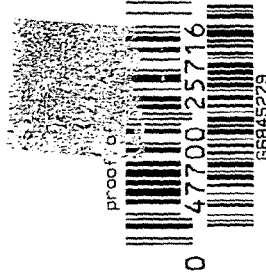


G6845279

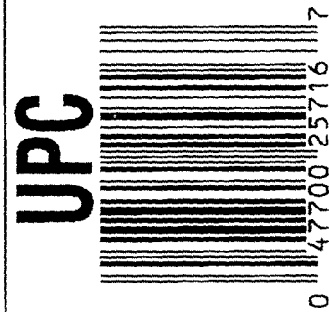
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



|               |       |
|---------------|-------|
| ORDER NO.     | 25716 |
| BARREL LENGTH | 24"   |
| CAPACITY      | 6     |

G6845279



BM FORM

GUN SERIAL # 66845279

| OP # | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |          | 3-17-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |          | 3-17-09 | RP      |
| 440  | PROOF                                                                                                                                  |          | 3-17-09 | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        |          | 3-17-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |          | 3-17-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-18-09 | RT      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-19-09 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | (H)      | 3-20-09 | (H)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |          |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |          | 3-24-09 | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |          | 3-24    | BT      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 2-27    |         |
| 545  | (BOLT)                                                                                                                                 |          |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |          |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 3-28-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 3-28-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 3-28-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 4-1-09  | SPD     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |          |         |         |

F004 REV 5/2006

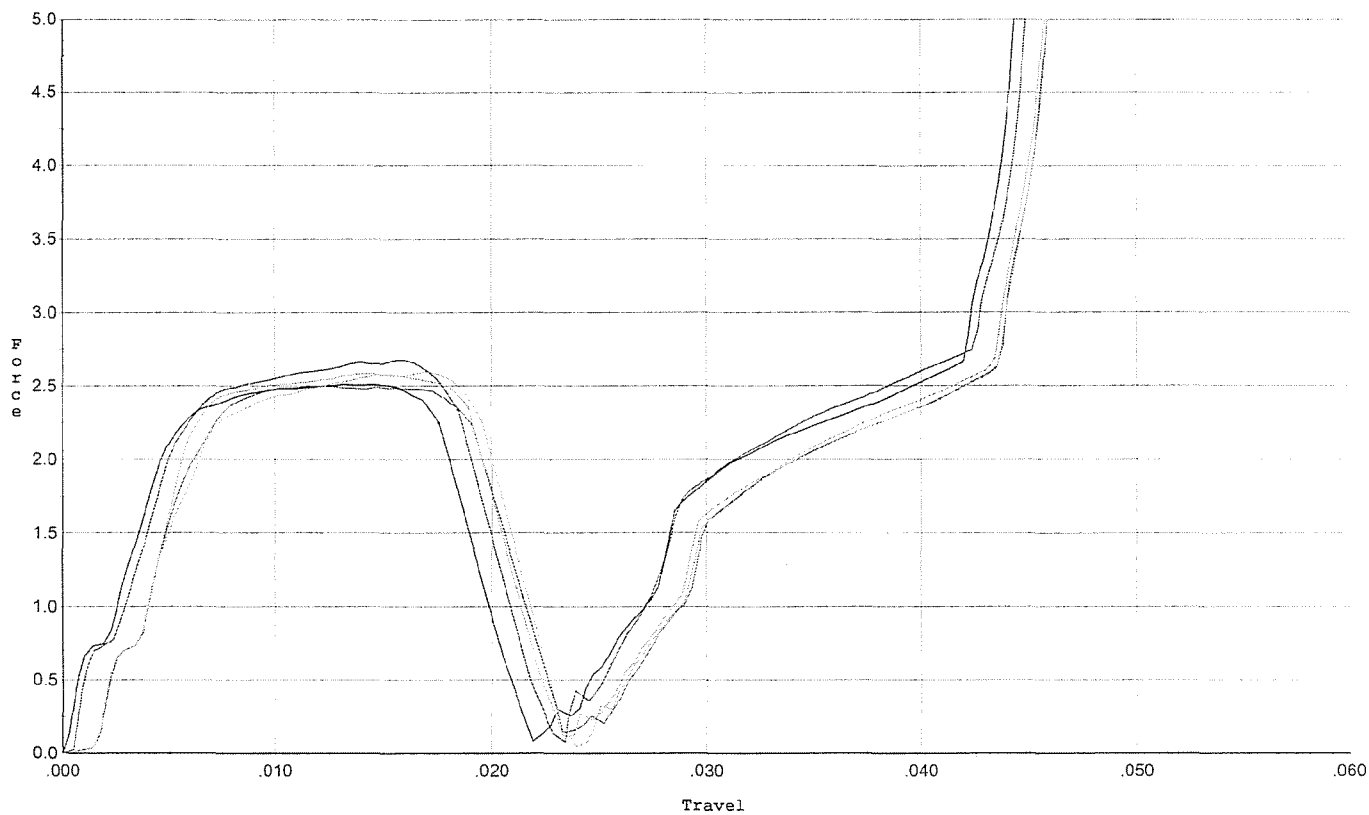
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>6</u> <u>55</u> <u>6</u>                                 | 4-13-09 | WN      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3.5</u> <u>3.5</u> <u>3.5</u>                            | 4-13-09 | WN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.024</u>                         | 4-13-09 | WN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 4-1-09  | S.P.D.  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 4-13-09 | WN      |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             |         |         |
|              | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             |         |         |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             |         |         |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                              | <u>PASS</u> FAIL<br><u>PASS</u> FAIL                        | 4-2-09  | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 4-2-09  | WN      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 4-13-09 | WN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.45</u> <u>2.33</u> <u>2.43</u> <u>2.39</u> <u>2.42</u> | 4-7-09  | RP      |
|              | C) FUNCTION                                                              |                                                             | 4-13-09 | WN      |
| 690          | PACK                                                                     |                                                             | 6/1/09  | 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



