

66774427

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



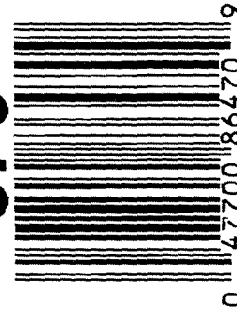
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6774427

UPC



BM FORM

GUN SERIAL # G 6774427

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-29-08	SPD
430	ASSEMBLE TO STOCK		7-29-08	SP
440	PROOF		7-29-08	SPD
460	CHECK HEADSPACE		7-29-08	SPD
470	DIS-ASSEMBLE ACTION		7-29-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX AUG 01 2008 OPERATOR BMT	7-31-08	RTZ
475	DRILL AND TAP SIGHT HOLES		7-31-08	SP
480	MAGNAFLUX BBL ACTION		8-1-08	BMT
490	MAGNAFLUX BOLT		7/29/08	MR
500	ROLLMARK CALIBER		8/1/08	RT
520	GOFF BLAST BBL / REC		8/4/08	DS
542	APPLY COATINGS (BARREL ACTION)		8 8	W
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-11-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-11-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-11-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-27-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

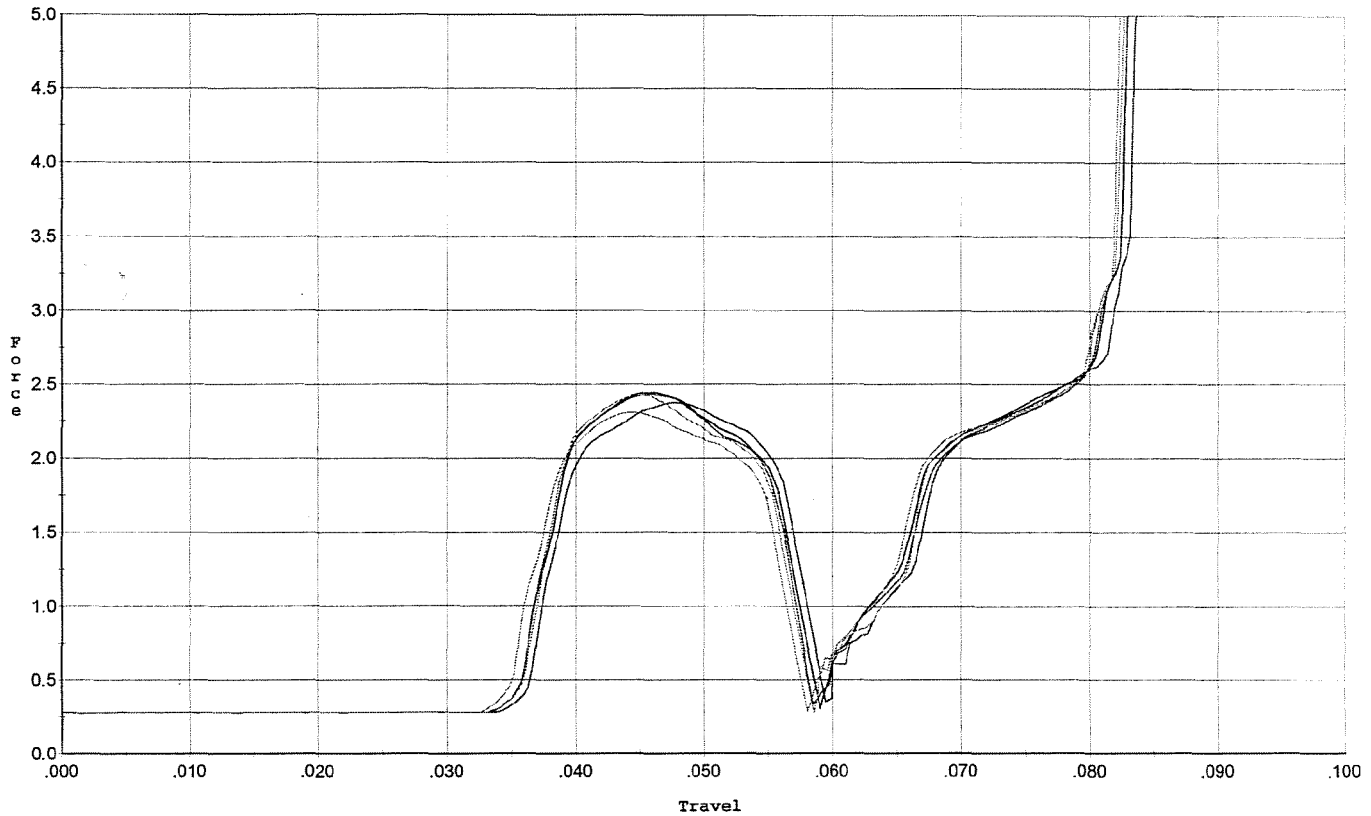
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>6.5</u>	10-9-08	R. N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>5.0</u> <u>5.0</u>	10-9-08	X. N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-9-08	X. N
	J) ASSEMBLE STOCK		8-27-08	L. N
	K) ASSEMBLE SWIVEL STUDS		10-9-08	L. A
	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	9-4-08	Fm
650	TARGET	<u>PASS</u> FAIL	9-4-08	Fm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-4-08	TRW
670	FINAL INSPECTION A) HEADSPACE		10-9-08	X. N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.69</u> <u>2.76</u> <u>2.64</u> <u>2.57</u>	9/30/08	Fm
	C) FUNCTION		10-9-08	X. N
690	PACK		12-4-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/12/08

