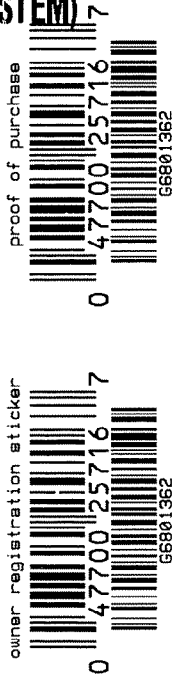


G6801362

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

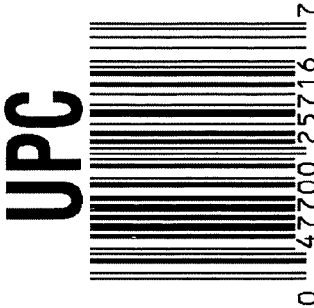
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801362



GUN SERIAL #

G 6801362

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TC
460	CHECK HEADSPACE		3-24-09	TC
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION		3-27-09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-27	BH
542	APPLY COATINGS (BARREL ACTION)		3-28	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-22-09	SP, JH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

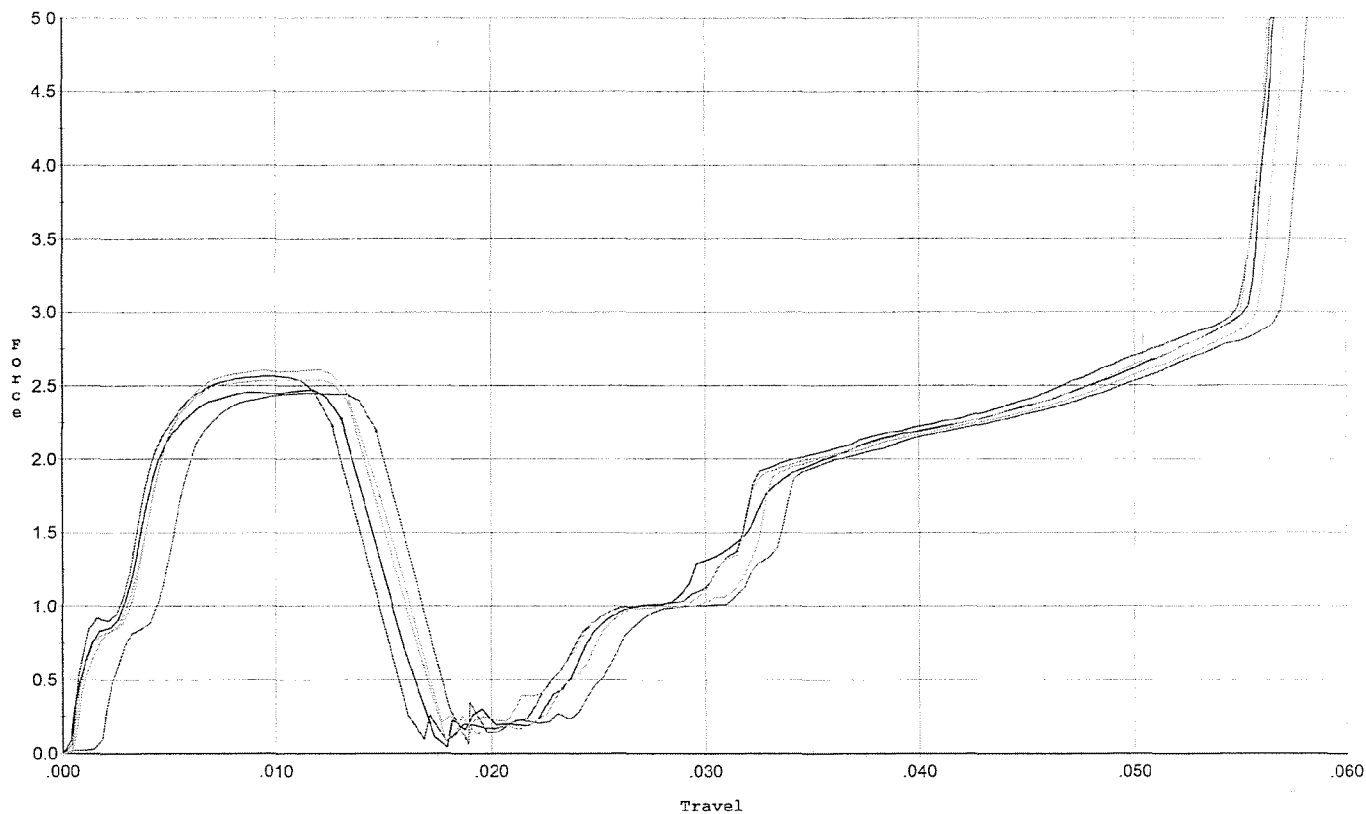
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.9</u> <u>4.9</u> <u>4.9</u>	5-6-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.9</u> <u>6.9</u> <u>6.9</u>	5-6-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.003</u> <u>.003</u> <u>.003</u>	5-6-09	L.N.
	J) ASSEMBLE STOCK		4-22-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		5-6-09	L.N.
	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	4-24-09	RP
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		5-6-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.40</u> <u>2.31</u> <u>2.35</u> <u>2.32</u>	4-28-09	N/V
	C) FUNCTION		5-6-09	L.N.
690	PACK		5/29/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



