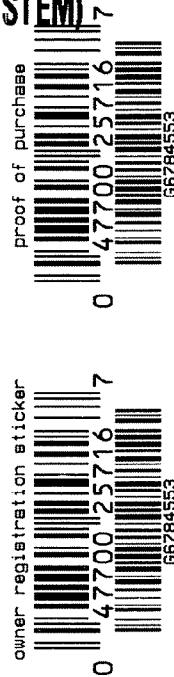


G6784553

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

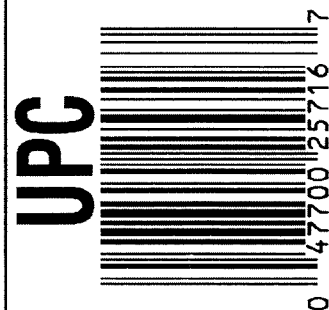
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6784553



GUN SERIAL # G6784553

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-27-08	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	MAGNA-FLUX	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	ULI 02 2008	9-30-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/2/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/03/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-31-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

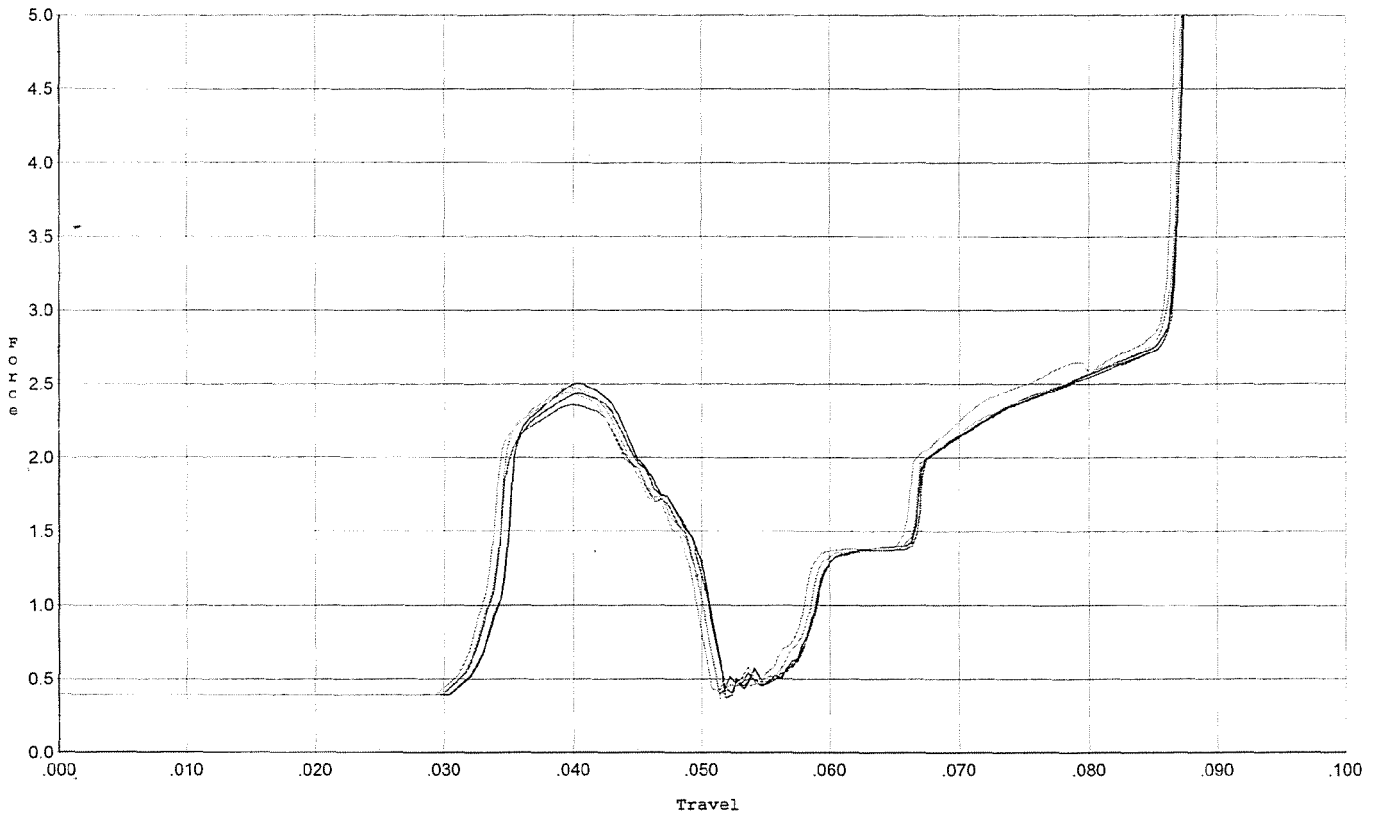
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>35</u> <u>35</u> <u>40</u>	11-6-08	X PD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	11-6-08	X PD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-6-08	X PD
	J) ASSEMBLE STOCK		10-31-08	PPD
	K) ASSEMBLE SWIVEL STUDS		11-6-08	X PD
	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	X PD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NA		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-6-08	X PD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.36</u> <u>2.24</u> <u>2.23</u> <u>2.29</u>	11-5-08	Fm
	C) FUNCTION		11-6-08	X PD
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.



