

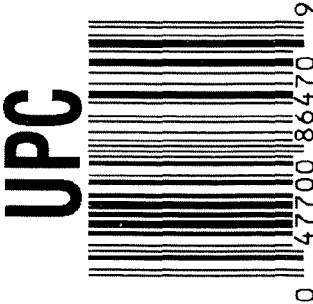
G6810422

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

G6810422



BM FORM

GUN SERIAL #

G 6810422

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-9-09	SP
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		2-9-09	SP
460	CHECK HEADSPACE		2-9-09	SP
470	DIS-ASSEMBLE ACTION		2-9-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	2-9-09	RT
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	2/13/09	(H)
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DC
542	APPLY COATINGS (BARREL ACTION)		2/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-18-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

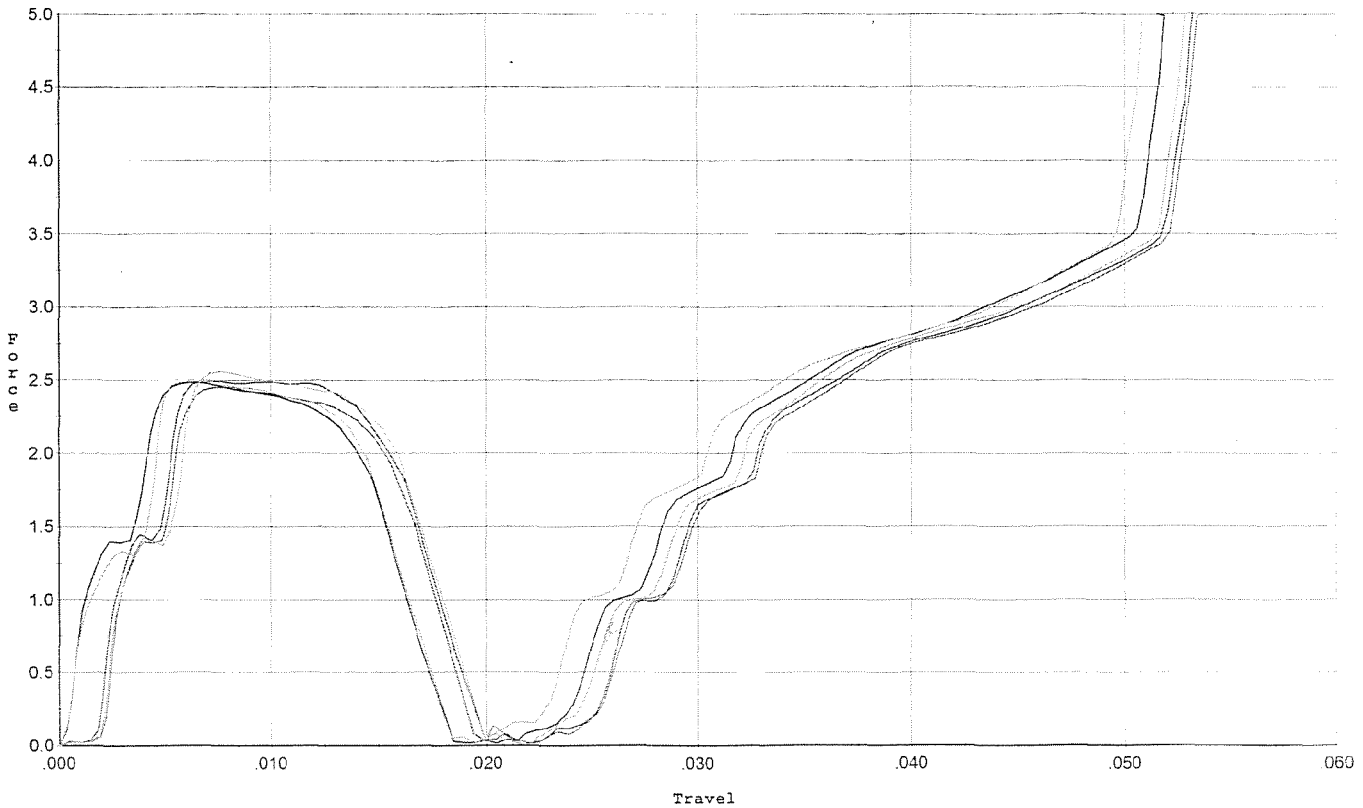
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>7</u>	3-2-09	W W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>5</u> <u>5</u>	3-2-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-2-09	W W
	J) ASSEMBLE STOCK		2-18-09	A.P.N.
	K) ASSEMBLE SWIVEL STUDS		3-2-09	W W
	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	2-20-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-20-09	W W
670	FINAL INSPECTION A) HEADSPACE		3-2-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.58</u> <u>2.34</u> <u>2.45</u> <u>2.58</u>	2-23-09	W W
	C) FUNCTION		3-2-09	W W
690	PACK		3/5/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



