

G685-2271

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



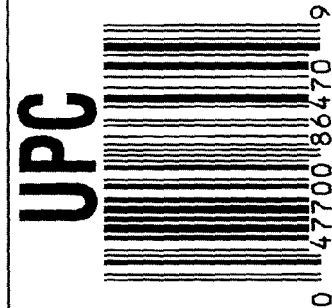
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

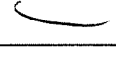
CAPACITY 6

G6852271



GUN SERIAL #

G6852271

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-5-09	RP
430	ASSEMBLE TO STOCK		5-5-09	JP
440	PROOF		5-5-09	RP
460	CHECK HEADSPACE	MAGNA FLUX	5-5-09	RP
470	DIS-ASSEMBLE ACTION		5-5-09	RP
472	SERIALIZE BOLT HANDLE		5-6-09	KJZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/8/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/12/09	RT
510	DRILL AND TAP SIGHT HOLES		5-6-09	JP
520	GOFF BLAST BBL / REC		5/12/09	REM
540	APPLY COATINGS (BARREL ACTION)		5/22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		5-26-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-26-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-26-09	JP
	D) OIL FIRING PIN ASSEMBLY		5-29-09	AD J.
	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>40</u> <u>40</u> <u>40</u>	6-19-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	6-19-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	6-19-09	LN
	J) ASSEMBLE STOCK		5-29-09	LN
	K) ASSEMBLE SWIVEL STUDS		6-19-09	LN
	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	6-9-09	LN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-9-09	RF
670	FINAL INSPECTION A) HEADSPACE		6-19-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>282</u> <u>277</u> <u>282</u> <u>274</u> <u>274</u>	6-19-09	LN
	C) FUNCTION		6-19-09	LN
690	PACK		7/20/09	FM

F004 REV 5/2006

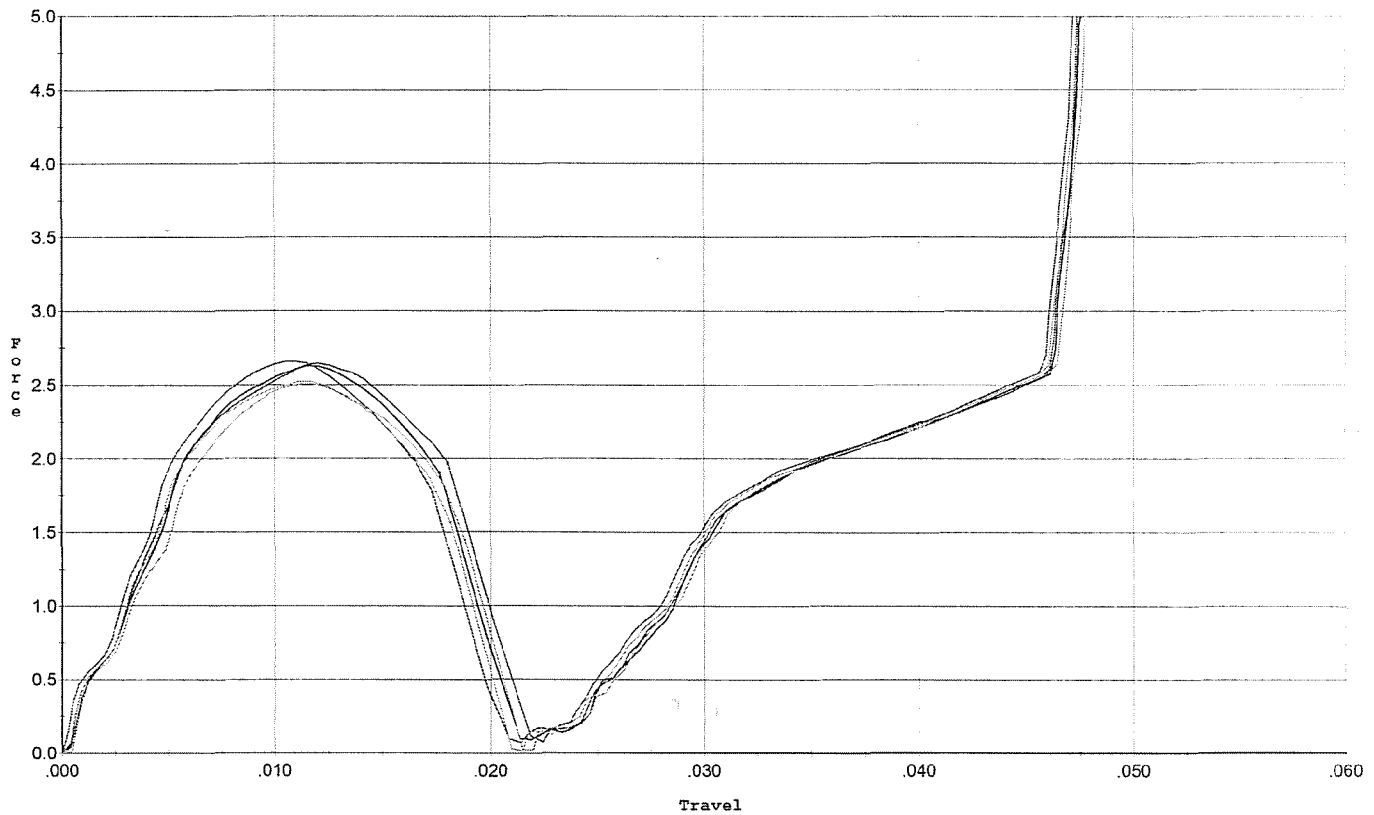
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 ~~0096110~~ 0096149

