

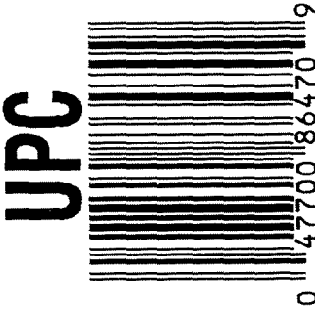
674 9765

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

G6749765



BM FORM

GUN SERIAL #

G6749765

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6/11/08	S.P.N.
430	ASSEMBLE TO STOCK		6/11/08	SP
440	PROOF		6-11-08	SD
460	CHECK HEADSPACE		6-11-08	SD
470	DIS-ASSEMBLE ACTION		6/11/08	S.P.N.
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	6-16-08	S.P.N.
475	DRILL AND TAP SIGHT HOLES	JUN 26 2008	6-17-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR: <i>curms</i>	6/20/08	<i>curms</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/18/08	RT
520	GOFF BLAST BBL / REC		6/20	RT
542	APPLY COATINGS (BARREL ACTION)		6-25-08	<i>u</i>
545	(BOLT)			
560	RE-ASSEMBLE ACTION		6/26/08	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6/26/08	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6/26/08	RP
	D) OIL FIRING PIN ASSEMBLY		6-27-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

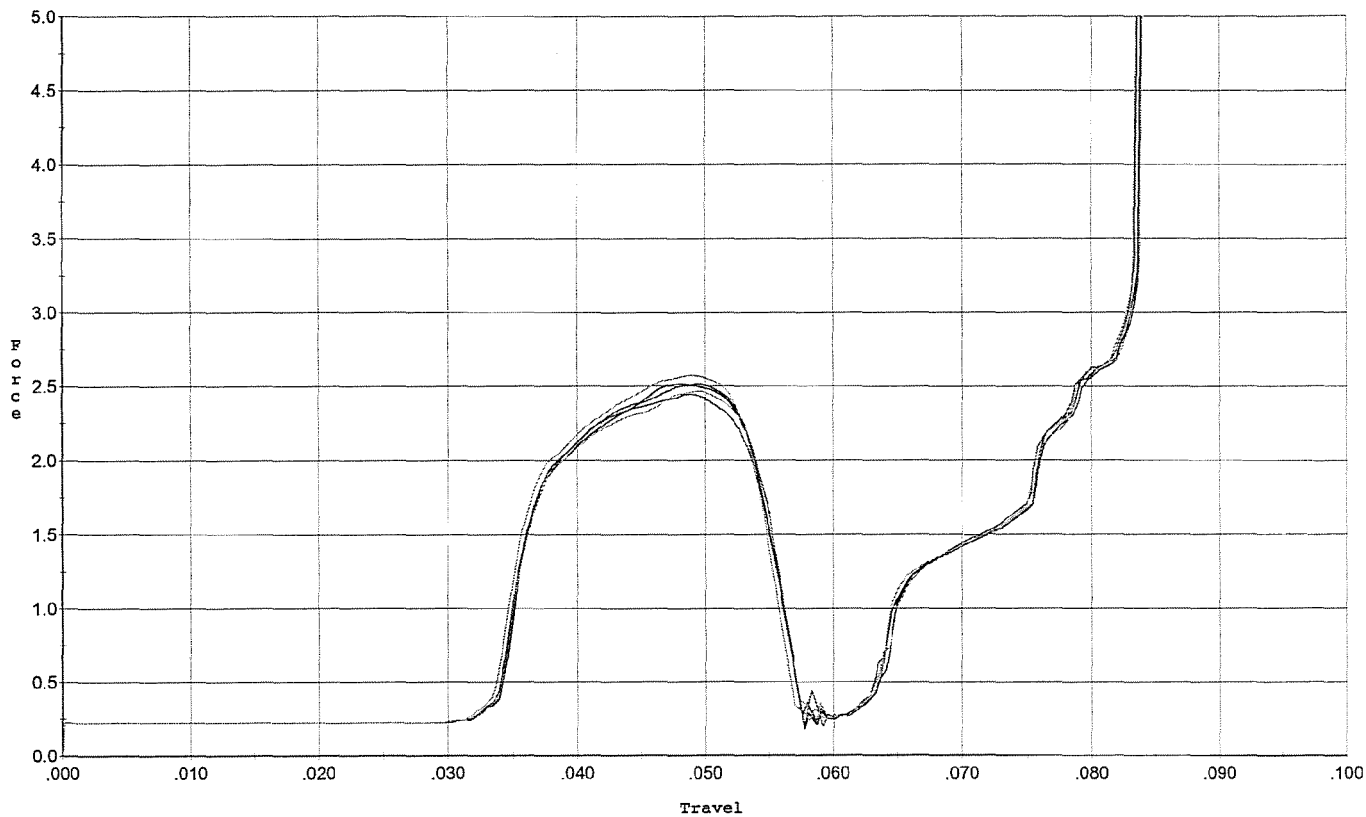
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	7/10/08	Fm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	7/10/08	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	7/10/08	Fm
	J) ASSEMBLE STOCK		6-27-08	LSN
	K) ASSEMBLE SWIVEL STUDS		7/21/08	Fm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-21/08	L.P.D.
	M) IRON SIGHT ALIGNMENT		7/21/08	L.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7/21/08	L.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-1-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/1/08	RP
670	FINAL INSPECTION A) HEADSPACE		7/21/08	Fm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.03</u> <u>2.12</u> <u>2.04</u> <u>2.16</u> <u>2.13</u>	7-8-08	SD
	C) FUNCTION		7/21/08	Fm
690	PACK		7/21/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R,Putch 5/15/08

