

6674 9853

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



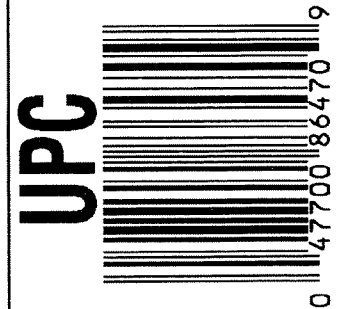
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6749853



GUN SERIAL # G6749853

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-25-08	RP
430	ASSEMBLE TO STOCK		6-25-08	SP
440	PROOF		6-25-08	SD
460	CHECK HEADSPACE		6-25-08	SD
470	DIS-ASSEMBLE ACTION		6-25-08	RP
472	SERIALIZE BOLT HANDLE		7-9-08	RP
475	DRILL AND TAP SIGHT HOLES		7-11-08	SP
480	MAGNAFLUX BBL ACTION		7-15-08	(RP)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-15-08	RT
520	GOFF BLAST BBL / REC		7-16	WS
542	APPLY COATINGS (BARREL ACTION)			
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		7-18-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

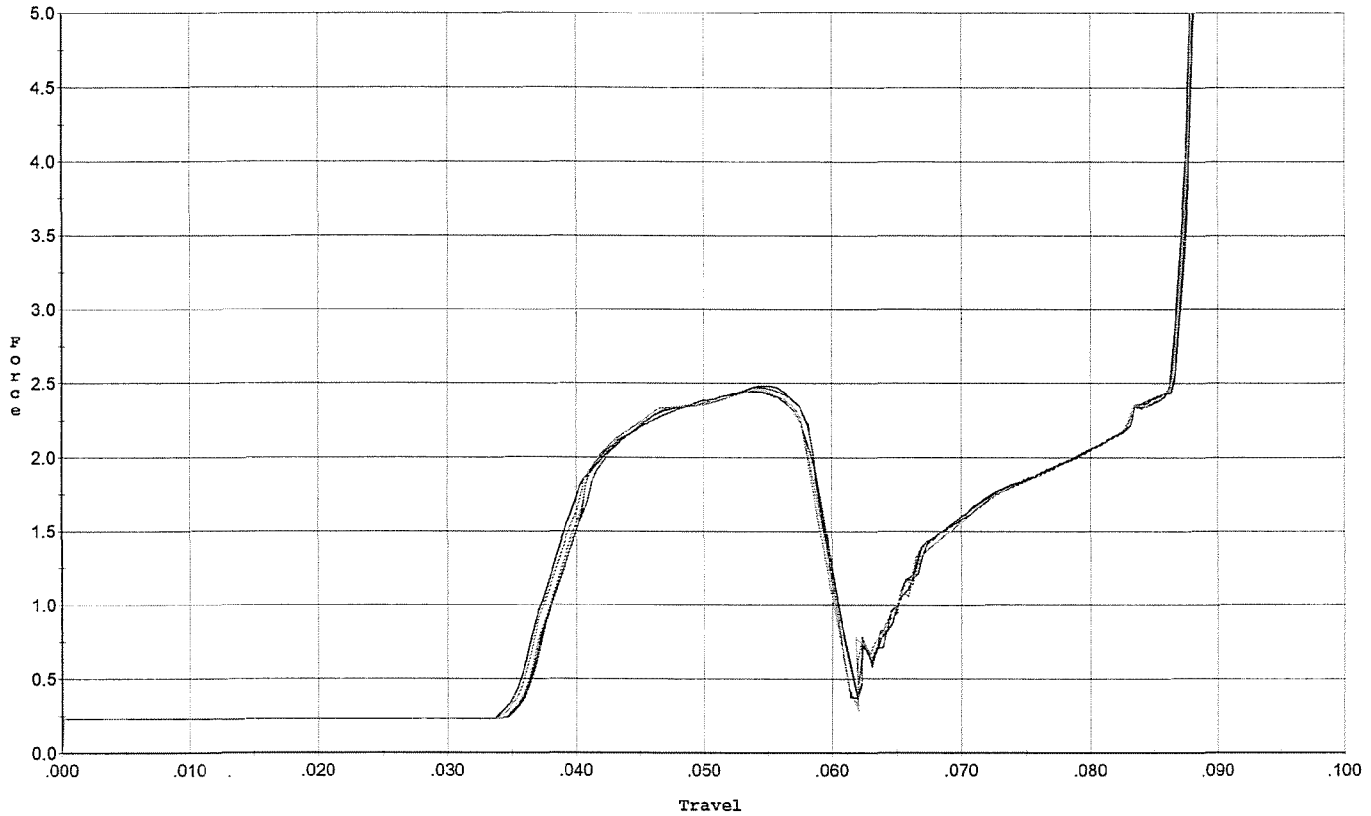
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	7-30	TC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7</u> <u>6.5</u> <u>7</u>	7-30 7-30	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	7-30	TC
	J) ASSEMBLE STOCK		7-18-08	PSW
	K) ASSEMBLE SWIVEL STUDS		8-4-08	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-4-08	L.P.D.
	M) IRON SIGHT ALIGNMENT		8-4-08	L.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	7-22-08	TRW
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/22/08	MEH
670	FINAL INSPECTION A) HEADSPACE		8-4-08	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.62</u> <u>2.62</u> <u>2.64</u> <u>2.57</u>	7-30-08	PSW
	C) FUNCTION		8-4-08	L.P.D.
690	PACK		8/5/08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/17/08

