

G6868475

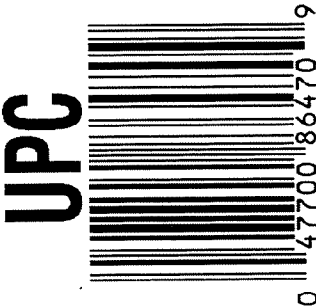
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6868475



GUN SERIAL # G 6868475

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-09	SP
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	7-28-09	SP
470	DIS-ASSEMBLE ACTION		7-28-09	SP
472	SERIALIZE BOLT HANDLE		7-29-09	RTZ
480	MAGNAFLUX BBL ACTION		7/31/09	(D)
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		8-18-09	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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

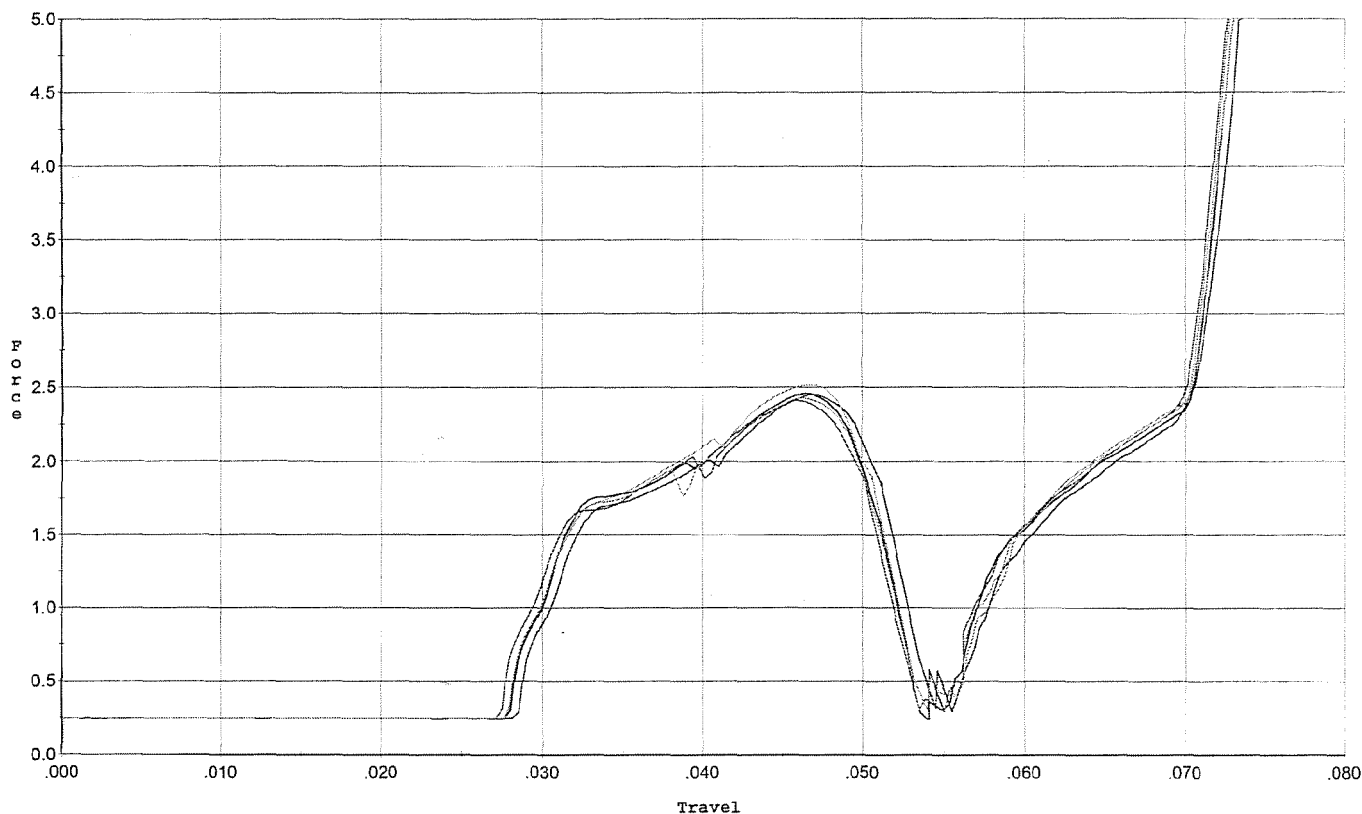
560	F) SAFETY ON FORCE	BARBER - M24 0095077 2 LBS MIN 10 LBS MAX	2°	2°	2°	8/27/09	RB		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	7°	7°	7°	8/27/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.024	.023	.023	8/27/09	RB		
	J) ASSEMBLE STOCK					8-24-09	217.0		
	K) ASSEMBLE 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		8/26/09	RB		
			PASS	FAIL					
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					8/24/09	TAR		
670	FINAL INSPECTION A) HEADSPACE					8/27/09	RB		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.64	2.68	2.67	2.51	2.53	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 8/21/2009

