

G6794495

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

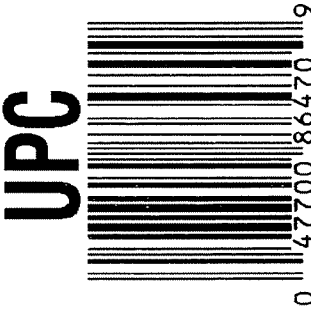


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794495



BM FORM

GUN SERIAL #

G 6794495

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-20-09	SP
430	ASSEMBLE TO STOCK		1-20-09	SP
440	PROOF		1-20-09	SP
460	CHECK HEADSPACE		1-20-09	SP
470	DIS-ASSEMBLE ACTION		1-20-09	SP
472	SERIALIZE BOLT HANDLE		1-21-09	RT
475	DRILL AND TAP SIGHT HOLES		1-21-09	SP
480	MAGNAFLUX BBL ACTION	(X)	1-23-09	(X)
490	MAGNAFLUX BOLT		1-23-09	MR
500	ROLLMARK CALIBER		1-24-09	RT
520	GOFF BLAST BBL / REC		1-24-09	DG
542	APPLY COATINGS (BARREL ACTION)		1-24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-10-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

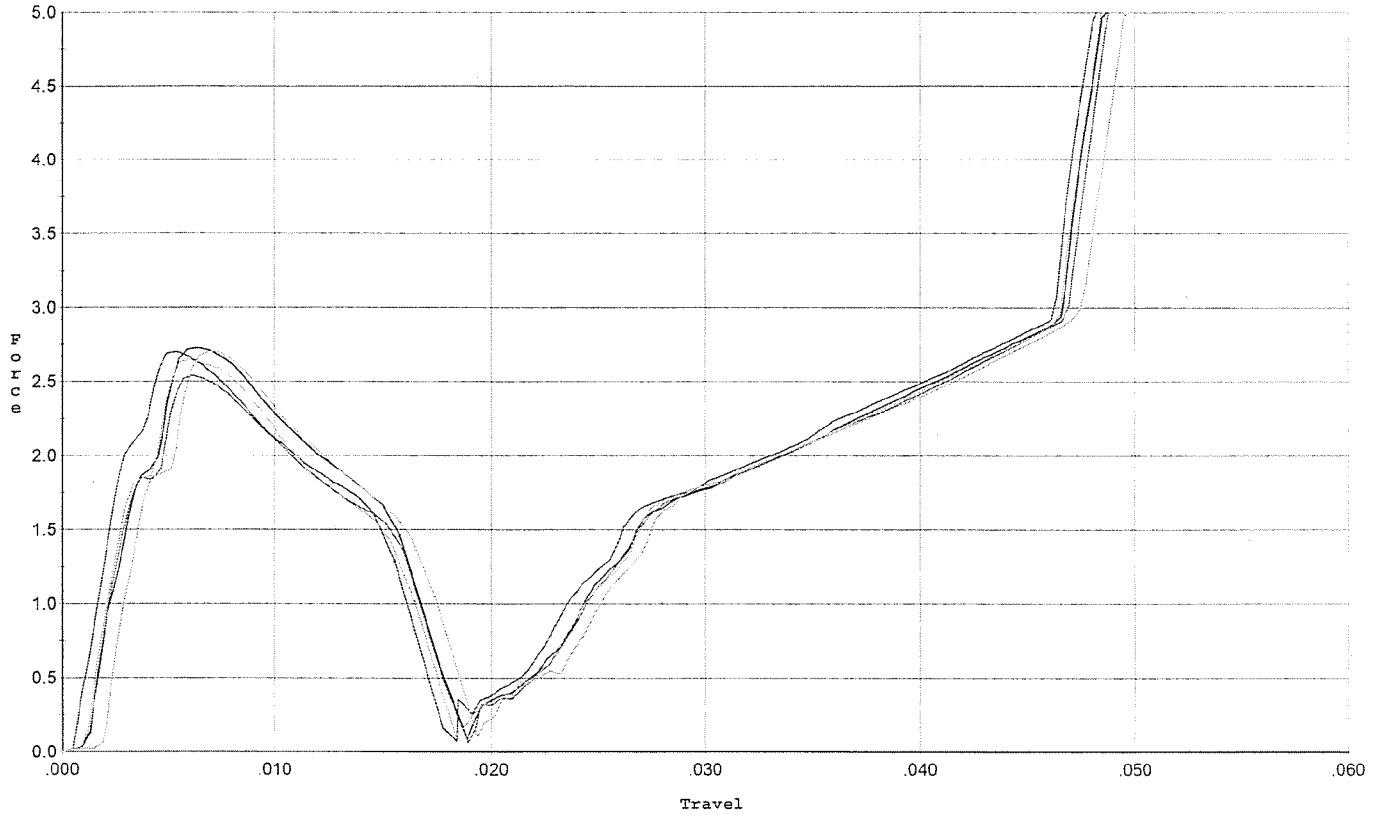
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-25-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-25-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	2-25-09	LN
	J) ASSEMBLE STOCK		2/16/09	FTZ
	K) ASSEMBLE SWIVEL STUDS		2-25-09	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	2-20-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-20-09	WU
670	FINAL INSPECTION A) HEADSPACE		2-25-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.45</u> <u>2.47</u> <u>2.51</u> <u>2.51</u>	2-23-09	WU
	C) FUNCTION		2-25-09	LN
690	PACK		3/2/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



