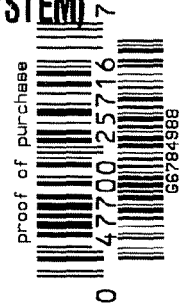


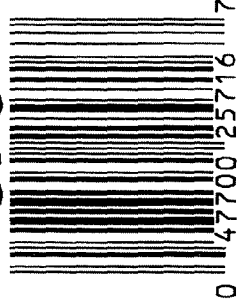
66784988

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
G6784988	
UPC 	

GUN SERIAL #

G6784988

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	RIZ
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX UCI 02 2008 OPERATOR 10	9-30-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/3/08	SP
542	APPLY COATINGS (BARREL ACTION)		10 9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-3-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

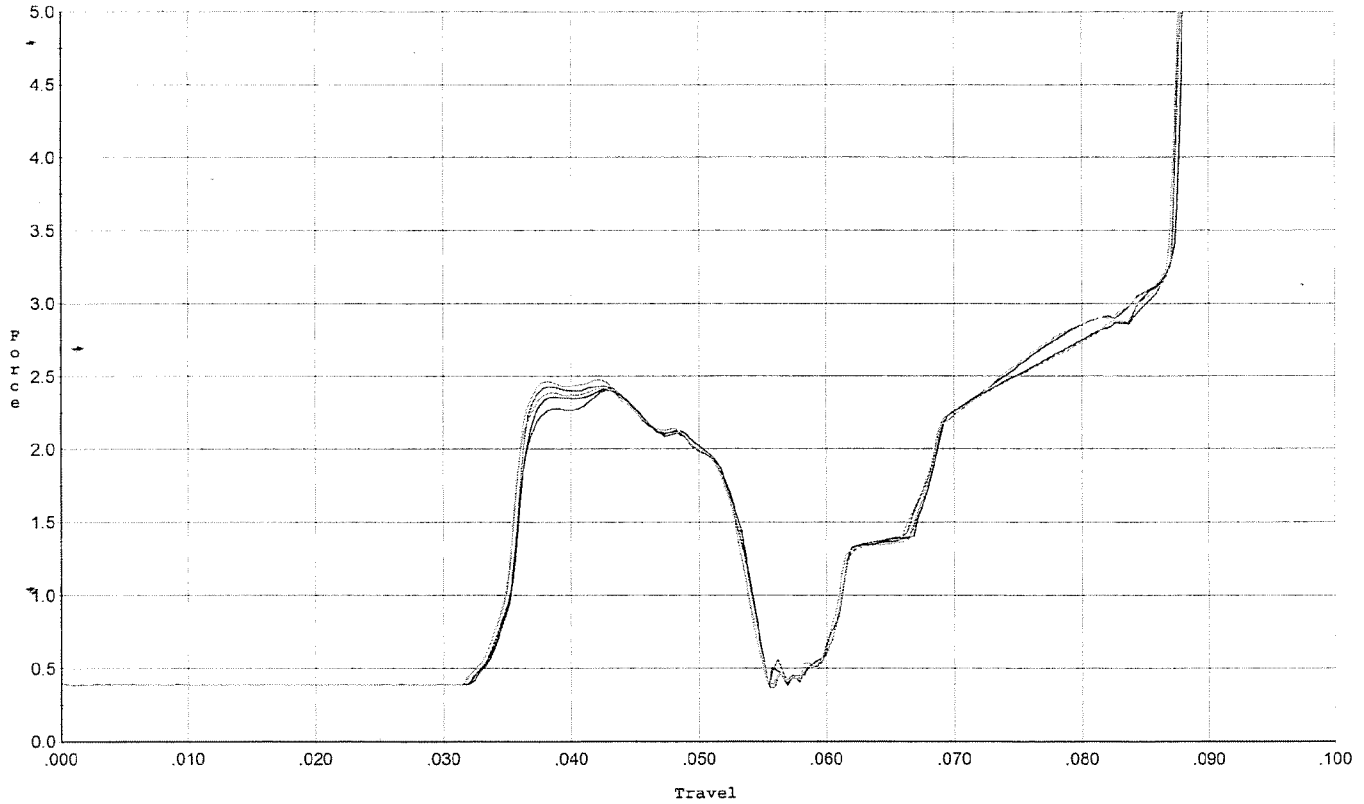
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	4.0 4.0 4.0	11-11-08	RJD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	6.0 6.0 5.0	11-11-08	RJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	.023 .023 .023	11-11-08	RJD
	J) ASSEMBLE STOCK		10-30-08	RJD
	K) ASSEMBLE SWIVEL STUDS		11-11-08	RJD
	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	11-3-08	RJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-11-08	RJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.31 2.24 2.37 2.26 2.45	11-5-08	Fm
	C) FUNCTION		11-11-08	RJD
690	PACK		11/12/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



