

G6884927

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



BM FORM

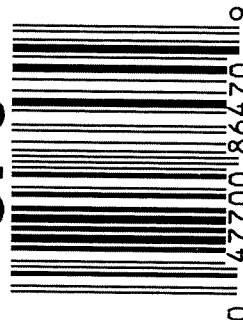
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6884927

UPC



GUN SERIAL #

G 6884927

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-3-09	RP
430	ASSEMBLE TO STOCK		9-3-09	SP
440	PROOF		9-3-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	9-3-09	RP
470	DIS-ASSEMBLE ACTION		9-3-09	RP
472	SERIALIZE BOLT HANDLE		7-4-09	RZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	9/10/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/10/09	SP
510	DRILL AND TAP SIGHT HOLES		9-4-09	SP
520	GOFF BLAST BBL / REC		9-11	TZ
540	APPLY COATINGS (BARREL ACTION)		9/15	-
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-21-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-21-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	9-21-09	SP
	D) OIL FIRING PIN ASSEMBLY		9-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

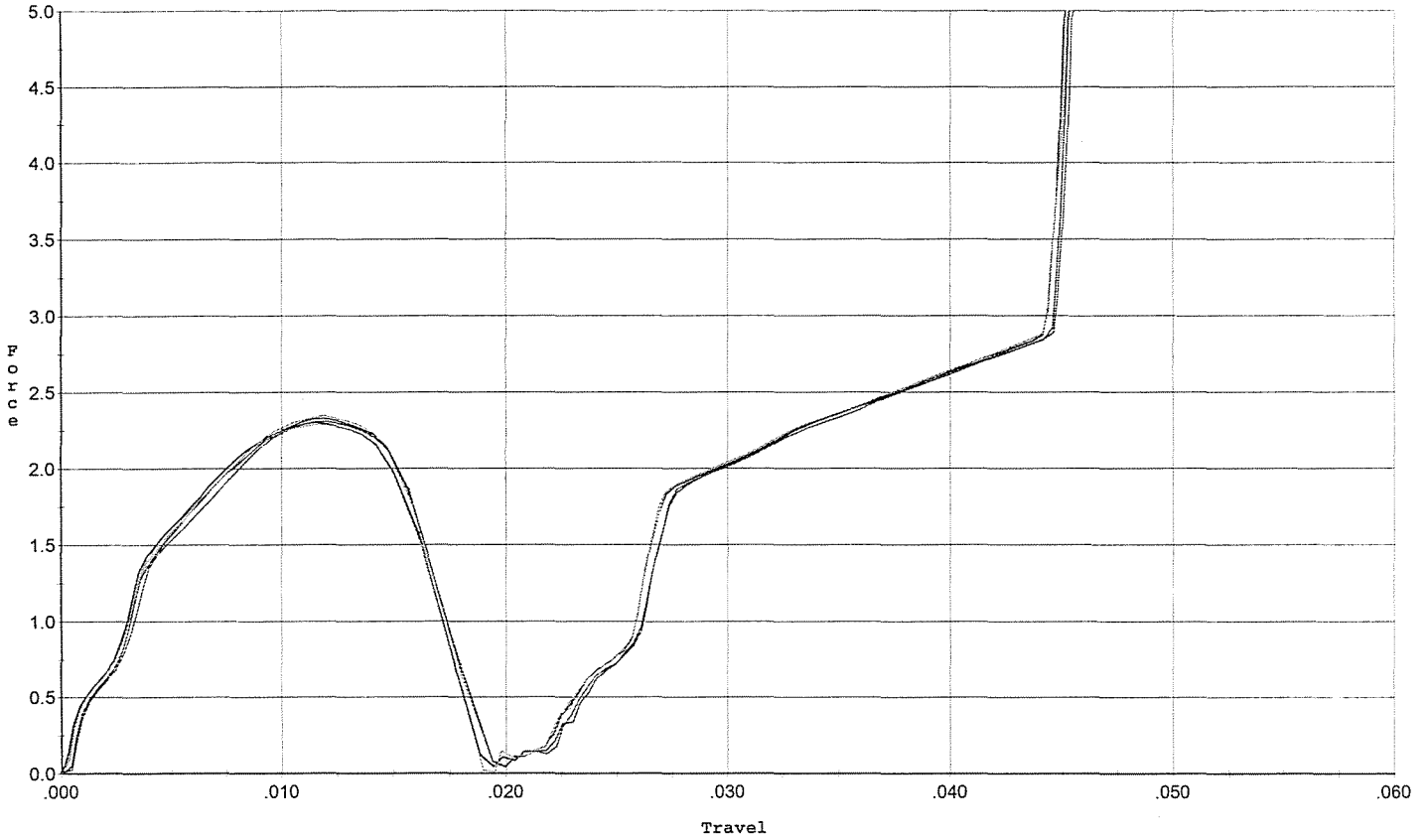
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3"</u>	<u>3"</u>	<u>3"</u>	9/30/09	RB		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>7"</u>	<u>7"</u>	<u>7"</u>	9/30/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.025</u>	9/30/09	RB		
	J) ASSEMBLE STOCK					9-23-09	D.H.		
	K) ASSEMBLE SWIVEL STUDS					9/30/09	RB		
	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		9-29-09	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					9-29-09	TAR		
670	FINAL INSPECTION A) HEADSPACE					9/30/09	RB		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u>	<u>2.87</u>	<u>2.76</u>	<u>2.82</u>	<u>2.76</u>	9-30-09	TL
	C) FUNCTION					9/30/09	RB		
690	PACK					10/2/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



