

G6774473

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

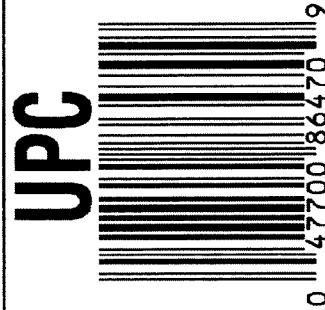


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6774473



BM FORM

GUN SERIAL #

G 6774473

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-31-08	SP
430	ASSEMBLE TO STOCK		7-31-08	SP
440	PROOF		7-31-08	SP
460	CHECK HEADSPACE		7-31-08	SP
470	DIS-ASSEMBLE ACTION		7-31-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-1-08	SP
475	DRILL AND TAP SIGHT HOLES	AUG 05 2008	8-2-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BT	8/5	BT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/5/08	RT
520	GOFF BLAST BBL / REC		8/6/08	RG
542	APPLY COATINGS (BARREL ACTION)		8/9	
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		8-12-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

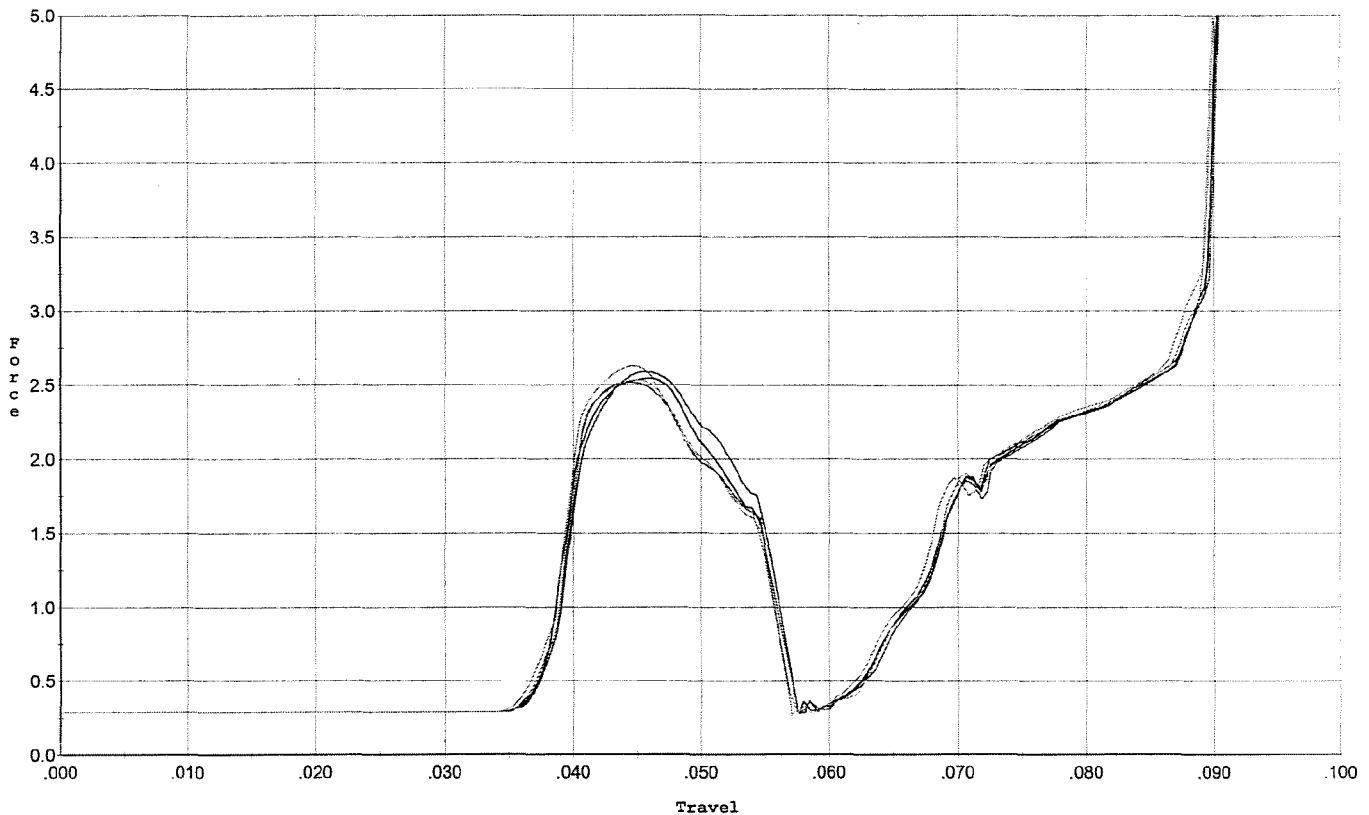
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.5</u> <u>3.0</u>	9-3-08	Rgn
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.5</u> <u>6.0</u> <u>6.0</u>	9-3-08	Rgn
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	9-3-08	Rgn
	J) ASSEMBLE STOCK		8-12-08	RTL
	K) ASSEMBLE SWIVEL STUDS		9-3-08	Rgn
	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	8-13-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NA		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-13-08	TRW
670	FINAL INSPECTION A) HEADSPACE		9-3-08	Rgn
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.66</u> <u>2.46</u> <u>2.44</u> <u>2.59</u>	8/16/08	Fm
	C) FUNCTION		9-3-08	Rgn
690	PACK		9-4-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/11/08

