

G 6863655

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

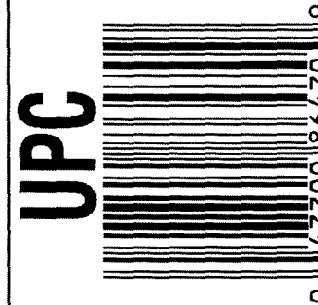


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863655



BM FORM

GUN SERIAL #

G 6863655

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SPD
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SPD
460	CHECK HEADSPACE	MAGNA FLUX	6-10-09	SPD
470	DIS-ASSEMBLE ACTION		6-10-09	SPD
472	SERIALIZE BOLT HANDLE		6-11-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	6/13/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/16/09	KTA
540	APPLY COATINGS (BARREL ACTION)		6/24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-26-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-26-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-26-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-7-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

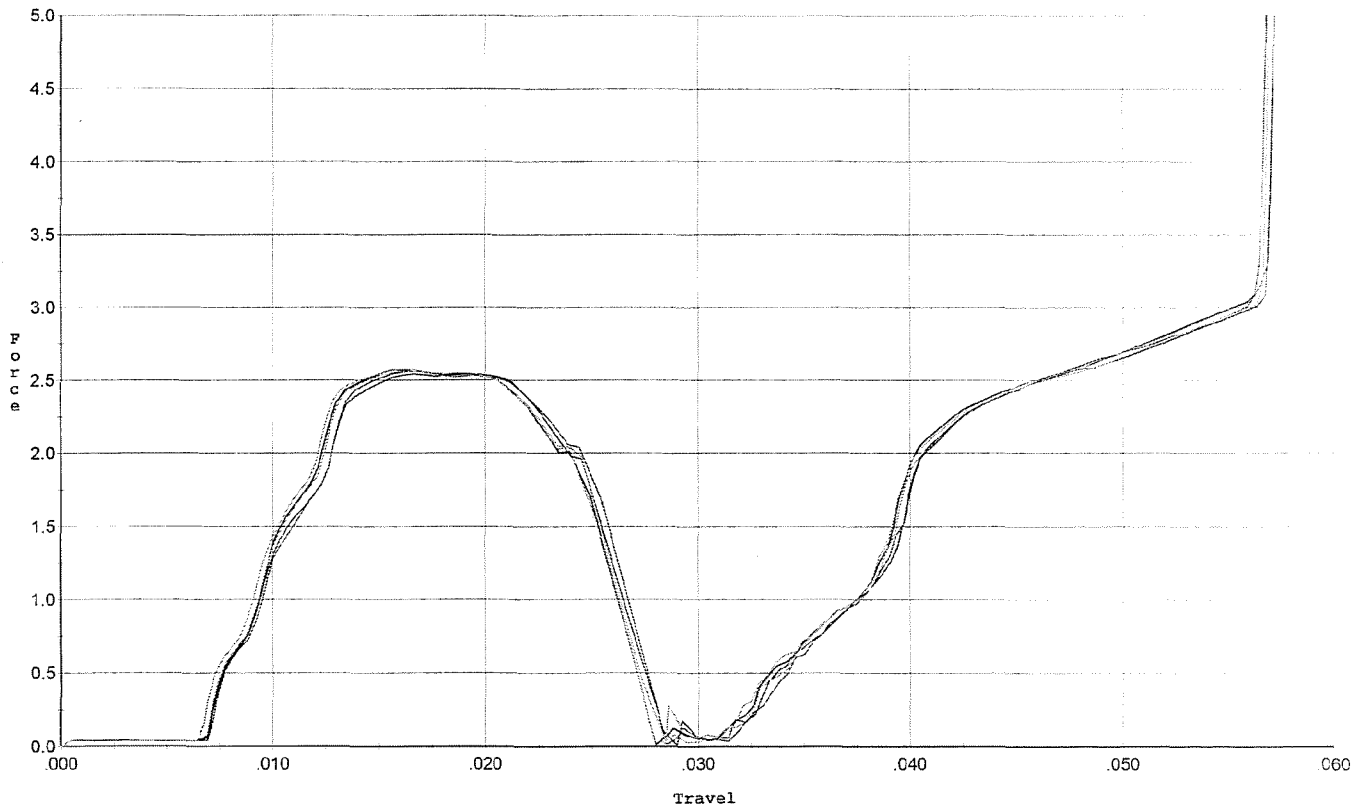
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>5.0</u>	8-15-09	XN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.0</u>	8-15-09	XN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-15-09	XN
	J) ASSEMBLE STOCK		8-7-09	L.P.R.
	K) ASSEMBLE SWIVEL STUDS		8-15-09	XN
	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	PASS FAIL PASS FAIL	8/11/09	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/11/09	TOR
670	FINAL INSPECTION A) HEADSPACE		8-15-09	XN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.52</u> <u>2.42</u> <u>2.39</u> <u>2.65</u>	8-14-09	XN
	C) FUNCTION		8-15-09	XN
690	PACK		8/17/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



