

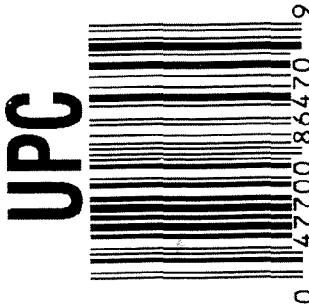
G-6807693

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

G6807693



BM FORM

GUN SERIAL # G 6807693

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-20-09	SP
430	ASSEMBLE TO STOCK		1-20-09	SP
440	PROOF		1-20-09	SP
460	CHECK HEADSPACE		1-20-09	SP
470	DIS-ASSEMBLE ACTION		1-20-09	SP
472	SERIALIZE BOLT HANDLE		1-21-09	RTC
475	DRILL AND TAP SIGHT HOLES		1-21-09	SP
480	MAGNAFLUX BBL ACTION	(A)	1/24/09	(B)
490	MAGNAFLUX BOLT		1/24/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1/24/09	DC
542	APPLY COATINGS (BARREL ACTION)		53	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-3-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

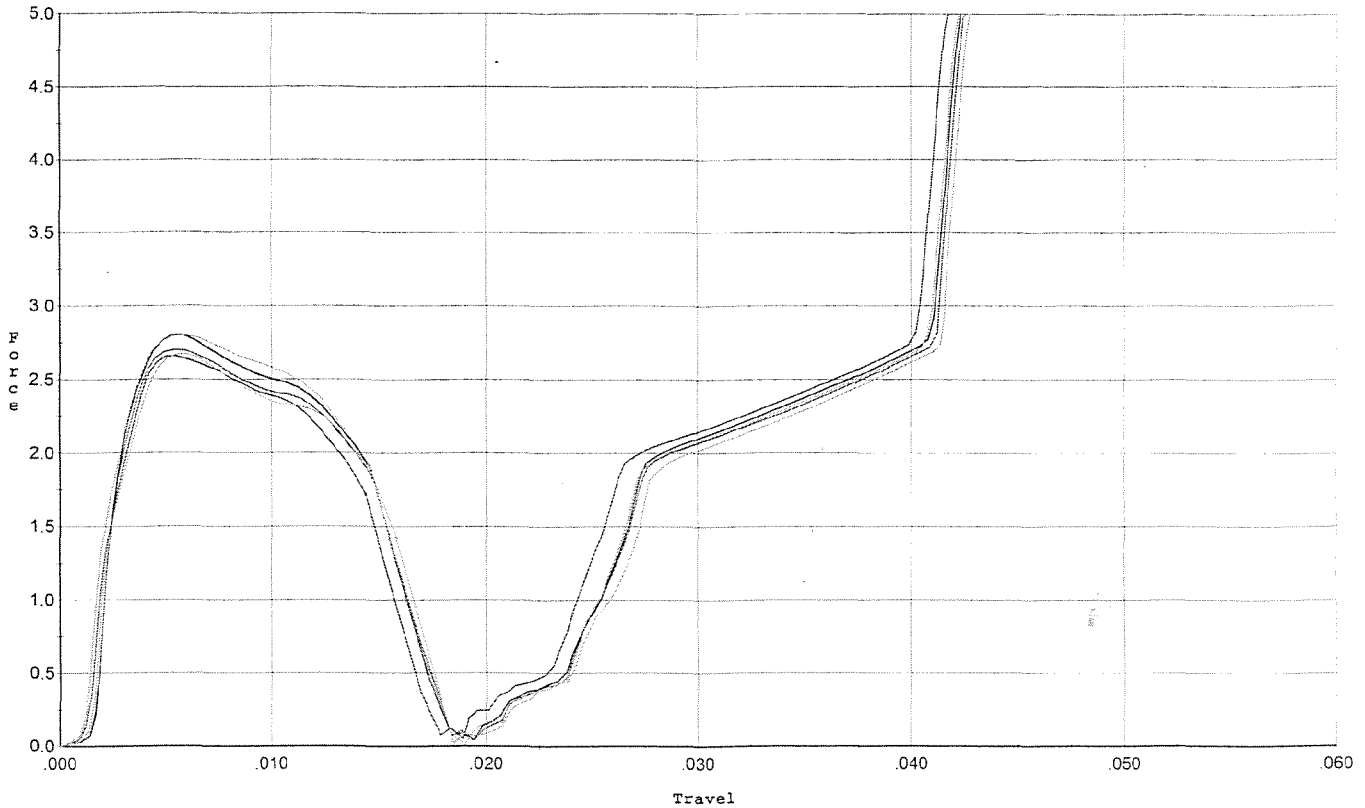
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	2-17-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	2-17-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.034</u> <u>.034</u>	2-17-09	LN
	J) ASSEMBLE STOCK		2-3-09	LN
	K) ASSEMBLE SWIVEL STUDS		2-17-09	LN
	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	2-12-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-12-09	N/A
670	FINAL INSPECTION A) HEADSPACE		2-17-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.64</u> <u>2.64</u> <u>2.63</u> <u>2.59</u>	2-13-09	NV
	C) FUNCTION		2-17-09	LN
690	PACK		2/25/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 2/3/2009

