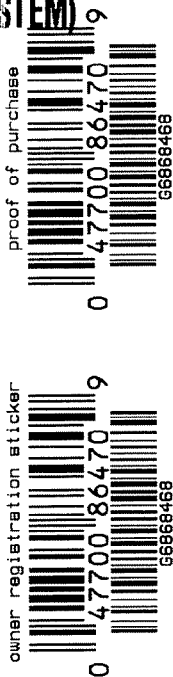


66868468

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
G6868468	
UPC	

BM FORM

GUN SERIAL # G 6868468

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-08	SP
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SP
460	CHECK HEADSPACE	MAGNAFLUX	7-28-09	SP
470	DIS-ASSEMBLE ACTION		7-28-09	SP
472	SERIALIZE BOLT HANDLE		7-29-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	7/31/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	DWD
510	DRILL AND TAP SIGHT HOLES		7-29-09	SP
520	GOFF BLAST BBL / REC		7/31/09	SP
540	APPLY COATINGS (BARREL ACTION)		8/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-21-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

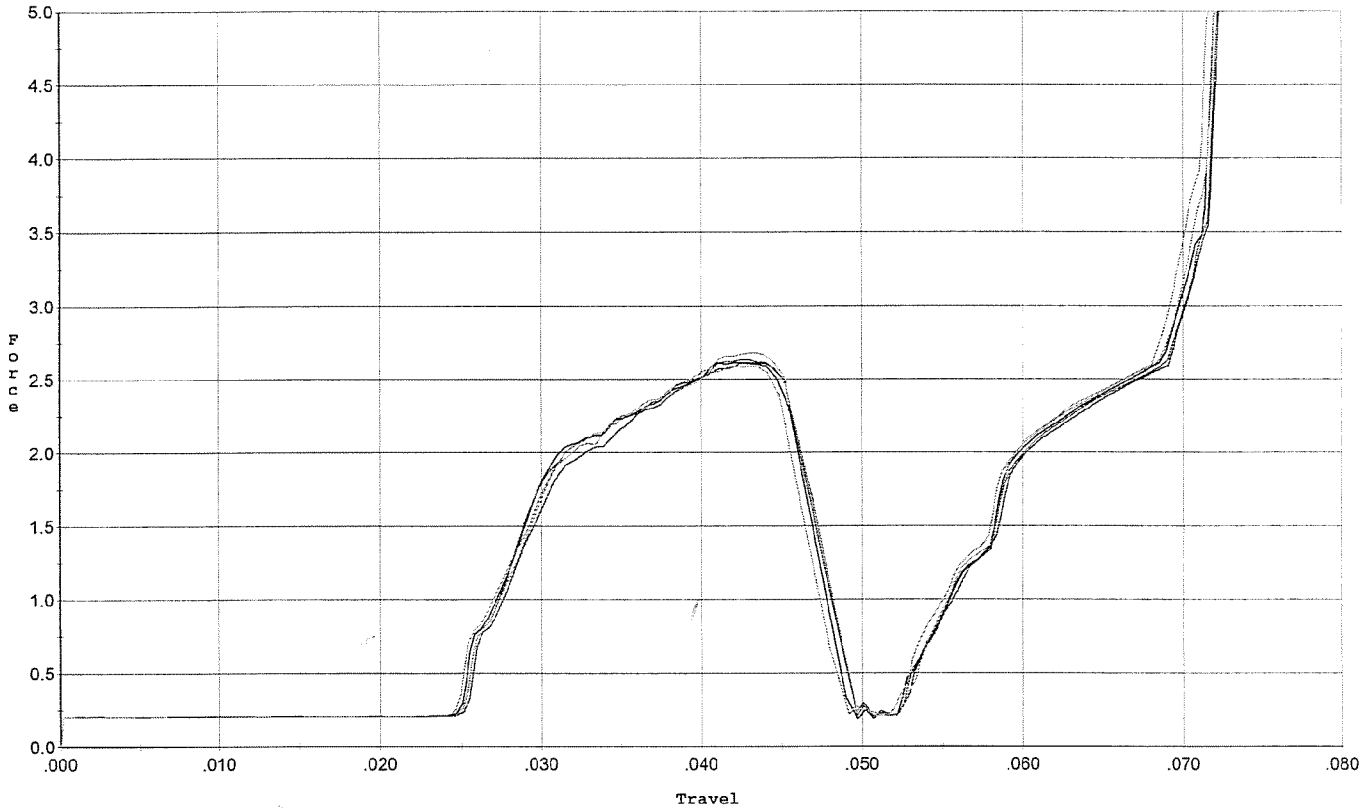
560	BARBER - M24 0094962 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	8-22-09	RN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>70</u>	<u>60</u>	<u>70</u>	8-22-09	RN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.023</u>	<u>.023</u>	8-22-09	RN		
	J) ASSEMBLE STOCK					8-21-09	RN		
	K) ASSEMBLE SWIVEL STUDS					8-22-09	RH		
	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		8-21-09	RP		
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION				N/A				
	MALFUNCTION					8-21-09	RP		
660	INSPECT FOR LIVE AMMO								
670	FINAL INSPECTION A) HEADSPACE					8-22-09	RN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>273</u>	<u>289</u>	<u>289</u>	<u>273</u>	<u>283</u>	8-22-09	RTZ
	C) FUNCTION					8-22-09	RN		
690	PACK					8/24/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/20/09