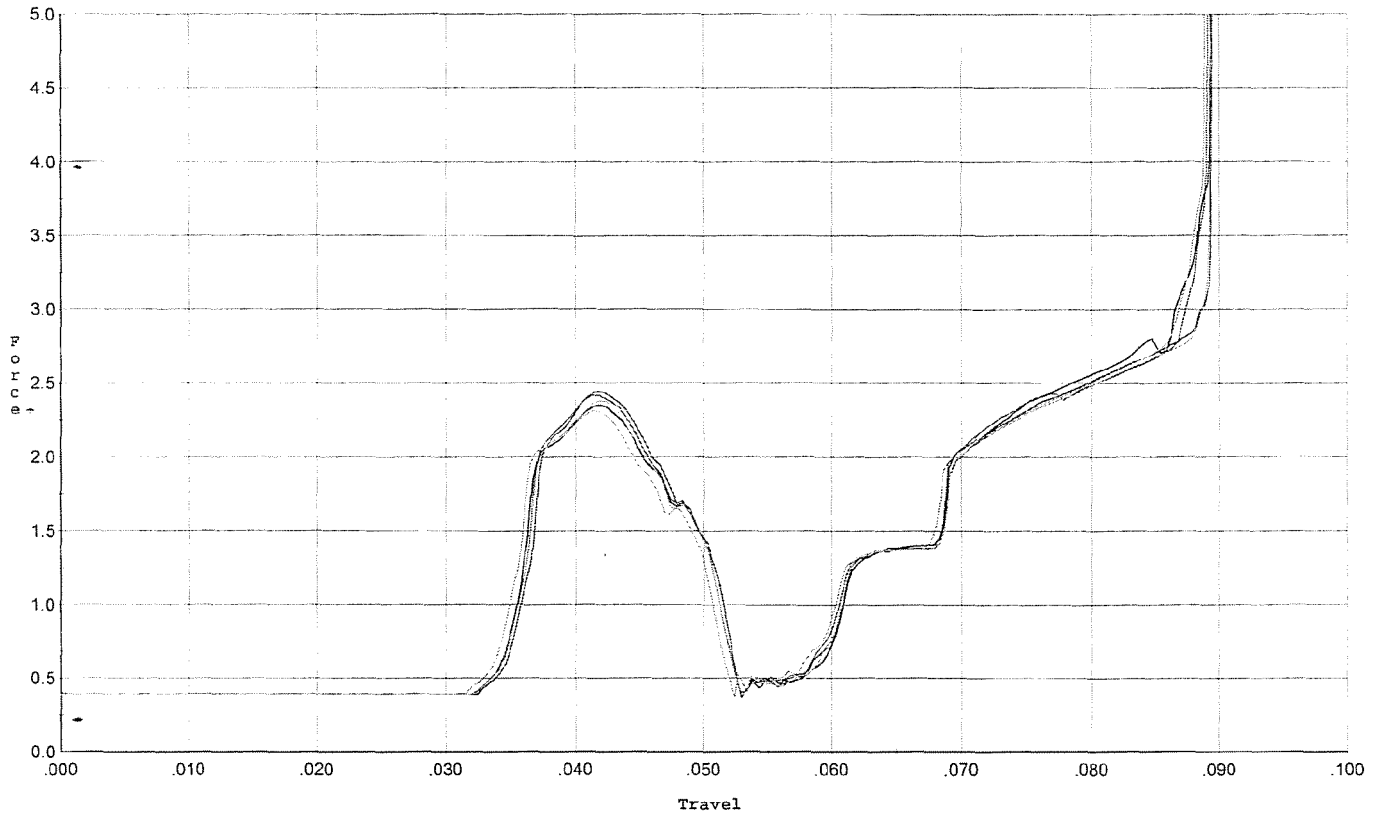
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.050	0.033	0.041	0.046		Set Trigger
2	2.503	0.050	0.033	0.041	0.047		Set Trigger
3	2.359	0.050	0.032	0.042	0.046		Set Trigger
4	2.478	0.050	0.032	0.042	0.047		Set Trigger
5	2.437	0.049	0.032	0.042	0.046		Set Trigger

