger
2	2.522	0.053	0.035	0.036	0.054		Set Trigger
3	2.485	0.052	0.035	0.036	0.053		Set Trigger
4	2.459	0.054	0.035	0.036	0.054		Set Trigger
5	2.436	0.052	0.034	0.036	0.052		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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



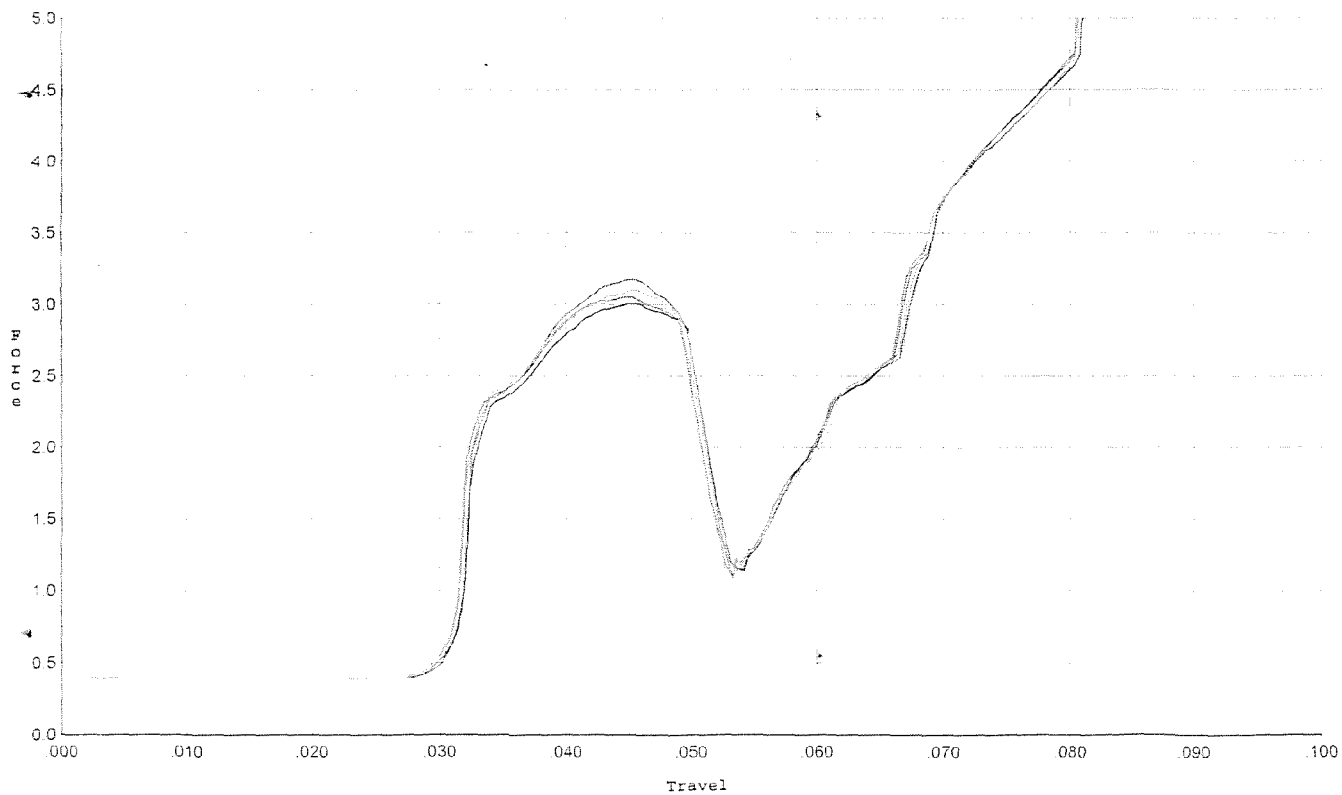
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.074	0.053	0.033	0.035	0.066		Set Trigger
2	3.028	0.053	0.034	0.034	0.065		Set Trigger
3	3.068	0.053	0.034	0.034	0.066		Set Trigger
4	3.207	0.053	0.033	0.034	0.069		Set Trigger
5	3.163	0.052	0.033	0.034	0.066		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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