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



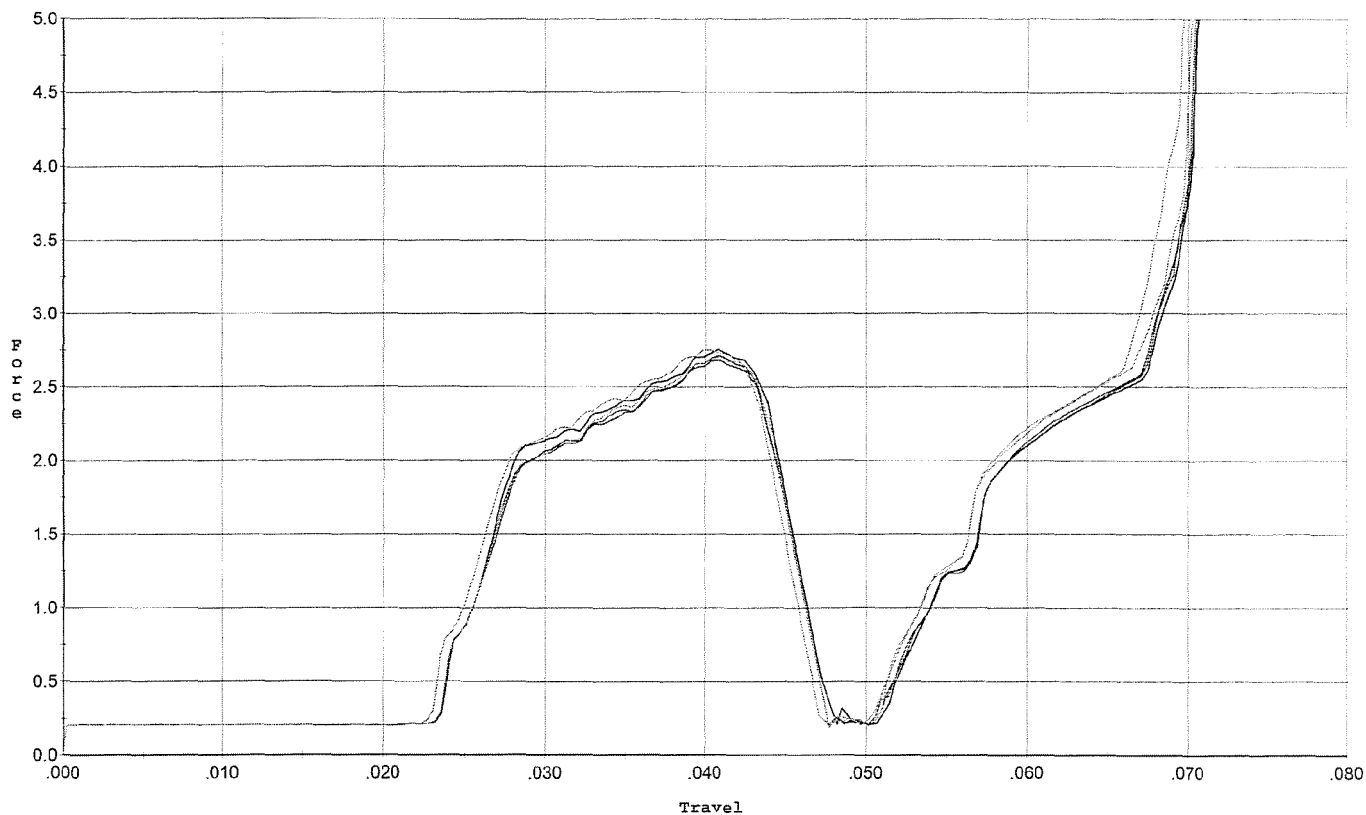
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.615	0.045	0.026	0.030	0.046		Set Trigger
2	2.615	0.046	0.025	0.030	0.048		Set Trigger
3	2.634	0.047	0.025	0.030	0.050		Set Trigger
4	2.680	0.047	0.025	0.030	0.050		Set Trigger
5	2.592	0.045	0.025	0.030	0.046		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/20/2009

