

G680 7789

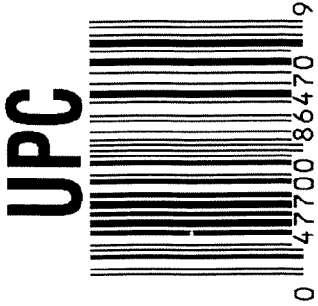
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6807789



GUN SERIAL # G 6807789

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-12-09	SPD
430	ASSEMBLE TO STOCK		2-12-09	SP
440	PROOF		2-12-09	SPD
460	CHECK HEADSPACE		2-12-09	SPD
470	DIS-ASSEMBLE ACTION		2-12-09	SPD
472	SERIALIZE BOLT HANDLE		2-13-09	RTZ
475	DRILL AND TAP SIGHT HOLES		2-13-09	SP
480	MAGNAFLUX BBL ACTION	OPERATION (A)	2/18/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		2/19/09	RT
520	GOFF BLAST BBL / REC		19 Feb 09	SPD
542	APPLY COATINGS (BARREL ACTION)		3/2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-4-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

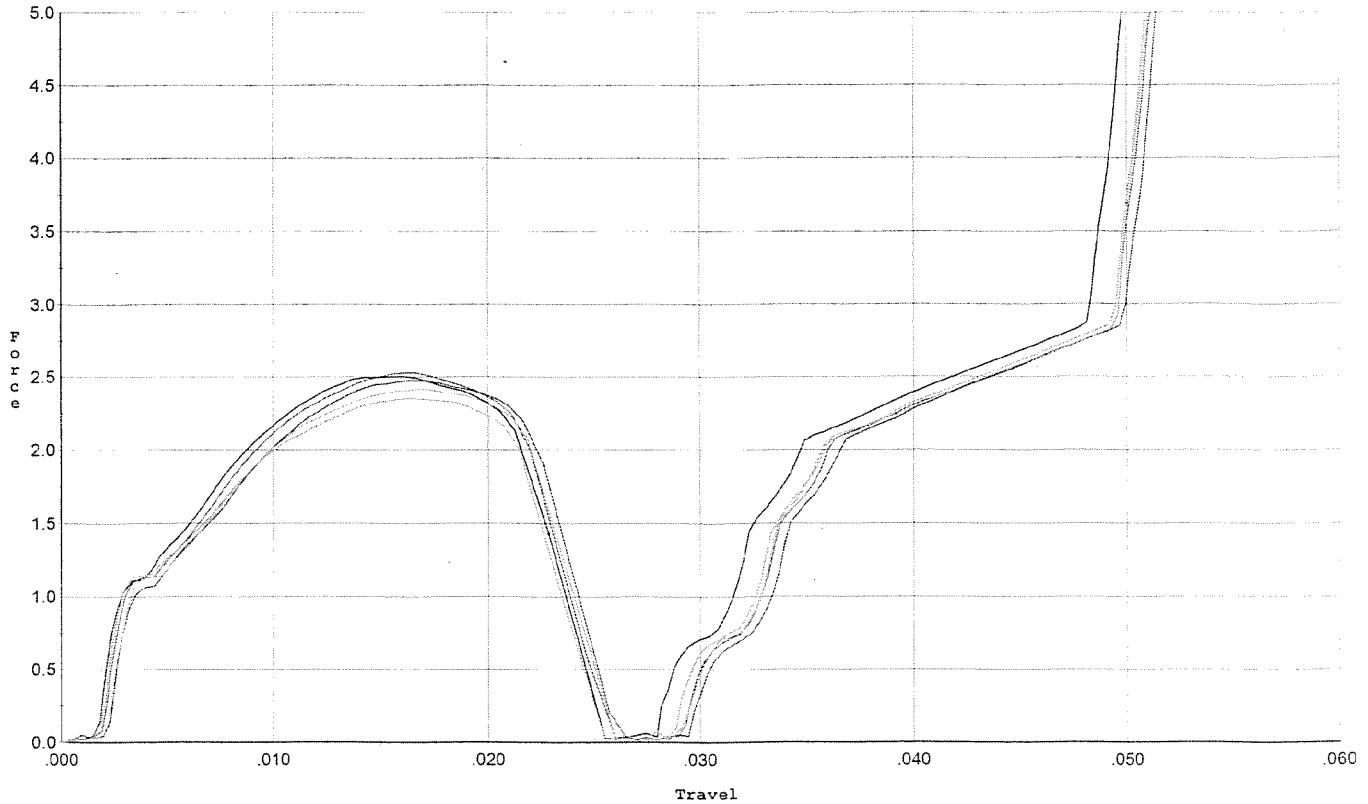
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>6.5</u> <u>6</u>	3-9-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>3</u> <u>3</u>	3-9-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-9-09	WN
	J) ASSEMBLE STOCK		3-4-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-10-09	WN
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	3-5-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-5-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-9-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.34</u> <u>2.37</u> <u>2.34</u> <u>2.35</u>	3-6-09	WN
	C) FUNCTION		3-9-09	WN
690	PACK		3/27/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 3/3/09

