

5674 9789

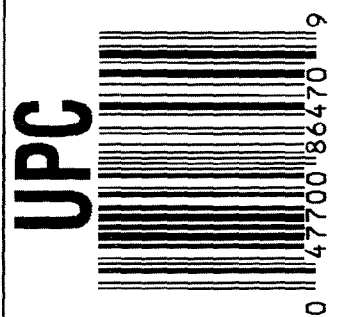
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



ORDER NO. **86470**

BARREL LENGTH	24"
CAPACITY	6

G6749789



BM FORM

GUN SERIAL # G 6749789

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-24-08	RP
430	ASSEMBLE TO STOCK		6-24-08	SP
440	PROOF		6-24-08	SD
460	CHECK HEADSPACE		6-24-08	SD
470	DIS-ASSEMBLE ACTION		6-24-08	RP
472	SERIALIZE RECHARGE HANDLE		6-25-08	RP
475	DRILL REAR AP SIGHT HOLES	MAGNA FLUX 2008	6-24-08	SD
480	MAGNAFLUX BBL ACTION	OPERATOR WMS	6-26-08	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-27-08	RT
520	GOFF BLAST BBL / REC		6/27	BT
542	APPLY COATINGS (BARREL ACTION)		7-9	CM
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-18-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-18-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-18-08	SP
	D) OIL FIRING PIN ASSEMBLY		7-21-08	PSA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

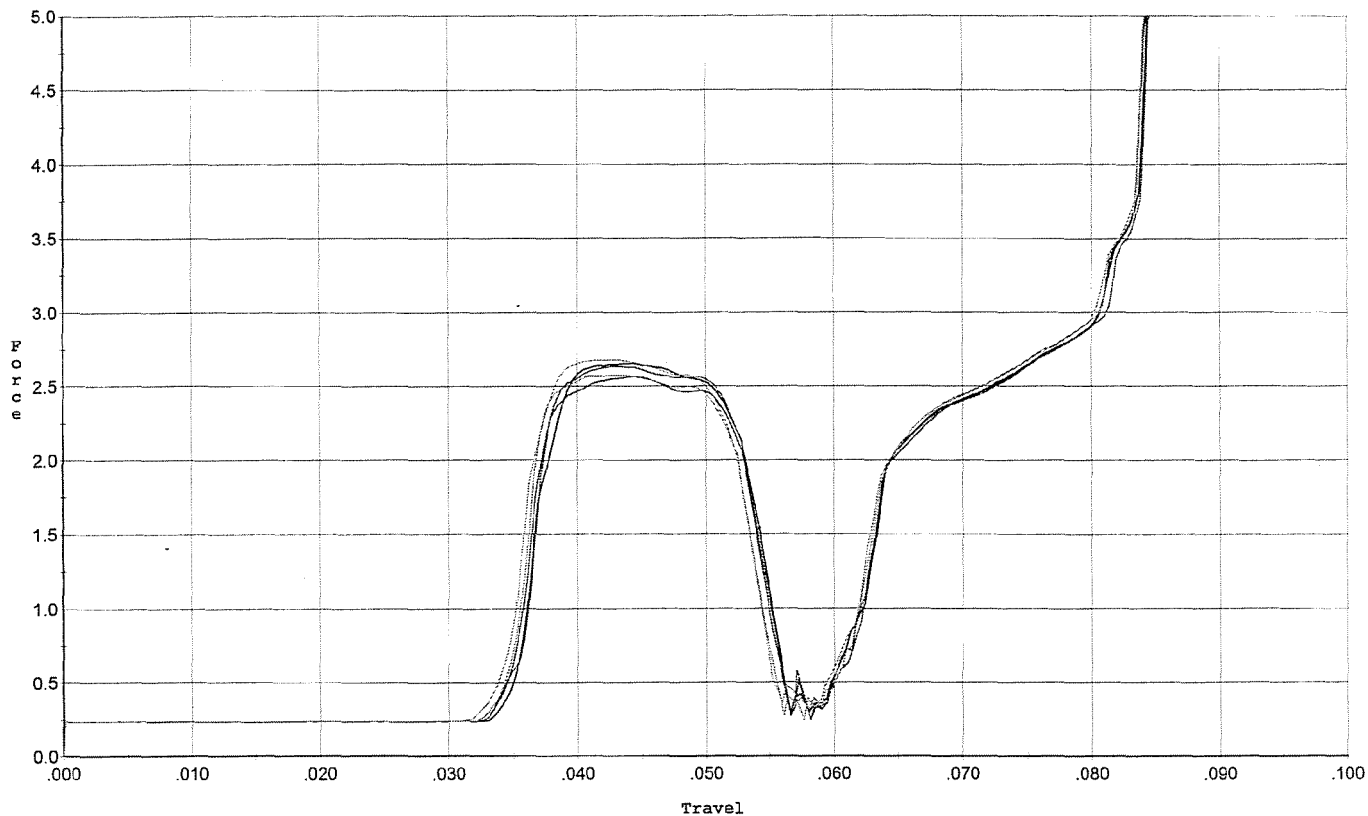
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>6</u>	7-30	TC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.5</u> <u>6.5</u> <u>6.5</u>	7-30	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	7-30	TC
	J) ASSEMBLE STOCK		7-21-08	RSN
	K) ASSEMBLE SWIVEL STUDS		8-4-08	J.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-4-08	J.P.D.
	M) IRON SIGHT ALIGNMENT		8-4-08	J.P.D.
	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	7-24-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/24/08	MEN
670	FINAL INSPECTION A) HEADSPACE		8-4-08	J.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.63</u> <u>2.53</u> <u>2.52</u> <u>2.66</u>	7-30-08	RSN
	C) FUNCTION		8-4-08	J.P.D.
690	PACK		8/6/08	FMY