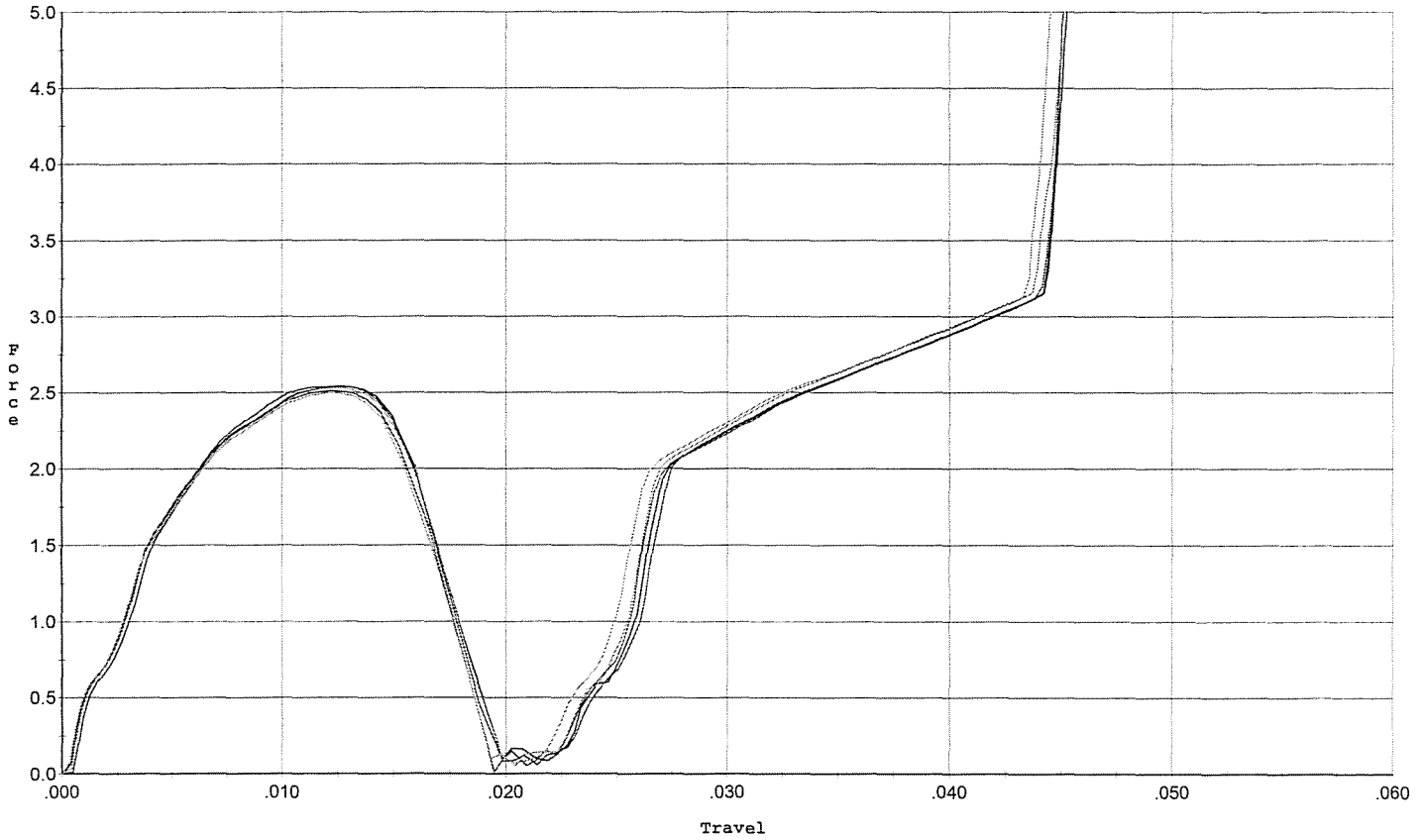
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.328	0.016	0.00	0.033	0.025		Set Trigger
2	2.302	0.016	0.00	0.033	0.026		Set Trigger
3	2.309	0.016	0.00	0.033	0.025		Set Trigger
4	2.288	0.016	0.00	0.033	0.026		Set Trigger
5	2.347	0.016	0.00	0.033	0.026		Set Trigger