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



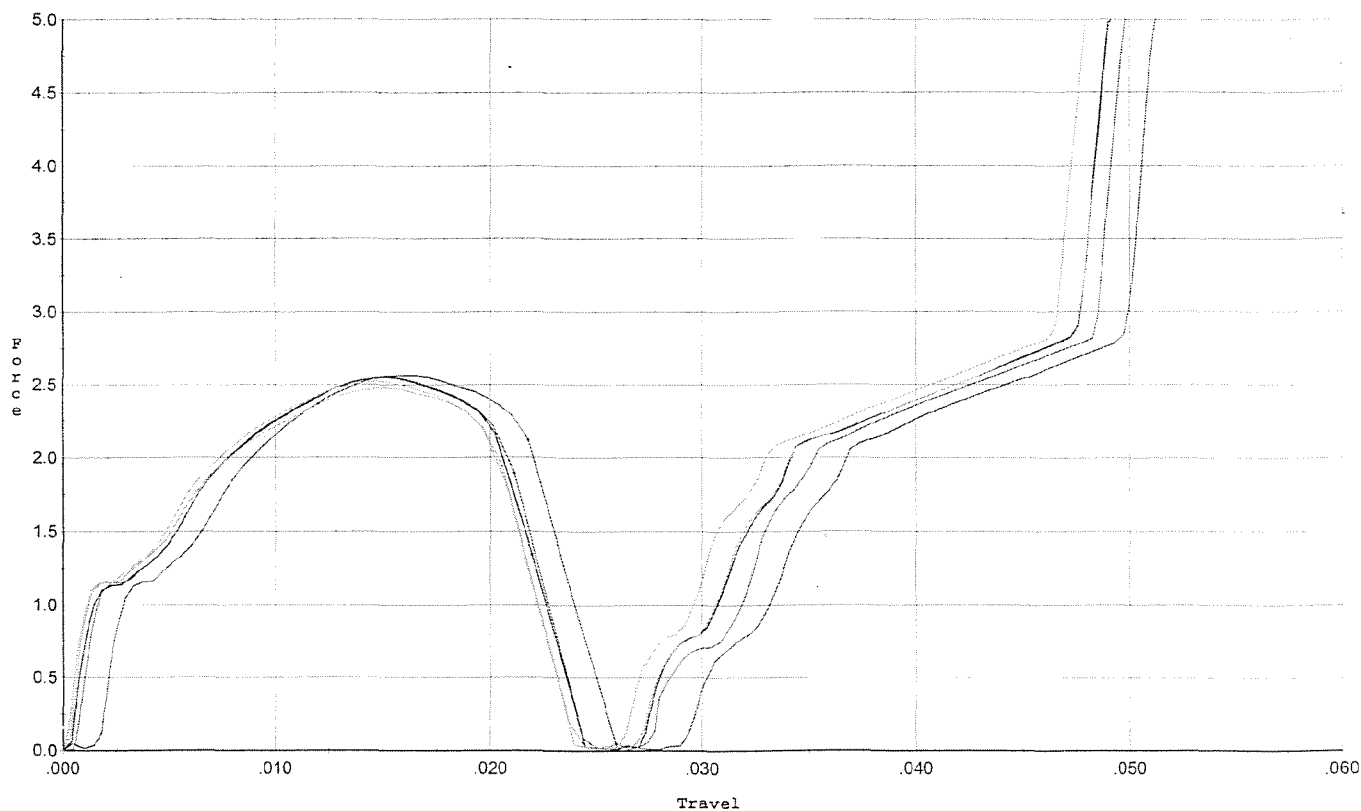
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.474	0.023	0.00	0.034	0.038		Set Trigger
2	2.501	0.023	0.00	0.032	0.040		Set Trigger
3	2.528	0.022	0.00	0.034	0.038		Set Trigger
4	2.414	0.024	0.00	0.033	0.039		Set Trigger
5	2.354	0.021	0.00	0.034	0.035		Set Trigger