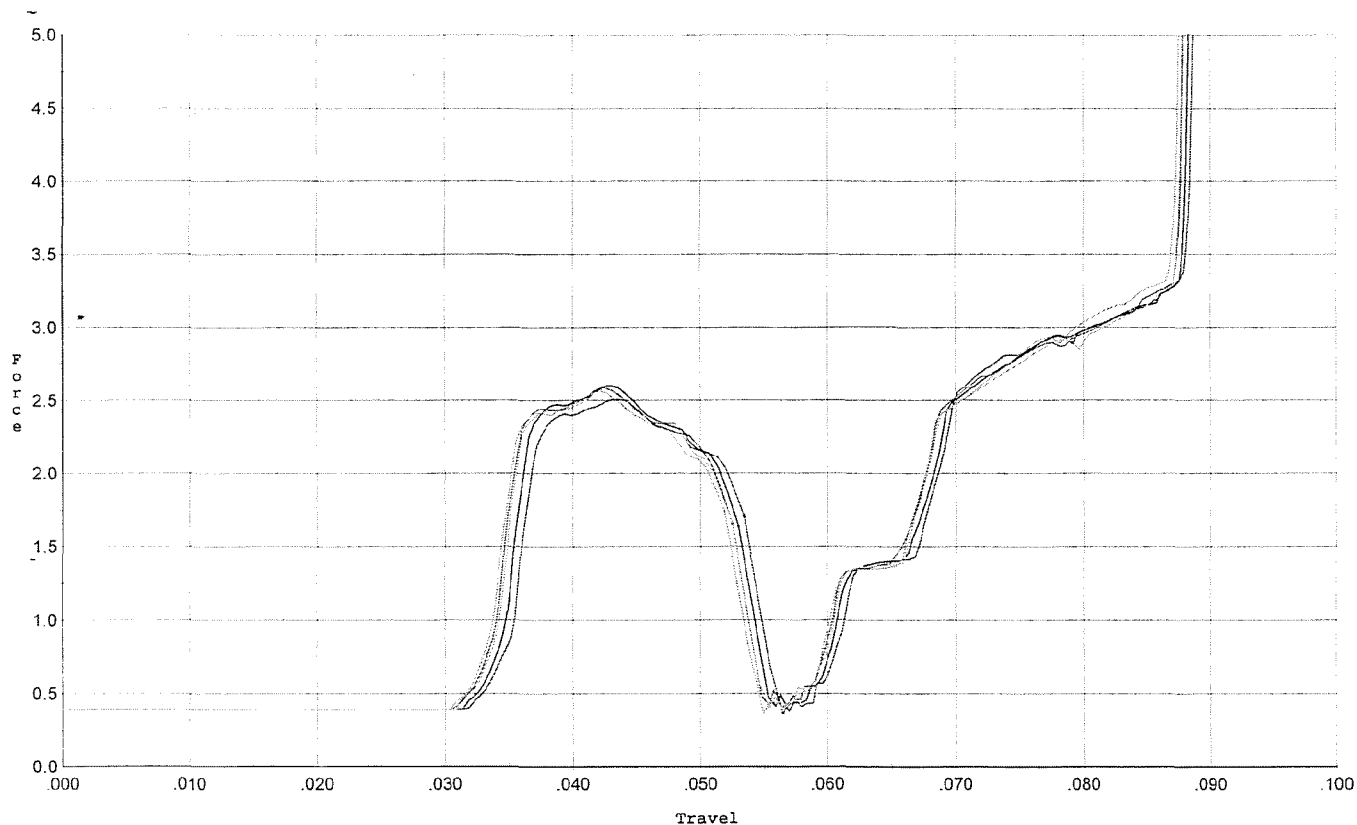
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.407	0.054	0.034	0.039	0.053		Set Trigger
2	2.417	0.053	0.033	0.038	0.053		Set Trigger
3	2.432	0.054	0.032	0.038	0.053		Set Trigger
4	2.419	0.053	0.034	0.039	0.053		Set Trigger
5	2.477	0.053	0.034	0.038	0.053		Set Trigger

Avg 2.43

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.