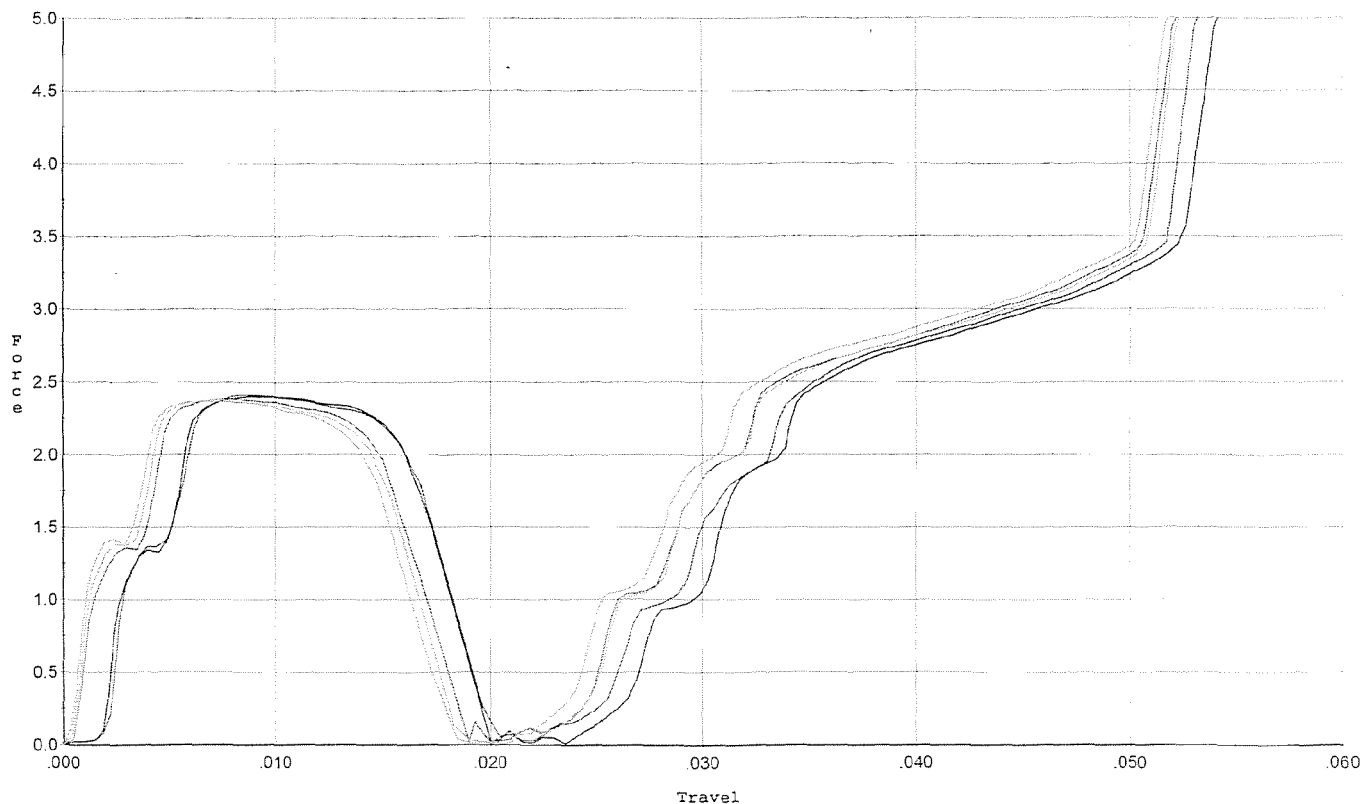
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.016	0.00	0.040	0.028		Set Trigger
2	2.485	0.015	0.00	0.040	0.027		Set Trigger
3	2.453	0.017	0.002	0.040	0.028		Set Trigger
4	2.561	0.018	0.00	0.039	0.030		Set Trigger
5	2.496	0.015	0.00	0.039	0.026		Set Trigger