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 7/18/08

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



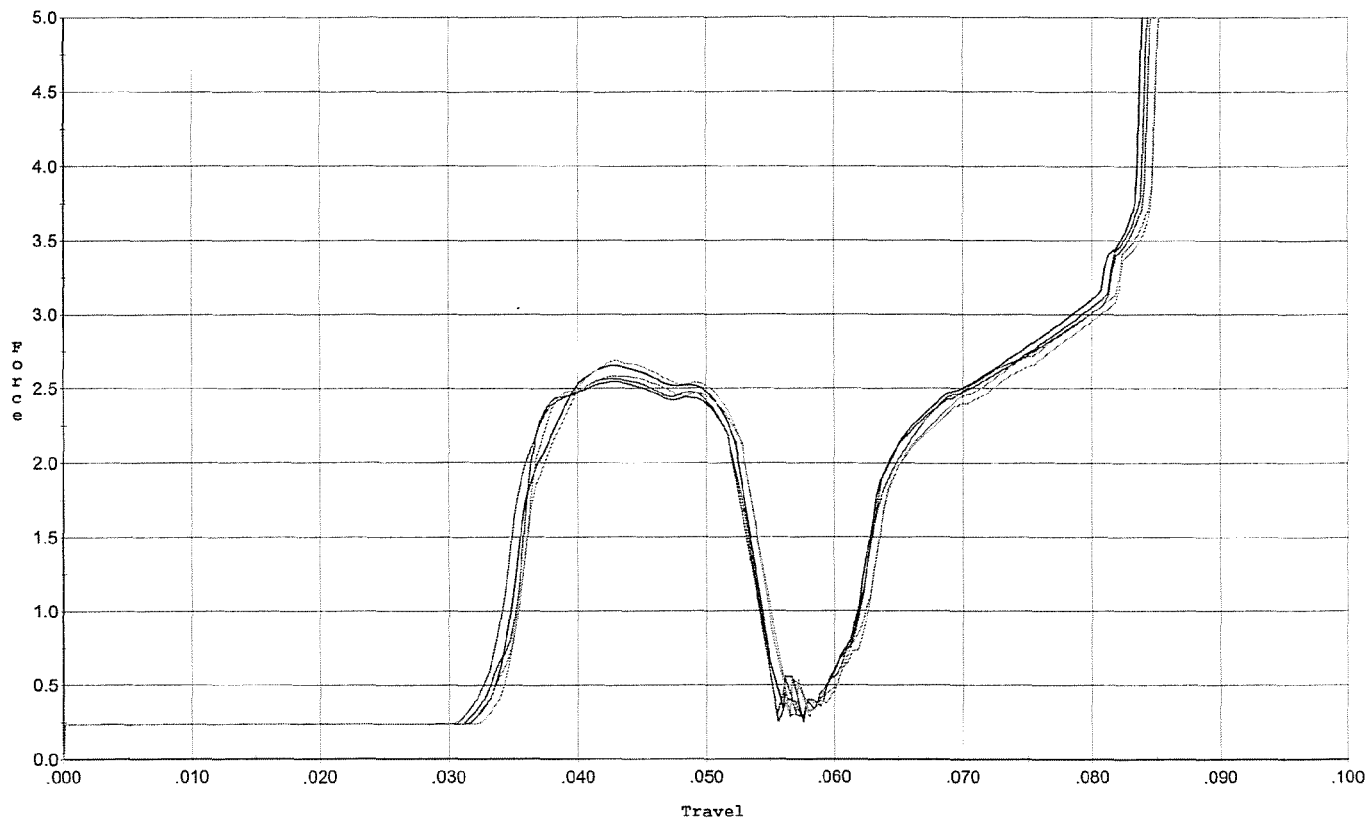
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.053	0.034	0.036	0.051		Set Trigger
2	2.650	0.054	0.035	0.036	0.052		Set Trigger
3	2.632	0.055	0.034	0.036	0.053		Set Trigger
4	2.678	0.052	0.033	0.036	0.052		Set Trigger
5	2.573	0.052	0.034	0.036	0.050		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/18/08

