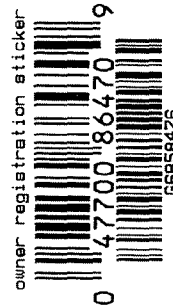
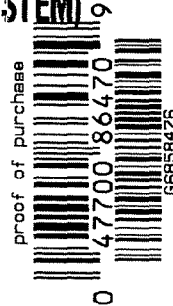


6685-8476

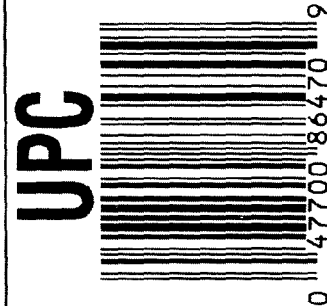
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

**BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD**



ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6858476



BM FORM

GUN SERIAL #

G 6858476

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-16-09	SP
430	ASSEMBLE TO STOCK		6-16-09	SP
440	PROOF		6-16-09	SP
460	CHECK HEADSPACE	MAGNA-FLUX	6-16-09	SP
470	DIS-ASSEMBLE ACTION		6-16-09	SP
472	SERIALIZE BOLT HANDLE		6-17-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(D)</u>	6/20/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/23/09	RT
510	DRILL AND TAP SIGHT HOLES		6-17-09	SP
520	GOFF BLAST BBL / REC		6/23	SP
540	APPLY COATINGS (BARREL ACTION)		7/17	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-28-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-28-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-28-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-11-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

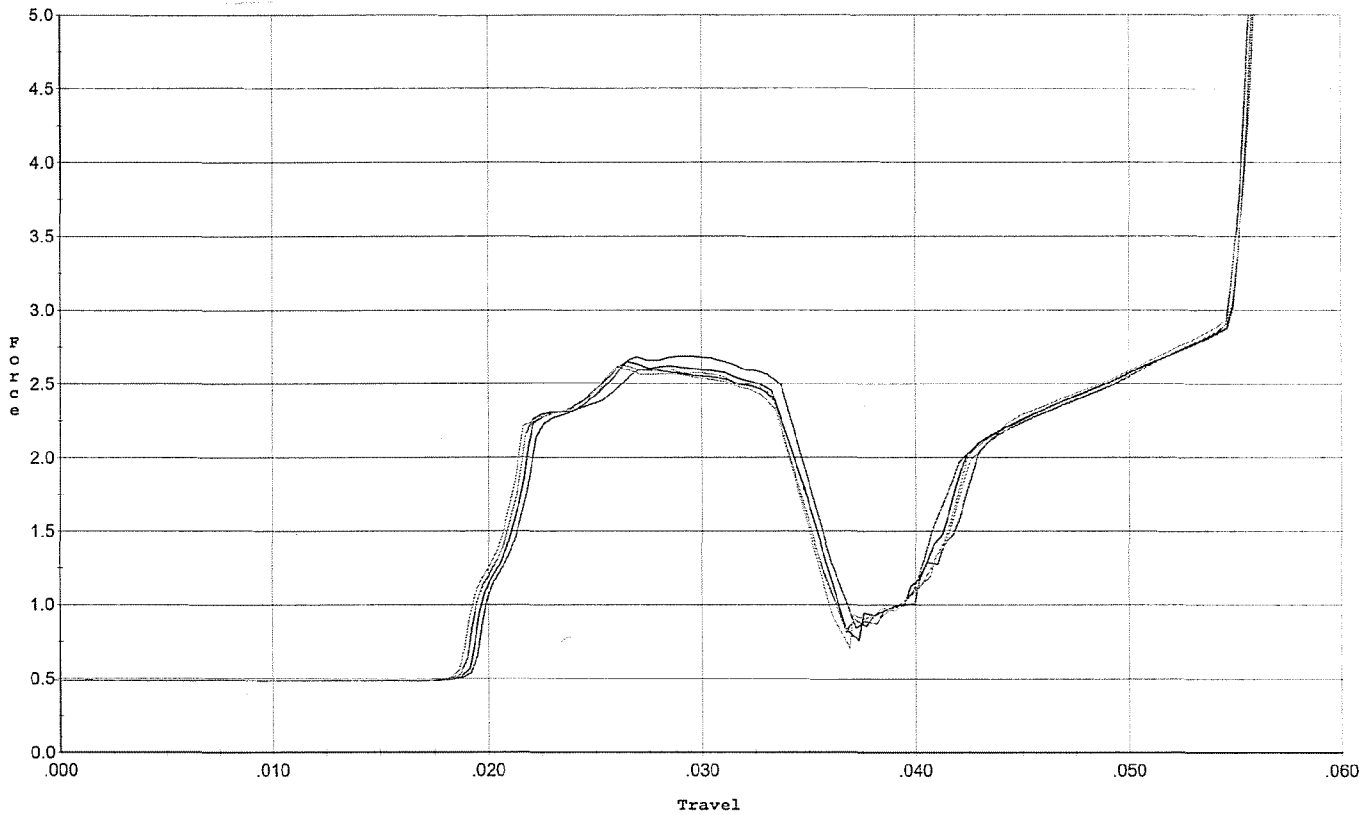
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>725</u> <u>775</u> <u>775</u>	8-14-09	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>20</u> <u>20</u> <u>20</u>	8-14-09	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>024</u> <u>024</u> <u>024</u>	8-14-09	RTZ
	J) ASSEMBLE STOCK		8-11-09	SPD
	K) ASSEMBLE SWIVEL STUDS		8-14-09	RTZ
	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	PASS FAIL PASS FAIL	8/13/09	RF
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/13/09	TAR
670	FINAL INSPECTION A) HEADSPACE		8-14-09	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>257</u> <u>250</u> <u>256</u> <u>252</u> <u>255</u>	8-14-09	2091
	C) FUNCTION		8-14-09	RTZ
690	PACK		8/17/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



