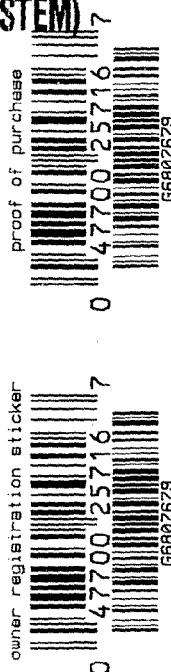


G680 7679

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

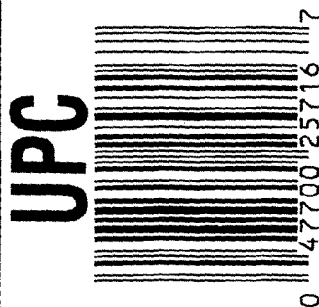
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807679



GUN SERIAL # G 6807679

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	(D)	3/5/09	(D)
490	MAGNAFLUX BOLT		3/5/09	mm
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		03-02-09	SP
520	GOFF BLAST BBL / REC		3/6	mm
540	APPLY COATINGS (BARREL ACTION)		5/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-12-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

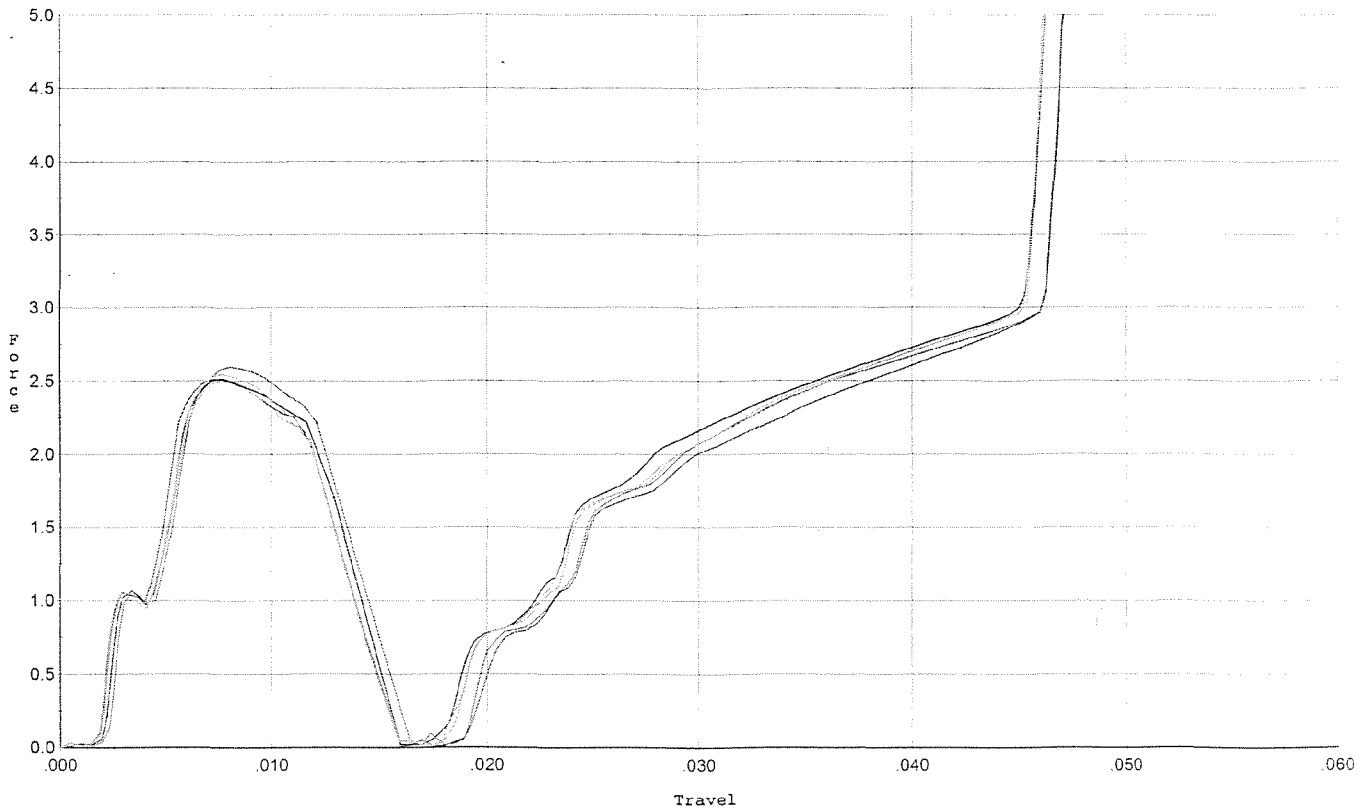
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>10</u> <u>6</u> <u>10</u>	3-20-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>5</u> <u>4.5</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-12-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	NW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	3-19-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-19-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.62</u> <u>2.58</u> <u>2.52</u> <u>2.47</u>	3-20-09	TC
	C) FUNCTION		3-20-09	NW
690	PACK		3-21-09	TC