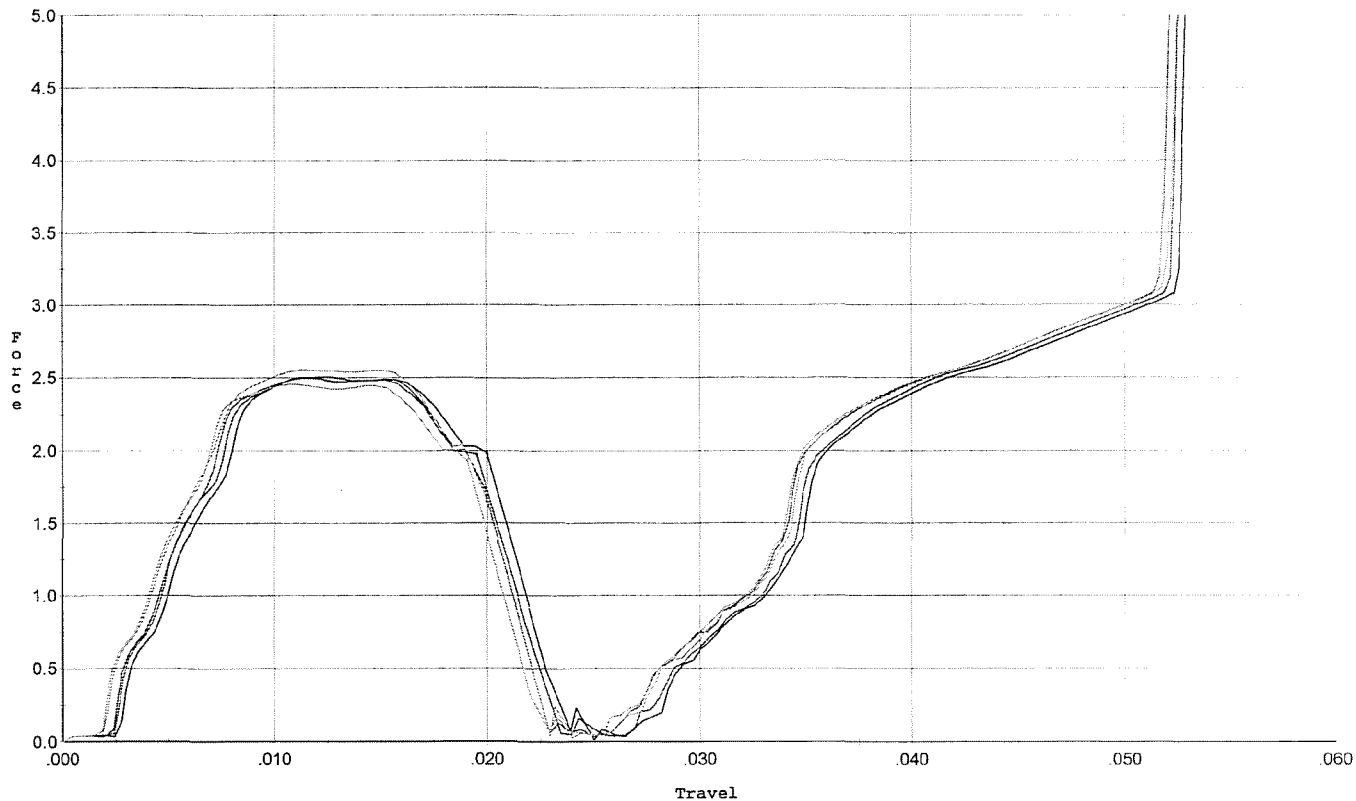
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.025	0.007	0.038	0.034		Set Trigger
2	2.570	0.025	0.007	0.037	0.035		Set Trigger
3	2.559	0.025	0.007	0.038	0.036		Set Trigger
4	2.564	0.024	0.007	0.037	0.035		Set Trigger
5	2.576	0.025	0.007	0.037	0.036		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