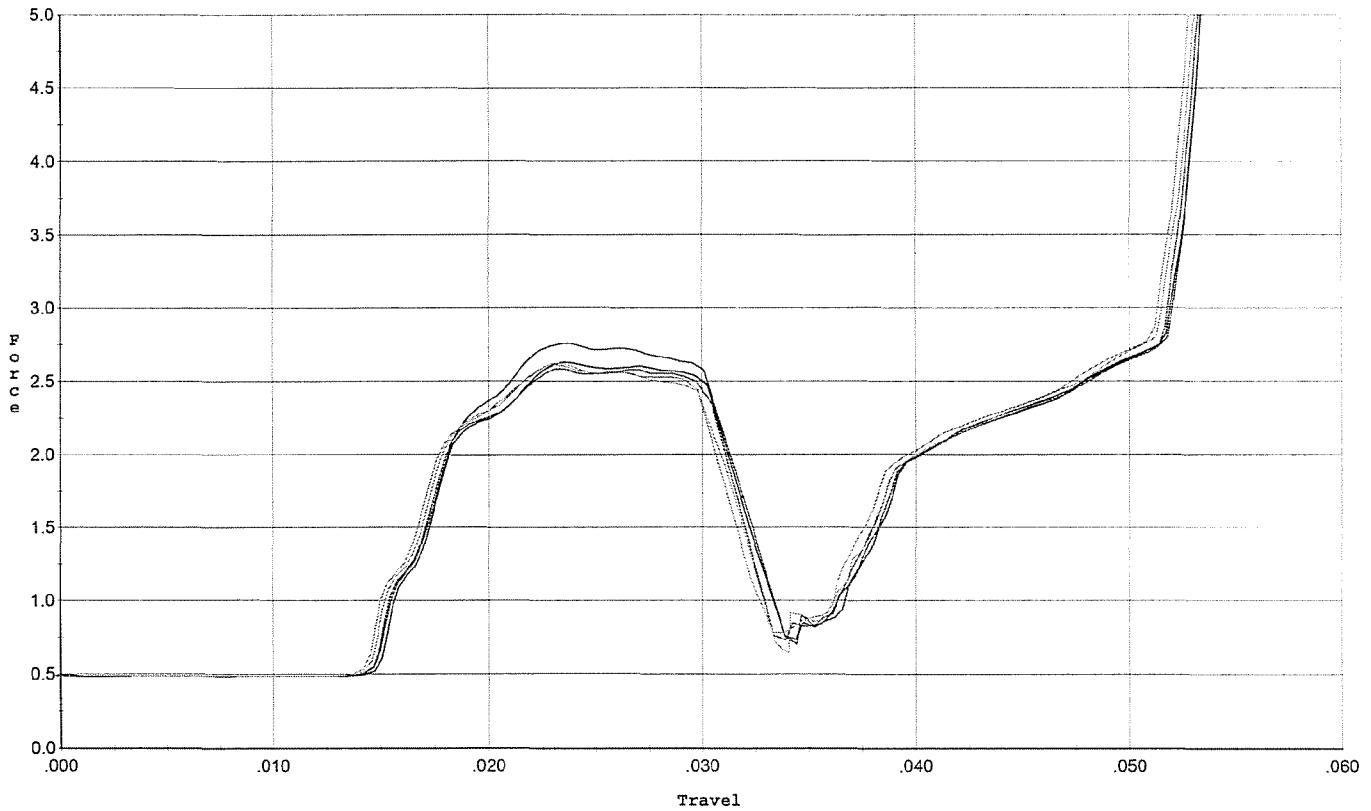
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.685	0.034	0.020	0.024	0.043		Set Trigger
2	2.651	0.035	0.019	0.024	0.044		Set Trigger
3	2.598	0.033	0.019	0.025	0.042		Set Trigger
4	2.620	0.033	0.019	0.025	0.042		Set Trigger
5	2.609	0.033	0.019	0.025	0.042		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



