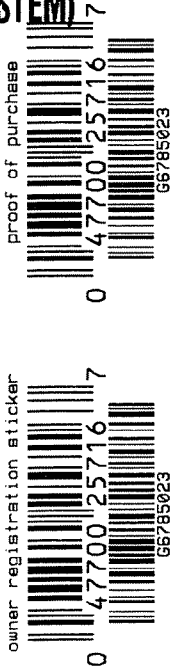


G-6785023

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

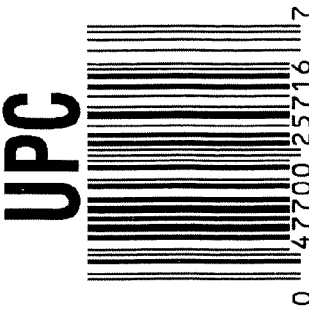
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6785023



GUN SERIAL # G6785023

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SP
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SP
460	CHECK HEADSPACE		9-29-08	SP
470	DIS-ASSEMBLE ACTION		9-29-08	SP
472	SERIALIZE BOLT HANDLE		9-30-08	RJZ
475	DRILL AND TAP SIGHT HOLES		10/1/08	Fm
480	MAGNAFLUX BBL ACTION		10/2/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/03/08	DL
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		10-31-08	Ran
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

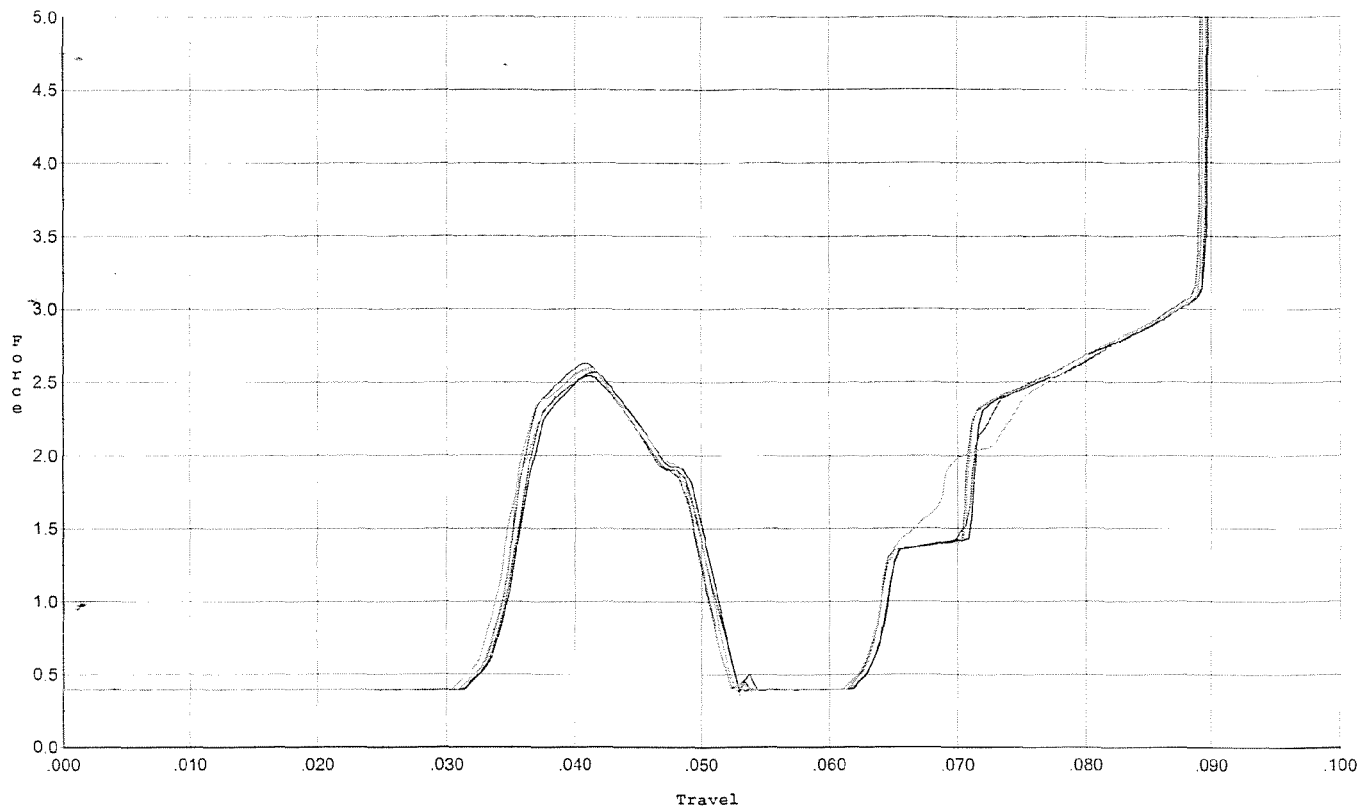
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>50</u> <u>50</u>	11-6-08	R.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-6-08	R.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-6-08	R.D.
	J) ASSEMBLE STOCK		10-31-08	R.D.
	K) ASSEMBLE SWIVEL STUDS		11-6-08	R.D.
	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	11-3-08	R.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-6-08	R.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.68</u> <u>2.67</u> <u>2.68</u> <u>2.67</u>	11-5-08	Fm
	C) FUNCTION		11-6-08	R.D.
690	PACK		11/10/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



