

G-6784991

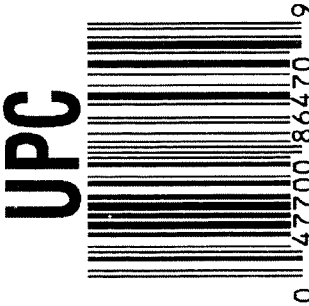
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784991



GUN SERIAL #

G 6784991

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-8-08	SP
430	ASSEMBLE TO STOCK		9-8-08	SP
440	PROOF		9-8-08	SP
460	CHECK HEADSPACE		9-8-08	SP
470	DIS-ASSEMBLE ACTION		9-8-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-9-08	RT
475	DRILL AND TAP SIGHT HOLES	SEP 10 2008	9-9-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BH	9-10-08	BH
490	MAGNAFLUX BOLT		9/13/08	mk
500	ROLLMARK CALIBER		9/14/08	RT
520	GOFF BLAST BBL / REC		9/11/08	RG
542	APPLY COATINGS (BARREL ACTION)		9-11	cu
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-16-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

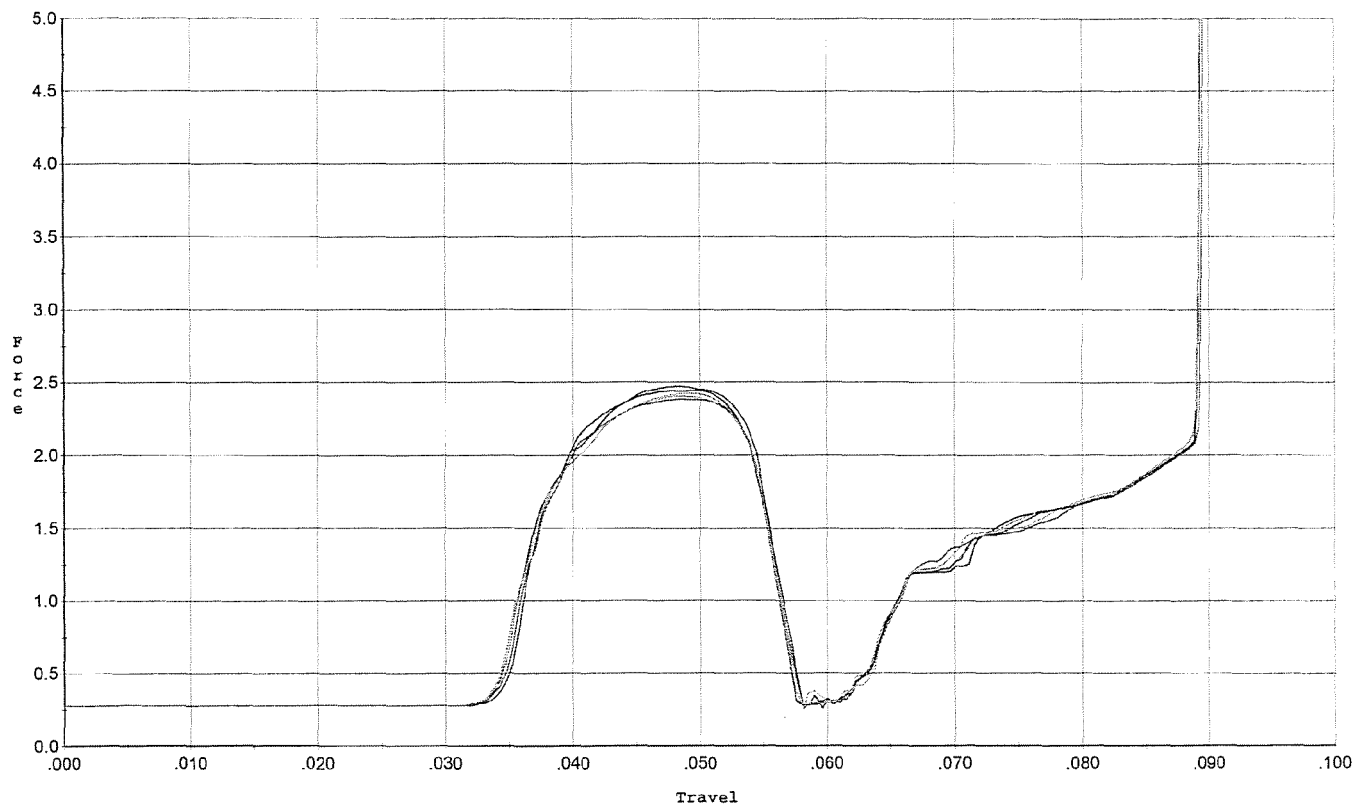
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2</u> <u>2</u> <u>2</u>	9-23-08	TC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	9-23-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.025</u>	9-23-08	TC
	J) ASSEMBLE STOCK		9-16-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		9-23-08	TC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	9-23-08	TC
650	TARGET	<u>PASS</u> FAIL	9-18-08	FM
	MALFUNCTION <i>Bolt catches</i>	CORRECTION	9-23-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>NA</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-18-08	AA
670	FINAL INSPECTION A) HEADSPACE		9-23-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>210</u> <u>245</u> <u>247</u> <u>218</u> <u>229</u>	9-23-08	L.P.D.
	C) FUNCTION		9-23-08	TC
690	PACK		12-8-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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

