

G6784566

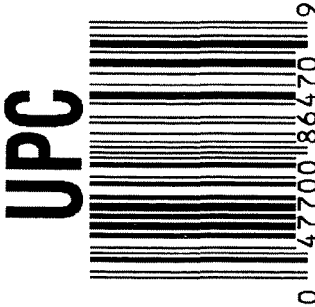
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784566



GUN SERIAL #

G6784566

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SPD
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SPD
460	CHECK HEADSPACE		9-19-08	SPD
470	DIS-ASSEMBLE ACTION		9-19-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-20-08	SP
475	DRILL AND TAP SIGHT HOLES	SEP 22 2008	9-20-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BH	9-22-08	BH
490	MAGNAFLUX BOLT		9/19/08	MR
500	ROLLMARK CALIBER		9/22/08	RT
520	GOFF BLAST BBL / REC		9/22/08	DS
542	APPLY COATINGS (BARREL ACTION)		9-27	~
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-1-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-1-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-1-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-10-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

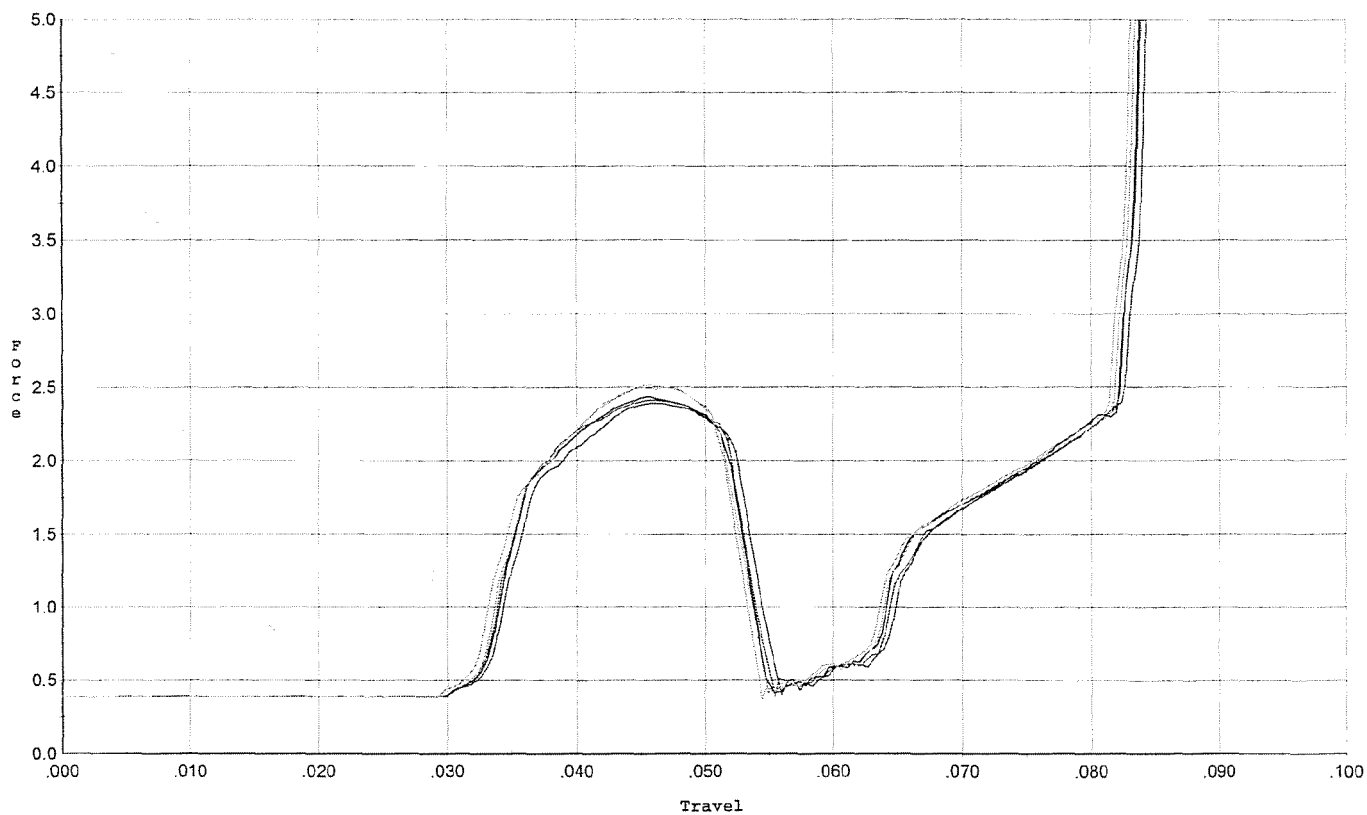
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.5</u> <u>4.0</u>	12-3-08	L N
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>4.0</u>	12-3-08	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-3-08	L N
	J) ASSEMBLE STOCK		10-10-08	L N
	K) ASSEMBLE SWIVEL STUDS		12-3-08	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL	10-27-08	TC
650	TARGET	<u>PASS</u> FAIL	10-11-08	TC
	MALFUNCTION <i>OH over live round</i>	CORRECTION	10-27-08	TC
	MALFUNCTION <i>CH over live round</i>	CORRECTION	10-27-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-11-08	L N
670	FINAL INSPECTION A) HEADSPACE		12-3-08	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.39</u> <u>2.33</u> <u>2.32</u> <u>2.29</u>	10-20-08	TC
	C) FUNCTION		12-3-08	R N
690	PACK		12-5-08	ESN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/8/08