Avg 2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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



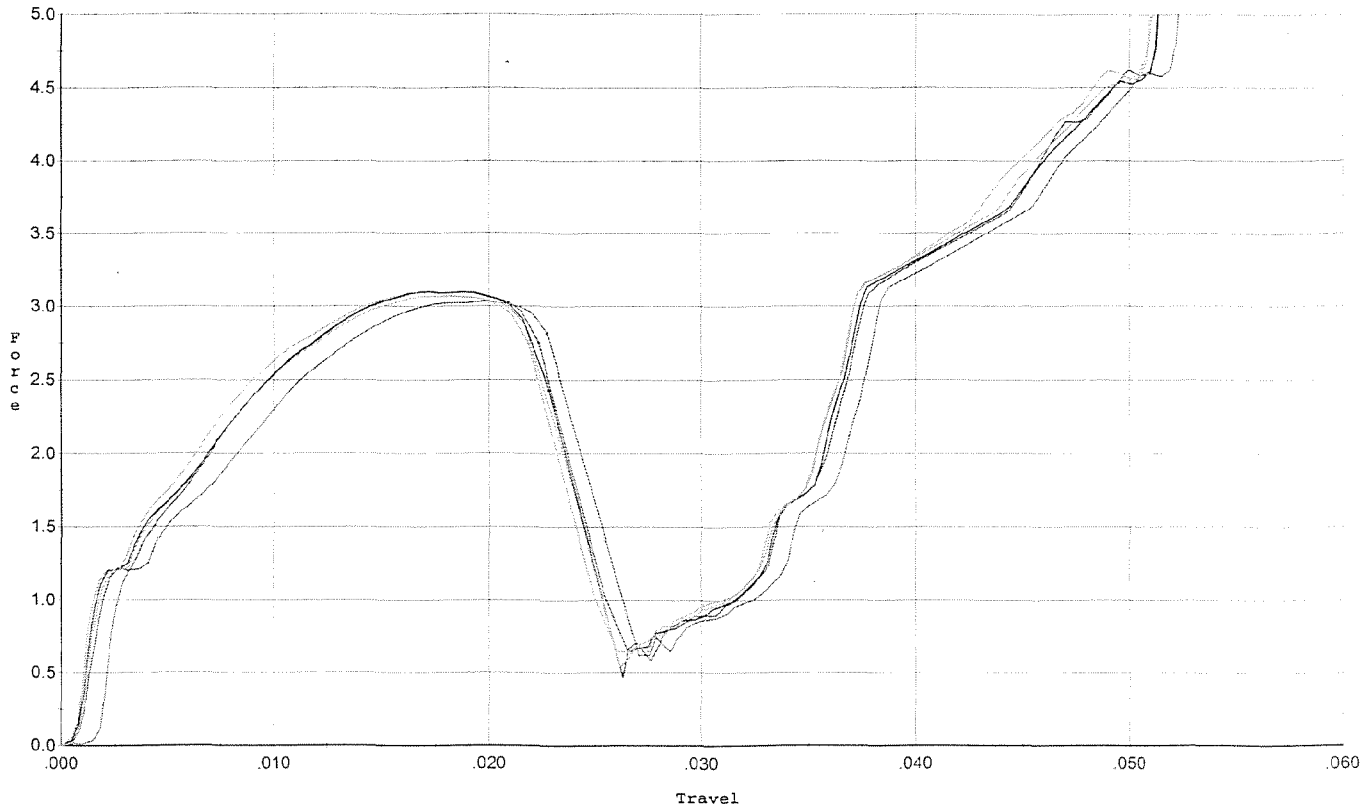
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.022	0.00	0.034	0.039		Set Trigger
2	2.550	0.022	0.00	0.033	0.040		Set Trigger
3	2.553	0.021	0.00	0.033	0.039		Set Trigger
4	2.523	0.021	0.00	0.032	0.039		Set Trigger
5	2.477	0.021	0.00	0.033	0.038		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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



