

G 6871309

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



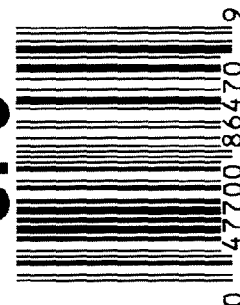
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6871309

UPC



BM FORM

GUN SERIAL # G 6871309

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-23-09	SPD
430	ASSEMBLE TO STOCK		7-23-09	SP
440	PROOF		7-23-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	7-23-09	SPD
470	DIS-ASSEMBLE ACTION		7-23-09	SPD
472	SERIALIZE BOLT HANDLE		7-24-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	7/28/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-28-09	AWD
510	DRILL AND TAP SIGHT HOLES		7-24-09	SP
520	GOFF BLAST BBL / REC		7/30/09	7/1/09
540	APPLY COATINGS (BARREL ACTION)		8/1/09	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-29-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

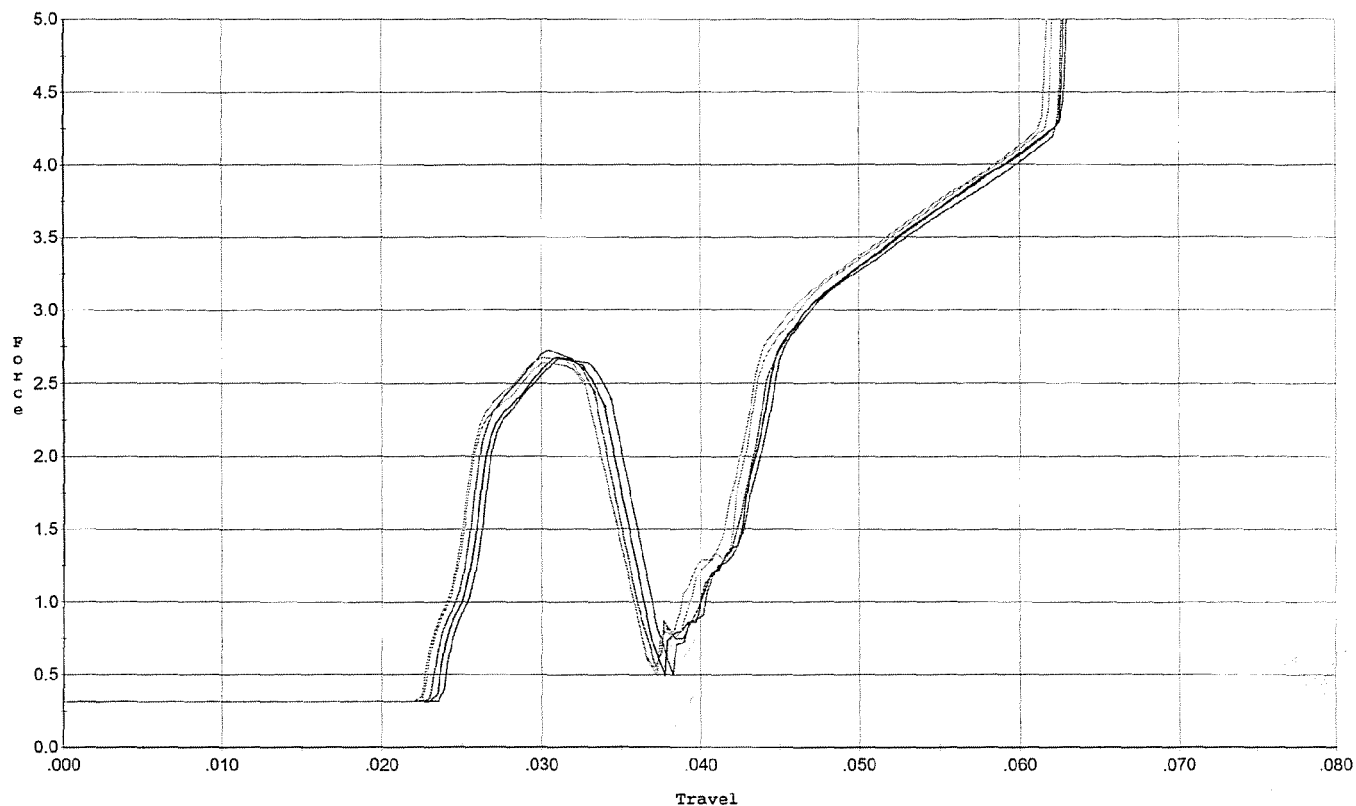
560	BARBER - M24 0080750 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2°</u>	<u>2°</u>	<u>2°</u>	9/3/09	RB		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>8°</u>	<u>8°</u>	<u>8°</u>	9/3/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.023</u>	<u>.023</u>	9/3/09	RB		
	J) ASSEMBLE STOCK					8-29-09	W.H.		
	K) ASSEMBLE SWIVEL STUDS					9/3/09	RB		
	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		9-2-09	RP		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					9-2-09	W.P.D.		
670	FINAL INSPECTION A) HEADSPACE					9/3/09	RB		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u>	<u>2.37</u>	<u>2.40</u>	<u>2.48</u>	<u>2.41</u>	9/3/09	RB
	C) FUNCTION					9/3/09	RB		
690	PACK					9-4-09	TK		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/22/2009

