

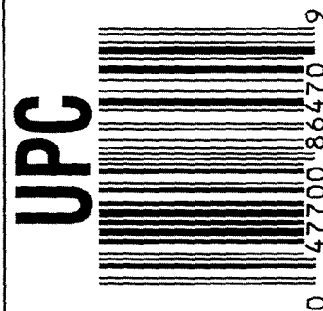
G6852317

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

G6852317



BM FORM

GUN SERIAL # G6852317

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-15-09	RPD
430	ASSEMBLE TO STOCK		4-15-09	RP
440	PROOF		4-15-09	RPD
460	CHECK HEADSPACE		4-15-09	RP
470	DIS-ASSEMBLE ACTION		4-15-09	RP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	4-16-09	GT
475	DRILL AND TAP SIGHT HOLES	APR 18 2009	4-16-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	4/18/09	(B)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/30/09	RT
520	GOFF BLAST BBL / REC		4/31/09	L.M.
542	APPLY COATINGS (BARREL ACTION)		4/27	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-22-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-22-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-22-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-29-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

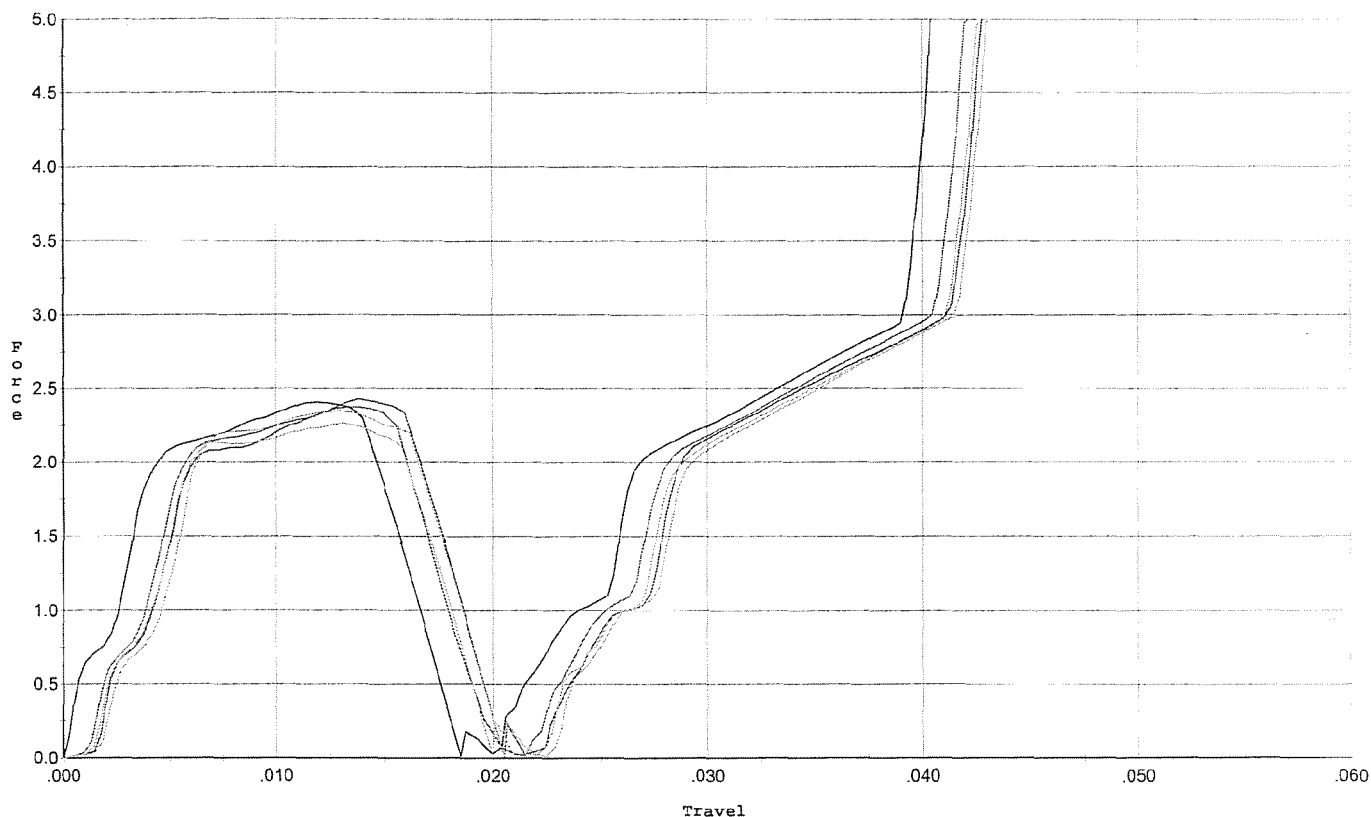
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3.0</u>	<u>3.0</u>	<u>3.0</u>	5-13-09	SPD		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	5-13-09	SPD		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	5-13-09	SPD		
	J) ASSEMBLE STOCK					4-28-09	W		
	K) ASSEMBLE SWIVEL STUDS					5-13-09	SPD		
	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		4-30-09	W		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION	N/A					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					4-30-09	TQR		
670	FINAL INSPECTION A) HEADSPACE					5-13-09	SPD		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u>	<u>2.72</u>	<u>2.71</u>	<u>2.73</u>	<u>2.79</u>	5-7-09	FR
	C) FUNCTION					5-13-09	SPD		
690	PACK					5/18/09	Fay		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



