

66810342

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

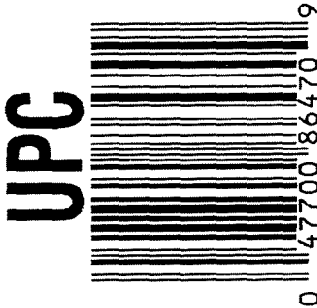


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6810342



BM FORM

GUN SERIAL #

G 6810342

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-5-09	SP
430	ASSEMBLE TO STOCK		2-5-09	SP
440	PROOF		2-5-09	SP
460	CHECK HEADSPACE		2-5-09	SP
470	DIS-ASSEMBLE ACTION		2-5-09	SP
472	SERIALIZE BOLT HANDLE		2-6-09	RT
475	DRILL AND TAP SIGHT HOLES		2-6-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR	2-7-09	RT
490	MAGNAFLUX BOLT		2-7-09	MR
500	ROLLMARK CALIBER		2-9-09	RT
520	GOFF BLAST BBL / REC		9-Feb-09	SP
542	APPLY COATINGS (BARREL ACTION)		2-11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-11-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-11-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

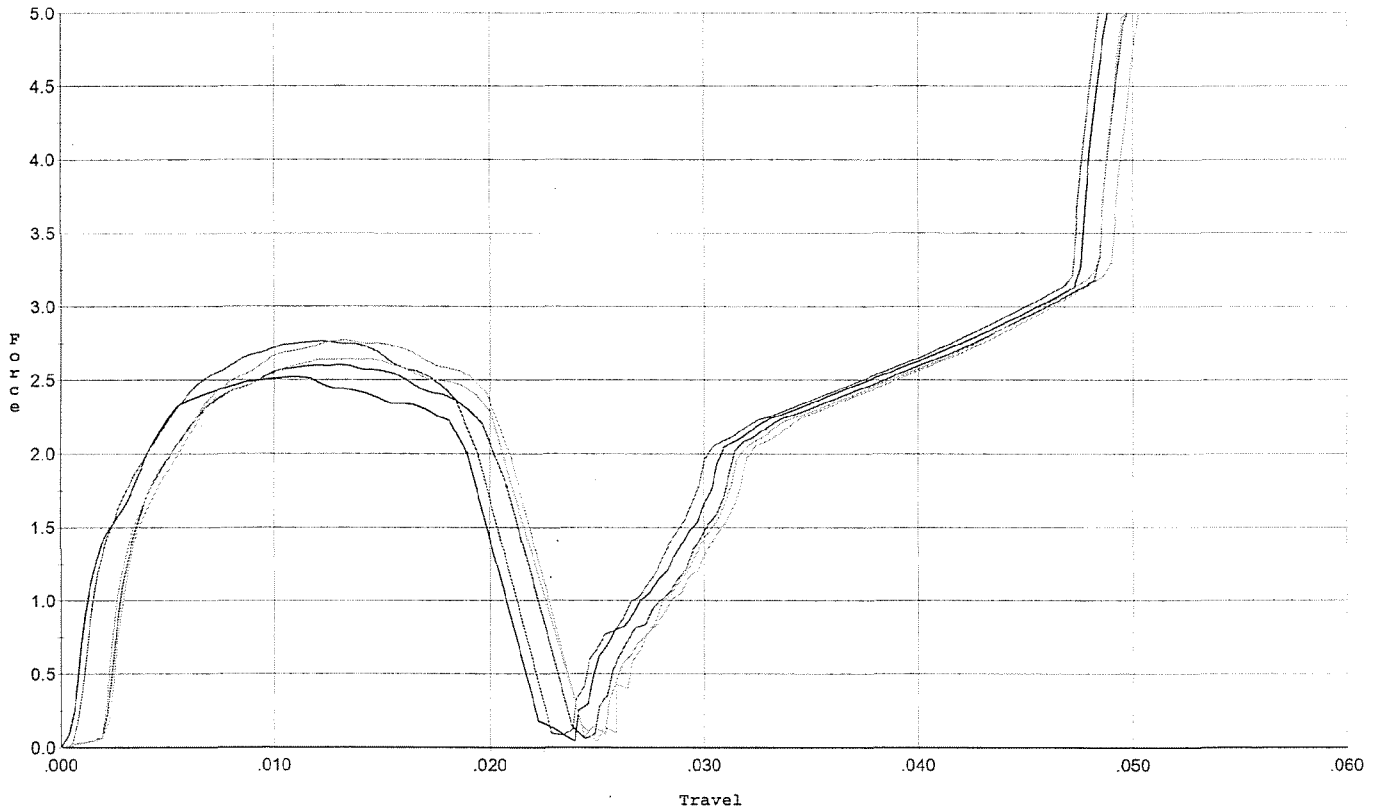
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-2-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-2-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	3-2-09	WV
	J) ASSEMBLE STOCK		2-2-09	RT
	K) ASSEMBLE SWIVEL STUDS		3-3-09	WV
	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	2-19-09	SPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-19-09	SP
670	FINAL INSPECTION A) HEADSPACE		3-2-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.75</u> <u>2.20</u> <u>2.65</u> <u>2.58</u>	2-23-09	WV
	C) FUNCTION		3-2-09	WV
690	PACK		3/5/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



