

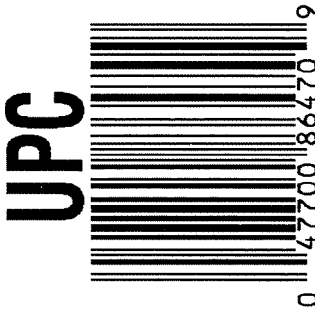
66863557

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

G6863557



BM FORM

GUN SERIAL # G 6863557

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-27-09	SP
430	ASSEMBLE TO STOCK		5-27-09	SP
440	PROOF		5-27-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5-27-09	SP
470	DIS-ASSEMBLE ACTION		5-27-09	SP
472	SERIALIZE BOLT HANDLE		5-28-09	RJZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	5-30-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-1-09	RT
510	DRILL AND TAP SIGHT HOLES		5-28-09	SP
520	GOFF BLAST BBL / REC		6-1-09	DLW
540	APPLY COATINGS (BARREL ACTION)		6-1-09	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-15-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-15-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-15-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-25-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

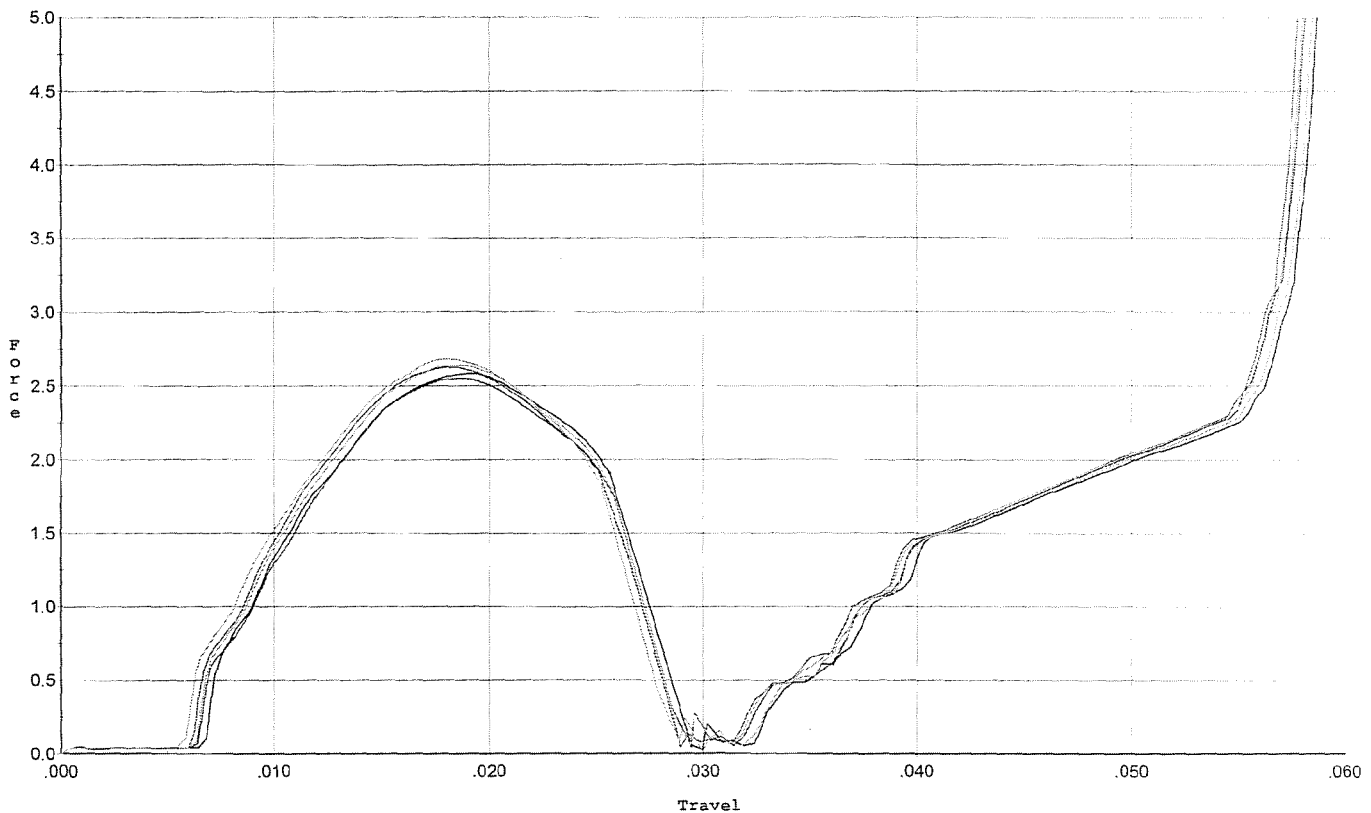
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7°</u> <u>7°</u> <u>7°</u>	7-28-09	RN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6°</u> <u>6°</u> <u>6°</u>	7-28-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	7-28-09	RN
	J) ASSEMBLE STOCK		6-25-09	RN
	K) ASSEMBLE SWIVEL STUDS		7-28-09	RN
	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	PASS FAIL PASS FAIL	7/24	AR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/24	TAR
670	FINAL INSPECTION A) HEADSPACE		7-28-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.28</u> <u>2.35</u> <u>2.41</u> <u>2.28</u>	7-27-09	RN
	C) FUNCTION		7-28-09	RN
690	PACK		8/4/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



