

G6784742

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



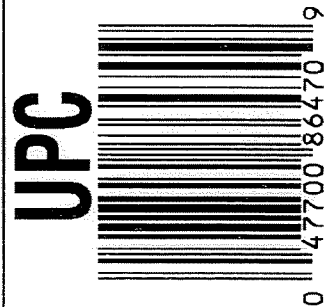
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6784742



GUN SERIAL #

G 6784742

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SPD
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SPD
460	CHECK HEADSPACE		9-9-08	SPD
470	DIS-ASSEMBLE ACTION		9-9-08	SPD
472	SERIALIZE BOLT HANDLE		9-10-08	KTC
475	DRILL AND TAP SIGHT HOLES		9-11-08	SP
480	MAGNAFLUX BBL ACTION		9-12-08	BN
490	MAGNAFLUX BOLT		9/9/08	MR
500	ROLLMARK CALIBER		9/12/08	RT
520	GOFF BLAST BBL / REC		9/13/08	OB
542	APPLY COATINGS (BARREL ACTION)		9/16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-20-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-20-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-20-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-11-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

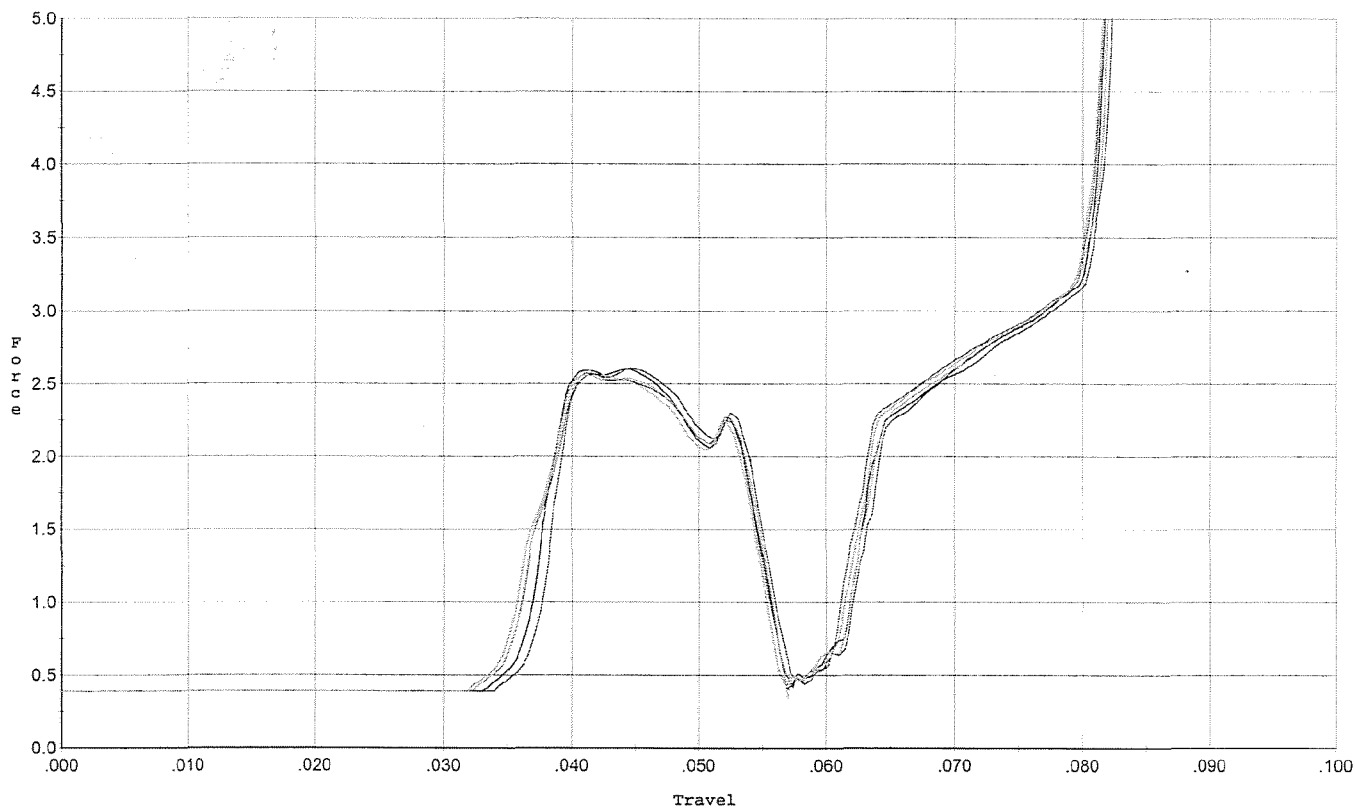
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-21-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.0</u>	10-21-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-21-08	LJ
	J) ASSEMBLE STOCK		10-11-08	LJ
	K) ASSEMBLE SWIVEL STUDS		10-21-08	LJ
	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	10-13-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-13-08	LJ
670	FINAL INSPECTION A) HEADSPACE		10-21-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.57</u> <u>2.64</u> <u>2.69</u> <u>2.53</u>	10-23-08	TC
	C) FUNCTION		10-21-08	LJ
690	PACK		12-9-08	BSW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/9/08