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



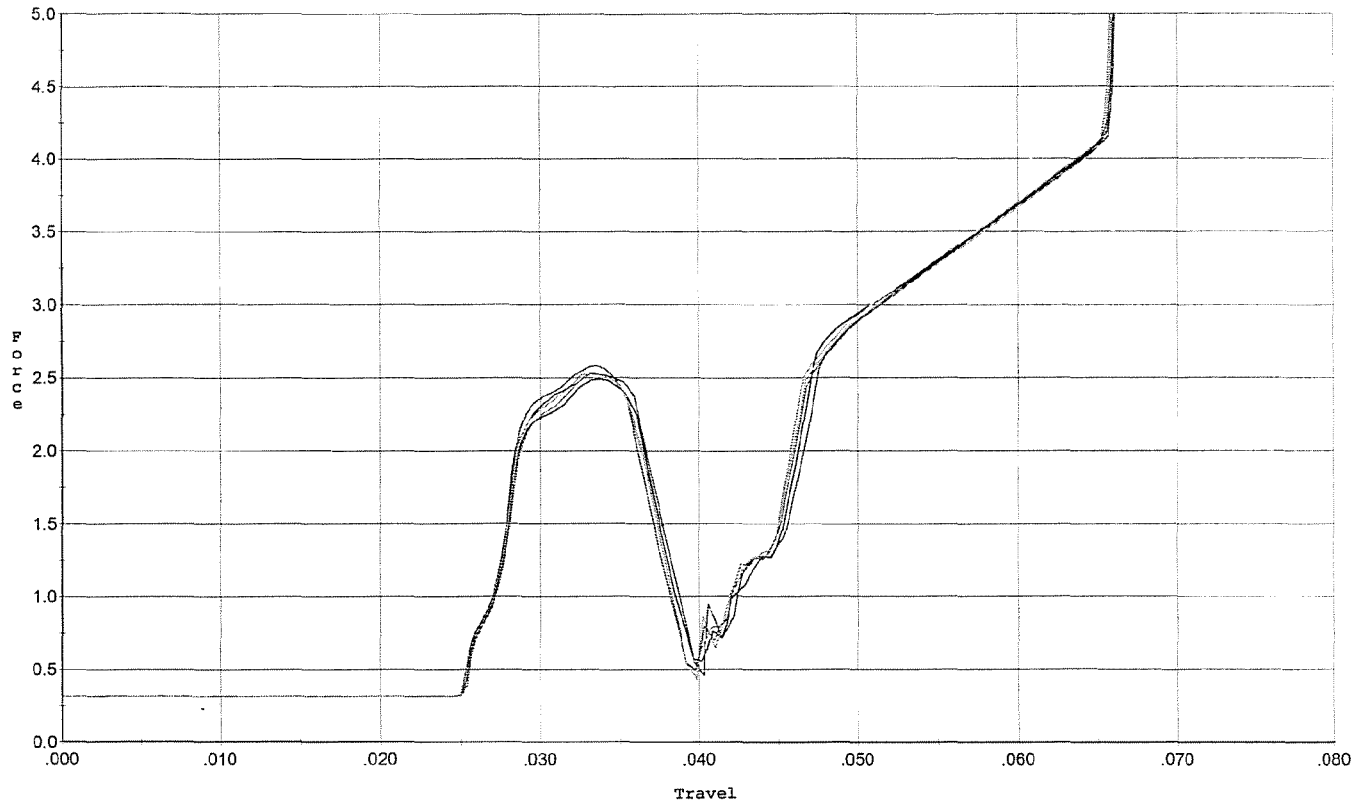
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.034	0.024	0.031	0.031		Set Trigger
2	2.677	0.034	0.024	0.031	0.031		Set Trigger
3	2.723	0.033	0.023	0.031	0.031		Set Trigger
4	2.639	0.035	0.023	0.030	0.032		Set Trigger
5	2.674	0.035	0.023	0.030	0.032		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/22/2009

