

G6784962

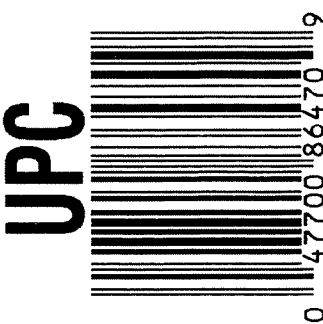
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784962



GUN SERIAL #

66784962

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-8-08	SP
430	ASSEMBLE TO STOCK		9-8-08	SP
440	PROOF		9-8-08	SP
460	CHECK HEADSPACE		9-8-08	SP
470	DIS-ASSEMBLE ACTION		9-8-08	SP
472	SERIALIZE BOLT HANDLE		9-9-08	RT
475	DRILL AND TAP SIGHT HOLES	SEP 10 2008	9-9-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BH	9-10-08	BH
490	MAGNAFLUX BOLT		9/8/08	MB
500	ROLLMARK CALIBER		9/10/08	RT
520	GOFF BLAST BBL / REC		9/10/08	OG
542	APPLY COATINGS (BARREL ACTION)		9/11	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-16-08	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>5.0</u> <u>5.0</u> <u>5.0</u>	10-24-08	L. J.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10-24-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-24-08	L. J.
	J) ASSEMBLE STOCK		9-16-08	L. J.
	K) ASSEMBLE SWIVEL STUDS		10-24-08	L. J.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	10-1-08	TC
650	TARGET	<u>PASS</u> FAIL	9-18-08	FM
	MALFUNCTION <i>BAC</i>	CORRECTION	10-1-08	TC
	MALFUNCTION	CORRECTION <i>N, A.</i>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-18-08	AA
670	FINAL INSPECTION A) HEADSPACE		10-24-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.60</u> <u>2.65</u> <u>2.57</u> <u>2.53</u>	9/23/08	FM
	C) FUNCTION		10-24-08	L. J.
690	PACK		12-9-08	L. J.

F004 REV 5/2006

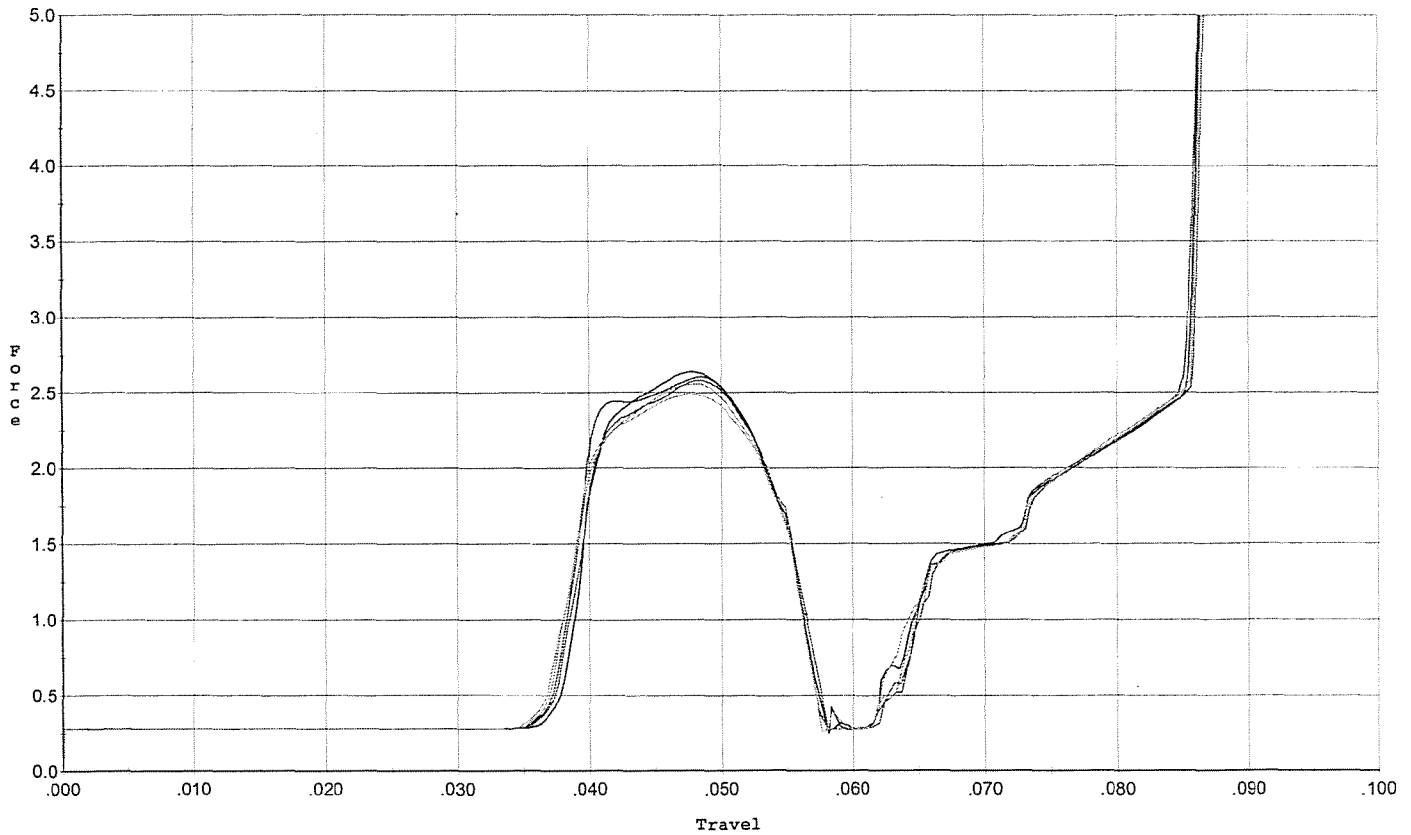
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0069830~~ 69869