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



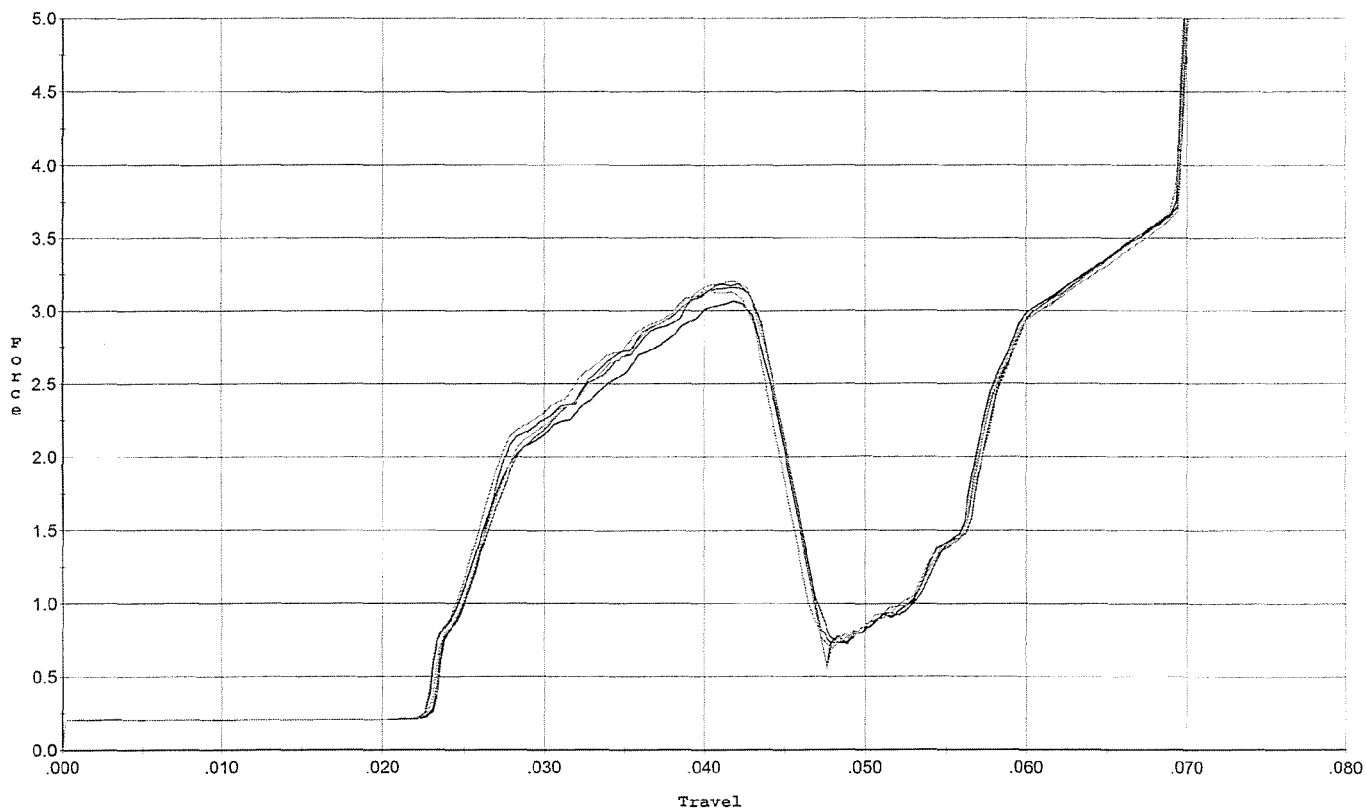
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.712	0.045	0.024	0.030	0.049		Set Trigger
2	2.753	0.044	0.024	0.030	0.049		Set Trigger
3	2.680	0.045	0.024	0.030	0.049		Set Trigger
4	2.697	0.044	0.024	0.029	0.049		Set Trigger
5	2.750	0.043	0.023	0.029	0.050		Set Trigger

