

5678 4984

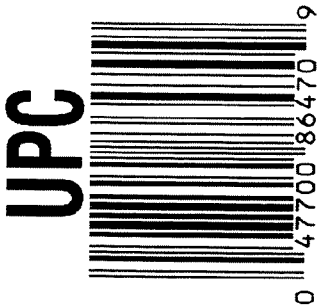
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784984



GUN SERIAL #

G 6784984

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SPD
430	ASSEMBLE TO STOCK		9-19-08	SPD
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		9-20-08	REN
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX SEP 22 2008 OPERATOR <u>BA</u>	9-20-08	JP
480	MAGNAFLUX BBL ACTION		9-22-08	BA
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)		9-24	a
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	JP
	D) OIL FIRING PIN ASSEMBLY		10-15-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

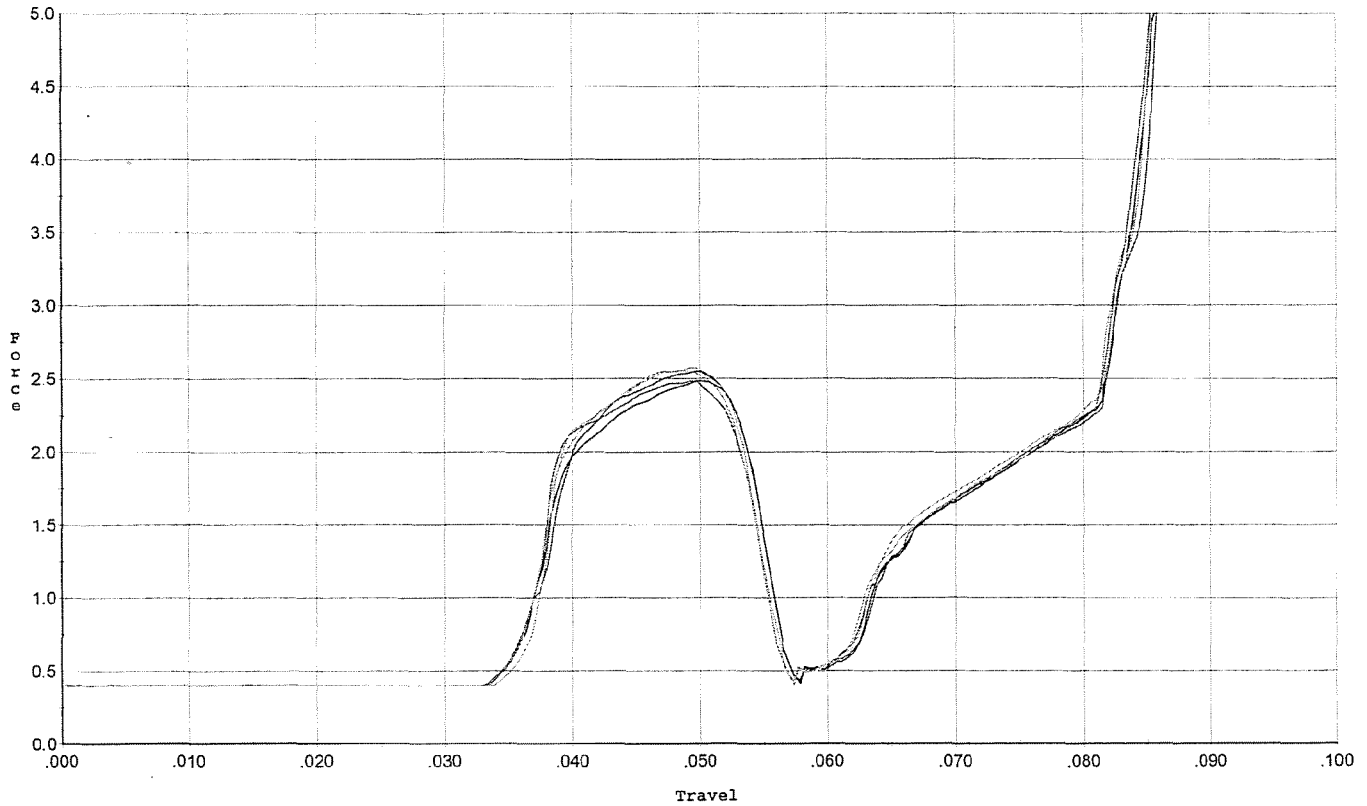
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>49</u> <u>49</u>	12-12-08	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>45</u> <u>50</u> <u>50</u>	12-12-08	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	12-12-08	LN
	J) ASSEMBLE STOCK		10-15-08	RP
	K) ASSEMBLE SWIVEL STUDS		12-12-08	LN
	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	RP
	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	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>221</u> <u>240</u> <u>257</u> <u>248</u> <u>246</u>	12-11-08	LN
	C) FUNCTION		12-12-08	LN
690	PACK		1/14/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



