

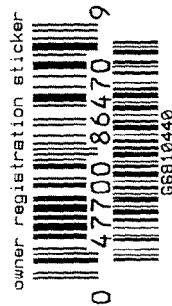
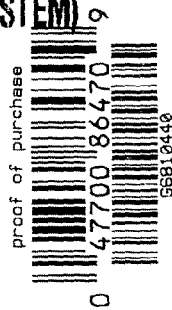
G6810445

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE

24" BARREL 7.62 NATO

WITH BIPOD

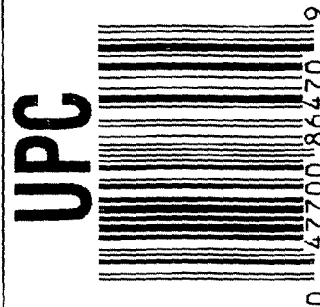


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6810440



BM FORM

GUN SERIAL #

G 6810440

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		28-09	SPN
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		29-09	SPN
460	CHECK HEADSPACE		29-09	SPN
470	DIS-ASSEMBLE ACTION		29-09	SPN
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	28-09	RJZ
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	2/13/09	HS
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/14/09	RT
520	GOFF BLAST BBL / REC		16 Feb 09	SPN
542	APPLY COATINGS (BARREL ACTION)		2/27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-3-09	SPN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

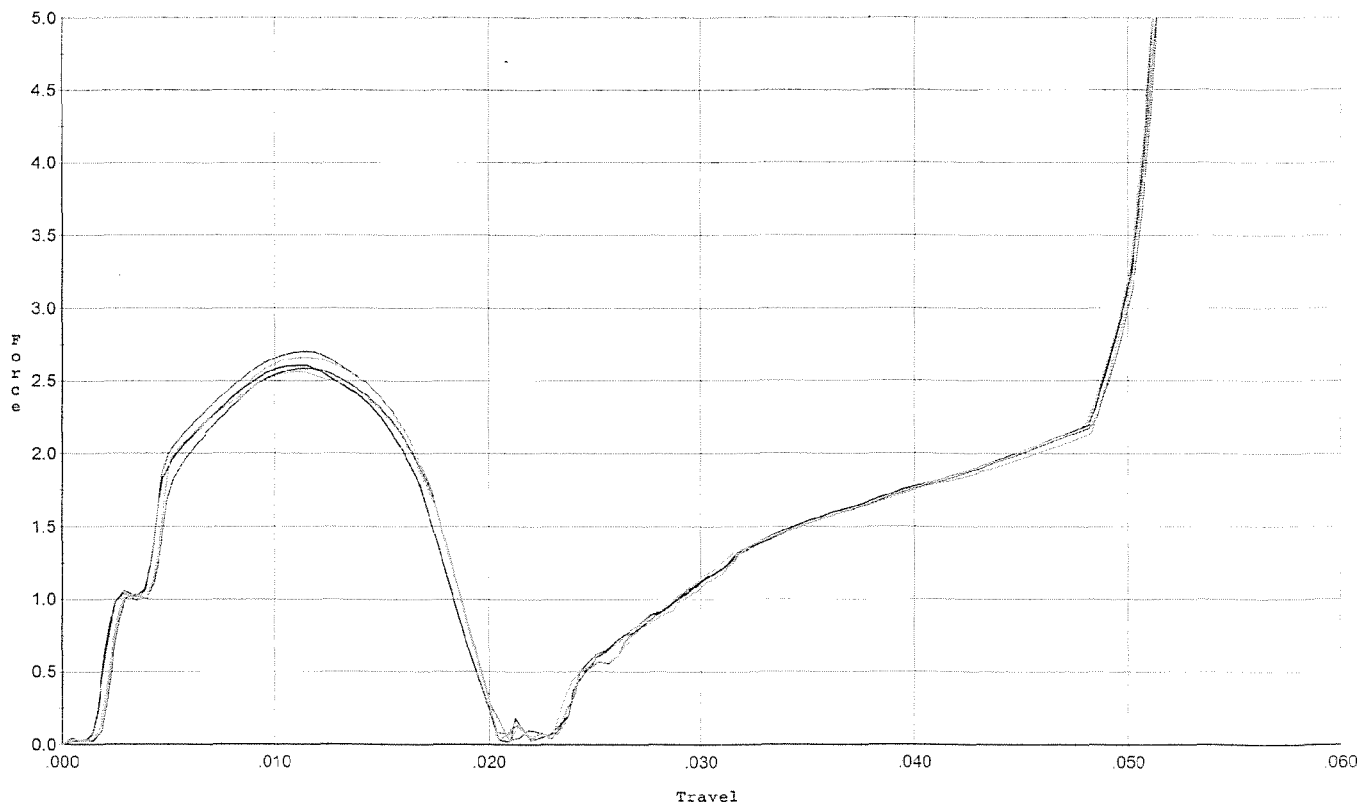
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>6</u> <u>4</u>	3-5-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-5-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-5-09	WV
	J) ASSEMBLE STOCK		3-3-09	APD
	K) ASSEMBLE SWIVEL STUDS			
	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 PASS FAIL FAIL	3-4-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-4-09	TC
670	FINAL INSPECTION A) HEADSPACE		3-5-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.51</u> <u>2.51</u> <u>2.25</u> <u>2.31</u>	3-4-09	WV
	C) FUNCTION		3-5-09	WV
690	PACK		3/6/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