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



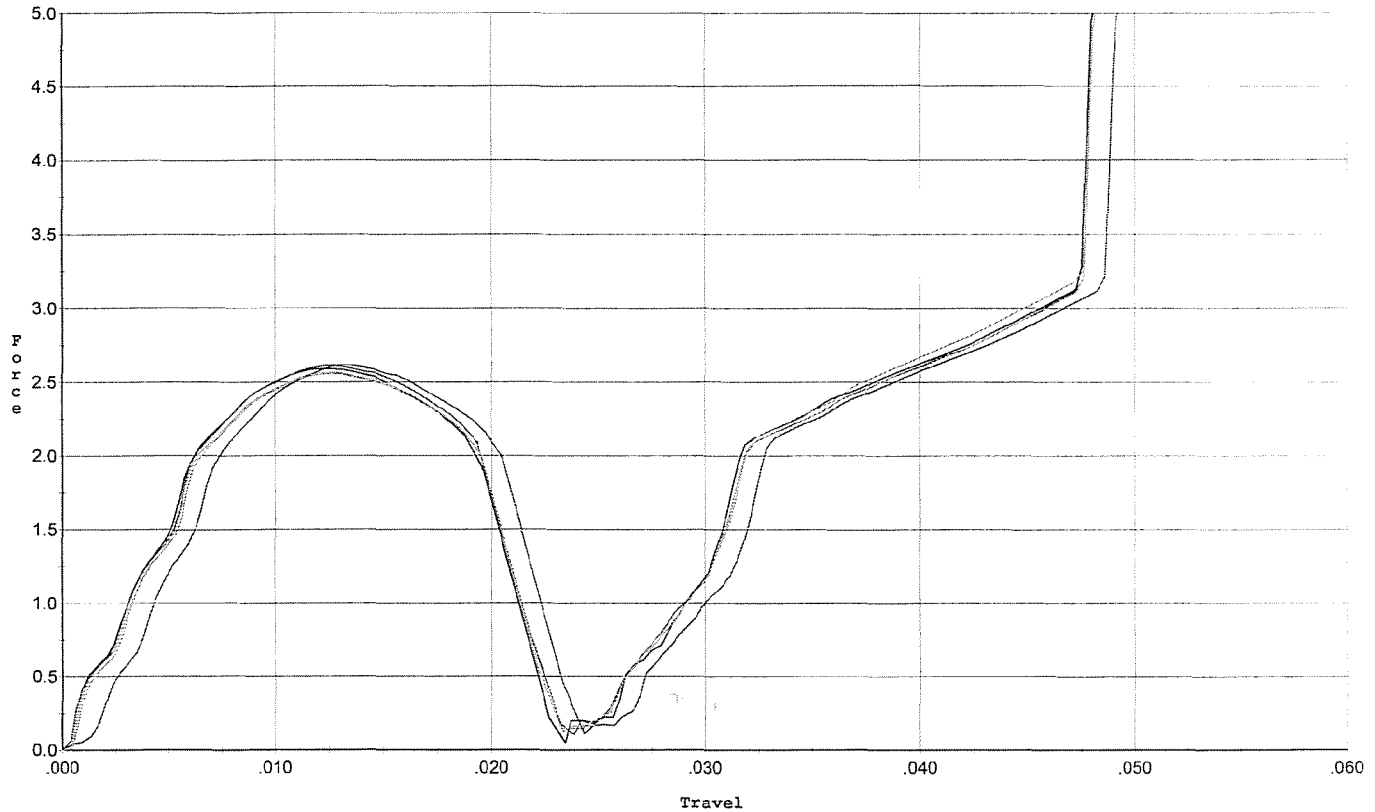
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.647	0.018	0.00	0.033	0.033		Set Trigger
2	2.628	0.018	0.00	0.034	0.032		Set Trigger
3	2.658	0.017	0.00	0.034	0.032		Set Trigger
4	2.524	0.018	0.00	0.034	0.032		Set Trigger
5	2.508	0.019	0.00	0.034	0.032		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