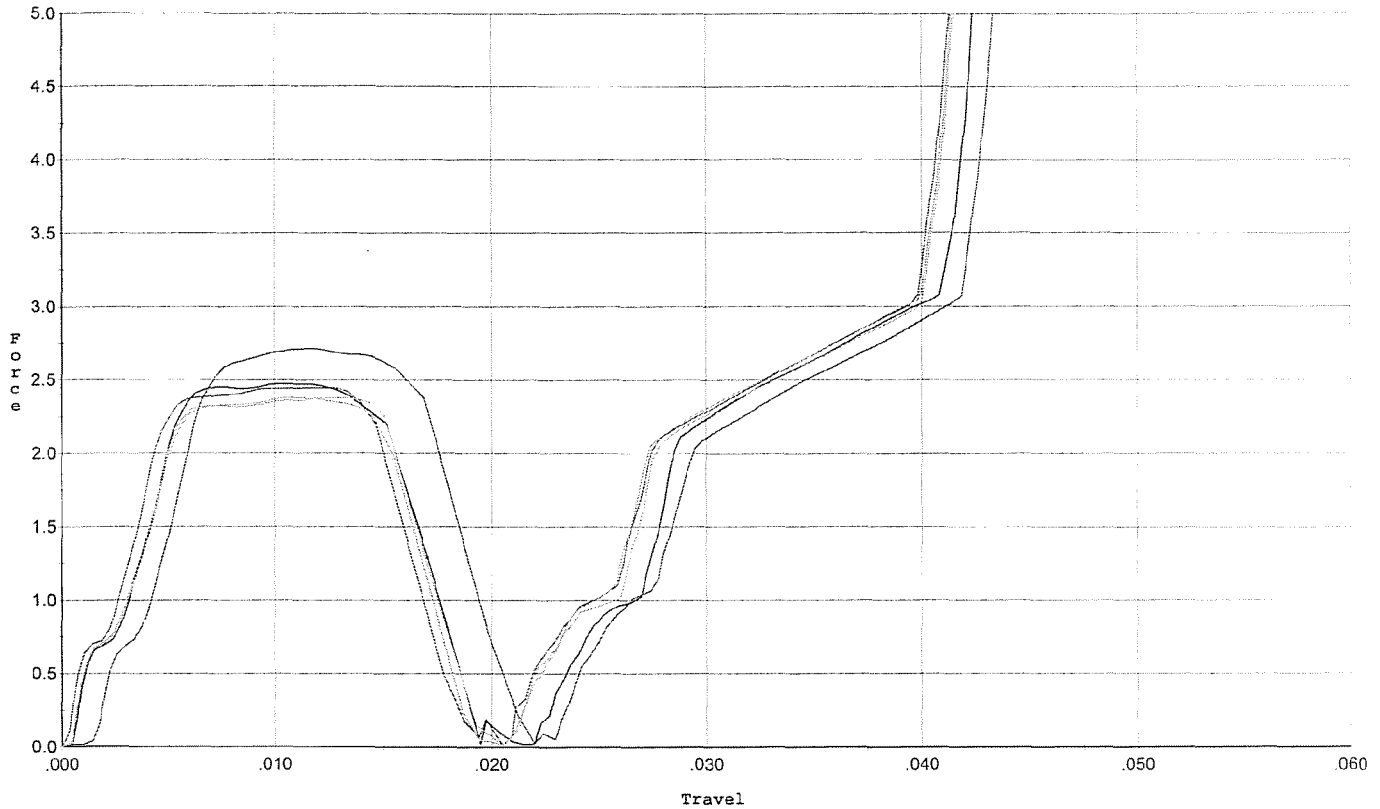
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.426	0.018	0.00	0.029	0.029		Set Trigger
2	2.405	0.016	0.00	0.029	0.028		Set Trigger
3	2.372	0.016	0.00	0.030	0.026		Set Trigger
4	2.264	0.018	0.00	0.030	0.027		Set Trigger
5	2.347	0.018	0.00	0.030	0.028		Set Trigger