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



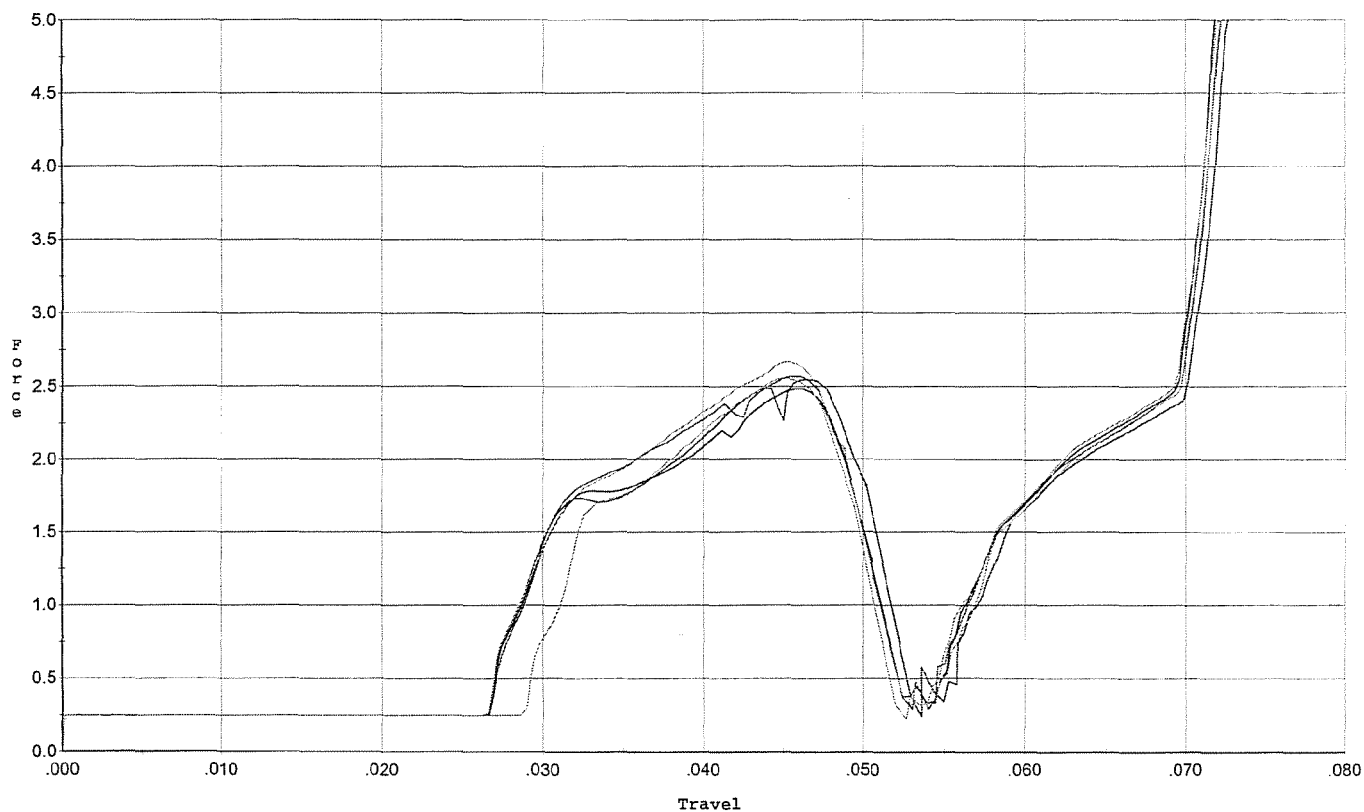
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.051	0.029	0.029	0.050		Set Trigger
2	2.457	0.051	0.028	0.029	0.050		Set Trigger
3	2.409	0.050	0.028	0.028	0.049		Set Trigger
4	2.515	0.051	0.028	0.028	0.051		Set Trigger
5	2.429	0.051	0.028	0.028	0.050		Set Trigger