Avg 2.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



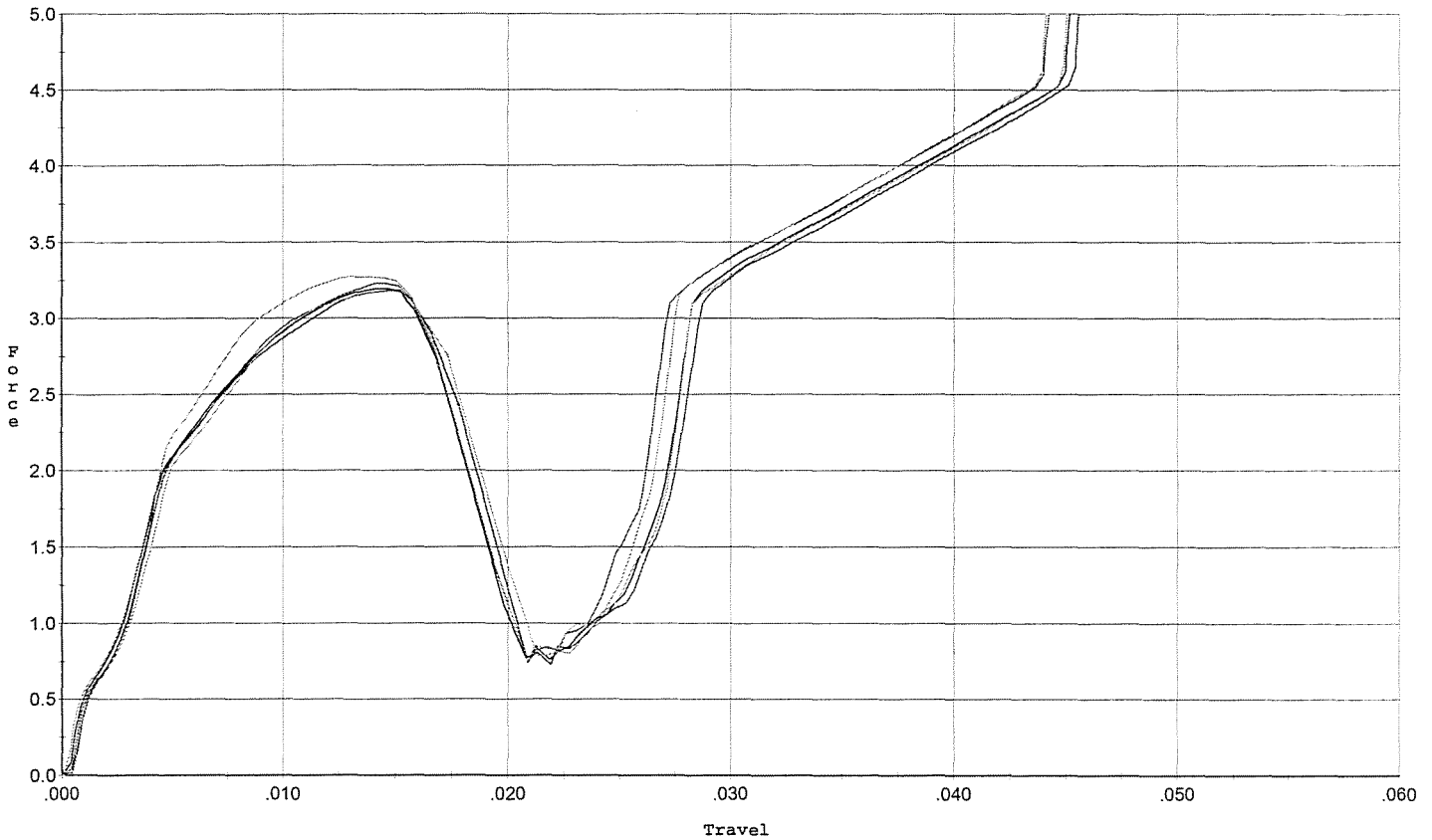
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.016	0.00	0.032	0.028		Set Trigger
2	2.537	0.016	0.00	0.032	0.028		Set Trigger
3	2.511	0.017	0.00	0.032	0.029		Set Trigger
4	2.500	0.017	0.00	0.031	0.029		Set Trigger
5	2.531	0.016	0.00	0.032	0.028		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



