

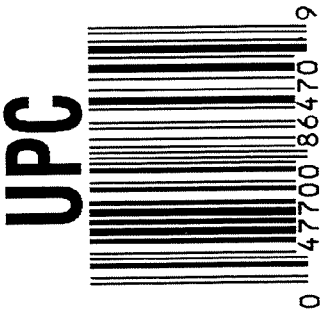
66810390

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     |

G6810390



BM FORM

GUN SERIAL #

G 6810390

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 2-26-09 | SP      |
| 430  | ASSEMBLE TO STOCK                                              |                     | 2-26-09 | RP      |
| 440  | PROOF                                                          |                     | 2-26-09 | SP      |
| 460  | CHECK HEADSPACE                                                |                     | 2-26-09 | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 2-26-09 | SP      |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 2-27-09 | KTR     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 2-27-09 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           |                     | 3/2/09  | (H)     |
| 490  | MAGNAFLUX BOLT                                                 |                     | 3/2/09  | MR      |
| 500  | ROLLMARK CALIBER                                               |                     | 3/2/09  | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 3/3/09  | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3/6     |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-9-09  | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 3-9-09  | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 3-9-09  | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 3-10-09 | R. N    |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

F004 REV 5/2006

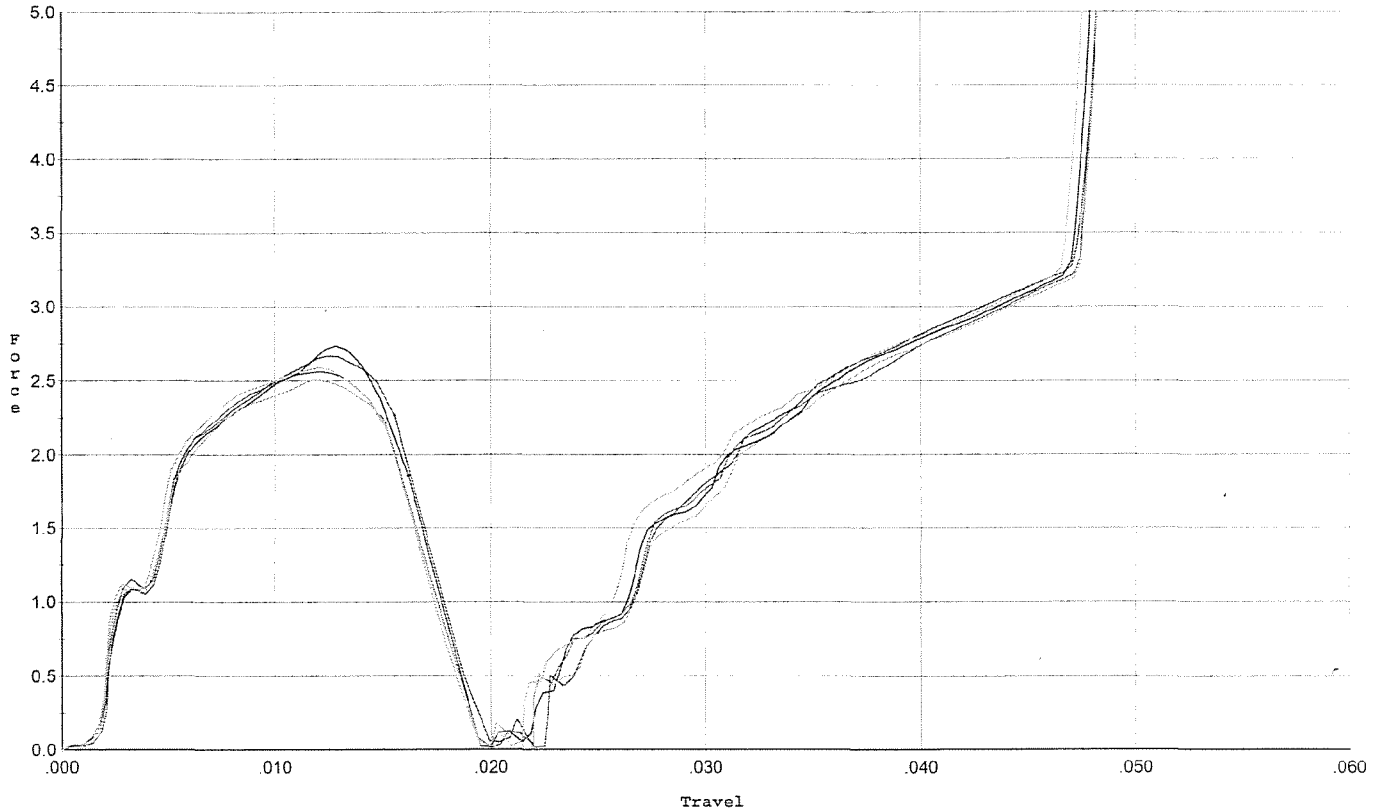
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5</u> <u>5</u> <u>5</u>                                  | 3-13-09 | W/W     |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4</u> <u>4</u> <u>4</u>                                  | 3-13-09 | W/W     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.023</u> <u>.023</u>                         | 3-13-09 | W/W     |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-10-09 | L.J.    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-13-09 | W/W     |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             |         |         |
|              | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             |         |         |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             |         |         |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                              | <u>PASS</u> FAIL<br><u>PASS</u> FAIL                        | 3-11-09 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-11-09 | W/W     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-13-09 | W/W     |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.53</u> <u>2.51</u> <u>2.56</u> <u>2.68</u> <u>2.58</u> | 3-12-09 | W/W     |
|              | C) FUNCTION                                                              |                                                             | 3-13-09 | W/W     |
| 690          | PACK                                                                     |                                                             | 3/24/09 | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