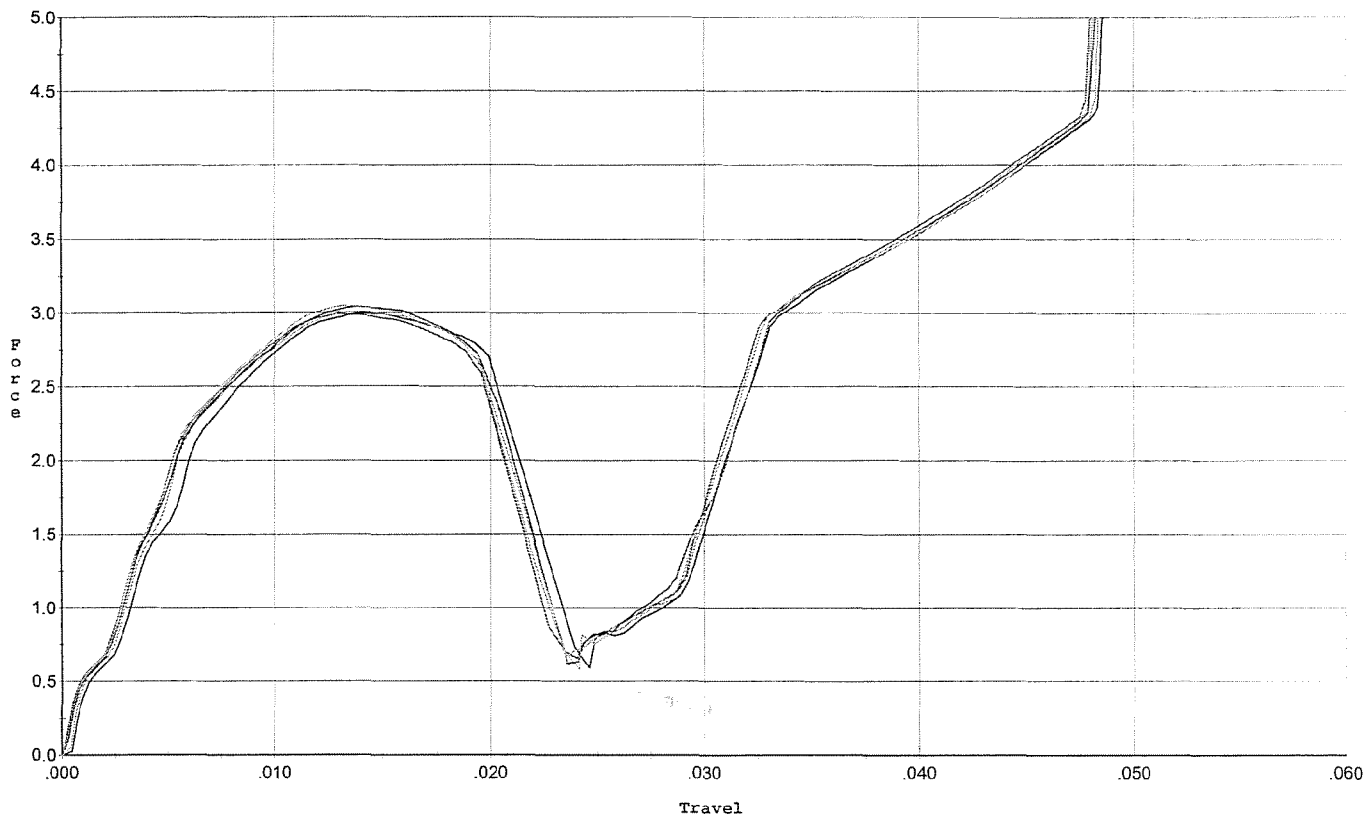
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.020	0.00	0.033	0.036		Set Trigger
2	2.590	0.020	0.00	0.032	0.036		Set Trigger
3	2.612	0.019	0.00	0.032	0.036		Set Trigger
4	2.564	0.019	0.00	0.032	0.035		Set Trigger
5	2.551	0.019	0.00	0.032	0.035		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