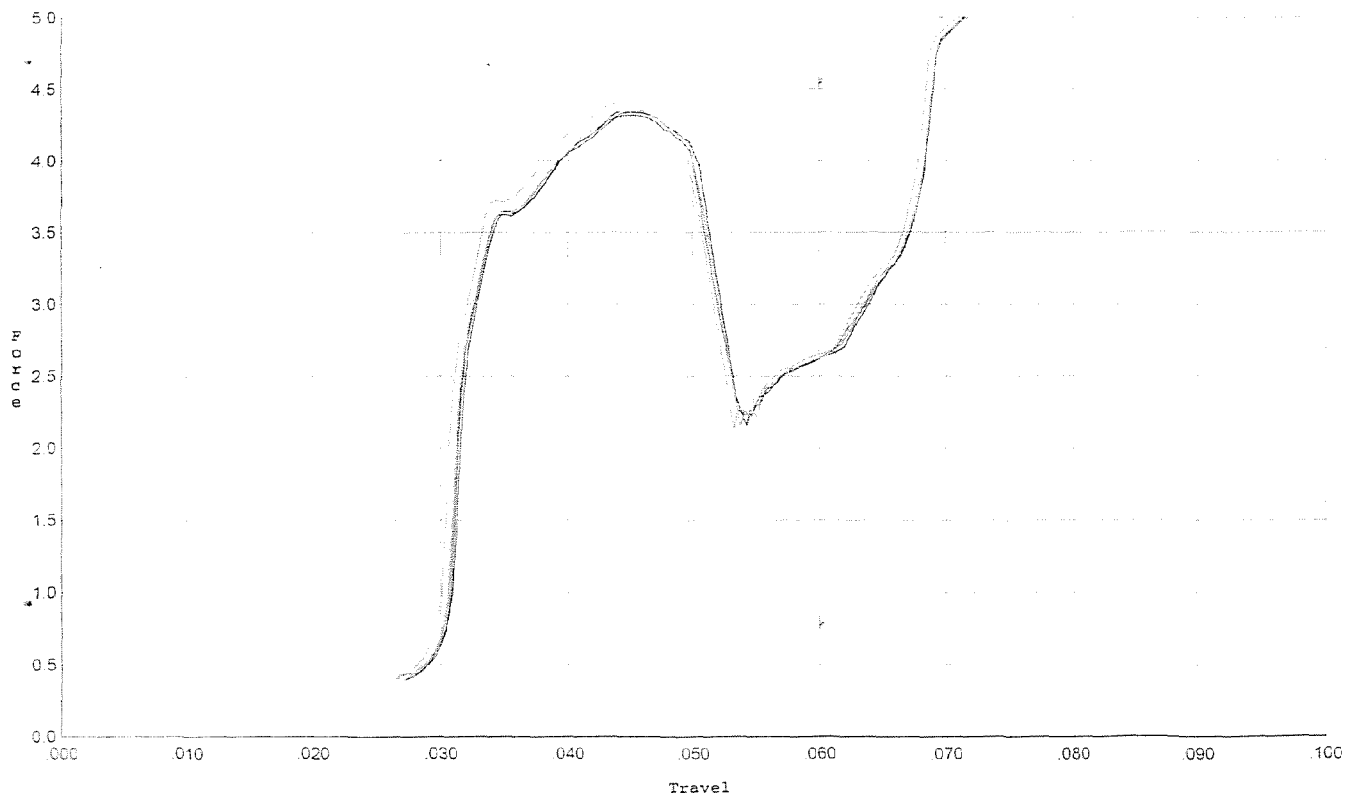
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.050	0.031	0.033	0.064		Set Trigger
2	3.006	0.050	0.031	0.033	0.062		Set Trigger
3	3.051	0.049	0.031	0.033	0.062		Set Trigger
4	3.036	0.050	0.031	0.033	0.063		Set Trigger
5	3.101	0.050	0.031	0.033	0.065		Set Trigger

