

G6810430

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



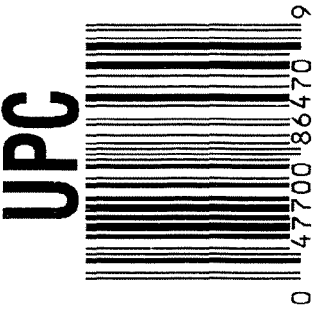
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810430



GUN SERIAL #

G 6810430

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-9-09	J.P.D.
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		2-9-09	J.P.D.
460	CHECK HEADSPACE		2-9-09	J.P.D.
470	DIS-ASSEMBLE ACTION		2-9-09	J.P.D.
472	SERIALIZE BOLT HANDLE		2-9-09	RT
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (AS)	2/13/09	(AS)
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/14/09	RT
520	GOFF BLAST BBL / REC		16 Feb. 09	AS
542	APPLY COATINGS (BARREL ACTION)		2/27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-3-09	J.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

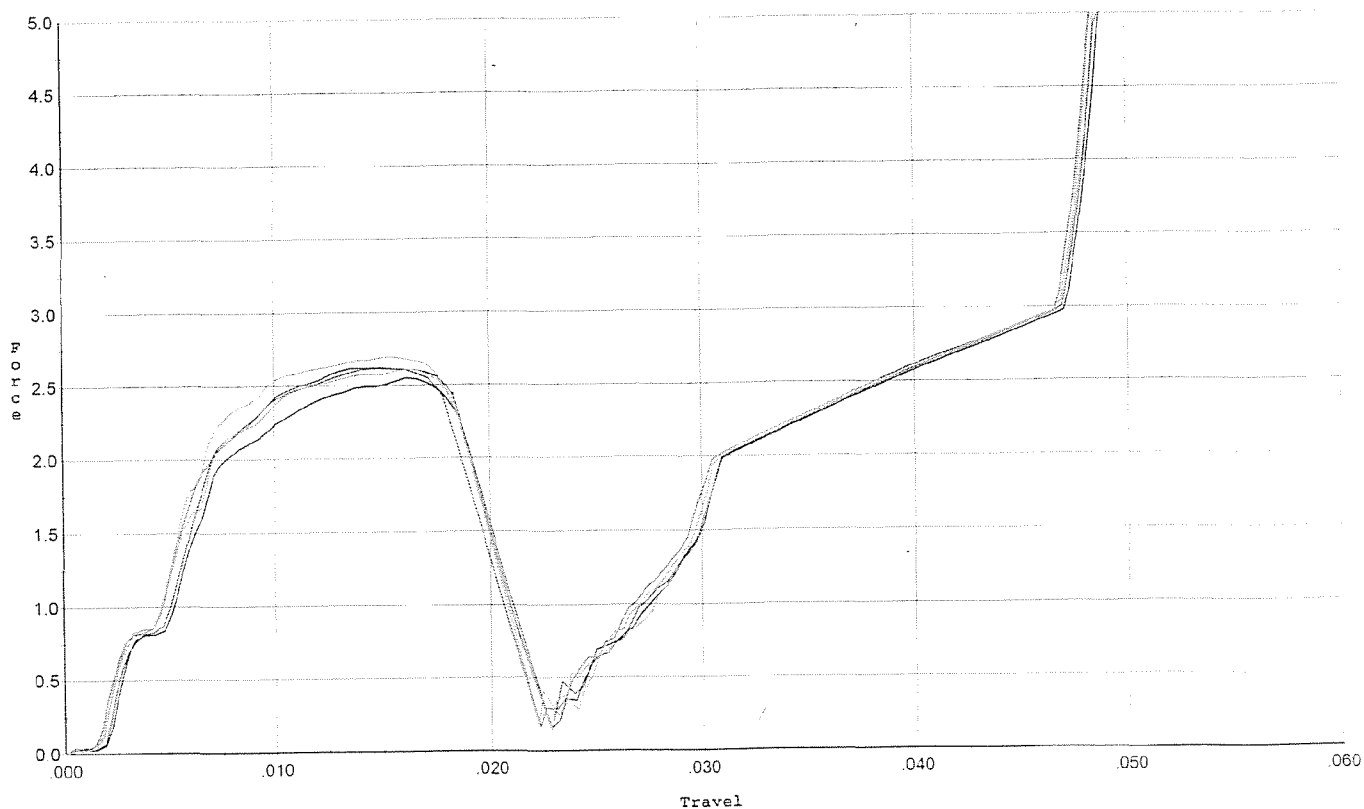
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5.5</u> <u>5</u>	3-5-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	3-5-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-5-09	WW
	J) ASSEMBLE STOCK		3-3-09	L.P.N.
	K) ASSEMBLE SWIVEL STUDS		3-5-09	WW
	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	3-4-09	WW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-4-09	TC
670	FINAL INSPECTION A) HEADSPACE		3-5-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.72</u> <u>2.62</u> <u>2.59</u> <u>2.54</u>	3-4-09	WW
	C) FUNCTION		3-5-09	WW
690	PACK		3/6/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



