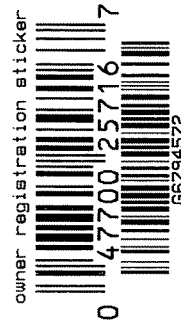
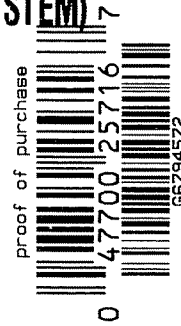


G6794572

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

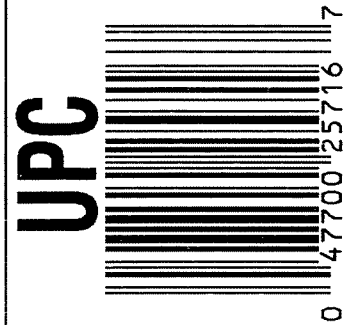
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794572



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794572

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-1-08	RSN
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (RS)	10/1/08	(RS)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10-8	✓
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		10-29-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

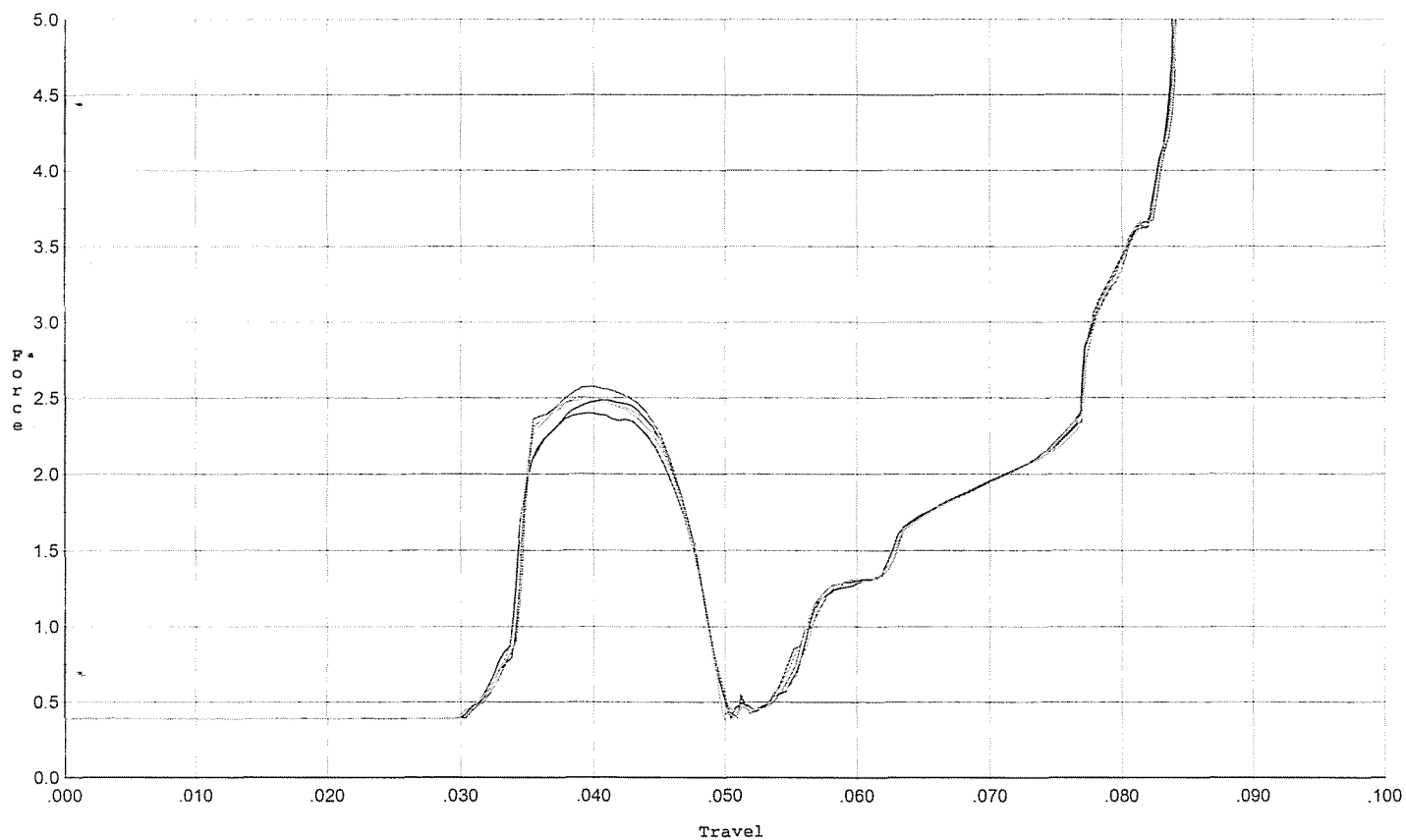
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	40	40	40	11-4-08	RQ		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	50	50	50	11-4-08	RQ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.033	.033	.033	11-4-08	RQ		
	J) ASSEMBLE STOCK					10-29-08	RSN		
	K) ASSEMBLE SWIVEL STUDS					11-4-08	RQ		
	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		10-30-08	Rgn		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					10-30-08	TC		
670	FINAL INSPECTION A) HEADSPACE					11-4-08	RQ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.19	2.25	2.37	2.25	2.20	11-3-08	TC
	C) FUNCTION					11-4-08	RQ		
690	PACK					11/4/08	Fm		