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



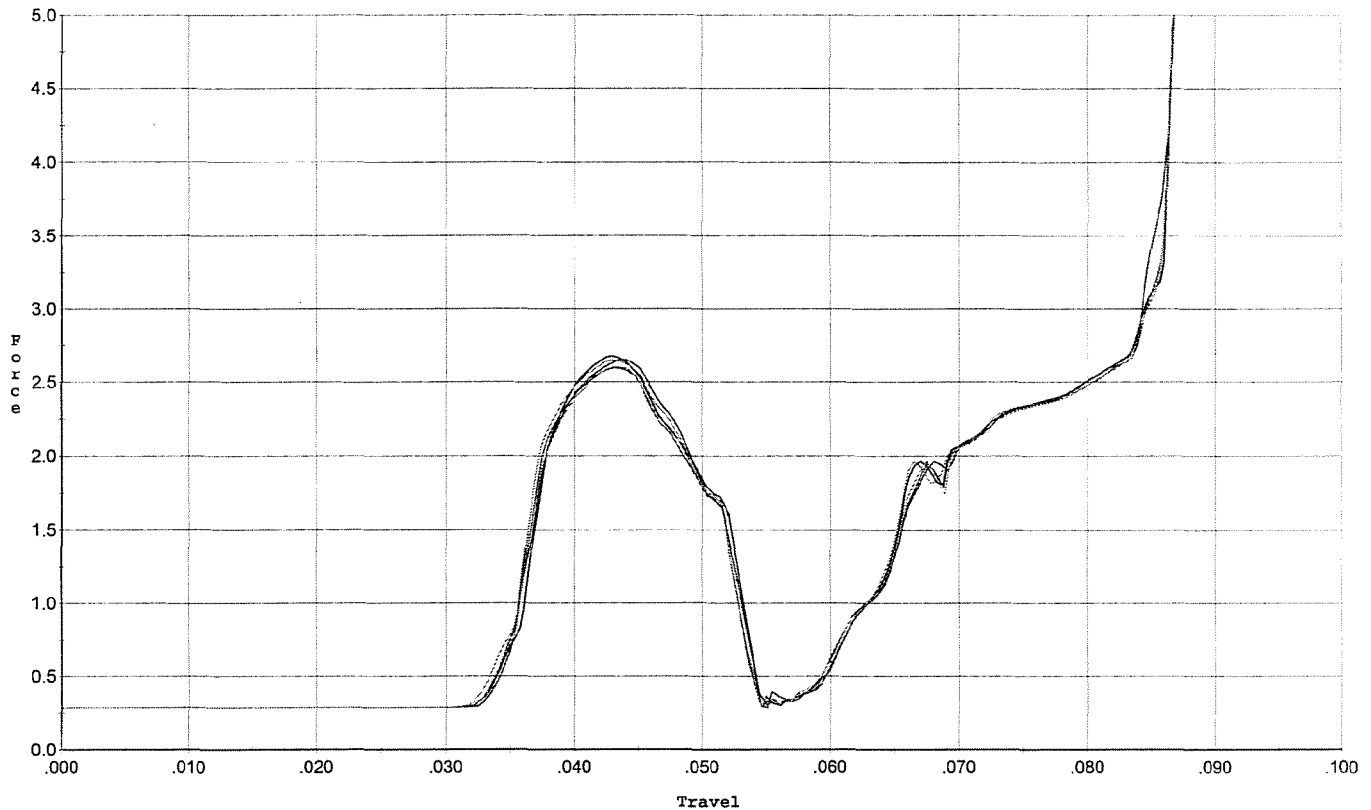
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.587	0.055	0.037	0.040	0.048		Set Trigger
2	2.542	0.055	0.037	0.040	0.046		Set Trigger
3	2.515	0.055	0.037	0.040	0.045		Set Trigger
4	2.534	0.055	0.037	0.040	0.046		Set Trigger
5	2.630	0.055	0.036	0.040	0.047		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Patch 8/11/08