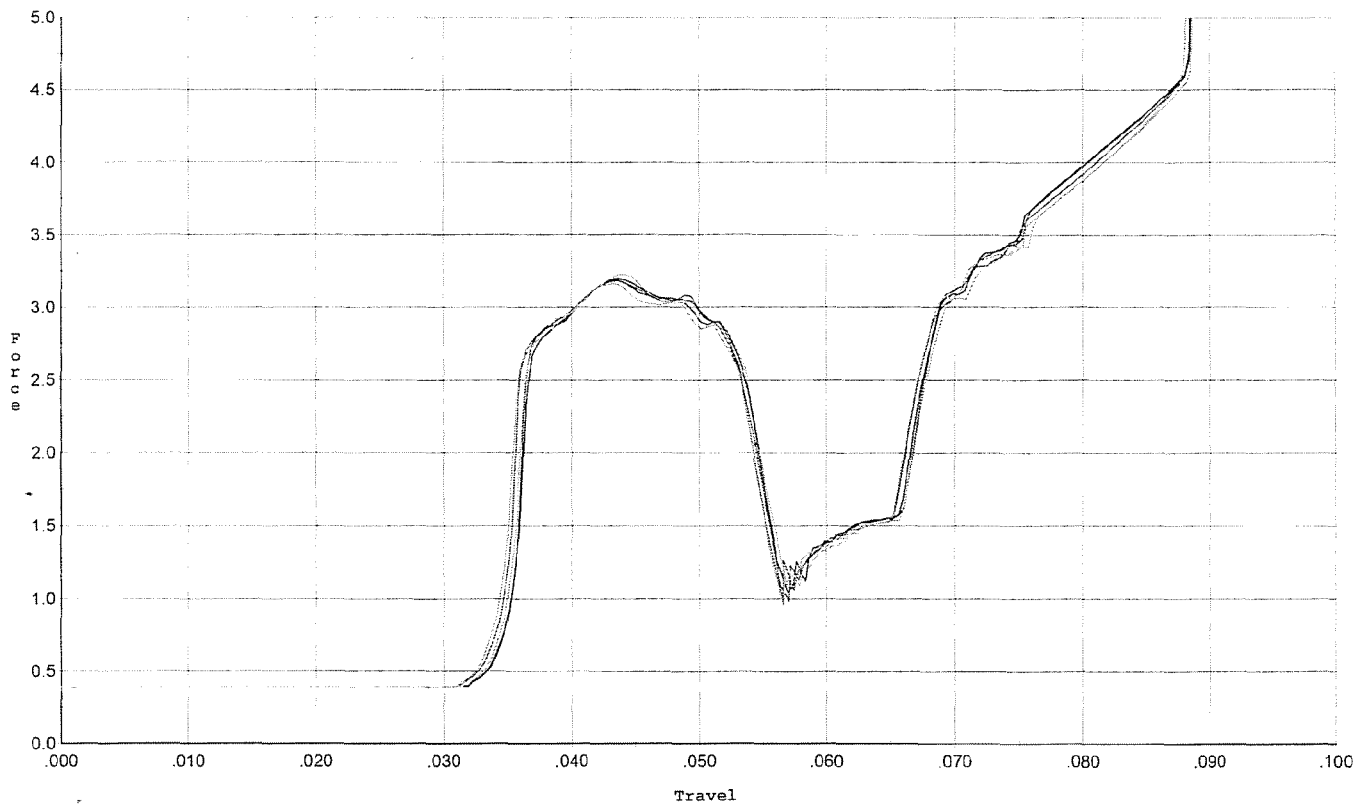
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.053	0.034	0.038	0.055		Set Trigger
2	2.600	0.053	0.033	0.039	0.056		Set Trigger
3	2.588	0.052	0.033	0.039	0.056		Set Trigger
4	2.577	0.052	0.031	0.039	0.055		Set Trigger
5	2.564	0.052	0.032	0.039	0.055		Set Trigger

Aug 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: 3.0 lbs. ini. +/- .75 lbs.



