

G6784998

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

G6784998



BM FORM

GUN SERIAL # G 678 4998

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SPD
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SPD
460	CHECK HEADSPACE		9-19-08	SPD
470	DIS-ASSEMBLE ACTION		9-19-08	SPD
472	SERIALIZE BOLT HANDLE		9-20-08	SP
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX SEP 22 2008	9-20-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BKT	9-22-08	BKT
490	MAGNAFLUX BOLT		9-22-08	MR
500	ROLLMARK CALIBER		9-22-08	RT
520	GOFF BLAST BBL / REC		9-22-08	DS
542	APPLY COATINGS (BARREL ACTION)		9-22-08	u
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-16-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

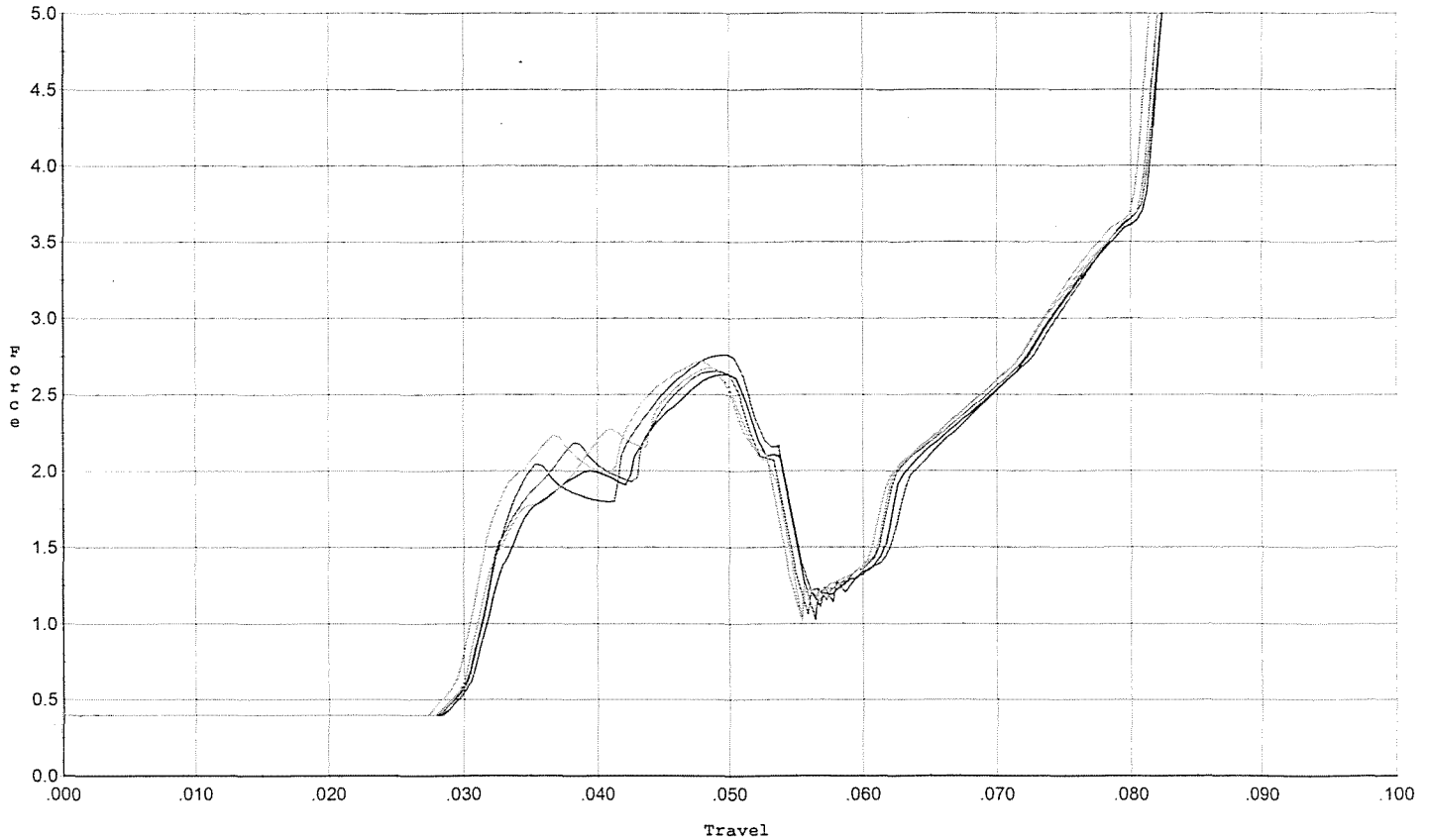
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0	4.0	4.0	12-15-08	RP		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	4.0	4.0	4.0	12-15-08	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.022	.022	.022	12-15-08	RP		
	J) ASSEMBLE STOCK					10-16-08	RP		
	K) ASSEMBLE SWIVEL STUDS					12-15-08	RP		
	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		PASS	FAIL		12-11-08	RP		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION	N/A					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					12-11-08	RP		
670	FINAL INSPECTION A) HEADSPACE					12-15-08	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.38	2.41	2.35	2.34	2.38	12-15-08	RP
	C) FUNCTION					12-15-08	RP		
690	PACK					12/19/08	FM		