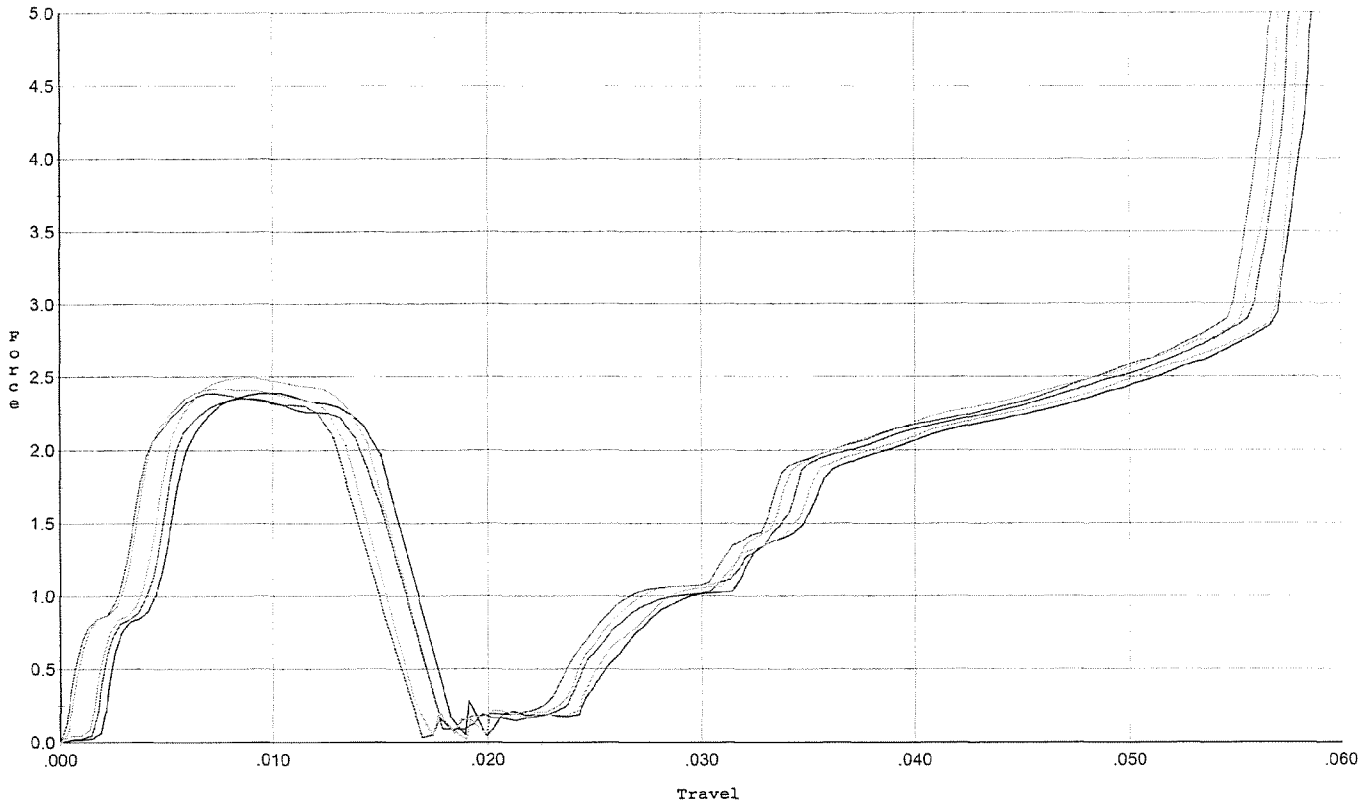
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.566	0.013	0.00	0.046	0.023		Set Trigger
2	2.473	0.013	0.00	0.046	0.023		Set Trigger
3	2.446	0.015	0.00	0.046	0.024		Set Trigger
4	2.539	0.013	0.00	0.046	0.024		Set Trigger
5	2.610	0.015	0.00	0.045	0.027		Set Trigger

