

G680 1385

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



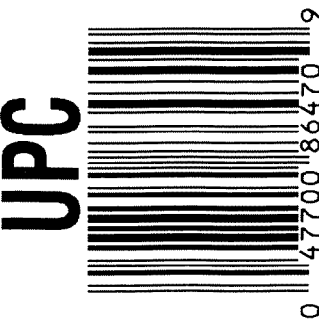
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6801385



GUN SERIAL #

G 680 1385

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	SP
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	SP
460	CHECK HEADSPACE		10-14-08	SP
470	DIS-ASSEMBLE ACTION		10-14-08	SP
472	SERIALIZE BOLT HANDLE		10-15-08	RT
475	DRILL AND TAP SIGHT HOLES		10-15-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/17/08	KB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DK
542	APPLY COATINGS (BARREL ACTION)		10/22/08	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-14-09	SP
	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>50</u> <u>50</u> <u>50</u>	1-19-09	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>7.0</u> <u>7.0</u>	1-19-09	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-19-09	L N
	J) ASSEMBLE STOCK		1-14-09	L N
	K) ASSEMBLE SWIVEL STUDS		1-19-09	R 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	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-15-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-15-09	L N
670	FINAL INSPECTION A) HEADSPACE		1-19-09	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.60</u> <u>2.62</u> <u>2.62</u> <u>2.53</u>	1-16-09	TC
	C) FUNCTION		1-19-09	L N
690	PACK		1-20-09	R N