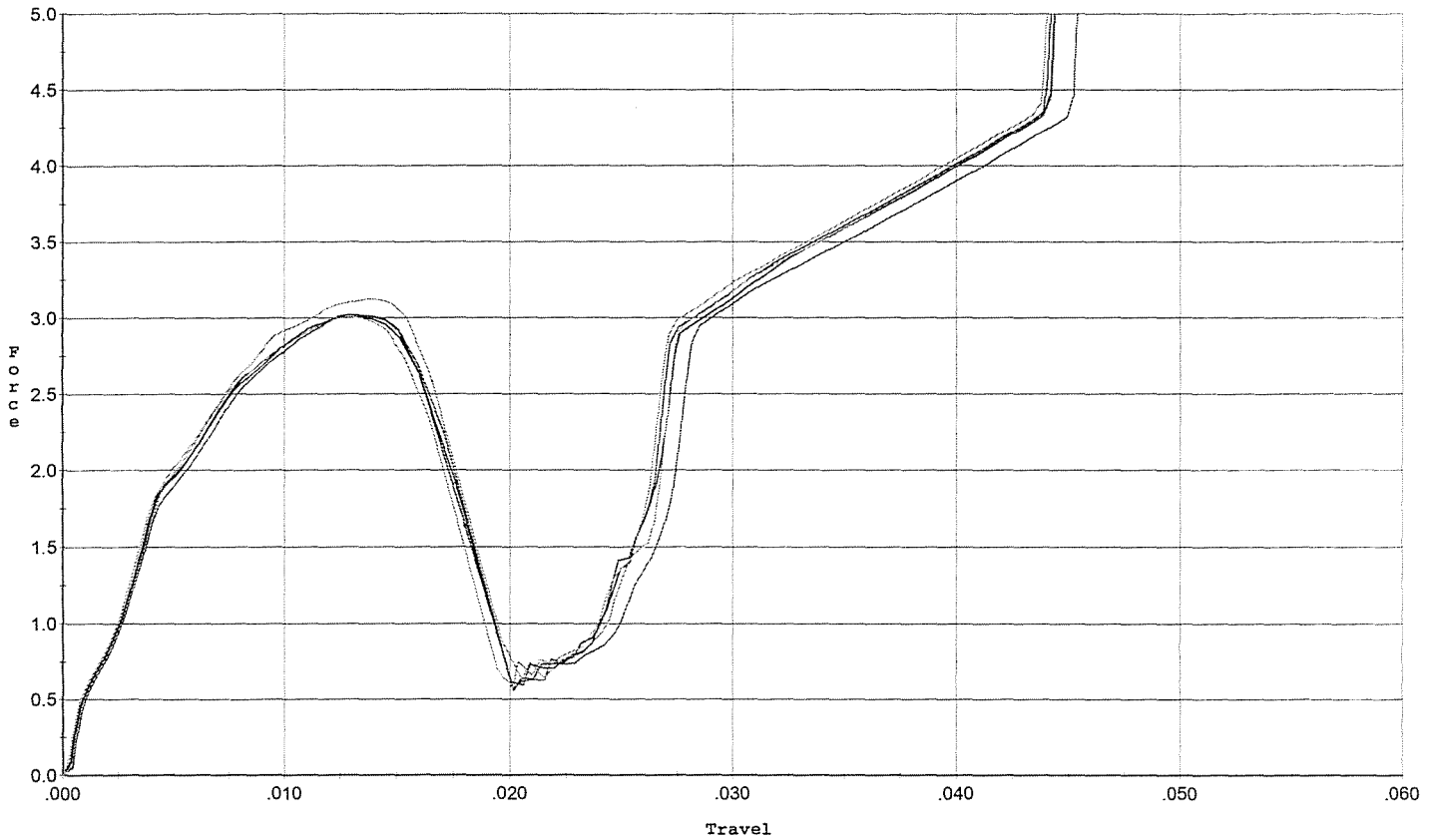
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.185	0.018	0.00	0.029	0.038		Set Trigger
2	3.193	0.017	0.00	0.029	0.036		Set Trigger
3	3.228	0.017	0.00	0.028	0.036		Set Trigger
4	3.175	0.017	0.00	0.028	0.037		Set Trigger
5	3.272	0.017	0.00	0.028	0.037		Set Trigger