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



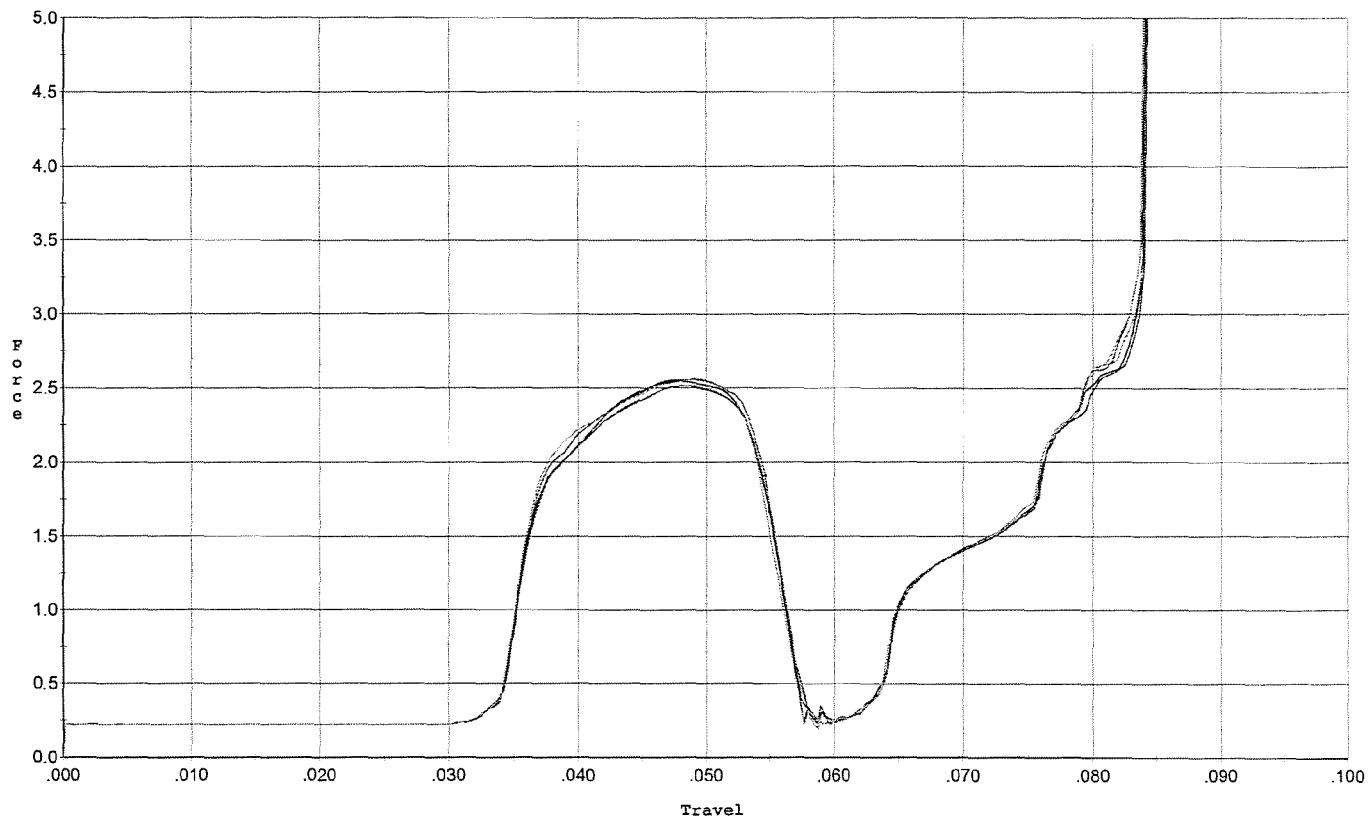
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.055	0.034	0.035	0.052		Set Trigger
2	2.515	0.055	0.034	0.035	0.052		Set Trigger
3	2.445	0.056	0.034	0.034	0.052		Set Trigger
4	2.465	0.055	0.034	0.035	0.052		Set Trigger
5	2.572	0.054	0.034	0.035	0.053		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R,Putch 5/15/08