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



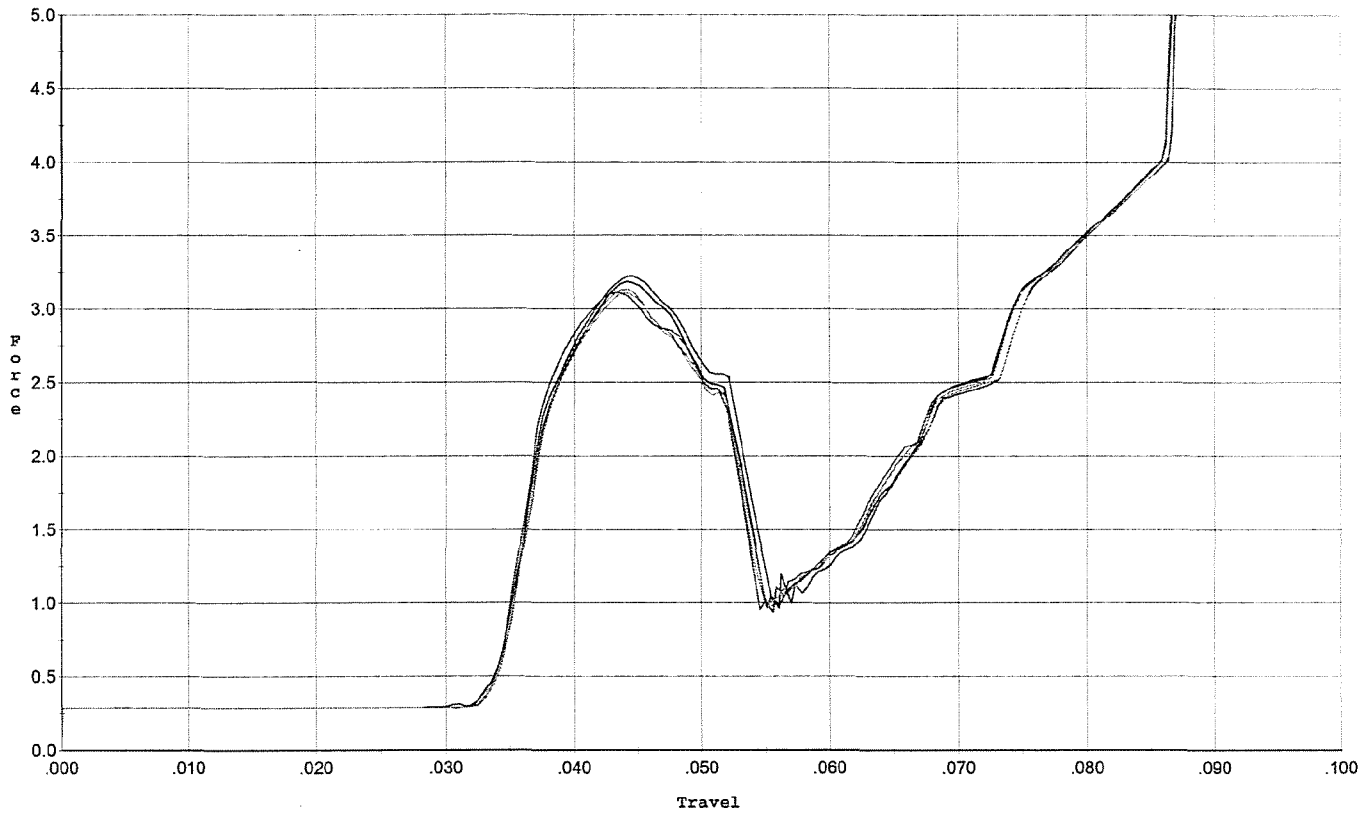
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.651	0.053	0.034	0.039	0.047		Set Trigger
2	2.676	0.052	0.034	0.039	0.047		Set Trigger
3	2.598	0.051	0.033	0.039	0.046		Set Trigger
4	2.601	0.051	0.034	0.039	0.046		Set Trigger
5	2.649	0.051	0.033	0.039	0.047		Set Trigger

