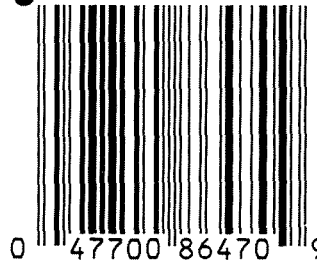


G6845838

Do Not Use

ORDER 86470
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



ORDER 86470
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



SERIAL NO.



GUN SERIAL #

G 684 5838

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-16-09	SPD
430	ASSEMBLE TO STOCK		4-16-09	RP
440	PROOF		4-16-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	4-16-09	SPD
470	DIS-ASSEMBLE ACTION		4-16-09	SPD
472	SERIALIZE BOLT HANDLE		4-17-09	RJZ
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	4-18-09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/20/09	RT
510	DRILL AND TAP SIGHT HOLES		4-17-09	SP
520	GOFF BLAST BBL / REC		4/21/09	L.M.
540	APPLY COATINGS (BARREL ACTION)		7-22	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-28-09	L.H.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

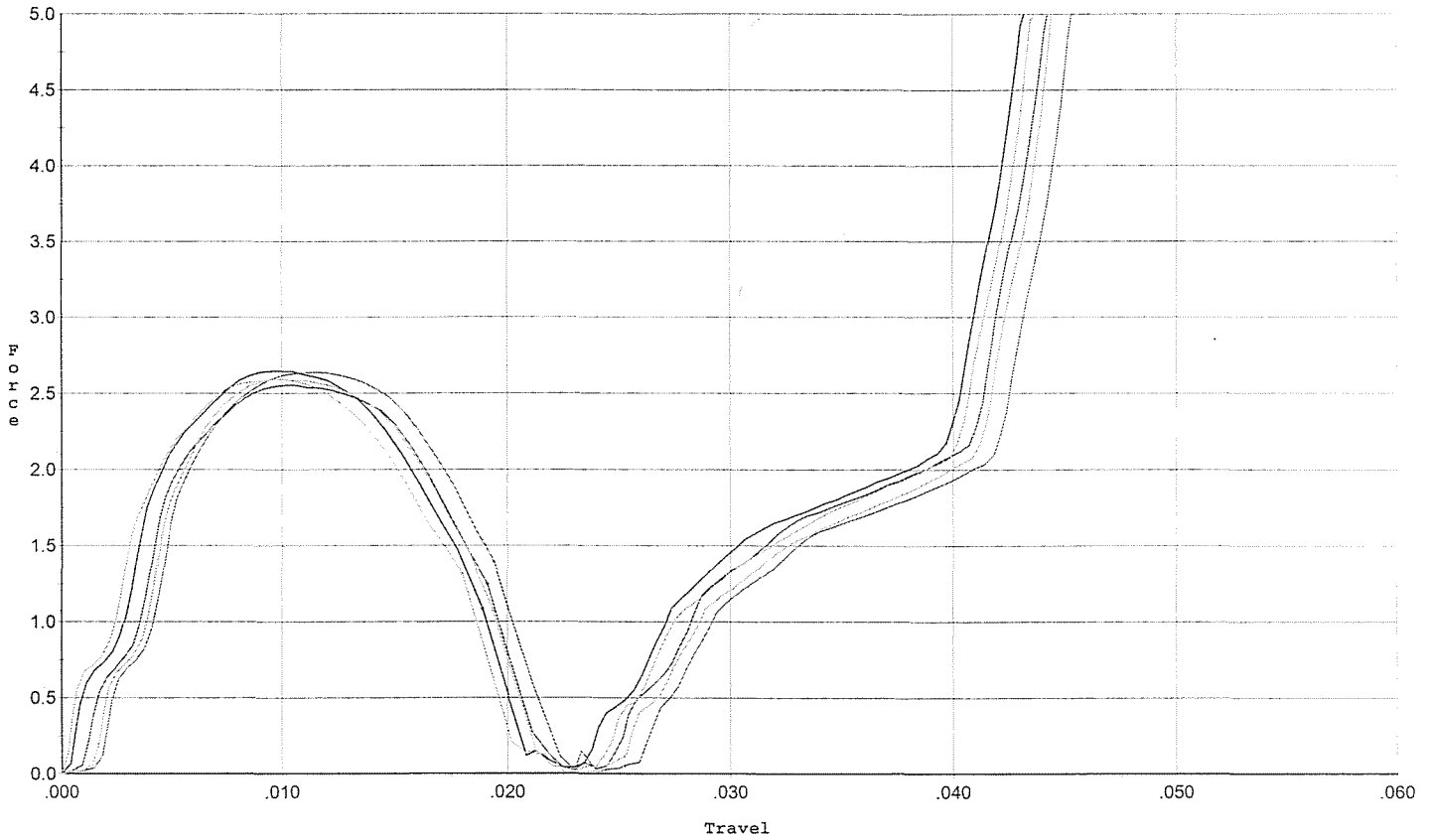
OP #	OP	BARBER - M24 6053856	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>30</u> <u>30</u> <u>30</u>	5-7-09	LN
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>30</u> <u>50</u> <u>50</u>	5-7-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.004</u> <u>.004</u> <u>.004</u>	5-7-09	LN
	J) ASSEMBLE STOCK			4-28-09	LN
	K) ASSEMBLE SWIVEL STUDS			5-7-09	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	5-1-09	LN
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			5-1-09	TGR
670	FINAL INSPECTION A) HEADSPACE			5-7-09	LN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>276</u> <u>270</u> <u>267</u> <u>269</u> <u>261</u>	5-6-09	RTZ
	C) FUNCTION			5-7-09	LN
690	PACK			5-26-09	WW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