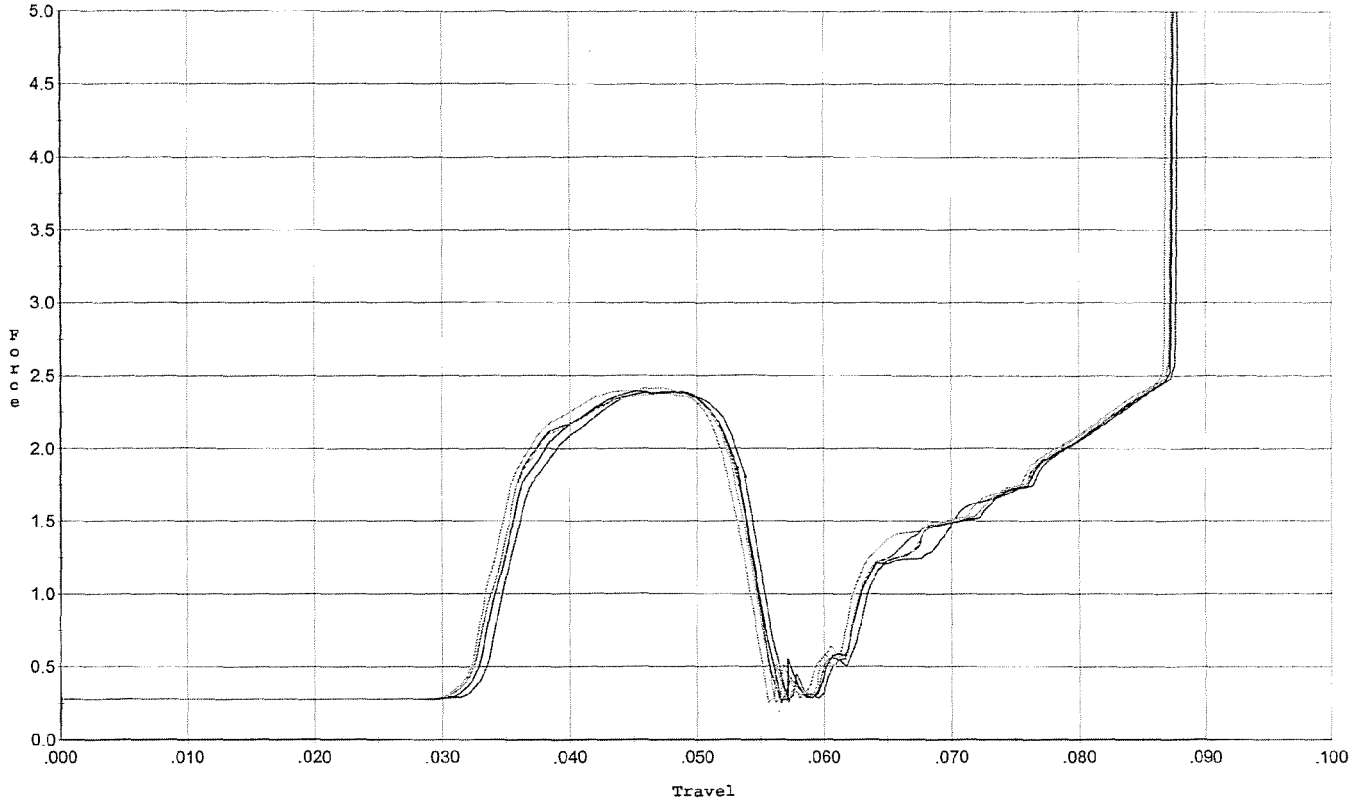


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.054	0.035	0.039	0.052		Set Trigger
2	2.444	0.055	0.034	0.039	0.052		Set Trigger
3	2.382	0.055	0.035	0.039	0.051		Set Trigger
4	2.423	0.055	0.034	0.039	0.051		Set Trigger
5	2.403	0.055	0.034	0.039	0.051		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 8/29/08		