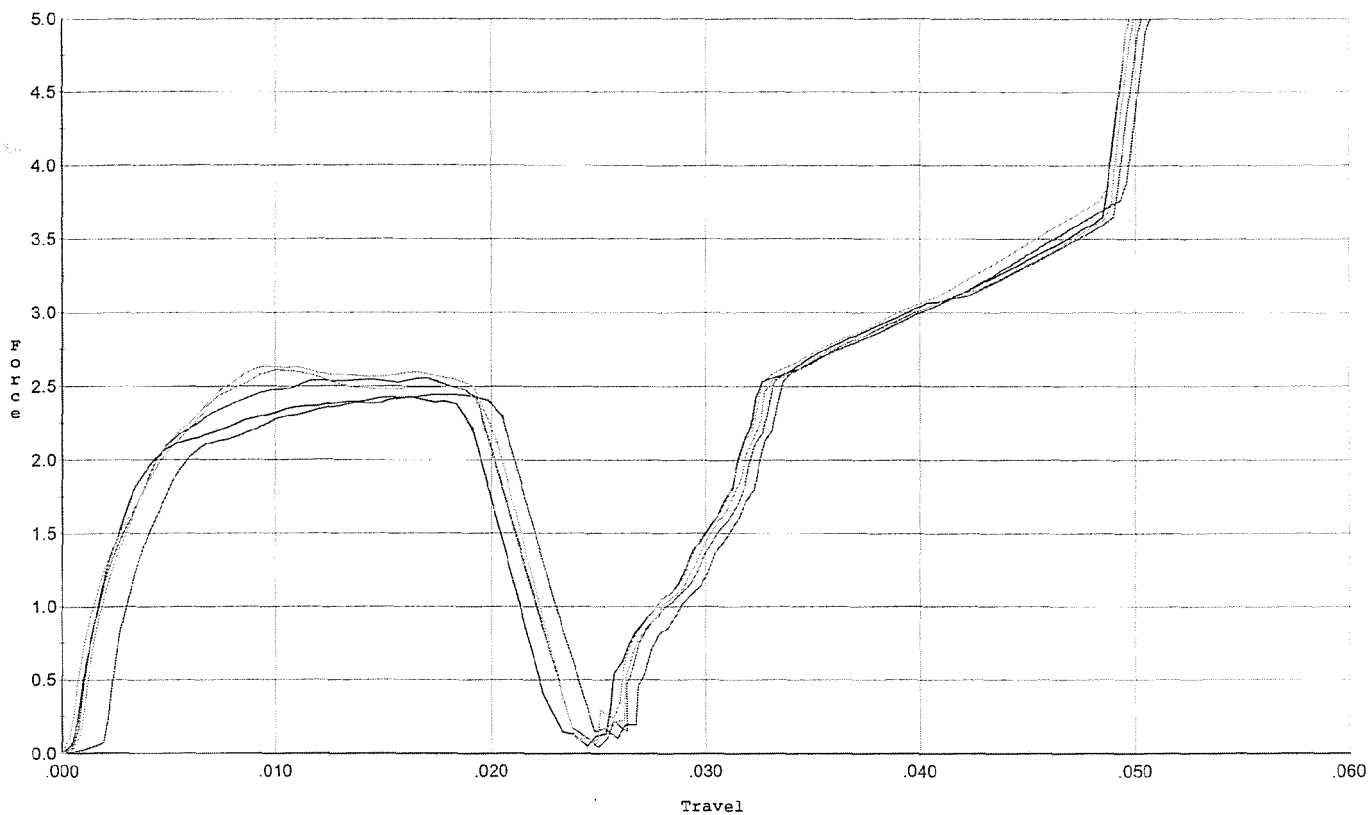
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.021	0.00	0.033	0.040		Set Trigger
2	2.518	0.019	0.00	0.034	0.038		Set Trigger
3	2.764	0.019	0.00	0.033	0.041		Set Trigger
4	2.644	0.020	0.00	0.034	0.039		Set Trigger
5	2.770	0.021	0.00	0.032	0.043		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