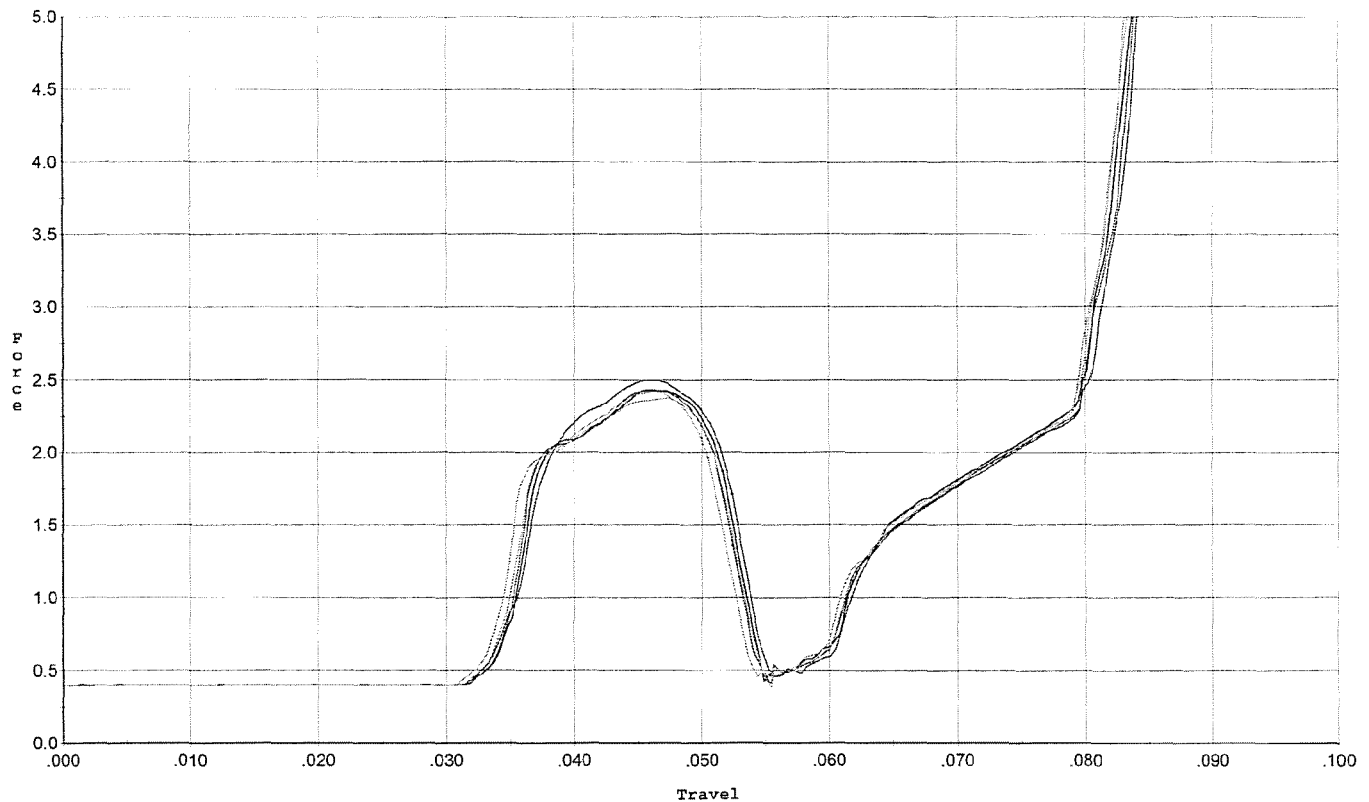
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.054	0.036	0.037	0.054		Set Trigger
2	2.486	0.054	0.035	0.037	0.053		Set Trigger
3	2.482	0.054	0.035	0.037	0.053		Set Trigger
4	2.570	0.053	0.035	0.037	0.053		Set Trigger
5	2.555	0.054	0.036	0.037	0.053		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