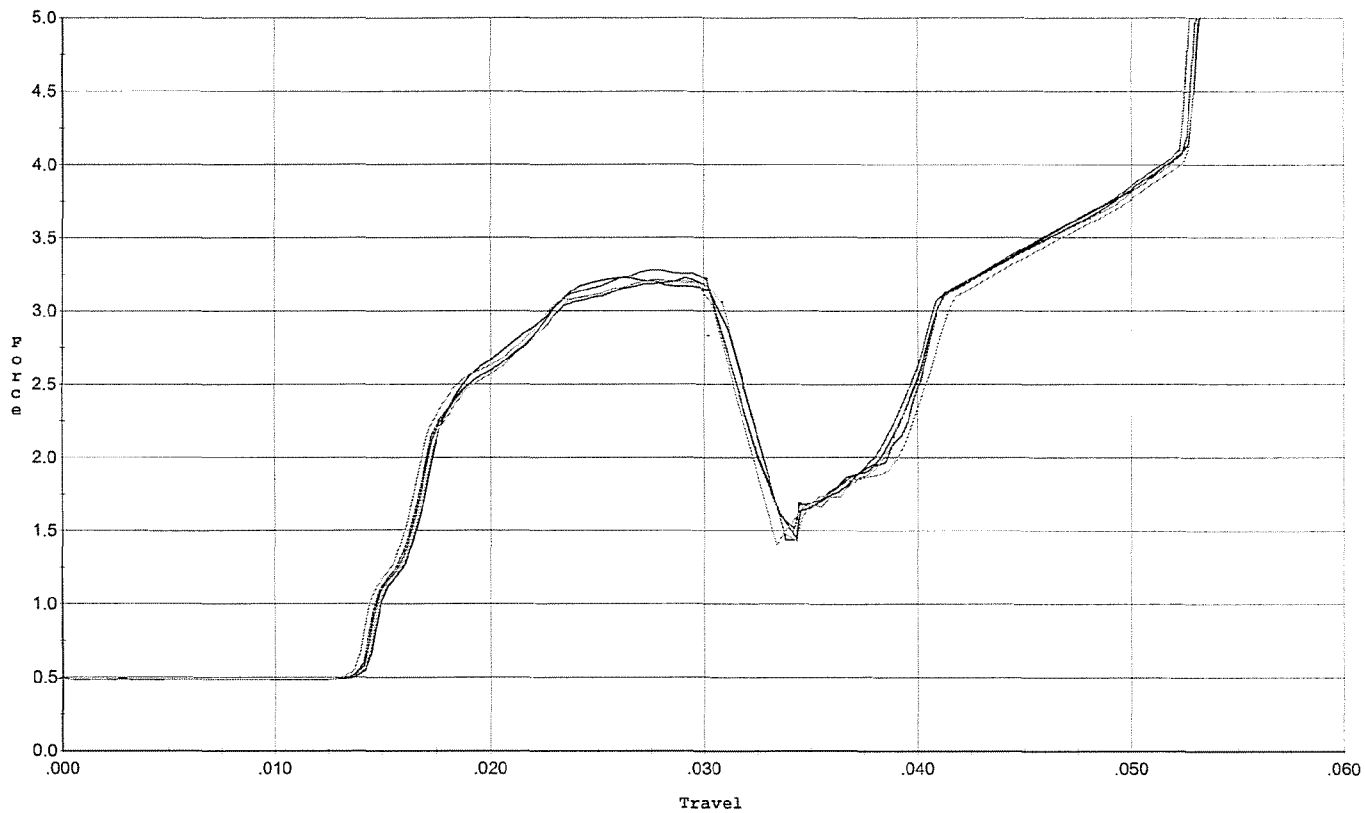
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.760	0.032	0.015	0.024	0.045		Set Trigger
2	2.631	0.030	0.015	0.025	0.042		Set Trigger
3	2.582	0.030	0.015	0.025	0.042		Set Trigger
4	2.622	0.031	0.015	0.025	0.043		Set Trigger
5	2.612	0.030	0.015	0.025	0.041		Set Trigger