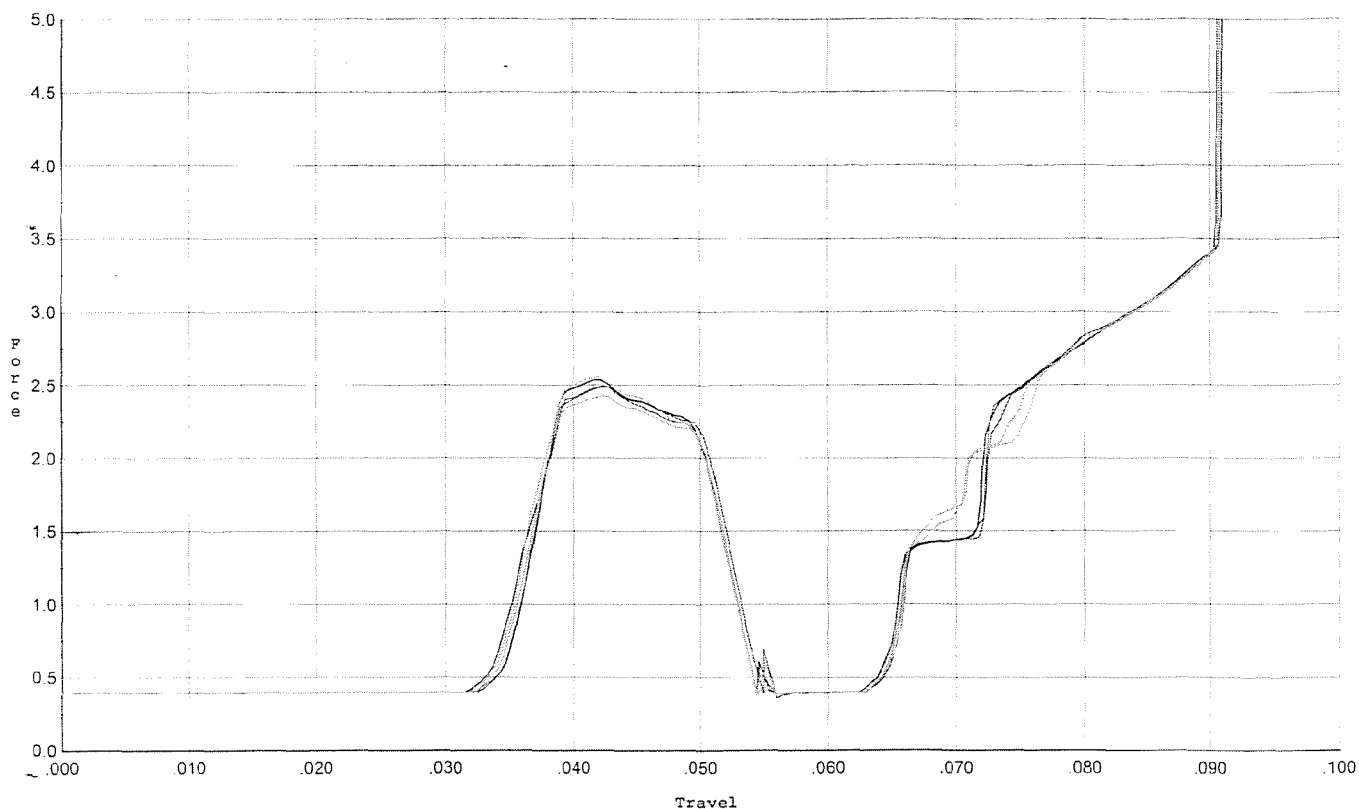
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.544	0.050	0.033	0.043	0.046		Set Trigger
2	2.568	0.052	0.034	0.043	0.049		Set Trigger
3	2.626	0.049	0.033	0.043	0.046		Set Trigger
4	2.598	0.050	0.033	0.043	0.048		Set Trigger
5	2.584	0.050	0.033	0.043	0.048		Set Trigger