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



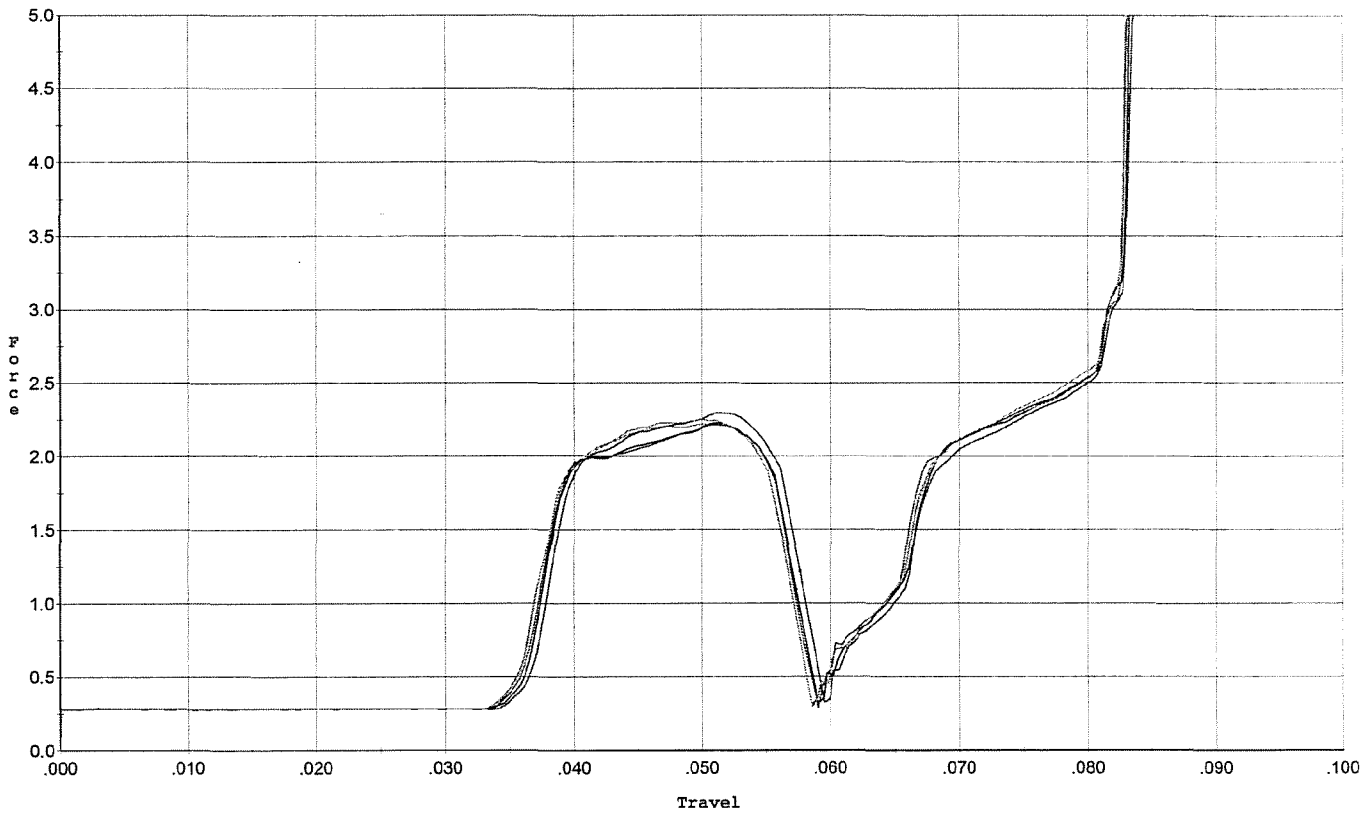
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.377	0.058	0.036	0.034	0.053		Set Trigger
2	2.445	0.056	0.036	0.034	0.052		Set Trigger
3	2.435	0.056	0.036	0.034	0.052		Set Trigger
4	2.428	0.055	0.036	0.034	0.051		Set Trigger
5	2.309	0.055	0.035	0.034	0.050		Set Trigger

