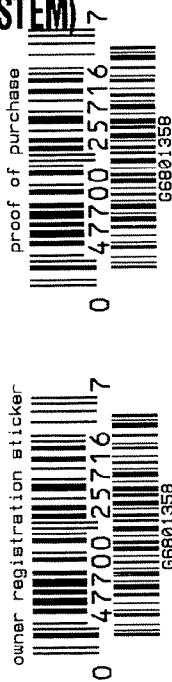


G-680 1358

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

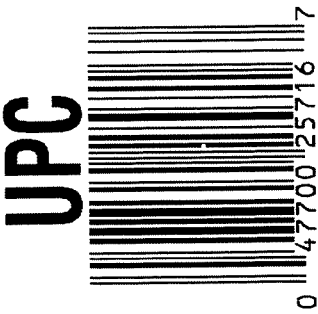
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801358



GUN SERIAL #

G 680 1358

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RJZ
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-6	TL
540	APPLY COATINGS (BARREL ACTION)		3-26	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	LJZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	LJZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	LJZ
	D) OIL FIRING PIN ASSEMBLY		3-27-09	LJZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

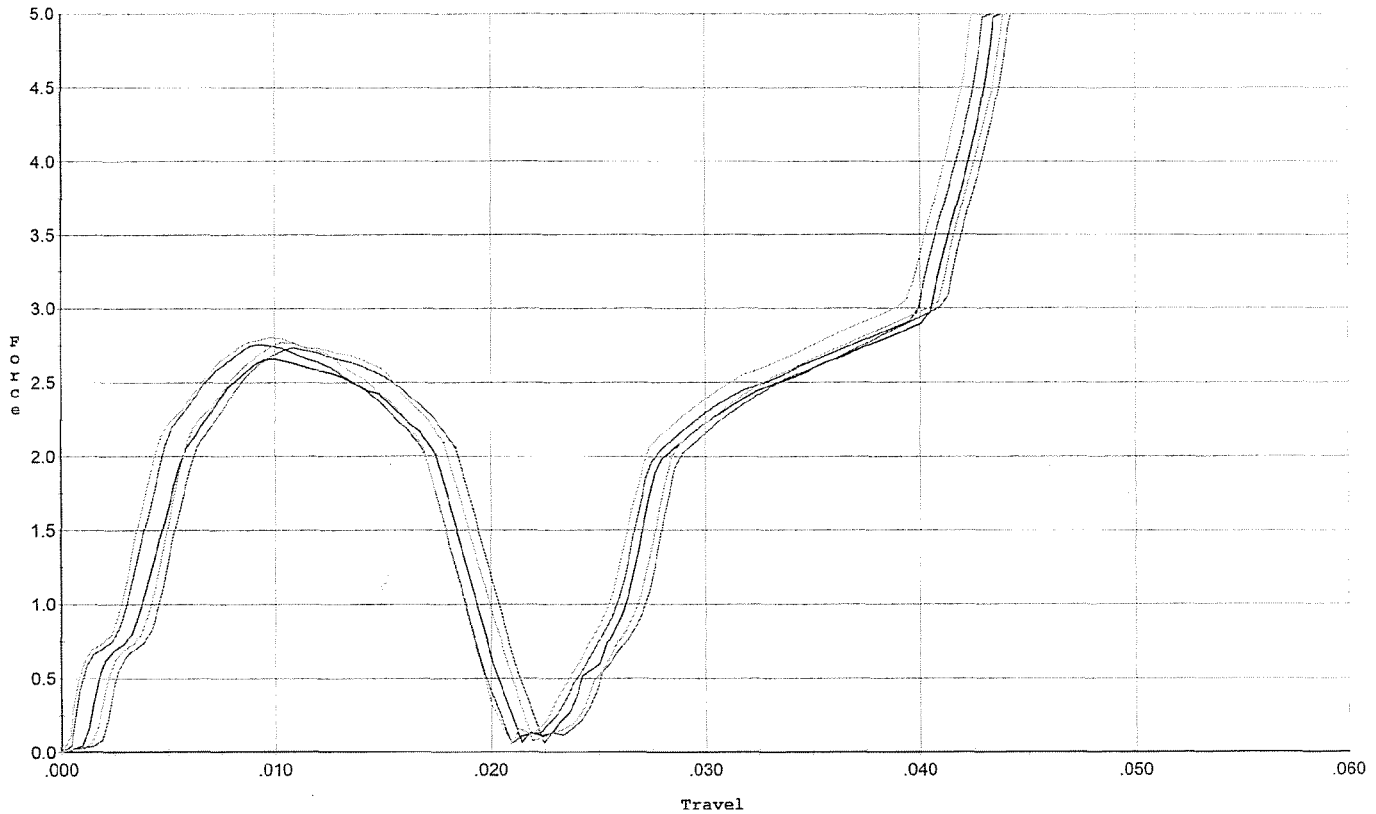
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	3-31-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>4</u>	3-31-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	3-31-09	WV
	J) ASSEMBLE STOCK		3-27-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-31-09	WV
	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-30-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u> <u>2.58</u> <u>2.24</u> <u>2.24</u> <u>2.58</u>	3-31-09	WV
	C) FUNCTION		3-31-09	WV
690	PACK		5/28/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