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note:

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



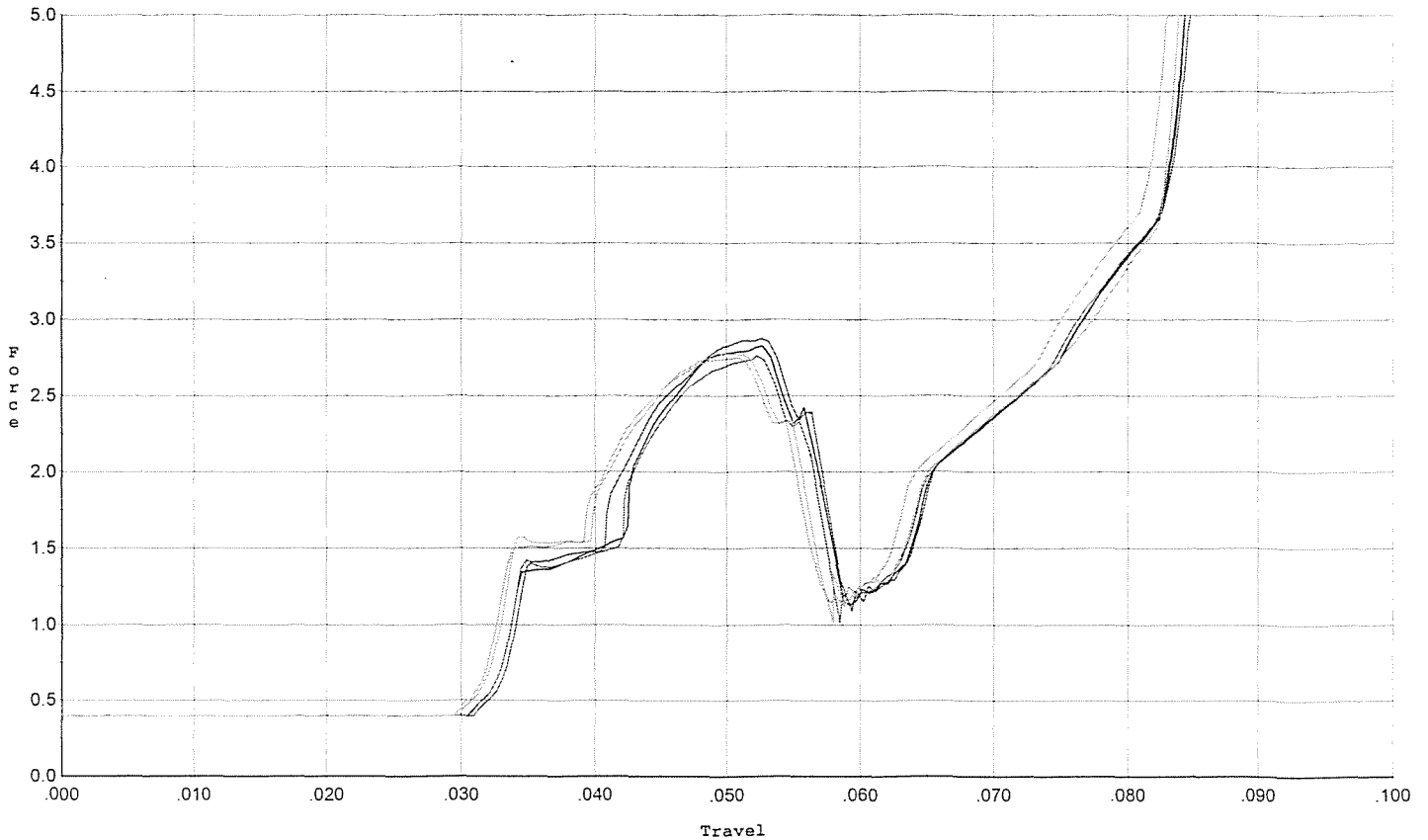
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.760	0.054	0.030	0.033	0.062		Set Trigger
2	2.631	0.054	0.031	0.033	0.060		Set Trigger
3	2.656	0.053	0.030	0.033	0.060		Set Trigger
4	2.677	0.054	0.030	0.033	0.061		Set Trigger
5	2.719	0.053	0.030	0.033	0.062		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