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



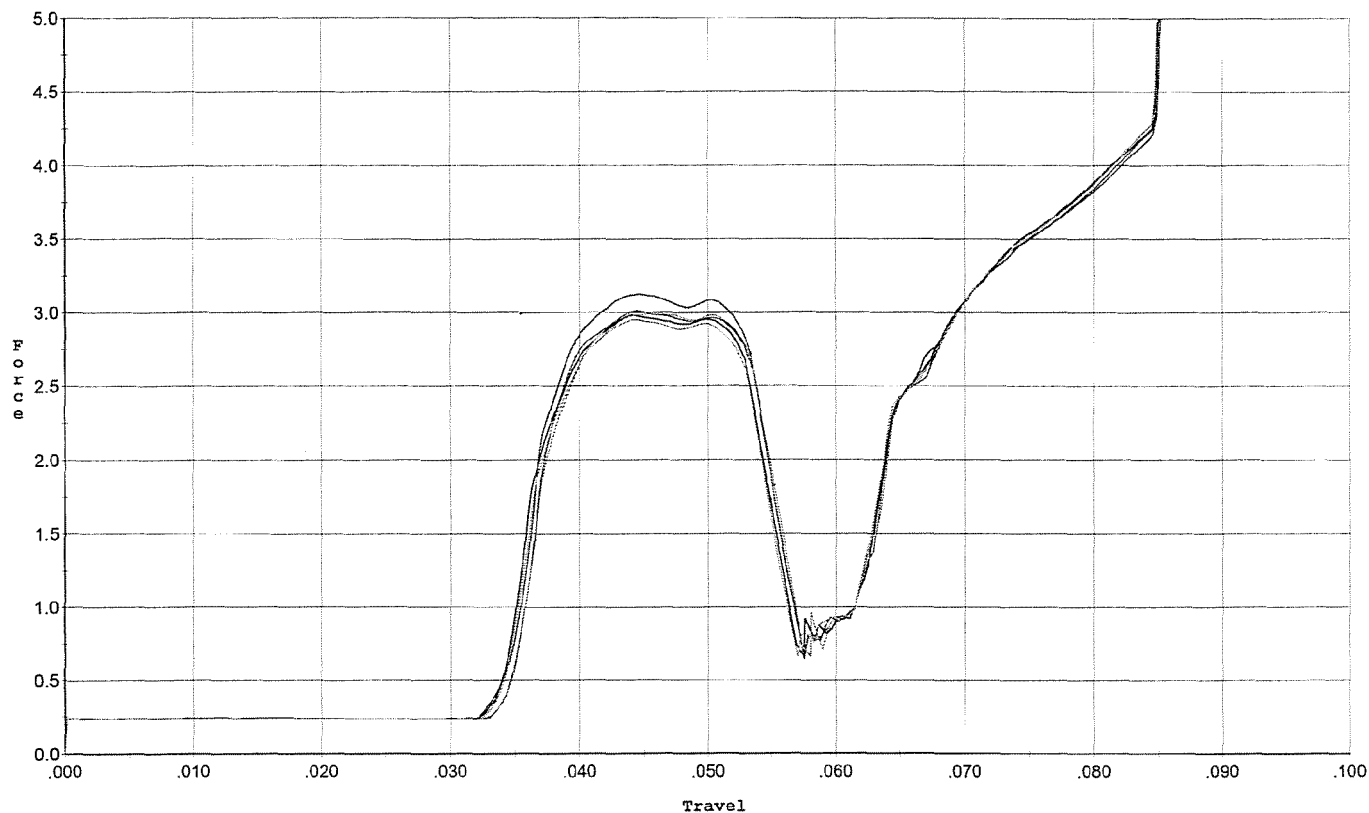
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.053	0.033	0.036	0.051		Set Trigger
2	2.651	0.052	0.033	0.036	0.051		Set Trigger
3	2.562	0.053	0.032	0.036	0.053		Set Trigger
4	2.690	0.053	0.033	0.036	0.052		Set Trigger
5	2.585	0.053	0.033	0.036	0.052		Set Trigger