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



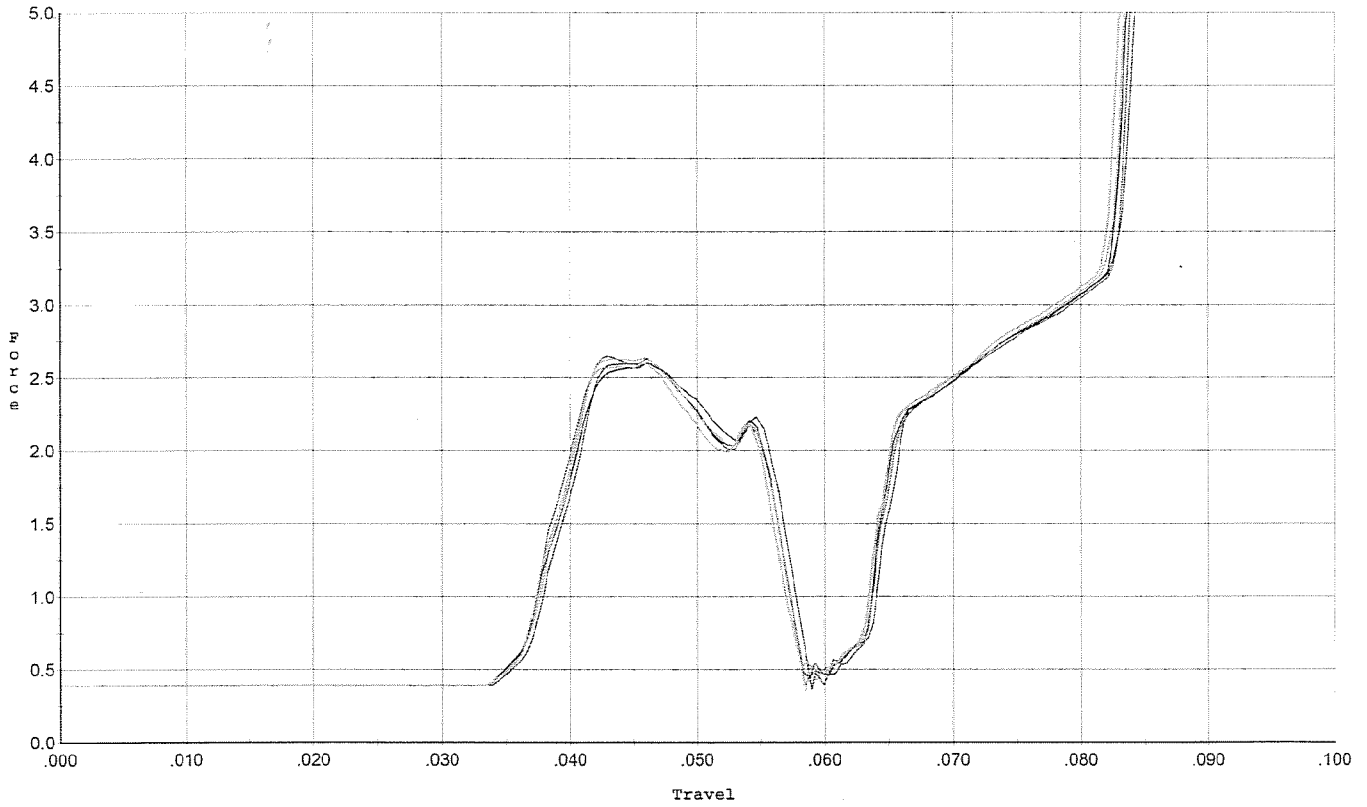
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.054	0.037	0.034	0.054		Set Trigger
2	2.604	0.055	0.036	0.034	0.055		Set Trigger
3	2.574	0.053	0.035	0.034	0.054		Set Trigger
4	2.593	0.054	0.035	0.034	0.056		Set Trigger
5	2.558	0.054	0.035	0.034	0.055		Set Trigger