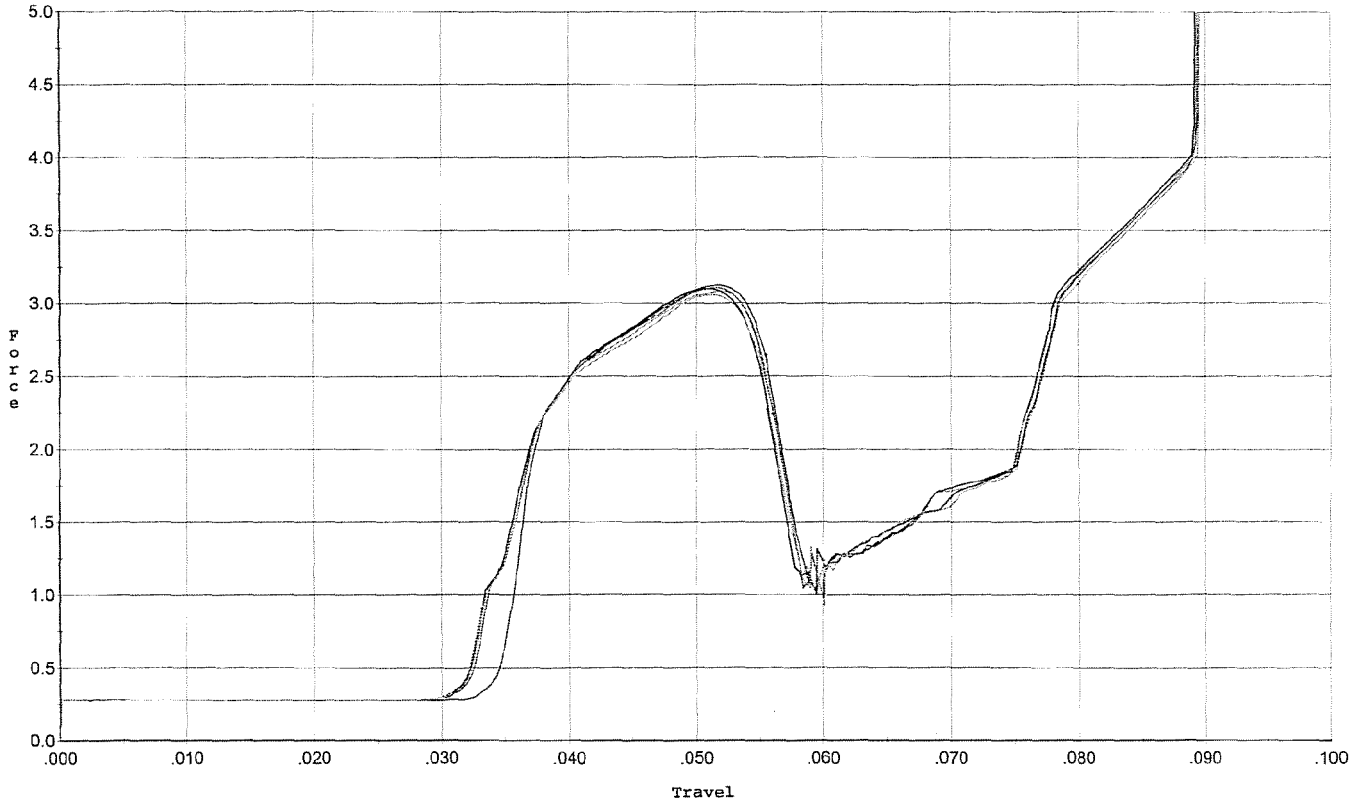
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.385	0.054	0.033	0.038	0.051		Set Trigger
2	2.393	0.053	0.033	0.038	0.051		Set Trigger
3	2.391	0.053	0.032	0.038	0.052		Set Trigger
4	2.376	0.054	0.032	0.038	0.052		Set Trigger
5	2.415	0.053	0.032	0.038	0.052		Set Trigger

