

G6784664

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

G6784664



BM FORM

GUN SERIAL # G 6784664

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	BSN
475	DRILL AND TAP SIGHT HOLES		9-20-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR B.H.	9-22-08	BSN
490	MAGNAFLUX BOLT		9/19/08	MR
500	ROLLMARK CALIBER		9/22/08	RT
520	GOFF BLAST BBL / REC		9/22/08	DG
542	APPLY COATINGS (BARREL ACTION)		9-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-29-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-9-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

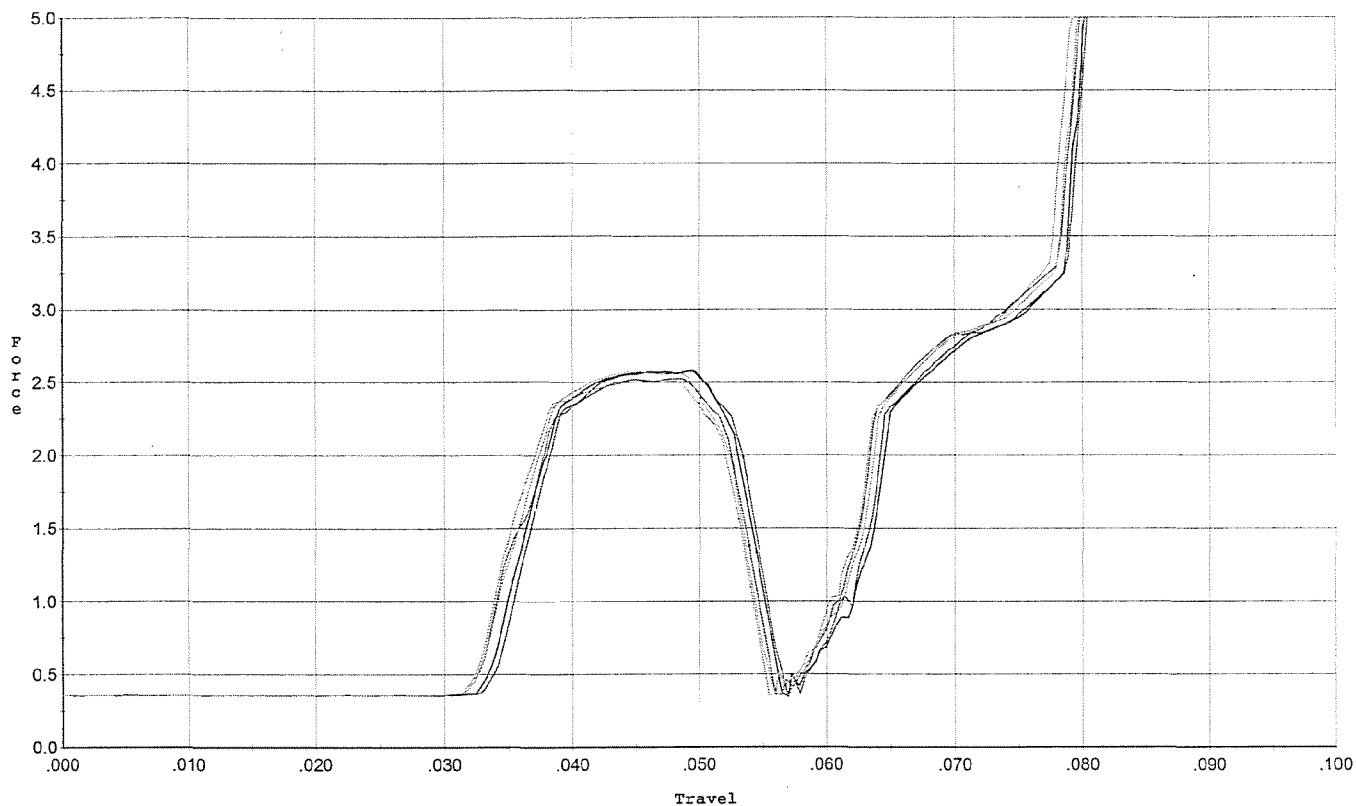
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>39</u> <u>39</u>	12-16-08	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	12-16-08	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.024</u>	12-16-08	L N
	J) ASSEMBLE STOCK		10-9-08	L N
	K) ASSEMBLE SWIVEL STUDS		12-16-08	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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12-9-08	L N
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-9-08	RP
670	FINAL INSPECTION A) HEADSPACE		12-16-08	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.31</u> <u>2.29</u> <u>2.28</u> <u>2.28</u>	12/11/08	RSN
	C) FUNCTION		12-16-08	L N
690	PACK		1/6/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults

