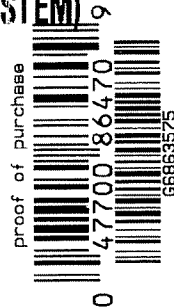


G6863575

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



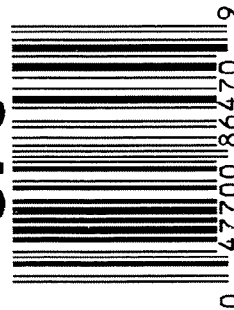
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6863575

UPC



BM FORM

GUN SERIAL #

G 6863575

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-13-09	SP
430	ASSEMBLE TO STOCK		8-13-09	SP
440	PROOF		8-13-09	SP
460	CHECK HEADSPACE		8-13-09	SP
470	DIS-ASSEMBLE ACTION		8-13-09	SP
472	SERIALIZE BOLT HANDLE		8-14-09	RTZ
480	MAGNAFLUX BBL ACTION		8/19/09	①
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/19/09	AND
510	DRILL AND TAP SIGHT HOLES		8-14-09	SP
520	GOFF BLAST BBL / REC		8/20	MTM
540	APPLY COATINGS (BARREL ACTION)		8/22	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		9-1-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

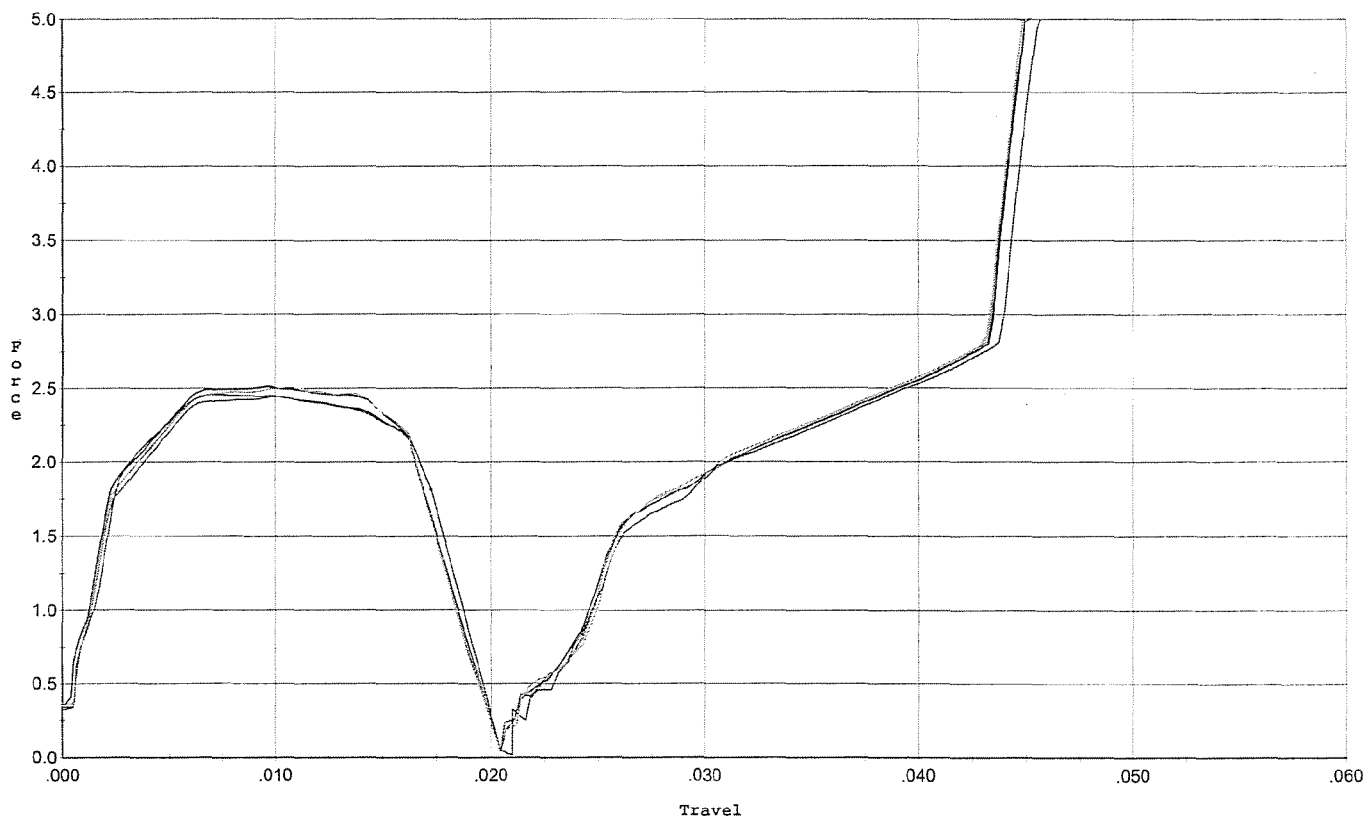
560	BARBER - M24 0093071 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	9/3/09	RB
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>8°</u> <u>8°</u> <u>8°</u>	9/3/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.023</u> <u>.024</u>	9/3/09	RB
	J) ASSEMBLE STOCK			9-1-09	L.D.
	K) ASSEMBLE SWIVEL STUDS			9/3/09	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		PASS FAIL PASS FAIL	9-2-09	TL
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			9-2-09	TCR
670	FINAL INSPECTION A) HEADSPACE			9/3/09	RB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>289</u> <u>270</u> <u>270</u> <u>255</u> <u>260</u>	9/3/09	RB
	C) FUNCTION			9/3/09	RB
690	PACK			9-9-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/28/2009

