

G6810389

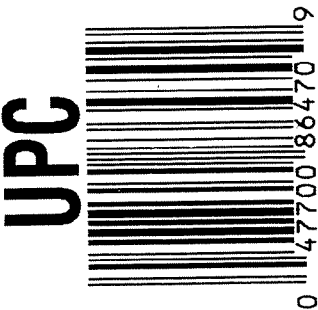
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6810389



GUN SERIAL #

G6810389

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-10-09	SP
430	ASSEMBLE TO STOCK		2-10-09	SP
440	PROOF		2-10-09	SP
460	CHECK HEADSPACE		2-10-09	SP
470	DIS-ASSEMBLE ACTION		2-10-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	2-11-09	RTZ
475	DRILL AND TAP SIGHT HOLES		2-11-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	2/13/09	(H)
490	MAGNAFLUX BOLT		2/13/09	
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DG
542	APPLY COATINGS (BARREL ACTION)		2/20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-23-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

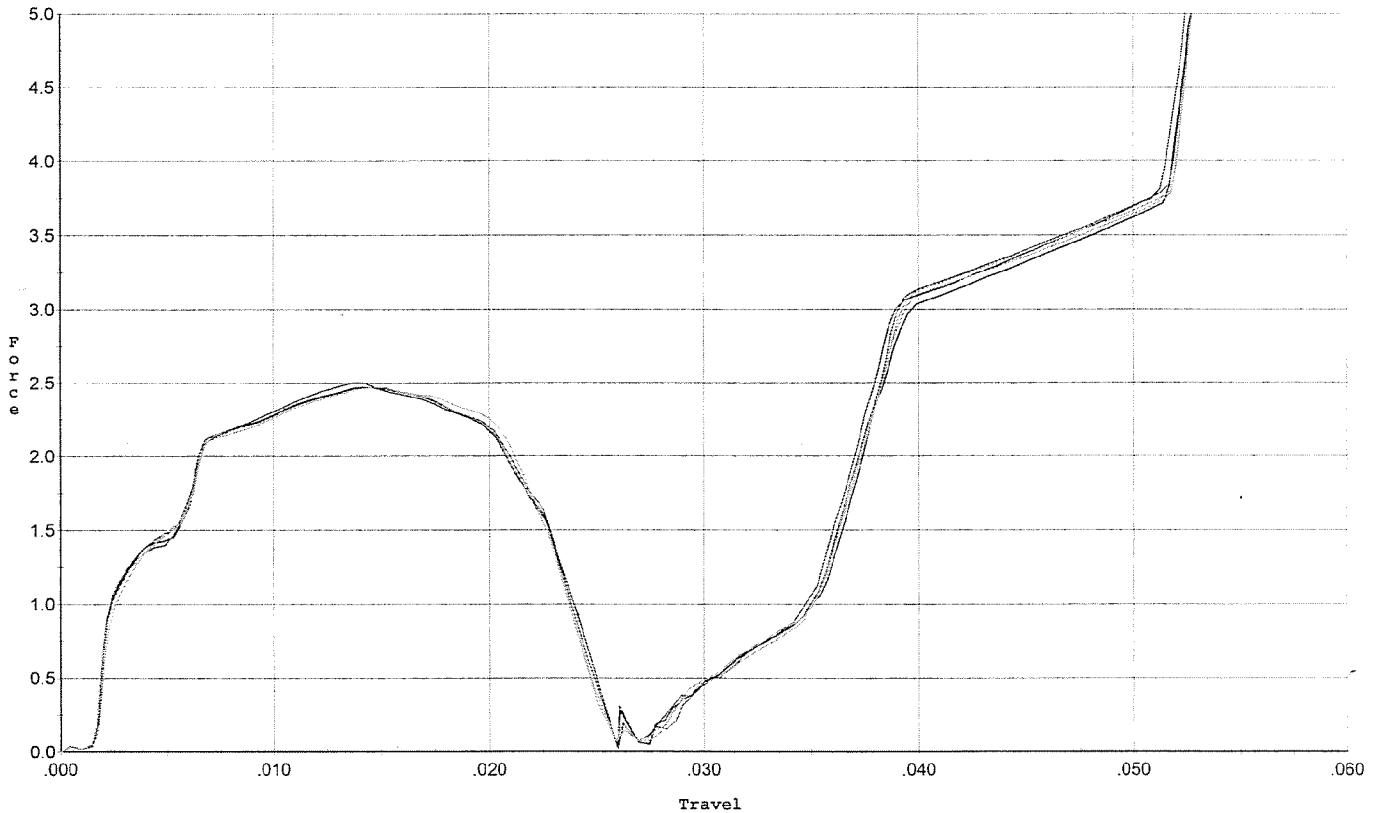
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	2-27-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	2-27-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	2-27-09	WN
	J) ASSEMBLE STOCK		2-23-09	RP
	K) ASSEMBLE SWIVEL STUDS		2-27-09	WN
	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	2-24-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-24-09	RP
670	FINAL INSPECTION A) HEADSPACE		2-27-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.39</u> <u>2.22</u> <u>2.10</u> <u>2.36</u>	2-25-09	WN
	C) FUNCTION		2-27-09	WN
690	PACK		3/2/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/20/09