AVG 2.60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/18/08

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



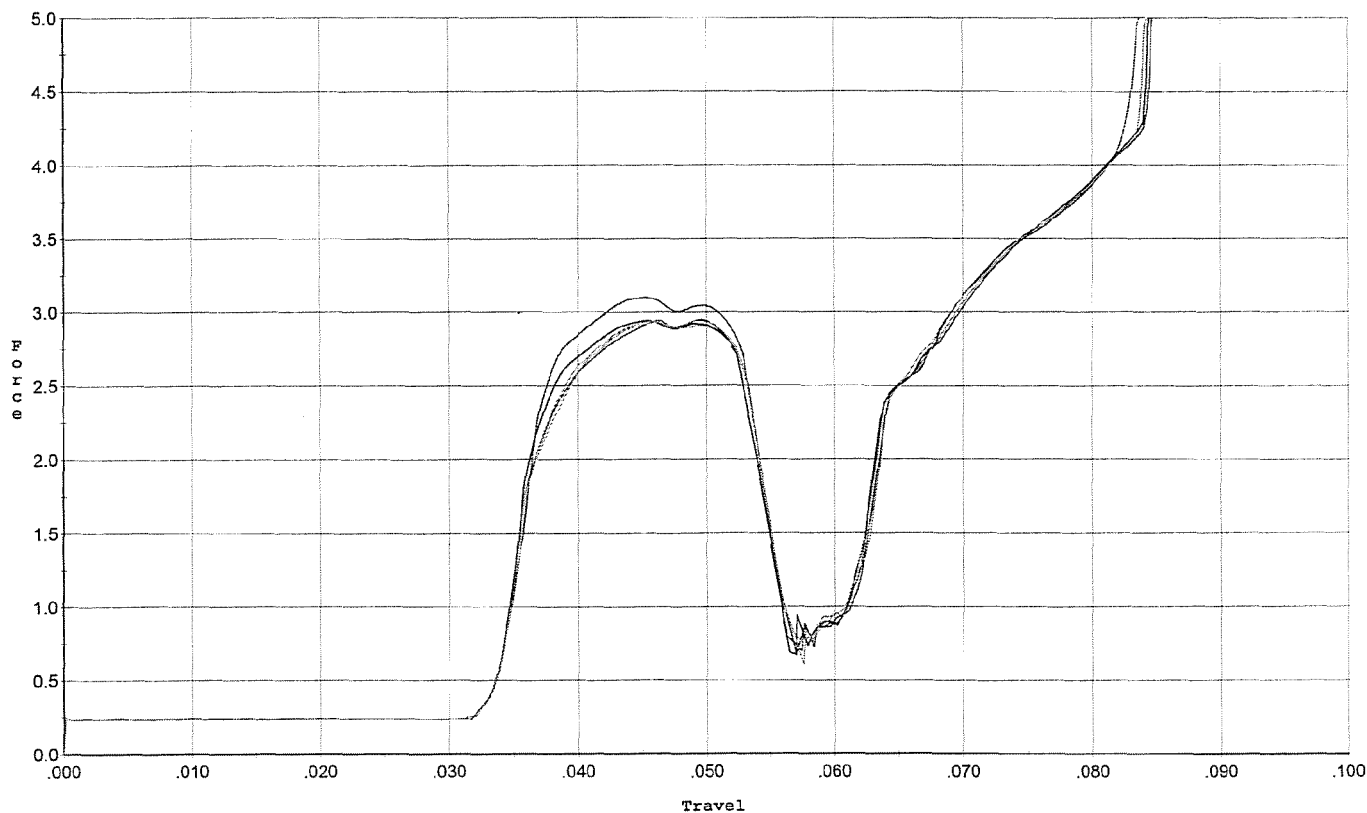
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.053	0.034	0.036	0.061		Set Trigger
2	2.981	0.055	0.034	0.036	0.061		Set Trigger
3	3.012	0.053	0.034	0.036	0.059		Set Trigger
4	2.950	0.053	0.034	0.036	0.058		Set Trigger
5	2.986	0.055	0.034	0.036	0.061		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/18/08