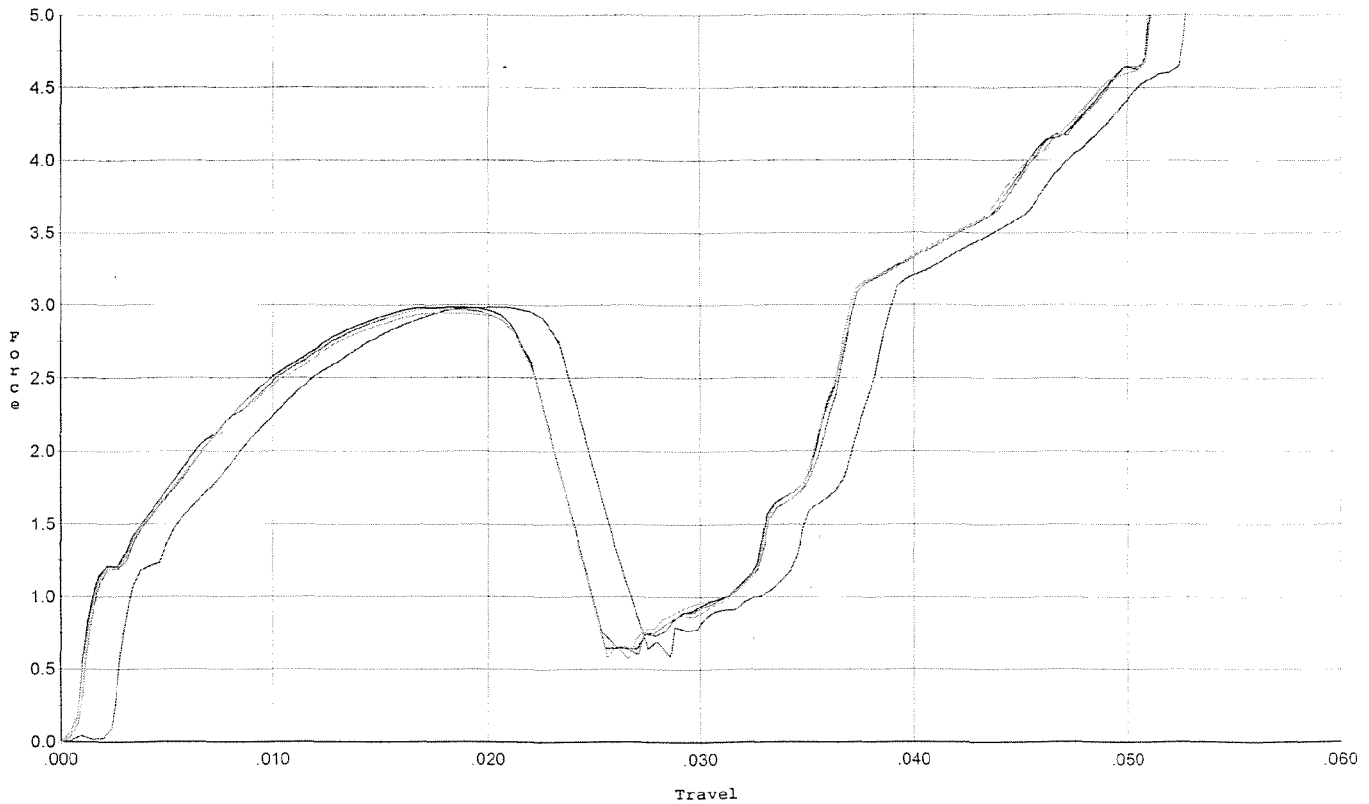
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.022	0.00	0.033	0.049		Set Trigger
2	3.099	0.023	0.00	0.033	0.050		Set Trigger
3	3.033	0.023	0.00	0.033	0.047		Set Trigger
4	3.069	0.023	0.00	0.033	0.051		Set Trigger
5	3.093	0.022	0.00	0.033	0.049		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 3/3/09