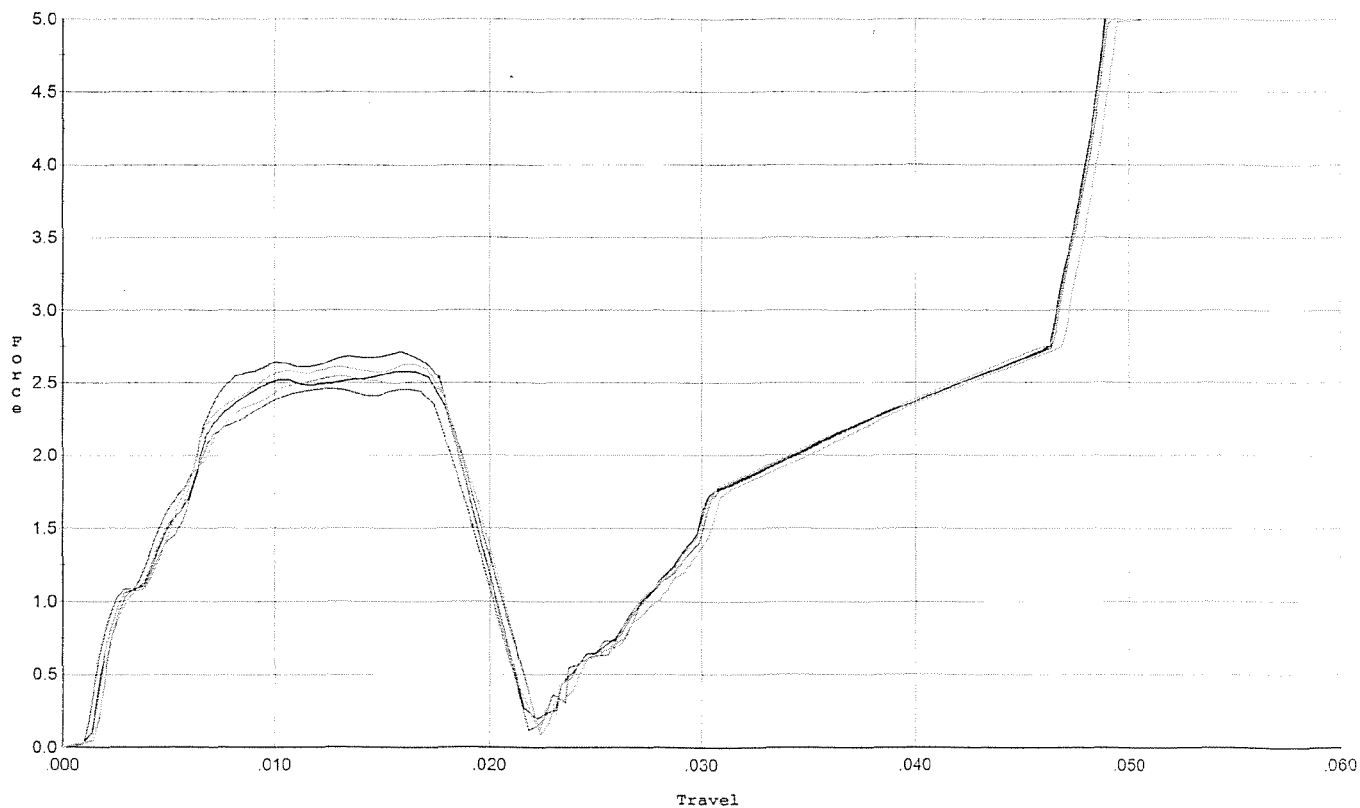
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.621	0.018	0.00	0.033	0.032		Set Trigger
2	2.550	0.018	0.002	0.033	0.031		Set Trigger
3	2.614	0.018	0.00	0.033	0.031		Set Trigger
4	2.696	0.018	0.00	0.033	0.034		Set Trigger
5	2.609	0.018	0.00	0.033	0.032		Set Trigger

