

56784687

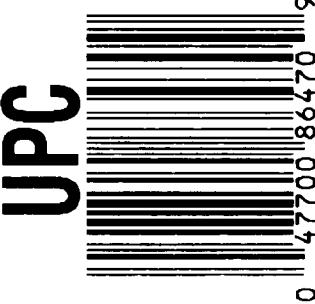
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784687



GUN SERIAL #

G 678 4687

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-25-08	J.P.D.
430	ASSEMBLE TO STOCK		8-25-08	JP
440	PROOF		8-25-08	J.P.D.
460	CHECK HEADSPACE		8-25-08	J.P.D.
470	DIS-ASSEMBLE ACTION		8-25-08	J.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-26-08	PSN
475	DRILL AND TAP SIGHT HOLES	AUG 28 2008	8-26-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR B.N.	8-28-08	B.N.
490	MAGNAFLUX BOLT		8/29/08	MR
500	ROLLMARK CALIBER		8/29/08	RT
520	GOFF BLAST BBL / REC		8/29/08	DC
542	APPLY COATINGS (BARREL ACTION)		8-31-	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-6-08	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-6-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-6-08	JP
	D) OIL FIRING PIN ASSEMBLY		9-11-08	J.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

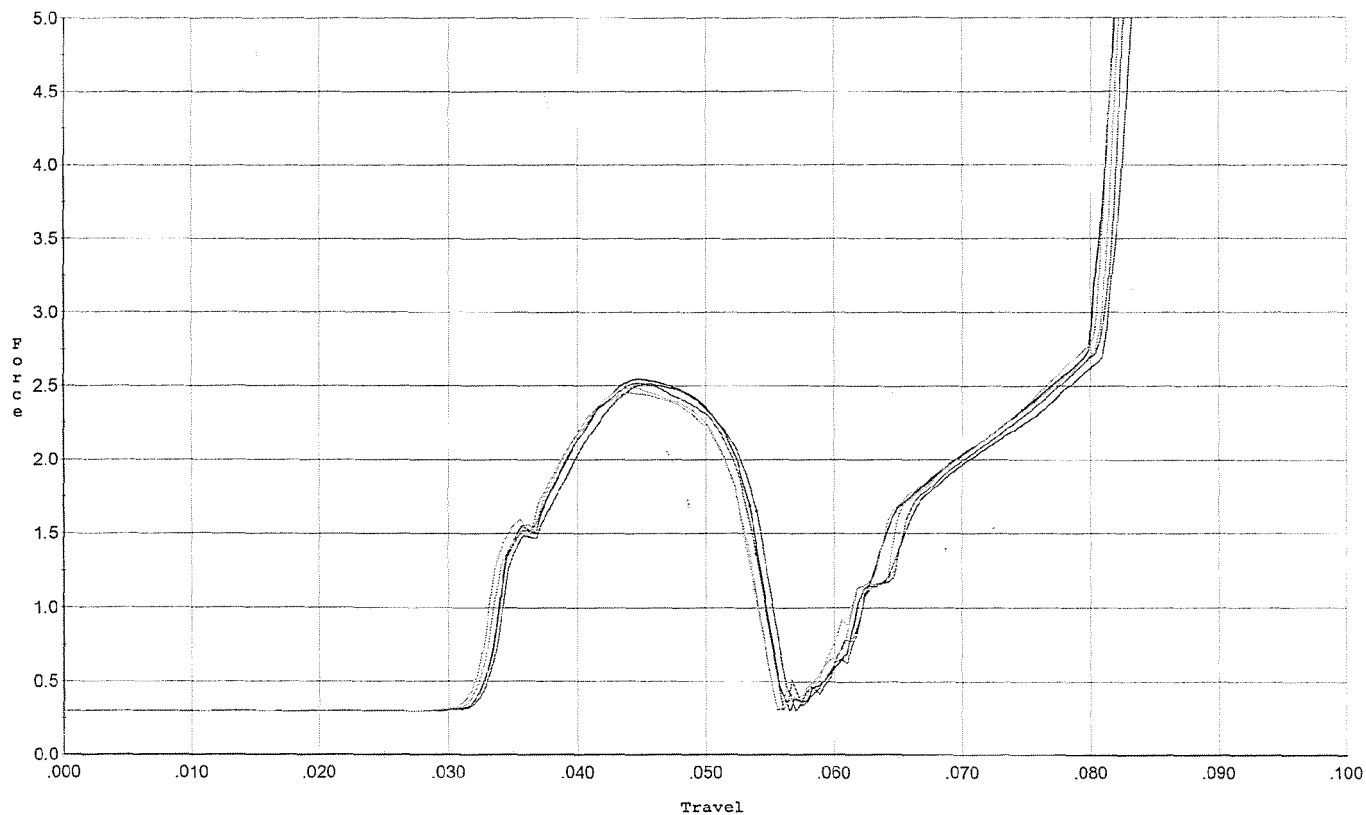
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-1-08	L. N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-1-08	L. N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	10-1-08	L. N.
	J) ASSEMBLE STOCK		9-11-08	L. N.
	K) ASSEMBLE SWIVEL STUDS		10-2-08	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	9-12-08	FM
	MALFUNCTION <i>CH</i>	CORRECTION	10-1-08	TC
	MALFUNCTION	CORRECTION <i>N.A</i>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-12-08	TRW
670	FINAL INSPECTION A) HEADSPACE		10-1-08	L. N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.47</u> <u>2.53</u> <u>2.54</u> <u>2.55</u>	9-18-08	TRW
	C) FUNCTION		10-1-08	L. N.
690	PACK		12-8-08	ESN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/9/08

