

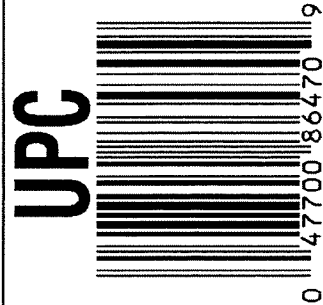
66875784

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



|               |              |
|---------------|--------------|
| ORDER NO.     | <b>86470</b> |
| BARREL LENGTH | 24"          |
| CAPACITY      | 6            |

**G6875784**



BM FORM

GUN SERIAL # G6875784

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                     | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                              | 8-14-09 | SP                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                              | 8-15-09 | SP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                              | 8-14-09 | SP                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA FLUX                                                                                   | 8-14-09 | SP                                                                                  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                              | 8-14-09 | SP                                                                                  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                              | 8-15-09 | KC                                                                                  |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 8/19/09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                              |         |                                                                                     |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                              | 8/19/09 | AWO                                                                                 |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                              | 8-17-09 | SP                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                              | 8/21/09 | MS                                                                                  |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                              | 8/29    | ✓                                                                                   |
| 545  | (BOLT)                                                                                                                                 |                                                                                              |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                              |         |                                                                                     |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                              | 9-1-09  | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                              | 9-1-09  | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO                                                                        | 9-1-09  | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                              | 9-9-09  | L.W.                                                                                |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |                                                                                              |         |                                                                                     |

F004 REV 5/2006

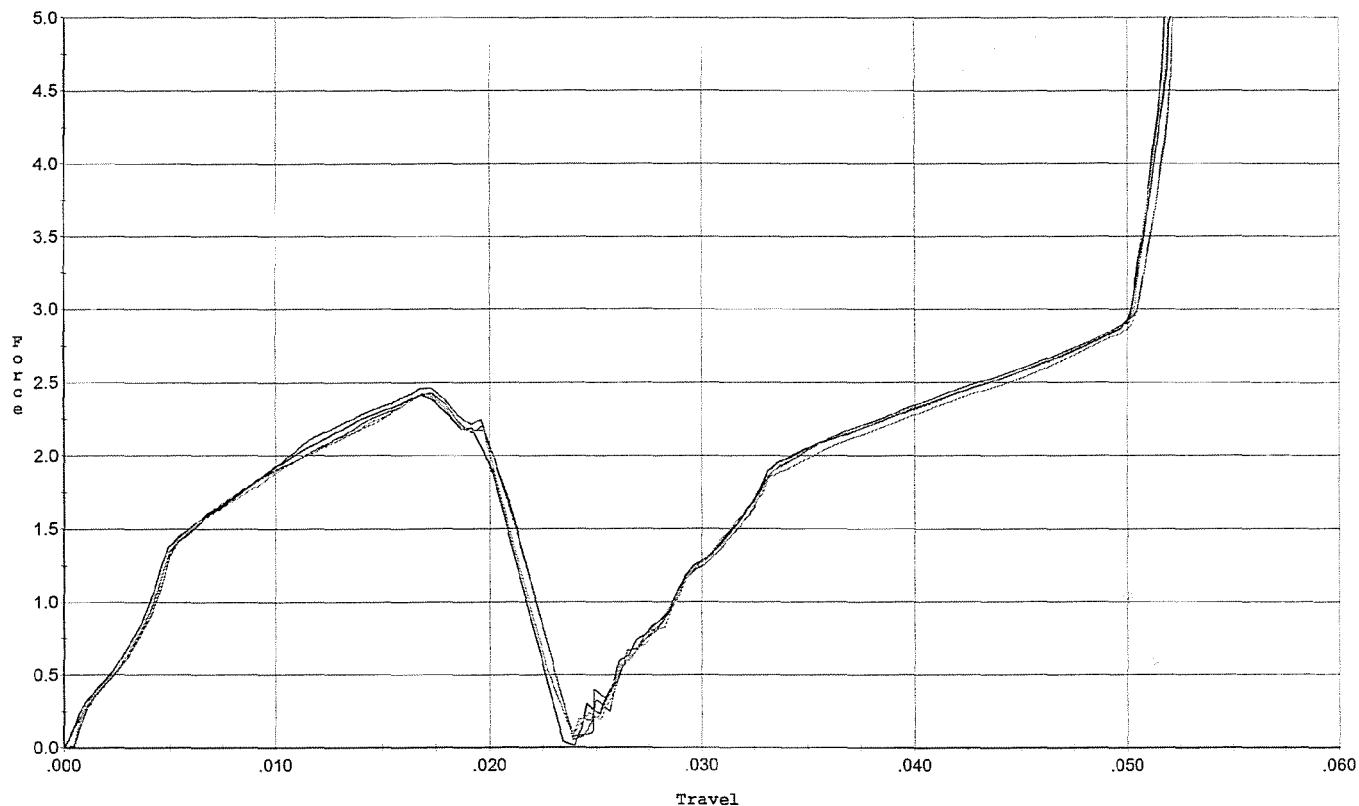
|              |                                                                       |                                           |                                                                |         |        |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|----------------------------------------------------------------|---------|--------|
| 560          | BARBER - M24 0081565<br>F) SAFETY ON FORCE                            | 2 LBS MIN<br>10 LBS MAX                   | <u>2<sup>9</sup></u> <u>2<sup>9</sup></u> <u>2<sup>9</sup></u> | 9/10/07 | RB     |
| CONT.        |                                                                       |                                           |                                                                |         |        |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>6<sup>9</sup></u> <u>6<sup>9</sup></u> <u>6<sup>9</sup></u> | 9/10/07 | RB     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                                |         |        |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> <u>.023</u> <u>.023</u>                            | 9/10/07 | RR     |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                                | 9-9-09  | PH     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                                | 9/10/07 | RB     |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                              |                                           |                                                                |         |        |
|              | M) IRON SIGHT<br>ALIGNMENT                                            |                                           |                                                                |         |        |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER |                                           |                                                                |         |        |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                           |                                           | <u>PASS</u> FAIL<br><u>PASS</u> FAIL                           | 9-9-09  | RP     |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                                |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                | N/A                                                            |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                                |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                                |         |        |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                                | 9-9-09  | S.P.D. |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                                | 9/10/07 | RB     |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.34</u> <u>2.32</u> <u>2.33</u> <u>2.42</u> <u>2.40</u>    | 9/10/07 | RB     |
|              | C) FUNCTION                                                           |                                           |                                                                | 9/10/07 | RB     |
| 690          | PACK                                                                  |                                           |                                                                | 9/11/07 | Fm     |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 9/8/09