A-2.71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/20/2009

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



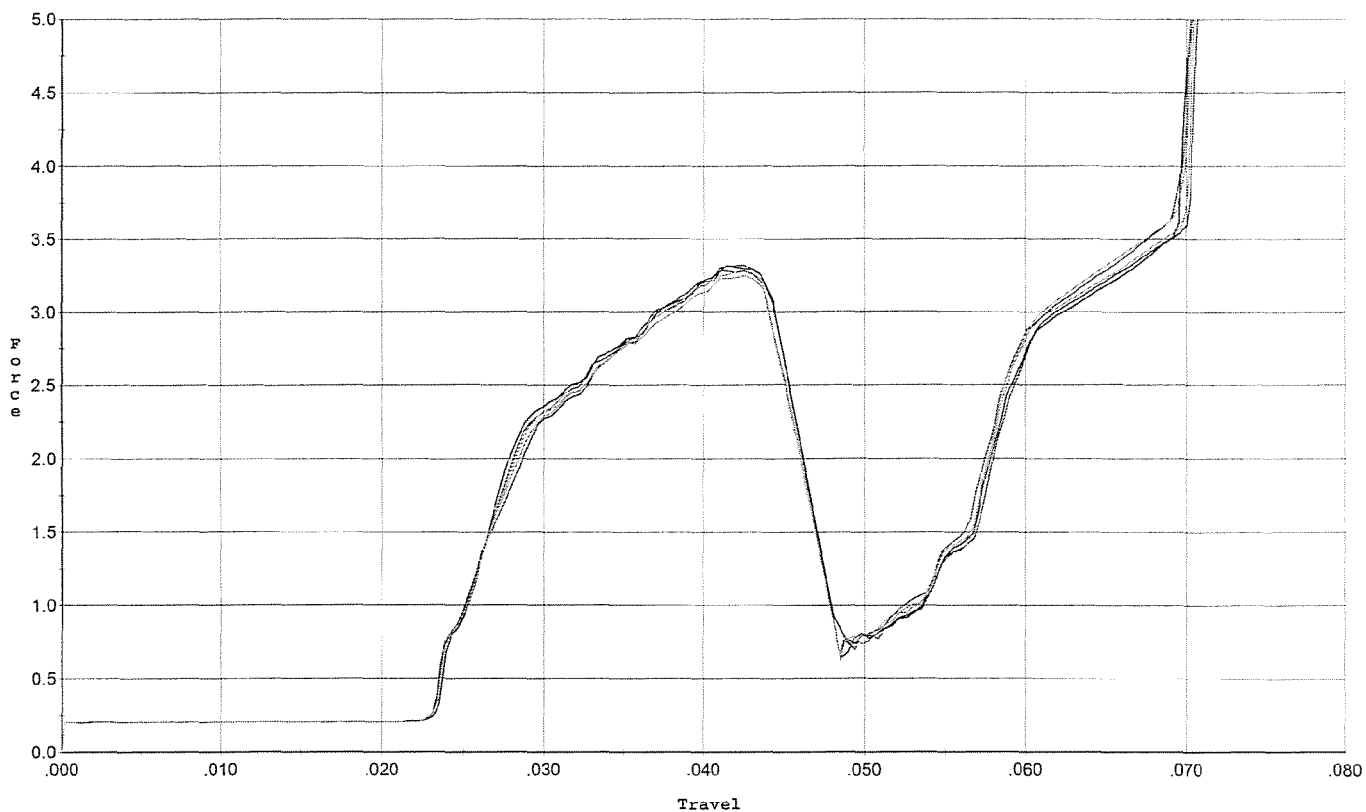
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.185	0.044	0.023	0.029	0.055		Set Trigger
2	3.066	0.044	0.023	0.028	0.054		Set Trigger
3	3.161	0.044	0.023	0.029	0.055		Set Trigger
4	3.201	0.044	0.023	0.029	0.055		Set Trigger
5	3.146	0.043	0.023	0.029	0.055		Set Trigger