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



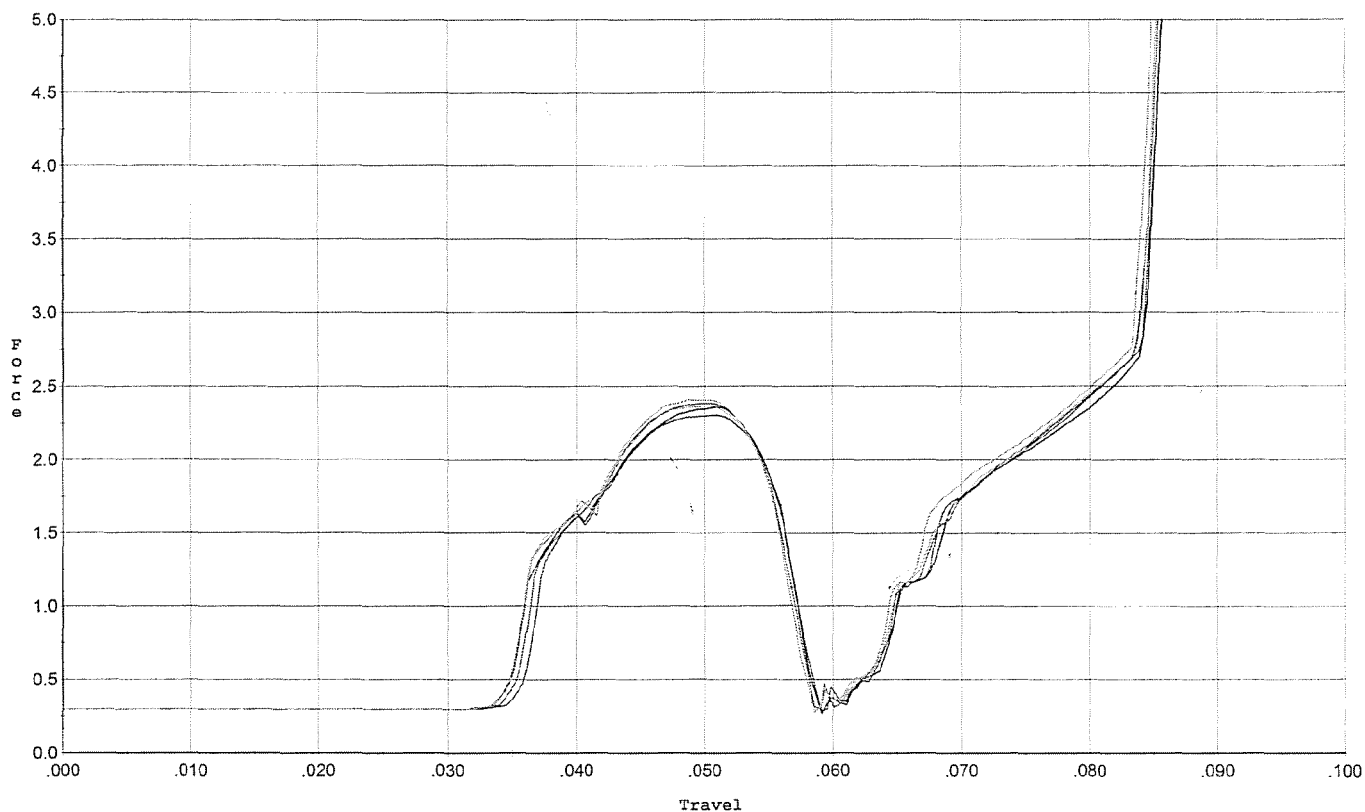
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.517	0.054	0.033	0.035	0.052		Set Trigger
2	2.547	0.053	0.032	0.034	0.053		Set Trigger
3	2.522	0.054	0.033	0.034	0.052		Set Trigger
4	2.491	0.053	0.032	0.034	0.052		Set Trigger
5	2.453	0.054	0.032	0.034	0.052		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/9/08

