

6680 7689

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

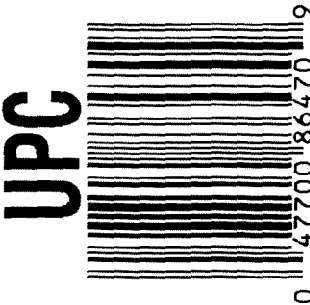


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807689



BM FORM

GUN SERIAL #

66807689

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES			
480	MAGNAFLUX BBL ACTION	(N)	3/27/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-27	RT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

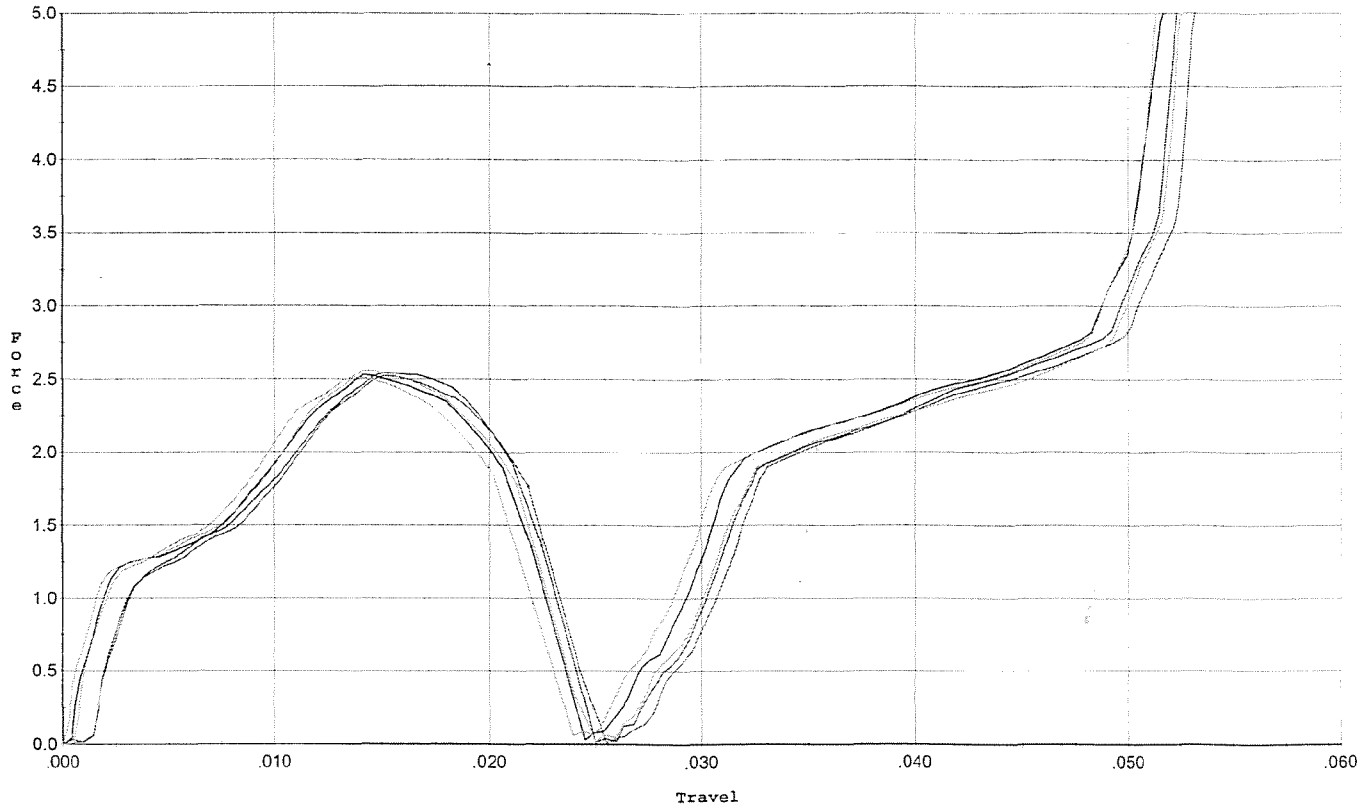
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>26</u> <u>26</u> <u>28</u>	4/28/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>38</u> <u>38</u> <u>40</u>	4/28/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	4/28/09	RP
	J) ASSEMBLE STOCK		4-23-09	RP
	K) ASSEMBLE SWIVEL STUDS		4/28/09	RP
	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	4-24-09	RP
	MALFUNCTION	CORRECTION	/	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		4/28/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.34</u> <u>2.43</u> <u>2.57</u> <u>2.39</u>	4-28-09	NW
	C) FUNCTION		4/28/09	RP
690	PACK		5/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