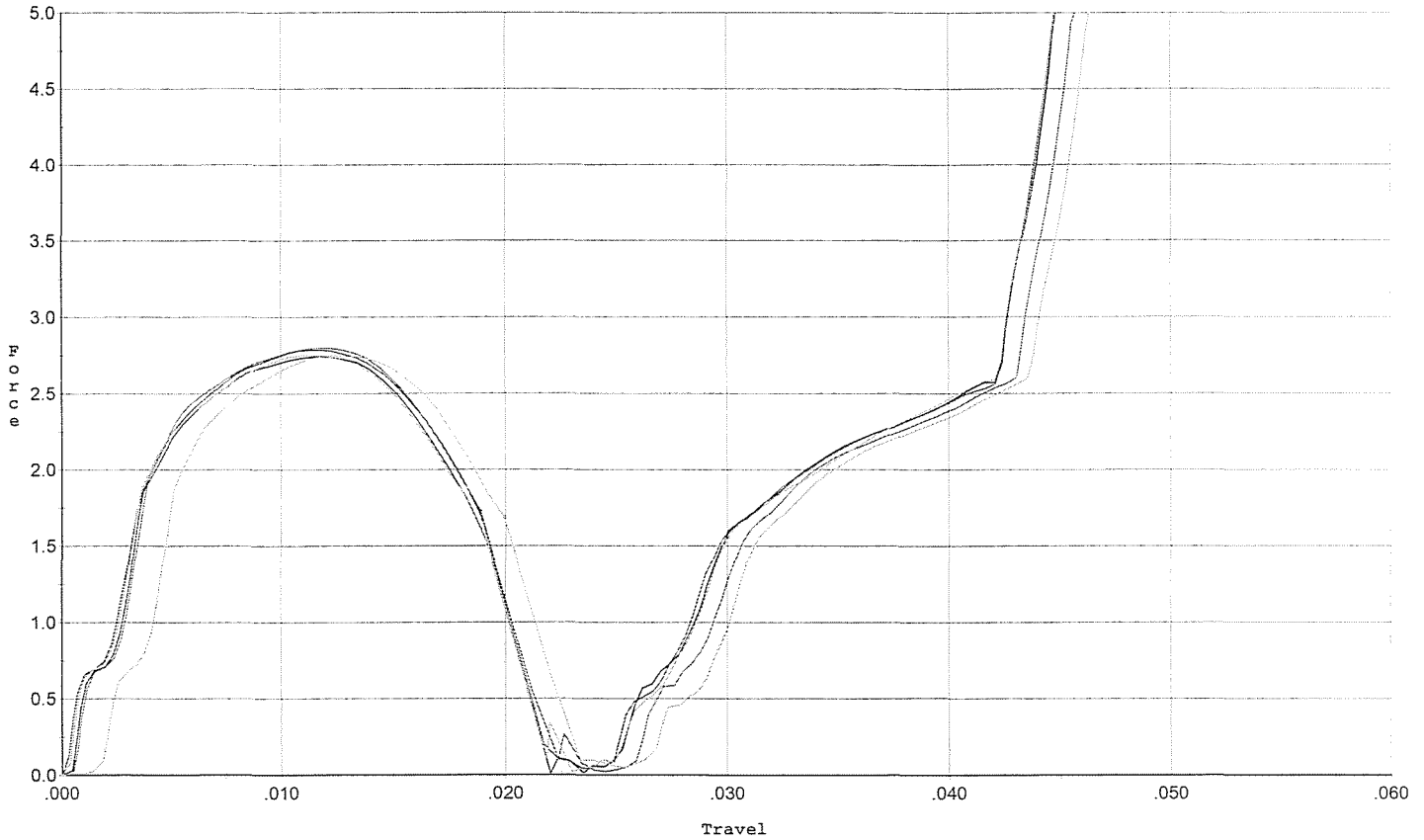
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.019	0.00	0.031	0.033		Set Trigger
2	2.644	0.019	0.00	0.030	0.035		Set Trigger
3	2.638	0.019	0.00	0.032	0.034		Set Trigger
4	2.593	0.019	0.00	0.031	0.033		Set Trigger
5	2.591	0.018	0.00	0.031	0.033		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