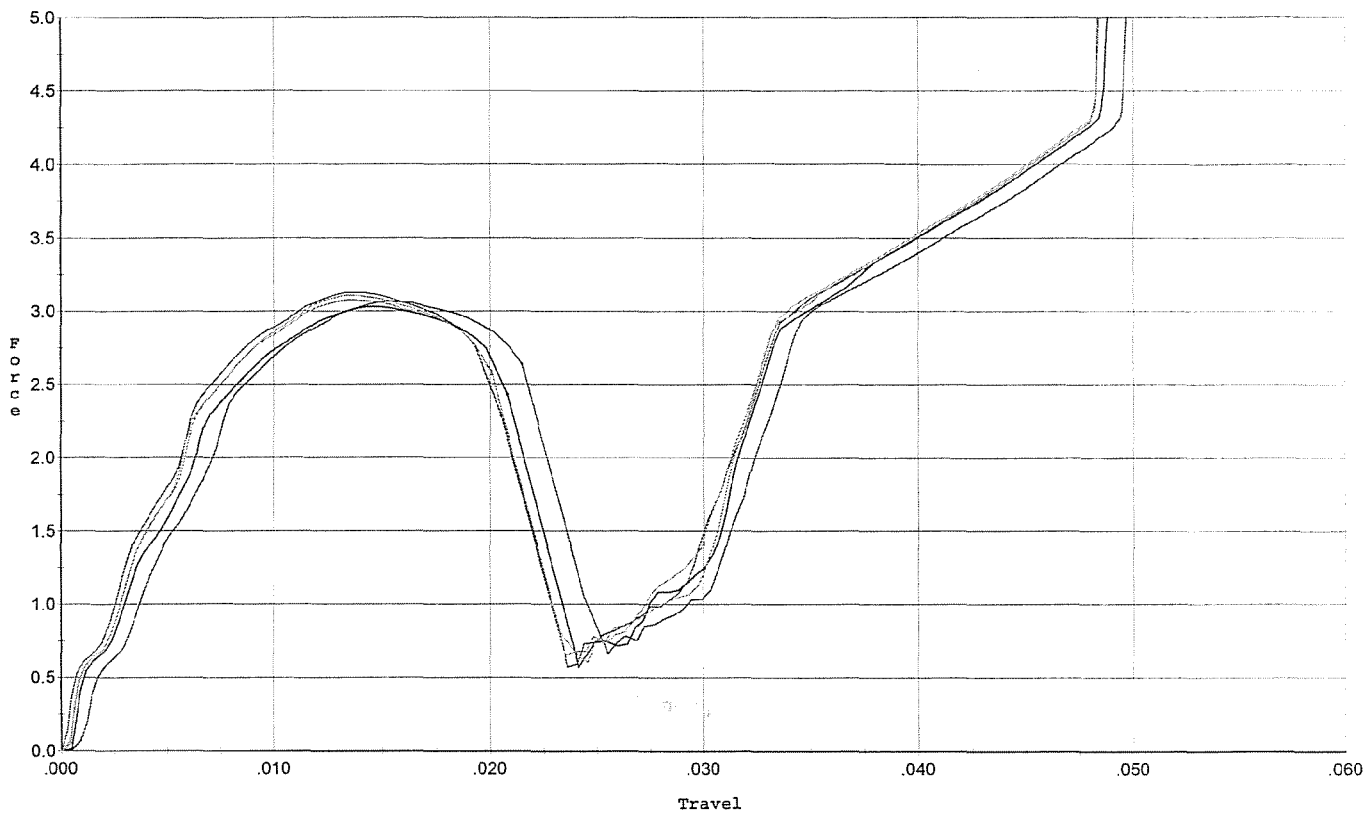
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.041	0.020	0.00	0.031	0.044		Set Trigger
2	2.994	0.022	0.00	0.031	0.046		Set Trigger
3	2.991	0.020	0.00	0.031	0.042		Set Trigger
4	3.049	0.019	0.00	0.031	0.042		Set Trigger
5	3.008	0.021	0.00	0.031	0.045		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