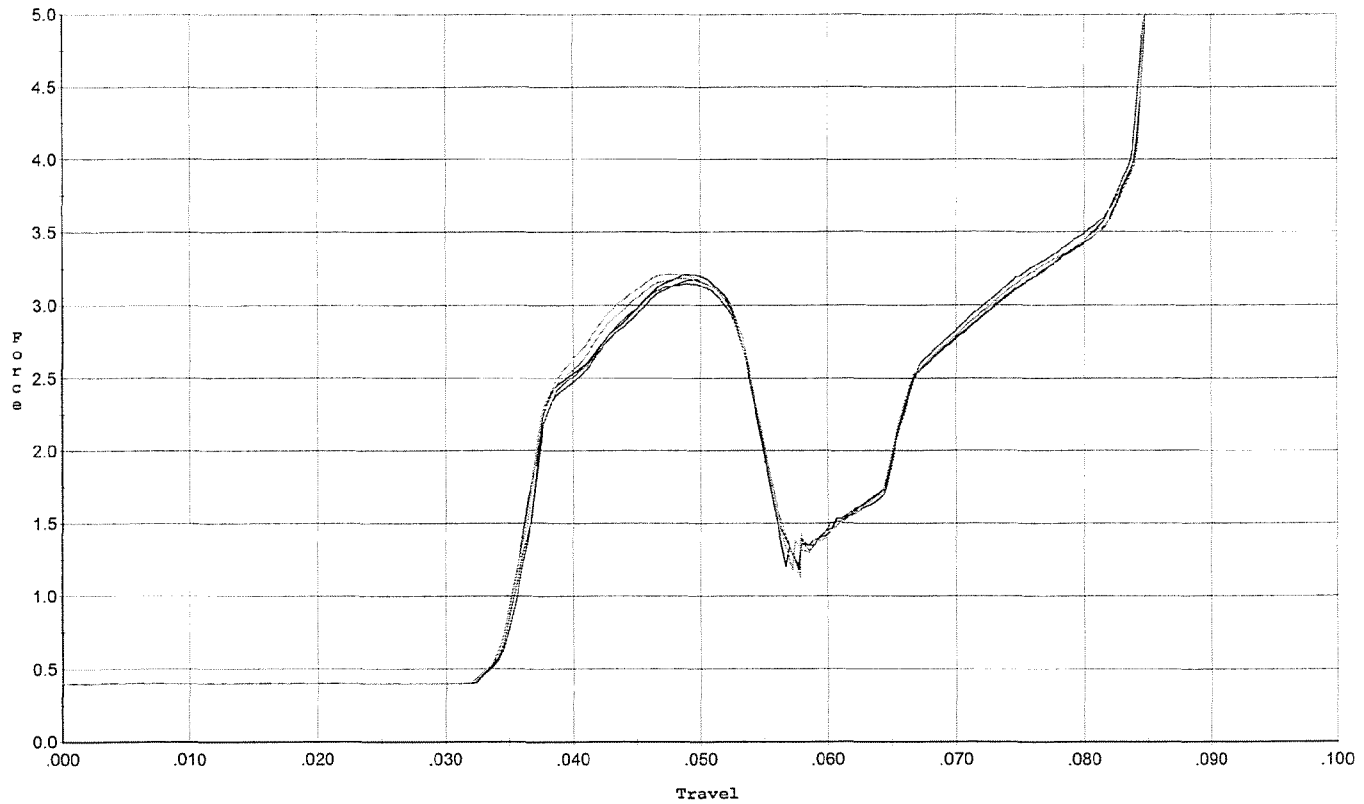
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.498	0.052	0.034	0.037	0.052		Set Trigger
2	2.431	0.052	0.034	0.037	0.050		Set Trigger
3	2.425	0.052	0.034	0.036	0.051		Set Trigger
4	2.372	0.052	0.034	0.036	0.051		Set Trigger
5	2.420	0.051	0.033	0.037	0.049		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