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



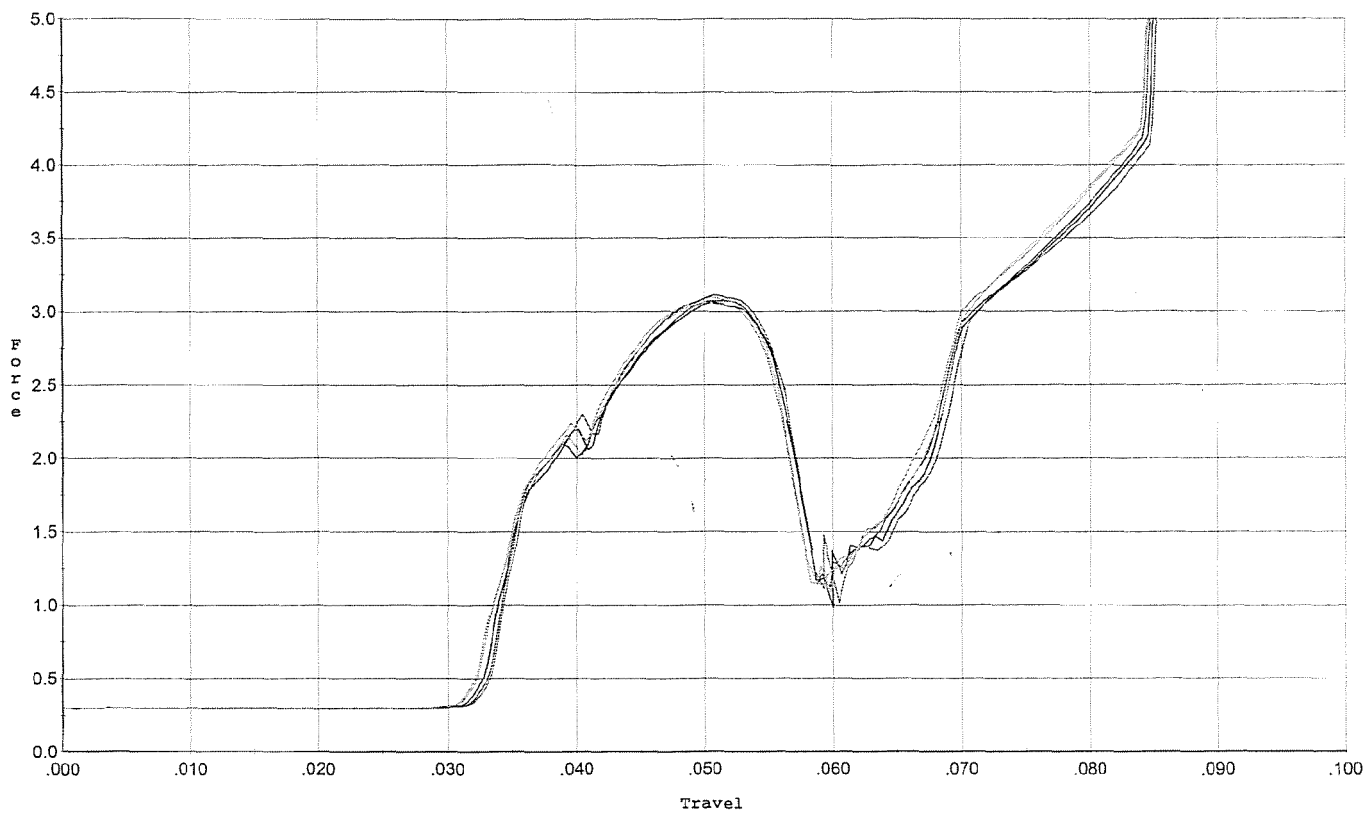
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.301	0.056	0.036	0.036	0.049		Set Trigger
2	2.358	0.056	0.035	0.036	0.051		Set Trigger
3	2.384	0.057	0.035	0.036	0.051		Set Trigger
4	2.409	0.055	0.035	0.036	0.051		Set Trigger
5	2.369	0.055	0.035	0.036	0.050		Set Trigger