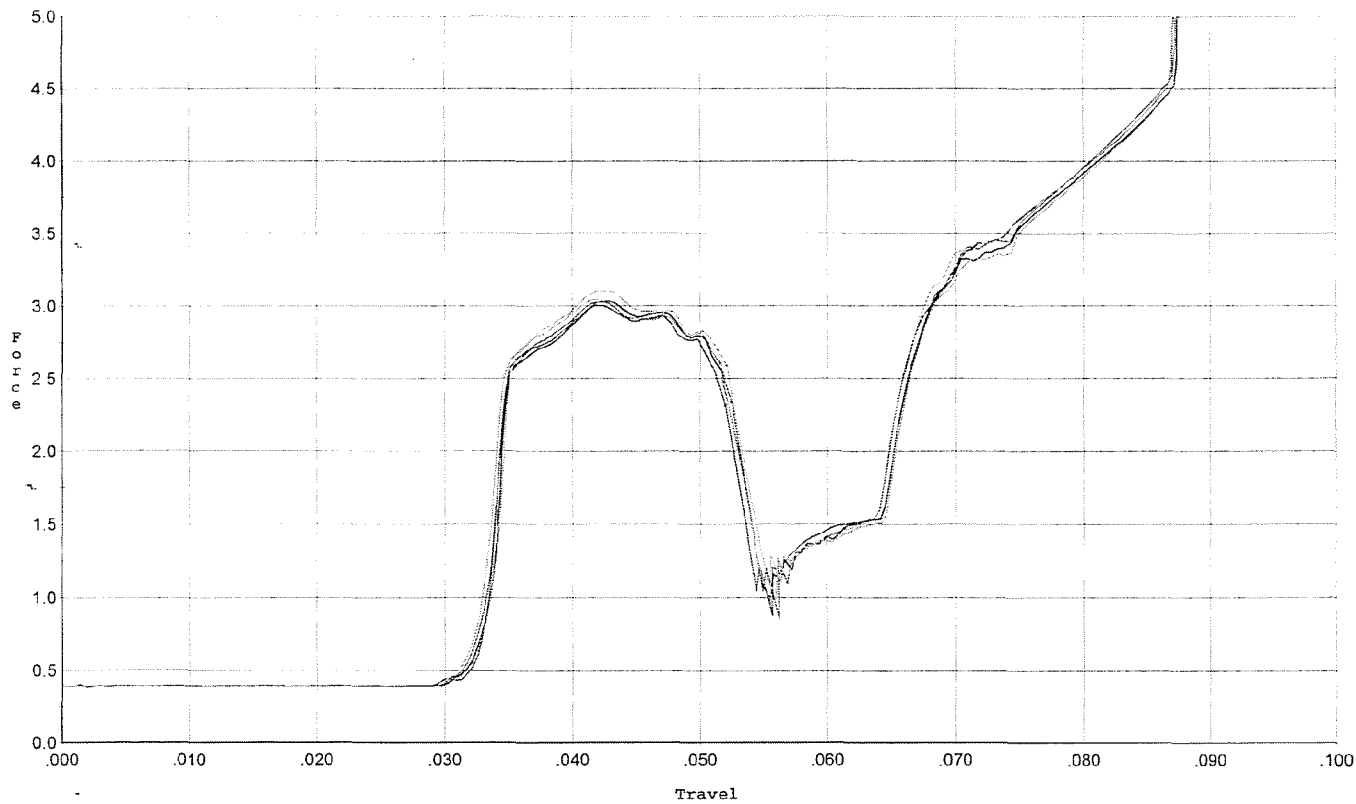
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.187	0.054	0.034	0.037	0.069		Set Trigger
2	3.198	0.054	0.034	0.037	0.068		Set Trigger
3	3.182	0.053	0.034	0.036	0.068		Set Trigger
4	3.223	0.054	0.034	0.037	0.069		Set Trigger
5	3.164	0.053	0.033	0.036	0.068		Set Trigger

Aug 3.19

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.