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



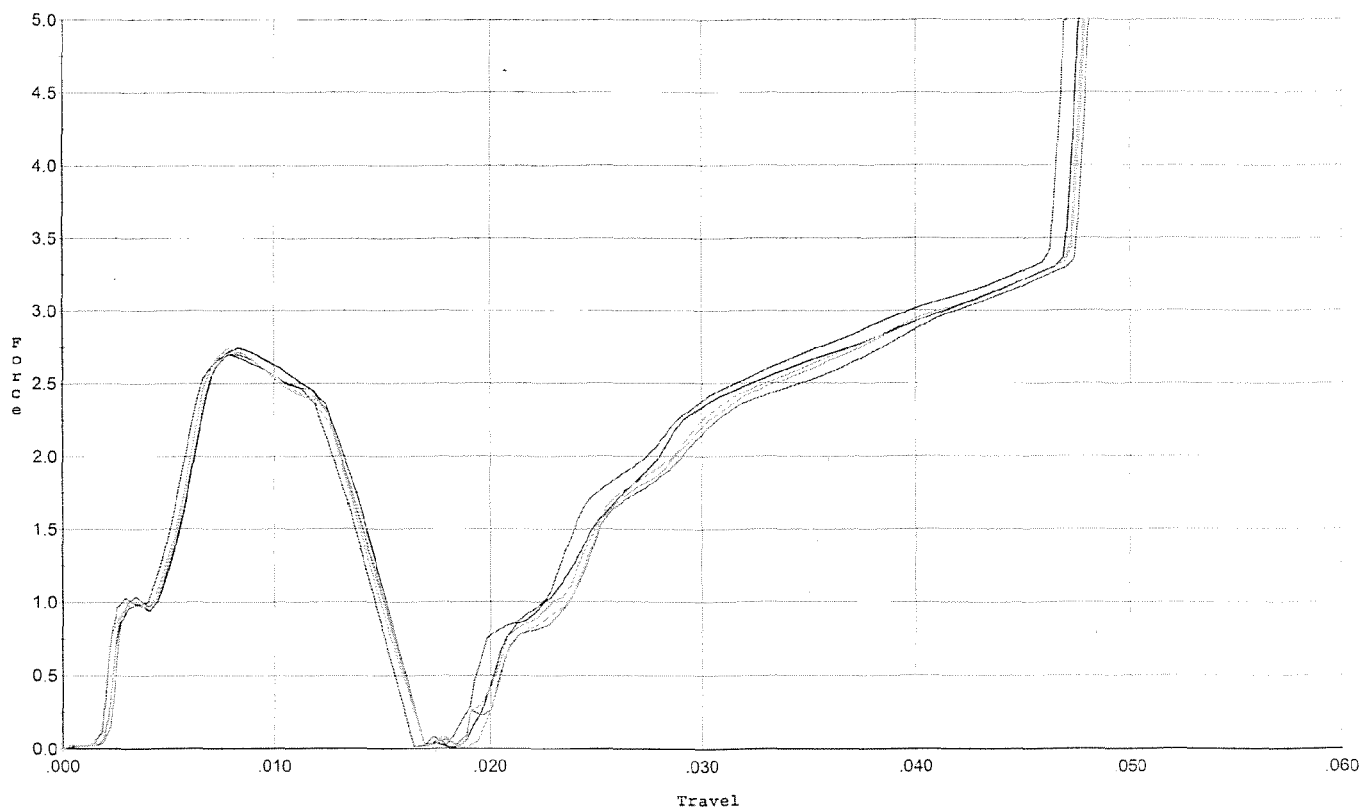
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.012	0.004	0.038	0.018		Set Trigger
2	2.515	0.013	0.002	0.037	0.019		Set Trigger
3	2.596	0.012	0.005	0.037	0.019		Set Trigger
4	2.546	0.012	0.004	0.037	0.018		Set Trigger
5	2.501	0.012	0.004	0.037	0.018		Set Trigger