Aug 2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



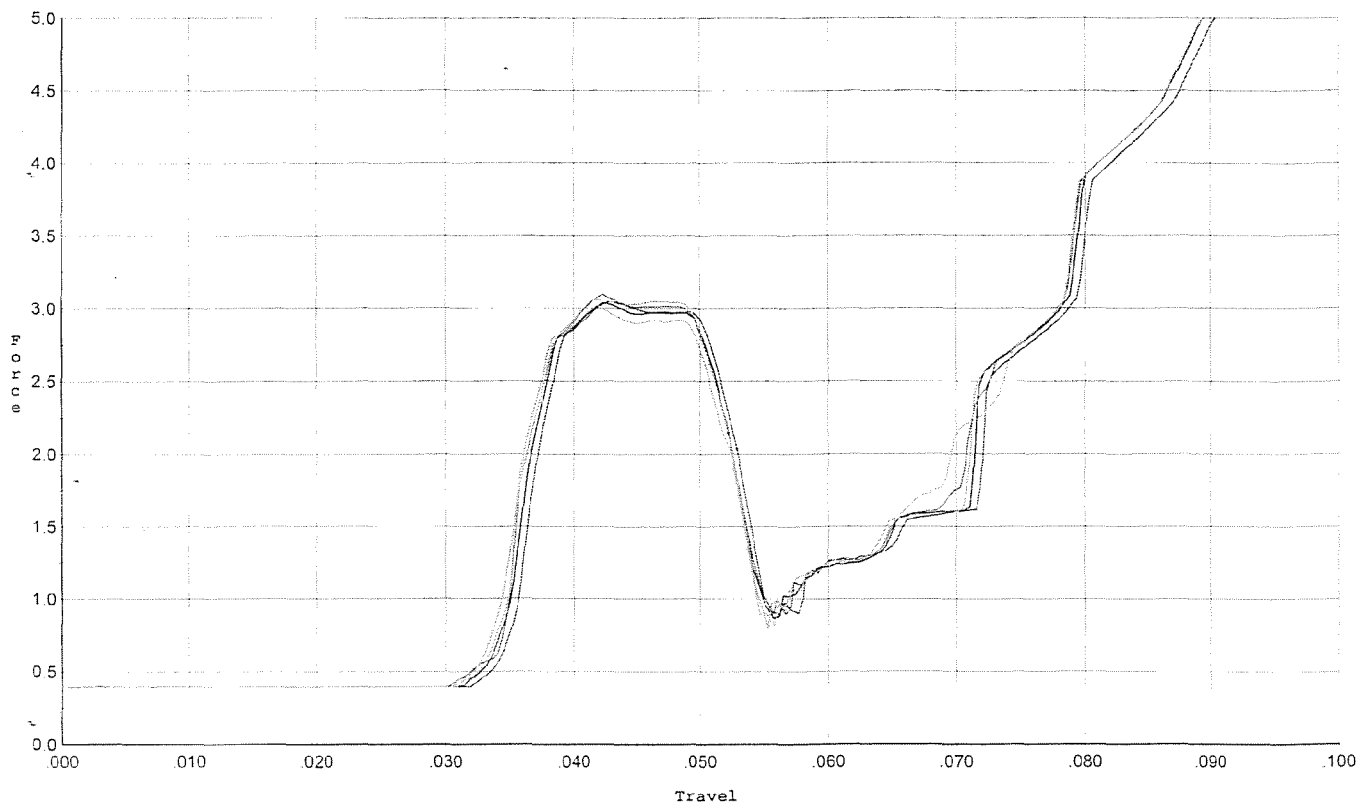
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.491	0.051	0.035	0.043	0.049		Set Trigger
2	2.536	0.053	0.034	0.042	0.052		Set Trigger
3	2.487	0.053	0.035	0.042	0.051		Set Trigger
4	2.554	0.052	0.034	0.042	0.051		Set Trigger
5	2.428	0.053	0.035	0.042	0.050		Set Trigger