A.2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



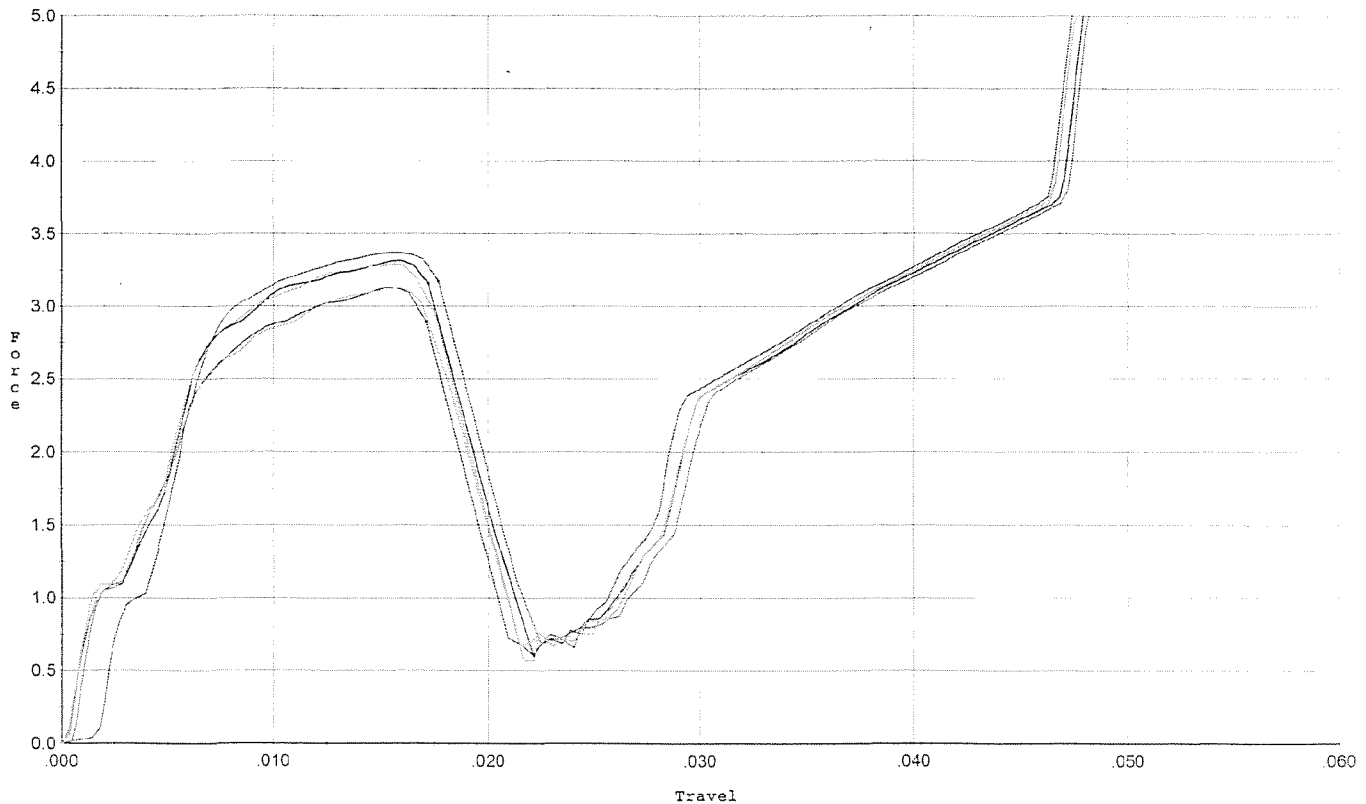
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.712	0.018	0.00	0.034	0.034		Set Trigger
2	2.579	0.018	0.00	0.034	0.033		Set Trigger
3	2.457	0.019	0.00	0.034	0.033		Set Trigger
4	2.625	0.018	0.00	0.034	0.033		Set Trigger
5	2.545	0.019	0.00	0.035	0.035		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