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



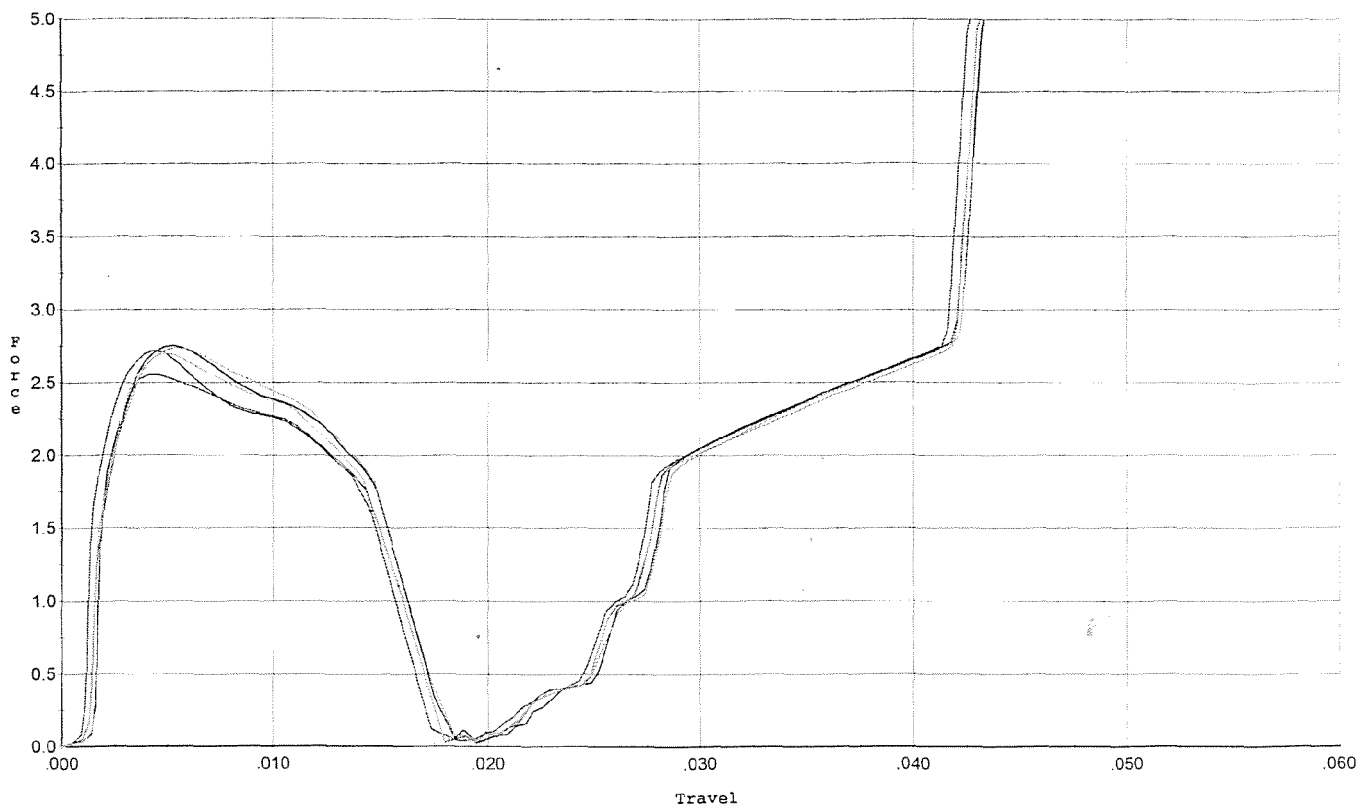
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.657	0.014	0.00	0.032	0.027		Set Trigger
2	2.804	0.015	0.00	0.032	0.028		Set Trigger
3	2.700	0.015	0.00	0.032	0.028		Set Trigger
4	2.673	0.016	0.00	0.032	0.029		Set Trigger
5	2.801	0.015	0.00	0.032	0.029		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



