

G6784578

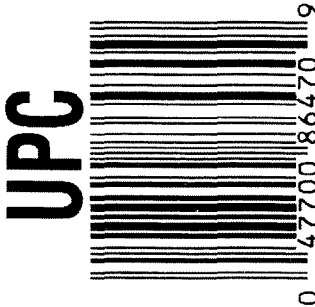
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784578



GUN SERIAL # G6784578

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SP
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SP
460	CHECK HEADSPACE		9-19-08	SP
470	DIS-ASSEMBLE ACTION	MAGNA - FLUX SEP 22 2008 OPERATOR <u>BH</u>	9-19-08	SP
472	SERIALIZE BOLT HANDLE		9-20-08	SP
475	DRILL AND TAP SIGHT HOLES		9-20-08	SP
480	MAGNAFLUX BBL ACTION		9-22-08	BH
490	MAGNAFLUX BOLT		9-22-08	MK
500	ROLLMARK CALIBER		9-22-08	RT
520	GOFF BLAST BBL / REC		9-23-08	DG
542	APPLY COATINGS (BARREL ACTION)		9-24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-14-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

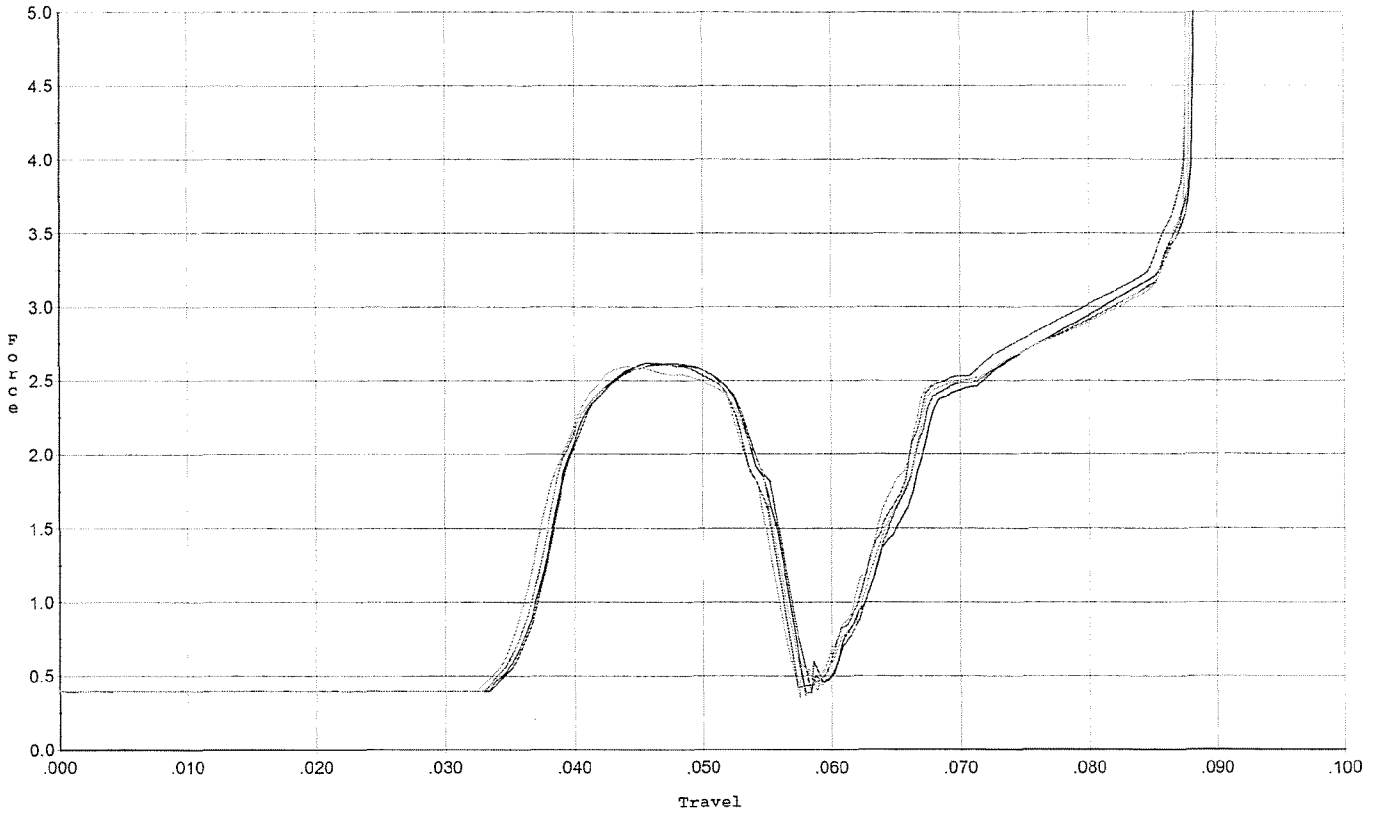
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	12-12-08	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	12-12-08	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>-.023</u> <u>-.023</u> <u>-.023</u>	12-12-08	R.N.
	J) ASSEMBLE STOCK		10-14-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		12-12-08	R.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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12-10-08	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-10-08	RP
670	FINAL INSPECTION A) HEADSPACE		12-12-08	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.30</u> <u>2.04</u> <u>2.04</u> <u>2.06</u>	12-11-08	R.N.
	C) FUNCTION		12-12-08	R.N.
690	PACK		12-16-08	R.N.

