

G678 9966

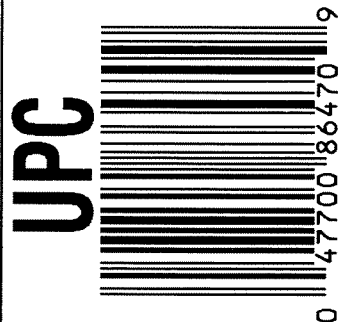
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6789966



GUN SERIAL # G 678 9966

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		12-1-08	SP
430	ASSEMBLE TO STOCK		12-1-08	SP
440	PROOF		12-1-08	SP
460	CHECK HEADSPACE		12-1-08	SP
470	DIS-ASSEMBLE ACTION		12-1-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	12-2-08	RSN
475	DRILL AND TAP SIGHT HOLES	2008 OPERATOR	12-2-08	SP
480	MAGNAFLUX BBL ACTION		12/9/08	SP
490	MAGNAFLUX BOLT		12/9/08	MR
500	ROLLMARK CALIBER		12/9/08	RT
520	GOFF BLAST BBL / REC		12/9/08	DG
542	APPLY COATINGS (BARREL ACTION)		12-15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-16-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-16-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-16-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-3-09	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV. 5/2006

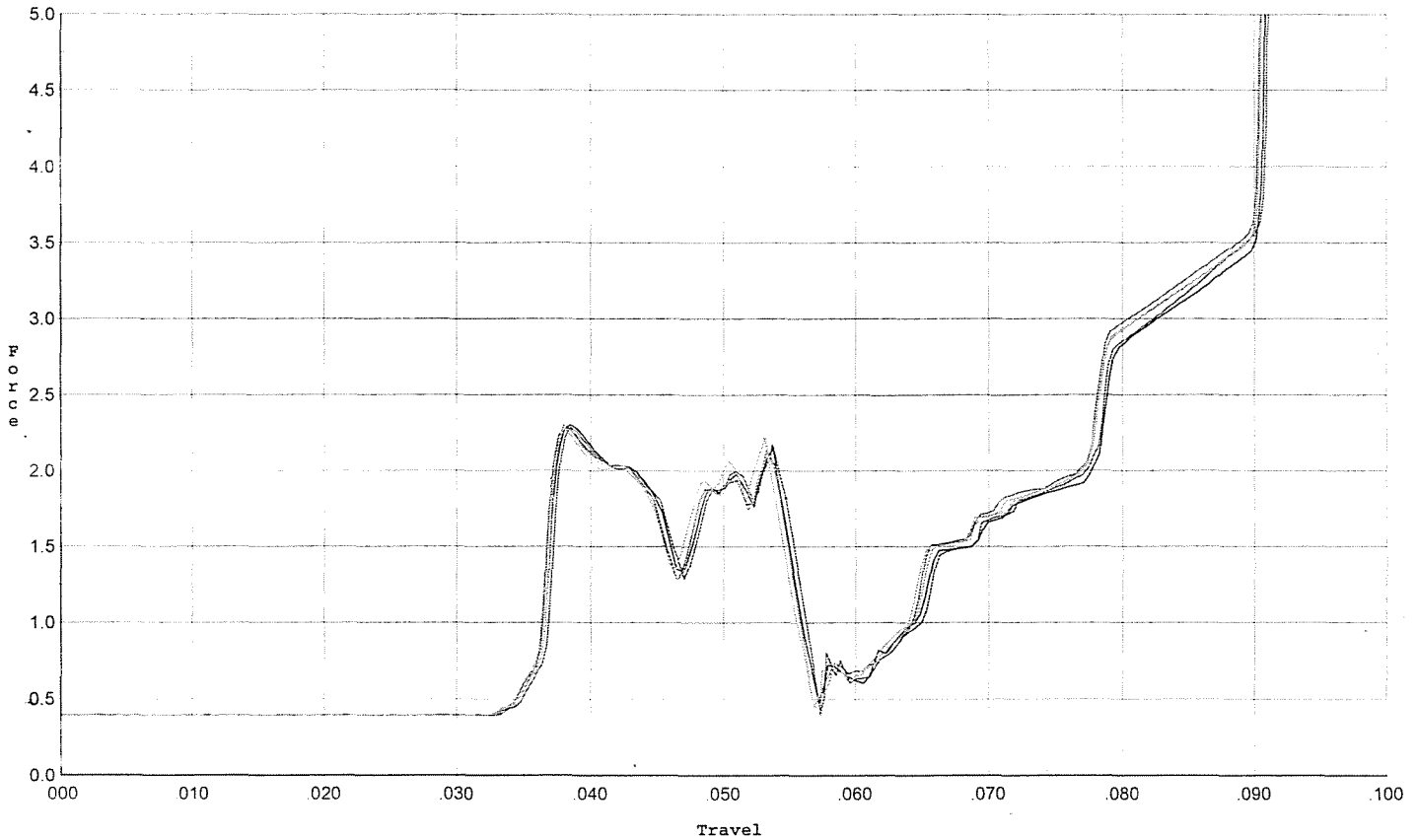
OP #	OP	BARBER - M24 6071622	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-6-09	L.N.
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	1-6-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	1-6-09	L.N.
	J) ASSEMBLE STOCK			1-5-09	RSN
	K) ASSEMBLE SWIVEL STUDS			1-6-09	L.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	1-5-09	L.N.
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			1-5-09	RP
670	FINAL INSPECTION A) HEADSPACE			1-6-09	L.N.
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.70</u> <u>2.71</u> <u>2.72</u> <u>2.80</u>	1-6-09	TC
	C) FUNCTION			1-6-09	L.N.
690	PACK			1/15/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