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



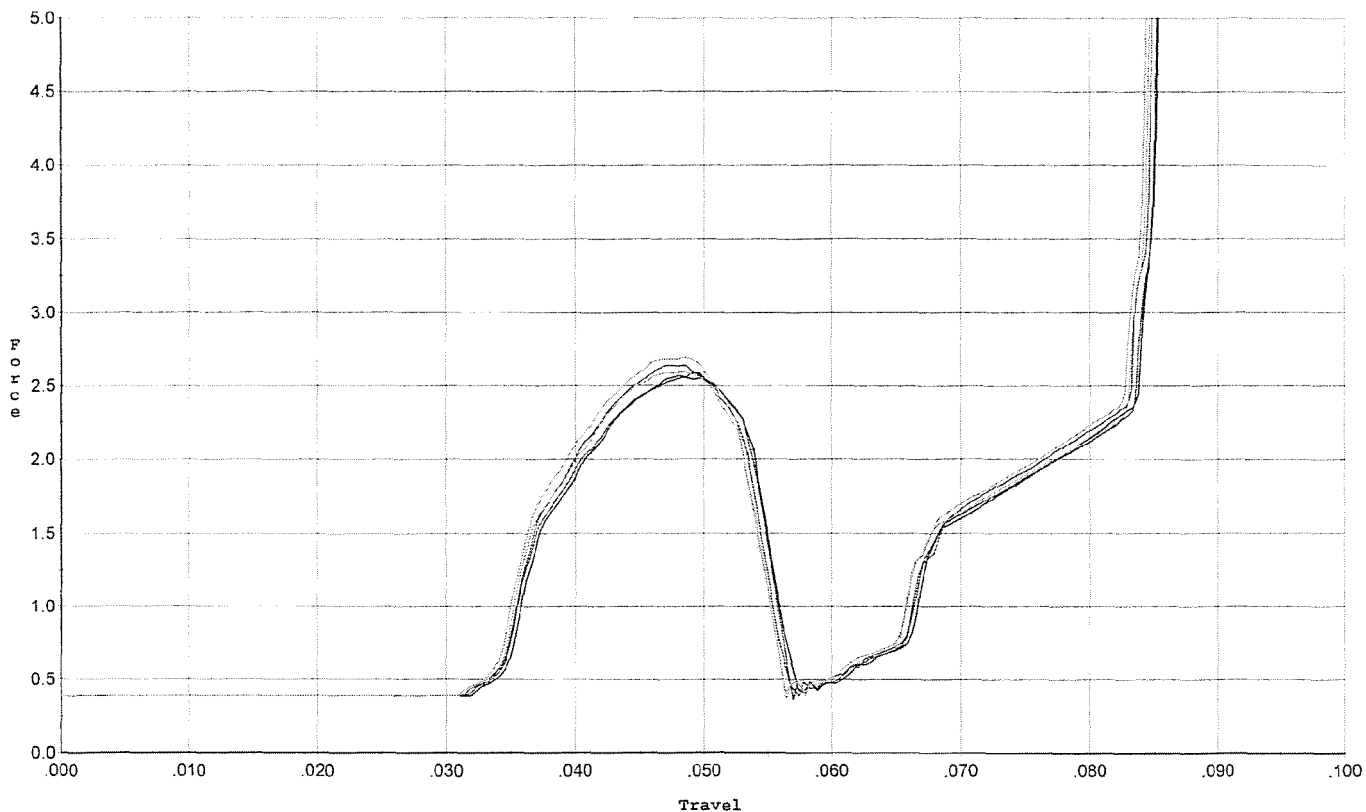
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.391	0.052	0.033	0.036	0.053		Set Trigger
2	2.431	0.052	0.033	0.036	0.053		Set Trigger
3	2.412	0.052	0.033	0.036	0.053		Set Trigger
4	2.515	0.053	0.033	0.036	0.055		Set Trigger
5	2.498	0.051	0.032	0.036	0.054		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/8/08