F004 REV 5/2006

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. ini. +/- .50 lbs.



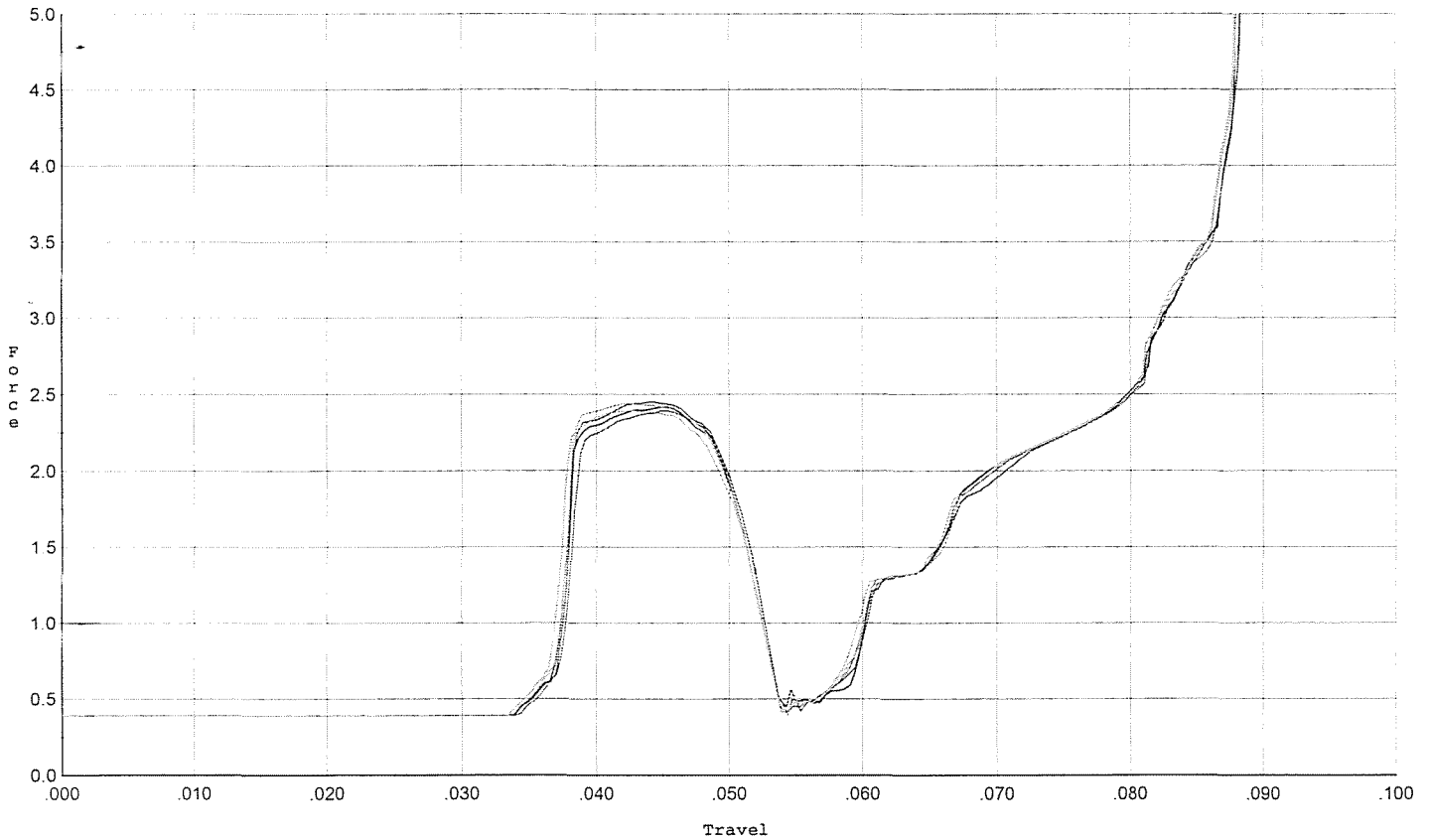
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.400	0.048	0.032	0.040	0.044		Set Trigger
2	2.486	0.048	0.032	0.040	0.045		Set Trigger
3	2.574	0.048	0.033	0.040	0.045		Set Trigger
4	2.500	0.048	0.033	0.040	0.045		Set Trigger
5	2.509	0.048	0.033	0.040	0.045		Set Trigger