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



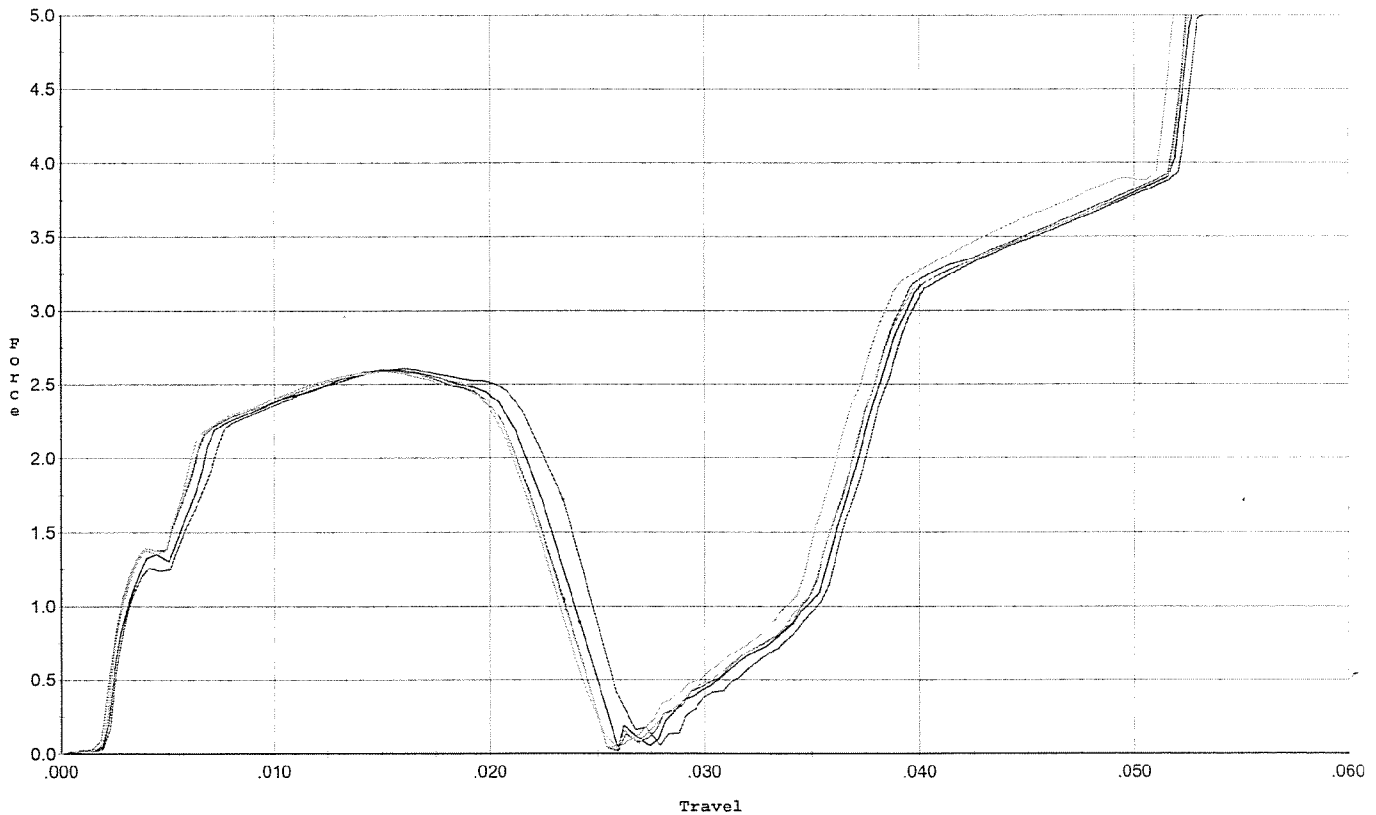
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.502	0.023	0.00	0.036	0.041		Set Trigger
2	2.470	0.024	0.00	0.035	0.043		Set Trigger
3	2.468	0.024	0.00	0.035	0.043		Set Trigger
4	2.470	0.023	0.00	0.036	0.041		Set Trigger
5	2.468	0.023	0.00	0.036	0.041		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/20/09