A 2.45

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/21/2009

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



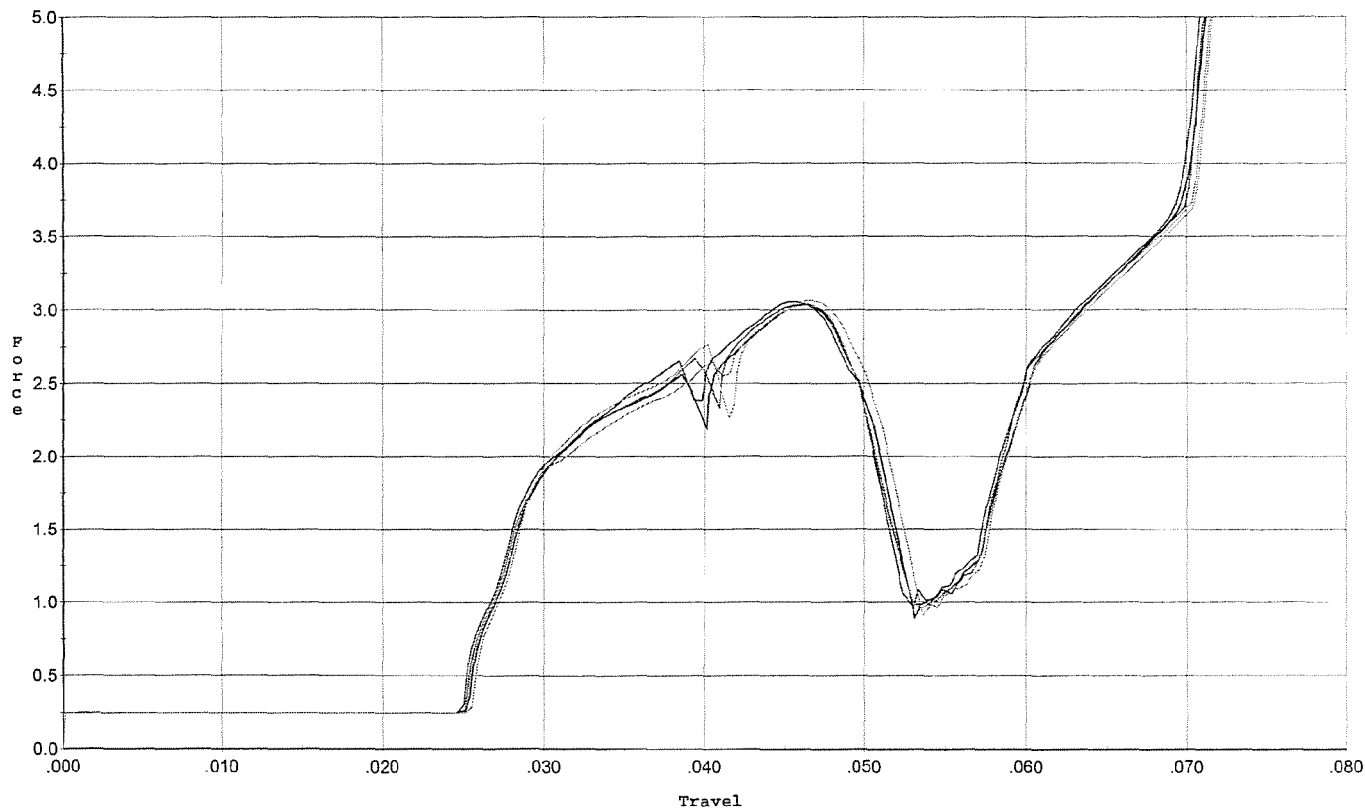
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.050	0.027	0.028	0.052		Set Trigger
2	2.483	0.050	0.027	0.028	0.051		Set Trigger
3	2.569	0.051	0.027	0.028	0.053		Set Trigger
4	2.667	0.049	0.027	0.029	0.052		Set Trigger
5	2.558	0.049	0.029	0.029	0.047		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