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



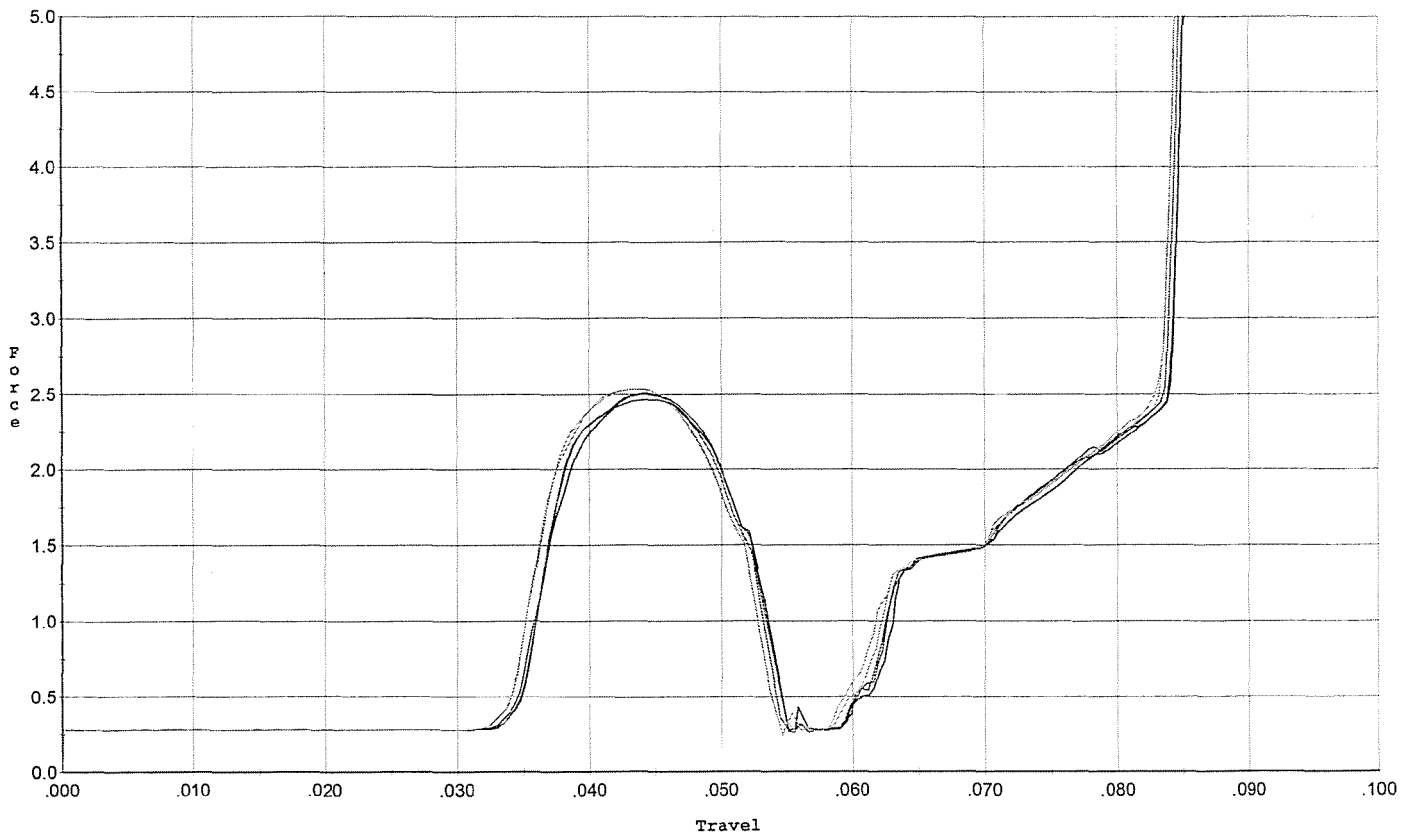
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.055	0.037	0.038	0.050		Set Trigger
2	2.636	0.055	0.038	0.038	0.049		Set Trigger
3	2.580	0.056	0.037	0.038	0.050		Set Trigger
4	2.491	0.055	0.037	0.037	0.049		Set Trigger
5	2.556	0.055	0.037	0.037	0.049		Set Trigger