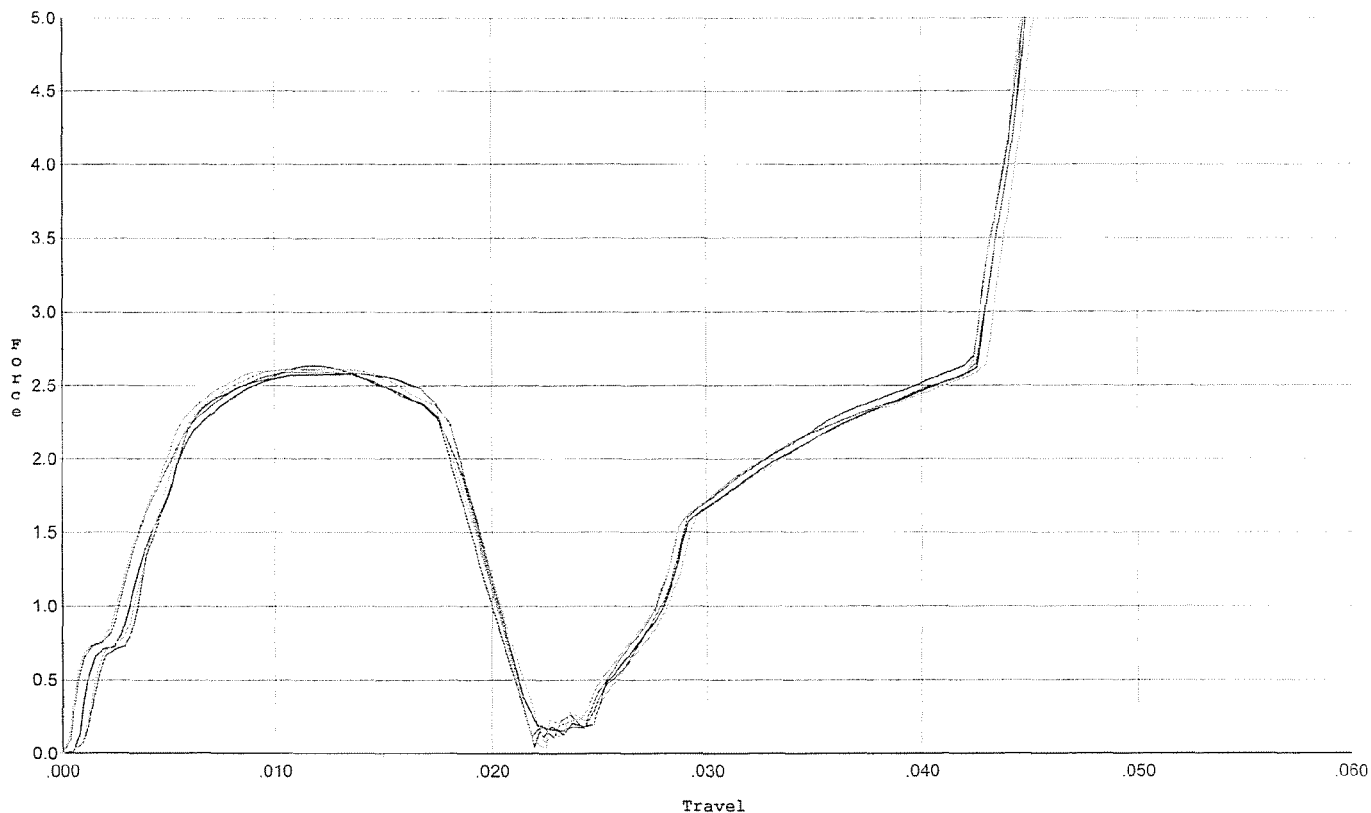
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.677      | 0.018             | 0.00            | 0.030      | 0.036             |           | Set Trigger |
| 2 | 2.510      | 0.018             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 3 | 2.499      | 0.019             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 4 | 2.599      | 0.020             | 0.00            | 0.030      | 0.036             |           | Set Trigger |
| 5 | 2.585      | 0.019             | 0.00            | 0.030      | 0.035             |           | Set Trigger |