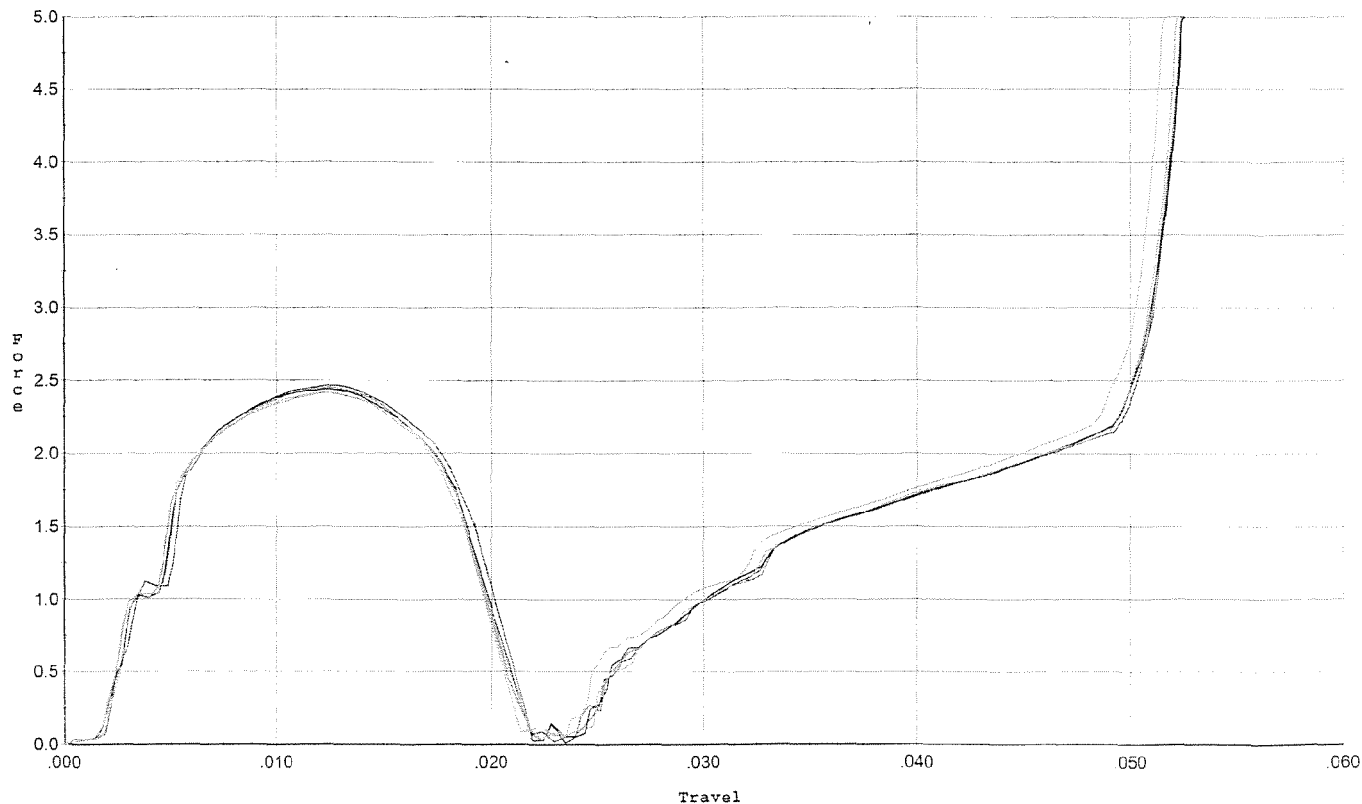
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.586	0.017	0.002	0.038	0.030		Set Trigger
2	2.605	0.017	0.00	0.039	0.029		Set Trigger
3	2.700	0.017	0.00	0.038	0.032		Set Trigger
4	2.660	0.017	0.004	0.038	0.031		Set Trigger
5	2.563	0.018	0.002	0.038	0.030		Set Trigger