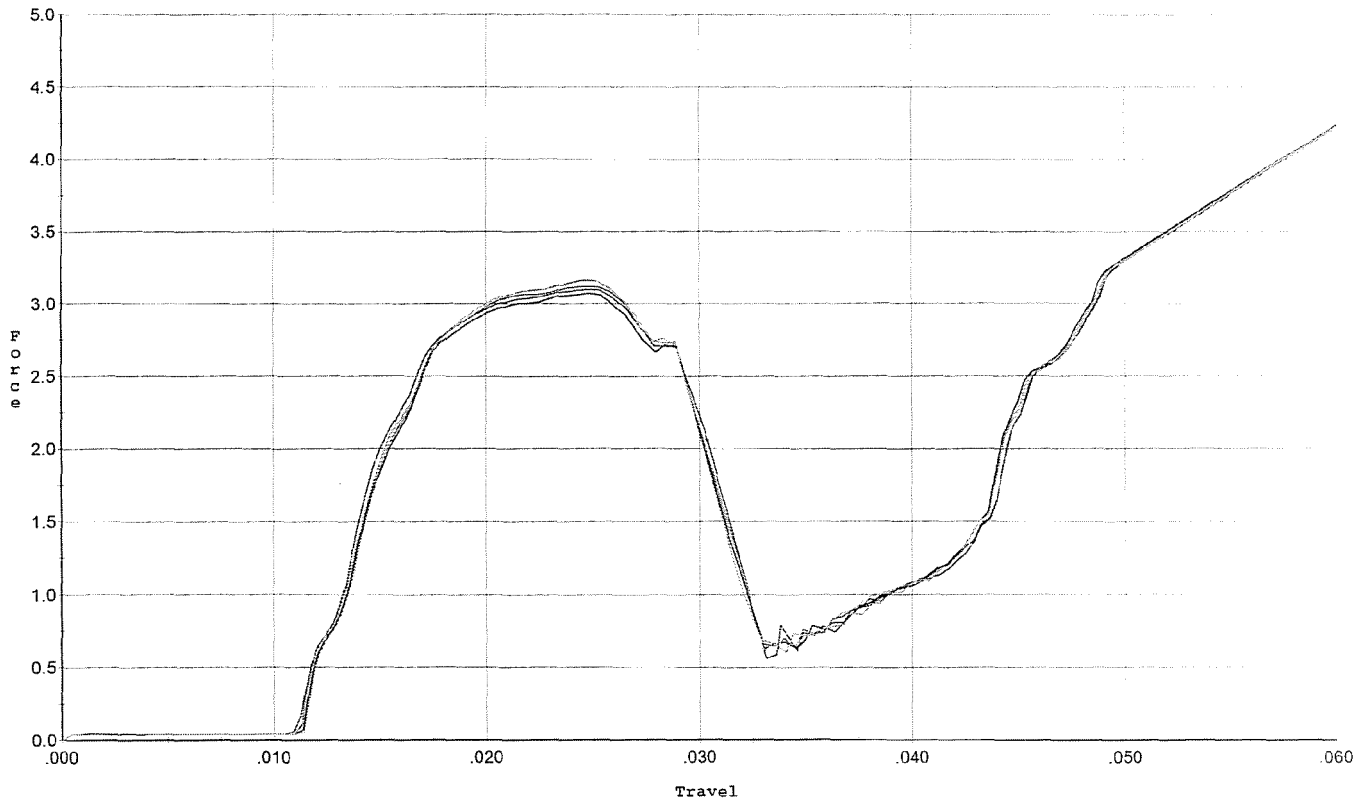
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.501	0.019	0.003	0.036	0.033		Set Trigger
2	2.504	0.020	0.003	0.036	0.033		Set Trigger
3	2.496	0.020	0.003	0.036	0.033		Set Trigger
4	2.458	0.019	0.002	0.037	0.032		Set Trigger
5	2.553	0.020	0.002	0.036	0.035		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/22/09