Avg 3.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



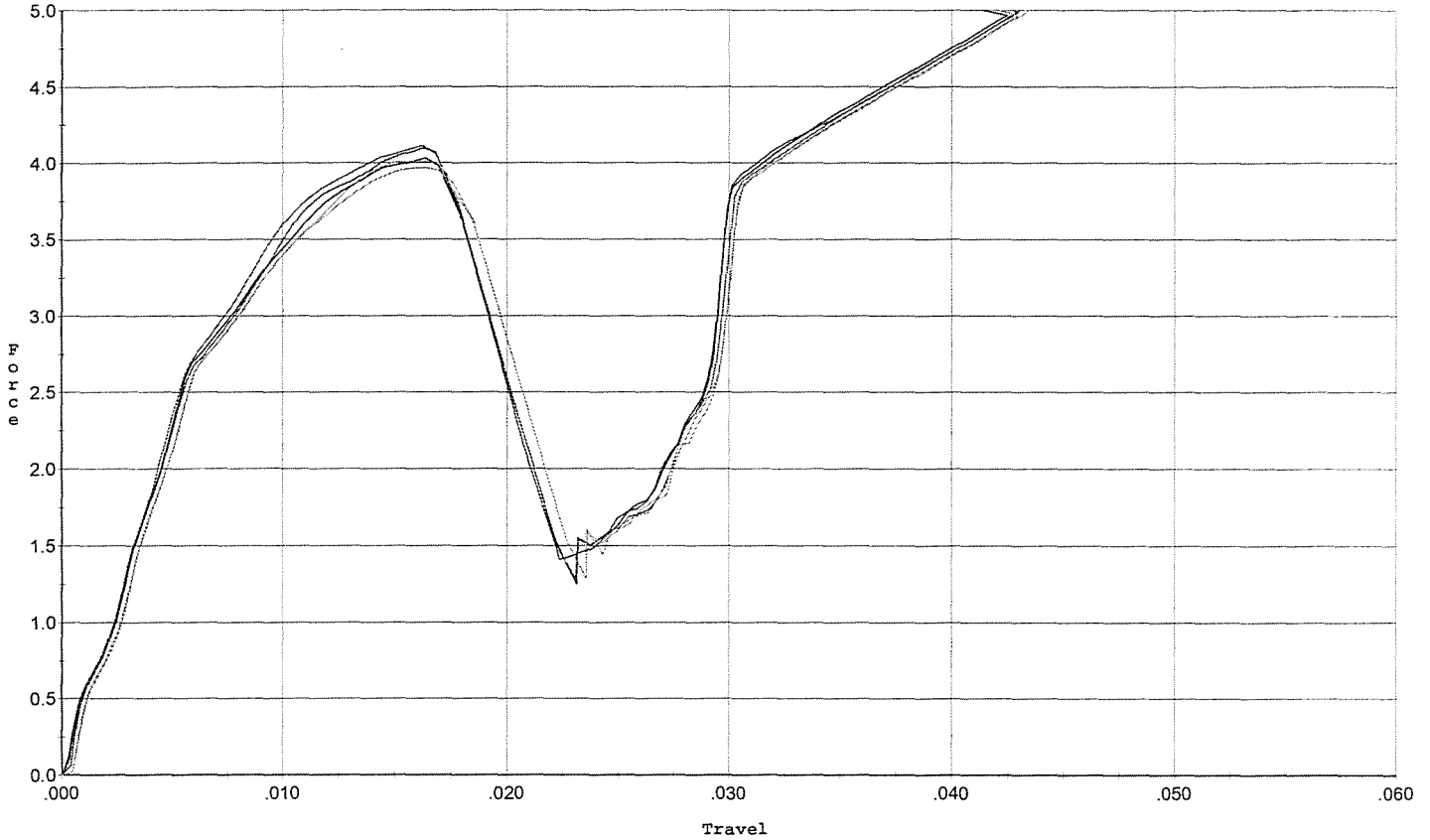
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.020	0.018	0.00	0.029	0.037		Set Trigger
2	3.007	0.018	0.00	0.029	0.036		Set Trigger
3	3.019	0.017	0.00	0.030	0.035		Set Trigger
4	3.007	0.016	0.00	0.029	0.034		Set Trigger
5	3.125	0.017	0.00	0.029	0.035		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