Avg 2.39

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



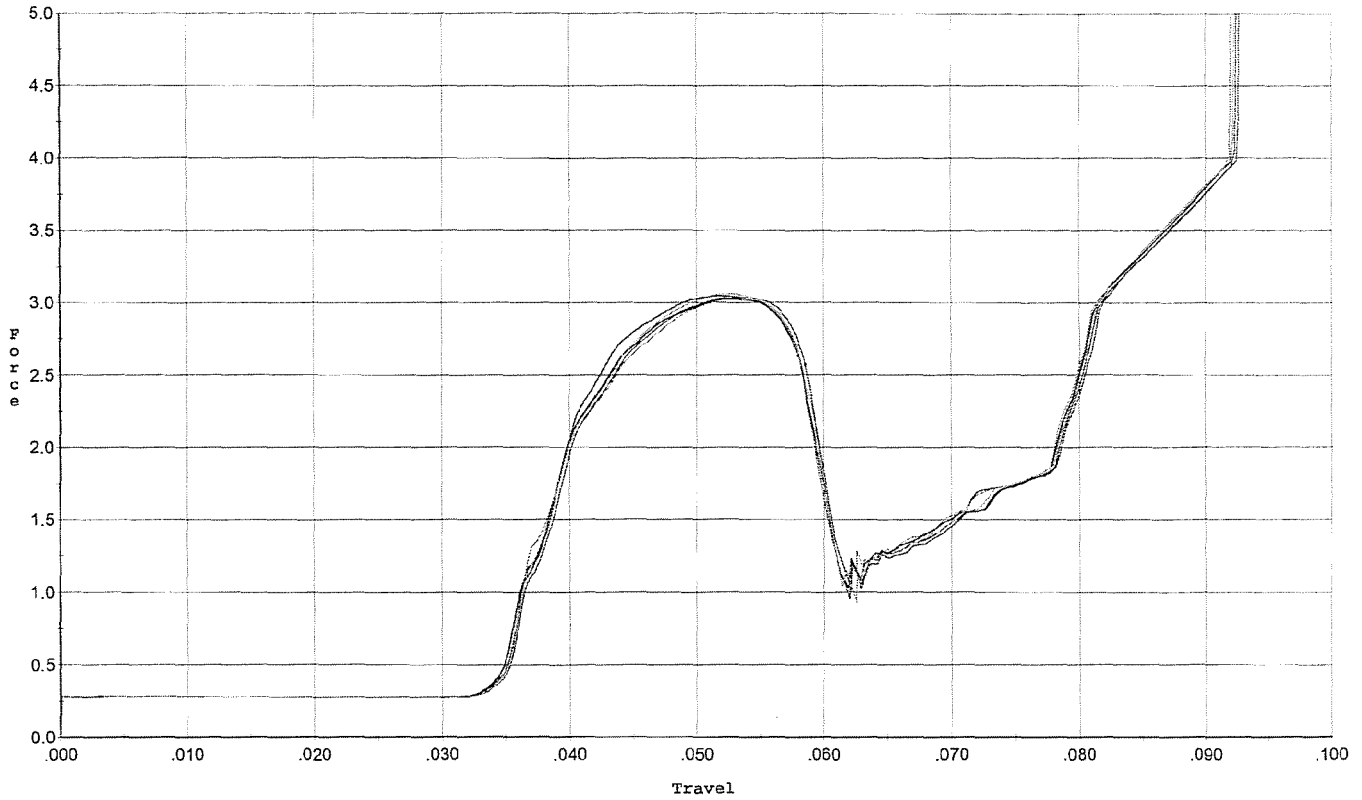
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.055	0.034	0.037	0.065		Set Trigger
2	3.100	0.055	0.032	0.037	0.067		Set Trigger
3	3.105	0.056	0.032	0.037	0.068		Set Trigger
4	3.058	0.055	0.032	0.037	0.065		Set Trigger
5	3.080	0.056	0.032	0.037	0.067		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