A-2-49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



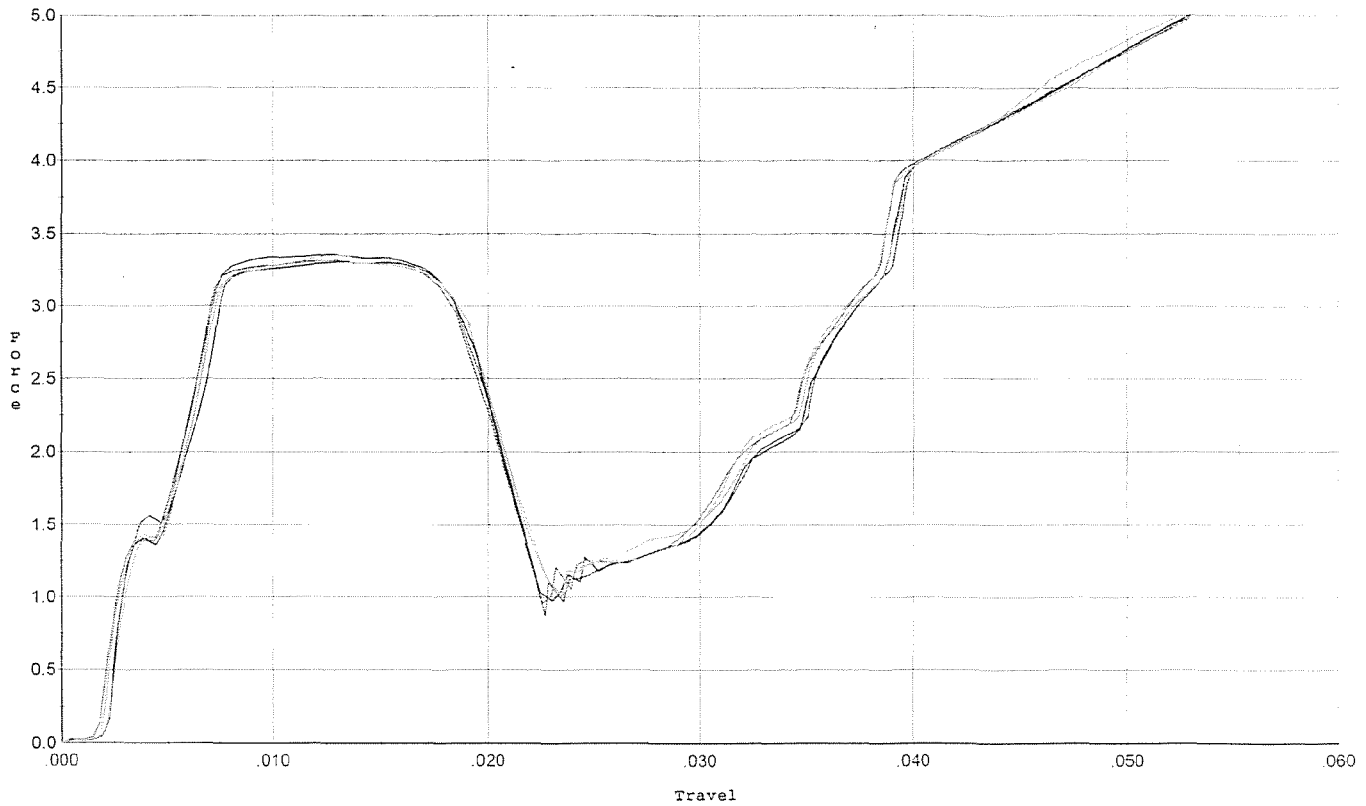
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.412	0.017	0.00	0.039	0.028		Set Trigger
2	2.399	0.017	0.00	0.040	0.029		Set Trigger
3	2.383	0.017	0.00	0.039	0.030		Set Trigger
4	2.375	0.015	0.00	0.040	0.028		Set Trigger
5	2.367	0.015	0.00	0.040	0.027		Set Trigger

