

66801419

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



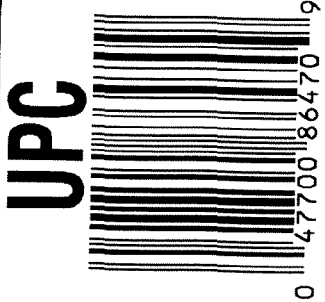
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6801419



GUN SERIAL # G6801419

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SP
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5-21-09	SP
470	DIS-ASSEMBLE ACTION		5-21-09	SP
472	SERIALIZE BOLT HANDLE		5-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	5-29-09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-22-09	SP
520	GOFF BLAST BBL / REC		5/29/09	SP
540	APPLY COATINGS (BARREL ACTION)		6/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-15-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-15-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-15-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-15-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

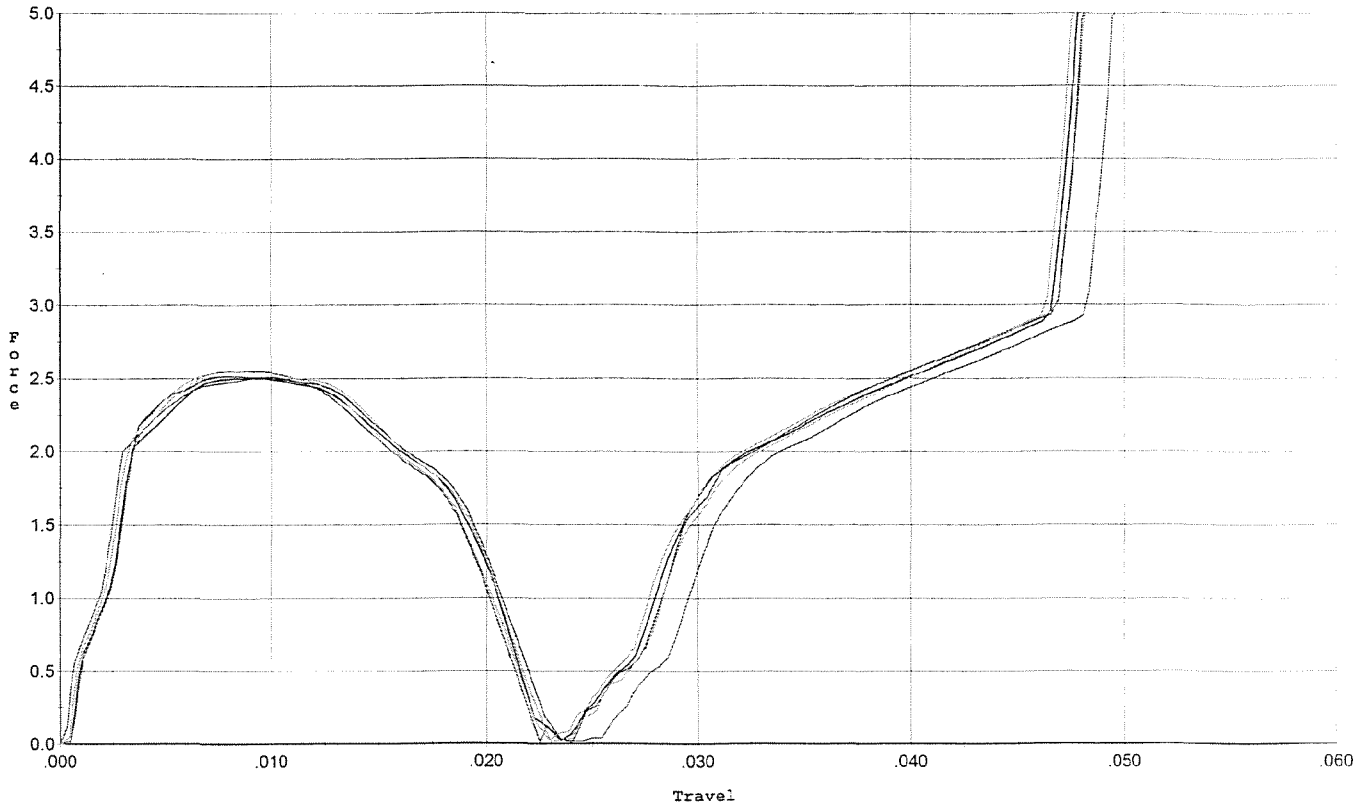
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	7-24-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	7-24-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	7-24-09	L.N.
	J) ASSEMBLE STOCK		6-15-09	L.P.R.
	K) ASSEMBLE SWIVEL STUDS		7-24-09	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	7/24	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/24	TAR
670	FINAL INSPECTION A) HEADSPACE		7-24-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.44</u> <u>2.26</u> <u>2.27</u> <u>2.41</u>	7-24-09	L.N.
	C) FUNCTION		7-24-09	L.N.
690	PACK		7/31/09	Fen