A-252

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



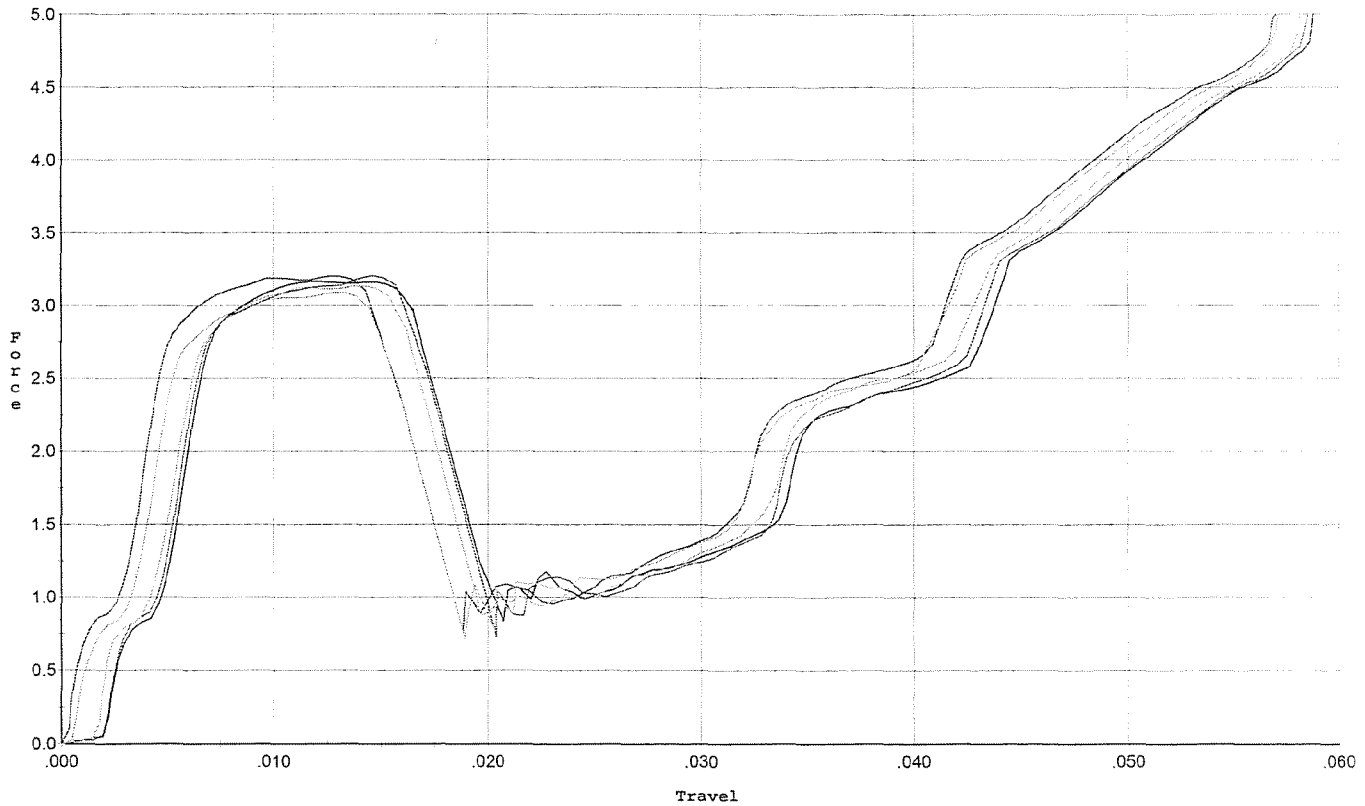
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.350	0.015	0.00	0.046	0.024		Set Trigger
2	2.385	0.015	0.00	0.047	0.023		Set Trigger
3	2.384	0.013	0.00	0.047	0.022		Set Trigger
4	2.494	0.014	0.00	0.047	0.024		Set Trigger
5	2.418	0.013	0.00	0.046	0.023		Set Trigger