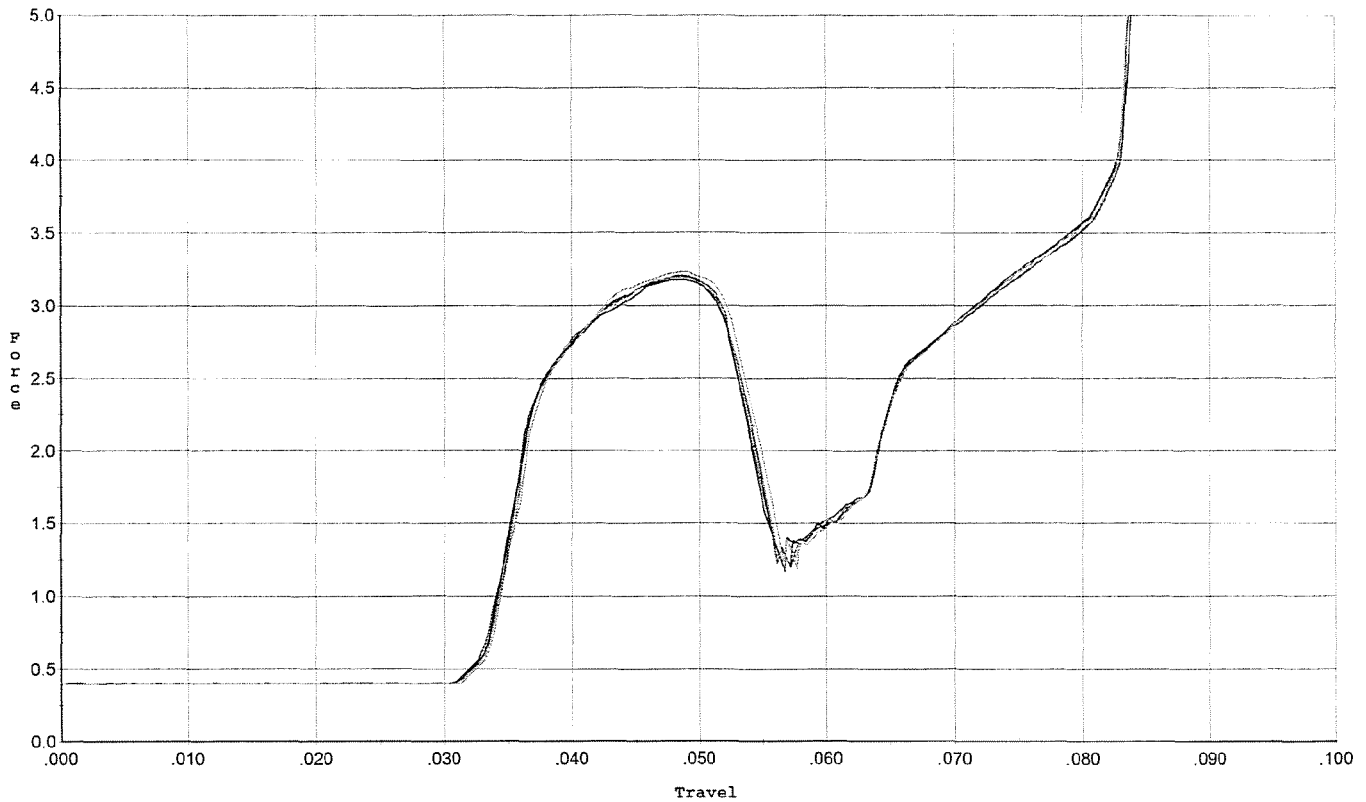
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.055	0.035	0.035	0.066		Set Trigger
2	3.207	0.055	0.034	0.035	0.068		Set Trigger
3	3.146	0.055	0.034	0.035	0.067		Set Trigger
4	3.212	0.055	0.034	0.035	0.068		Set Trigger
5	3.181	0.055	0.034	0.035	0.068		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