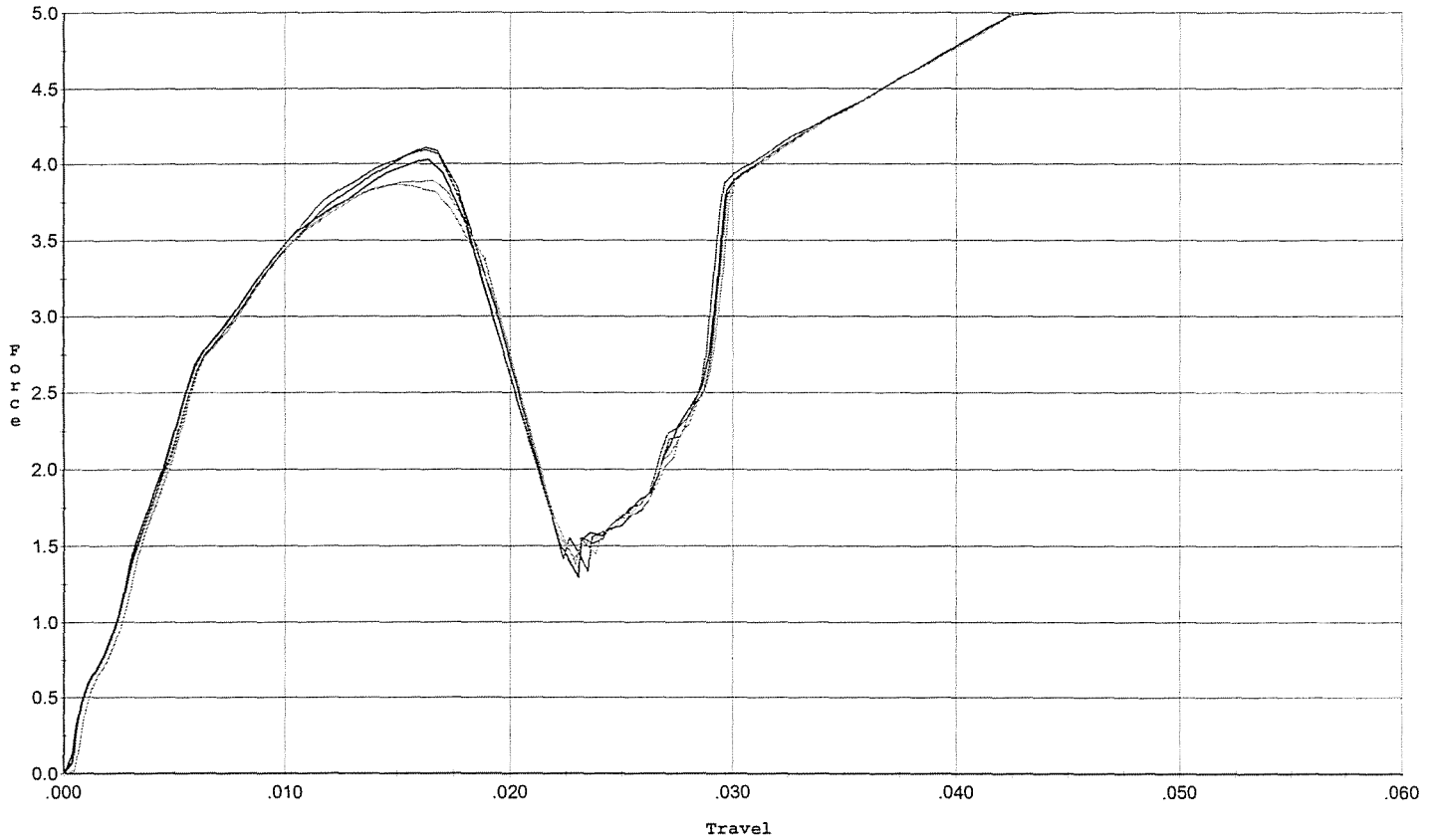
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.098	0.018	0.00	0.029	0.047		Set Trigger
2	4.032	0.018	0.00	0.029	0.047		Set Trigger
3	4.112	0.018	0.00	0.029	0.048		Set Trigger
4	4.010	0.018	0.00	0.029	0.048		Set Trigger
5	3.968	0.019	0.00	0.029	0.048		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