A-2-36

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/9/2009

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



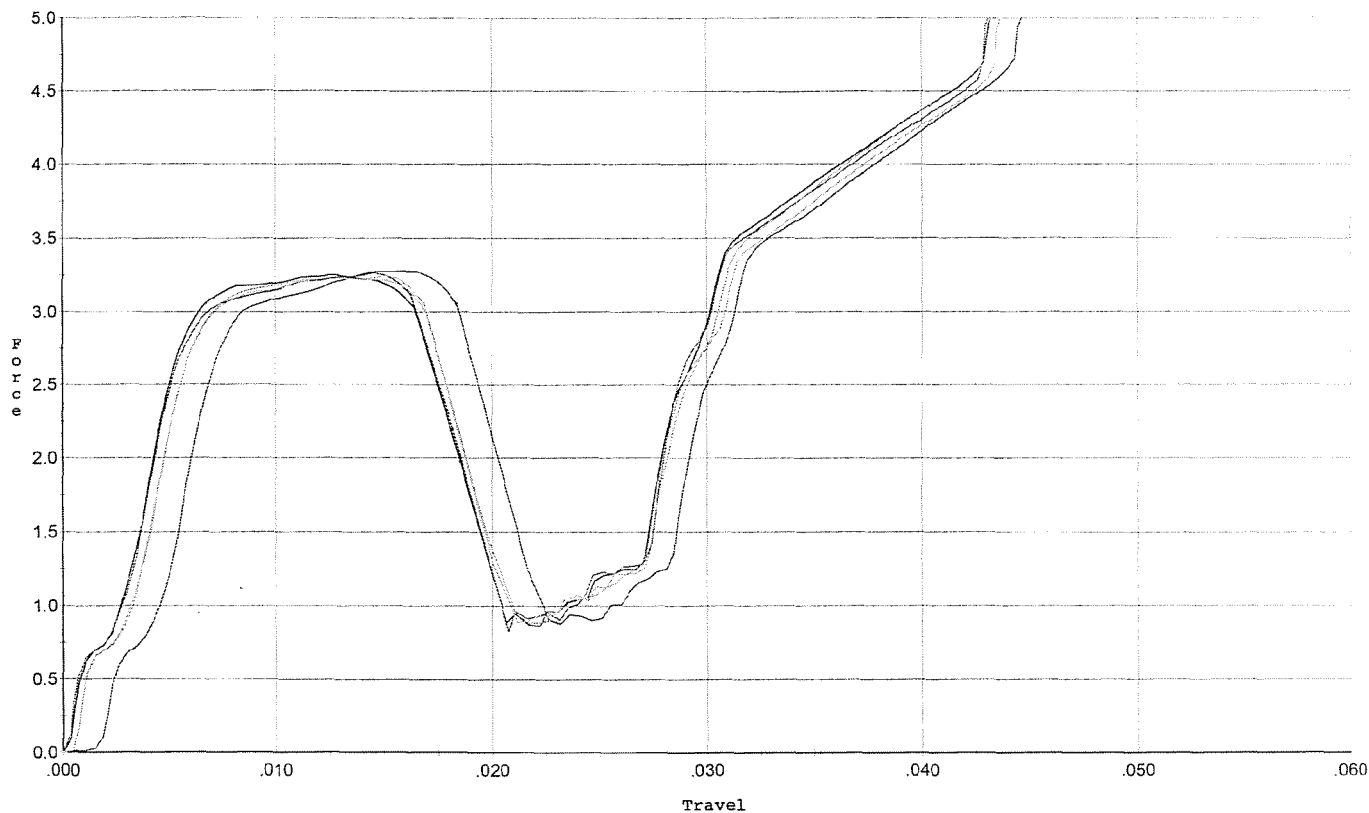
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.712	0.017	0.00	0.029	0.031		Set Trigger
2	2.472	0.017	0.00	0.030	0.030		Set Trigger
3	2.446	0.015	0.00	0.030	0.027		Set Trigger
4	2.377	0.015	0.00	0.030	0.026		Set Trigger
5	2.376	0.016	0.00	0.030	0.027		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