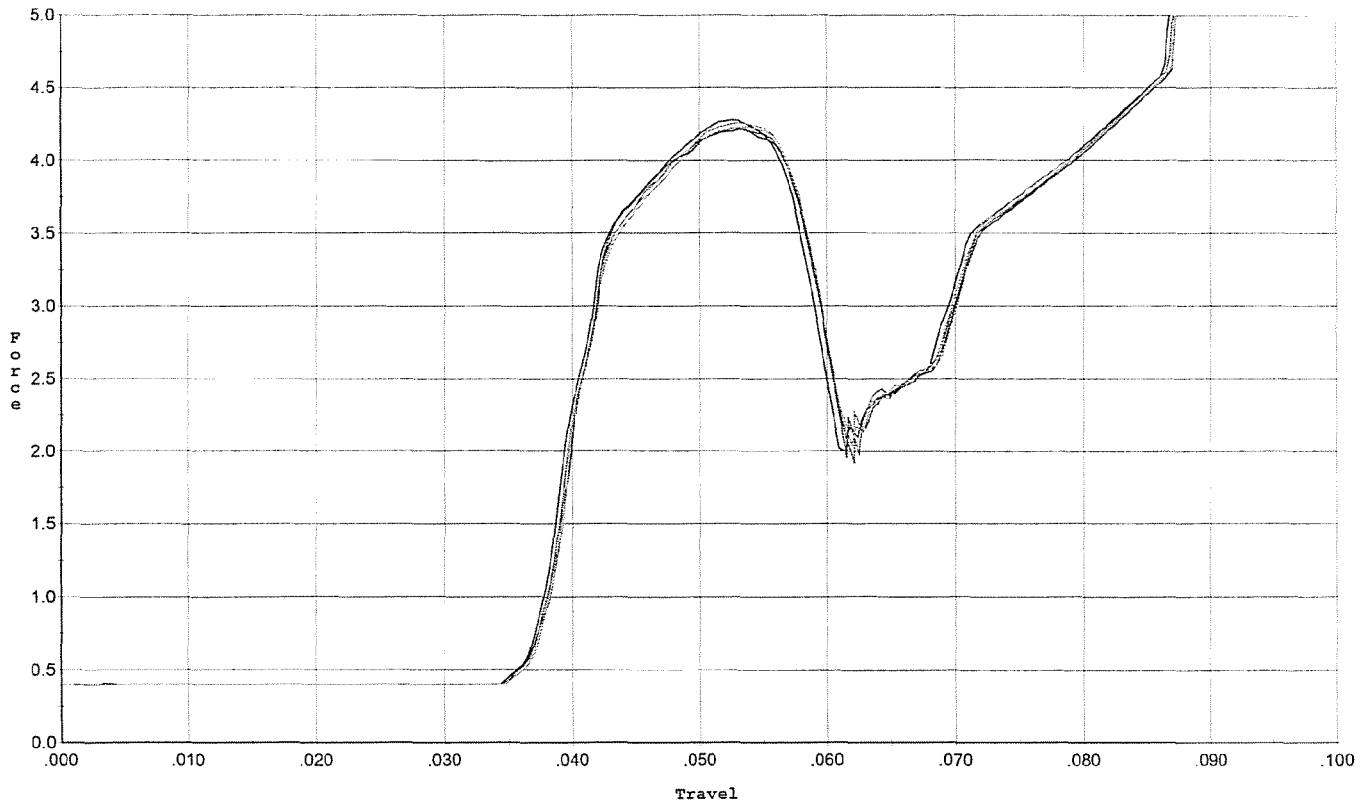
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.176	0.053	0.033	0.035	0.068		Set Trigger
2	3.205	0.053	0.033	0.035	0.067		Set Trigger
3	3.209	0.054	0.033	0.034	0.069		Set Trigger
4	3.234	0.055	0.033	0.034	0.071		Set Trigger
5	3.194	0.054	0.034	0.034	0.068		Set Trigger