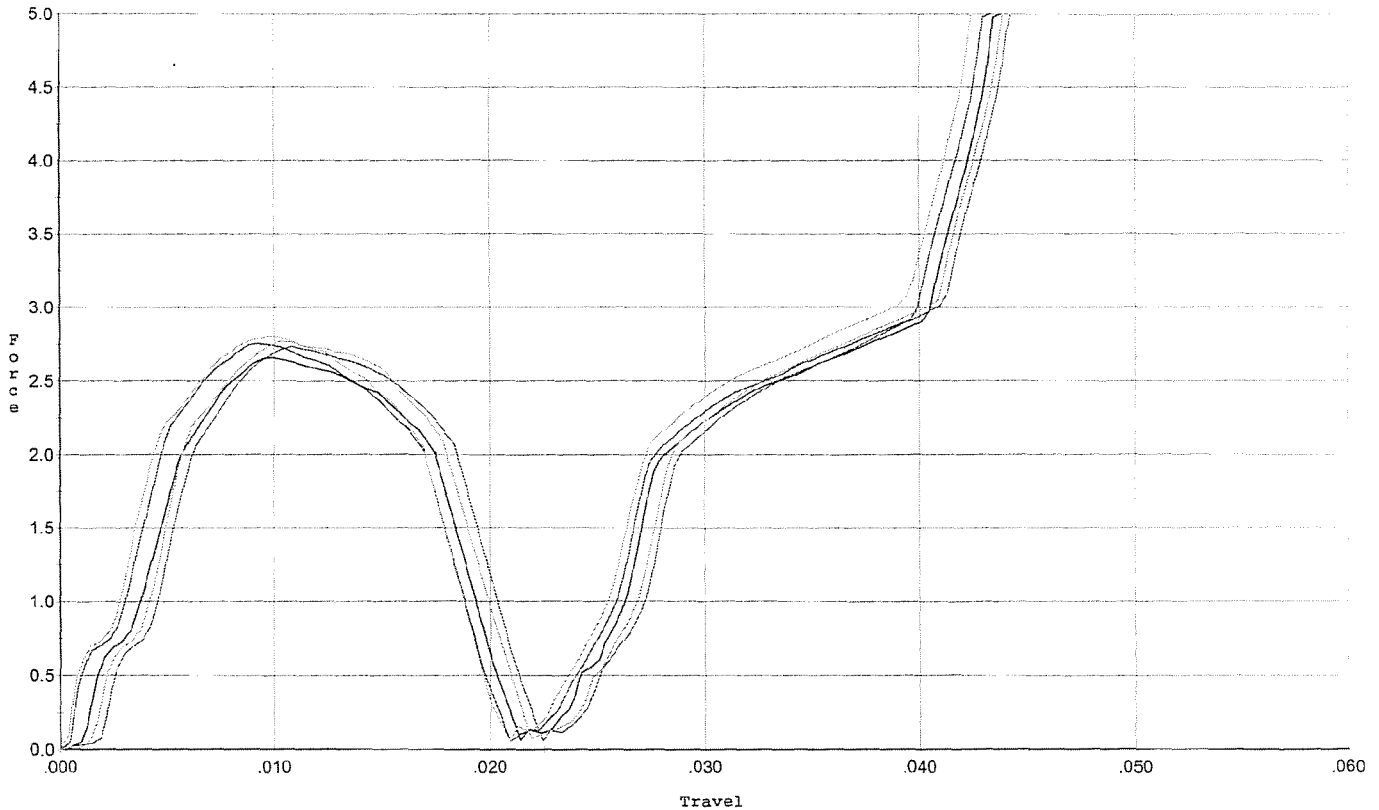
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.754	0.017	0.00	0.030	0.032		Set Trigger
2	2.658	0.017	0.00	0.030	0.031		Set Trigger
3	2.734	0.018	0.00	0.030	0.033		Set Trigger
4	2.804	0.017	0.00	0.029	0.033		Set Trigger
5	2.769	0.018	0.00	0.030	0.033		Set Trigger