A-2.40

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



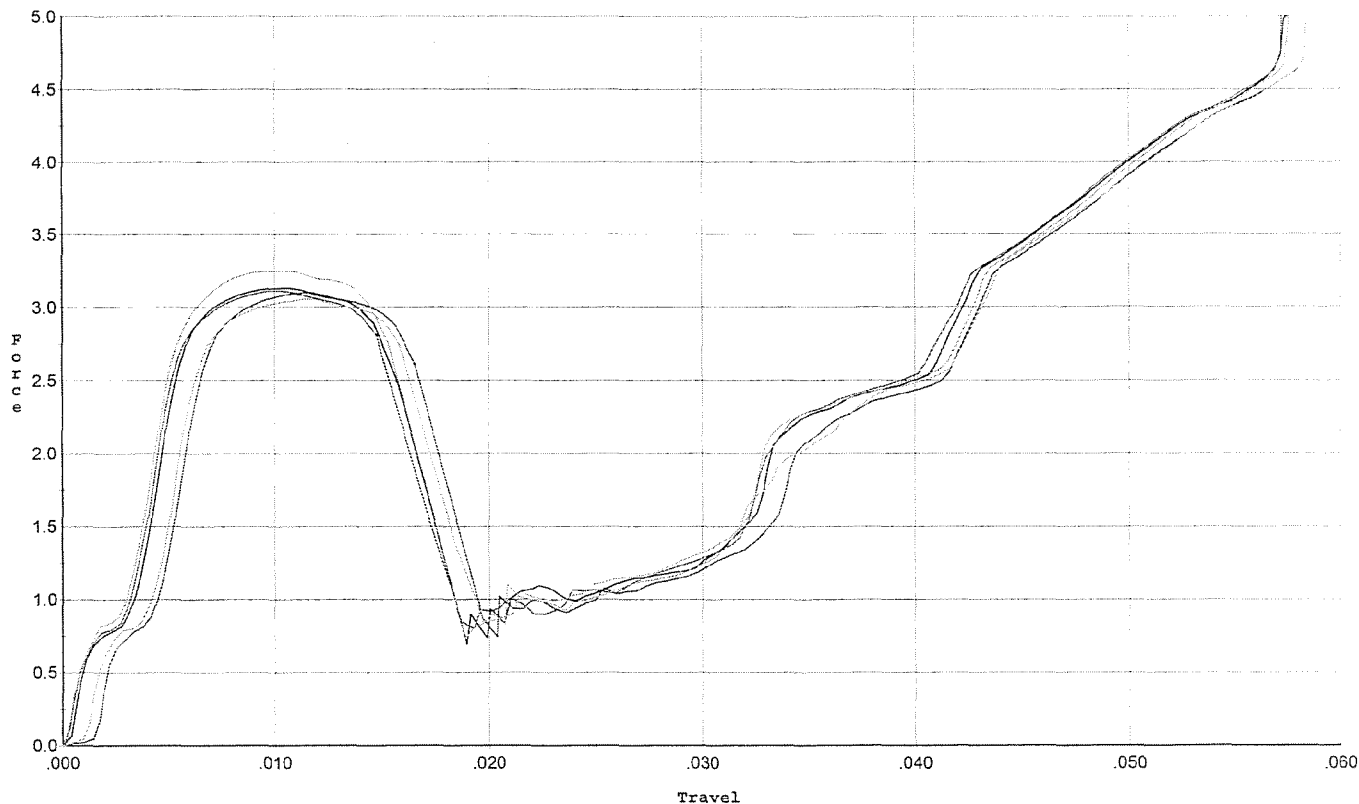
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.201	0.016	0.00	0.042	0.036		Set Trigger
2	3.165	0.016	0.00	0.043	0.034		Set Trigger
3	3.207	0.017	0.00	0.043	0.035		Set Trigger
4	3.136	0.016	0.00	0.043	0.033		Set Trigger
5	3.090	0.016	0.00	0.042	0.033		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