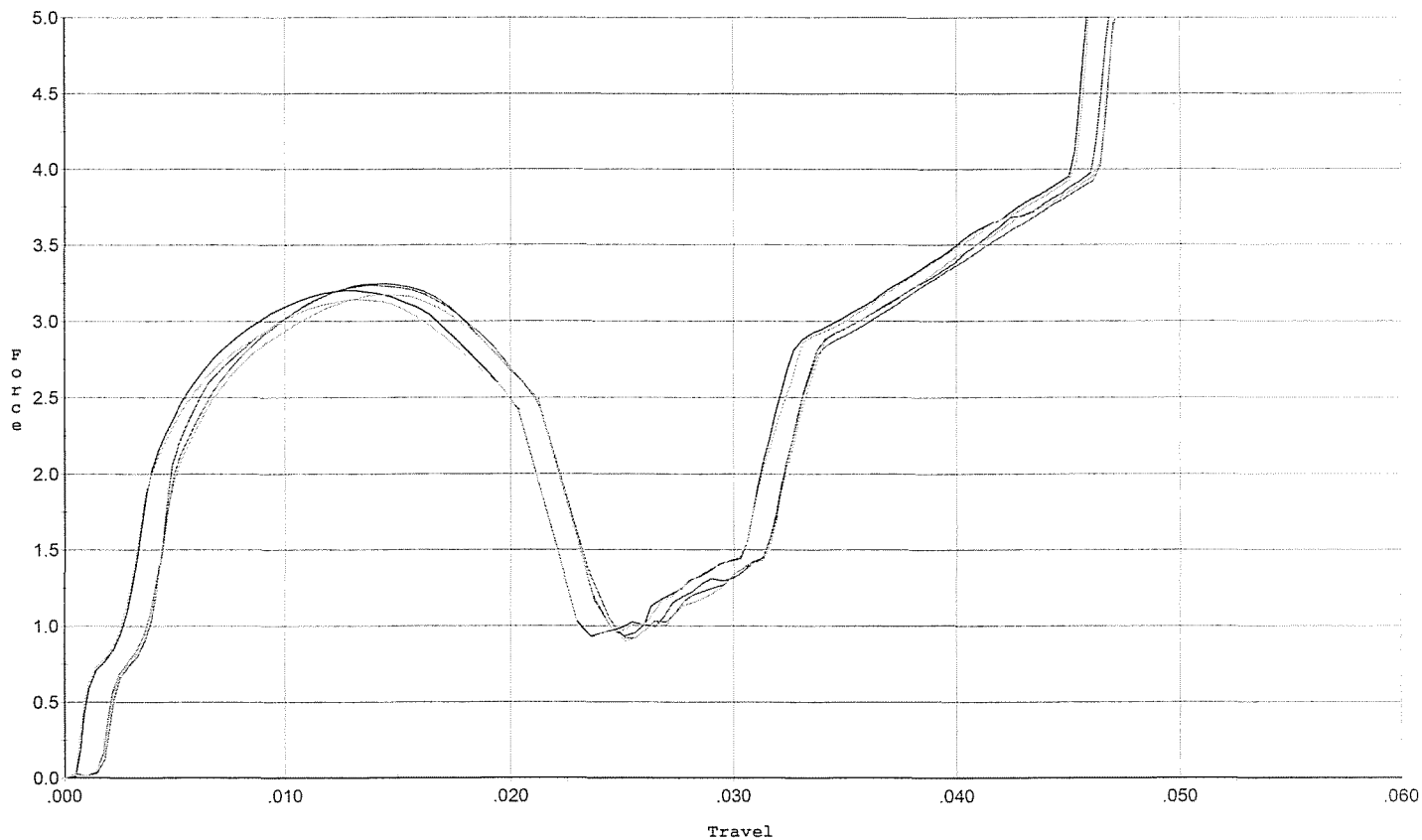
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.788	0.019	0.00	0.031	0.038		Set Trigger
2	2.745	0.019	0.00	0.031	0.038		Set Trigger
3	2.799	0.019	0.00	0.031	0.038		Set Trigger
4	2.749	0.020	0.00	0.032	0.037		Set Trigger
5	2.750	0.019	0.00	0.031	0.038		Set Trigger