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



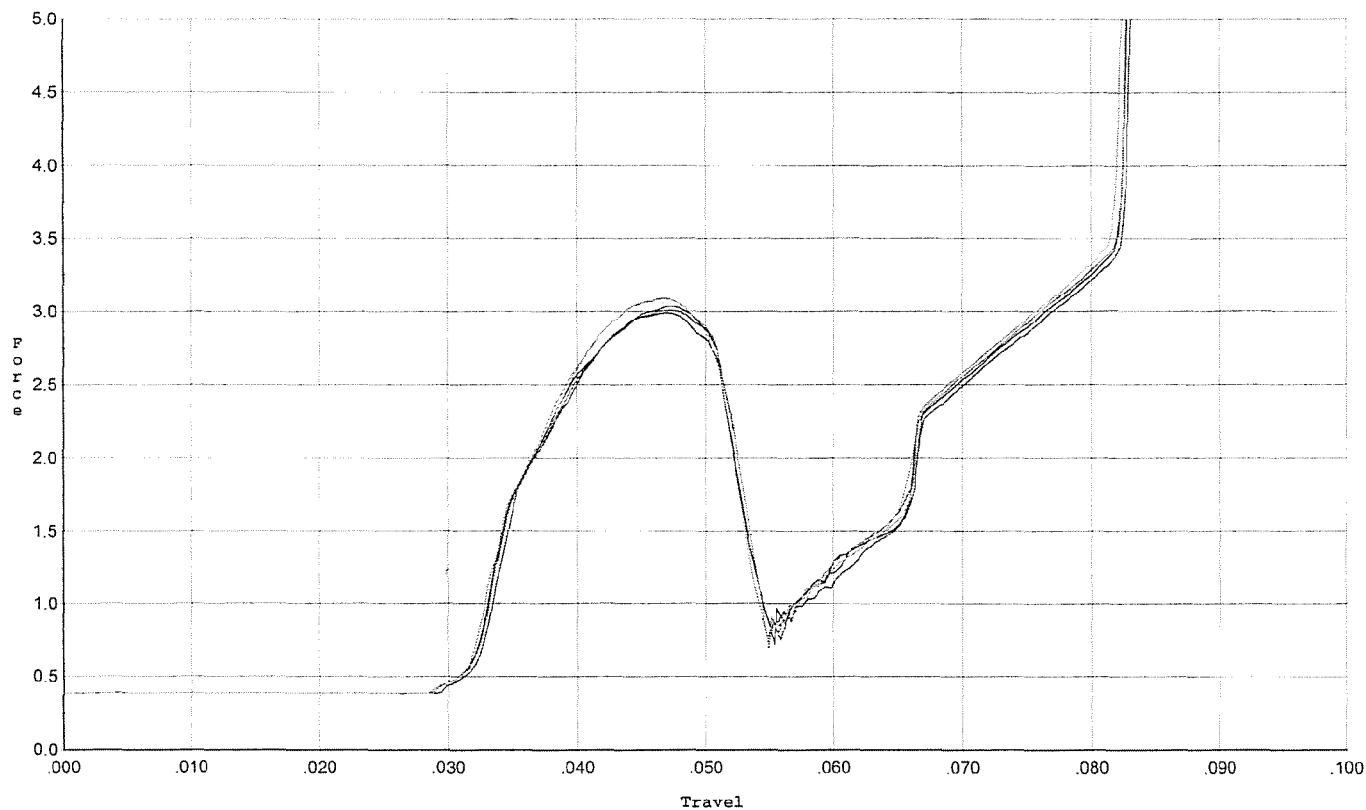
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.587	0.054	0.035	0.036	0.055		Set Trigger
2	2.569	0.054	0.035	0.036	0.054		Set Trigger
3	2.639	0.053	0.035	0.036	0.055		Set Trigger
4	2.593	0.054	0.034	0.036	0.055		Set Trigger
5	2.691	0.054	0.034	0.036	0.057		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/8/08