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



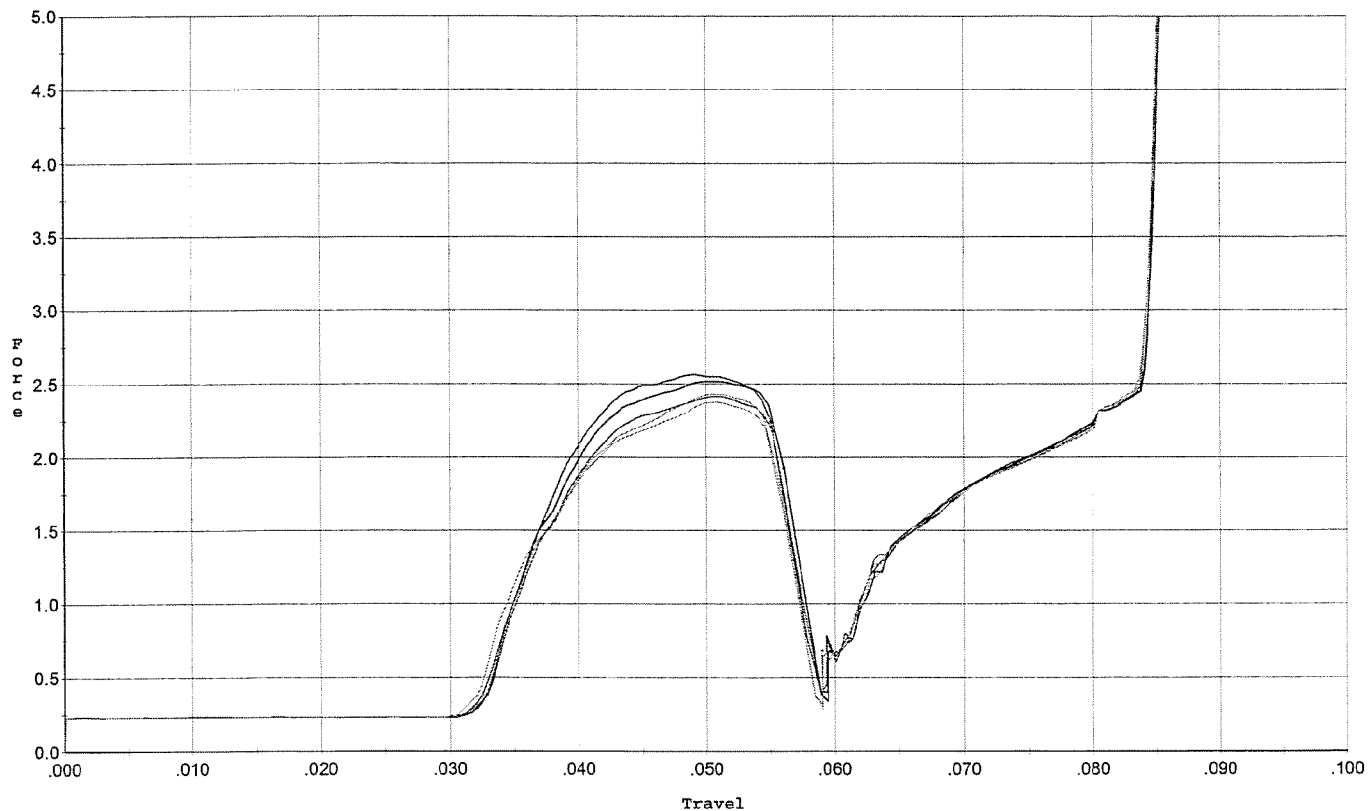
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.059	0.036	0.036	0.055		Set Trigger
2	2.482	0.058	0.035	0.035	0.056		Set Trigger
3	2.469	0.058	0.036	0.036	0.054		Set Trigger
4	2.461	0.058	0.035	0.036	0.054		Set Trigger
5	2.458	0.059	0.036	0.035	0.055		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/17/08