A-2.57

## 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



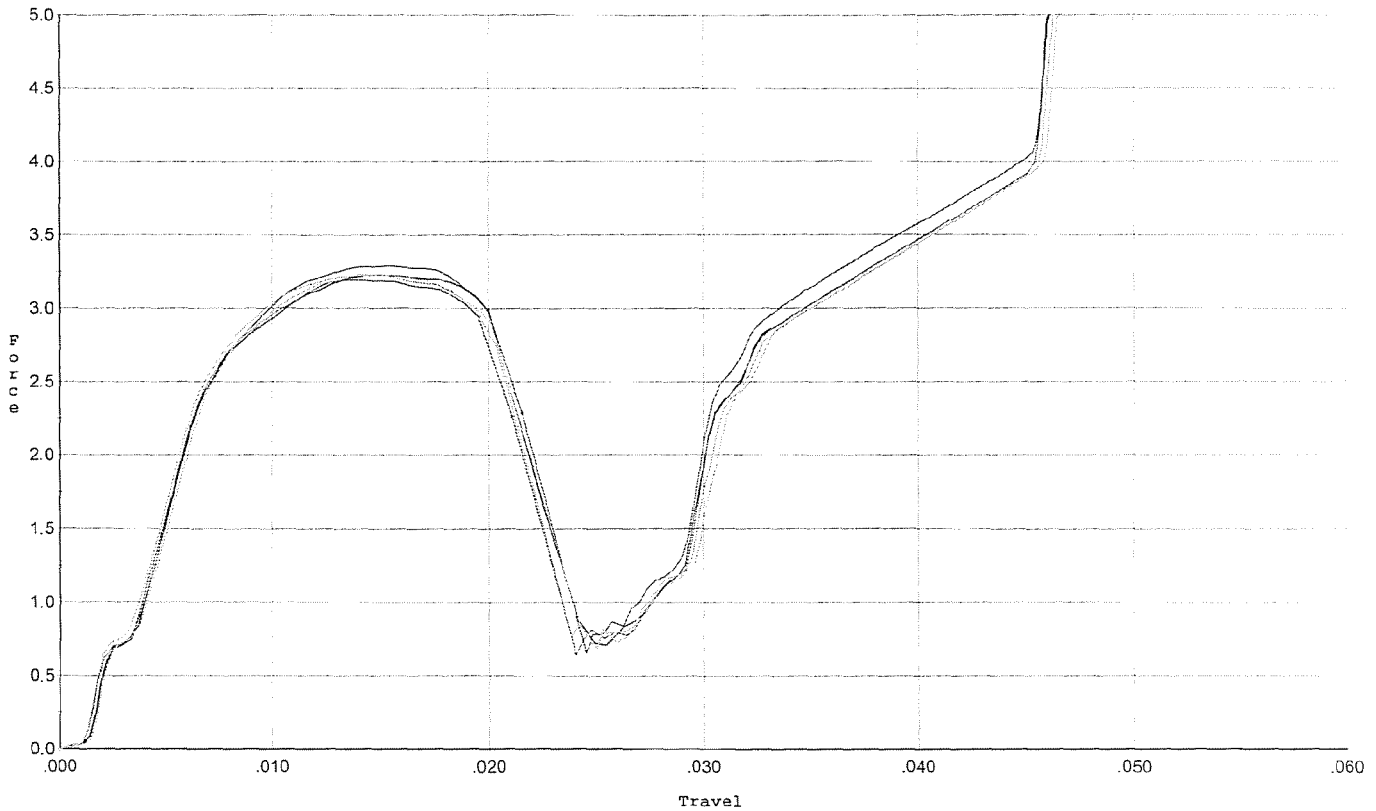
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.638      | 0.019             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 2 | 2.582      | 0.018             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 3 | 2.594      | 0.018             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 4 | 2.613      | 0.018             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 5 | 2.622      | 0.019             | 0.00            | 0.030      | 0.038             |           | Set Trigger |