AVG 2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



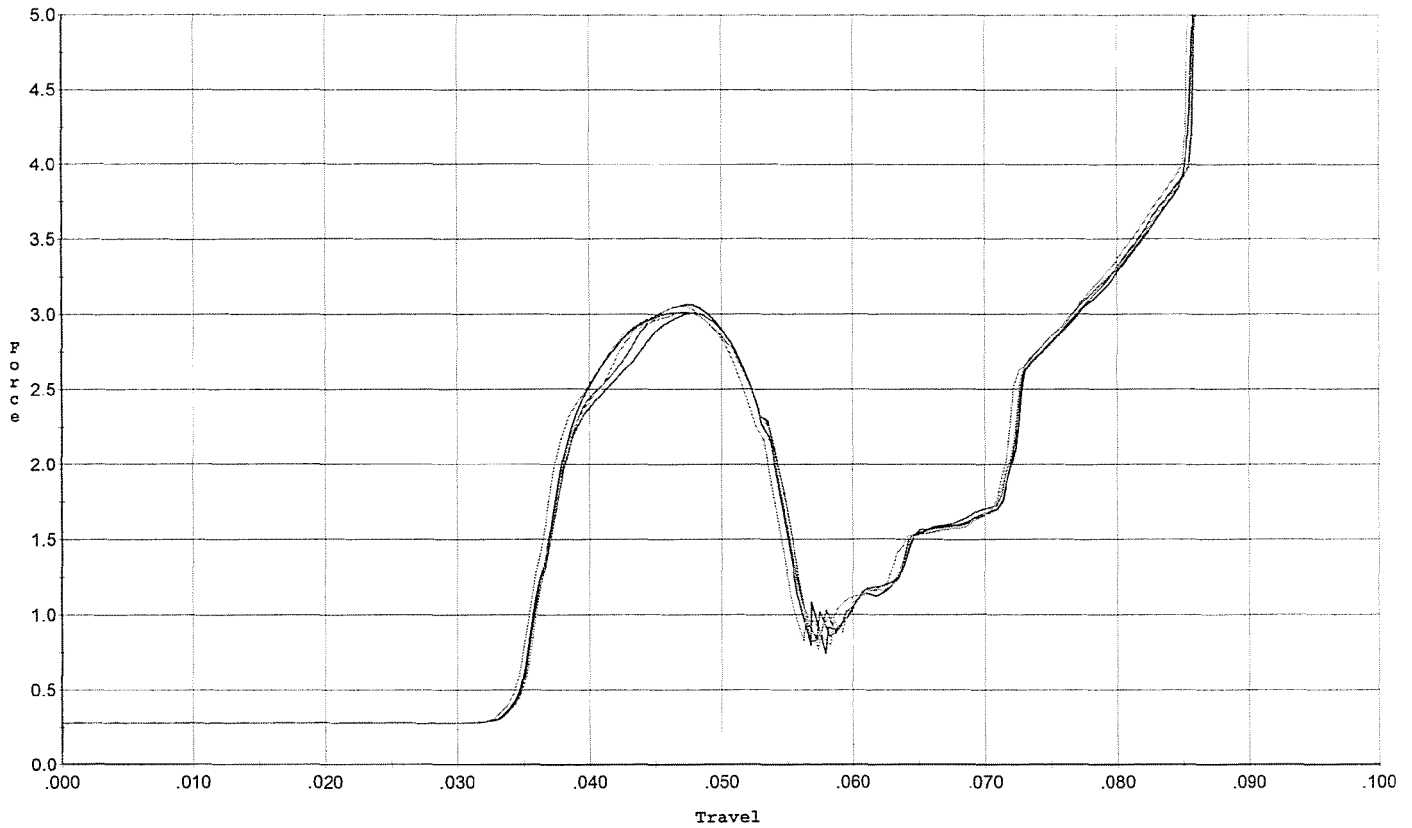
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.052	0.034	0.038	0.046		Set Trigger
2	2.507	0.053	0.035	0.037	0.047		Set Trigger
3	2.462	0.052	0.035	0.037	0.046		Set Trigger
4	2.532	0.052	0.034	0.037	0.046		Set Trigger
5	2.534	0.052	0.034	0.037	0.046		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