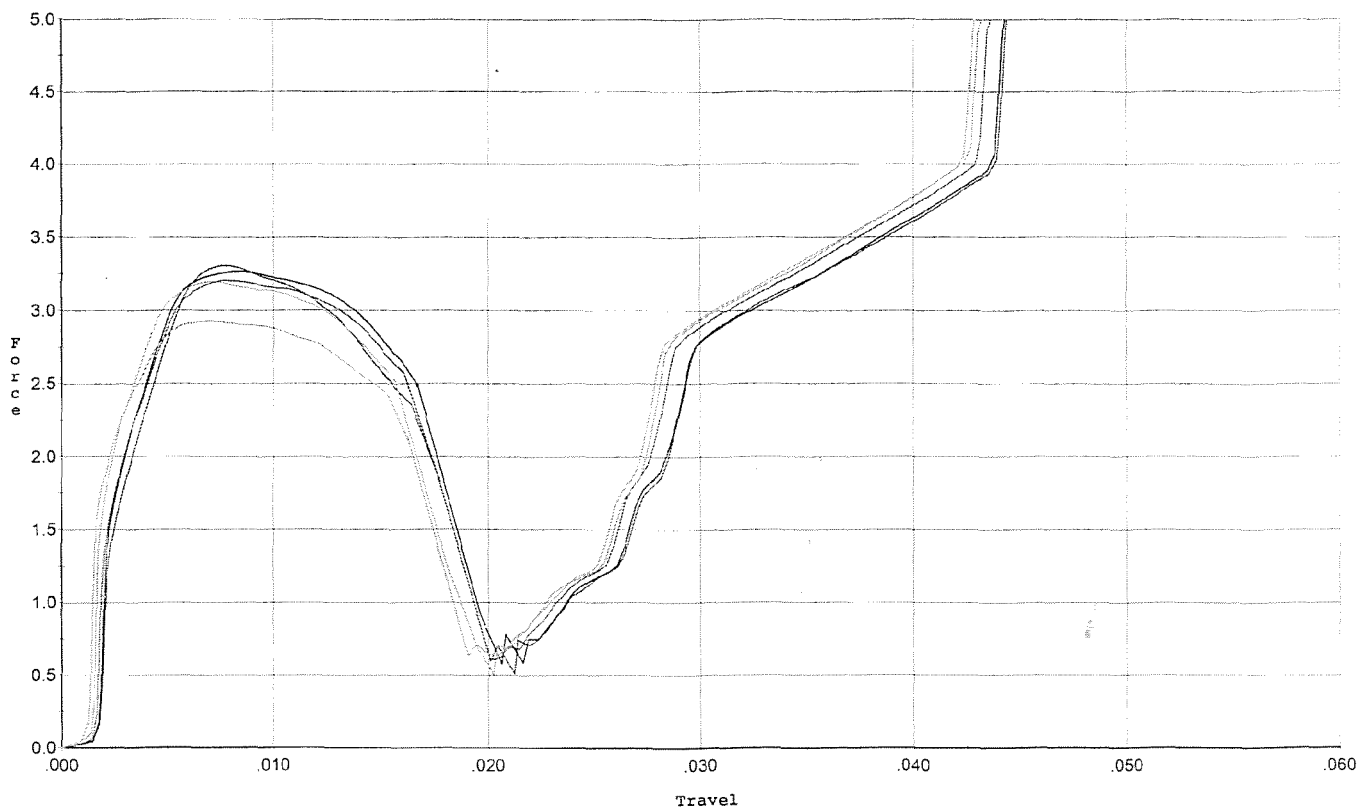
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.721	0.015	0.00	0.032	0.028		Set Trigger
2	2.754	0.015	0.00	0.033	0.029		Set Trigger
3	2.555	0.016	0.00	0.032	0.029		Set Trigger
4	2.702	0.016	0.00	0.032	0.030		Set Trigger
5	2.738	0.015	0.00	0.033	0.029		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



