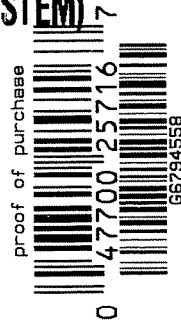


G6794558

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

- INSTRUCTION BOOK 3518

BM FORM

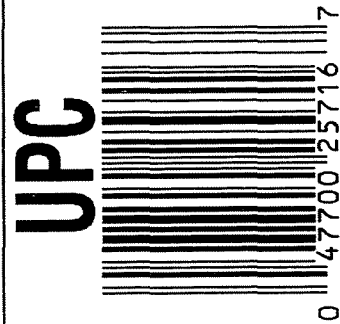


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794558



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794558

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	BA
475	DRILL AND TAP SIGHT HOLES	2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (RB)	10/2/08	(RB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DC
542	APPLY COATINGS (BARREL ACTION)		10 8	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-7-08	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	BA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

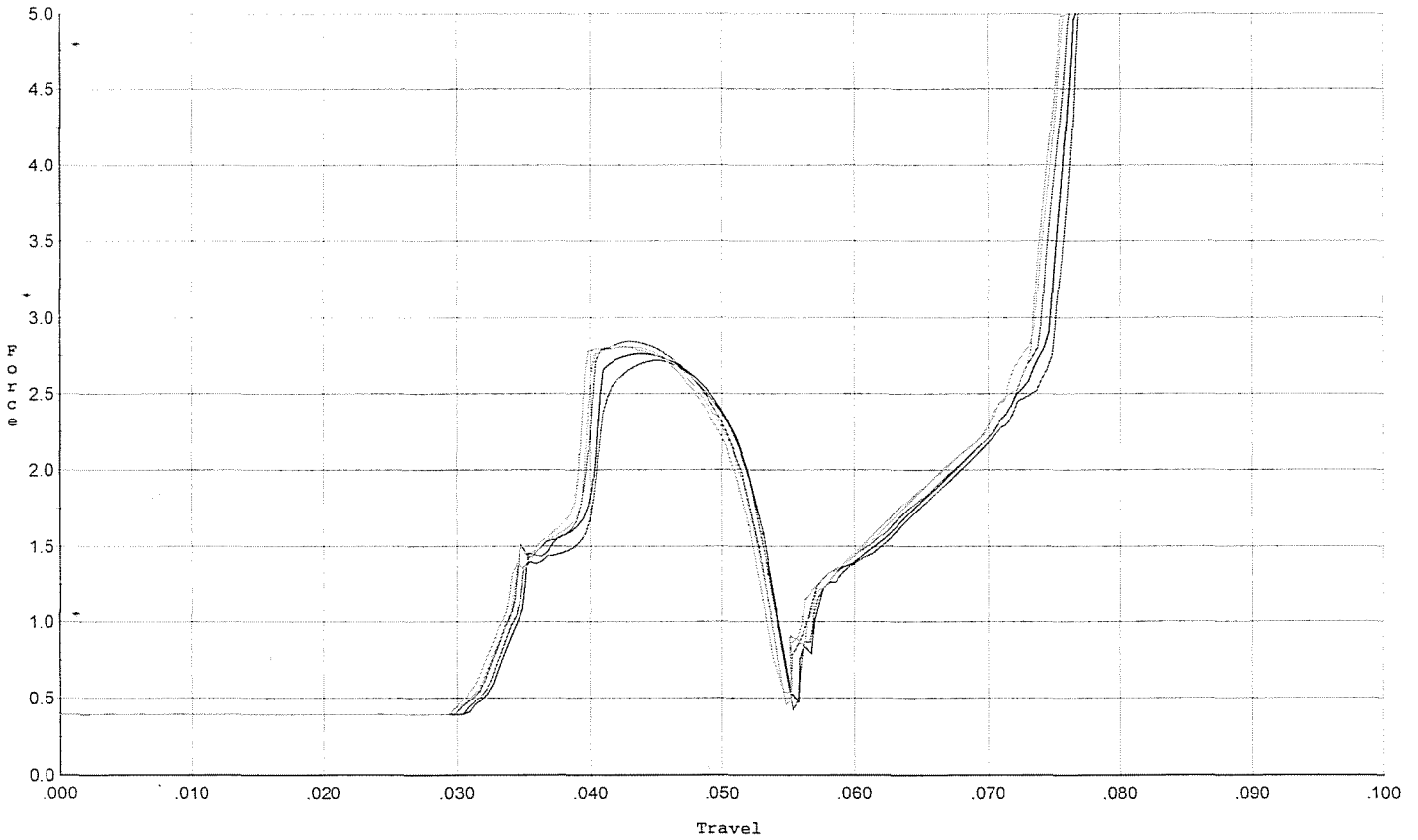
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.5</u> <u>4.0</u>	11-5-08	290
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-5-08	290
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-5-08	290
	J) ASSEMBLE STOCK		10-29-08	RSN
	K) ASSEMBLE SWIVEL STUDS		11-5-08	290
	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	10-30-08	RSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-5-08	290
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.10</u> <u>2.17</u> <u>2.24</u> <u>2.15</u> <u>2.08</u>	11-5-08	Fm
	C) FUNCTION		11-5-08	290
690	PACK		11/7/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