Avg 2.49

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.



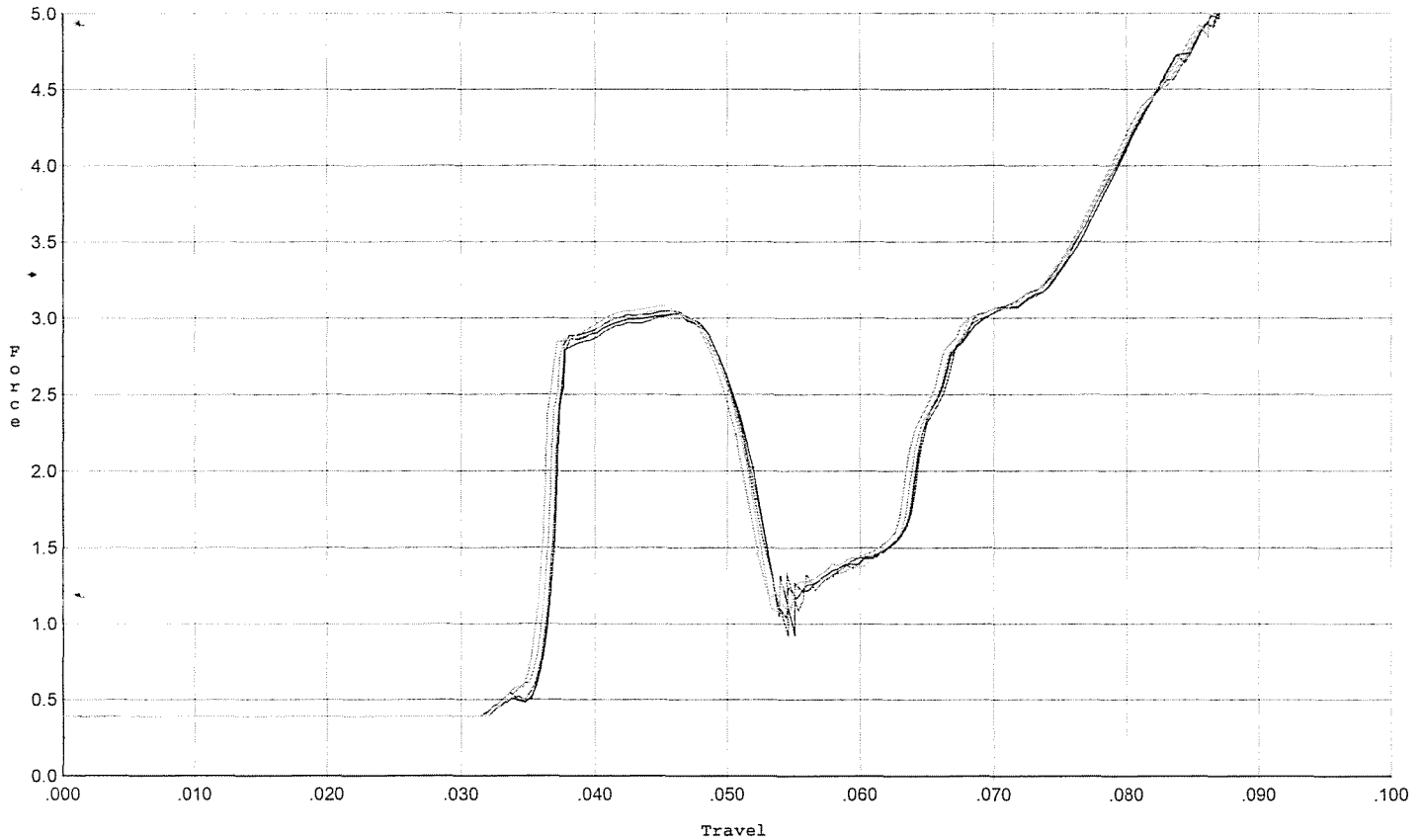
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.453	0.052	0.037	0.040	0.047		Set Trigger
2	2.417	0.052	0.037	0.040	0.047		Set Trigger
3	2.394	0.052	0.037	0.041	0.046		Set Trigger
4	2.395	0.051	0.036	0.040	0.046		Set Trigger
5	2.444	0.052	0.036	0.040	0.048		Set Trigger

Aug 2.42

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.