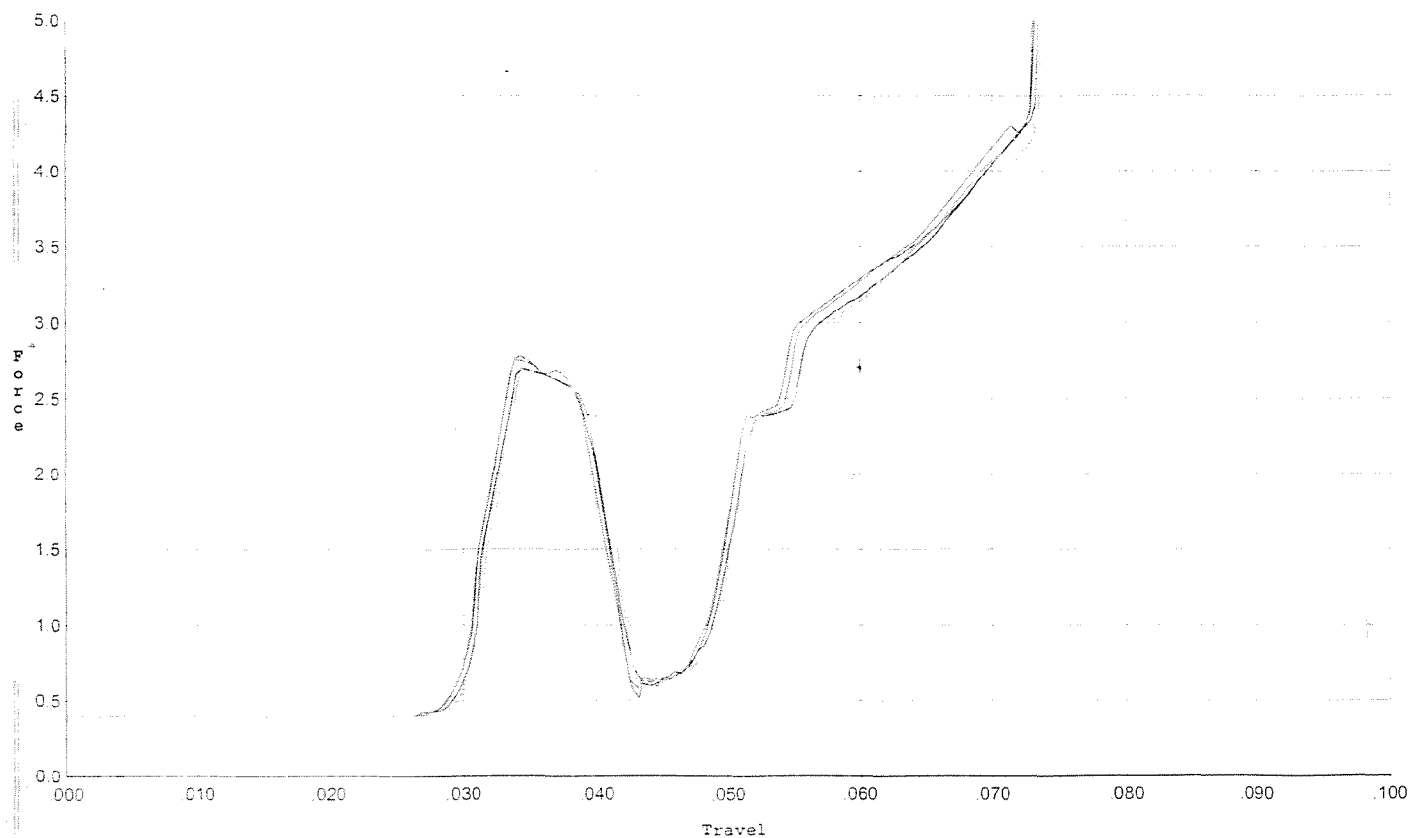
F004 REV 5/2006

BARBER - M24 0014658

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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	2.780	0.040	0.029	0.036	0.036		Set Trigger
2	2.698	0.039	0.030	0.036	0.035		Set Trigger
3	2.751	0.039	0.030	0.036	0.034		Set Trigger
4	2.685	0.041	0.030	0.036	0.036		Set Trigger
5	2.775	0.040	0.030	0.036	0.035		Set Trigger

A-2-73

Trigger Scan 2 01, SN 10337, printed by Remington Arms Co., Inc. 1/14/2009 10:13:07 AM

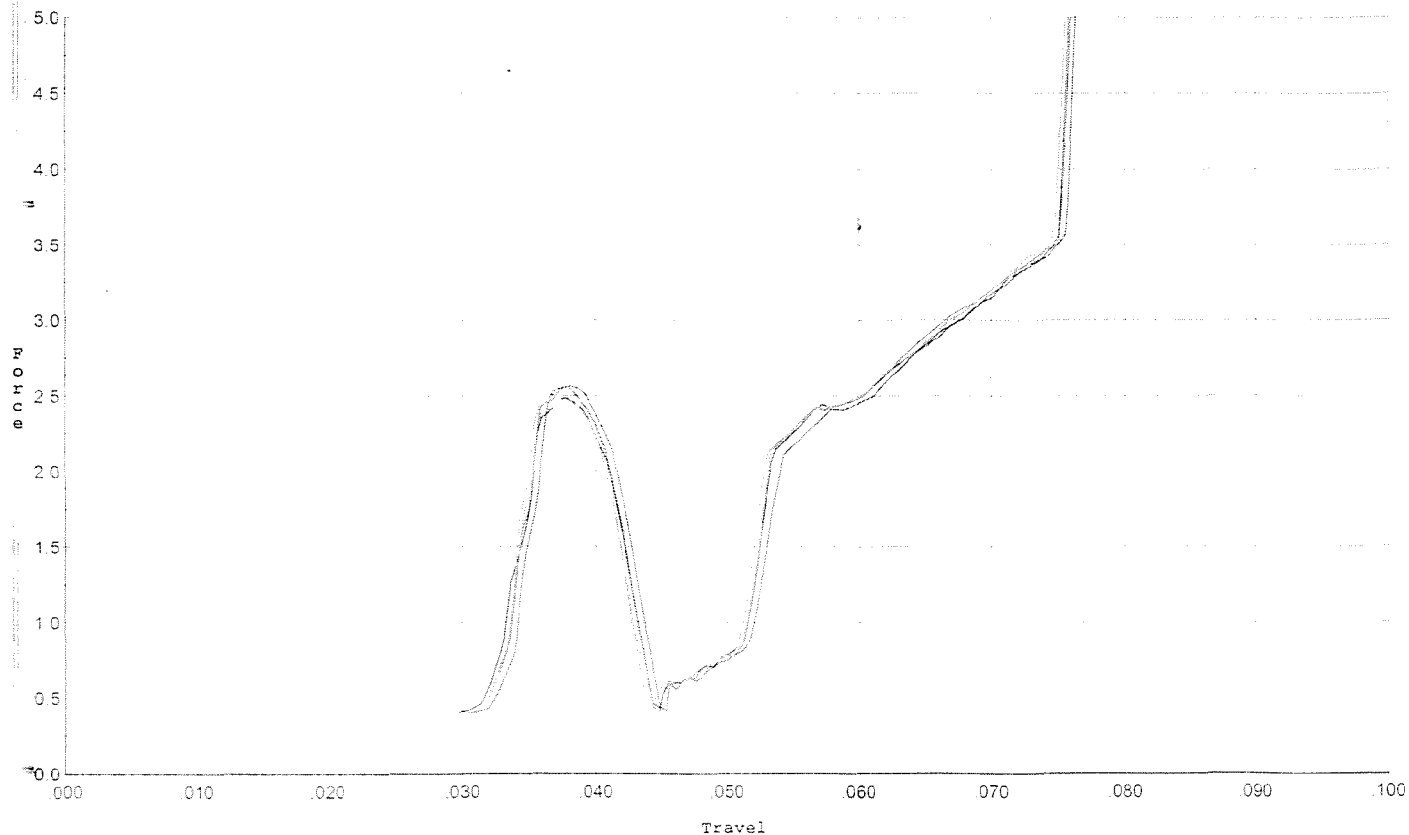
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0014658