Aug 2.44

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.



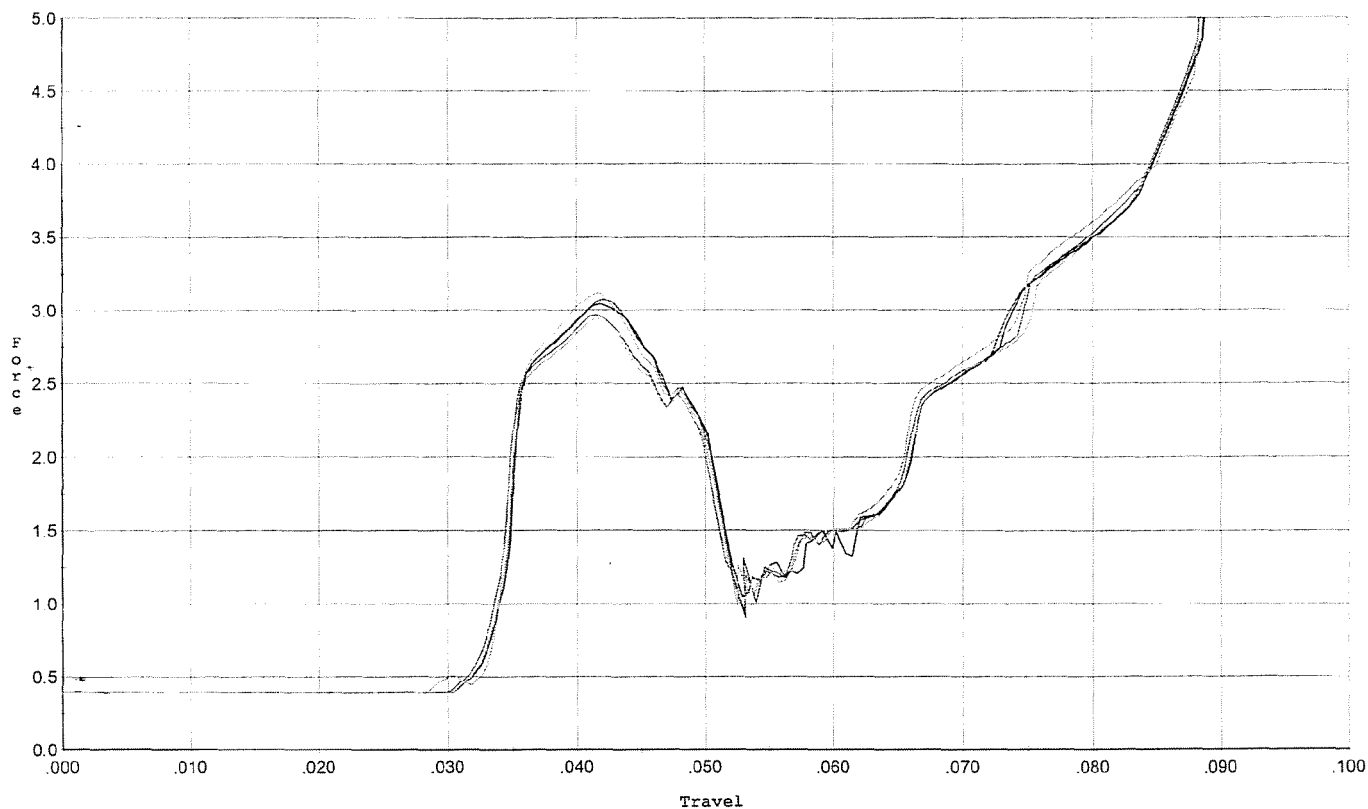
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.051	0.035	0.042	0.045		Set Trigger
2	2.353	0.050	0.034	0.043	0.044		Set Trigger
3	2.418	0.050	0.034	0.042	0.044		Set Trigger
4	2.378	0.050	0.035	0.043	0.044		Set Trigger
5	2.312	0.050	0.034	0.043	0.043		Set Trigger