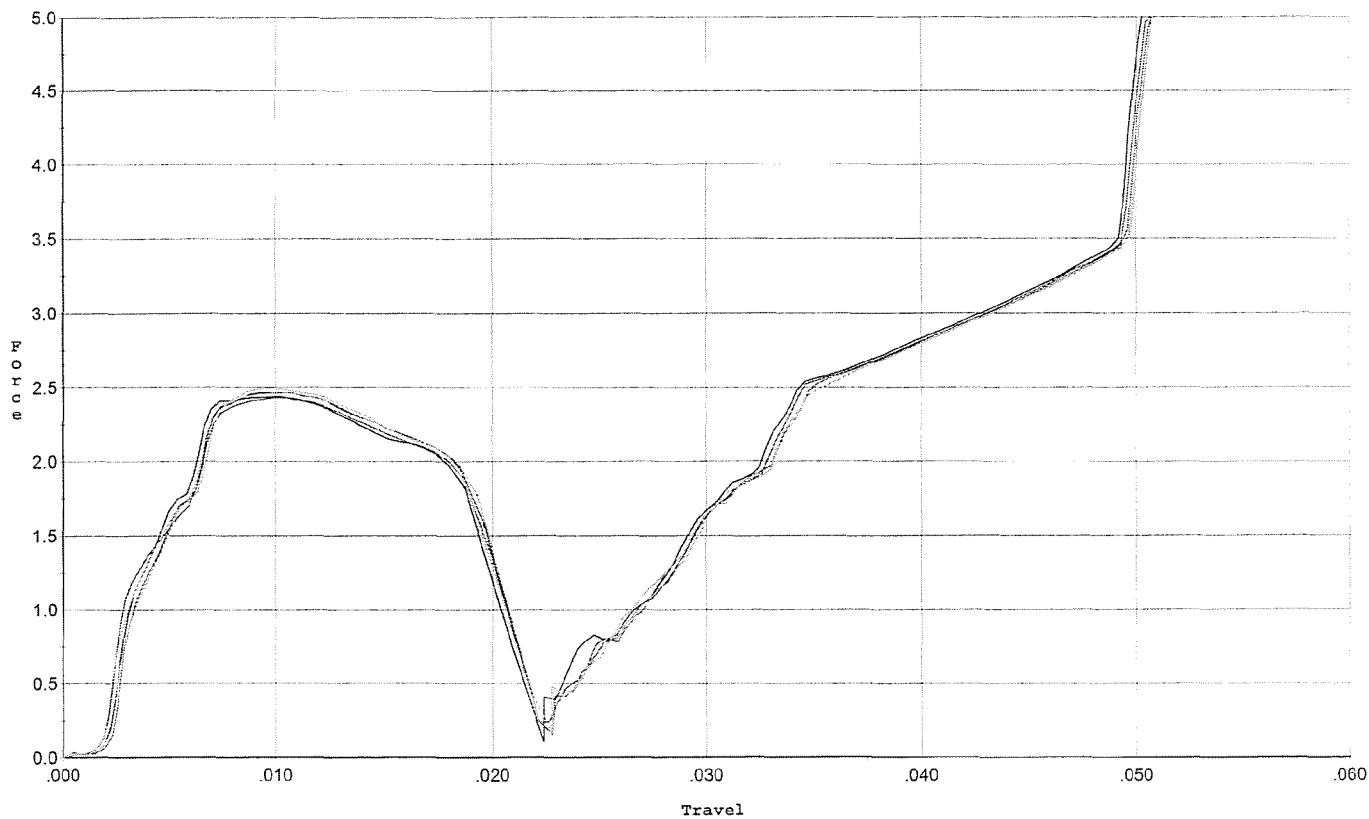
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.701	0.016	0.00	0.037	0.028		Set Trigger
2	2.726	0.016	0.00	0.037	0.027		Set Trigger
3	2.542	0.016	0.00	0.037	0.026		Set Trigger
4	2.649	0.016	0.00	0.037	0.028		Set Trigger
5	2.705	0.017	0.00	0.037	0.028		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