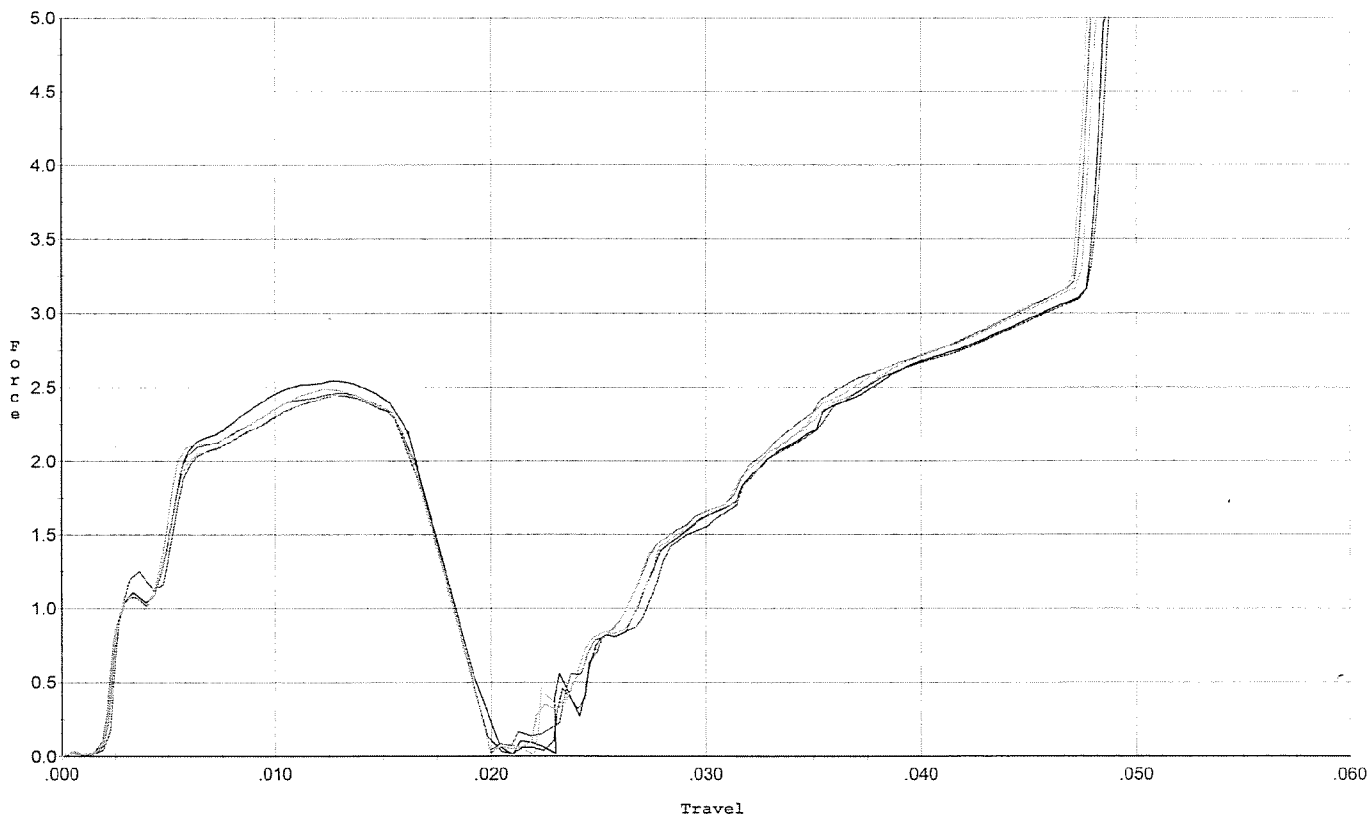
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.668      | 0.016             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 2 | 2.736      | 0.016             | 0.00            | 0.035      | 0.028             |           | Set Trigger |
| 3 | 2.564      | 0.015             | 0.00            | 0.036      | 0.026             |           | Set Trigger |
| 4 | 2.591      | 0.015             | 0.004           | 0.035      | 0.026             |           | Set Trigger |
| 5 | 2.503      | 0.015             | 0.004           | 0.036      | 0.025             |           | Set Trigger |

