

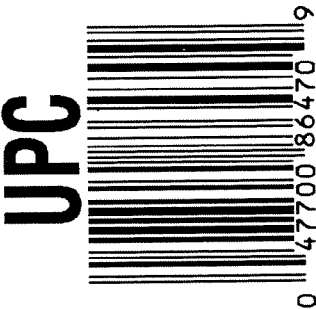
G676 5844

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

G6765044



BM FORM

GUN SERIAL # G6765044

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-18-08	R.P.D.
430	ASSEMBLE TO STOCK		6-18-08	SP
440	PROOF		6-18-08	SD
460	CHECK HEADSPACE		6-18-08	SD
470	DIS-ASSEMBLE ACTION	MAGNA - FLUX	6-18-08	R.P.D.
472	SERIALIZE BOLT HANDLE		6-20-08	R.P.D.
475	DRILL AND TAP SIGHT HOLES	TOP 27 2006 OPERATOR WMS	6-23-08	SD
480	MAGNAFLUX BBL ACTION		6-24-08	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-24-08	RT
520	GOFF BLAST BBL / REC		6-24	RT
542	APPLY COATINGS (BARREL ACTION)		28	CM
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-9	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-9	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-9	SP
	D) OIL FIRING PIN ASSEMBLY		7-15-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

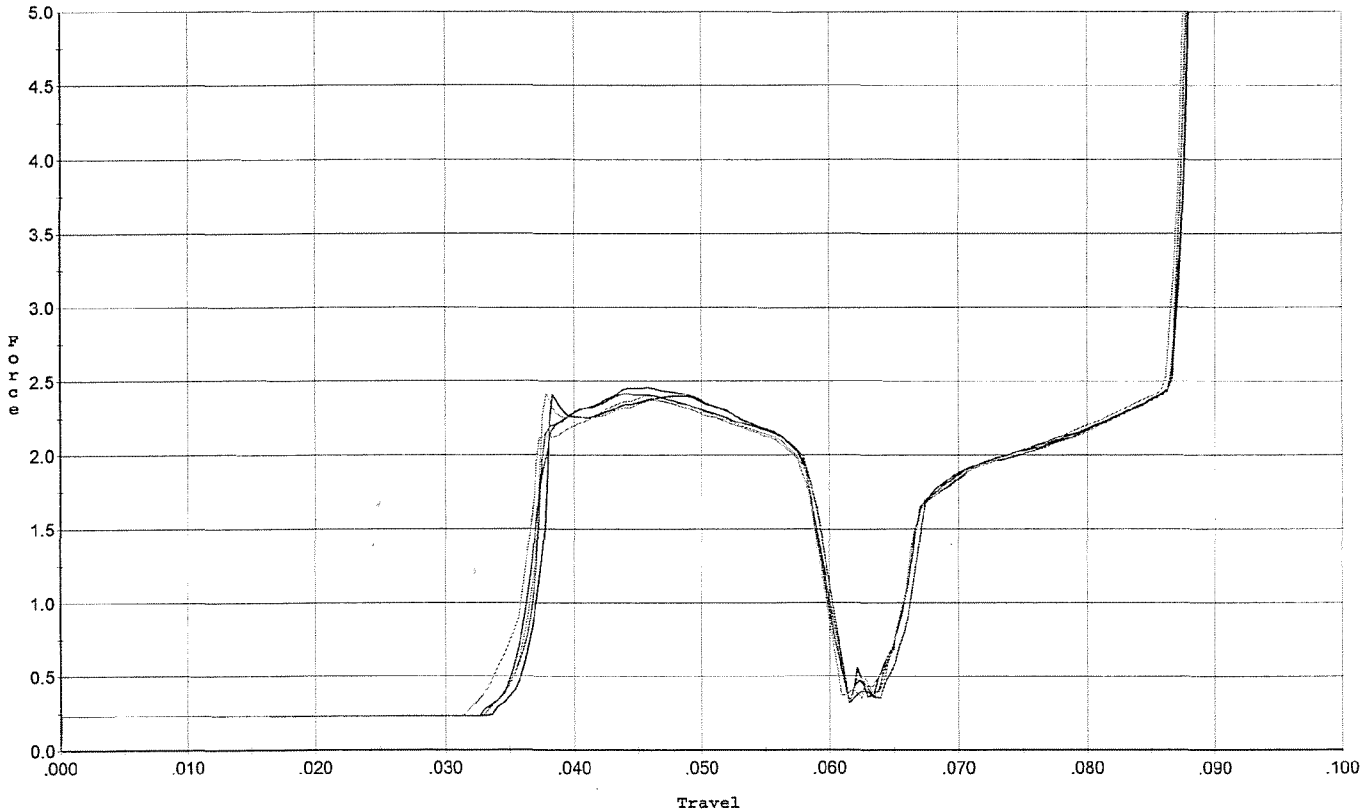
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9</u> <u>8</u> <u>8</u>	<u>7-22</u>	<u>TC</u>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6</u> <u>6</u> <u>6</u>	<u>7-22</u>	<u>TC</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	<u>7-22</u>	<u>TC</u>
	J) ASSEMBLE STOCK		<u>7-15-08</u>	<u>ESN</u>
	K) ASSEMBLE SWIVEL STUDS		<u>7-30-08</u>	<u>LR</u>
	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	<u>7-16-08</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>7/16/08</u>	<u>RMES</u>
670	FINAL INSPECTION A) HEADSPACE		<u>7-30-08</u>	<u>RTZ</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.59</u> <u>2.38</u> <u>2.64</u> <u>2.58</u>	<u>7/22/08</u>	<u>Fm</u>
	C) FUNCTION		<u>7-30-08</u>	<u>LR</u>
690	PACK		<u>7/30/08</u>	<u>Fm</u>