A-2.76

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



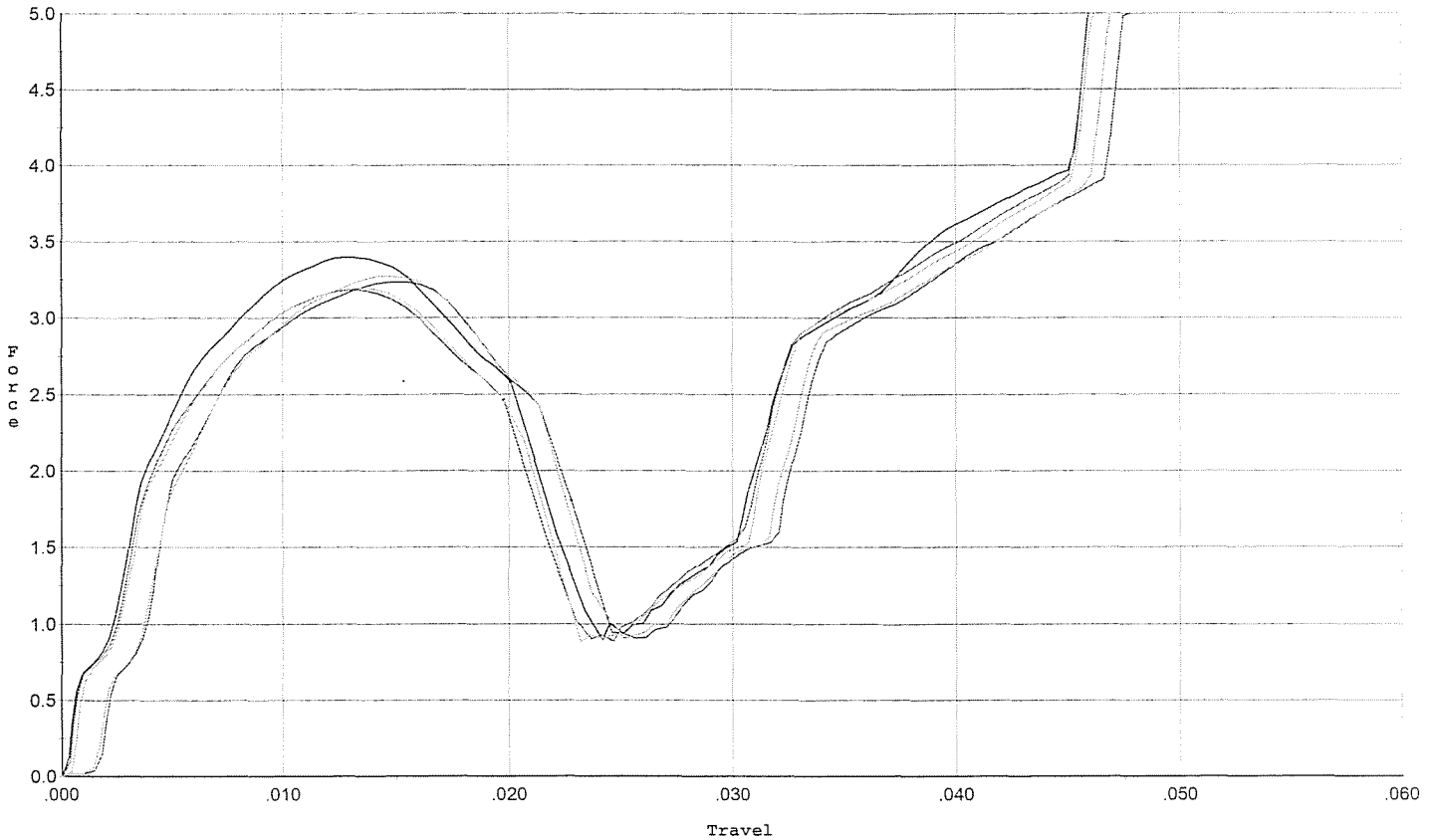
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.245	0.021	0.00	0.030	0.048		Set Trigger
2	3.199	0.020	0.00	0.029	0.047		Set Trigger
3	3.233	0.021	0.00	0.030	0.047		Set Trigger
4	3.139	0.020	0.00	0.029	0.047		Set Trigger
5	3.172	0.021	0.00	0.030	0.047		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