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



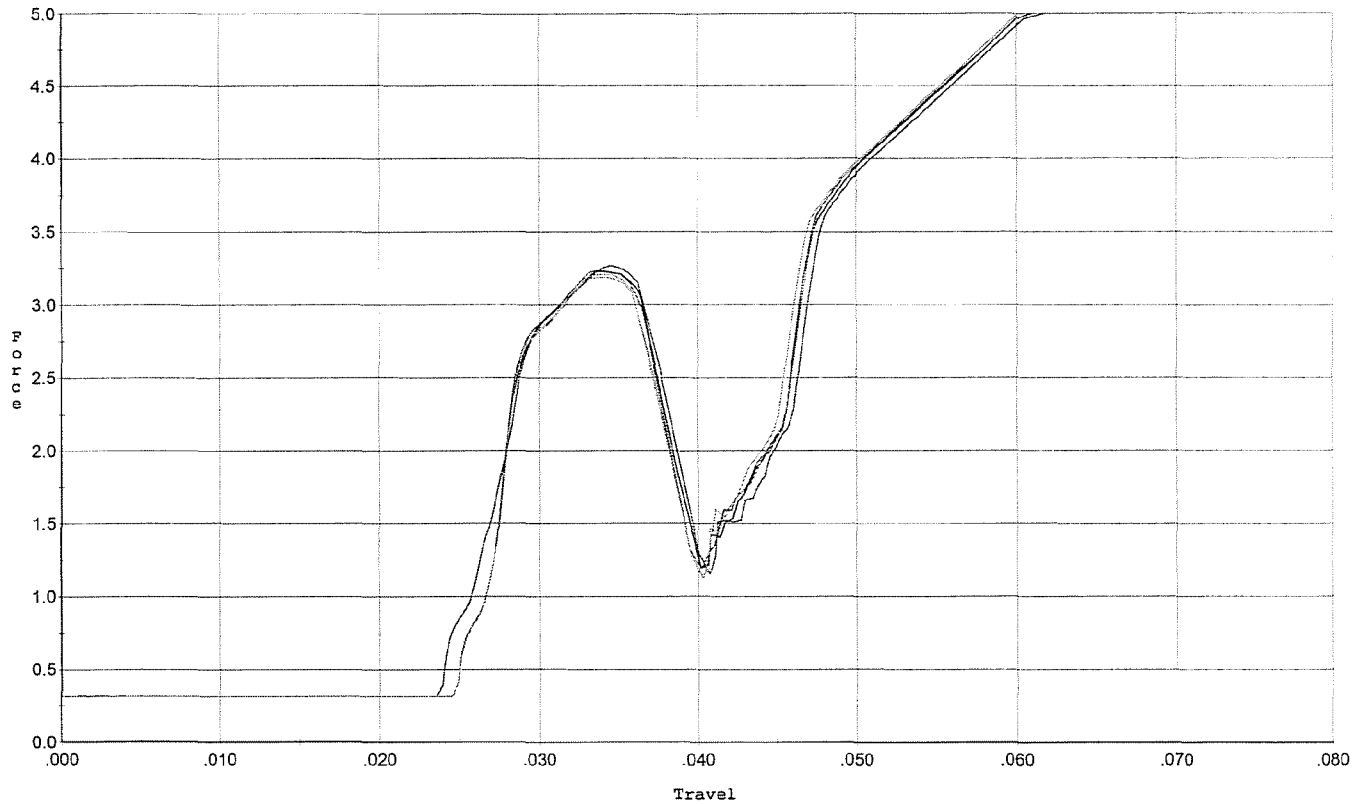
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.038	0.025	0.032	0.033		Set Trigger
2	2.492	0.036	0.025	0.032	0.031		Set Trigger
3	2.583	0.035	0.025	0.033	0.030		Set Trigger
4	2.524	0.037	0.025	0.032	0.031		Set Trigger
5	2.521	0.036	0.025	0.032	0.031		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/22/2009