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



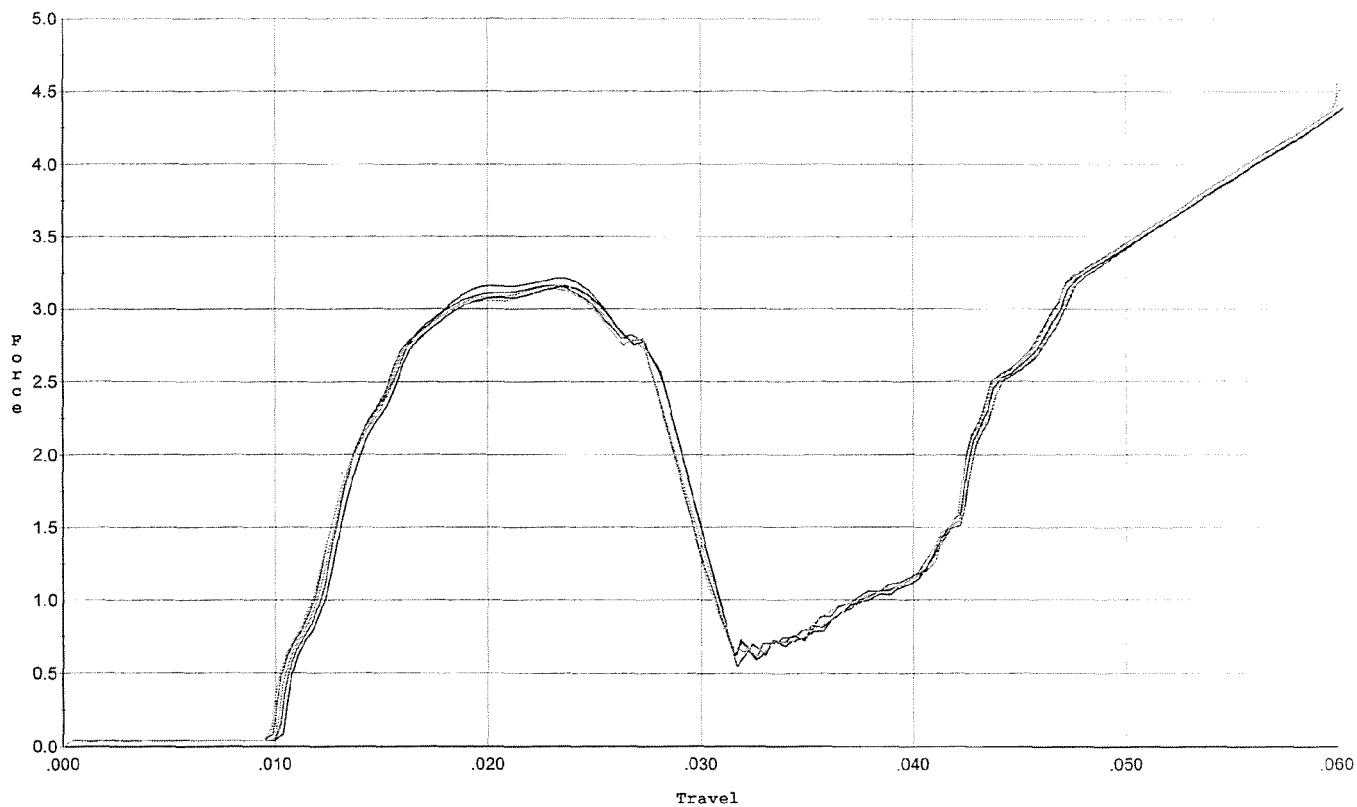
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.099	0.030	0.011	0.037	0.046		Set Trigger
2	3.072	0.029	0.012	0.037	0.043		Set Trigger
3	3.119	0.029	0.011	0.037	0.044		Set Trigger
4	3.158	0.029	0.012	0.037	0.044		Set Trigger
5	3.167	0.029	0.011	0.037	0.044		Set Trigger