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



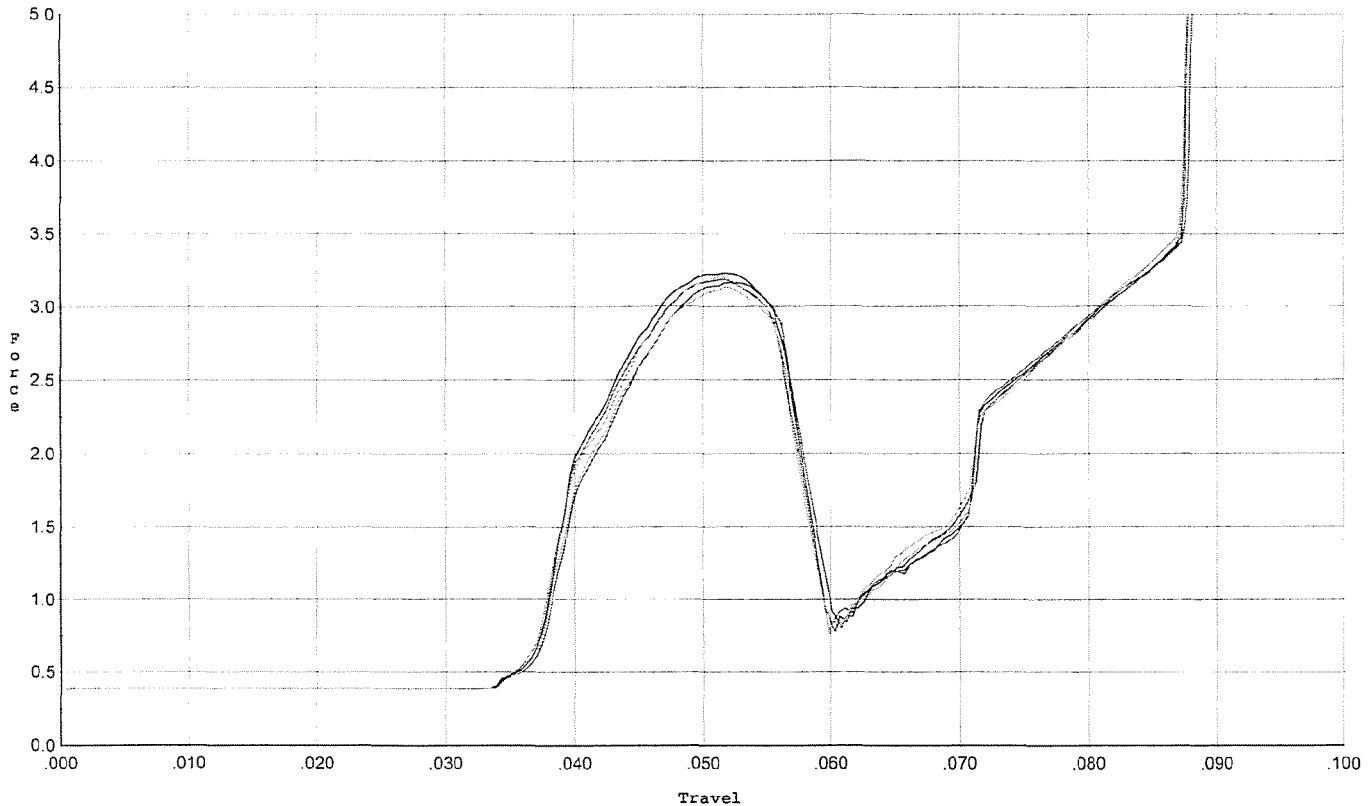
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.036	0.052	0.032	0.035	0.061		Set Trigger
2	2.990	0.051	0.032	0.035	0.060		Set Trigger
3	3.005	0.052	0.032	0.035	0.062		Set Trigger
4	3.088	0.052	0.032	0.035	0.062		Set Trigger
5	3.093	0.051	0.032	0.034	0.061		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/8/08