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



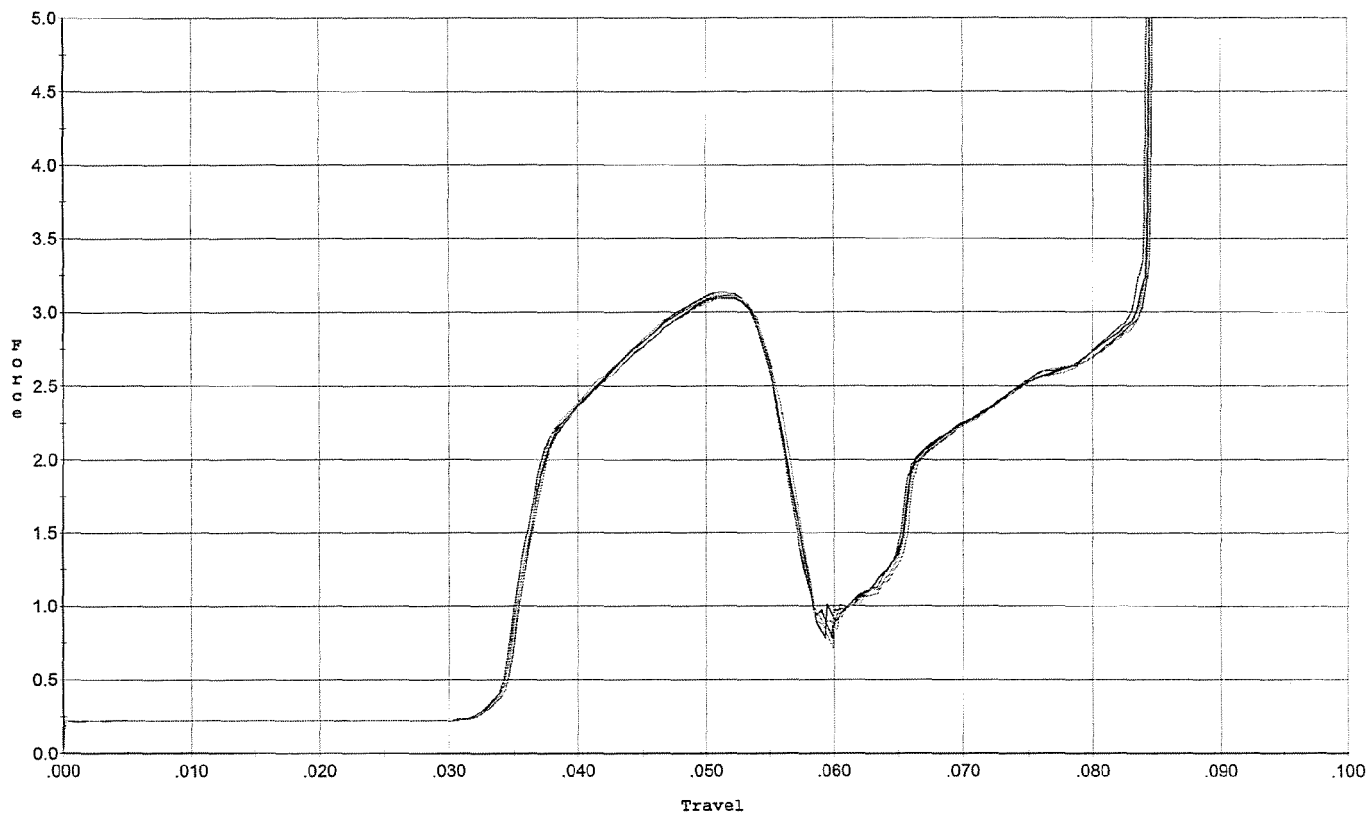
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.055	0.034	0.035	0.052		Set Trigger
2	2.546	0.055	0.034	0.035	0.053		Set Trigger
3	2.562	0.055	0.034	0.035	0.053		Set Trigger
4	2.554	0.054	0.034	0.035	0.052		Set Trigger
5	2.515	0.055	0.034	0.035	0.052		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R,Putch 5/15/08