A 3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/20/2009

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



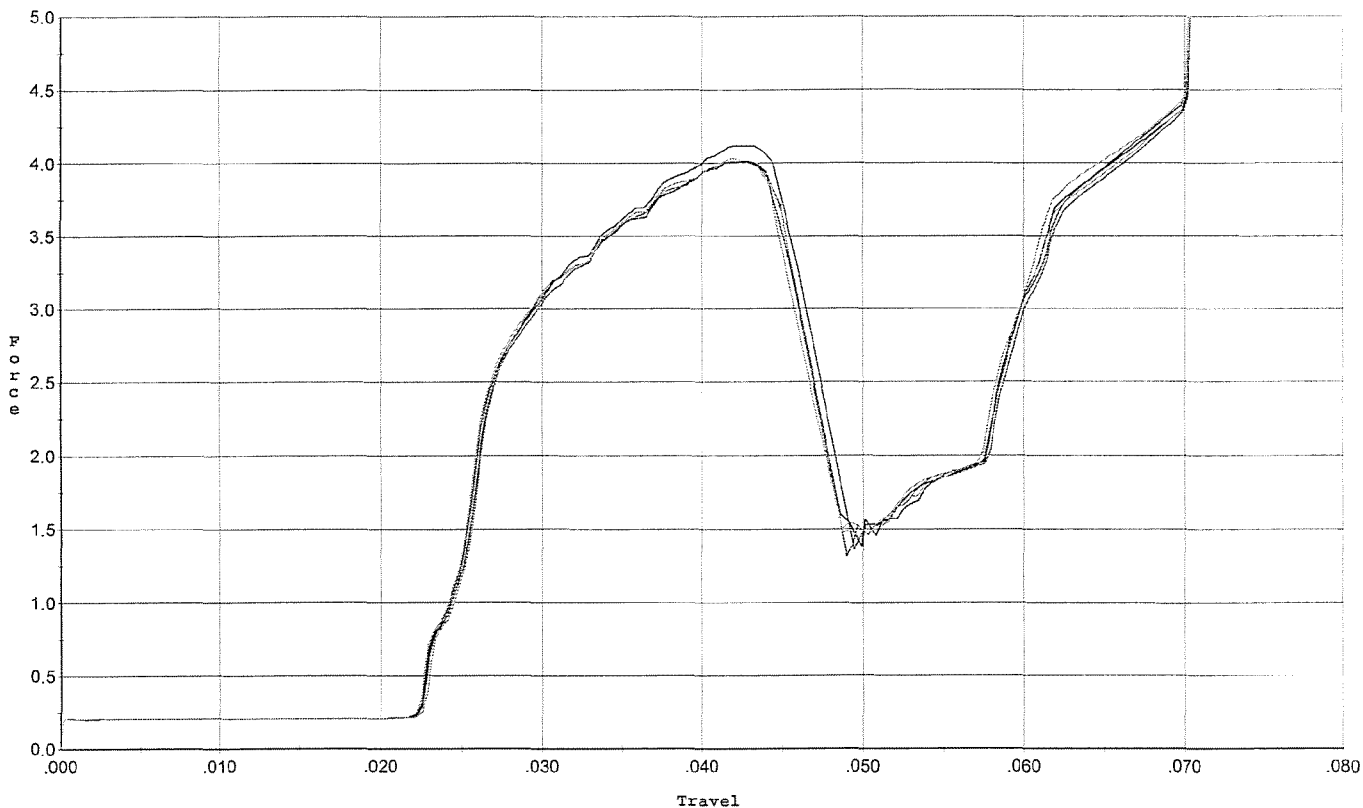
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.320	0.044	0.023	0.029	0.058		Set Trigger
2	3.318	0.044	0.024	0.028	0.059		Set Trigger
3	3.283	0.046	0.023	0.028	0.060		Set Trigger
4	3.291	0.045	0.023	0.028	0.059		Set Trigger
5	3.250	0.046	0.023	0.028	0.059		Set Trigger