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



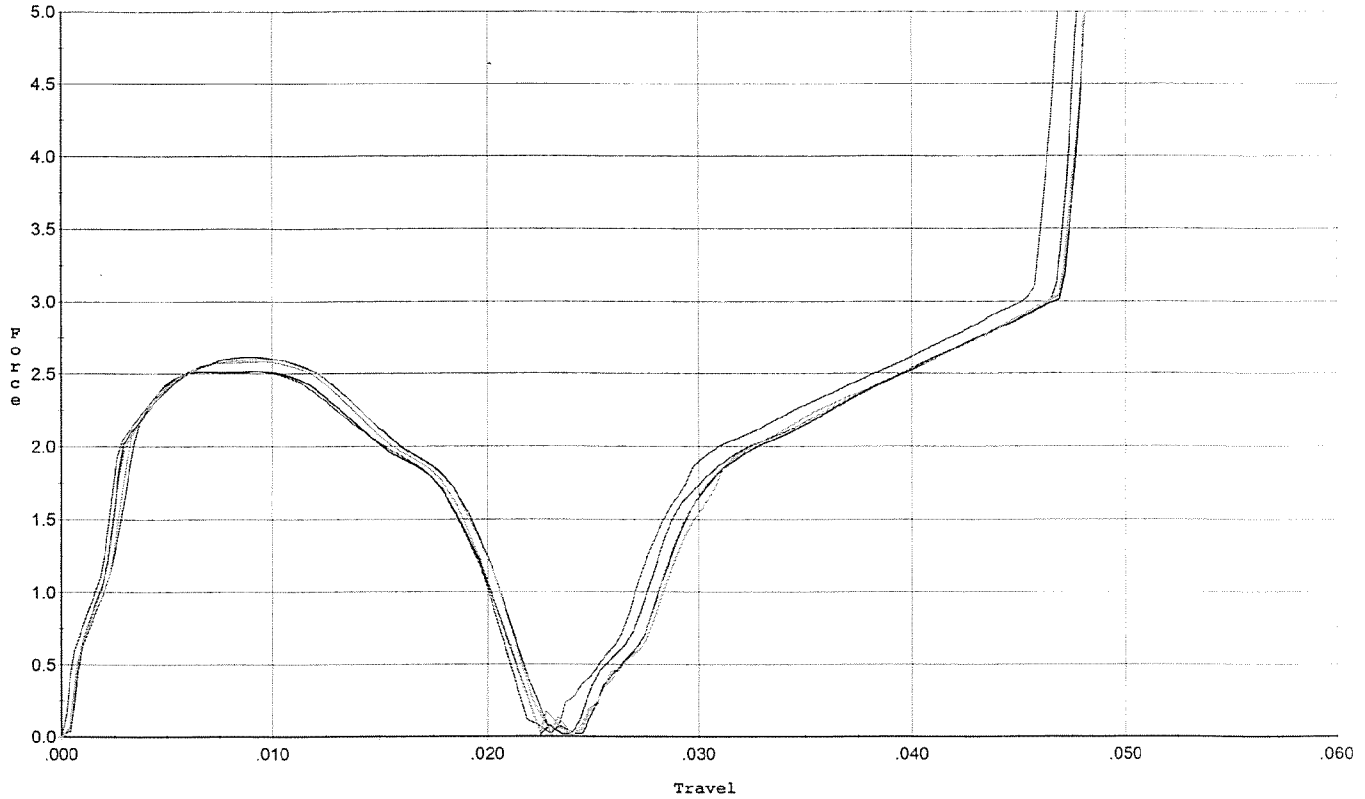
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.021	0.00	0.032	0.040		Set Trigger
2	2.504	0.020	0.00	0.032	0.038		Set Trigger
3	2.505	0.021	0.00	0.034	0.039		Set Trigger
4	2.546	0.021	0.00	0.033	0.039		Set Trigger
5	2.558	0.020	0.00	0.032	0.038		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