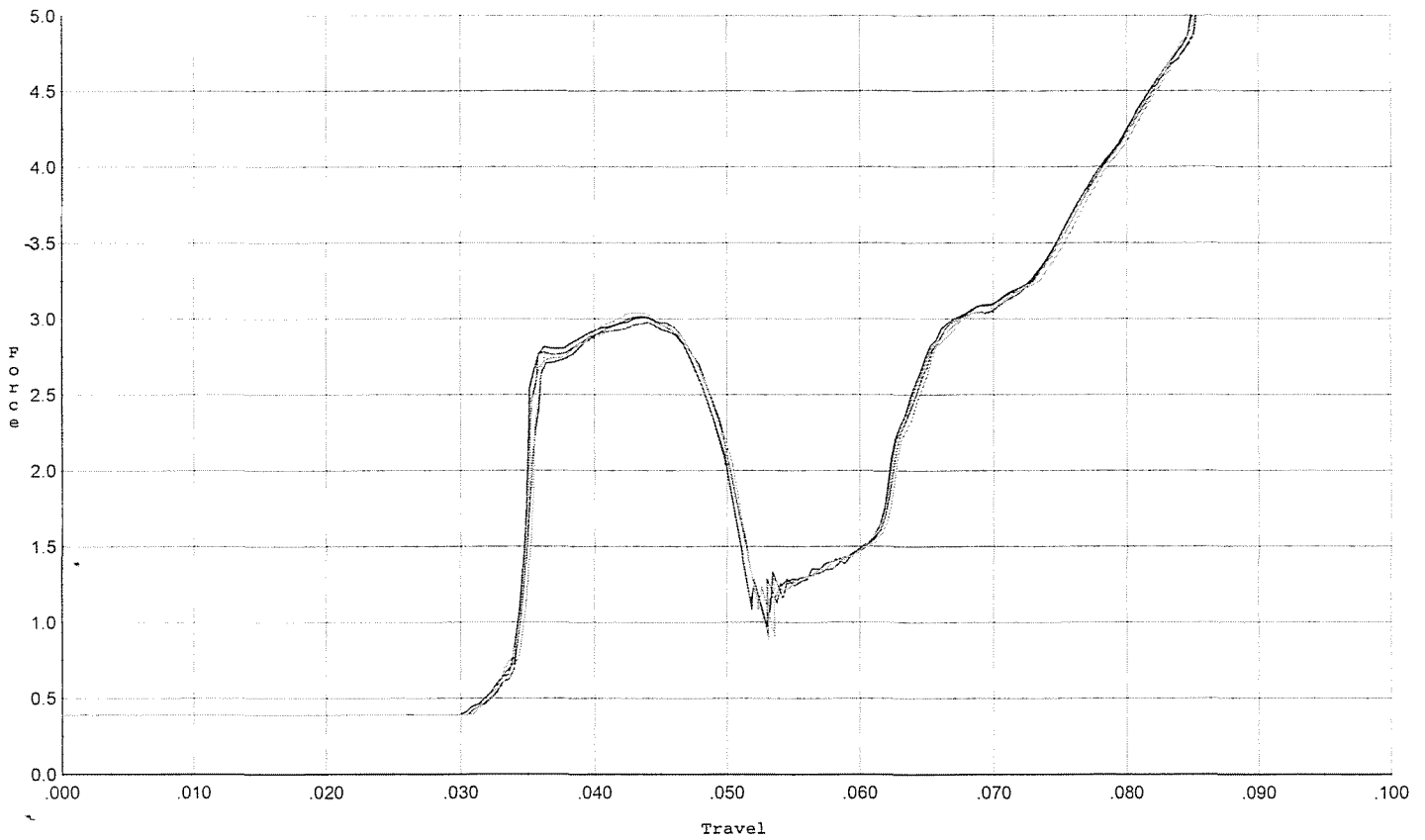
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.052	0.036	0.038	0.059		Set Trigger
2	3.023	0.052	0.036	0.038	0.058		Set Trigger
3	3.021	0.051	0.035	0.038	0.057		Set Trigger
4	3.048	0.051	0.035	0.037	0.058		Set Trigger
5	3.082	0.051	0.035	0.038	0.058		Set Trigger

Avg 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: 3.0 lbs. after 20 cycles +/- .75 lbs.