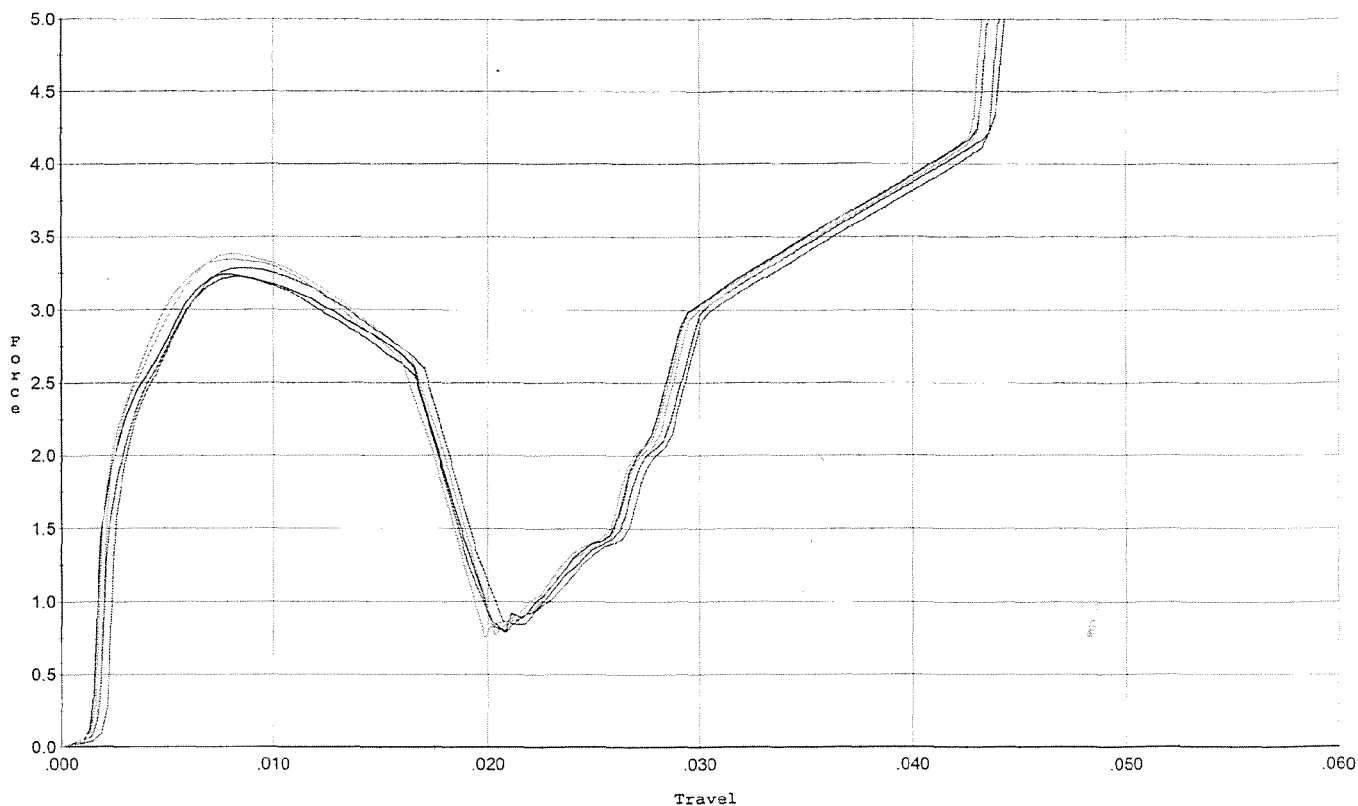
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.304	0.018	0.00	0.030	0.040		Set Trigger
2	3.266	0.017	0.00	0.029	0.039		Set Trigger
3	3.206	0.018	0.00	0.029	0.041		Set Trigger
4	3.197	0.016	0.00	0.029	0.037		Set Trigger
5	2.928	0.016	0.00	0.029	0.036		Set Trigger