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



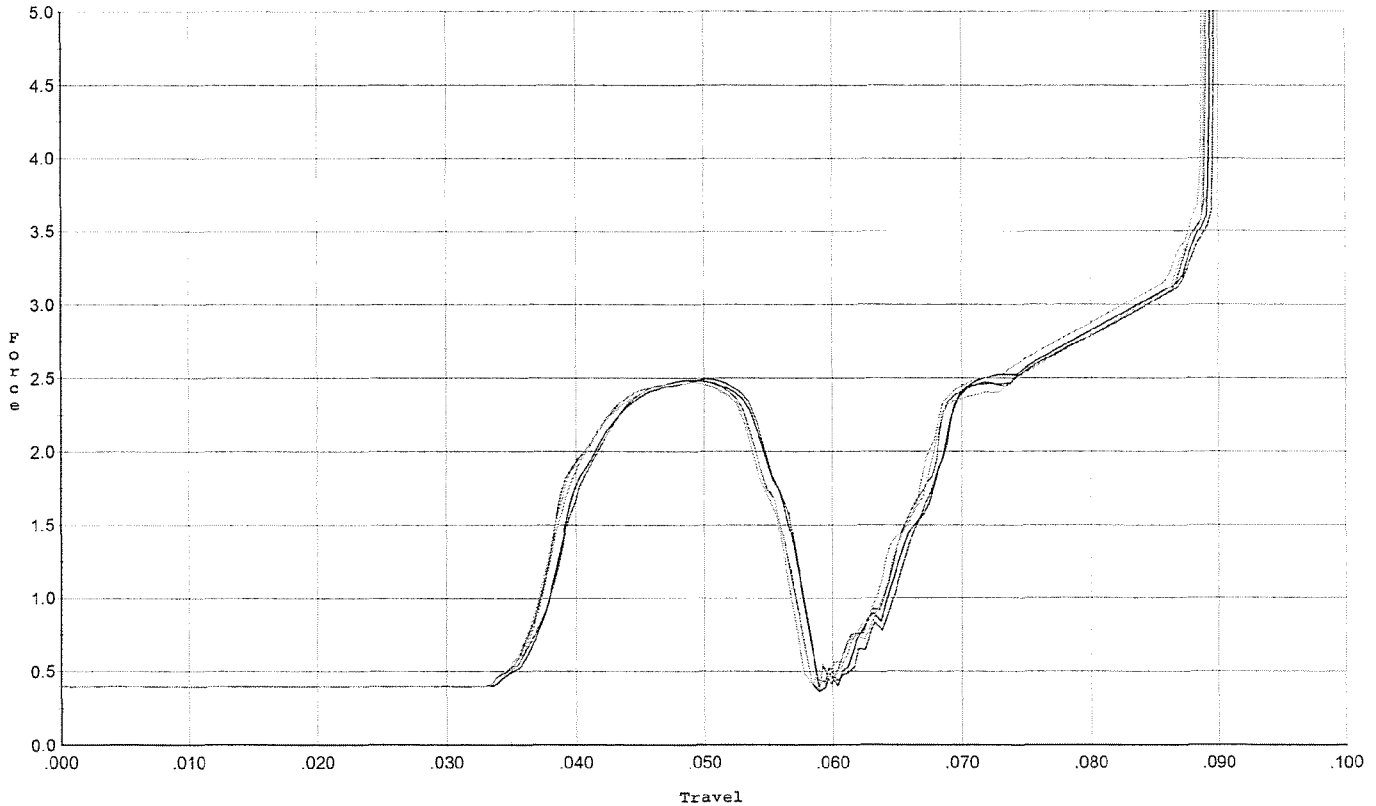
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.055	0.036	0.038	0.057		Set Trigger
2	2.619	0.056	0.036	0.038	0.058		Set Trigger
3	2.617	0.055	0.035	0.038	0.057		Set Trigger
4	2.596	0.055	0.035	0.038	0.057		Set Trigger
5	2.609	0.054	0.035	0.038	0.056		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