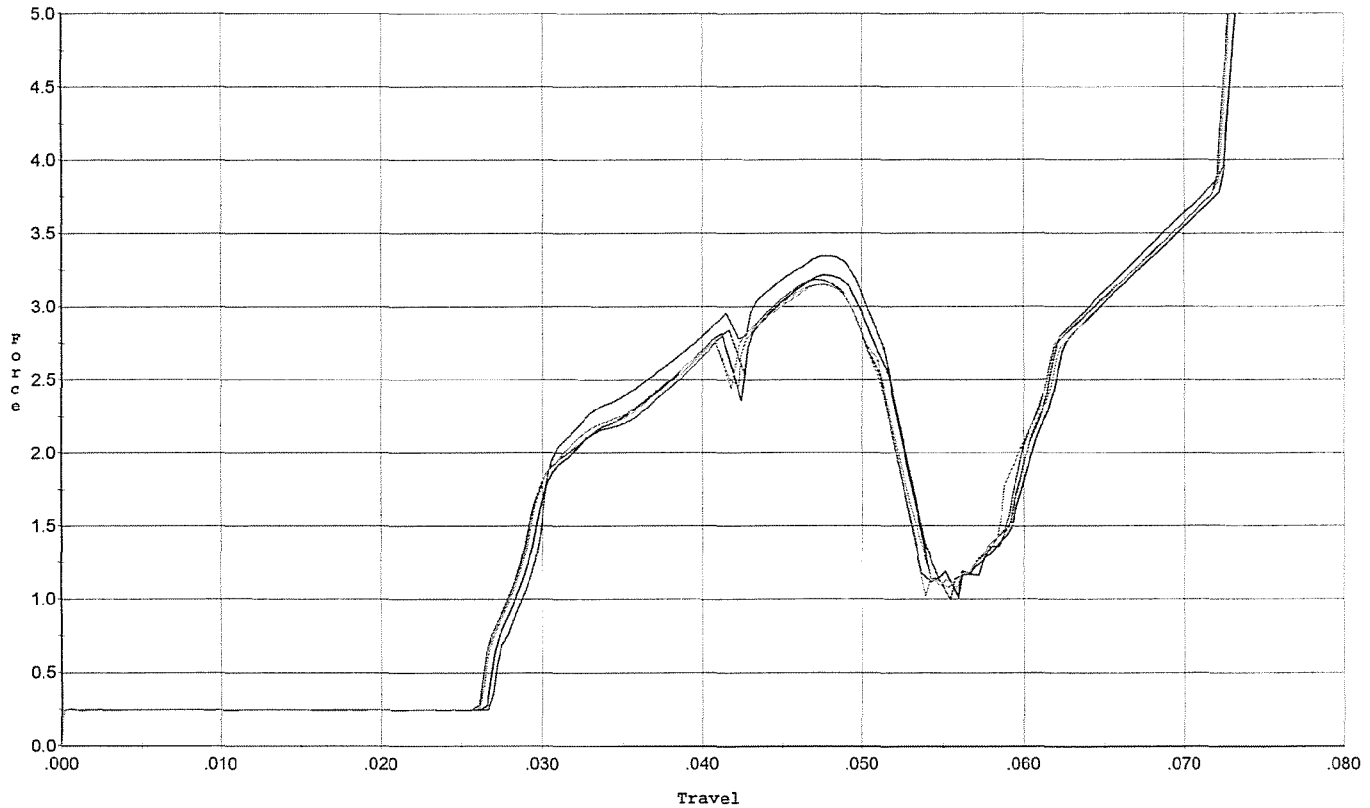
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.050	0.025	0.026	0.064		Set Trigger
2	3.034	0.051	0.025	0.026	0.064		Set Trigger
3	3.034	0.050	0.025	0.026	0.063		Set Trigger
4	3.060	0.051	0.026	0.026	0.066		Set Trigger
5	3.032	0.050	0.025	0.027	0.063		Set Trigger