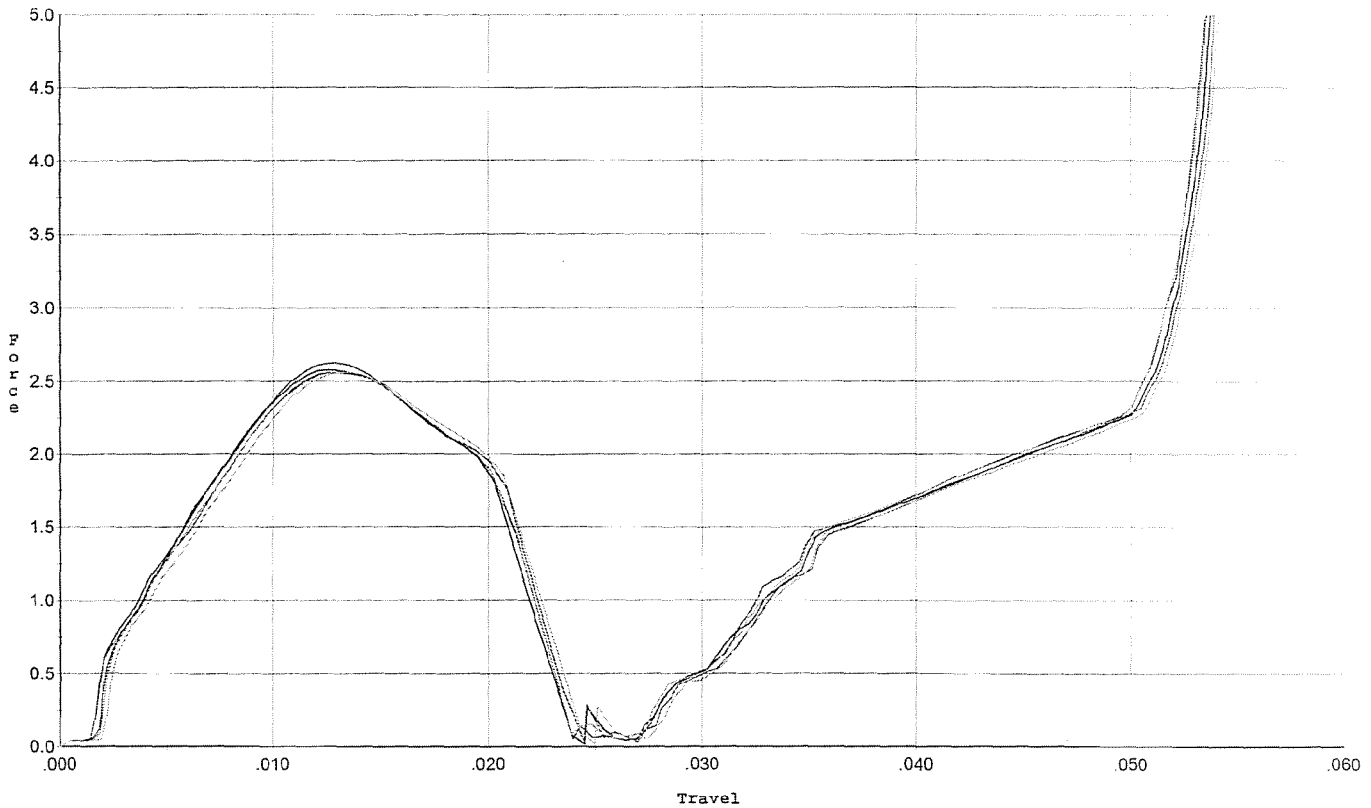
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.553	0.026	0.007	0.038	0.037		Set Trigger
2	2.583	0.026	0.007	0.038	0.037		Set Trigger
3	2.625	0.026	0.006	0.037	0.039		Set Trigger
4	2.642	0.026	0.007	0.038	0.038		Set Trigger
5	2.683	0.025	0.006	0.038	0.038		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