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



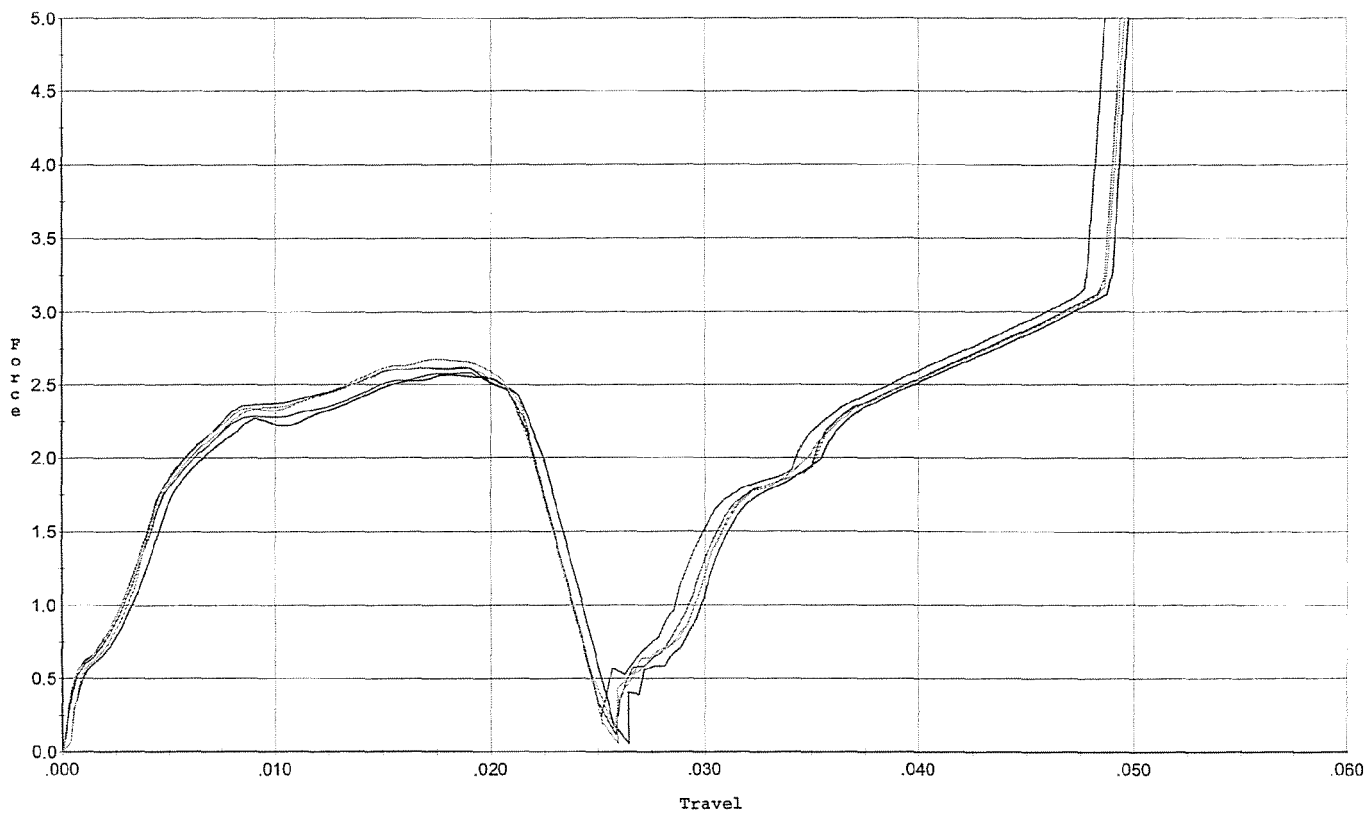
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.017	0.00	0.032	0.034		Set Trigger
2	2.515	0.016	0.00	0.032	0.033		Set Trigger
3	2.442	0.016	0.00	0.032	0.032		Set Trigger
4	2.504	0.016	0.00	0.032	0.032		Set Trigger
5	2.507	0.016	0.00	0.032	0.032		Set Trigger

