

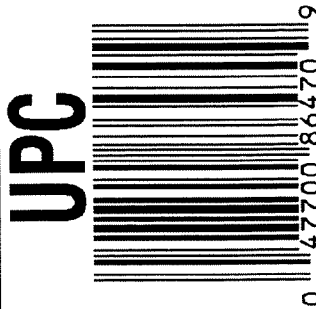
66868450

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

G6868450



BM FORM

GUN SERIAL # G 6868450

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-09	SPD
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	7-28-09	SPD
470	DIS-ASSEMBLE ACTION		7-28-09	SPD
472	SERIALIZE BOLT HANDLE		7-29-09	SP
480	MAGNAFLUX BBL ACTION	OPERATION	7/31/09	(SP)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	DWS
510	DRILL AND TAP SIGHT HOLES		7-29-09	SP
520	GOFF BLAST BBL / REC		7/31/09	SP
540	APPLY COATINGS (BARREL ACTION)		8/1/09	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-18-09	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		8-24-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

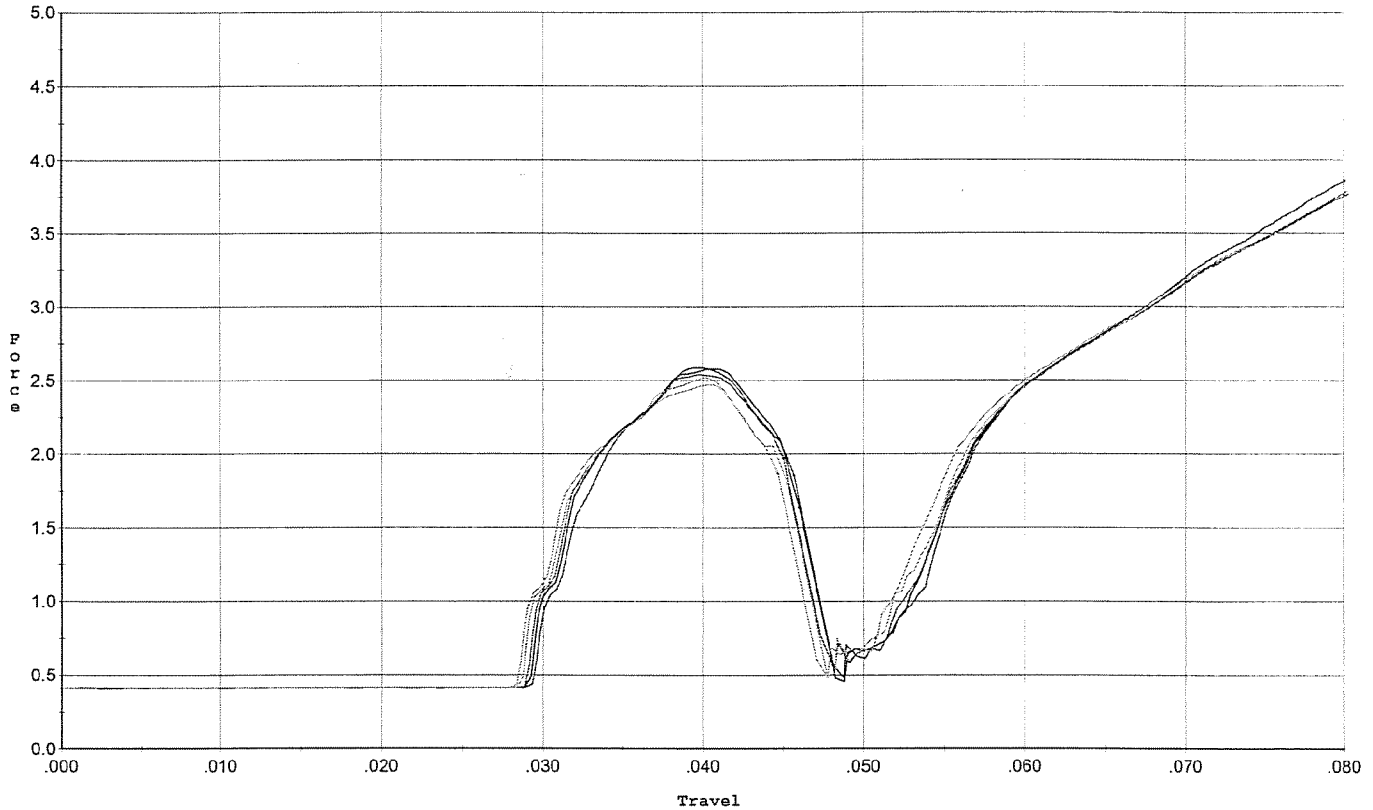
560	BARBER - M24 0094791 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	8/27/09	RB
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	8/27/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>023</u> <u>023</u> <u>023</u>	8/27/09	RB
	J) ASSEMBLE STOCK			8-24-09	S.P.A.
	K) ASSEMBLE SWIVEL STUDS			8/27/09	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		PASS FAIL PASS FAIL	8/26/09	RB
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			8/26/09	TAR
670	FINAL INSPECTION A) HEADSPACE			8/27/09	RB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.61</u> <u>2.62</u> <u>2.43</u> <u>2.39</u>	8/27/09	RB
	C) FUNCTION			8/27/09	RB
690	PACK			8-27-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