Model: M24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



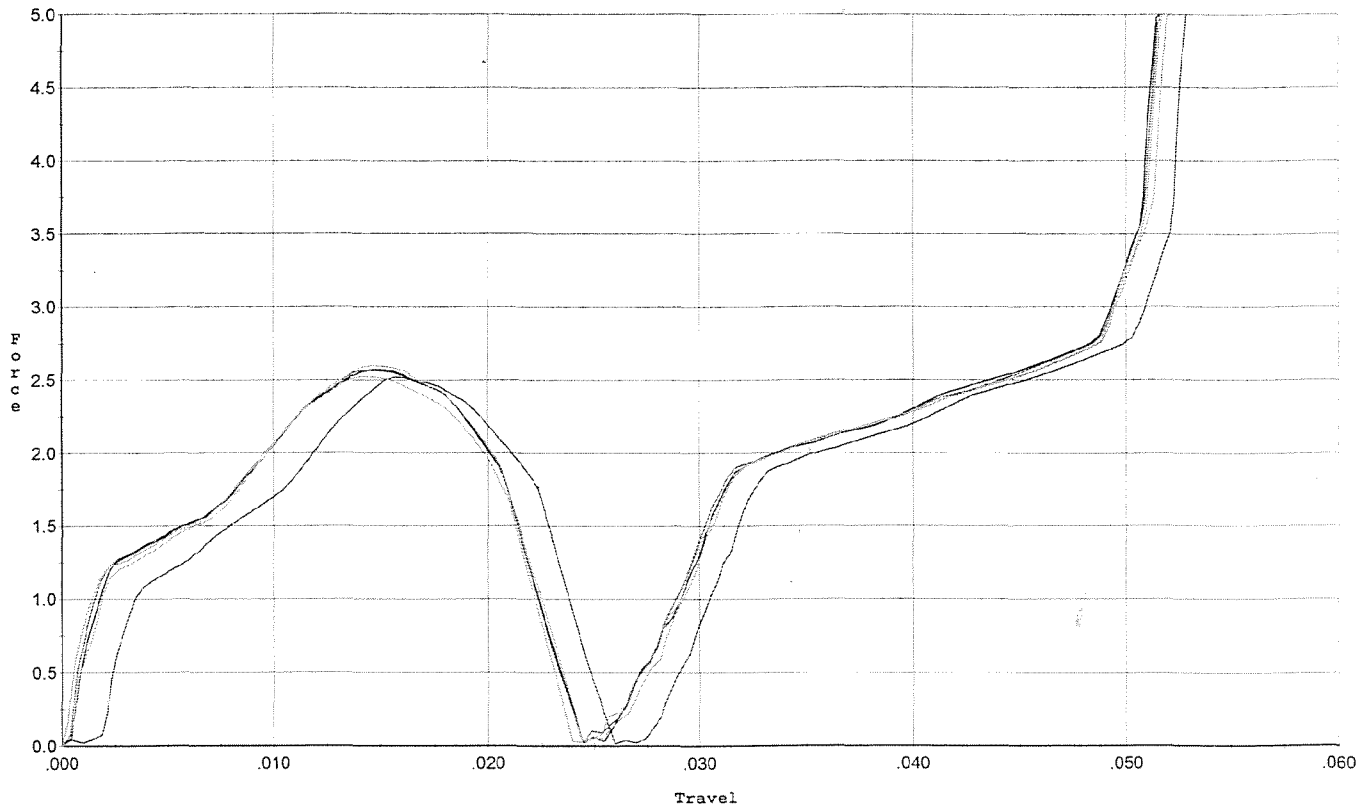
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.022	0.00	0.035	0.037		Set Trigger
2	2.530	0.022	0.00	0.034	0.037		Set Trigger
3	2.523	0.022	0.00	0.035	0.036		Set Trigger
4	2.559	0.021	0.00	0.035	0.037		Set Trigger
5	2.515	0.022	0.00	0.034	0.038		Set Trigger