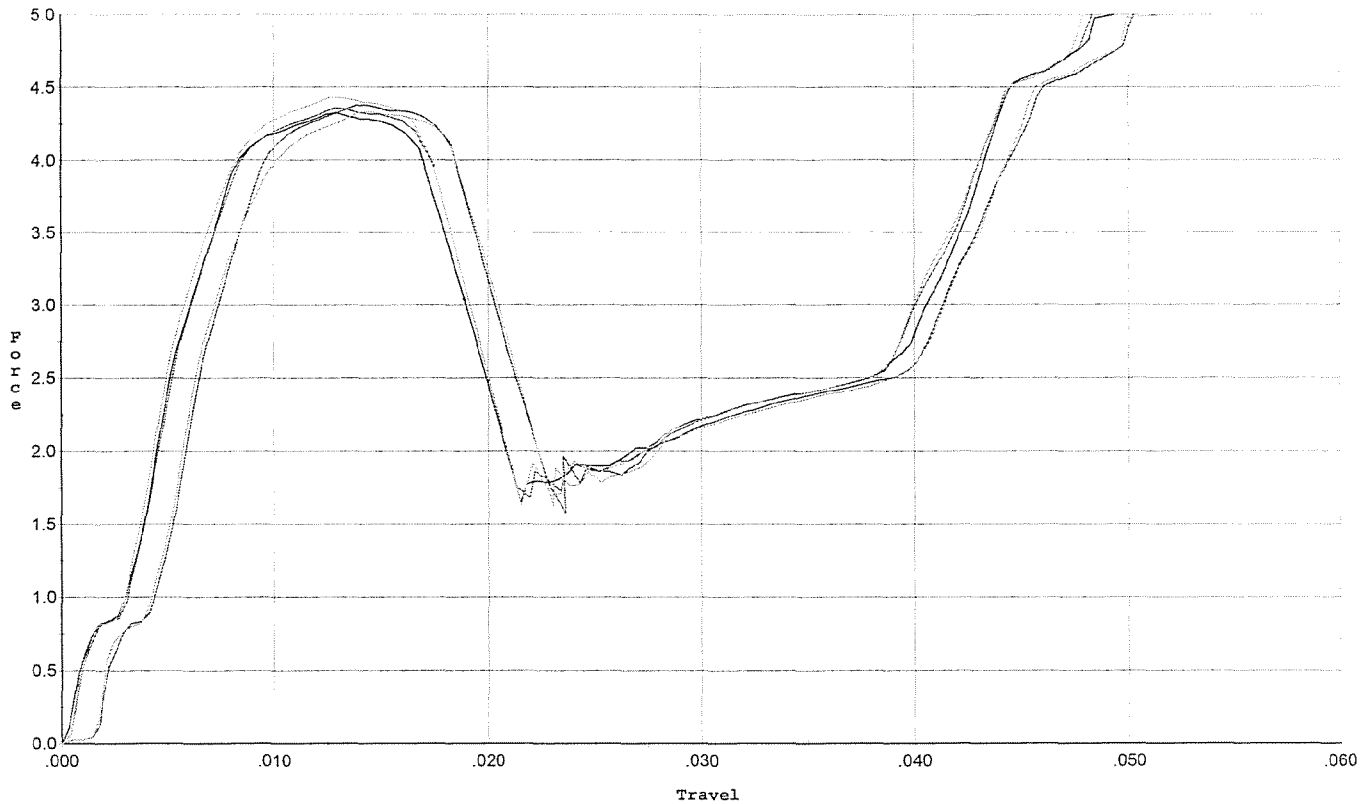
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.099	0.017	0.00	0.043	0.033		Set Trigger
2	3.130	0.016	0.00	0.043	0.034		Set Trigger
3	3.112	0.015	0.00	0.043	0.032		Set Trigger
4	3.057	0.016	0.00	0.043	0.032		Set Trigger
5	3.251	0.015	0.00	0.043	0.035		Set Trigger