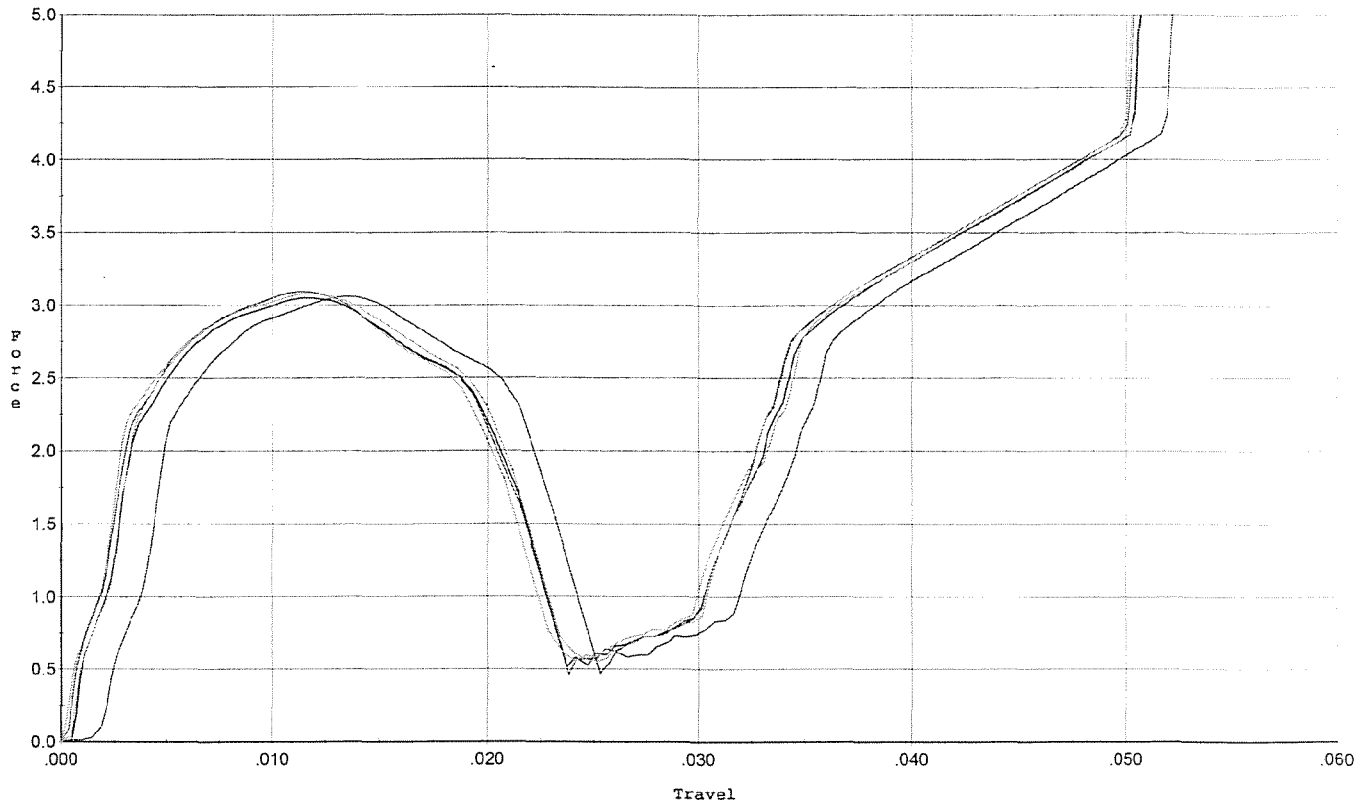
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.614	0.020	0.00	0.032	0.039		Set Trigger
2	2.519	0.020	0.00	0.033	0.037		Set Trigger
3	2.515	0.020	0.00	0.032	0.038		Set Trigger
4	2.604	0.020	0.00	0.033	0.039		Set Trigger
5	2.585	0.021	0.00	0.033	0.040		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