A.2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 2/26/2009

Model: M24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



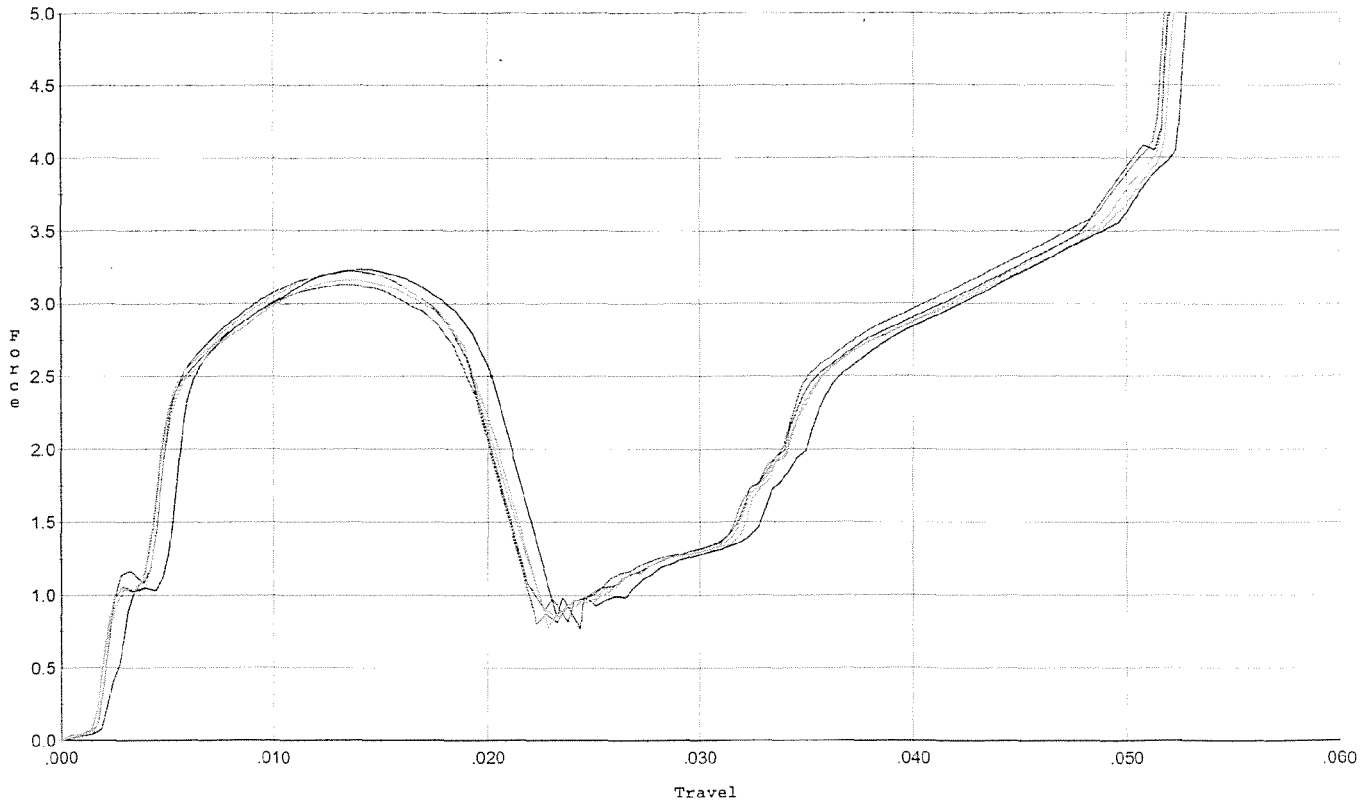
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.466	0.019	0.005	0.038	0.032		Set Trigger
2	2.439	0.018	0.002	0.039	0.031		Set Trigger
3	2.450	0.018	0.00	0.039	0.031		Set Trigger
4	2.419	0.019	0.002	0.038	0.031		Set Trigger
5	2.414	0.018	0.005	0.038	0.030		Set Trigger