A 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/28/2009

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



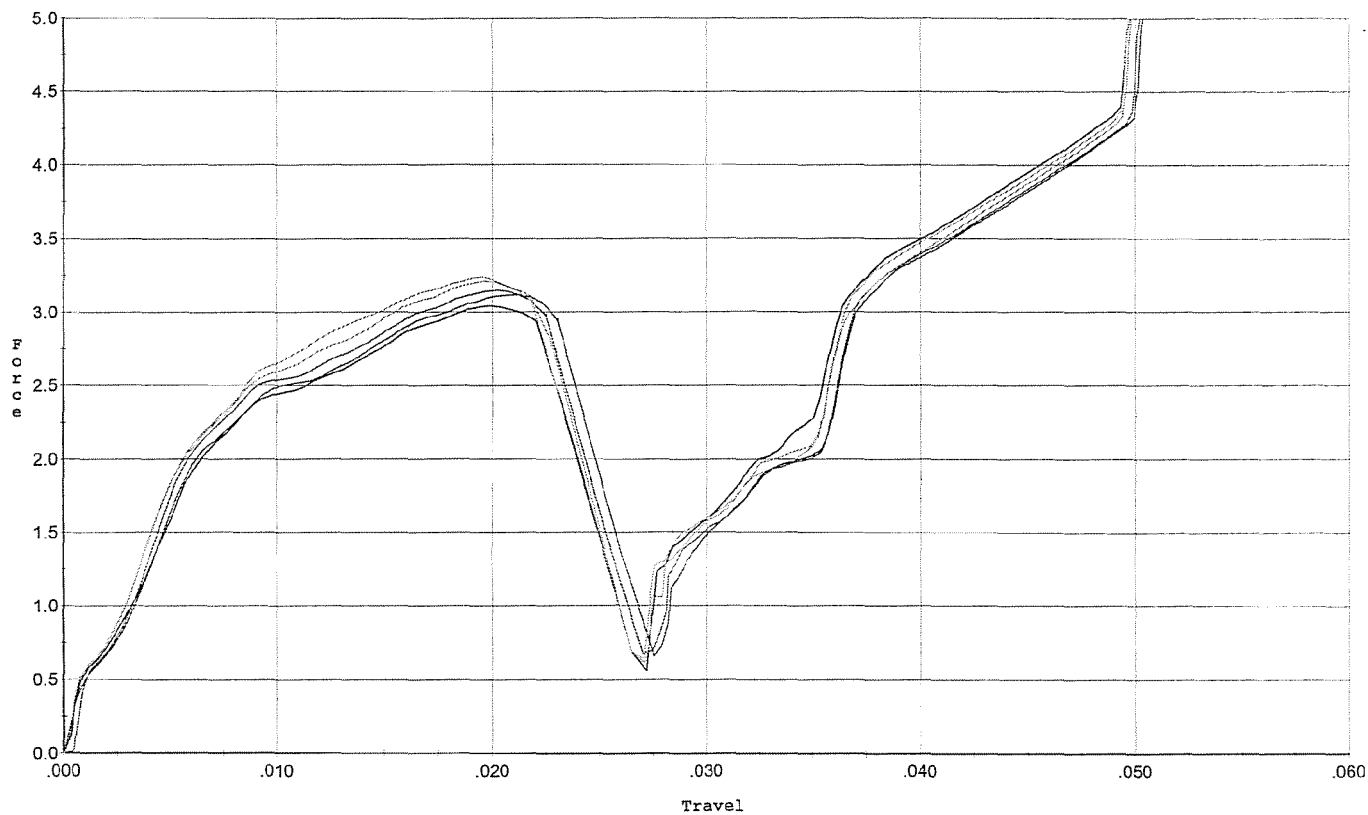
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.620	0.022	0.00	0.031	0.043		Set Trigger
2	2.566	0.022	0.00	0.032	0.043		Set Trigger
3	2.580	0.022	0.00	0.032	0.042		Set Trigger
4	2.623	0.021	0.00	0.032	0.042		Set Trigger
5	2.673	0.022	0.00	0.032	0.043		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/28/2009