AVG 2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/11/08

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



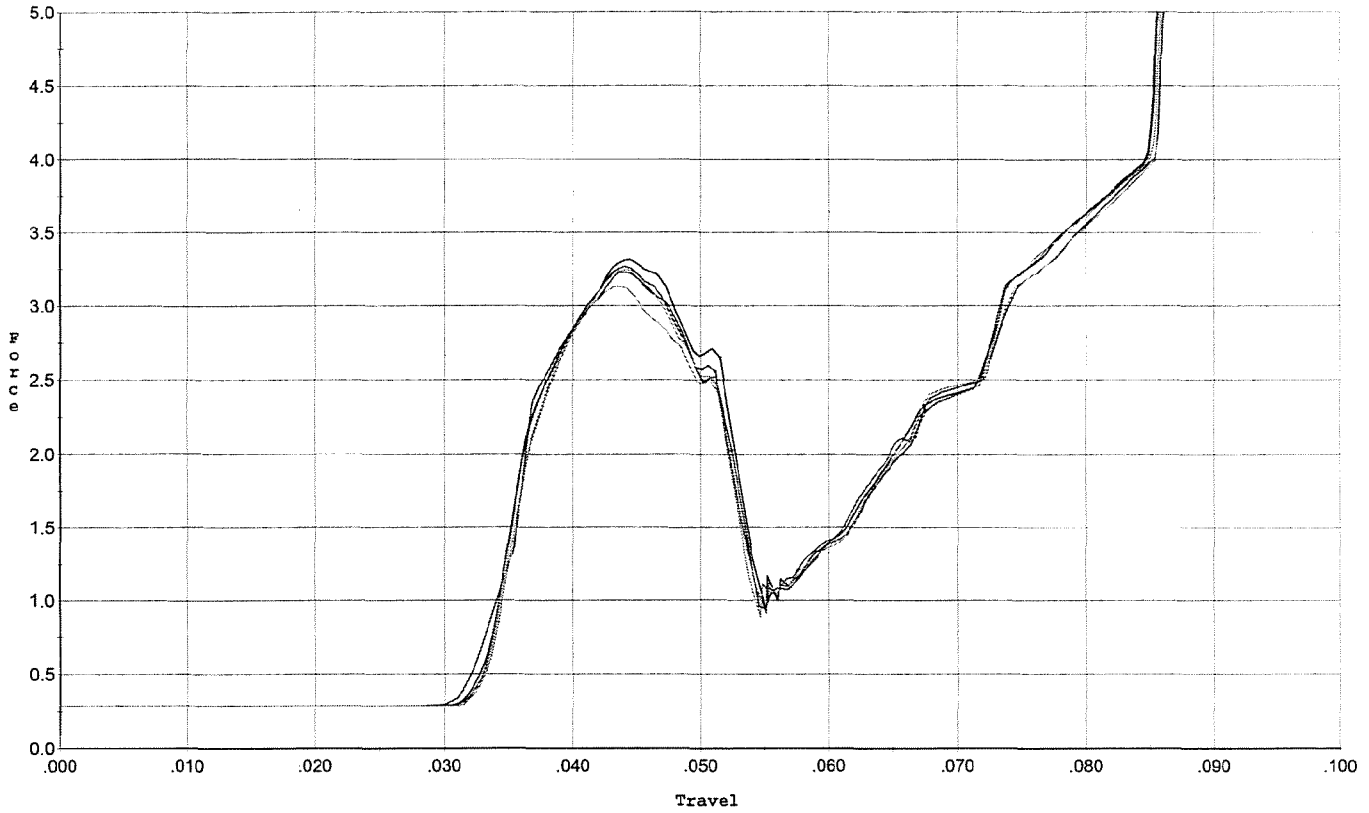
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.052	0.033	0.038	0.058		Set Trigger
2	3.185	0.053	0.033	0.037	0.058		Set Trigger
3	3.110	0.052	0.033	0.037	0.056		Set Trigger
4	3.131	0.052	0.033	0.038	0.055		Set Trigger
5	3.103	0.052	0.034	0.038	0.055		Set Trigger