Avg 2.39

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



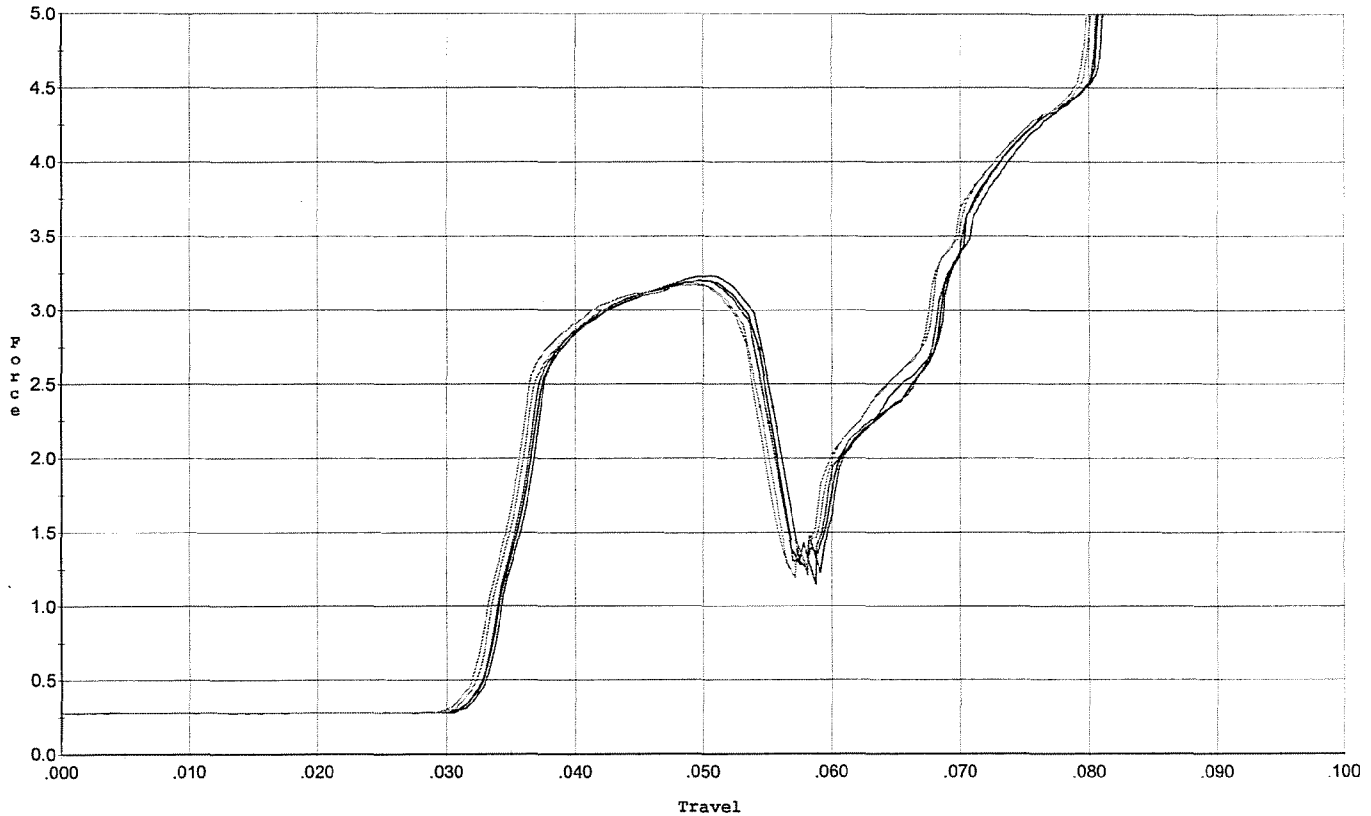
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.294	0.058	0.037	0.034	0.052		Set Trigger
2	2.227	0.057	0.036	0.034	0.050		Set Trigger
3	2.212	0.056	0.036	0.034	0.049		Set Trigger
4	2.220	0.056	0.035	0.034	0.050		Set Trigger
5	2.250	0.057	0.035	0.034	0.051		Set Trigger

