

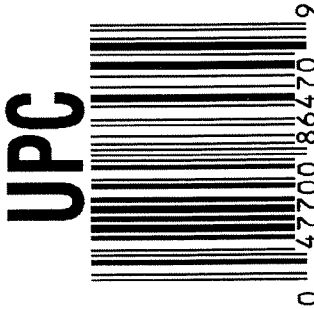
Q 6869831

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

G6869831



BM FORM

GUN SERIAL # G 6869831

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	SP
480	MAGNAFLUX BBL ACTION		8-19-09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/19/09	OWD
510	DRILL AND TAP SIGHT HOLES		8-17-09	SP
520	GOFF BLAST BBL / REC		8/24/09	SP
540	APPLY COATINGS (BARREL ACTION)		8/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

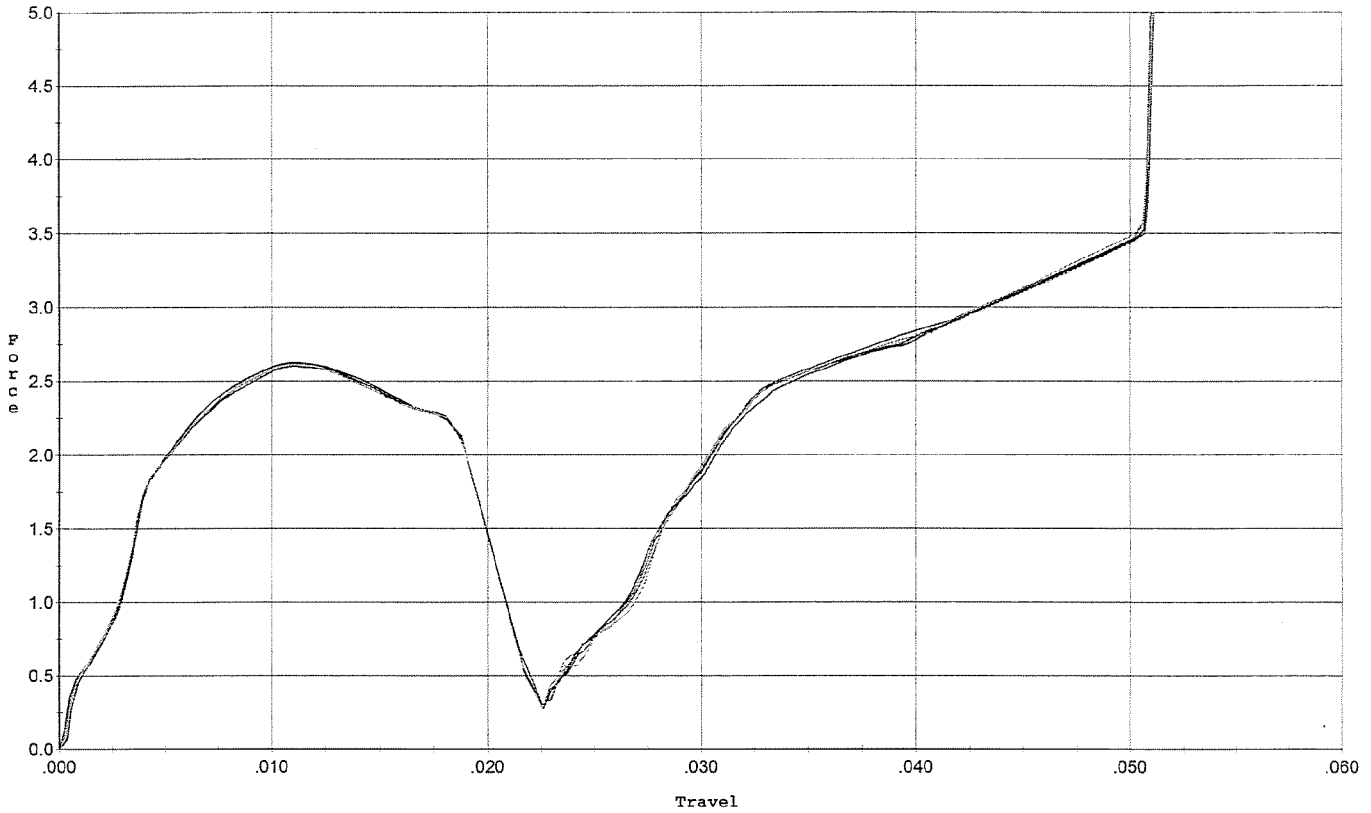
560	BARBER - M24 0095473 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	2.2	2.0	2.2	9-1-09	RP		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	3.4	3.2	3.4	9-1-09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.023	9-1-09	RP		
	J) ASSEMBLE STOCK					8-28-09	RP		
	K) ASSEMBLE SWIVEL STUDS					9-1-09	RP		
	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		9/1/09	RP		
			PASS	FAIL					
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					9/1/09	TAR		
670	FINAL INSPECTION A) HEADSPACE					9-1-09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.48	2.54	2.61	2.54	2.54	9-1-09	RP
	C) FUNCTION					9-1-09	RP		
690	PACK					9-2-09	TL		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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