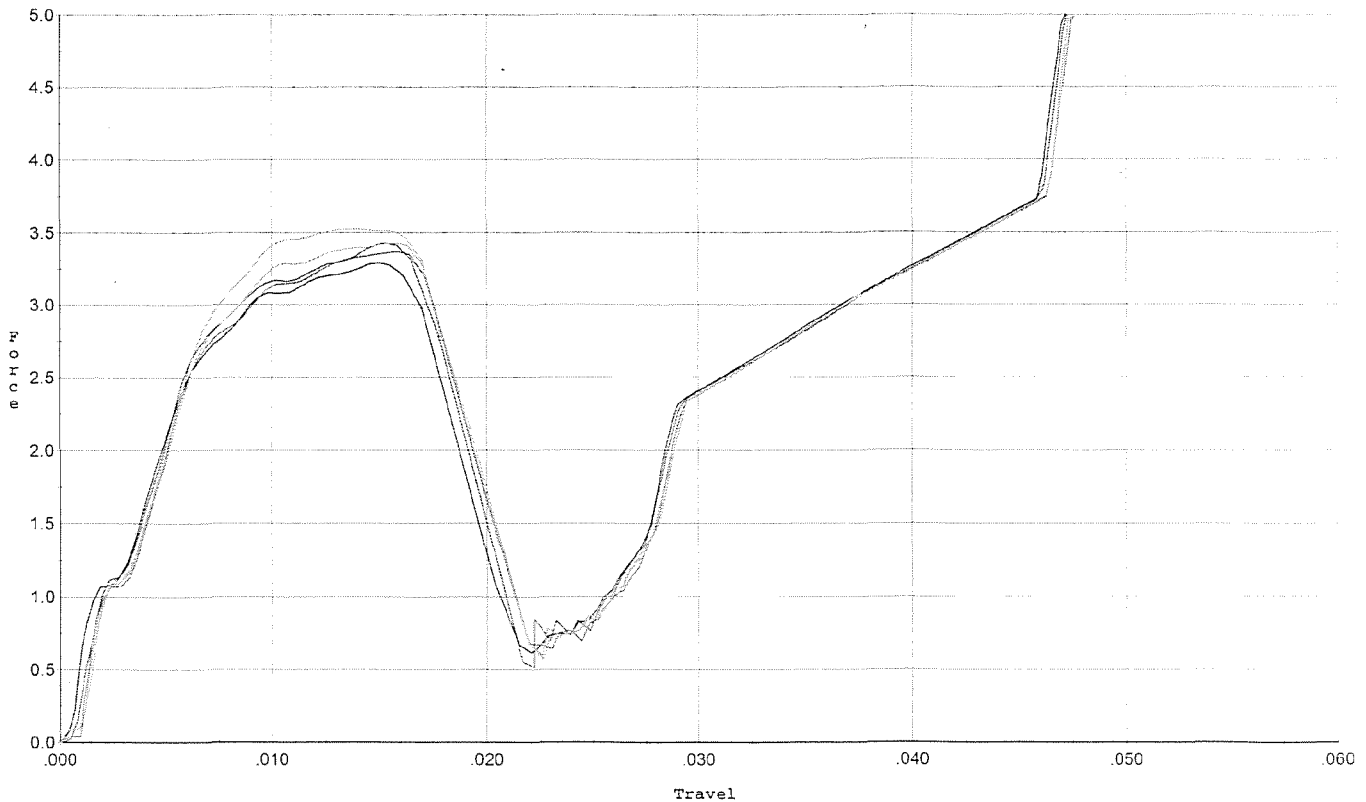
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.128	0.017	0.00	0.032	0.035		Set Trigger
2	3.315	0.017	0.00	0.032	0.039		Set Trigger
3	3.369	0.018	0.00	0.032	0.041		Set Trigger
4	3.128	0.018	0.00	0.032	0.040		Set Trigger
5	3.289	0.018	0.00	0.032	0.040		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