A.2.74

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



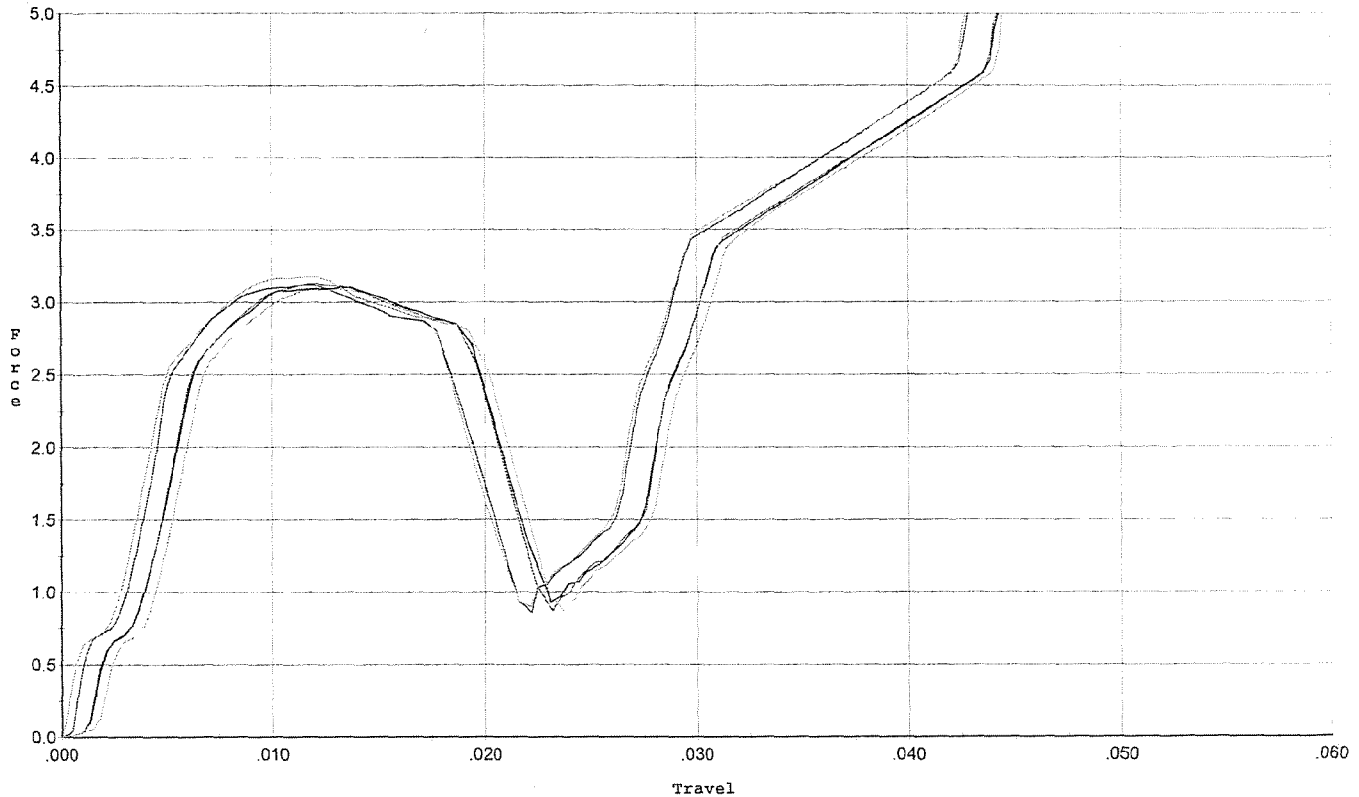
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.754	0.017	0.00	0.030	0.032		Set Trigger
2	2.658	0.017	0.00	0.030	0.031		Set Trigger
3	2.734	0.018	0.00	0.030	0.033		Set Trigger
4	2.804	0.017	0.00	0.029	0.033		Set Trigger
5	2.769	0.018	0.00	0.030	0.033		Set Trigger