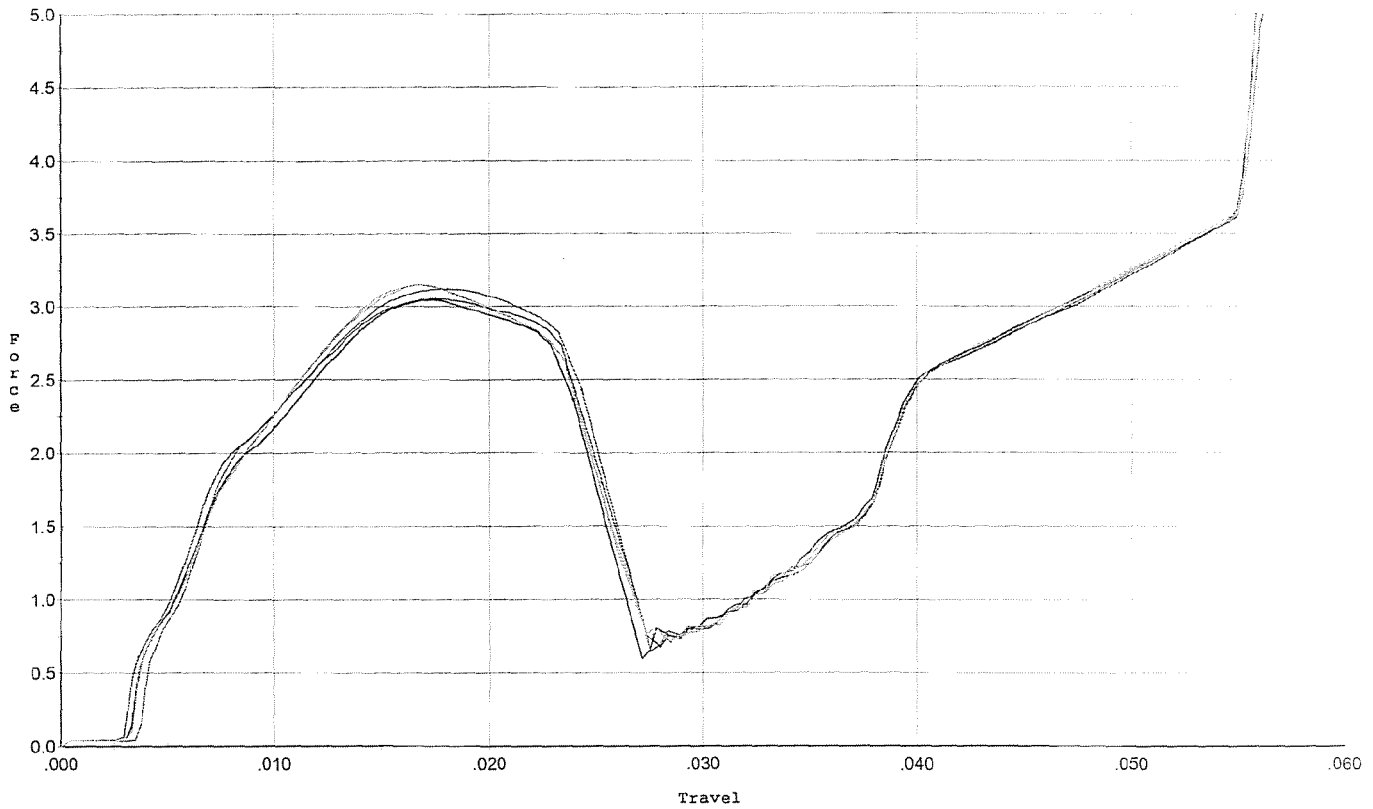
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.623	0.021	0.002	0.038	0.036		Set Trigger
2	2.574	0.020	0.00	0.038	0.035		Set Trigger
3	2.558	0.021	0.00	0.038	0.035		Set Trigger
4	2.559	0.021	0.002	0.038	0.034		Set Trigger
5	2.563	0.021	0.002	0.038	0.036		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