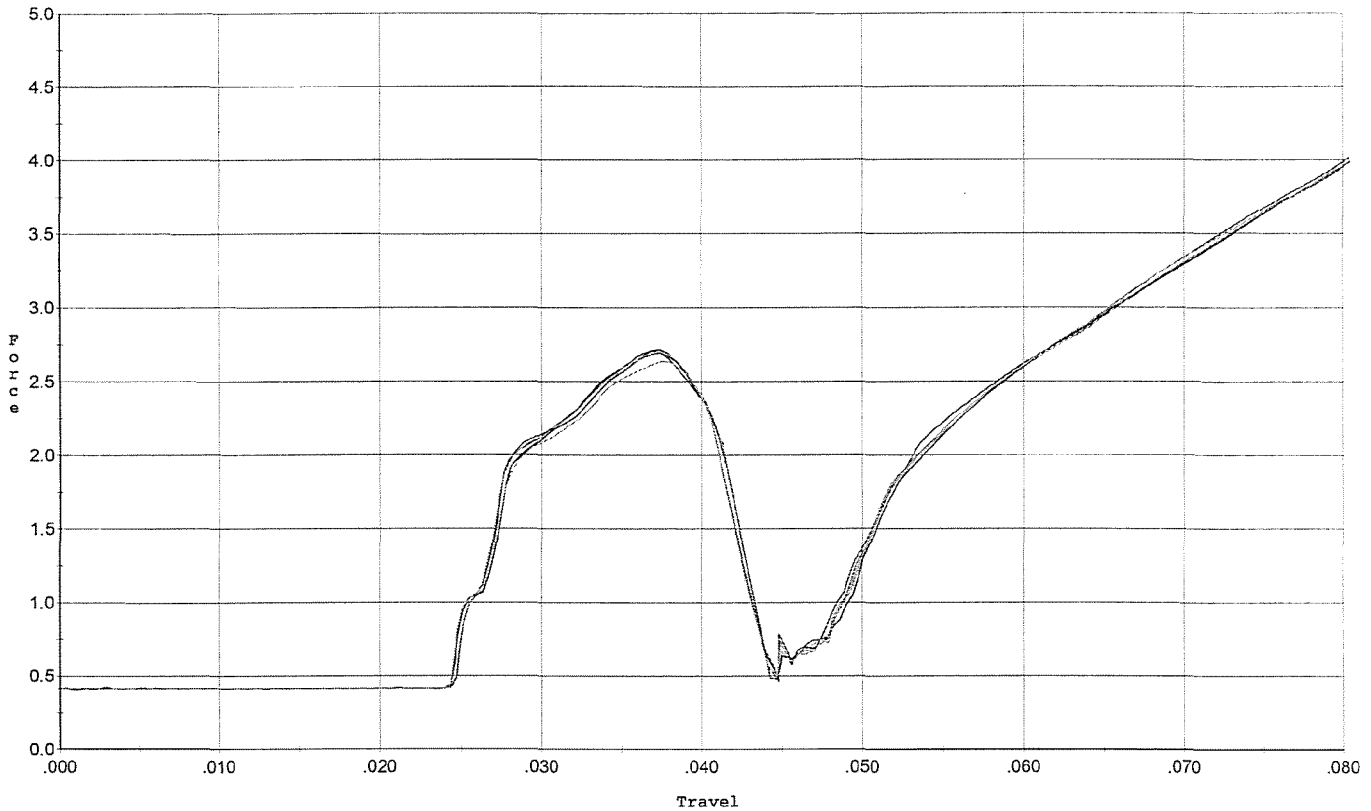
#	Peak Force	Travel To Actuate	Initial Take-up	Overtavel	Energy To Actuate	Lock Time	Action Type
1	2.587	0.046	0.030	0.060	0.046		Set Trigger
2	2.580	0.046	0.029	0.061	0.047		Set Trigger
3	2.540	0.045	0.029	0.061	0.046		Set Trigger
4	2.471	0.045	0.029	0.061	0.045		Set Trigger
5	2.520	0.045	0.029	0.061	0.045		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