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

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



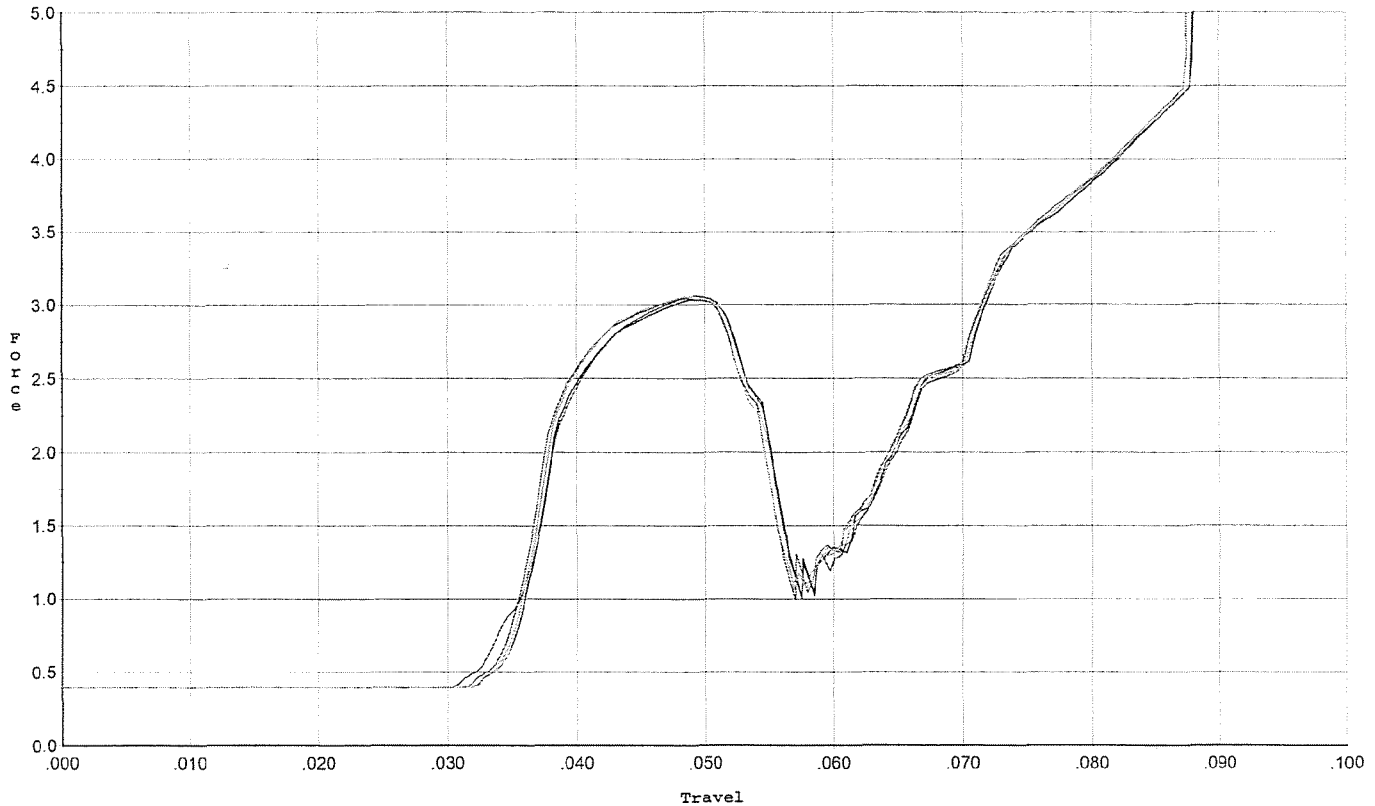
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.057	0.036	0.038	0.056		Set Trigger
2	2.480	0.057	0.037	0.038	0.056		Set Trigger
3	2.485	0.057	0.036	0.038	0.057		Set Trigger
4	2.471	0.057	0.036	0.038	0.056		Set Trigger
5	2.469	0.056	0.036	0.038	0.055		Set Trigger