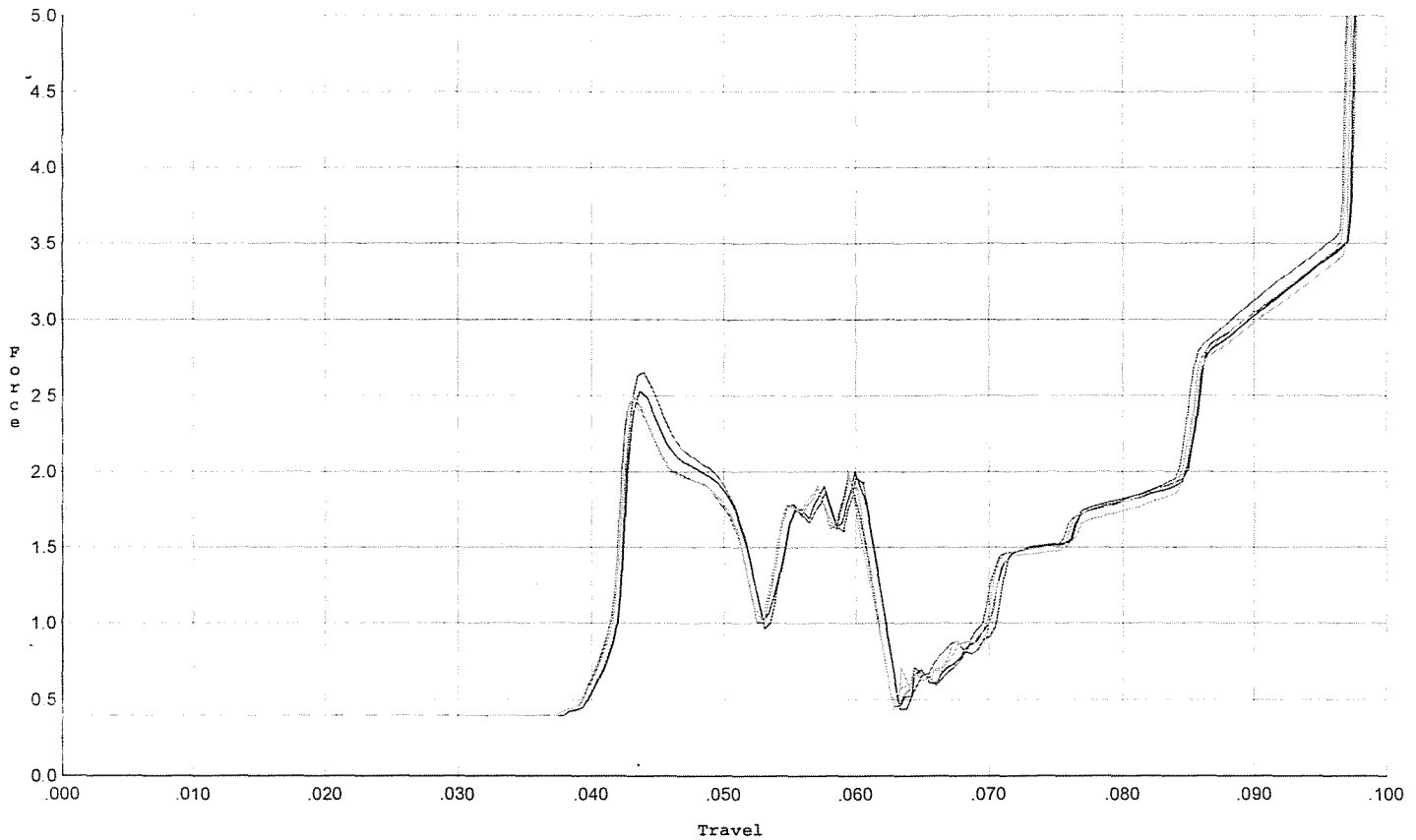
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.290	0.055	0.035	0.040	0.049		Set Trigger
2	2.307	0.054	0.035	0.040	0.049		Set Trigger
3	2.299	0.054	0.035	0.040	0.049		Set Trigger
4	2.283	0.054	0.035	0.040	0.048		Set Trigger
5	2.276	0.053	0.035	0.041	0.048		Set Trigger

