

6686984-9

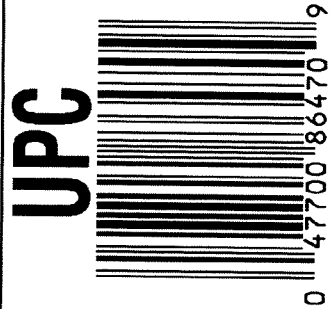
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6869849



GUN SERIAL # G 6869849

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-23-09	SP
430	ASSEMBLE TO STOCK		6-23-09	SP
440	PROOF		6-23-09	SP
460	CHECK HEADSPACE	MAGNAFLUX	6-23-09	SP
470	DIS-ASSEMBLE ACTION		6-23-09	SP
472	SERIALIZE BOLT HANDLE		6-24-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	6/26/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/26/09	RT
510	DRILL AND TAP SIGHT HOLES		6-24-09	SP
520	GOFF BLAST BBL / REC		6-26-09	SP
540	APPLY COATINGS (BARREL ACTION)		7/14	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-14-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-14-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-14-09	SP
	D) OIL FIRING PIN ASSEMBLY		7-16-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

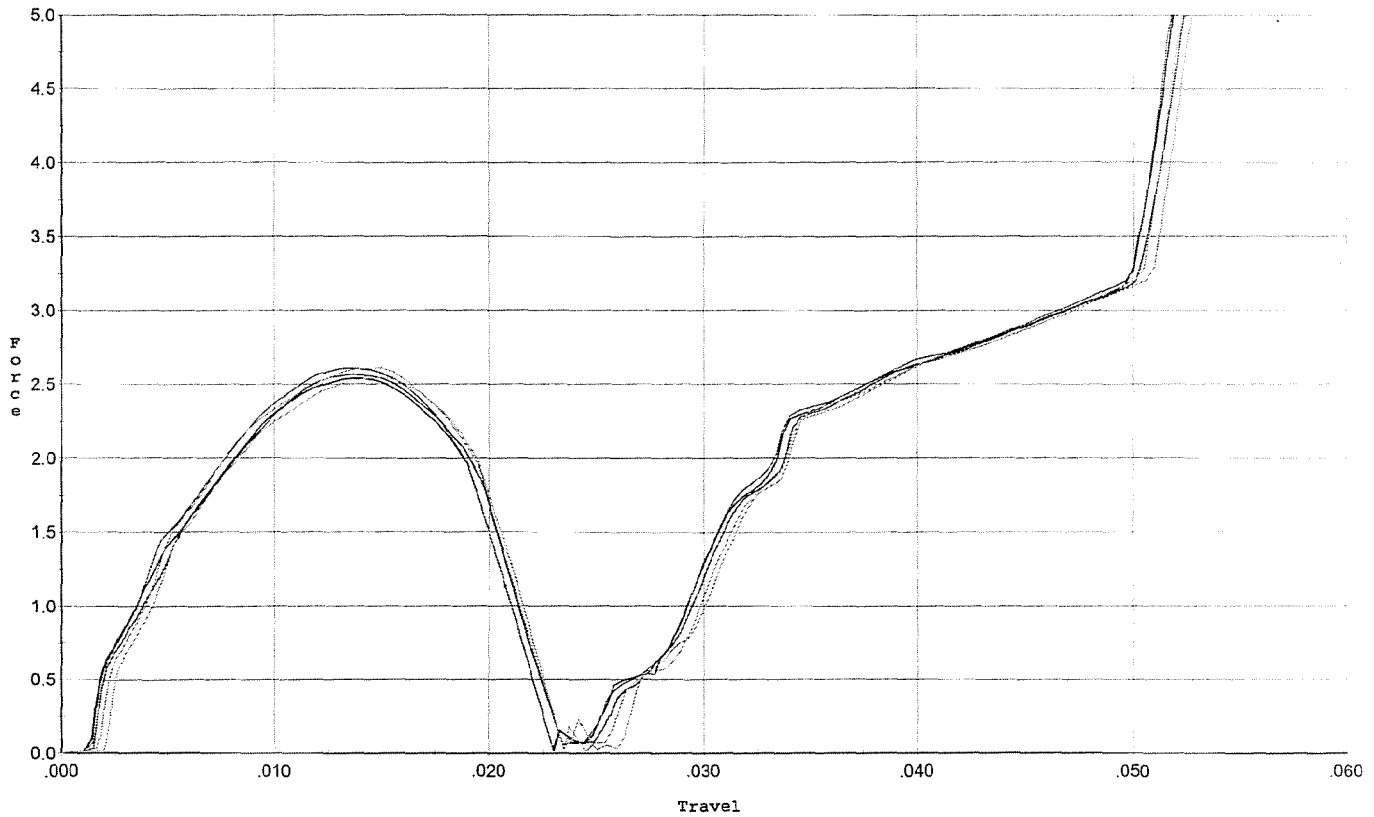
560	F) SAFETY ON FORCE	BARBER M24 0095689 2 LBS MIN 10 LBS MAX	<u>50</u> <u>50</u> <u>40</u>	7-30-09	L N
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	7-30-09	L N
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	7-30-09	L N
	J) ASSEMBLE STOCK			7-16-09	L N
	K) ASSEMBLE SWIVEL STUDS			7-30-09	L N
	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	7-27-09	L N
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			7/27/09	RP
670	FINAL INSPECTION A) HEADSPACE			7-30-09	L N
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>241</u> <u>250</u> <u>245</u> <u>242</u> <u>241</u>	7-30-09	L N
	C) FUNCTION			7-30-09	L N
690	PACK			8/6/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