AUG 23 8

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.



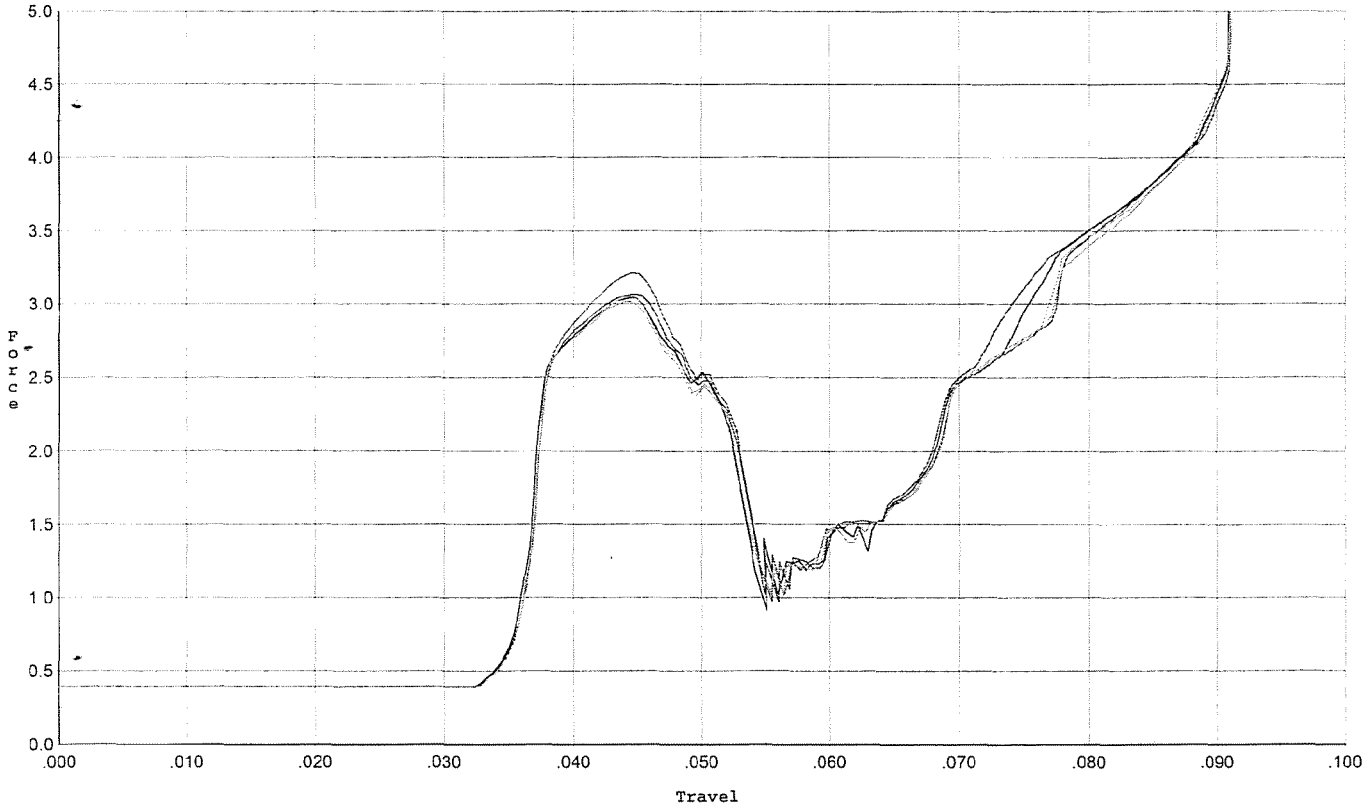
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.071	0.050	0.033	0.040	0.057		Set Trigger
2	3.044	0.050	0.033	0.040	0.057		Set Trigger
3	2.968	0.050	0.033	0.041	0.055		Set Trigger
4	2.945	0.050	0.033	0.041	0.054		Set Trigger
5	3.119	0.051	0.033	0.040	0.058		Set Trigger

Aug 302

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.