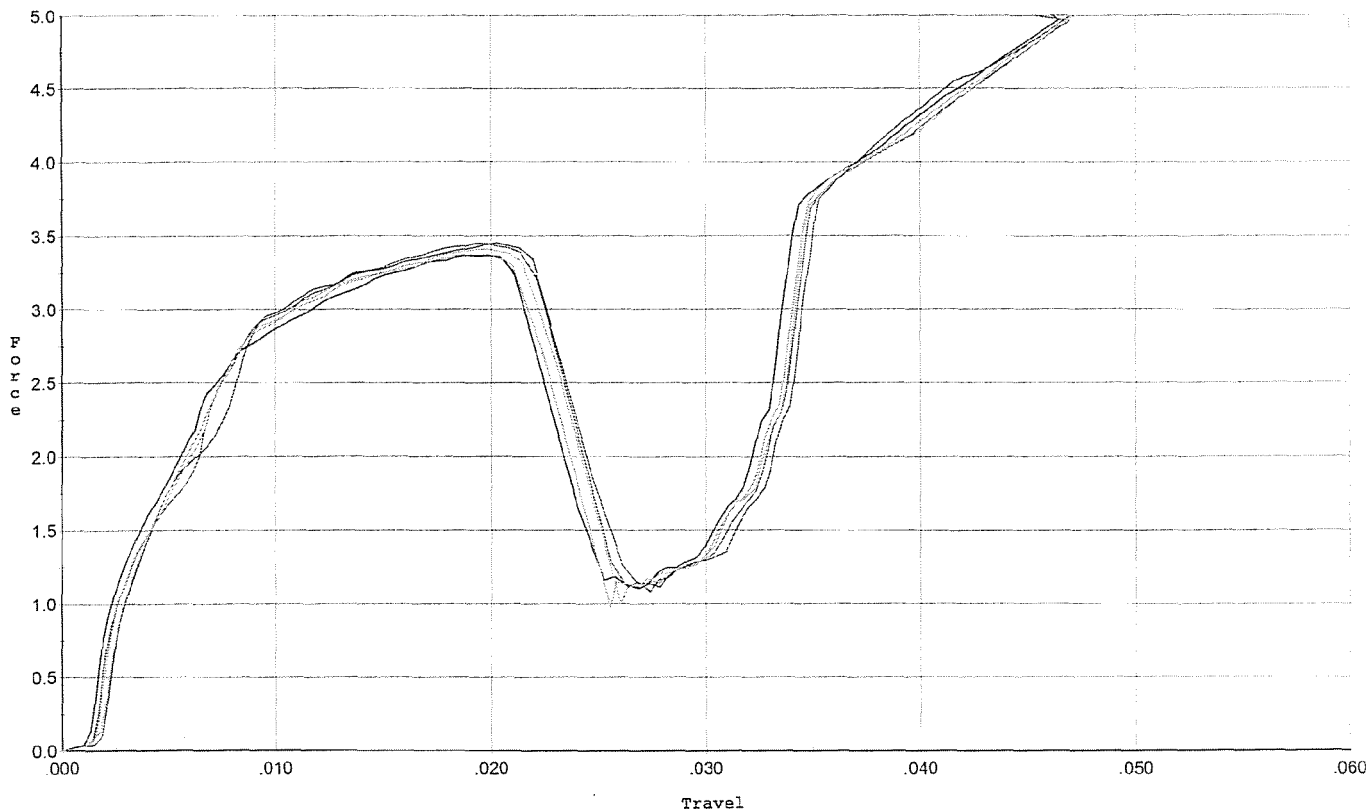
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.021	0.00	0.033	0.037		Set Trigger
2	2.429	0.019	0.00	0.034	0.037		Set Trigger
3	2.553	0.022	0.00	0.033	0.043		Set Trigger
4	2.635	0.020	0.00	0.033	0.042		Set Trigger
5	2.612	0.019	0.00	0.033	0.039		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



