

66794765

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

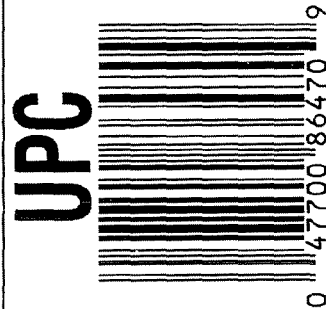


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794765



BM FORM

GUN SERIAL # G 6794765

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-4-08	SPD
430	ASSEMBLE TO STOCK		11-4-08	SP
440	PROOF		11-4-08	SPD
460	CHECK HEADSPACE		11-4-08	SPD
470	DIS-ASSEMBLE ACTION		11-4-08	SPD
472	SERIALIZE BOLT HANDLE		11-5-08	RBN
475	DRILL AND TAP SIGHT HOLES		11-5-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	11/6/08	
490	MAGNAFLUX BOLT		11/6/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/6/08	DG
542	APPLY COATINGS (BARREL ACTION)		1/20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-24-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-24-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-9-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

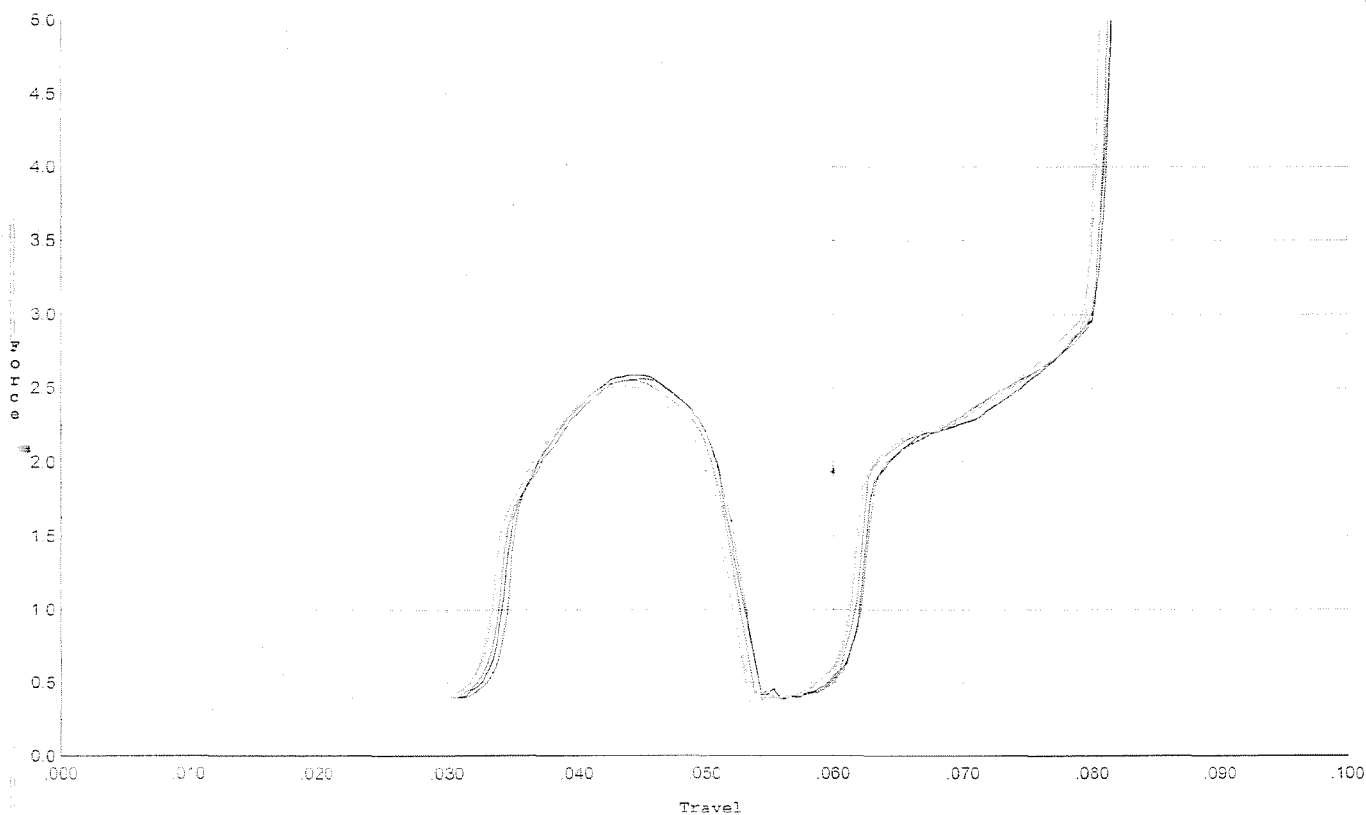
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	8-2-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	8-2-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	8-2-09	LN
	J) ASSEMBLE STOCK		1-19-09	LTZ
	K) ASSEMBLE SWIVEL STUDS		8-2-09	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	1-29-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-29-09	WN
670	FINAL INSPECTION A) HEADSPACE		2-2-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.41</u> <u>2.49</u> <u>2.49</u> <u>2.65</u> <u>2.7</u>	1-30-09	WN
	C) FUNCTION		8-2-09	LN
690	PACK		2/1/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. P. 1/14/09