A-2-38

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



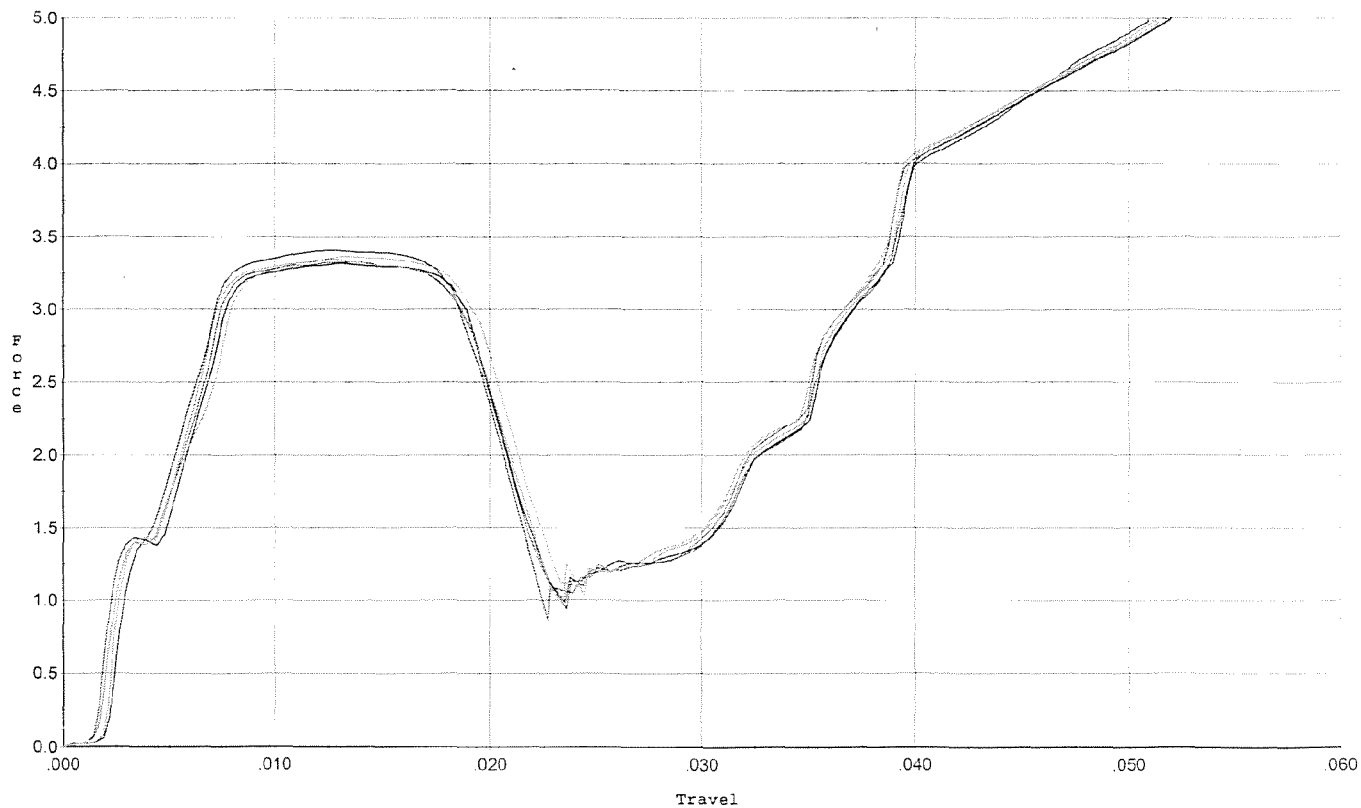
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.356	0.020	0.002	0.037	0.046		Set Trigger
2	3.301	0.019	0.002	0.037	0.044		Set Trigger
3	3.312	0.020	0.00	0.037	0.046		Set Trigger
4	3.354	0.019	0.00	0.037	0.044		Set Trigger
5	3.317	0.019	0.00	0.037	0.044		Set Trigger