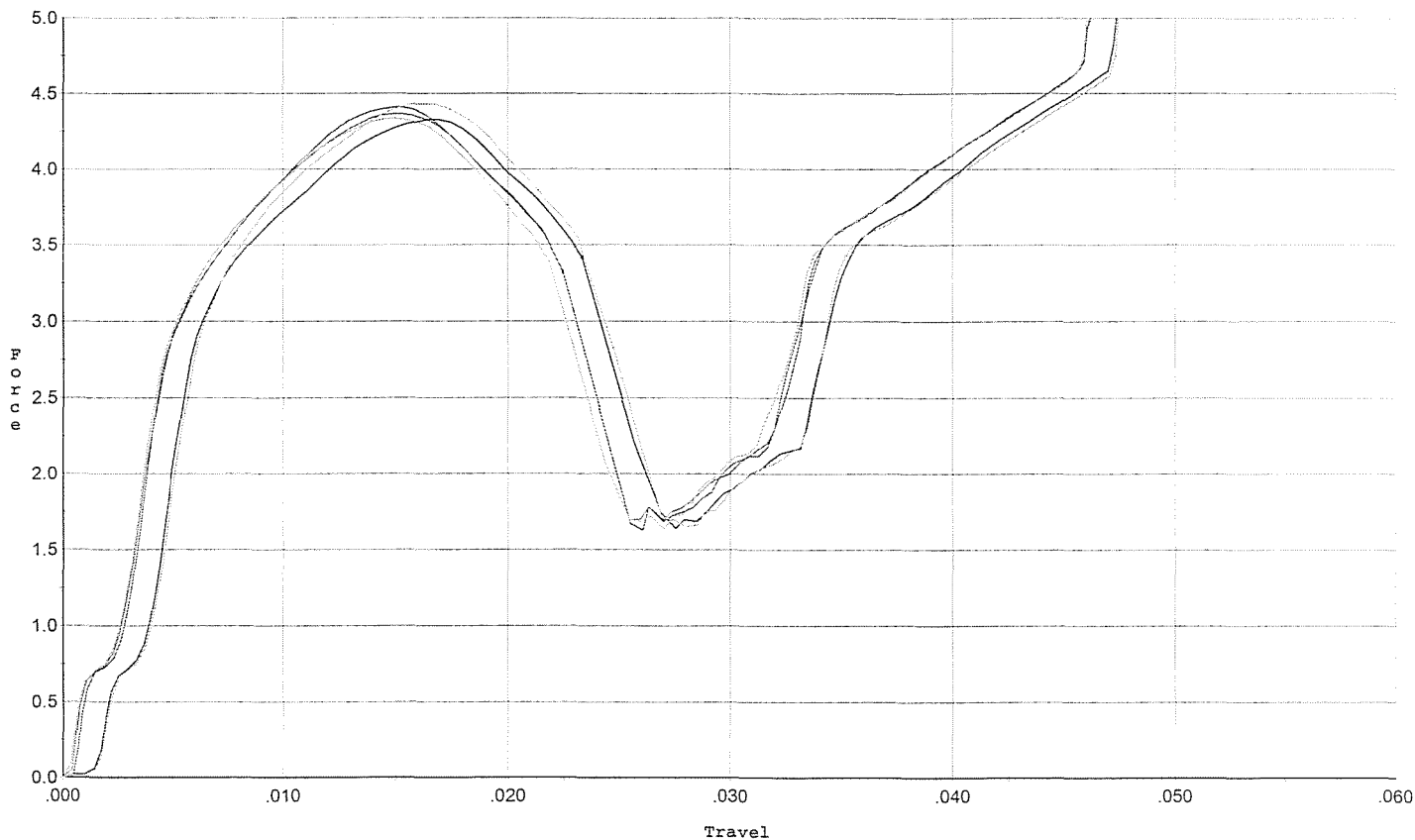
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.235	0.023	0.00	0.030	0.050		Set Trigger
2	3.398	0.020	0.00	0.029	0.049		Set Trigger
3	3.182	0.020	0.00	0.030	0.045		Set Trigger
4	3.191	0.021	0.00	0.030	0.047		Set Trigger
5	3.274	0.021	0.00	0.029	0.047		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