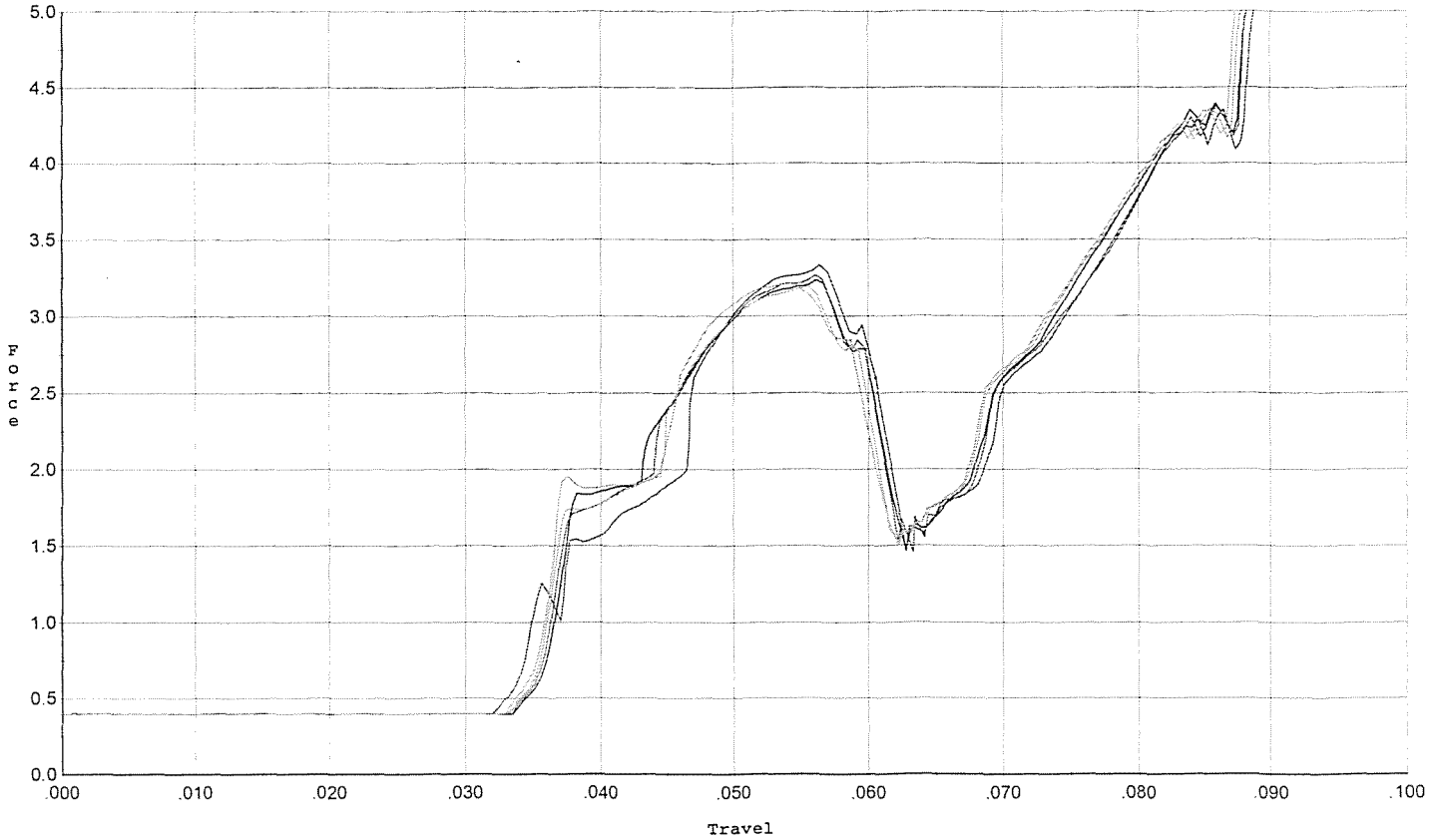
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.877	0.056	0.033	0.034	0.064		Set Trigger
2	2.827	0.057	0.033	0.033	0.063		Set Trigger
3	2.764	0.056	0.033	0.034	0.061		Set Trigger
4	2.779	0.055	0.030	0.034	0.062		Set Trigger
5	2.753	0.054	0.032	0.033	0.062		Set Trigger