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



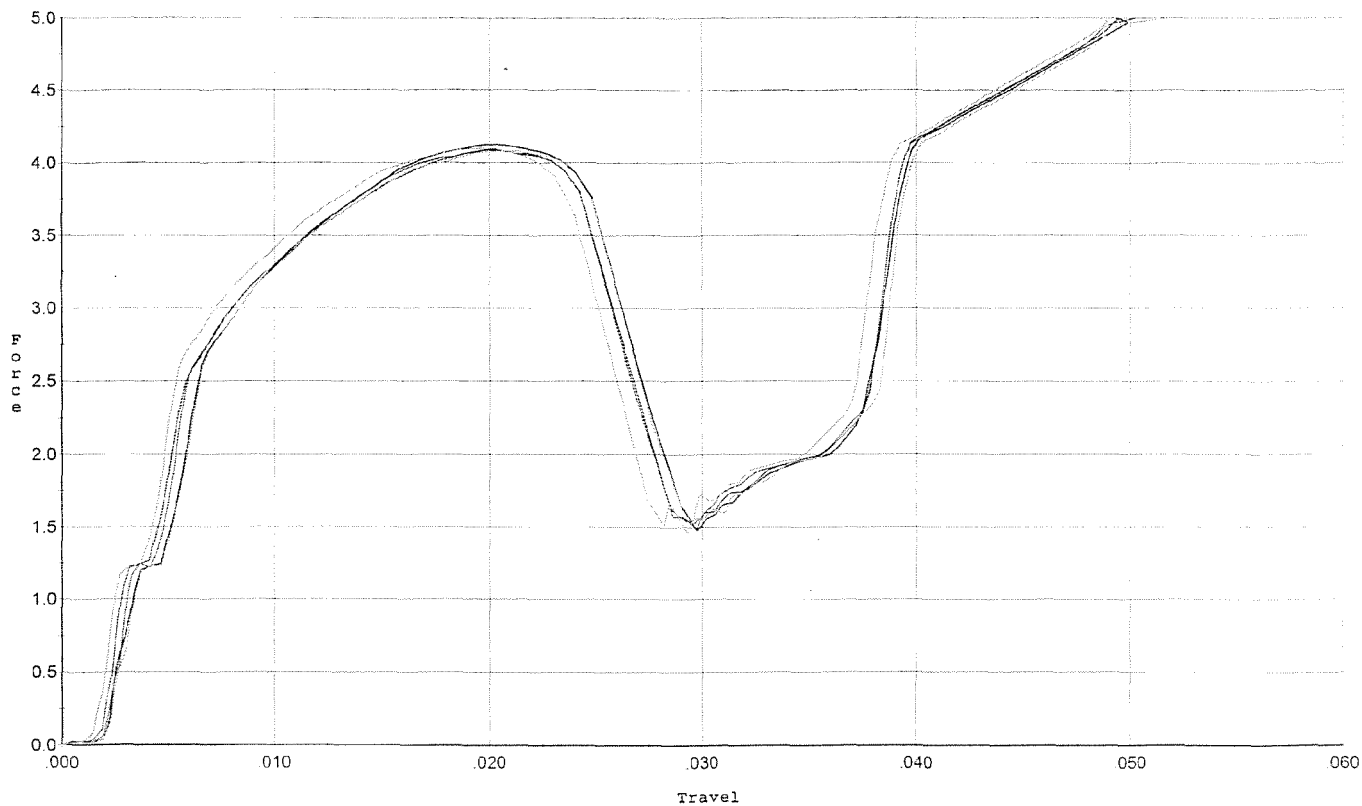
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.980	0.023	0.00	0.033	0.047		Set Trigger
2	2.980	0.022	0.00	0.033	0.048		Set Trigger
3	2.967	0.022	0.00	0.033	0.047		Set Trigger
4	2.943	0.022	0.00	0.033	0.047		Set Trigger
5	2.969	0.022	0.00	0.033	0.048		Set Trigger