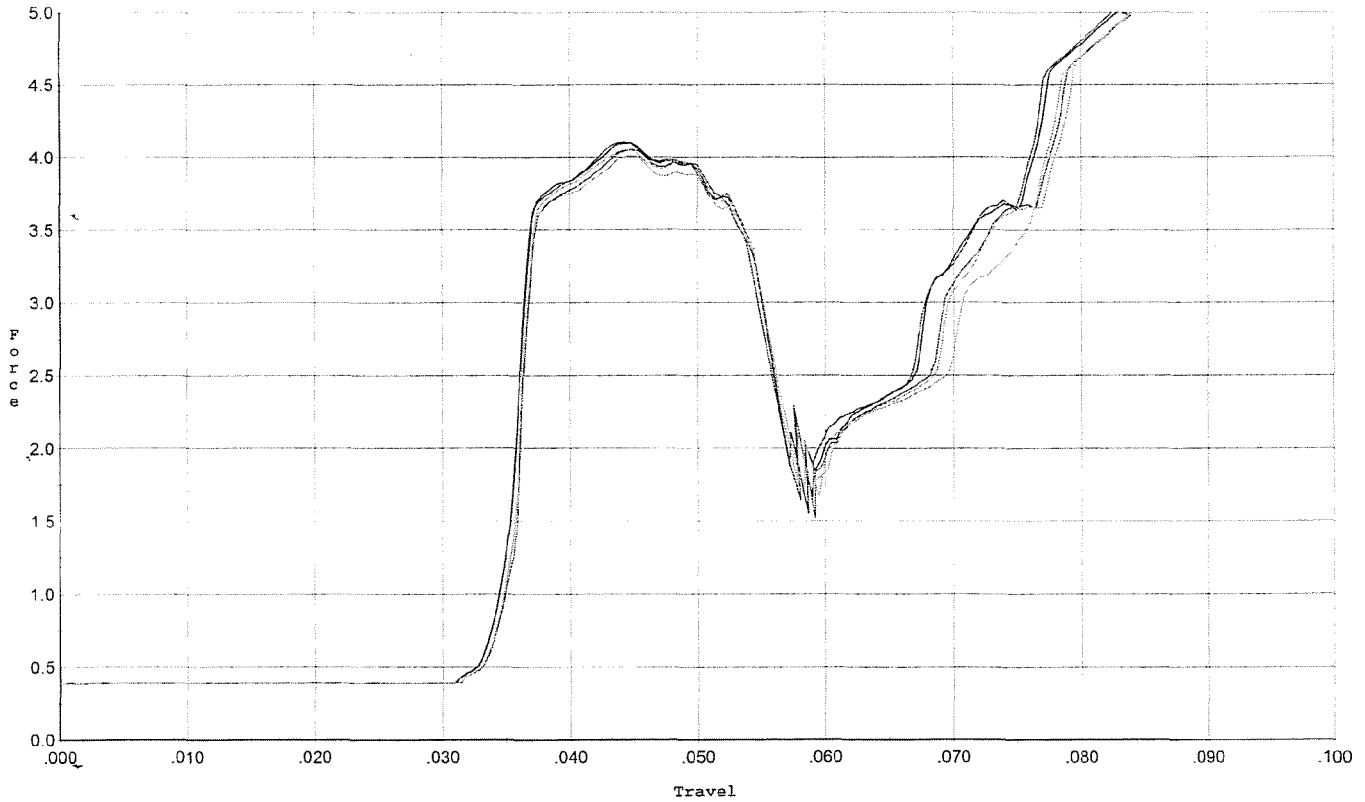
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.004	0.052	0.033	0.037	0.065		Set Trigger
2	3.034	0.053	0.032	0.037	0.066		Set Trigger
3	3.027	0.052	0.032	0.037	0.066		Set Trigger
4	3.046	0.053	0.032	0.036	0.068		Set Trigger
5	3.101	0.052	0.033	0.037	0.066		Set Trigger

Aug 3.04

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.



