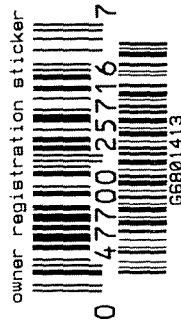
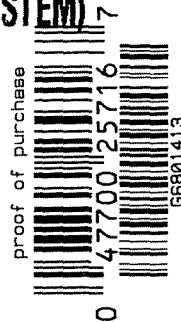


56801413

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

- INSTRUCTION BOOK 3518

BM FORM



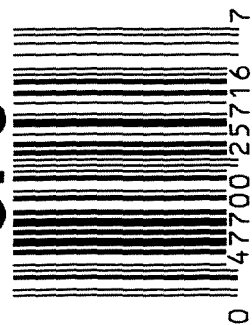
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801413

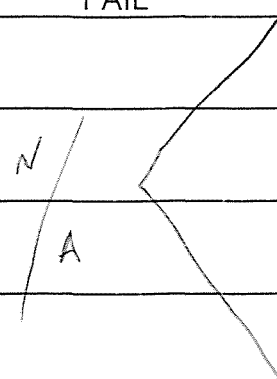
UPC



GUN SERIAL # G 680 1413

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-8-08	BS
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/11/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-29-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

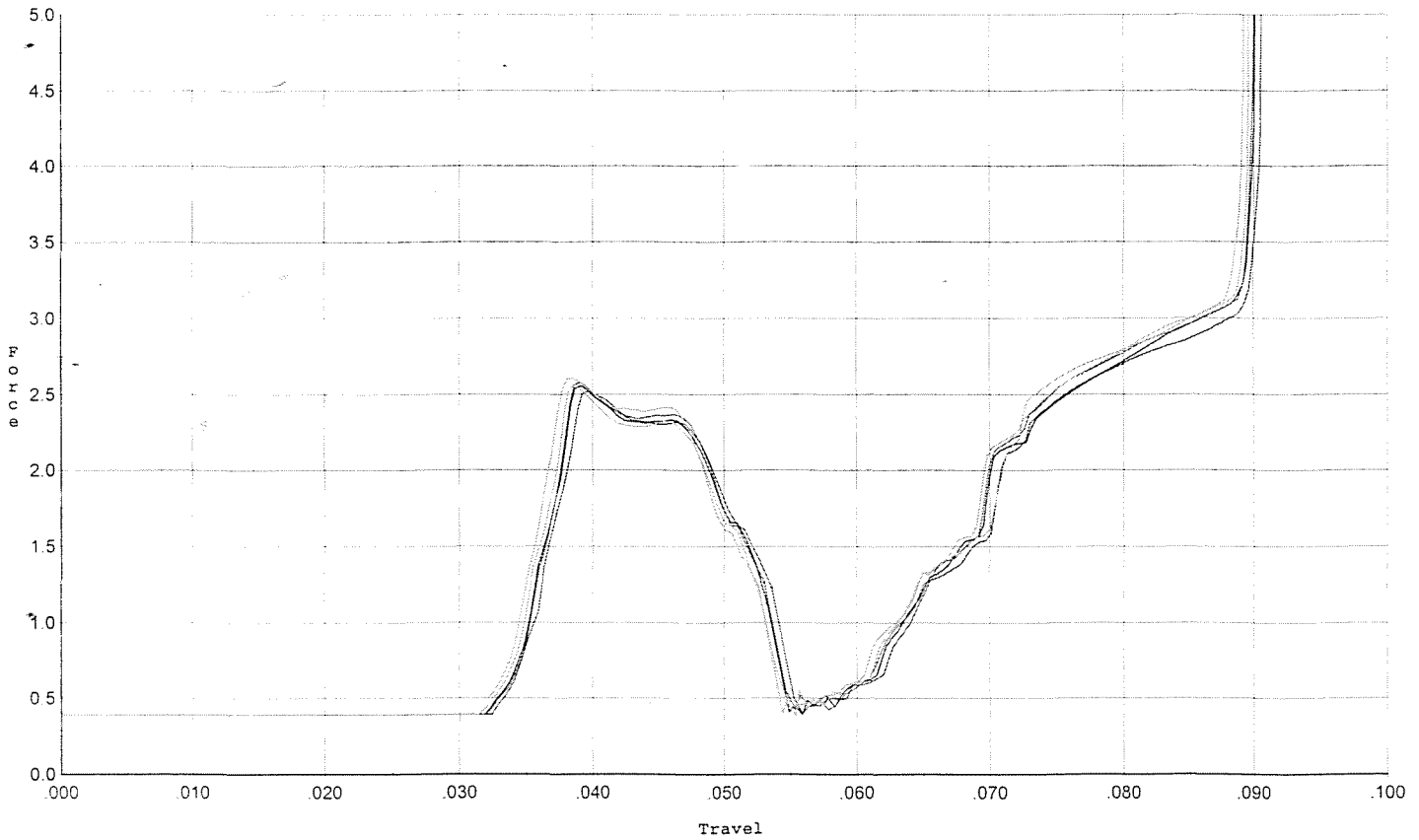
BARBER - M24 0014985		2 LBS MIN 10 LBS MAX	<u>5.0</u>	<u>4.0</u>	<u>4.0</u>	11/7/08 DW		
560	F) SAFETY ON FORCE							
CONT.								
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.0</u>	<u>3.0</u>	<u>3.0</u>	11/7/08 DW		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u>	<u>.025</u>	<u>.025</u>	11/7/08 DW		
	J) ASSEMBLE STOCK					10-29-08 RTZ		
	K) ASSEMBLE SWIVEL STUDS					11/07/08 DW		
	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		10-30-08 RSC		
			<u>PASS</u>	FAIL				
	MALFUNCTION							
	MALFUNCTION							
	MALFUNCTION							
	MALFUNCTION							
	MALFUNCTION							
660	INSPECT FOR LIVE AMMO					10-30-08 TZ		
670	FINAL INSPECTION A) HEADSPACE					11/07/08 DW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u>	<u>2.35</u>	<u>2.33</u>	<u>2.39</u>	<u>2.35</u>	11-5-08 FM
	C) FUNCTION							11/7/08 DW
690	PACK							11/11/08 FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