A-2.53

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



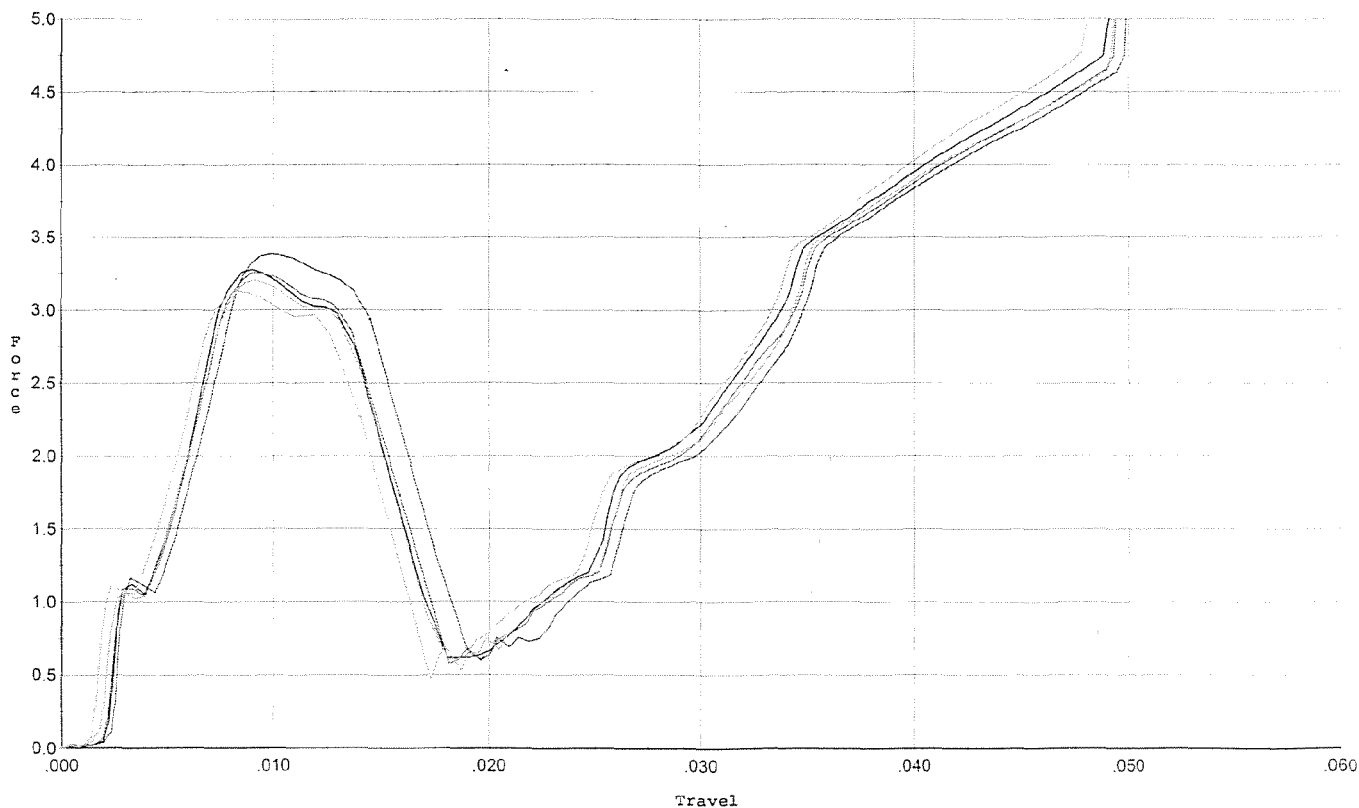
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.695	0.013	0.00	0.036	0.022		Set Trigger
2	2.746	0.014	0.002	0.037	0.022		Set Trigger
3	2.699	0.015	0.00	0.037	0.023		Set Trigger
4	2.712	0.014	0.002	0.037	0.022		Set Trigger
5	2.742	0.013	0.004	0.037	0.020		Set Trigger