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



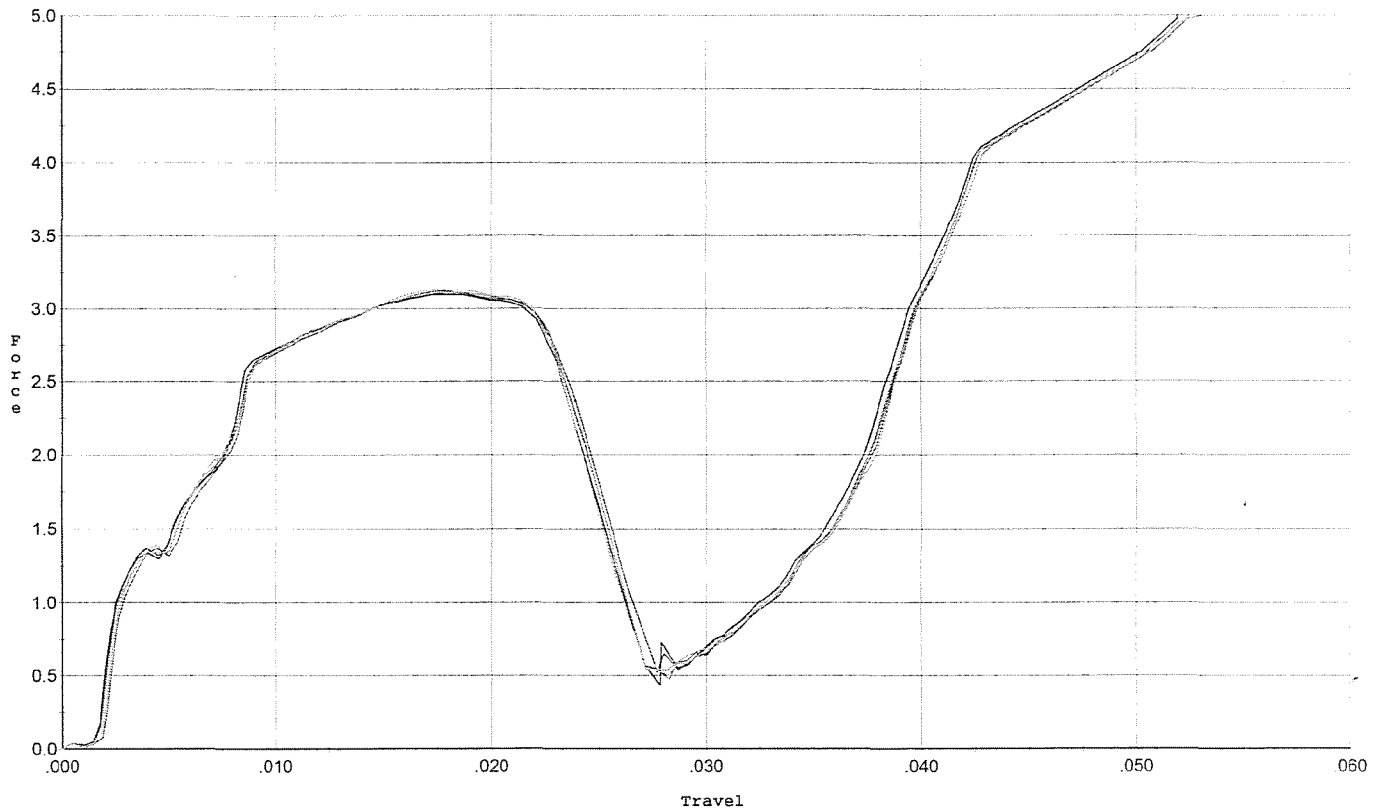
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.023	0.00	0.035	0.043		Set Trigger
2	2.597	0.024	0.00	0.035	0.044		Set Trigger
3	2.602	0.023	0.005	0.035	0.043		Set Trigger
4	2.590	0.022	0.00	0.035	0.041		Set Trigger
5	2.586	0.024	0.00	0.035	0.044		Set Trigger