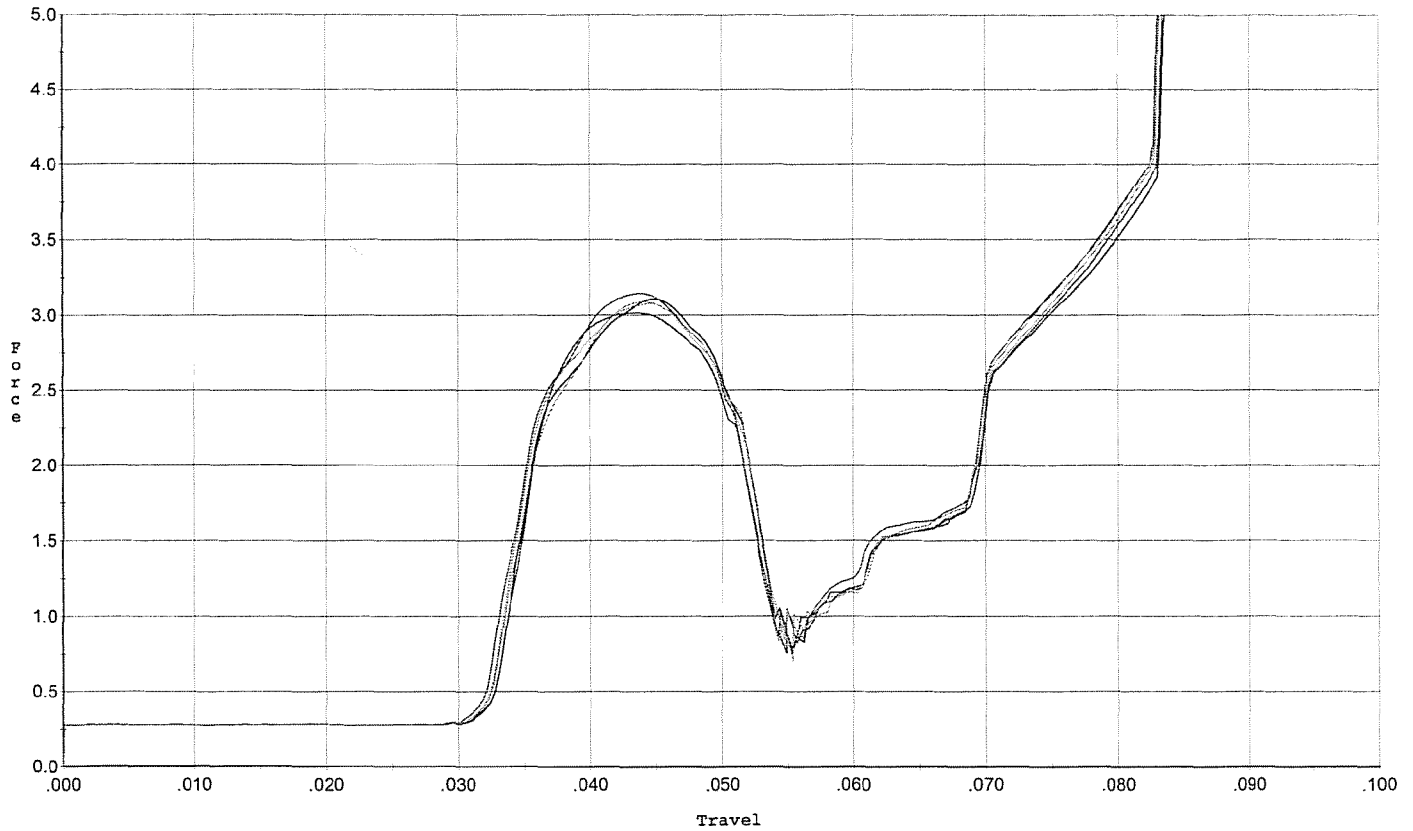
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.009	0.054	0.035	0.037	0.056		Set Trigger
2	3.063	0.054	0.035	0.036	0.058		Set Trigger
3	3.012	0.055	0.035	0.036	0.058		Set Trigger
4	3.007	0.054	0.035	0.037	0.057		Set Trigger
5	3.051	0.053	0.034	0.036	0.057		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