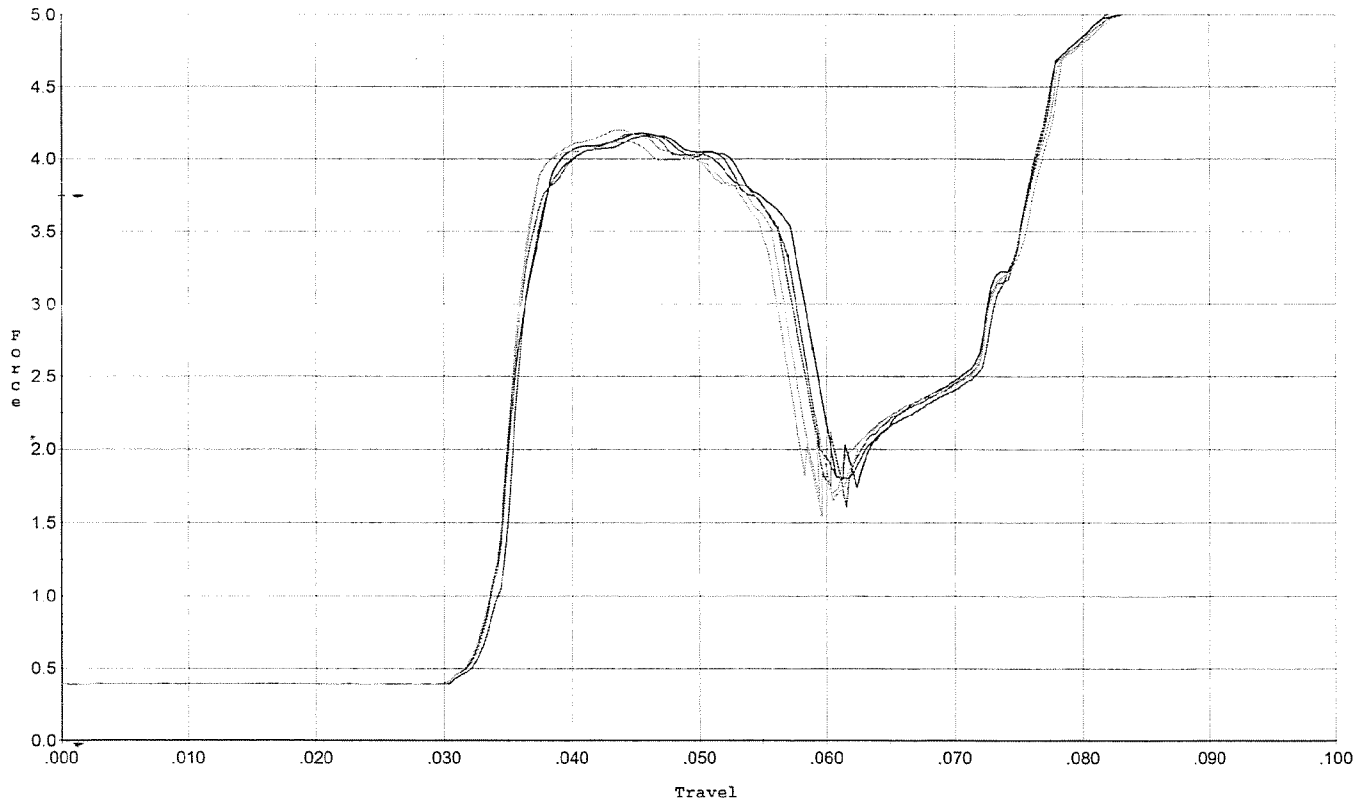
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.054	0.033	0.036	0.086		Set Trigger
2	4.099	0.055	0.033	0.036	0.088		Set Trigger
3	4.053	0.054	0.034	0.037	0.086		Set Trigger
4	4.012	0.054	0.034	0.037	0.086		Set Trigger
5	4.053	0.054	0.034	0.037	0.087		Set Trigger

Aug 4.06

Trigger Profile [lbs,inch]