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



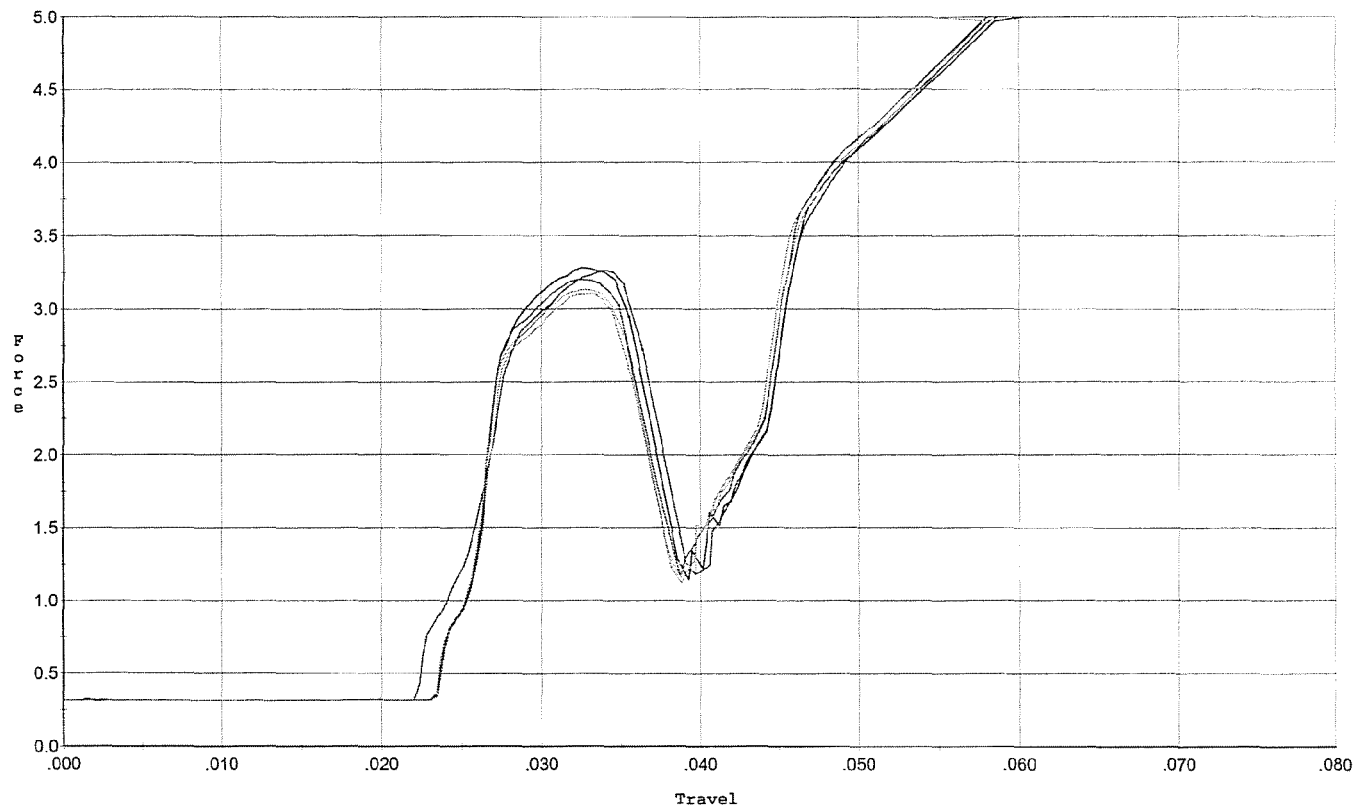
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.268	0.038	0.024	0.030	0.042		Set Trigger
2	3.228	0.036	0.025	0.030	0.039		Set Trigger
3	3.234	0.036	0.025	0.030	0.039		Set Trigger
4	3.189	0.037	0.025	0.029	0.039		Set Trigger
5	3.207	0.037	0.025	0.029	0.040		Set Trigger