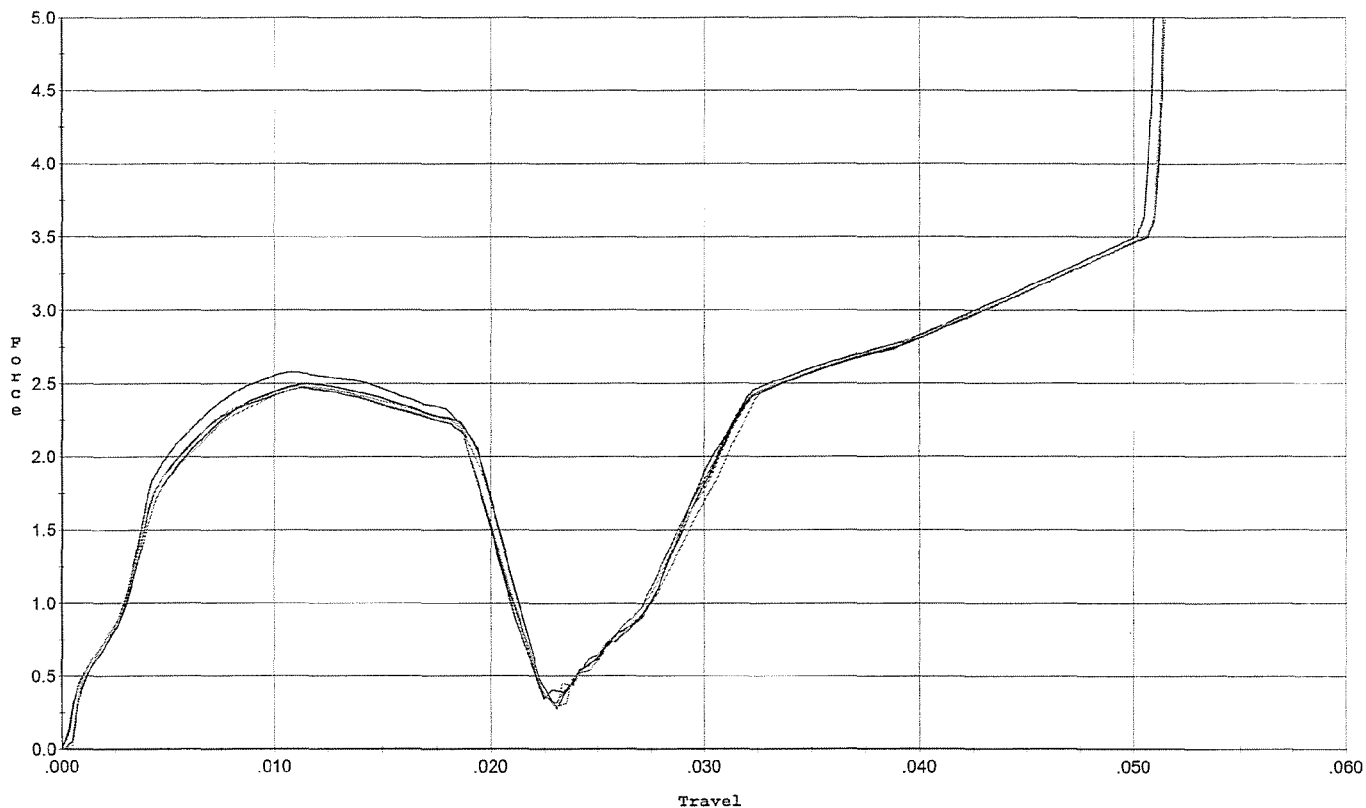
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.601	0.019	0.00	0.035	0.036		Set Trigger
2	2.628	0.019	0.00	0.035	0.036		Set Trigger
3	2.620	0.019	0.00	0.035	0.036		Set Trigger
4	2.609	0.019	0.00	0.035	0.036		Set Trigger
5	2.612	0.019	0.00	0.035	0.036		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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