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



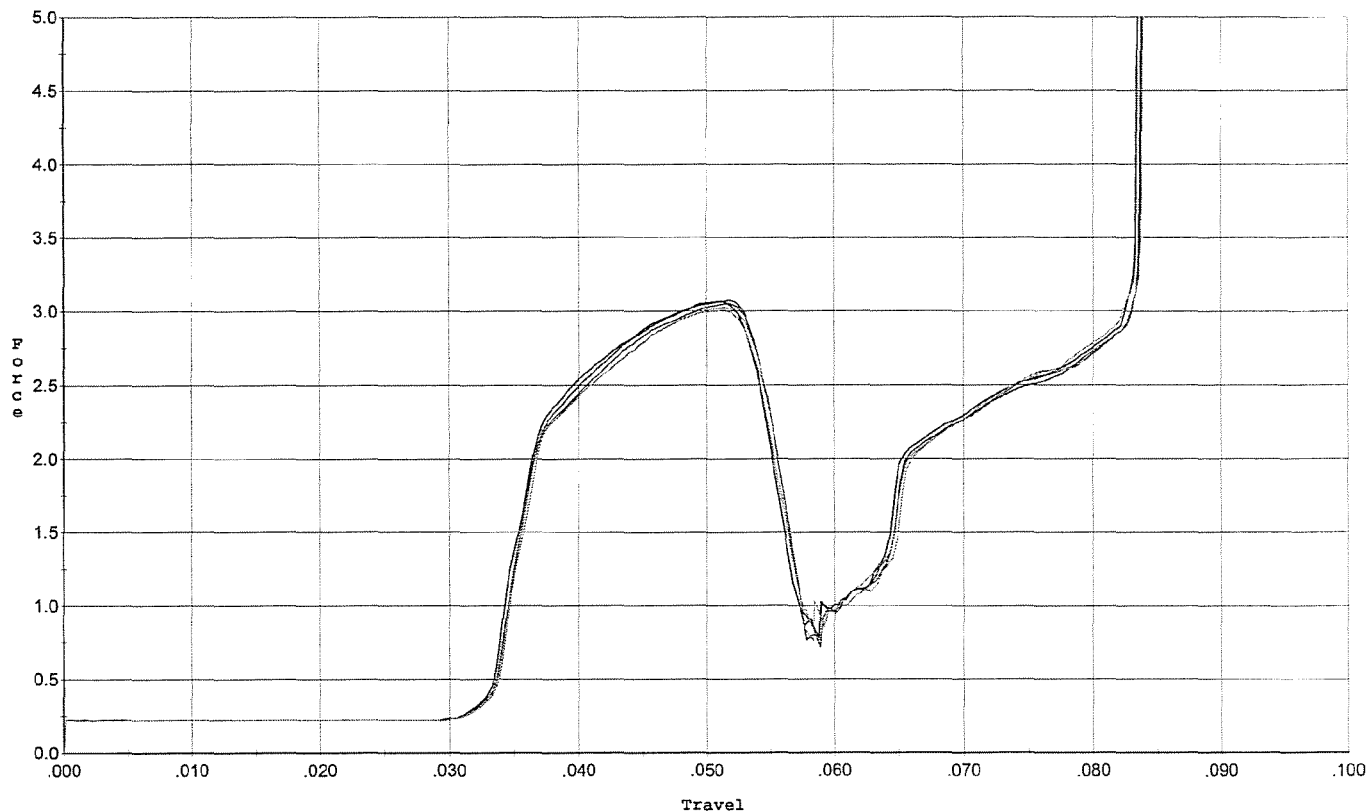
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.055	0.035	0.035	0.062		Set Trigger
2	3.092	0.055	0.034	0.034	0.062		Set Trigger
3	3.107	0.055	0.034	0.034	0.062		Set Trigger
4	3.102	0.056	0.035	0.034	0.063		Set Trigger
5	3.122	0.055	0.034	0.034	0.062		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R,Putch 5/15/08