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



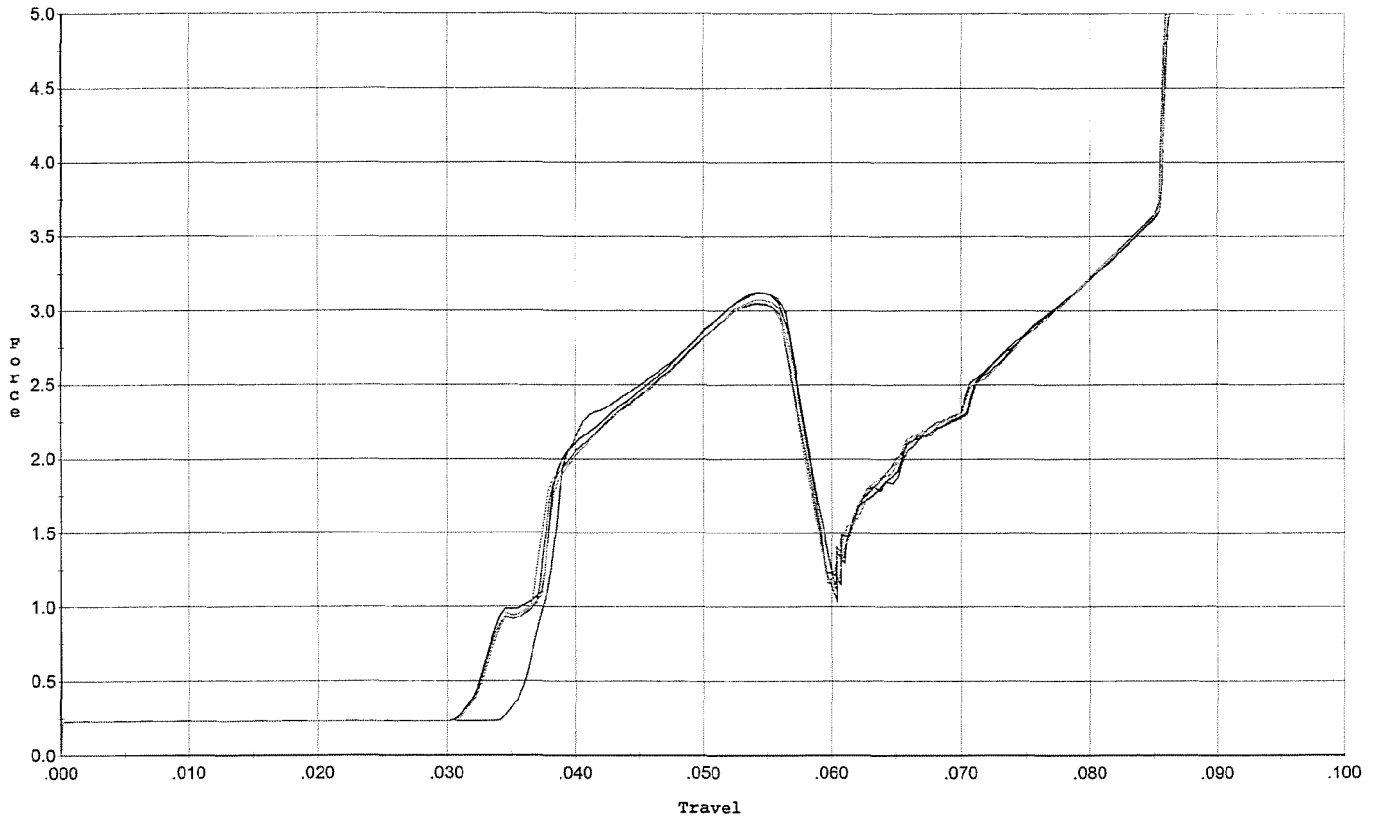
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.565	0.055	0.033	0.035	0.055		Set Trigger
2	2.517	0.056	0.033	0.035	0.056		Set Trigger
3	2.415	0.055	0.033	0.035	0.052		Set Trigger
4	2.378	0.056	0.032	0.035	0.053		Set Trigger
5	2.432	0.056	0.033	0.035	0.052		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 7/17/08