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



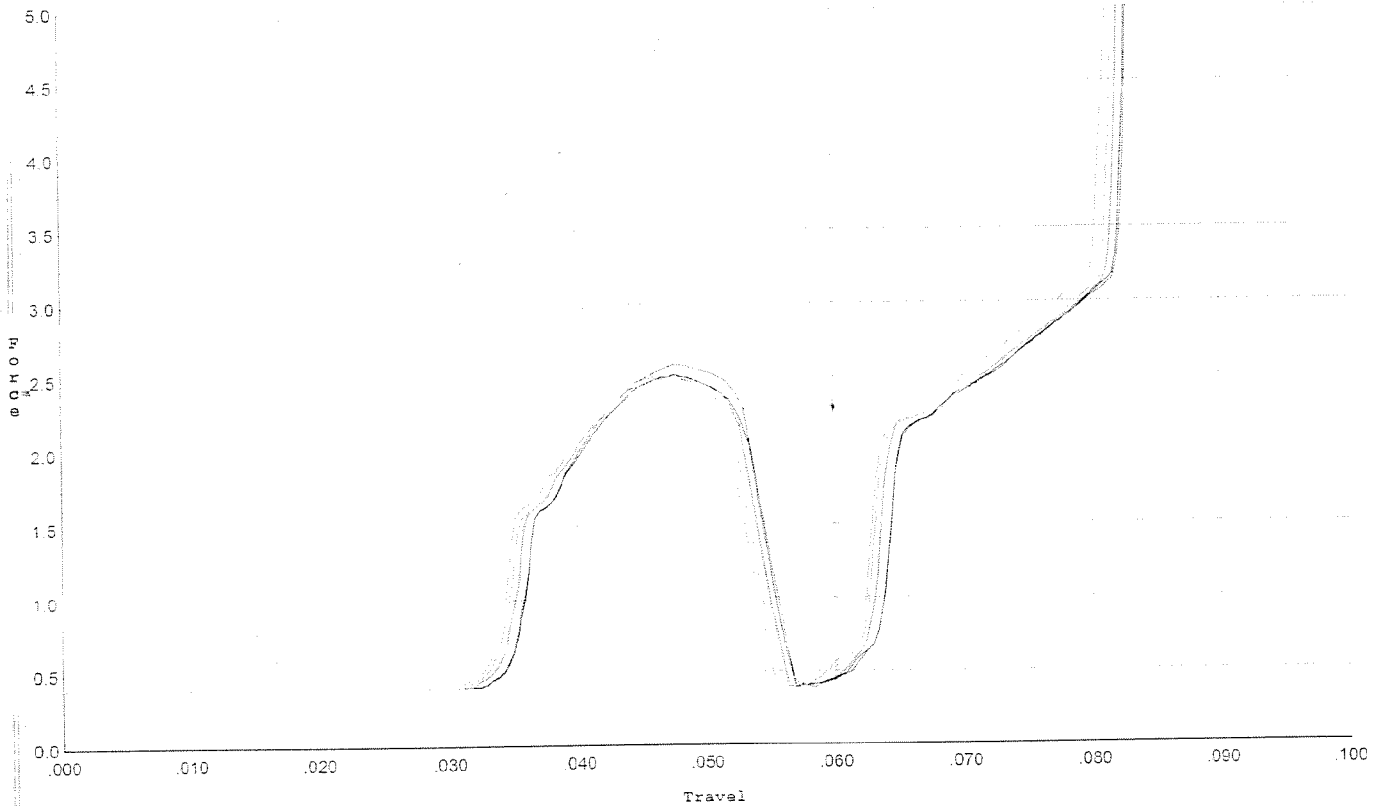
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.052	0.034	0.035	0.053		Set Trigger
2	2.587	0.051	0.033	0.035	0.053		Set Trigger
3	2.549	0.051	0.033	0.035	0.053		Set Trigger
4	2.519	0.051	0.032	0.035	0.052		Set Trigger
5	2.517	0.051	0.032	0.034	0.053		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. P. 1/14/09

