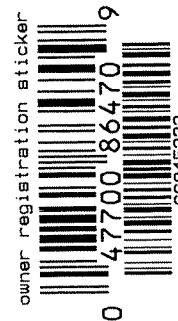
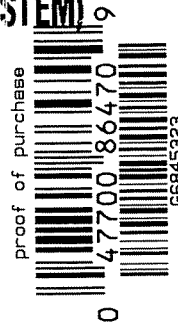


G-6845323

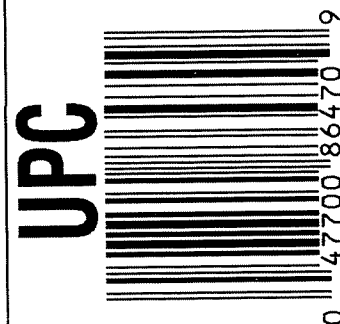
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6845323



GUN SERIAL # G 6845323

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-4-09	RP
430	ASSEMBLE TO STOCK		5-4-09	SP
440	PROOF		5-4-09	RP
460	CHECK HEADSPACE	MAGNA FLUX	5-4-09	RP
470	DIS-ASSEMBLE ACTION		5-4-09	RP
472	SERIALIZE BOLT HANDLE		5-5-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	5/6/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/7/09	RT
510	DRILL AND TAP SIGHT HOLES		5-5-09	SP
520	GOFF BLAST BBL / REC		5/7/09	REM
540	APPLY COATINGS (BARREL ACTION)		5/7/14	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-14-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-14-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