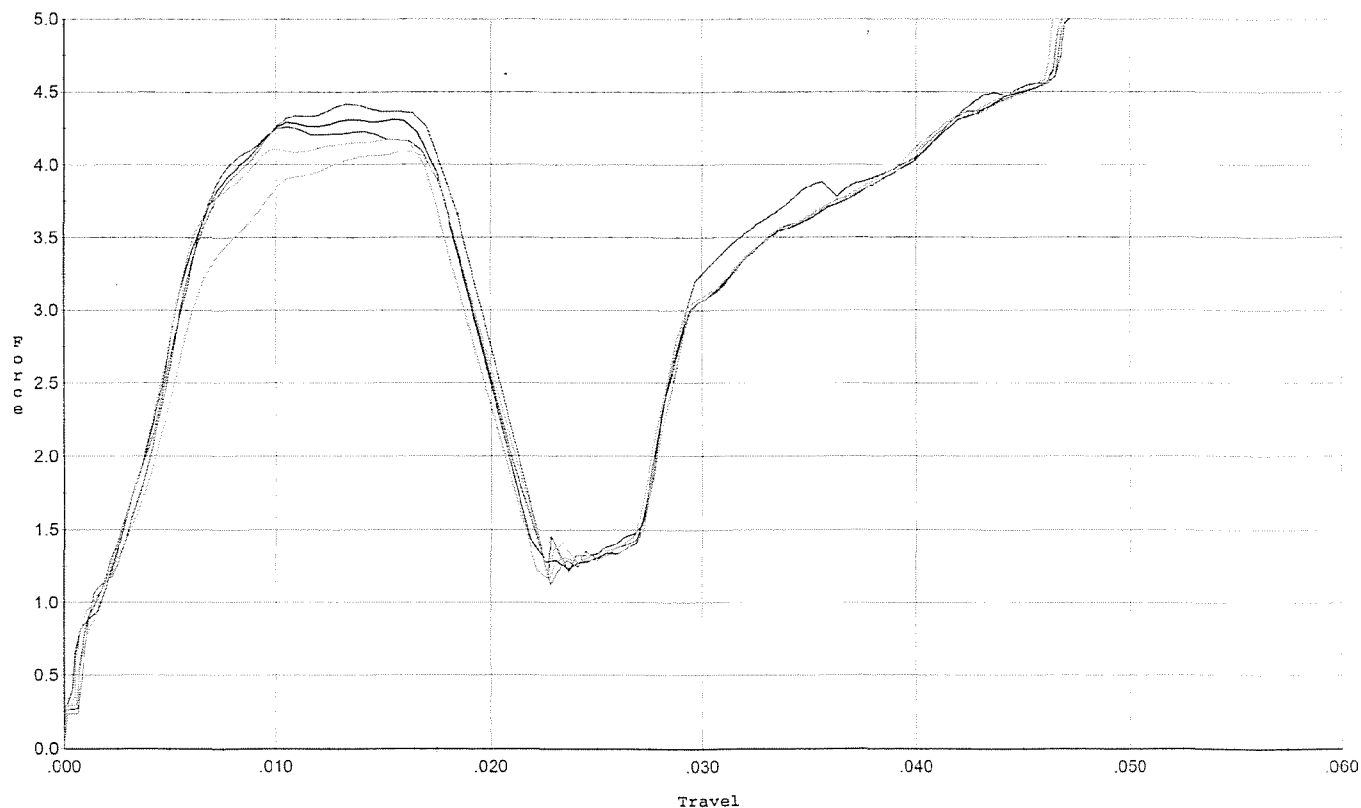
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.429	0.018	0.00	0.032	0.041		Set Trigger
2	3.291	0.017	0.00	0.032	0.039		Set Trigger
3	3.369	0.017	0.00	0.032	0.039		Set Trigger
4	3.428	0.019	0.00	0.031	0.045		Set Trigger
5	3.521	0.017	0.00	0.032	0.041		Set Trigger