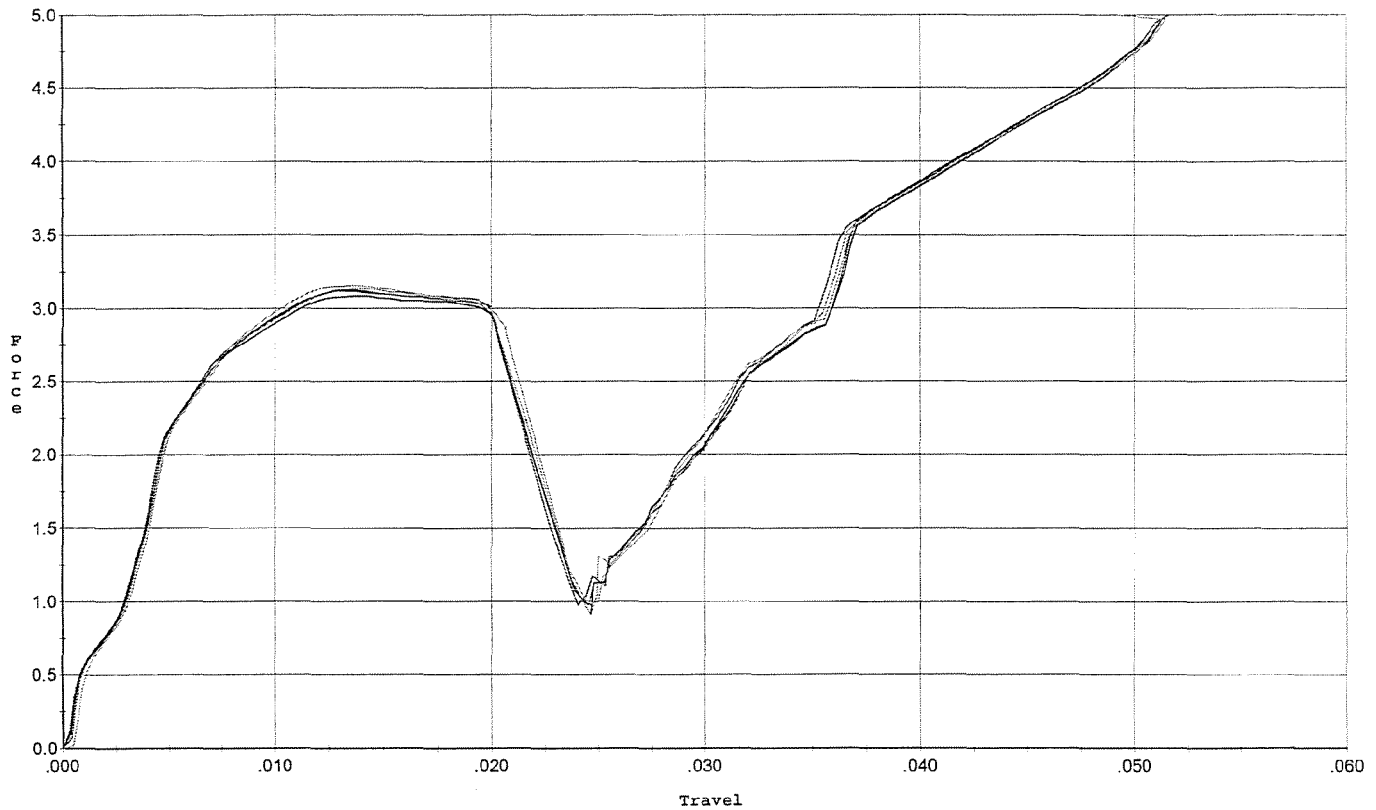
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.578	0.019	0.00	0.035	0.036		Set Trigger
2	2.500	0.019	0.00	0.035	0.036		Set Trigger
3	2.470	0.019	0.00	0.035	0.035		Set Trigger
4	2.481	0.019	0.00	0.035	0.035		Set Trigger
5	2.477	0.020	0.00	0.035	0.036		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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