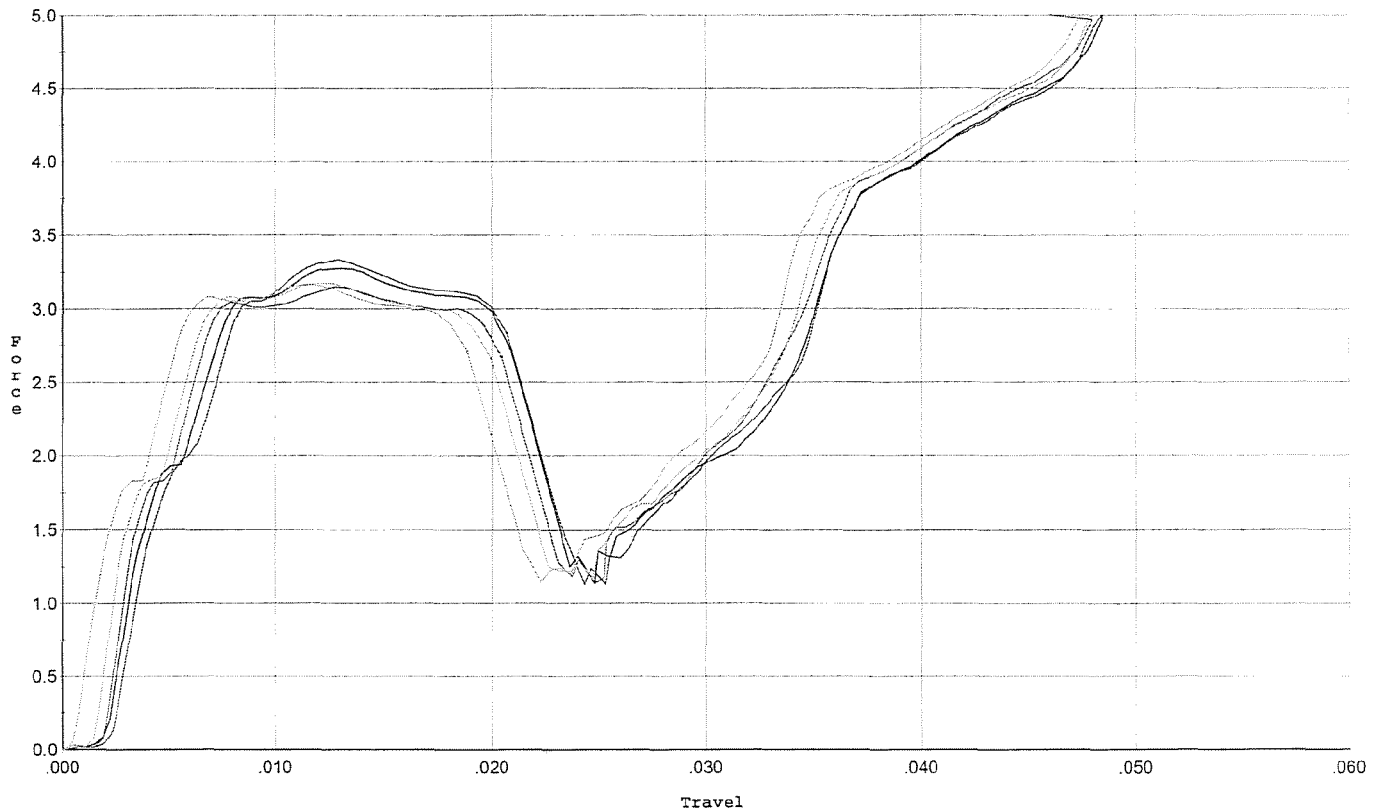
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.466	0.020	0.00	0.035	0.034		Set Trigger
2	2.437	0.019	0.00	0.035	0.032		Set Trigger
3	2.430	0.020	0.002	0.035	0.033		Set Trigger
4	2.495	0.020	0.00	0.035	0.035		Set Trigger
5	2.469	0.019	0.00	0.035	0.033		Set Trigger