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



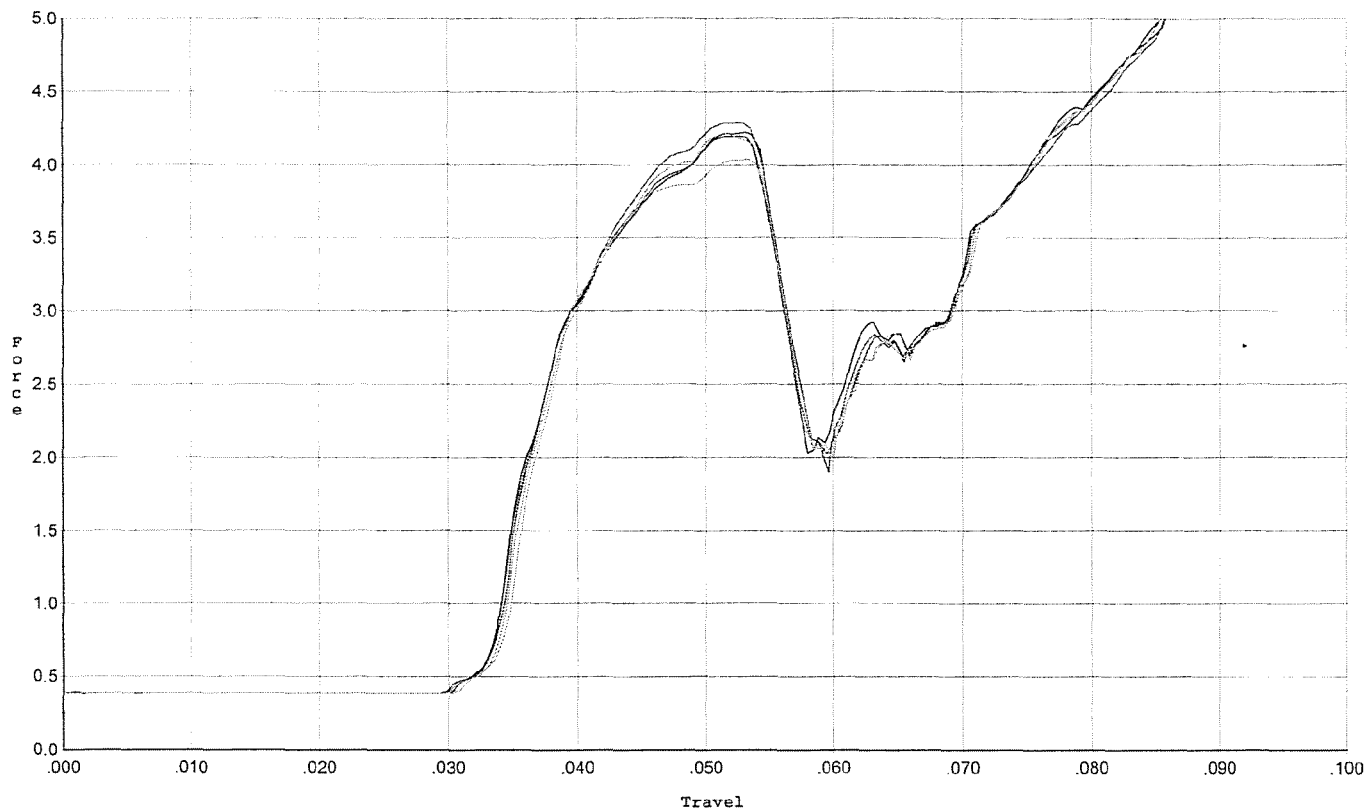
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.164	0.056	0.037	0.036	0.064		Set Trigger
2	3.230	0.056	0.037	0.036	0.067		Set Trigger
3	3.185	0.057	0.037	0.036	0.067		Set Trigger
4	3.201	0.056	0.037	0.037	0.065		Set Trigger
5	3.131	0.057	0.037	0.036	0.065		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/8/08