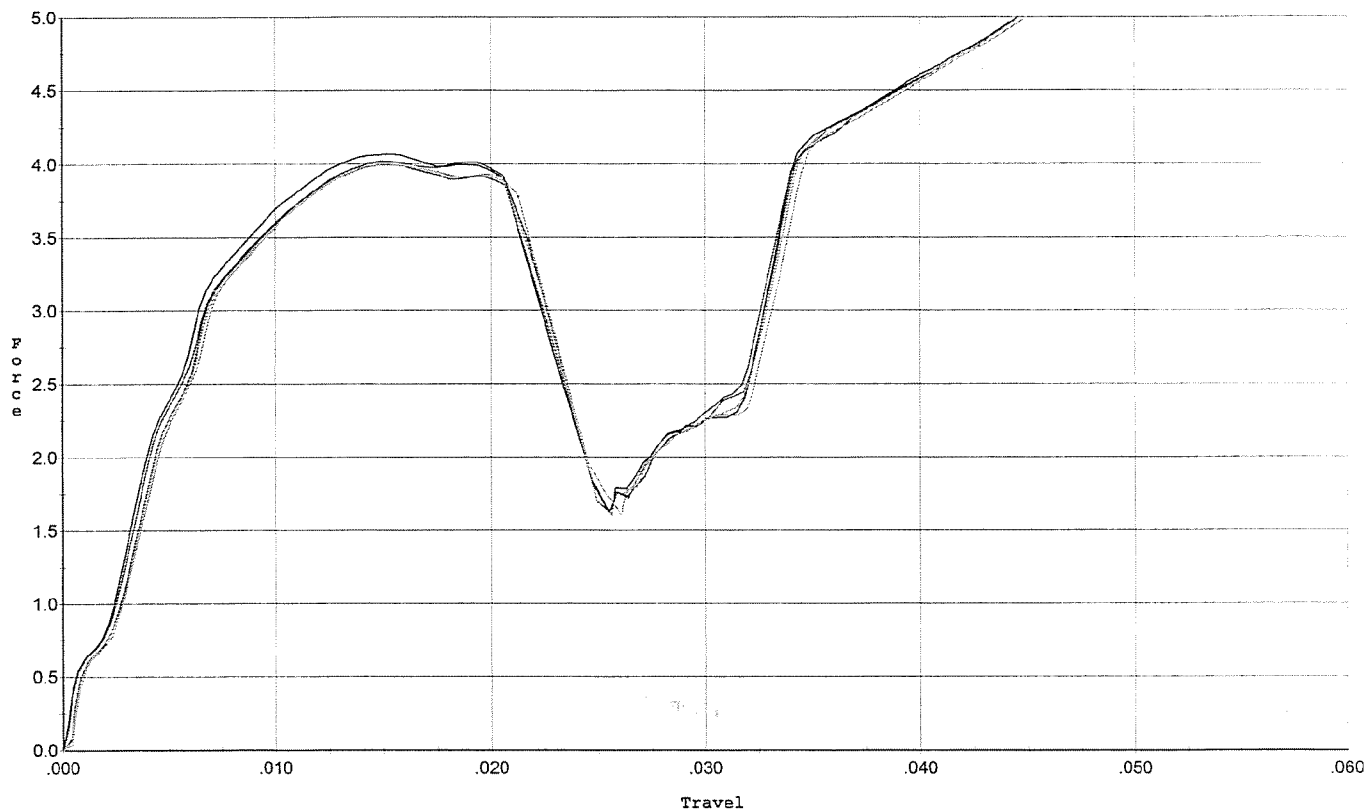
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.021	0.00	0.032	0.045		Set Trigger
2	3.032	0.021	0.00	0.031	0.044		Set Trigger
3	3.128	0.021	0.00	0.031	0.046		Set Trigger
4	3.110	0.020	0.00	0.031	0.044		Set Trigger
5	3.078	0.020	0.00	0.031	0.044		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