A-264

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



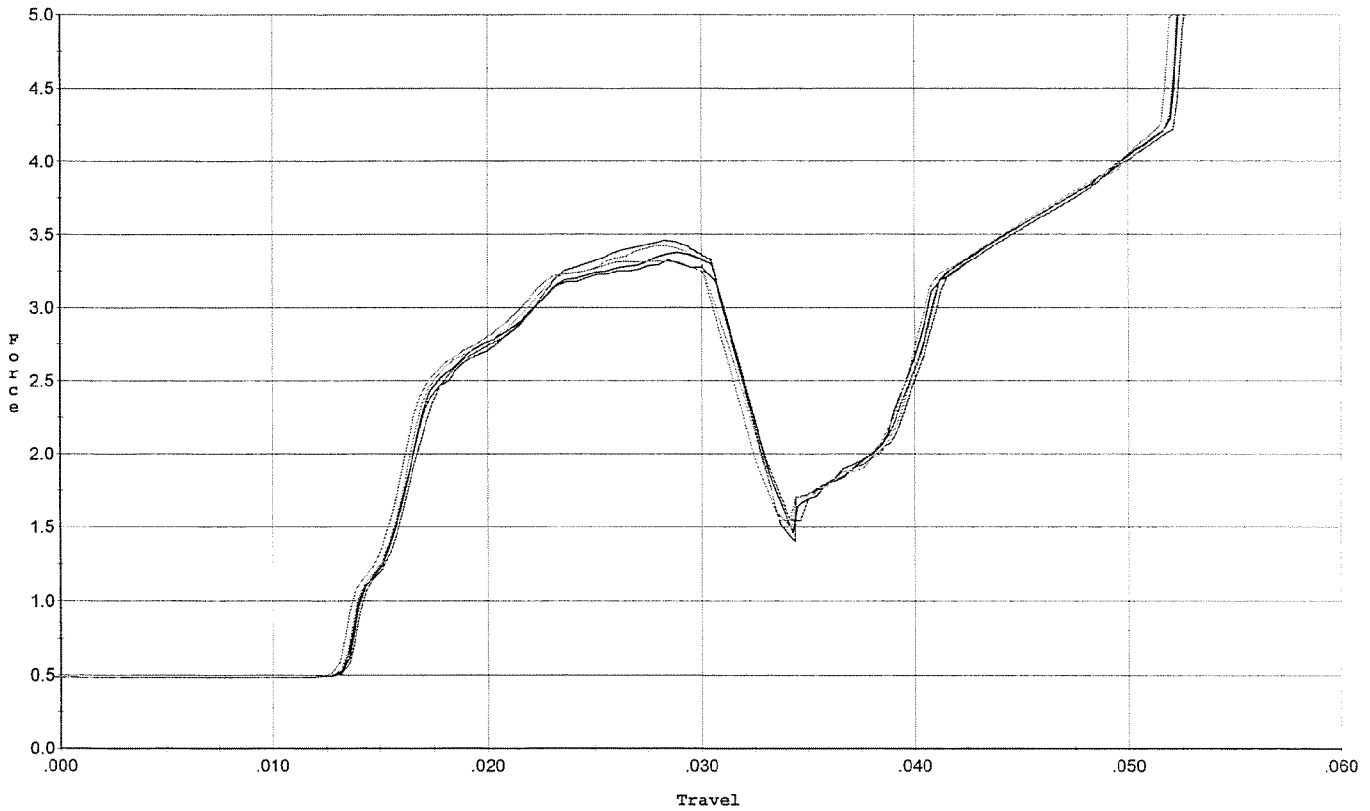
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.030	0.014	0.023	0.049		Set Trigger
2	3.228	0.031	0.014	0.023	0.051		Set Trigger
3	3.279	0.030	0.014	0.023	0.050		Set Trigger
4	3.207	0.031	0.014	0.023	0.051		Set Trigger
5	3.212	0.030	0.014	0.023	0.050		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