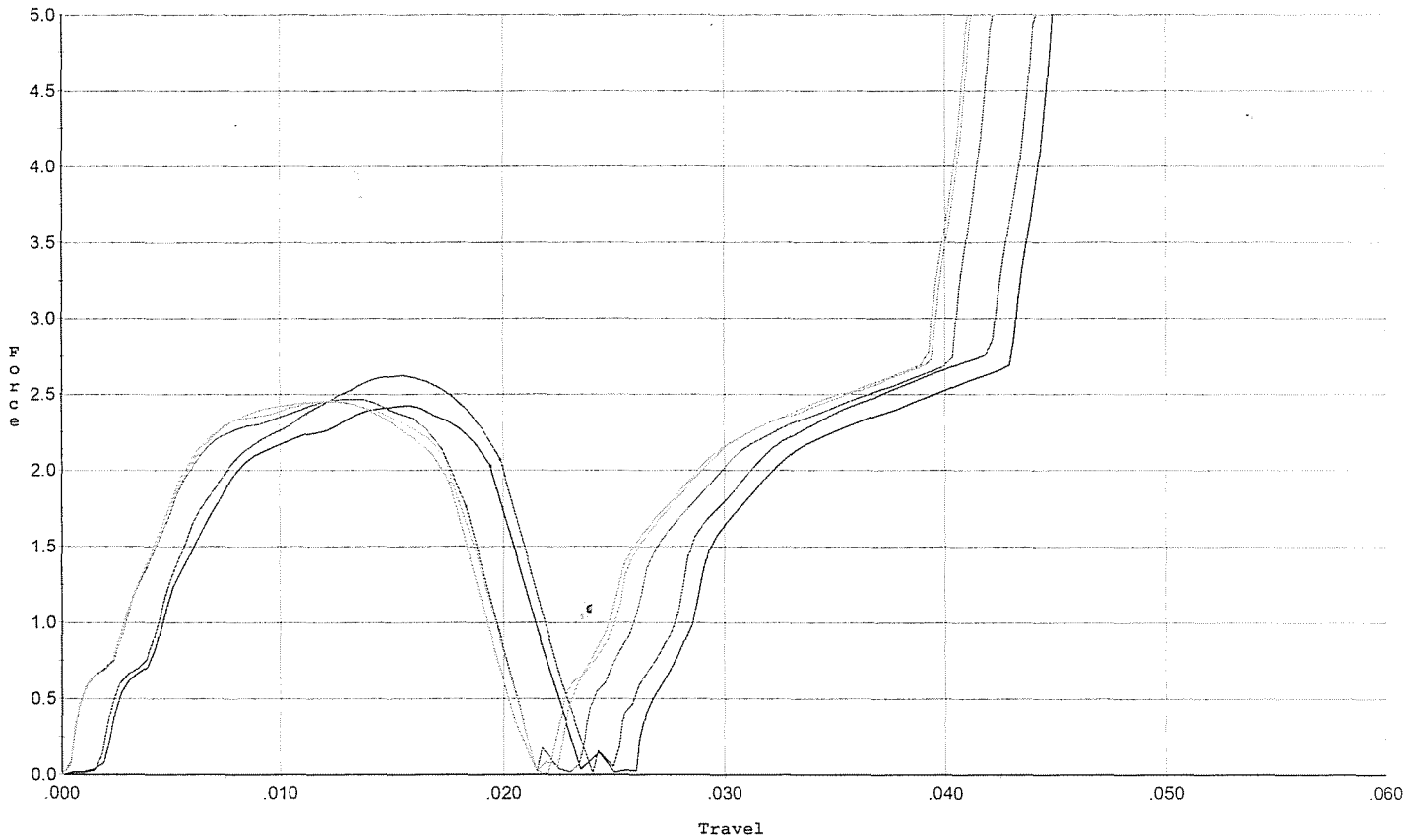
F004 REV 5/2006

BARBER - M24 0053437									
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	6-15-09	LJ		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	6-15-09	LJ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	6-15-09	LJ		
	J) ASSEMBLE STOCK					5-20-09	LJ		
	K) ASSEMBLE SWIVEL STUDS					6-15-09	LJ		
	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		6/10/09	RB		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					6/20/09	TCR		
670	FINAL INSPECTION A) HEADSPACE					6-15-09	LJ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>230</u>	<u>229</u>	<u>224</u>	<u>225</u>	<u>231</u>	6-15-09	RT
	C) FUNCTION					6-15-09	LJ		
690	PACK					6/17/09	Fm		

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



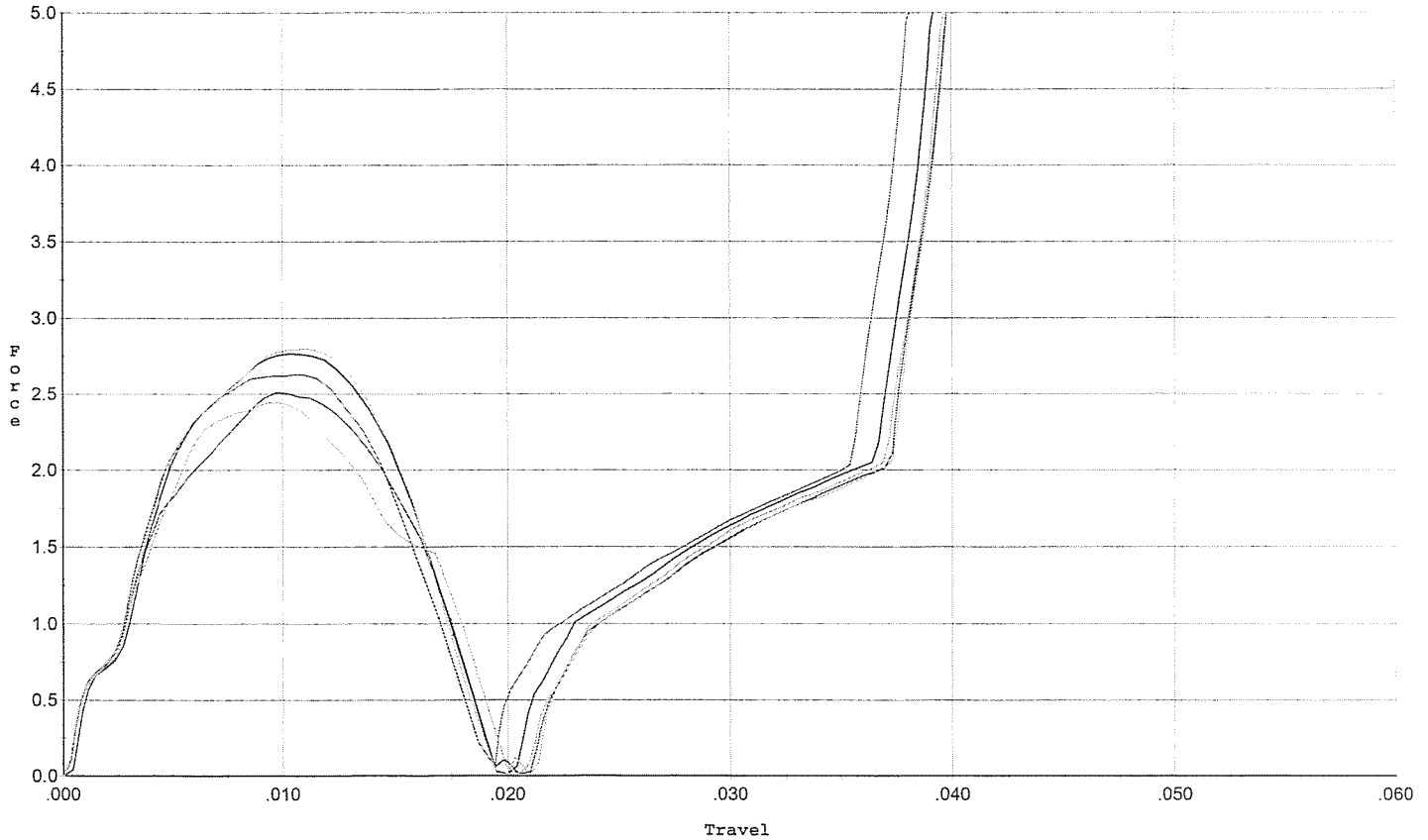
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.625	0.020	0.00	0.029	0.035		Set Trigger
2	2.424	0.019	0.00	0.030	0.031		Set Trigger
3	2.465	0.018	0.00	0.028	0.033		Set Trigger
4	2.459	0.019	0.00	0.027	0.034		Set Trigger
5	2.449	0.018	0.00	0.028	0.031		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