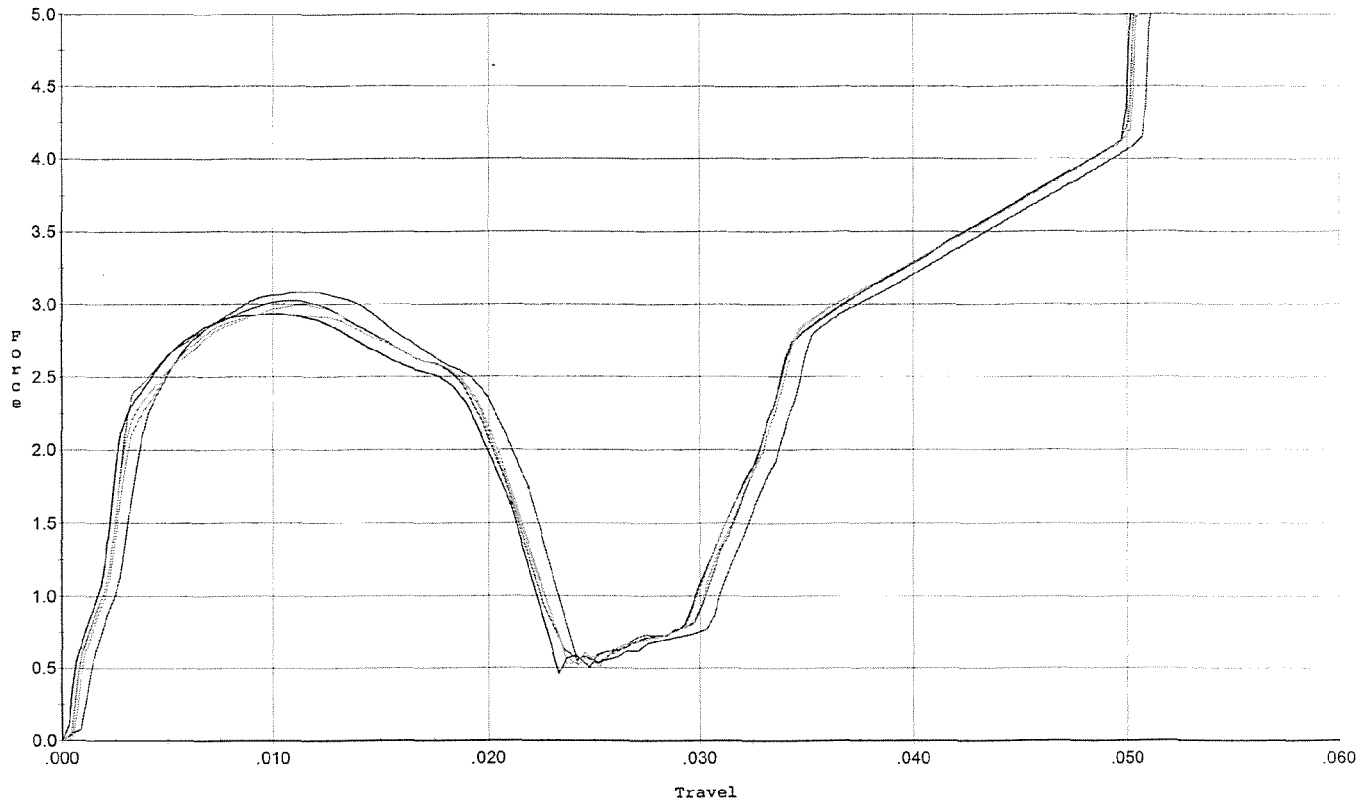
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.062	0.023	0.00	0.034	0.049		Set Trigger
2	3.050	0.021	0.00	0.033	0.048		Set Trigger
3	3.096	0.022	0.00	0.033	0.049		Set Trigger
4	3.086	0.021	0.00	0.033	0.048		Set Trigger
5	3.080	0.021	0.00	0.033	0.049		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