A-3.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/20/2009

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



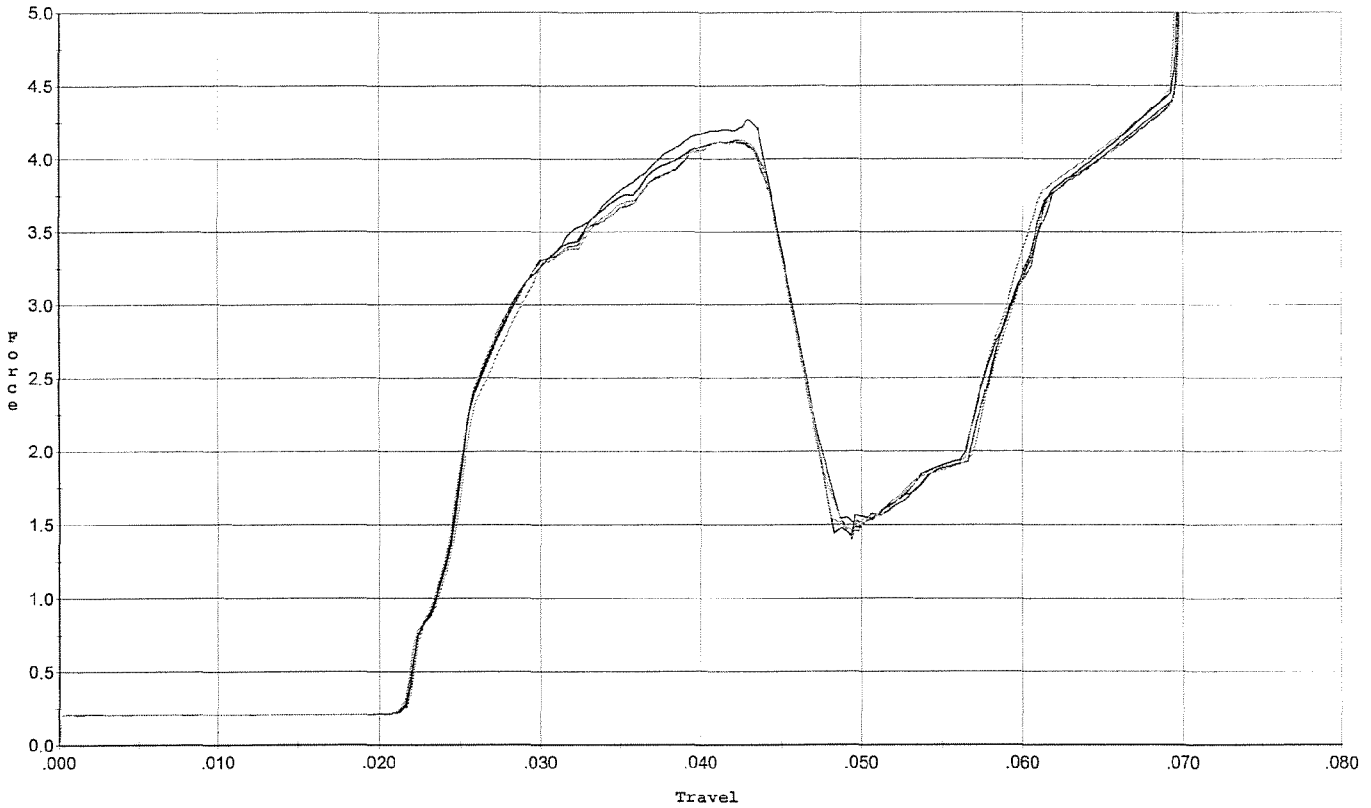
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.120	0.046	0.023	0.026	0.080		Set Trigger
2	4.015	0.045	0.023	0.026	0.076		Set Trigger
3	4.006	0.045	0.023	0.026	0.076		Set Trigger
4	4.015	0.044	0.022	0.026	0.074		Set Trigger
5	4.033	0.045	0.023	0.026	0.076		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/20/2009