A-2-43

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



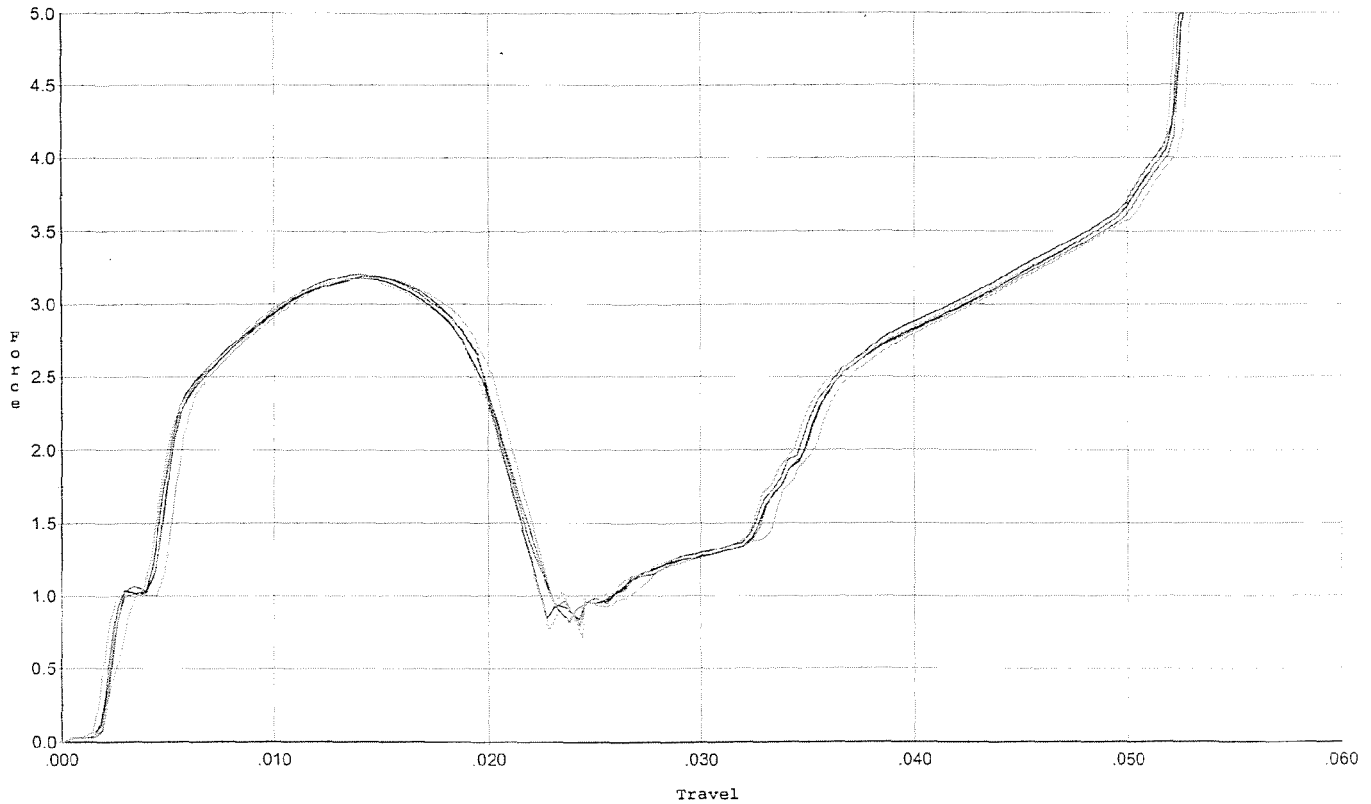
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.222	0.019	0.00	0.035	0.042		Set Trigger
2	3.234	0.020	0.00	0.035	0.044		Set Trigger
3	3.132	0.019	0.00	0.035	0.042		Set Trigger
4	3.234	0.019	0.00	0.035	0.042		Set Trigger
5	3.161	0.020	0.00	0.035	0.044		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