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



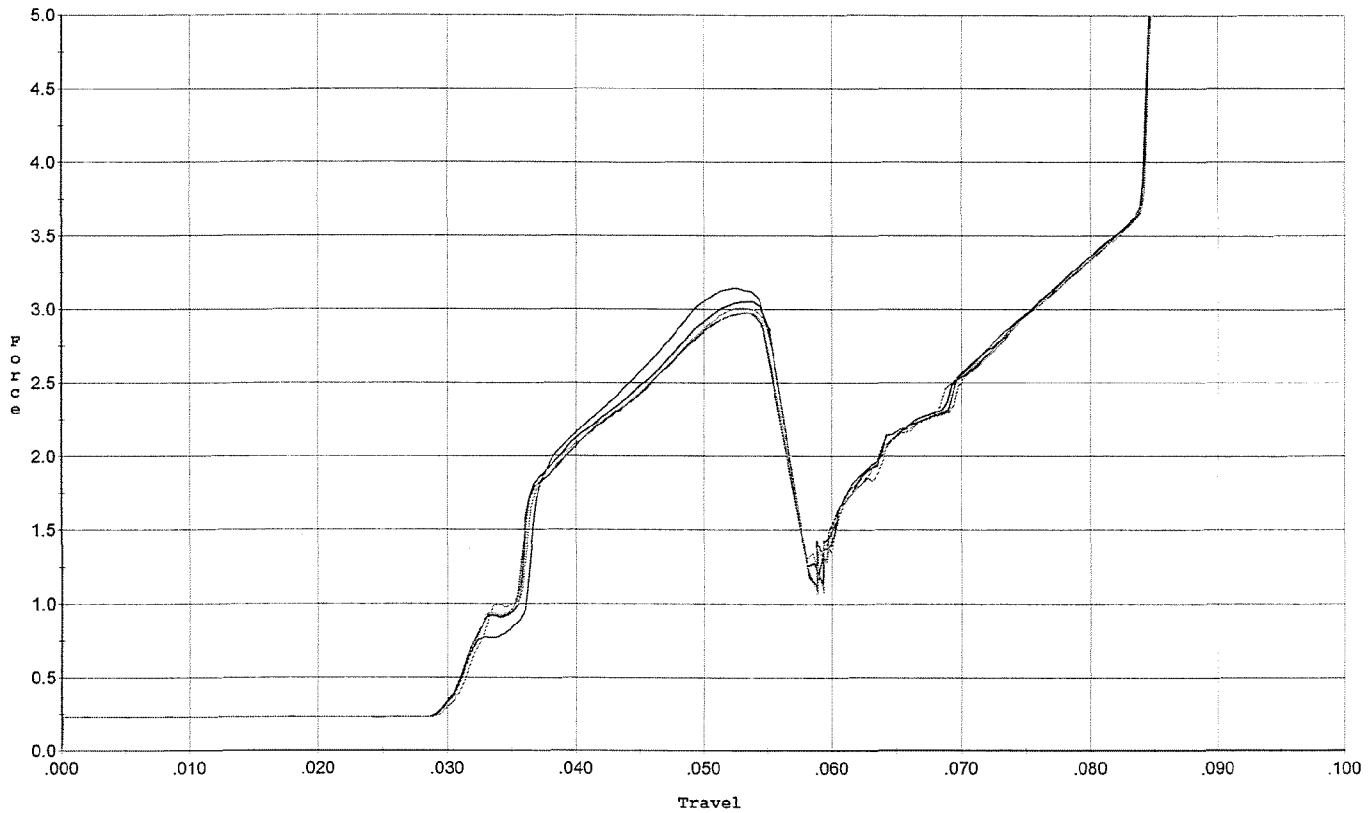
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.119	0.056	0.036	0.035	0.061		Set Trigger
2	3.123	0.057	0.032	0.034	0.064		Set Trigger
3	3.043	0.058	0.032	0.033	0.064		Set Trigger
4	3.054	0.056	0.032	0.034	0.062		Set Trigger
5	3.075	0.057	0.032	0.034	0.063		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/17/08