A-229

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



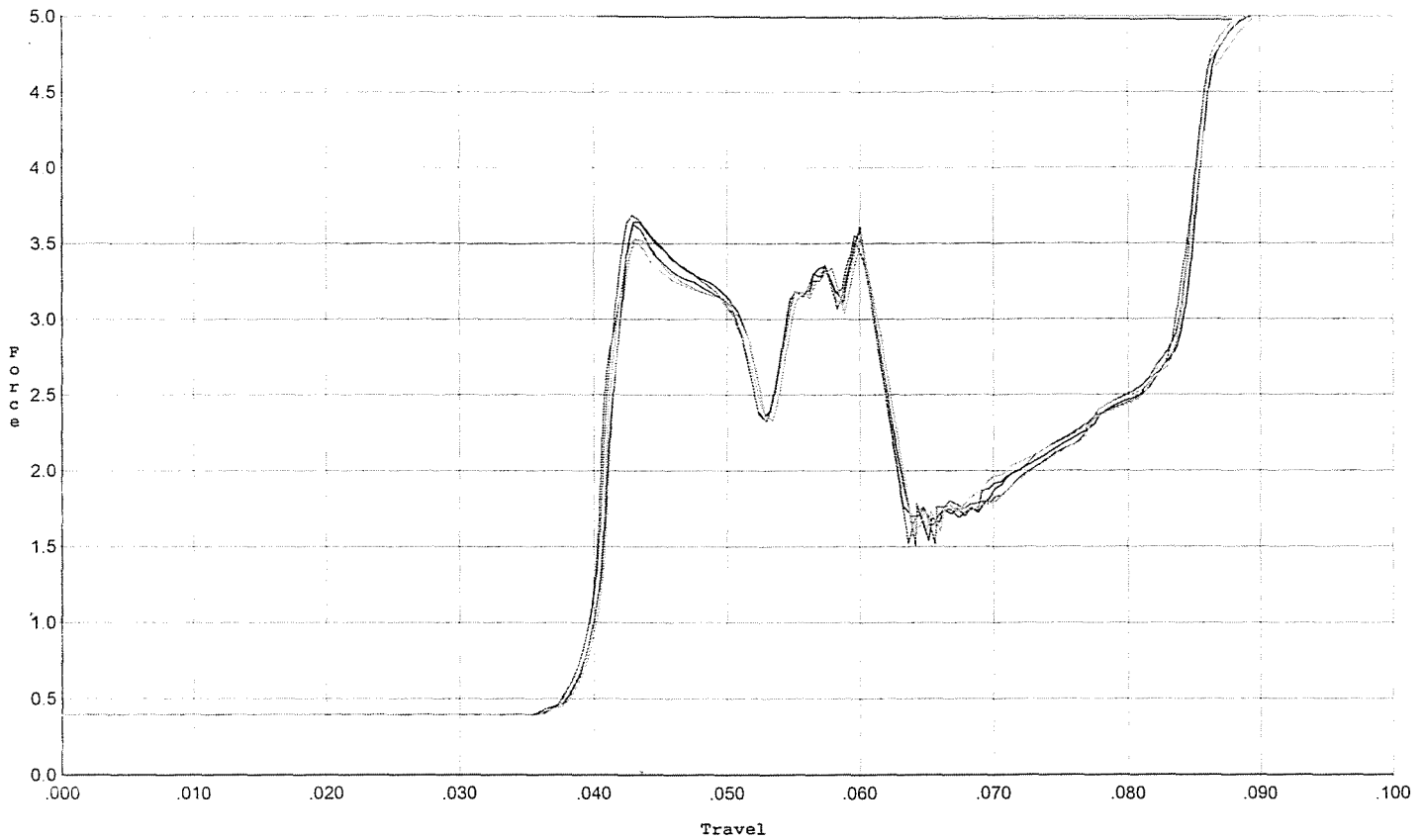
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.653	0.061	0.040	0.042	0.053		Set Trigger
2	2.532	0.061	0.040	0.042	0.052		Set Trigger
3	2.492	0.061	0.040	0.042	0.052		Set Trigger
4	2.498	0.060	0.040	0.042	0.051		Set Trigger
5	2.430	0.059	0.040	0.042	0.050		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