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

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



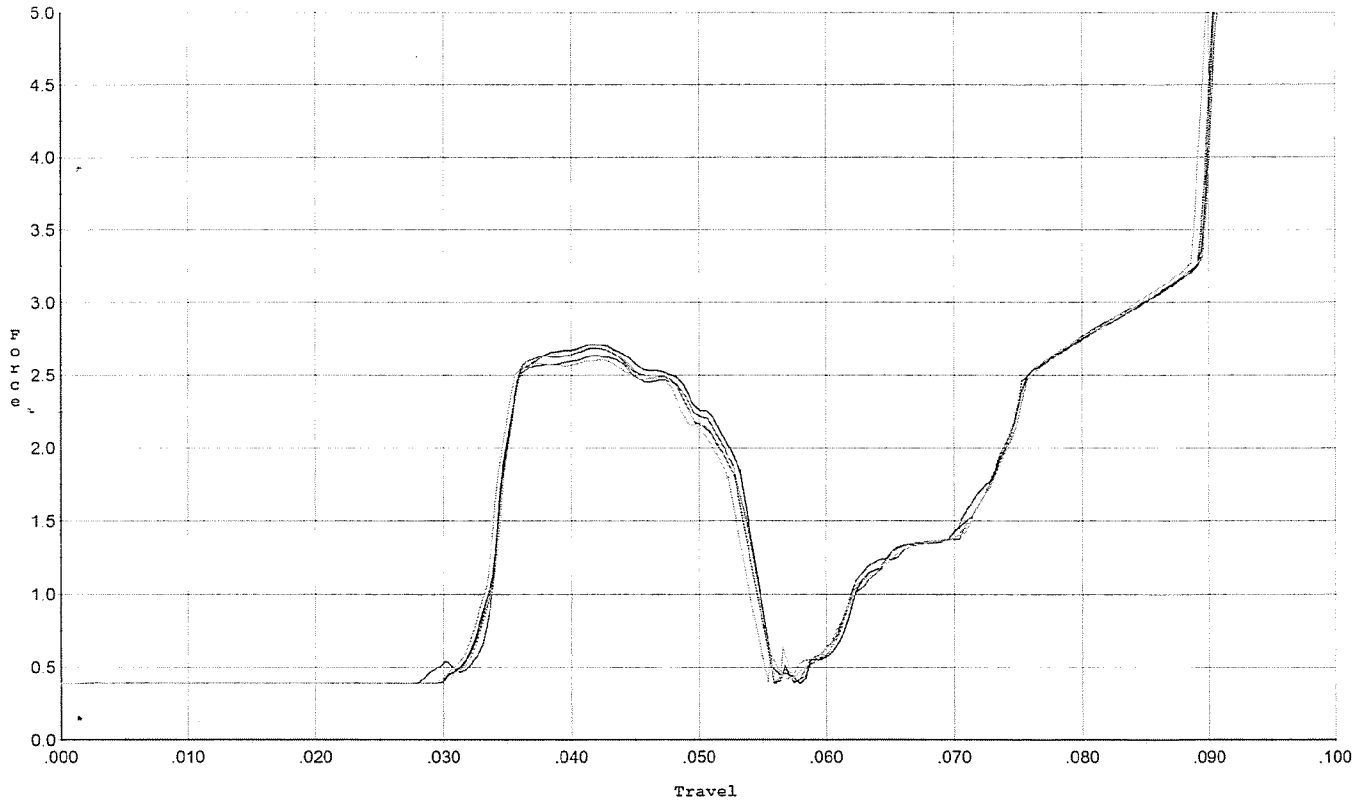
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.057	0.033	0.035	0.099		Set Trigger
2	4.178	0.059	0.033	0.035	0.106		Set Trigger
3	4.174	0.056	0.033	0.035	0.098		Set Trigger
4	4.200	0.056	0.033	0.036	0.097		Set Trigger
5	4.118	0.055	0.033	0.036	0.095		Set Trigger

Aug 4.16

Trigger Profile [lbs,inch]