Aug 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 10/9/08

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



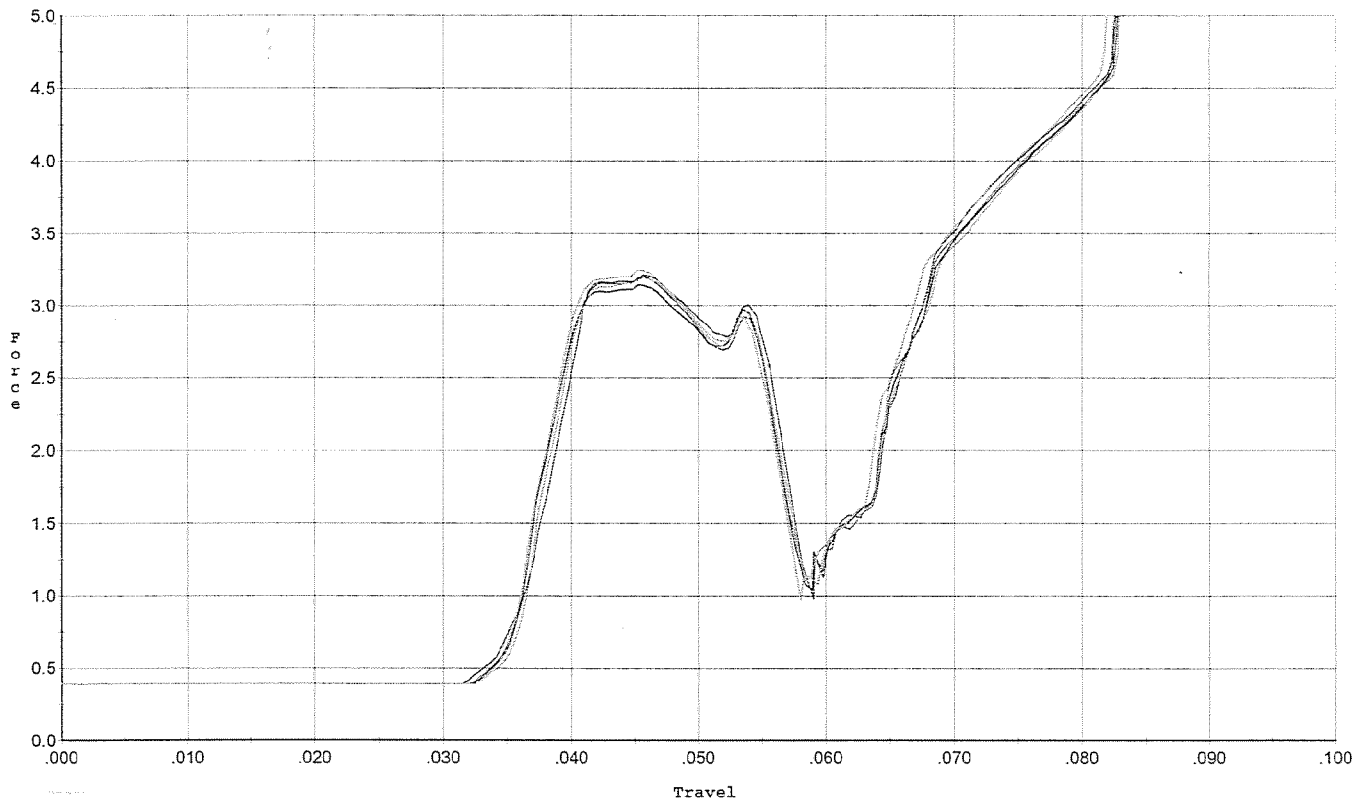
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.056	0.037	0.034	0.057		Set Trigger
2	2.605	0.056	0.036	0.034	0.056		Set Trigger
3	2.647	0.056	0.036	0.034	0.057		Set Trigger
4	2.640	0.056	0.036	0.034	0.056		Set Trigger
5	2.598	0.055	0.036	0.034	0.055		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/9/08