Aug 2.96

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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



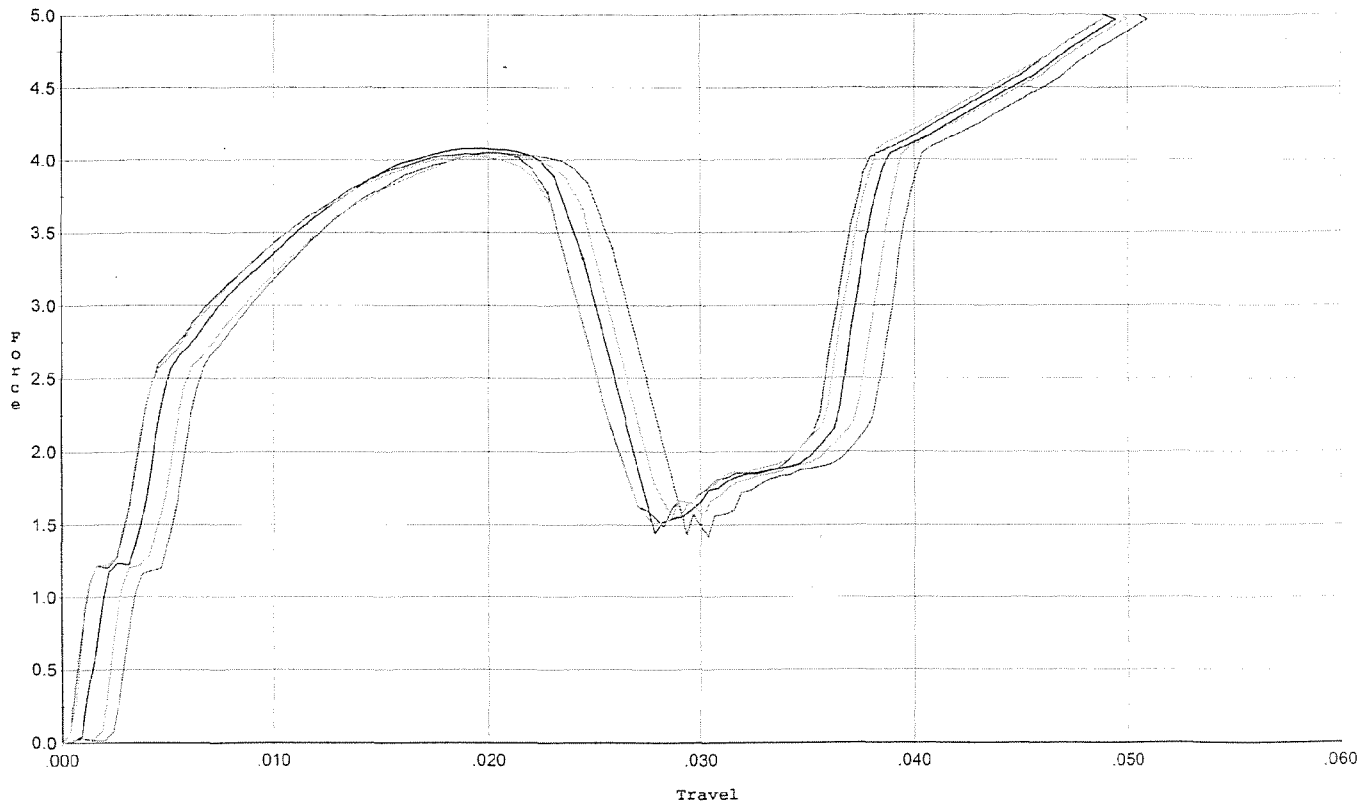
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.090	0.024	0.00	0.030	0.068		Set Trigger
2	4.128	0.025	0.002	0.030	0.069		Set Trigger
3	4.088	0.024	0.00	0.030	0.068		Set Trigger
4	4.082	0.025	0.00	0.030	0.069		Set Trigger
5	4.102	0.024	0.00	0.030	0.069		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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