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



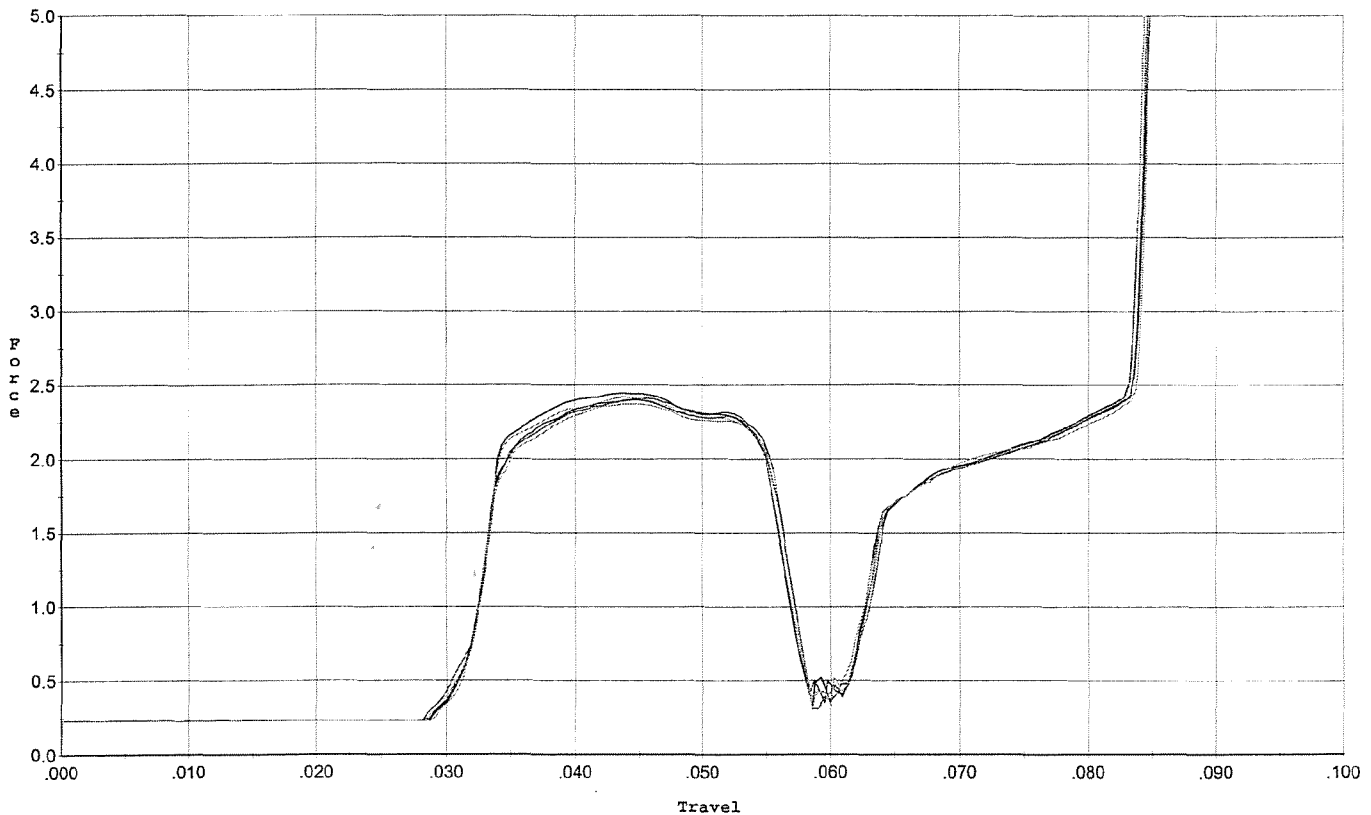
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.058	0.035	0.036	0.058		Set Trigger
2	2.409	0.058	0.036	0.036	0.057		Set Trigger
3	2.459	0.059	0.035	0.036	0.060		Set Trigger
4	2.396	0.058	0.033	0.035	0.059		Set Trigger
5	2.421	0.058	0.035	0.036	0.058		Set Trigger