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



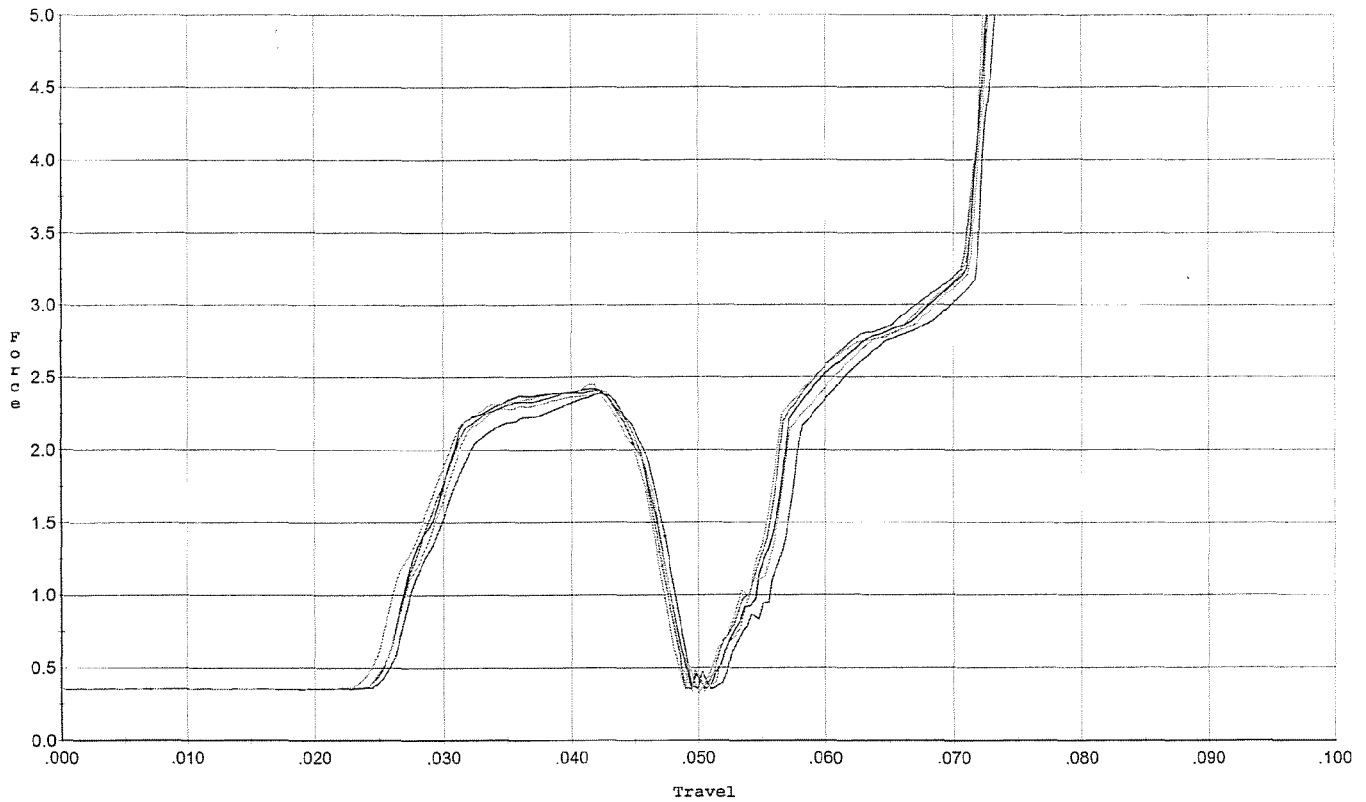
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.053	0.034	0.033	0.055		Set Trigger
2	2.581	0.054	0.033	0.033	0.057		Set Trigger
3	2.523	0.054	0.033	0.033	0.056		Set Trigger
4	2.578	0.052	0.033	0.033	0.055		Set Trigger
5	2.512	0.053	0.033	0.033	0.055		Set Trigger