Avg 2.36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/9/08

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



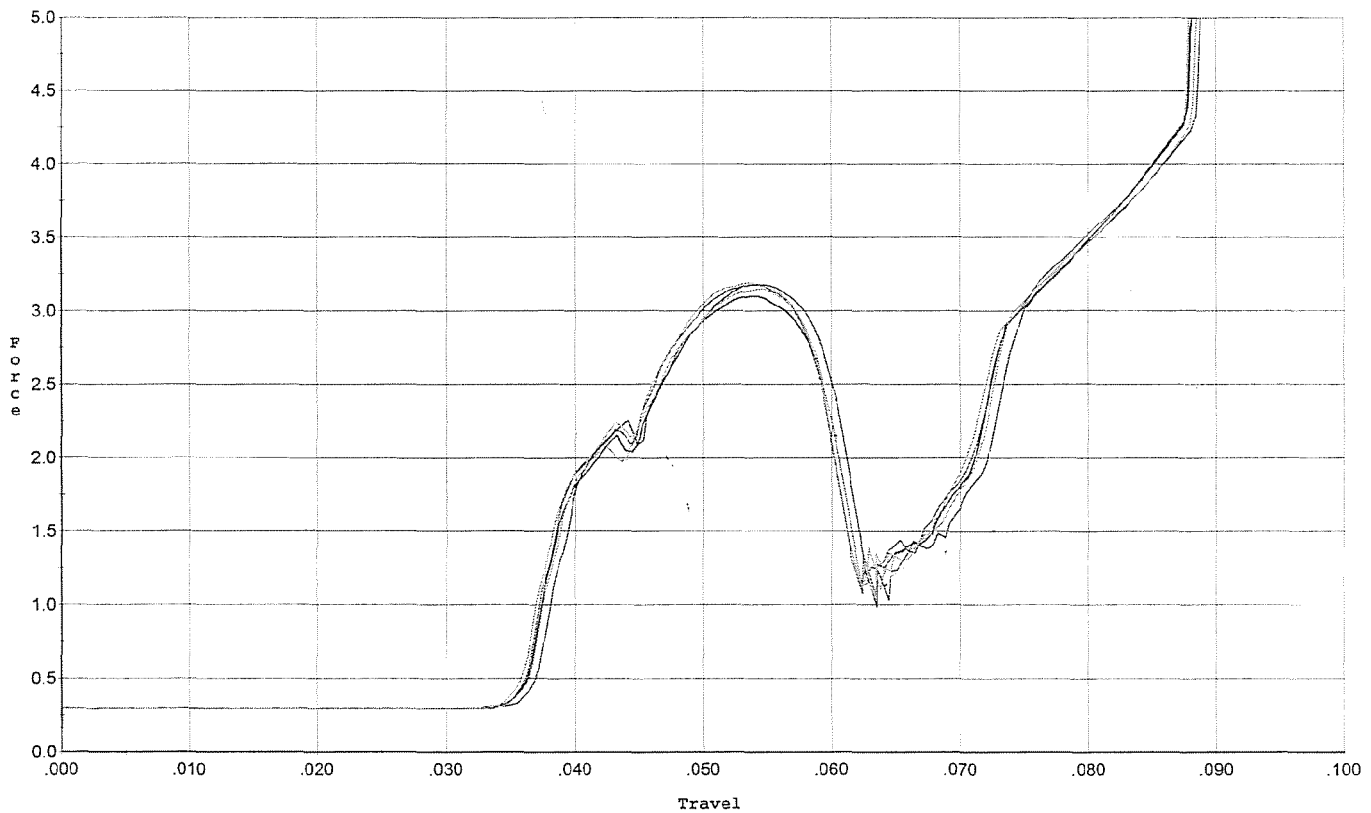
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.057	0.033	0.034	0.067		Set Trigger
2	3.059	0.057	0.033	0.034	0.067		Set Trigger
3	3.113	0.056	0.033	0.034	0.067		Set Trigger
4	3.095	0.056	0.032	0.033	0.067		Set Trigger
5	3.062	0.056	0.032	0.033	0.067		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/9/08