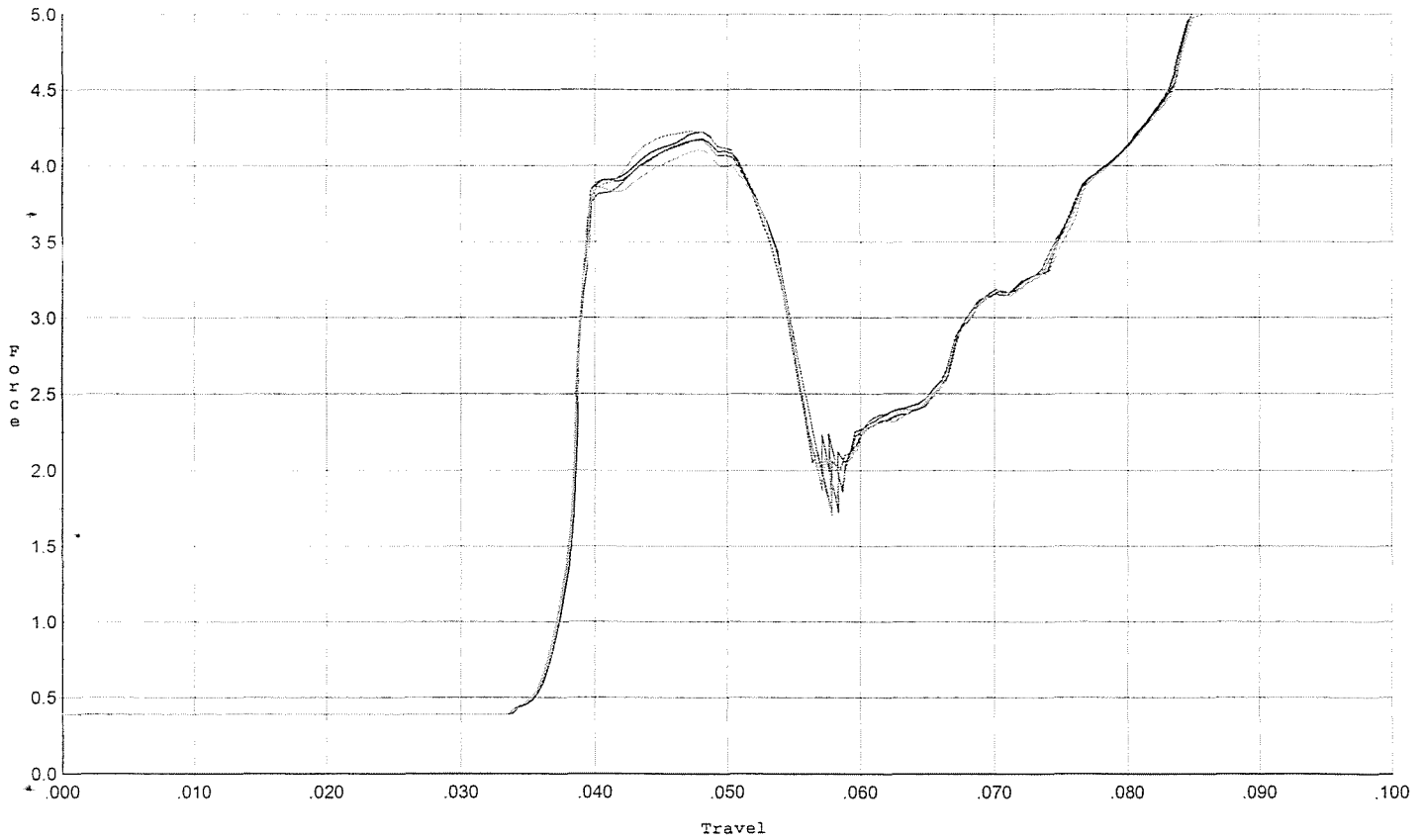
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.015	0.050	0.033	0.038	0.056		Set Trigger
2	3.012	0.050	0.033	0.037	0.057		Set Trigger
3	2.976	0.050	0.033	0.037	0.056		Set Trigger
4	2.976	0.050	0.033	0.038	0.056		Set Trigger
5	3.040	0.050	0.033	0.037	0.058		Set Trigger

Aug 3.00

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.