Avg 2.48

Trigger Profile [lbs,inch]

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

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



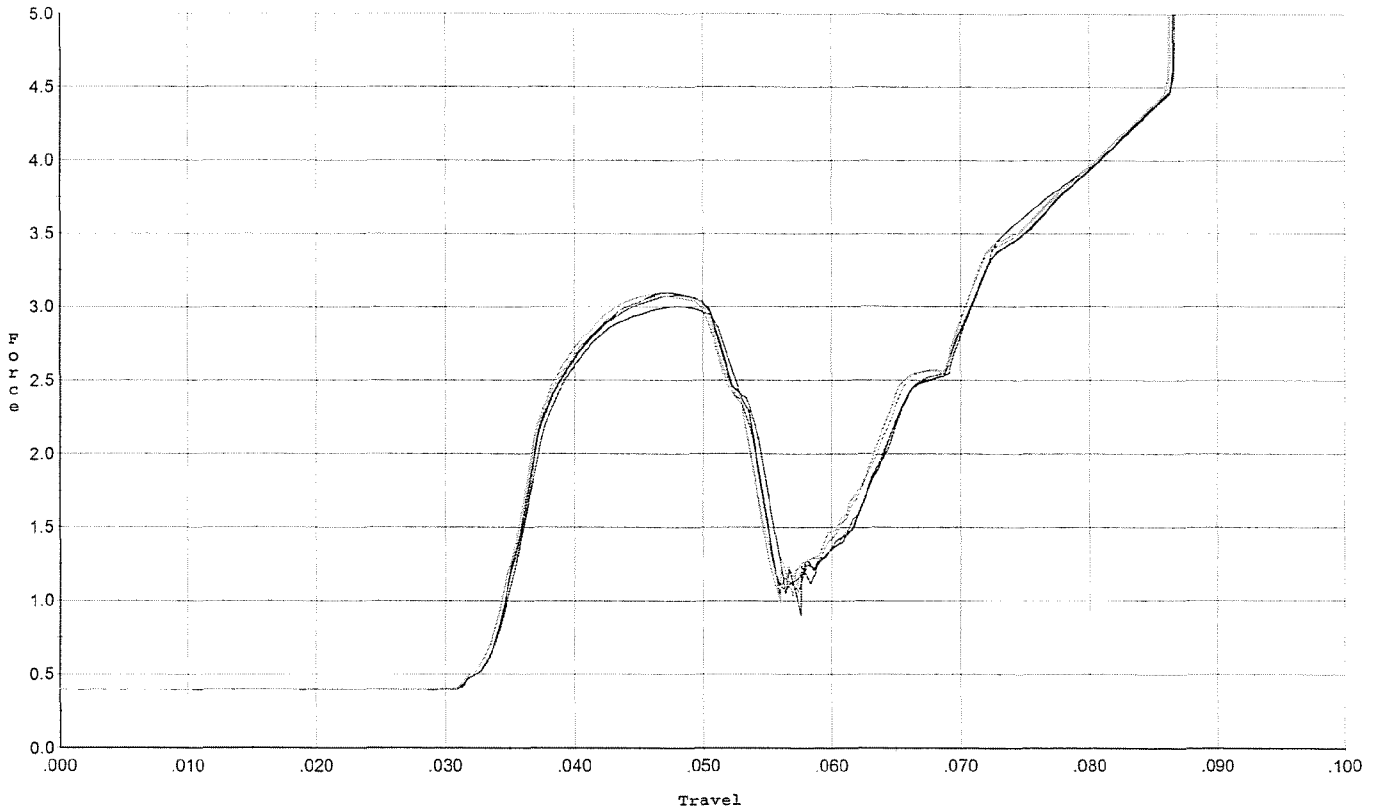
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.054	0.033	0.037	0.065		Set Trigger
2	3.034	0.054	0.035	0.037	0.064		Set Trigger
3	3.041	0.054	0.034	0.037	0.064		Set Trigger
4	3.053	0.055	0.035	0.037	0.065		Set Trigger
5	3.058	0.054	0.035	0.037	0.064		Set Trigger