A-2.80

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



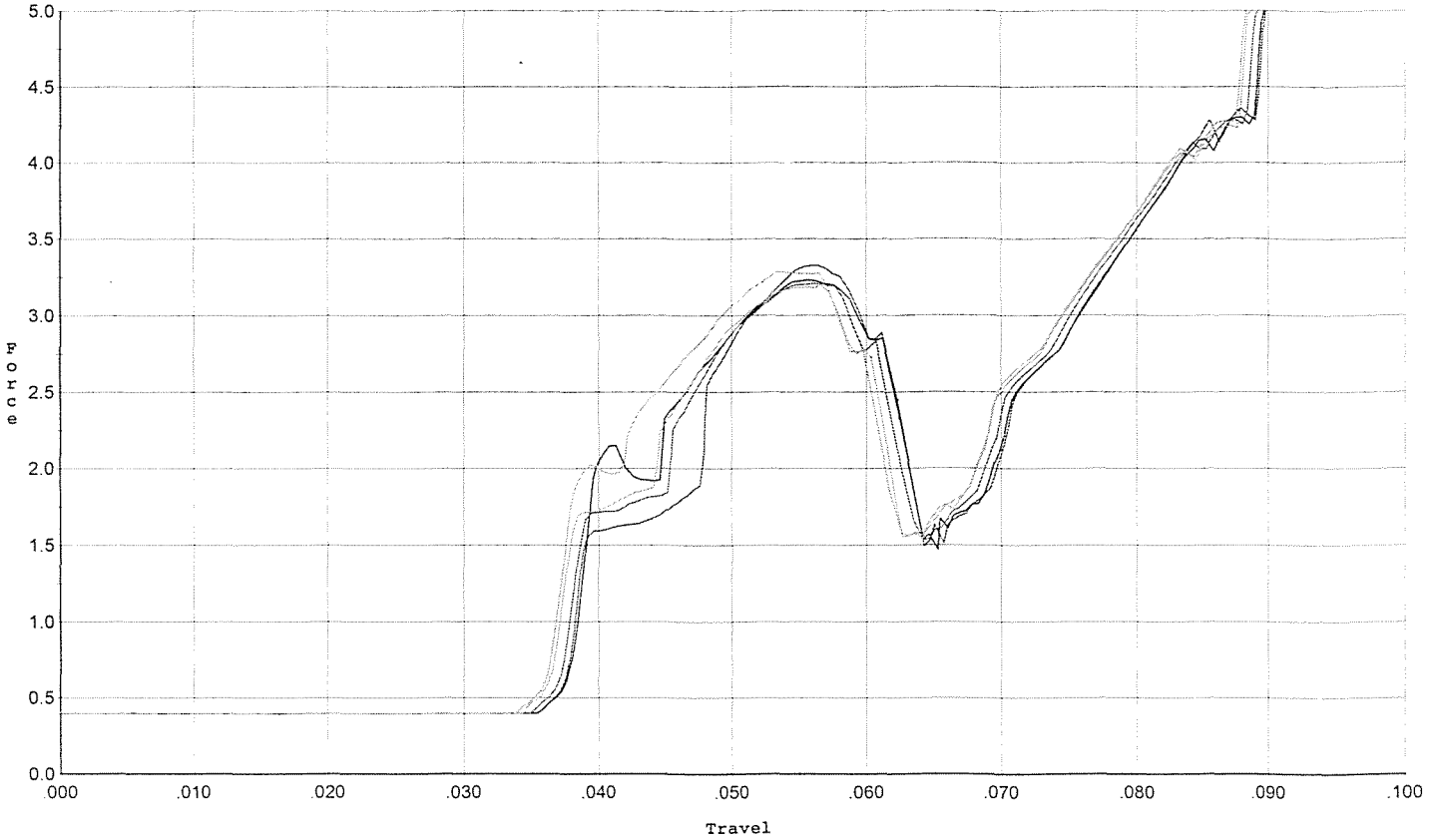
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.334	0.061	0.034	0.034	0.076		Set Trigger
2	3.231	0.060	0.036	0.034	0.076		Set Trigger
3	3.264	0.060	0.034	0.033	0.076		Set Trigger
4	3.193	0.059	0.034	0.034	0.074		Set Trigger
5	3.215	0.059	0.033	0.034	0.074		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