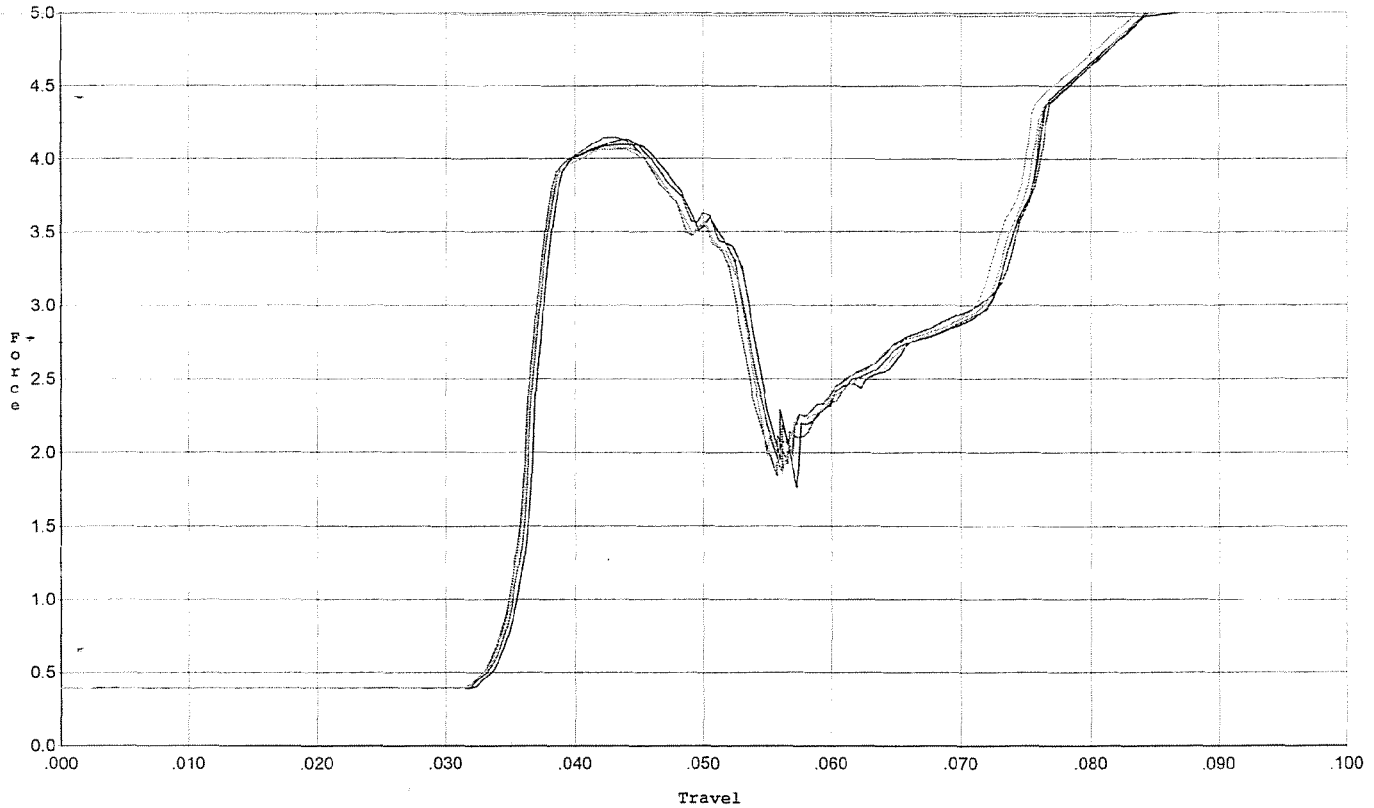
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.053	0.035	0.040	0.059		Set Trigger
2	3.040	0.052	0.035	0.041	0.058		Set Trigger
3	3.213	0.053	0.035	0.040	0.060		Set Trigger
4	3.051	0.052	0.035	0.041	0.057		Set Trigger
5	3.018	0.052	0.035	0.041	0.057		Set Trigger

Aug. 3.07

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.