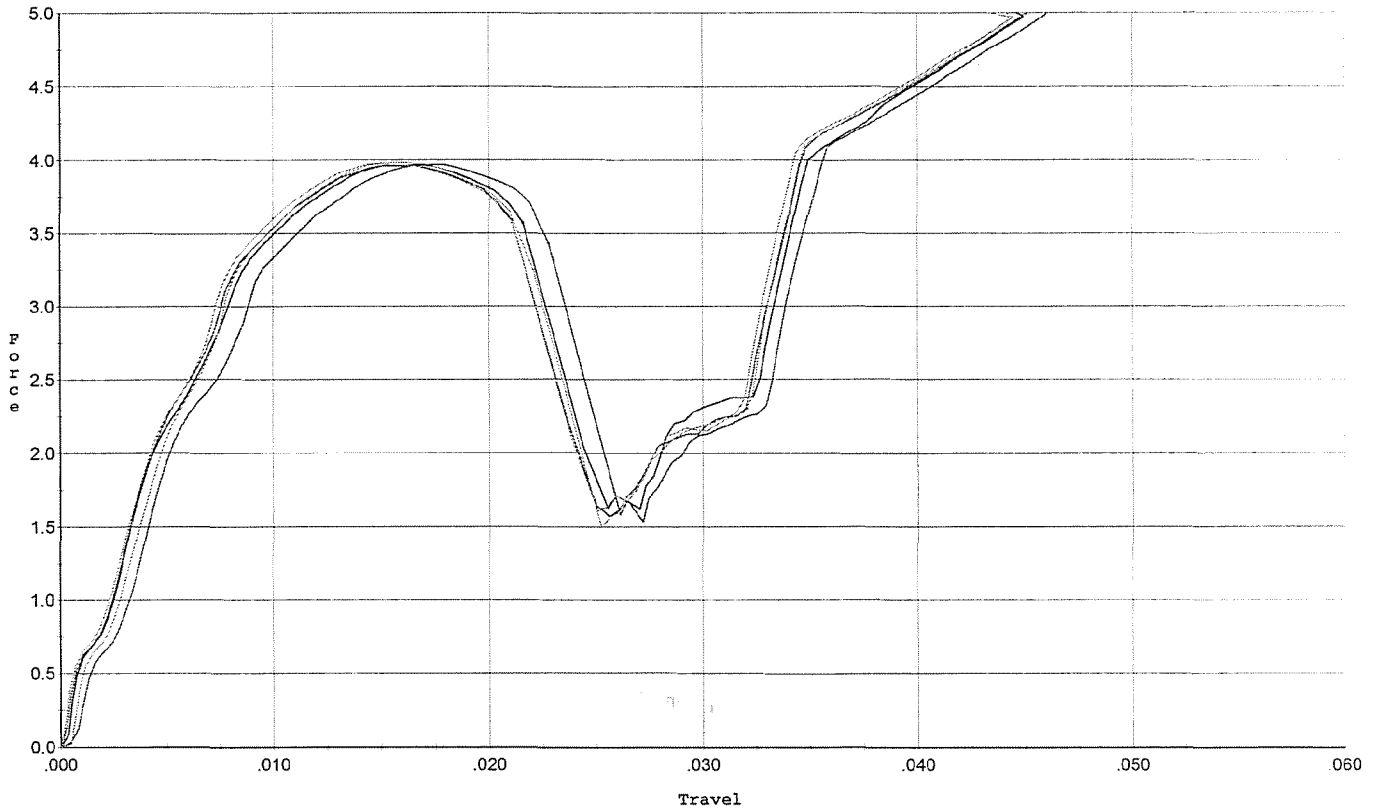
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.017	0.022	0.00	0.028	0.062		Set Trigger
2	4.069	0.021	0.00	0.028	0.059		Set Trigger
3	3.989	0.023	0.00	0.028	0.063		Set Trigger
4	3.989	0.022	0.00	0.028	0.062		Set Trigger
5	3.999	0.021	0.00	0.028	0.060		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