Aug-2-55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults

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



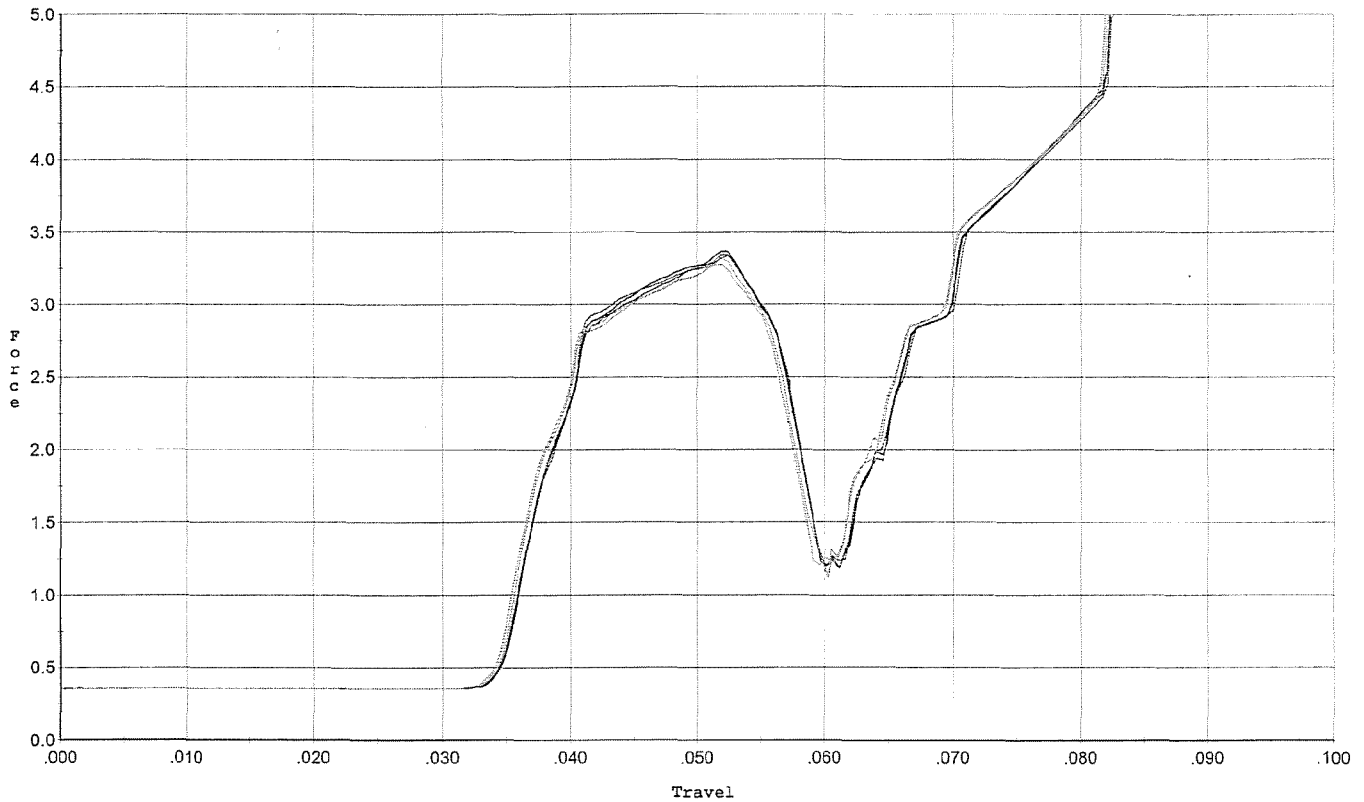
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.391	0.047	0.026	0.031	0.050		Set Trigger
2	2.418	0.047	0.026	0.031	0.052		Set Trigger
3	2.405	0.047	0.026	0.031	0.052		Set Trigger
4	2.409	0.046	0.026	0.031	0.050		Set Trigger
5	2.447	0.046	0.025	0.031	0.051		Set Trigger

Aug. 2.411

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .50 lbs.