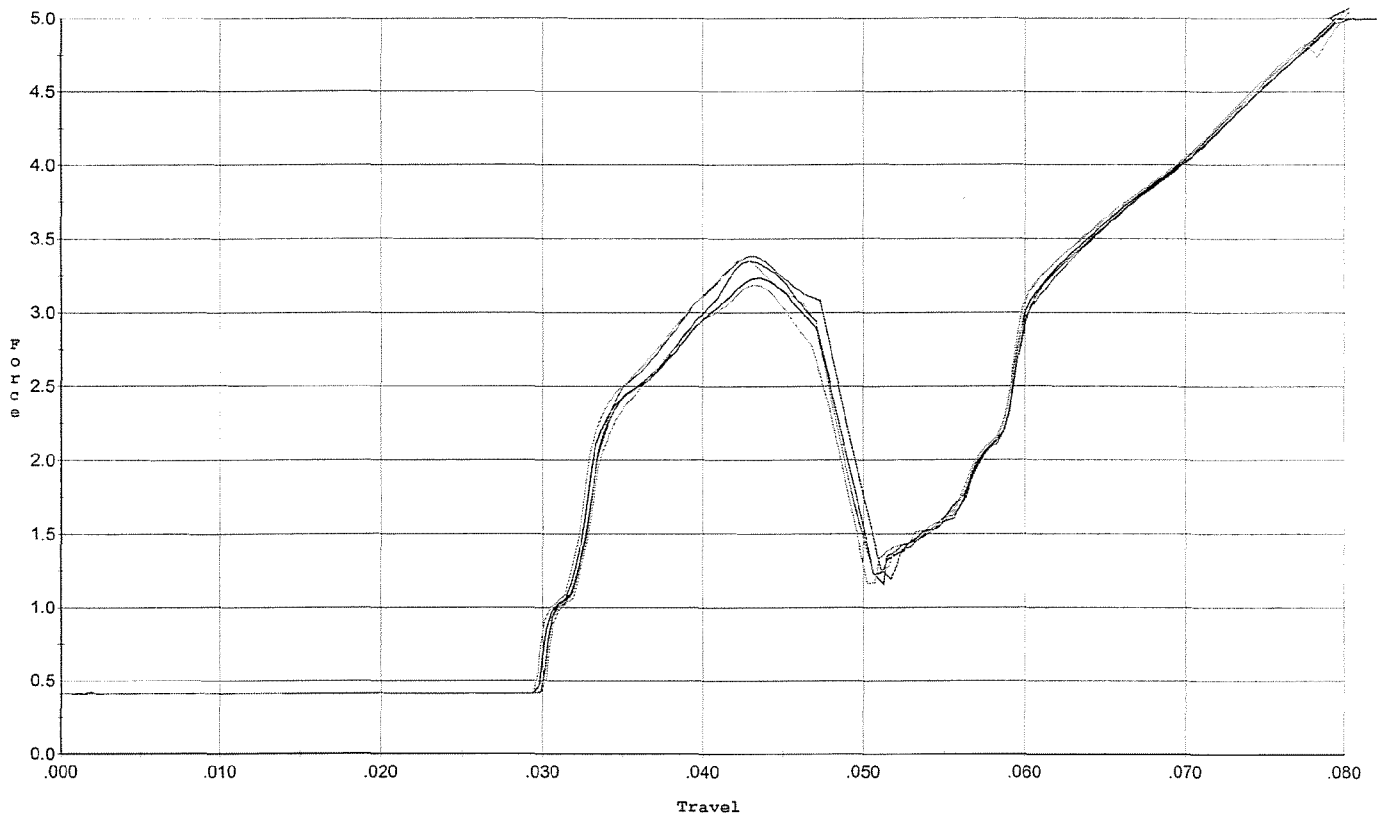
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.709	0.042	0.025	0.062	0.047		Set Trigger
2	2.717	0.041	0.025	0.062	0.046		Set Trigger
3	2.696	0.041	0.025	0.062	0.045		Set Trigger
4	2.706	0.041	0.025	0.062	0.045		Set Trigger
5	2.637	0.041	0.025	0.062	0.046		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