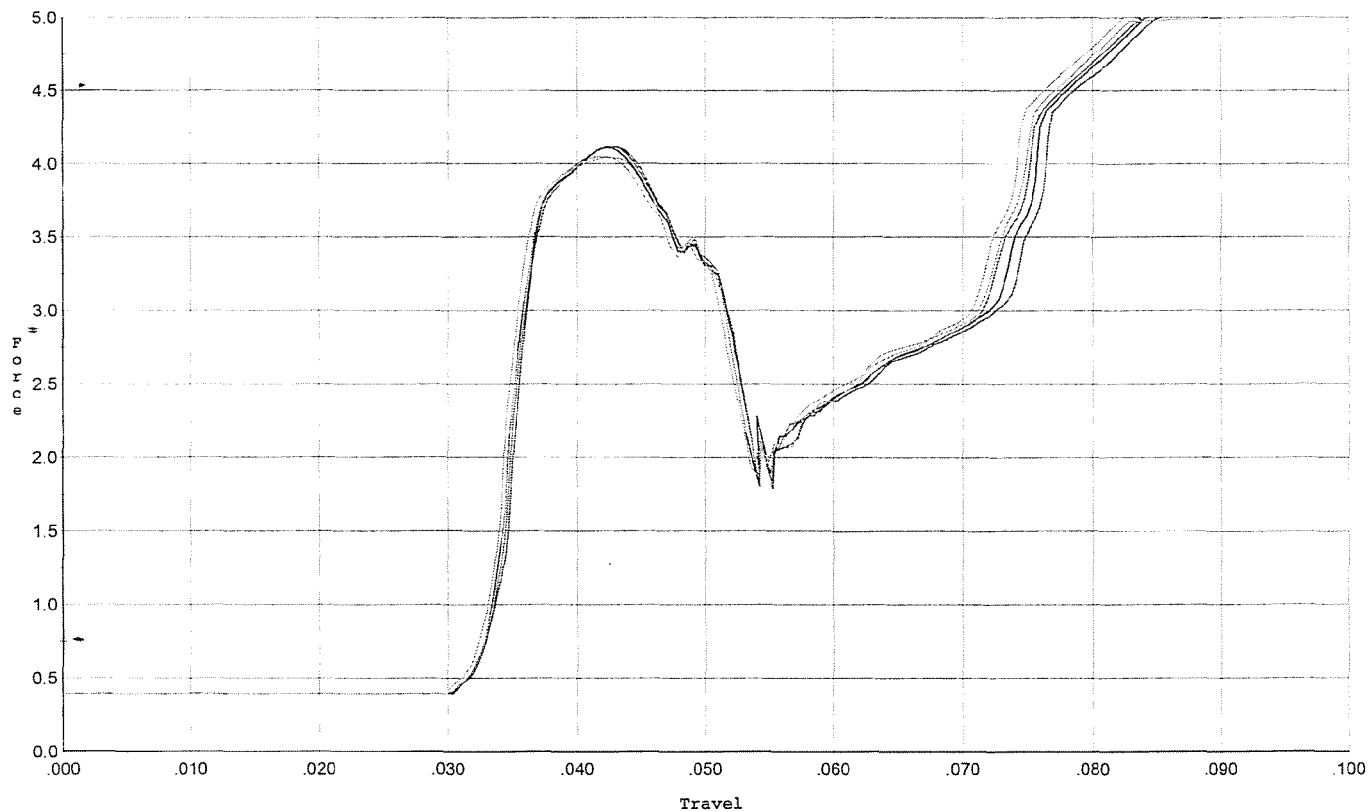
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.052	0.034	0.035	0.078		Set Trigger
2	4.099	0.053	0.034	0.035	0.079		Set Trigger
3	4.147	0.052	0.034	0.036	0.077		Set Trigger
4	4.081	0.053	0.034	0.036	0.079		Set Trigger
5	4.066	0.053	0.034	0.036	0.078		Set Trigger

Avg. 4.10

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.