4.2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



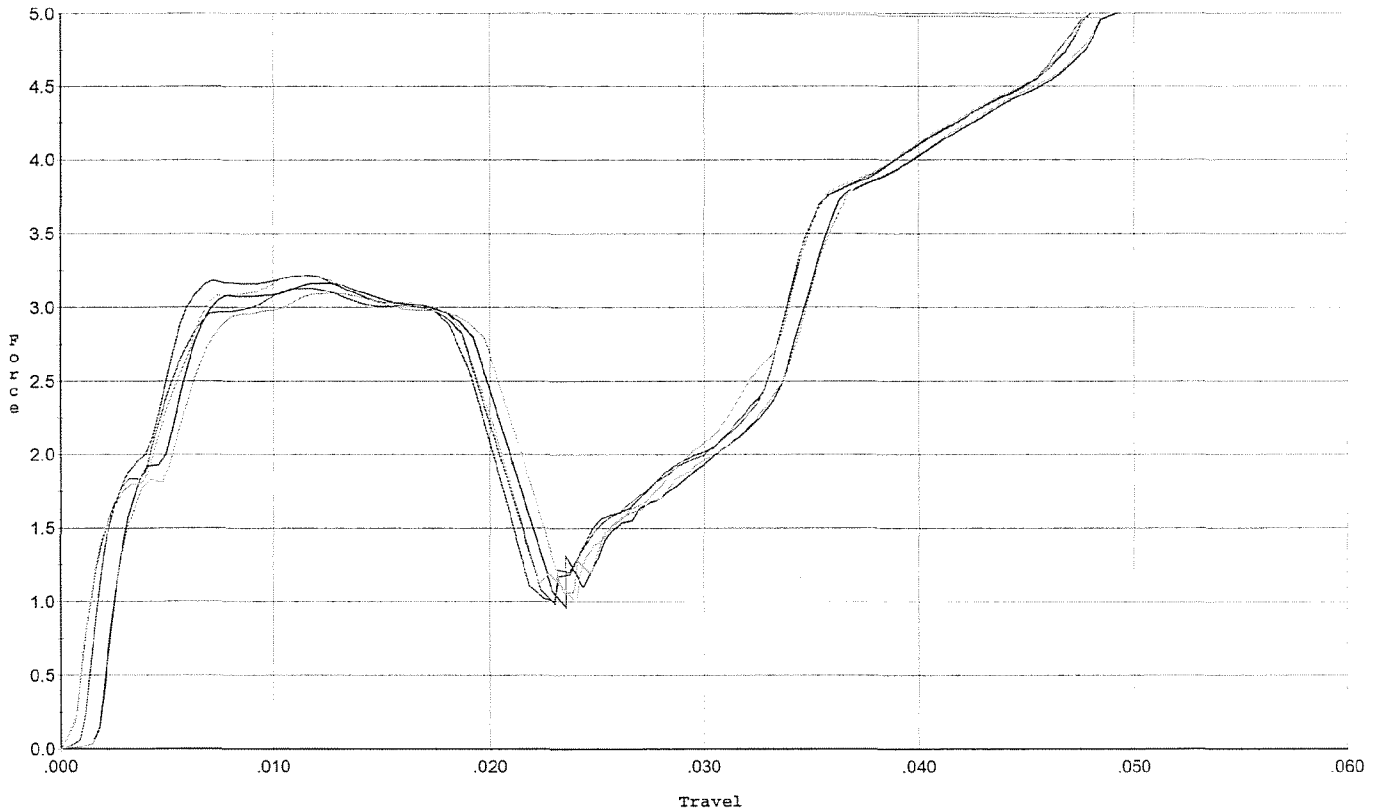
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.334	0.021	0.002	0.033	0.047		Set Trigger
2	3.274	0.021	0.00	0.033	0.048		Set Trigger
3	3.144	0.020	0.002	0.033	0.046		Set Trigger
4	3.172	0.020	0.00	0.033	0.046		Set Trigger
5	3.161	0.019	0.00	0.033	0.045		Set Trigger