A-2.61

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/3/2009

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



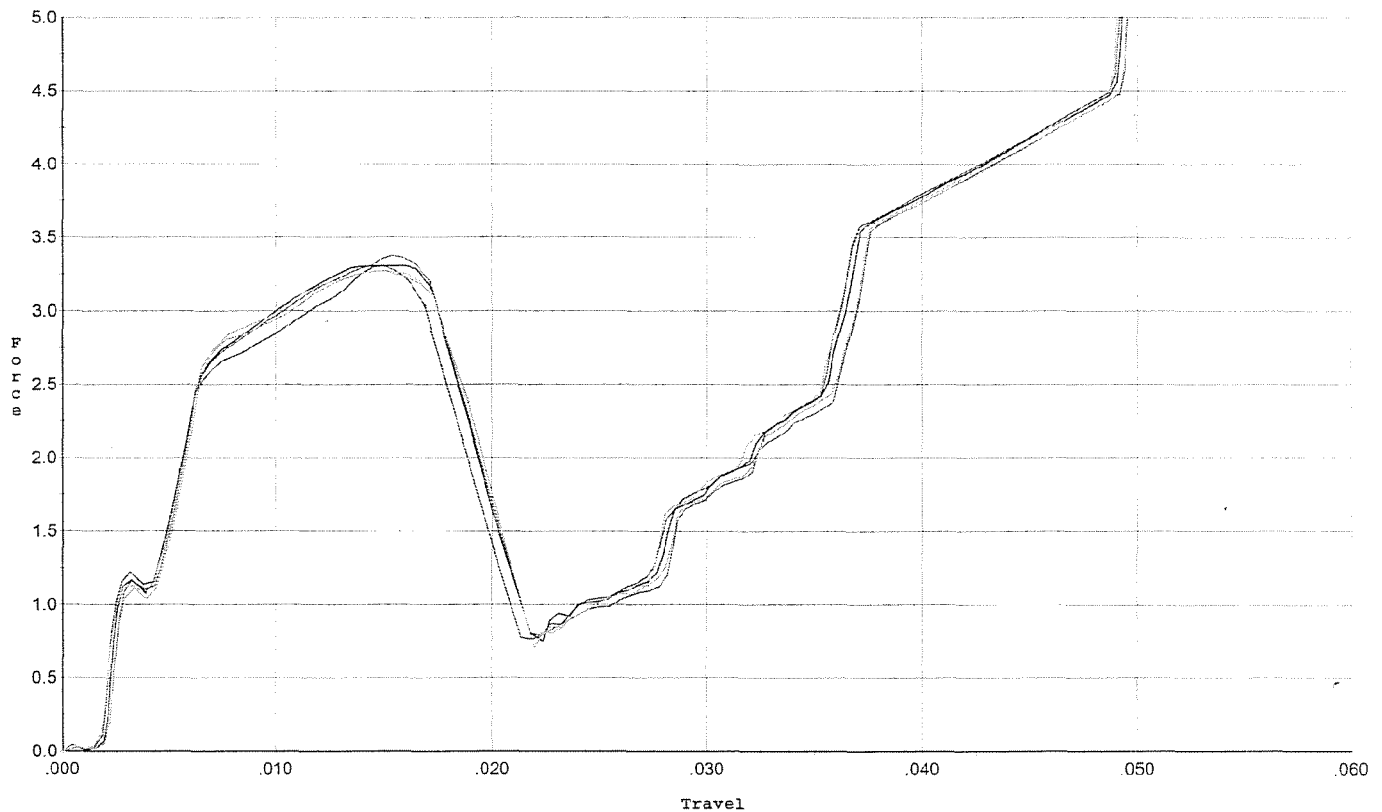
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.447      | 0.016             | 0.002           | 0.036      | 0.027             |           | Set Trigger |
| 2 | 2.545      | 0.016             | 0.002           | 0.035      | 0.028             |           | Set Trigger |
| 3 | 2.459      | 0.017             | 0.002           | 0.035      | 0.028             |           | Set Trigger |
| 4 | 2.448      | 0.017             | 0.002           | 0.035      | 0.027             |           | Set Trigger |
| 5 | 2.487      | 0.017             | 0.002           | 0.035      | 0.028             |           | Set Trigger |