A-3.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

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



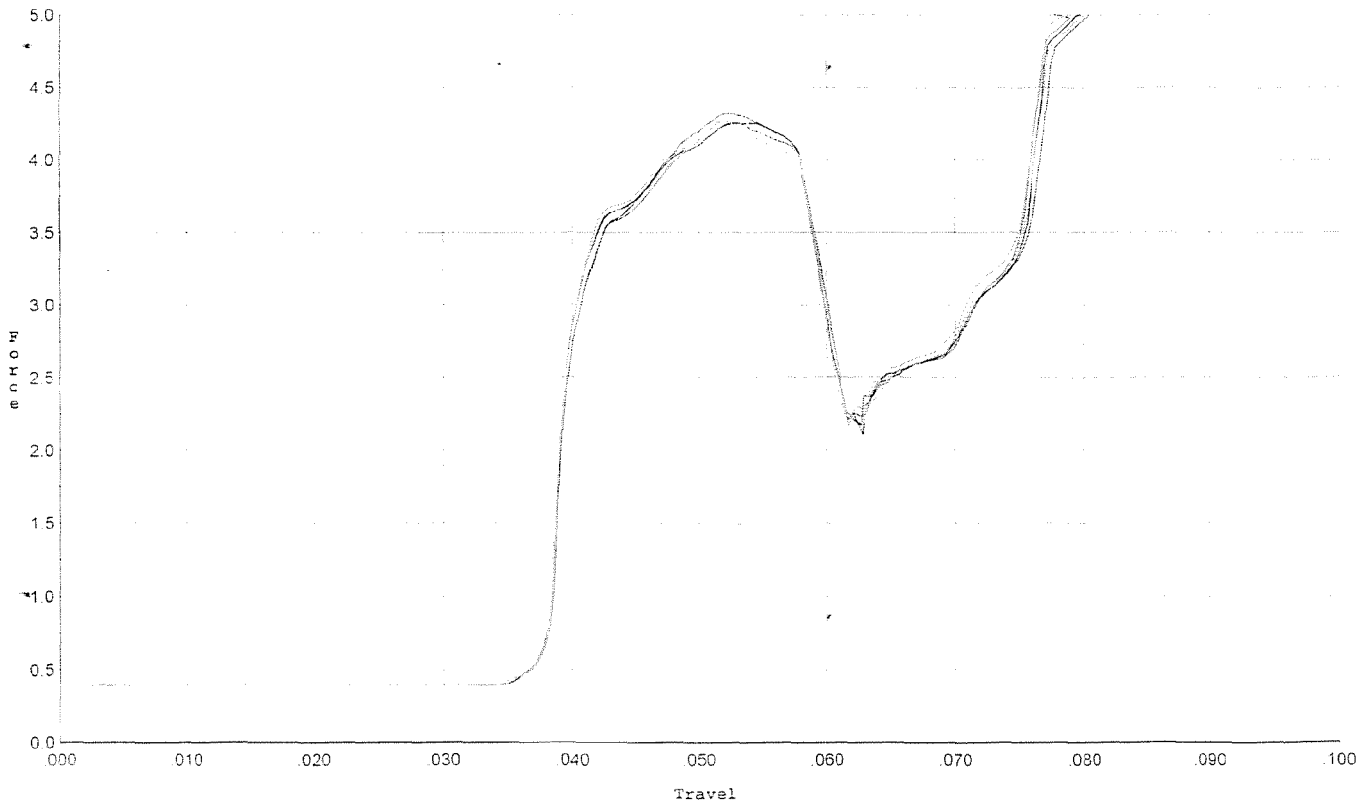
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.315	0.050	0.030	0.031	0.088		Set Trigger
2	4.342	0.050	0.030	0.031	0.090		Set Trigger
3	4.354	0.051	0.030	0.031	0.092		Set Trigger
4	4.350	0.051	0.030	0.031	0.092		Set Trigger
5	4.399	0.050	0.029	0.030	0.093		Set Trigger

17-4-35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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