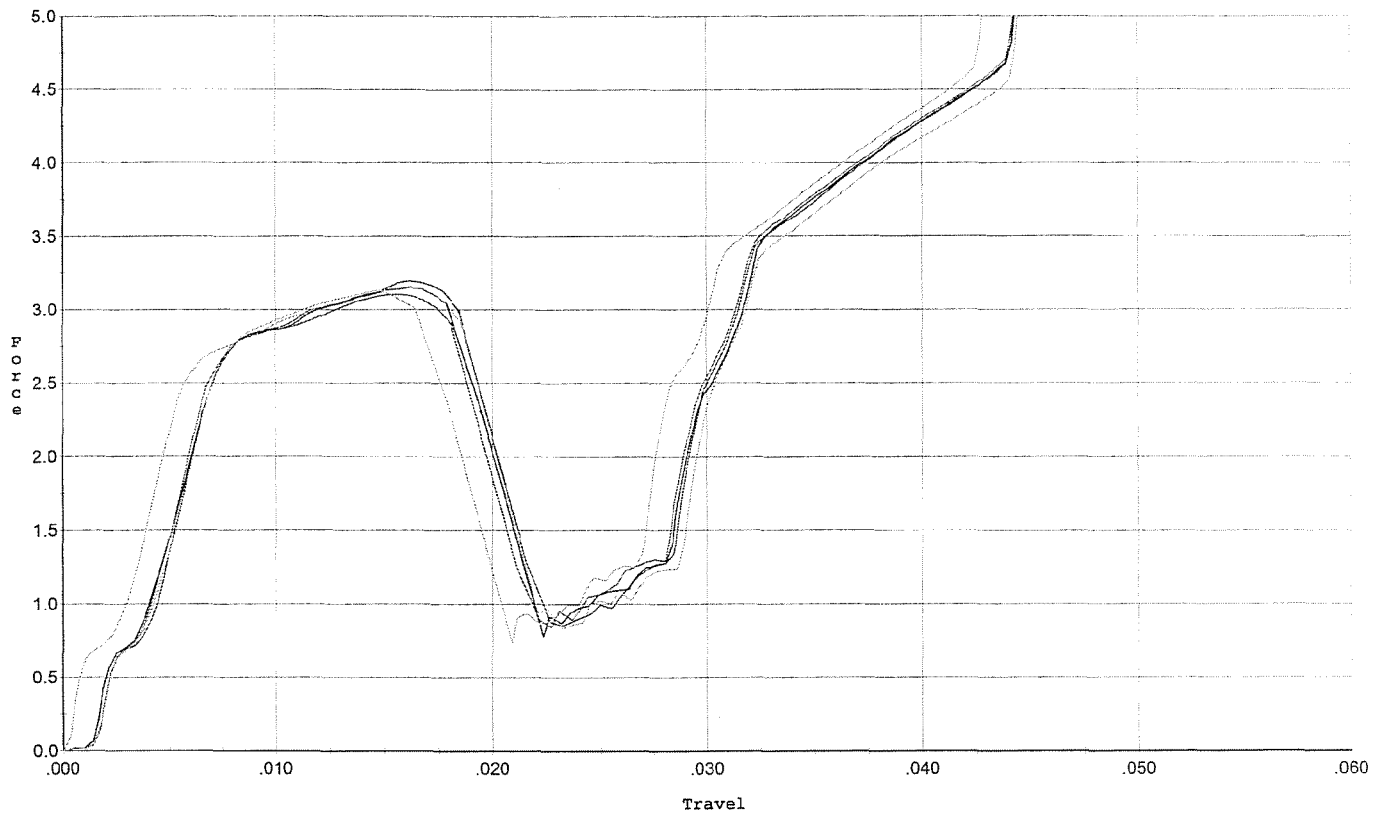
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.275	0.018	0.00	0.029	0.040		Set Trigger
2	3.250	0.018	0.00	0.028	0.043		Set Trigger
3	3.265	0.018	0.00	0.028	0.042		Set Trigger
4	3.232	0.017	0.00	0.029	0.038		Set Trigger
5	3.245	0.017	0.00	0.028	0.038		Set Trigger