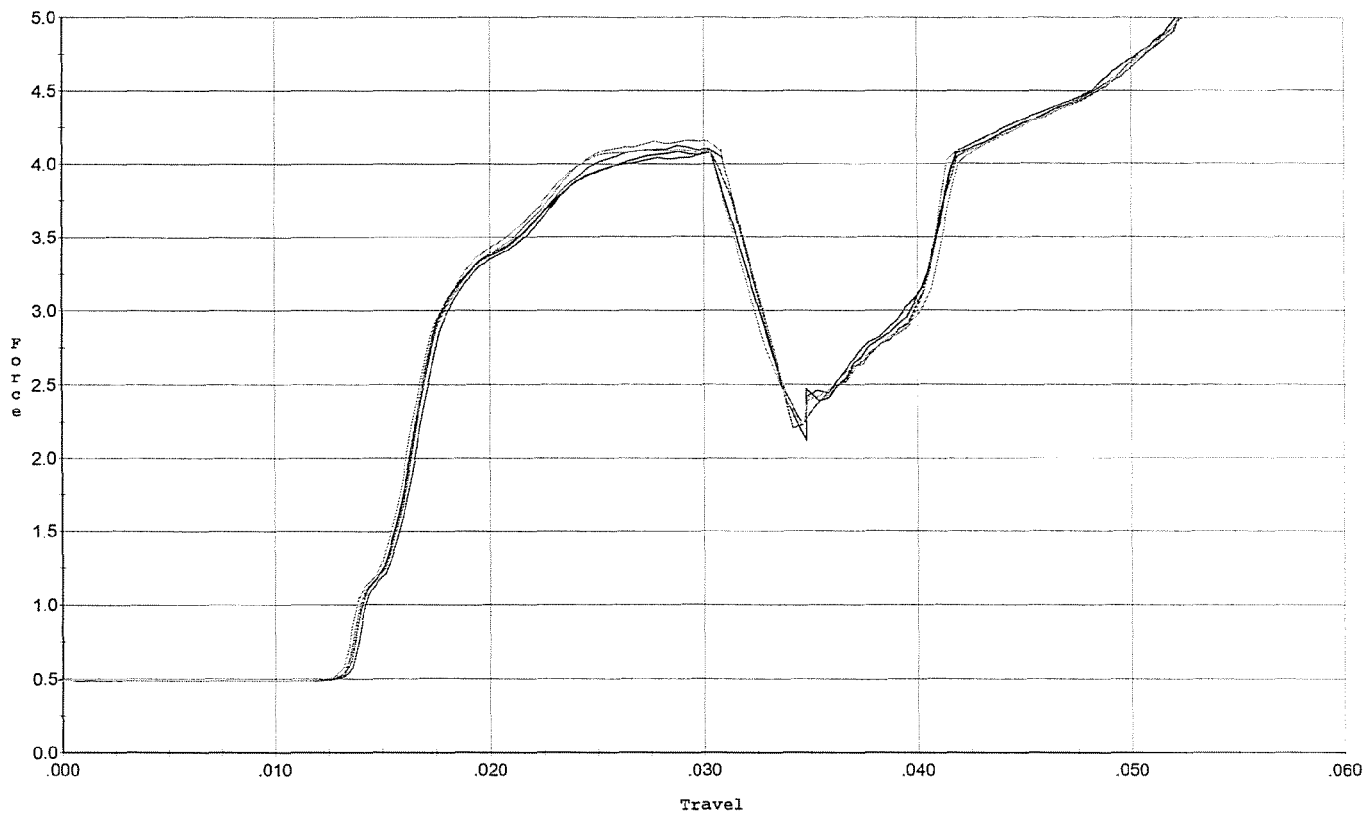
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.325	0.031	0.014	0.022	0.053		Set Trigger
2	3.377	0.030	0.014	0.022	0.053		Set Trigger
3	3.458	0.030	0.014	0.022	0.053		Set Trigger
4	3.423	0.031	0.013	0.022	0.055		Set Trigger
5	3.318	0.030	0.013	0.022	0.053		Set Trigger