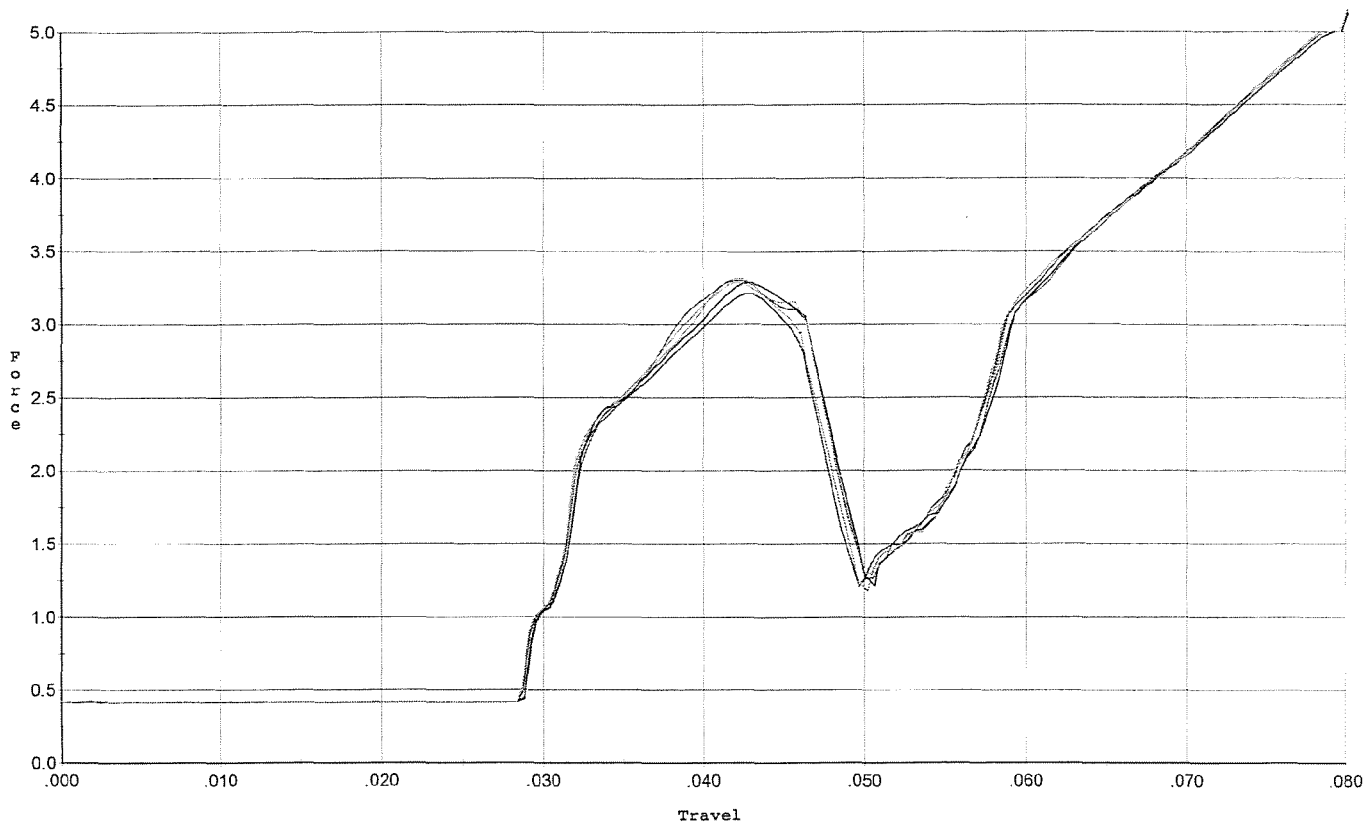
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.350	0.049	0.030	0.042	0.060		Set Trigger
2	3.236	0.047	0.030	0.043	0.058		Set Trigger
3	3.384	0.047	0.030	0.042	0.060		Set Trigger
4	3.362	0.047	0.030	0.042	0.059		Set Trigger
5	3.188	0.048	0.030	0.043	0.057		Set Trigger