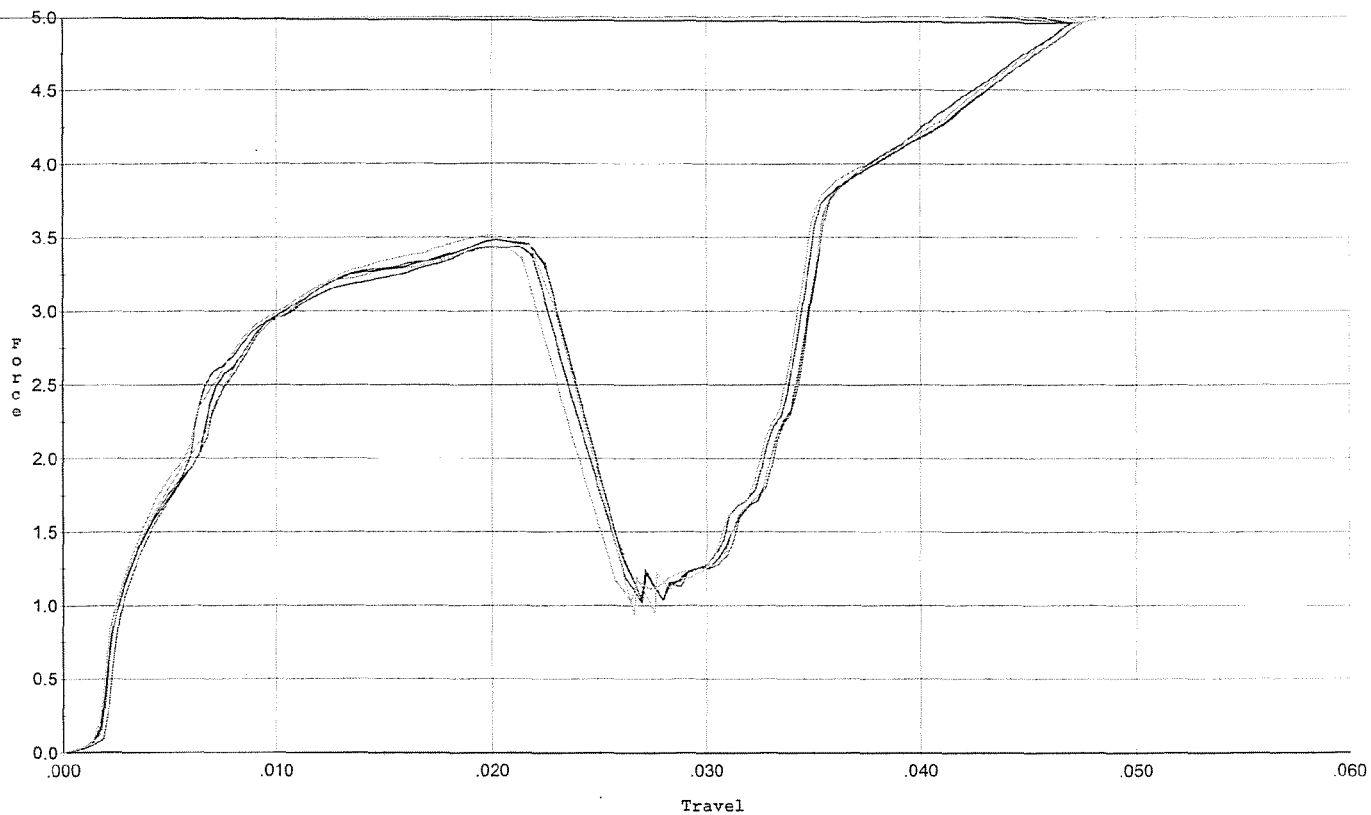
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.453	0.022	0.00	0.032	0.052		Set Trigger
2	3.369	0.021	0.00	0.032	0.050		Set Trigger
3	3.450	0.022	0.00	0.032	0.053		Set Trigger
4	3.410	0.023	0.00	0.032	0.054		Set Trigger
5	3.372	0.022	0.00	0.032	0.052		Set Trigger