Aug 2.53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



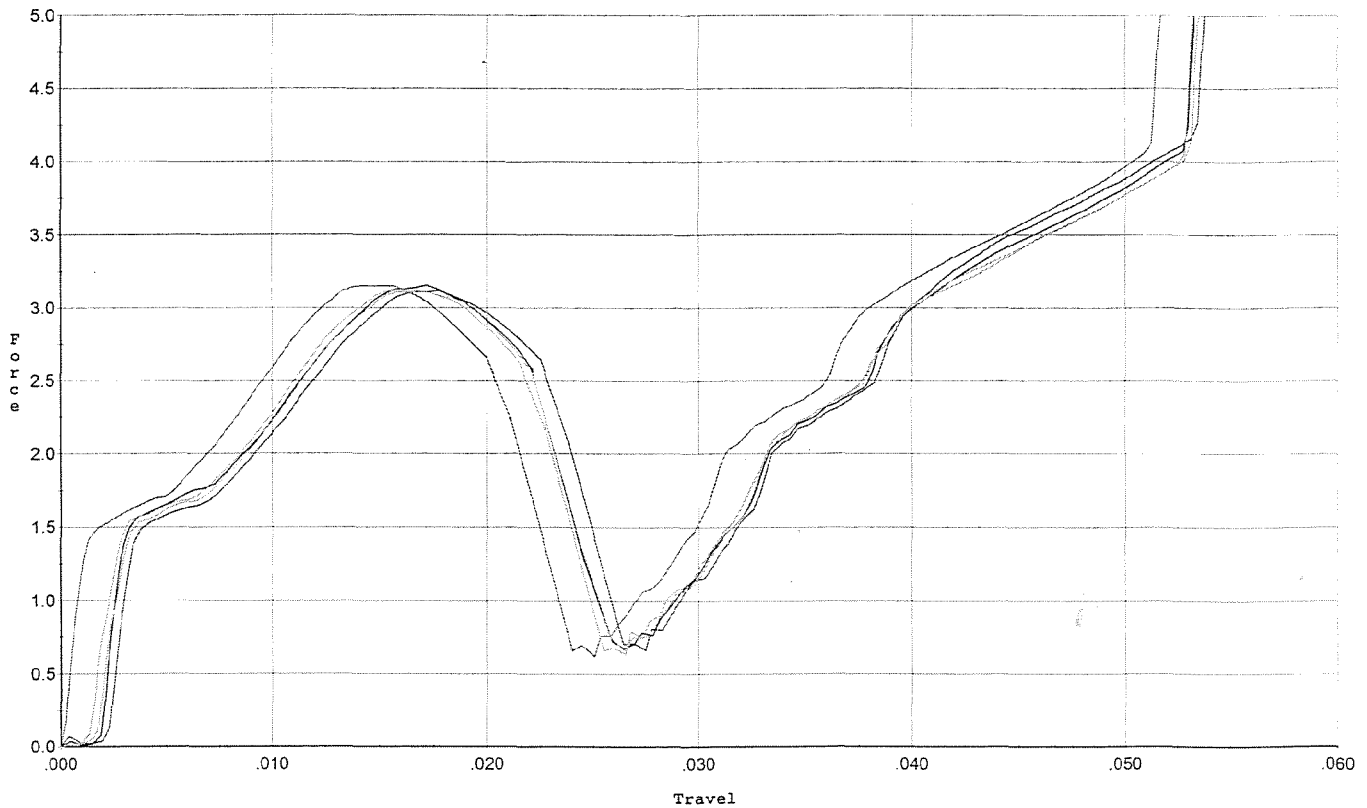
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.022	0.00	0.035	0.036		Set Trigger
2	2.569	0.021	0.00	0.035	0.037		Set Trigger
3	2.564	0.021	0.00	0.035	0.037		Set Trigger
4	2.597	0.022	0.00	0.034	0.039		Set Trigger
5	2.524	0.021	0.00	0.035	0.037		Set Trigger