Aug 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/22/09

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



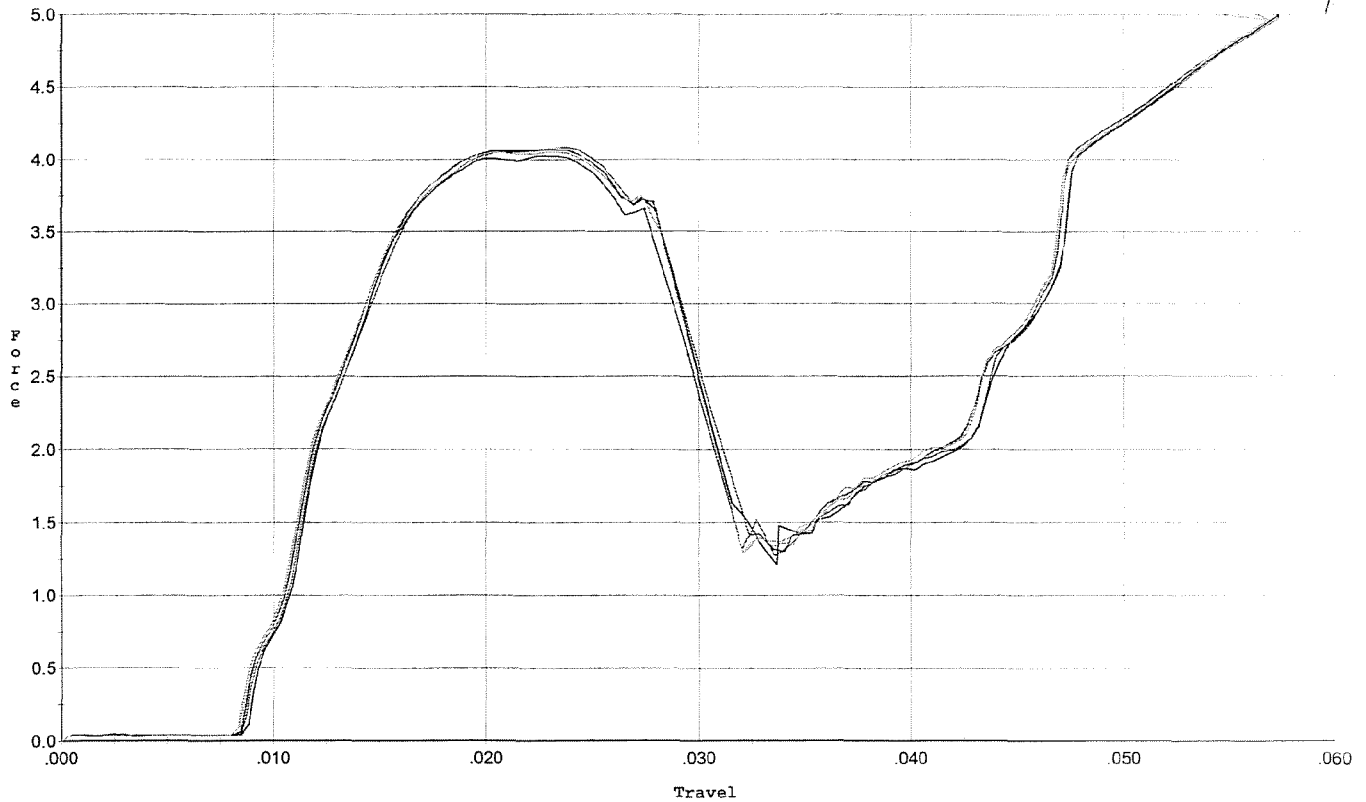
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.028	0.010	0.037	0.045		Set Trigger
2	3.153	0.028	0.011	0.037	0.044		Set Trigger
3	3.161	0.027	0.010	0.037	0.044		Set Trigger
4	3.137	0.027	0.010	0.037	0.044		Set Trigger
5	3.161	0.027	0.010	0.037	0.043		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