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



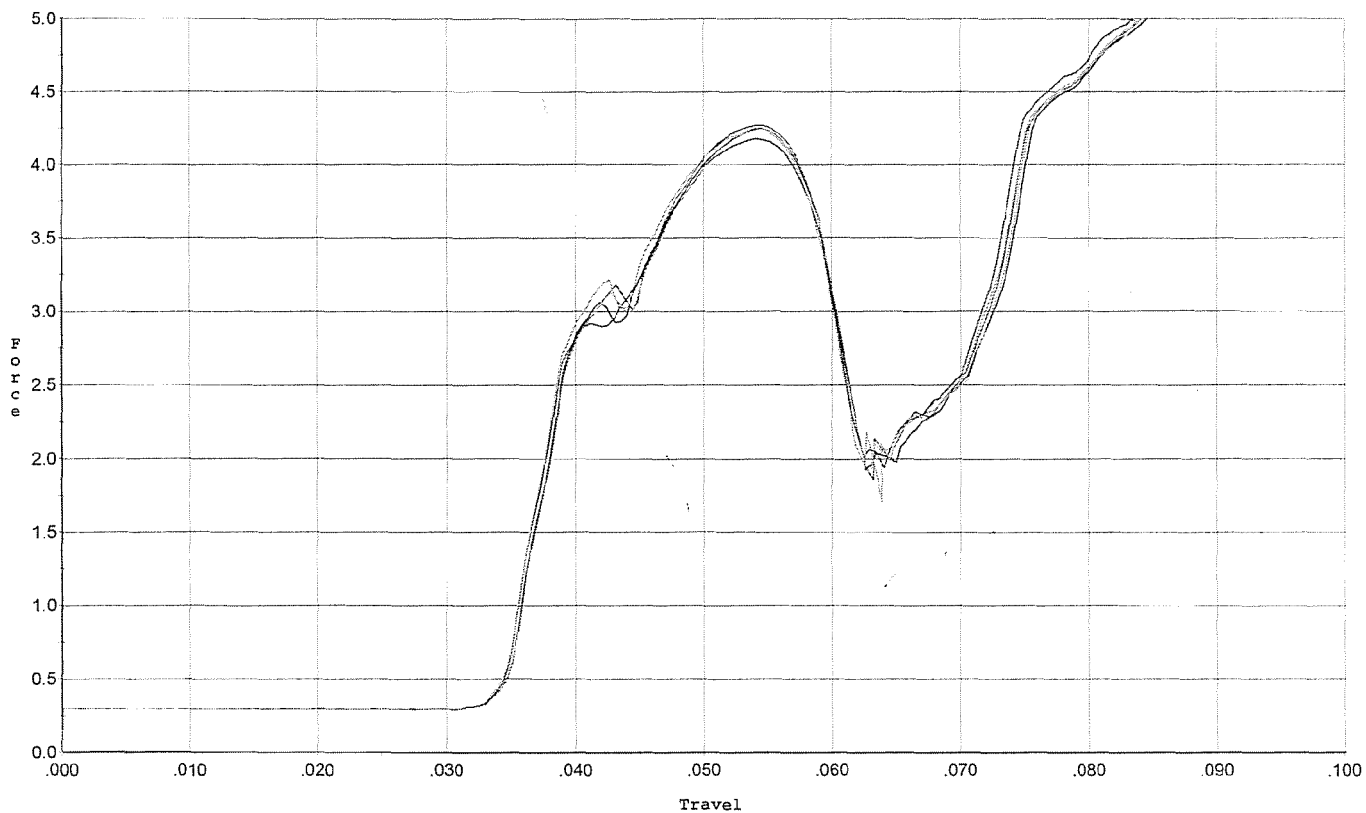
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.060	0.037	0.034	0.070		Set Trigger
2	3.101	0.060	0.036	0.034	0.069		Set Trigger
3	3.177	0.059	0.036	0.035	0.069		Set Trigger
4	3.147	0.060	0.036	0.035	0.069		Set Trigger
5	3.192	0.059	0.036	0.034	0.069		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/9/08