Aug 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



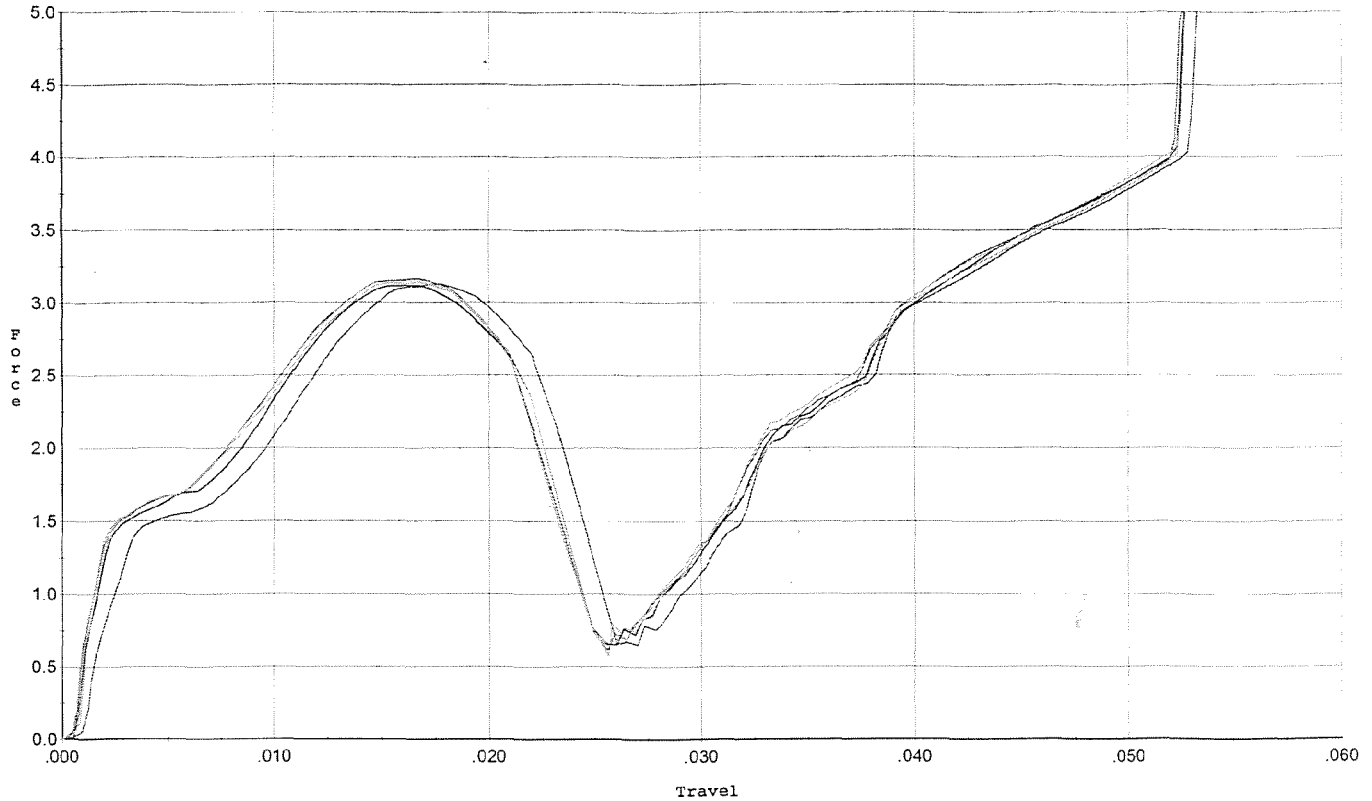
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.024	0.002	0.033	0.048		Set Trigger
2	3.155	0.022	0.002	0.034	0.046		Set Trigger
3	3.152	0.021	0.00	0.034	0.047		Set Trigger
4	3.104	0.022	0.00	0.034	0.046		Set Trigger
5	3.117	0.023	0.00	0.034	0.047		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