A3-04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



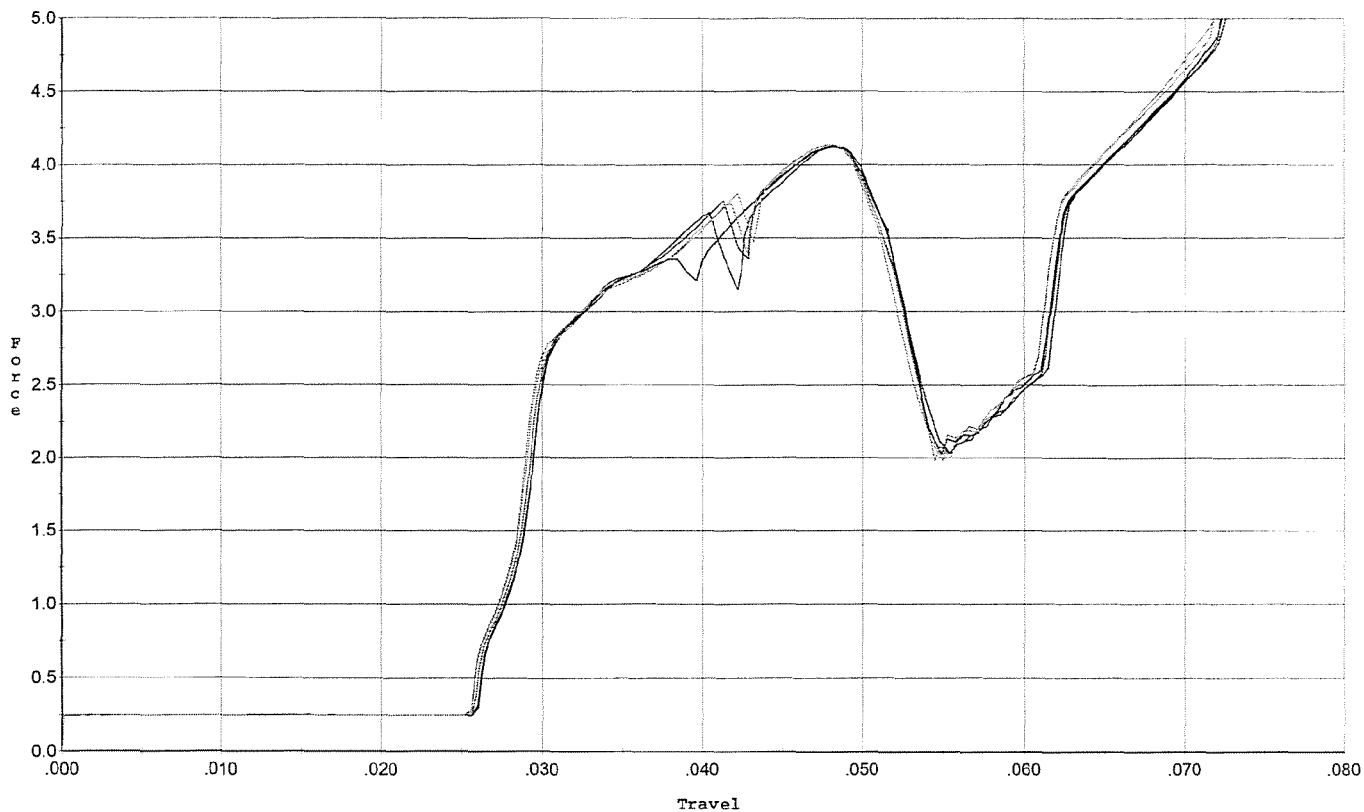
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.343	0.051	0.027	0.027	0.069		Set Trigger
2	3.215	0.052	0.027	0.027	0.067		Set Trigger
3	3.184	0.051	0.026	0.027	0.066		Set Trigger
4	3.152	0.051	0.026	0.027	0.066		Set Trigger
5	3.146	0.051	0.026	0.027	0.066		Set Trigger