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



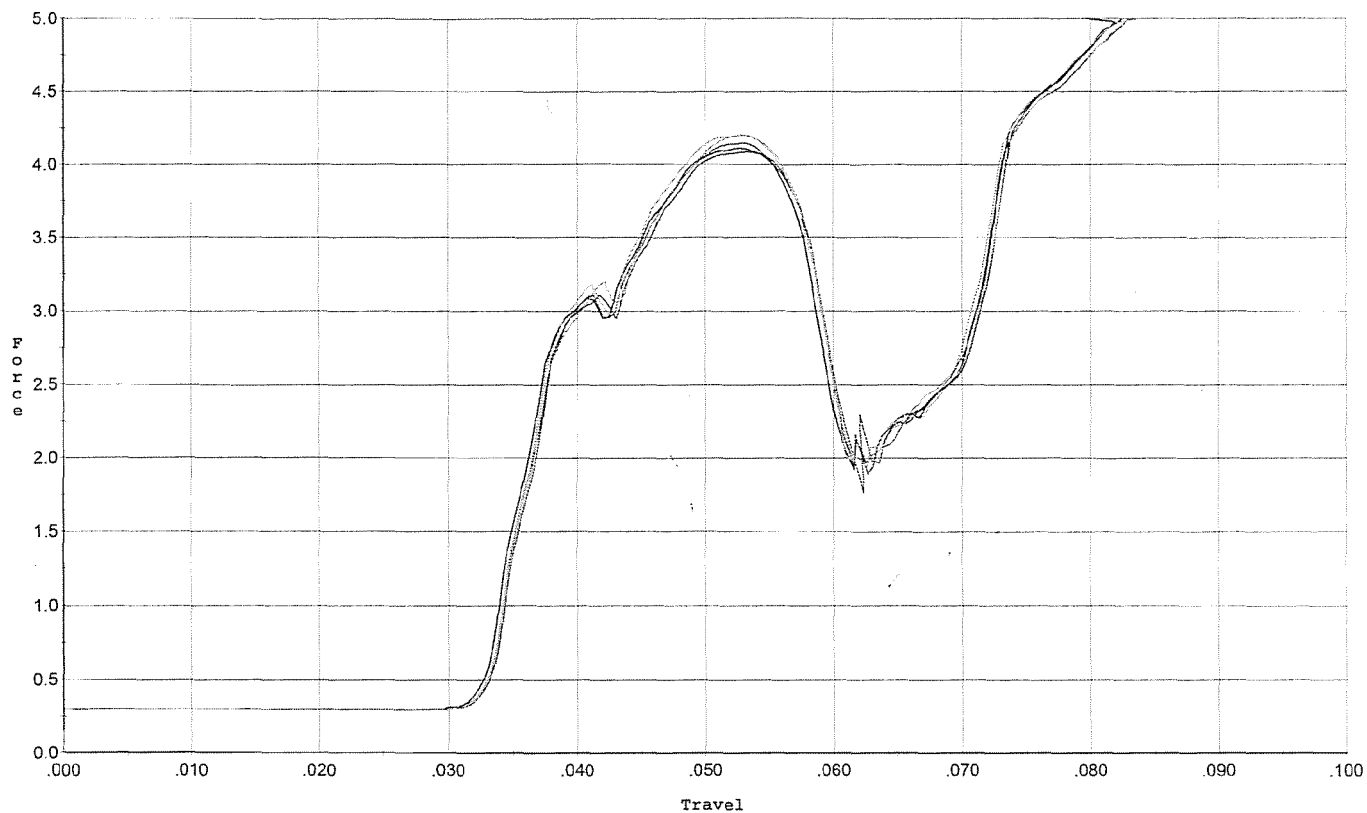
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.176	0.059	0.035	0.033	0.092		Set Trigger
2	4.246	0.059	0.035	0.033	0.092		Set Trigger
3	4.269	0.059	0.035	0.033	0.093		Set Trigger
4	4.245	0.061	0.035	0.032	0.095		Set Trigger
5	4.250	0.059	0.035	0.033	0.094		Set Trigger