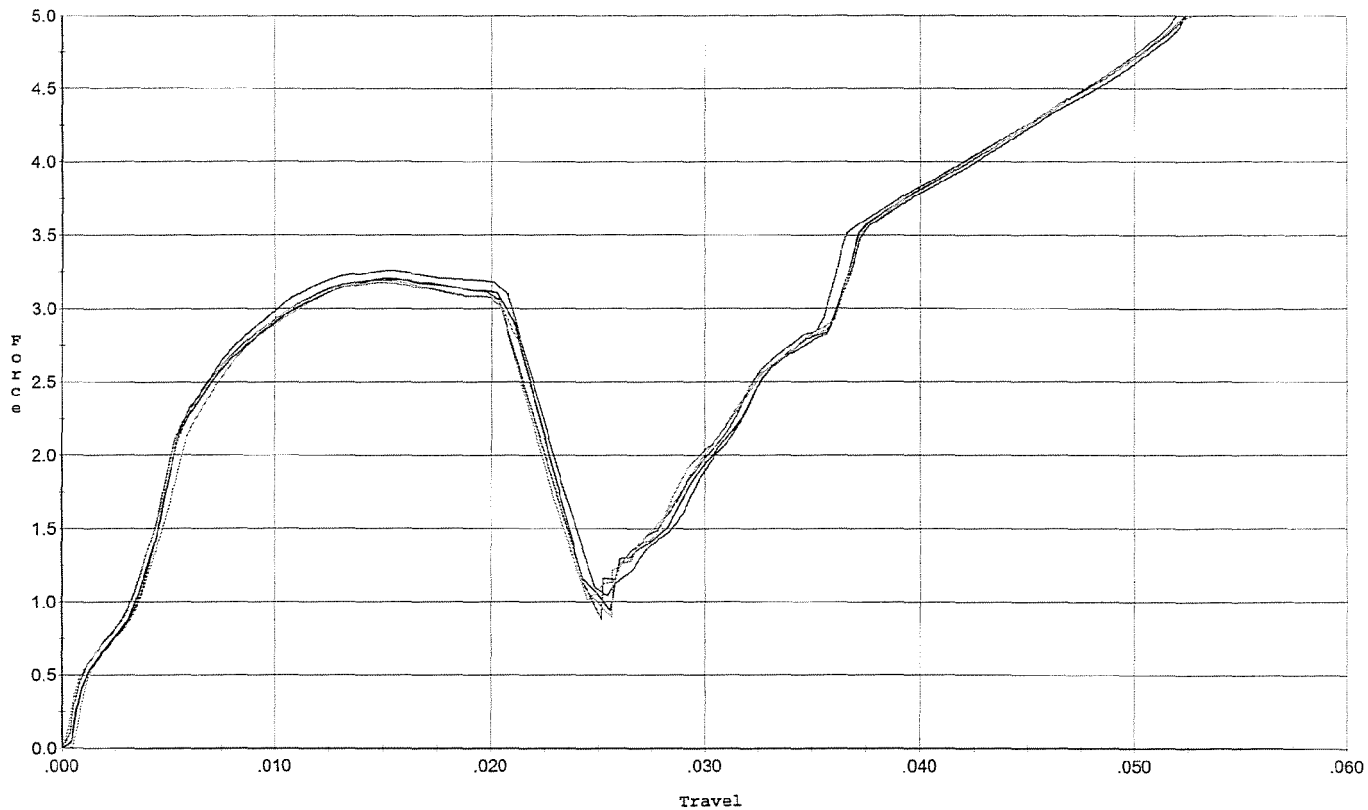
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.020	0.00	0.033	0.046		Set Trigger
2	3.082	0.020	0.00	0.033	0.046		Set Trigger
3	3.126	0.020	0.00	0.033	0.046		Set Trigger
4	3.155	0.022	0.00	0.032	0.050		Set Trigger
5	3.137	0.021	0.00	0.033	0.047		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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