AVG 2.59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/20/09

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



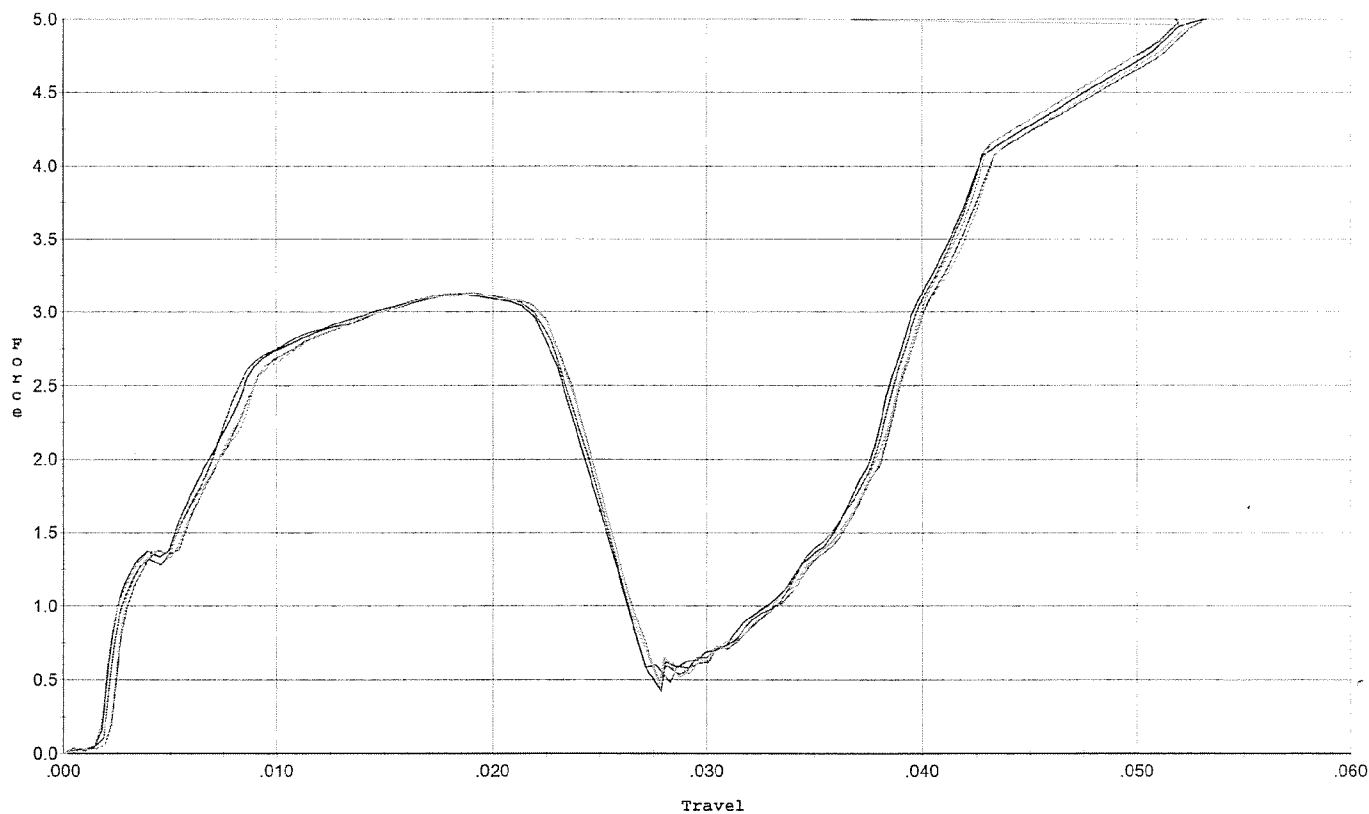
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.106	0.024	0.00	0.034	0.052		Set Trigger
2	3.096	0.023	0.00	0.035	0.050		Set Trigger
3	3.121	0.024	0.00	0.035	0.053		Set Trigger
4	3.130	0.024	0.00	0.035	0.053		Set Trigger
5	3.110	0.023	0.005	0.035	0.050		Set Trigger