Avg 4.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 9/9/08

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



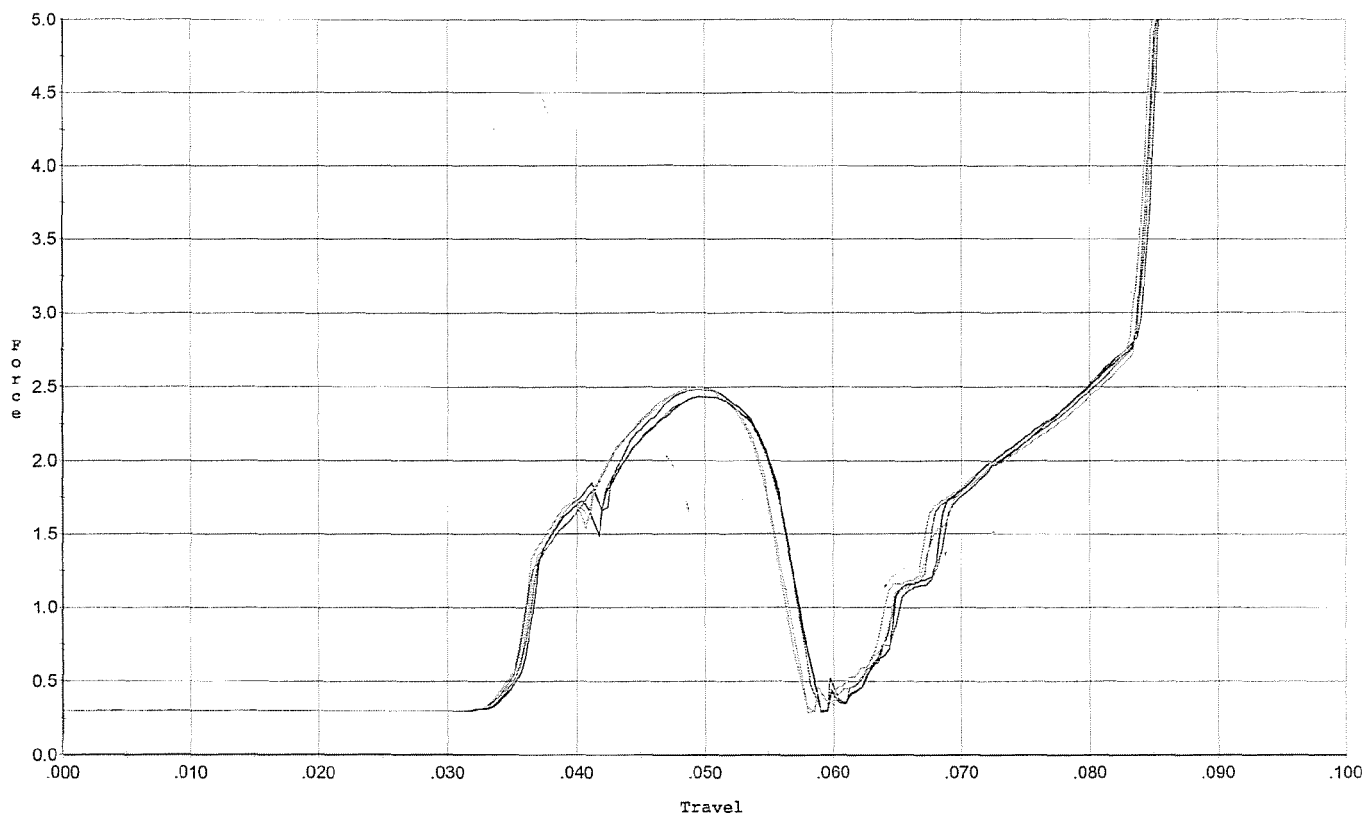
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.058	0.033	0.032	0.092		Set Trigger
2	4.113	0.058	0.033	0.032	0.092		Set Trigger
3	4.148	0.058	0.033	0.032	0.092		Set Trigger
4	4.198	0.058	0.033	0.032	0.094		Set Trigger
5	4.204	0.058	0.033	0.032	0.093		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/9/08