A 3.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



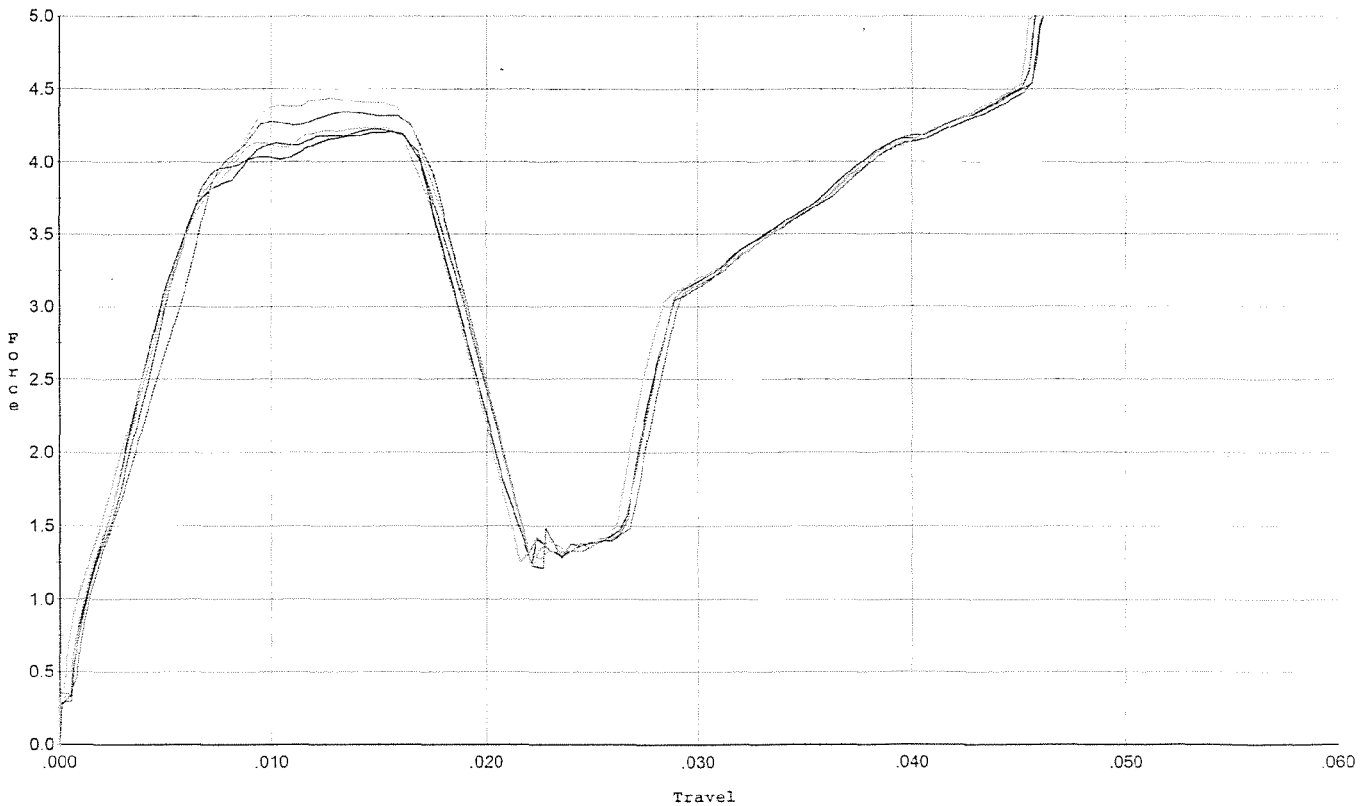
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.262	0.018	0.00	0.029	0.053		Set Trigger
2	4.311	0.018	0.00	0.029	0.053		Set Trigger
3	4.418	0.018	0.00	0.029	0.056		Set Trigger
4	4.094	0.018	0.00	0.029	0.049		Set Trigger
5	4.175	0.017	0.00	0.029	0.050		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