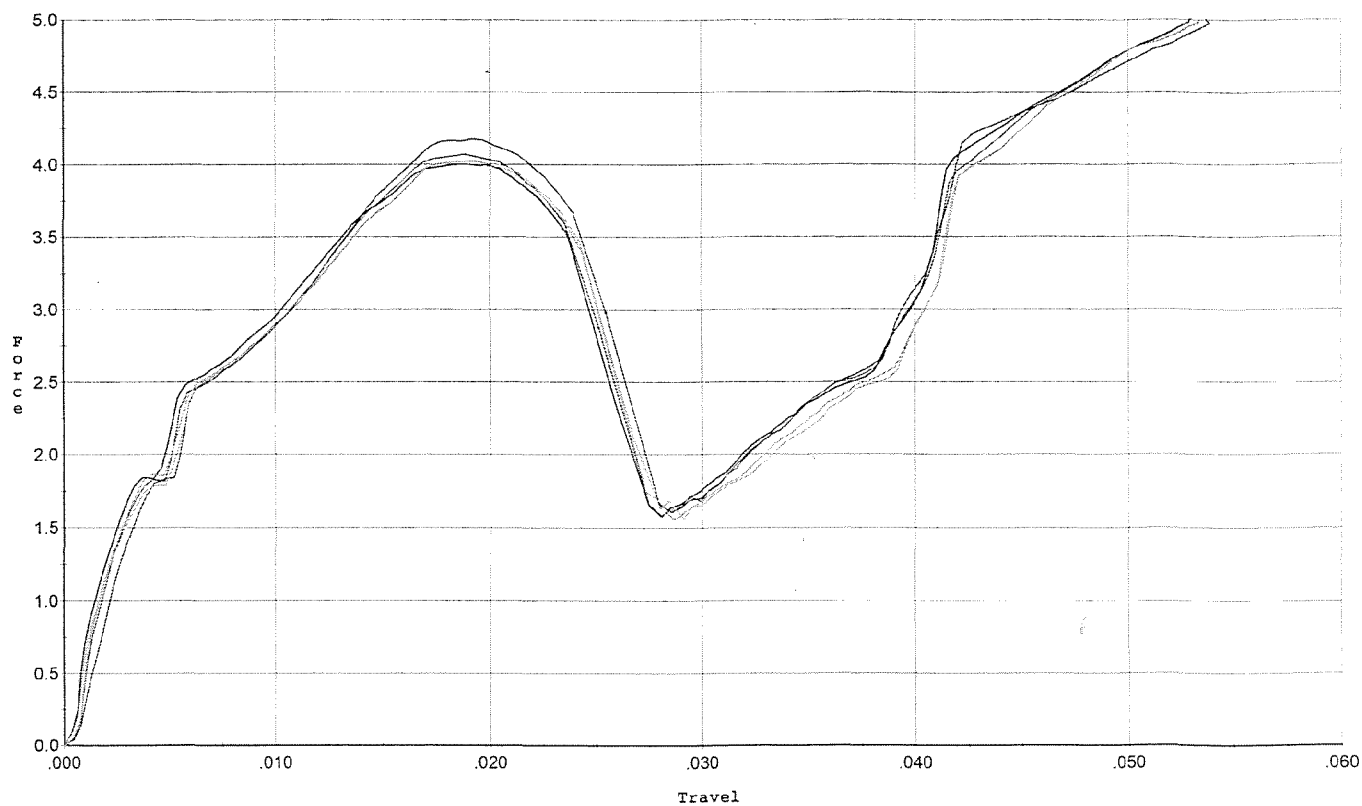
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.130	0.023	0.00	0.033	0.048		Set Trigger
2	3.118	0.022	0.00	0.034	0.046		Set Trigger
3	3.161	0.023	0.00	0.034	0.049		Set Trigger
4	3.139	0.022	0.00	0.034	0.047		Set Trigger
5	3.152	0.021	0.00	0.034	0.045		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