Aug 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



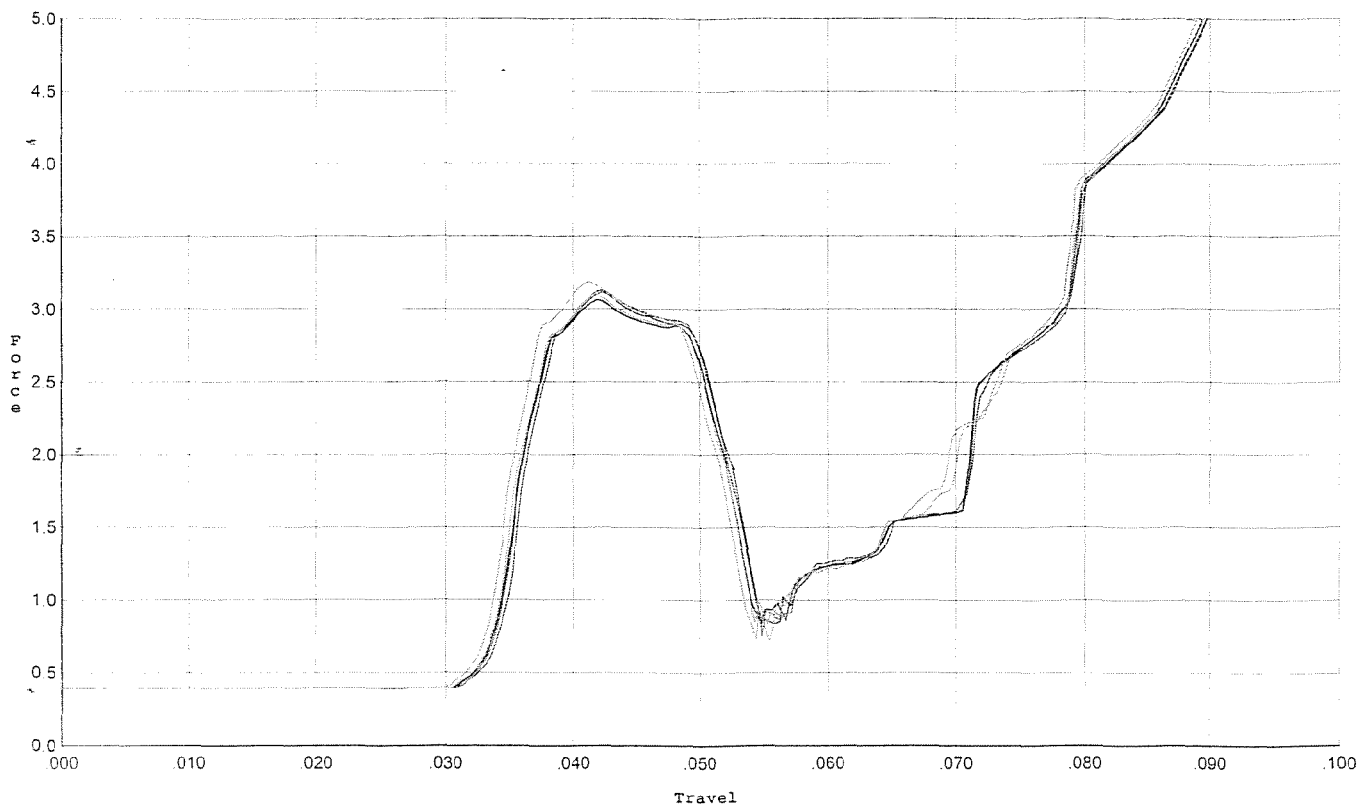
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.053	0.035	0.040	0.062		Set Trigger
2	3.039	0.052	0.034	0.040	0.061		Set Trigger
3	3.096	0.052	0.034	0.039	0.062		Set Trigger
4	3.020	0.052	0.034	0.039	0.061		Set Trigger
5	3.060	0.052	0.033	0.039	0.063		Set Trigger