A-332

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



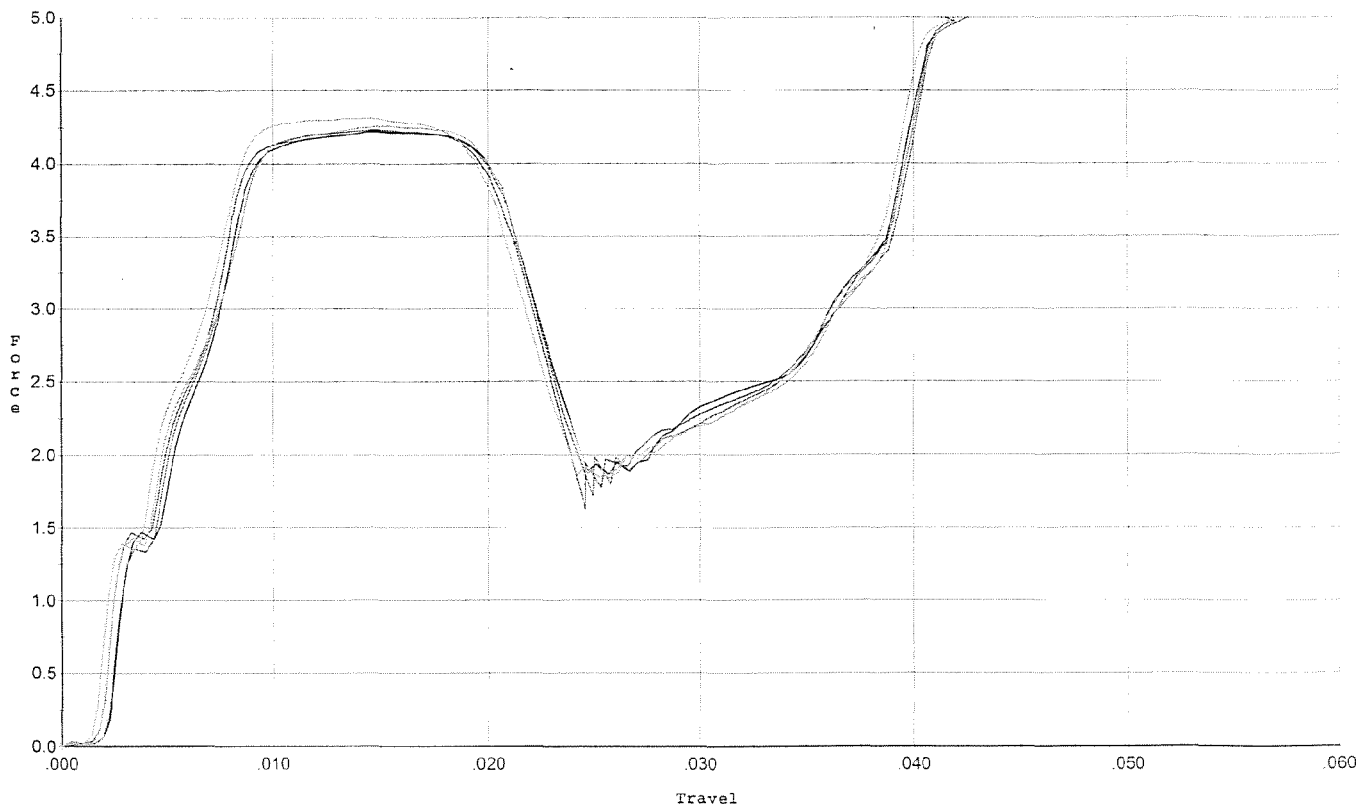
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.407	0.020	0.00	0.037	0.047		Set Trigger
2	3.317	0.019	0.002	0.037	0.043		Set Trigger
3	3.325	0.019	0.00	0.036	0.045		Set Trigger
4	3.363	0.020	0.00	0.036	0.046		Set Trigger
5	3.344	0.019	0.00	0.036	0.044		Set Trigger