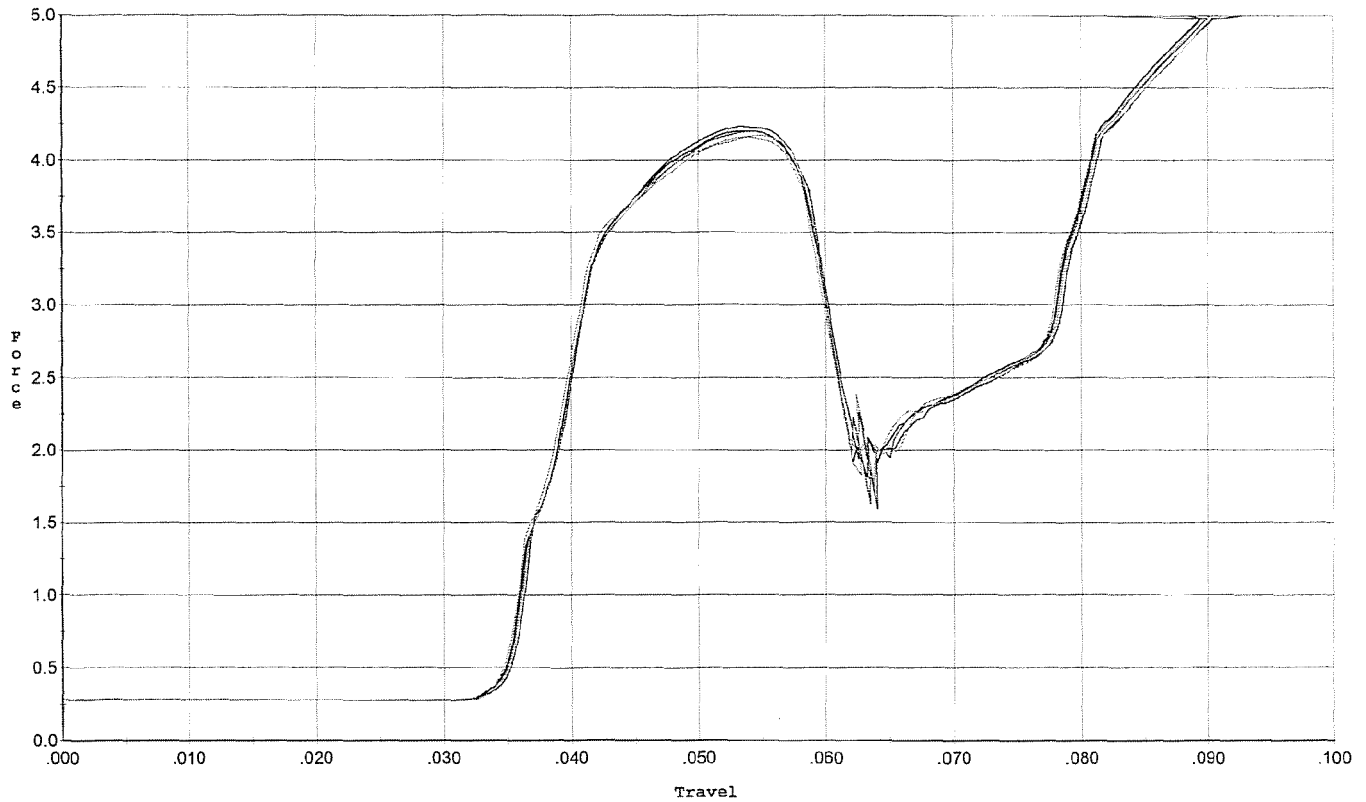
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.060	0.035	0.038	0.071		Set Trigger
2	3.027	0.058	0.035	0.038	0.068		Set Trigger
3	3.037	0.059	0.035	0.038	0.068		Set Trigger
4	3.058	0.059	0.035	0.038	0.070		Set Trigger
5	3.023	0.058	0.035	0.037	0.067		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