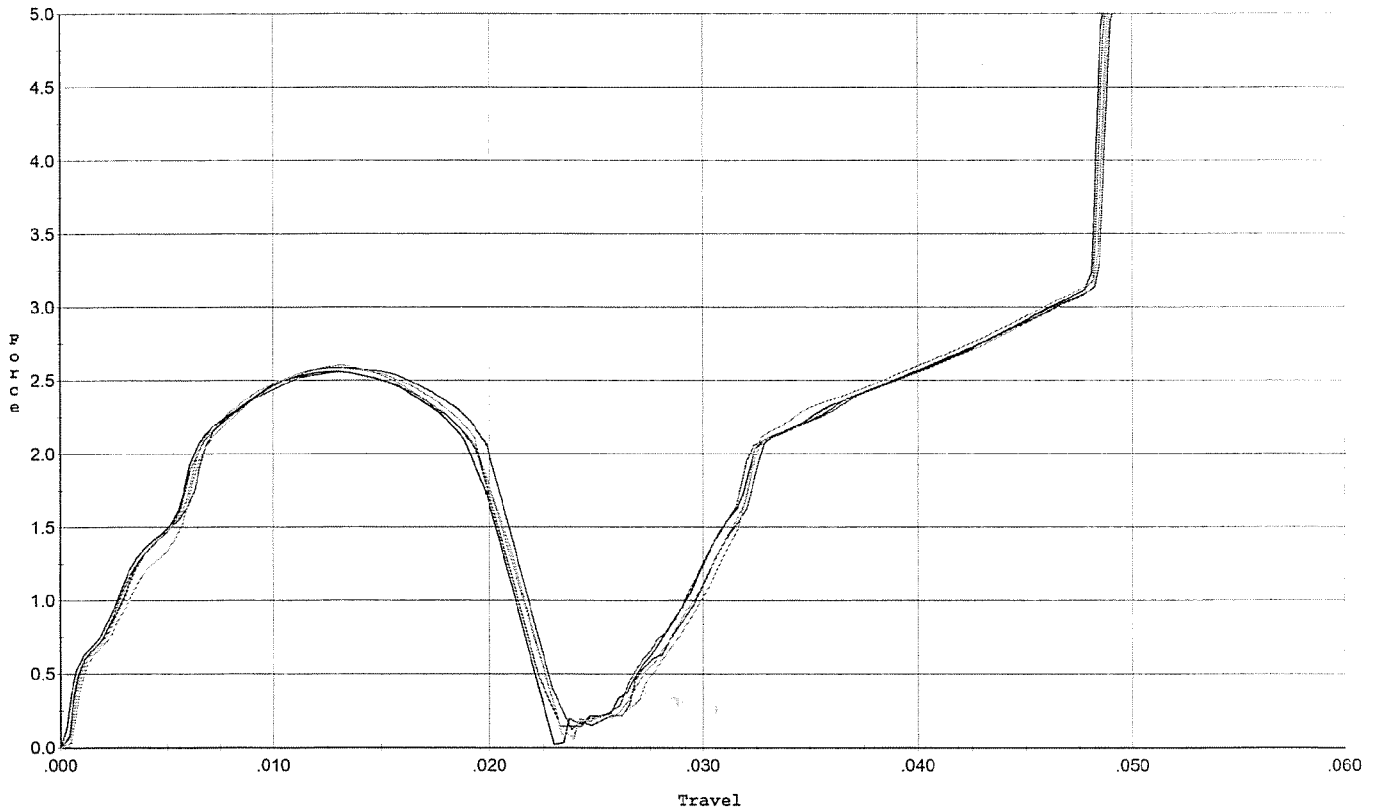
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.969	0.023	0.00	0.029	0.061		Set Trigger
2	3.966	0.022	0.00	0.029	0.060		Set Trigger
3	3.961	0.021	0.00	0.029	0.058		Set Trigger
4	3.981	0.022	0.00	0.028	0.061		Set Trigger
5	3.977	0.021	0.00	0.029	0.059		Set Trigger