A-3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



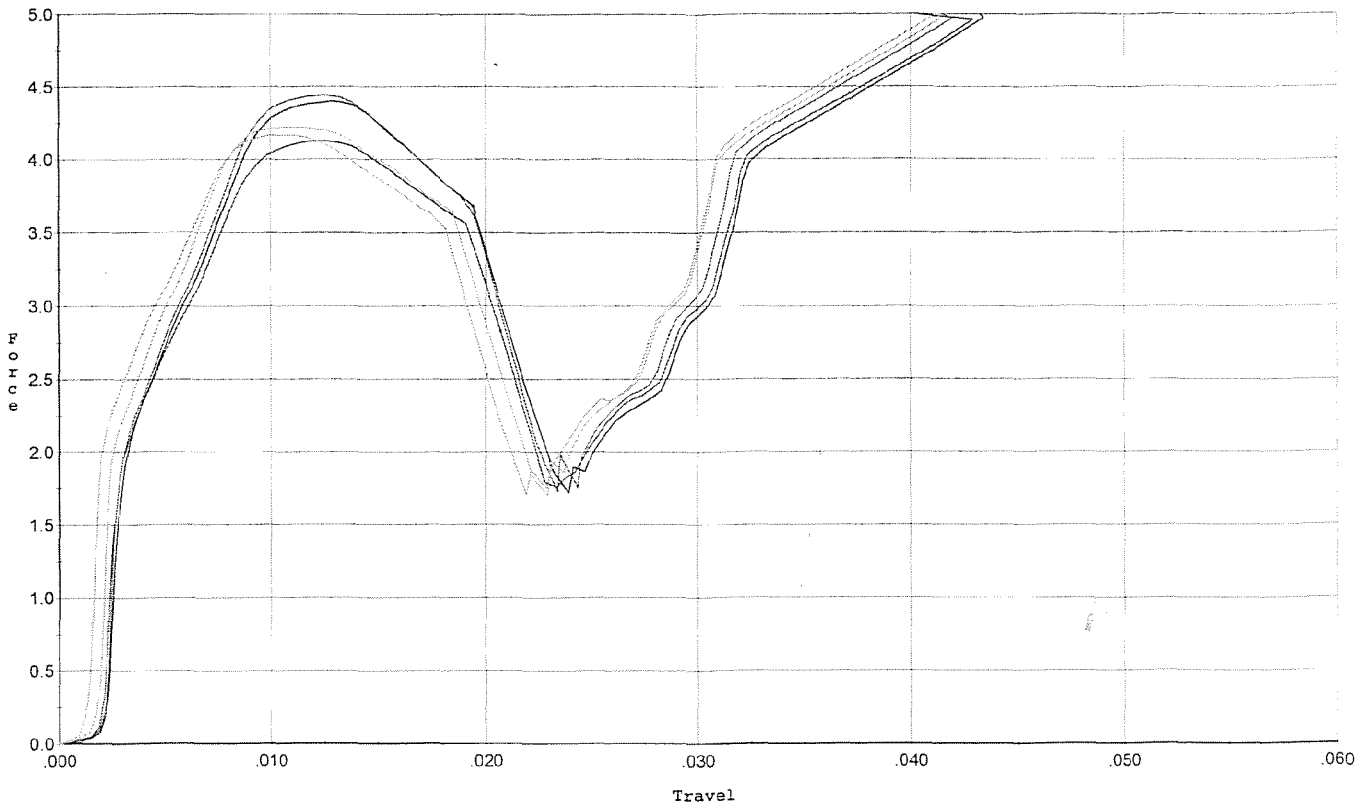
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.017	0.00	0.030	0.038		Set Trigger
2	3.242	0.017	0.00	0.029	0.039		Set Trigger
3	3.288	0.017	0.00	0.029	0.039		Set Trigger
4	3.381	0.018	0.00	0.029	0.043		Set Trigger
5	3.345	0.017	0.00	0.029	0.042		Set Trigger