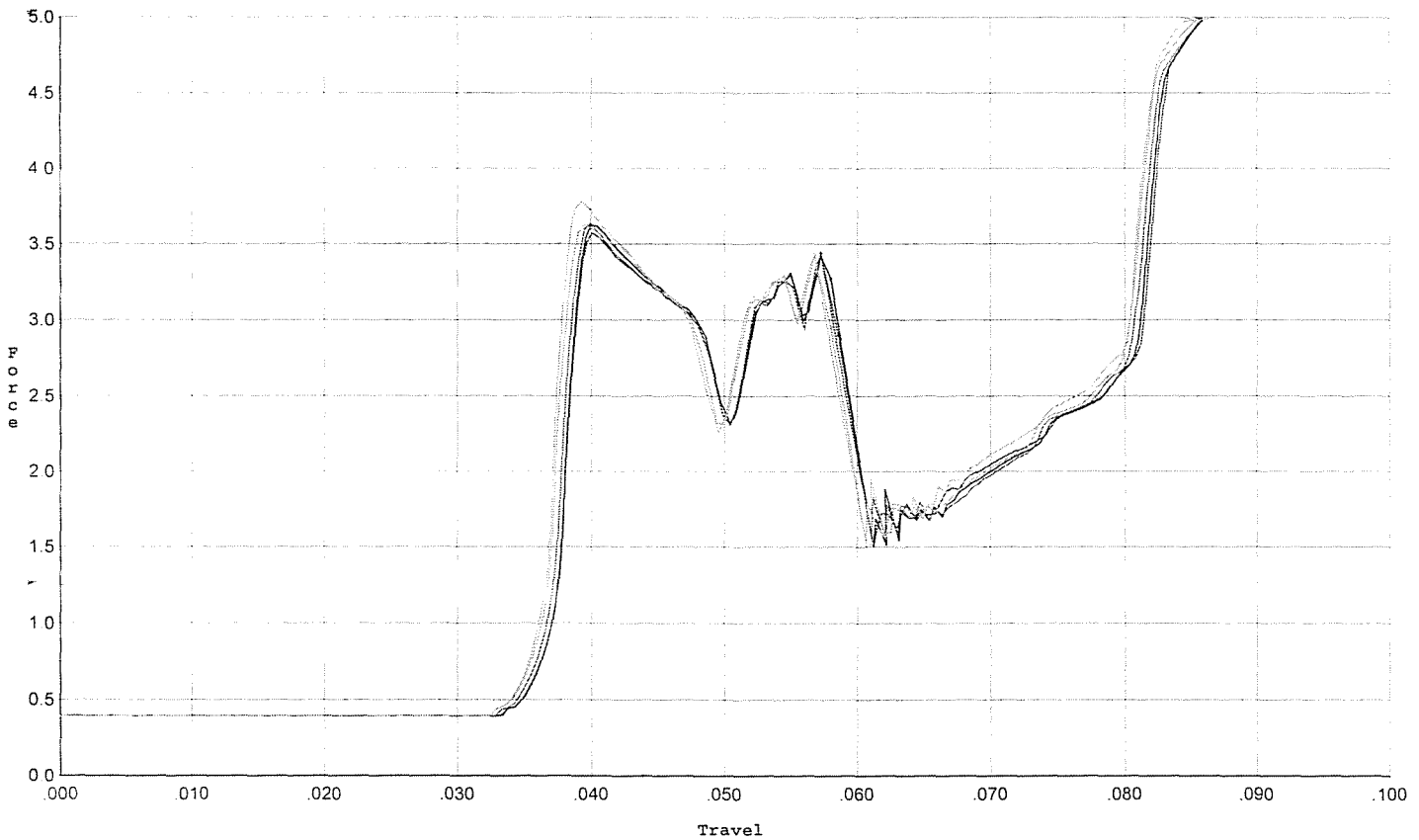
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.627	0.060	0.038	0.040	0.082		Set Trigger
2	3.642	0.060	0.039	0.040	0.081		Set Trigger
3	3.688	0.060	0.038	0.039	0.082		Set Trigger
4	3.555	0.060	0.038	0.040	0.080		Set Trigger
5	3.536	0.062	0.039	0.039	0.083		Set Trigger