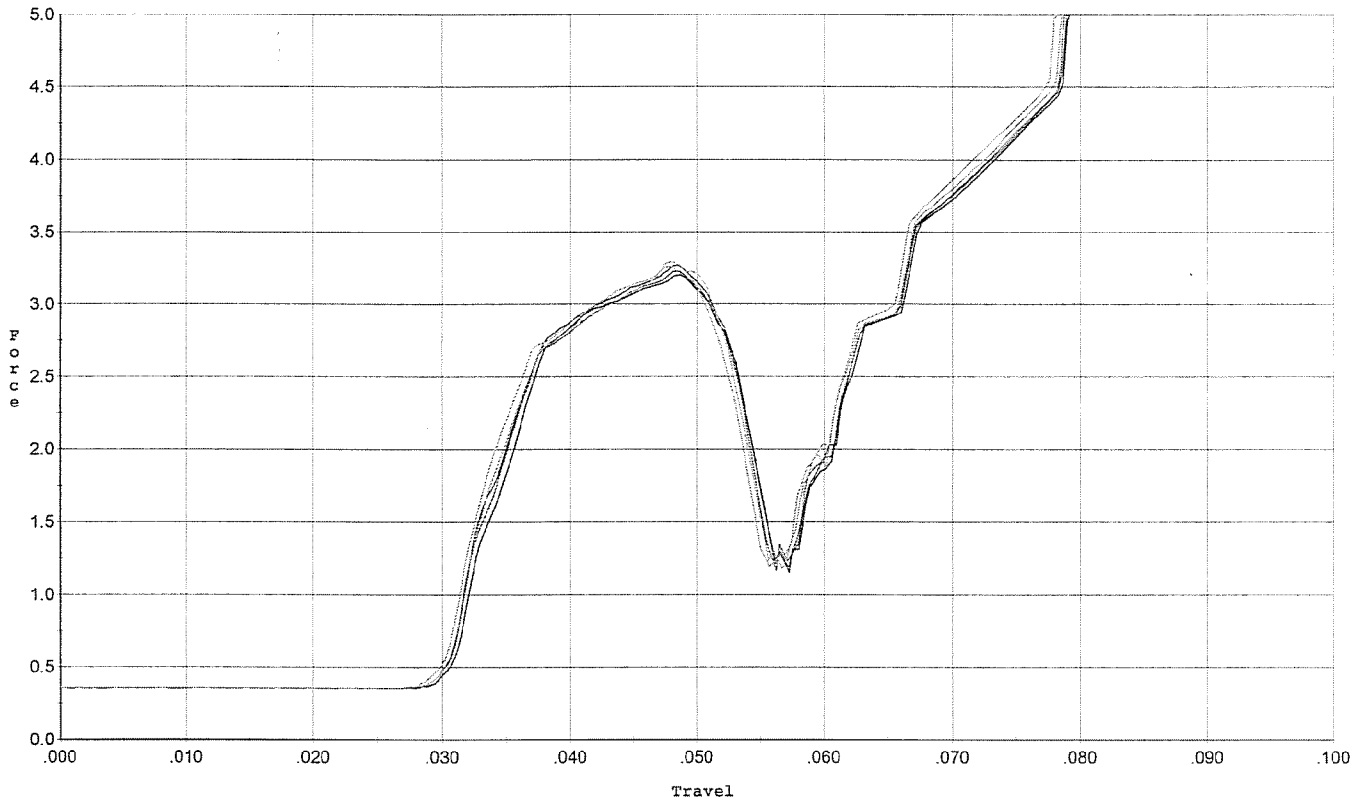
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.344	0.057	0.035	0.031	0.074		Set Trigger
2	3.367	0.058	0.035	0.031	0.074		Set Trigger
3	3.335	0.057	0.035	0.031	0.074		Set Trigger
4	3.276	0.057	0.034	0.031	0.073		Set Trigger
5	3.328	0.057	0.035	0.031	0.072		Set Trigger

Avg. 3.33

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schultz

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles+/- .50 lbs.