A3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/22/2009

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



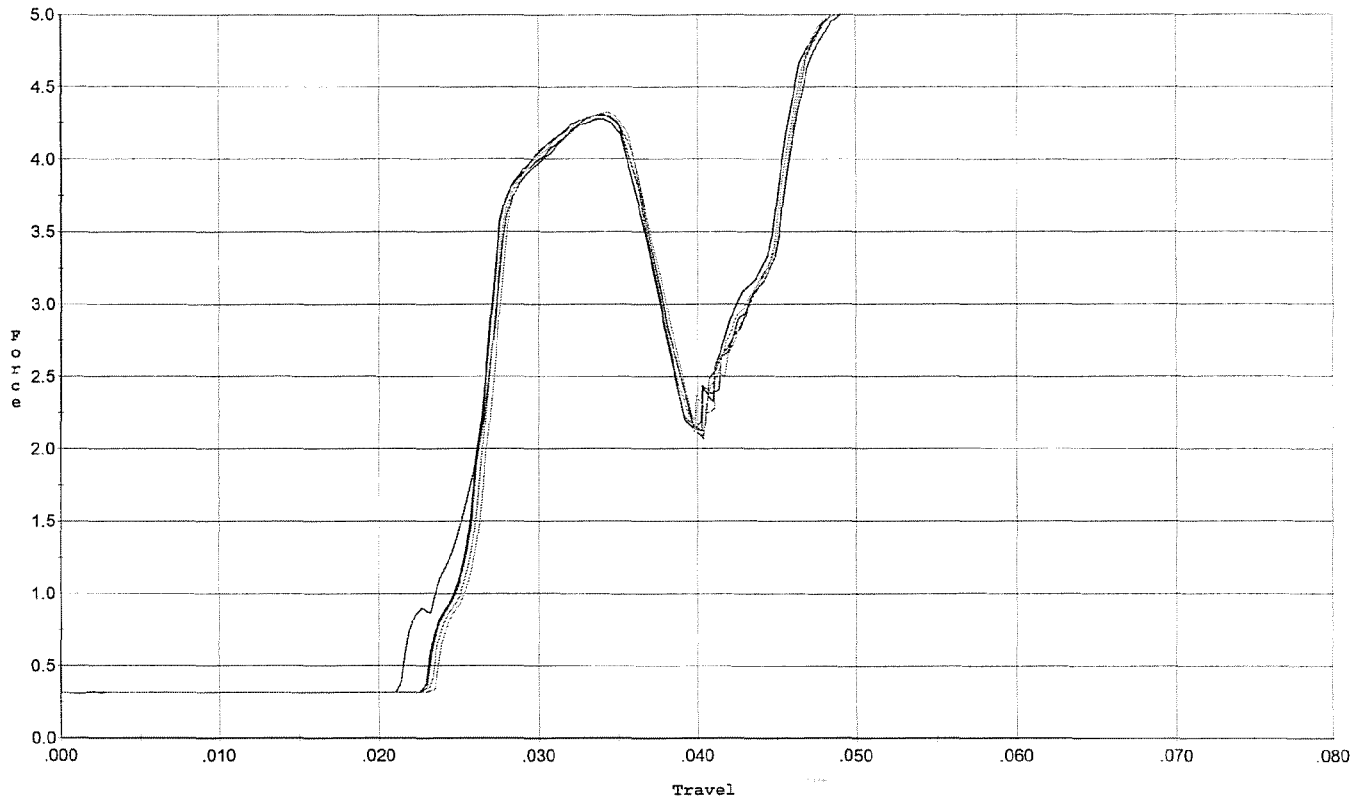
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.265	0.036	0.022	0.029	0.042		Set Trigger
2	3.281	0.036	0.024	0.029	0.040		Set Trigger
3	3.198	0.035	0.024	0.029	0.038		Set Trigger
4	3.135	0.035	0.023	0.030	0.038		Set Trigger
5	3.104	0.036	0.024	0.030	0.038		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/22/2009