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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



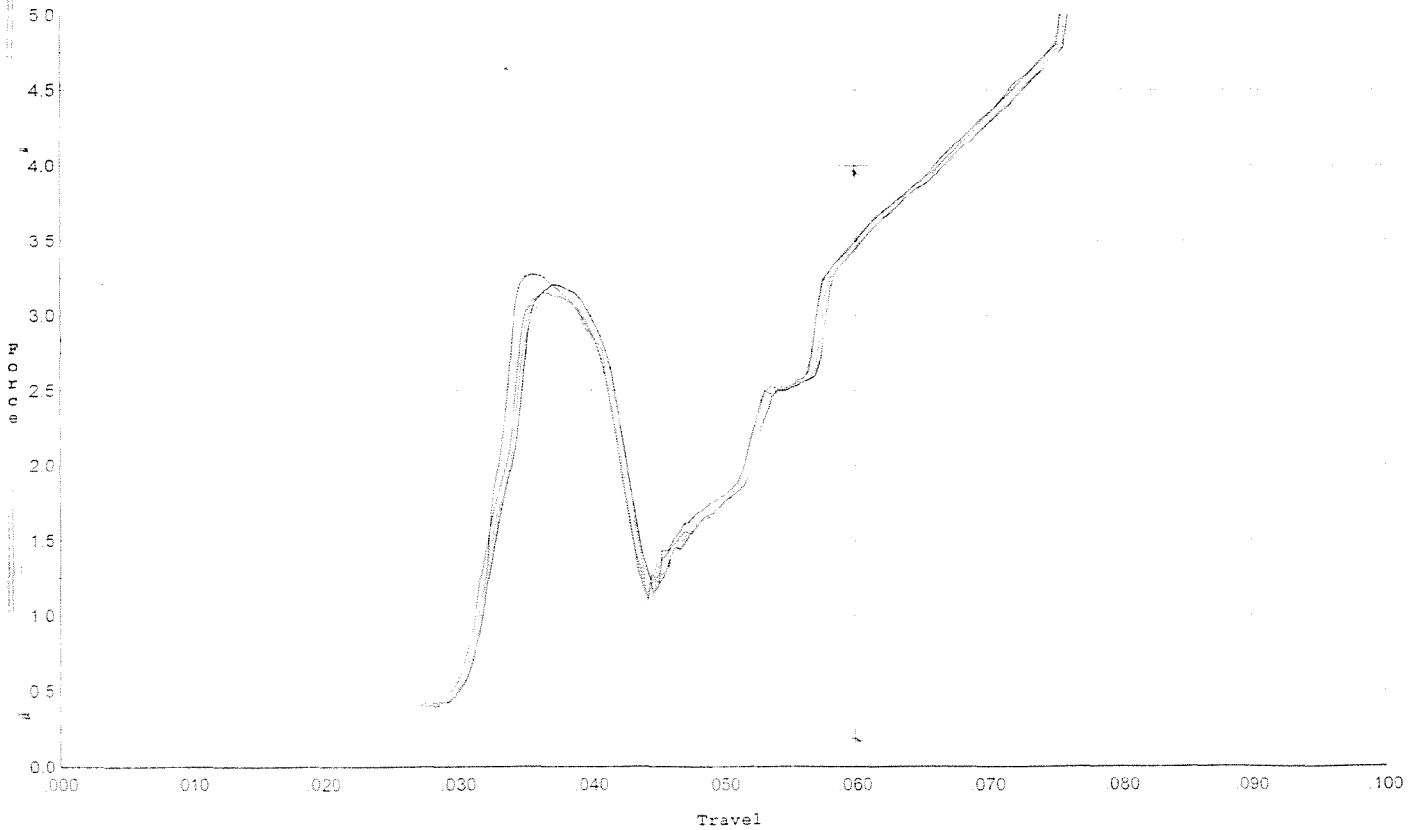
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.043	0.033	0.037	0.033		Set Trigger
2	2.485	0.042	0.032	0.037	0.033		Set Trigger
3	2.554	0.042	0.032	0.037	0.033		Set Trigger
4	2.496	0.041	0.032	0.038	0.031		Set Trigger
5	2.579	0.041	0.032	0.038	0.032		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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	3.272	0.041	0.030	0.035	0.041		Set Trigger
2	3.204	0.041	0.031	0.035	0.041		Set Trigger
3	3.143	0.041	0.030	0.035	0.040		Set Trigger
4	3.169	0.041	0.030	0.036	0.040		Set Trigger
5	3.130	0.042	0.031	0.035	0.041		Set Trigger