A 2.74

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



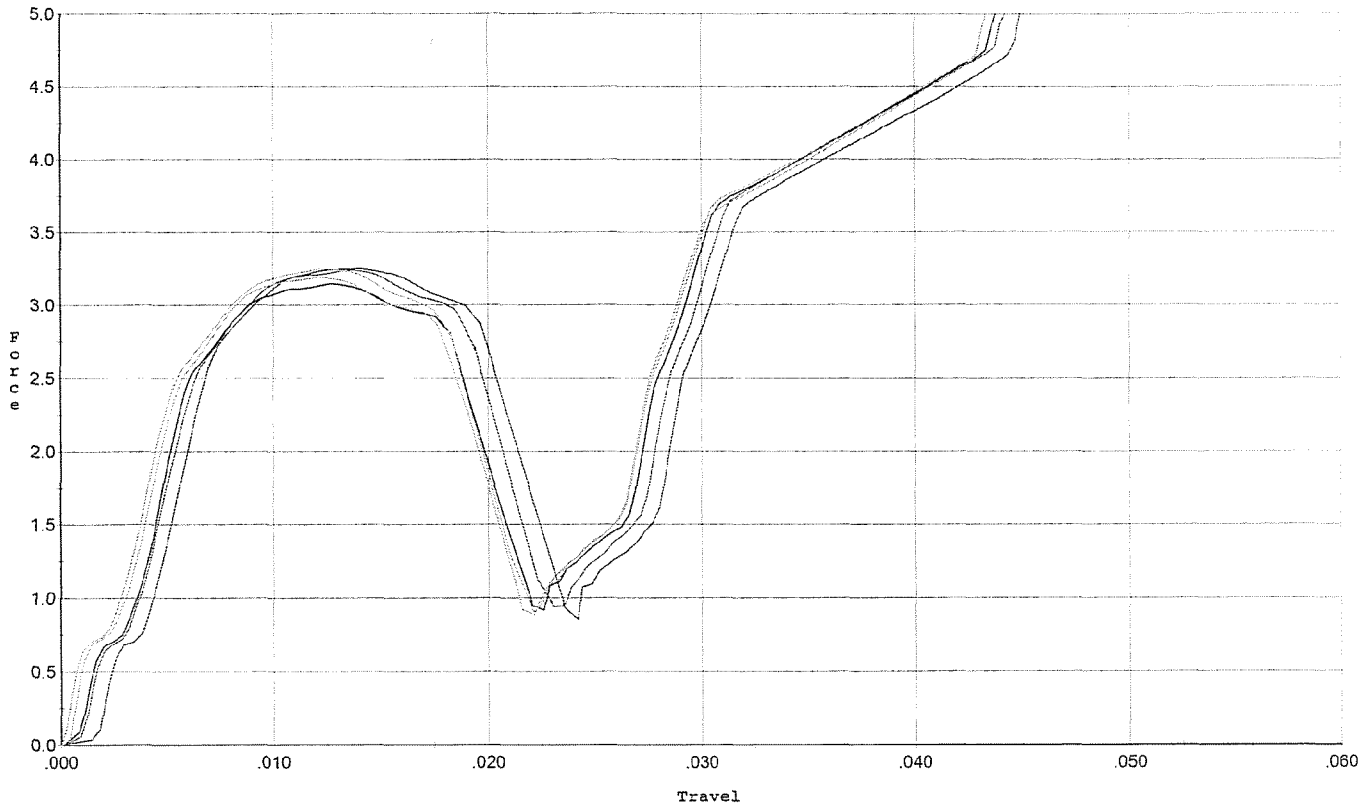
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.019	0.00	0.027	0.043		Set Trigger
2	3.100	0.019	0.00	0.028	0.042		Set Trigger
3	3.127	0.020	0.00	0.028	0.042		Set Trigger
4	3.088	0.020	0.00	0.028	0.042		Set Trigger
5	3.172	0.018	0.00	0.027	0.041		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