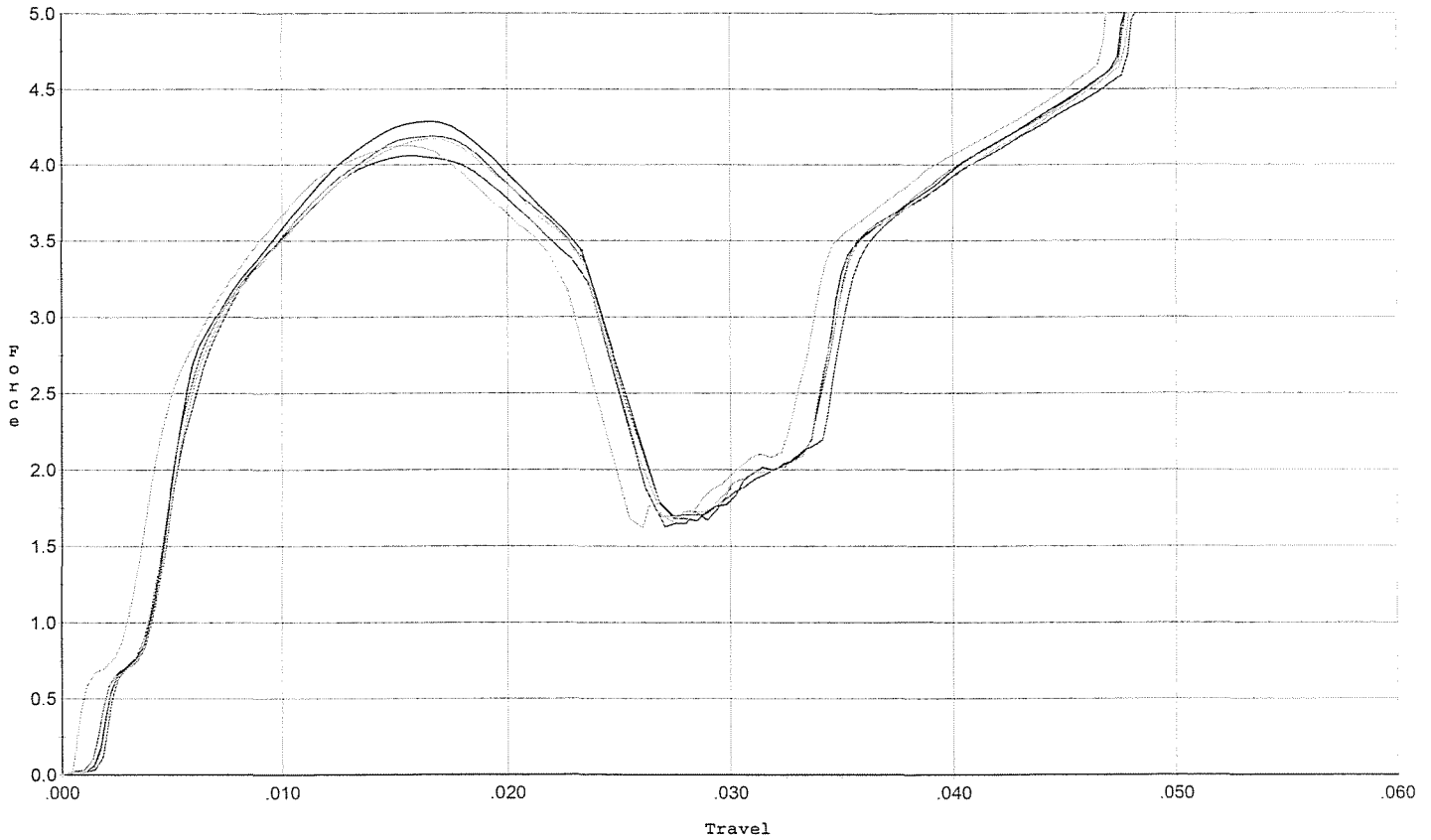
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.414	0.022	0.00	0.026	0.068		Set Trigger
2	4.327	0.023	0.00	0.023	0.068		Set Trigger
3	4.366	0.022	0.00	0.026	0.068		Set Trigger
4	4.339	0.022	0.00	0.026	0.066		Set Trigger
5	4.434	0.025	0.00	0.023	0.073		Set Trigger