A-3.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



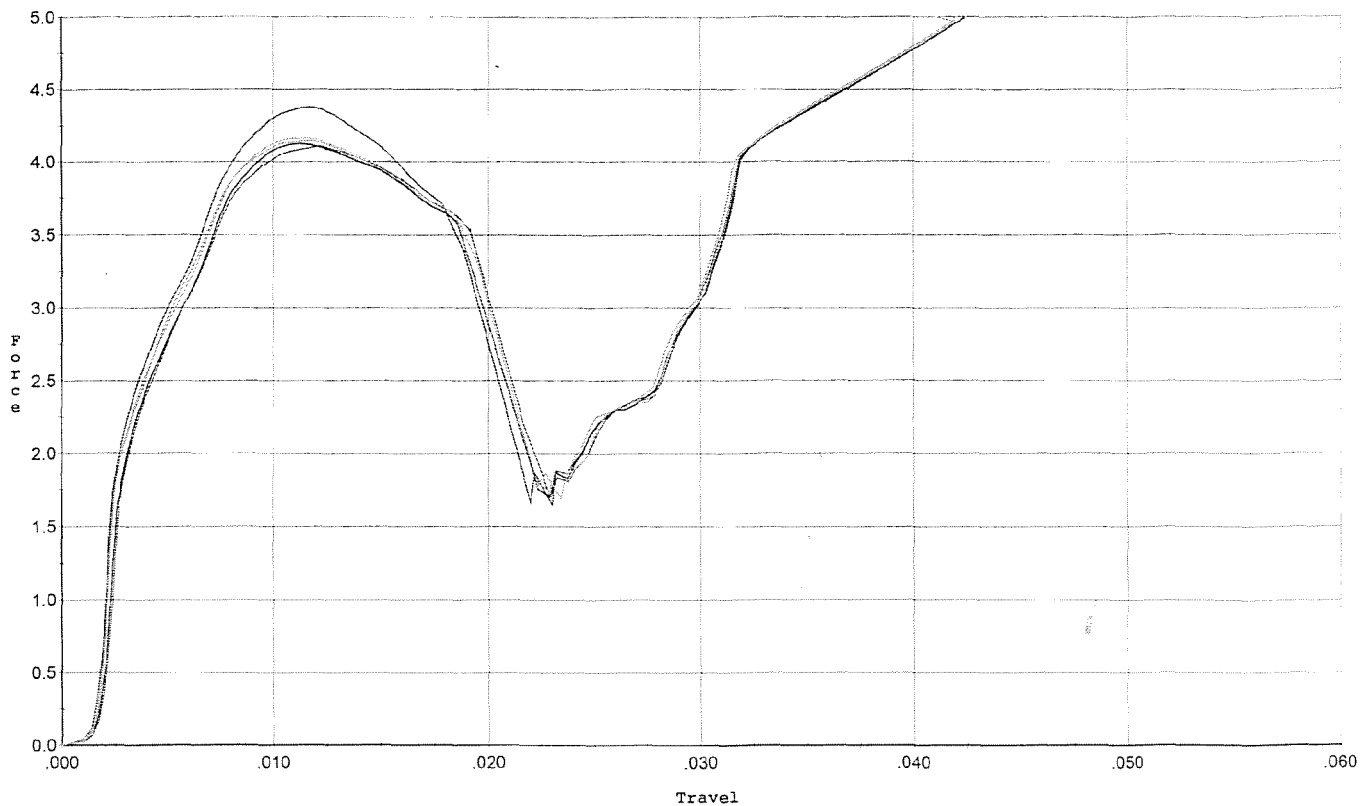
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.021	0.00	0.027	0.059		Set Trigger
2	4.399	0.019	0.00	0.027	0.057		Set Trigger
3	4.440	0.020	0.00	0.026	0.058		Set Trigger
4	4.220	0.018	0.00	0.026	0.055		Set Trigger
5	4.168	0.018	0.00	0.027	0.054		Set Trigger