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



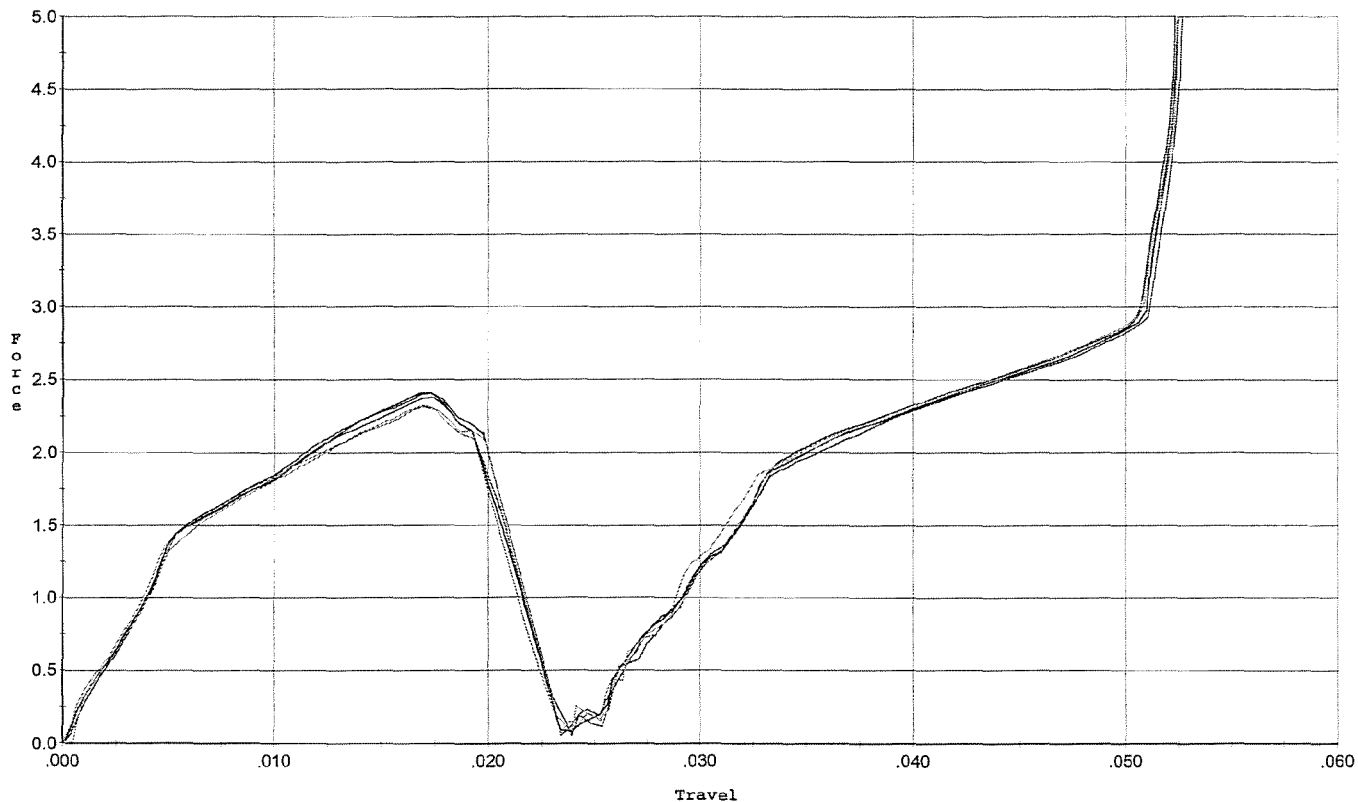
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.460      | 0.021             | 0.00            | 0.035      | 0.034             |           | Set Trigger |
| 2 | 2.415      | 0.020             | 0.00            | 0.035      | 0.032             |           | Set Trigger |
| 3 | 2.429      | 0.021             | 0.00            | 0.035      | 0.033             |           | Set Trigger |
| 4 | 2.415      | 0.020             | 0.00            | 0.035      | 0.031             |           | Set Trigger |
| 5 | 2.427      | 0.020             | 0.00            | 0.036      | 0.031             |           | Set Trigger |