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



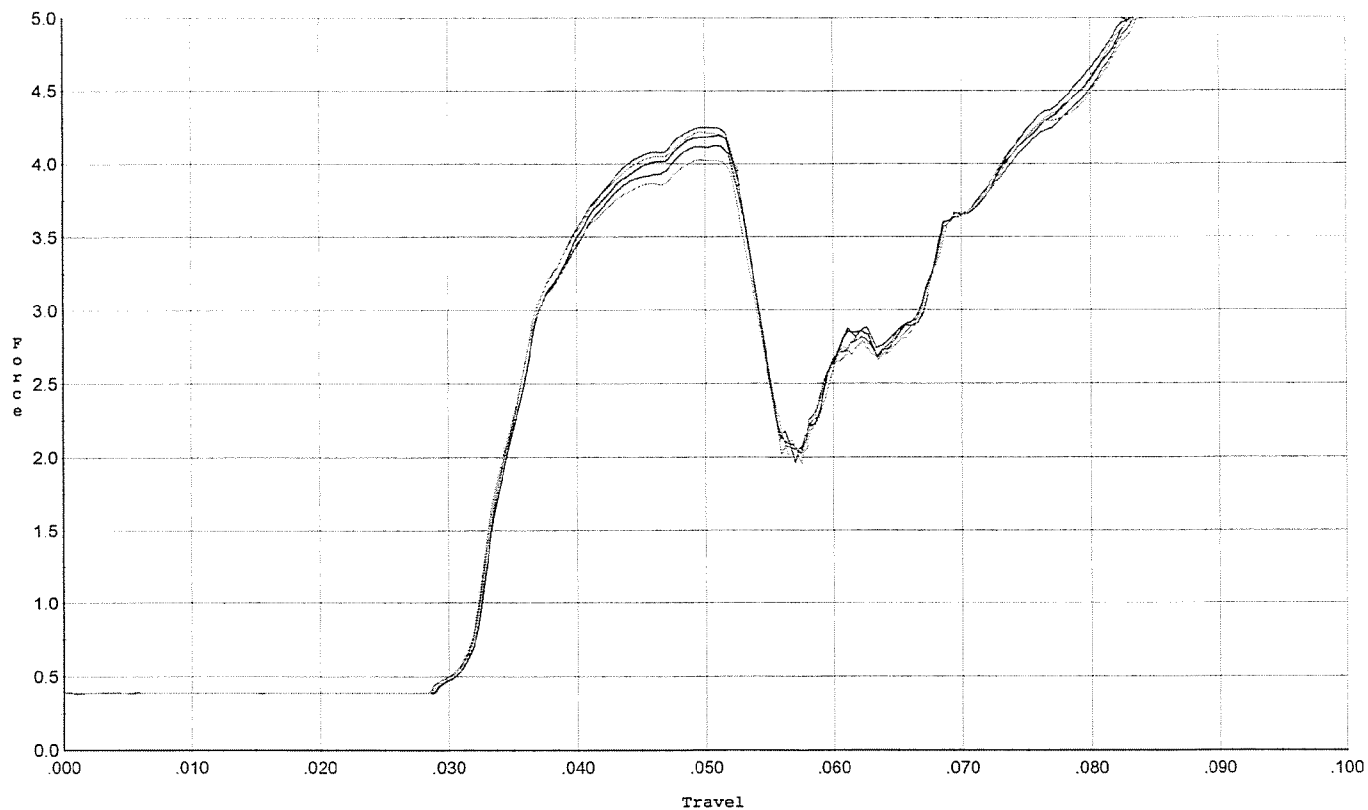
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.222	0.054	0.033	0.034	0.086		Set Trigger
2	4.196	0.055	0.033	0.033	0.087		Set Trigger
3	4.289	0.054	0.033	0.034	0.087		Set Trigger
4	4.037	0.055	0.034	0.034	0.084		Set Trigger
5	4.216	0.055	0.034	0.034	0.086		Set Trigger