A.3.21

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/13/2009

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



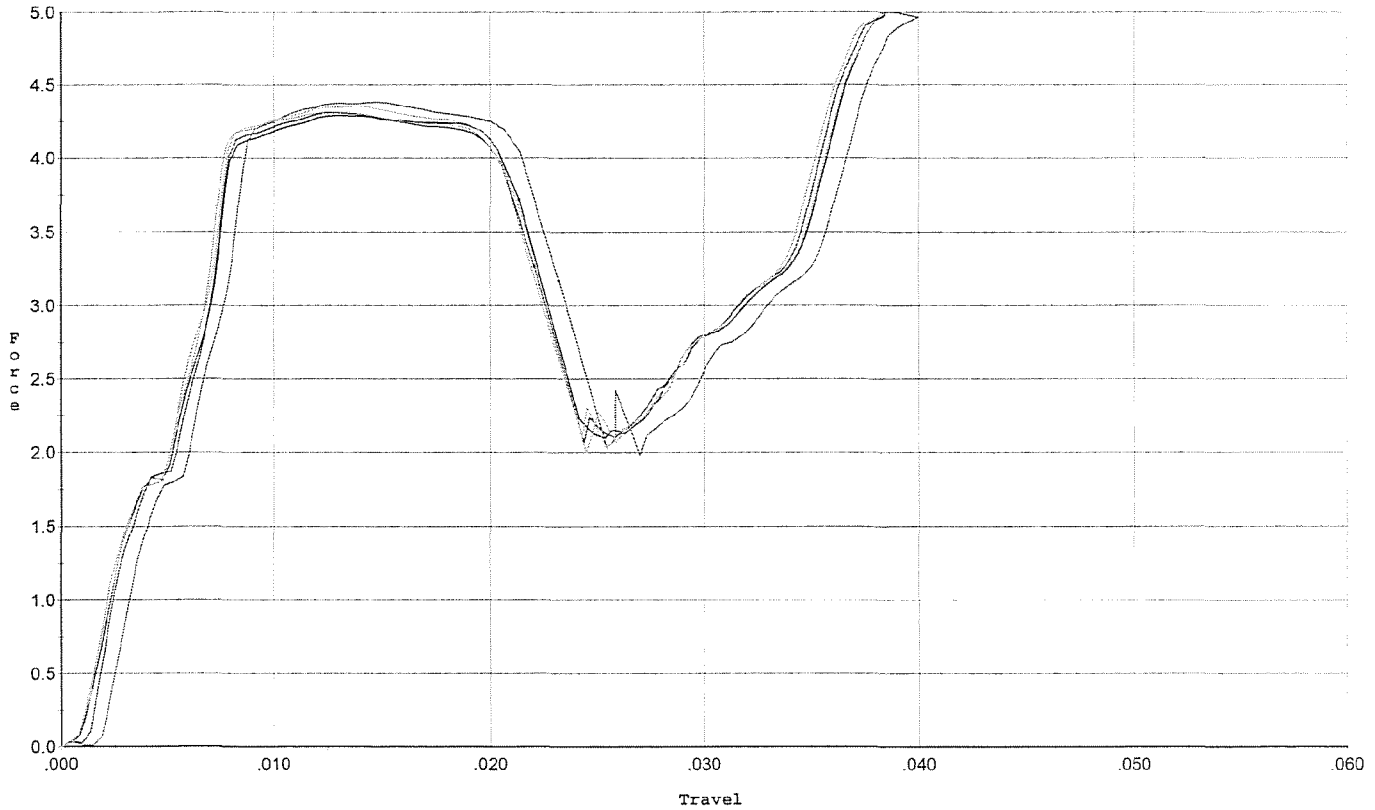
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.216	0.019	0.00	0.033	0.046		Set Trigger
2	3.164	0.021	0.00	0.033	0.048		Set Trigger
3	3.128	0.021	0.00	0.033	0.049		Set Trigger
4	3.220	0.020	0.00	0.033	0.048		Set Trigger
5	3.099	0.021	0.00	0.033	0.048		Set Trigger