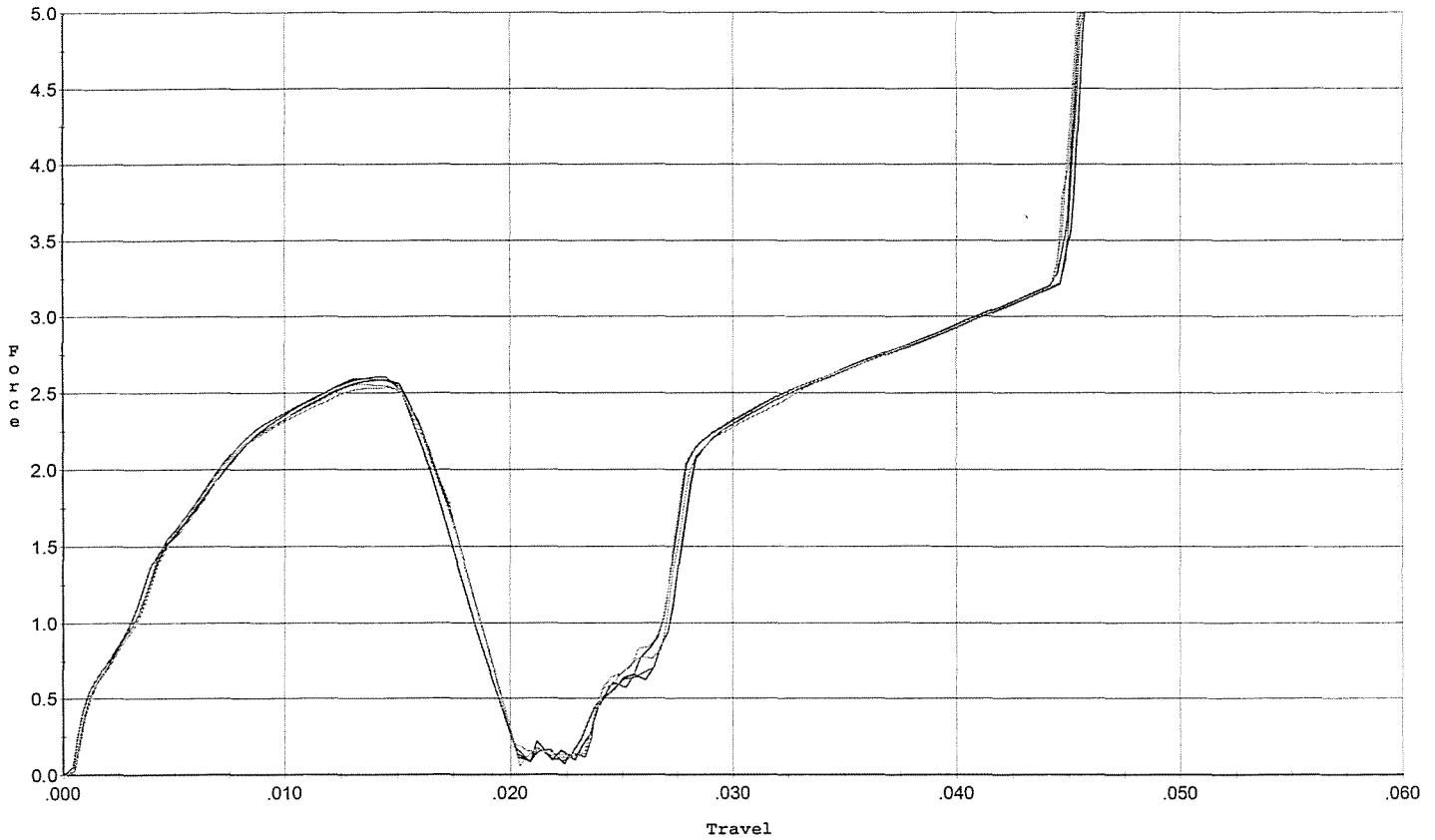
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.109	0.019	0.00	0.028	0.051		Set Trigger
2	4.031	0.018	0.00	0.028	0.047		Set Trigger
3	4.093	0.018	0.00	0.028	0.047		Set Trigger
4	3.866	0.019	0.00	0.028	0.049		Set Trigger
5	3.892	0.019	0.00	0.028	0.049		Set Trigger

Avg 3.99

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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