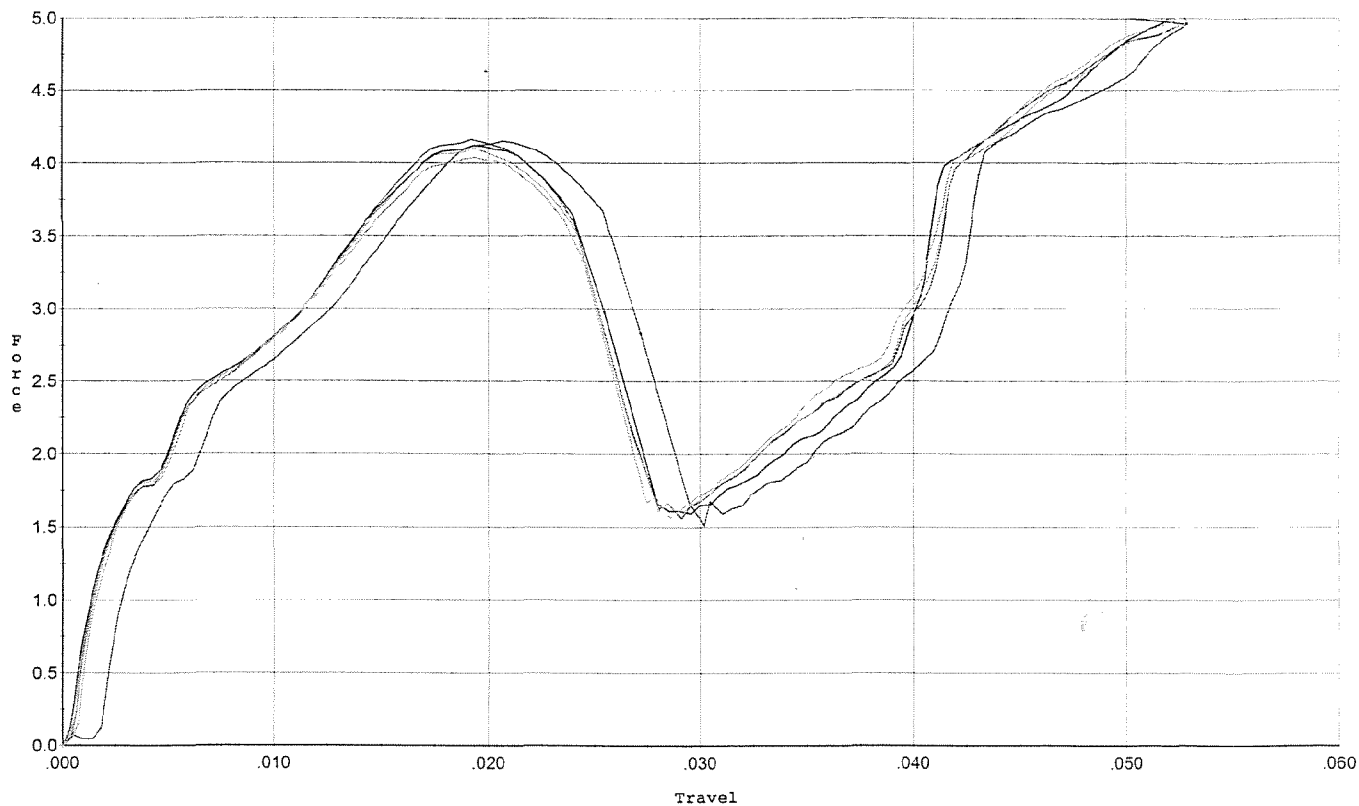
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.174	0.025	0.00	0.032	0.071		Set Trigger
2	4.001	0.024	0.00	0.032	0.066		Set Trigger
3	4.070	0.025	0.00	0.031	0.069		Set Trigger
4	4.019	0.024	0.00	0.032	0.066		Set Trigger
5	4.006	0.024	0.00	0.032	0.067		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