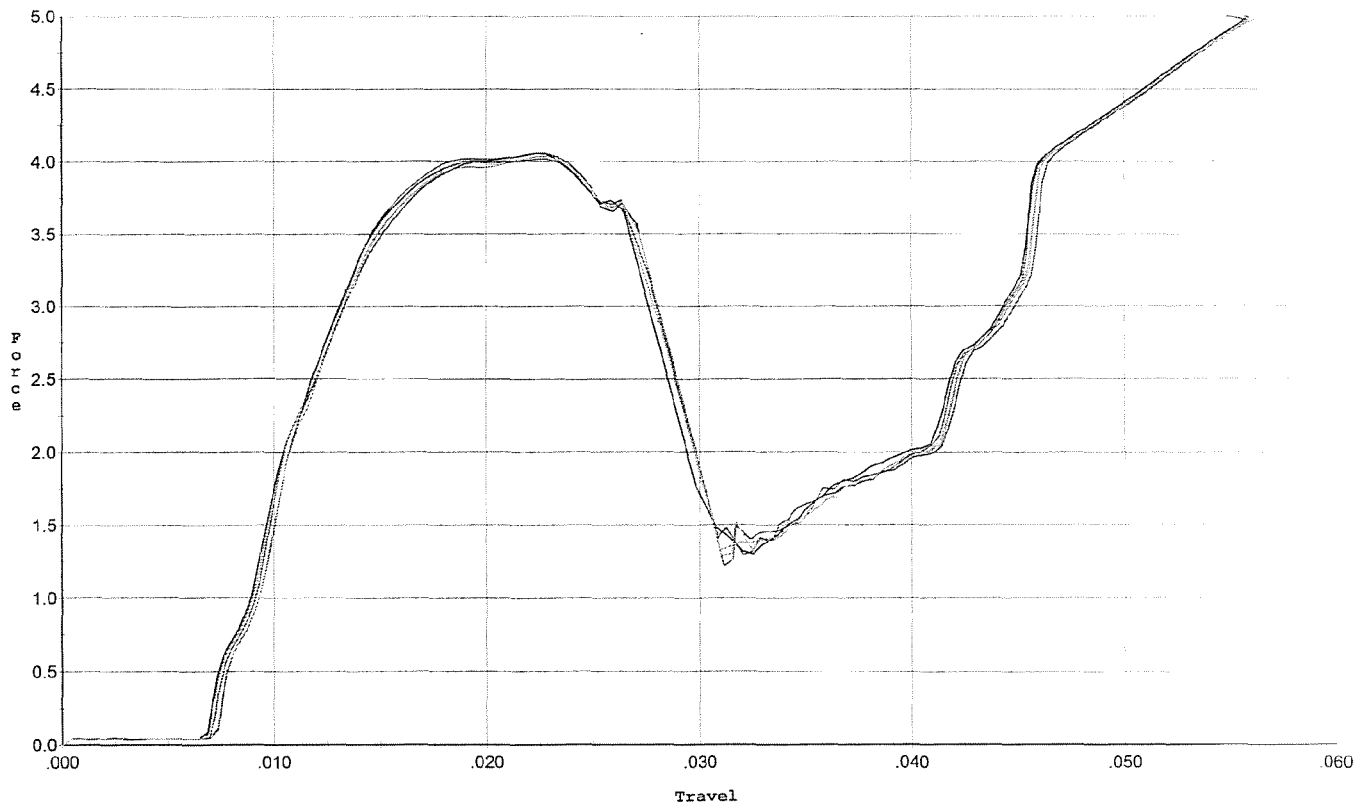
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.026	0.029	0.009	0.034	0.063		Set Trigger
2	4.072	0.028	0.009	0.034	0.061		Set Trigger
3	4.087	0.028	0.009	0.034	0.060		Set Trigger
4	4.084	0.028	0.008	0.034	0.062		Set Trigger
5	4.054	0.028	0.009	0.034	0.061		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