Avg 2.42

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 9/8/09

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



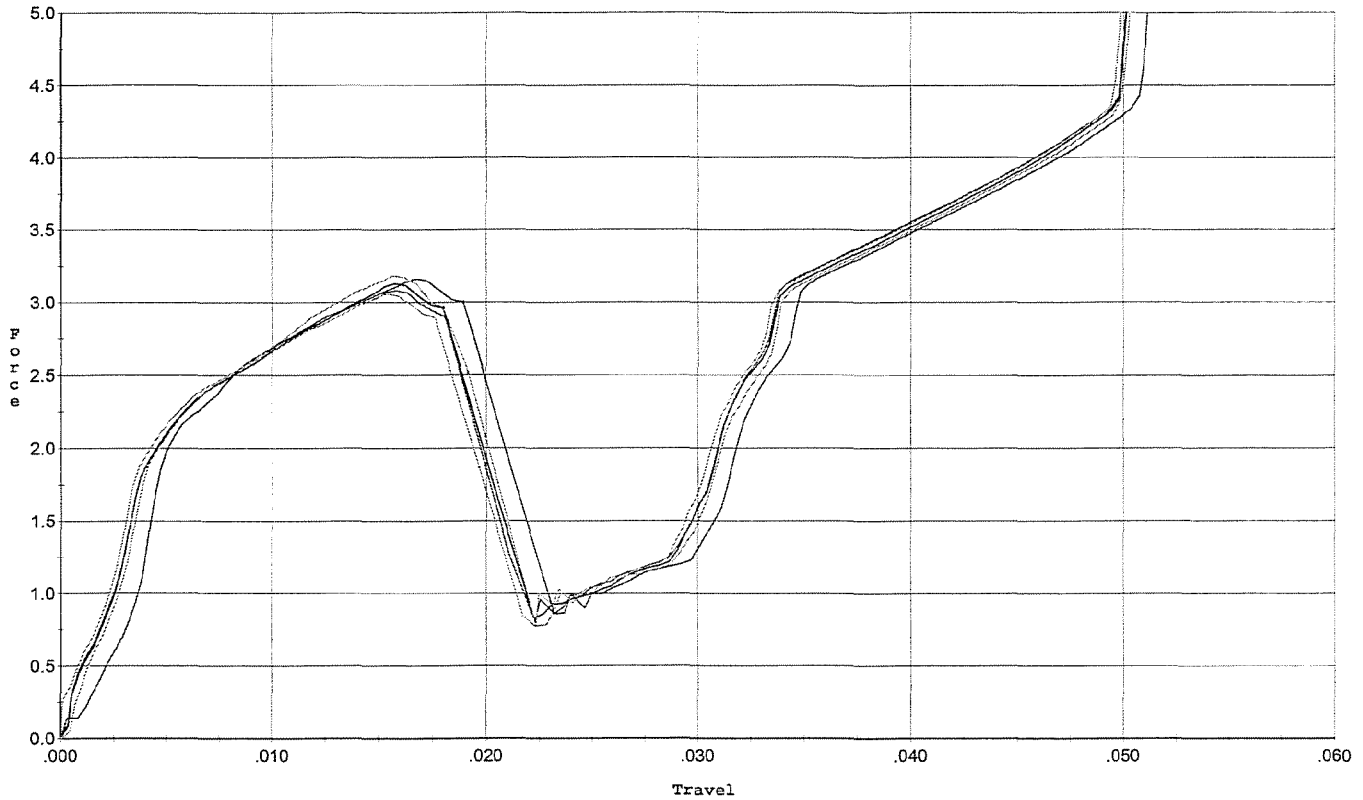
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.408      | 0.020             | 0.00            | 0.036      | 0.032             |           | Set Trigger |
| 2 | 2.411      | 0.021             | 0.00            | 0.036      | 0.033             |           | Set Trigger |
| 3 | 2.380      | 0.021             | 0.00            | 0.036      | 0.032             |           | Set Trigger |
| 4 | 2.327      | 0.020             | 0.00            | 0.036      | 0.031             |           | Set Trigger |
| 5 | 2.318      | 0.019             | 0.00            | 0.036      | 0.030             |           | Set Trigger |