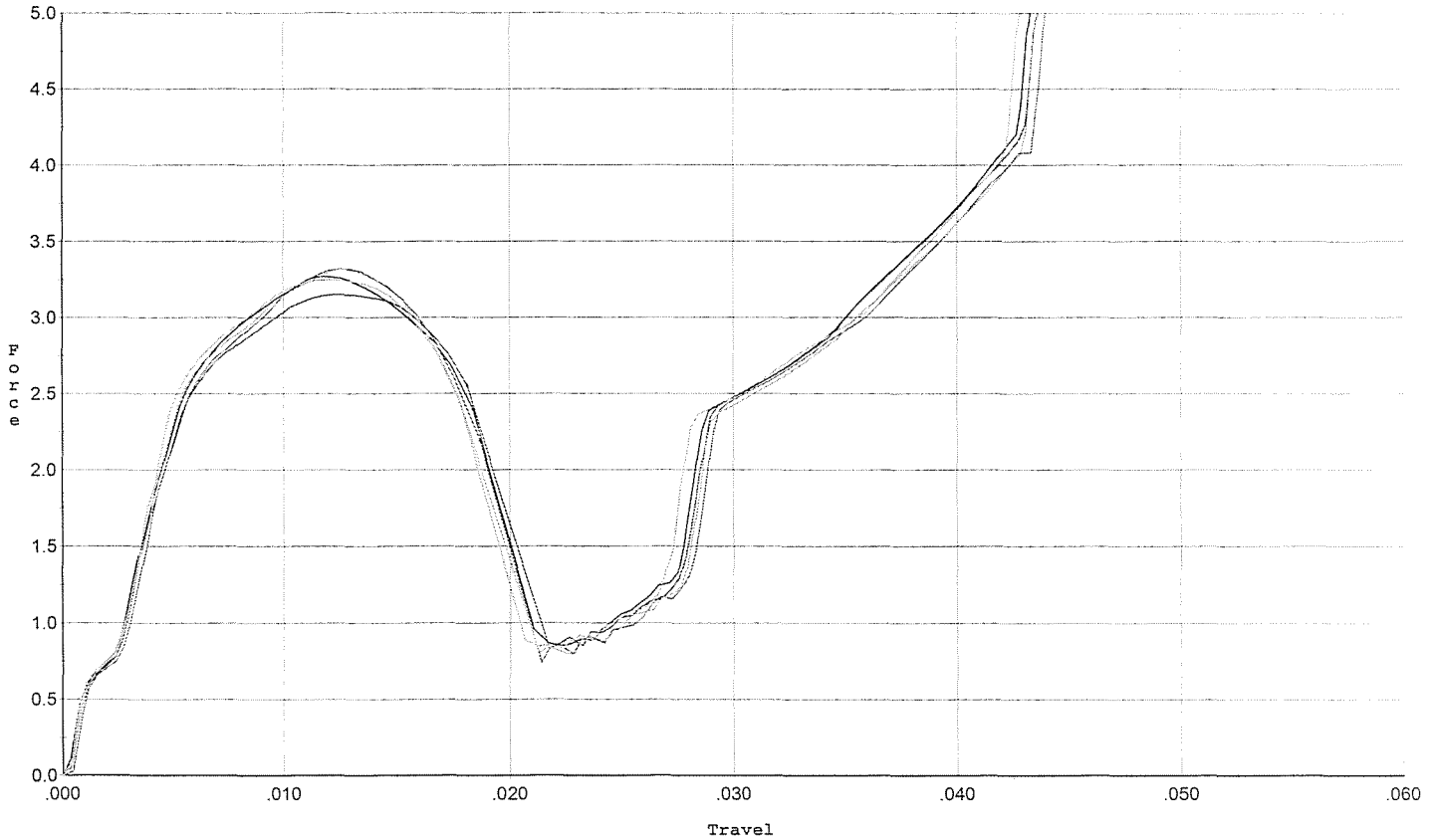
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.508	0.017	0.00	0.028	0.030		Set Trigger
2	2.764	0.018	0.00	0.028	0.032		Set Trigger
3	2.627	0.017	0.00	0.027	0.031		Set Trigger
4	2.794	0.016	0.00	0.029	0.030		Set Trigger
5	2.444	0.018	0.00	0.028	0.030		Set Trigger