A-4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



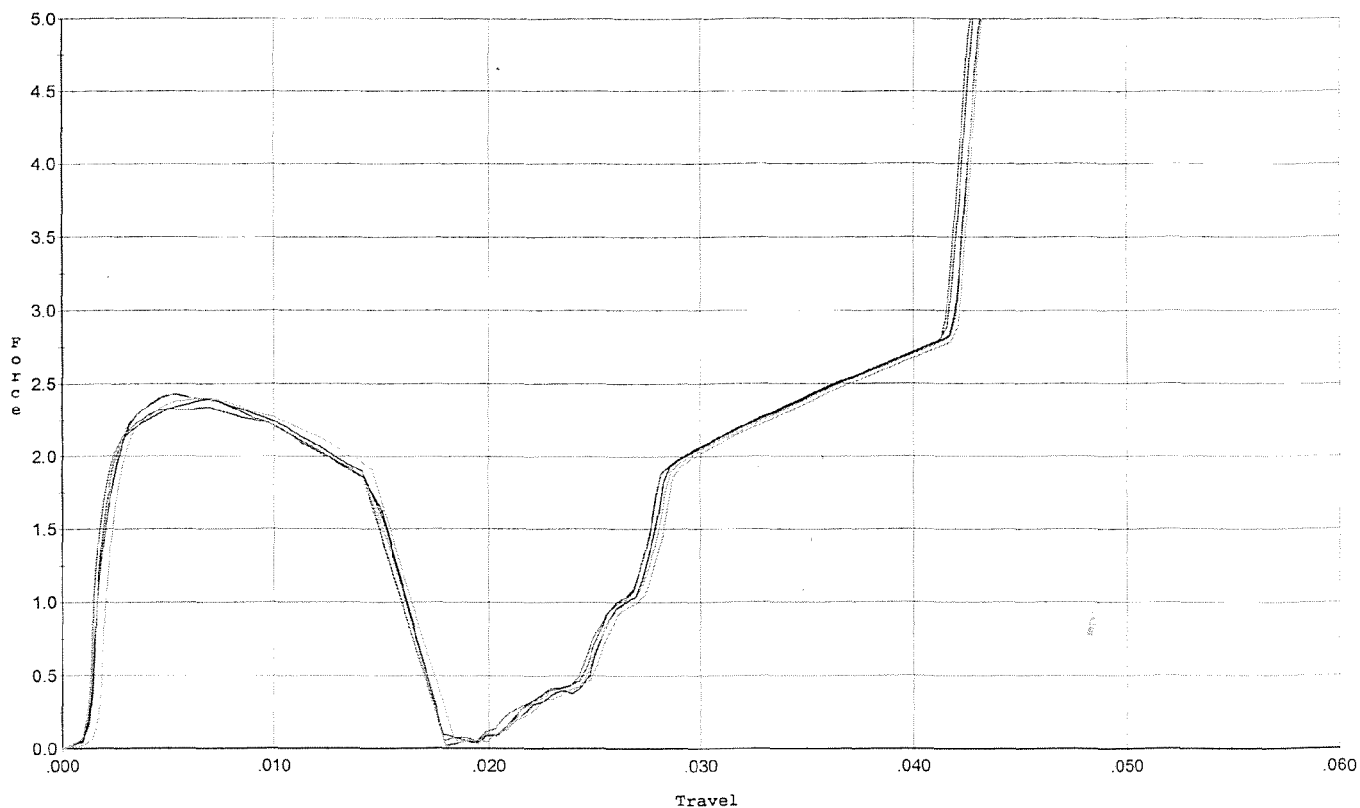
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.380	0.019	0.00	0.027	0.056		Set Trigger
2	4.125	0.019	0.00	0.027	0.053		Set Trigger
3	4.109	0.019	0.00	0.027	0.055		Set Trigger
4	4.164	0.019	0.00	0.027	0.057		Set Trigger
5	4.148	0.018	0.00	0.027	0.054		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