Aug 3.04

Trigger Profile [lbs,inch]

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

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



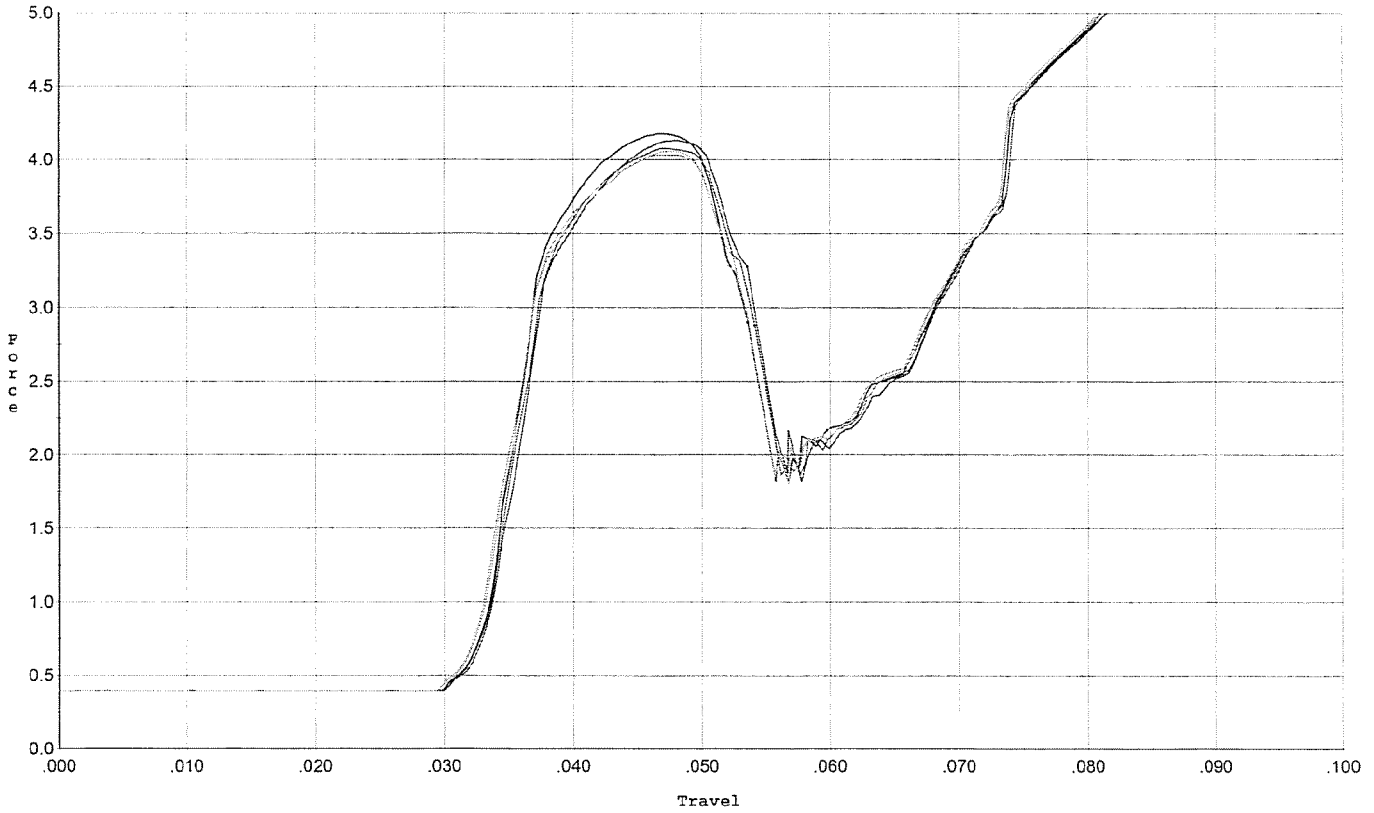
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.004	0.054	0.034	0.036	0.065		Set Trigger
2	3.096	0.054	0.034	0.036	0.065		Set Trigger
3	3.077	0.054	0.033	0.037	0.065		Set Trigger
4	3.099	0.053	0.033	0.037	0.064		Set Trigger
5	3.070	0.053	0.033	0.036	0.064		Set Trigger