A.2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



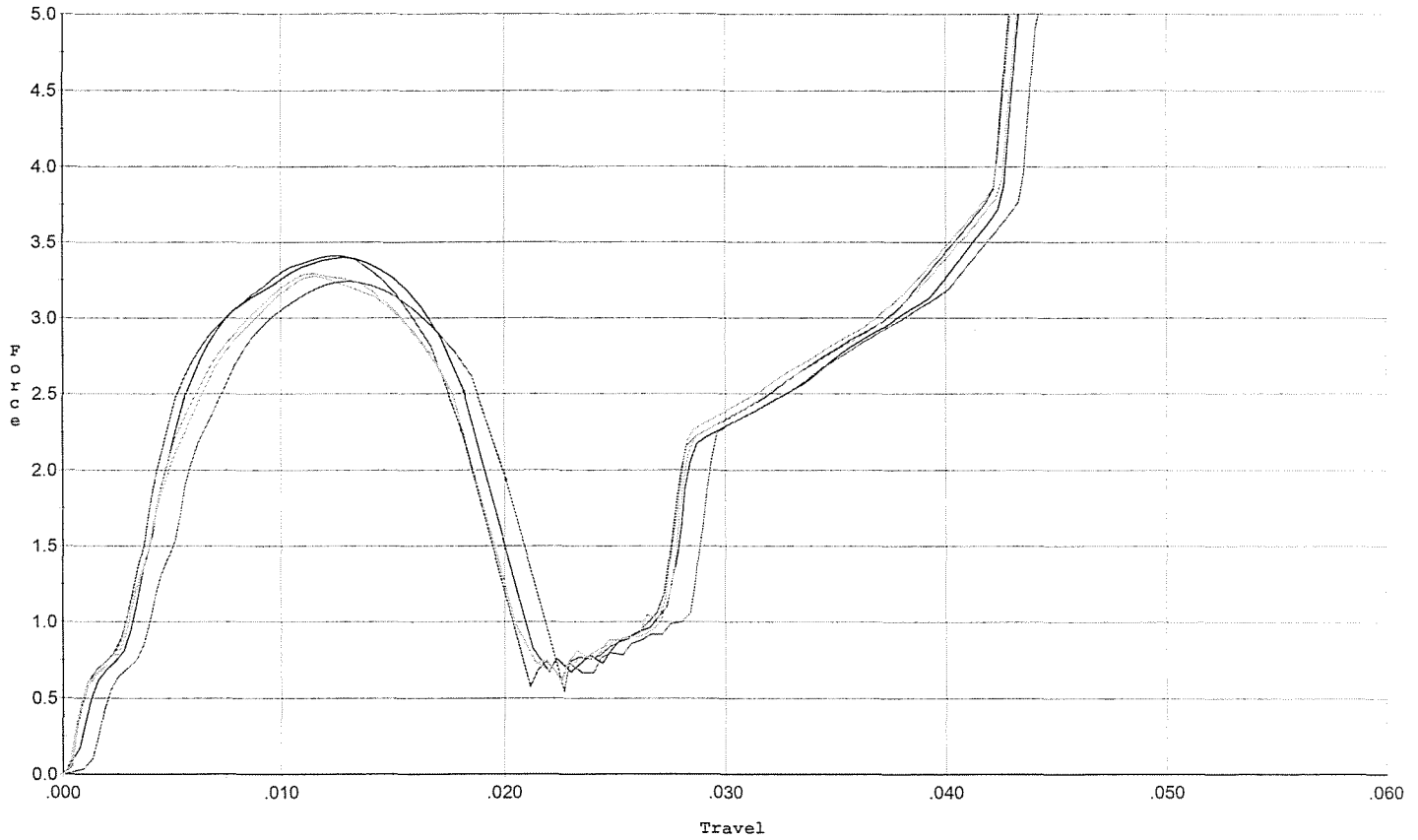
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.151	0.018	0.00	0.028	0.040		Set Trigger
2	3.269	0.018	0.00	0.028	0.042		Set Trigger
3	3.320	0.019	0.00	0.029	0.042		Set Trigger
4	3.247	0.018	0.00	0.028	0.040		Set Trigger
5	3.321	0.018	0.00	0.029	0.040		Set Trigger