A 2.71

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



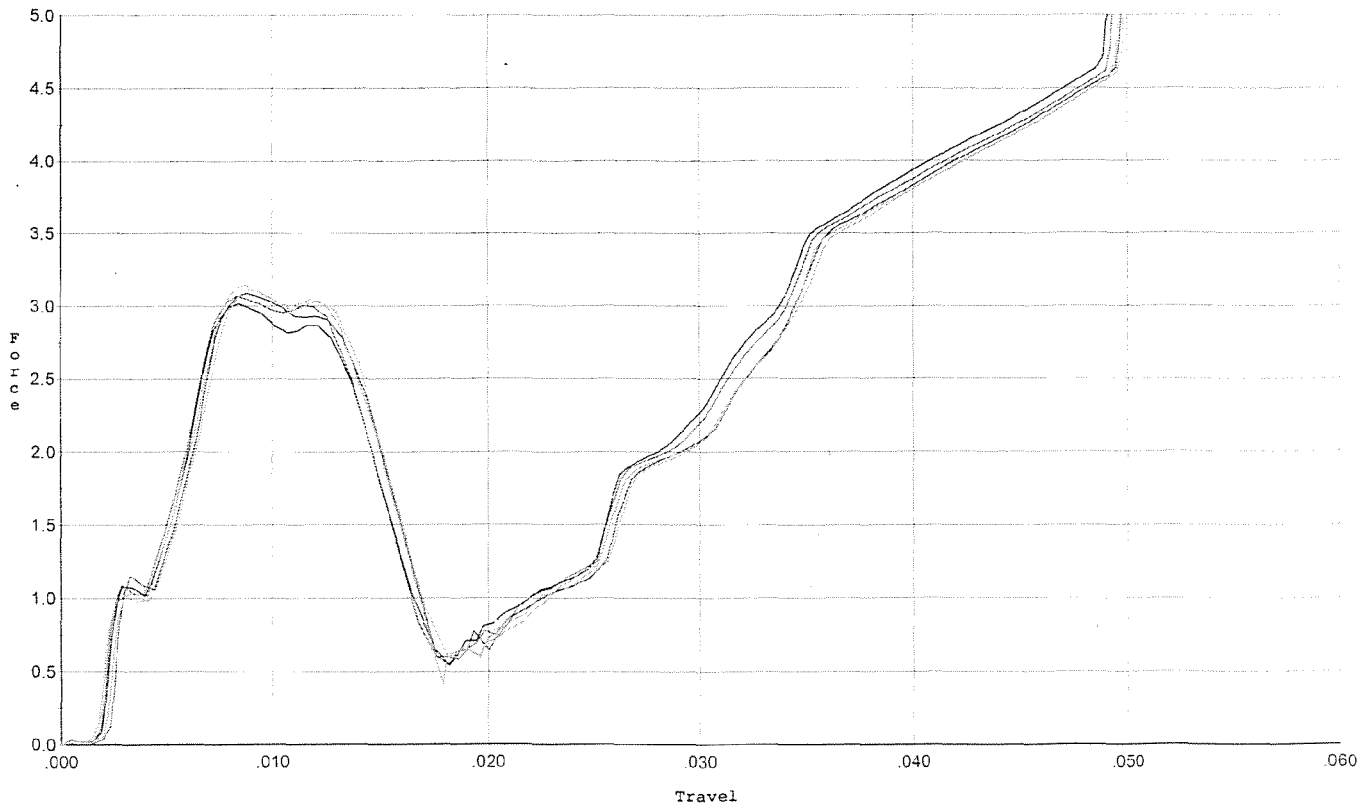
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.382	0.015	0.005	0.035	0.029		Set Trigger
2	3.277	0.014	0.00	0.036	0.027		Set Trigger
3	3.258	0.016	0.002	0.035	0.030		Set Trigger
4	3.130	0.014	0.004	0.035	0.027		Set Trigger
5	3.206	0.014	0.00	0.036	0.027		Set Trigger