Aug 4.19

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/8/08

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



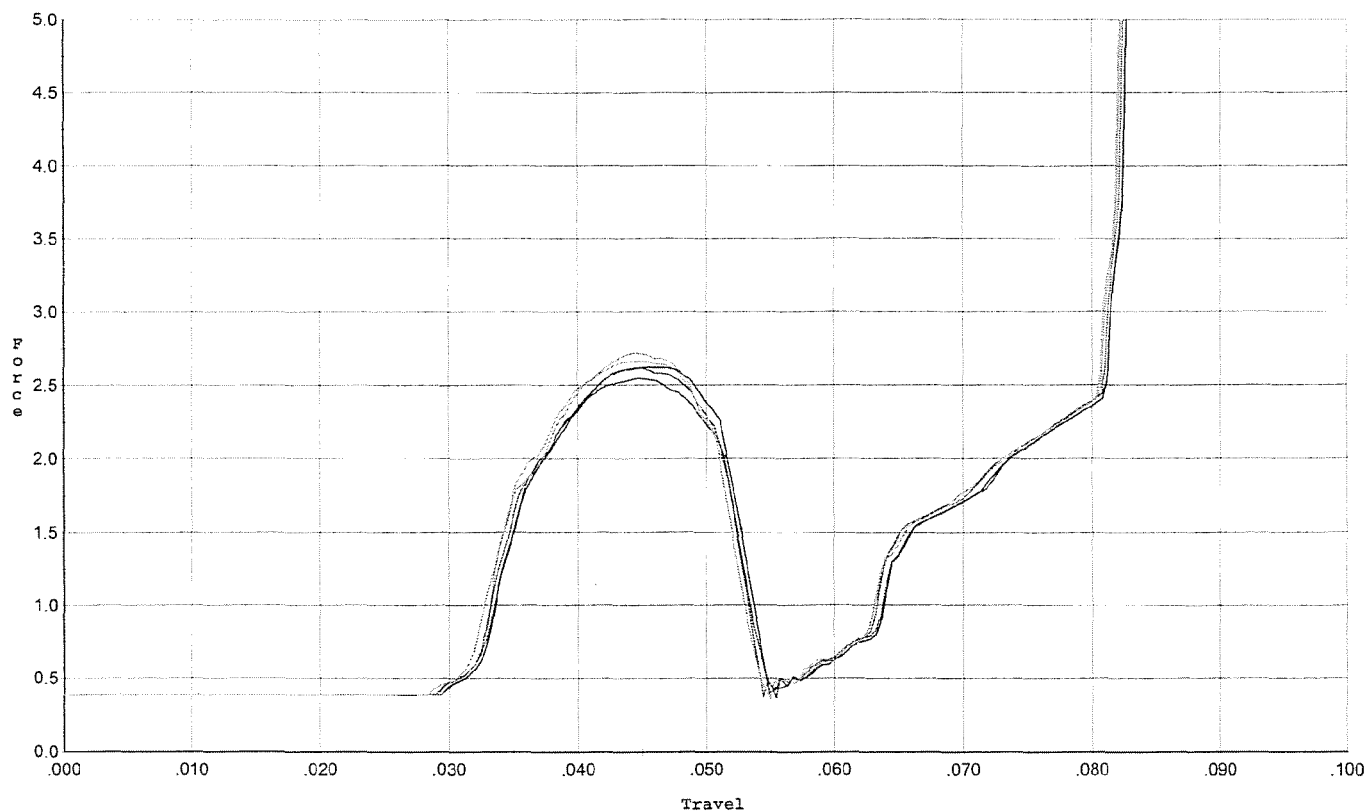
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.124	0.053	0.031	0.033	0.085		Set Trigger
2	4.199	0.053	0.032	0.033	0.085		Set Trigger
3	4.249	0.052	0.032	0.033	0.086		Set Trigger
4	4.220	0.052	0.032	0.033	0.086		Set Trigger
5	4.028	0.054	0.029	0.033	0.086		Set Trigger