Avg 2.36

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 9/8/09

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



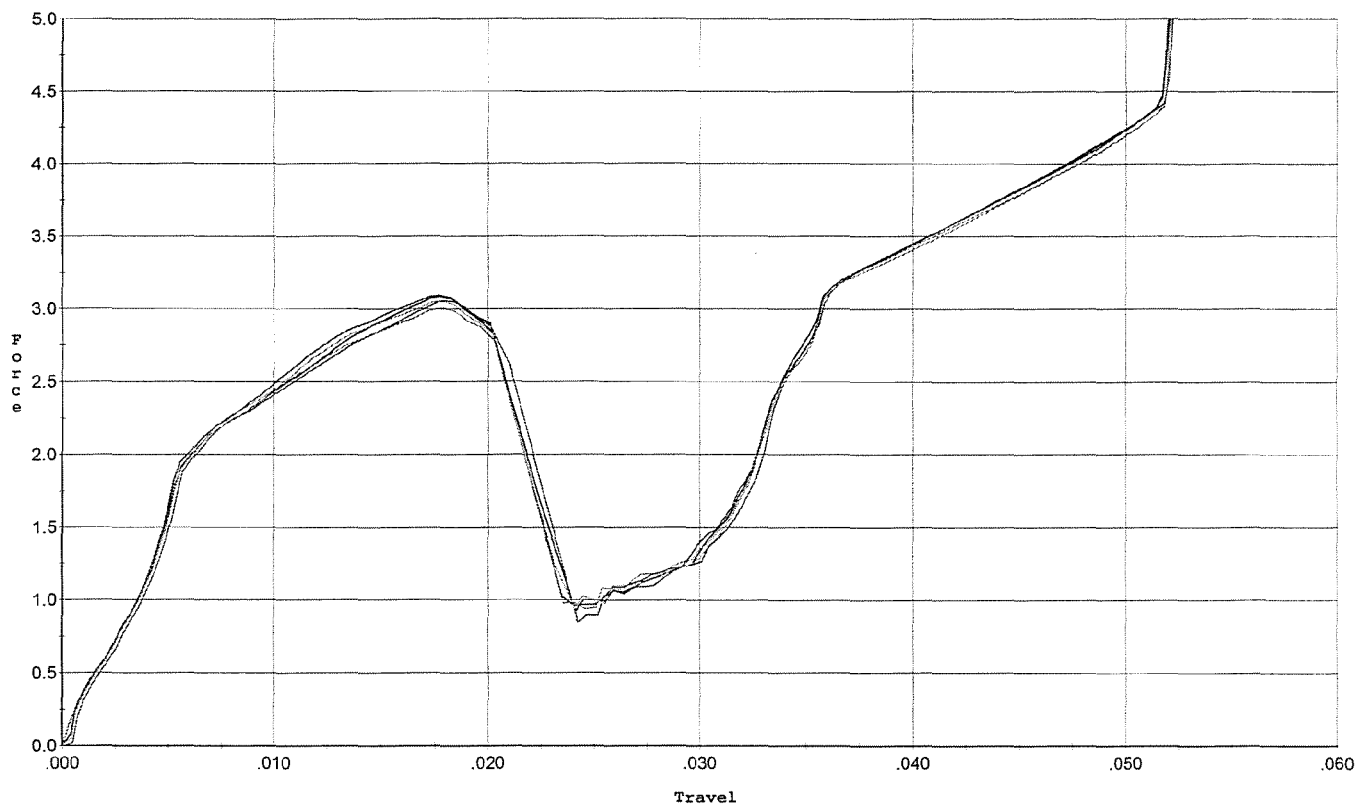
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.161      | 0.019             | 0.00            | 0.034      | 0.040             |           | Set Trigger |
| 2 | 3.130      | 0.018             | 0.00            | 0.033      | 0.039             |           | Set Trigger |
| 3 | 3.081      | 0.018             | 0.00            | 0.033      | 0.039             |           | Set Trigger |
| 4 | 3.058      | 0.020             | 0.00            | 0.033      | 0.042             |           | Set Trigger |
| 5 | 3.184      | 0.019             | 0.00            | 0.033      | 0.042             |           | Set Trigger |