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



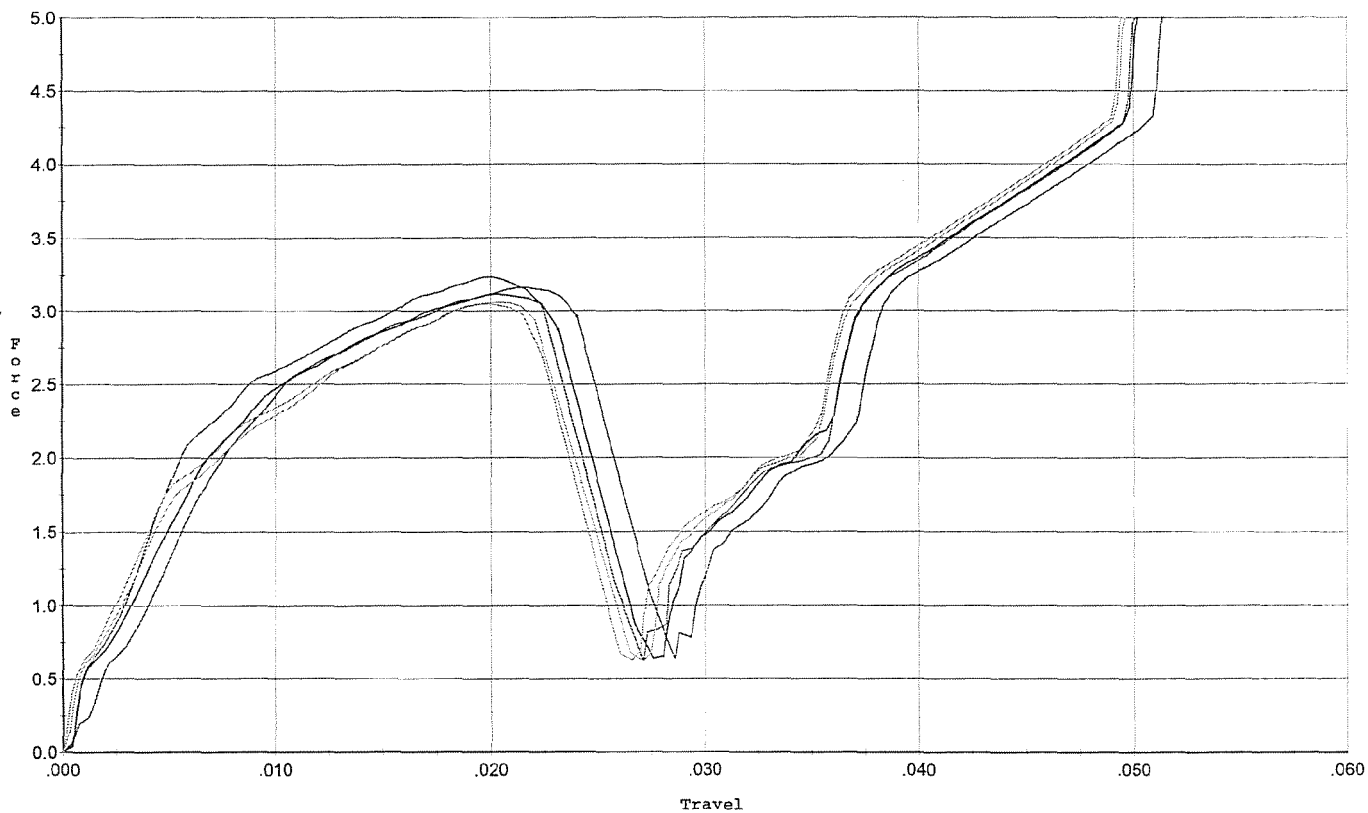
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.023	0.00	0.030	0.050		Set Trigger
2	3.043	0.024	0.00	0.030	0.051		Set Trigger
3	3.149	0.022	0.00	0.031	0.049		Set Trigger
4	3.213	0.022	0.00	0.031	0.049		Set Trigger
5	3.241	0.023	0.00	0.030	0.052		Set Trigger