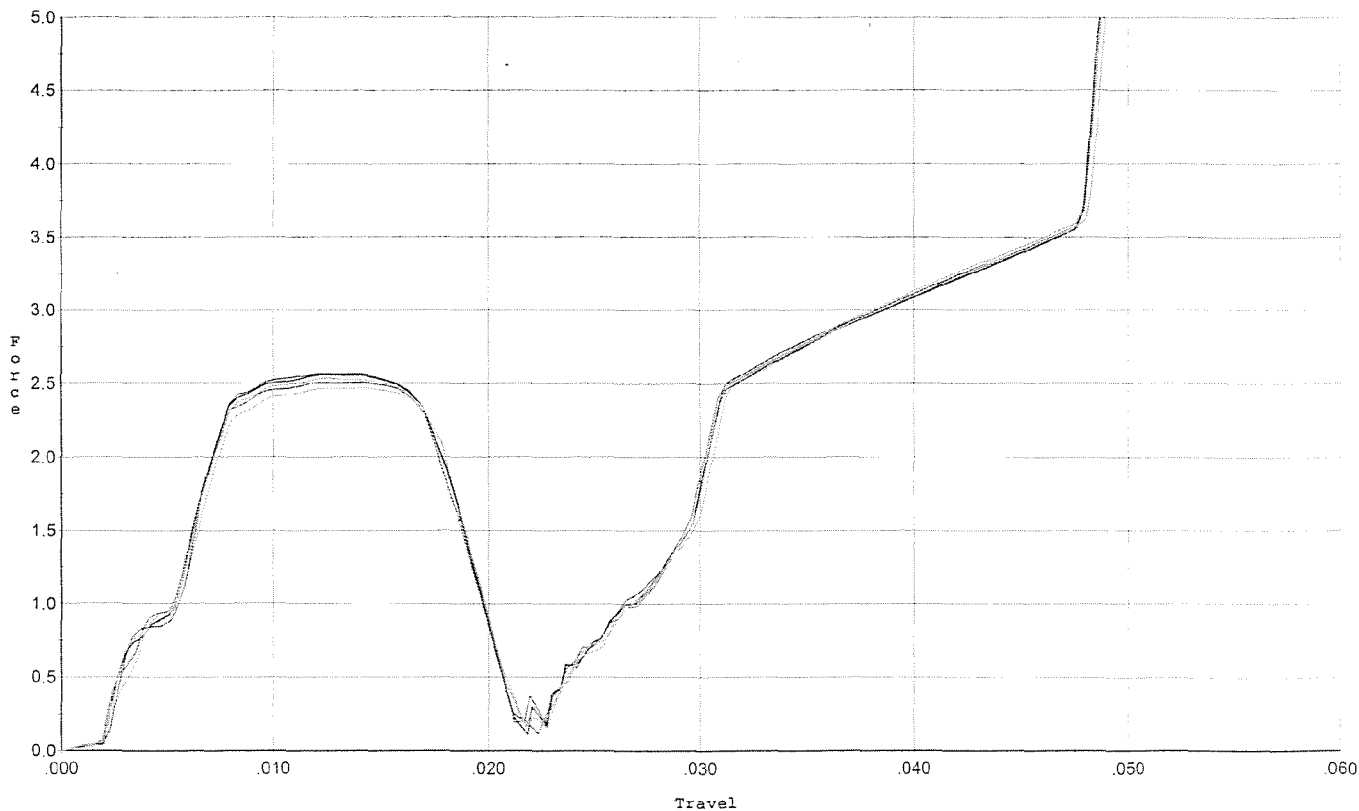
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.224	0.019	0.00	0.029	0.056		Set Trigger
2	4.209	0.017	0.00	0.029	0.051		Set Trigger
3	4.345	0.018	0.00	0.029	0.053		Set Trigger
4	4.438	0.018	0.00	0.028	0.056		Set Trigger
5	4.236	0.017	0.00	0.028	0.053		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