Aug 3.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



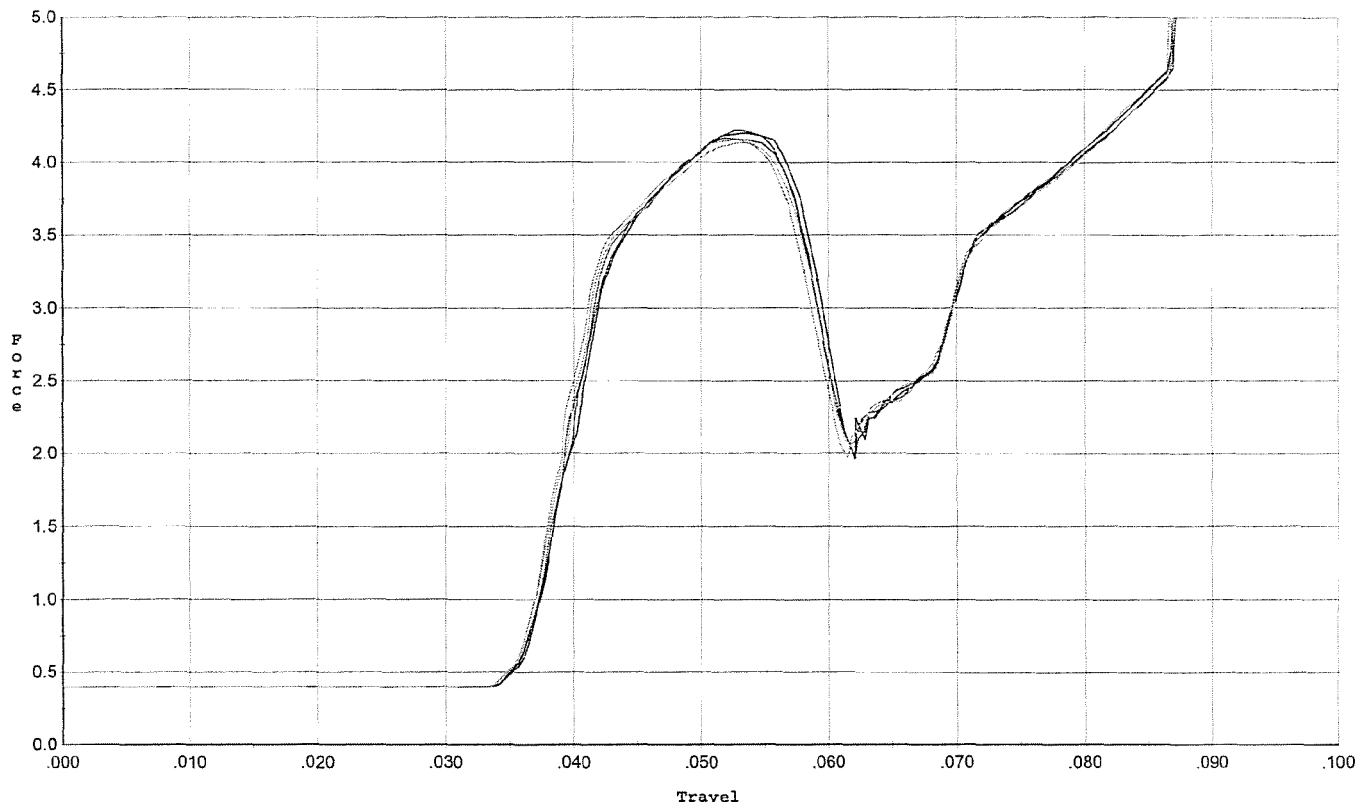
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.212	0.059	0.037	0.032	0.092		Set Trigger
2	4.277	0.059	0.037	0.033	0.092		Set Trigger
3	4.220	0.059	0.037	0.032	0.093		Set Trigger
4	4.231	0.059	0.037	0.032	0.092		Set Trigger
5	4.255	0.059	0.037	0.032	0.092		Set Trigger