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



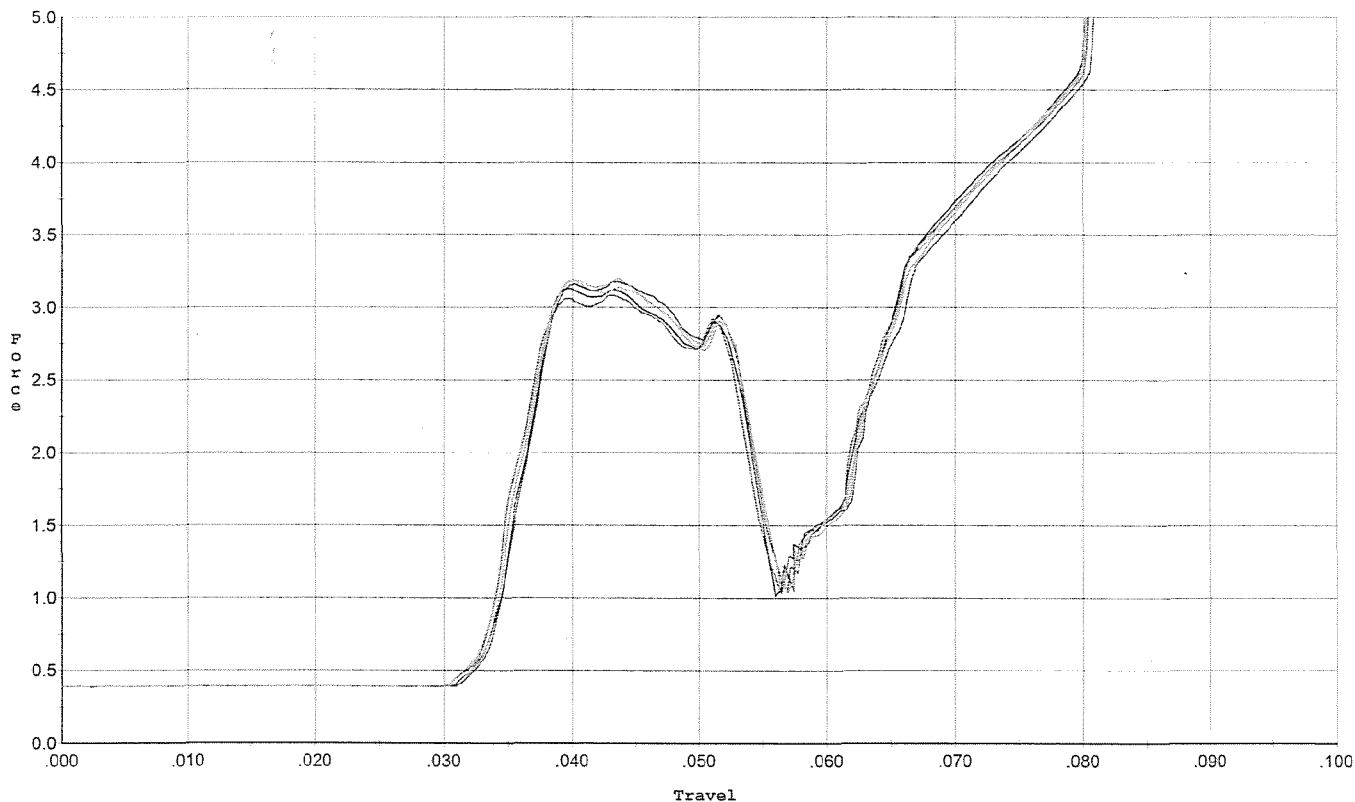
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.214	0.056	0.035	0.032	0.069		Set Trigger
2	3.146	0.055	0.035	0.033	0.068		Set Trigger
3	3.206	0.055	0.035	0.033	0.068		Set Trigger
4	3.193	0.055	0.035	0.033	0.067		Set Trigger
5	3.244	0.055	0.035	0.032	0.069		Set Trigger