A. 4.37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



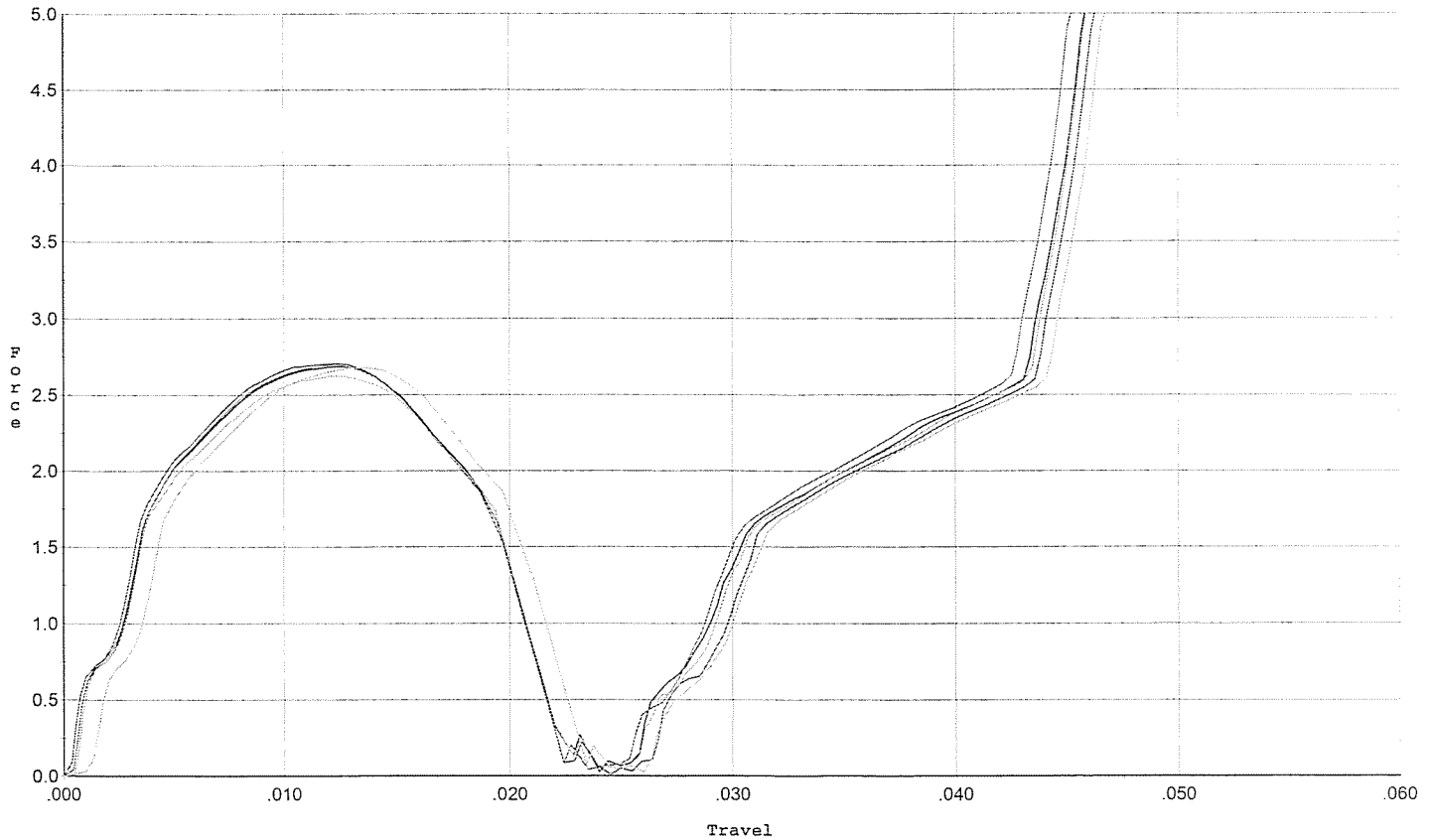
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.060	0.024	0.00	0.027	0.064		Set Trigger
2	4.288	0.023	0.00	0.025	0.066		Set Trigger
3	4.189	0.023	0.00	0.025	0.065		Set Trigger
4	4.174	0.023	0.00	0.026	0.065		Set Trigger
5	4.126	0.023	0.00	0.026	0.065		Set Trigger