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



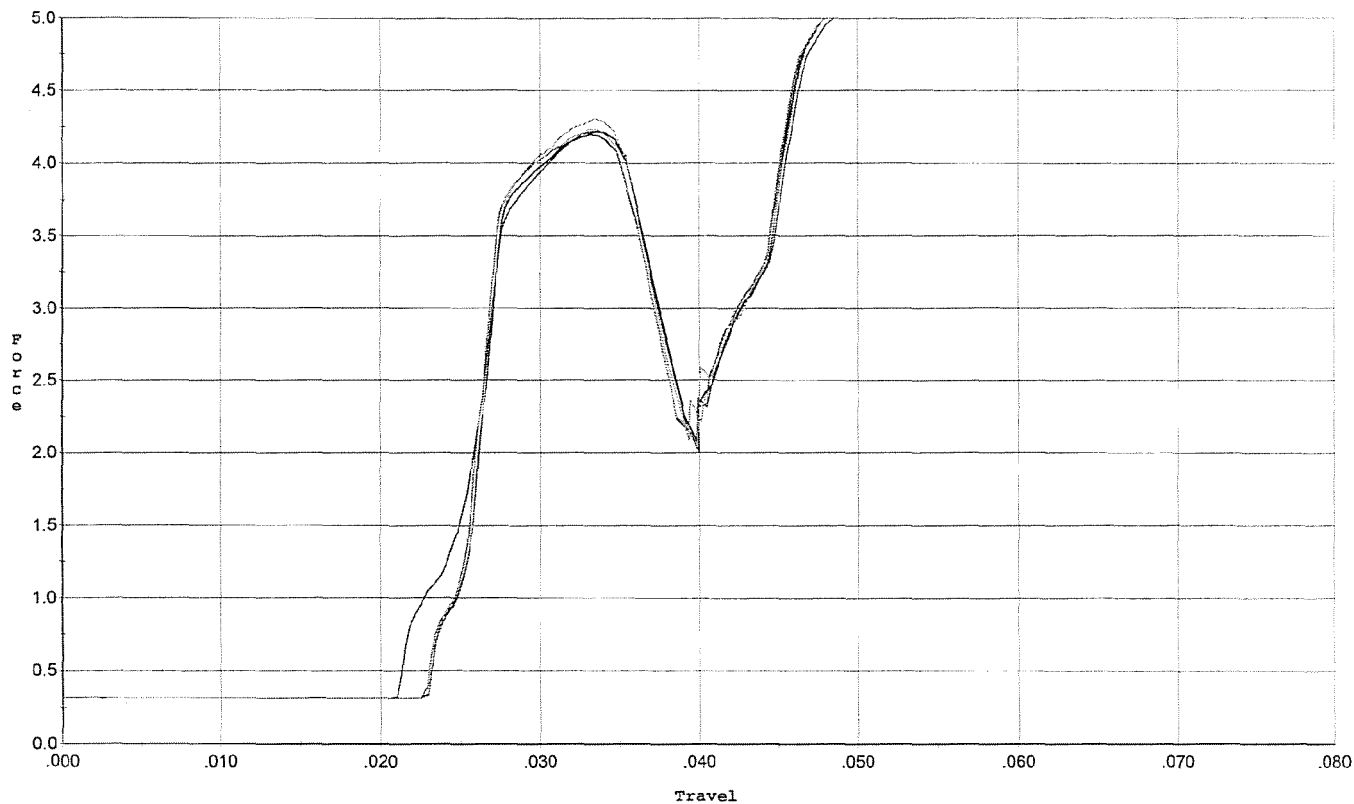
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.310	0.036	0.021	0.023	0.054		Set Trigger
2	4.279	0.037	0.023	0.023	0.054		Set Trigger
3	4.304	0.036	0.023	0.023	0.053		Set Trigger
4	4.320	0.038	0.024	0.023	0.055		Set Trigger
5	4.301	0.036	0.023	0.024	0.052		Set Trigger