Avg 3.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/9/08

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



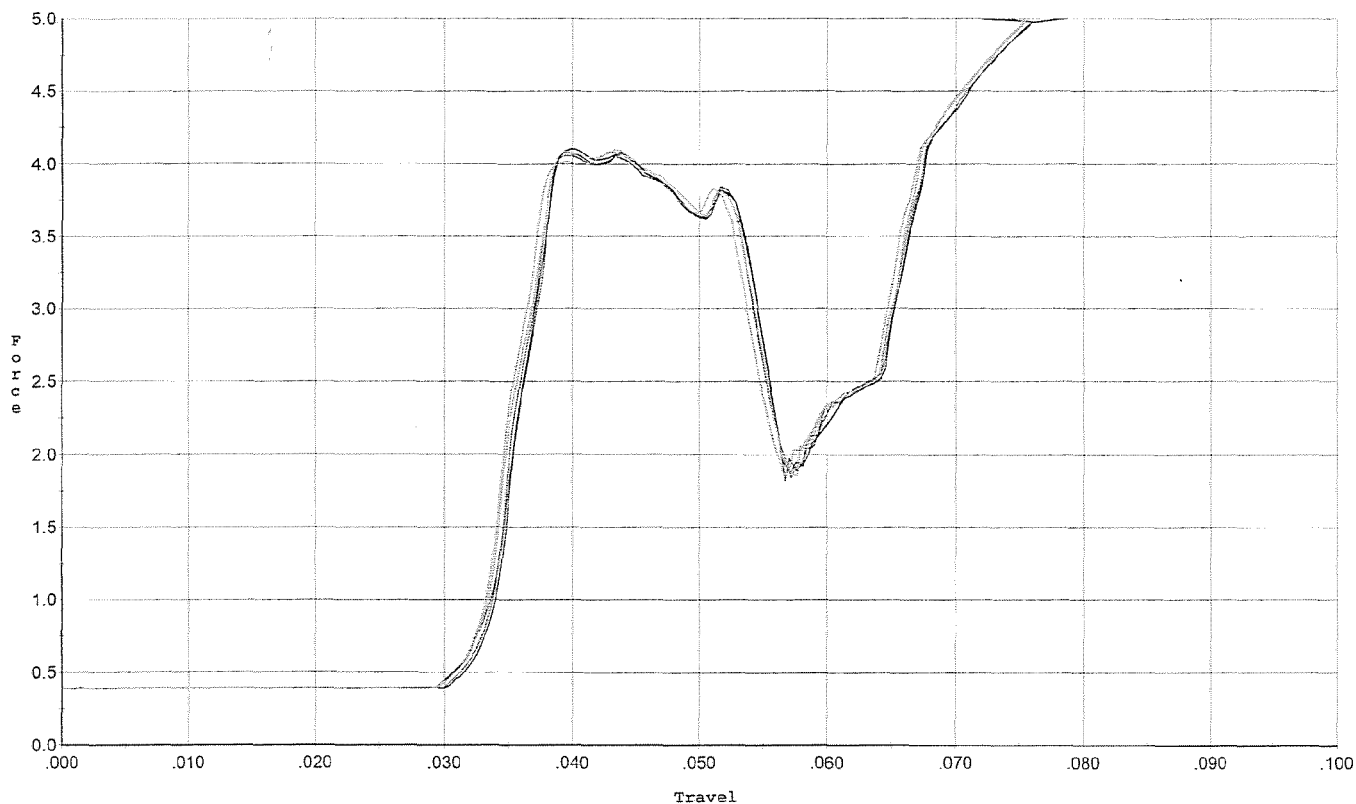
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.175	0.053	0.034	0.033	0.067		Set Trigger
2	3.132	0.053	0.033	0.032	0.067		Set Trigger
3	3.082	0.052	0.033	0.033	0.066		Set Trigger
4	3.183	0.053	0.033	0.032	0.067		Set Trigger
5	3.201	0.053	0.033	0.032	0.068		Set Trigger