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



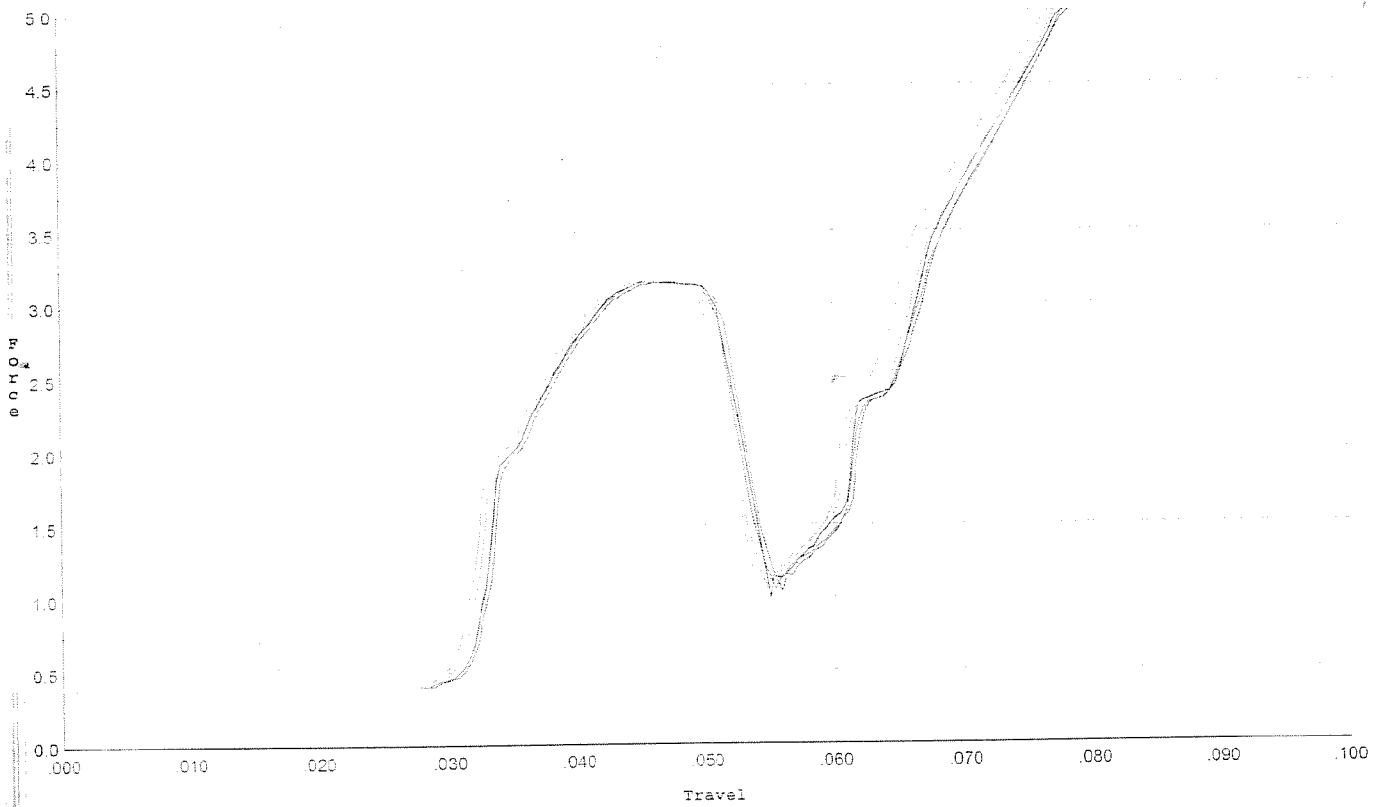
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.584	0.053	0.035	0.035	0.054		Set Trigger
2	2.518	0.053	0.035	0.035	0.054		Set Trigger
3	2.500	0.053	0.034	0.035	0.054		Set Trigger
4	2.515	0.052	0.034	0.035	0.053		Set Trigger
5	2.481	0.052	0.033	0.034	0.052		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. P. 1/14/09