A.B.35

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- .20 lb



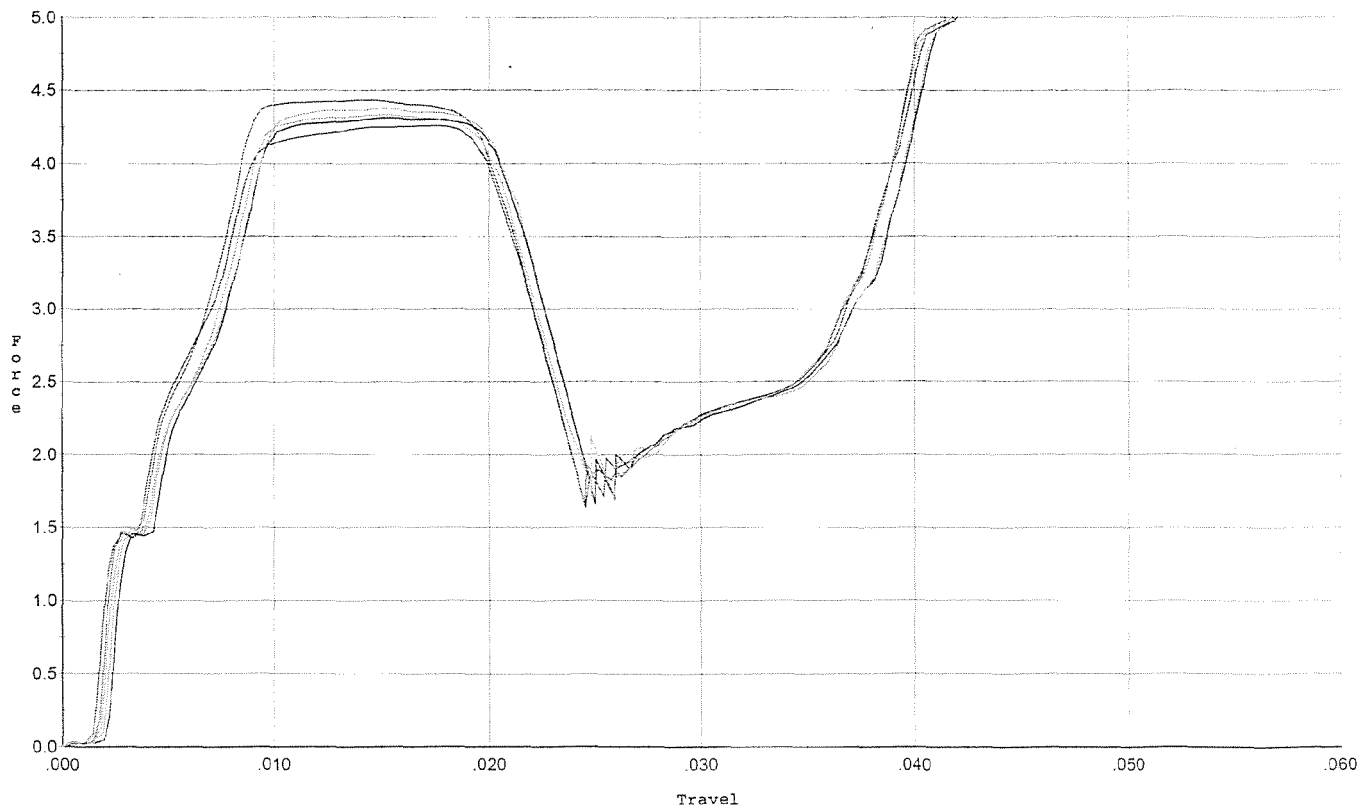
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.218	0.021	0.00	0.030	0.061		Set Trigger
2	4.227	0.021	0.002	0.030	0.059		Set Trigger
3	4.234	0.021	0.002	0.030	0.059		Set Trigger
4	4.312	0.020	0.00	0.031	0.060		Set Trigger
5	4.258	0.021	0.00	0.030	0.060		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