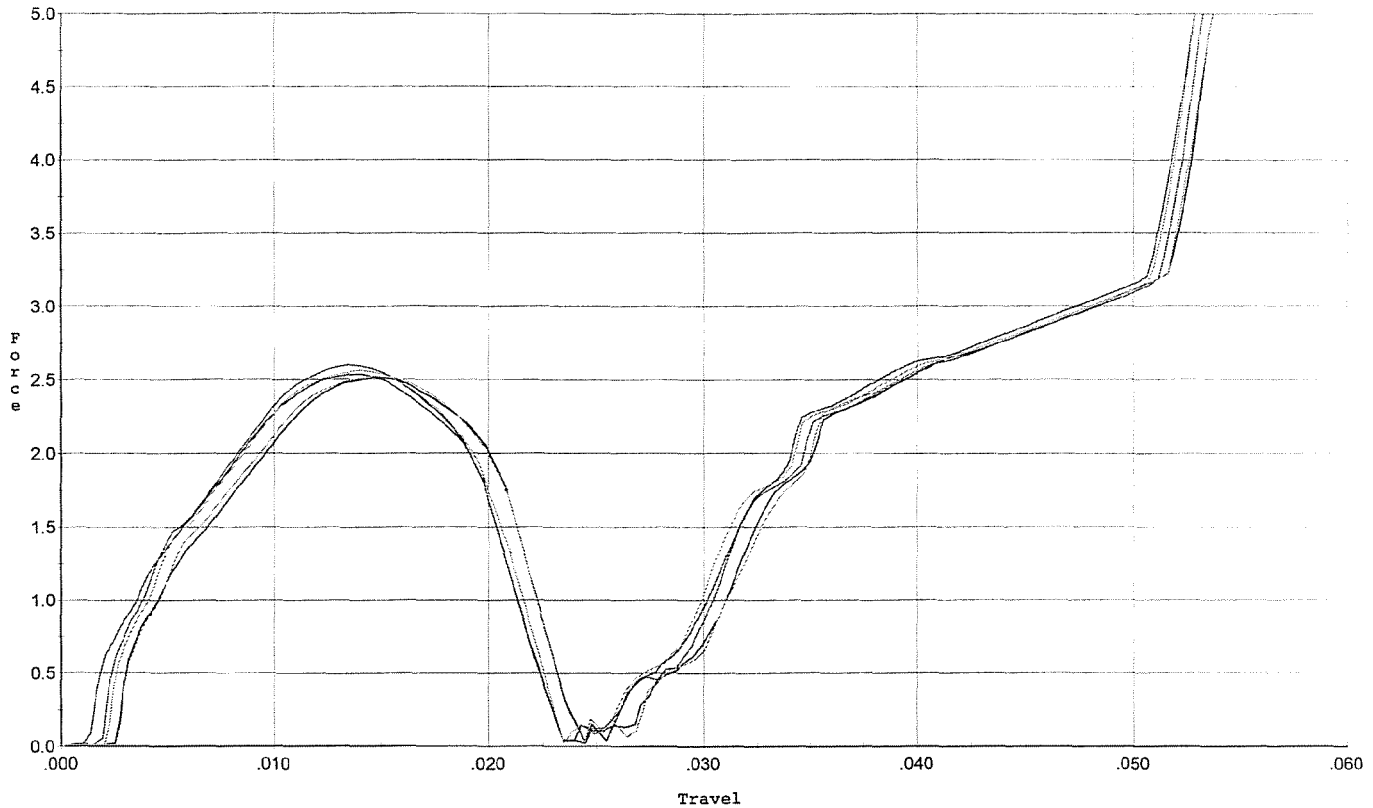
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.566	0.020	0.00	0.036	0.034		Set Trigger
2	2.539	0.021	0.00	0.036	0.035		Set Trigger
3	2.608	0.021	0.00	0.036	0.036		Set Trigger
4	2.545	0.021	0.002	0.036	0.035		Set Trigger
5	2.611	0.020	0.002	0.037	0.034		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