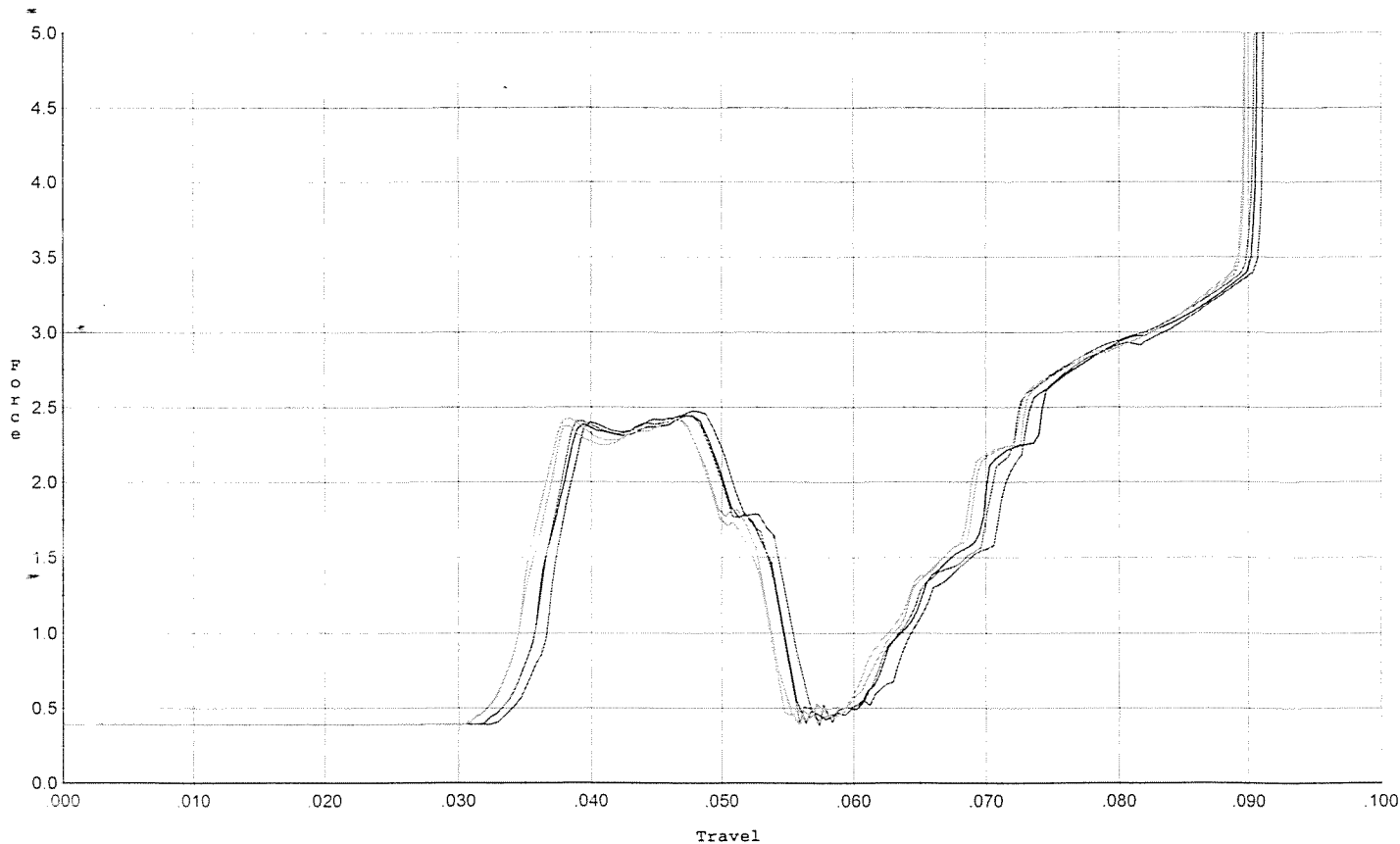
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.054	0.033	0.041	0.051		Set Trigger
2	2.556	0.053	0.034	0.041	0.051		Set Trigger
3	2.577	0.053	0.034	0.041	0.051		Set Trigger
4	2.566	0.053	0.034	0.041	0.051		Set Trigger
5	2.604	0.053	0.033	0.041	0.052		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