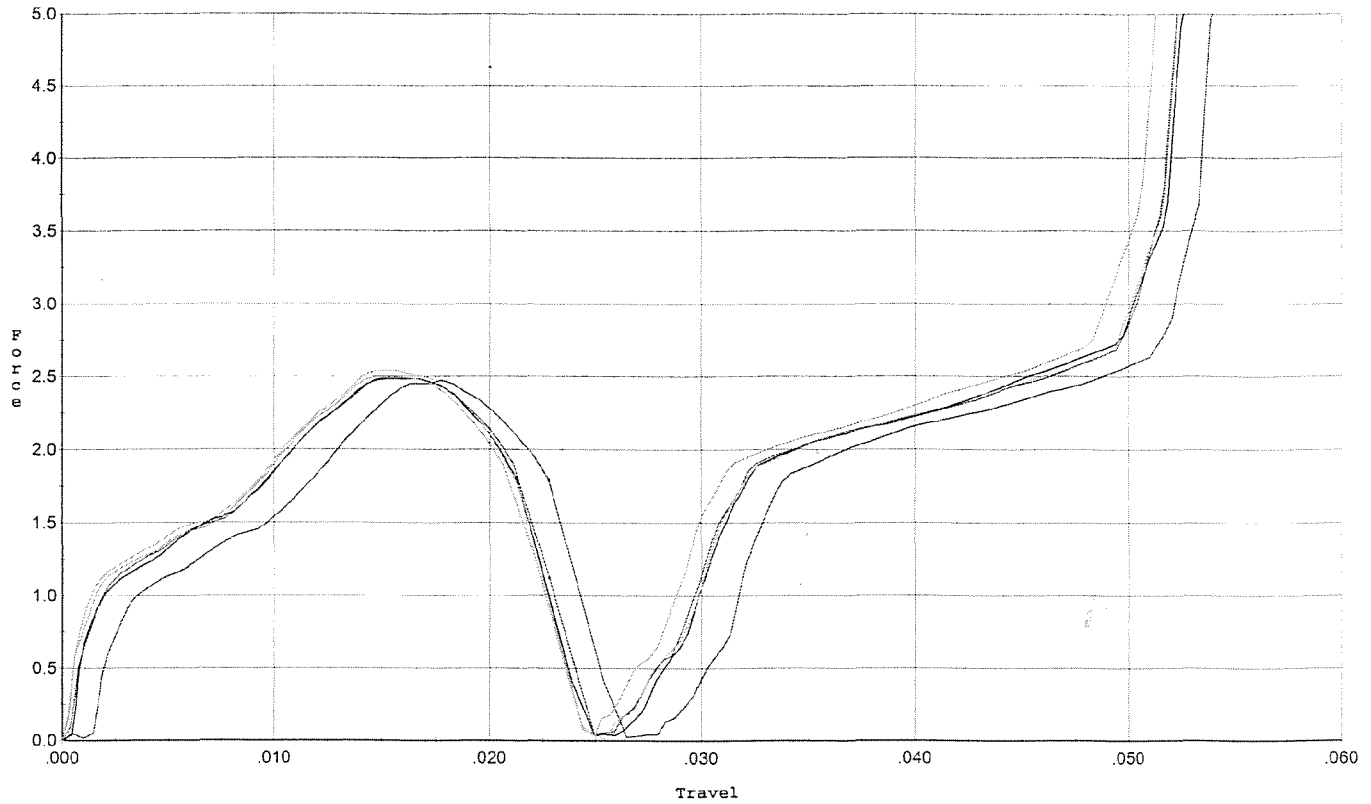
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.151	0.027	0.002	0.031	0.072		Set Trigger
2	4.118	0.025	0.00	0.031	0.071		Set Trigger
3	4.160	0.024	0.00	0.031	0.067		Set Trigger
4	4.037	0.024	0.00	0.031	0.067		Set Trigger
5	4.101	0.024	0.00	0.031	0.066		Set Trigger

Aug 4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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