A-2.47

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



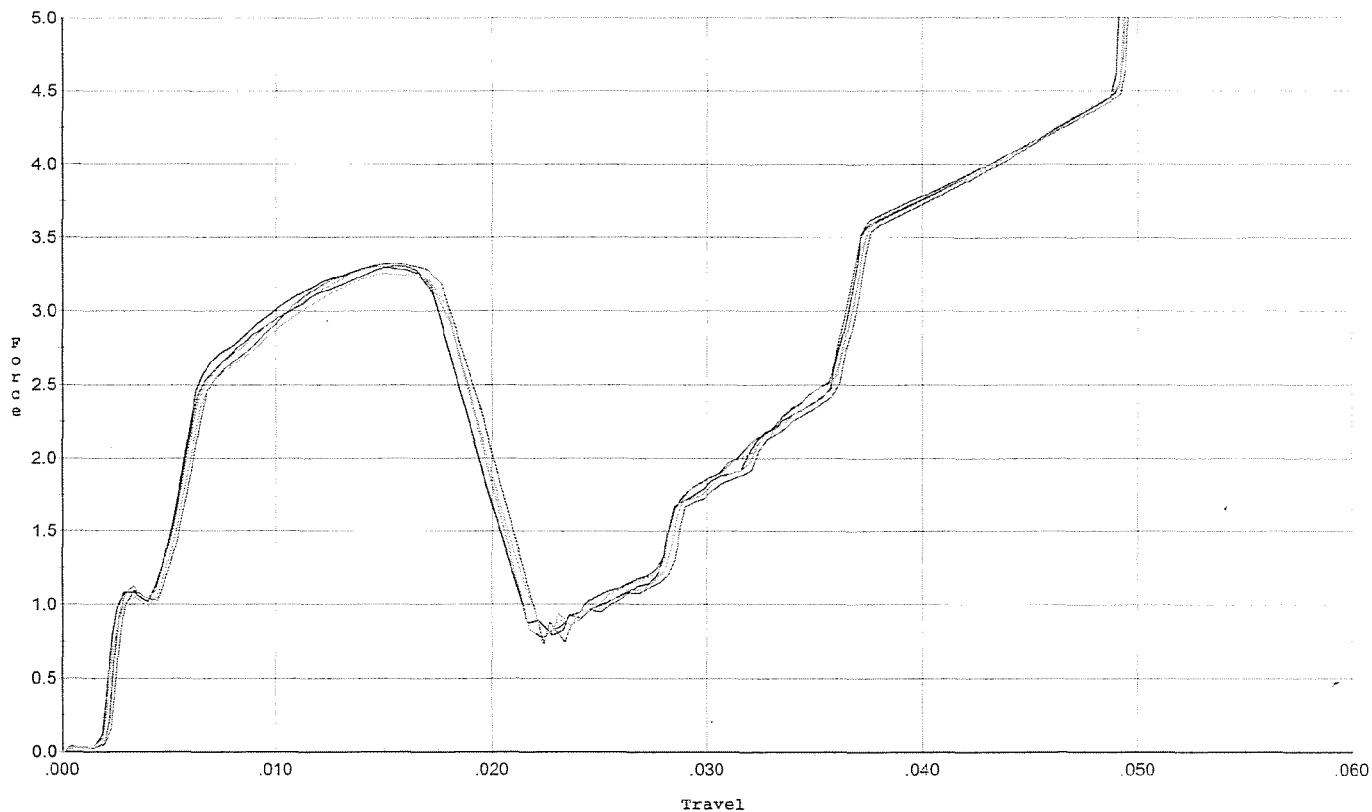
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.306      | 0.017             | 0.00            | 0.034      | 0.036             |           | Set Trigger |
| 2 | 3.306      | 0.017             | 0.002           | 0.034      | 0.037             |           | Set Trigger |
| 3 | 3.375      | 0.017             | 0.002           | 0.034      | 0.037             |           | Set Trigger |
| 4 | 3.272      | 0.019             | 0.00            | 0.033      | 0.041             |           | Set Trigger |
| 5 | 3.268      | 0.019             | 0.002           | 0.033      | 0.041             |           | Set Trigger |