AUG 287

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



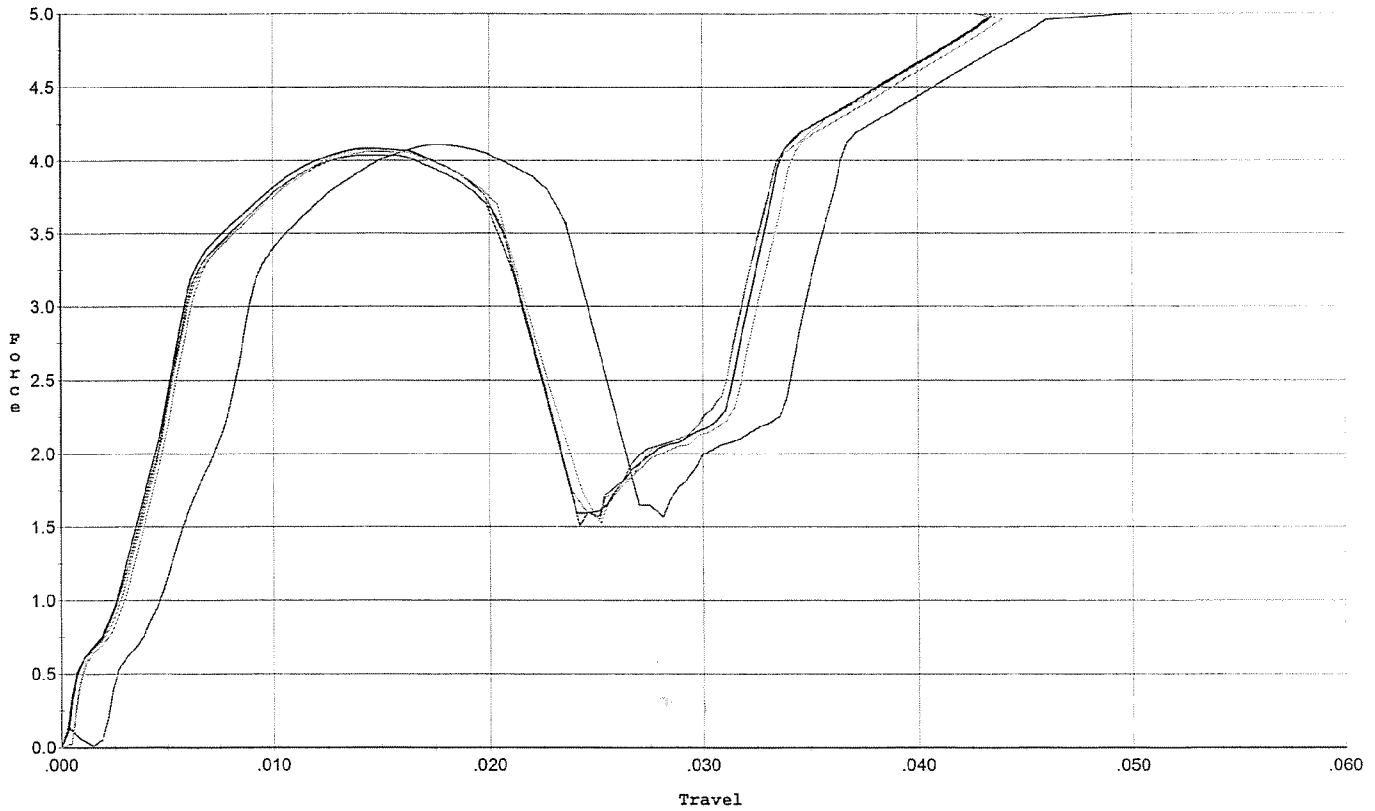
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.020	0.00	0.033	0.037		Set Trigger
2	2.558	0.020	0.00	0.033	0.037		Set Trigger
3	2.555	0.019	0.00	0.033	0.036		Set Trigger
4	2.604	0.021	0.00	0.032	0.038		Set Trigger
5	2.589	0.021	0.00	0.032	0.039		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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	4.109	0.024	0.002	0.029	0.063		Set Trigger
2	4.083	0.021	0.00	0.028	0.060		Set Trigger
3	4.038	0.021	0.00	0.029	0.060		Set Trigger
4	4.074	0.020	0.00	0.029	0.058		Set Trigger
5	4.061	0.021	0.00	0.029	0.059		Set Trigger

Avg 4.07