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



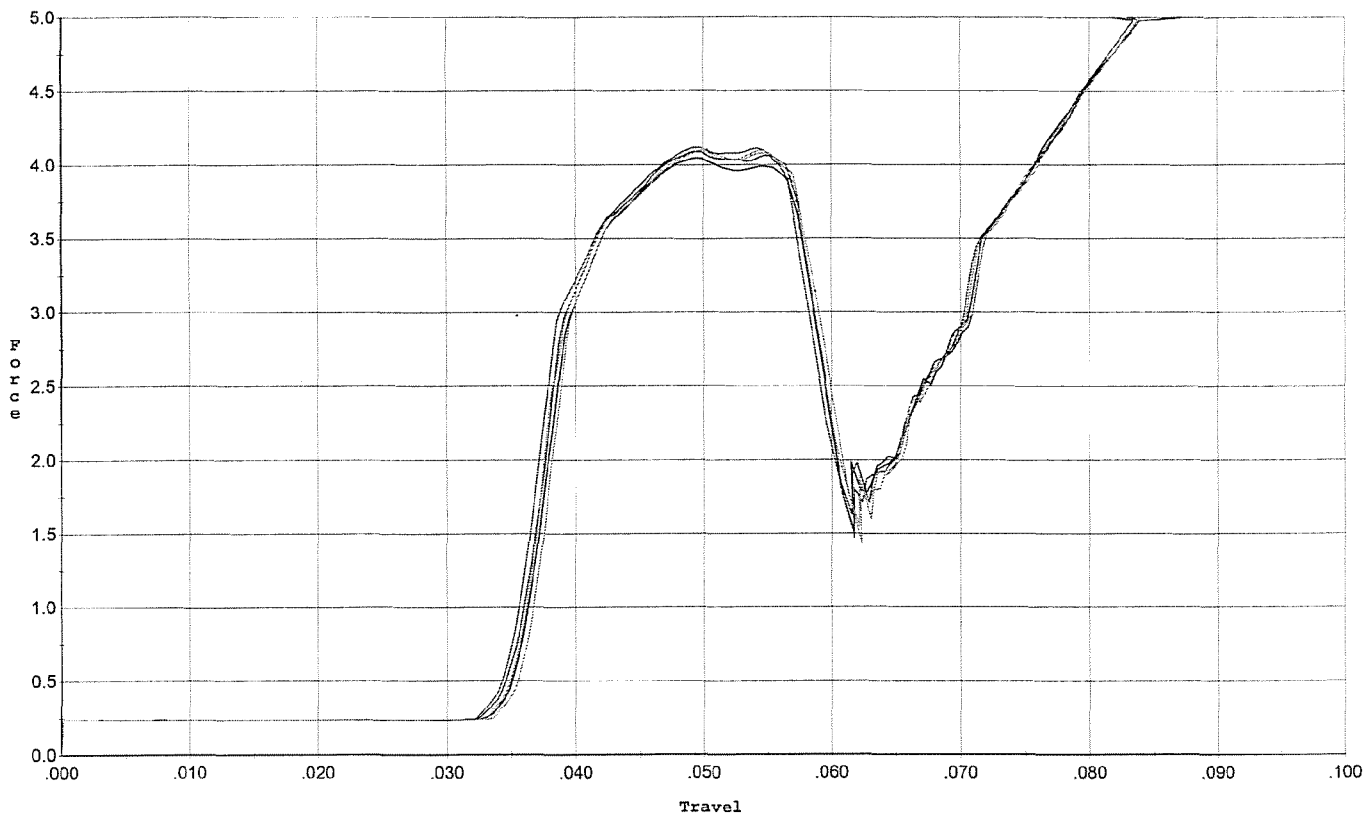
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.097	0.053	0.033	0.035	0.061		Set Trigger
2	2.939	0.054	0.033	0.035	0.060		Set Trigger
3	2.947	0.053	0.033	0.035	0.058		Set Trigger
4	2.930	0.053	0.033	0.035	0.058		Set Trigger
5	2.940	0.053	0.033	0.035	0.058		Set Trigger