Avg 2.42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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



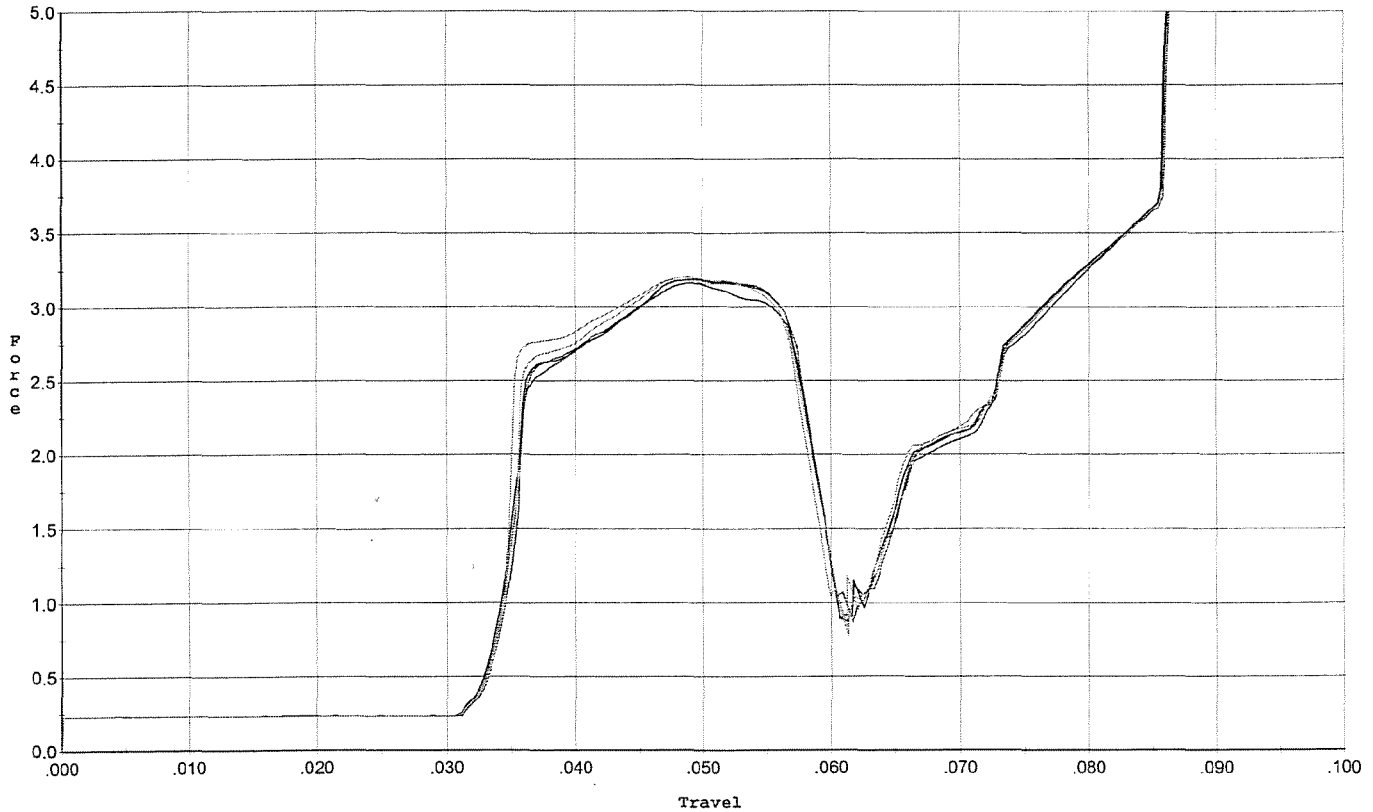
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.412	0.056	0.029	0.033	0.060		Set Trigger
2	2.445	0.055	0.031	0.034	0.060		Set Trigger
3	2.400	0.056	0.030	0.033	0.060		Set Trigger
4	2.372	0.056	0.030	0.034	0.059		Set Trigger
5	2.420	0.055	0.031	0.033	0.059		Set Trigger