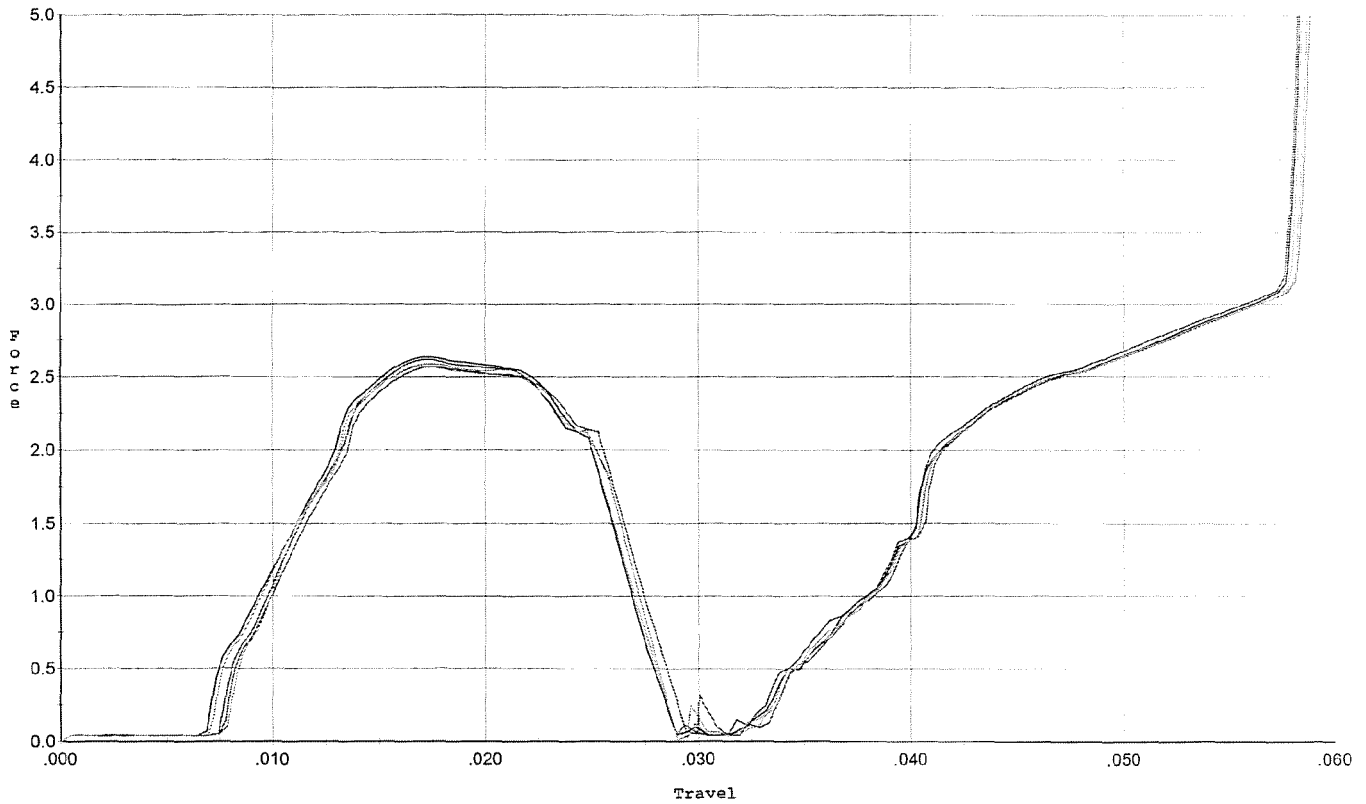
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.027	0.007	0.034	0.061		Set Trigger
2	4.057	0.026	0.007	0.034	0.060		Set Trigger
3	4.058	0.028	0.007	0.034	0.063		Set Trigger
4	4.033	0.027	0.007	0.034	0.061		Set Trigger
5	4.039	0.028	0.007	0.034	0.063		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