A.3-13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



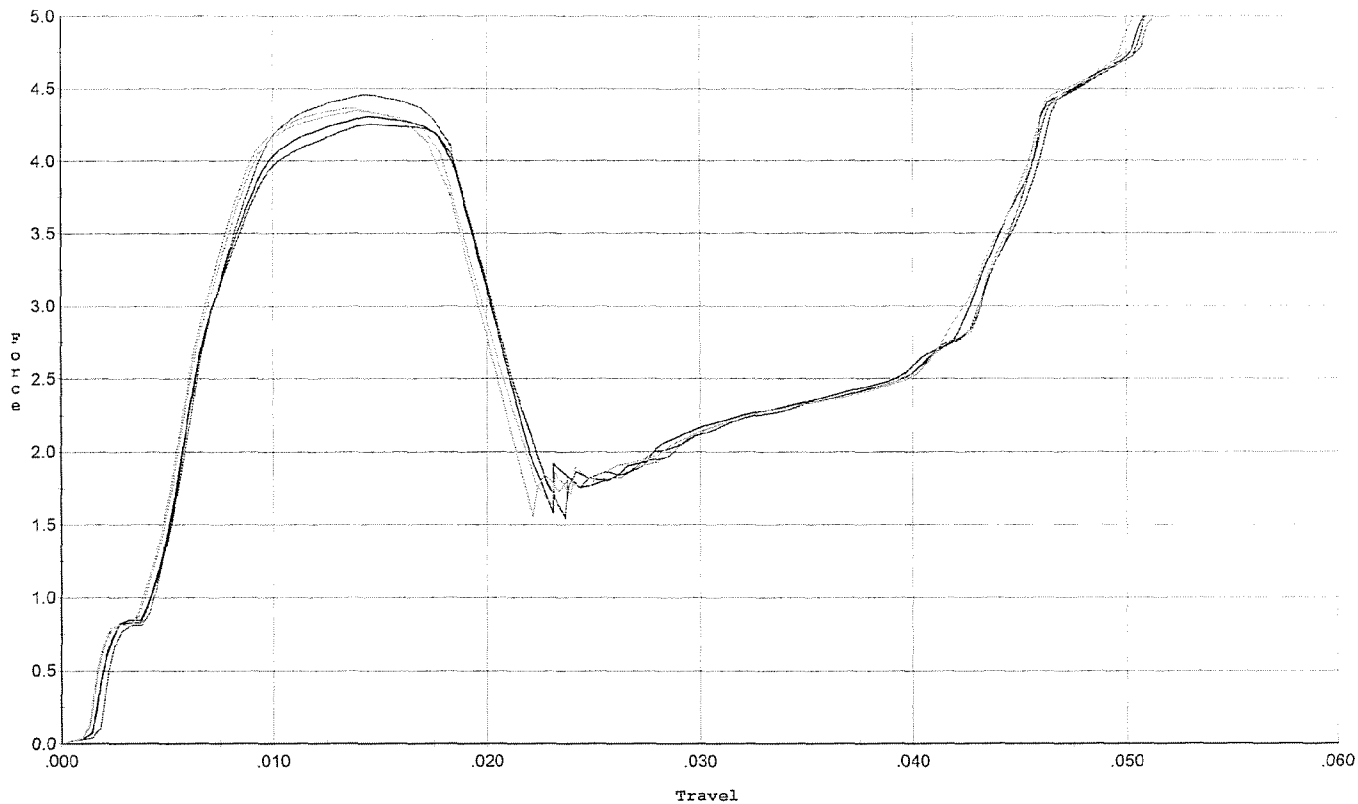
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.380	0.018	0.00	0.033	0.050		Set Trigger
2	4.325	0.019	0.00	0.032	0.054		Set Trigger
3	4.358	0.017	0.00	0.032	0.050		Set Trigger
4	4.434	0.017	0.00	0.032	0.051		Set Trigger
5	4.335	0.020	0.00	0.032	0.055		Set Trigger