AVG 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/11/08

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



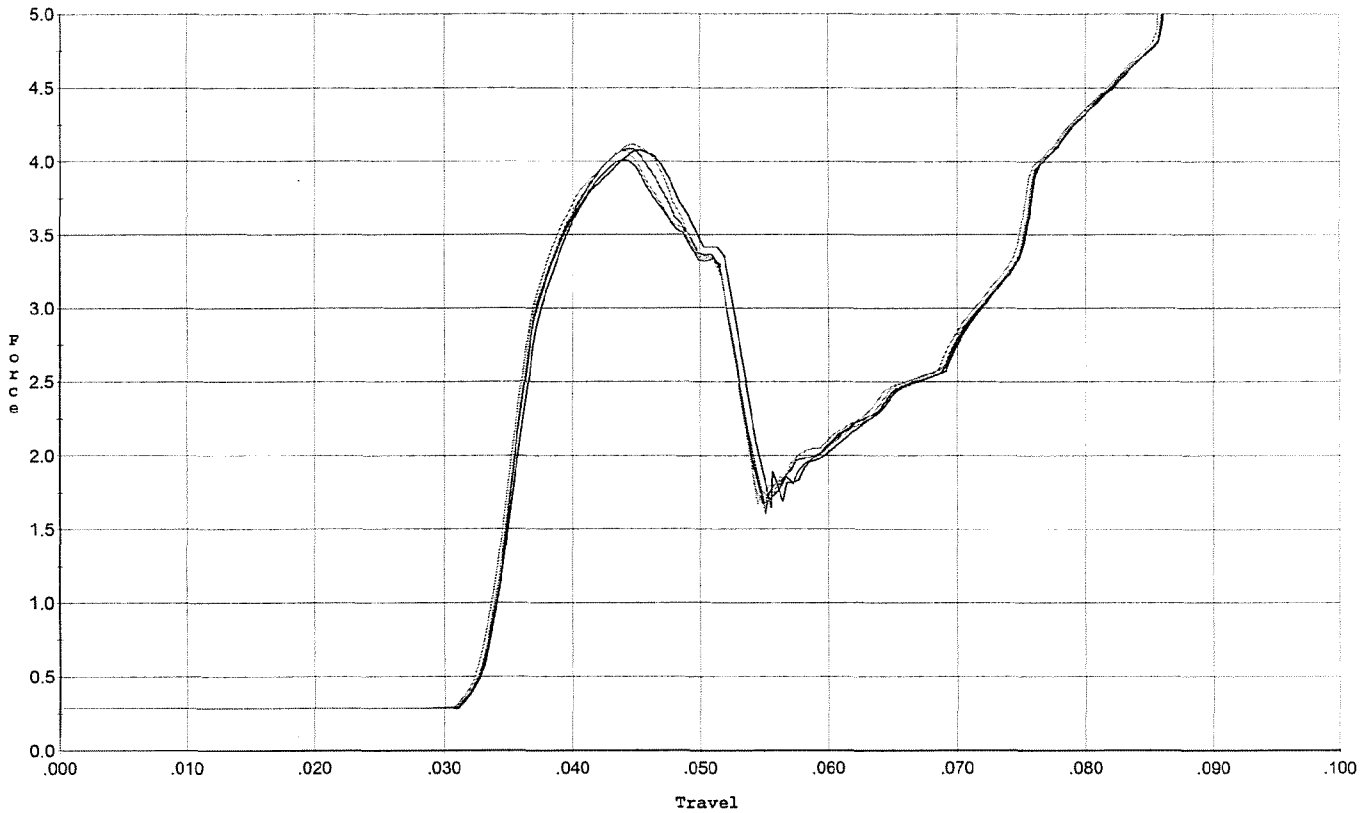
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.228	0.052	0.032	0.037	0.059		Set Trigger
2	3.314	0.051	0.032	0.037	0.059		Set Trigger
3	3.266	0.051	0.033	0.037	0.057		Set Trigger
4	3.244	0.051	0.033	0.037	0.057		Set Trigger
5	3.131	0.051	0.033	0.037	0.056		Set Trigger