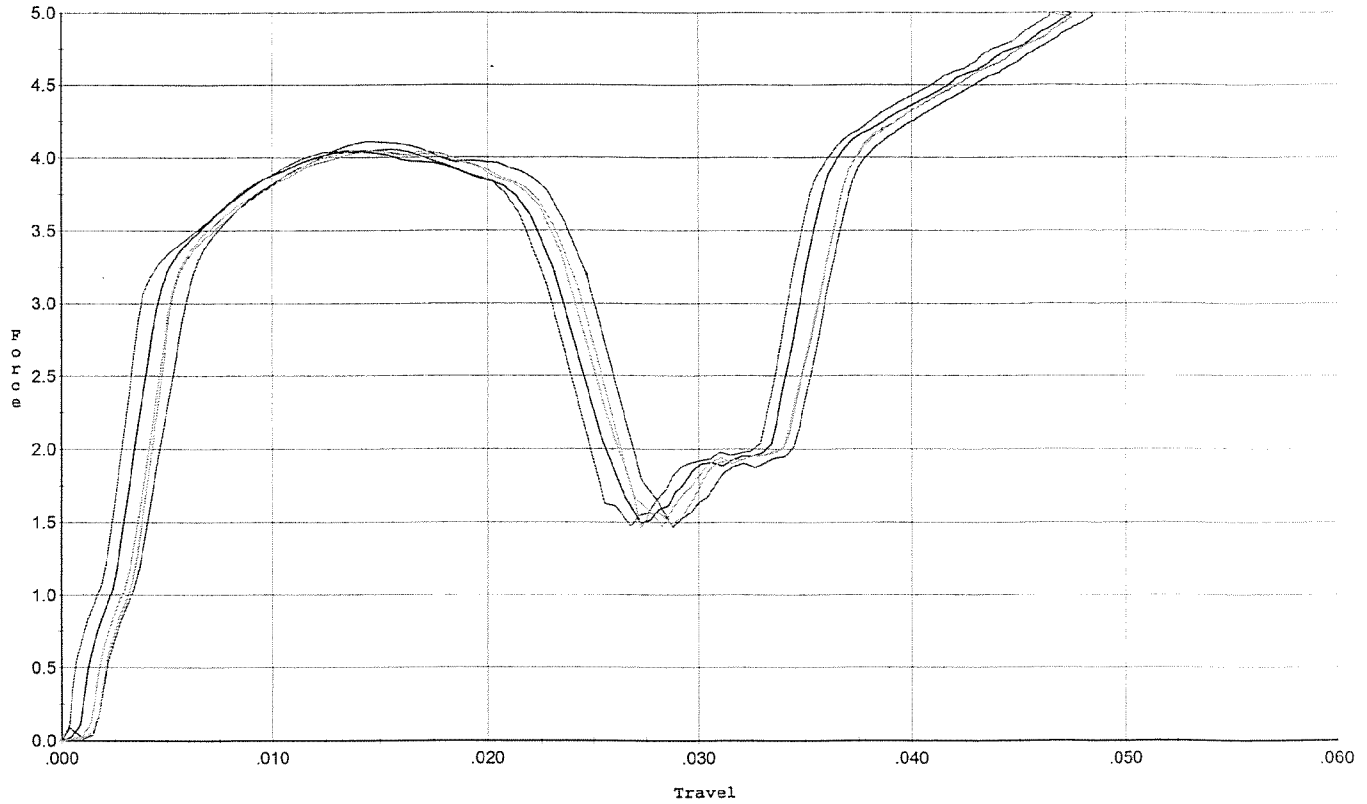
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.090	0.022	0.00	0.034	0.049		Set Trigger
2	2.933	0.021	0.00	0.033	0.047		Set Trigger
3	3.029	0.021	0.00	0.033	0.047		Set Trigger
4	2.993	0.021	0.00	0.033	0.047		Set Trigger
5	2.946	0.020	0.00	0.033	0.046		Set Trigger