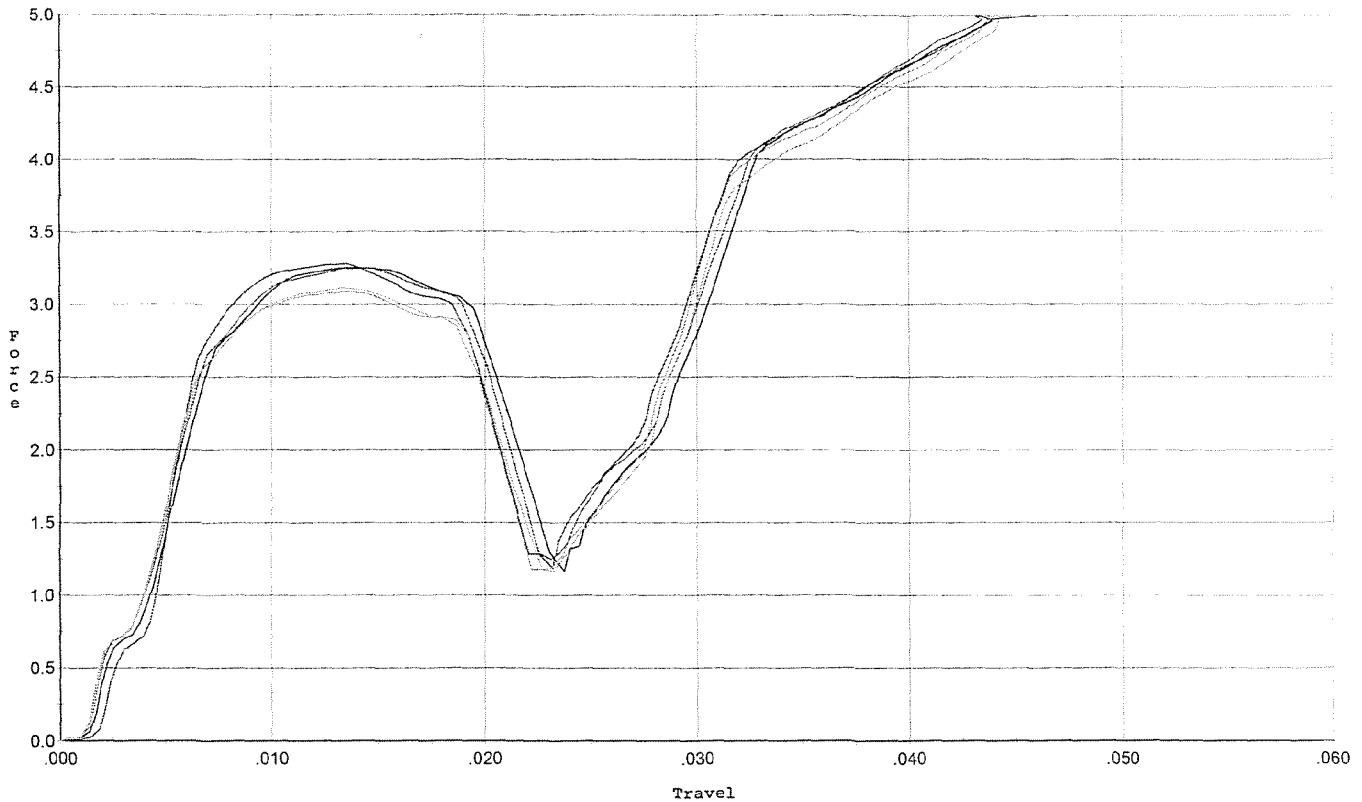
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.250	0.020	0.00	0.028	0.043		Set Trigger
2	3.146	0.018	0.00	0.028	0.040		Set Trigger
3	3.240	0.019	0.00	0.028	0.043		Set Trigger
4	3.189	0.019	0.00	0.027	0.043		Set Trigger
5	3.245	0.018	0.00	0.027	0.042		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



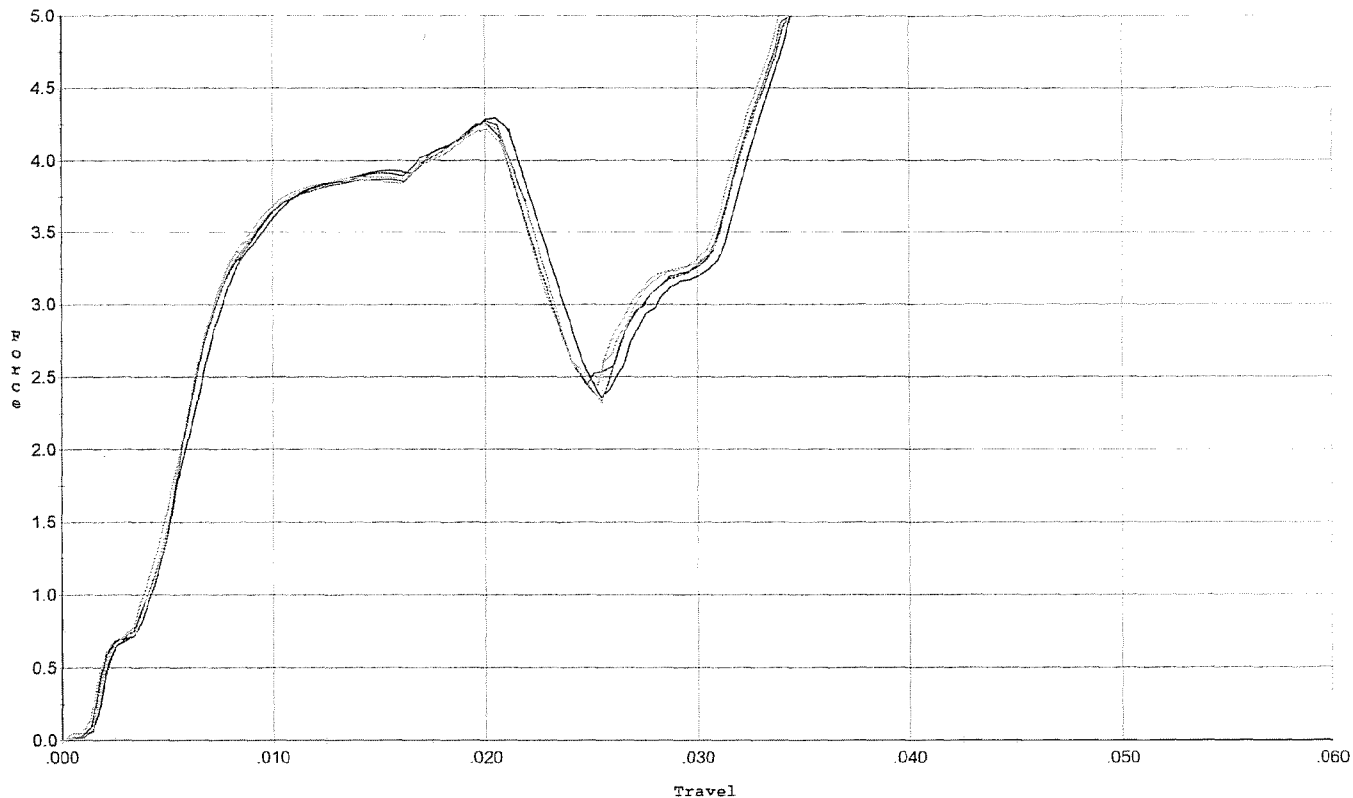
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.280	0.019	0.00	0.028	0.042		Set Trigger
2	3.246	0.021	0.00	0.027	0.046		Set Trigger
3	3.252	0.020	0.00	0.027	0.045		Set Trigger
4	3.112	0.019	0.00	0.028	0.041		Set Trigger
5	3.086	0.020	0.00	0.027	0.042		Set Trigger