A. 2.61

## 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



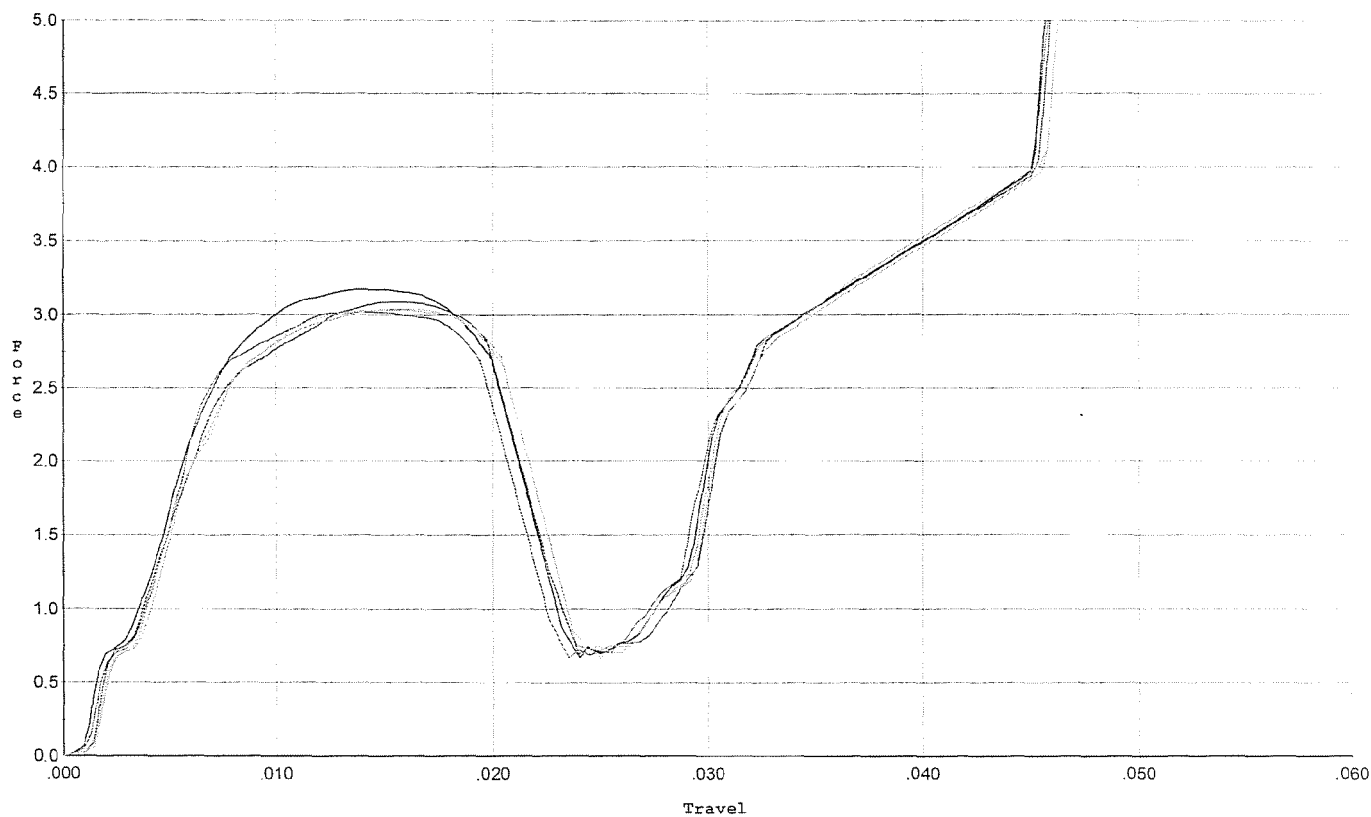
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.290      | 0.022             | 0.00            | 0.029      | 0.048             |           | Set Trigger |
| 2 | 3.227      | 0.020             | 0.00            | 0.029      | 0.044             |           | Set Trigger |
| 3 | 3.194      | 0.021             | 0.00            | 0.029      | 0.046             |           | Set Trigger |
| 4 | 3.233      | 0.020             | 0.00            | 0.030      | 0.044             |           | Set Trigger |
| 5 | 3.226      | 0.020             | 0.00            | 0.029      | 0.046             |           | Set Trigger |