Avg 2.99

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



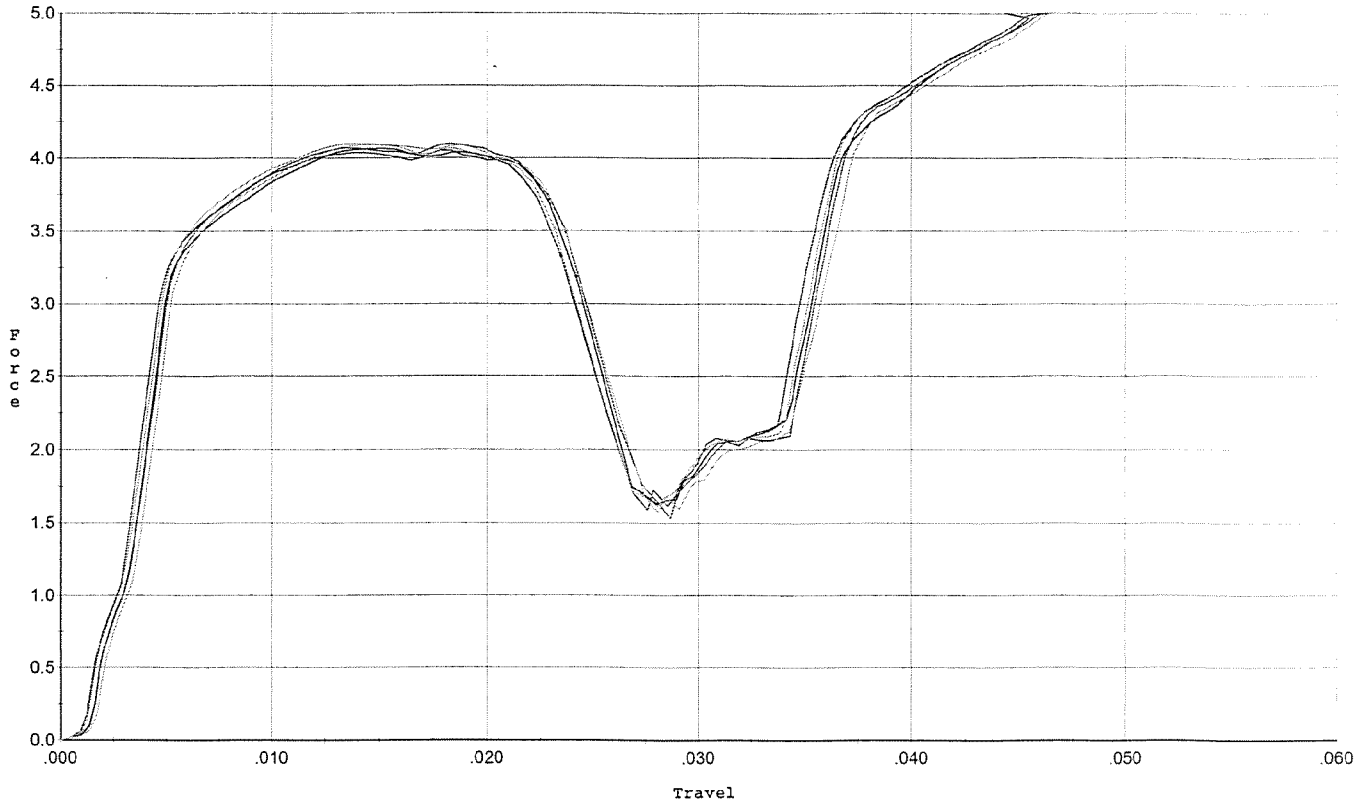
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.109	0.025	0.00	0.030	0.073		Set Trigger
2	4.037	0.023	0.00	0.030	0.070		Set Trigger
3	4.055	0.023	0.00	0.030	0.070		Set Trigger
4	4.052	0.023	0.00	0.030	0.069		Set Trigger
5	4.045	0.024	0.00	0.030	0.072		Set Trigger