Avg 2.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/12/08

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



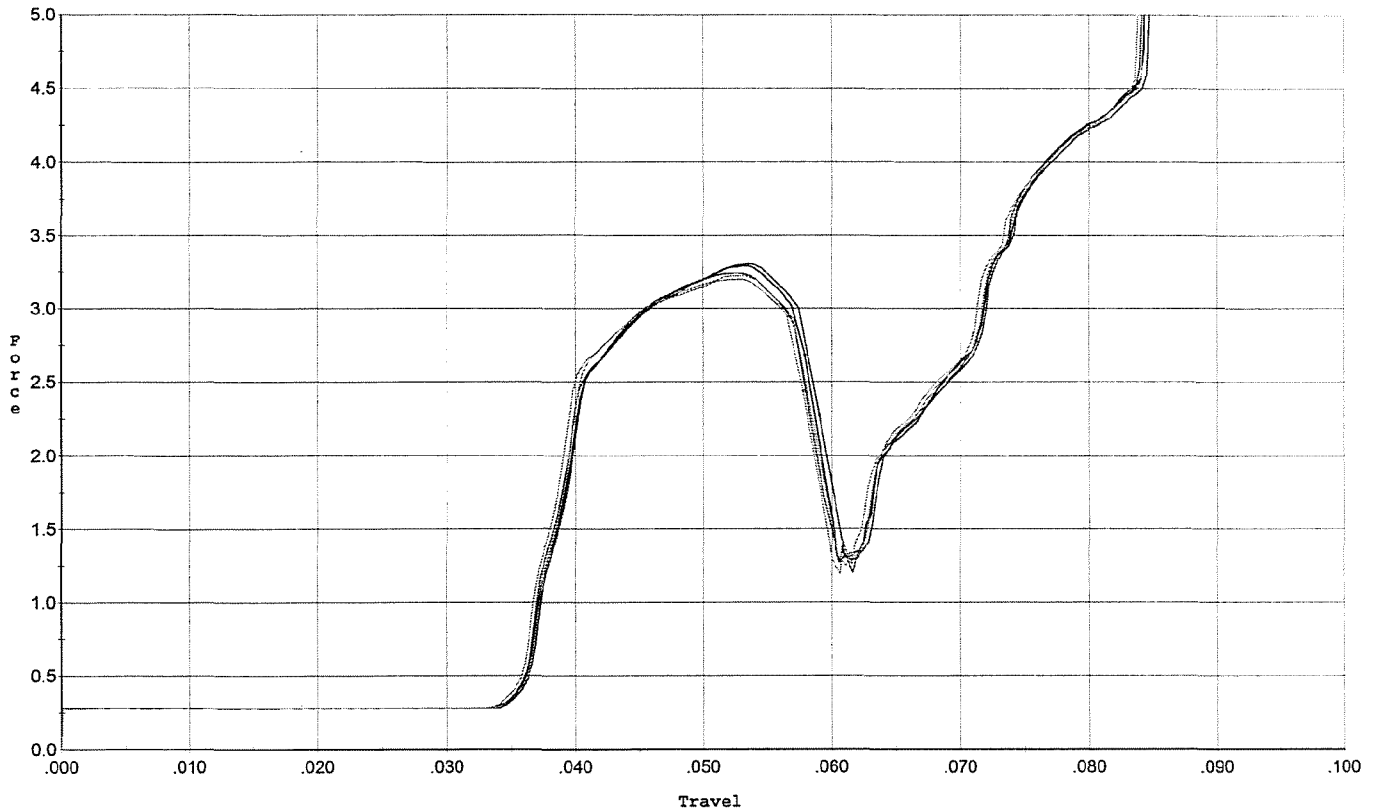
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.233	0.055	0.033	0.032	0.070		Set Trigger
2	3.202	0.054	0.033	0.031	0.068		Set Trigger
3	3.200	0.055	0.033	0.031	0.069		Set Trigger
4	3.168	0.054	0.032	0.031	0.068		Set Trigger
5	3.183	0.053	0.032	0.031	0.067		Set Trigger