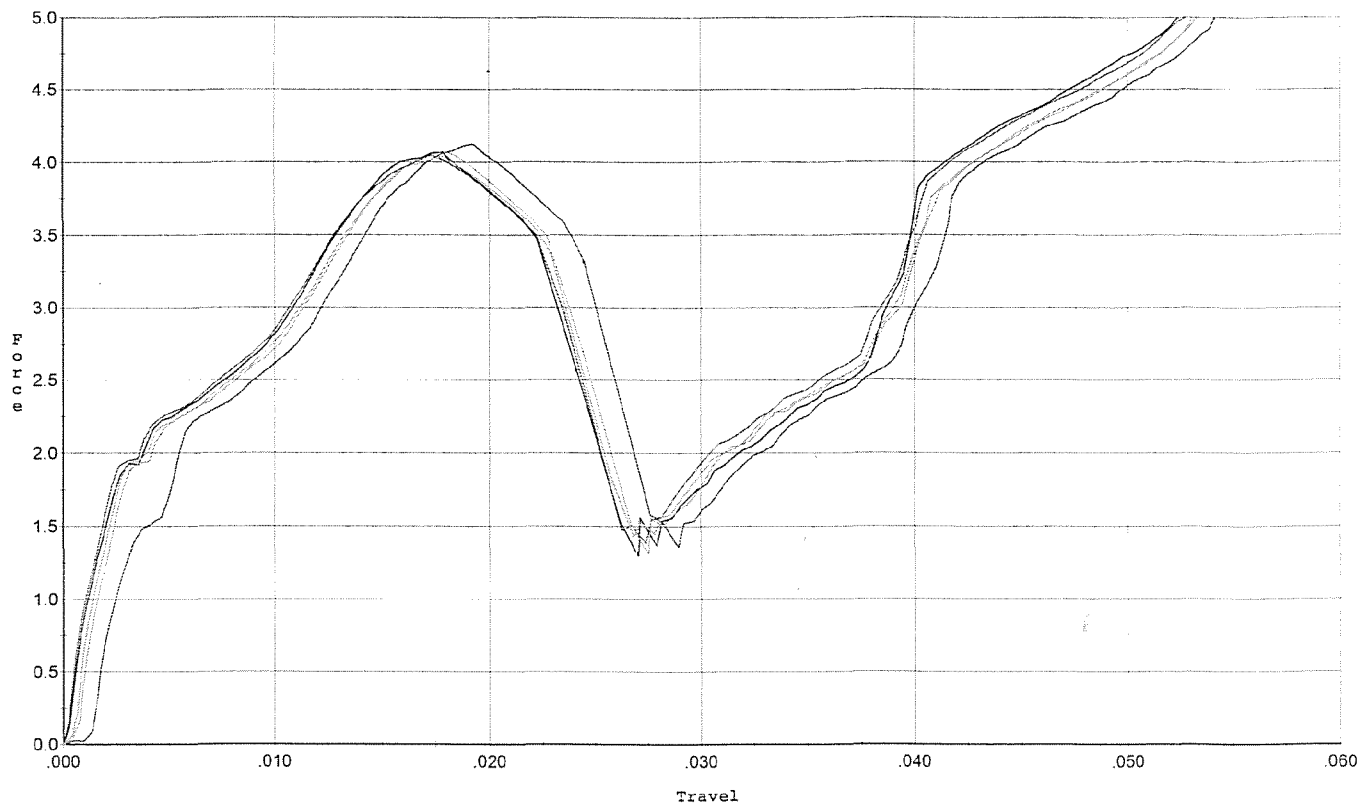
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.023	0.00	0.036	0.036		Set Trigger
2	2.484	0.021	0.00	0.035	0.036		Set Trigger
3	2.493	0.023	0.00	0.034	0.039		Set Trigger
4	2.542	0.021	0.00	0.035	0.038		Set Trigger
5	2.496	0.022	0.00	0.034	0.038		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/12/09

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	4.126	0.024	0.00	0.032	0.064		Set Trigger
2	4.066	0.024	0.00	0.031	0.066		Set Trigger
3	4.050	0.023	0.00	0.031	0.064		Set Trigger
4	4.040	0.023	0.00	0.031	0.062		Set Trigger
5	4.076	0.024	0.00	0.031	0.065		Set Trigger

Aug 4.07