A. 3.30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



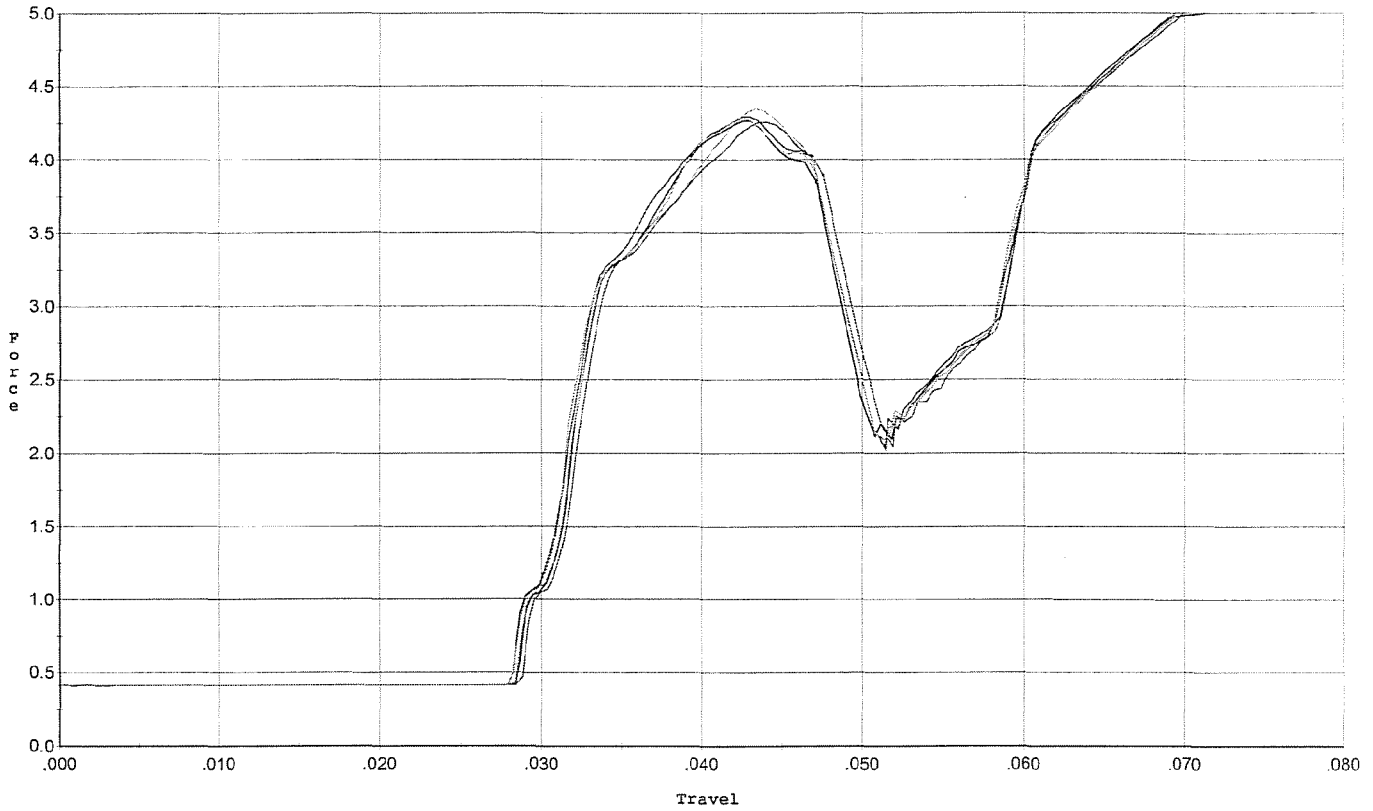
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.210	0.046	0.029	0.043	0.057		Set Trigger
2	3.285	0.046	0.029	0.043	0.059		Set Trigger
3	3.301	0.046	0.029	0.042	0.059		Set Trigger
4	3.288	0.046	0.029	0.042	0.059		Set Trigger
5	3.317	0.046	0.029	0.043	0.058		Set Trigger