A-3-38

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



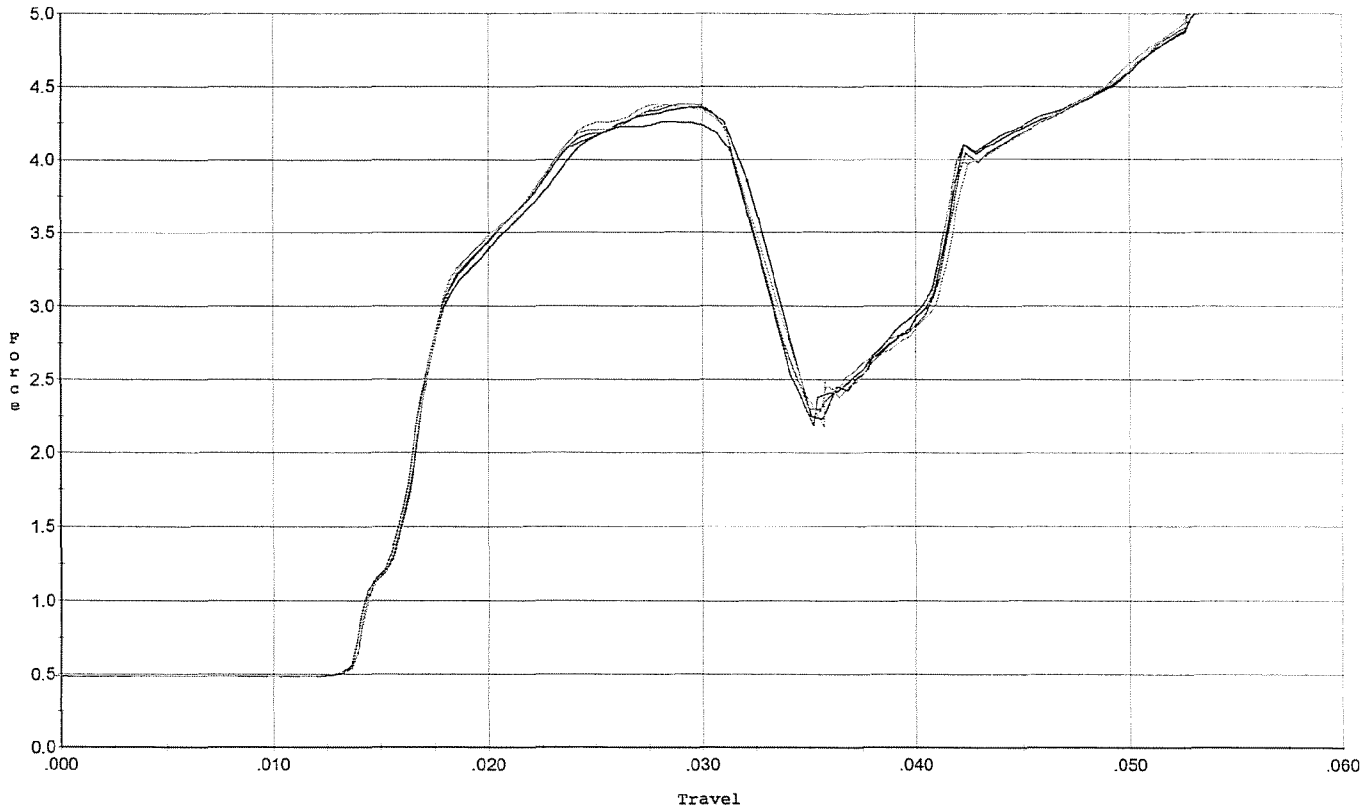
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.097	0.031	0.014	0.020	0.063		Set Trigger
2	4.085	0.032	0.014	0.019	0.066		Set Trigger
3	4.125	0.031	0.014	0.020	0.065		Set Trigger
4	4.099	0.030	0.013	0.020	0.063		Set Trigger
5	4.160	0.031	0.014	0.020	0.064		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