Aug 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



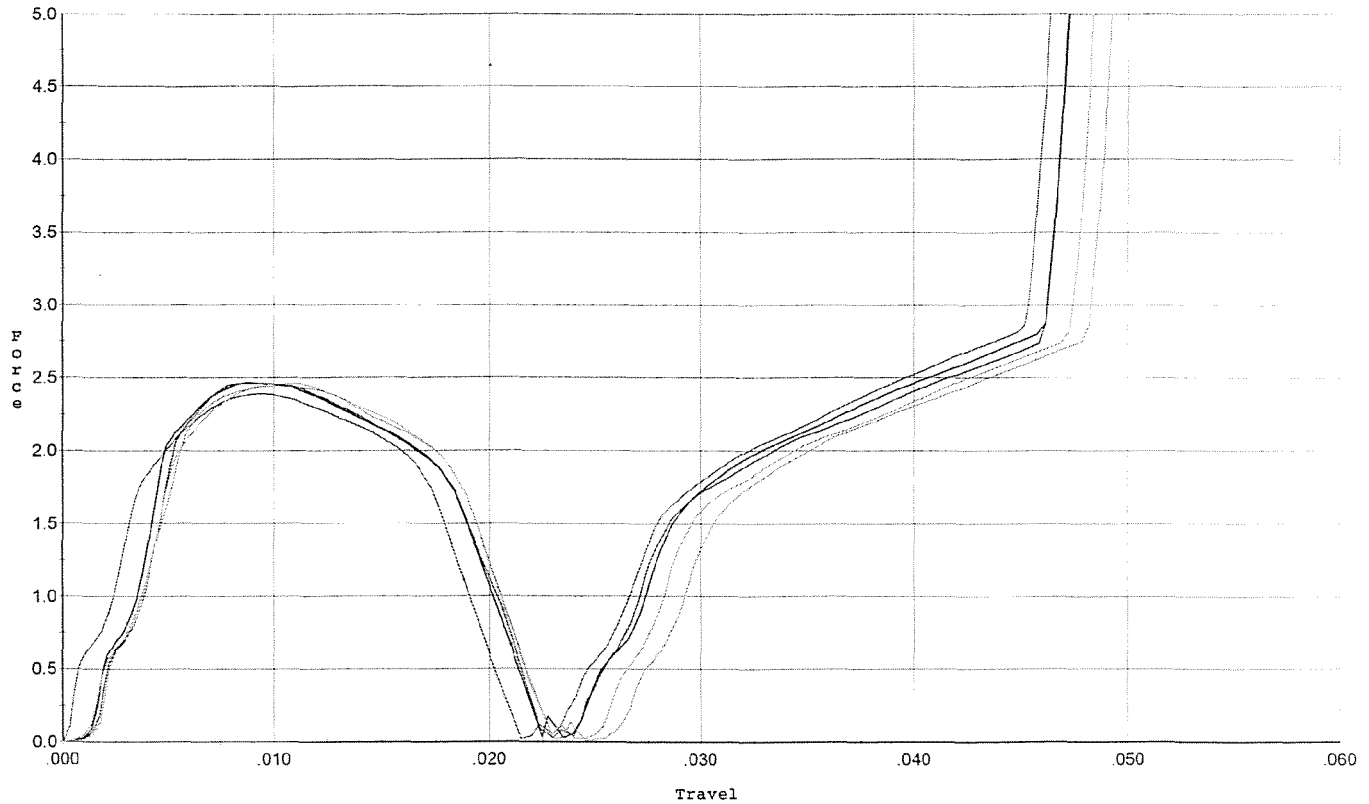
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.052	0.023	0.00	0.030	0.071		Set Trigger
2	4.064	0.024	0.00	0.030	0.073		Set Trigger
3	4.099	0.024	0.00	0.030	0.072		Set Trigger
4	4.091	0.024	0.00	0.030	0.071		Set Trigger
5	4.099	0.023	0.00	0.030	0.071		Set Trigger

Aug 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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