Aug 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



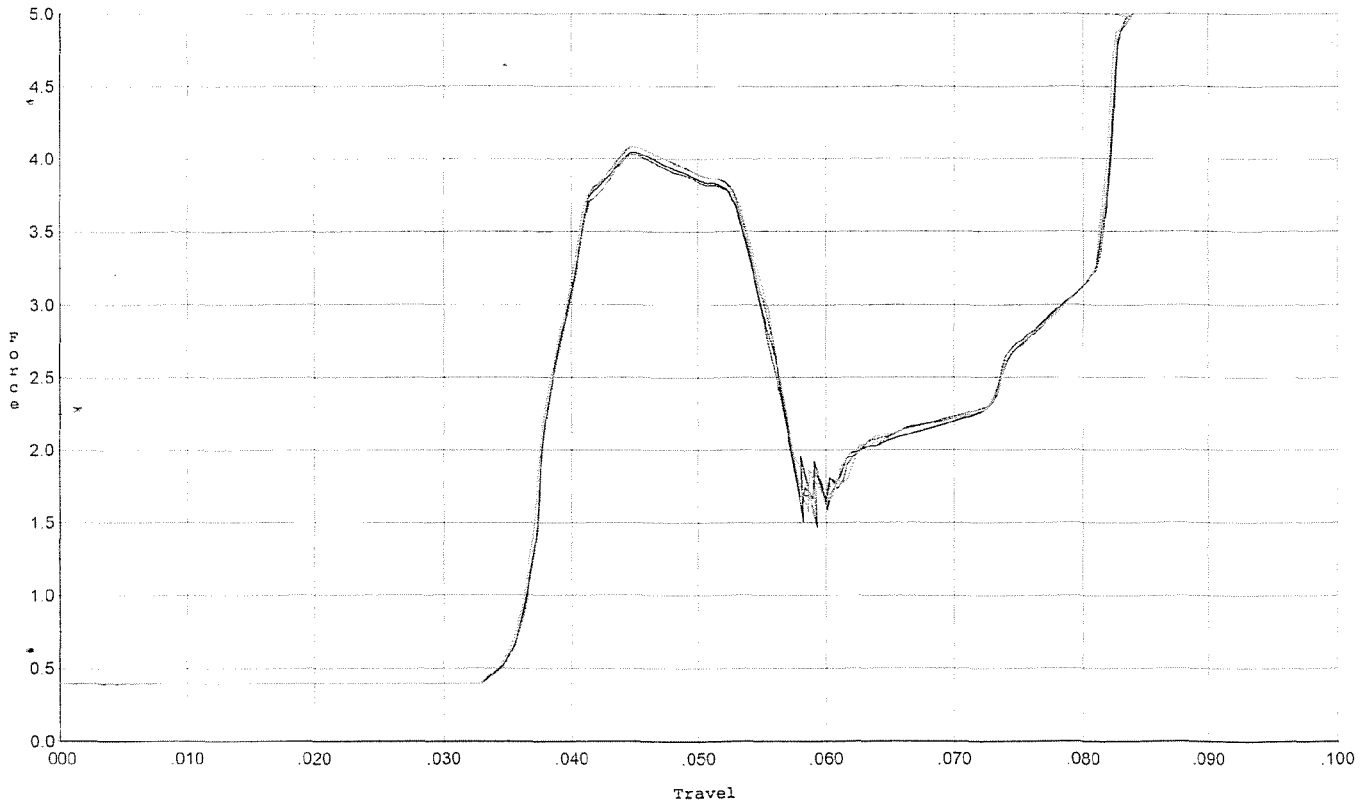
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.053	0.034	0.040	0.062		Set Trigger
2	3.064	0.052	0.033	0.040	0.061		Set Trigger
3	3.130	0.053	0.033	0.040	0.063		Set Trigger
4	3.107	0.052	0.033	0.040	0.062		Set Trigger
5	3.191	0.052	0.033	0.039	0.062		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