A 3.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



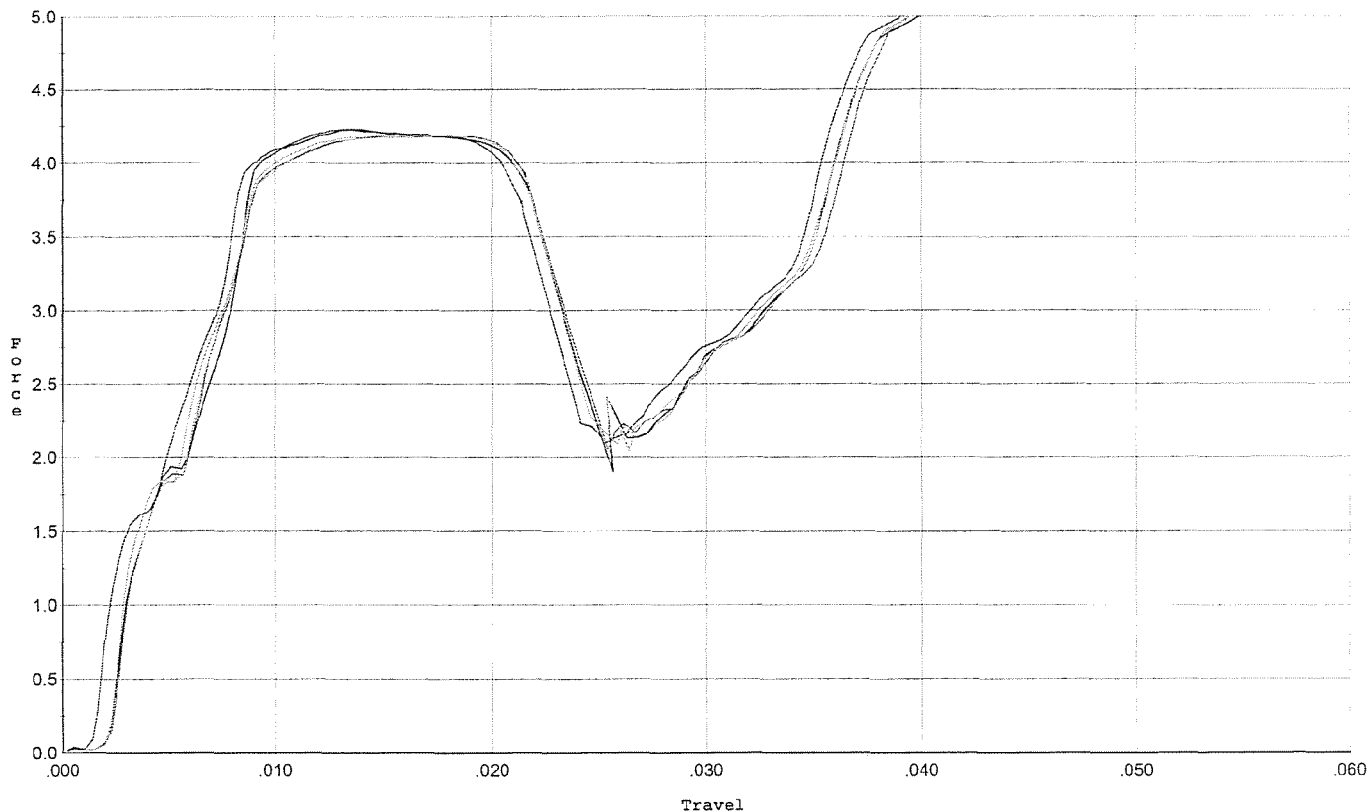
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.309	0.022	0.00	0.029	0.065		Set Trigger
2	4.289	0.021	0.00	0.029	0.064		Set Trigger
3	4.382	0.023	0.002	0.029	0.068		Set Trigger
4	4.356	0.022	0.00	0.029	0.066		Set Trigger
5	4.314	0.020	0.00	0.029	0.062		Set Trigger