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



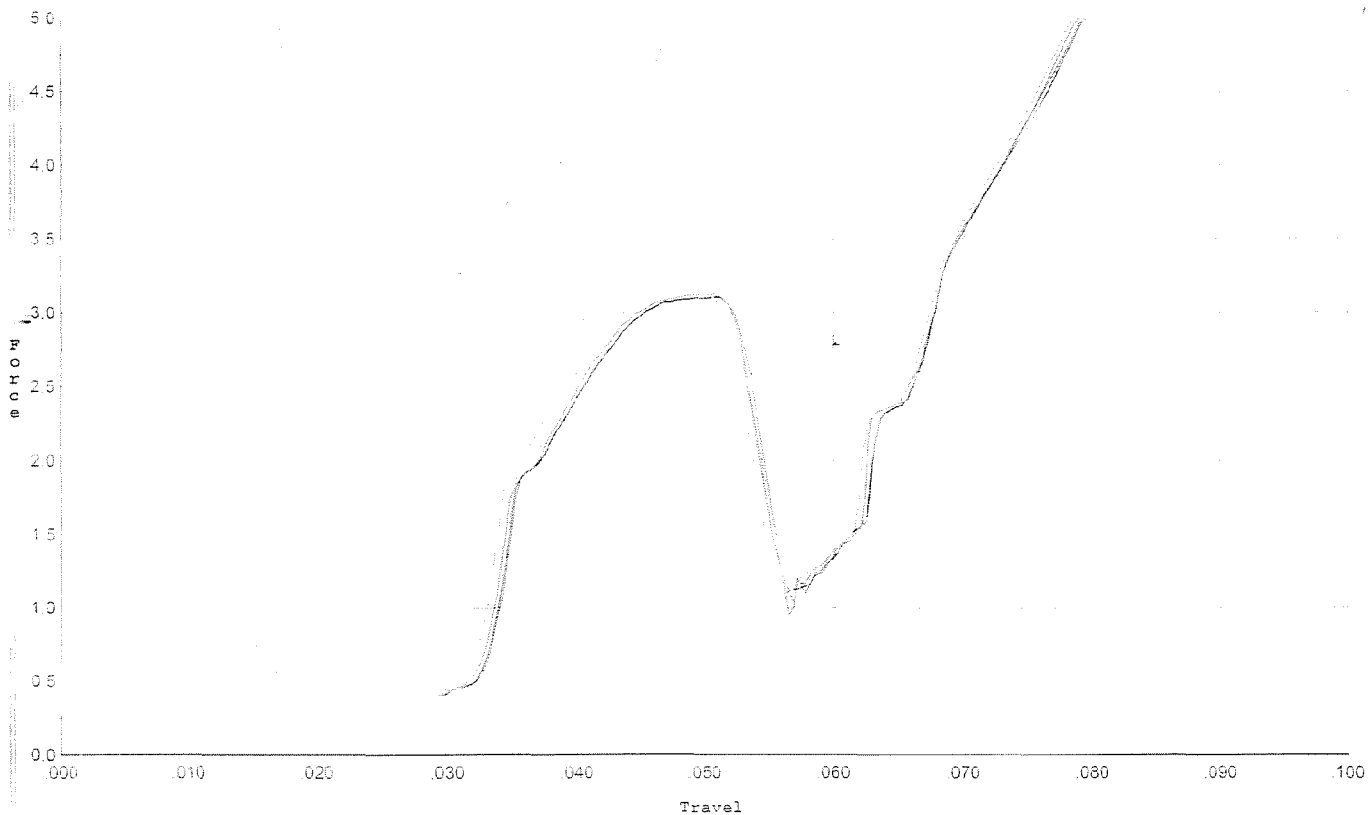
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.145	0.052	0.032	0.033	0.066		Set Trigger
2	3.155	0.053	0.032	0.032	0.068		Set Trigger
3	3.161	0.051	0.032	0.033	0.065		Set Trigger
4	3.168	0.051	0.031	0.032	0.065		Set Trigger
5	3.142	0.050	0.031	0.032	0.064		Set Trigger