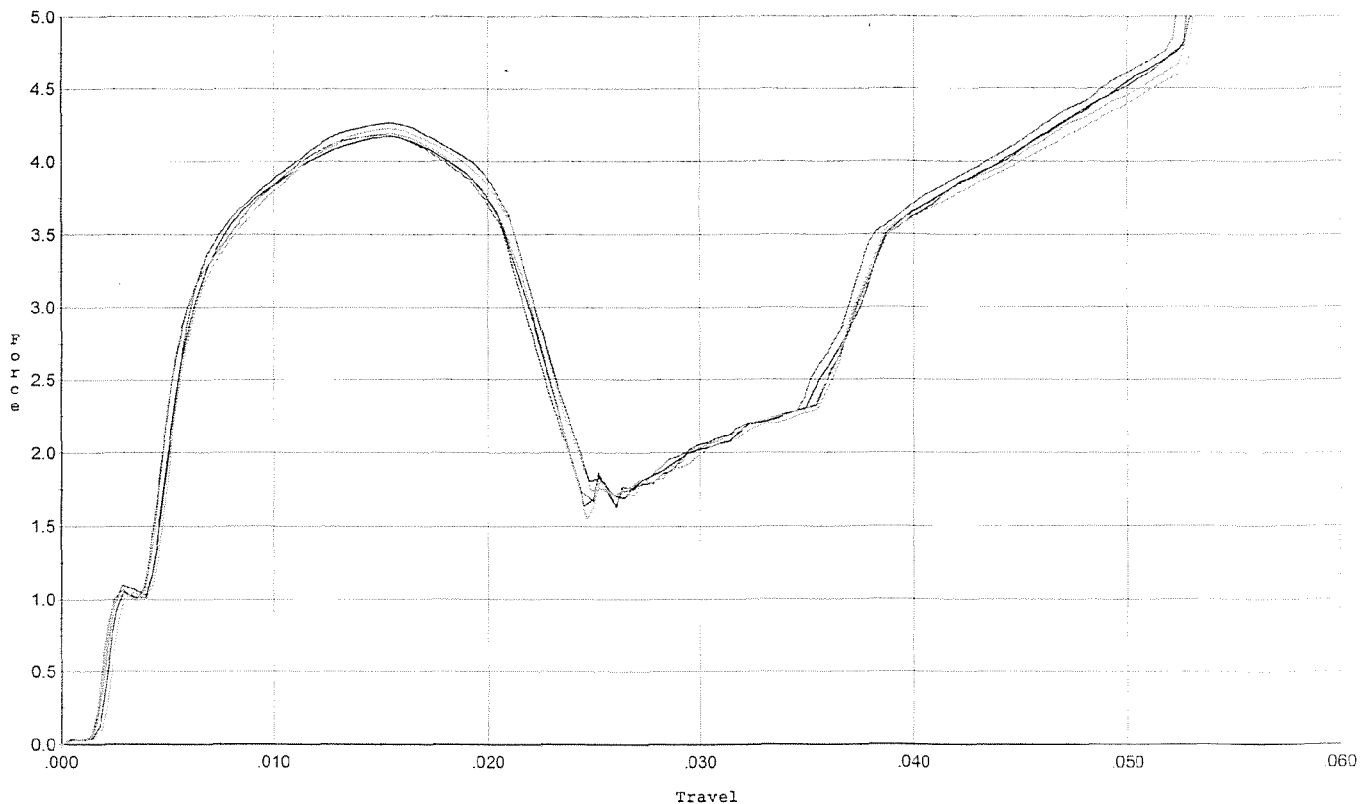
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.194	0.020	0.002	0.035	0.042		Set Trigger
2	3.180	0.020	0.00	0.036	0.043		Set Trigger
3	3.207	0.019	0.00	0.036	0.042		Set Trigger
4	3.177	0.020	0.00	0.035	0.044		Set Trigger
5	3.204	0.020	0.002	0.036	0.043		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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