A-3.30

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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 | 3.307      | 0.017             | 0.002           | 0.034      | 0.037             |           | Set Trigger |
| 2 | 3.301      | 0.017             | 0.002           | 0.034      | 0.037             |           | Set Trigger |
| 3 | 3.322      | 0.019             | 0.002           | 0.033      | 0.041             |           | Set Trigger |
| 4 | 3.255      | 0.018             | 0.002           | 0.033      | 0.038             |           | Set Trigger |
| 5 | 3.305      | 0.018             | 0.002           | 0.033      | 0.039             |           | Set Trigger |

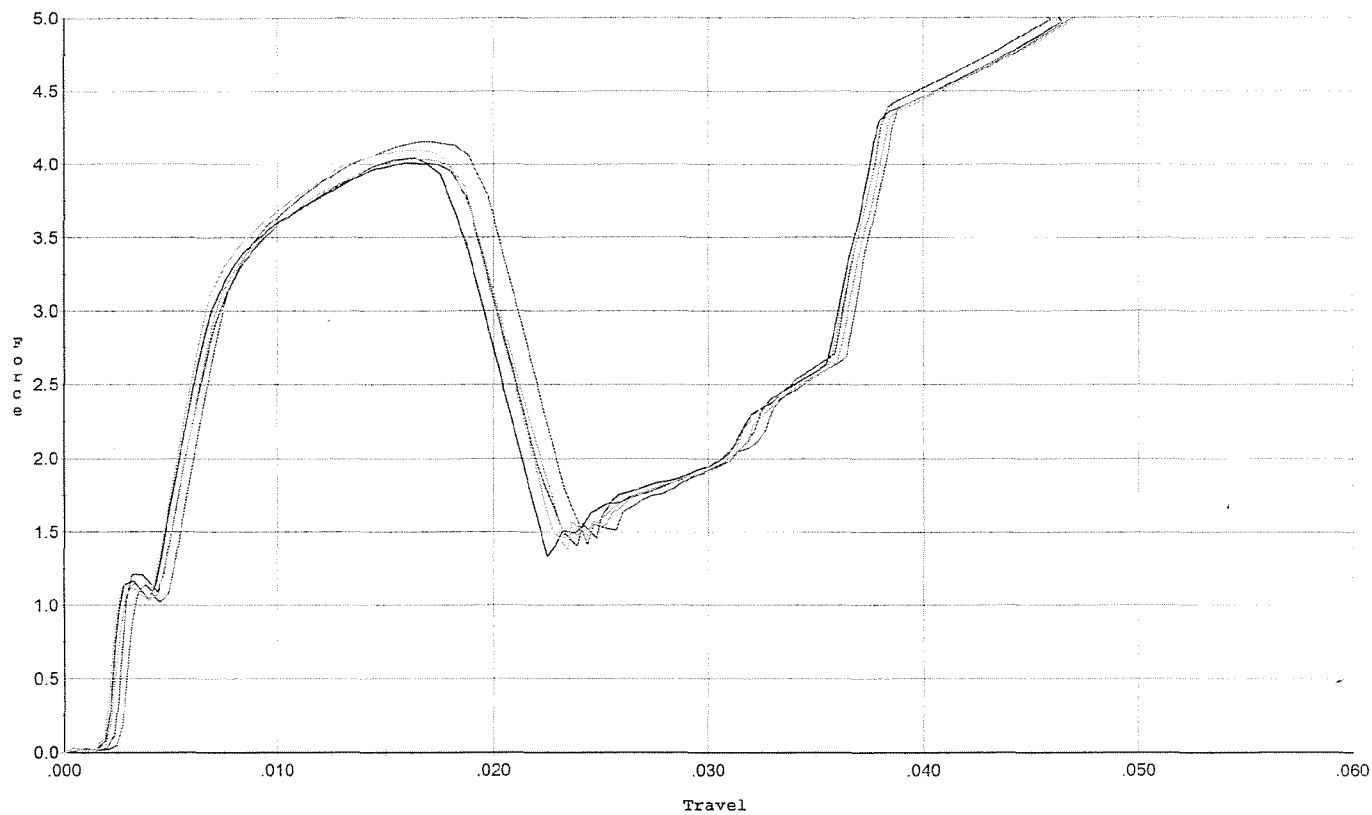