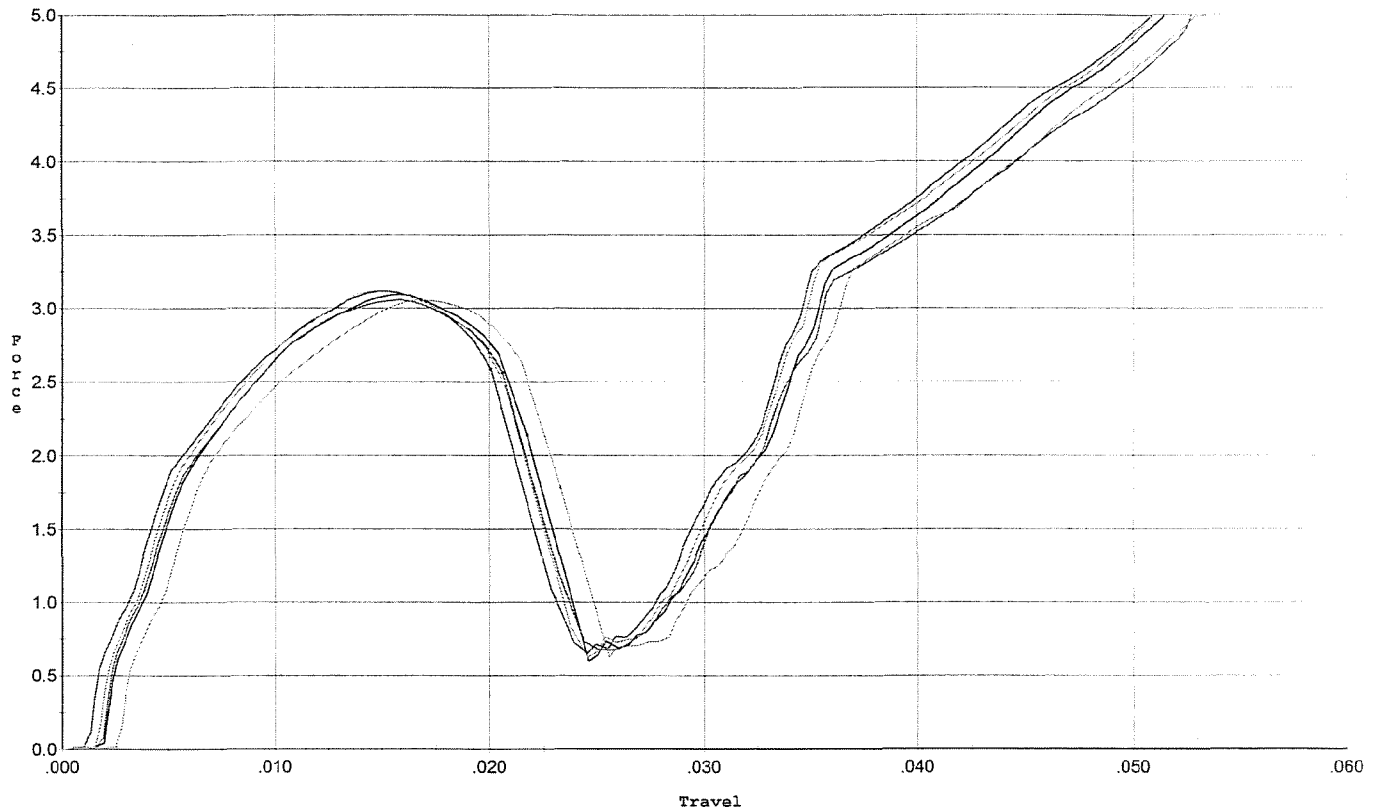
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.020	0.00	0.037	0.034		Set Trigger
2	2.515	0.021	0.003	0.037	0.034		Set Trigger
3	2.600	0.020	0.002	0.037	0.034		Set Trigger
4	2.565	0.021	0.002	0.036	0.035		Set Trigger
5	2.526	0.021	0.003	0.037	0.034		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