A-3.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



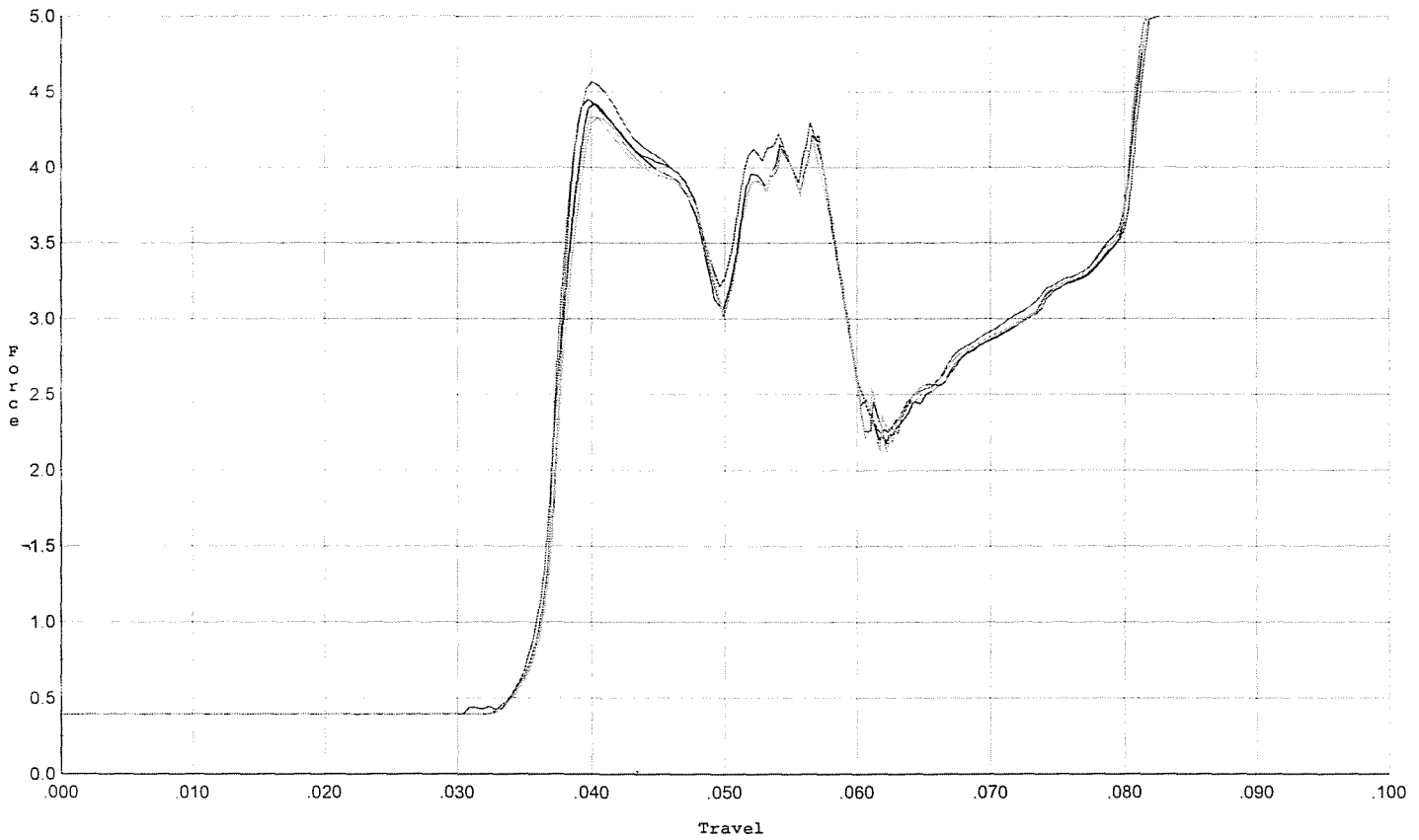
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.573	0.059	0.036	0.038	0.081		Set Trigger
2	3.622	0.058	0.036	0.038	0.081		Set Trigger
3	3.636	0.057	0.035	0.038	0.080		Set Trigger
4	3.624	0.058	0.035	0.037	0.082		Set Trigger
5	3.780	0.057	0.035	0.037	0.081		Set Trigger