Aug 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/9/08

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



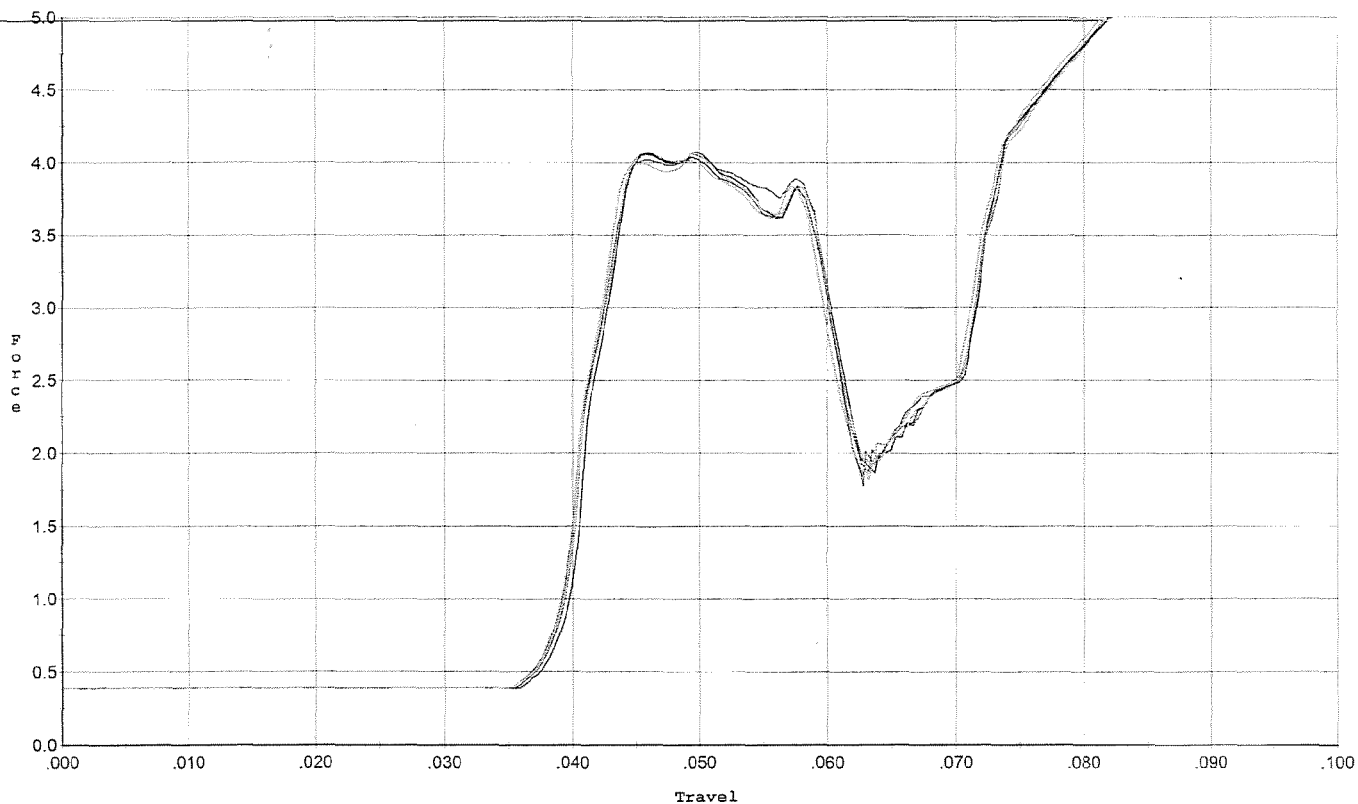
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.054	0.032	0.031	0.087		Set Trigger
2	4.099	0.054	0.033	0.031	0.086		Set Trigger
3	4.055	0.053	0.032	0.031	0.085		Set Trigger
4	4.096	0.053	0.032	0.031	0.086		Set Trigger
5	4.082	0.053	0.032	0.031	0.085		Set Trigger