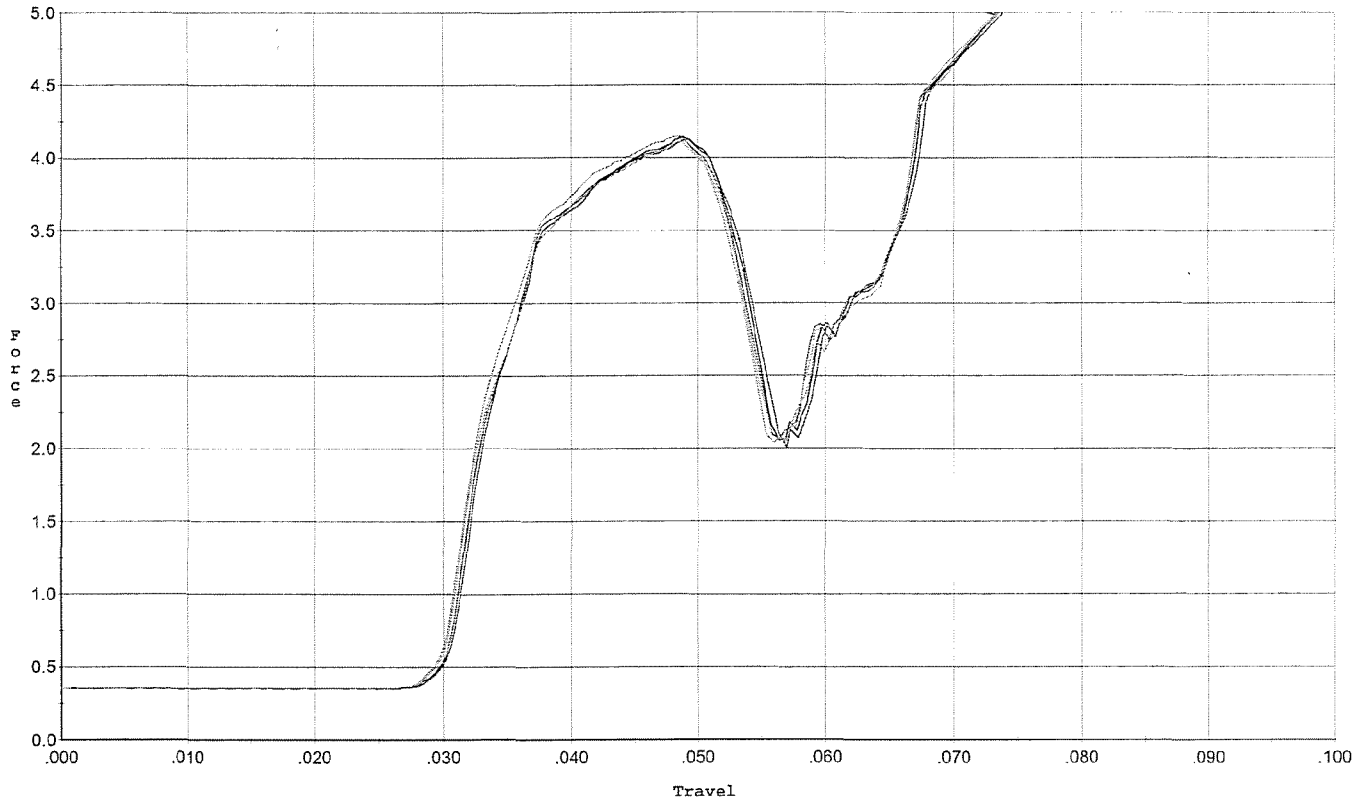
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.270	0.055	0.031	0.031	0.073		Set Trigger
2	3.201	0.053	0.031	0.031	0.069		Set Trigger
3	3.228	0.053	0.031	0.031	0.070		Set Trigger
4	3.296	0.054	0.031	0.031	0.071		Set Trigger
5	3.261	0.053	0.030	0.031	0.070		Set Trigger