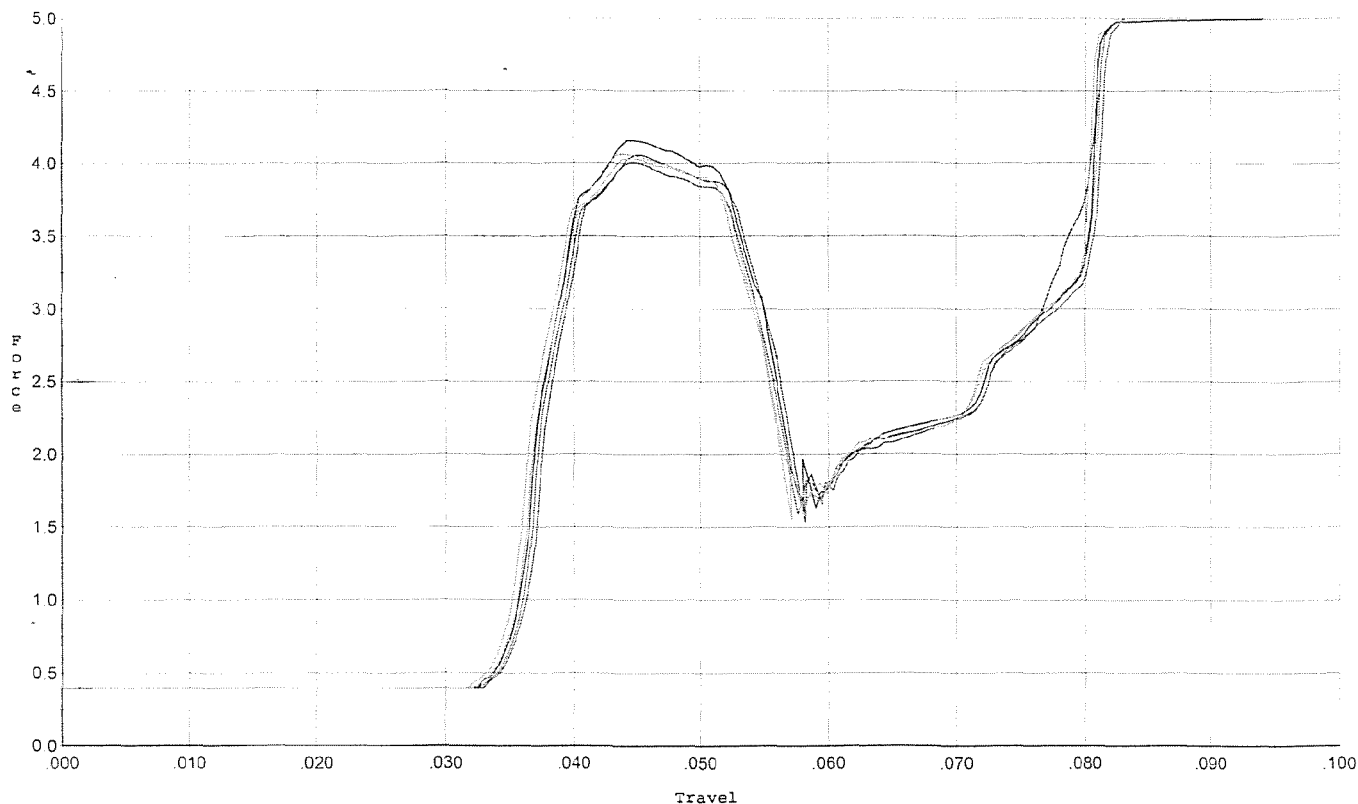
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.032	0.056	0.035	0.038	0.083		Set Trigger
2	4.045	0.056	0.035	0.038	0.082		Set Trigger
3	4.082	0.056	0.035	0.038	0.083		Set Trigger
4	4.059	0.056	0.035	0.038	0.082		Set Trigger
5	4.083	0.055	0.035	0.037	0.083		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