A-4-30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/22/2009

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



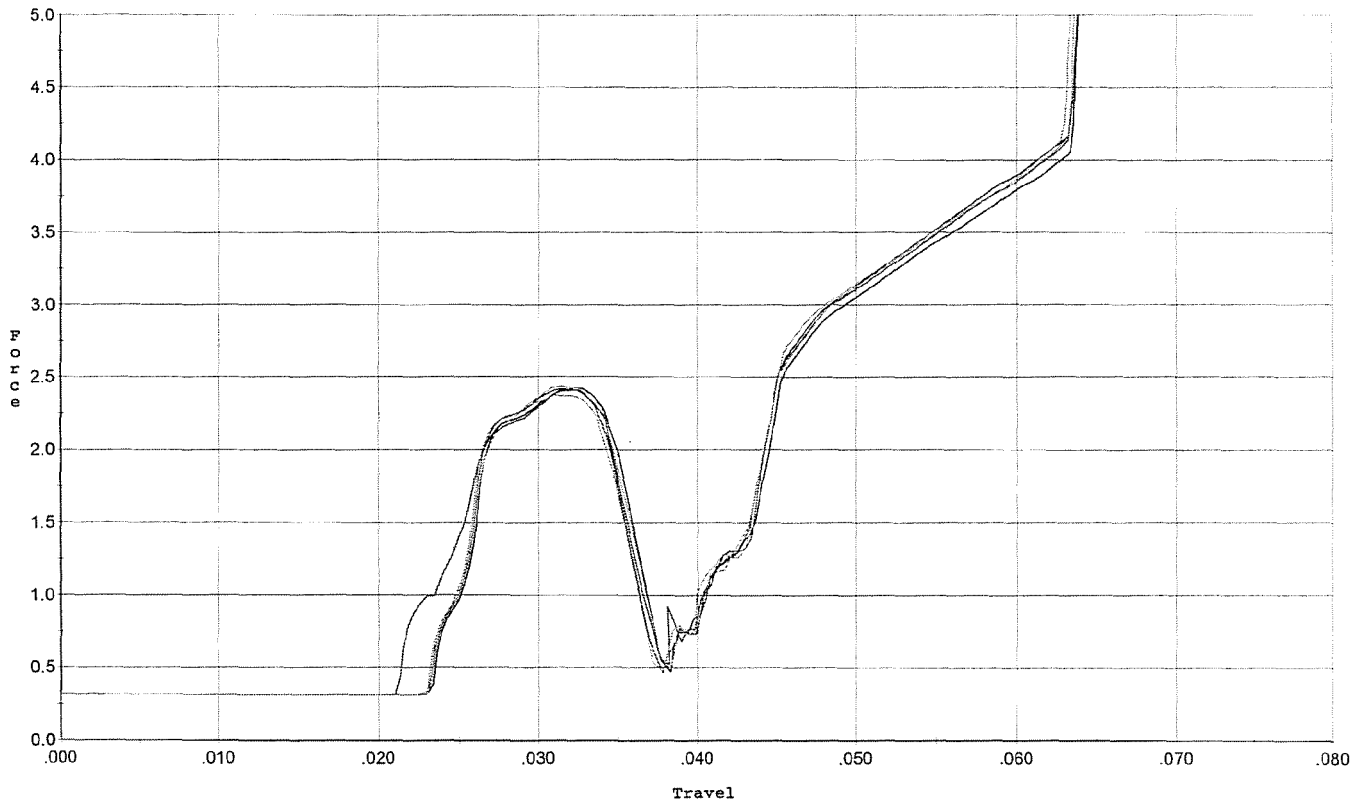
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.220	0.035	0.021	0.023	0.053		Set Trigger
2	4.216	0.035	0.023	0.024	0.051		Set Trigger
3	4.197	0.036	0.023	0.023	0.052		Set Trigger
4	4.233	0.036	0.023	0.023	0.052		Set Trigger
5	4.304	0.035	0.023	0.023	0.051		Set Trigger