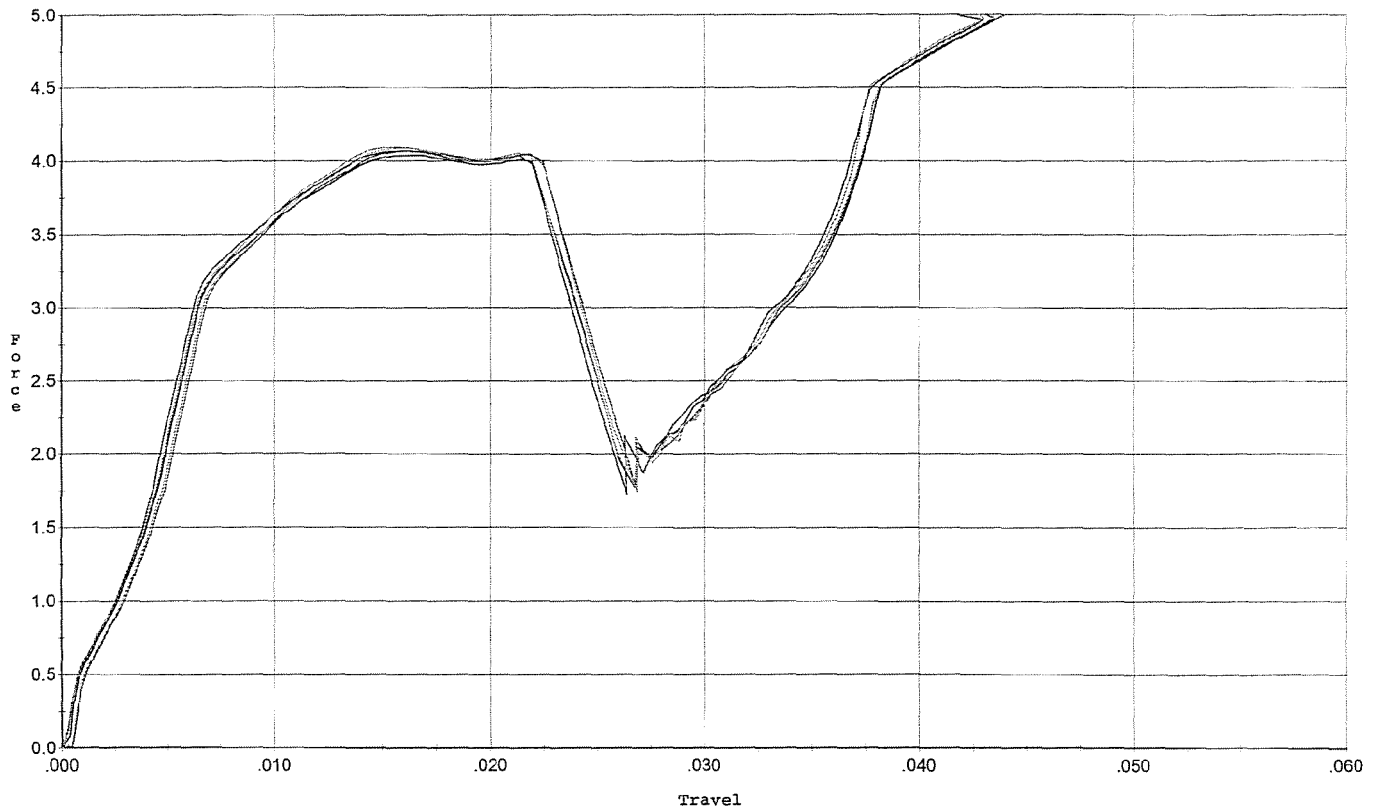
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.021	0.00	0.033	0.048		Set Trigger
2	3.207	0.021	0.00	0.033	0.048		Set Trigger
3	3.198	0.020	0.00	0.033	0.047		Set Trigger
4	3.175	0.020	0.00	0.033	0.047		Set Trigger
5	3.185	0.021	0.00	0.033	0.048		Set Trigger