Aug 3-25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schultz

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



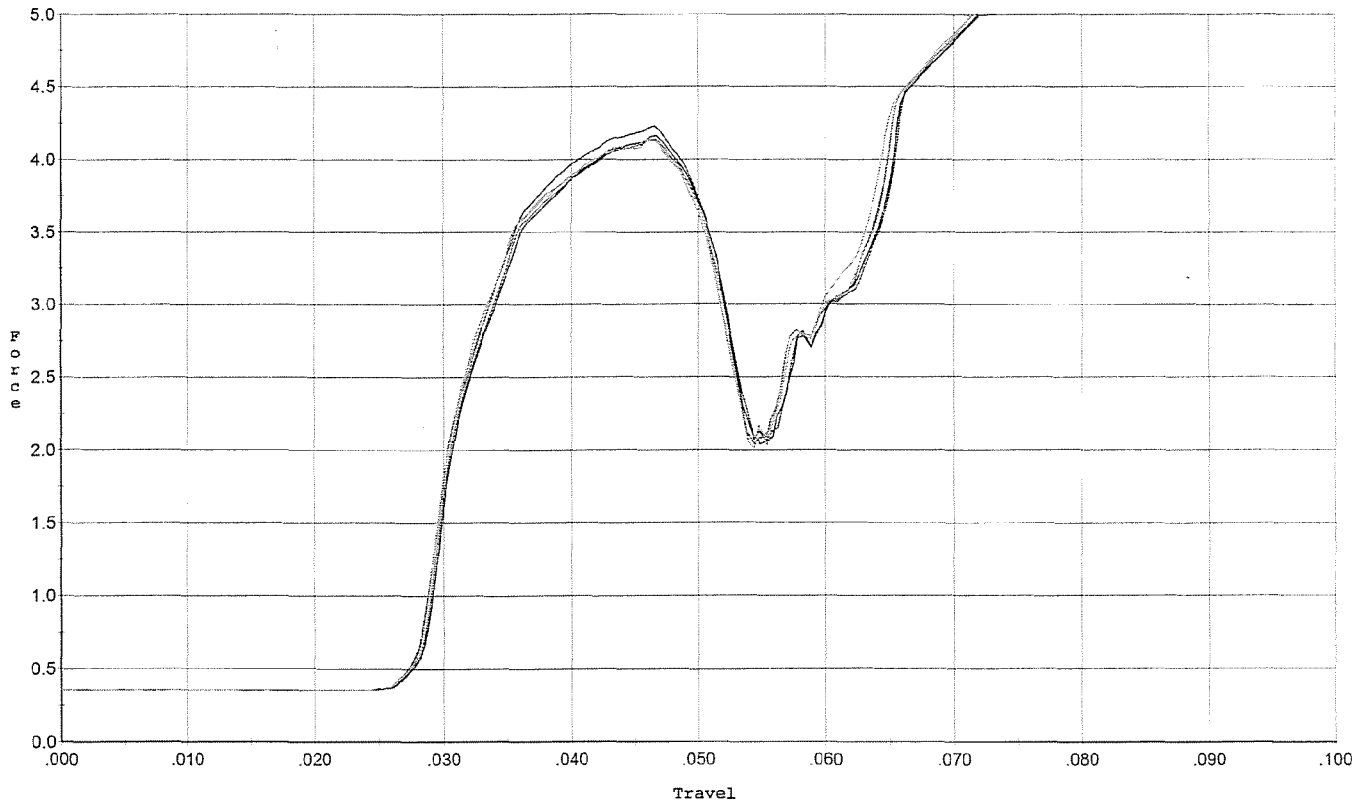
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.125	0.053	0.030	0.029	0.089		Set Trigger
2	4.150	0.054	0.030	0.029	0.090		Set Trigger
3	4.139	0.053	0.030	0.029	0.087		Set Trigger
4	4.112	0.053	0.030	0.029	0.088		Set Trigger
5	4.151	0.053	0.030	0.029	0.090		Set Trigger