Avg 2.97

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/18/08

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



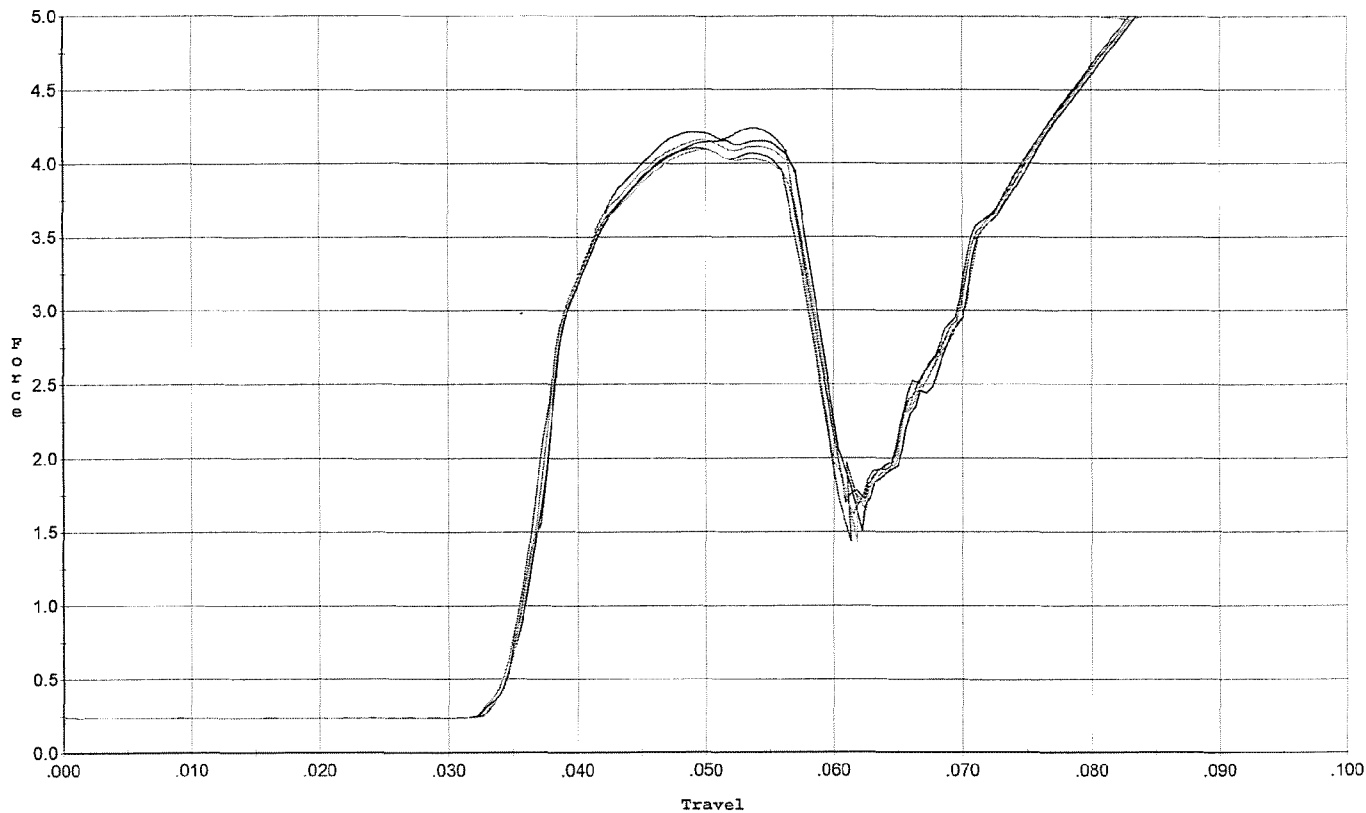
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.057	0.034	0.033	0.088		Set Trigger
2	4.049	0.058	0.035	0.034	0.087		Set Trigger
3	4.115	0.057	0.034	0.034	0.088		Set Trigger
4	4.098	0.057	0.035	0.034	0.088		Set Trigger
5	4.103	0.059	0.035	0.034	0.089		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/18/08