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



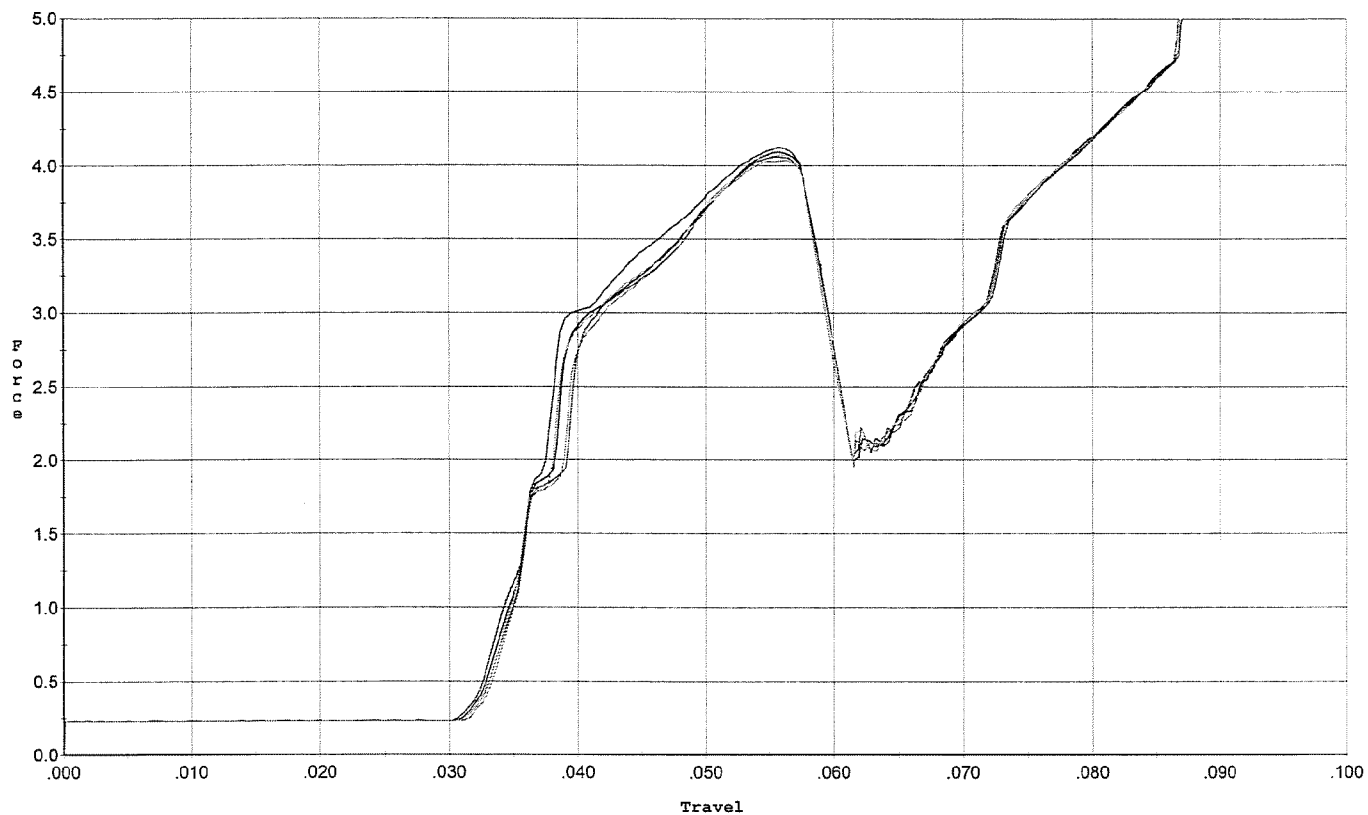
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.141	0.055	0.031	0.034	0.062		Set Trigger
2	3.051	0.055	0.031	0.034	0.062		Set Trigger
3	2.977	0.055	0.031	0.034	0.060		Set Trigger
4	2.975	0.056	0.031	0.034	0.062		Set Trigger
5	3.012	0.055	0.031	0.033	0.061		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/17/08