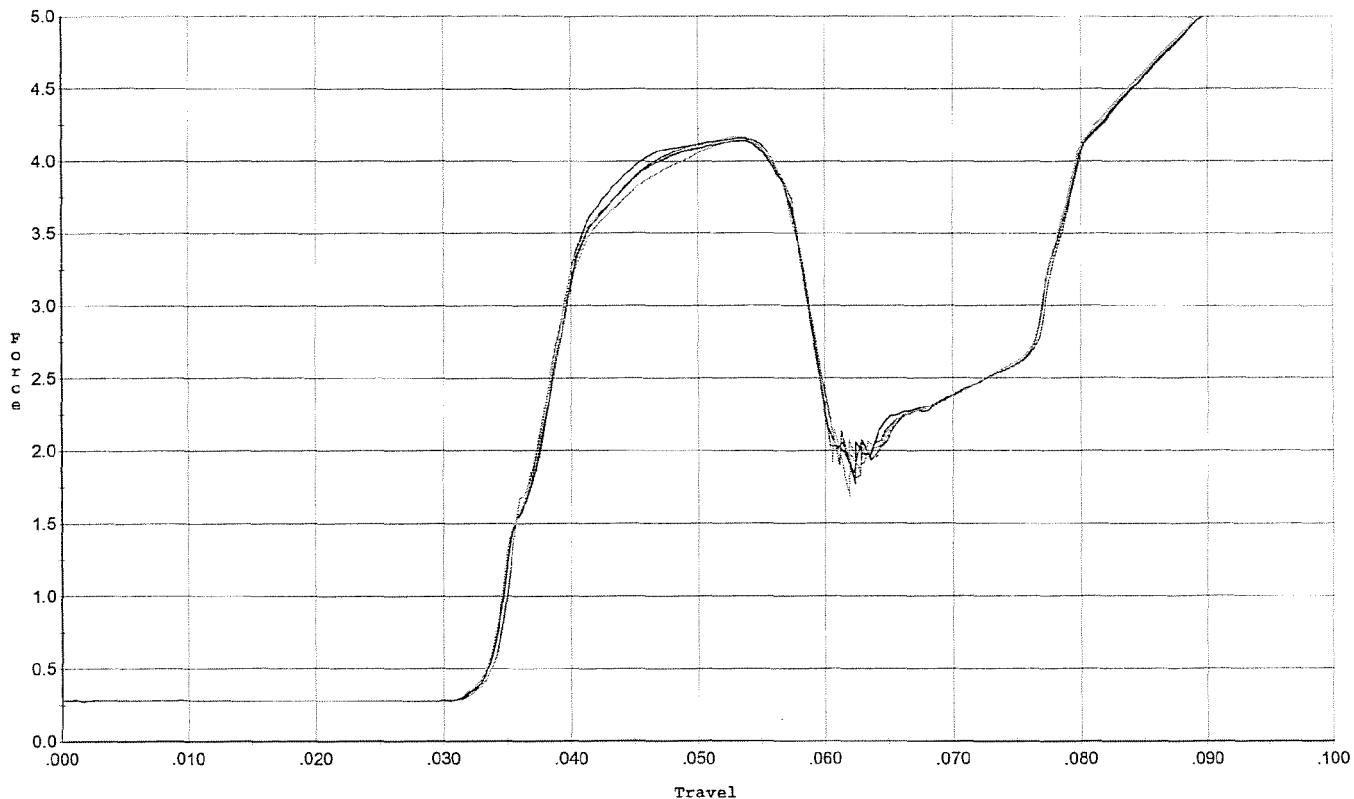
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.059	0.035	0.036	0.093		Set Trigger
2	4.201	0.059	0.035	0.036	0.094		Set Trigger
3	4.199	0.059	0.035	0.036	0.093		Set Trigger
4	4.169	0.059	0.035	0.036	0.093		Set Trigger
5	4.161	0.060	0.034	0.035	0.095		Set Trigger