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



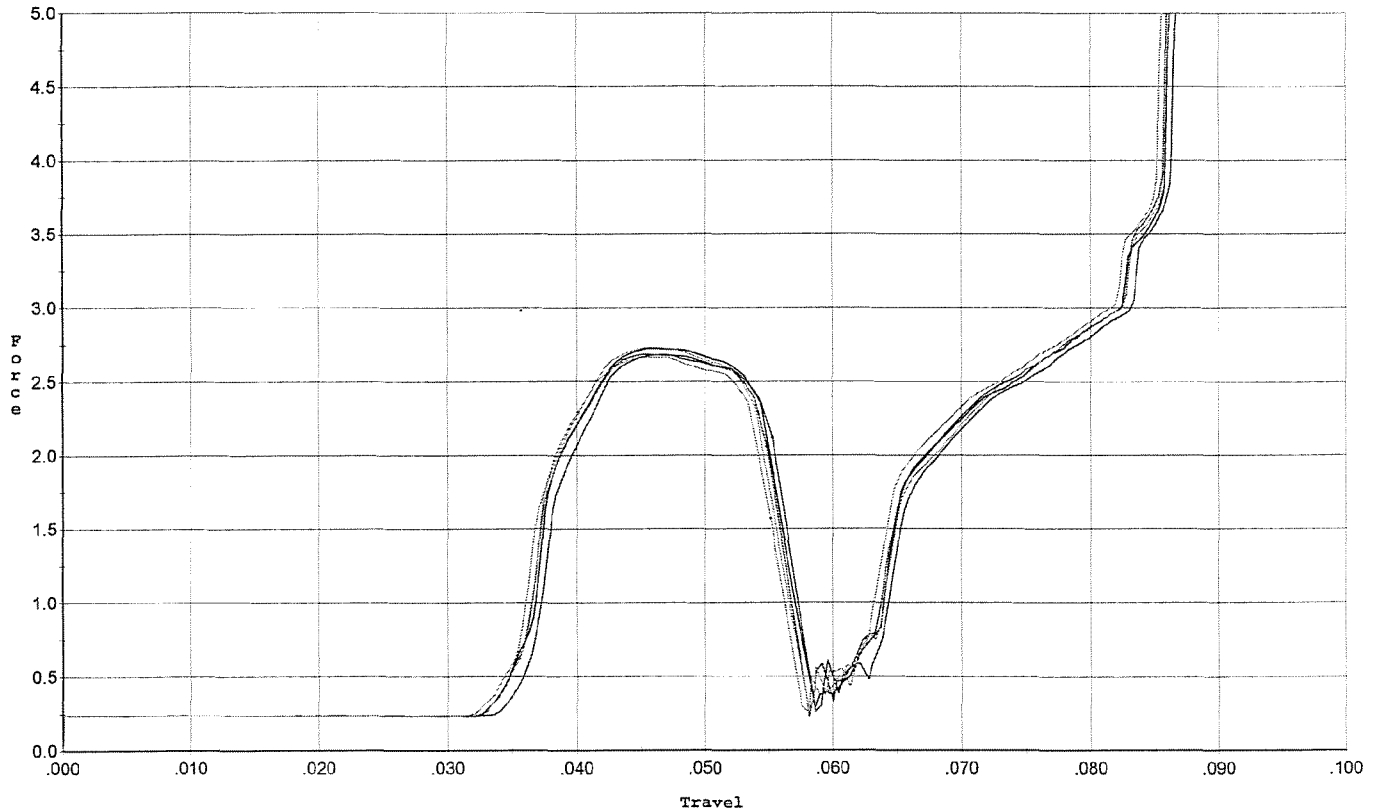
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.239	0.056	0.034	0.034	0.088		Set Trigger
2	4.157	0.057	0.034	0.034	0.089		Set Trigger
3	4.103	0.058	0.034	0.034	0.089		Set Trigger
4	4.092	0.057	0.034	0.034	0.087		Set Trigger
5	4.160	0.058	0.034	0.033	0.091		Set Trigger