~~A. J. T. F.~~
A. 3.41 cms

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



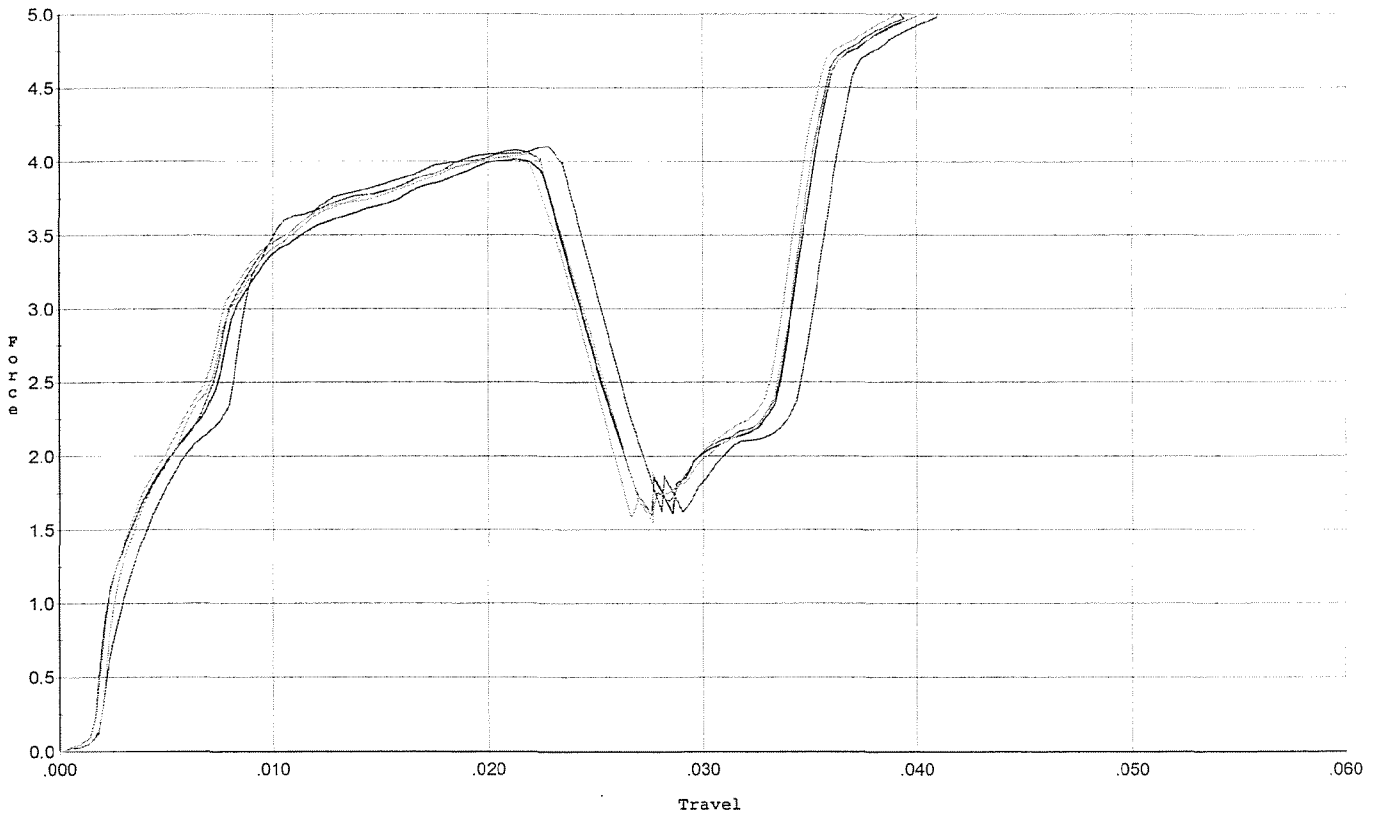
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.440	0.022	0.00	0.032	0.053		Set Trigger
2	3.485	0.022	0.00	0.032	0.054		Set Trigger
3	3.485	0.022	0.00	0.032	0.054		Set Trigger
4	3.518	0.023	0.00	0.032	0.056		Set Trigger
5	3.428	0.021	0.00	0.032	0.052		Set Trigger