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



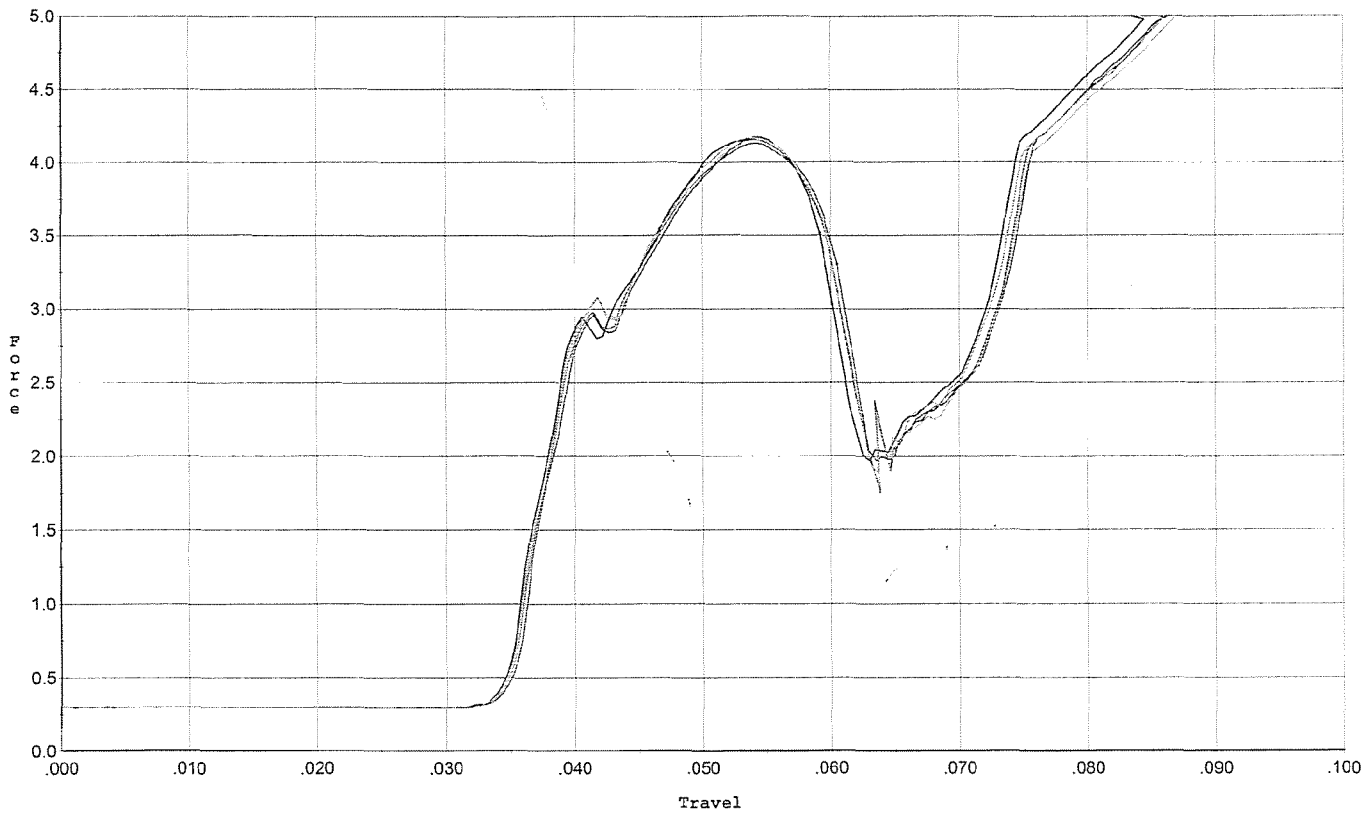
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.481	0.056	0.035	0.036	0.052		Set Trigger
2	2.431	0.056	0.036	0.036	0.051		Set Trigger
3	2.432	0.056	0.035	0.035	0.052		Set Trigger
4	2.499	0.056	0.036	0.036	0.052		Set Trigger
5	2.480	0.055	0.035	0.036	0.051		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 9/9/08

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	4.174	0.060	0.035	0.033	0.094		Set Trigger
2	4.155	0.059	0.034	0.033	0.092		Set Trigger
3	4.131	0.060	0.035	0.033	0.093		Set Trigger
4	4.153	0.060	0.035	0.033	0.093		Set Trigger
5	4.169	0.060	0.034	0.033	0.094		Set Trigger

Avg 4.15