A-4.33

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



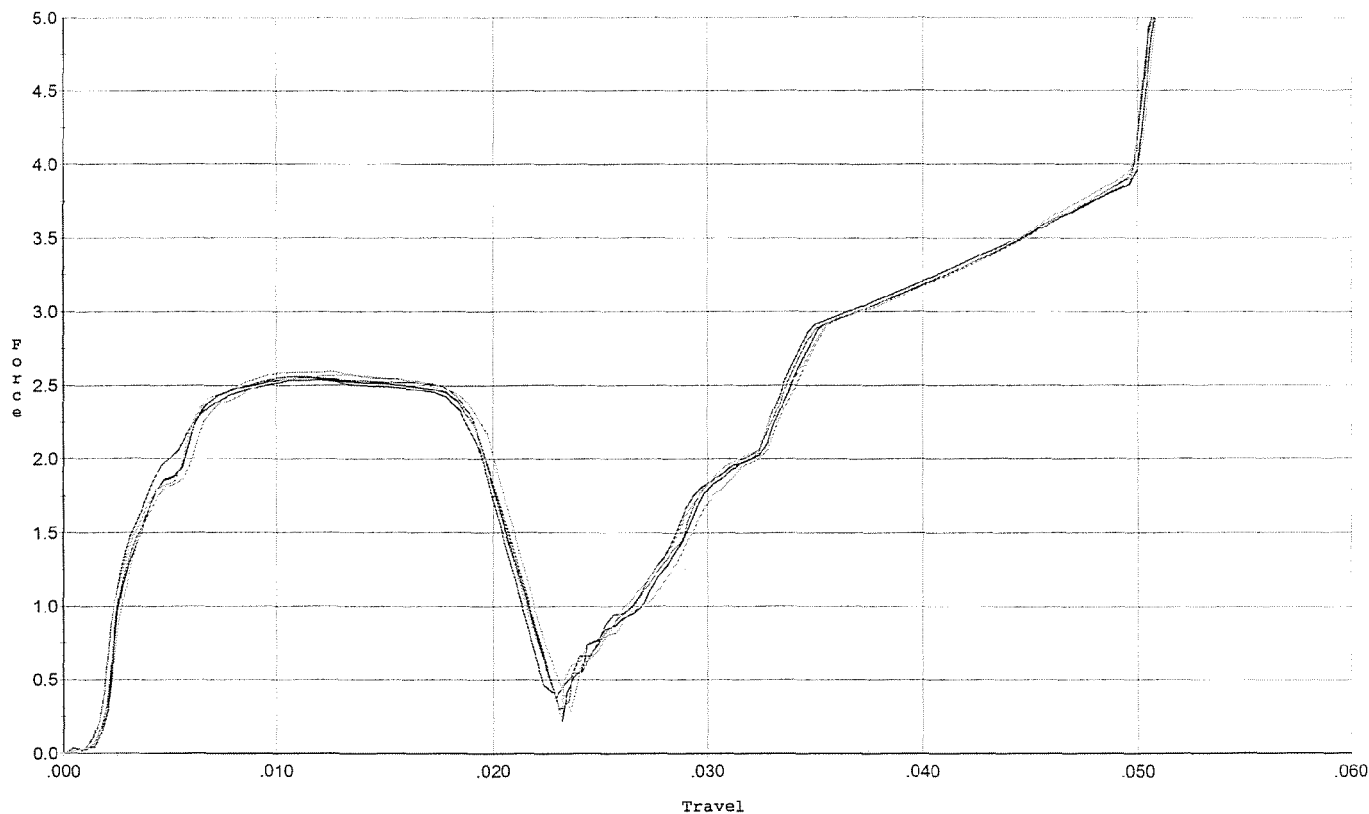
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.226	0.021	0.00	0.029	0.063		Set Trigger
2	4.222	0.022	0.00	0.029	0.062		Set Trigger
3	4.180	0.022	0.002	0.029	0.061		Set Trigger
4	4.182	0.022	0.002	0.029	0.062		Set Trigger
5	4.187	0.022	0.002	0.028	0.062		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