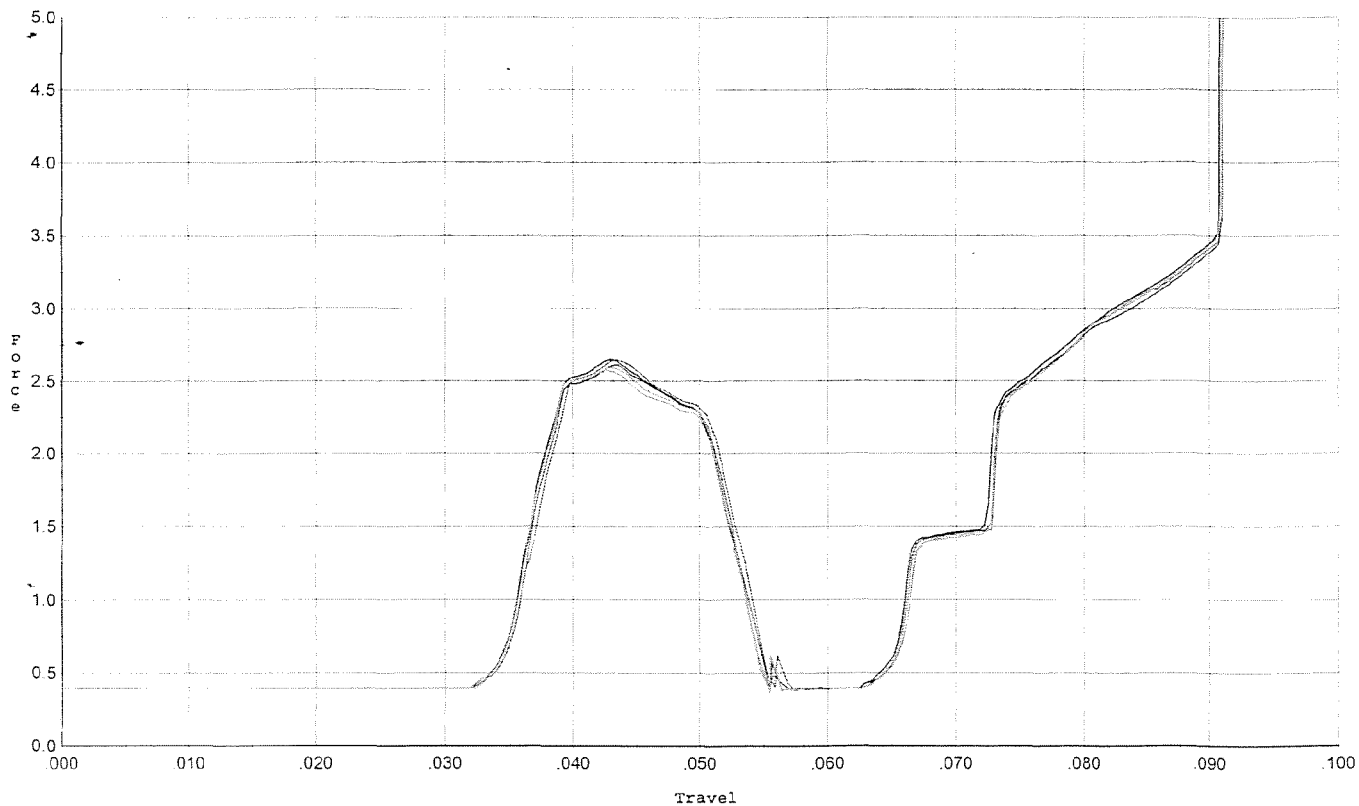
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.059	0.056	0.035	0.037	0.083		Set Trigger
2	4.158	0.055	0.035	0.037	0.084		Set Trigger
3	4.005	0.056	0.035	0.037	0.082		Set Trigger
4	4.030	0.054	0.034	0.037	0.082		Set Trigger
5	4.067	0.055	0.034	0.037	0.083		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