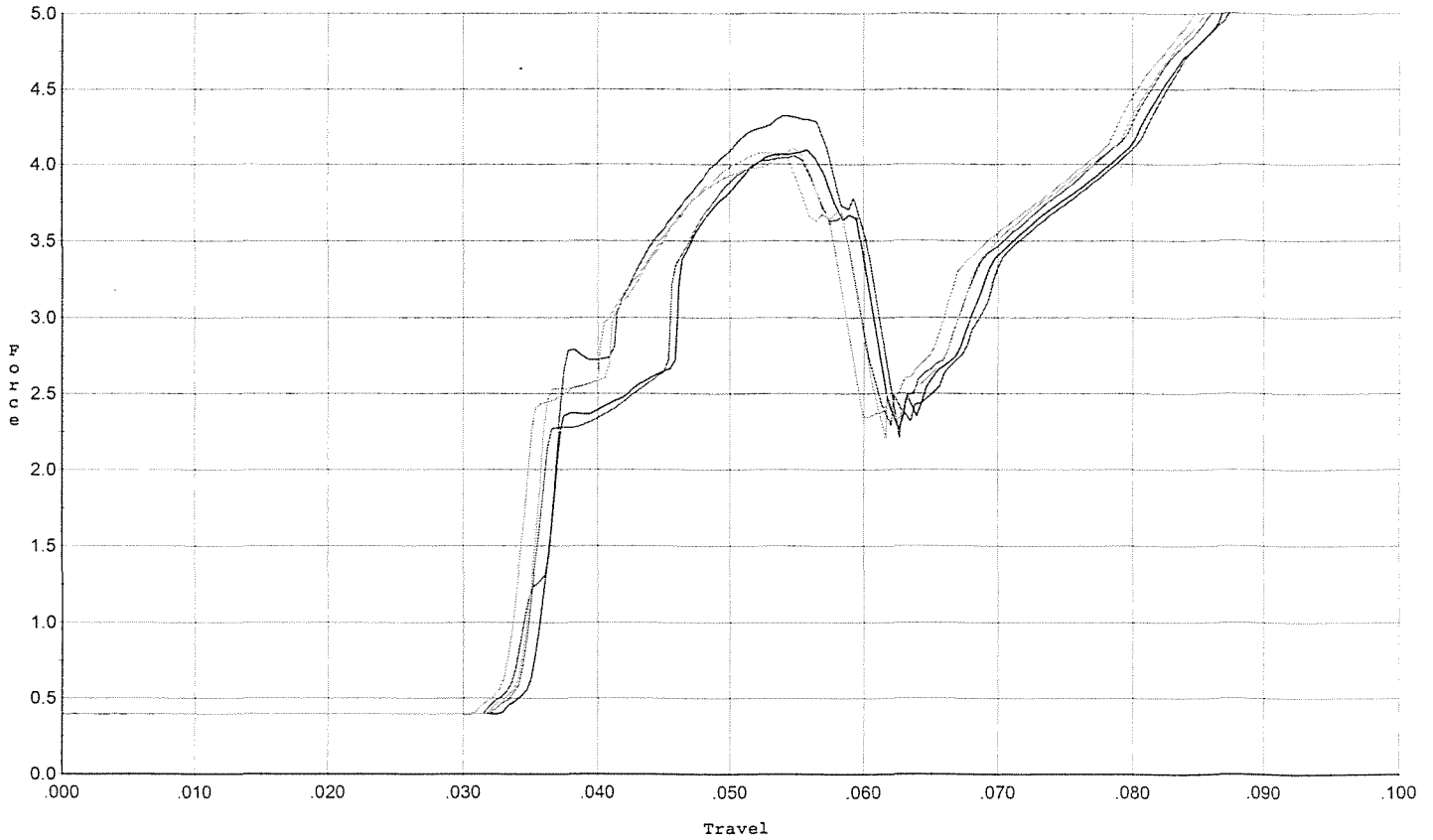
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.062	0.038	0.033	0.076		Set Trigger
2	3.231	0.062	0.038	0.033	0.080		Set Trigger
3	3.209	0.061	0.037	0.034	0.075		Set Trigger
4	3.200	0.060	0.036	0.033	0.075		Set Trigger
5	3.285	0.060	0.036	0.034	0.078		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 10/13/2008