Avg 2.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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



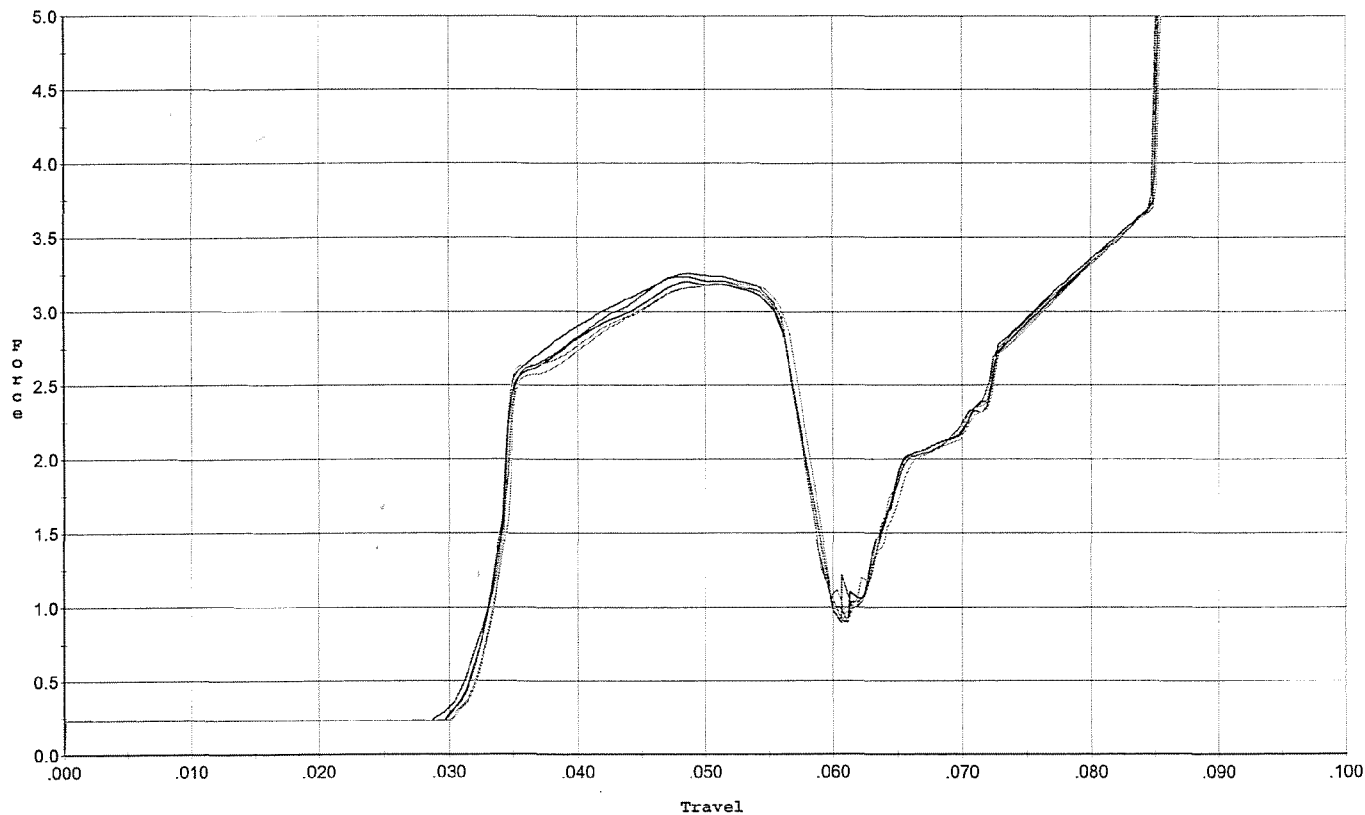
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.058	0.033	0.034	0.075		Set Trigger
2	3.185	0.058	0.032	0.033	0.076		Set Trigger
3	3.188	0.057	0.033	0.034	0.075		Set Trigger
4	3.203	0.058	0.033	0.034	0.077		Set Trigger
5	3.185	0.057	0.033	0.034	0.076		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/14/08