1A-3-19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



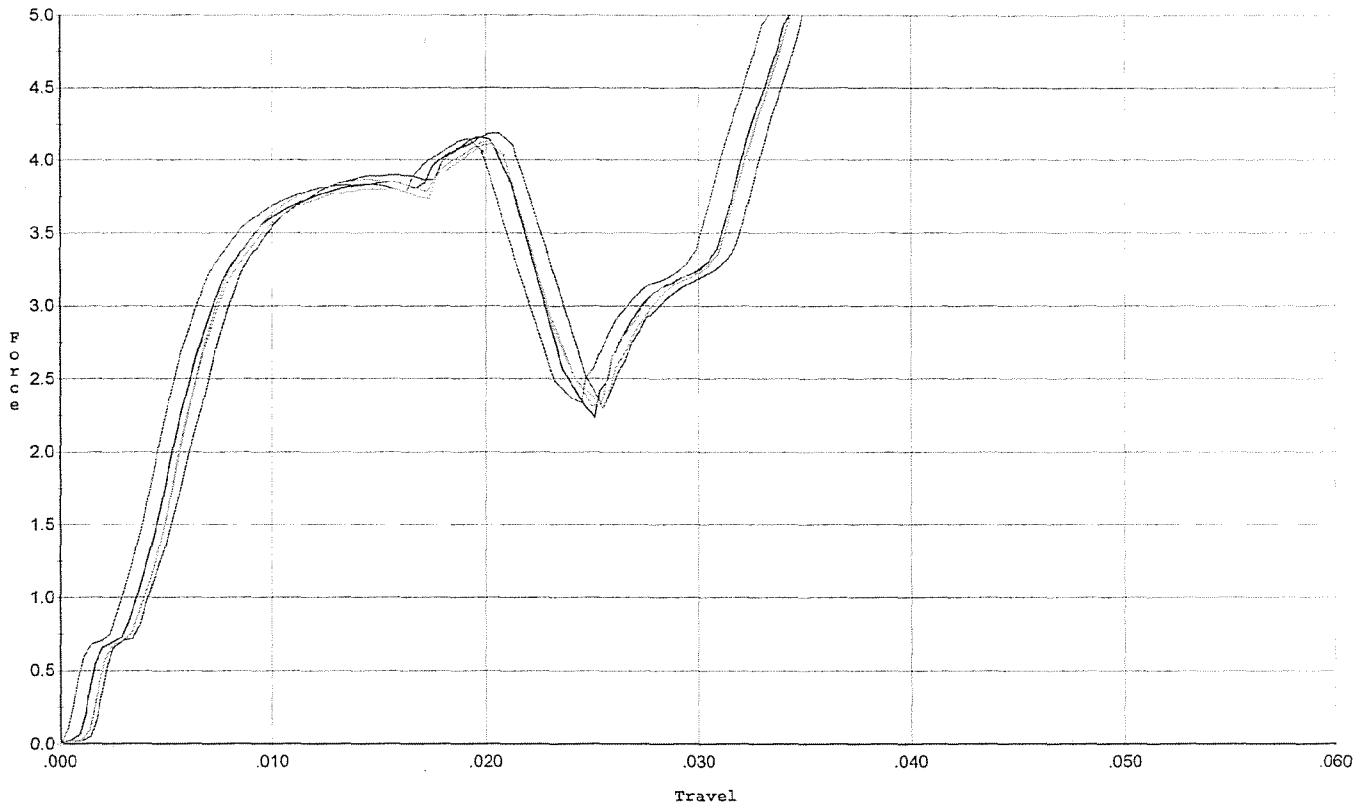
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.274	0.022	0.00	0.021	0.060		Set Trigger
2	4.294	0.021	0.00	0.020	0.058		Set Trigger
3	4.255	0.021	0.00	0.021	0.056		Set Trigger
4	4.258	0.022	0.00	0.020	0.060		Set Trigger
5	4.216	0.021	0.00	0.020	0.057		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