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



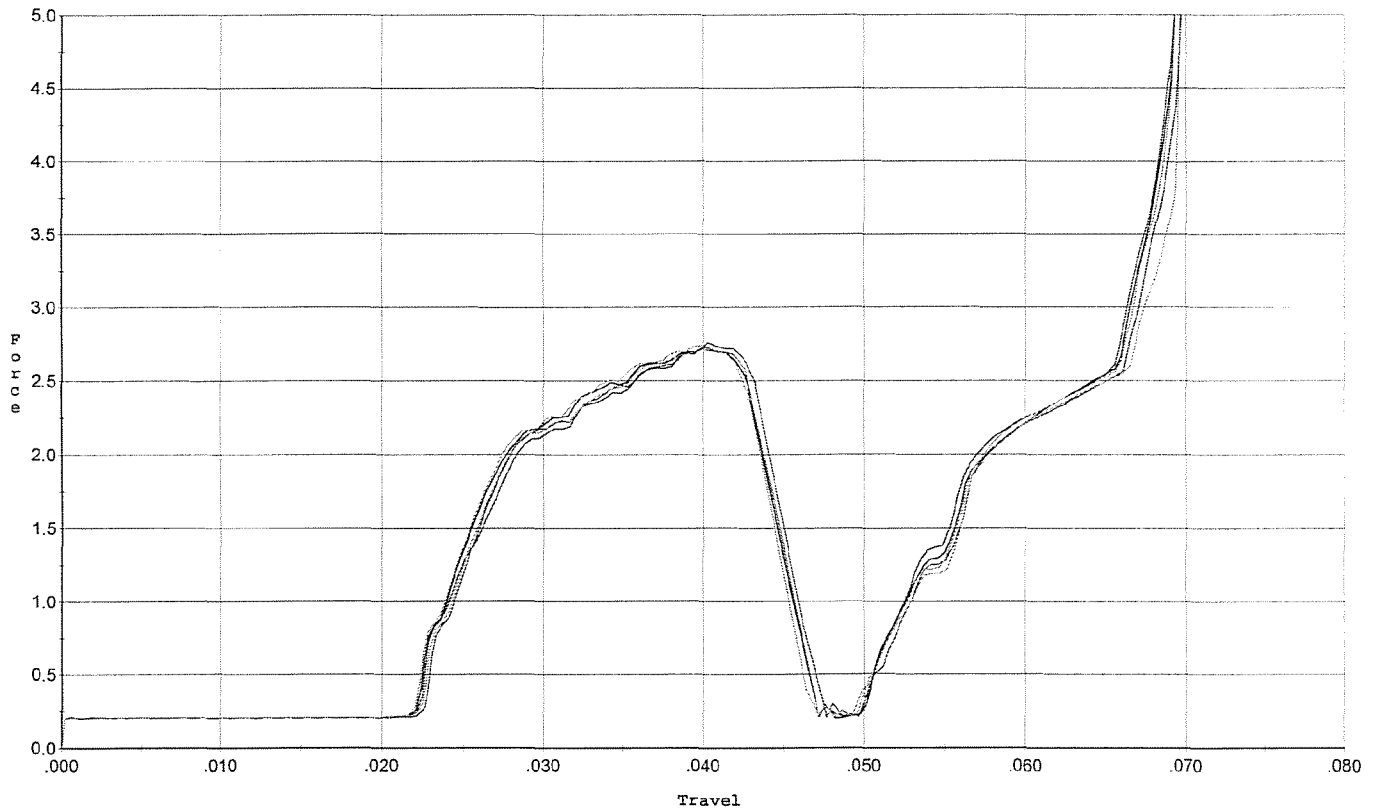
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.272	0.044	0.022	0.026	0.078		Set Trigger
2	4.120	0.044	0.022	0.026	0.078		Set Trigger
3	4.124	0.044	0.022	0.026	0.077		Set Trigger
4	4.133	0.044	0.022	0.026	0.076		Set Trigger
5	4.119	0.044	0.022	0.026	0.078		Set Trigger