Avg ③ RP
 3.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/31/09

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



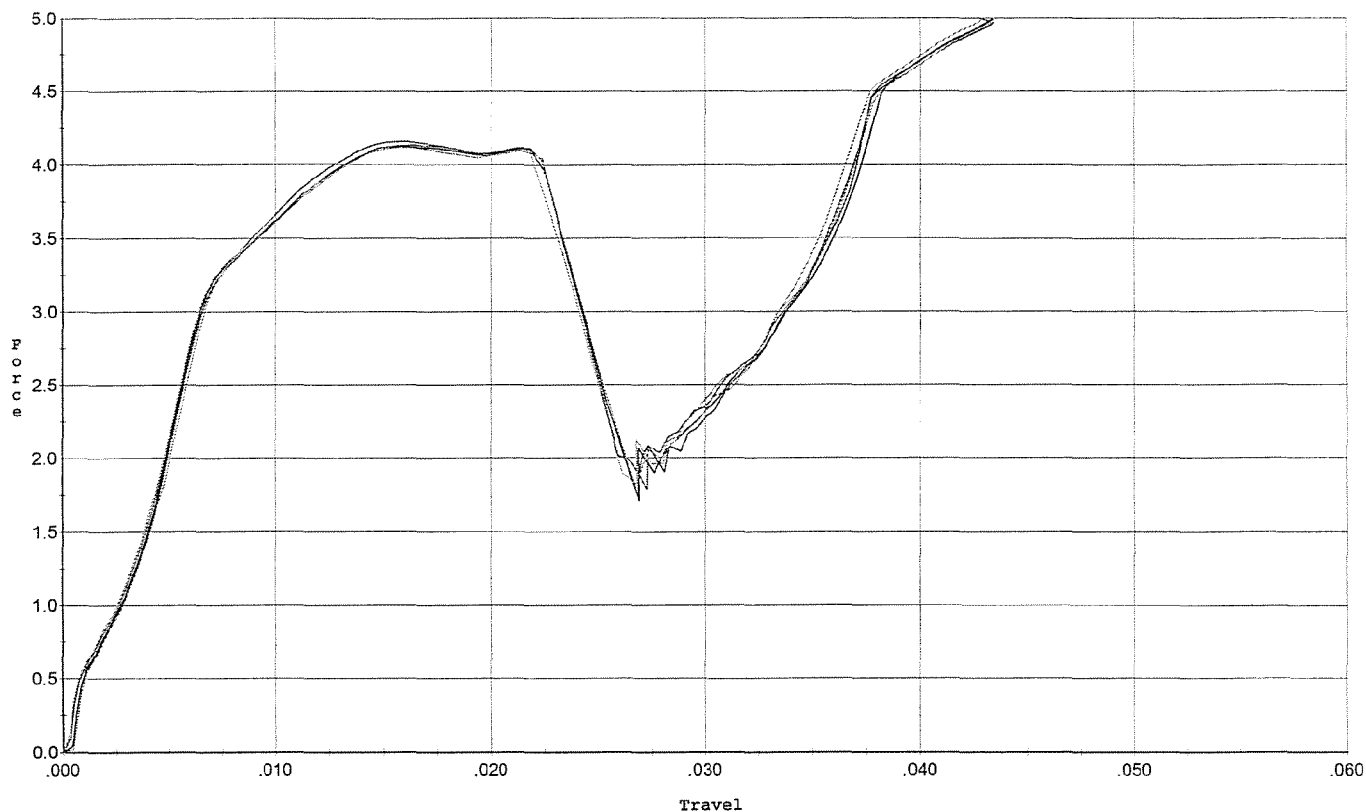
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.068	0.022	0.00	0.030	0.064		Set Trigger
2	4.037	0.024	0.00	0.030	0.068		Set Trigger
3	4.066	0.022	0.00	0.030	0.064		Set Trigger
4	4.087	0.022	0.00	0.030	0.065		Set Trigger
5	4.093	0.024	0.00	0.030	0.069		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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