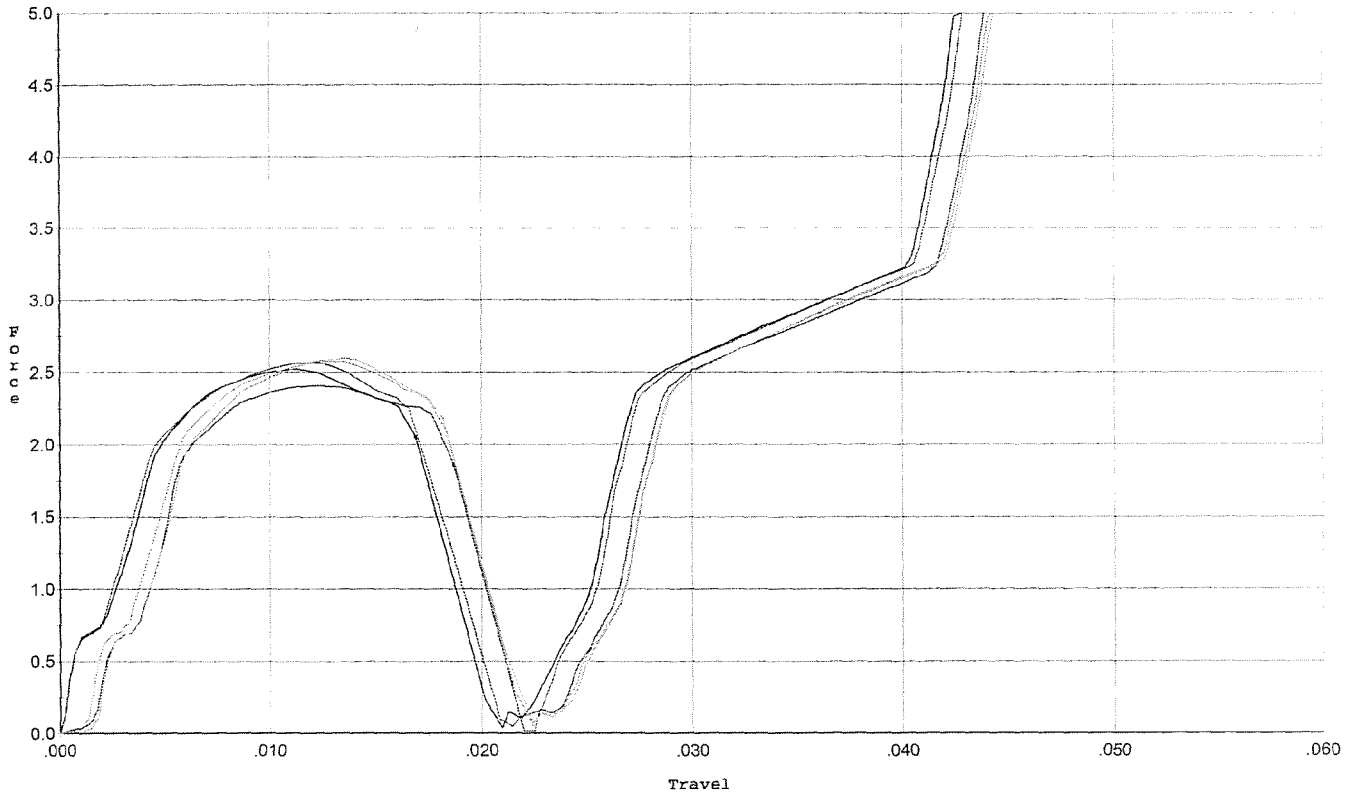
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.187	0.023	0.00	0.021	0.062		Set Trigger
2	4.164	0.021	0.00	0.021	0.058		Set Trigger
3	4.148	0.020	0.00	0.023	0.055		Set Trigger
4	4.115	0.021	0.00	0.021	0.056		Set Trigger
5	4.131	0.021	0.00	0.021	0.056		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