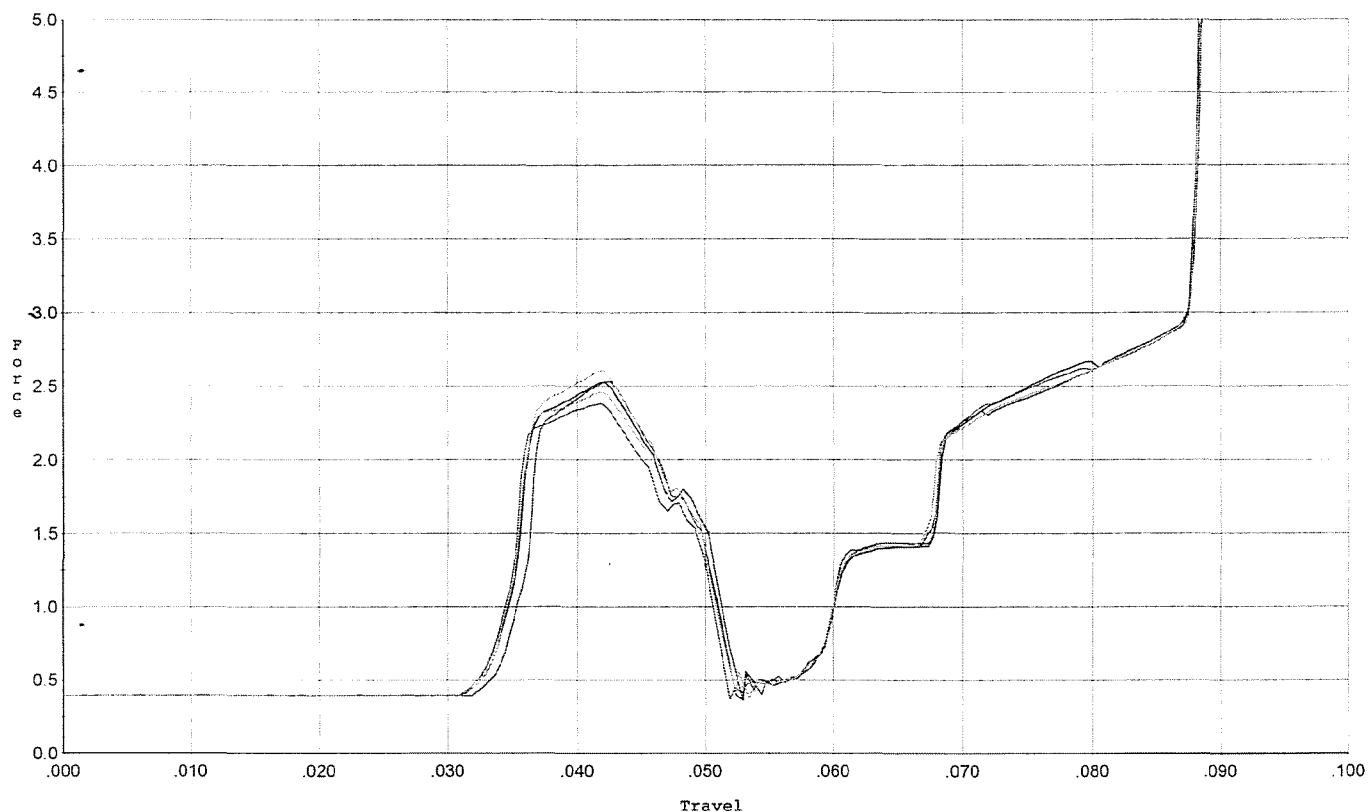
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.119	0.052	0.032	0.036	0.079		Set Trigger
2	4.109	0.051	0.032	0.035	0.077		Set Trigger
3	4.120	0.052	0.032	0.035	0.079		Set Trigger
4	4.044	0.051	0.032	0.035	0.077		Set Trigger
5	4.047	0.051	0.032	0.035	0.076		Set Trigger