A-3-64

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/18/2008

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



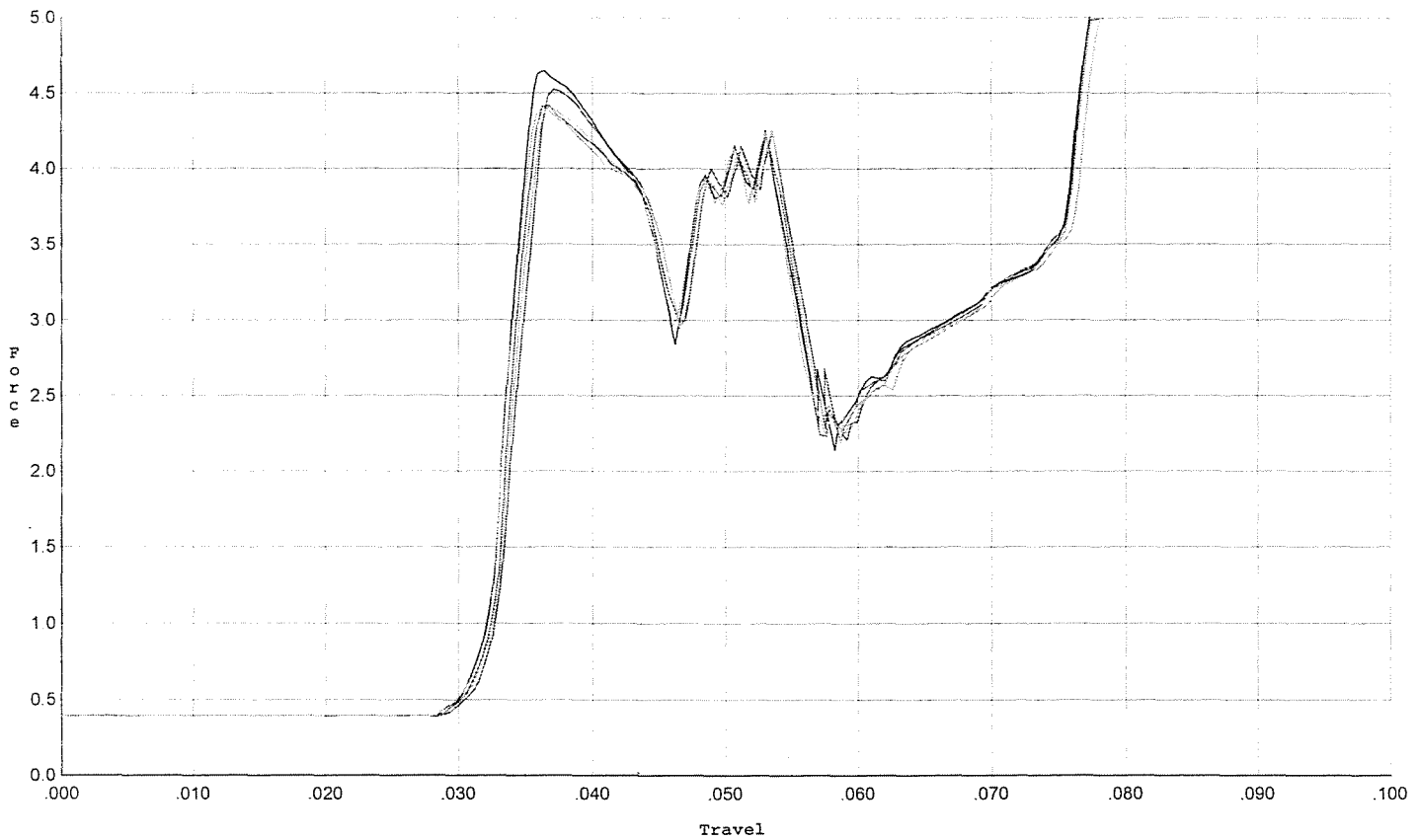
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.451	0.057	0.034	0.035	0.099		Set Trigger
2	4.423	0.057	0.035	0.035	0.097		Set Trigger
3	4.569	0.057	0.035	0.034	0.098		Set Trigger
4	4.331	0.057	0.035	0.035	0.096		Set Trigger
5	4.333	0.058	0.035	0.035	0.097		Set Trigger