Avg 3.12

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 9/8/09

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



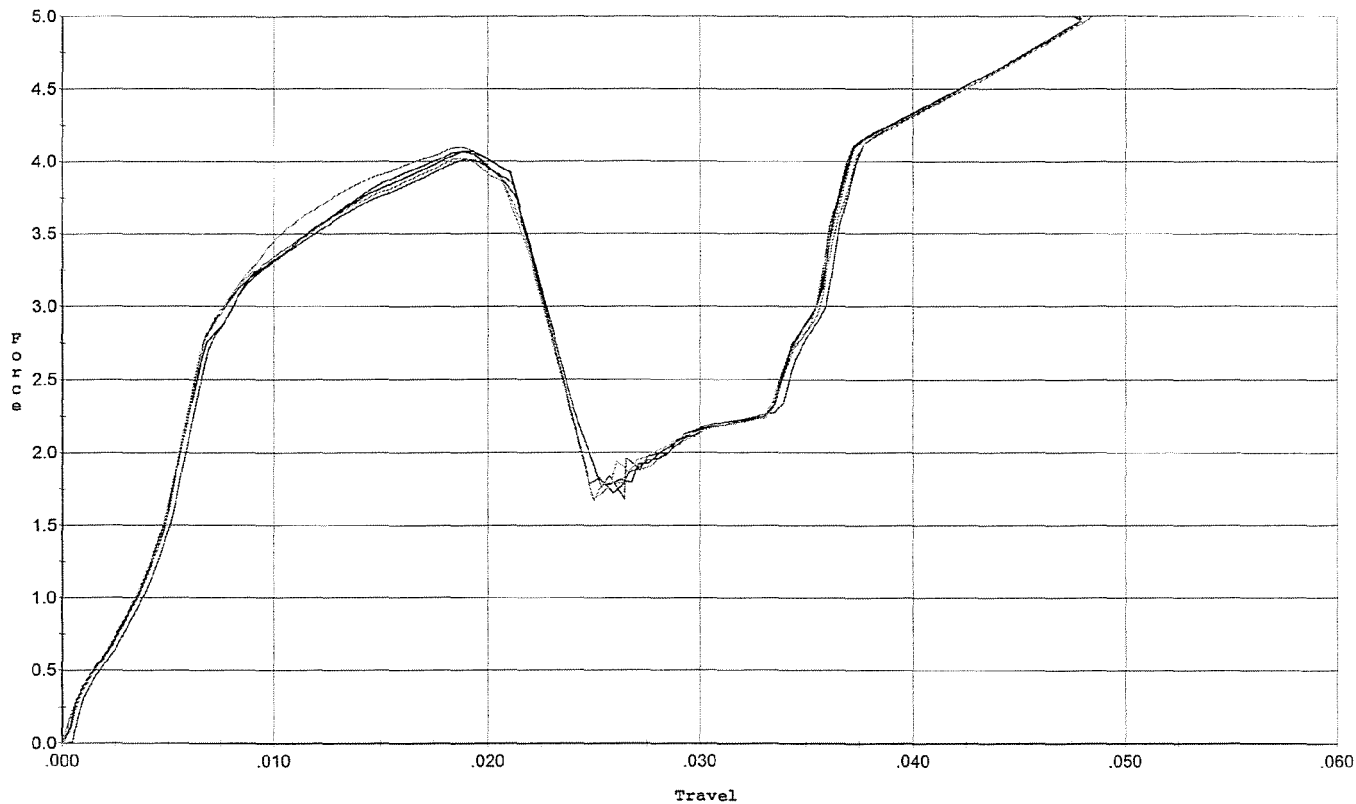
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.090      | 0.020             | 0.00            | 0.033      | 0.042             |           | Set Trigger |
| 2 | 3.083      | 0.020             | 0.00            | 0.033      | 0.041             |           | Set Trigger |
| 3 | 3.054      | 0.021             | 0.00            | 0.033      | 0.043             |           | Set Trigger |
| 4 | 3.048      | 0.020             | 0.00            | 0.034      | 0.041             |           | Set Trigger |
| 5 | 3.007      | 0.020             | 0.00            | 0.033      | 0.041             |           | Set Trigger |