Aug 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/9/08

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



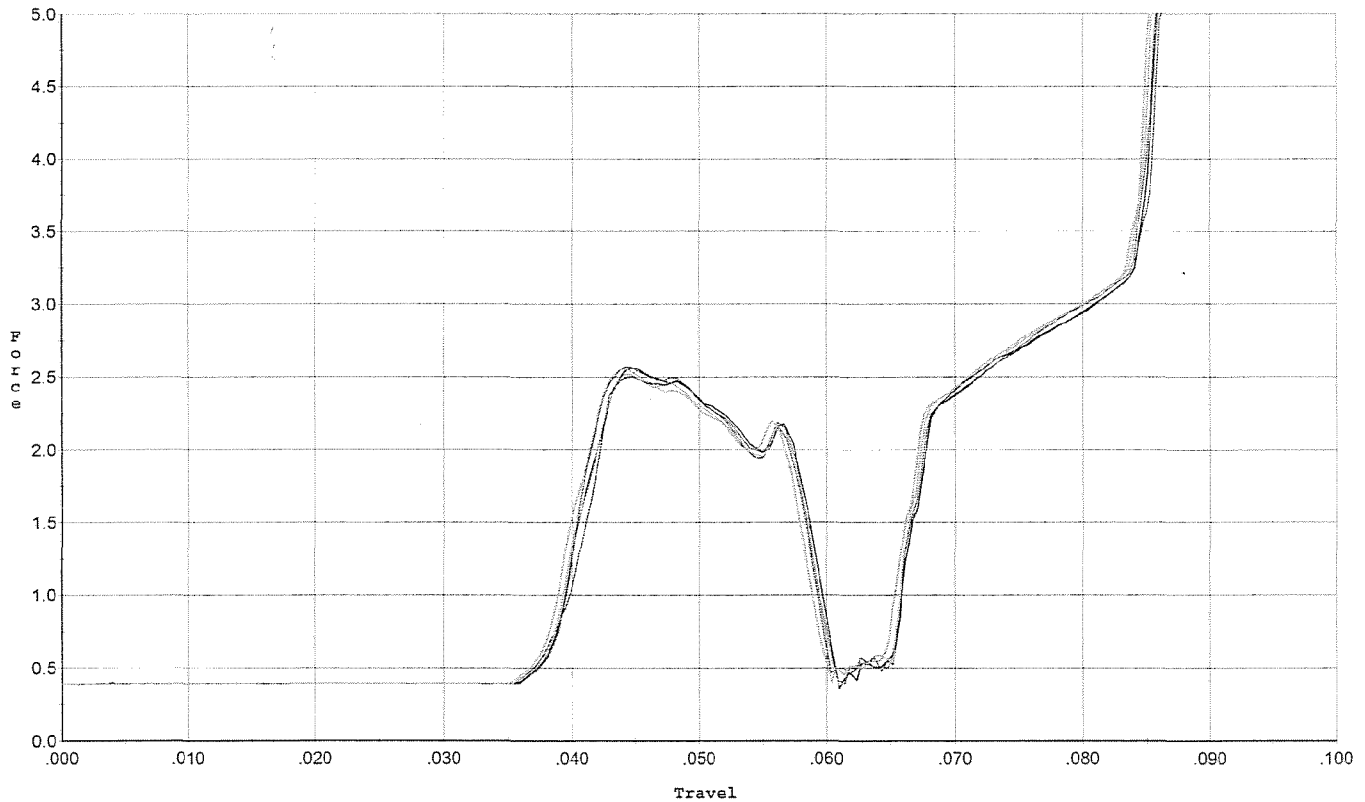
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.059	0.038	0.031	0.089		Set Trigger
2	4.074	0.059	0.038	0.031	0.088		Set Trigger
3	4.061	0.059	0.038	0.031	0.090		Set Trigger
4	4.069	0.059	0.038	0.031	0.089		Set Trigger
5	4.013	0.058	0.038	0.031	0.087		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 10/9/08