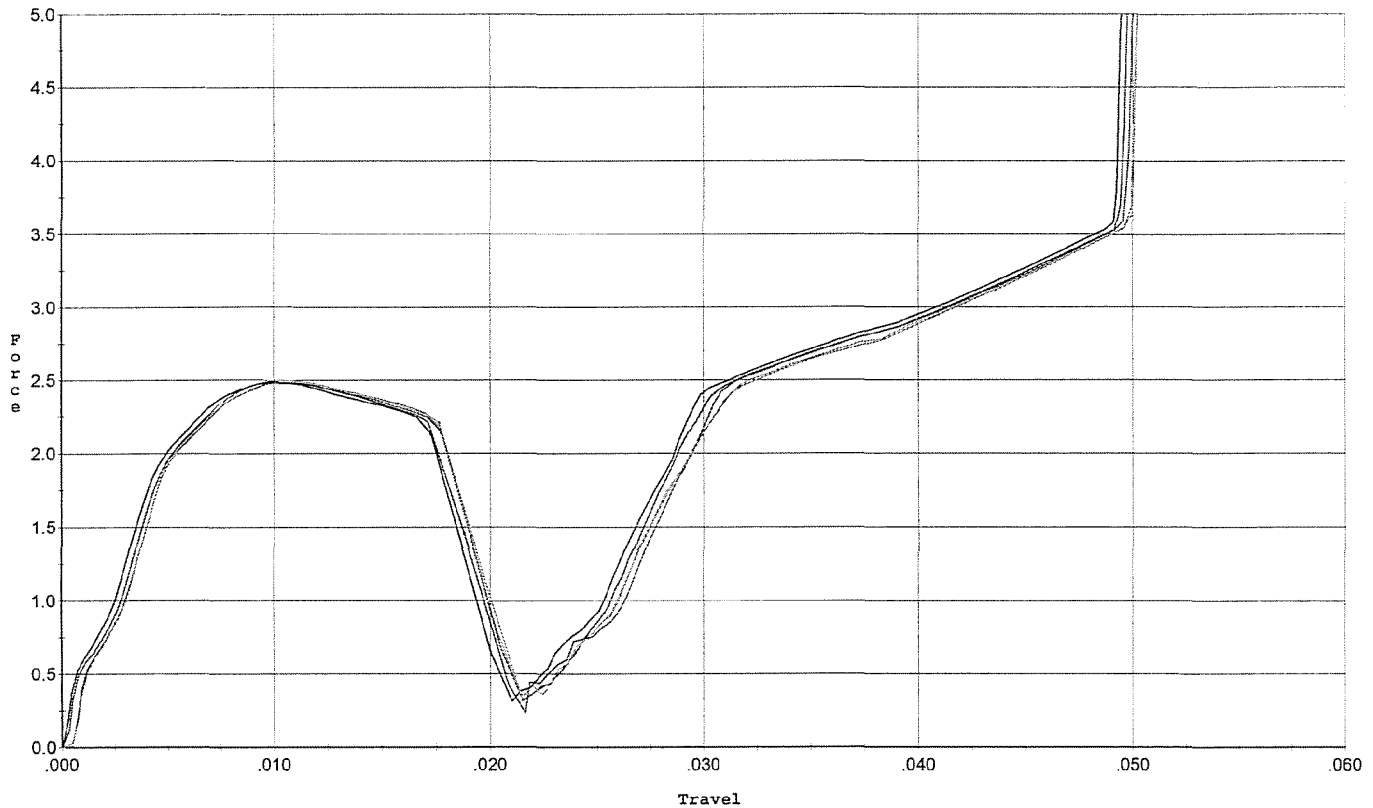
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.022	0.00	0.030	0.065		Set Trigger
2	4.129	0.022	0.00	0.030	0.066		Set Trigger
3	4.156	0.022	0.00	0.030	0.067		Set Trigger
4	4.118	0.023	0.00	0.030	0.069		Set Trigger
5	4.130	0.022	0.00	0.030	0.065		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/31/09