A.3.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 4/22/2009

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



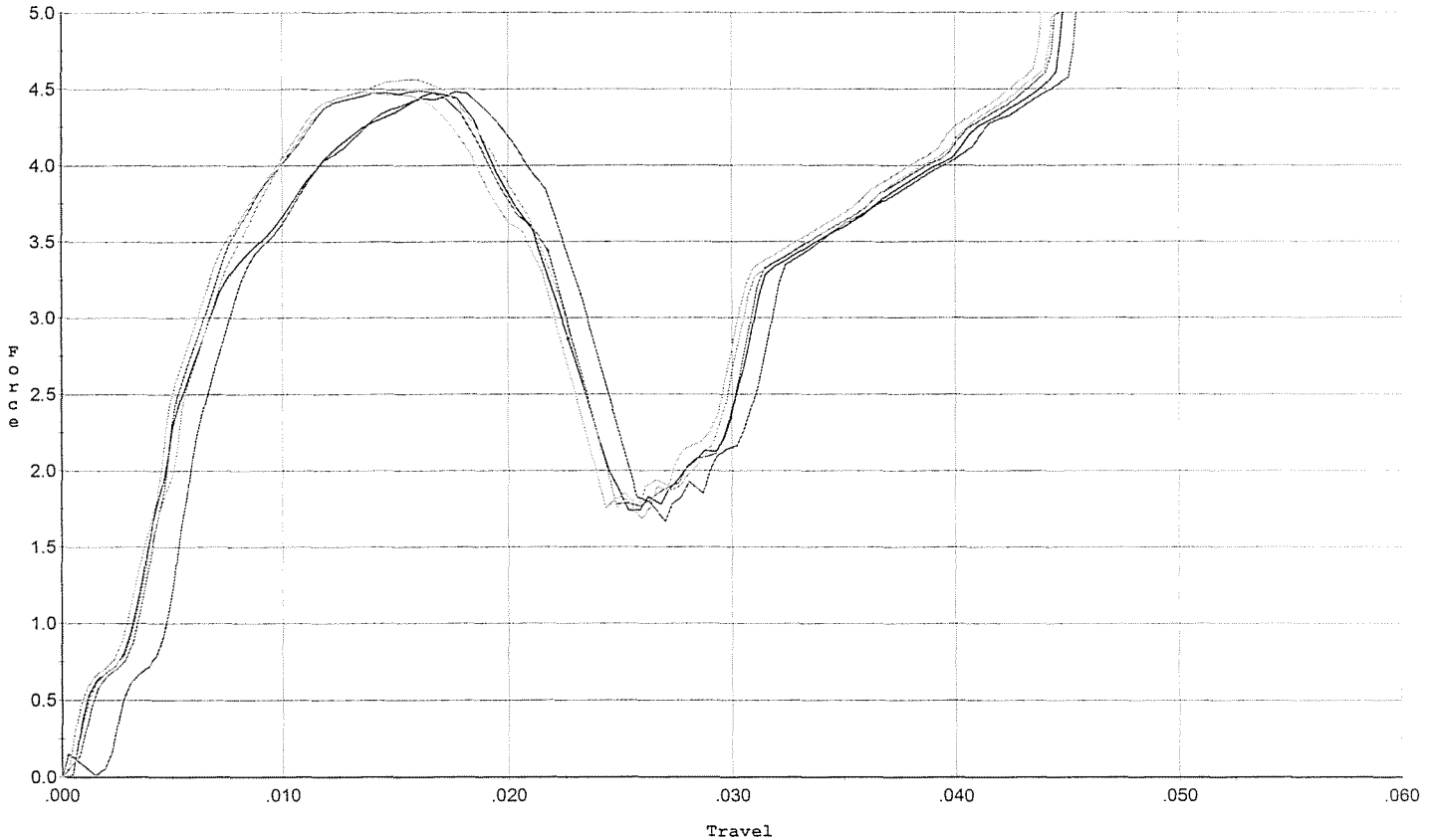
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.412	0.018	0.00	0.028	0.042		Set Trigger
2	3.400	0.018	0.00	0.028	0.042		Set Trigger
3	3.242	0.020	0.00	0.029	0.042		Set Trigger
4	3.278	0.018	0.00	0.028	0.039		Set Trigger
5	3.294	0.018	0.00	0.028	0.039		Set Trigger