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



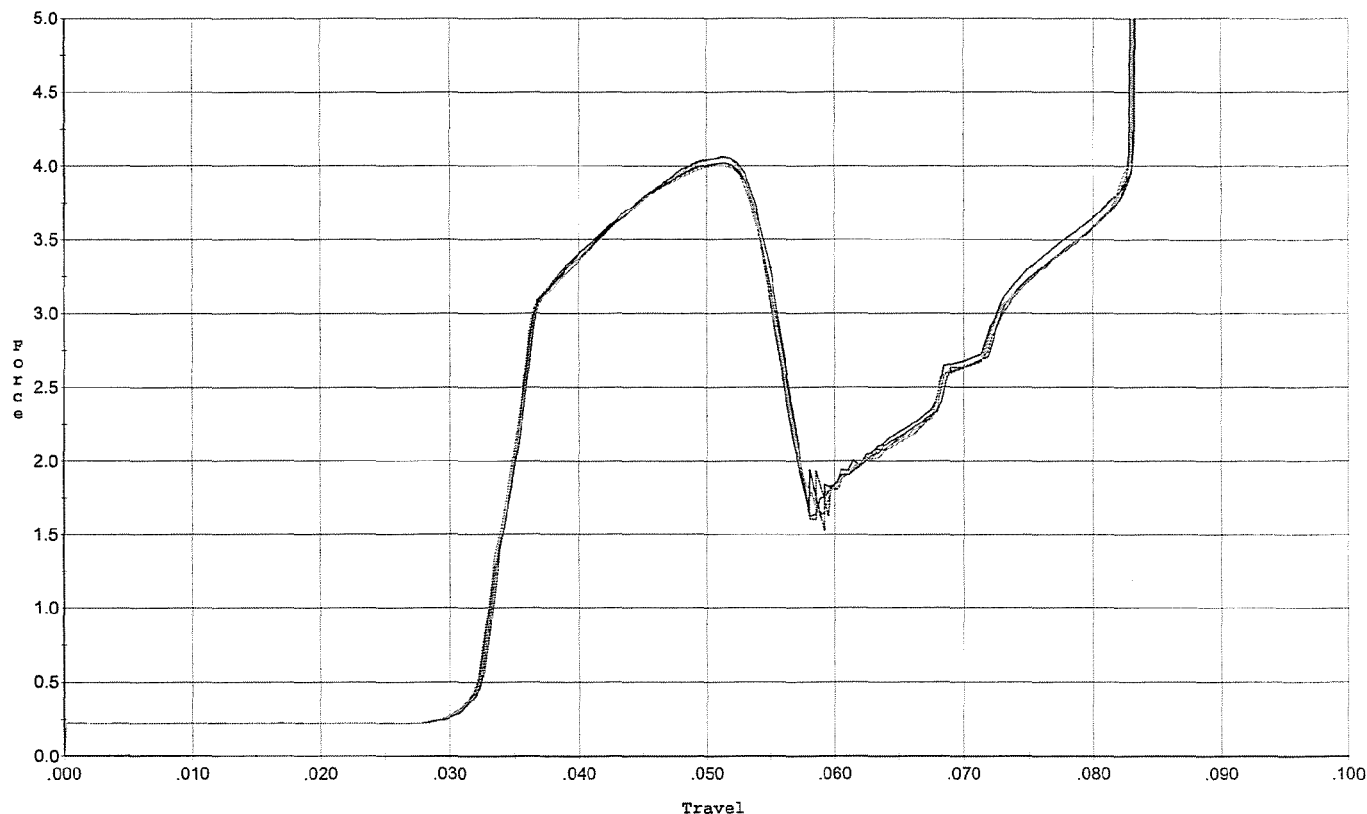
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.055	0.034	0.034	0.063		Set Trigger
2	3.064	0.054	0.033	0.034	0.062		Set Trigger
3	3.048	0.055	0.034	0.034	0.062		Set Trigger
4	3.024	0.055	0.034	0.034	0.061		Set Trigger
5	3.007	0.056	0.034	0.034	0.062		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R,Putch 5/15/08