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

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



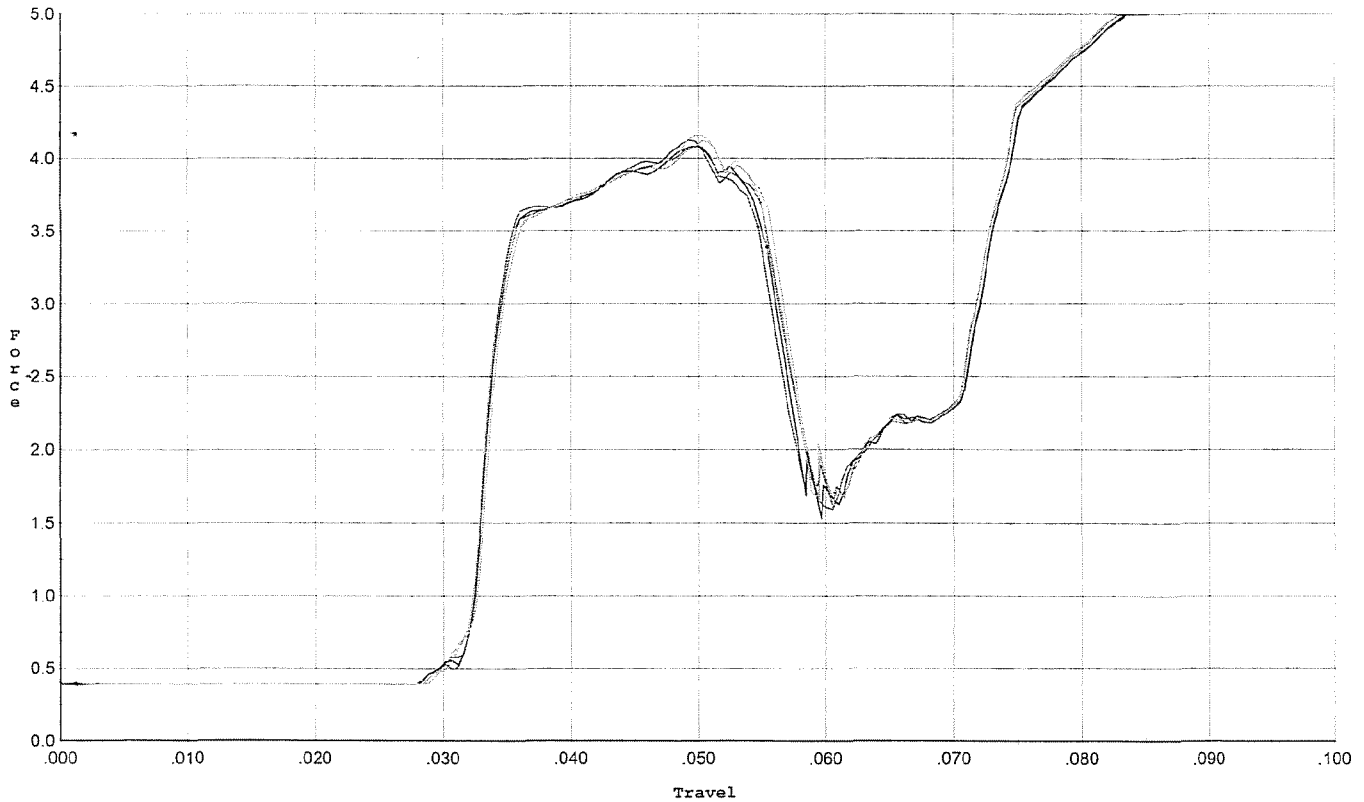
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.635	0.054	0.033	0.041	0.060		Set Trigger
2	2.709	0.053	0.032	0.040	0.061		Set Trigger
3	2.683	0.053	0.032	0.041	0.060		Set Trigger
4	2.693	0.054	0.033	0.040	0.061		Set Trigger
5	2.609	0.052	0.032	0.041	0.059		Set Trigger

Aug 2.66

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	4.124	0.055	0.032	0.034	0.096		Set Trigger
2	4.082	0.055	0.032	0.034	0.097		Set Trigger
3	4.080	0.055	0.031	0.034	0.097		Set Trigger
4	4.160	0.057	0.031	0.034	0.101		Set Trigger
5	4.120	0.055	0.031	0.034	0.098		Set Trigger

AUG 4.11