A.S.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



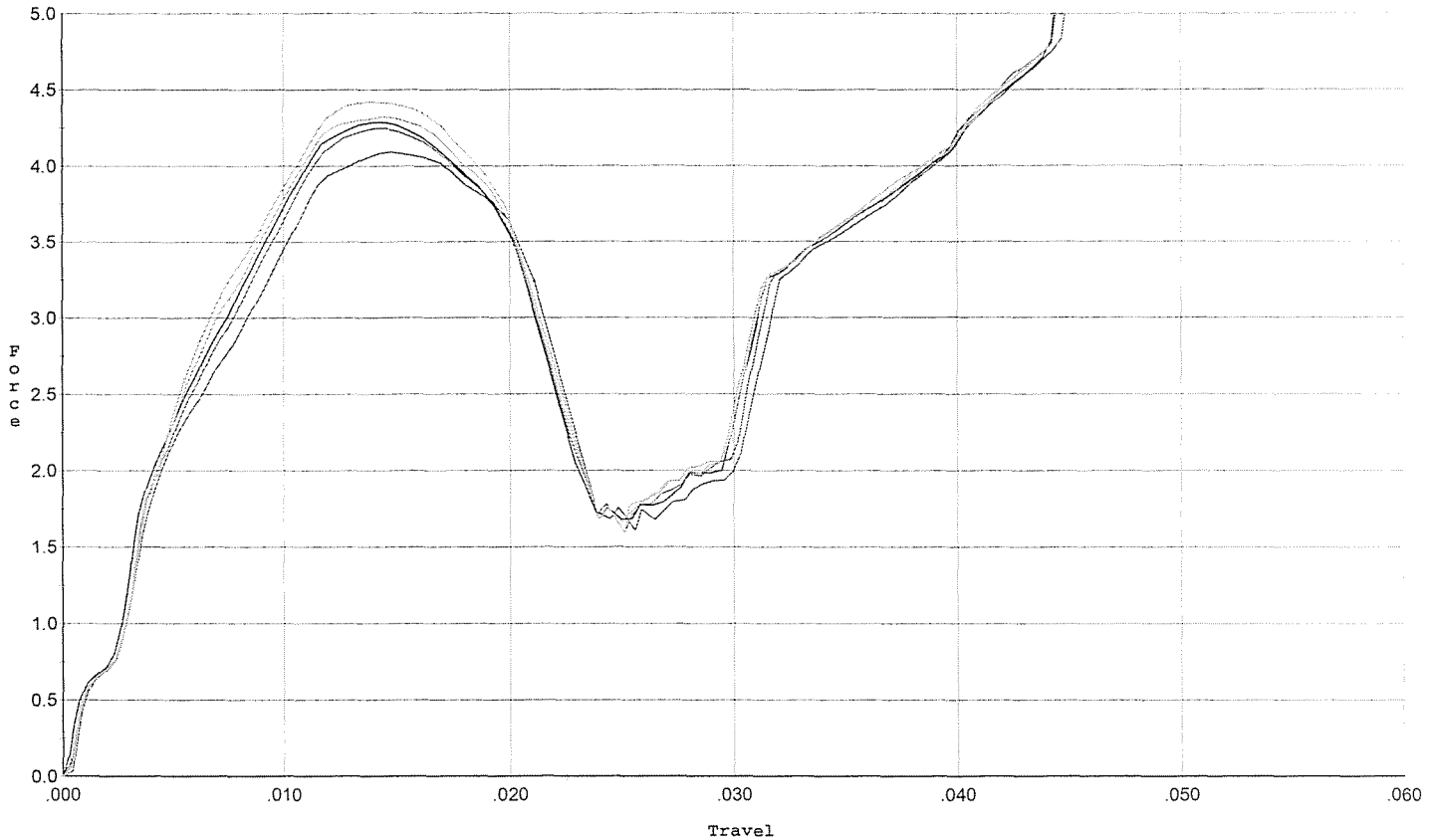
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.485	0.023	0.002	0.022	0.065		Set Trigger
2	4.477	0.023	0.00	0.024	0.066		Set Trigger
3	4.491	0.022	0.00	0.025	0.065		Set Trigger
4	4.481	0.021	0.00	0.025	0.064		Set Trigger
5	4.562	0.022	0.00	0.022	0.066		Set Trigger