AVG 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/18/08

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



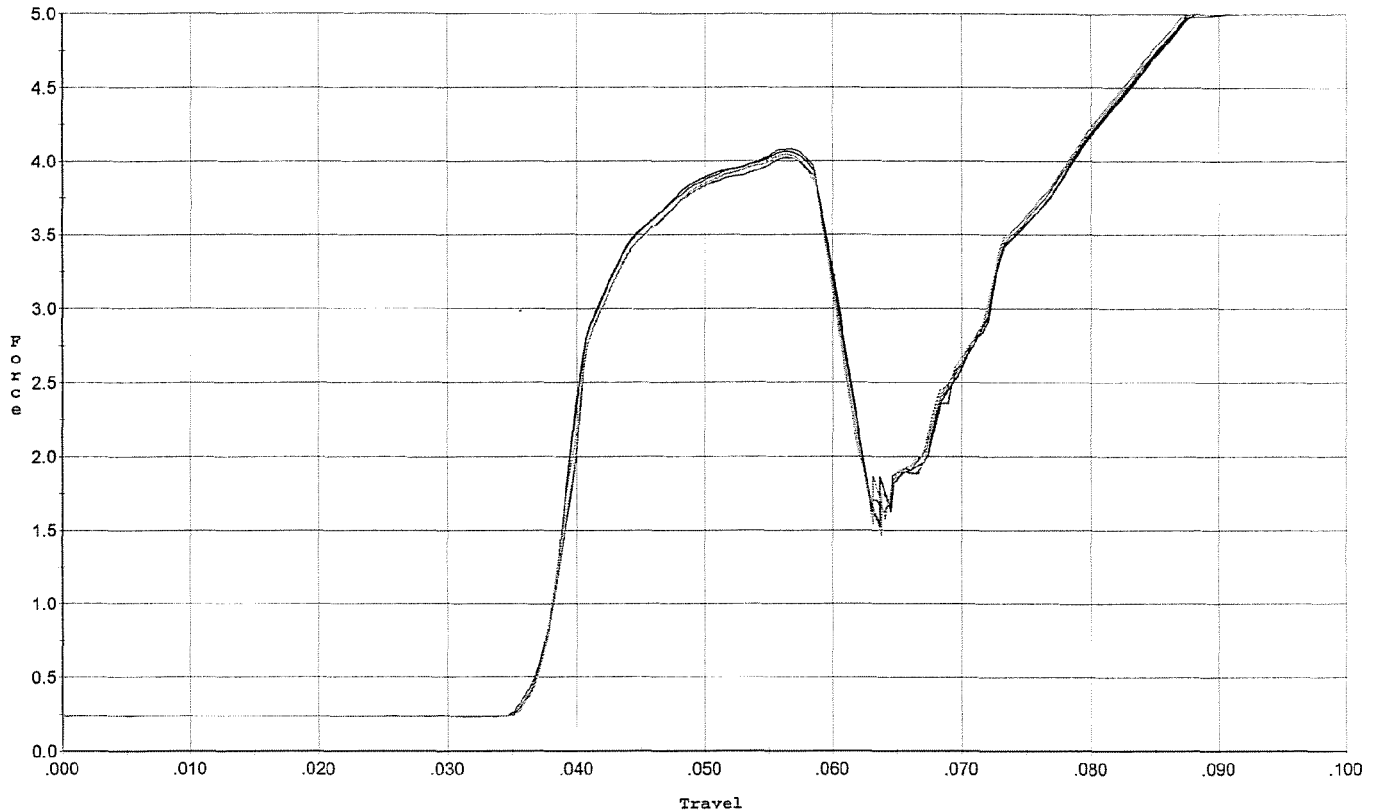
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.682	0.055	0.035	0.037	0.054		Set Trigger
2	2.724	0.054	0.034	0.037	0.055		Set Trigger
3	2.685	0.055	0.035	0.036	0.055		Set Trigger
4	2.731	0.054	0.034	0.037	0.054		Set Trigger
5	2.666	0.055	0.034	0.036	0.054		Set Trigger

Avg 2.69

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/18/08

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	4.082	0.060	0.036	0.034	0.089		Set Trigger
2	4.066	0.060	0.037	0.034	0.089		Set Trigger
3	4.021	0.059	0.036	0.035	0.084		Set Trigger
4	4.030	0.059	0.037	0.035	0.085		Set Trigger
5	4.048	0.059	0.036	0.035	0.084		Set Trigger

Avg 4.04