A.H. 42

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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



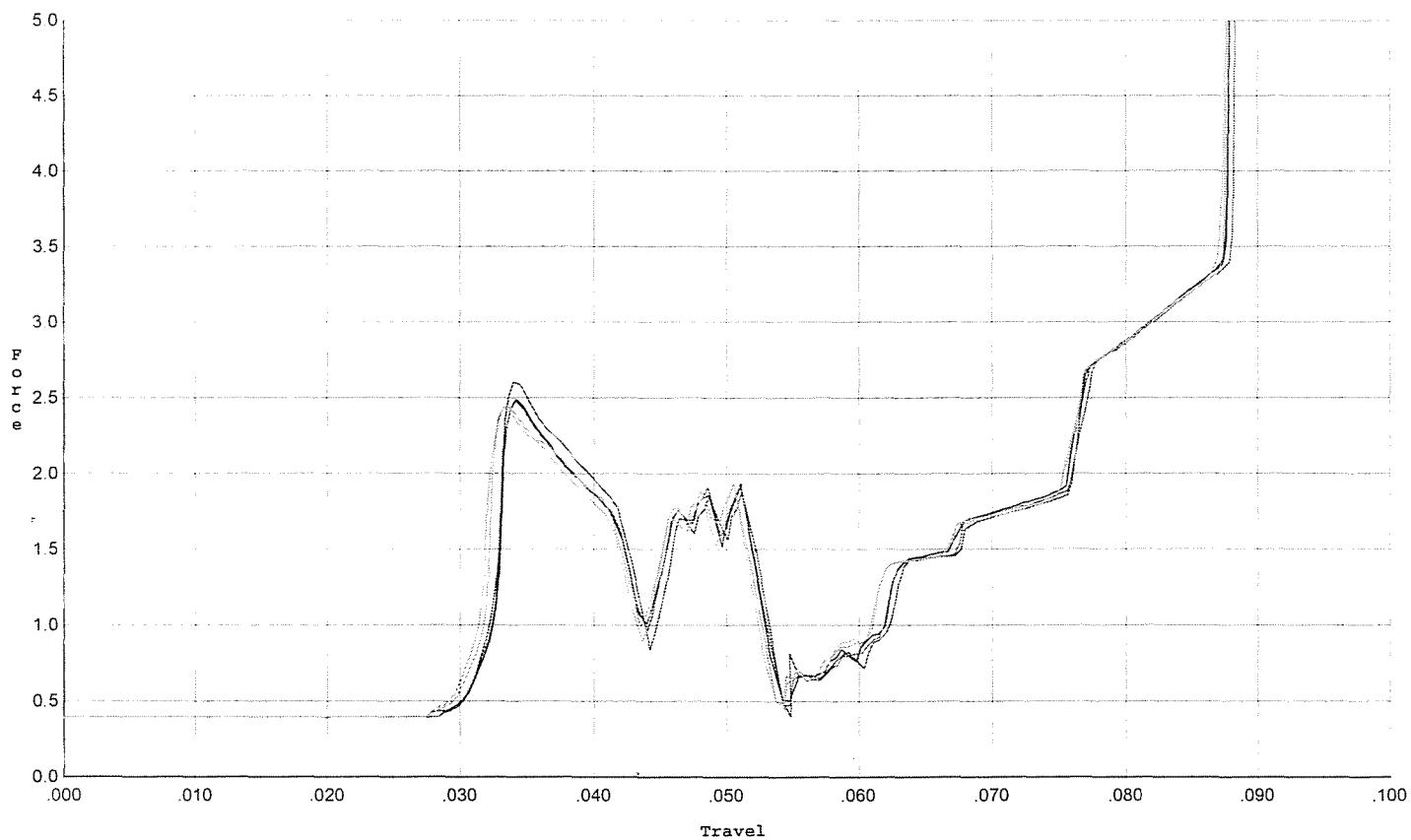
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.526	0.056	0.032	0.033	0.099		Set Trigger
2	4.649	0.055	0.031	0.033	0.100		Set Trigger
3	4.419	0.054	0.031	0.033	0.096		Set Trigger
4	4.413	0.054	0.031	0.033	0.095		Set Trigger
5	4.405	0.053	0.031	0.033	0.094		Set Trigger