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



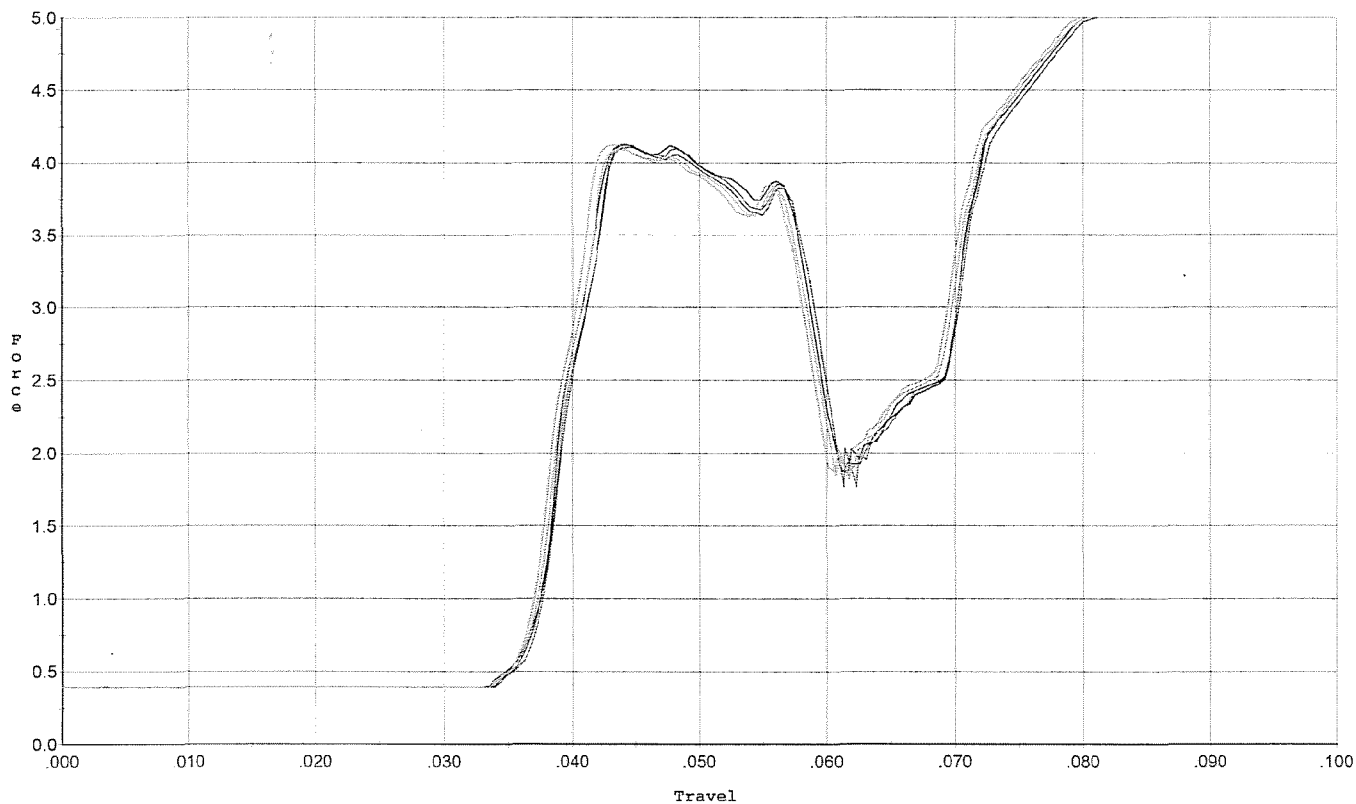
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.505	0.058	0.038	0.035	0.056		Set Trigger
2	2.564	0.059	0.038	0.034	0.058		Set Trigger
3	2.569	0.058	0.039	0.034	0.057		Set Trigger
4	2.518	0.058	0.038	0.034	0.056		Set Trigger
5	2.558	0.057	0.038	0.034	0.056		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/9/08

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	4.107	0.059	0.036	0.031	0.091		Set Trigger
2	4.126	0.057	0.036	0.031	0.090		Set Trigger
3	4.122	0.059	0.037	0.030	0.092		Set Trigger
4	4.091	0.059	0.036	0.031	0.091		Set Trigger
5	4.123	0.057	0.036	0.031	0.089		Set Trigger

Avg 4.11