Aug 3.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. P. 1/14/09

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



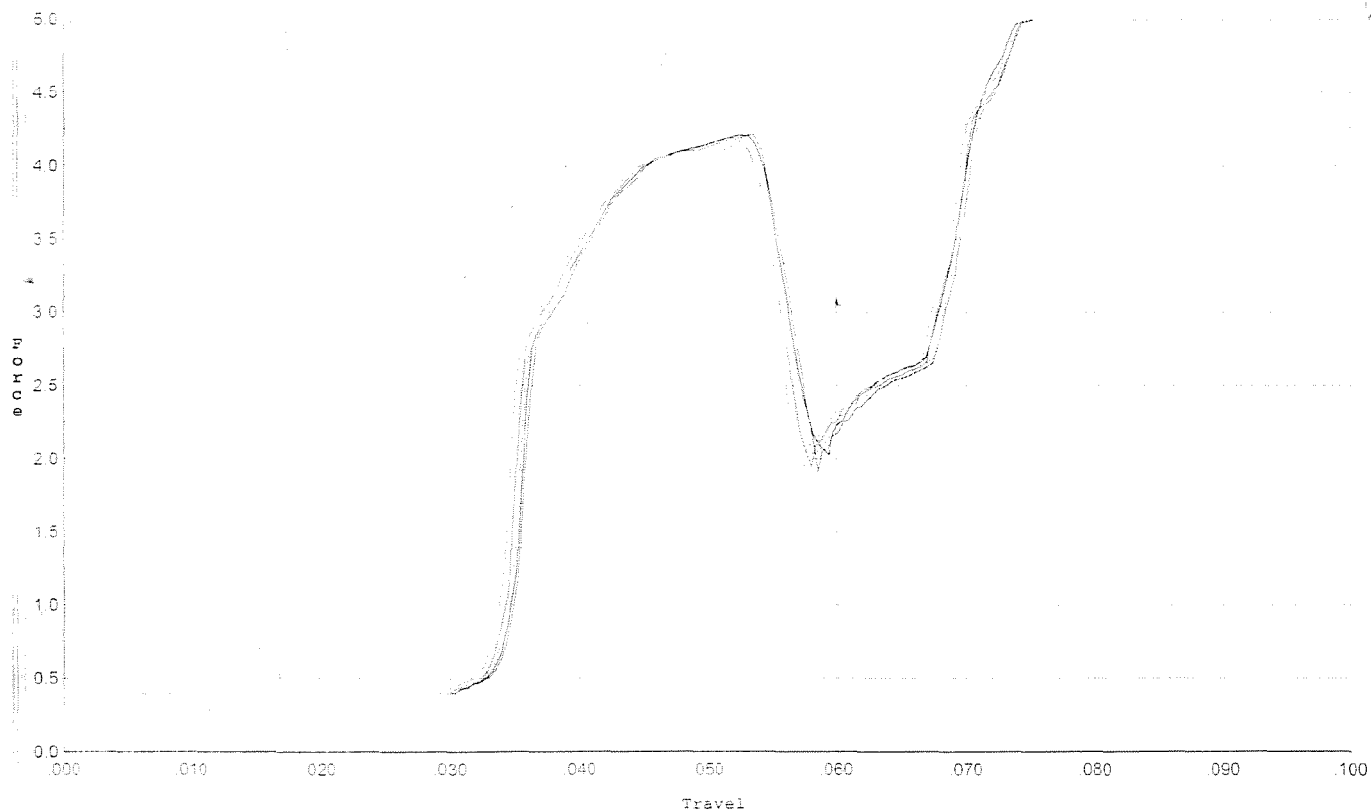
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.108	0.054	0.033	0.033	0.066		Set Trigger
2	3.104	0.053	0.033	0.033	0.065		Set Trigger
3	3.126	0.053	0.033	0.033	0.066		Set Trigger
4	3.144	0.054	0.033	0.033	0.068		Set Trigger
5	3.135	0.052	0.032	0.032	0.066		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. P. 1/14/09