A.3.25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



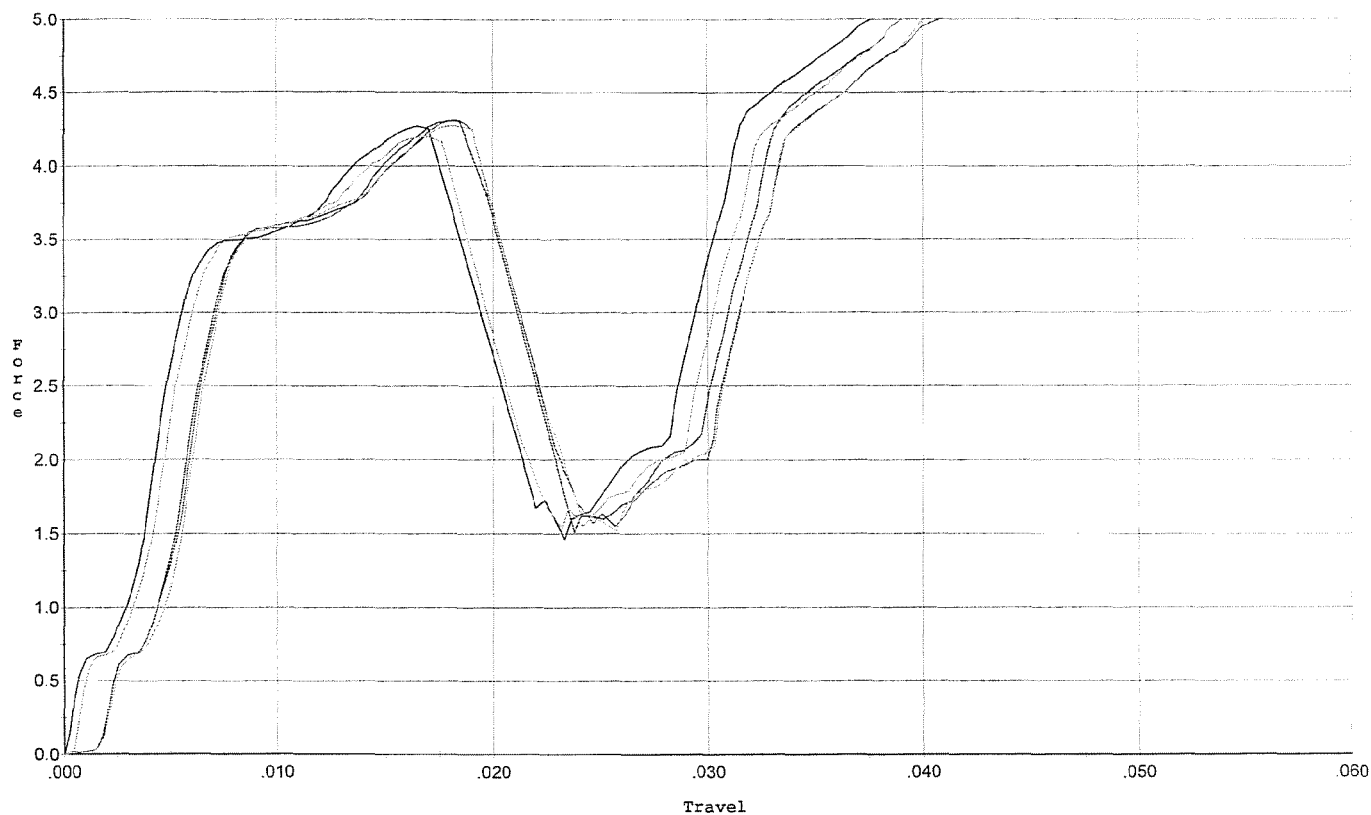
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.018	0.00	0.029	0.039		Set Trigger
2	3.154	0.019	0.00	0.029	0.041		Set Trigger
3	3.104	0.018	0.00	0.029	0.037		Set Trigger
4	3.150	0.019	0.00	0.029	0.039		Set Trigger
5	3.132	0.018	0.00	0.028	0.039		Set Trigger