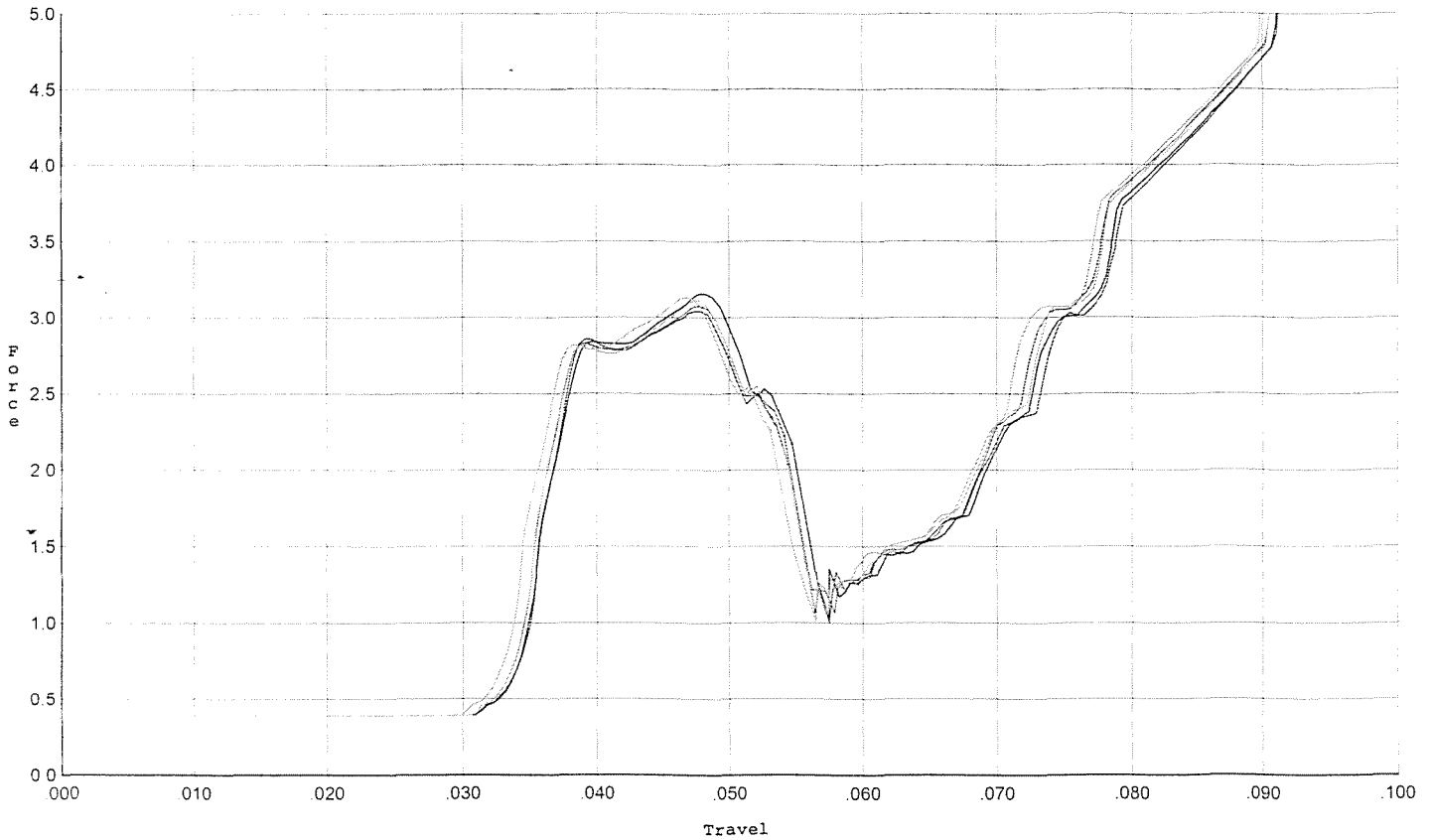
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.476	0.054	0.035	0.040	0.053		Set Trigger
2	2.445	0.054	0.034	0.040	0.053		Set Trigger
3	2.447	0.054	0.034	0.040	0.053		Set Trigger
4	2.417	0.053	0.033	0.041	0.052		Set Trigger
5	2.433	0.053	0.033	0.041	0.053		Set Trigger