Aug 3.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/20/09

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



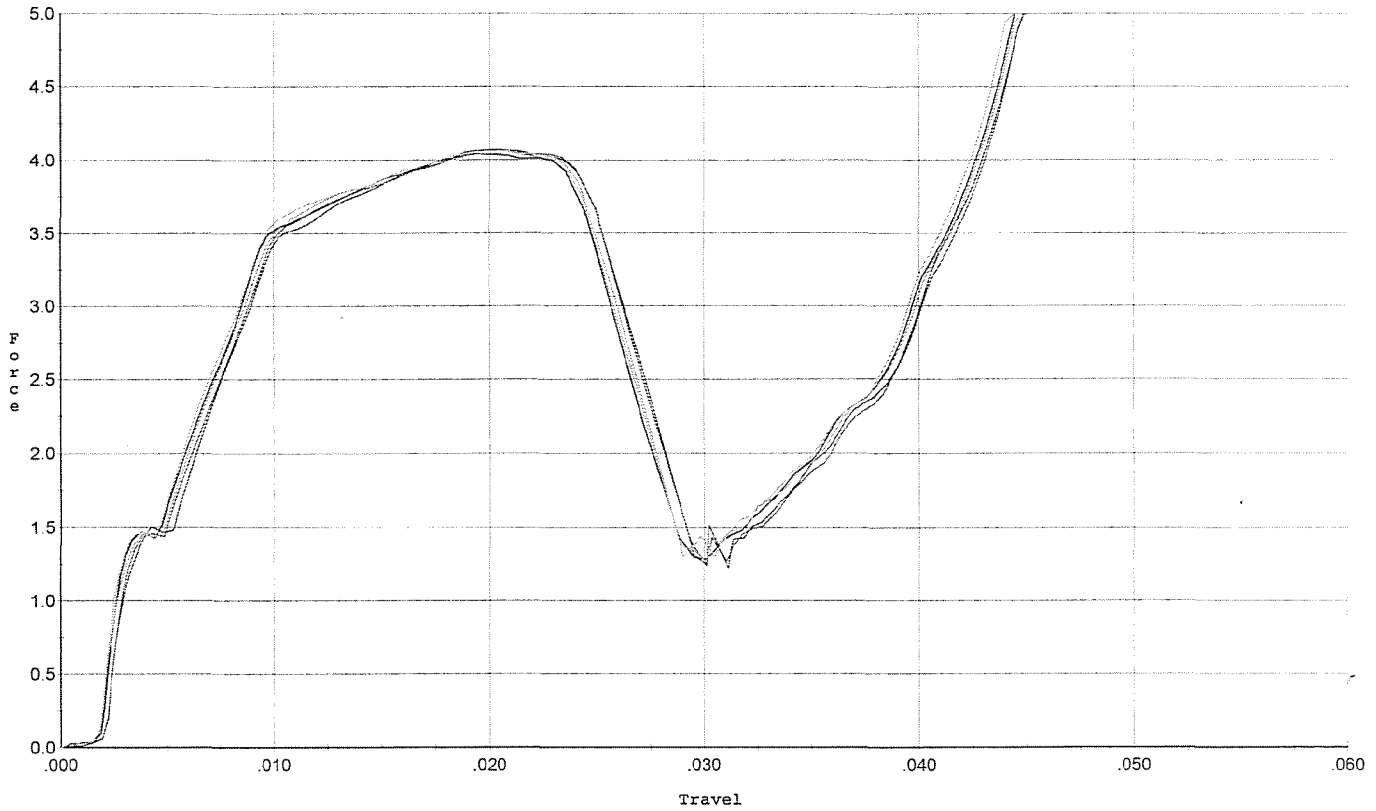
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.128	0.024	0.00	0.035	0.054		Set Trigger
2	3.115	0.025	0.00	0.035	0.055		Set Trigger
3	3.115	0.024	0.00	0.035	0.051		Set Trigger
4	3.115	0.024	0.00	0.035	0.052		Set Trigger
5	3.125	0.024	0.005	0.035	0.052		Set Trigger