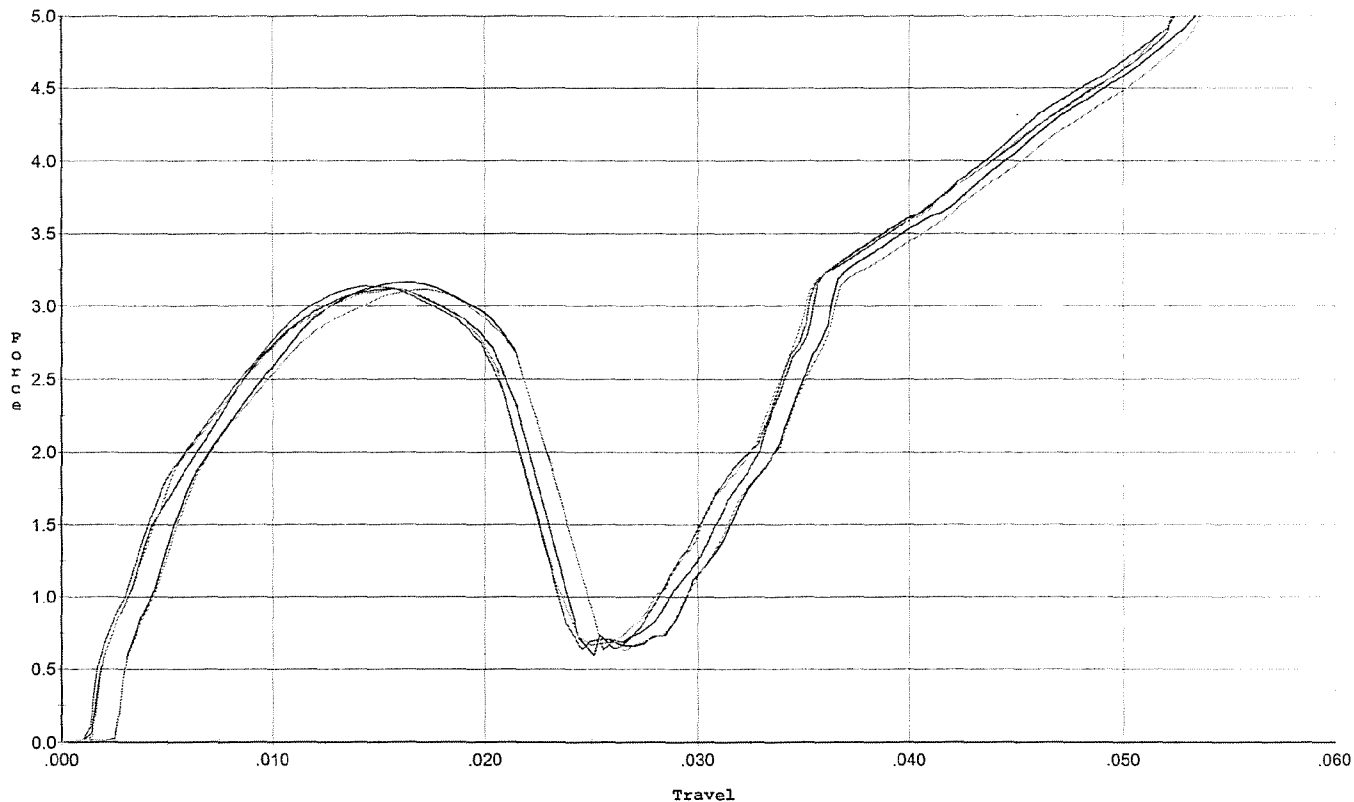
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.020	0.00	0.034	0.043		Set Trigger
2	3.096	0.022	0.002	0.034	0.045		Set Trigger
3	3.058	0.021	0.002	0.034	0.042		Set Trigger
4	3.120	0.021	0.002	0.034	0.044		Set Trigger
5	3.056	0.023	0.003	0.034	0.046		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