A.3.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



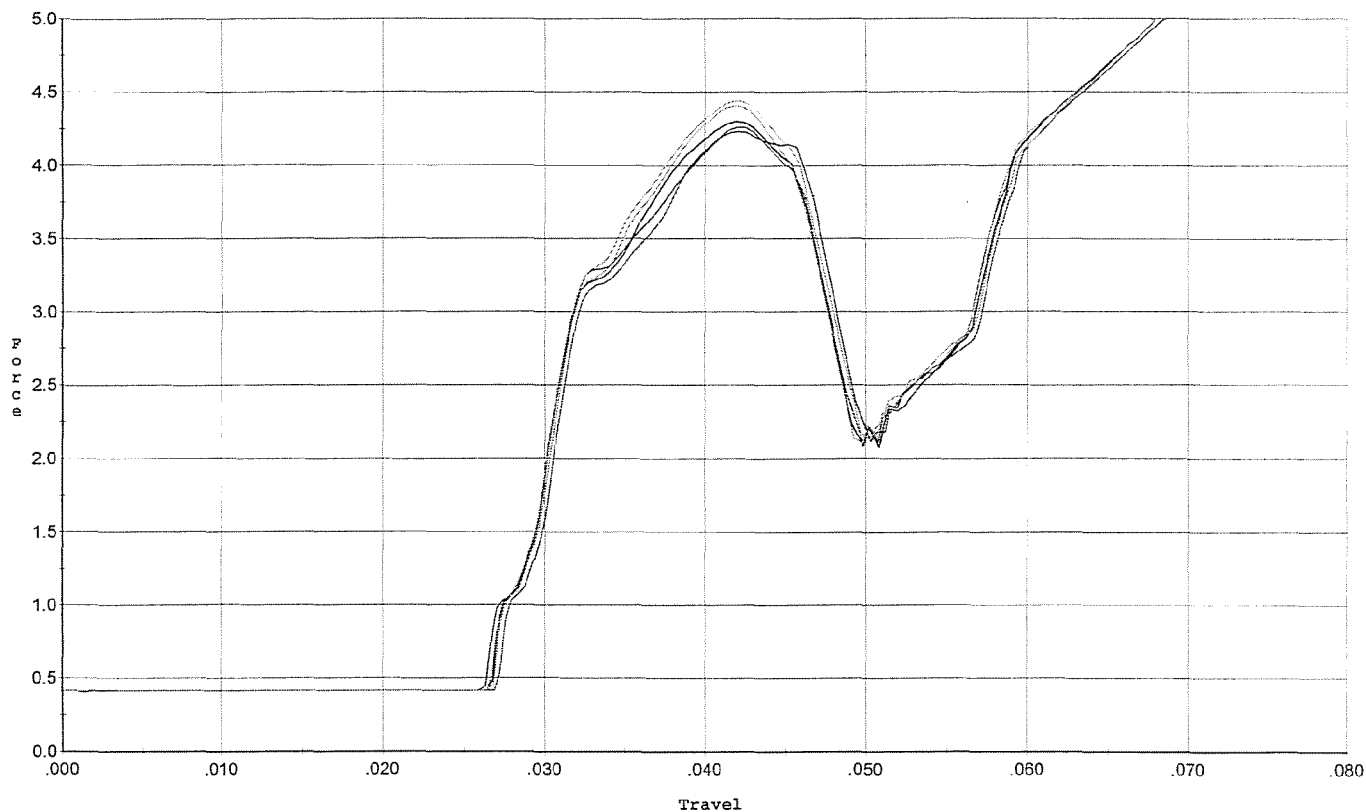
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.047	0.028	0.032	0.077		Set Trigger
2	4.258	0.047	0.029	0.032	0.076		Set Trigger
3	4.257	0.048	0.029	0.033	0.076		Set Trigger
4	4.277	0.047	0.029	0.032	0.076		Set Trigger
5	4.347	0.047	0.028	0.032	0.076		Set Trigger