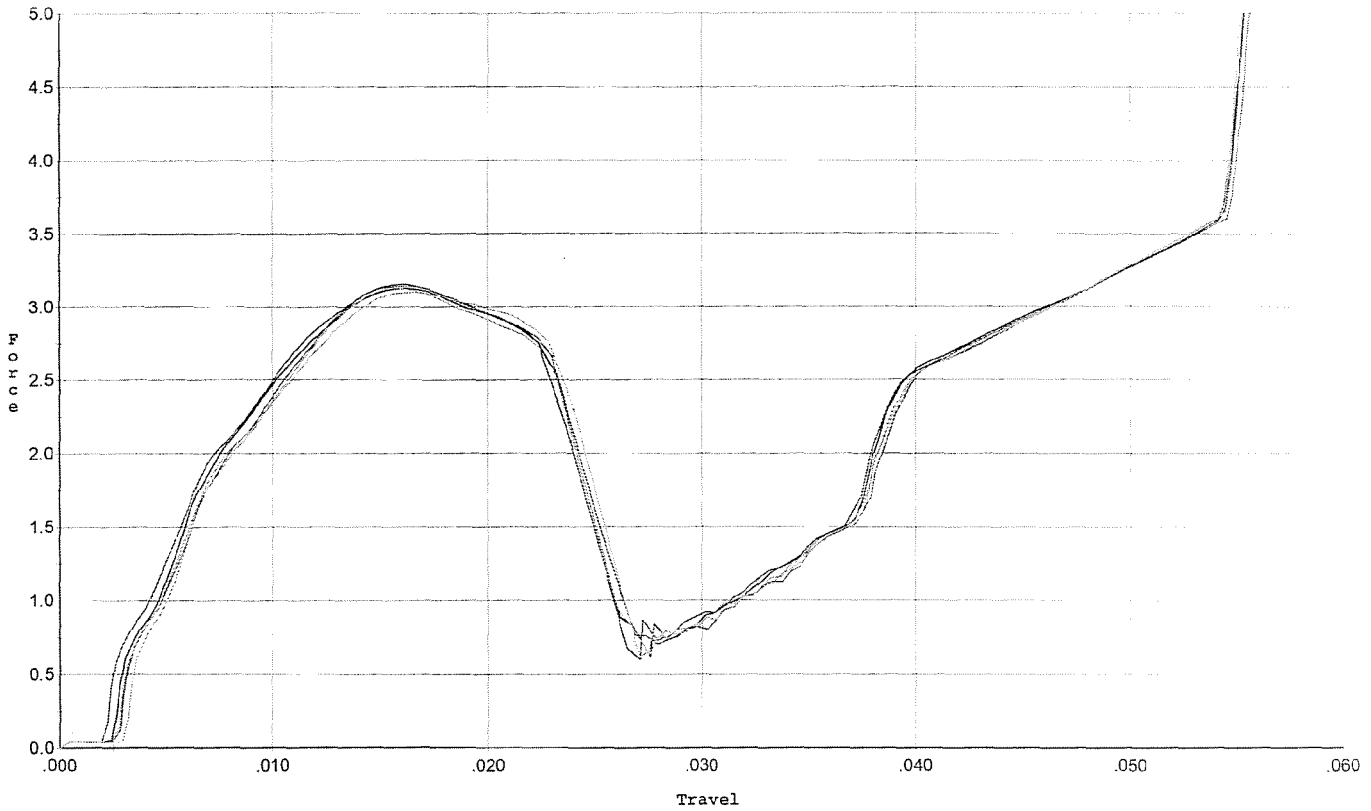
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.025	0.003	0.036	0.050		Set Trigger
2	3.049	0.024	0.003	0.036	0.046		Set Trigger
3	3.120	0.024	0.004	0.036	0.048		Set Trigger
4	3.150	0.023	0.003	0.036	0.047		Set Trigger
5	3.150	0.024	0.003	0.036	0.047		Set Trigger