A 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



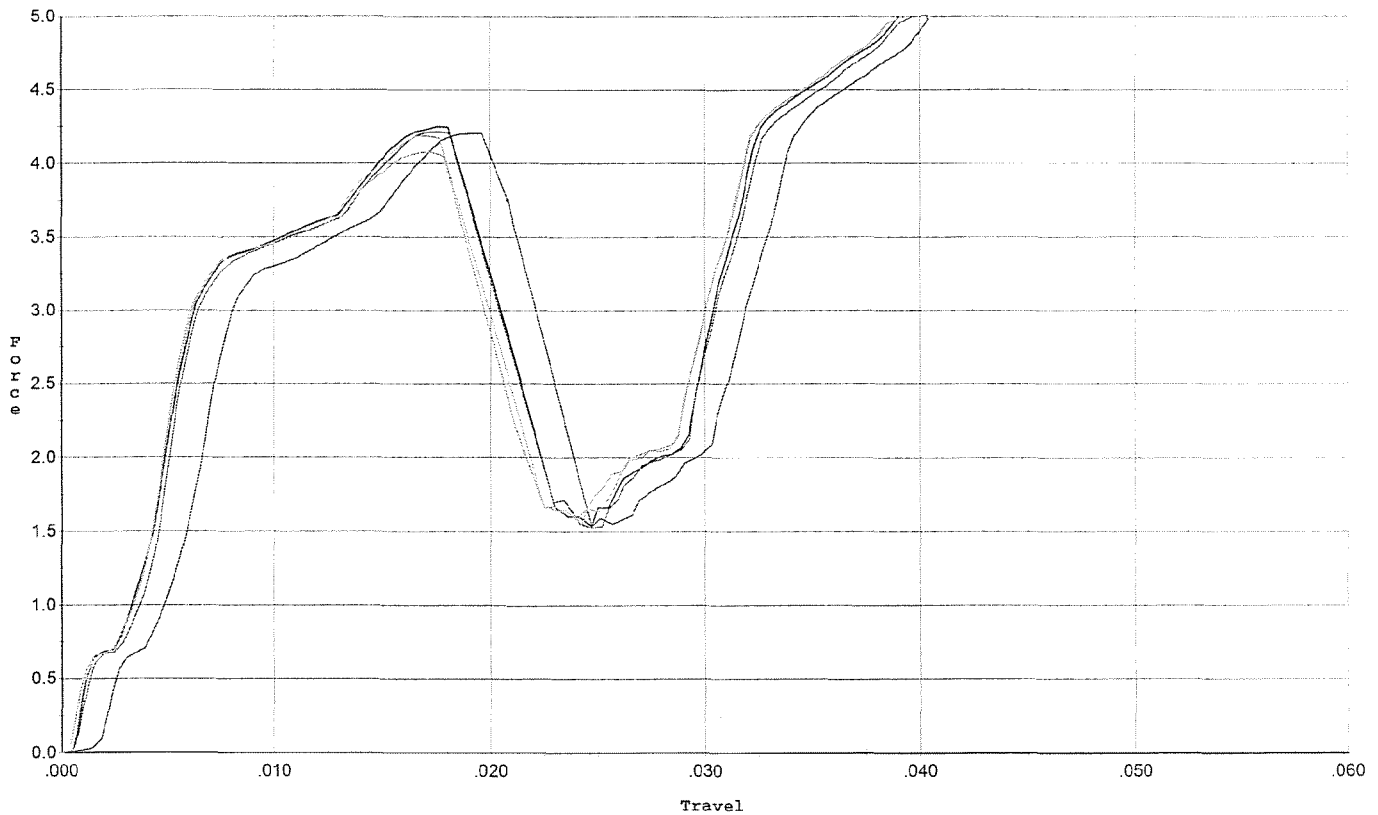
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.307	0.020	0.00	0.026	0.052		Set Trigger
2	4.272	0.019	0.00	0.026	0.054		Set Trigger
3	4.315	0.019	0.00	0.026	0.050		Set Trigger
4	4.273	0.019	0.00	0.026	0.050		Set Trigger
5	4.199	0.018	0.00	0.026	0.048		Set Trigger