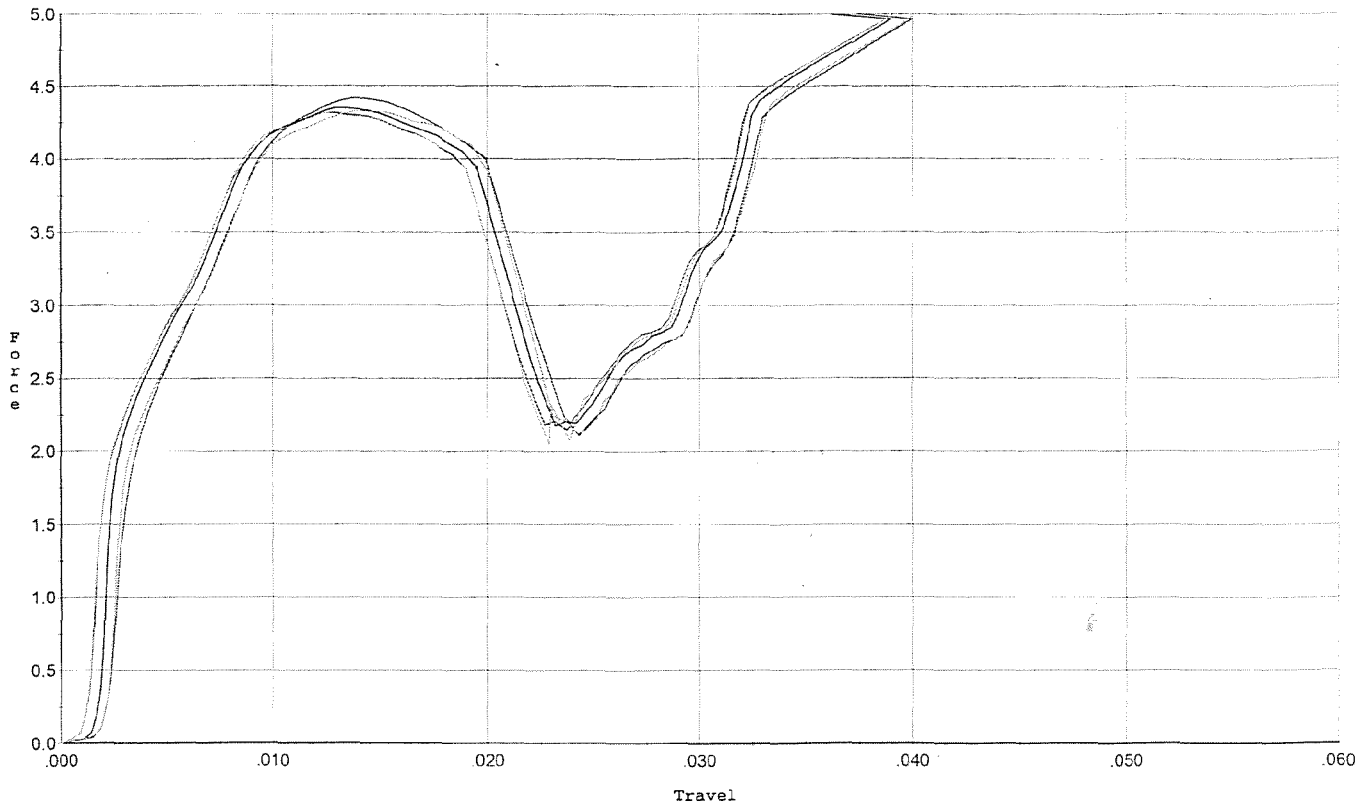
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.388	0.015	0.00	0.032	0.027		Set Trigger
2	2.428	0.015	0.00	0.032	0.027		Set Trigger
3	2.338	0.014	0.00	0.032	0.026		Set Trigger
4	2.395	0.015	0.00	0.032	0.026		Set Trigger
5	2.424	0.015	0.00	0.032	0.028		Set Trigger

A.2-59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/3/2009

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	4.419	0.020	0.00	0.024	0.060		Set Trigger
2	4.351	0.020	0.00	0.024	0.059		Set Trigger
3	4.317	0.019	0.00	0.024	0.058		Set Trigger
4	4.324	0.019	0.00	0.024	0.058		Set Trigger
5	4.328	0.020	0.00	0.025	0.060		Set Trigger

A-4.34