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



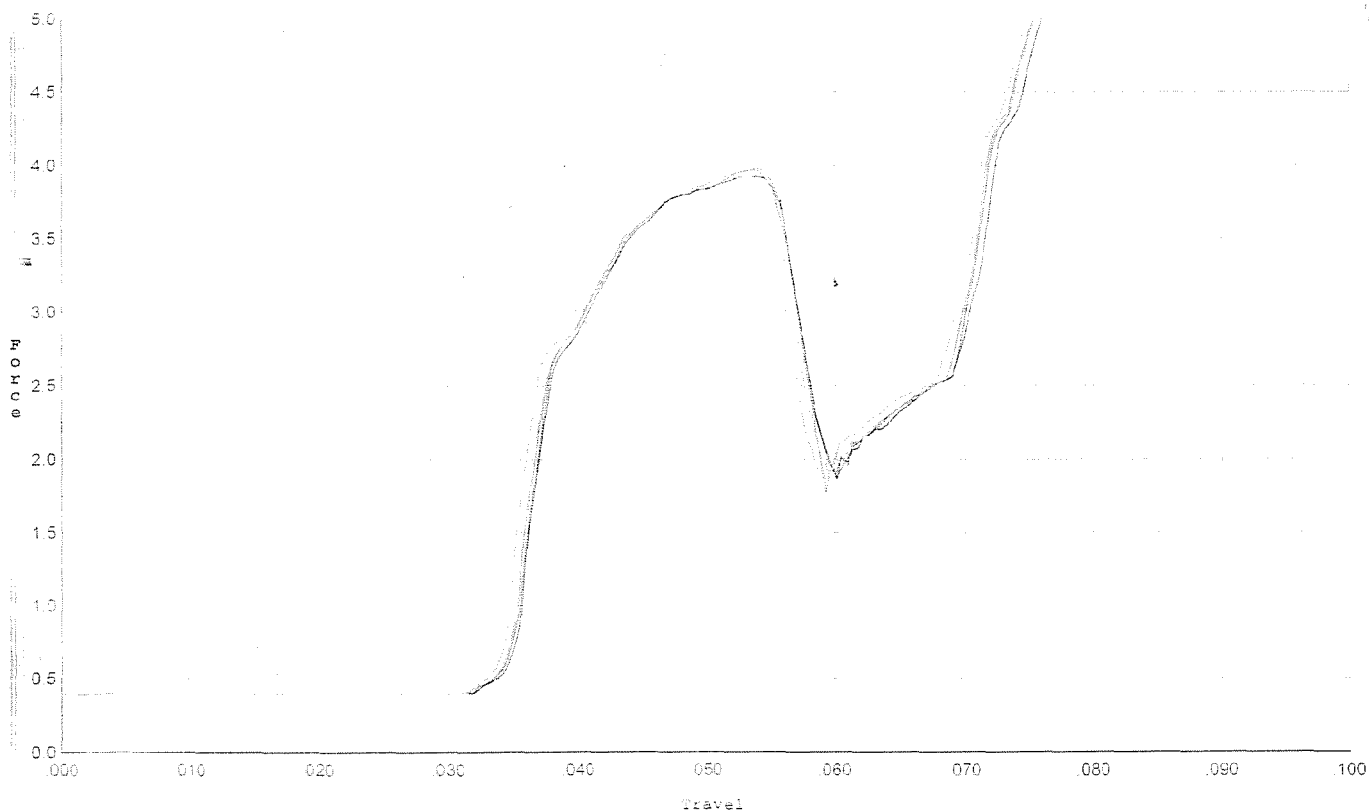
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.208	0.056	0.034	0.026	0.092		Set Trigger
2	4.206	0.054	0.034	0.027	0.090		Set Trigger
3	4.174	0.054	0.033	0.027	0.089		Set Trigger
4	4.131	0.054	0.034	0.027	0.088		Set Trigger
5	4.142	0.054	0.033	0.027	0.089		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. P. 1/14/09