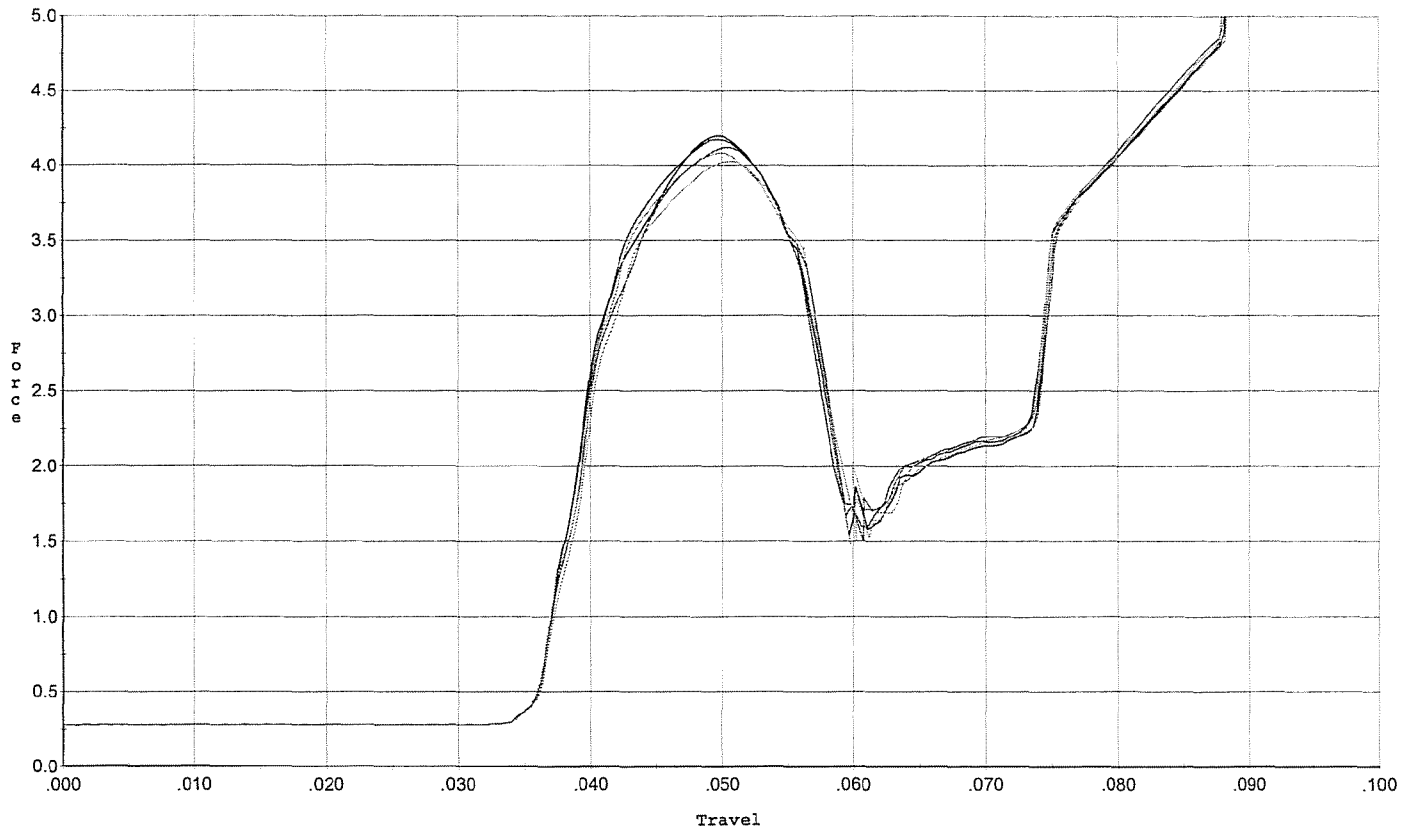
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.013	0.051	0.033	0.036	0.056		Set Trigger
2	3.107	0.052	0.033	0.036	0.058		Set Trigger
3	3.146	0.051	0.032	0.035	0.058		Set Trigger
4	3.089	0.052	0.032	0.035	0.059		Set Trigger
5	3.077	0.051	0.032	0.035	0.058		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