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



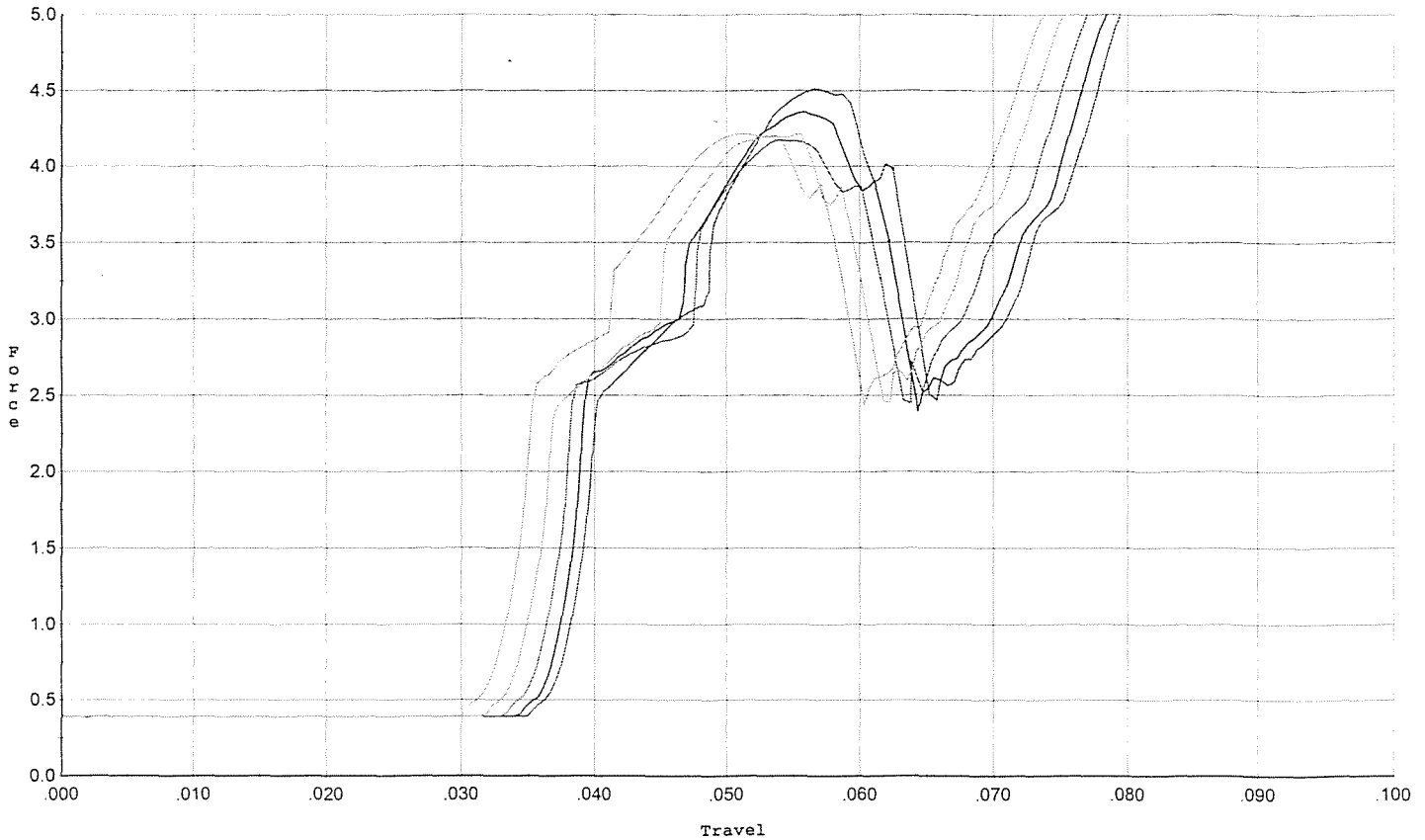
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.324	0.060	0.034	0.031	0.104		Set Trigger
2	4.096	0.059	0.035	0.031	0.093		Set Trigger
3	4.056	0.058	0.034	0.031	0.091		Set Trigger
4	4.106	0.058	0.034	0.031	0.097		Set Trigger
5	4.066	0.058	0.033	0.031	0.094		Set Trigger

A-4-B

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

Model: M/24
Serial No: Form #F005
Trigger: 4..0 lbs. after 20 cycles +/- 1.0 lbs.