17.3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/28/2009

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



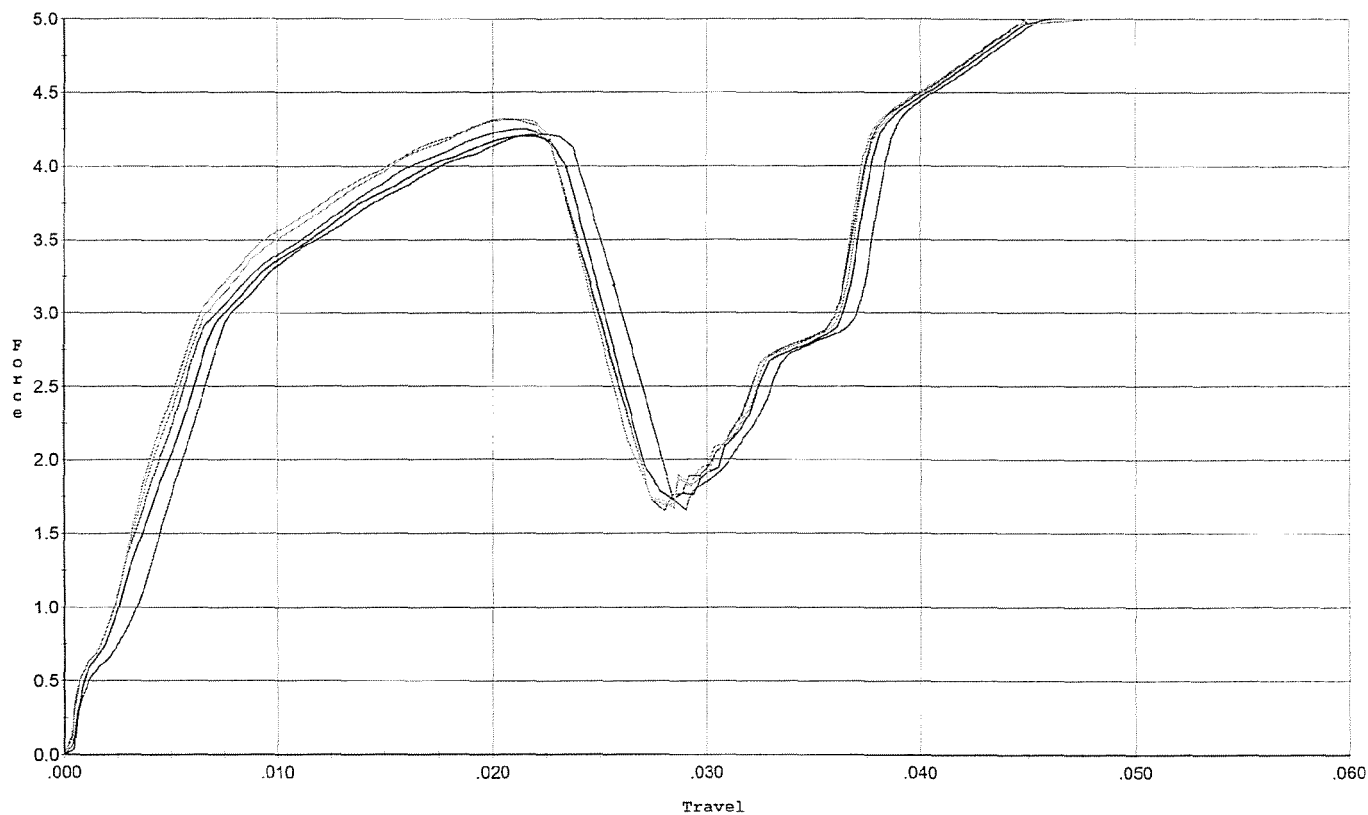
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.024	0.00	0.030	0.051		Set Trigger
2	3.116	0.023	0.00	0.030	0.050		Set Trigger
3	3.236	0.022	0.00	0.031	0.051		Set Trigger
4	3.060	0.024	0.00	0.030	0.051		Set Trigger
5	3.050	0.022	0.00	0.030	0.048		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/28/2009