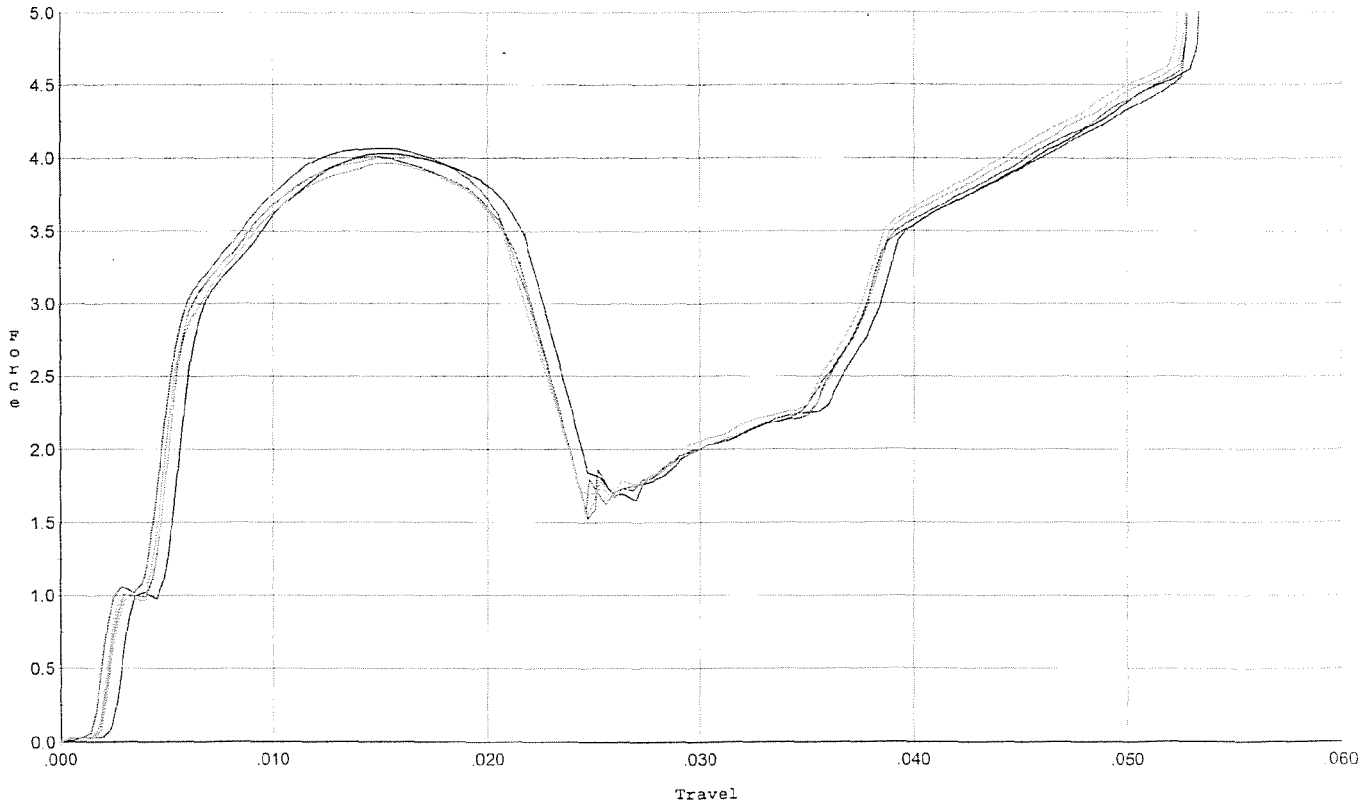
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.266	0.021	0.004	0.033	0.060		Set Trigger
2	4.166	0.022	0.004	0.033	0.062		Set Trigger
3	4.182	0.021	0.00	0.033	0.058		Set Trigger
4	4.224	0.021	0.00	0.033	0.059		Set Trigger
5	4.192	0.022	0.00	0.033	0.061		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