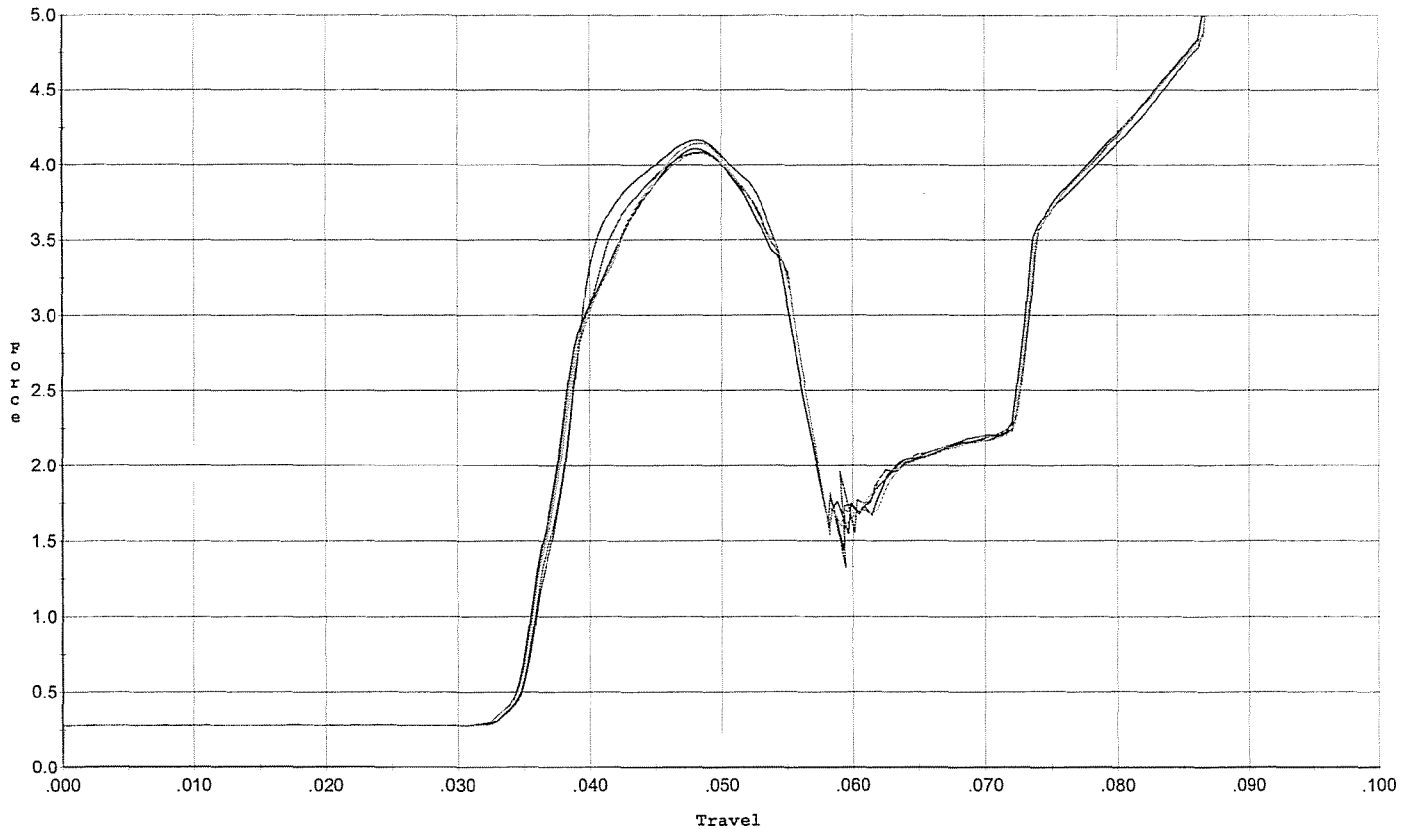
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.056	0.036	0.036	0.078		Set Trigger
2	4.196	0.057	0.036	0.036	0.081		Set Trigger
3	4.120	0.056	0.036	0.036	0.078		Set Trigger
4	4.027	0.056	0.036	0.036	0.077		Set Trigger
5	4.080	0.057	0.036	0.035	0.079		Set Trigger