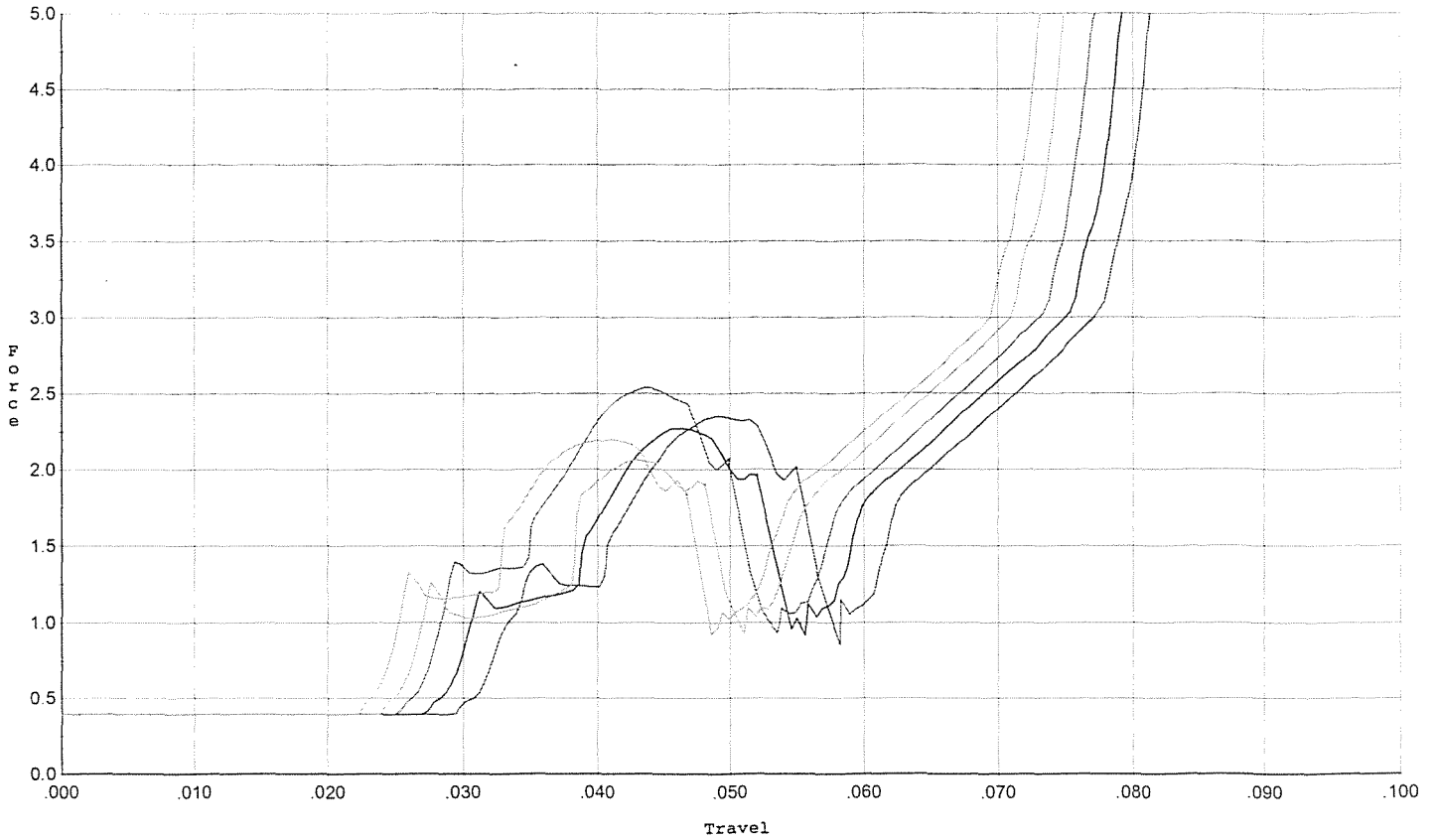
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.513	0.062	0.037	0.030	0.104		Set Trigger
2	4.358	0.062	0.036	0.030	0.103		Set Trigger
3	4.169	0.062	0.035	0.029	0.099		Set Trigger
4	4.212	0.060	0.032	0.029	0.099		Set Trigger
5	4.211	0.058	0.032	0.029	0.100		Set Trigger