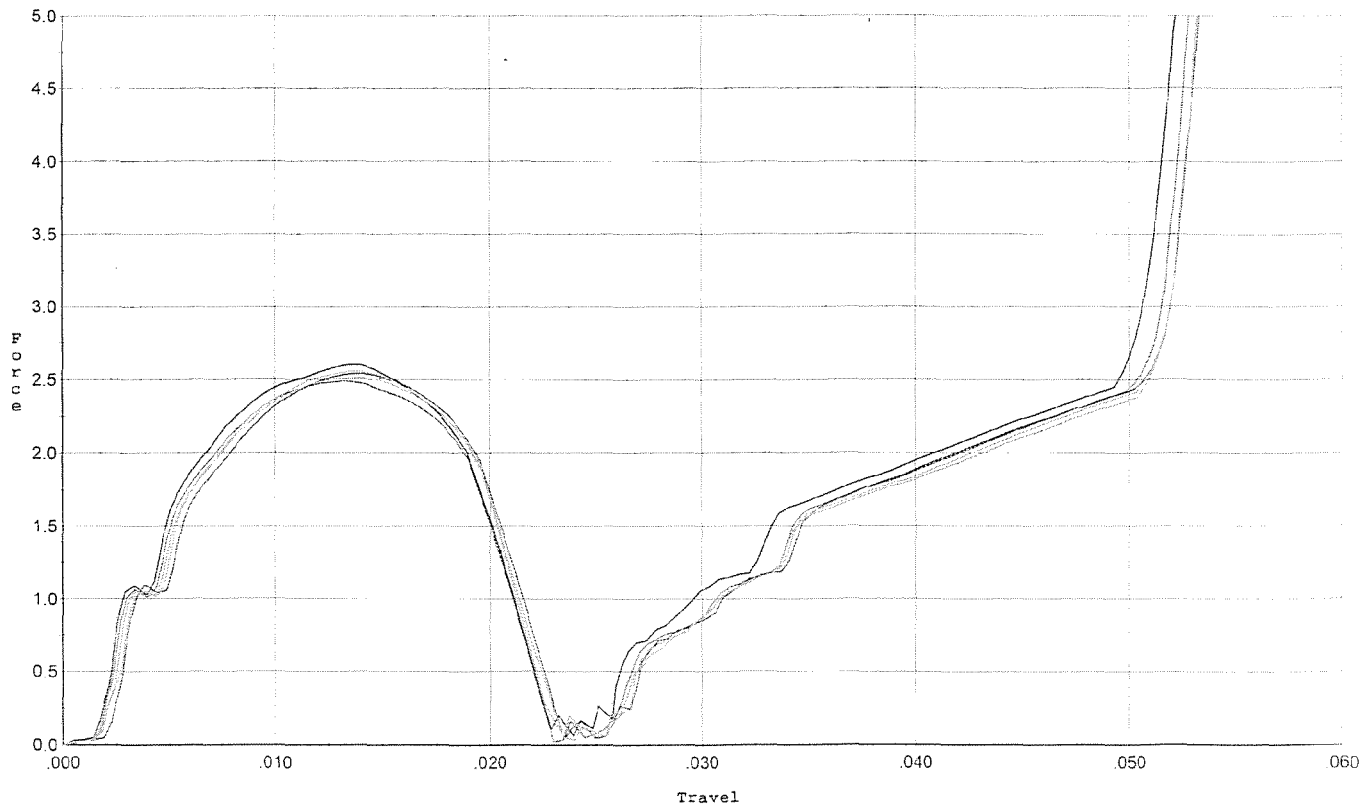
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.067	0.022	0.00	0.033	0.061		Set Trigger
2	4.028	0.022	0.002	0.033	0.058		Set Trigger
3	4.009	0.022	0.004	0.033	0.059		Set Trigger
4	3.999	0.023	0.002	0.032	0.061		Set Trigger
5	3.968	0.022	0.002	0.033	0.059		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/26/2009