A - 4.458

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/18/2008

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



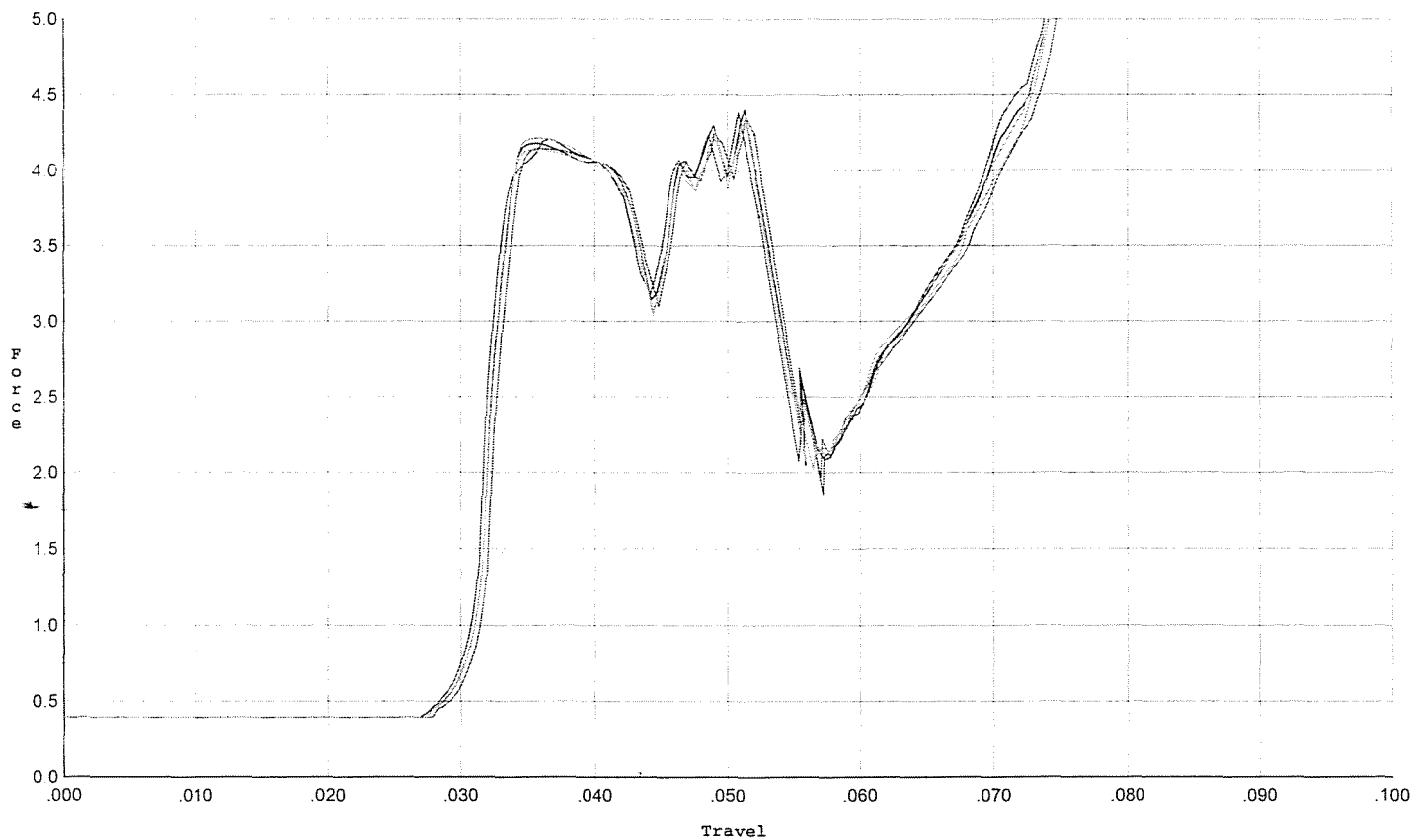
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.052	0.031	0.040	0.050		Set Trigger
2	2.490	0.051	0.031	0.041	0.048		Set Trigger
3	2.482	0.051	0.031	0.041	0.048		Set Trigger
4	2.439	0.051	0.030	0.042	0.047		Set Trigger
5	2.434	0.052	0.030	0.041	0.050		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/18/2008

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	4.385	0.052	0.030	0.026	0.095		Set Trigger
2	4.406	0.054	0.030	0.025	0.098		Set Trigger
3	4.355	0.052	0.030	0.026	0.094		Set Trigger
4	4.296	0.051	0.030	0.026	0.092		Set Trigger
5	4.357	0.051	0.030	0.026	0.093		Set Trigger

A-4-36