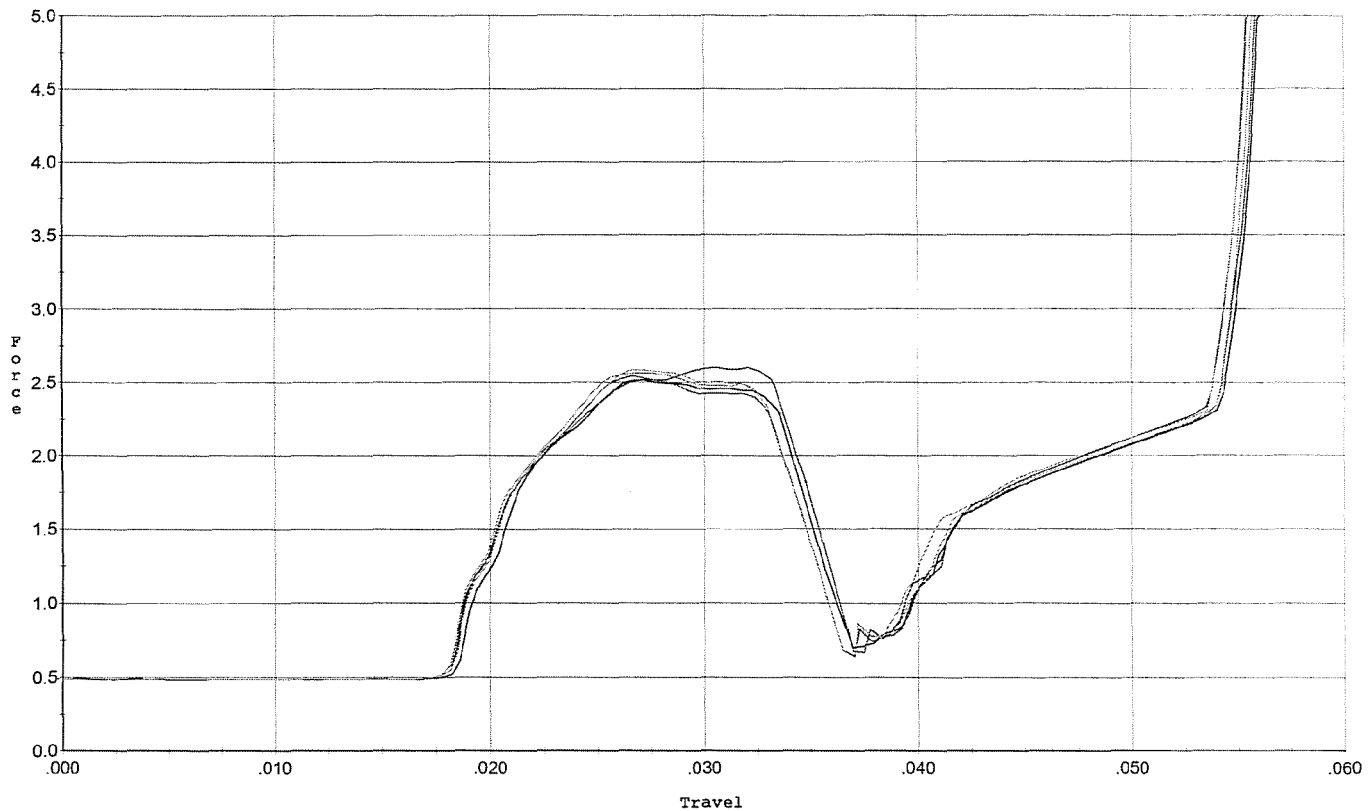
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.261	0.031	0.014	0.020	0.067		Set Trigger
2	4.361	0.032	0.014	0.019	0.069		Set Trigger
3	4.384	0.031	0.014	0.020	0.067		Set Trigger
4	4.379	0.031	0.014	0.020	0.067		Set Trigger
5	4.385	0.031	0.014	0.020	0.067		Set Trigger