AVG 3.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/11/08

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



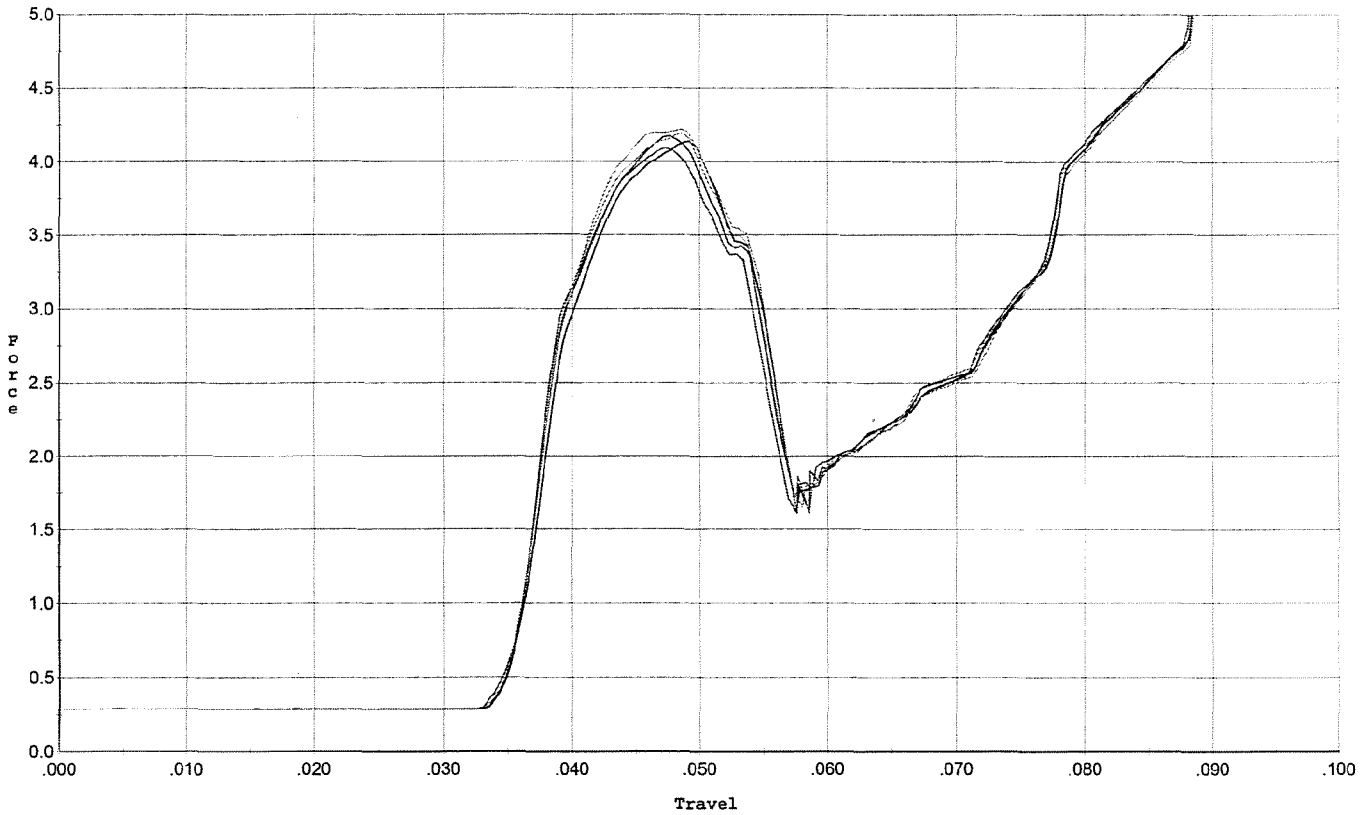
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.010	0.051	0.033	0.036	0.071		Set Trigger
2	4.074	0.052	0.032	0.036	0.073		Set Trigger
3	4.084	0.051	0.032	0.036	0.072		Set Trigger
4	4.068	0.052	0.032	0.036	0.072		Set Trigger
5	4.118	0.052	0.032	0.036	0.073		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/11/08