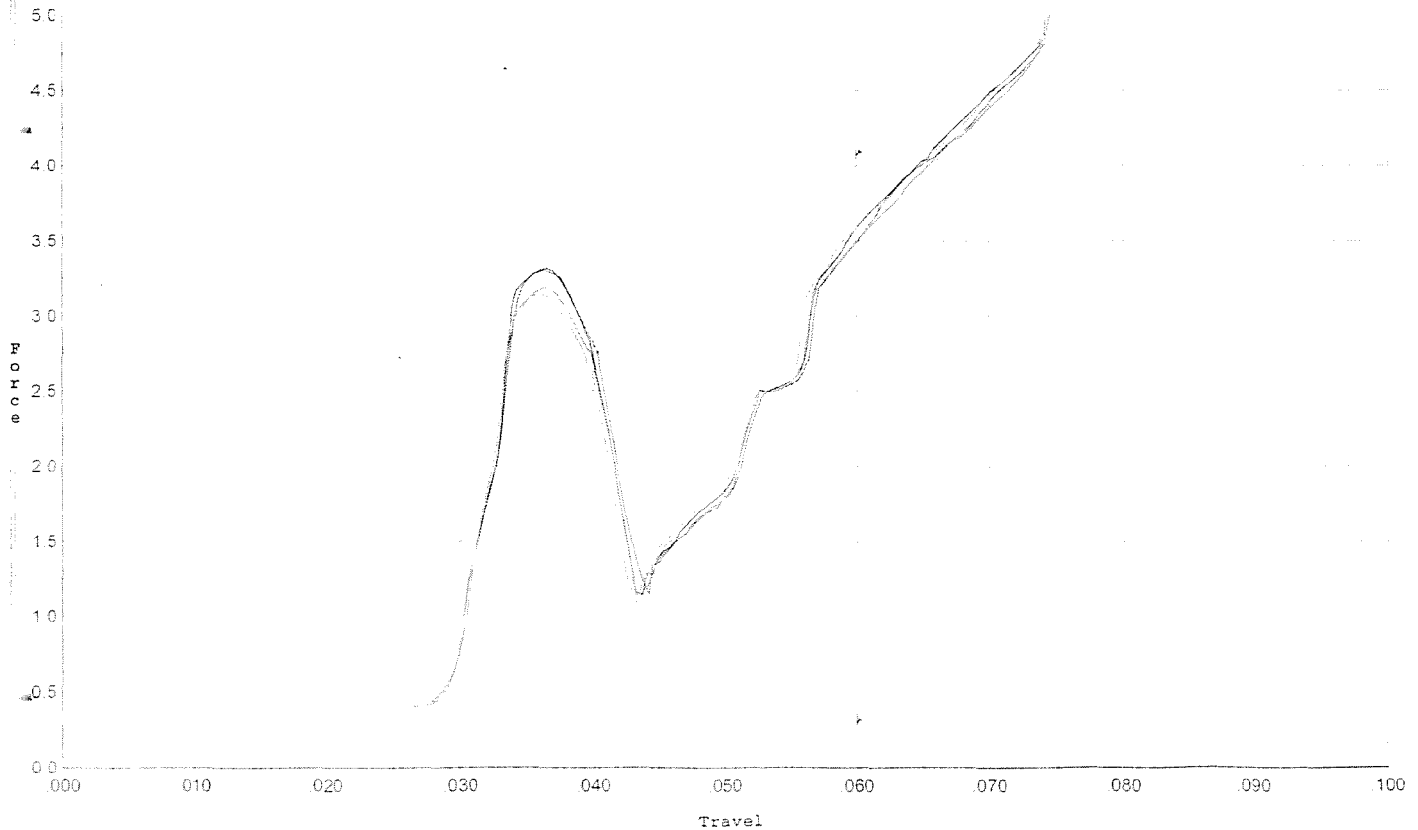
A-3.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