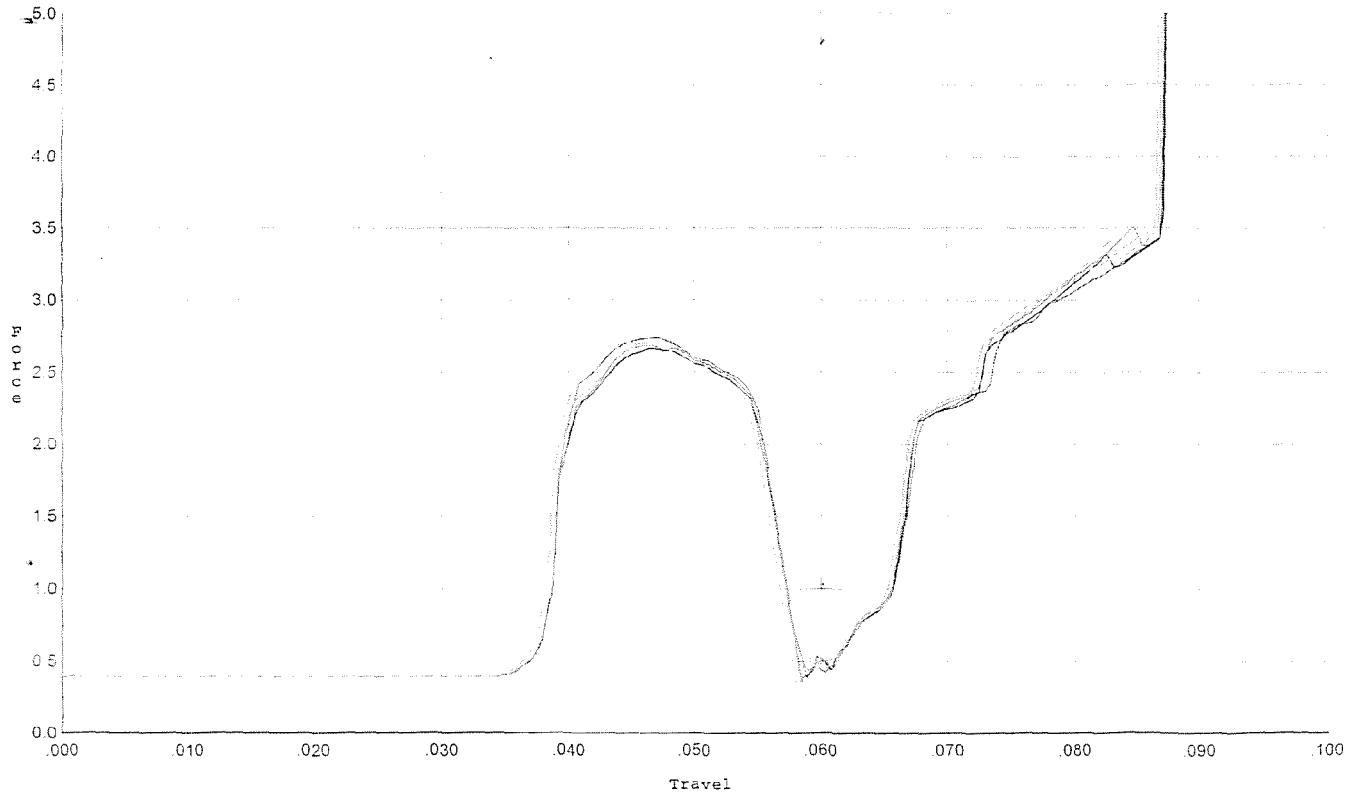
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.320	0.058	0.038	0.033	0.093		Set Trigger
2	4.253	0.060	0.038	0.032	0.096		Set Trigger
3	4.257	0.059	0.038	0.032	0.095		Set Trigger
4	4.284	0.058	0.038	0.033	0.093		Set Trigger
5	4.273	0.058	0.038	0.033	0.093		Set Trigger