Avg 3.05

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 9/8/09

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



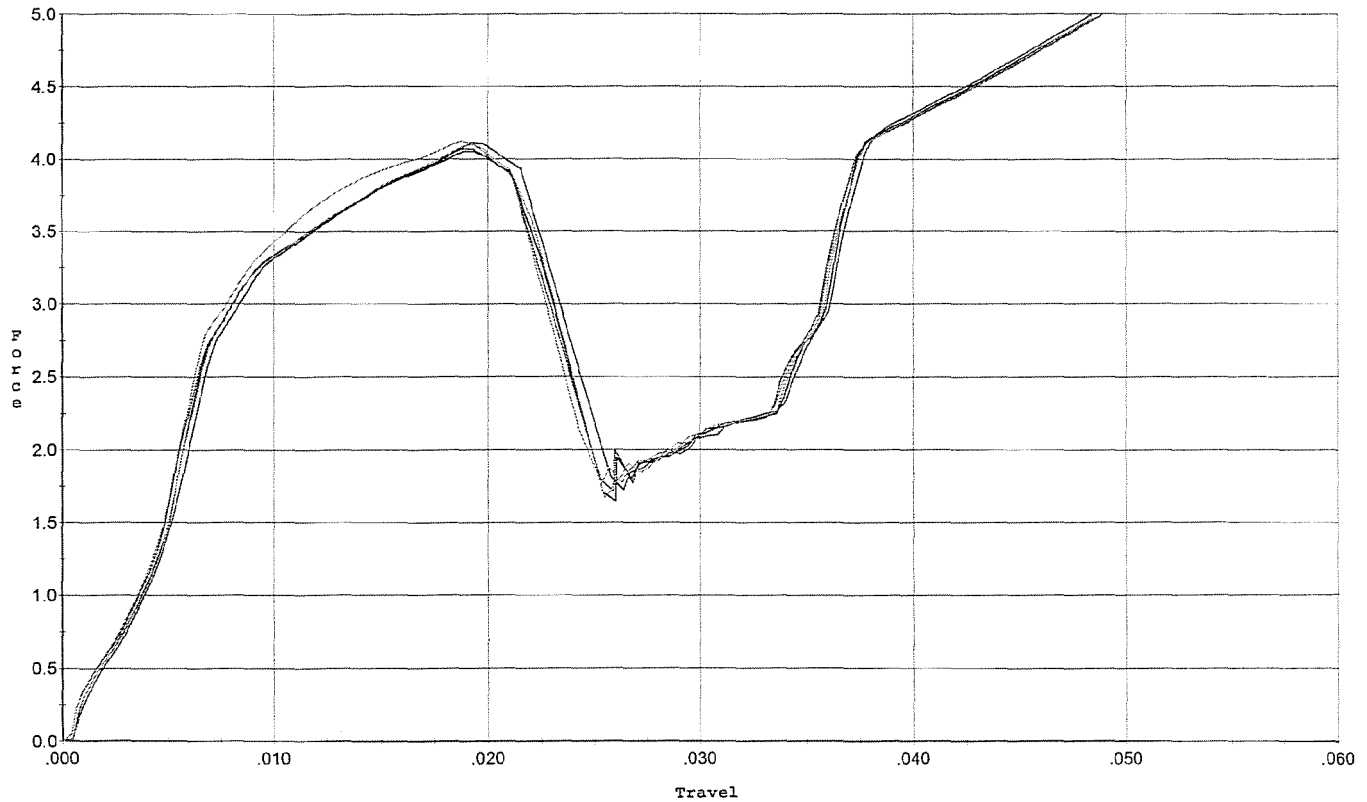
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.068      | 0.021             | 0.00            | 0.032      | 0.057             |           | Set Trigger |
| 2 | 4.069      | 0.021             | 0.00            | 0.032      | 0.056             |           | Set Trigger |
| 3 | 4.012      | 0.021             | 0.00            | 0.032      | 0.055             |           | Set Trigger |
| 4 | 4.020      | 0.022             | 0.00            | 0.031      | 0.058             |           | Set Trigger |
| 5 | 4.098      | 0.022             | 0.00            | 0.032      | 0.058             |           | Set Trigger |