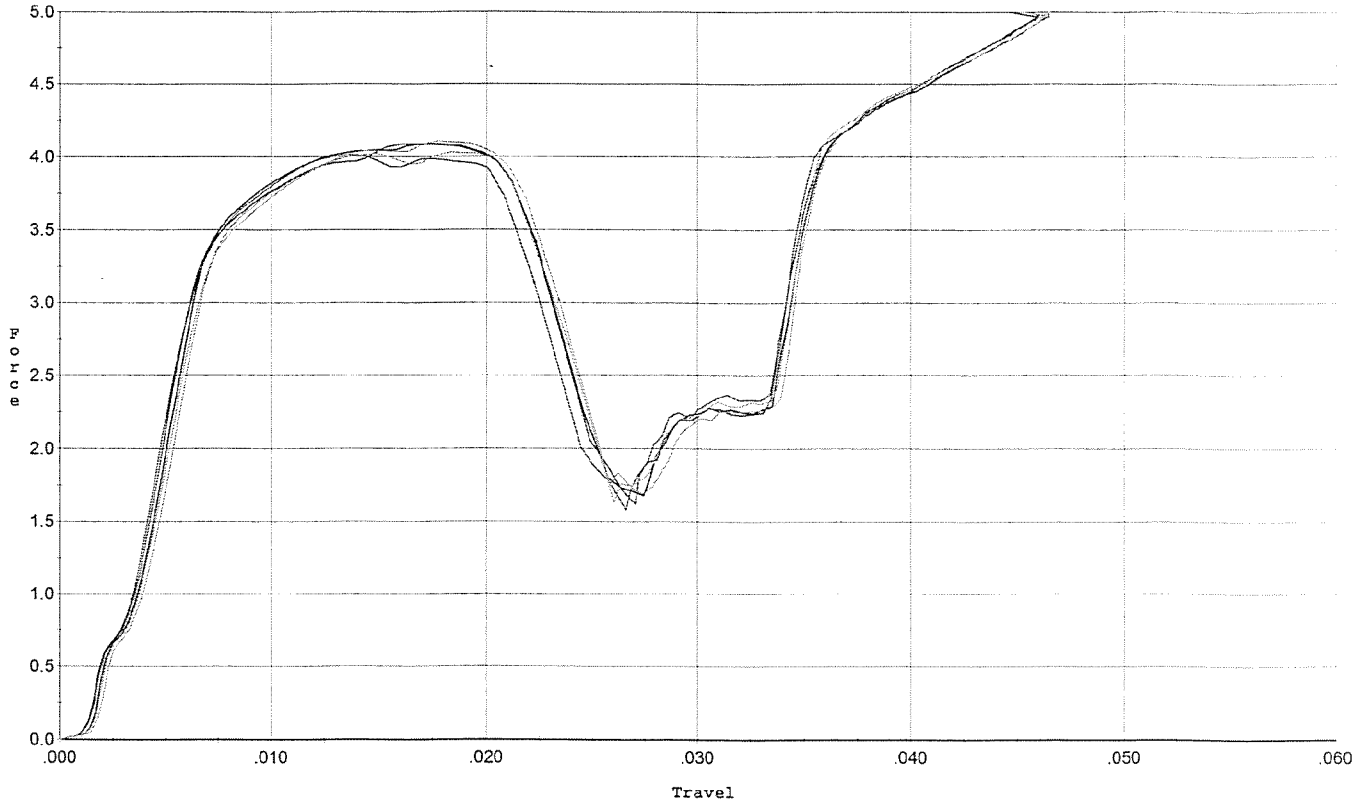
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.462	0.021	0.00	0.032	0.035		Set Trigger
2	2.466	0.021	0.00	0.032	0.036		Set Trigger
3	2.391	0.019	0.00	0.032	0.033		Set Trigger
4	2.458	0.020	0.00	0.033	0.035		Set Trigger
5	2.438	0.020	0.00	0.034	0.035		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

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	4.085	0.022	0.00	0.029	0.064		Set Trigger
2	4.086	0.022	0.00	0.029	0.064		Set Trigger
3	4.013	0.022	0.00	0.030	0.063		Set Trigger
4	4.029	0.024	0.00	0.029	0.067		Set Trigger
5	4.105	0.023	0.00	0.029	0.066		Set Trigger

Avg 4.06