A-3.23

## 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



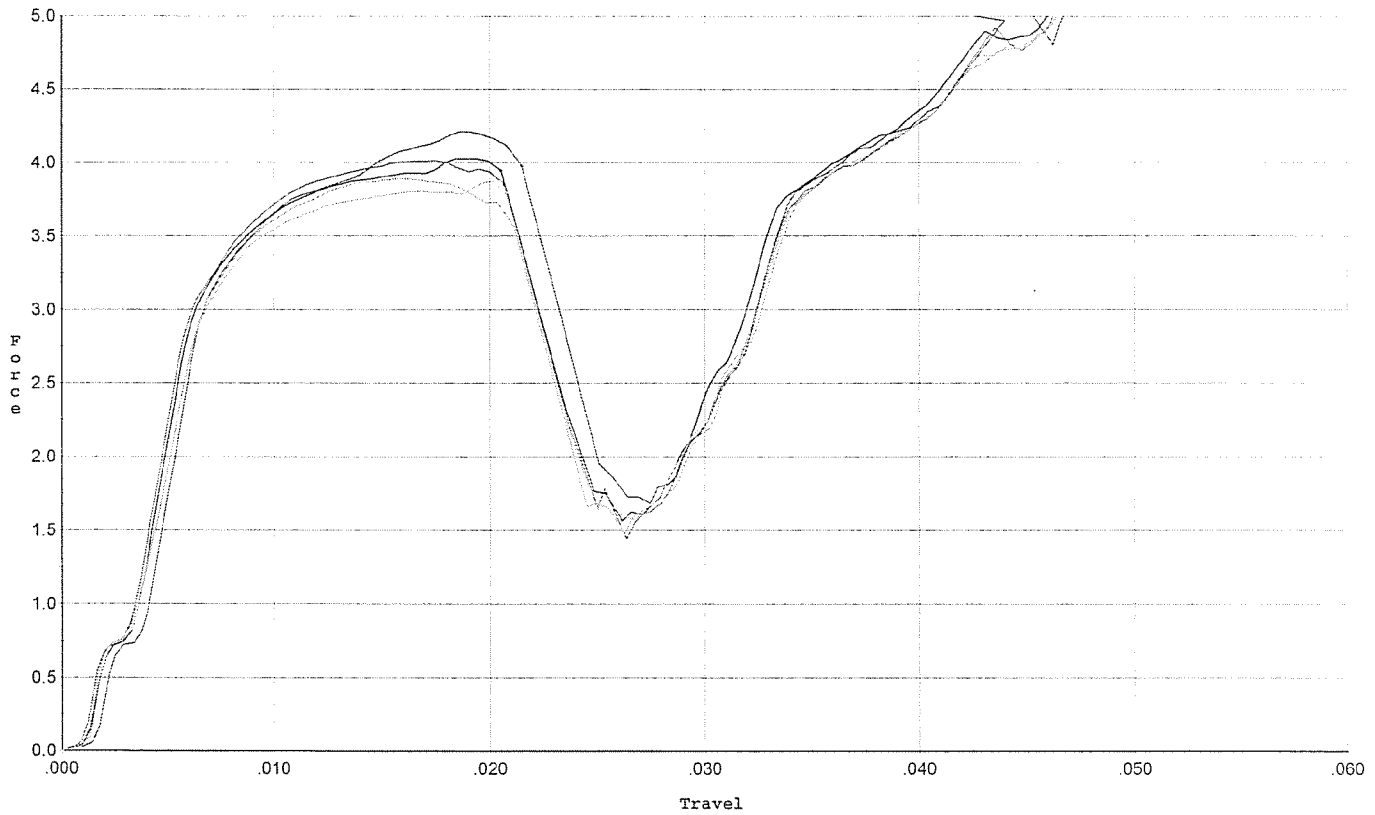
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.086      | 0.020             | 0.00            | 0.030      | 0.042             |           | Set Trigger |
| 2 | 3.171      | 0.020             | 0.00            | 0.029      | 0.044             |           | Set Trigger |
| 3 | 3.019      | 0.019             | 0.00            | 0.029      | 0.041             |           | Set Trigger |
| 4 | 3.039      | 0.020             | 0.00            | 0.030      | 0.043             |           | Set Trigger |
| 5 | 3.034      | 0.020             | 0.00            | 0.029      | 0.043             |           | Set Trigger |