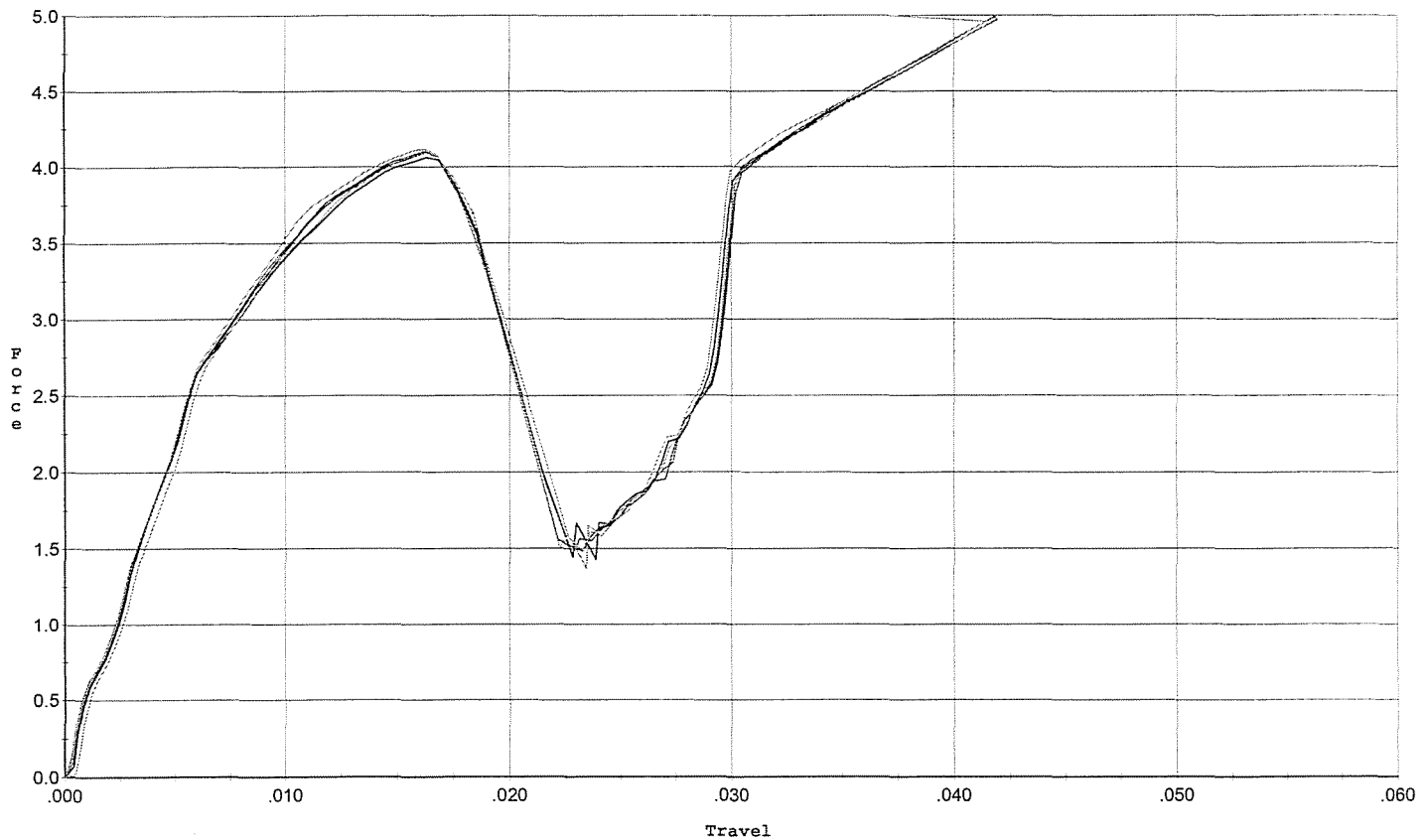
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.605	0.016	0.00	0.032	0.029		Set Trigger
2	2.586	0.017	0.00	0.032	0.030		Set Trigger
3	2.595	0.017	0.00	0.032	0.030		Set Trigger
4	2.537	0.017	0.00	0.031	0.030		Set Trigger
5	2.558	0.018	0.00	0.031	0.030		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 9/16/09

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	4.089	0.019	0.00	0.028	0.050		Set Trigger
2	4.063	0.019	0.00	0.028	0.049		Set Trigger
3	4.099	0.019	0.00	0.028	0.050		Set Trigger
4	4.116	0.019	0.00	0.028	0.051		Set Trigger
5	4.090	0.018	0.00	0.028	0.048		Set Trigger

Avg 4.09