A. 4.27

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



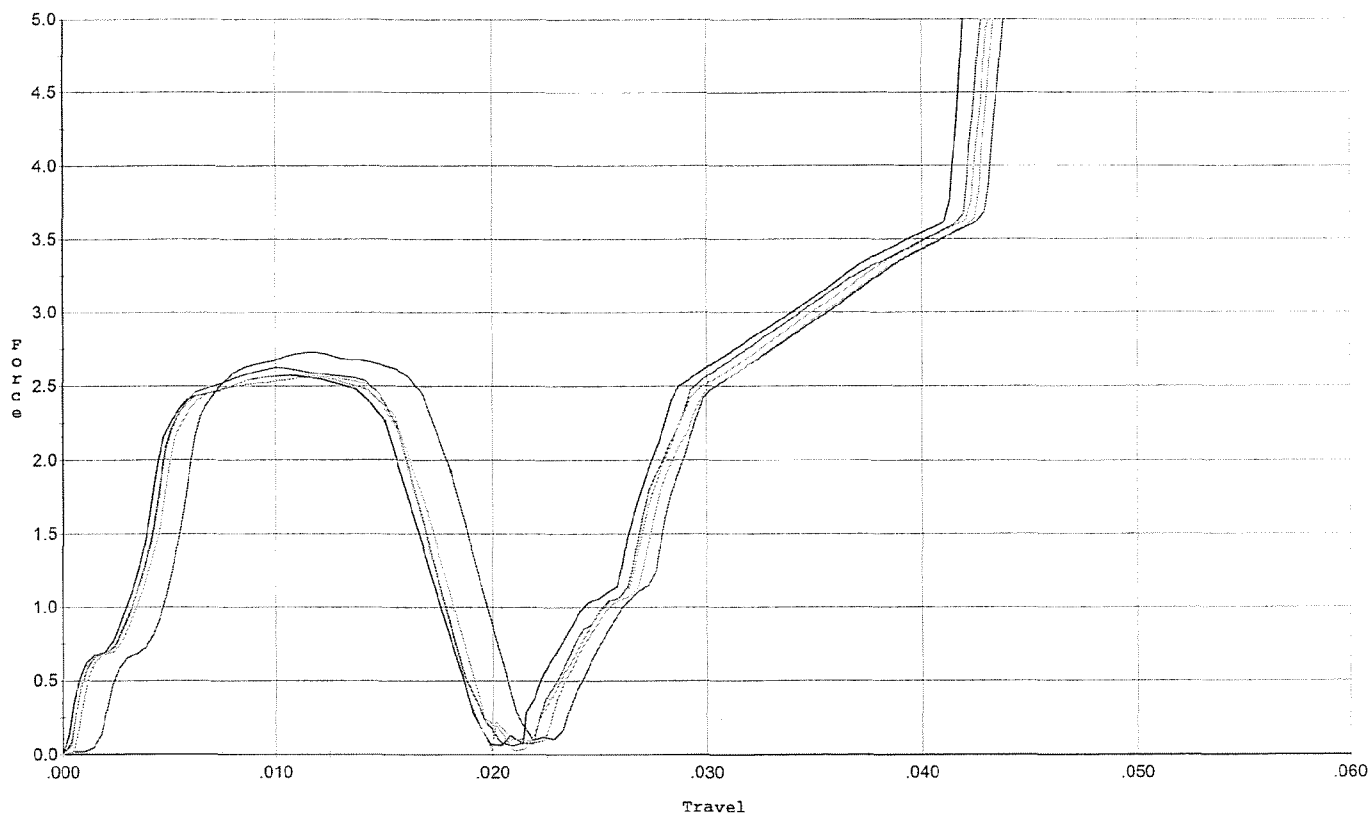
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.204	0.021	0.00	0.026	0.052		Set Trigger
2	4.249	0.020	0.00	0.026	0.055		Set Trigger
3	4.215	0.018	0.00	0.026	0.048		Set Trigger
4	4.188	0.020	0.00	0.026	0.053		Set Trigger
5	4.076	0.018	0.00	0.026	0.047		Set Trigger