A. 4.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



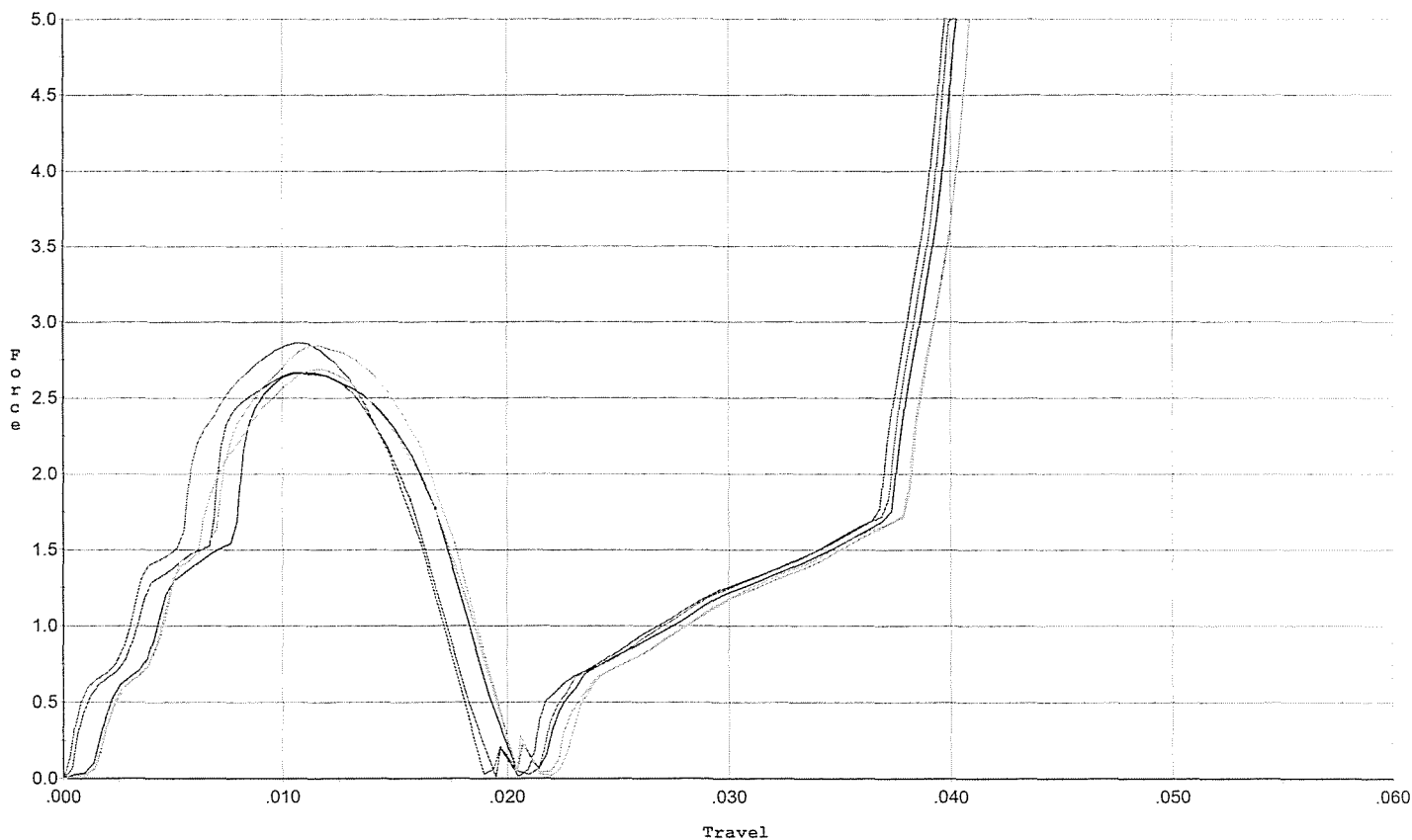
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.092	0.021	0.00	0.026	0.057		Set Trigger
2	4.288	0.020	0.00	0.026	0.057		Set Trigger
3	4.244	0.020	0.00	0.026	0.056		Set Trigger
4	4.323	0.020	0.00	0.026	0.057		Set Trigger
5	4.423	0.022	0.00	0.026	0.063		Set Trigger