A-3-29



## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



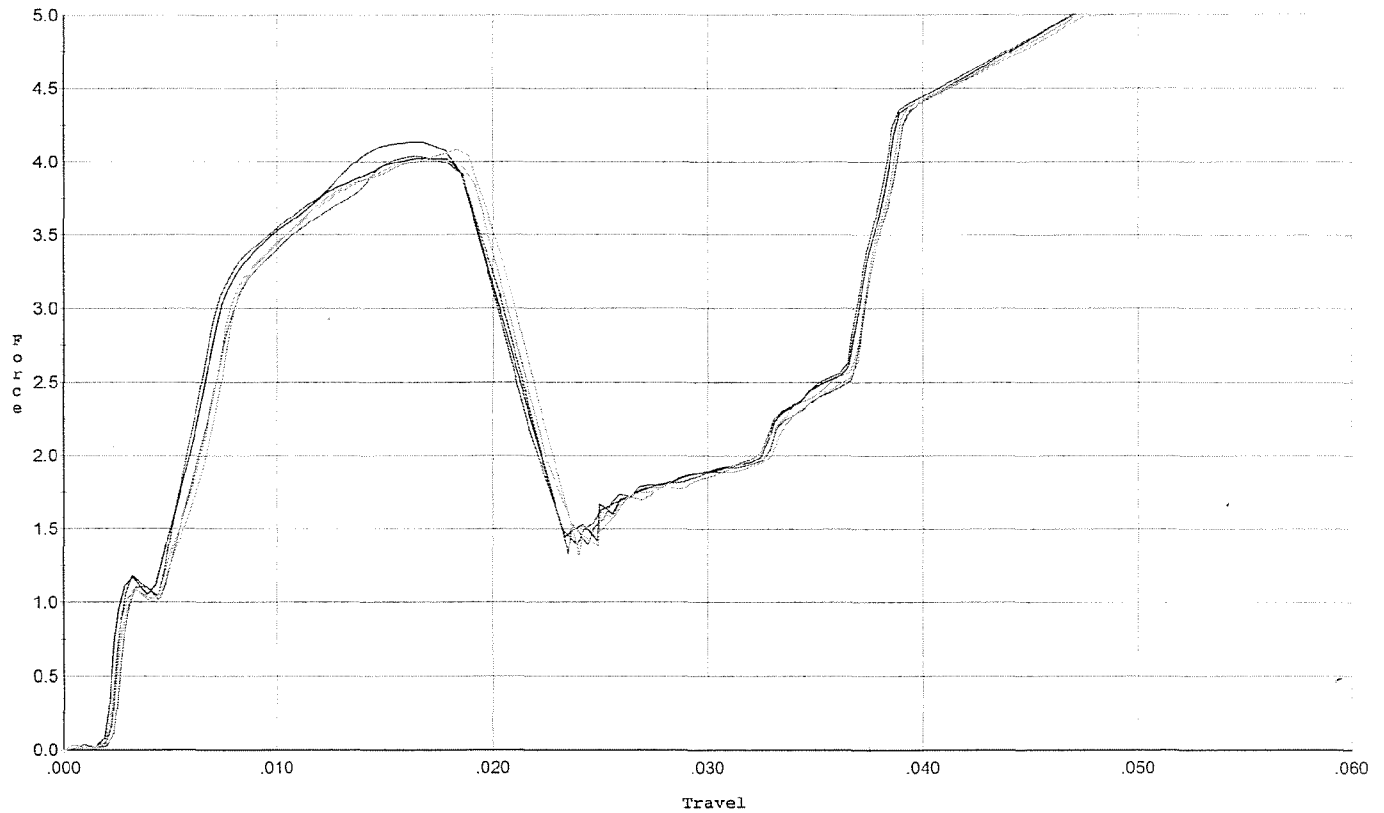
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.041      | 0.019             | 0.005           | 0.032      | 0.048             |           | Set Trigger |
| 2 | 4.010      | 0.019             | 0.002           | 0.032      | 0.048             |           | Set Trigger |
| 3 | 4.154      | 0.020             | 0.003           | 0.031      | 0.052             |           | Set Trigger |
| 4 | 4.101      | 0.019             | 0.004           | 0.031      | 0.050             |           | Set Trigger |
| 5 | 4.036      | 0.019             | 0.002           | 0.032      | 0.048             |           | Set Trigger |