A-3-25

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



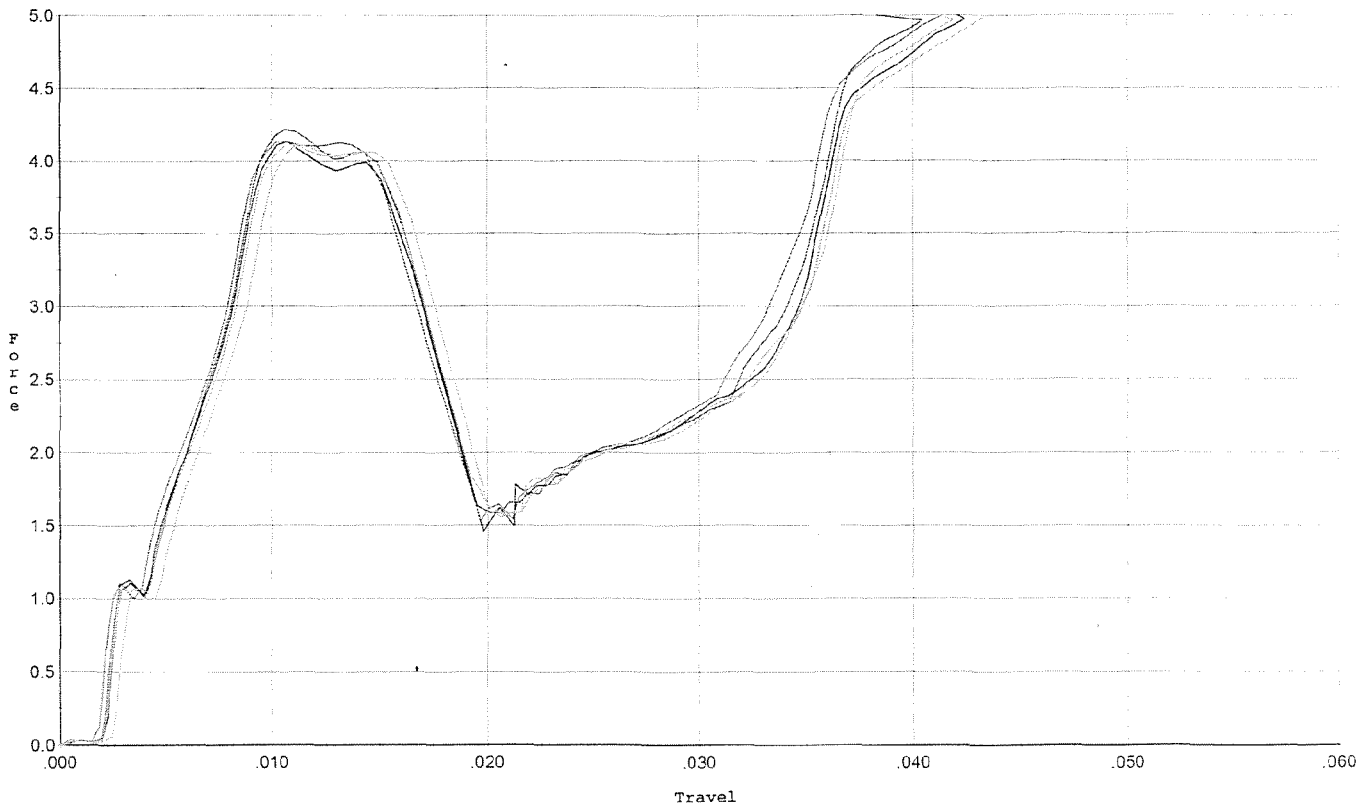
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.085	0.014	0.005	0.036	0.026		Set Trigger
2	3.018	0.014	0.004	0.036	0.025		Set Trigger
3	3.069	0.014	0.004	0.036	0.025		Set Trigger
4	3.112	0.014	0.00	0.036	0.026		Set Trigger
5	3.143	0.015	0.00	0.036	0.028		Set Trigger