A3-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



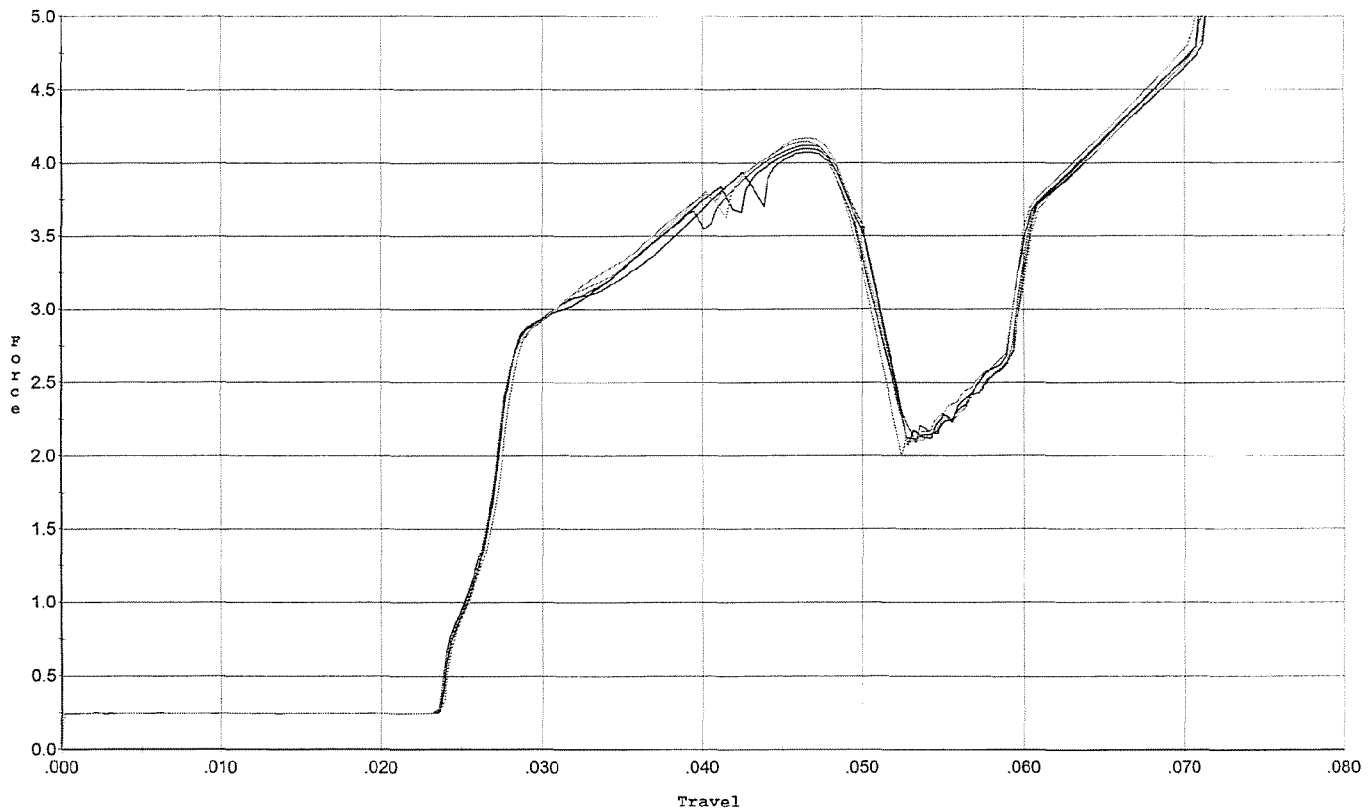
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.052	0.026	0.025	0.089		Set Trigger
2	4.131	0.052	0.026	0.025	0.088		Set Trigger
3	4.121	0.052	0.026	0.025	0.090		Set Trigger
4	4.141	0.052	0.026	0.025	0.090		Set Trigger
5	4.137	0.051	0.026	0.025	0.088		Set Trigger