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



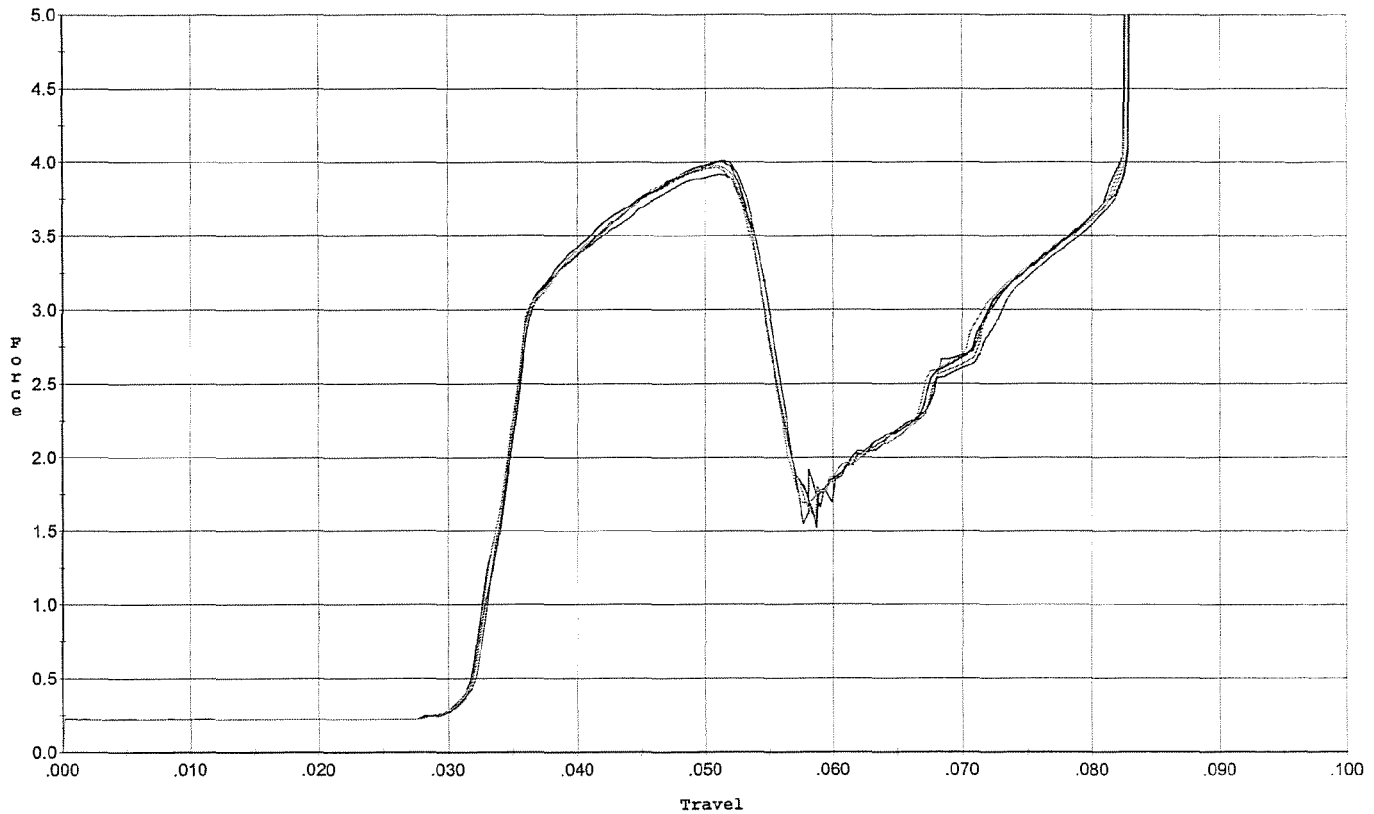
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.058	0.055	0.032	0.032	0.084		Set Trigger
2	4.018	0.054	0.032	0.032	0.082		Set Trigger
3	4.022	0.056	0.032	0.032	0.084		Set Trigger
4	4.004	0.054	0.032	0.032	0.082		Set Trigger
5	4.066	0.054	0.032	0.032	0.082		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R,Putch 5/15/08