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



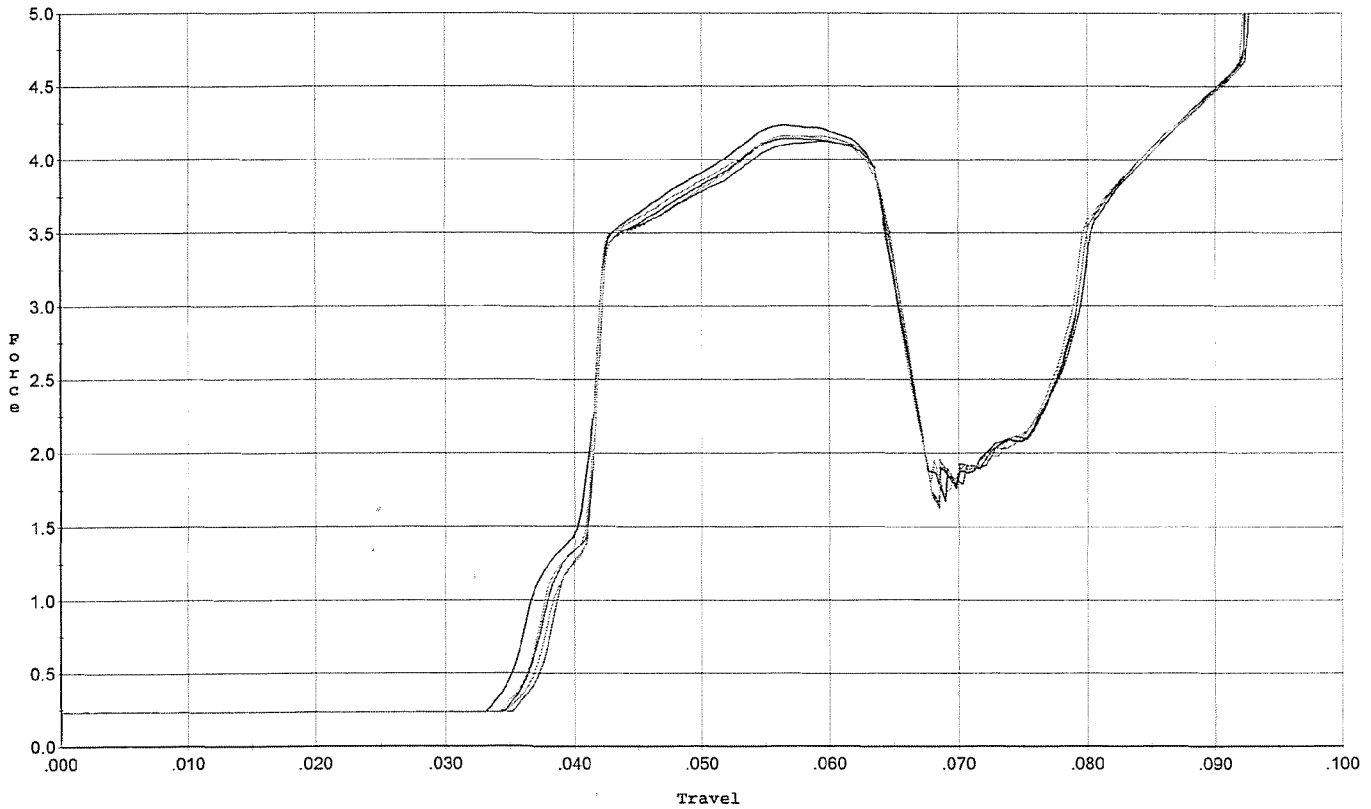
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.233	0.056	0.031	0.033	0.077		Set Trigger
2	3.201	0.056	0.031	0.033	0.076		Set Trigger
3	3.254	0.056	0.031	0.033	0.076		Set Trigger
4	3.190	0.057	0.032	0.033	0.076		Set Trigger
5	3.191	0.056	0.032	0.033	0.075		Set Trigger