A-4.06

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



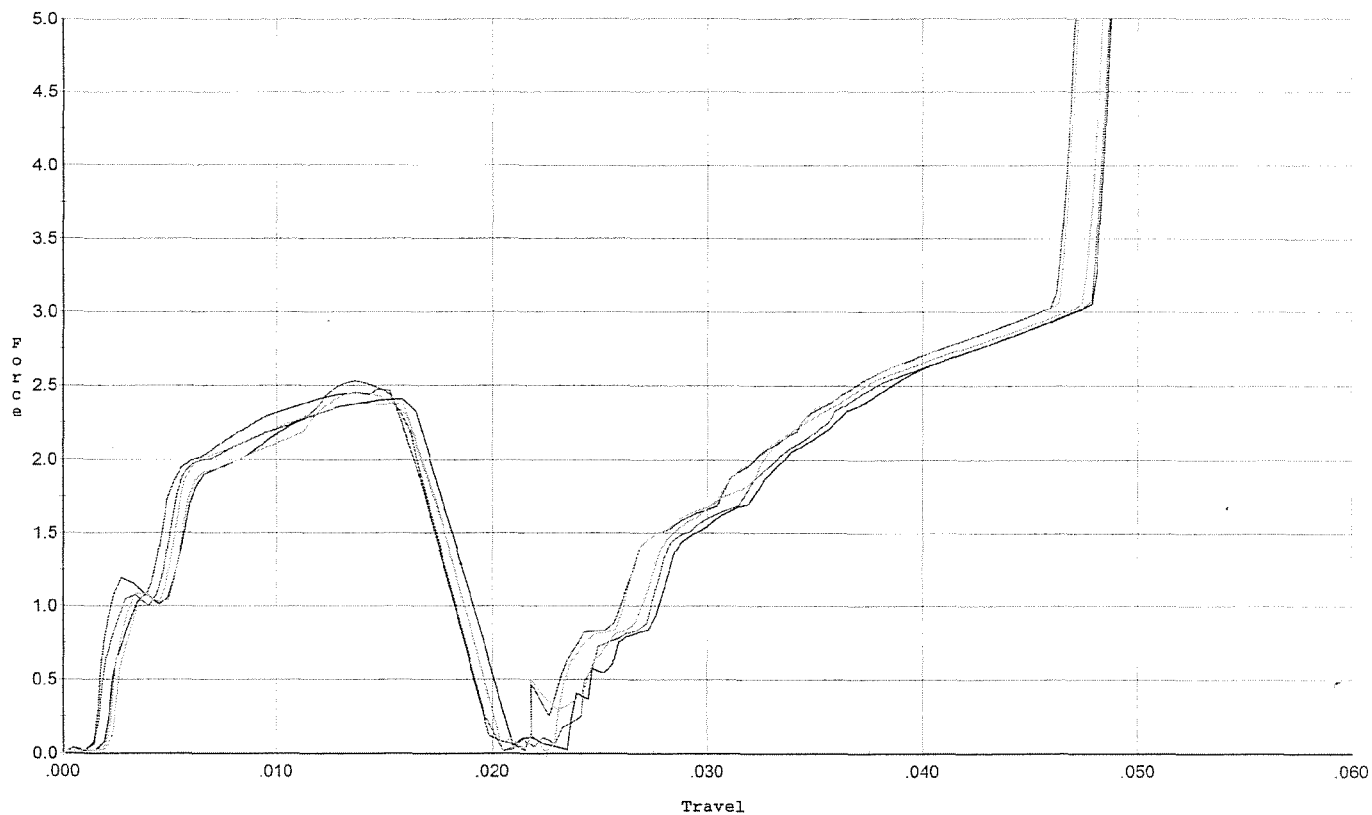
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.136      | 0.019             | 0.002           | 0.032      | 0.048             |           | Set Trigger |
| 2 | 4.022      | 0.019             | 0.002           | 0.032      | 0.048             |           | Set Trigger |
| 3 | 4.038      | 0.020             | 0.005           | 0.032      | 0.051             |           | Set Trigger |
| 4 | 4.013      | 0.019             | 0.00            | 0.032      | 0.048             |           | Set Trigger |
| 5 | 4.082      | 0.020             | 0.002           | 0.032      | 0.052             |           | Set Trigger |