Avg 3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



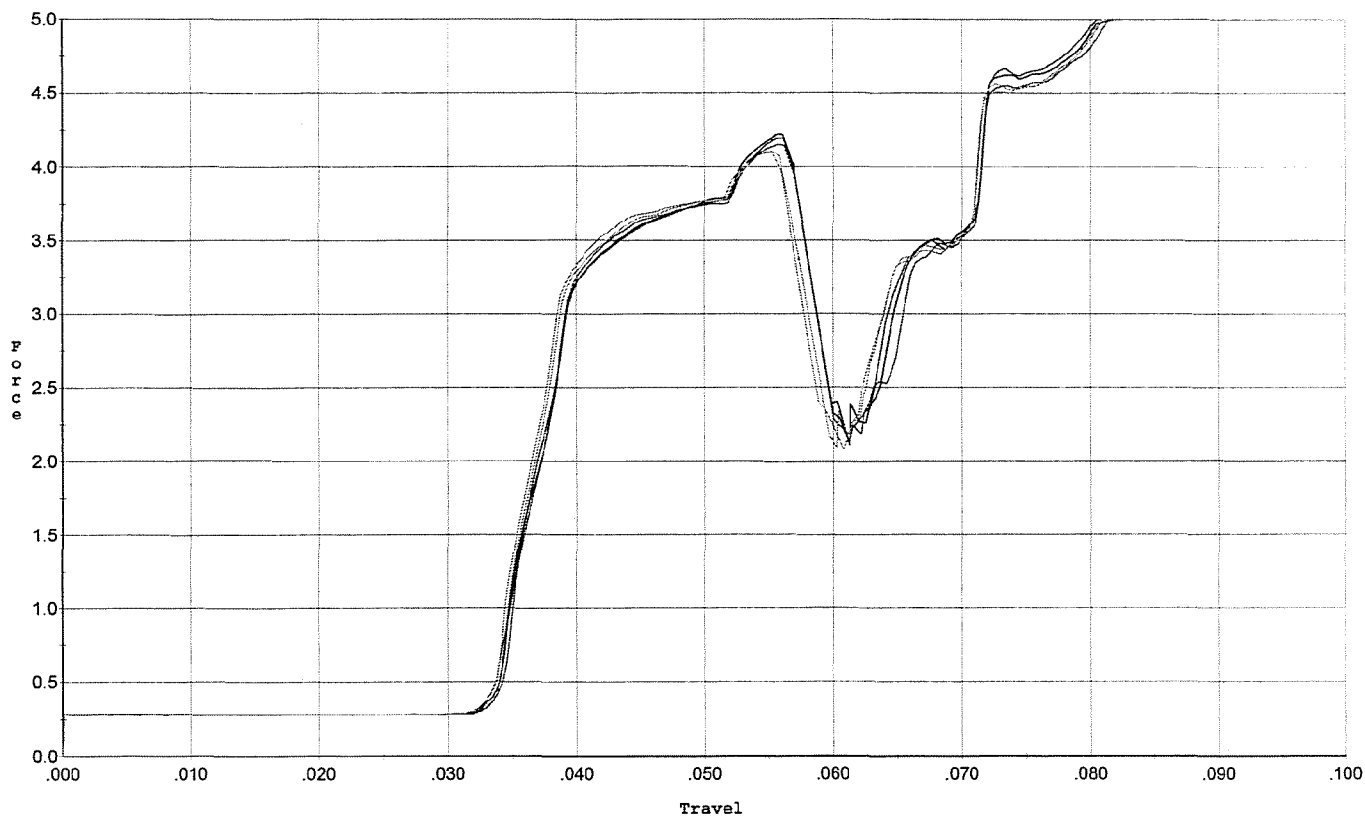
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.307	0.059	0.036	0.032	0.072		Set Trigger
2	3.294	0.058	0.036	0.032	0.071		Set Trigger
3	3.242	0.057	0.036	0.032	0.069		Set Trigger
4	3.225	0.059	0.036	0.032	0.071		Set Trigger
5	3.199	0.058	0.036	0.032	0.070		Set Trigger