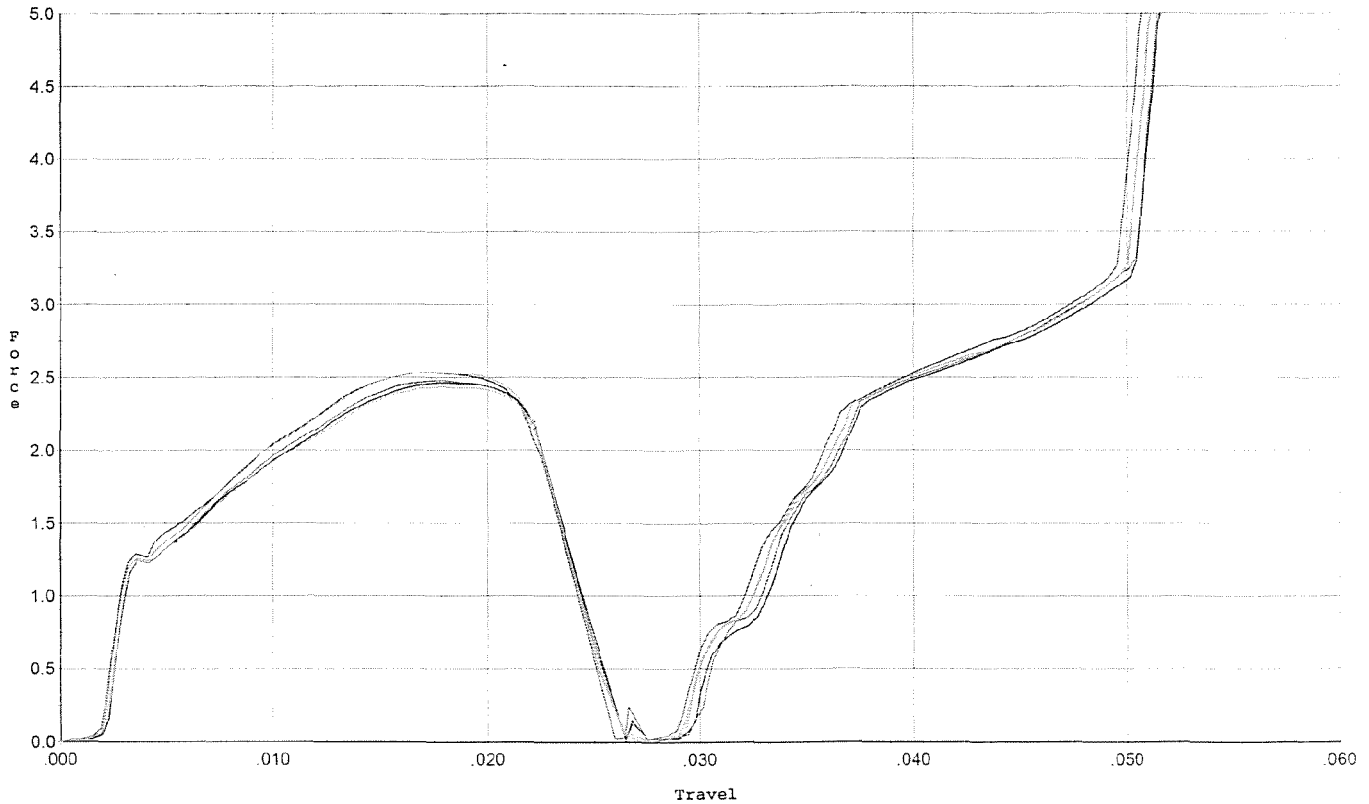
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.023	0.00	0.029	0.067		Set Trigger
2	4.077	0.024	0.00	0.030	0.071		Set Trigger
3	4.048	0.026	0.003	0.030	0.071		Set Trigger
4	4.020	0.023	0.00	0.030	0.067		Set Trigger
5	4.031	0.024	0.00	0.030	0.068		Set Trigger

Aug 4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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