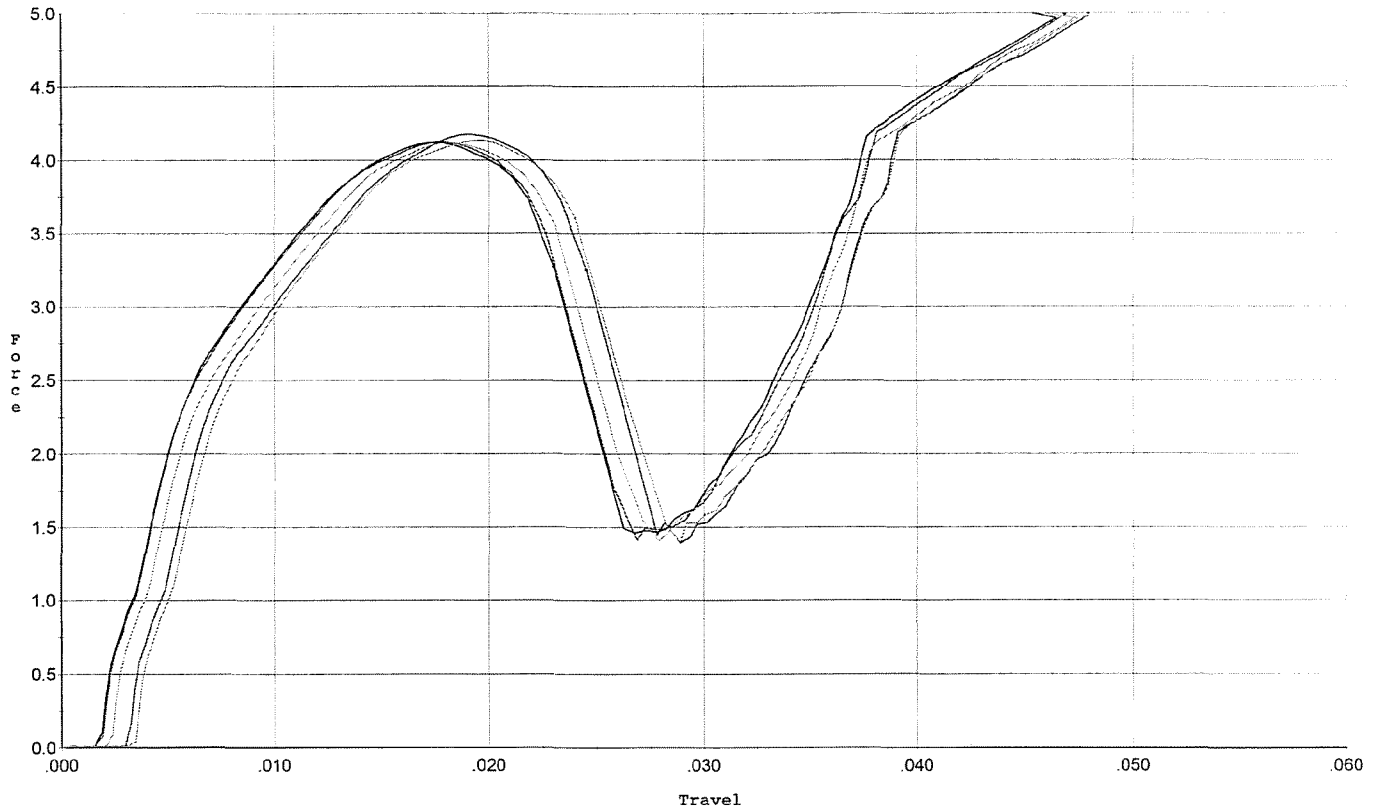
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.021	0.00	0.034	0.046		Set Trigger
2	3.164	0.023	0.003	0.034	0.048		Set Trigger
3	3.135	0.021	0.00	0.034	0.045		Set Trigger
4	3.116	0.021	0.00	0.034	0.044		Set Trigger
5	3.117	0.023	0.003	0.034	0.047		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