A-4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



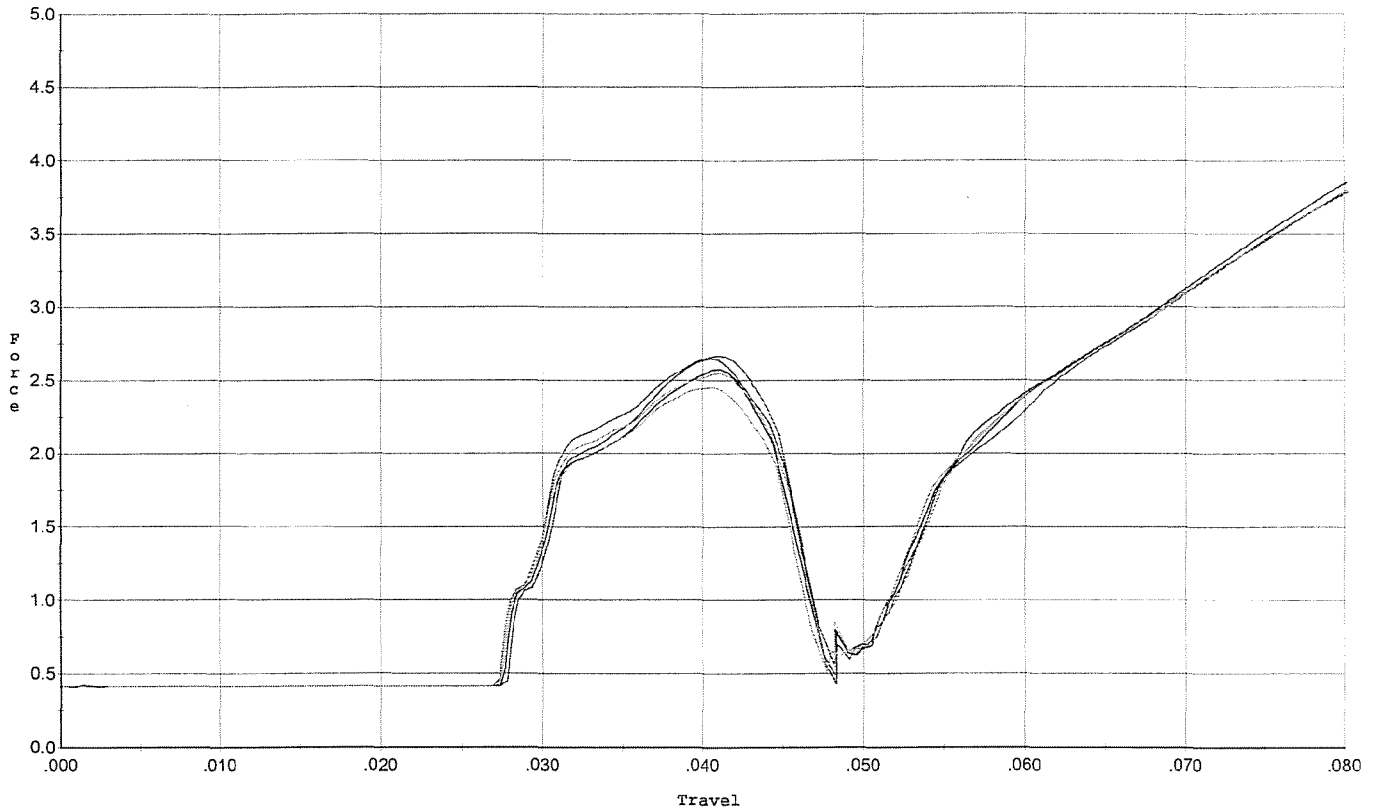
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.047	0.027	0.031	0.079		Set Trigger
2	4.300	0.046	0.027	0.031	0.078		Set Trigger
3	4.260	0.046	0.027	0.032	0.075		Set Trigger
4	4.440	0.048	0.027	0.031	0.082		Set Trigger
5	4.406	0.047	0.027	0.031	0.078		Set Trigger