A-3.07

## 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



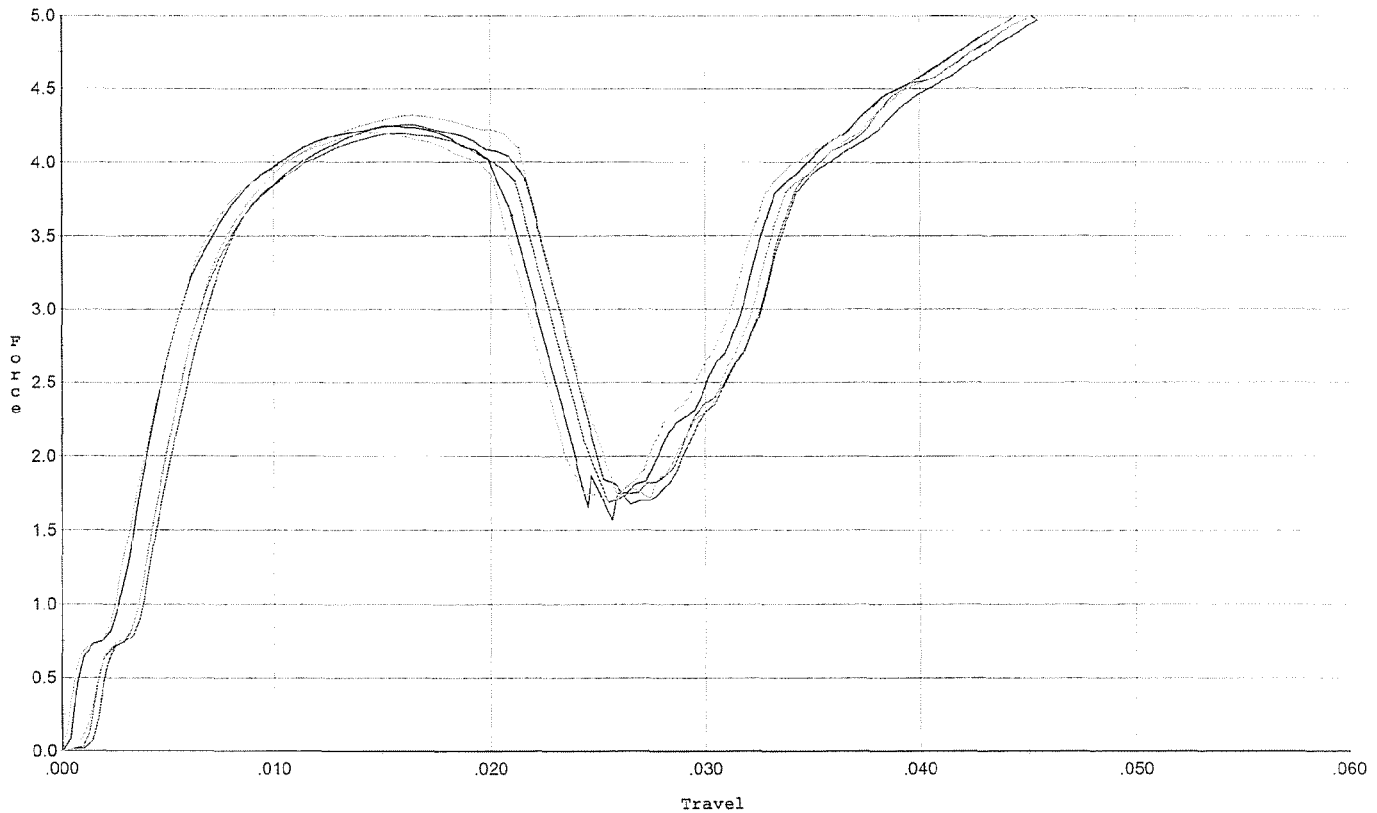
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.209      | 0.021             | 0.00            | 0.026      | 0.060             |           | Set Trigger |
| 2 | 4.026      | 0.020             | 0.00            | 0.027      | 0.057             |           | Set Trigger |
| 3 | 4.013      | 0.021             | 0.00            | 0.027      | 0.058             |           | Set Trigger |
| 4 | 3.877      | 0.021             | 0.00            | 0.028      | 0.056             |           | Set Trigger |
| 5 | 3.889      | 0.021             | 0.00            | 0.027      | 0.057             |           | Set Trigger |