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



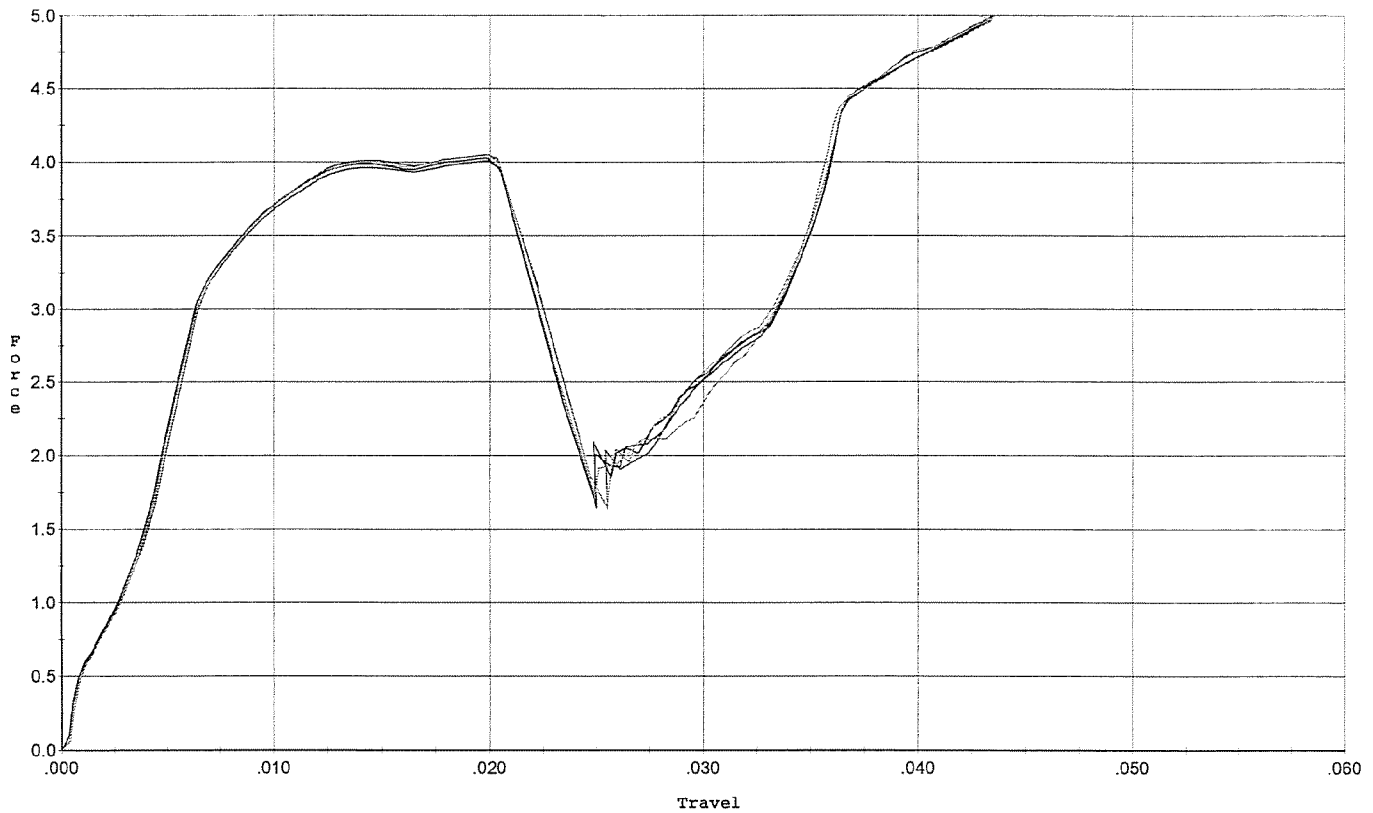
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.019	0.00	0.034	0.034		Set Trigger
2	2.485	0.017	0.00	0.034	0.032		Set Trigger
3	2.488	0.018	0.00	0.034	0.032		Set Trigger
4	2.502	0.018	0.00	0.035	0.033		Set Trigger
5	2.489	0.018	0.00	0.035	0.032		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/31/09

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	4.009	0.020	0.00	0.031	0.058		Set Trigger
2	4.029	0.021	0.00	0.031	0.058		Set Trigger
3	4.047	0.022	0.00	0.030	0.063		Set Trigger
4	4.050	0.020	0.00	0.031	0.058		Set Trigger
5	4.052	0.022	0.00	0.030	0.063		Set Trigger

Aug 4.03