Avg 4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/29/08

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



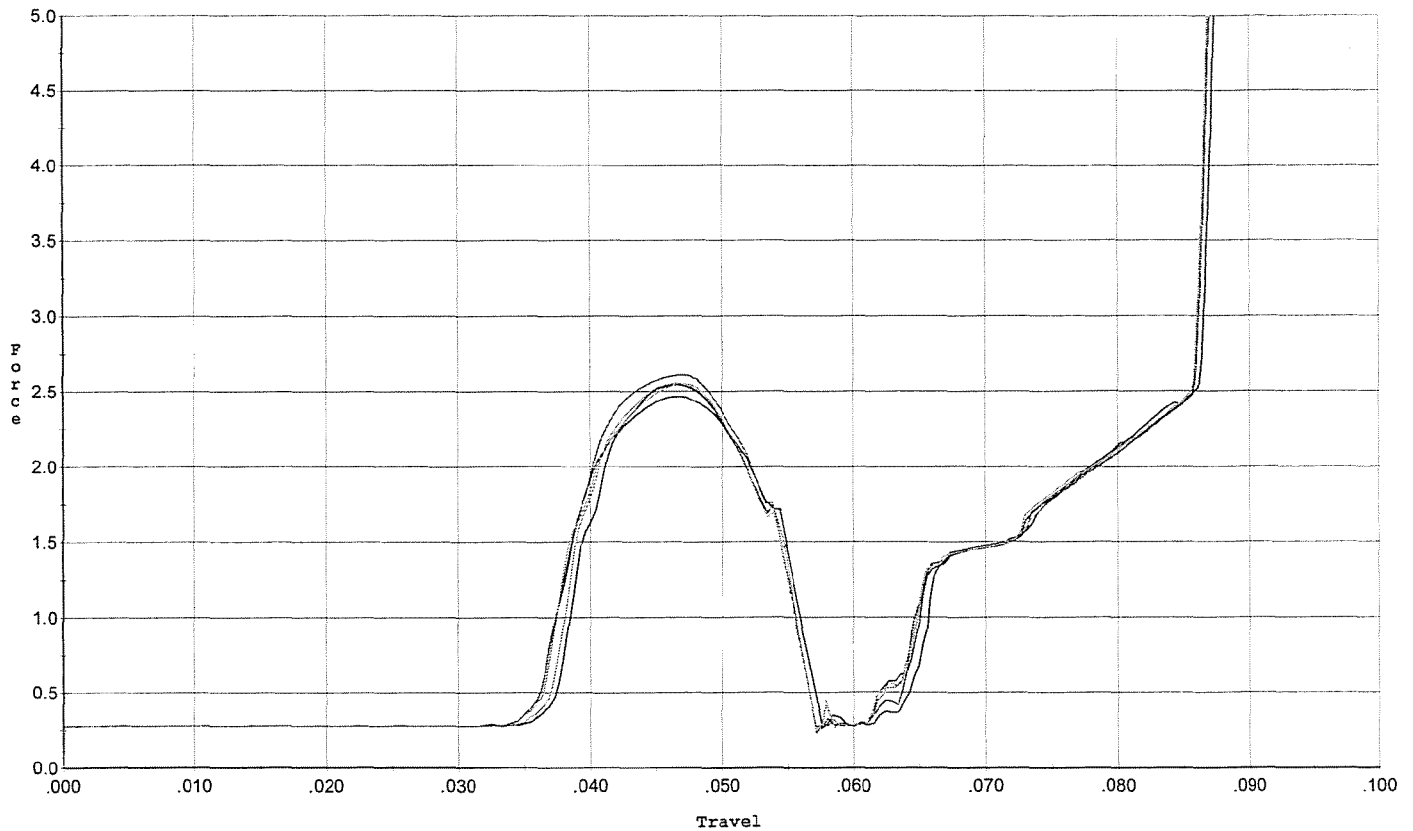
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.164	0.055	0.035	0.035	0.079		Set Trigger
2	4.105	0.054	0.034	0.035	0.076		Set Trigger
3	4.081	0.055	0.035	0.035	0.078		Set Trigger
4	4.142	0.055	0.034	0.035	0.078		Set Trigger
5	4.074	0.055	0.034	0.035	0.078		Set Trigger