Aug 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



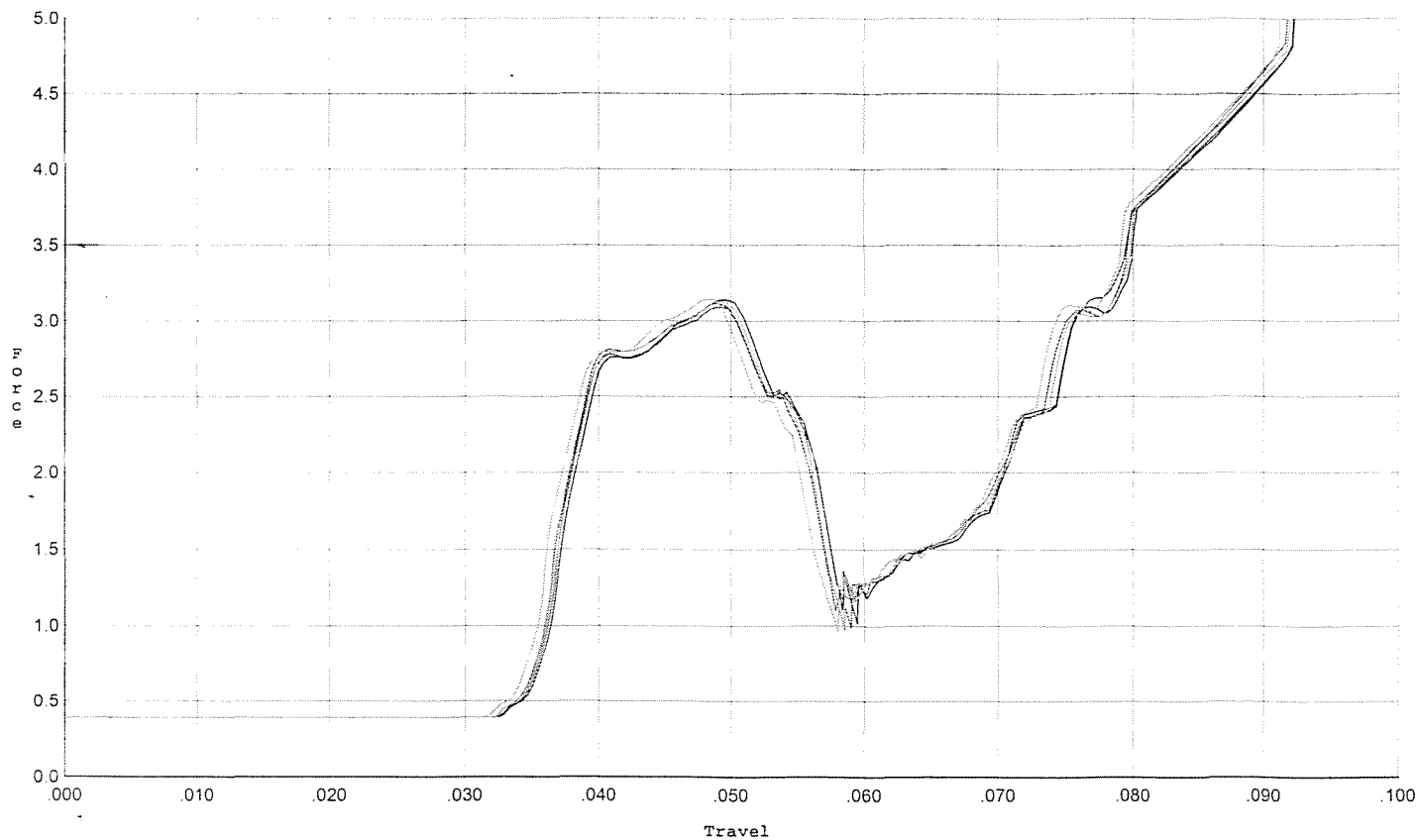
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.042	0.054	0.034	0.039	0.065		Set Trigger
2	3.157	0.055	0.034	0.038	0.067		Set Trigger
3	3.074	0.054	0.033	0.038	0.066		Set Trigger
4	3.112	0.054	0.033	0.038	0.066		Set Trigger
5	3.131	0.053	0.033	0.039	0.066		Set Trigger