Aug 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/20/09

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



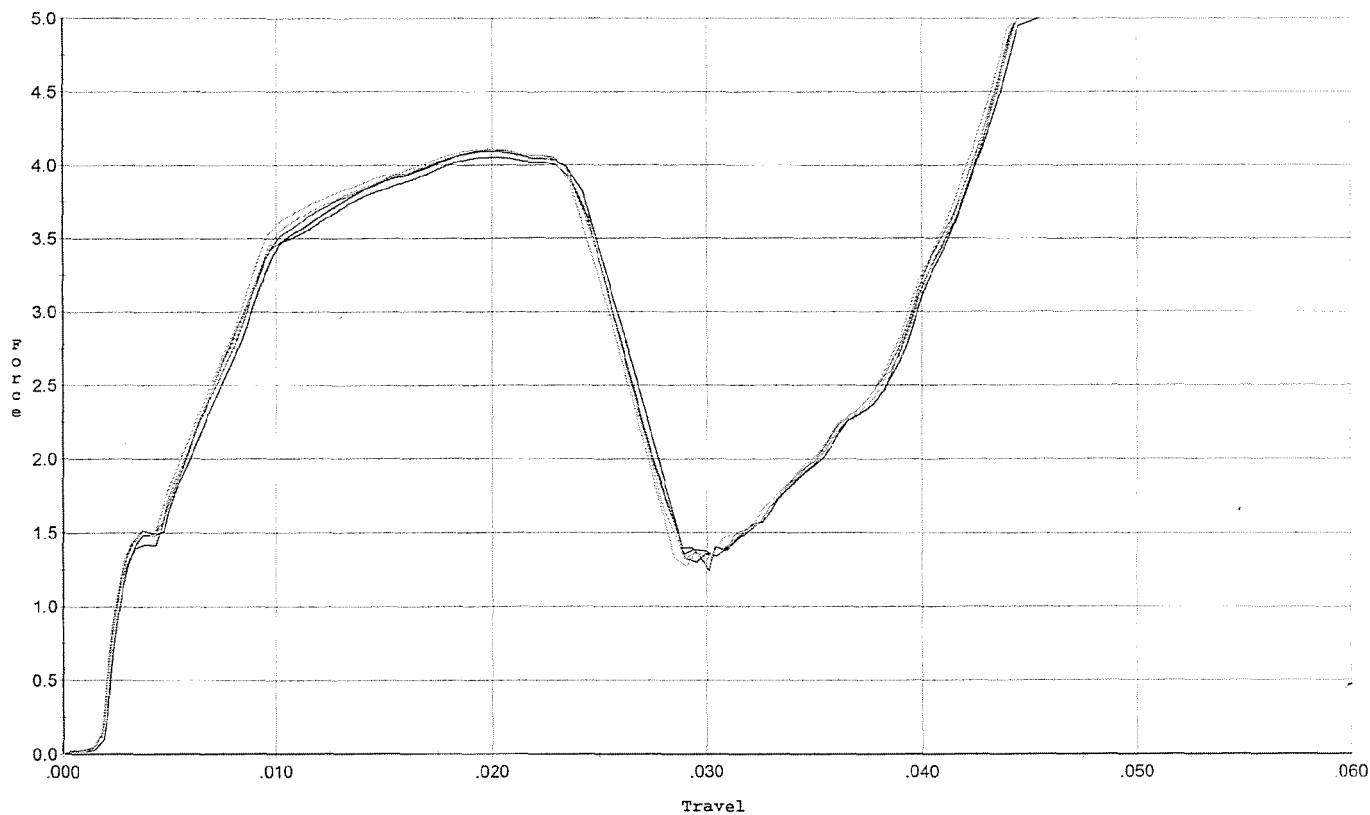
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.065	0.027	0.00	0.030	0.075		Set Trigger
2	4.045	0.024	0.00	0.031	0.069		Set Trigger
3	4.070	0.025	0.00	0.030	0.070		Set Trigger
4	4.064	0.027	0.00	0.030	0.075		Set Trigger
5	4.051	0.026	0.00	0.030	0.072		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/20/09