Aug 3.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



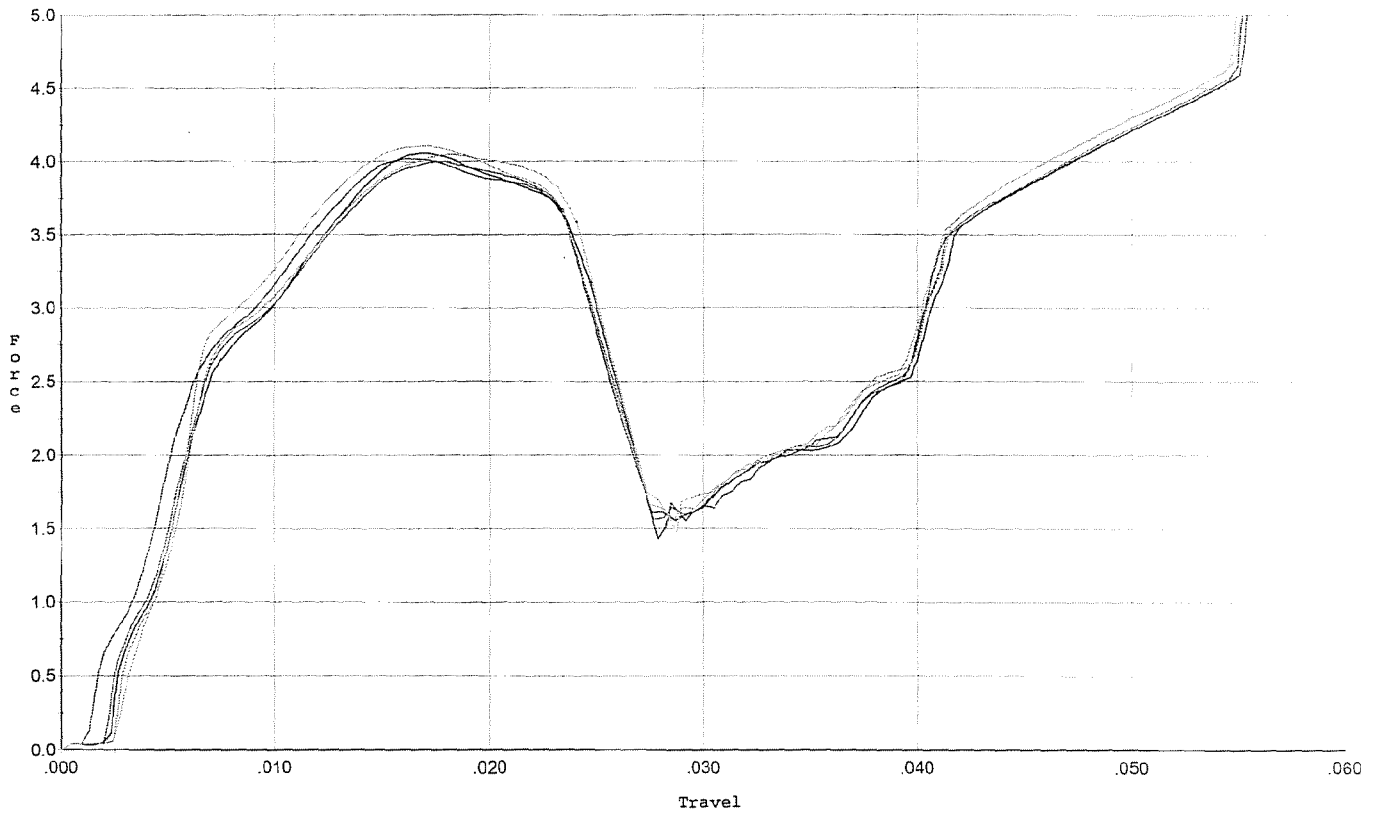
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.024	0.002	0.036	0.050		Set Trigger
2	3.126	0.023	0.003	0.036	0.047		Set Trigger
3	3.141	0.023	0.003	0.036	0.047		Set Trigger
4	3.096	0.024	0.003	0.035	0.048		Set Trigger
5	3.123	0.023	0.003	0.036	0.047		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