Aug 3.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



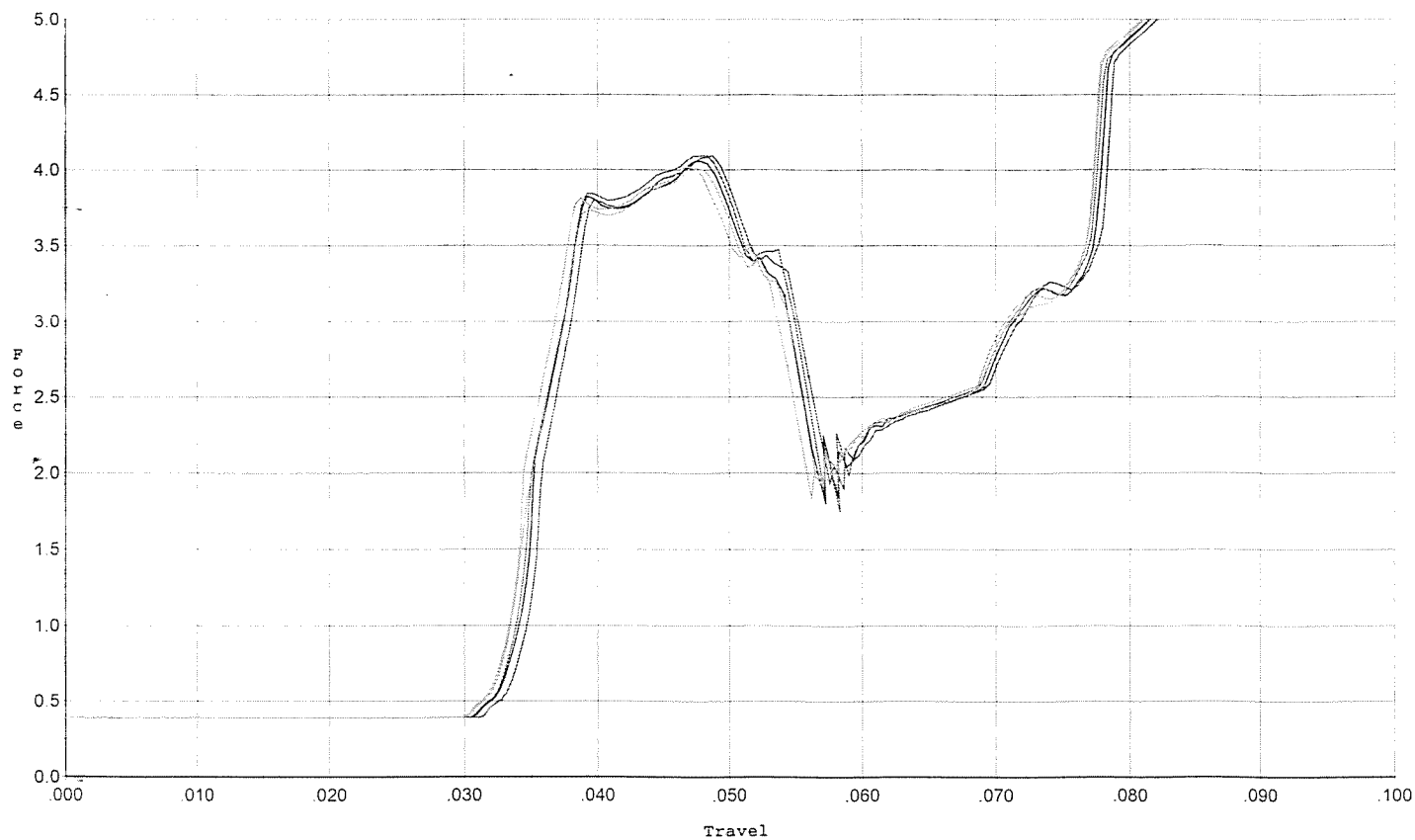
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.090	0.056	0.035	0.039	0.067		Set Trigger
2	3.141	0.056	0.035	0.039	0.068		Set Trigger
3	3.115	0.056	0.035	0.039	0.068		Set Trigger
4	3.129	0.056	0.035	0.039	0.067		Set Trigger
5	3.143	0.055	0.034	0.039	0.066		Set Trigger