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



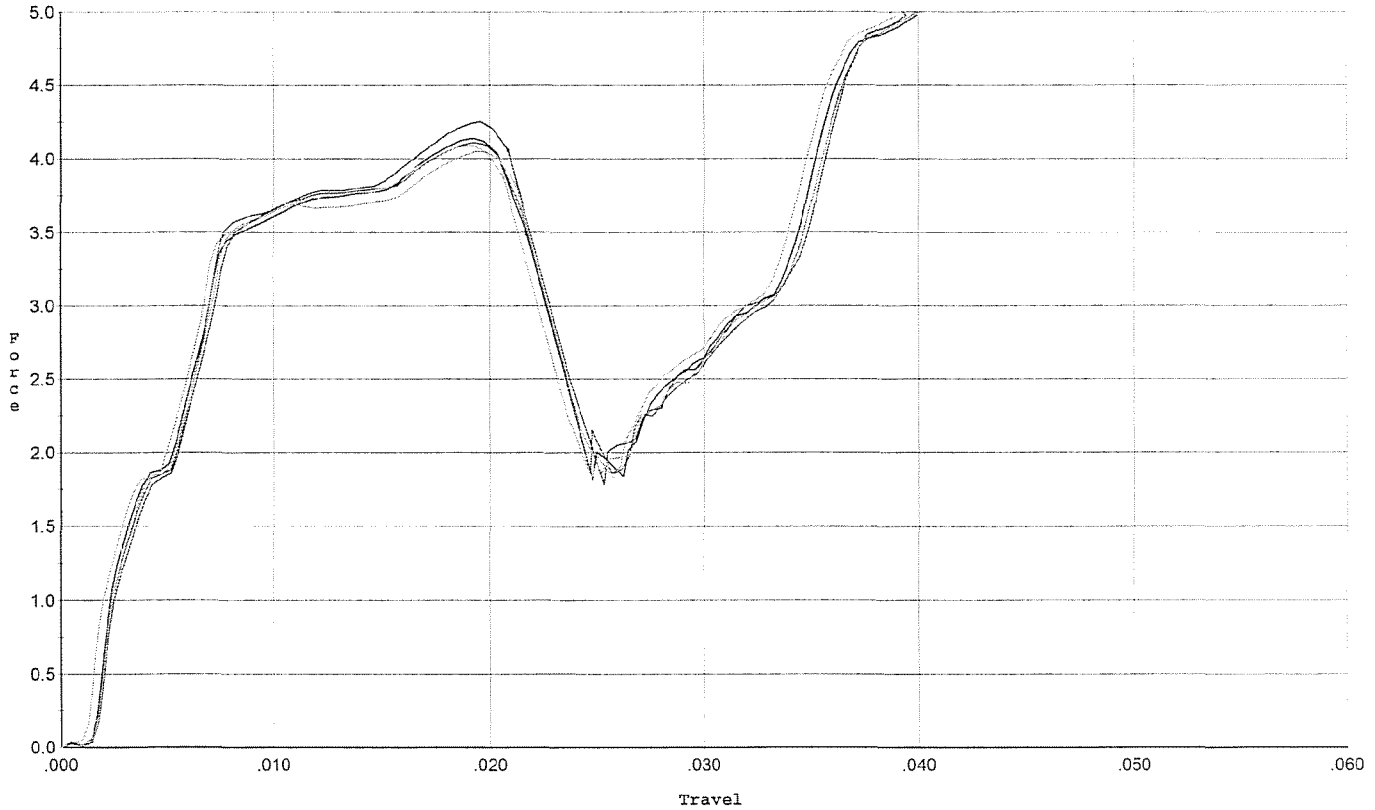
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.019	0.00	0.034	0.037		Set Trigger
2	2.550	0.021	0.00	0.034	0.040		Set Trigger
3	2.558	0.021	0.00	0.034	0.040		Set Trigger
4	2.596	0.019	0.00	0.034	0.037		Set Trigger
5	2.576	0.020	0.00	0.034	0.038		Set Trigger

A-256

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/13/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.250	0.021	0.00	0.030	0.058		Set Trigger
2	4.137	0.022	0.00	0.030	0.061		Set Trigger
3	4.109	0.021	0.00	0.030	0.060		Set Trigger
4	4.086	0.021	0.00	0.029	0.058		Set Trigger
5	4.049	0.021	0.00	0.030	0.058		Set Trigger

A-4-12