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



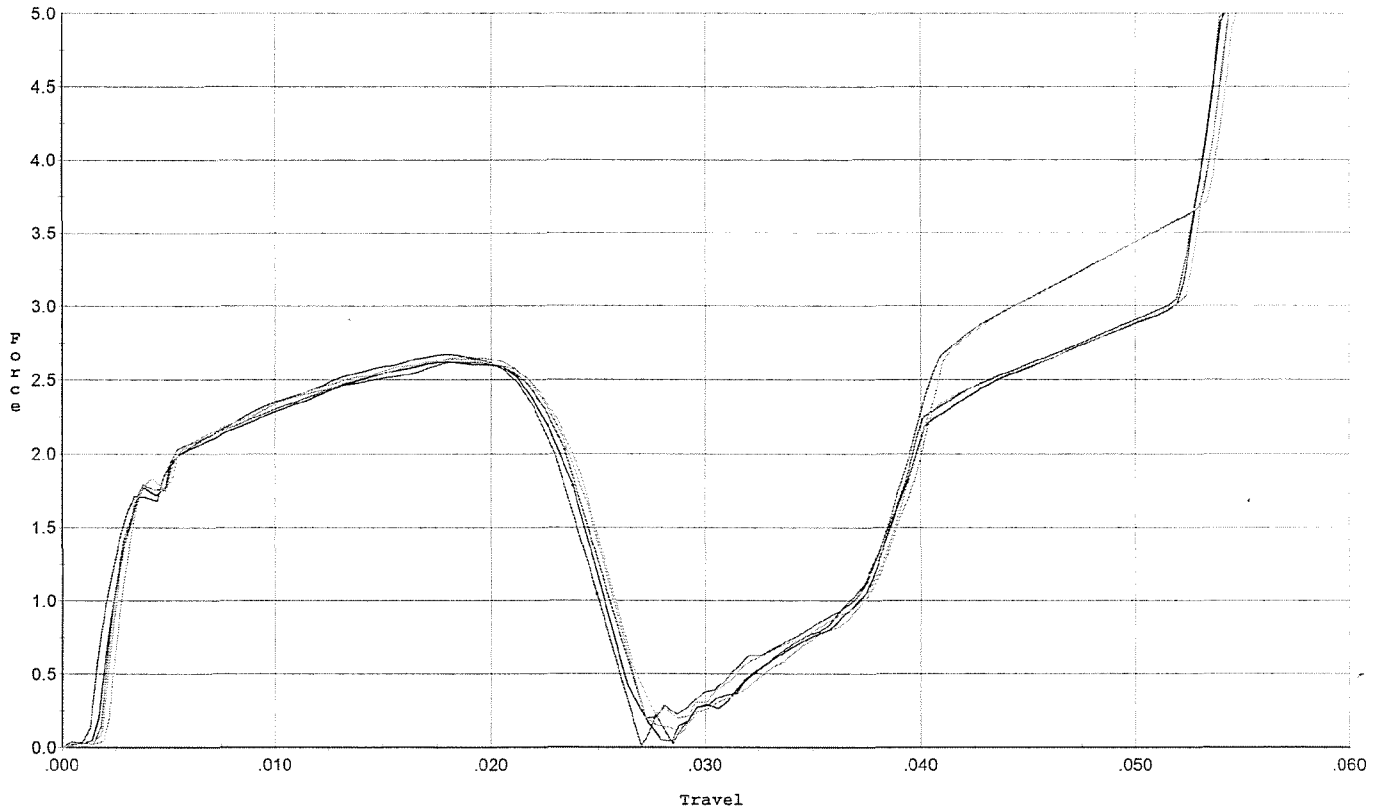
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.025	0.00	0.030	0.069		Set Trigger
2	4.096	0.026	0.00	0.030	0.073		Set Trigger
3	4.107	0.024	0.00	0.030	0.069		Set Trigger
4	4.106	0.025	0.00	0.030	0.072		Set Trigger
5	4.107	0.025	0.00	0.030	0.070		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/20/09