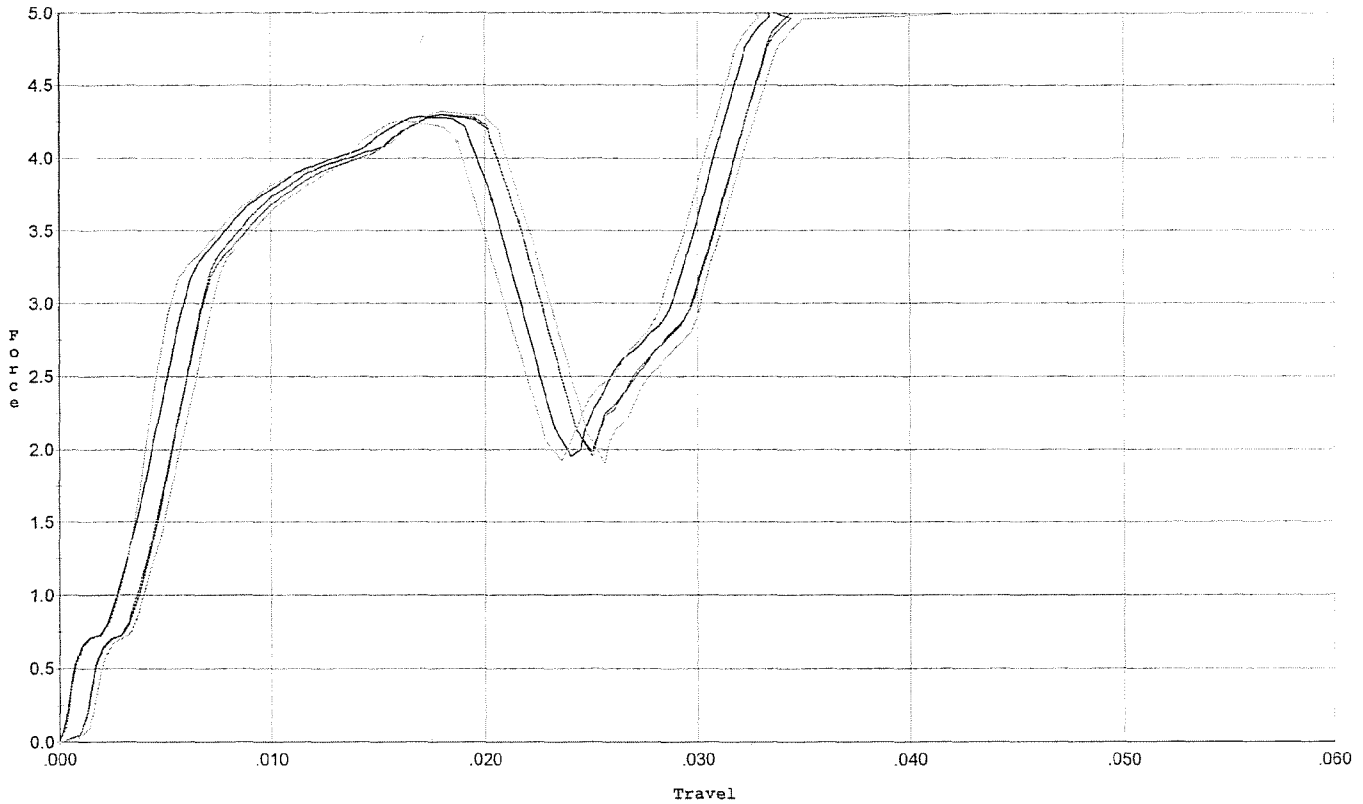
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.408	0.019	0.00	0.029	0.031		Set Trigger
2	2.520	0.017	0.00	0.029	0.031		Set Trigger
3	2.569	0.018	0.00	0.029	0.035		Set Trigger
4	2.596	0.018	0.00	0.029	0.033		Set Trigger
5	2.577	0.018	0.00	0.029	0.032		Set Trigger

A-253

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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	4.296	0.022	0.00	0.024	0.061		Set Trigger
2	4.283	0.020	0.00	0.024	0.059		Set Trigger
3	4.301	0.022	0.00	0.024	0.061		Set Trigger
4	4.322	0.022	0.00	0.022	0.063		Set Trigger
5	4.258	0.019	0.00	0.024	0.054		Set Trigger

A. 4.29