Aug 4-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schultz

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



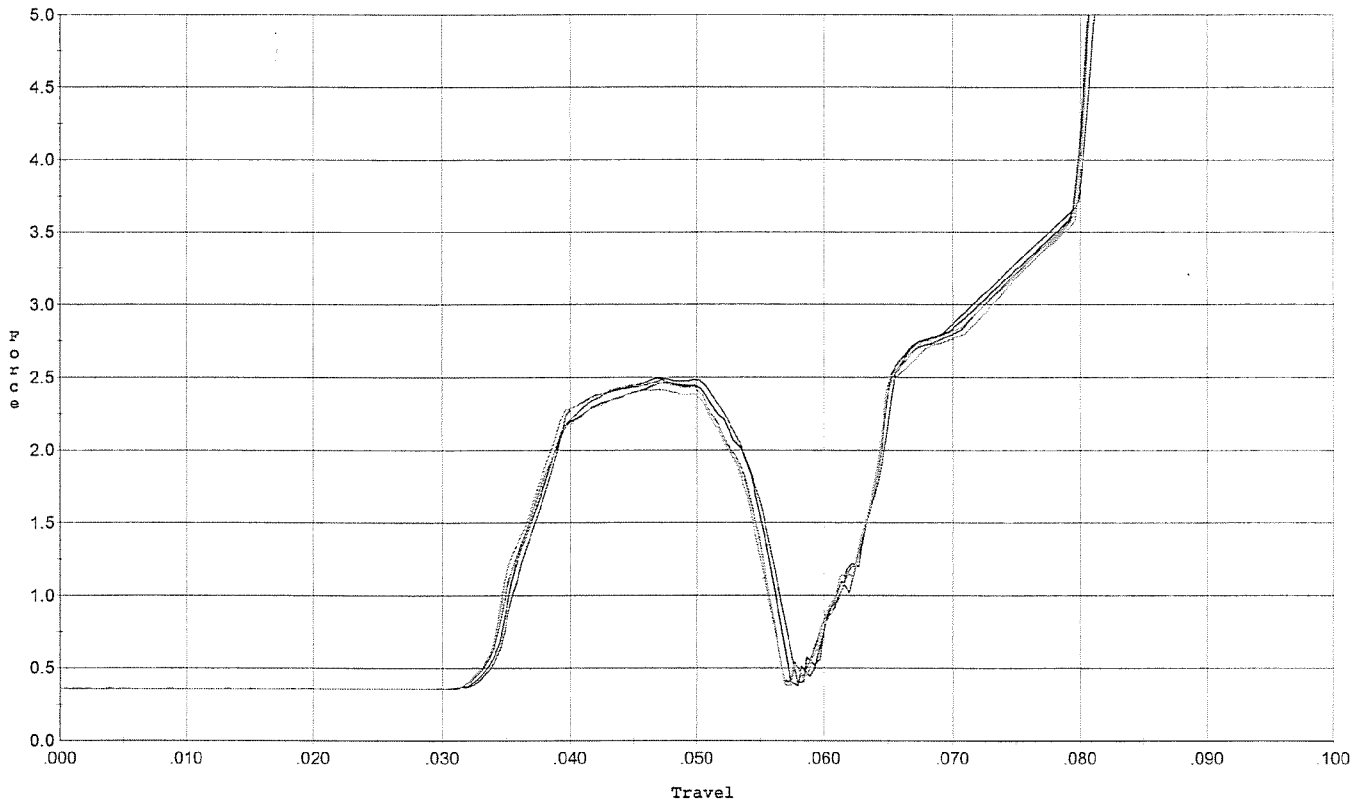
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.231	0.051	0.028	0.029	0.091		Set Trigger
2	4.164	0.051	0.028	0.029	0.089		Set Trigger
3	4.139	0.052	0.028	0.028	0.090		Set Trigger
4	4.142	0.051	0.028	0.028	0.088		Set Trigger
5	4.139	0.051	0.028	0.029	0.088		Set Trigger