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



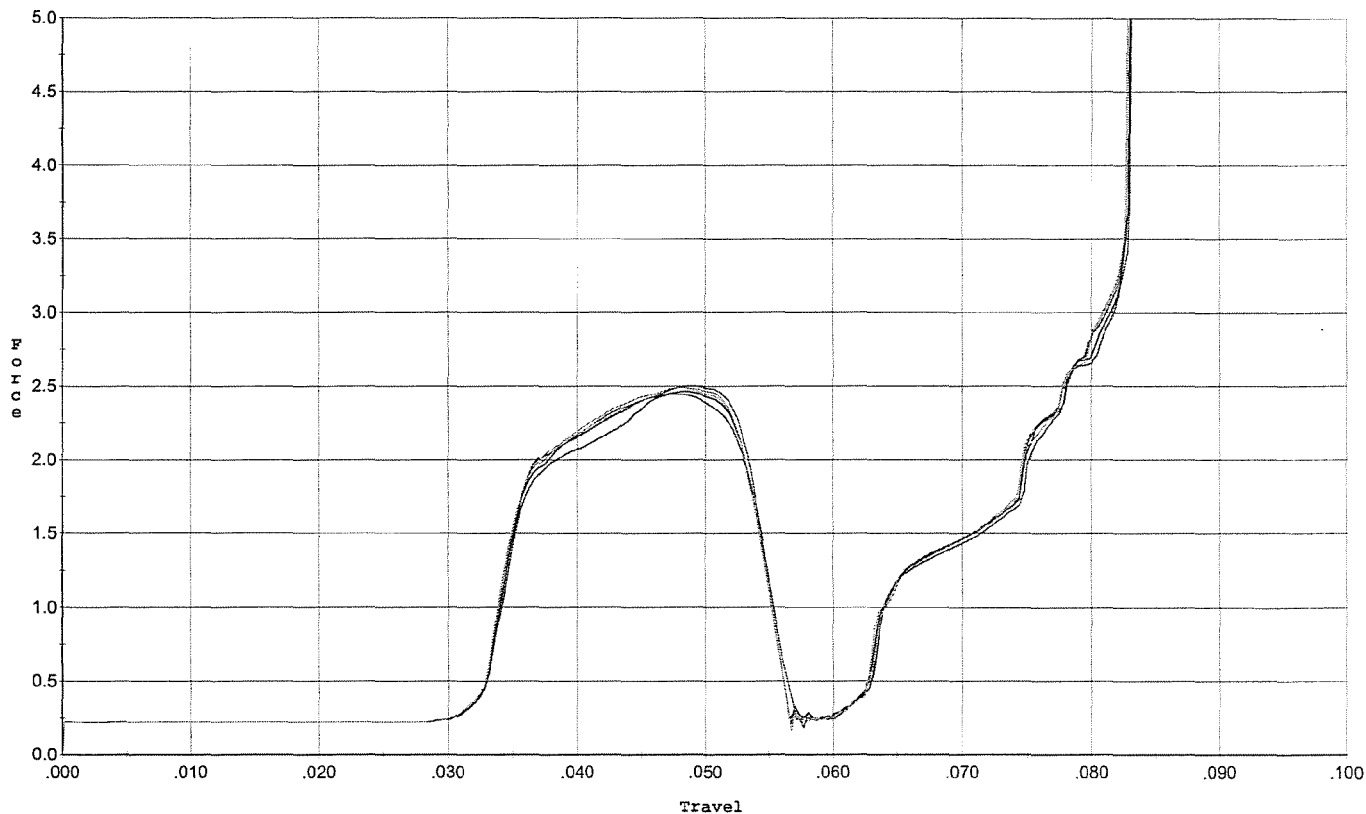
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.012	0.055	0.032	0.032	0.083		Set Trigger
2	4.004	0.054	0.032	0.032	0.081		Set Trigger
3	3.915	0.054	0.032	0.032	0.080		Set Trigger
4	3.960	0.054	0.032	0.032	0.081		Set Trigger
5	3.972	0.054	0.032	0.032	0.080		Set Trigger