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



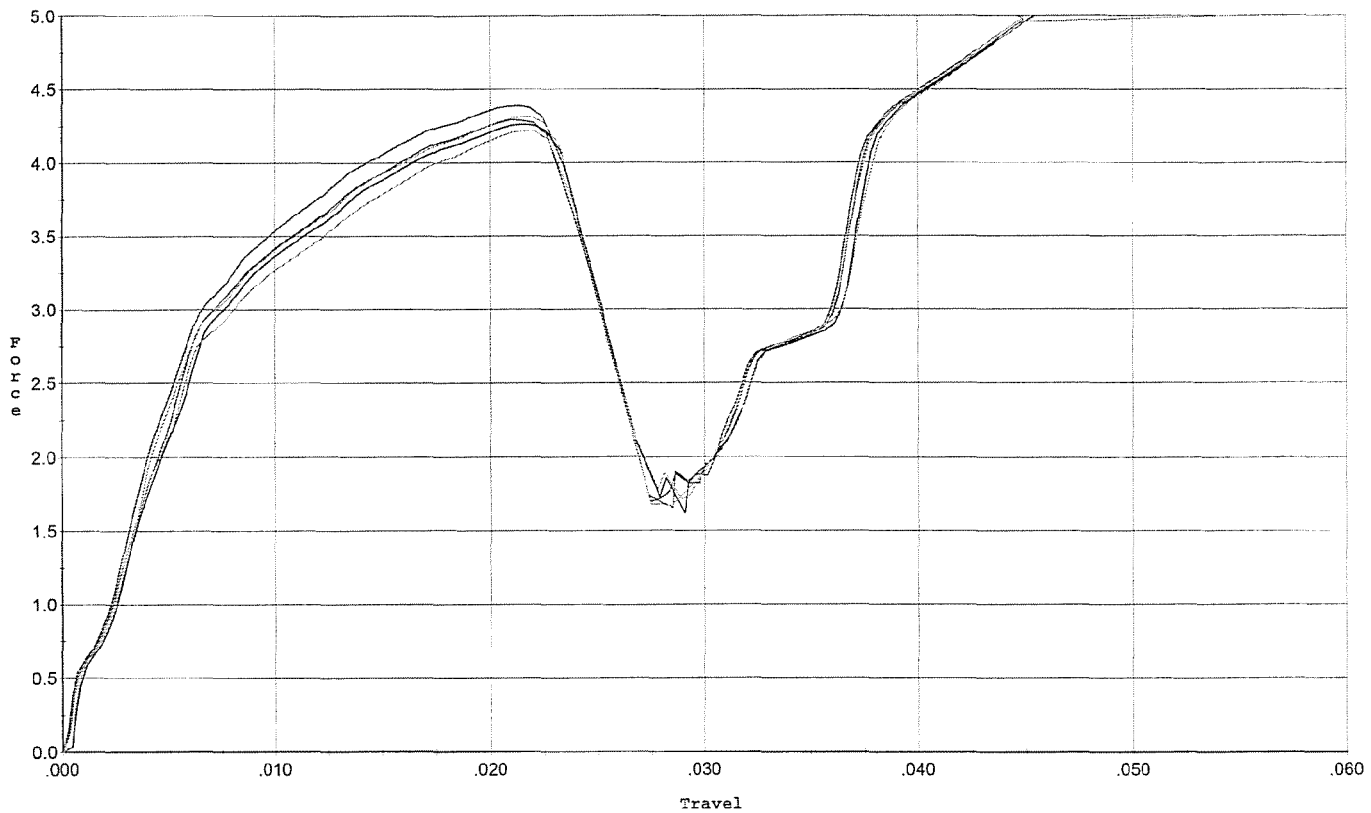
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.213	0.026	0.00	0.024	0.073		Set Trigger
2	4.201	0.023	0.00	0.028	0.068		Set Trigger
3	4.252	0.023	0.00	0.028	0.066		Set Trigger
4	4.315	0.025	0.00	0.027	0.074		Set Trigger
5	4.320	0.023	0.00	0.028	0.068		Set Trigger