Aug 4.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schultz

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



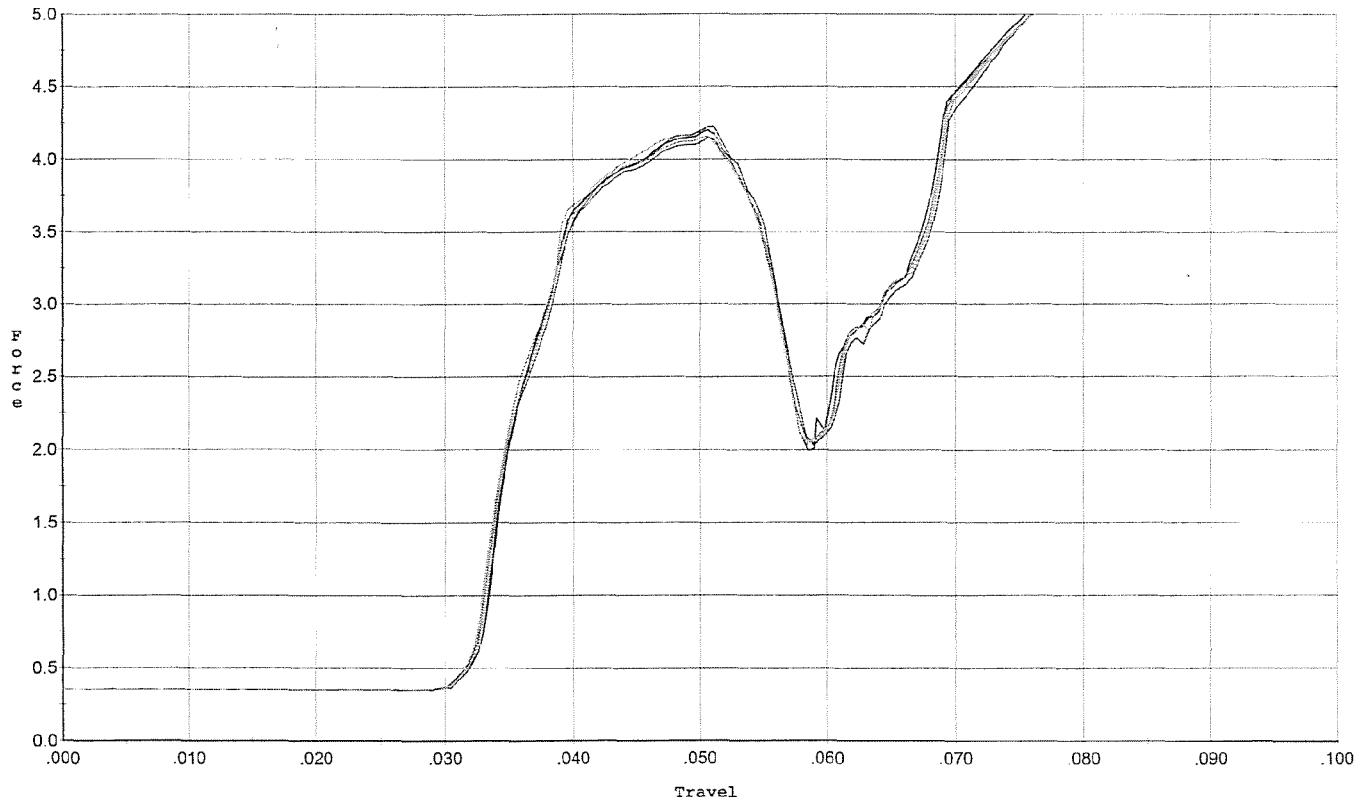
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.494	0.056	0.034	0.032	0.057		Set Trigger
2	2.462	0.055	0.034	0.032	0.056		Set Trigger
3	2.482	0.055	0.034	0.033	0.055		Set Trigger
4	2.419	0.055	0.034	0.033	0.055		Set Trigger
5	2.461	0.055	0.034	0.033	0.056		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schultz

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	4.228	0.055	0.032	0.029	0.091		Set Trigger
2	4.203	0.056	0.032	0.029	0.092		Set Trigger
3	4.153	0.055	0.032	0.029	0.091		Set Trigger
4	4.159	0.056	0.032	0.029	0.092		Set Trigger
5	4.207	0.055	0.032	0.029	0.092		Set Trigger

Aug 4.19