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



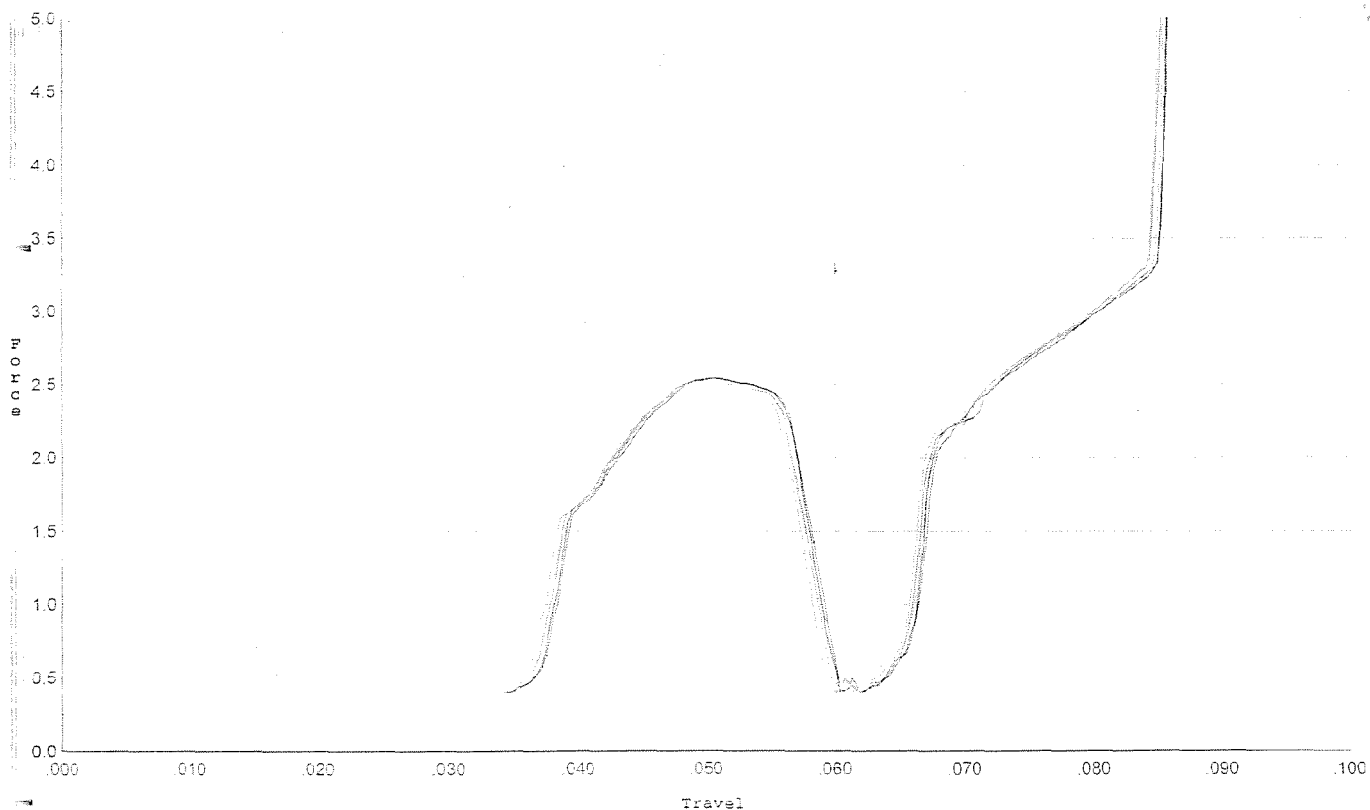
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.977	0.056	0.035	0.025	0.086		Set Trigger
2	3.924	0.056	0.035	0.025	0.085		Set Trigger
3	3.965	0.056	0.034	0.025	0.087		Set Trigger
4	3.928	0.055	0.035	0.025	0.085		Set Trigger
5	3.930	0.055	0.034	0.025	0.085		Set Trigger