A.4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



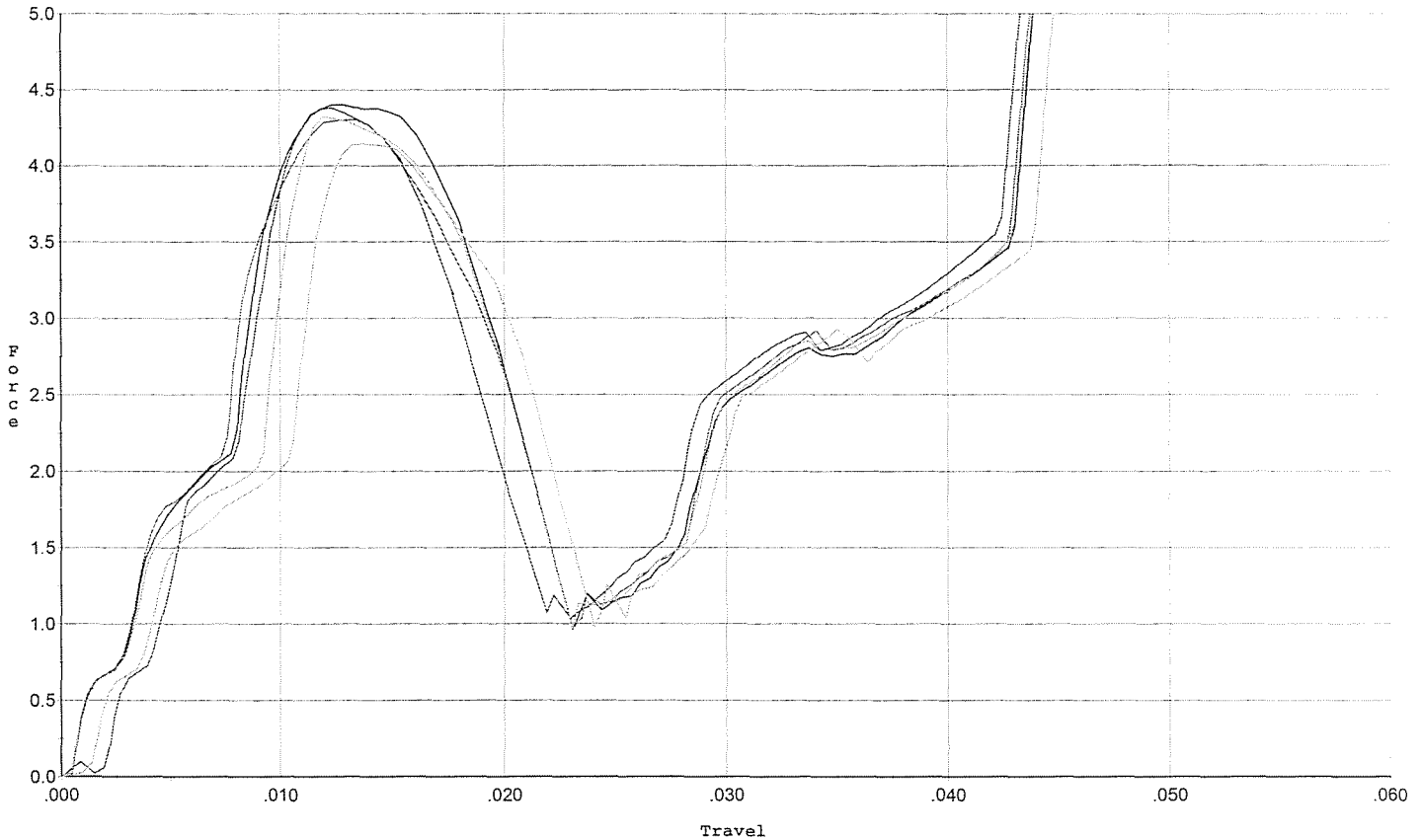
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.016	0.00	0.029	0.027		Set Trigger
2	2.659	0.017	0.00	0.029	0.027		Set Trigger
3	2.864	0.016	0.00	0.030	0.030		Set Trigger
4	2.690	0.018	0.00	0.029	0.030		Set Trigger
5	2.845	0.018	0.00	0.029	0.030		Set Trigger

A-2-74

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 4/22/2009

Model: M/24
Serial No: Form #F005
Trigger: 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	4.382	0.018	0.00	0.028	0.042		Set Trigger
2	4.404	0.020	0.00	0.028	0.052		Set Trigger
3	4.302	0.020	0.00	0.027	0.051		Set Trigger
4	4.145	0.021	0.00	0.027	0.047		Set Trigger
5	4.324	0.020	0.00	0.027	0.049		Set Trigger

A-4-31