Avg 3.97

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R,Putch 5/15/08

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



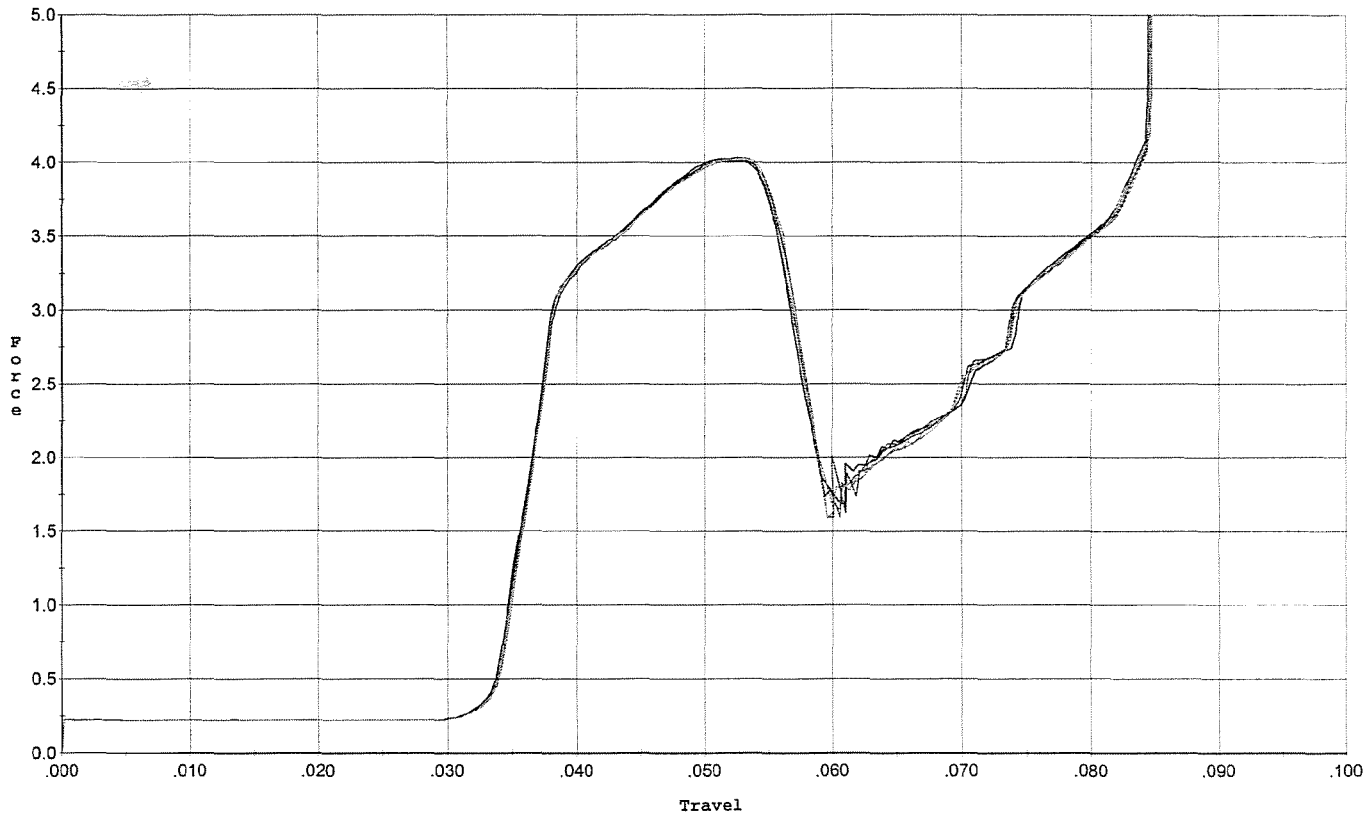
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.054	0.033	0.034	0.051		Set Trigger
2	2.464	0.054	0.033	0.034	0.052		Set Trigger
3	2.502	0.054	0.033	0.034	0.052		Set Trigger
4	2.493	0.054	0.033	0.034	0.053		Set Trigger
5	2.491	0.054	0.033	0.034	0.052		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R,Putch 5/15/08

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	4.010	0.056	0.034	0.033	0.084		Set Trigger
2	4.028	0.056	0.034	0.033	0.082		Set Trigger
3	4.010	0.057	0.034	0.032	0.085		Set Trigger
4	4.024	0.057	0.034	0.033	0.084		Set Trigger
5	4.028	0.056	0.034	0.033	0.084		Set Trigger

Avg 4.02