Aug 4.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/8/08

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



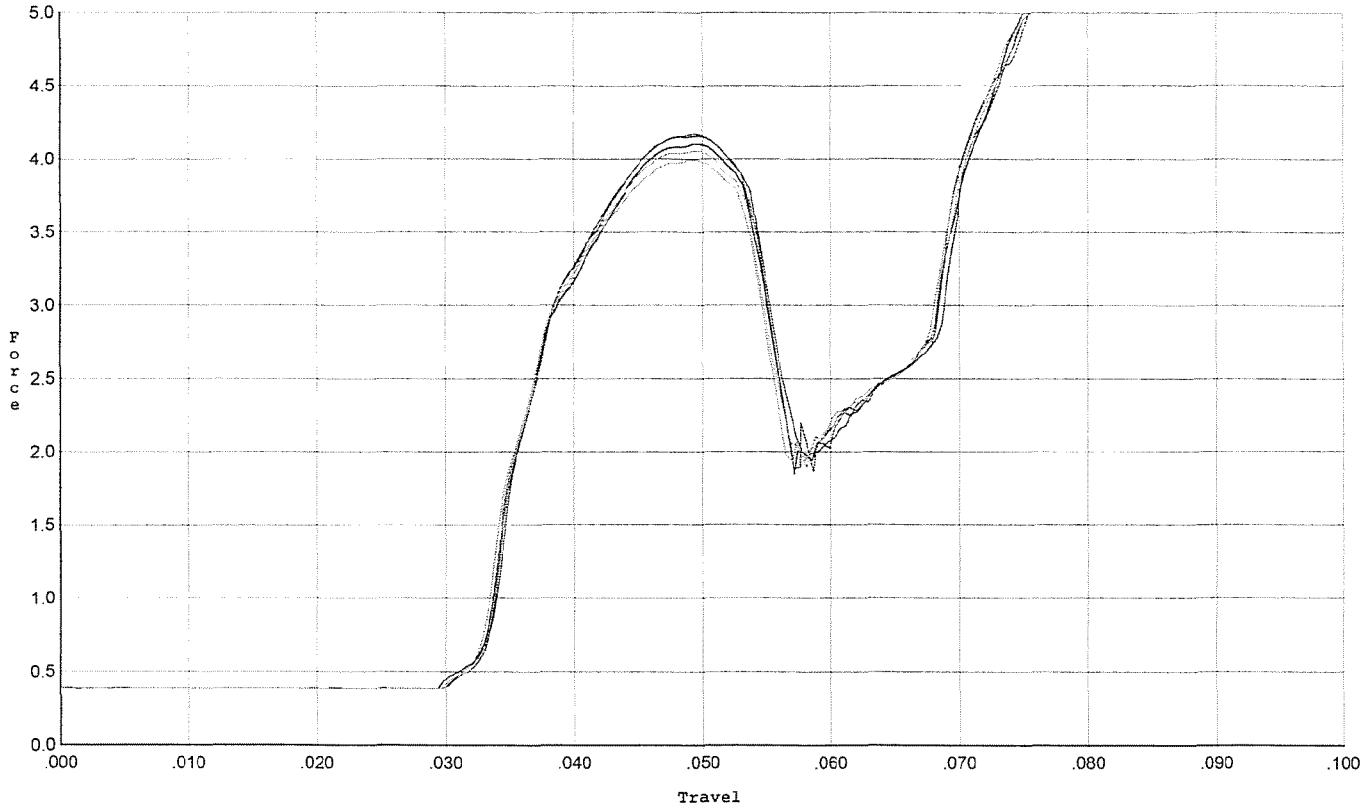
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.051	0.032	0.035	0.054		Set Trigger
2	2.623	0.053	0.033	0.035	0.056		Set Trigger
3	2.619	0.052	0.032	0.035	0.055		Set Trigger
4	2.662	0.051	0.032	0.035	0.055		Set Trigger
5	2.718	0.051	0.032	0.035	0.055		Set Trigger

Aug 2.63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/8/08

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	4.164	0.054	0.033	0.034	0.085		Set Trigger
2	4.104	0.055	0.033	0.033	0.086		Set Trigger
3	4.172	0.054	0.033	0.033	0.086		Set Trigger
4	4.057	0.053	0.033	0.034	0.083		Set Trigger
5	3.996	0.054	0.033	0.033	0.083		Set Trigger

Avg 4.09