A-4.27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/18/2008

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



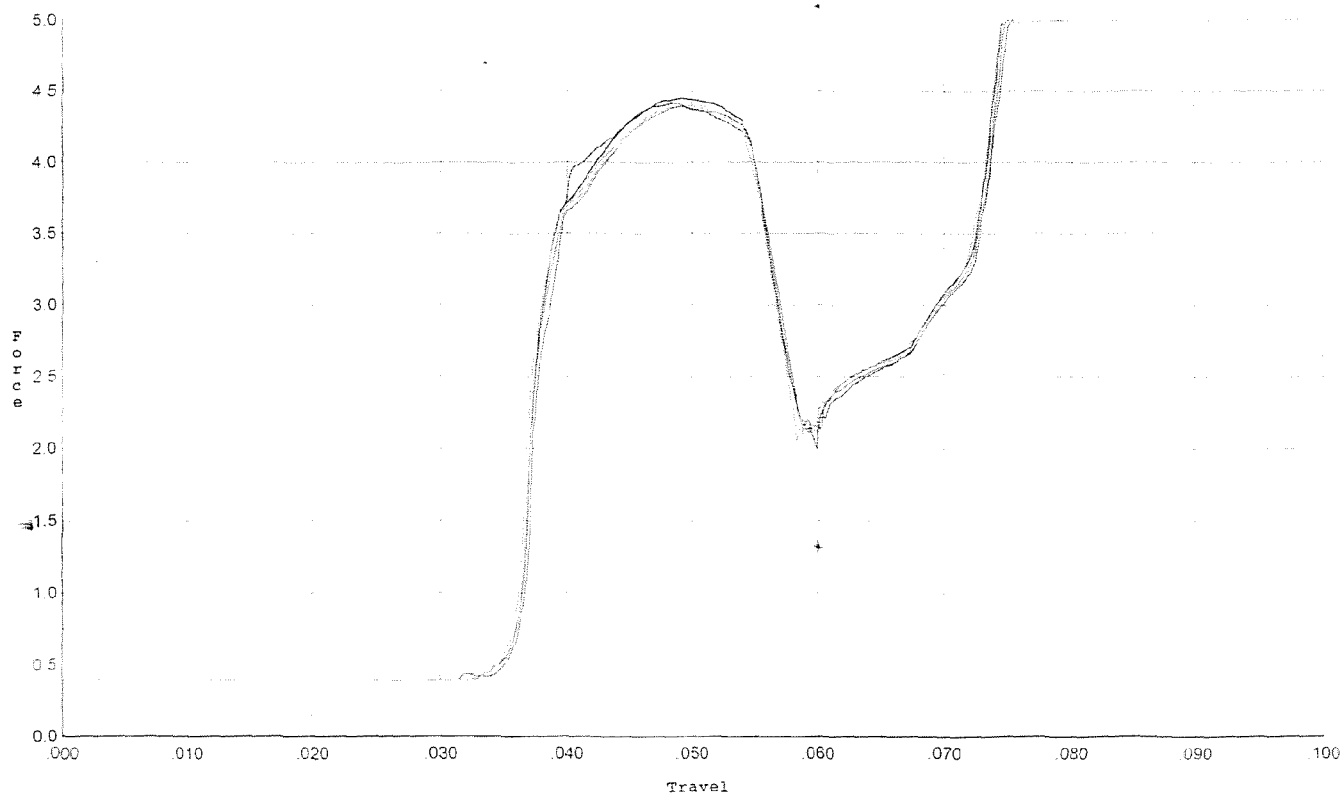
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.747	0.055	0.038	0.038	0.058		Set Trigger
2	2.668	0.055	0.038	0.038	0.057		Set Trigger
3	2.691	0.056	0.038	0.037	0.058		Set Trigger
4	2.707	0.055	0.037	0.037	0.057		
5	2.691	0.055	0.038	0.037	0.057		

A-2.70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/18/2008

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	4.418	0.055	0.036	0.034	0.090		Set Trigger
2	4.451	0.055	0.036	0.033	0.091		Set Trigger
3	4.393	0.055	0.036	0.033	0.090		Set Trigger
4	4.423	0.056	0.036	0.033	0.094		Set Trigger
5	4.418	0.055	0.035	0.033	0.092		Set Trigger

A-4.42