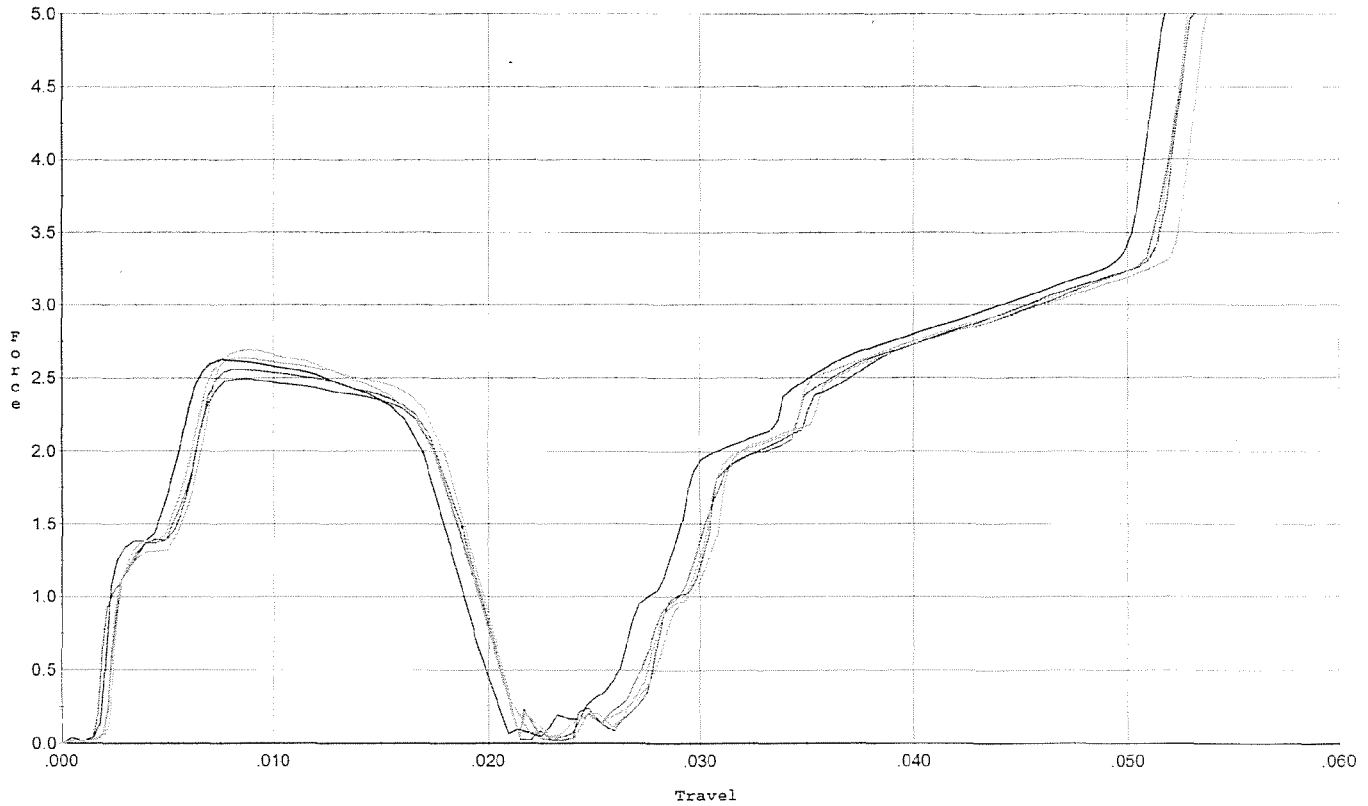
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.261	0.021	0.00	0.031	0.064		Set Trigger
2	4.313	0.022	0.002	0.031	0.063		Set Trigger
3	4.434	0.021	0.00	0.031	0.064		Set Trigger
4	4.333	0.021	0.00	0.031	0.061		Set Trigger
5	4.374	0.021	0.002	0.030	0.063		Set Trigger