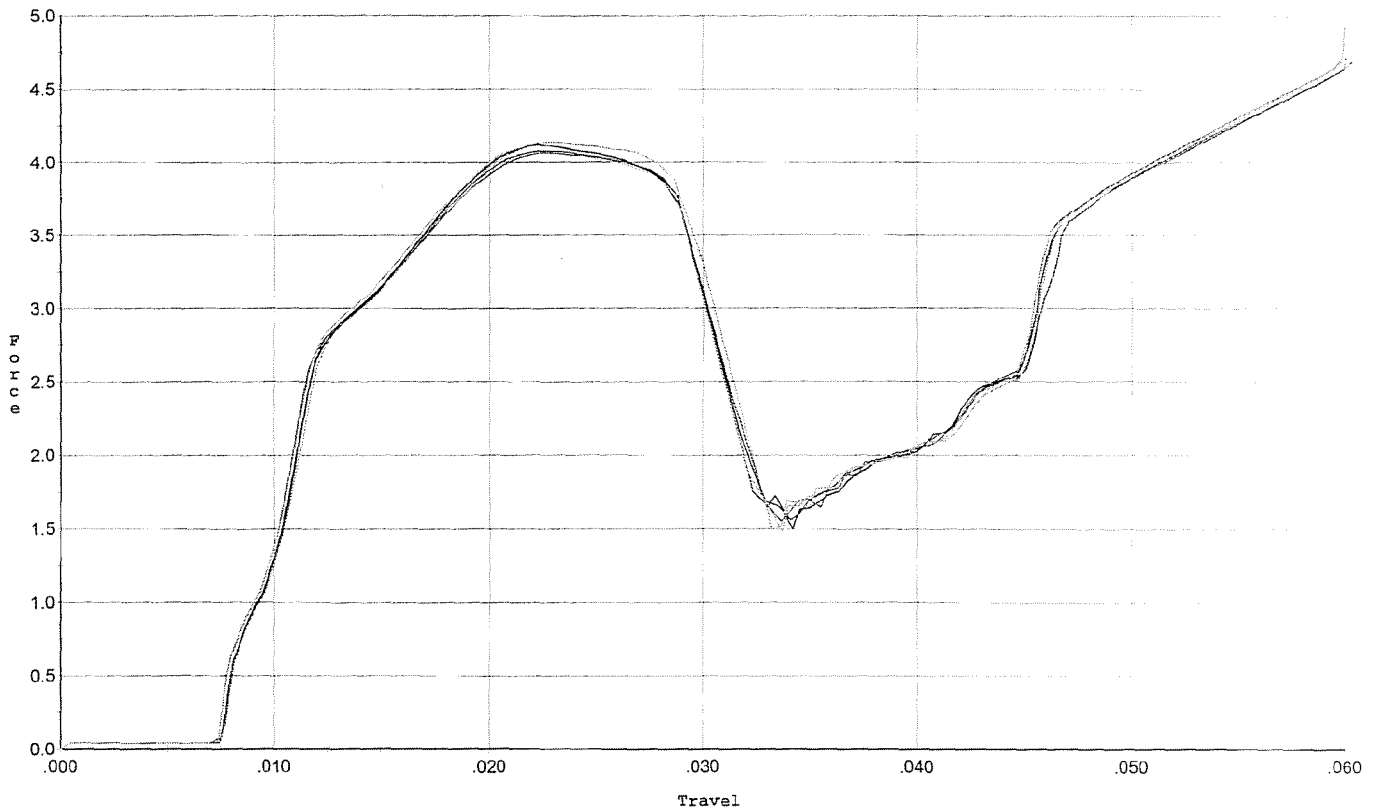
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.018	0.024	0.00	0.033	0.064		Set Trigger
2	4.056	0.025	0.002	0.033	0.065		Set Trigger
3	3.998	0.025	0.002	0.033	0.068		Set Trigger
4	4.104	0.023	0.003	0.033	0.064		Set Trigger
5	4.045	0.024	0.003	0.033	0.064		Set Trigger