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



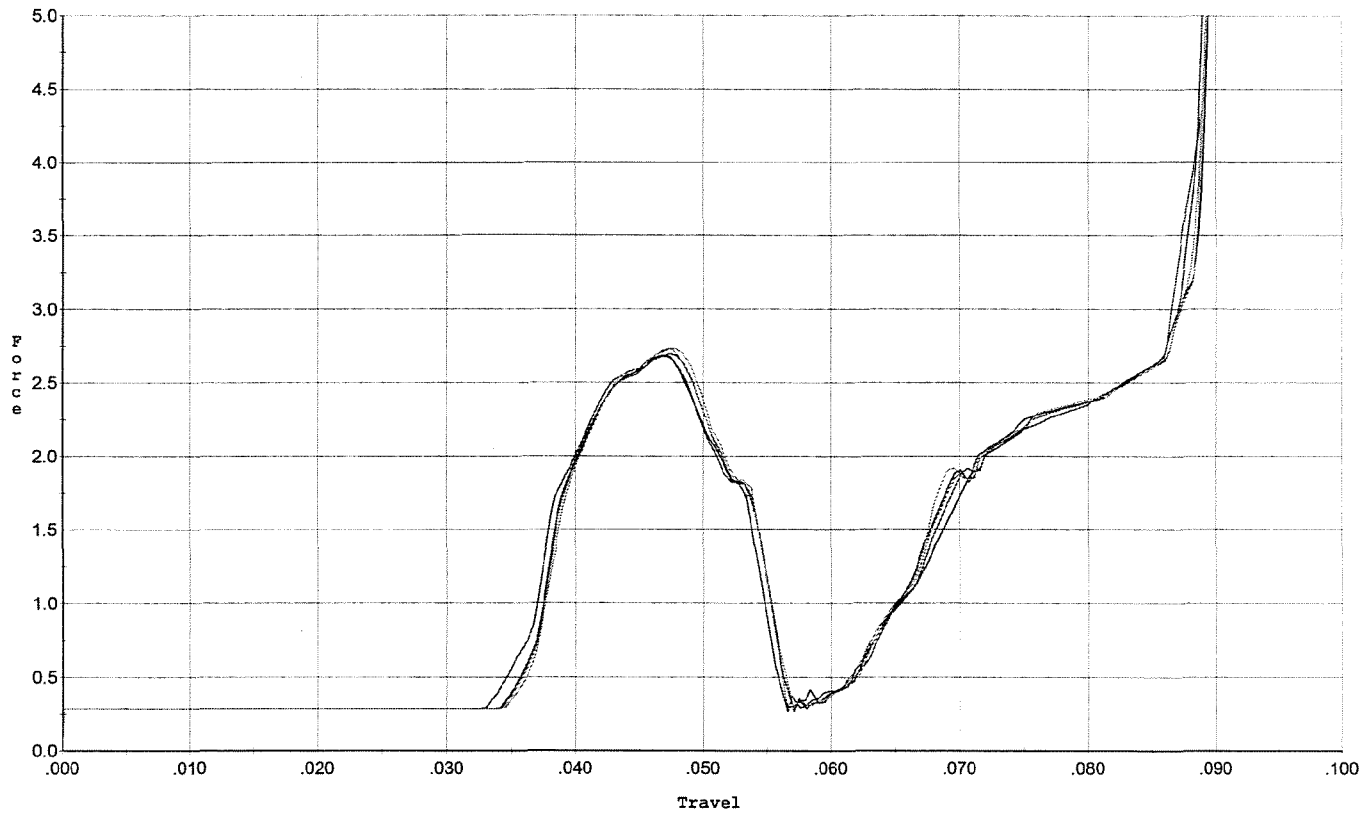
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.173	0.054	0.034	0.037	0.074		Set Trigger
2	4.136	0.055	0.035	0.037	0.076		Set Trigger
3	4.092	0.053	0.034	0.037	0.073		Set Trigger
4	4.191	0.054	0.034	0.037	0.075		Set Trigger
5	4.220	0.055	0.034	0.037	0.078		Set Trigger