A-434

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



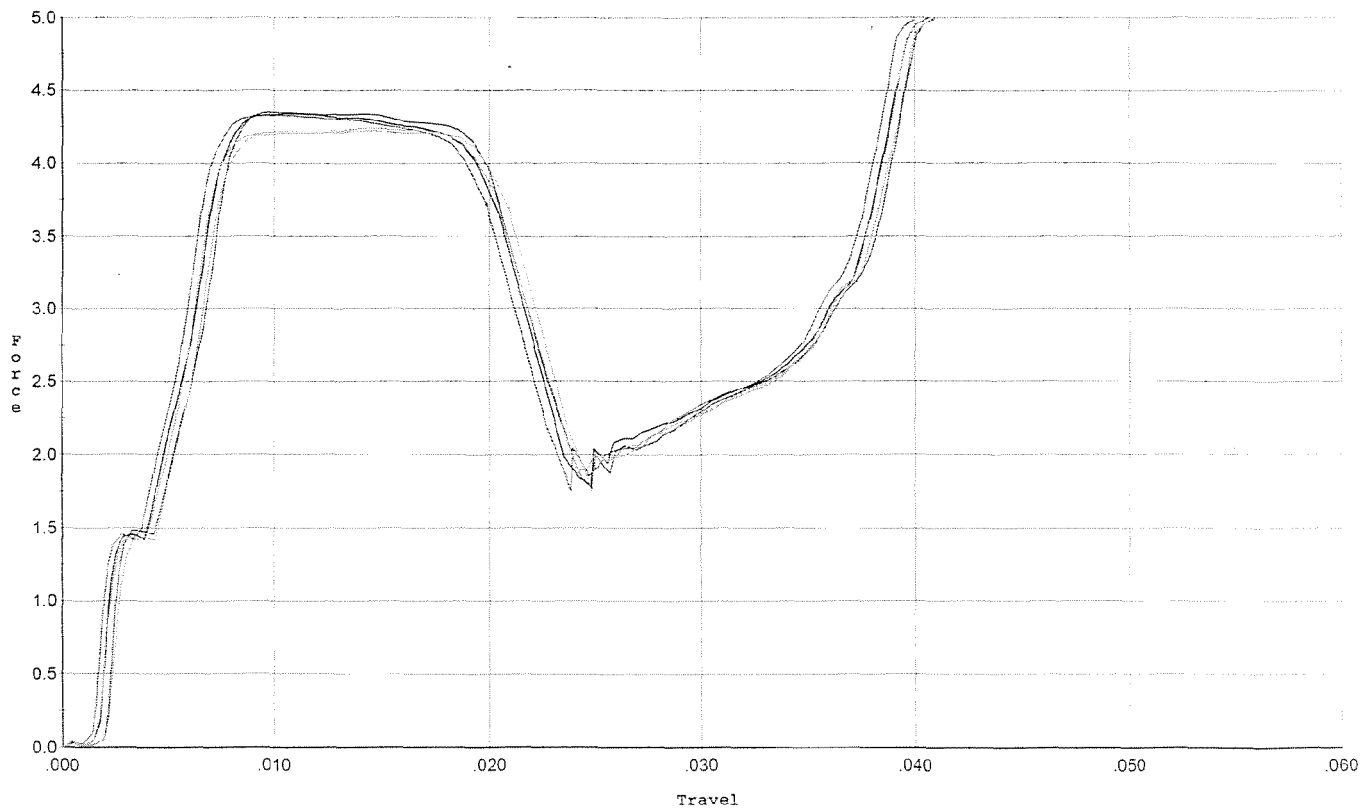
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.019	0.00	0.038	0.034		Set Trigger
2	2.624	0.017	0.00	0.038	0.031		Set Trigger
3	2.558	0.019	0.00	0.038	0.033		Set Trigger
4	2.693	0.019	0.00	0.038	0.034		Set Trigger
5	2.636	0.018	0.005	0.038	0.032		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.020	0.002	0.033	0.059		Set Trigger
2	4.339	0.020	0.00	0.032	0.061		Set Trigger
3	4.328	0.020	0.00	0.033	0.060		Set Trigger
4	4.226	0.021	0.002	0.033	0.061		Set Trigger
5	4.240	0.020	0.00	0.033	0.060		Set Trigger

A-429