A-3-49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



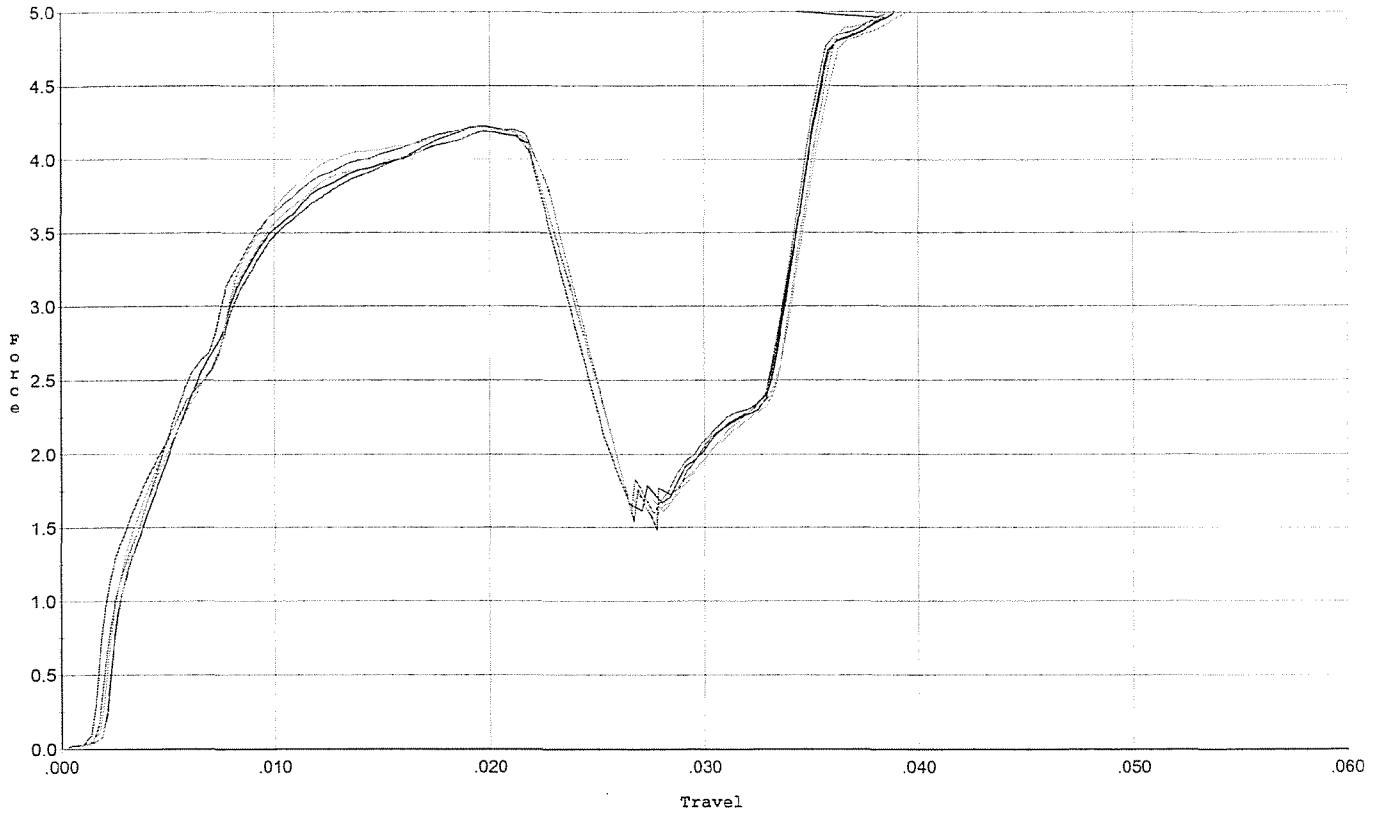
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.023	0.00	0.031	0.065		Set Trigger
2	4.018	0.023	0.00	0.030	0.062		Set Trigger
3	4.060	0.022	0.00	0.030	0.062		Set Trigger
4	4.024	0.023	0.00	0.030	0.065		Set Trigger
5	4.050	0.025	0.00	0.030	0.068		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