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



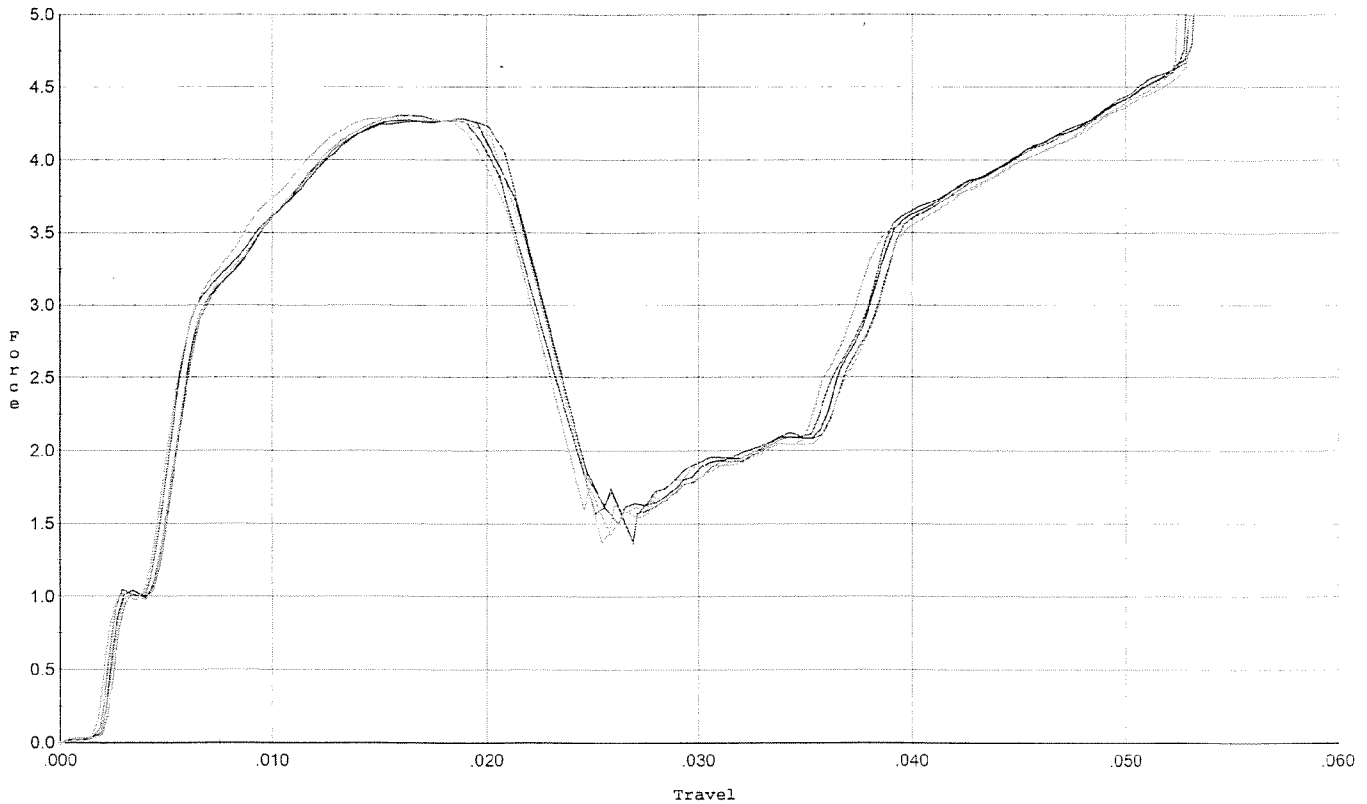
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.021	0.00	0.037	0.036		Set Trigger
2	2.603	0.020	0.00	0.037	0.036		Set Trigger
3	2.488	0.021	0.002	0.037	0.035		Set Trigger
4	2.555	0.020	0.00	0.038	0.034		Set Trigger
5	2.511	0.020	0.00	0.038	0.034		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/26/2009

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	4.268	0.021	0.004	0.033	0.058		Set Trigger
2	4.282	0.021	0.002	0.033	0.060		Set Trigger
3	4.307	0.021	0.00	0.033	0.059		Set Trigger
4	4.303	0.022	0.00	0.033	0.061		Set Trigger
5	4.289	0.021	0.002	0.032	0.060		Set Trigger

A-4.29