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



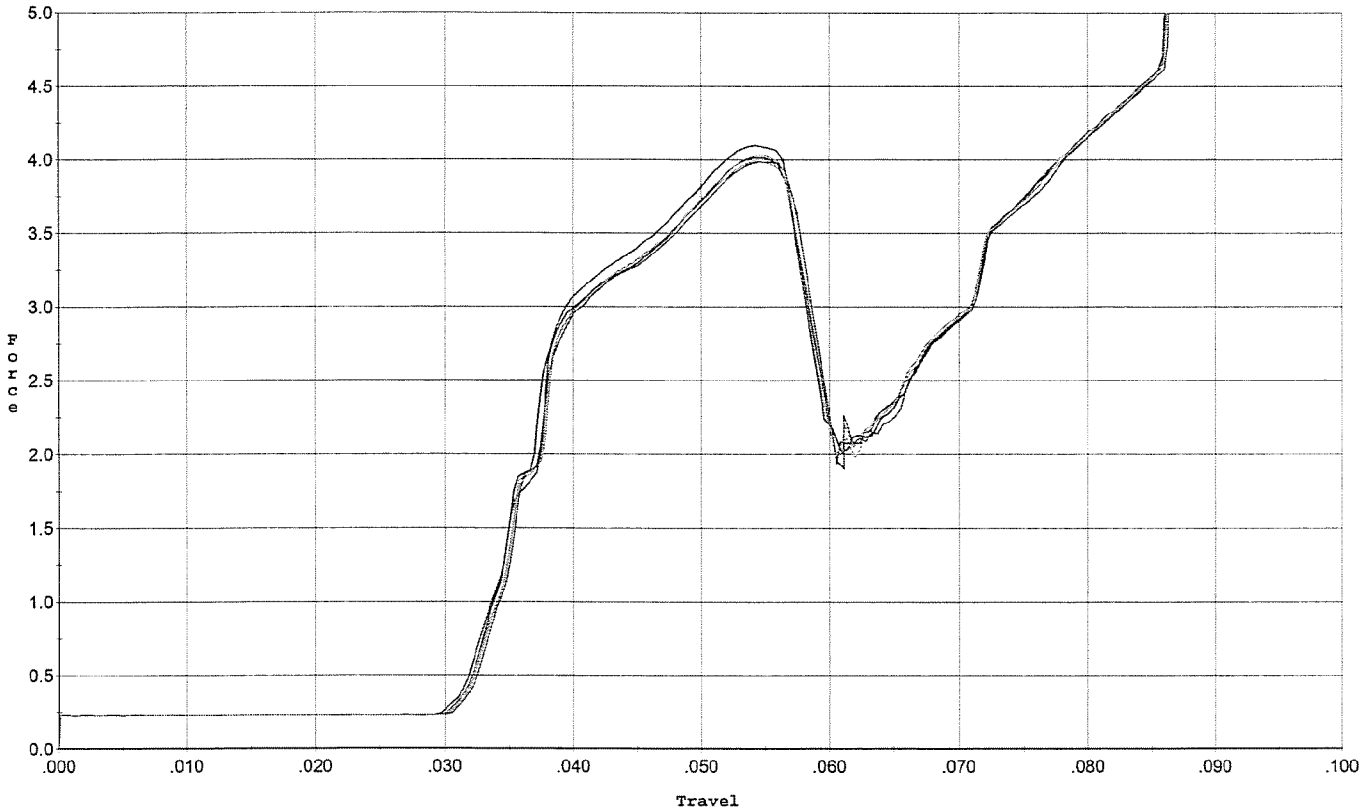
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.124	0.059	0.032	0.032	0.092		Set Trigger
2	4.092	0.059	0.032	0.032	0.089		Set Trigger
3	4.058	0.059	0.033	0.032	0.088		Set Trigger
4	4.072	0.057	0.033	0.032	0.086		Set Trigger
5	4.036	0.059	0.033	0.032	0.087		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 7/17/08