A-3.08

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



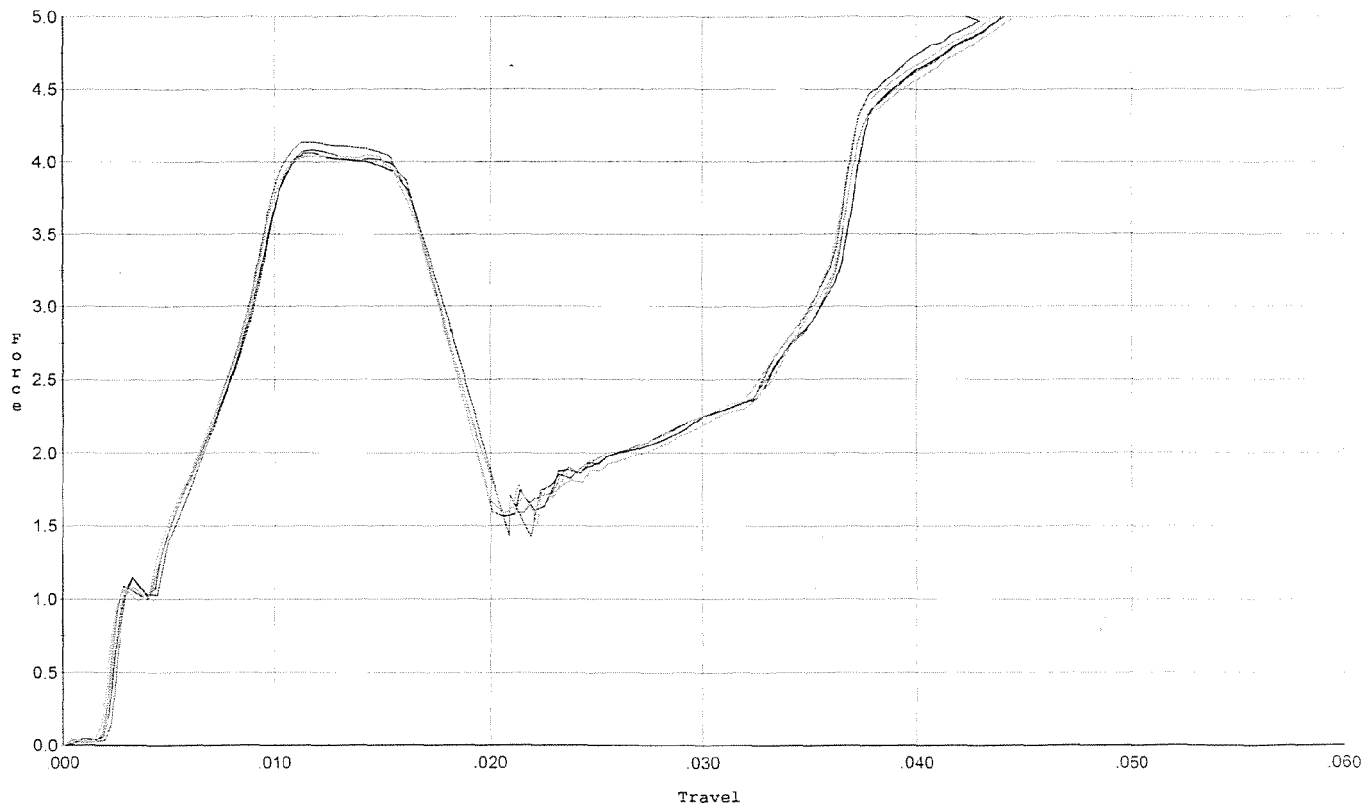
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.216	0.016	0.00	0.034	0.039		Set Trigger
2	4.134	0.017	0.00	0.034	0.040		Set Trigger
3	4.136	0.015	0.002	0.034	0.037		Set Trigger
4	4.115	0.016	0.002	0.035	0.038		Set Trigger
5	4.114	0.017	0.00	0.034	0.039		Set Trigger