AVG 3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



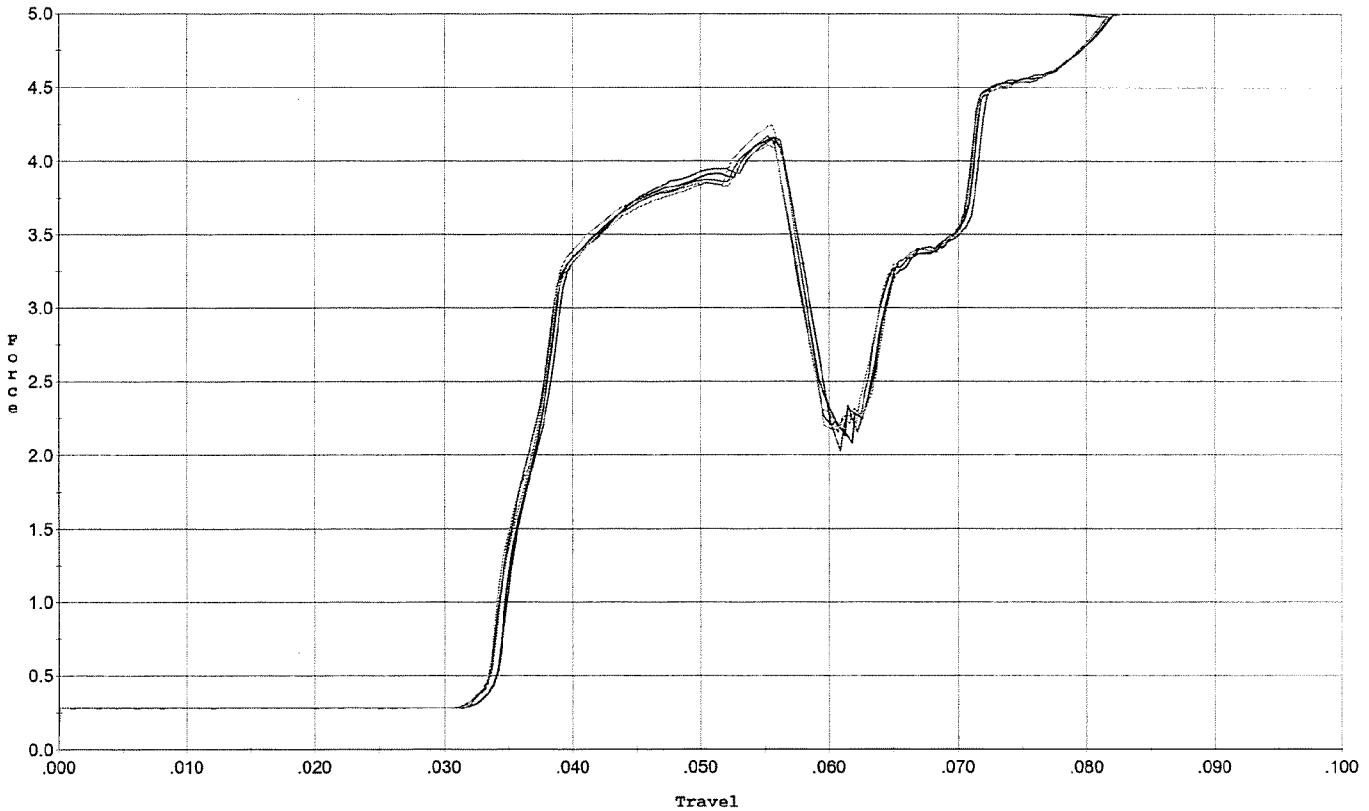
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.057	0.034	0.029	0.089		Set Trigger
2	4.220	0.057	0.034	0.029	0.088		Set Trigger
3	4.149	0.057	0.034	0.029	0.088		Set Trigger
4	4.104	0.057	0.034	0.029	0.089		Set Trigger
5	4.098	0.056	0.033	0.029	0.087		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/12/08