Aug 4.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/13/08

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



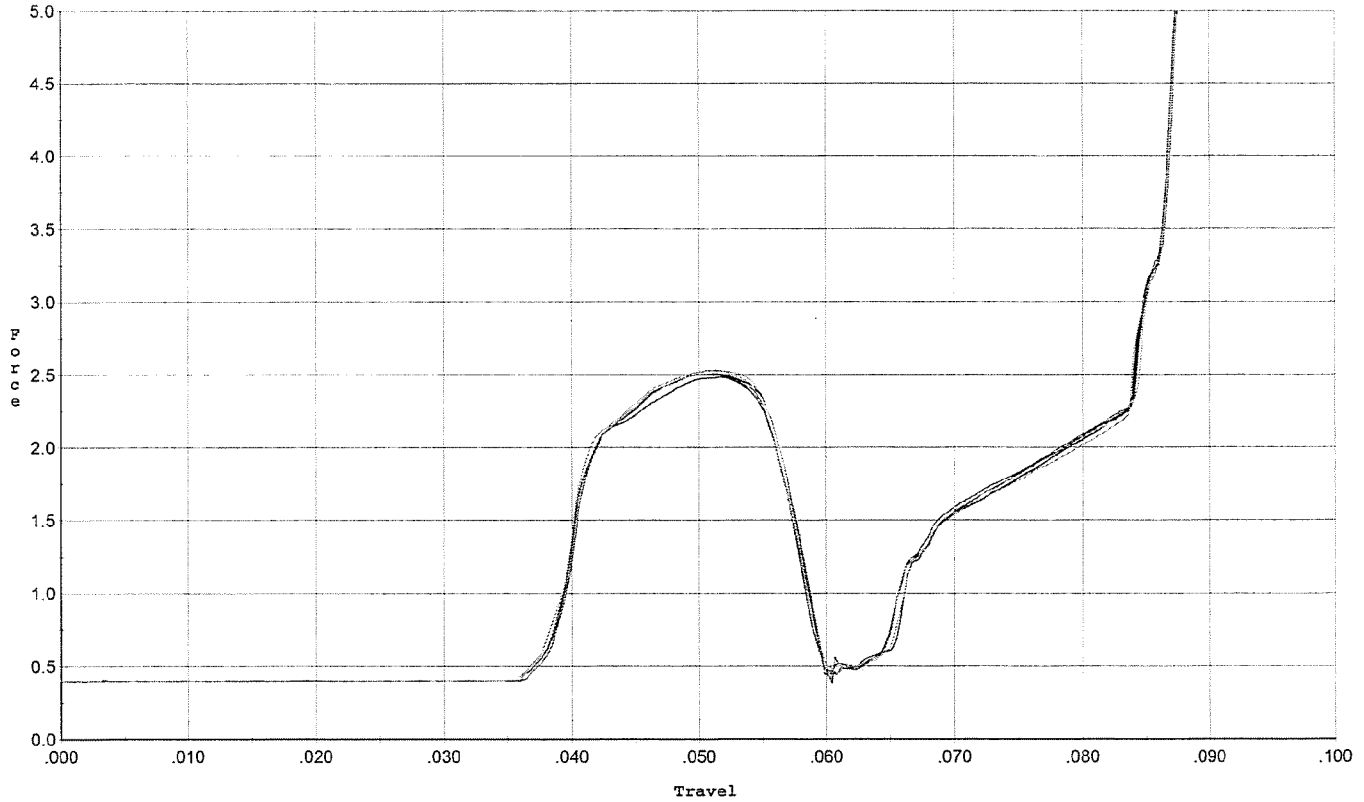
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.058	0.036	0.033	0.090		Set Trigger
2	4.199	0.059	0.036	0.032	0.092		Set Trigger
3	4.218	0.059	0.036	0.032	0.091		Set Trigger
4	4.134	0.059	0.036	0.032	0.091		Set Trigger
5	4.158	0.058	0.036	0.033	0.090		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/13/08