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



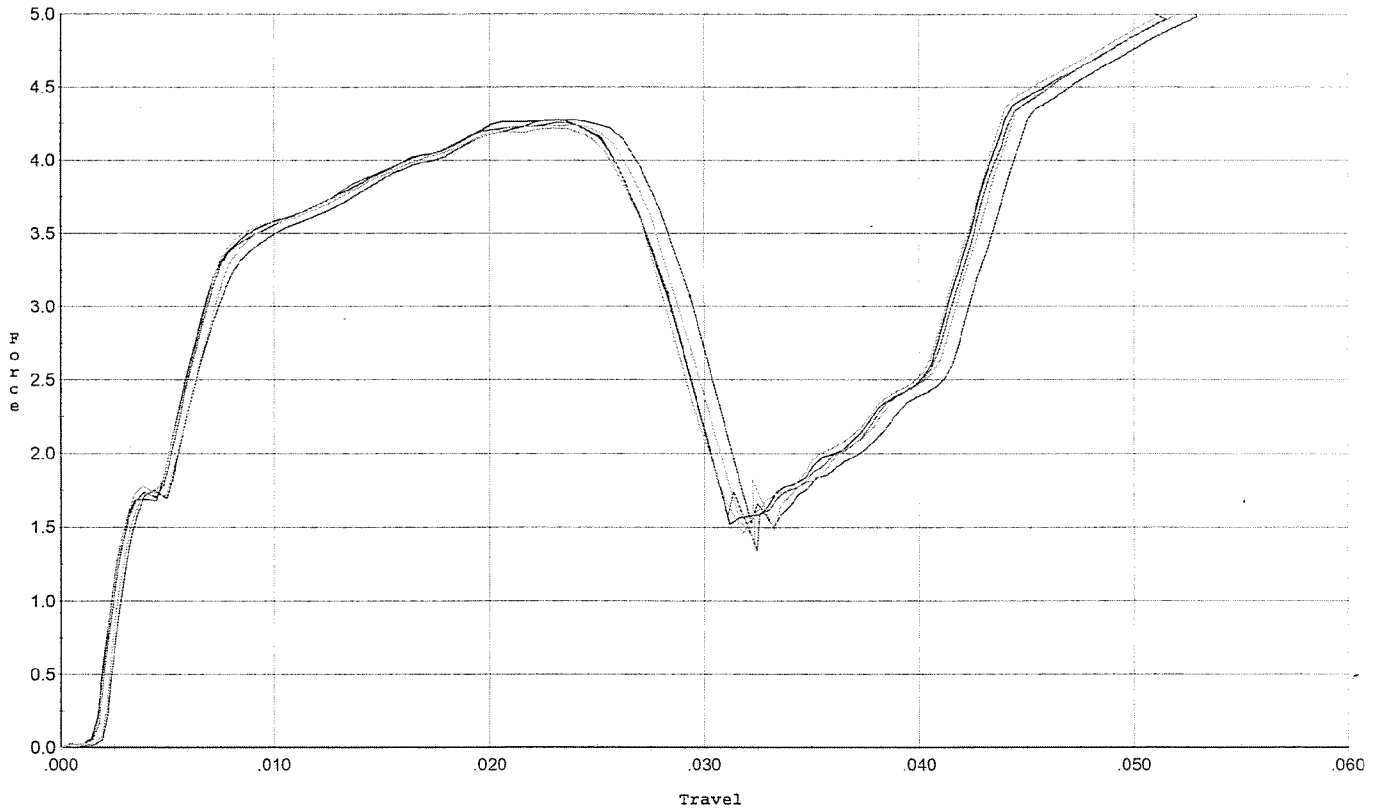
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.025	0.00	0.036	0.050		Set Trigger
2	2.621	0.024	0.00	0.036	0.047		Set Trigger
3	2.618	0.023	0.002	0.037	0.046		Set Trigger
4	2.641	0.024	0.00	0.036	0.048		Set Trigger
5	2.655	0.024	0.002	0.036	0.048		Set Trigger

Avg 2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/20/09

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	4.273	0.029	0.002	0.027	0.088		Set Trigger
2	4.274	0.028	0.005	0.028	0.087		Set Trigger
3	4.254	0.028	0.00	0.028	0.086		Set Trigger
4	4.238	0.029	0.005	0.027	0.089		Set Trigger
5	4.220	0.027	0.00	0.031	0.082		Set Trigger

Avg 4.25