Model: M/24
 Serial No: Form #F005 20
 Trigger: 3.0 lbs after 50 cycles +/- .75 lb

CMS



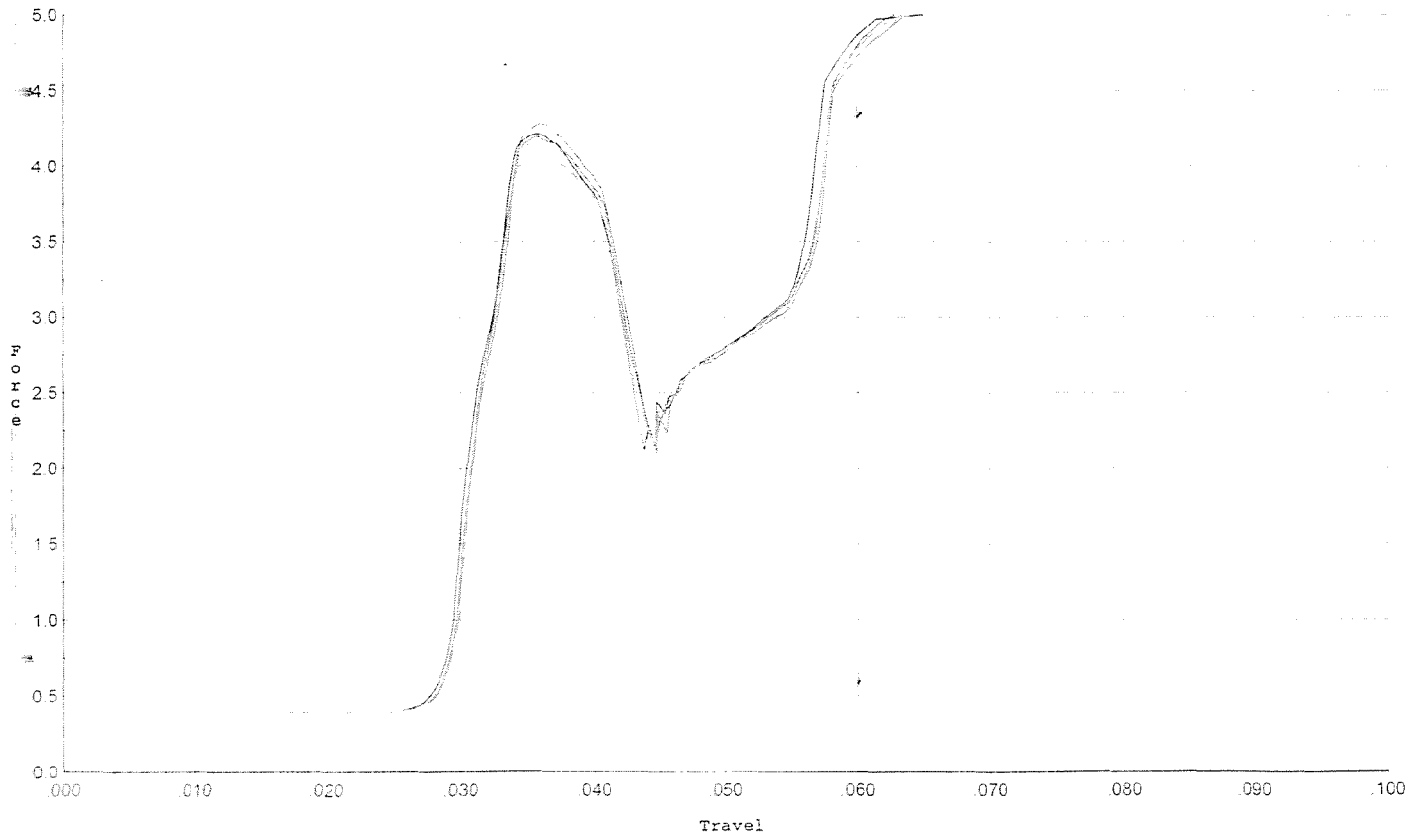
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.307	0.040	0.029	0.035	0.042		Set Trigger
2	3.320	0.041	0.029	0.035	0.042		Set Trigger
3	3.185	0.041	0.029	0.035	0.042		Set Trigger
4	3.142	0.040	0.029	0.035	0.040		Set Trigger
5	3.157	0.040	0.029	0.035	0.040		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