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



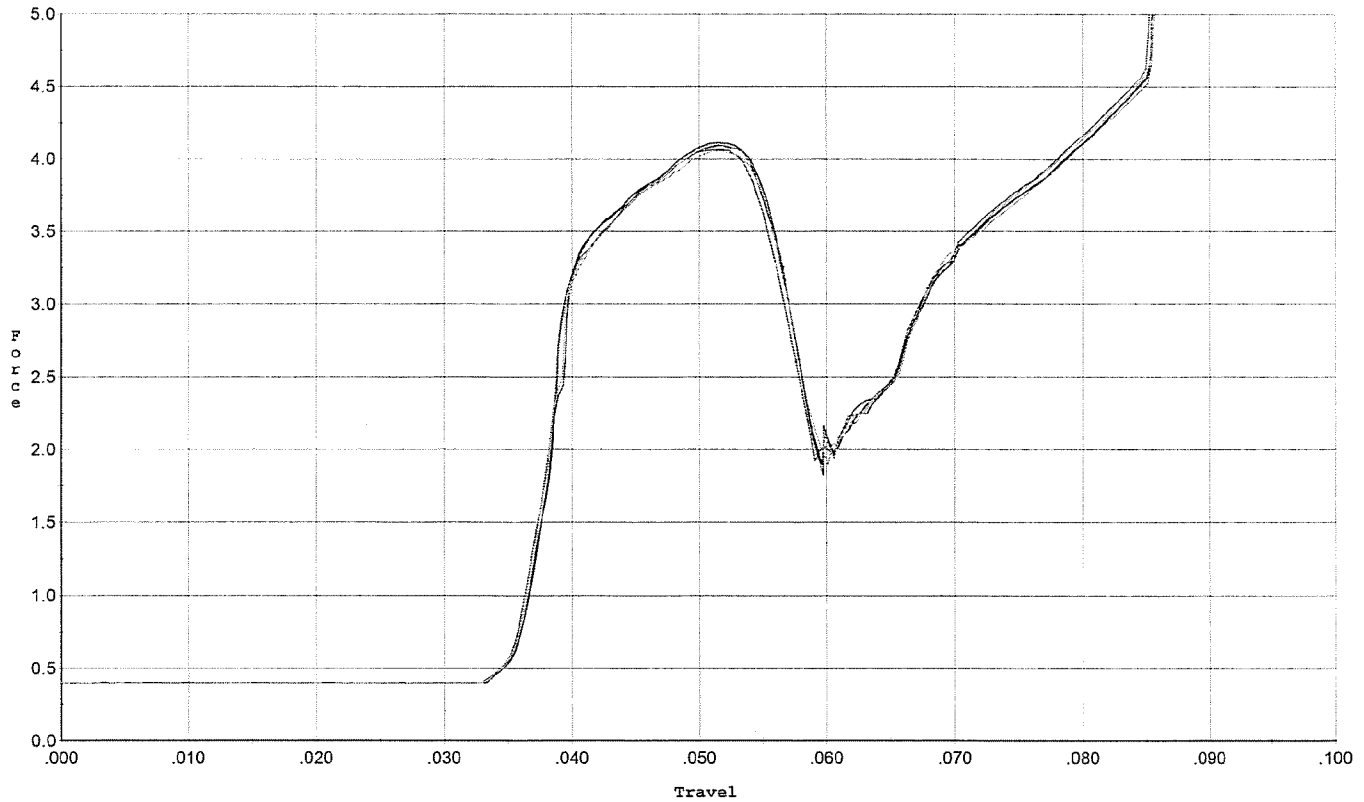
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.485	0.057	0.038	0.037	0.055		Set Trigger
2	2.507	0.058	0.038	0.036	0.057		Set Trigger
3	2.501	0.058	0.038	0.036	0.057		Set Trigger
4	2.524	0.058	0.038	0.037	0.057		Set Trigger
5	2.533	0.057	0.038	0.037	0.056		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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	4.093	0.057	0.036	0.033	0.086		Set Trigger
2	4.112	0.057	0.036	0.033	0.087		Set Trigger
3	4.063	0.058	0.035	0.033	0.087		Set Trigger
4	4.052	0.057	0.036	0.033	0.086		Set Trigger
5	4.099	0.057	0.036	0.033	0.087		Set Trigger

Avg 4.08