A. 4.32

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

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



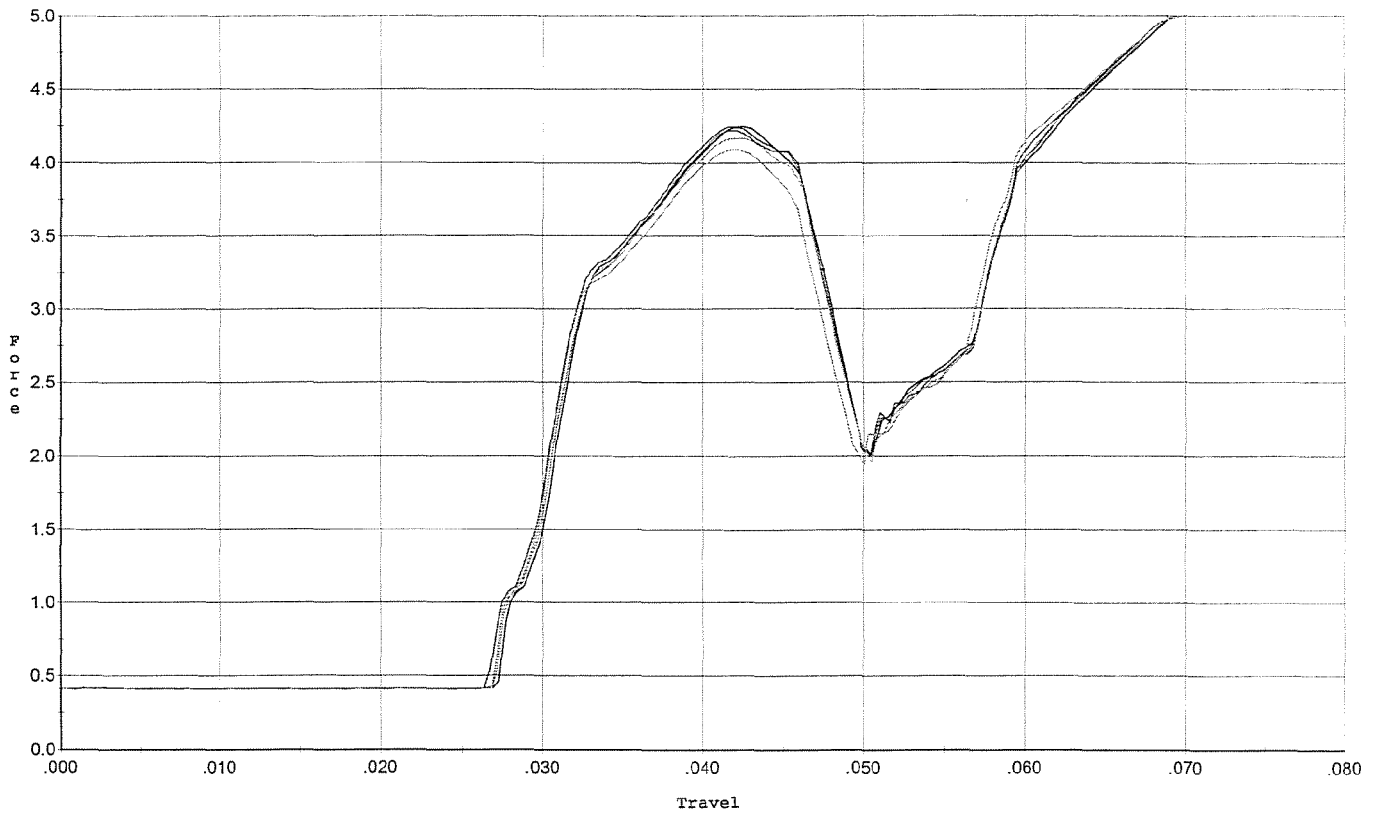
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.649	0.045	0.028	0.061	0.048		Set Trigger
2	2.575	0.044	0.028	0.061	0.046		Set Trigger
3	2.668	0.045	0.027	0.061	0.049		Set Trigger
4	2.549	0.045	0.028	0.062	0.048		Set Trigger
5	2.452	0.045	0.028	0.061	0.046		Set Trigger

A-257

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/24/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & test



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.240	0.046	0.027	0.032	0.076		Set Trigger
2	4.246	0.048	0.027	0.032	0.078		Set Trigger
3	4.218	0.046	0.027	0.032	0.075		Set Trigger
4	4.167	0.046	0.027	0.032	0.075		Set Trigger
5	4.088	0.046	0.027	0.032	0.073		Set Trigger

A-4.19