A-4-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



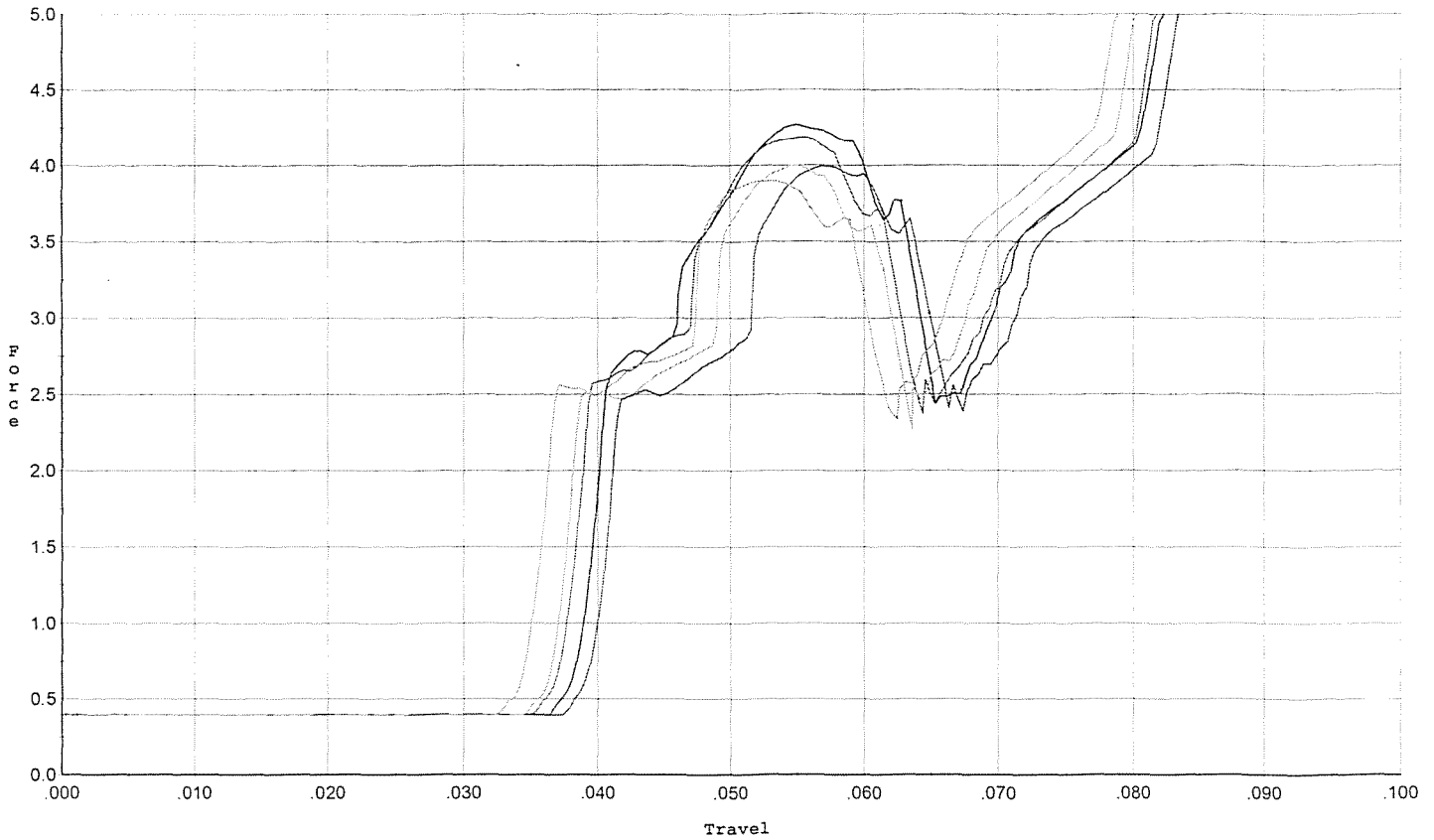
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.350	0.055	0.032	0.032	0.054		Set Trigger
2	2.269	0.052	0.029	0.033	0.050		Set Trigger
3	2.539	0.050	0.027	0.032	0.054		Set Trigger
4	2.063	0.048	0.024	0.032	0.044		Set Trigger
5	2.196	0.047	0.023	0.032	0.048		Set Trigger

A-2.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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	3.995	0.065	0.038	0.024	0.096		Set Trigger
2	4.268	0.063	0.037	0.024	0.102		Set Trigger
3	4.185	0.061	0.036	0.025	0.098		Set Trigger
4	4.003	0.061	0.035	0.024	0.093		Set Trigger
5	3.900	0.059	0.033	0.025	0.091		Set Trigger

A-4-07