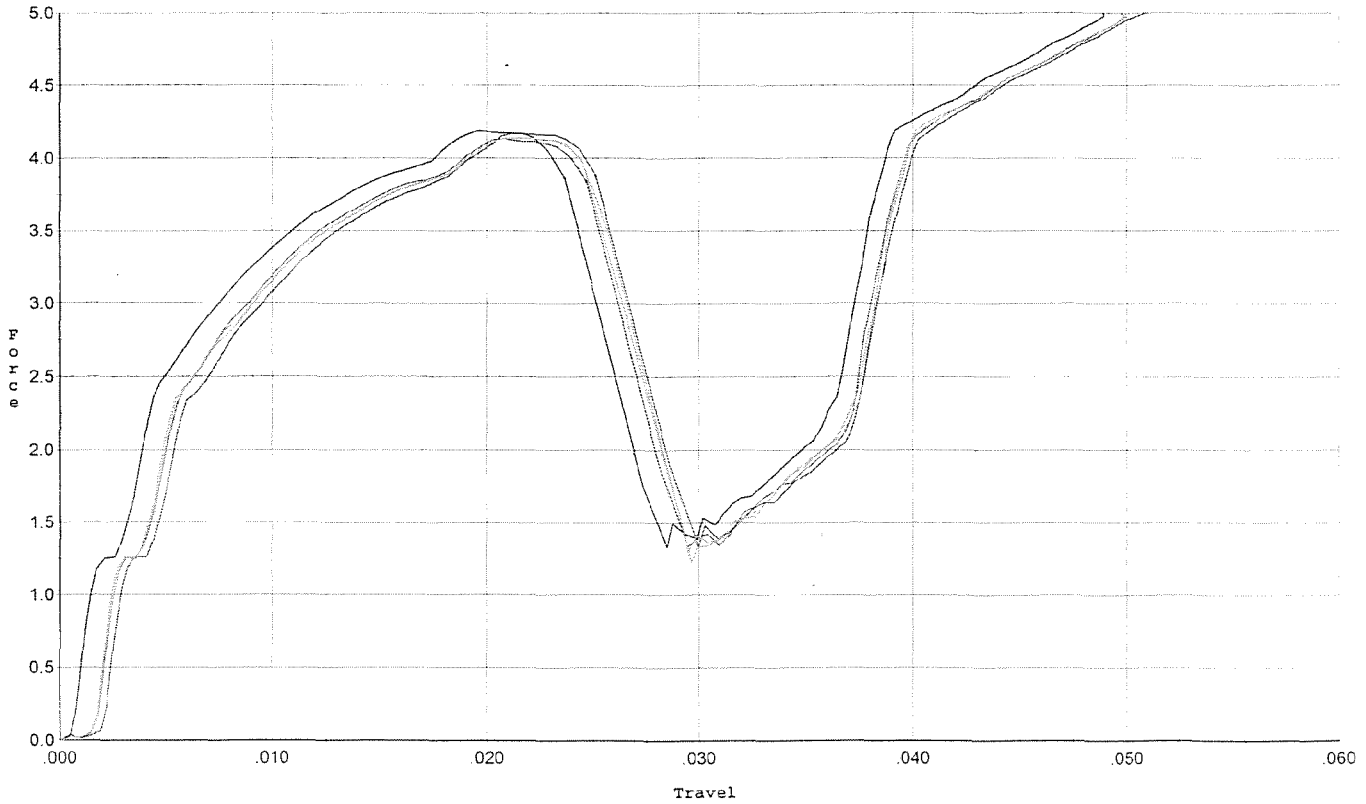
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.023	0.00	0.033	0.040		Set Trigger
2	2.465	0.022	0.002	0.034	0.038		Set Trigger
3	2.479	0.022	0.00	0.034	0.038		Set Trigger
4	2.437	0.022	0.00	0.033	0.038		Set Trigger
5	2.538	0.022	0.00	0.033	0.039		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 3/3/09

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	4.167	0.025	0.00	0.029	0.070		Set Trigger
2	4.189	0.024	0.00	0.030	0.070		Set Trigger
3	4.131	0.025	0.00	0.030	0.069		Set Trigger
4	4.141	0.027	0.00	0.030	0.075		Set Trigger
5	4.142	0.026	0.00	0.030	0.072		Set Trigger

Aug 4.15