A-4.14

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



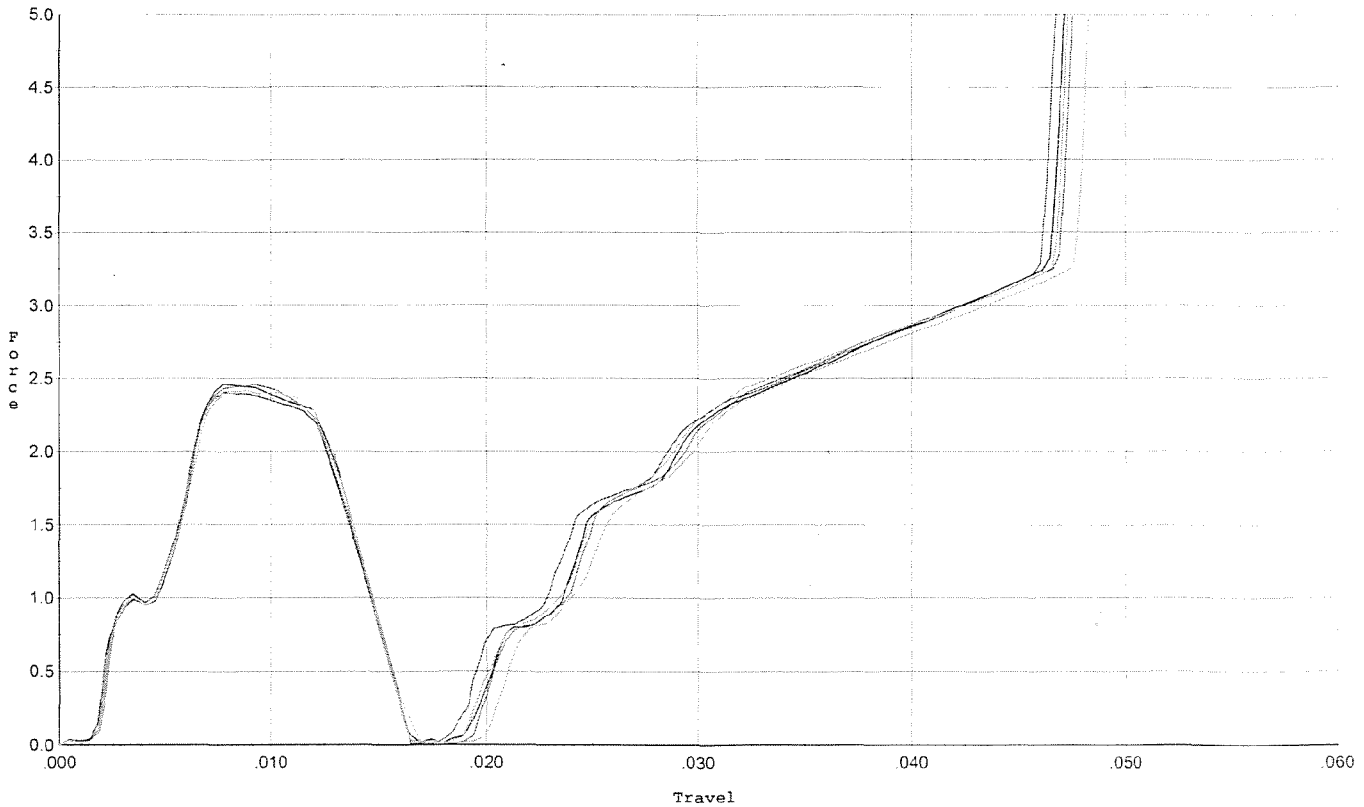
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.018	0.005	0.034	0.043		Set Trigger
2	4.058	0.016	0.00	0.035	0.038		Set Trigger
3	4.134	0.016	0.002	0.035	0.039		Set Trigger
4	4.042	0.016	0.00	0.034	0.039		Set Trigger
5	4.046	0.017	0.002	0.034	0.039		Set Trigger