A.4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/9/2009

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



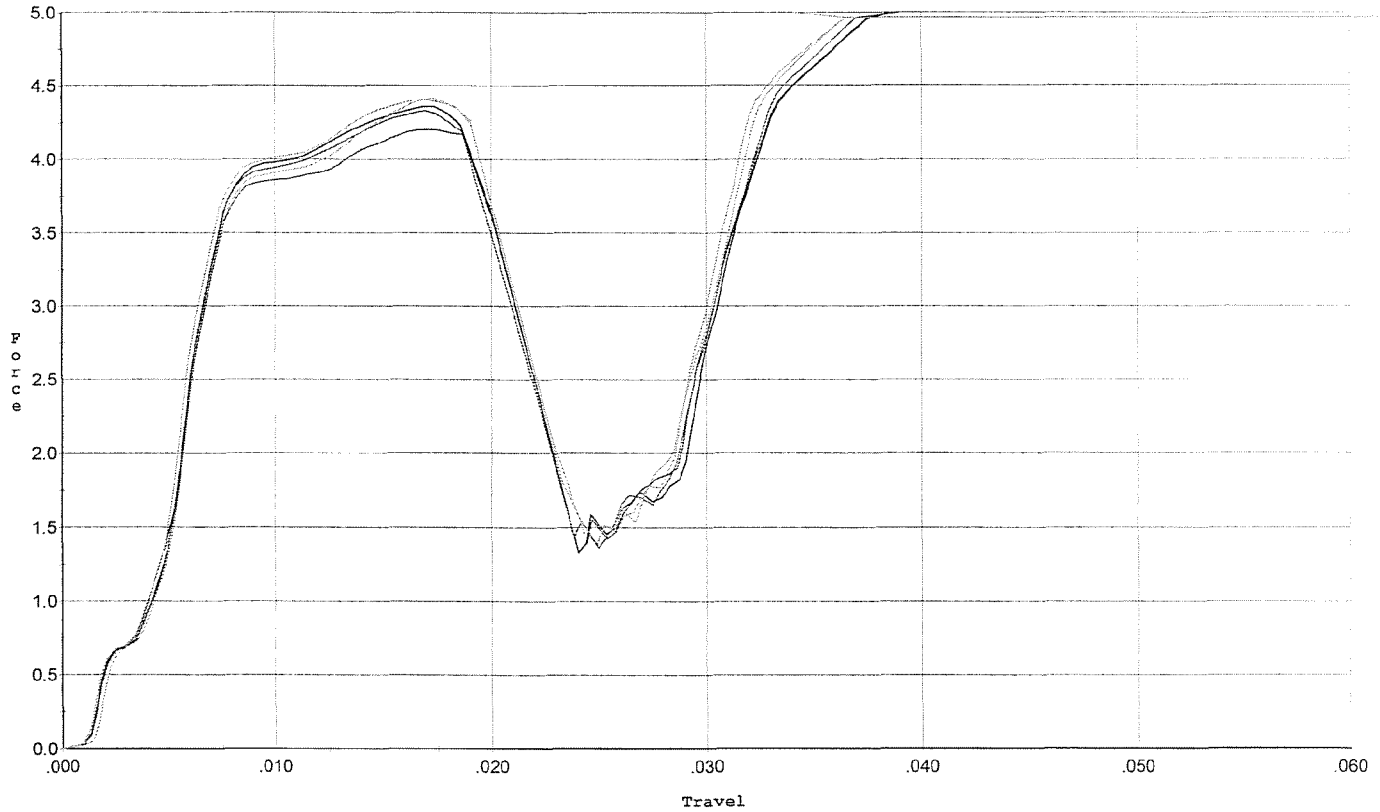
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.726	0.018	0.00	0.030	0.033		Set Trigger
2	2.574	0.015	0.00	0.030	0.028		Set Trigger
3	2.626	0.016	0.00	0.030	0.029		Set Trigger
4	2.578	0.017	0.00	0.030	0.031		Set Trigger
5	2.557	0.016	0.00	0.030	0.029		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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	4.204	0.020	0.00	0.026	0.055		Set Trigger
2	4.360	0.020	0.00	0.026	0.056		Set Trigger
3	4.331	0.021	0.00	0.026	0.058		Set Trigger
4	4.416	0.019	0.00	0.026	0.053		Set Trigger
5	4.407	0.019	0.00	0.026	0.055		Set Trigger

A.4.34