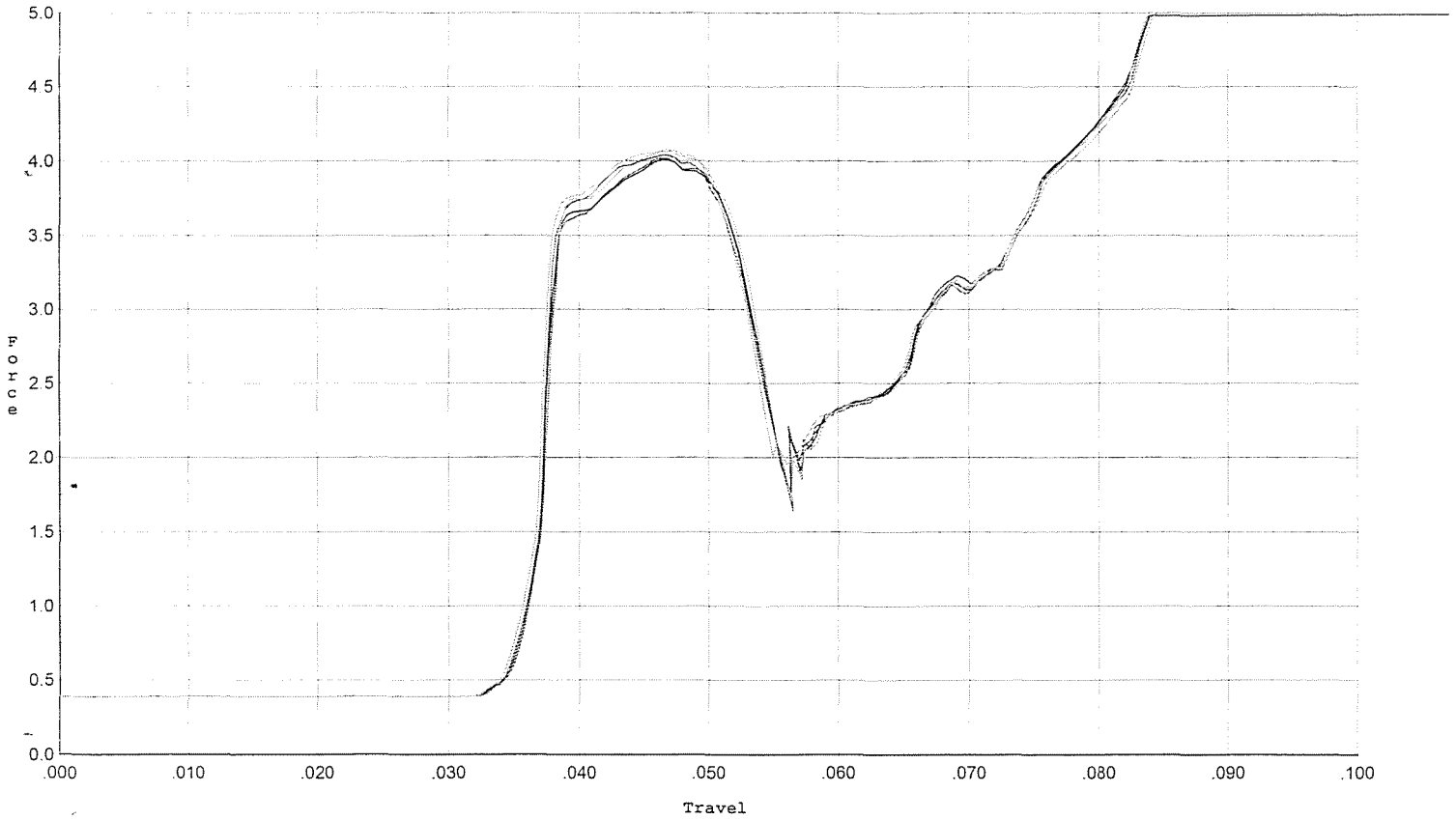
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.177	0.054	0.036	0.038	0.079		Set Trigger
2	4.220	0.054	0.036	0.038	0.079		Set Trigger
3	4.166	0.054	0.036	0.038	0.079		Set Trigger
4	4.103	0.054	0.036	0.038	0.078		Set Trigger
5	4.227	0.054	0.036	0.038	0.080		Set Trigger

Aug 4.17

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. after 20 cycles +/- 1.0 lbs.