Avg 3.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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



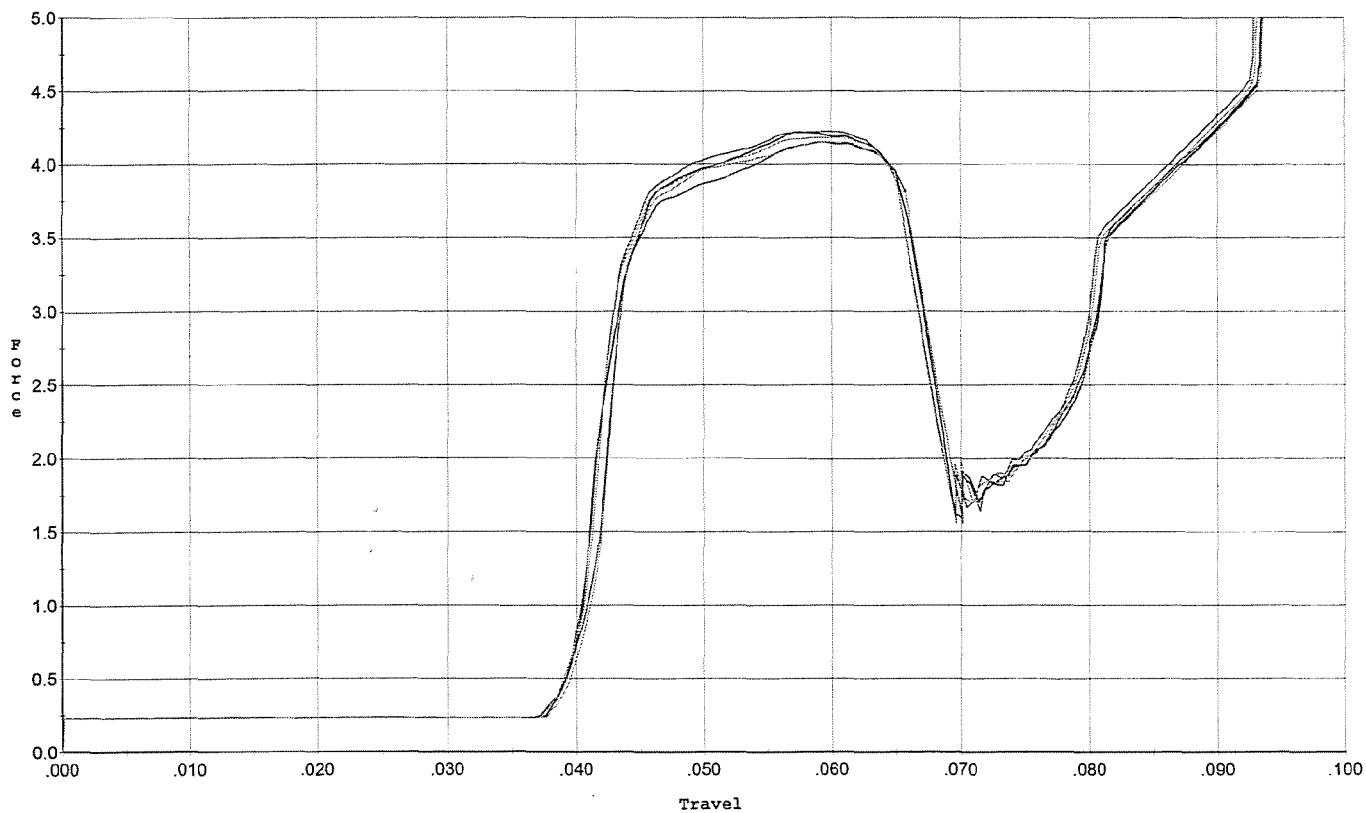
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.142	0.065	0.036	0.032	0.106		Set Trigger
2	4.235	0.063	0.035	0.032	0.106		Set Trigger
3	4.123	0.065	0.037	0.032	0.104		Set Trigger
4	4.161	0.065	0.036	0.032	0.105		Set Trigger
5	4.161	0.064	0.037	0.032	0.103		Set Trigger