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



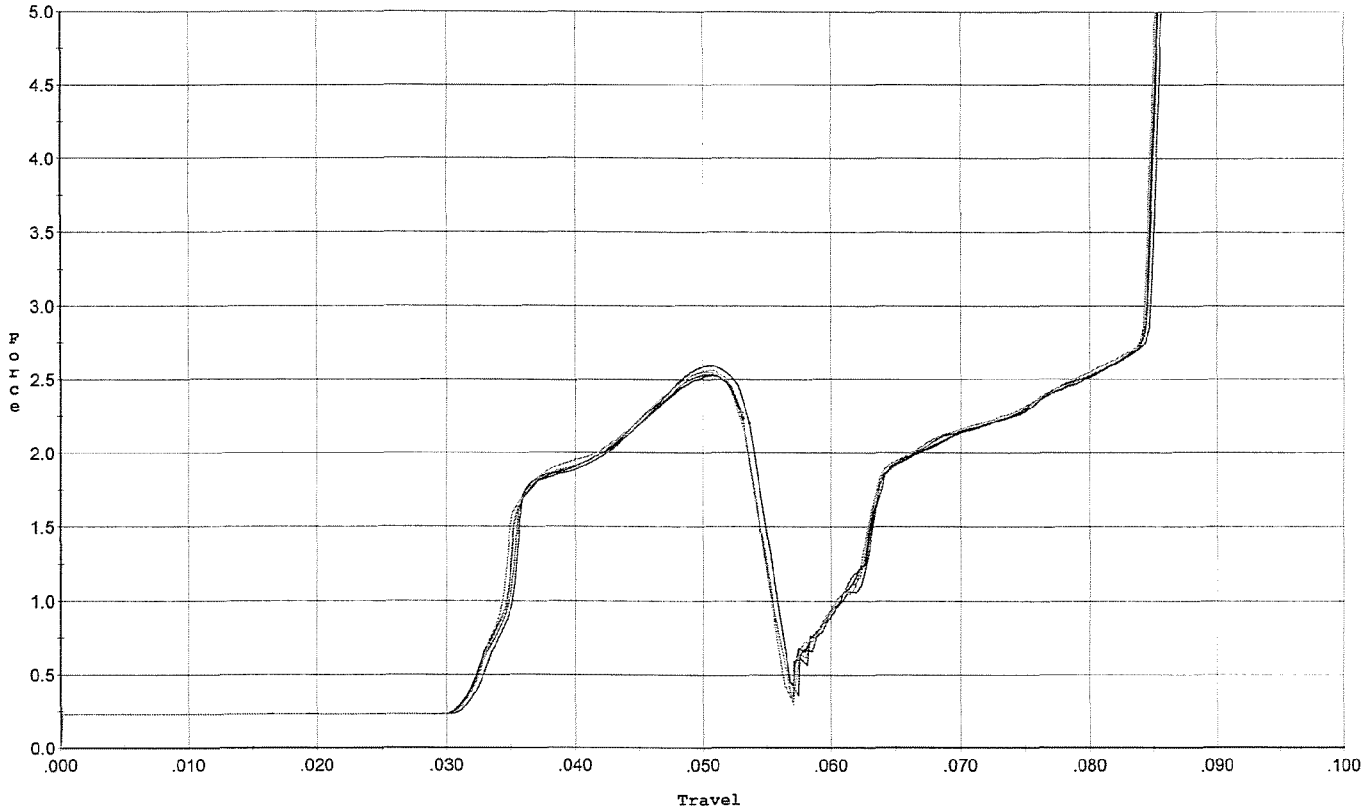
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.056	0.031	0.032	0.086		Set Trigger
2	4.015	0.057	0.032	0.033	0.085		Set Trigger
3	3.985	0.057	0.032	0.032	0.086		Set Trigger
4	4.029	0.058	0.032	0.032	0.088		Set Trigger
5	3.991	0.057	0.032	0.033	0.084		Set Trigger