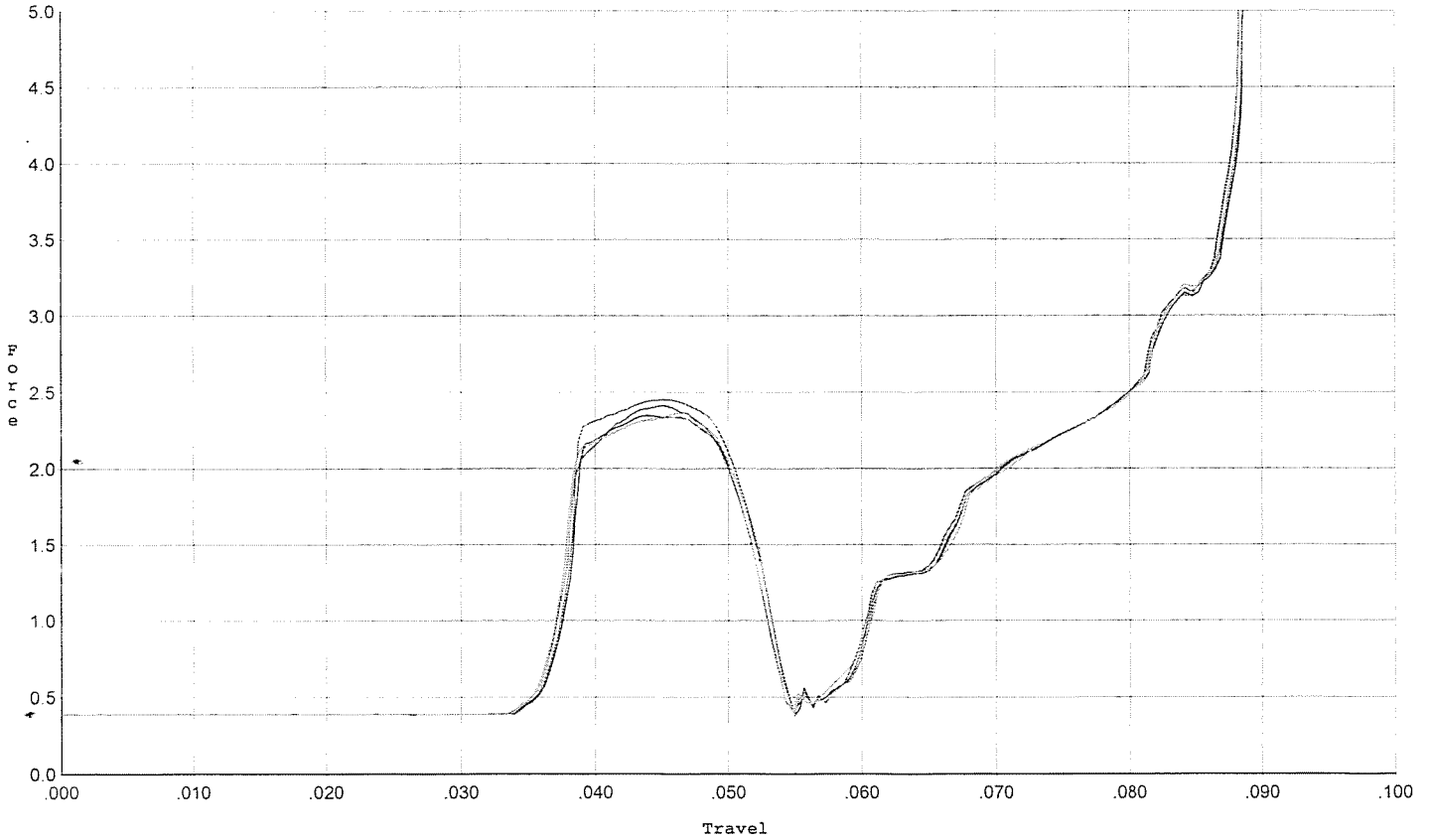
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.018	0.052	0.035	0.037	0.075		Set Trigger
2	4.009	0.054	0.035	0.037	0.078		Set Trigger
3	4.040	0.053	0.035	0.037	0.076		Set Trigger
4	4.081	0.053	0.034	0.037	0.078		Set Trigger
5	4.072	0.053	0.035	0.037	0.078		Set Trigger

Aug 4.04

Trigger Profile [lbs,inch]