A.4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/20/2009

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



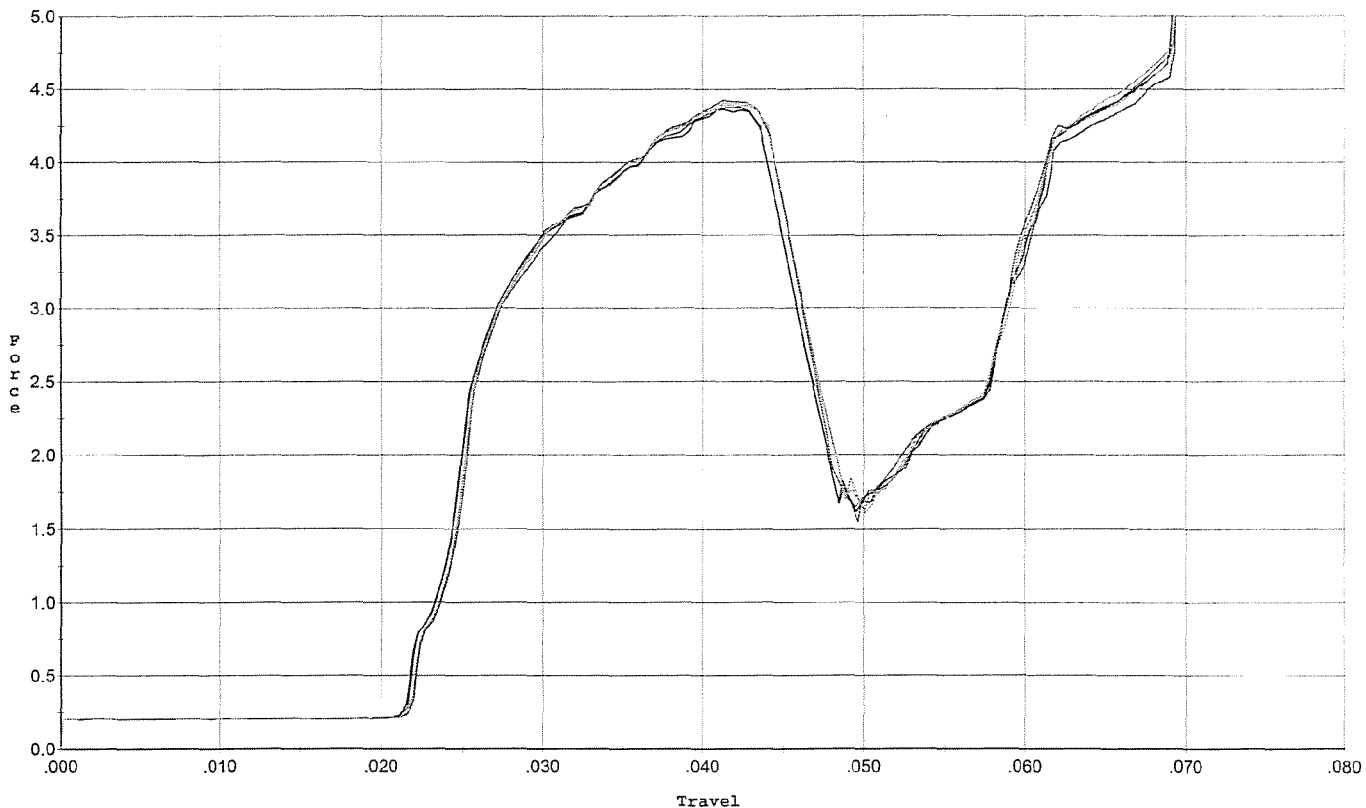
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.723	0.045	0.022	0.029	0.051		Set Trigger
2	2.713	0.043	0.022	0.029	0.050		Set Trigger
3	2.761	0.043	0.023	0.029	0.050		Set Trigger
4	2.714	0.044	0.023	0.029	0.051		Set Trigger
5	2.739	0.043	0.022	0.029	0.050		Set Trigger

A-2-73

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/20/2009

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	4.374	0.044	0.022	0.025	0.080		Set Trigger
2	4.360	0.044	0.022	0.025	0.081		Set Trigger
3	4.423	0.044	0.022	0.025	0.082		Set Trigger
4	4.407	0.044	0.022	0.025	0.082		Set Trigger
5	4.391	0.044	0.022	0.025	0.082		Set Trigger

A-4.39