Aug 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



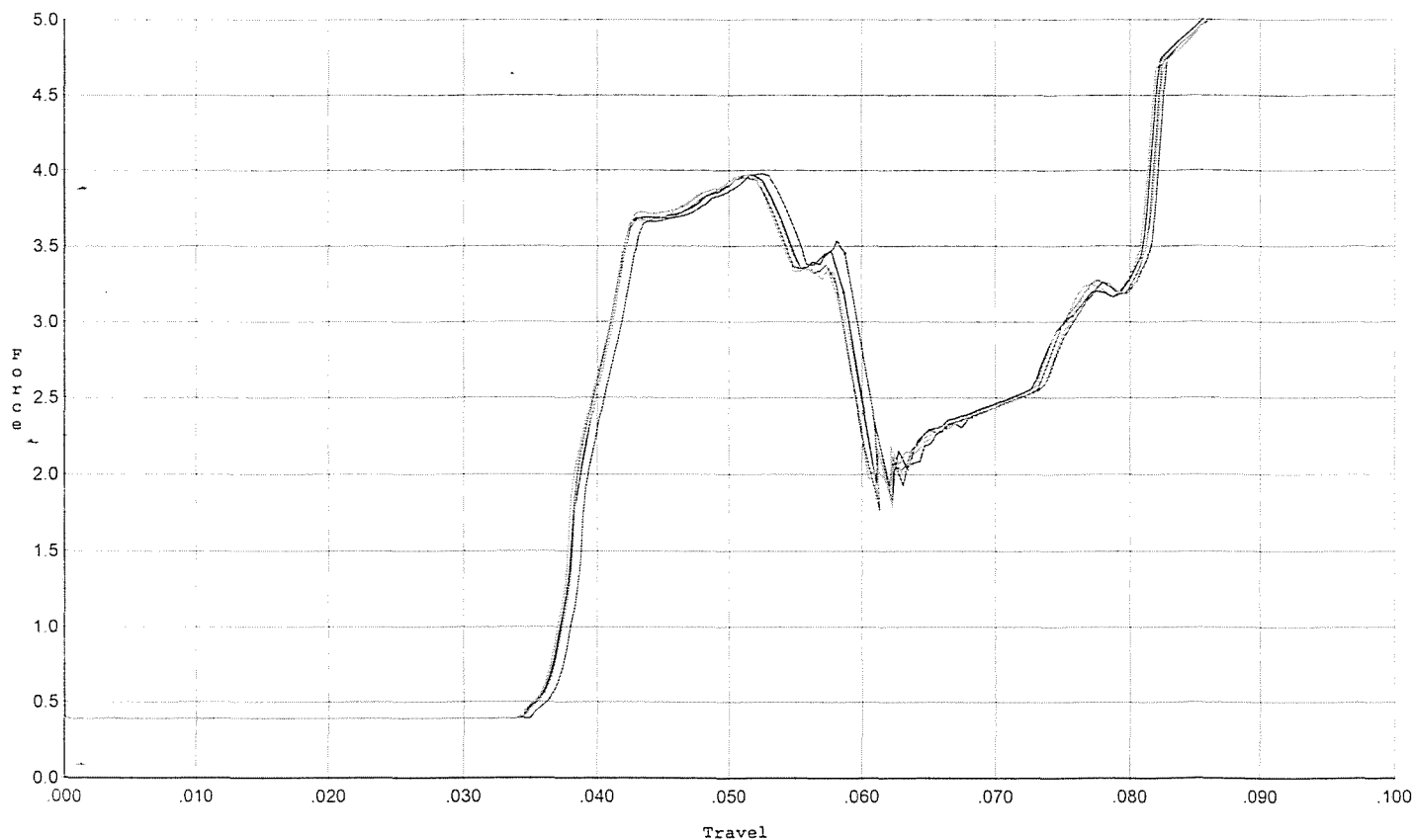
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.095	0.056	0.033	0.037	0.088		Set Trigger
2	4.058	0.054	0.033	0.037	0.084		Set Trigger
3	4.096	0.055	0.033	0.036	0.088		Set Trigger
4	4.011	0.054	0.032	0.036	0.085		Set Trigger
5	4.020	0.054	0.032	0.037	0.085		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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