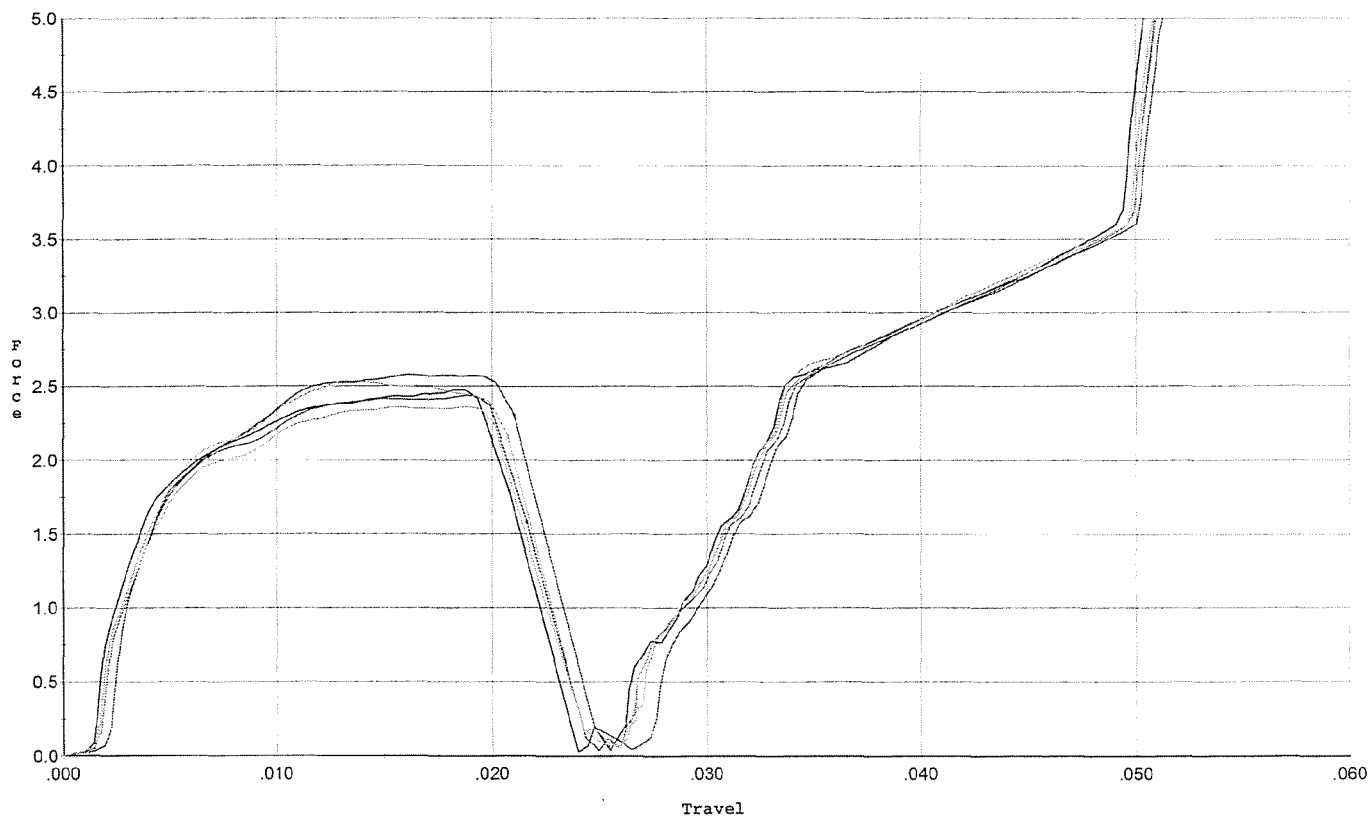
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.227	0.023	0.00	0.030	0.065		Set Trigger
2	4.190	0.024	0.00	0.030	0.067		Set Trigger
3	4.221	0.022	0.00	0.030	0.063		Set Trigger
4	4.222	0.023	0.00	0.030	0.065		Set Trigger
5	4.203	0.024	0.00	0.030	0.068		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