A 4.36

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



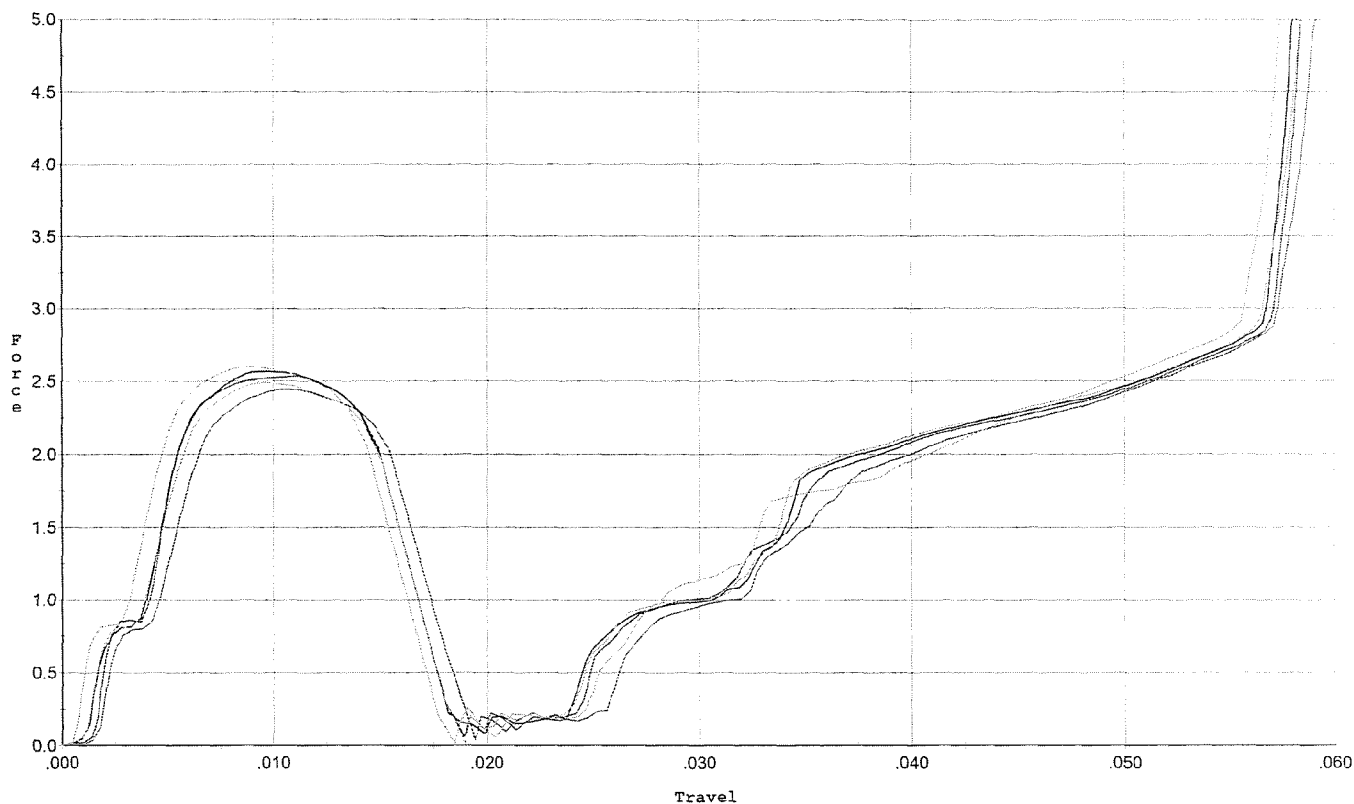
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.018	0.00	0.034	0.050		Set Trigger
2	4.307	0.018	0.00	0.034	0.050		Set Trigger
3	4.456	0.018	0.00	0.034	0.050		Set Trigger
4	4.347	0.018	0.00	0.034	0.049		Set Trigger
5	4.362	0.018	0.00	0.035	0.051		Set Trigger