Aug 3.06

Trigger Profile [lbs,inch]

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

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



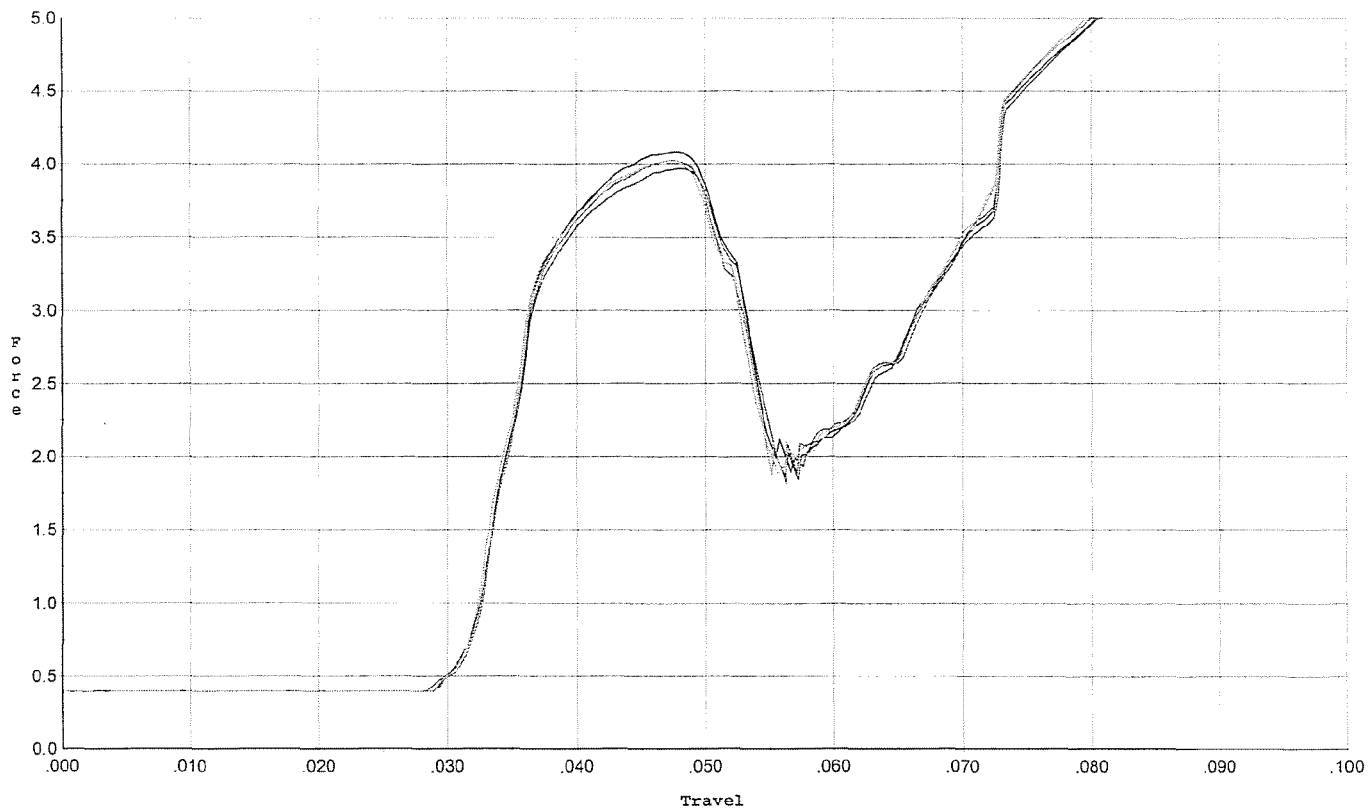
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.129	0.054	0.032	0.033	0.084		Set Trigger
2	4.179	0.054	0.032	0.033	0.085		Set Trigger
3	4.077	0.054	0.032	0.032	0.085		Set Trigger
4	4.058	0.054	0.032	0.033	0.083		Set Trigger
5	4.033	0.053	0.032	0.032	0.084		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