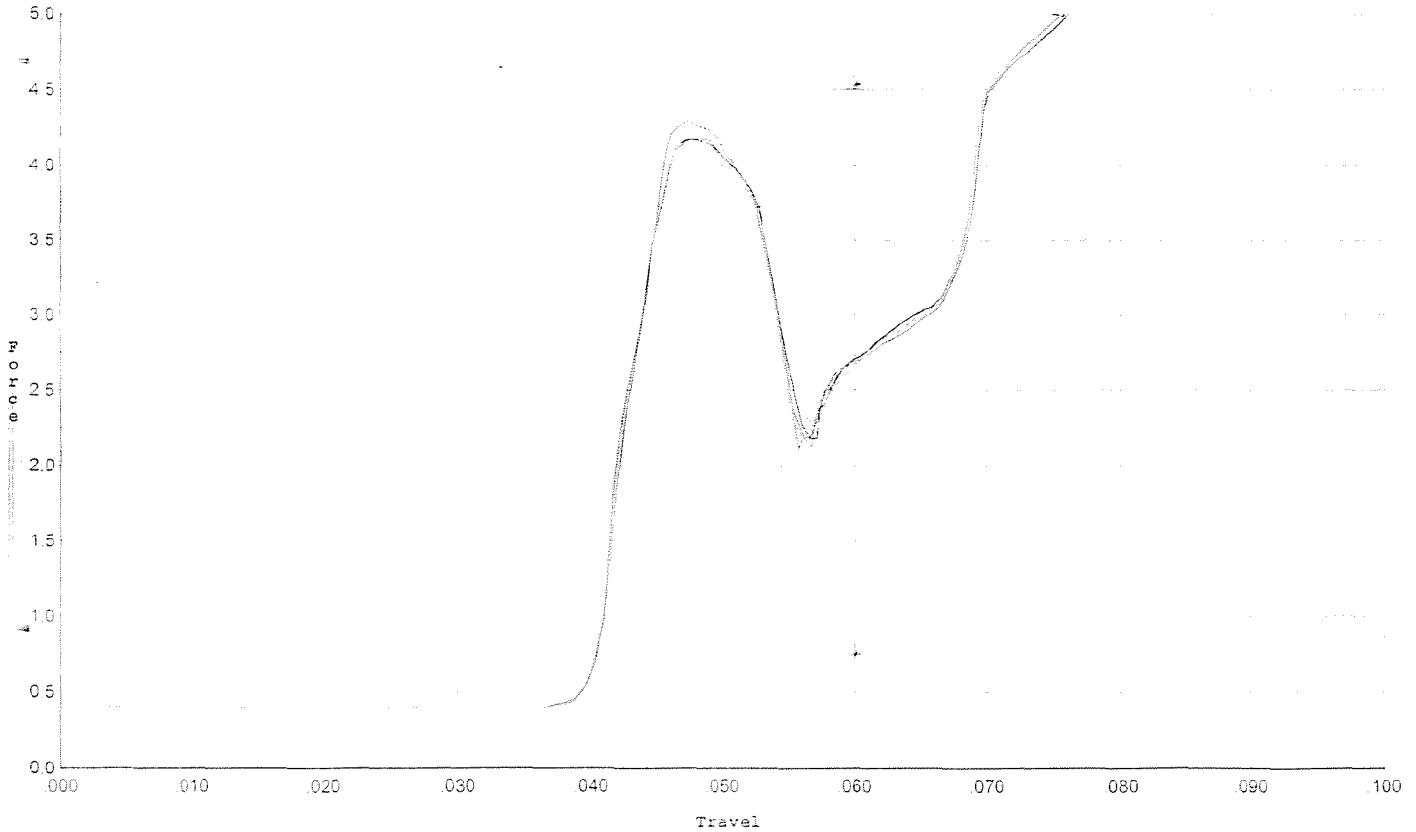
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.282	0.042	0.029	0.031	0.058		Set Trigger
2	4.209	0.041	0.028	0.031	0.056		Set Trigger
3	4.195	0.041	0.029	0.031	0.055		Set Trigger
4	4.166	0.041	0.029	0.031	0.055		Set Trigger
5	4.091	0.041	0.029	0.031	0.055		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