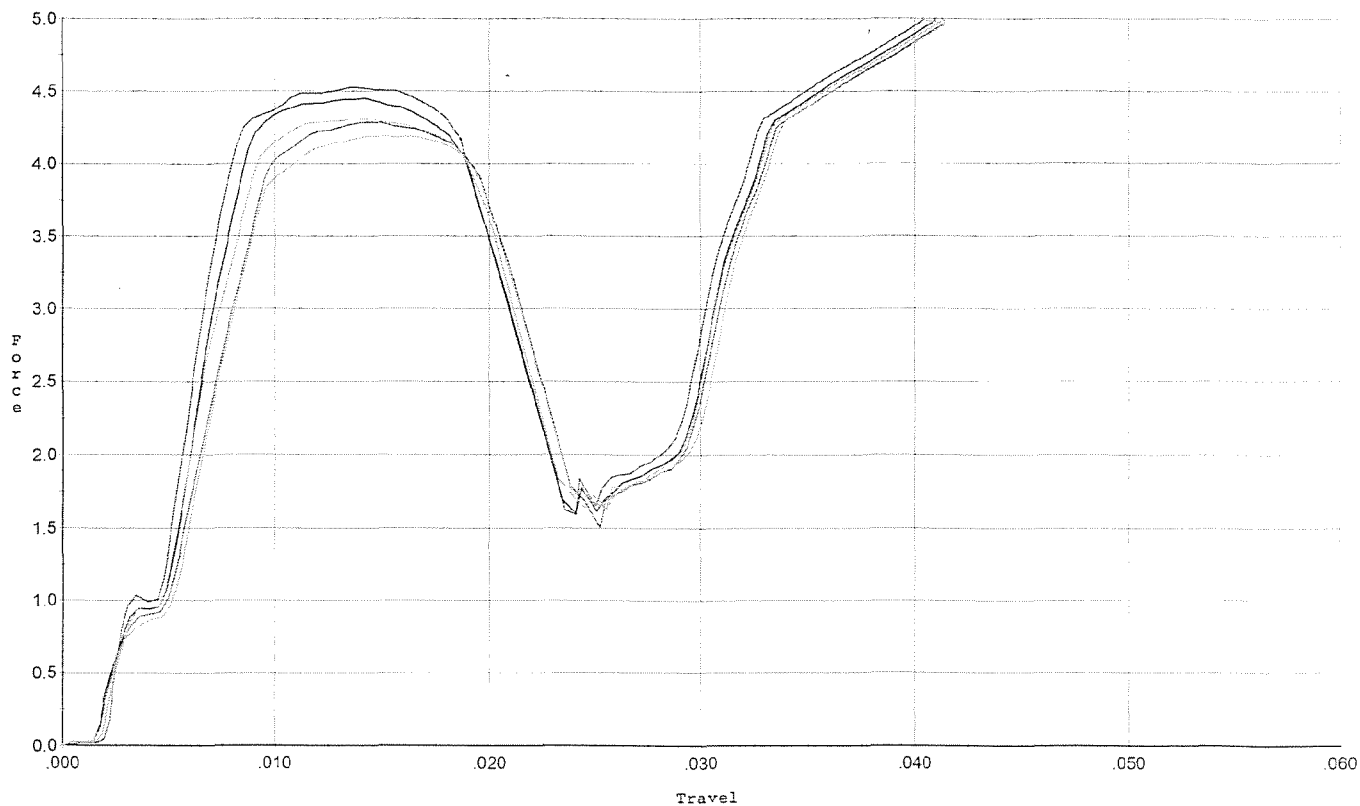
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.018	0.002	0.033	0.030		Set Trigger
2	2.558	0.018	0.00	0.033	0.030		Set Trigger
3	2.504	0.019	0.00	0.033	0.031		Set Trigger
4	2.468	0.018	0.002	0.034	0.029		Set Trigger
5	2.534	0.018	0.00	0.033	0.030		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.527	0.019	0.00	0.029	0.054		Set Trigger
2	4.450	0.021	0.00	0.030	0.059		Set Trigger
3	4.285	0.021	0.00	0.030	0.057		Set Trigger
4	4.191	0.021	0.002	0.030	0.056		Set Trigger
5	4.309	0.020	0.002	0.030	0.055		Set Trigger

A-4-35