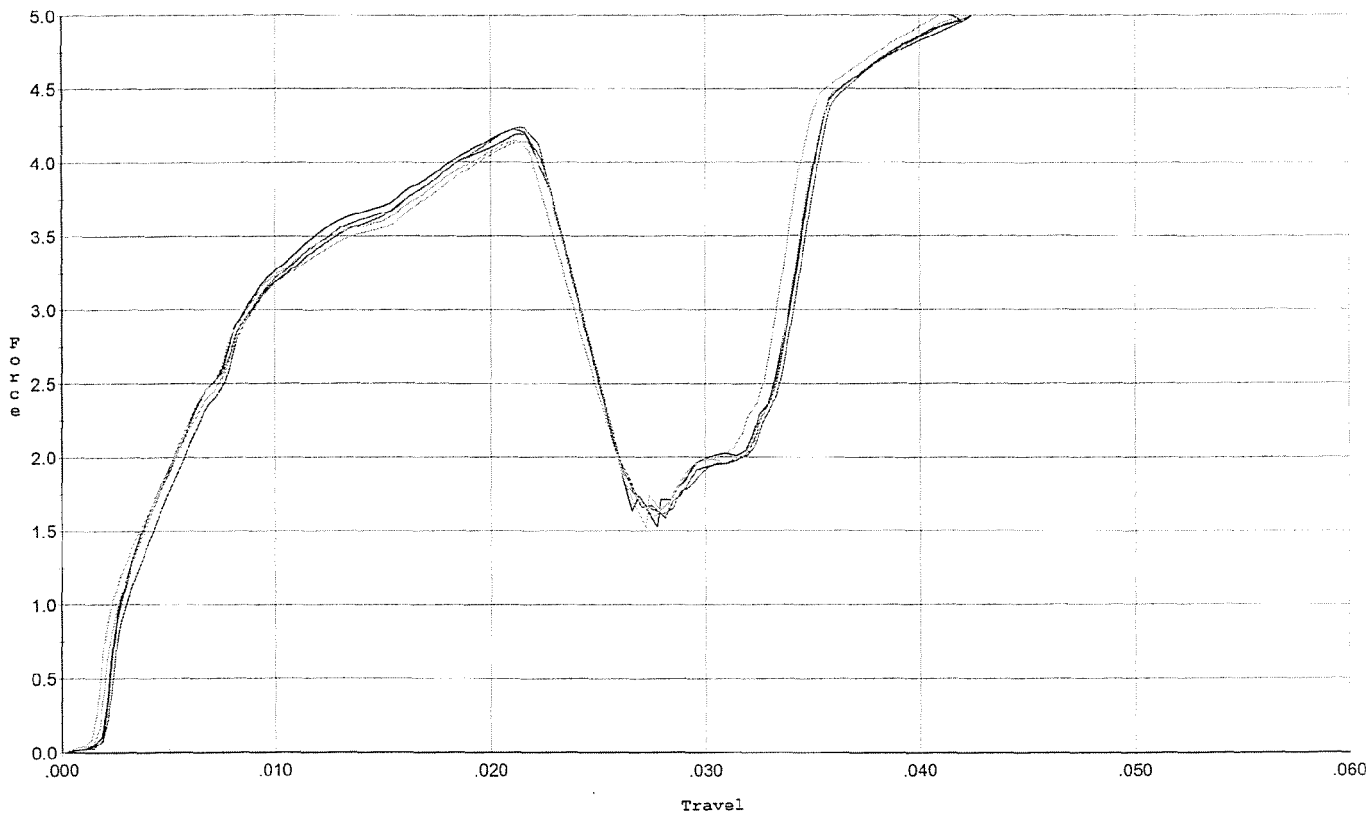
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.579	0.021	0.00	0.033	0.040		Set Trigger
2	2.477	0.021	0.00	0.033	0.038		Set Trigger
3	2.436	0.022	0.00	0.034	0.039		Set Trigger
4	2.361	0.020	0.00	0.034	0.036		Set Trigger
5	2.537	0.021	0.00	0.033	0.039		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.022	0.00	0.030	0.060		Set Trigger
2	4.226	0.023	0.00	0.030	0.062		Set Trigger
3	4.242	0.022	0.00	0.031	0.060		Set Trigger
4	4.143	0.023	0.00	0.030	0.061		Set Trigger
5	4.153	0.022	0.00	0.030	0.058		Set Trigger

A-4.19