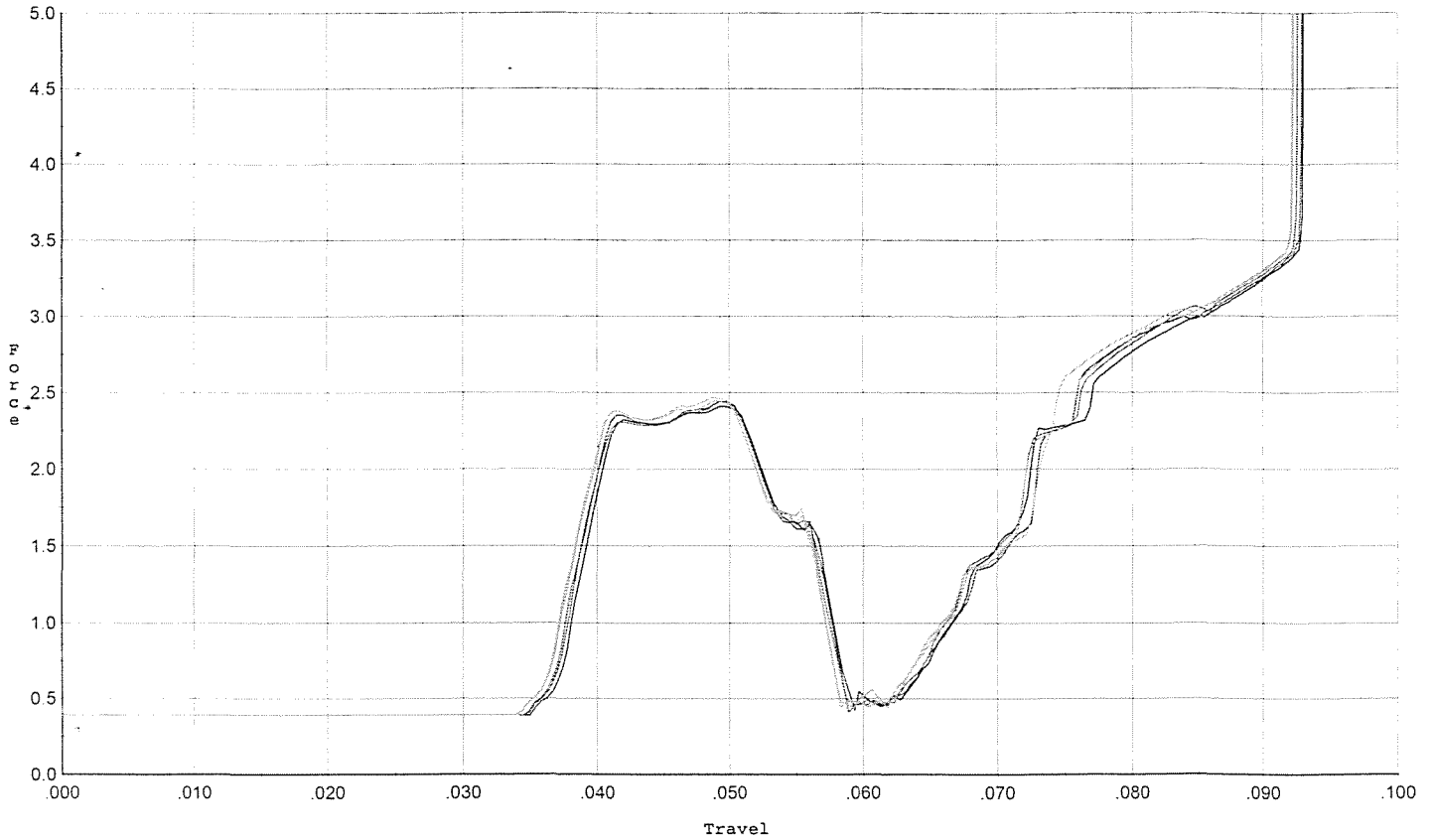


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.977	0.059	0.037	0.039	0.088		Set Trigger
2	3.972	0.059	0.036	0.038	0.089		Set Trigger
3	3.953	0.058	0.035	0.038	0.087		Set Trigger
4	3.969	0.059	0.036	0.038	0.089		Set Trigger
5	3.968	0.058	0.036	0.038	0.088		Set Trigger

Aug 3.96

Trigger Profile [lbs,inch]

• Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 10/28/08		



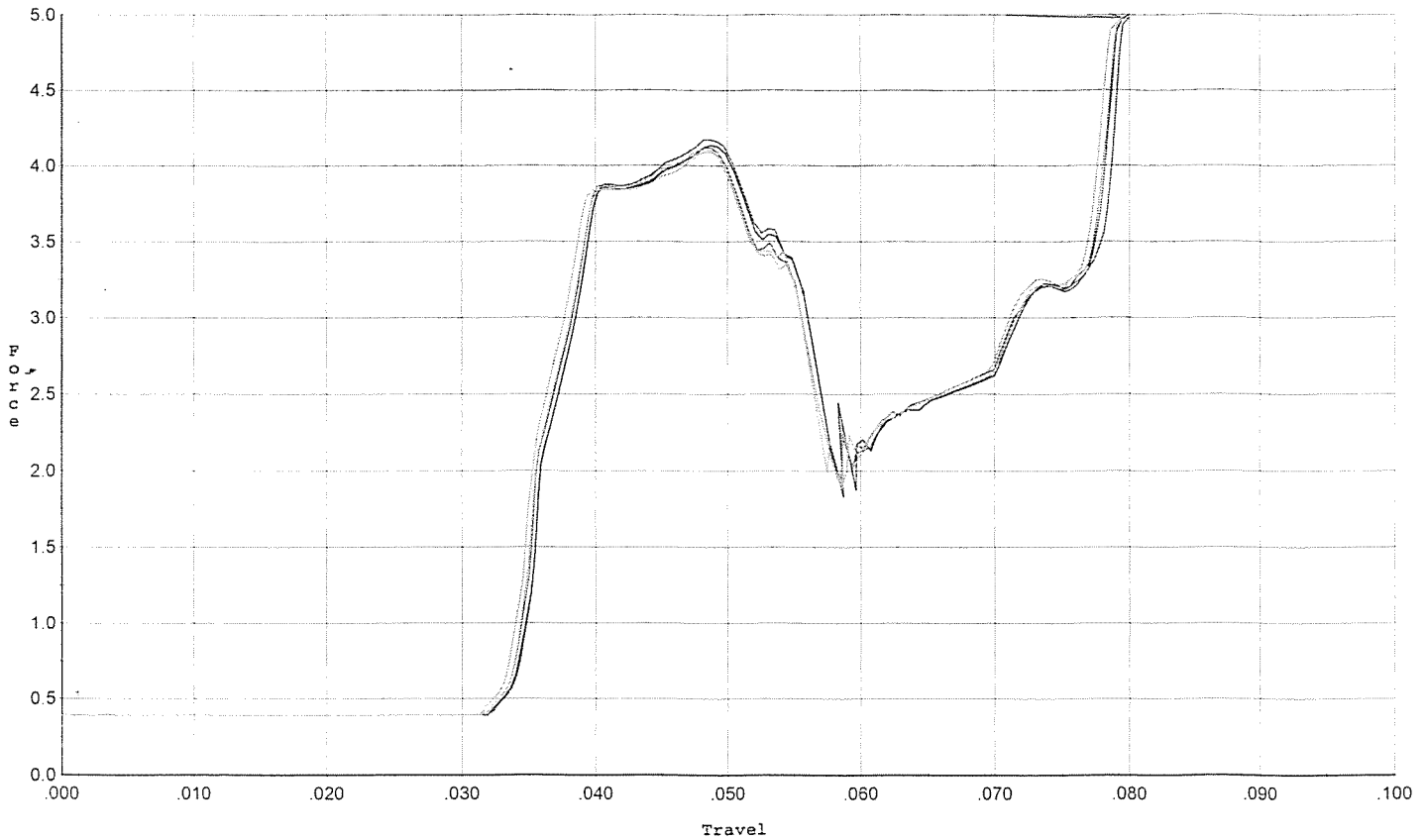
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.057	0.035	0.040	0.055		Set Trigger
2	2.413	0.057	0.037	0.040	0.054		Set Trigger
3	2.442	0.056	0.035	0.040	0.054		Set Trigger
4	2.469	0.056	0.036	0.040	0.055		Set Trigger
5	2.445	0.056	0.036	0.040	0.055		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.056	0.034	0.037	0.089		Set Trigger
2	4.133	0.056	0.034	0.037	0.088		Set Trigger
3	4.118	0.055	0.034	0.037	0.087		Set Trigger
4	4.088	0.055	0.034	0.037	0.087		Set Trigger
5	4.102	0.055	0.033	0.036	0.089		Set Trigger

Aug 4.12