AVG 4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/29/08

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



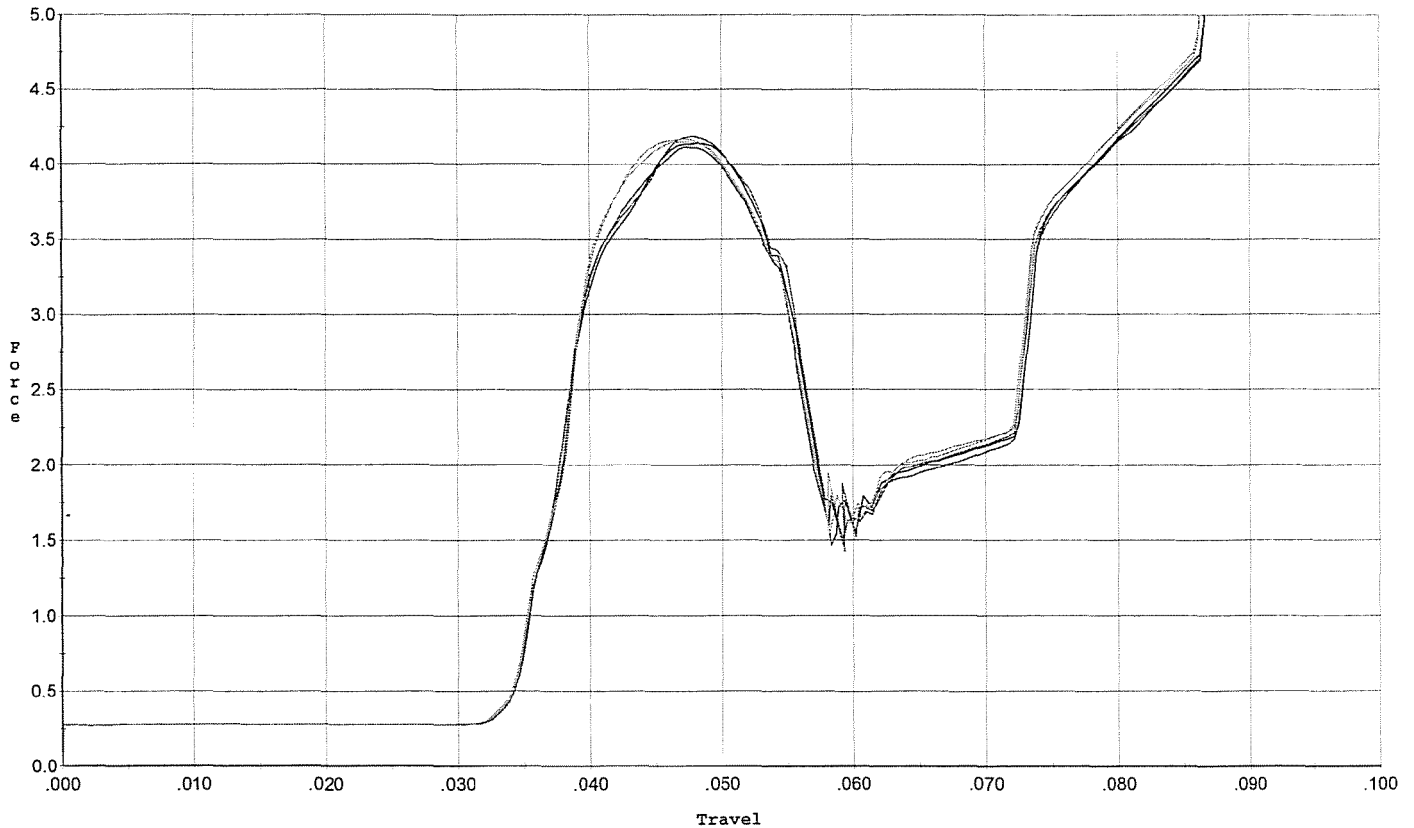
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.543	0.055	0.036	0.038	0.048		Set Trigger
2	2.464	0.054	0.037	0.038	0.046		Set Trigger
3	2.609	0.055	0.036	0.038	0.049		Set Trigger
4	2.550	0.055	0.036	0.038	0.048		Set Trigger
5	2.556	0.055	0.037	0.038	0.047		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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	4.115	0.054	0.034	0.035	0.077		Set Trigger
2	4.141	0.056	0.034	0.035	0.079		Set Trigger
3	4.182	0.055	0.034	0.035	0.079		Set Trigger
4	4.146	0.054	0.034	0.035	0.078		Set Trigger
5	4.169	0.054	0.034	0.035	0.078		Set Trigger

Avg 4.15