Aug 4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



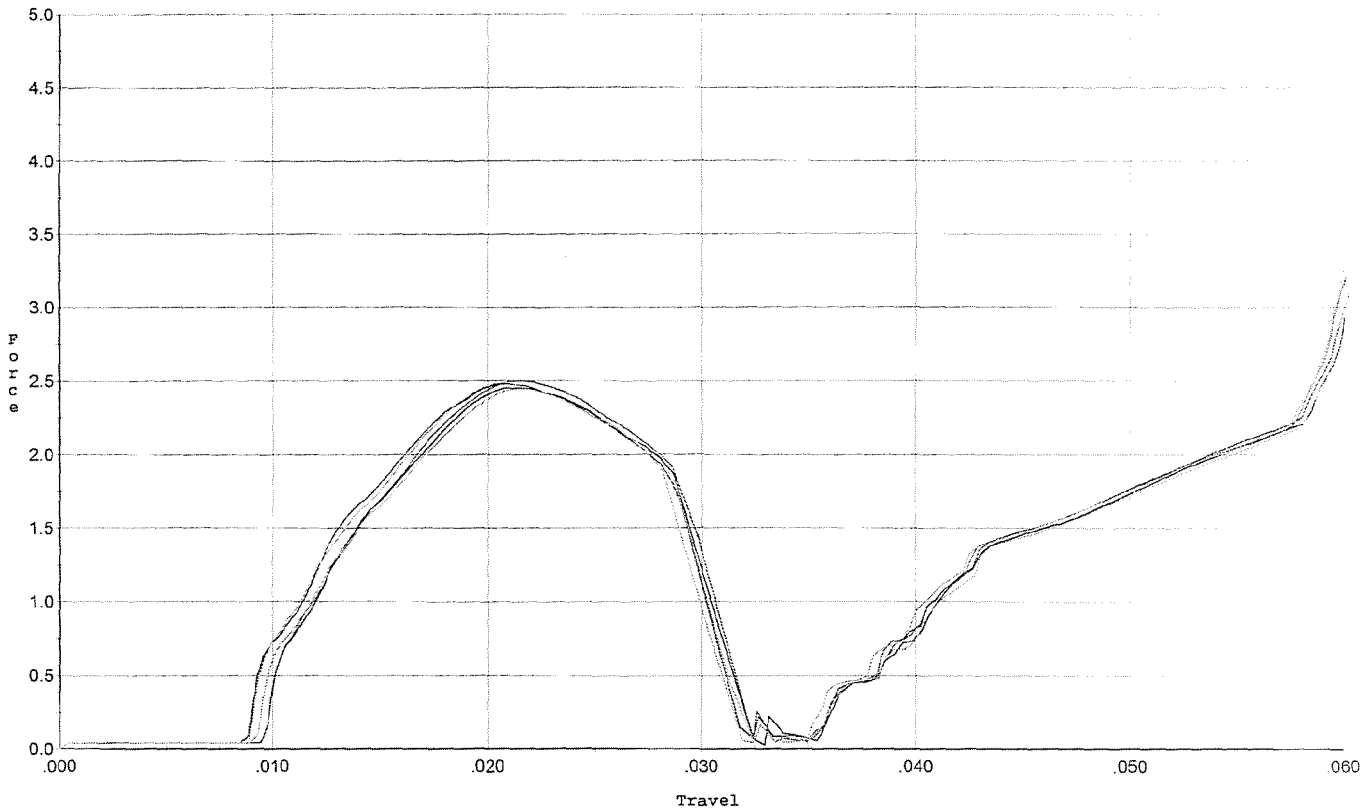
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.077	0.029	0.008	0.033	0.066		Set Trigger
2	4.120	0.029	0.008	0.033	0.067		Set Trigger
3	4.065	0.029	0.008	0.033	0.067		Set Trigger
4	4.115	0.029	0.008	0.033	0.068		Set Trigger
5	4.139	0.030	0.008	0.030	0.070		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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