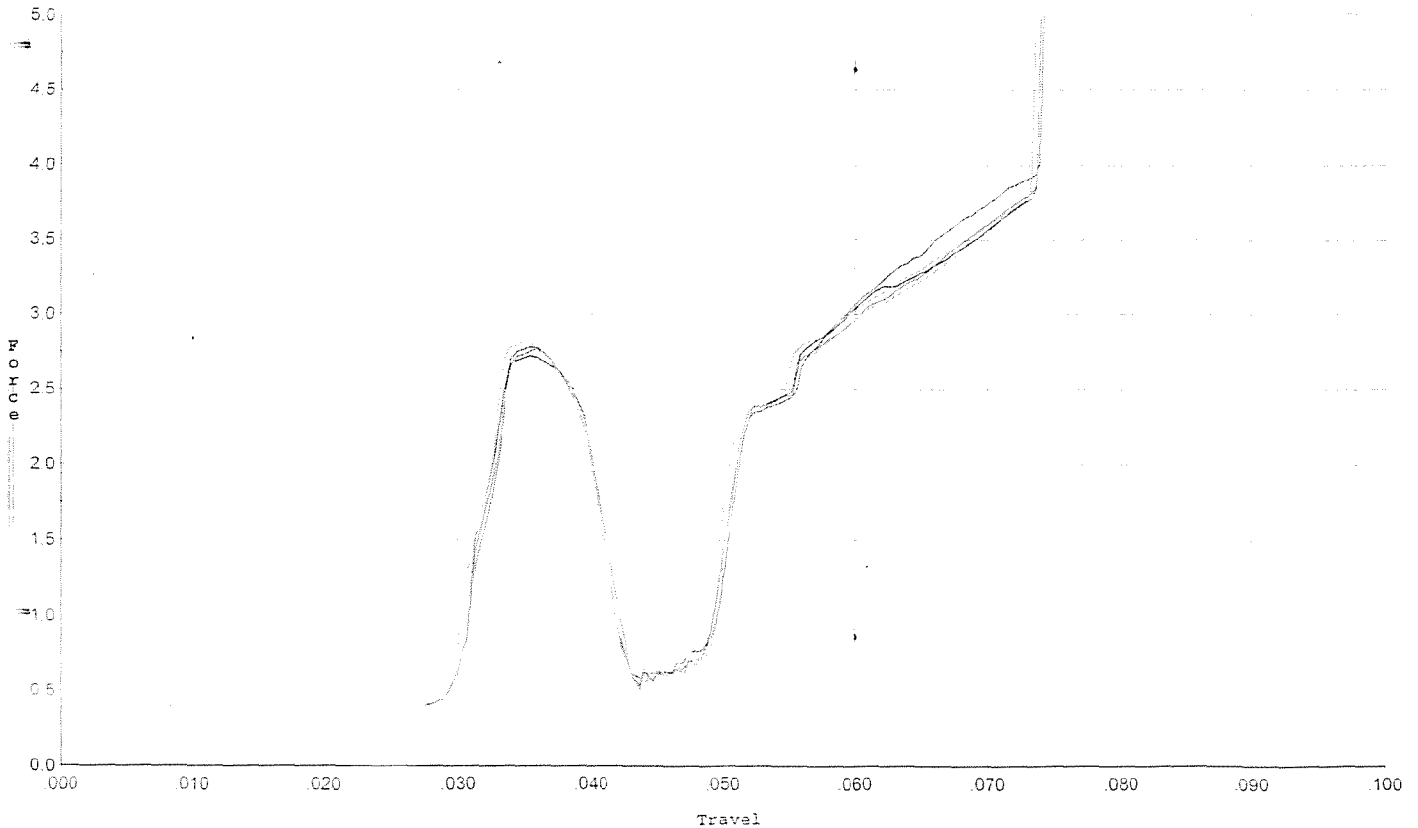
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.175	0.053	0.040	0.033	0.063		Set Trigger
2	4.169	0.053	0.040	0.034	0.063		Set Trigger
3	4.289	0.053	0.040	0.033	0.064		Set Trigger
4	4.152	0.053	0.040	0.033	0.063		Set Trigger
5	4.192	0.053	0.040	0.033	0.063		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/14/2009