Aug = 4.08

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



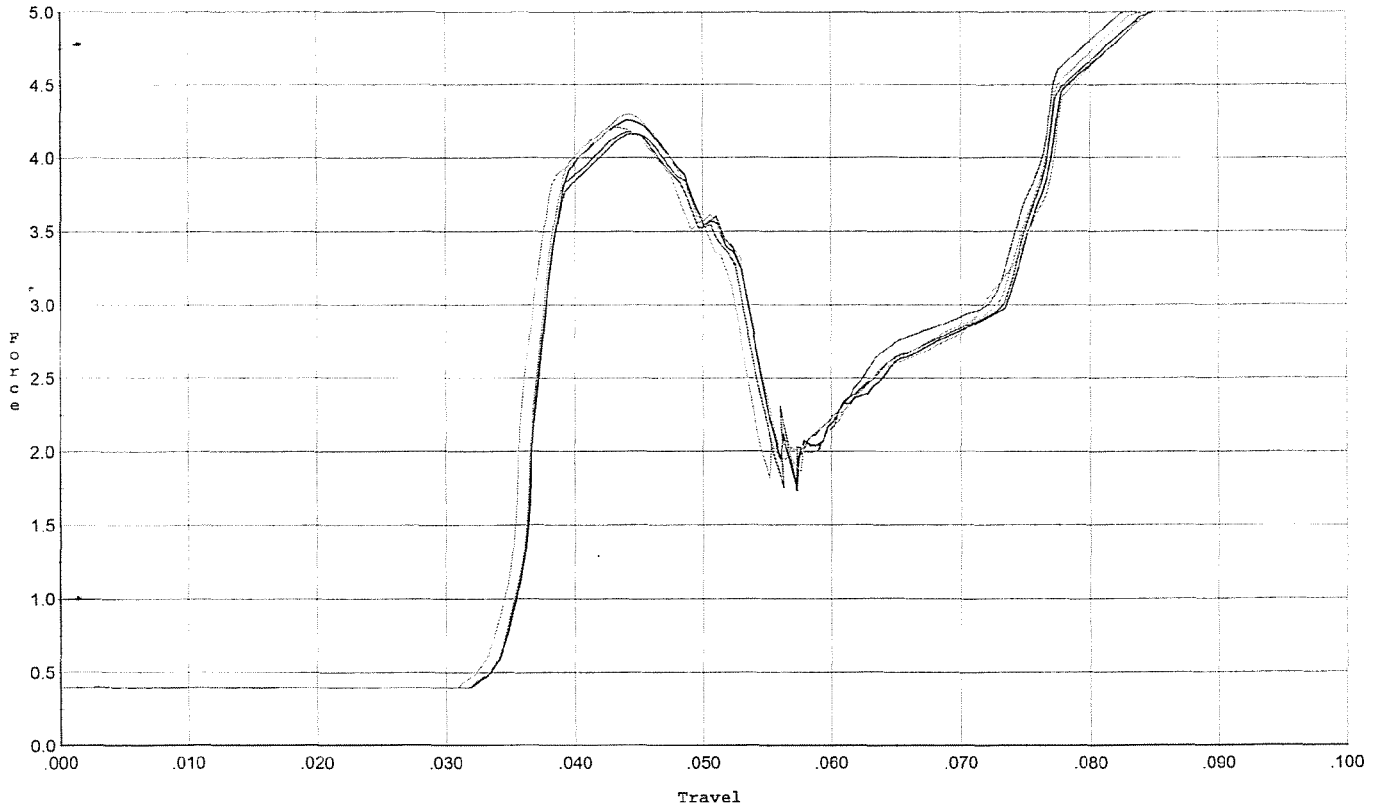
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.050	0.034	0.042	0.046		Set Trigger
2	2.529	0.051	0.033	0.042	0.047		Set Trigger
3	2.383	0.050	0.033	0.042	0.045		Set Trigger
4	2.461	0.050	0.033	0.042	0.046		Set Trigger
5	2.603	0.050	0.033	0.042	0.047		Set Trigger

Avg 2.50

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	4.162	0.053	0.034	0.038	0.079		Set Trigger
2	4.258	0.053	0.034	0.038	0.080		Set Trigger
3	4.177	0.053	0.034	0.038	0.078		Set Trigger
4	4.296	0.053	0.034	0.038	0.080		Set Trigger
5	4.205	0.052	0.033	0.037	0.079		Set Trigger

Aug 4.22