1A 4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



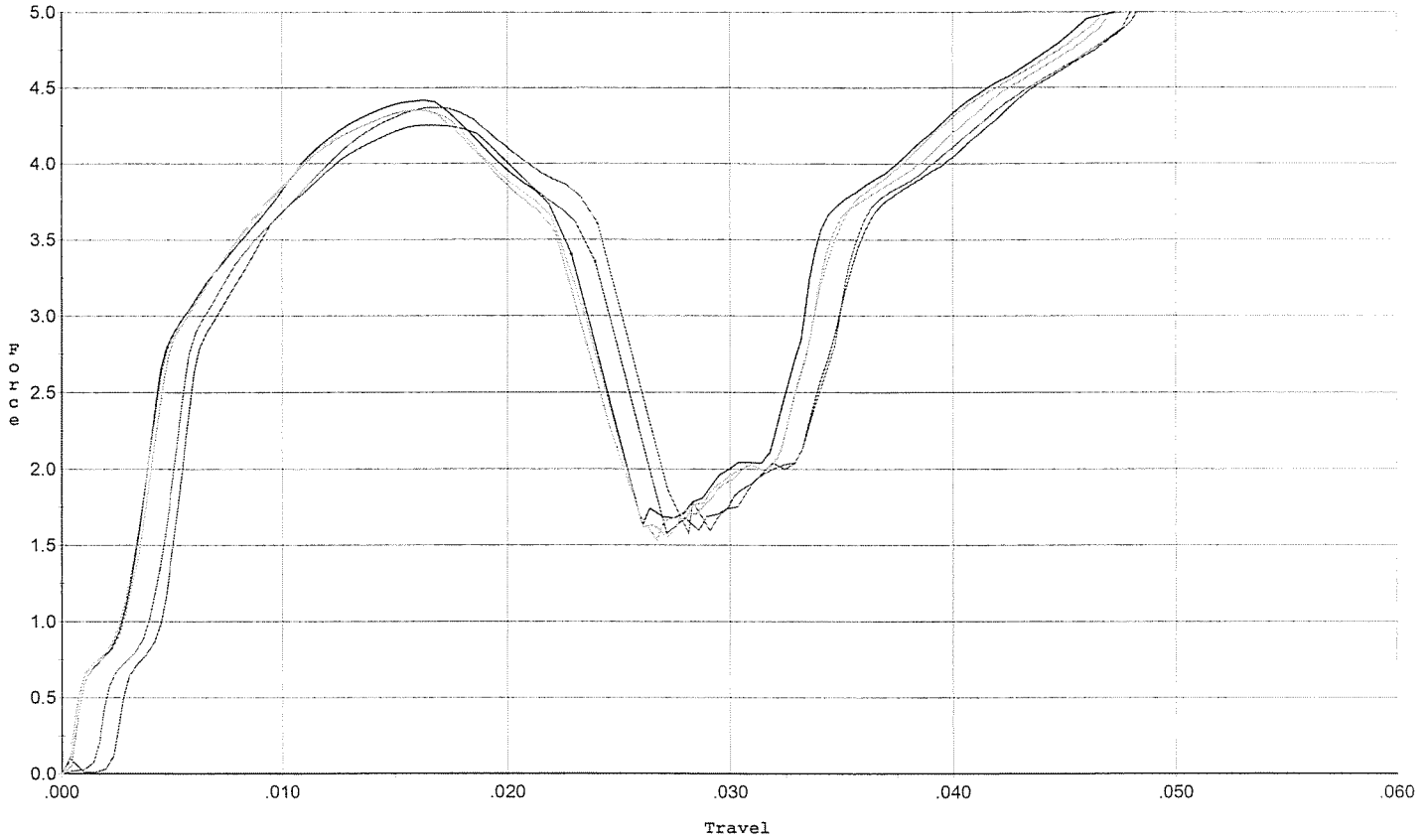
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.706	0.020	0.00	0.031	0.038		Set Trigger
2	2.685	0.019	0.00	0.031	0.037		Set Trigger
3	2.696	0.020	0.00	0.031	0.038		Set Trigger
4	2.680	0.021	0.00	0.031	0.039		Set Trigger
5	2.624	0.019	0.00	0.031	0.036		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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	4.253	0.024	0.002	0.024	0.068		Set Trigger
2	4.419	0.023	0.00	0.026	0.070		Set Trigger
3	4.372	0.024	0.00	0.023	0.071		Set Trigger
4	4.352	0.023	0.00	0.027	0.071		Set Trigger
5	4.355	0.022	0.00	0.027	0.067		Set Trigger

A-4.35