A. 4.35

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



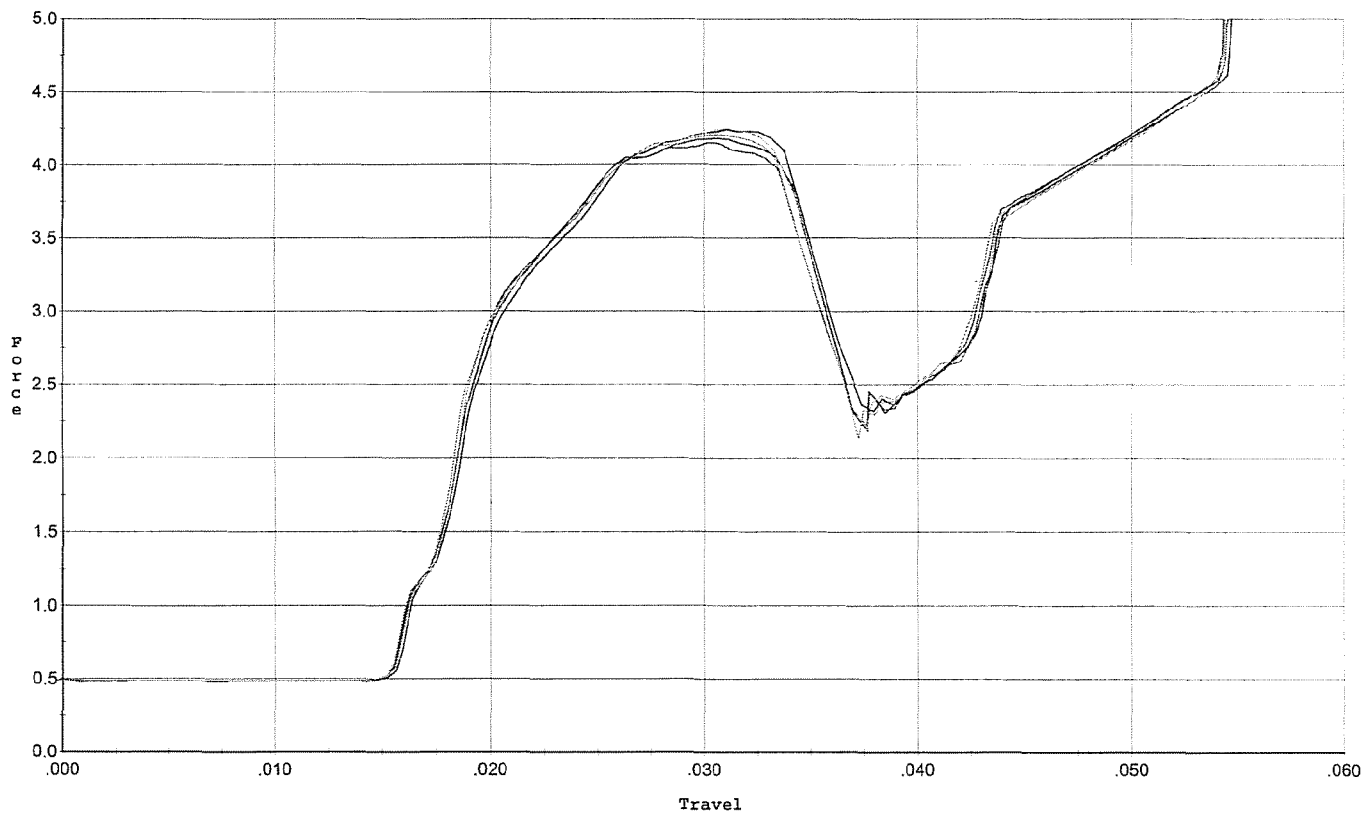
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.035	0.018	0.025	0.044		Set Trigger
2	2.515	0.034	0.019	0.025	0.041		Set Trigger
3	2.543	0.035	0.018	0.024	0.043		Set Trigger
4	2.585	0.035	0.018	0.025	0.043		Set Trigger
5	2.562	0.035	0.018	0.024	0.044		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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	4.180	0.034	0.016	0.020	0.070		Set Trigger
2	4.242	0.034	0.016	0.020	0.069		Set Trigger
3	4.153	0.033	0.016	0.020	0.067		Set Trigger
4	4.205	0.033	0.016	0.020	0.068		Set Trigger
5	4.248	0.034	0.016	0.020	0.070		Set Trigger

A-4-20