Avg 4.05

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 9/8/09

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



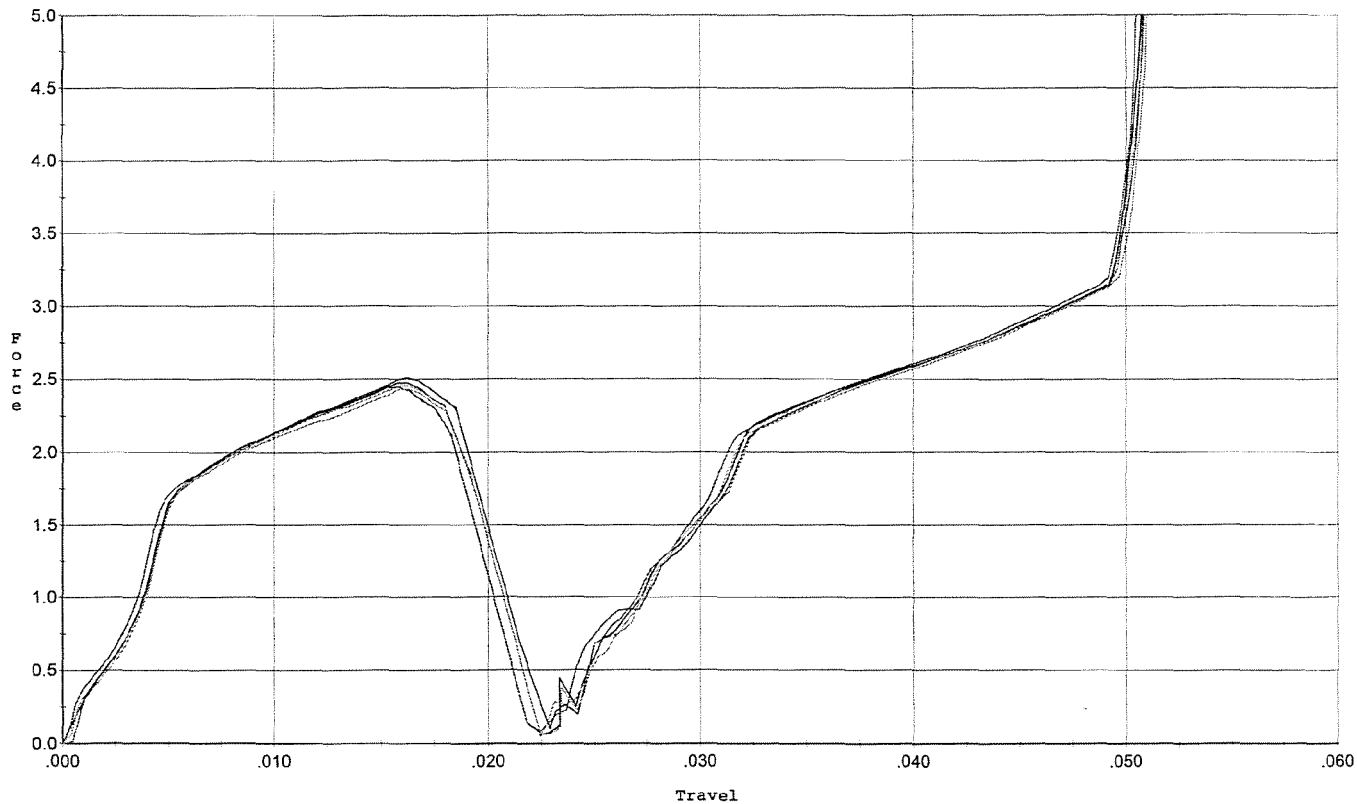
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.114      | 0.022             | 0.00            | 0.032      | 0.057             |           | Set Trigger |
| 2 | 4.053      | 0.022             | 0.00            | 0.031      | 0.060             |           | Set Trigger |
| 3 | 4.071      | 0.021             | 0.00            | 0.032      | 0.056             |           | Set Trigger |
| 4 | 4.097      | 0.022             | 0.00            | 0.031      | 0.059             |           | Set Trigger |
| 5 | 4.123      | 0.021             | 0.00            | 0.032      | 0.057             |           | Set Trigger |