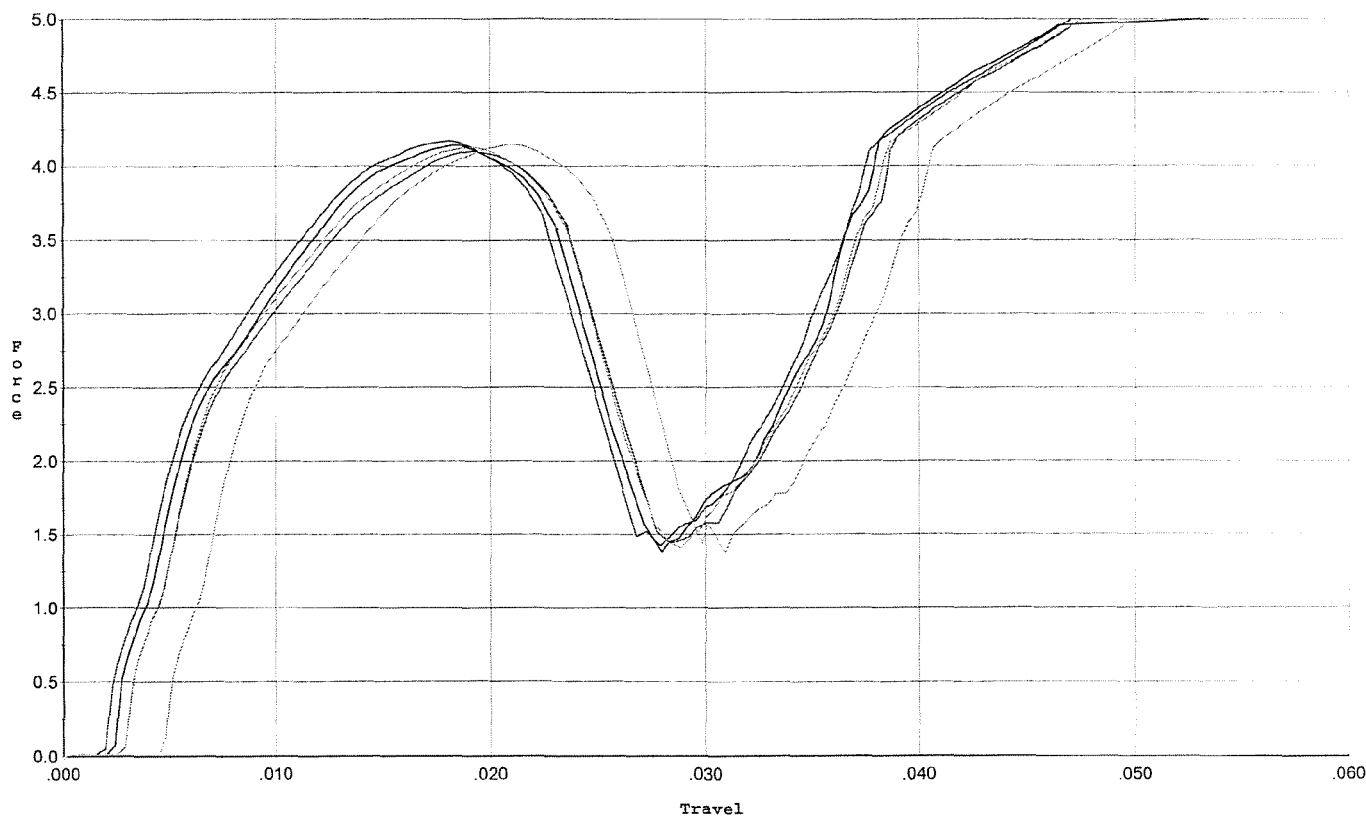
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.176	0.025	0.003	0.032	0.064		Set Trigger
2	4.120	0.023	0.002	0.032	0.063		Set Trigger
3	4.124	0.023	0.002	0.032	0.062		Set Trigger
4	4.118	0.023	0.002	0.032	0.062		Set Trigger
5	4.136	0.024	0.004	0.033	0.062		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