A 4.26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/28/2009

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



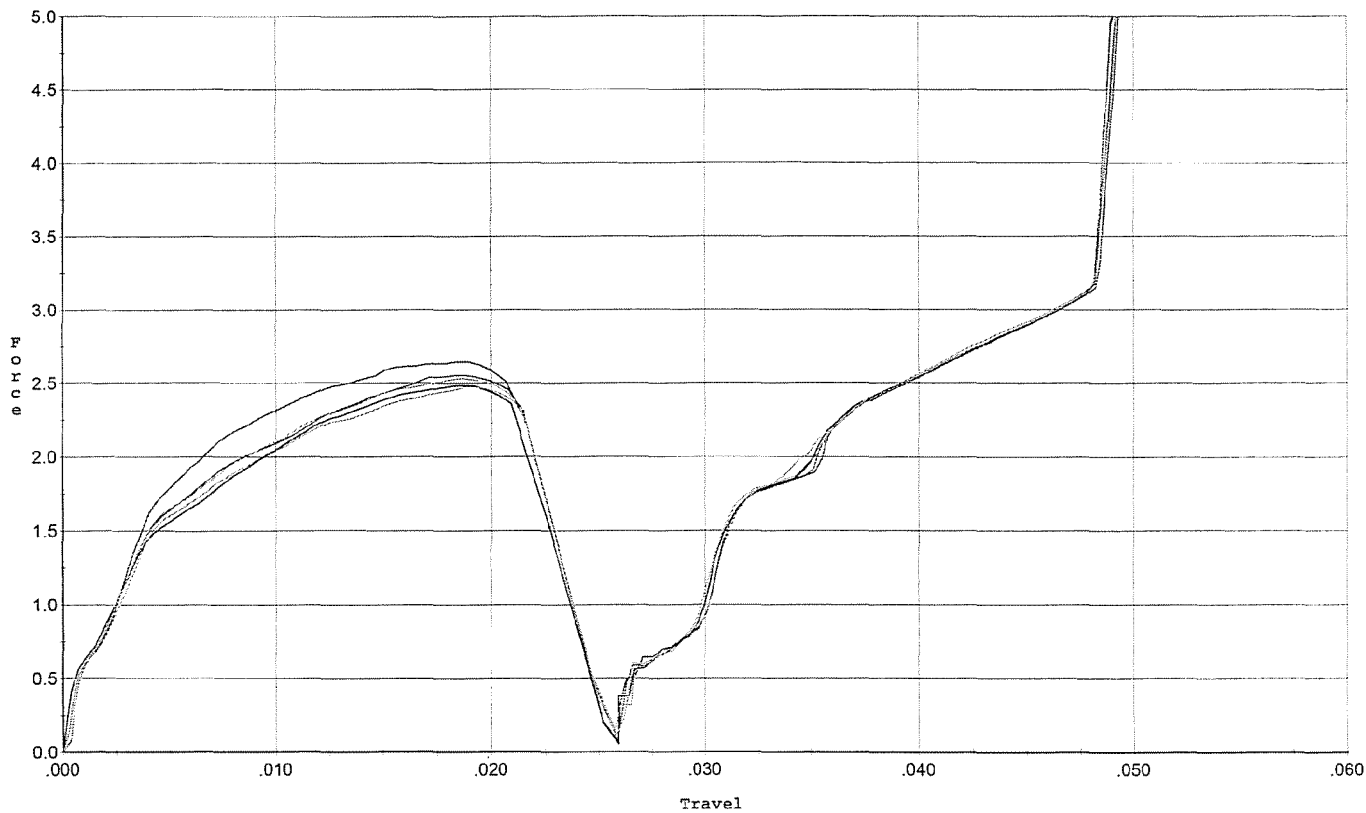
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.388	0.023	0.00	0.027	0.071		Set Trigger
2	4.260	0.023	0.00	0.028	0.068		Set Trigger
3	4.291	0.024	0.00	0.027	0.071		Set Trigger
4	4.312	0.023	0.00	0.028	0.069		Set Trigger
5	4.216	0.024	0.00	0.027	0.068		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/28/2009