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



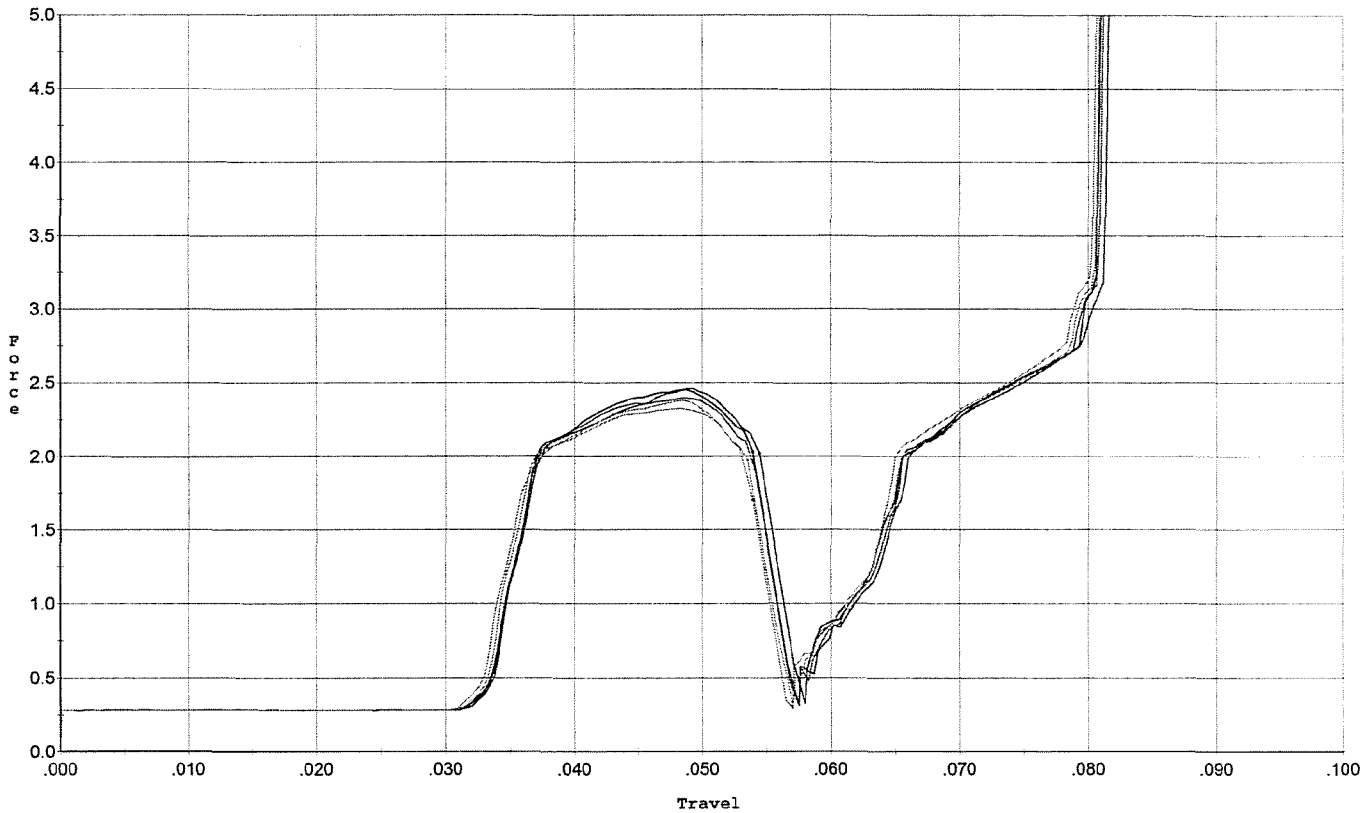
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.158	0.058	0.034	0.029	0.091		Set Trigger
2	4.164	0.056	0.034	0.030	0.088		Set Trigger
3	4.170	0.056	0.033	0.030	0.087		Set Trigger
4	4.111	0.058	0.034	0.029	0.090		Set Trigger
5	4.248	0.056	0.033	0.029	0.090		Set Trigger