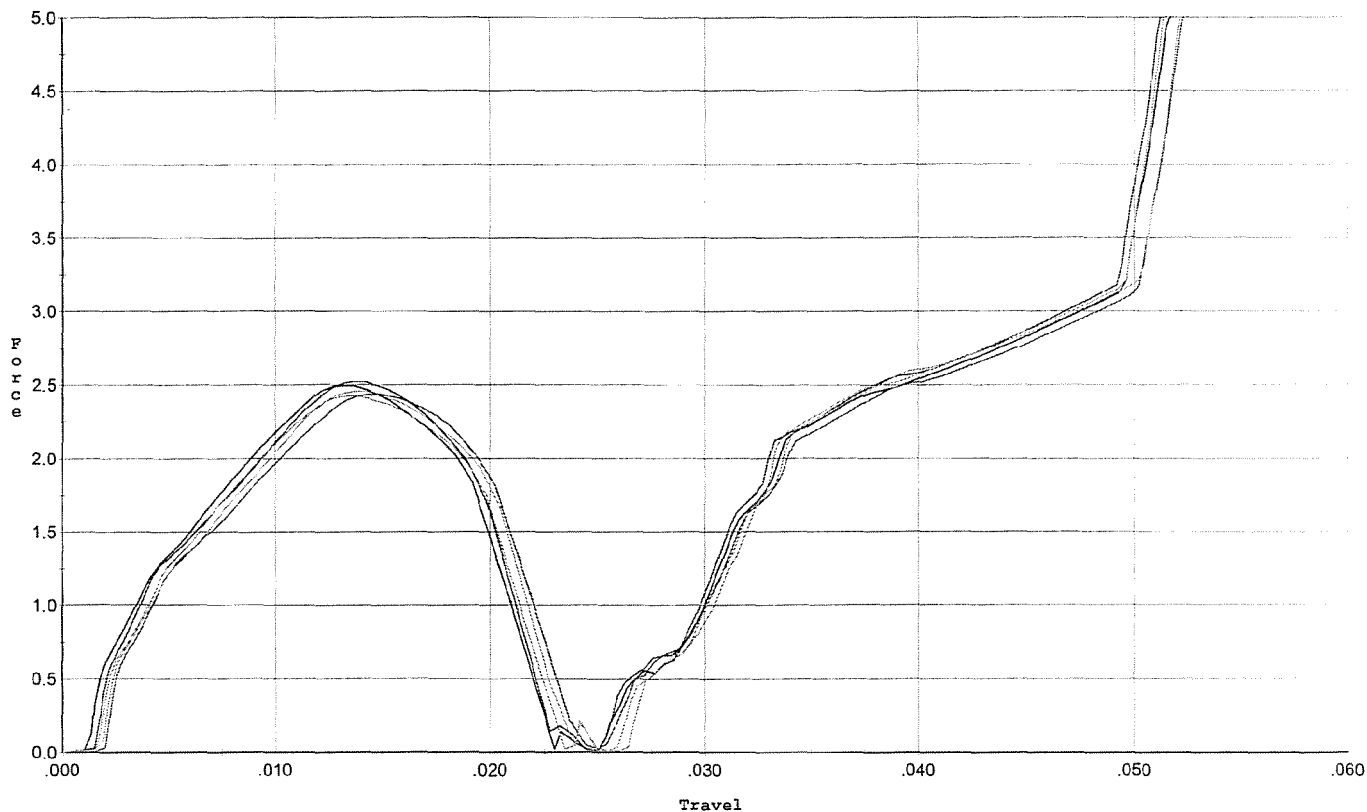
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.025	0.002	0.032	0.067		Set Trigger
2	4.140	0.023	0.002	0.032	0.062		Set Trigger
3	4.102	0.024	0.003	0.032	0.061		Set Trigger
4	4.147	0.026	0.005	0.033	0.064		Set Trigger
5	4.128	0.024	0.003	0.032	0.062		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/12/09