Avg 4.02

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/17/08

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



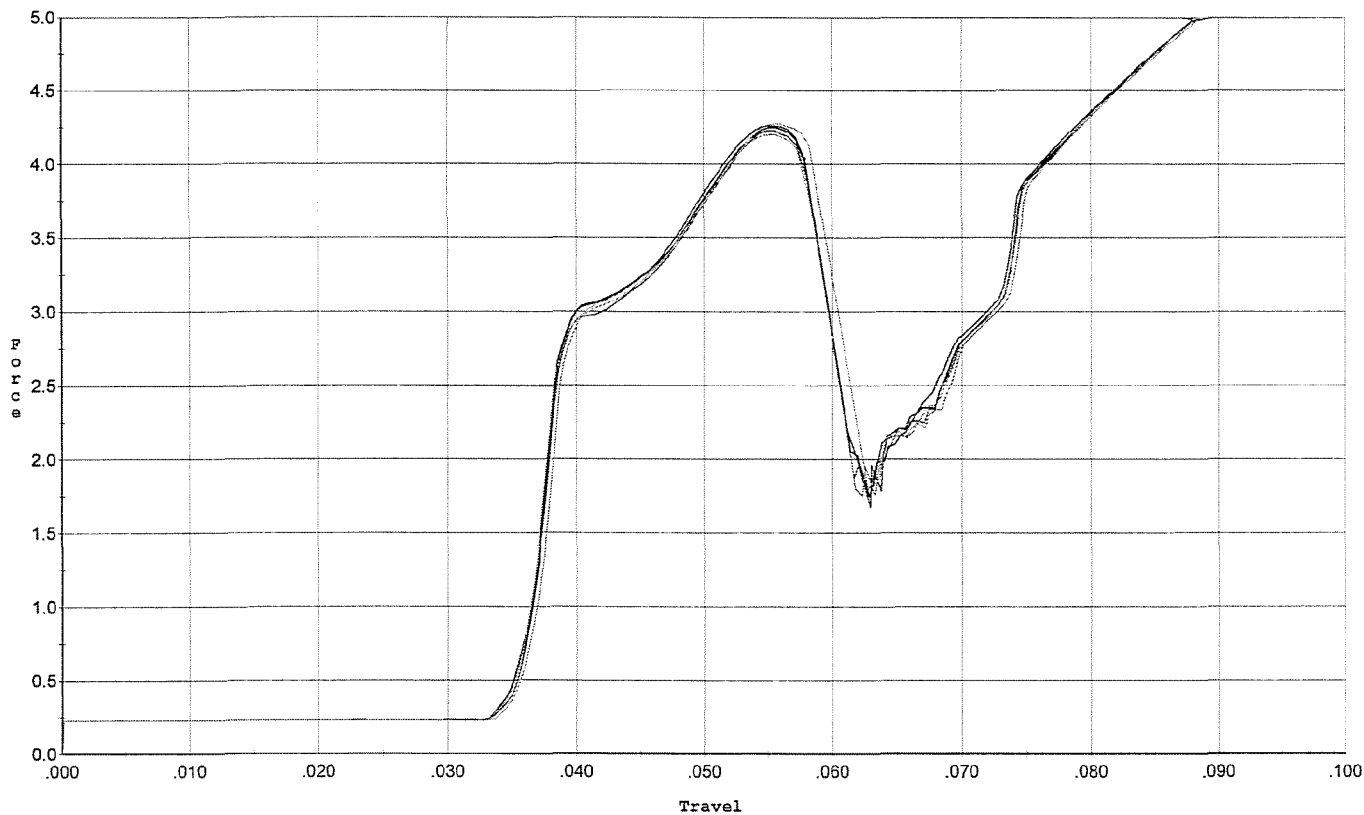
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.597	0.054	0.032	0.036	0.051		Set Trigger
2	2.529	0.053	0.032	0.036	0.050		Set Trigger
3	2.535	0.053	0.032	0.036	0.049		Set Trigger
4	2.561	0.053	0.032	0.036	0.050		Set Trigger
5	2.549	0.053	0.032	0.036	0.050		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 7/17/08

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	4.261	0.058	0.035	0.034	0.087		Set Trigger
2	4.250	0.058	0.035	0.034	0.086		Set Trigger
3	4.227	0.058	0.035	0.034	0.086		Set Trigger
4	4.201	0.058	0.035	0.034	0.087		Set Trigger
5	4.274	0.060	0.035	0.033	0.091		Set Trigger

Avg 4.24