A-4.05

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



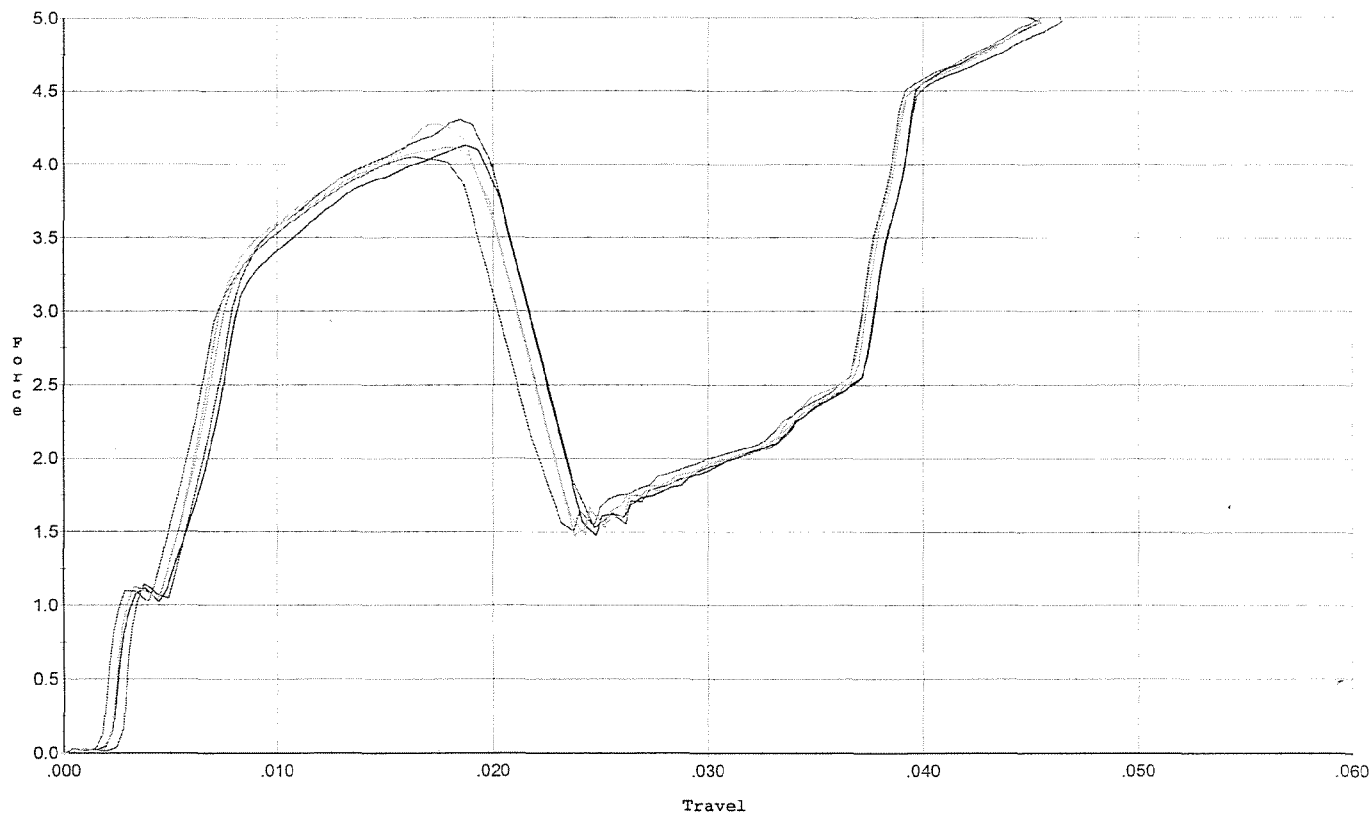
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.477      | 0.017             | 0.004           | 0.034      | 0.028             |           | Set Trigger |
| 2 | 2.407      | 0.019             | 0.002           | 0.035      | 0.029             |           | Set Trigger |
| 3 | 2.531      | 0.016             | 0.00            | 0.036      | 0.027             |           | Set Trigger |
| 4 | 2.381      | 0.017             | 0.005           | 0.034      | 0.028             |           | Set Trigger |
| 5 | 2.450      | 0.017             | 0.00            | 0.035      | 0.027             |           | Set Trigger |

A-2.44

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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 | 4.306      | 0.020             | 0.003           | 0.032      | 0.052             |           | Set Trigger |
| 2 | 4.129      | 0.020             | 0.00            | 0.031      | 0.052             |           | Set Trigger |
| 3 | 4.050      | 0.019             | 0.004           | 0.032      | 0.048             |           | Set Trigger |
| 4 | 4.269      | 0.020             | 0.005           | 0.031      | 0.053             |           | Set Trigger |
| 5 | 4.120      | 0.020             | 0.005           | 0.031      | 0.052             |           | Set Trigger |

A-4.17