A-4.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/22/2009

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



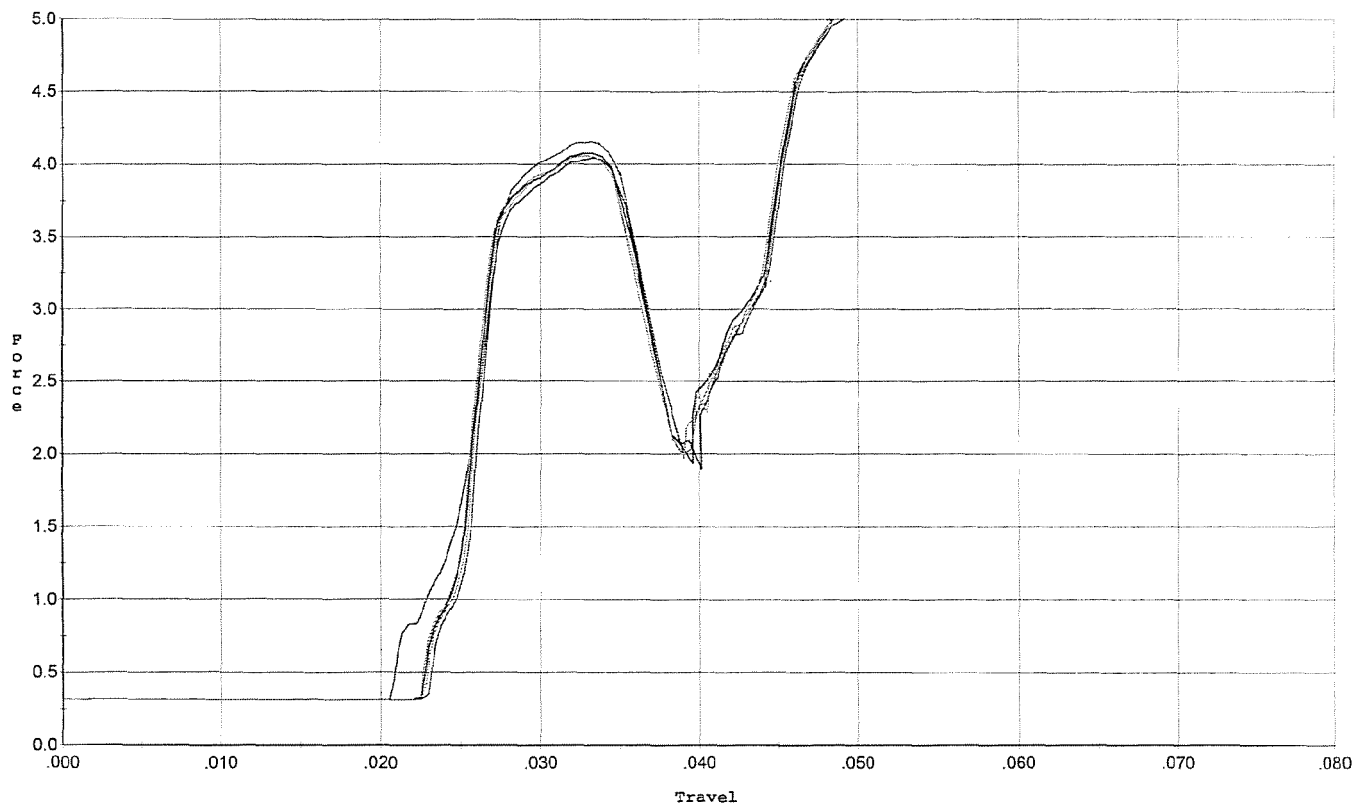
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.411	0.034	0.021	0.032	0.031		Set Trigger
2	2.428	0.035	0.023	0.032	0.031		Set Trigger
3	2.424	0.034	0.023	0.032	0.030		Set Trigger
4	2.435	0.036	0.023	0.032	0.031		Set Trigger
5	2.377	0.035	0.023	0.032	0.030		Set Trigger

A.2.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/22/2009

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	4.041	0.035	0.021	0.025	0.051		Set Trigger
2	4.077	0.036	0.023	0.025	0.050		Set Trigger
3	4.154	0.035	0.023	0.025	0.049		Set Trigger
4	4.064	0.036	0.023	0.025	0.050		Set Trigger
5	4.058	0.035	0.023	0.025	0.048		Set Trigger

A 4.07