A-4.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



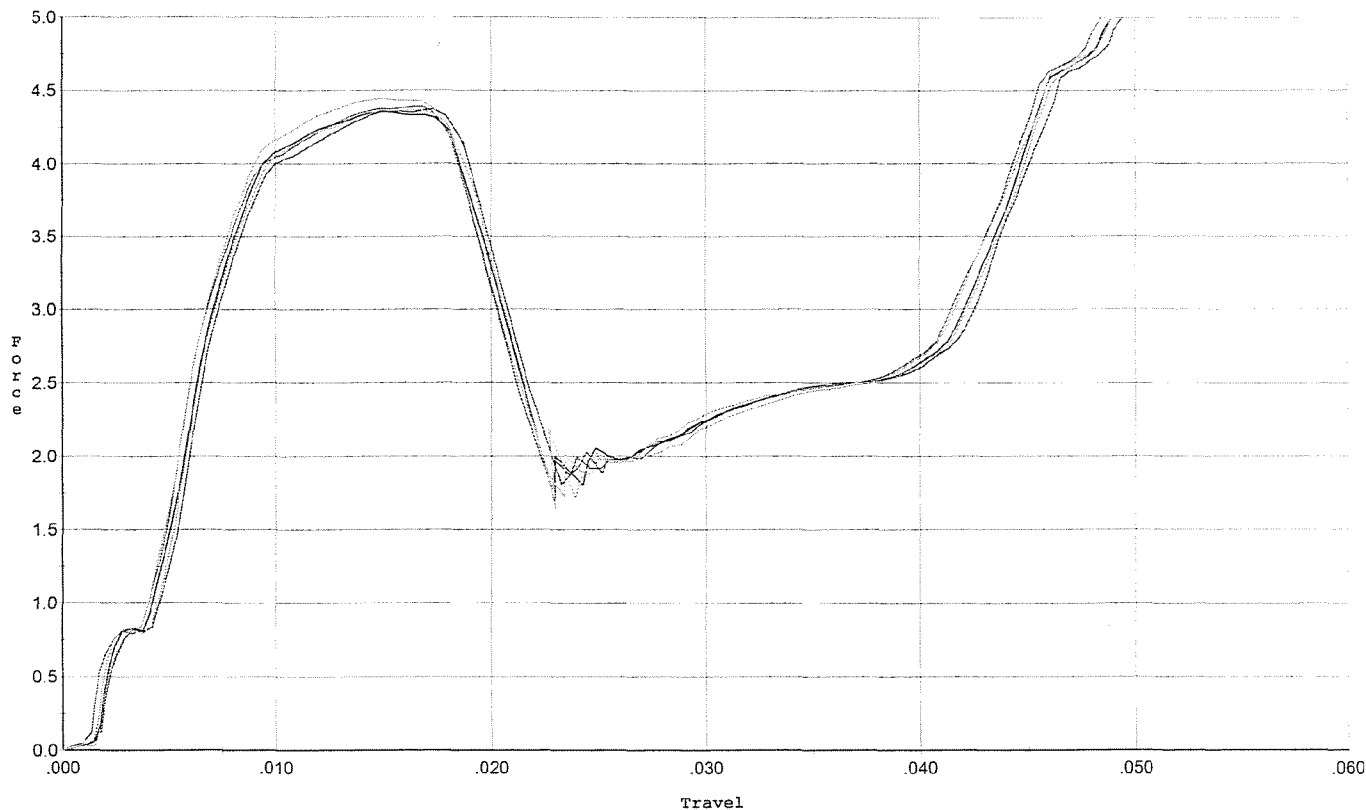
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.015	0.00	0.046	0.025		Set Trigger
2	2.567	0.015	0.00	0.046	0.026		Set Trigger
3	2.442	0.015	0.00	0.047	0.024		Set Trigger
4	2.490	0.015	0.00	0.046	0.025		Set Trigger
5	2.601	0.014	0.00	0.046	0.026		Set Trigger

A-2-52

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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	4.373	0.019	0.00	0.034	0.051		Set Trigger
2	4.356	0.020	0.00	0.033	0.055		Set Trigger
3	4.391	0.018	0.00	0.034	0.051		Set Trigger
4	4.369	0.019	0.002	0.034	0.053		Set Trigger
5	4.441	0.018	0.00	0.034	0.051		Set Trigger

A 4.38