Avg 4.09

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 9/8/09

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



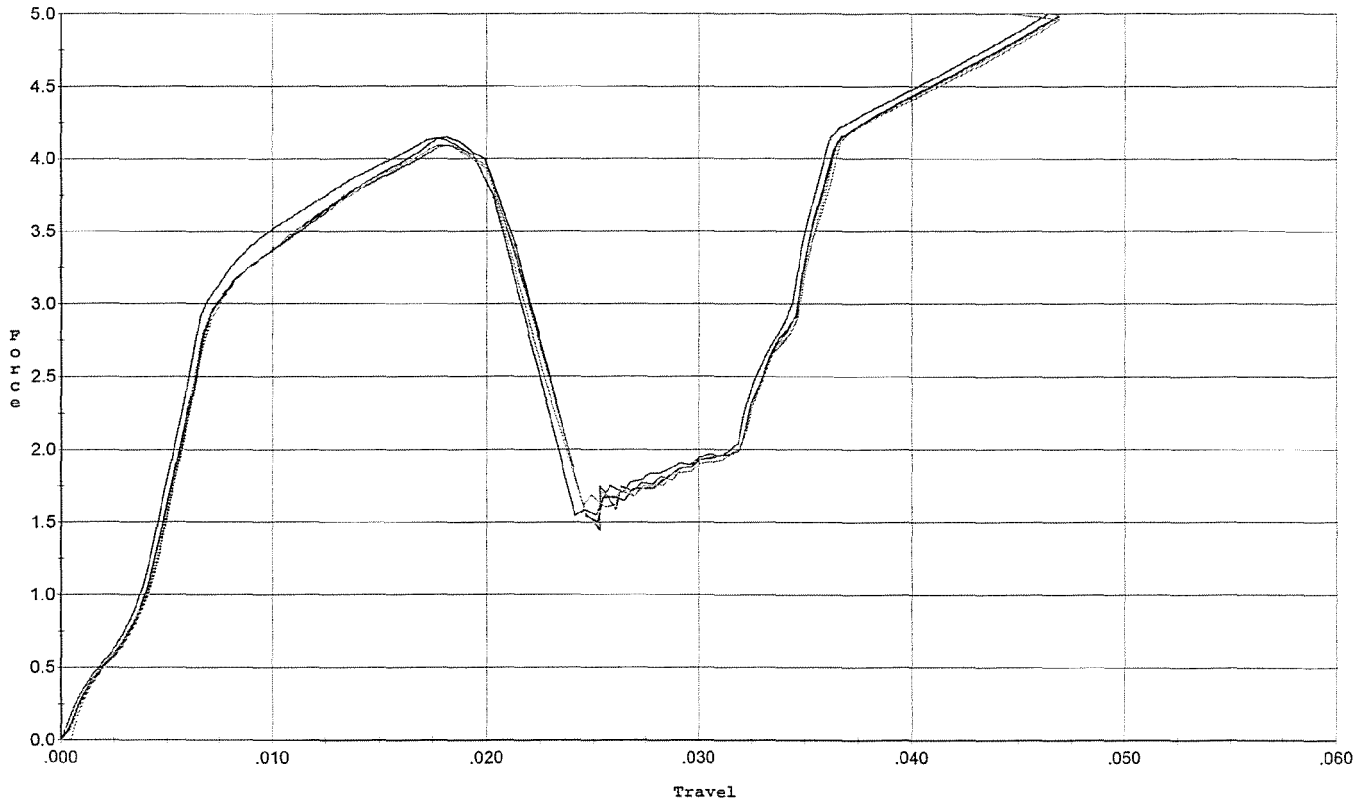
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.510      | 0.018             | 0.00            | 0.035      | 0.032             |           | Set Trigger |
| 2 | 2.475      | 0.019             | 0.00            | 0.035      | 0.033             |           | Set Trigger |
| 3 | 2.448      | 0.018             | 0.00            | 0.035      | 0.031             |           | Set Trigger |
| 4 | 2.434      | 0.019             | 0.00            | 0.035      | 0.032             |           | Set Trigger |
| 5 | 2.457      | 0.019             | 0.00            | 0.035      | 0.032             |           | Set Trigger |

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## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 9/8/09

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 | 4.144      | 0.020             | 0.00            | 0.032      | 0.055             |           | Set Trigger |
| 2 | 4.150      | 0.021             | 0.00            | 0.032      | 0.057             |           | Set Trigger |
| 3 | 4.089      | 0.022             | 0.00            | 0.031      | 0.057             |           | Set Trigger |
| 4 | 4.088      | 0.022             | 0.00            | 0.032      | 0.057             |           | Set Trigger |
| 5 | 4.093      | 0.020             | 0.00            | 0.032      | 0.053             |           | Set Trigger |

Avg 4.11