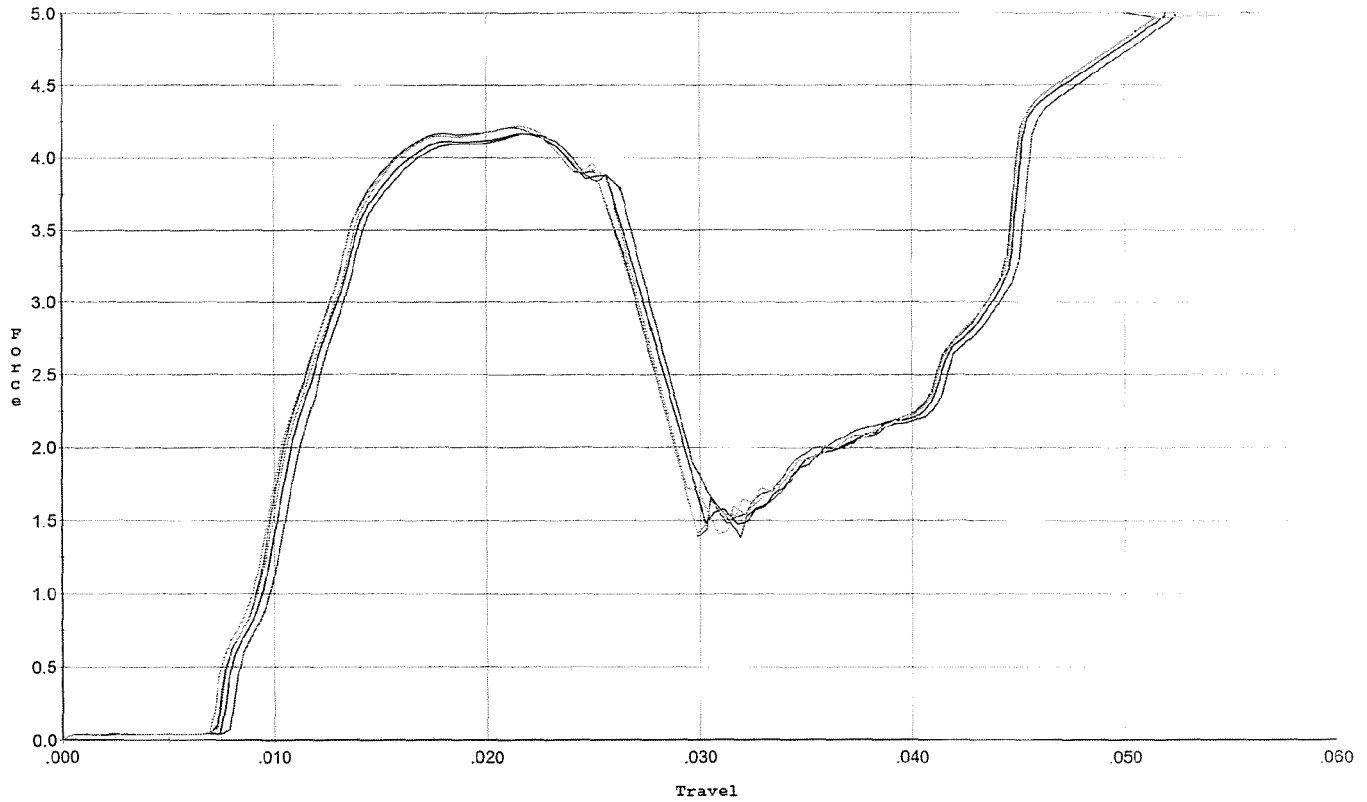
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.026	0.008	0.038	0.036		Set Trigger
2	2.633	0.025	0.007	0.038	0.036		Set Trigger
3	2.566	0.025	0.008	0.038	0.035		Set Trigger
4	2.570	0.025	0.007	0.038	0.035		Set Trigger
5	2.586	0.026	0.008	0.038	0.036		Set Trigger

Aug 2.58

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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	4.165	0.026	0.008	0.033	0.059		Set Trigger
2	4.169	0.028	0.008	0.033	0.063		Set Trigger
3	4.207	0.027	0.007	0.033	0.061		Set Trigger
4	4.211	0.027	0.007	0.033	0.062		Set Trigger
5	4.218	0.026	0.007	0.033	0.059		Set Trigger

Avg 4.19