A-4.00

## 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



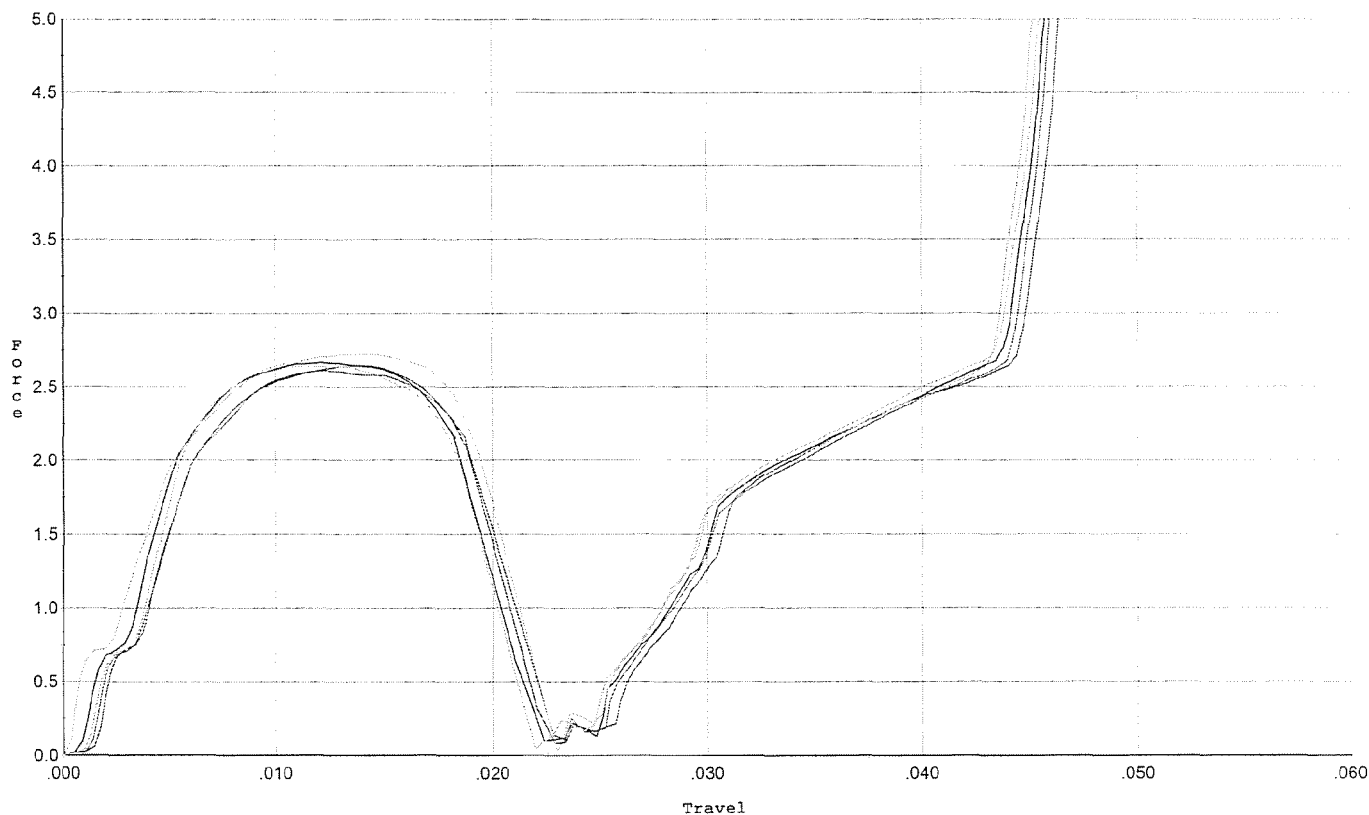
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.253      | 0.022             | 0.00            | 0.026      | 0.062             |           | Set Trigger |
| 2 | 4.245      | 0.021             | 0.00            | 0.026      | 0.063             |           | Set Trigger |
| 3 | 4.194      | 0.021             | 0.00            | 0.026      | 0.061             |           | Set Trigger |
| 4 | 4.201      | 0.020             | 0.00            | 0.026      | 0.060             |           | Set Trigger |
| 5 | 4.321      | 0.021             | 0.00            | 0.026      | 0.063             |           | Set Trigger |