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

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



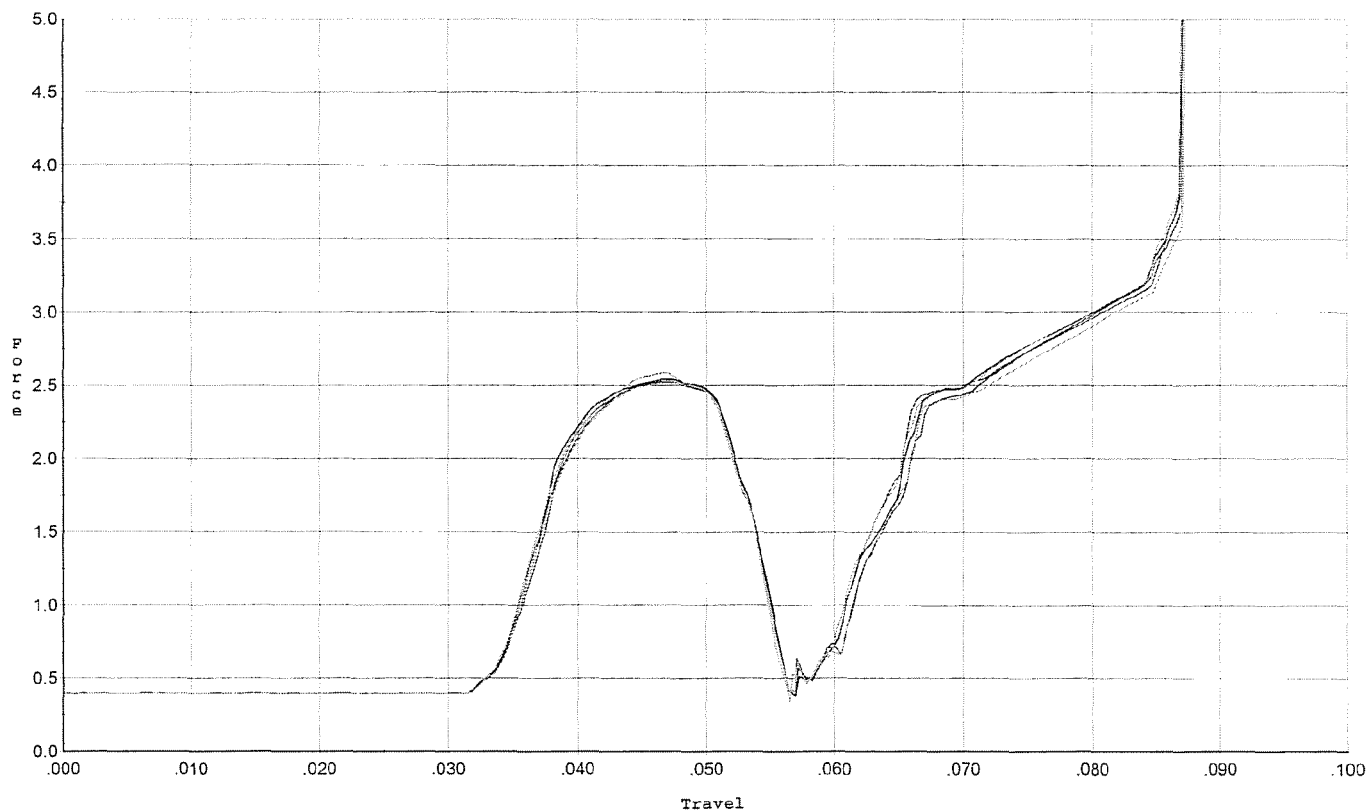
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.971	0.052	0.031	0.033	0.082		Set Trigger
2	4.085	0.052	0.031	0.033	0.083		Set Trigger
3	4.024	0.053	0.032	0.033	0.083		Set Trigger
4	4.023	0.053	0.031	0.033	0.083		Set Trigger
5	4.012	0.052	0.031	0.033	0.081		Set Trigger

Aug 4.02

Trigger Profile [lbs,inch]