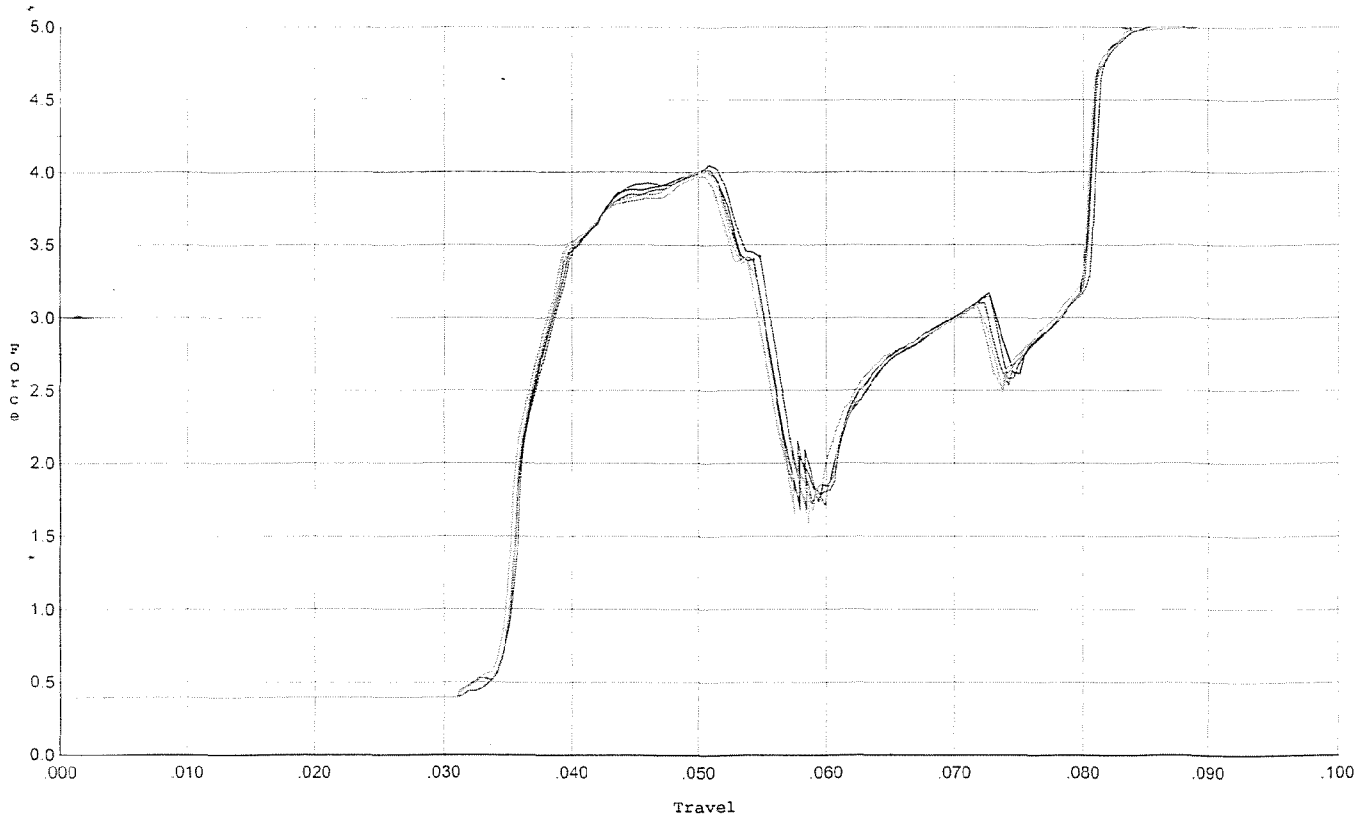
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.614	0.052	0.035	0.042	0.051		Set Trigger
2	2.650	0.053	0.034	0.042	0.053		Set Trigger
3	2.647	0.054	0.035	0.041	0.054		Set Trigger
4	2.593	0.053	0.035	0.042	0.053		Set Trigger
5	2.575	0.053	0.034	0.042	0.053		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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	4.053	0.055	0.034	0.037	0.085		Set Trigger
2	4.016	0.054	0.034	0.037	0.083		Set Trigger
3	4.014	0.054	0.034	0.037	0.083		Set Trigger
4	4.010	0.055	0.034	0.037	0.084		Set Trigger
5	3.973	0.054	0.034	0.037	0.082		Set Trigger

Aug 4.01