A-4.24

## 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



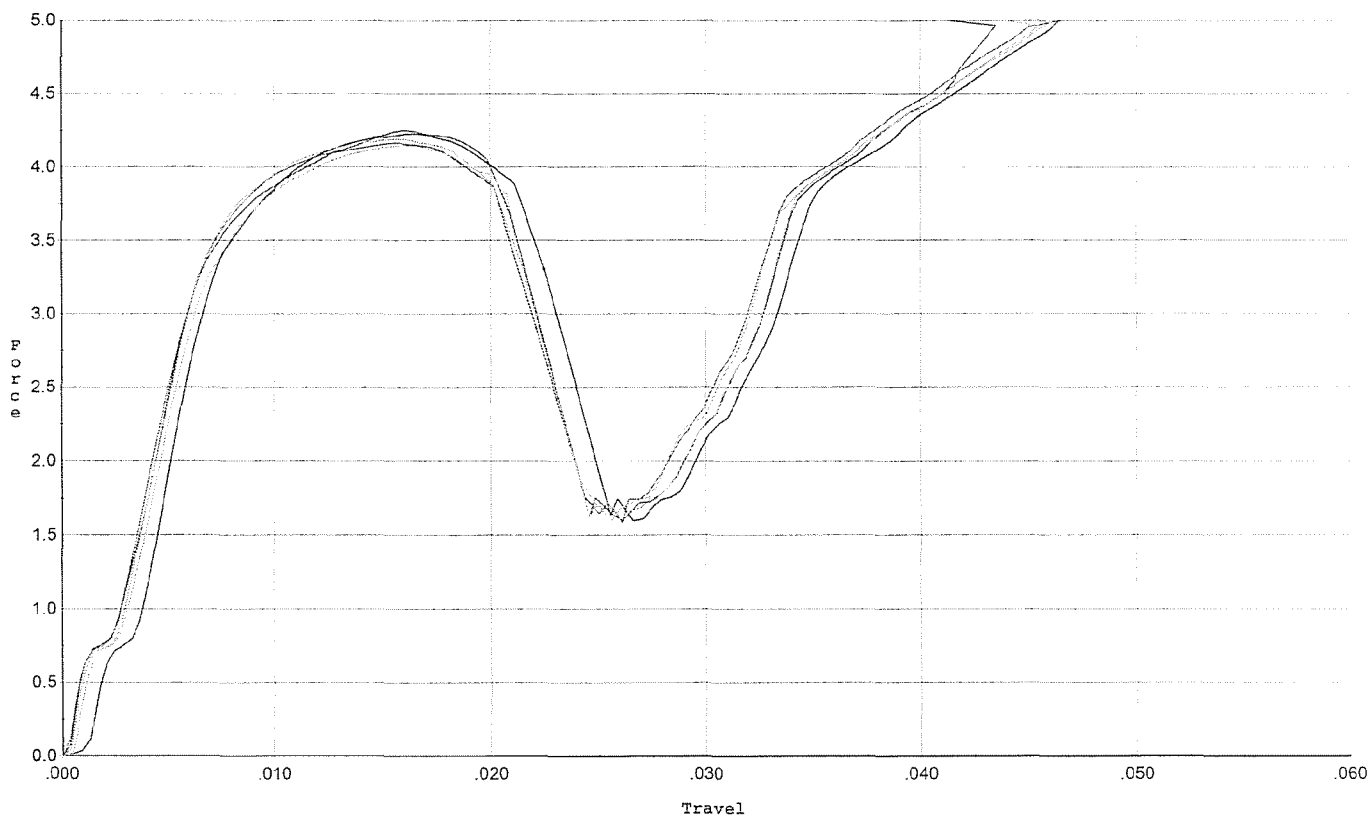
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.645      | 0.019             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 2 | 2.663      | 0.018             | 0.00            | 0.031      | 0.035             |           | Set Trigger |
| 3 | 2.609      | 0.021             | 0.00            | 0.031      | 0.037             |           | Set Trigger |
| 4 | 2.726      | 0.019             | 0.00            | 0.030      | 0.037             |           | Set Trigger |
| 5 | 2.640      | 0.018             | 0.00            | 0.031      | 0.036             |           | Set Trigger |

A-2-65

## 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 | 4.249      | 0.021             | 0.00            | 0.026      | 0.062             |           | Set Trigger |
| 2 | 4.228      | 0.022             | 0.00            | 0.027      | 0.065             |           | Set Trigger |
| 3 | 4.161      | 0.022             | 0.00            | 0.026      | 0.065             |           | Set Trigger |
| 4 | 4.146      | 0.021             | 0.00            | 0.027      | 0.060             |           | Set Trigger |
| 5 | 4.190      | 0.021             | 0.00            | 0.027      | 0.063             |           | Set Trigger |

A-4.19