Avg 4.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



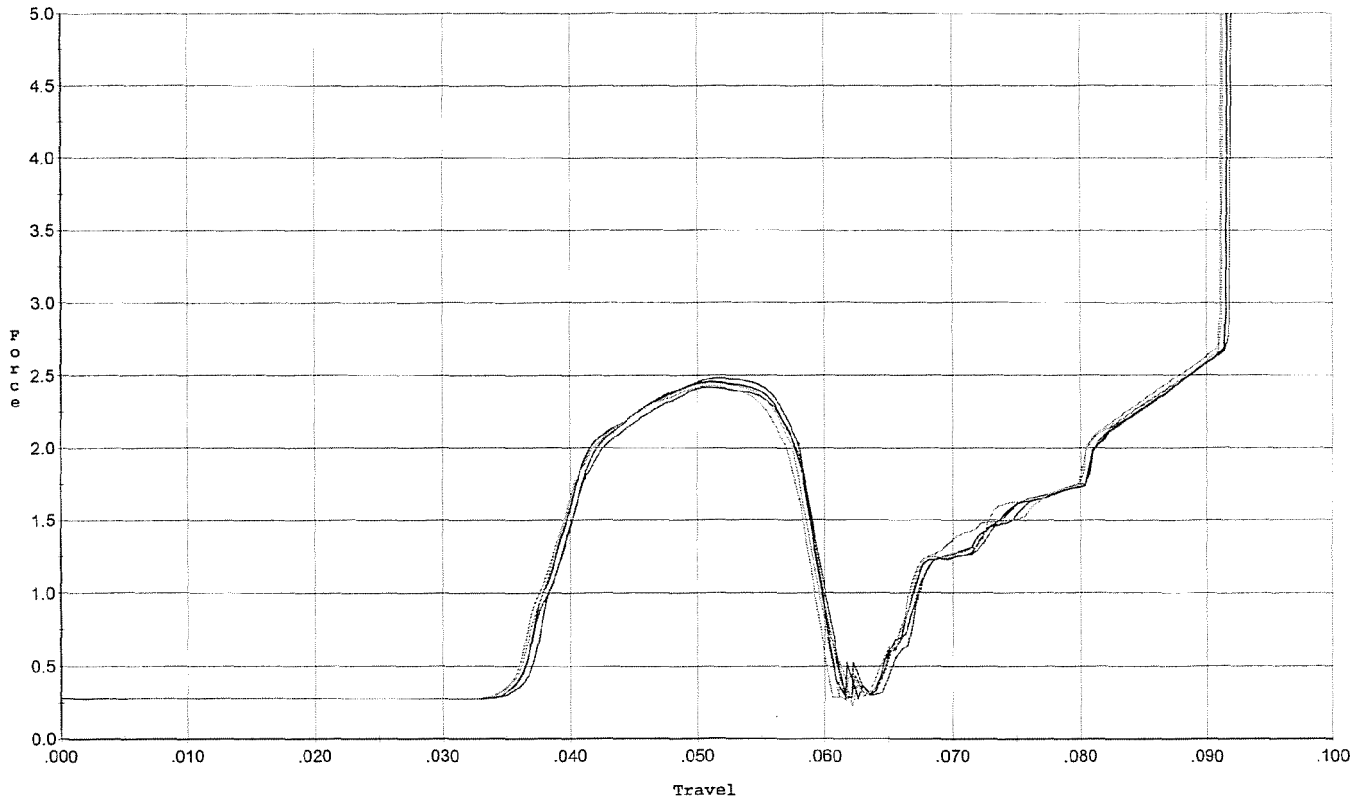
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.161	0.058	0.033	0.035	0.093		Set Trigger
2	4.138	0.057	0.033	0.035	0.092		Set Trigger
3	4.162	0.057	0.034	0.035	0.091		Set Trigger
4	4.170	0.058	0.033	0.035	0.093		Set Trigger
5	4.145	0.057	0.034	0.035	0.091		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