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

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



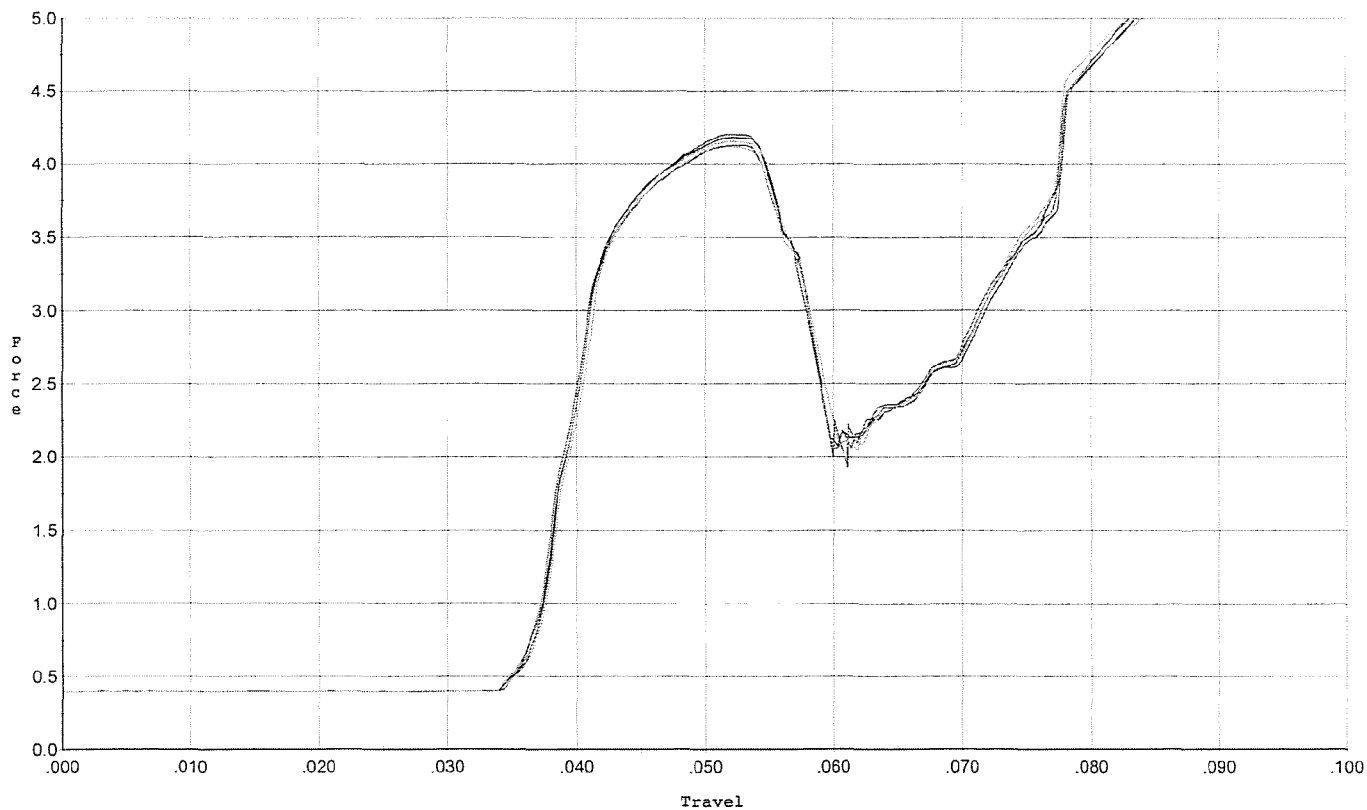
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.546	0.055	0.034	0.038	0.055		Set Trigger
2	2.522	0.055	0.034	0.038	0.056		Set Trigger
3	2.535	0.053	0.034	0.038	0.054		Set Trigger
4	2.526	0.053	0.034	0.038	0.054		Set Trigger
5	2.588	0.054	0.034	0.038	0.055		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

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

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	4.202	0.058	0.035	0.033	0.088		Set Trigger
2	4.182	0.057	0.036	0.033	0.088		Set Trigger
3	4.128	0.058	0.034	0.033	0.088		Set Trigger
4	4.154	0.057	0.035	0.033	0.087		Set Trigger
5	4.118	0.057	0.034	0.032	0.087		Set Trigger

Avg 4.15