A4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



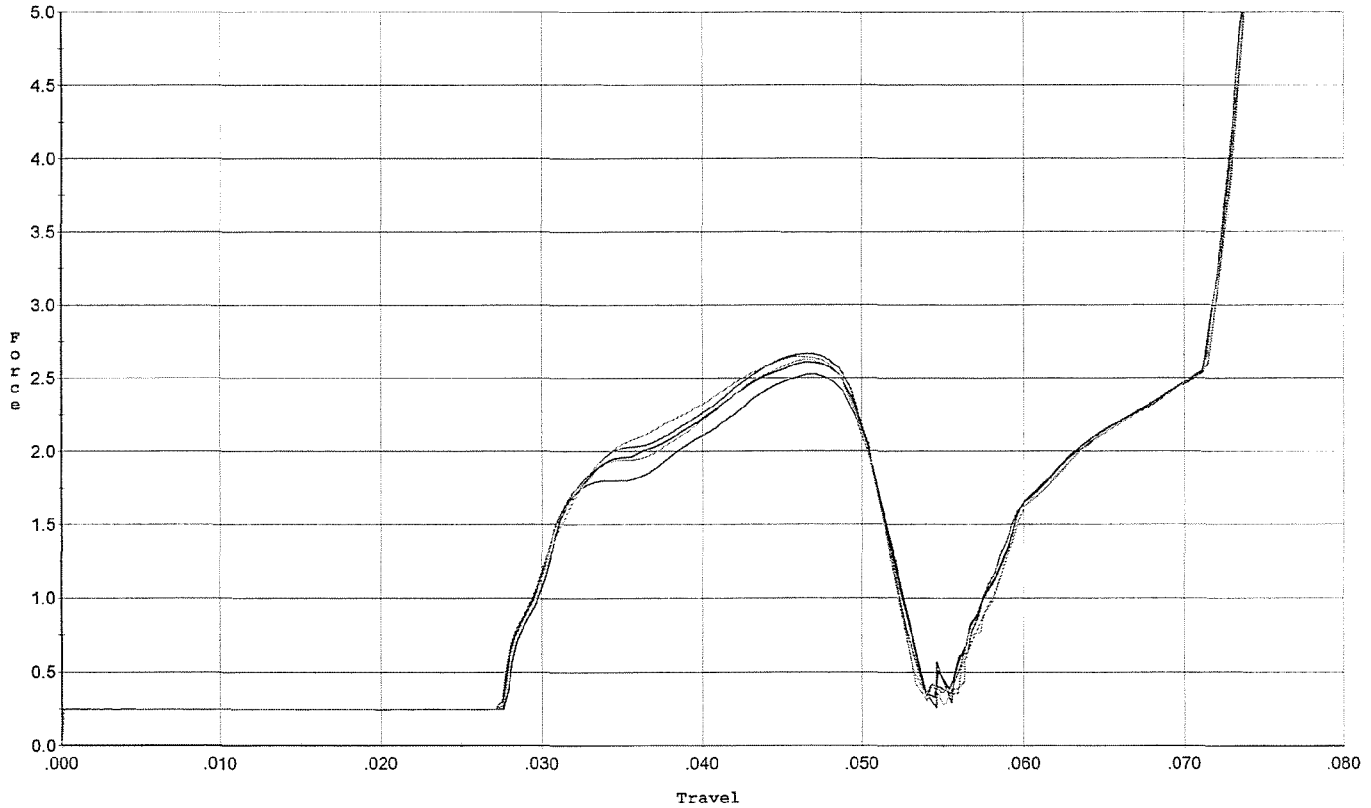
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.050	0.024	0.025	0.088		Set Trigger
2	4.099	0.050	0.024	0.024	0.090		Set Trigger
3	4.121	0.050	0.024	0.024	0.090		Set Trigger
4	4.170	0.051	0.024	0.025	0.091		Set Trigger
5	4.147	0.050	0.024	0.024	0.090		Set Trigger