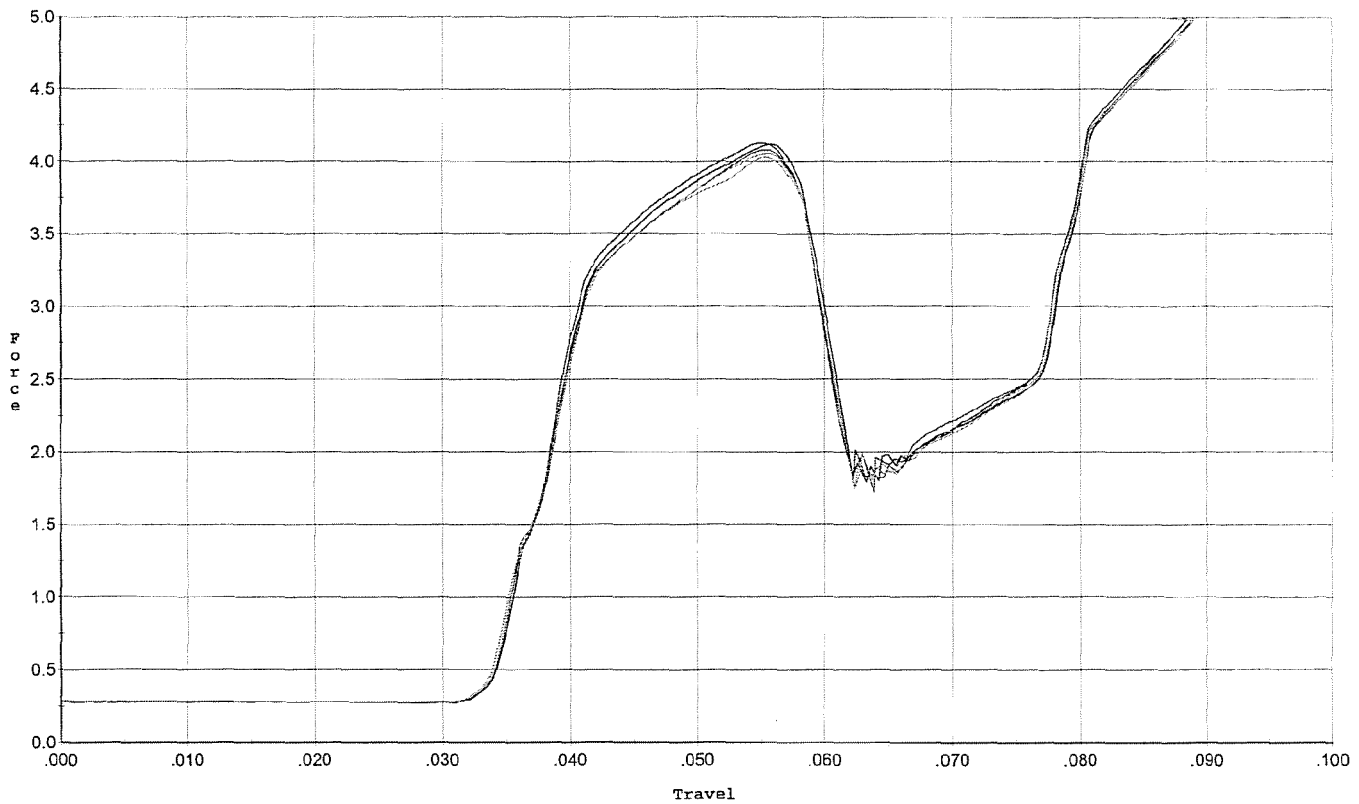
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.058	0.037	0.039	0.055		Set Trigger
2	2.455	0.058	0.036	0.038	0.056		Set Trigger
3	2.419	0.058	0.036	0.039	0.054		Set Trigger
4	2.445	0.059	0.036	0.038	0.056		Set Trigger
5	2.429	0.058	0.036	0.038	0.055		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/29/08

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	4.126	0.058	0.034	0.035	0.091		Set Trigger
2	4.120	0.060	0.034	0.035	0.092		Set Trigger
3	4.080	0.058	0.034	0.035	0.089		Set Trigger
4	4.052	0.058	0.034	0.035	0.089		Set Trigger
5	4.030	0.058	0.034	0.035	0.088		Set Trigger

Avg 4.08