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



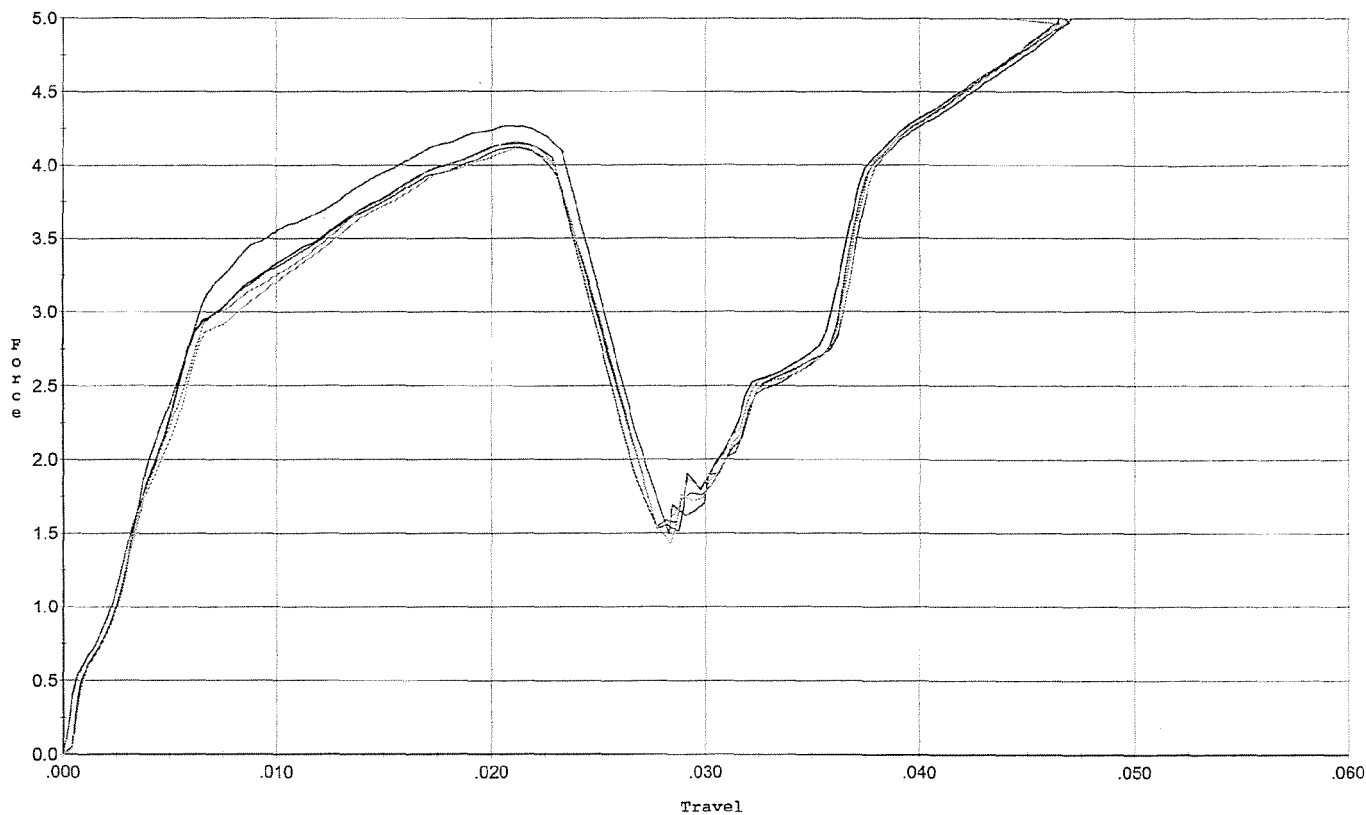
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.022	0.00	0.031	0.043		Set Trigger
2	2.485	0.023	0.00	0.031	0.041		Set Trigger
3	2.554	0.021	0.00	0.031	0.040		Set Trigger
4	2.531	0.022	0.00	0.031	0.040		Set Trigger
5	2.476	0.022	0.00	0.032	0.039		Set Trigger

A-253

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/28/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.266	0.023	0.00	0.028	0.070		Set Trigger
2	4.150	0.025	0.00	0.028	0.073		Set Trigger
3	4.121	0.023	0.00	0.028	0.066		Set Trigger
4	4.112	0.025	0.00	0.028	0.070		Set Trigger
5	4.162	0.023	0.00	0.028	0.065		Set Trigger

A. 4.16