Avg 3.94

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. P. 1/14/09

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



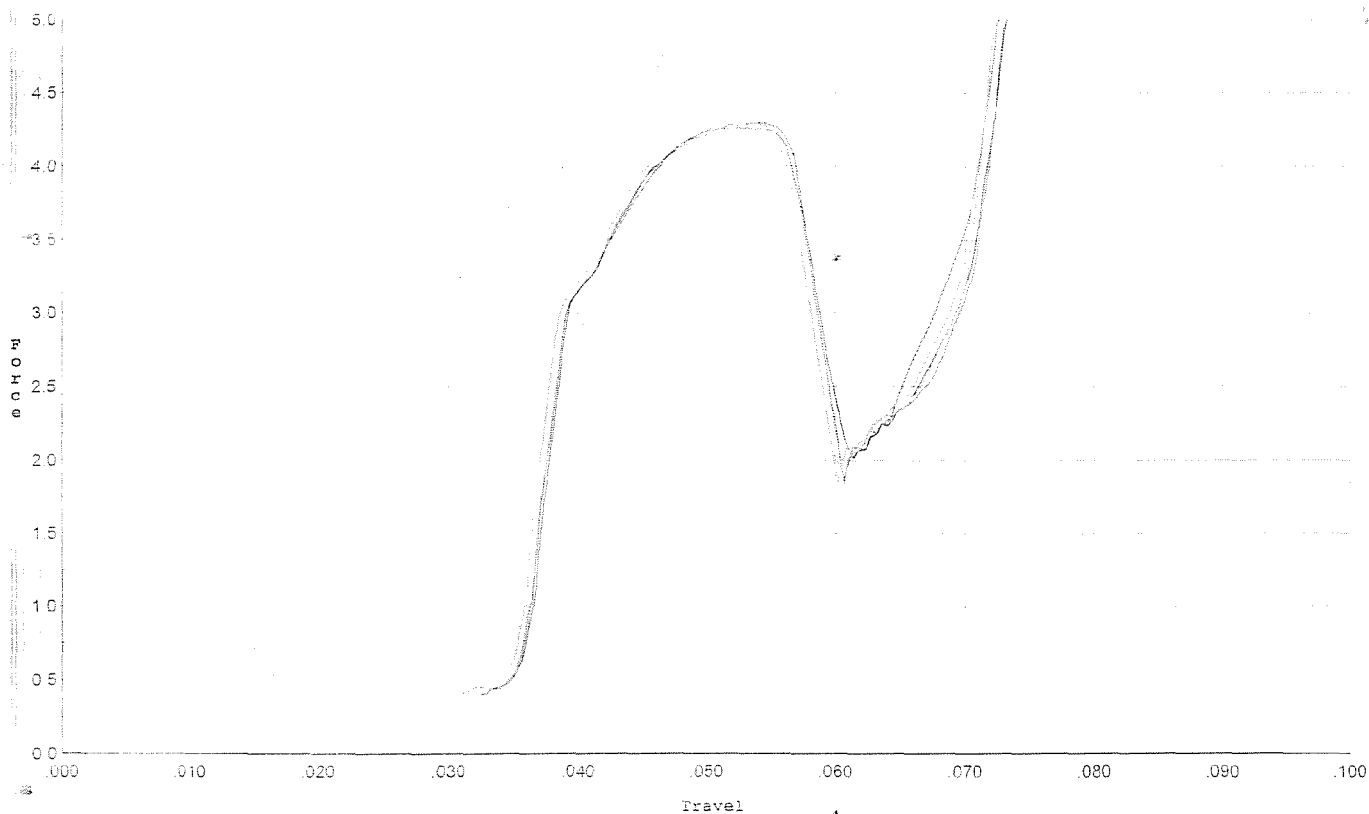
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.538	0.058	0.038	0.034	0.059		Set Trigger
2	2.544	0.057	0.037	0.034	0.058		Set Trigger
3	2.533	0.058	0.037	0.034	0.059		Set Trigger
4	2.524	0.058	0.037	0.034	0.059		Set Trigger
5	2.520	0.057	0.036	0.034	0.058		Set Trigger

Aug 253

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. P. 1/14/09

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	4.257	0.057	0.035	0.020	0.094		Set Trigger
2	4.298	0.057	0.036	0.020	0.094		Set Trigger
3	4.292	0.057	0.036	0.020	0.095		Set Trigger
4	4.281	0.057	0.035	0.020	0.095		Set Trigger
5	4.267	0.057	0.035	0.020	0.094		Set Trigger

Avg 4.27