Avg. 4.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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



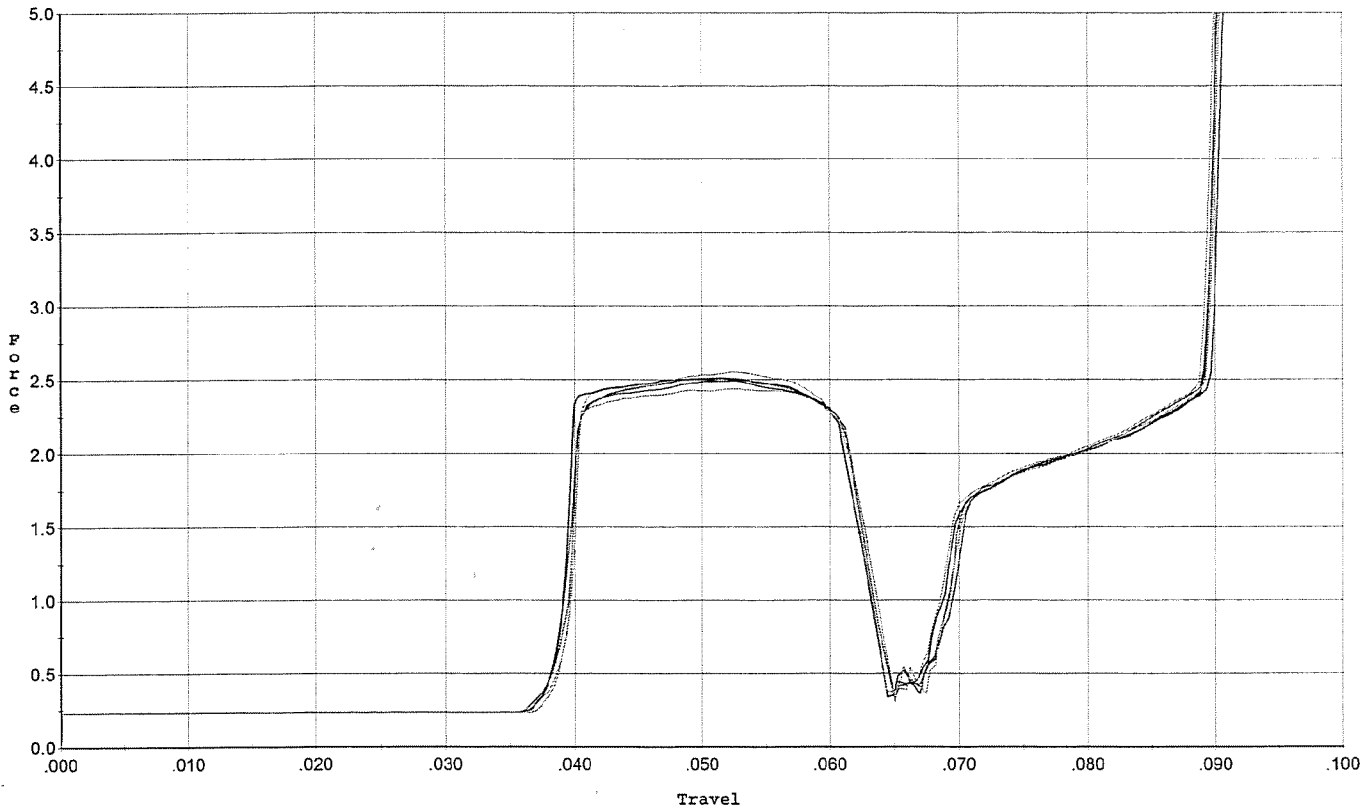
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.066	0.038	0.031	0.105		Set Trigger
2	4.221	0.066	0.039	0.031	0.109		Set Trigger
3	4.220	0.065	0.038	0.031	0.107		Set Trigger
4	4.182	0.065	0.038	0.032	0.106		Set Trigger
5	4.150	0.066	0.039	0.032	0.106		Set Trigger

AVG 4.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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