AVG 4.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/11/08

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



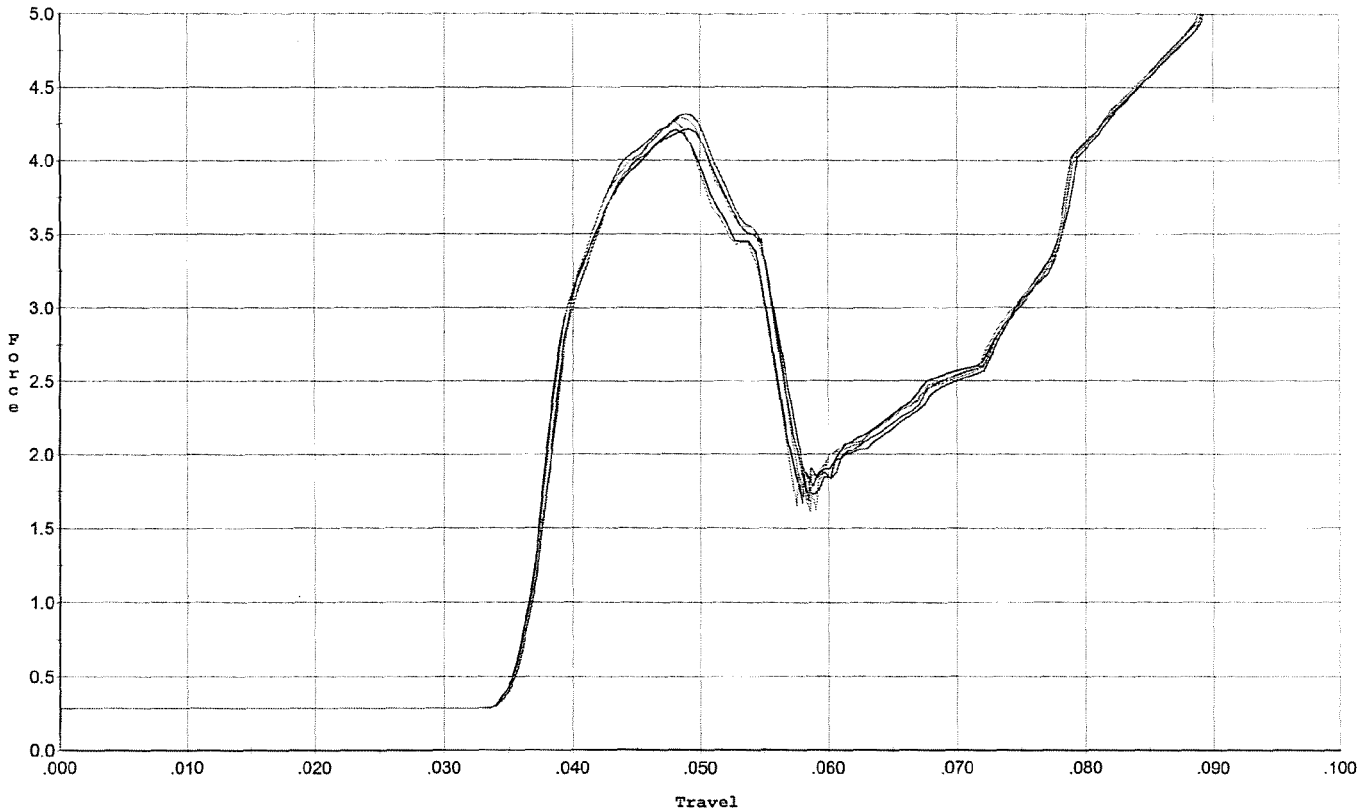
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.681	0.053	0.034	0.040	0.048		Set Trigger
2	2.688	0.054	0.035	0.040	0.048		Set Trigger
3	2.696	0.054	0.035	0.040	0.048		Set Trigger
4	2.733	0.054	0.035	0.040	0.048		Set Trigger
5	2.727	0.054	0.036	0.040	0.048		Set Trigger

AVG 2.70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/11/08

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	4.214	0.055	0.035	0.037	0.077		Set Trigger
2	4.206	0.054	0.035	0.037	0.075		Set Trigger
3	4.317	0.055	0.035	0.037	0.078		Set Trigger
4	4.292	0.055	0.035	0.037	0.077		Set Trigger
5	4.260	0.055	0.035	0.037	0.076		Set Trigger

AVG 4.25