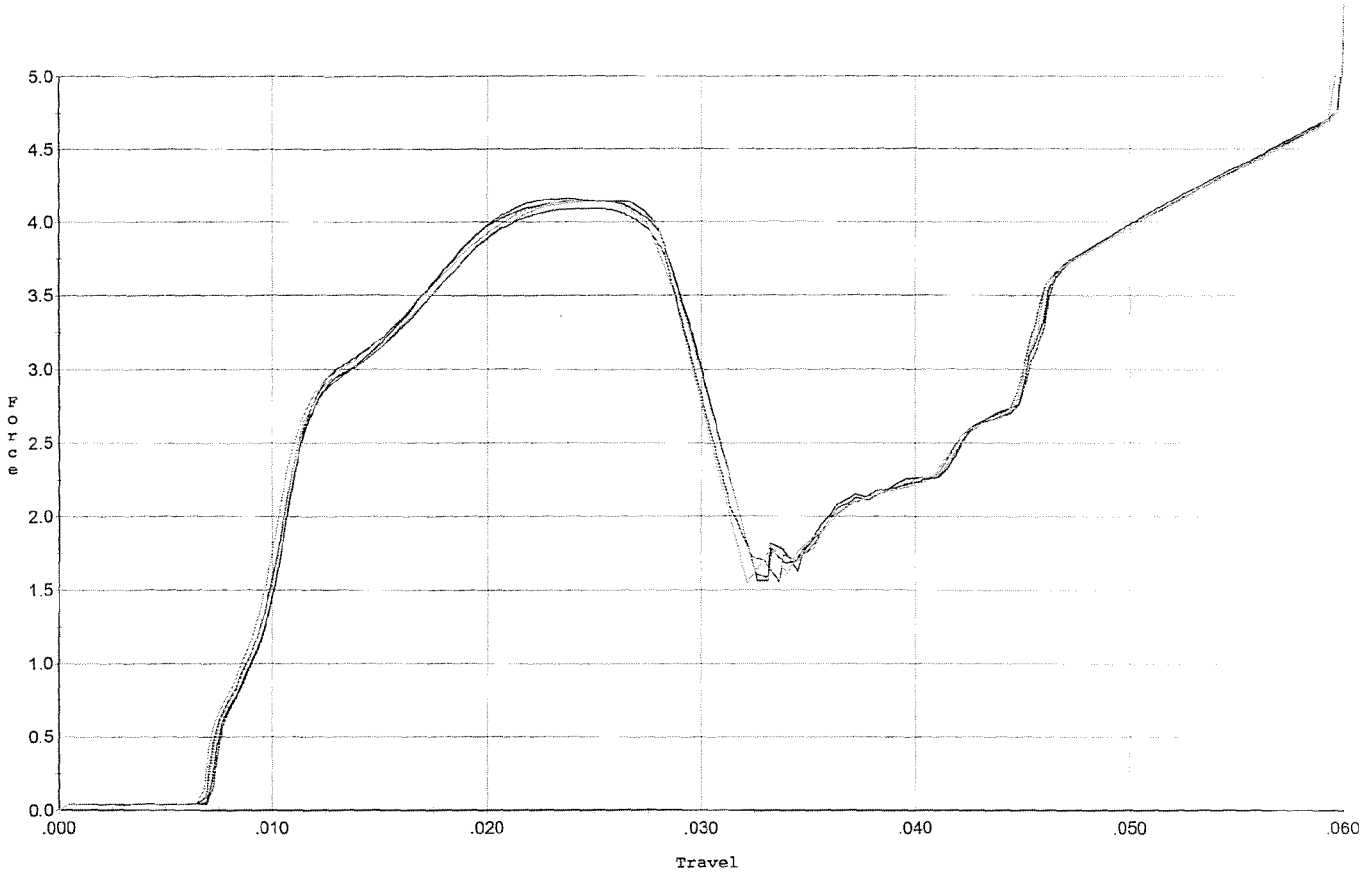
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.478	0.029	0.009	0.039	0.038		Set Trigger
2	2.453	0.029	0.010	0.039	0.036		Set Trigger
3	2.500	0.030	0.010	0.038	0.038		Set Trigger
4	2.446	0.029	0.009	0.039	0.036		Set Trigger
5	2.483	0.028	0.009	0.039	0.036		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/22/09

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	4.164	0.030	0.007	0.033	0.070		Set Trigger
2	4.147	0.030	0.007	0.033	0.070		Set Trigger
3	4.090	0.028	0.007	0.033	0.066		Set Trigger
4	4.147	0.029	0.007	0.033	0.068		Set Trigger
5	4.147	0.030	0.007	0.033	0.070		Set Trigger

Avg 4.13