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

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



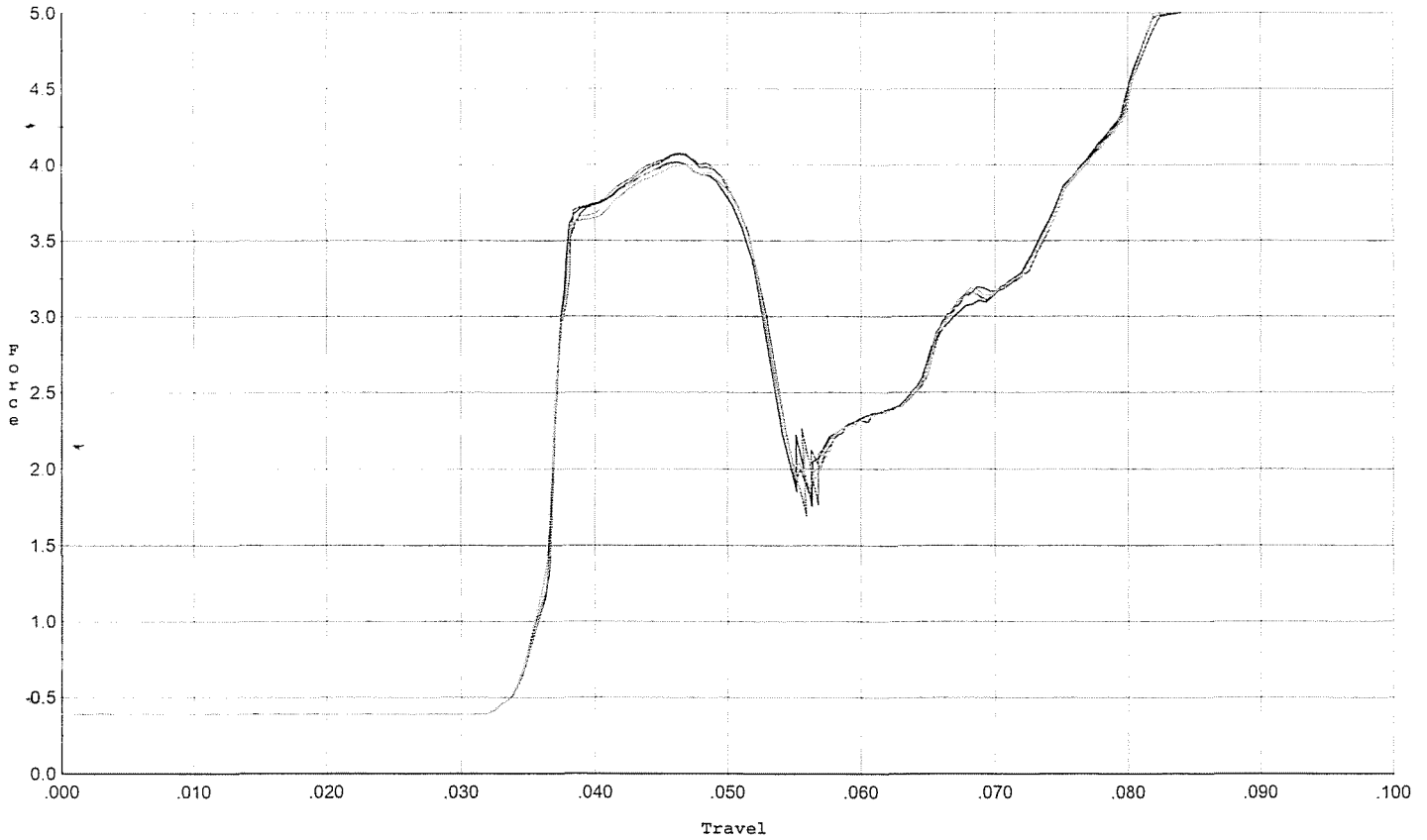
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.410	0.052	0.036	0.041	0.046		Set Trigger
2	2.347	0.052	0.036	0.040	0.047		Set Trigger
3	2.451	0.052	0.036	0.040	0.048		Set Trigger
4	2.342	0.052	0.036	0.041	0.046		Set Trigger
5	2.365	0.052	0.036	0.040	0.047		Set Trigger

Aug 2.38

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	4.069	0.053	0.034	0.037	0.077		Set Trigger
2	4.015	0.052	0.034	0.037	0.075		Set Trigger
3	4.077	0.052	0.035	0.037	0.075		Set Trigger
4	4.004	0.053	0.034	0.037	0.077		Set Trigger
5	3.994	0.052	0.034	0.037	0.075		Set Trigger

Aug 4.03