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



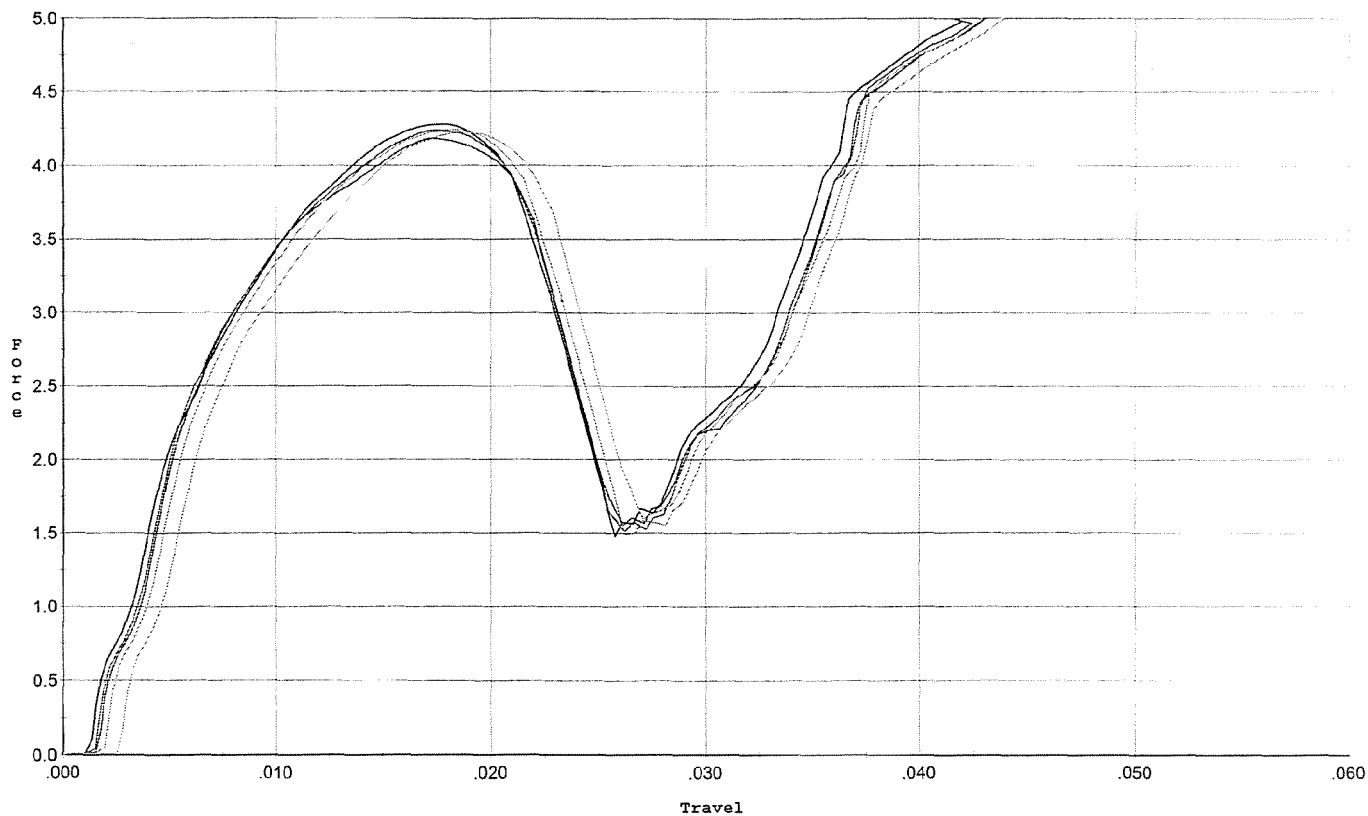
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.020	0.00	0.036	0.033		Set Trigger
2	2.495	0.021	0.00	0.036	0.034		Set Trigger
3	2.441	0.022	0.002	0.036	0.034		Set Trigger
4	2.457	0.020	0.002	0.035	0.033		Set Trigger
5	2.426	0.020	0.002	0.036	0.032		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/12/09

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	4.184	0.022	0.00	0.031	0.060		Set Trigger
2	4.279	0.023	0.00	0.030	0.063		Set Trigger
3	4.239	0.022	0.00	0.031	0.061		Set Trigger
4	4.223	0.023	0.003	0.031	0.061		Set Trigger
5	4.239	0.023	0.002	0.031	0.064		Set Trigger

Avg 4.23