A-4.07

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



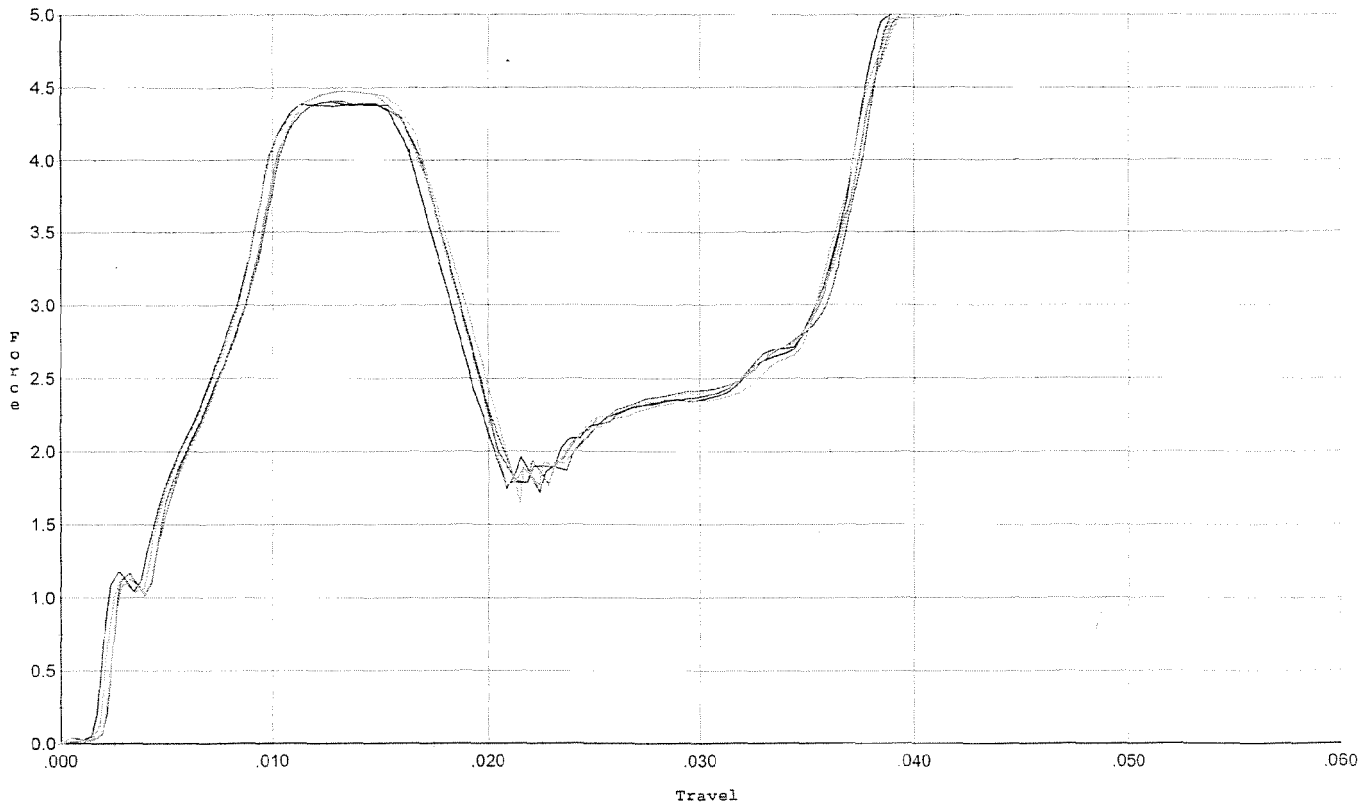
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.407	0.014	0.002	0.036	0.020		Set Trigger
2	2.460	0.013	0.00	0.037	0.020		Set Trigger
3	2.458	0.014	0.002	0.037	0.020		Set Trigger
4	2.415	0.013	0.00	0.038	0.019		Set Trigger
5	2.420	0.013	0.00	0.037	0.019		Set Trigger

A-2-43

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	4.381	0.017	0.00	0.027	0.043		Set Trigger
2	4.403	0.016	0.00	0.028	0.043		Set Trigger
3	4.413	0.017	0.002	0.026	0.043		Set Trigger
4	4.476	0.017	0.00	0.027	0.045		Set Trigger
5	4.472	0.019	0.002	0.028	0.049		Set Trigger

A-4.42