A 4.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/21/2009

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



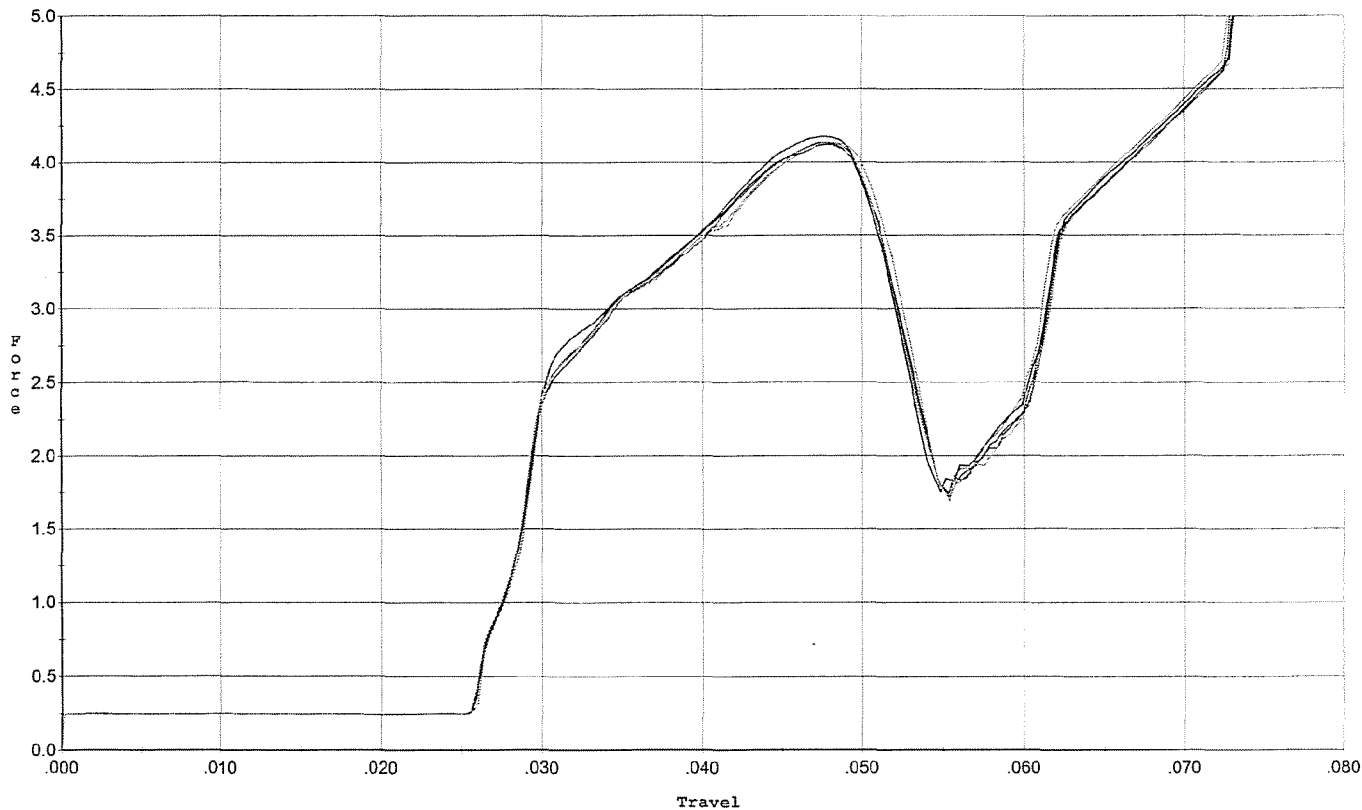
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.527	0.052	0.028	0.028	0.054		Set Trigger
2	2.608	0.050	0.028	0.029	0.053		Set Trigger
3	2.664	0.050	0.028	0.029	0.054		Set Trigger
4	2.626	0.051	0.028	0.029	0.053		Set Trigger
5	2.646	0.051	0.028	0.029	0.055		Set Trigger

A2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/21/2009

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	4.177	0.051	0.026	0.026	0.087		Set Trigger
2	4.126	0.051	0.026	0.026	0.087		Set Trigger
3	4.135	0.051	0.026	0.026	0.086		Set Trigger
4	4.133	0.052	0.026	0.026	0.088		Set Trigger
5	4.114	0.051	0.026	0.026	0.086		Set Trigger

A 4.13