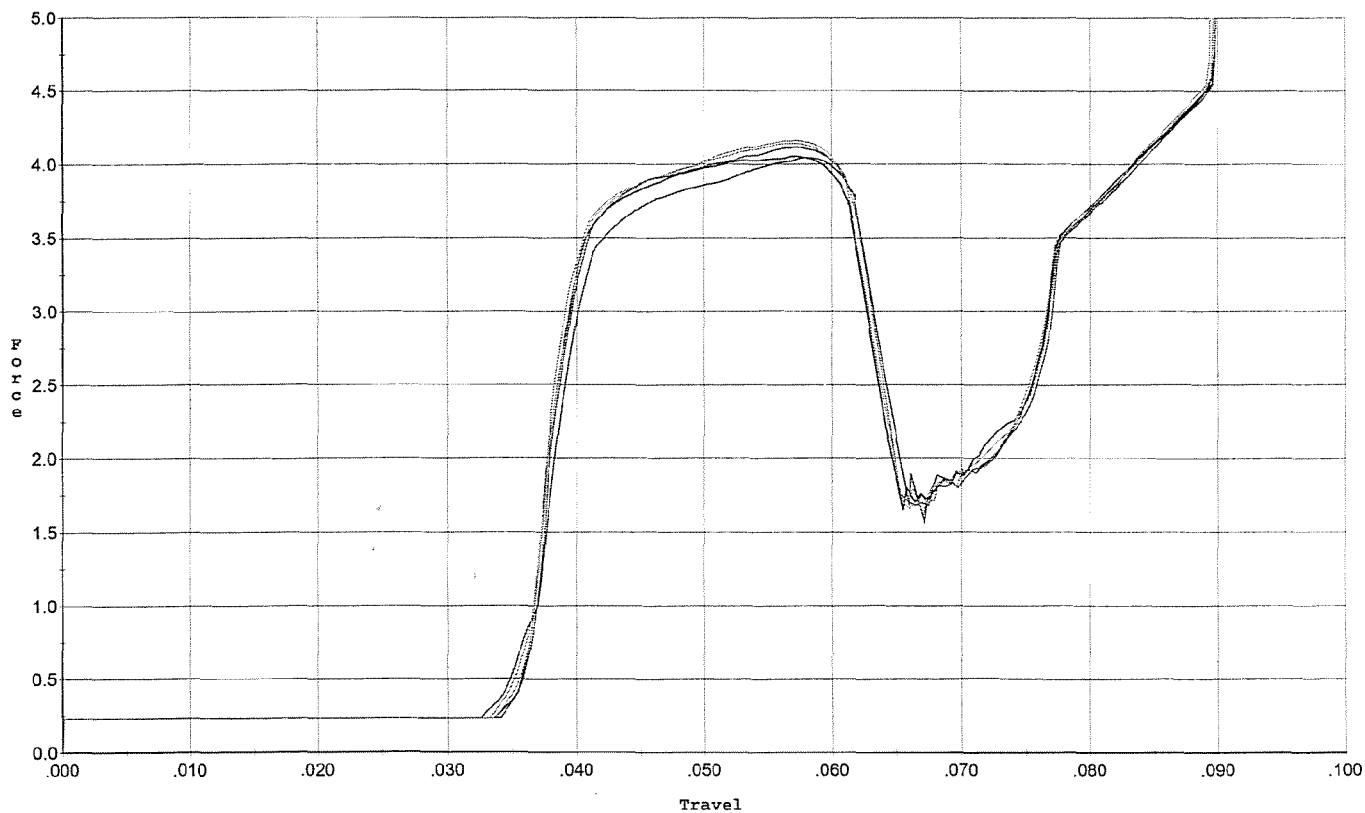
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.504	0.063	0.038	0.035	0.065		Set Trigger
2	2.508	0.062	0.038	0.035	0.065		Set Trigger
3	2.496	0.061	0.038	0.035	0.063		Set Trigger
4	2.440	0.063	0.038	0.035	0.063		Set Trigger
5	2.552	0.061	0.038	0.035	0.063		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/14/08

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	4.043	0.062	0.034	0.032	0.102		Set Trigger
2	4.052	0.061	0.035	0.032	0.102		Set Trigger
3	4.116	0.062	0.035	0.032	0.104		Set Trigger
4	4.141	0.061	0.034	0.032	0.103		Set Trigger
5	4.161	0.062	0.035	0.032	0.105		Set Trigger

Avg 4.10