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



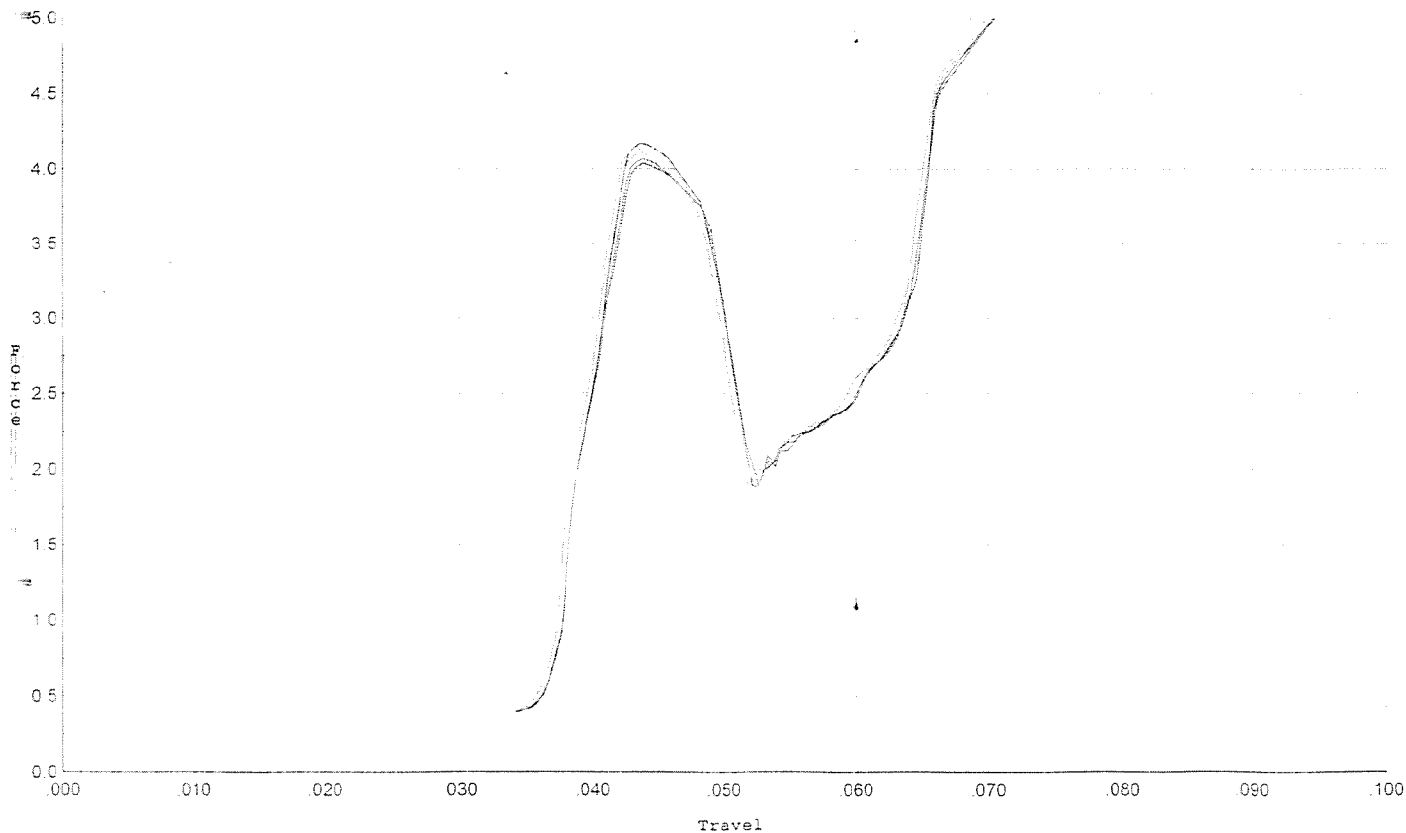
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.780	0.039	0.030	0.037	0.035		Set Trigger
2	2.718	0.040	0.030	0.036	0.035		Set Trigger
3	2.766	0.039	0.030	0.036	0.035		Set Trigger
4	2.743	0.040	0.030	0.036	0.035		Set Trigger
5	2.809	0.040	0.029	0.036	0.036		Set Trigger

A-2-76

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/14/2009

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	4.037	0.049	0.037	0.035	0.058		Set Trigger
2	4.167	0.049	0.037	0.035	0.059		Set Trigger
3	4.066	0.049	0.037	0.035	0.058		Set Trigger
4	4.107	0.048	0.036	0.035	0.057		Set Trigger
5	4.134	0.049	0.036	0.035	0.058		Set Trigger

A-4.10