Avg 4.17

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/12/08

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



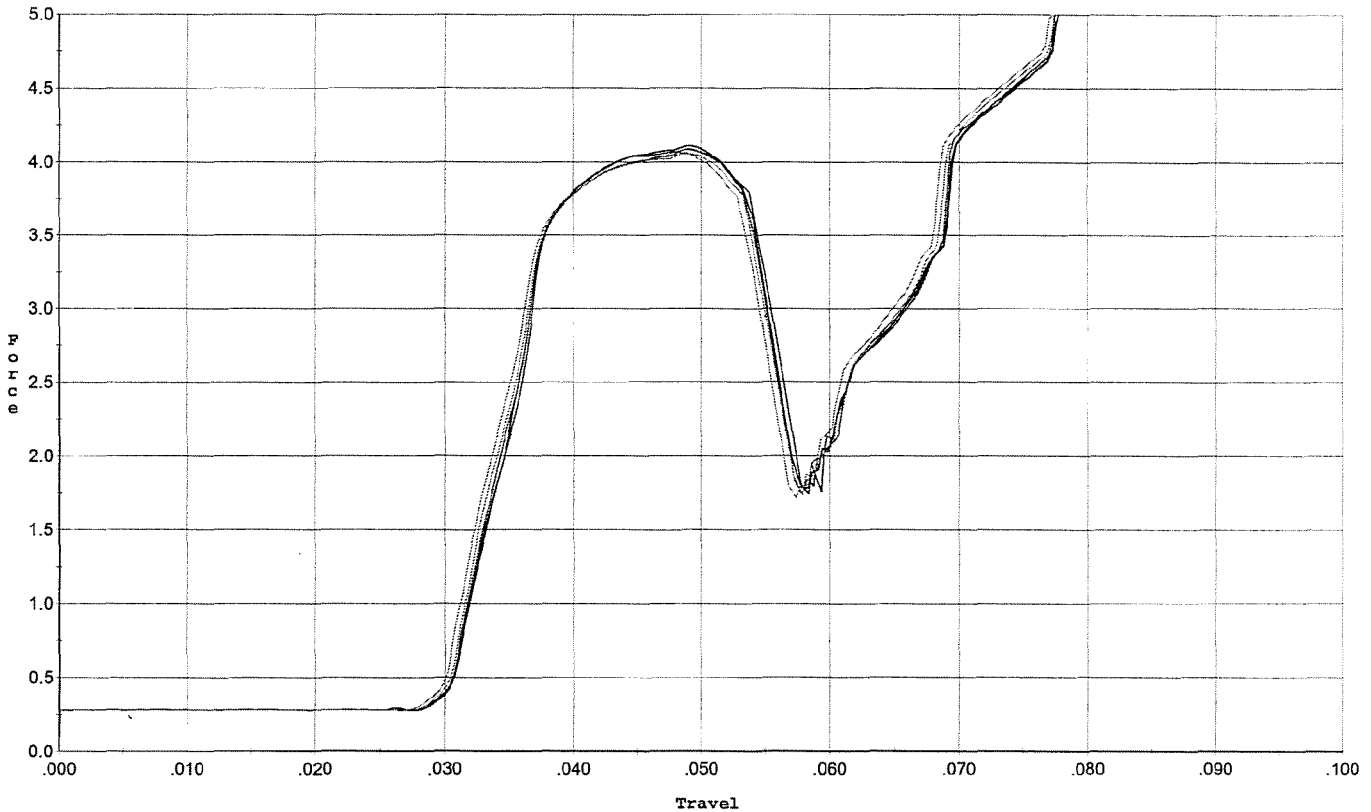
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.054	0.034	0.033	0.054		Set Trigger
2	2.453	0.054	0.034	0.033	0.053		Set Trigger
3	2.396	0.054	0.034	0.033	0.053		Set Trigger
4	2.325	0.054	0.033	0.033	0.051		Set Trigger
5	2.382	0.054	0.033	0.033	0.052		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/12/08

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	4.086	0.055	0.031	0.028	0.091		Set Trigger
2	4.109	0.054	0.031	0.029	0.088		Set Trigger
3	4.085	0.054	0.031	0.028	0.089		Set Trigger
4	4.054	0.055	0.030	0.028	0.090		Set Trigger
5	4.064	0.054	0.030	0.028	0.089		Set Trigger

Avq 4.08