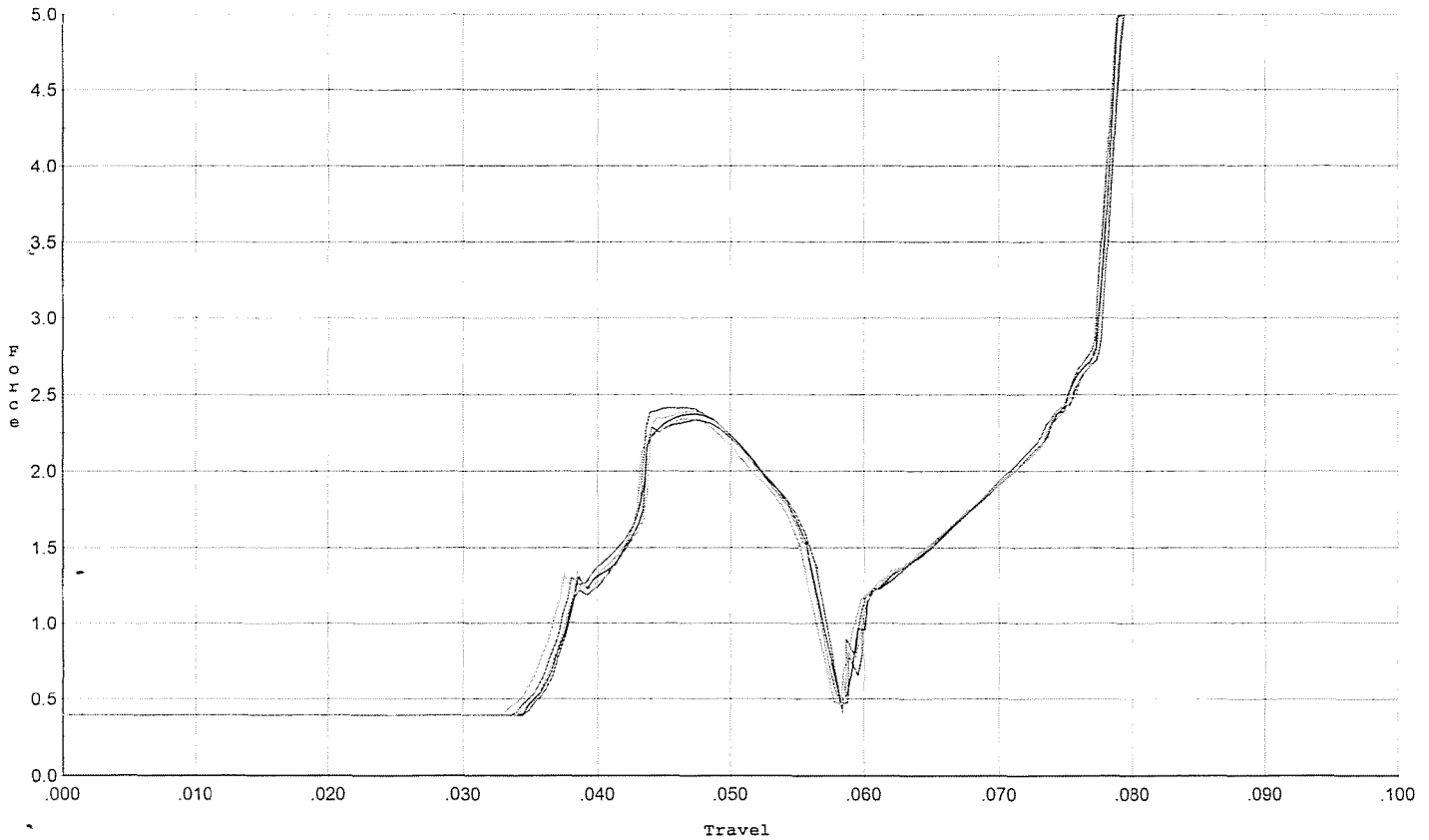
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.717	0.053	0.033	0.031	0.055		Set Trigger
2	2.761	0.053	0.033	0.030	0.055		Set Trigger
3	2.839	0.053	0.032	0.030	0.056		Set Trigger
4	2.803	0.053	0.032	0.030	0.056		Set Trigger
5	2.809	0.052	0.032	0.030	0.055		Set Trigger

A-2.78

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



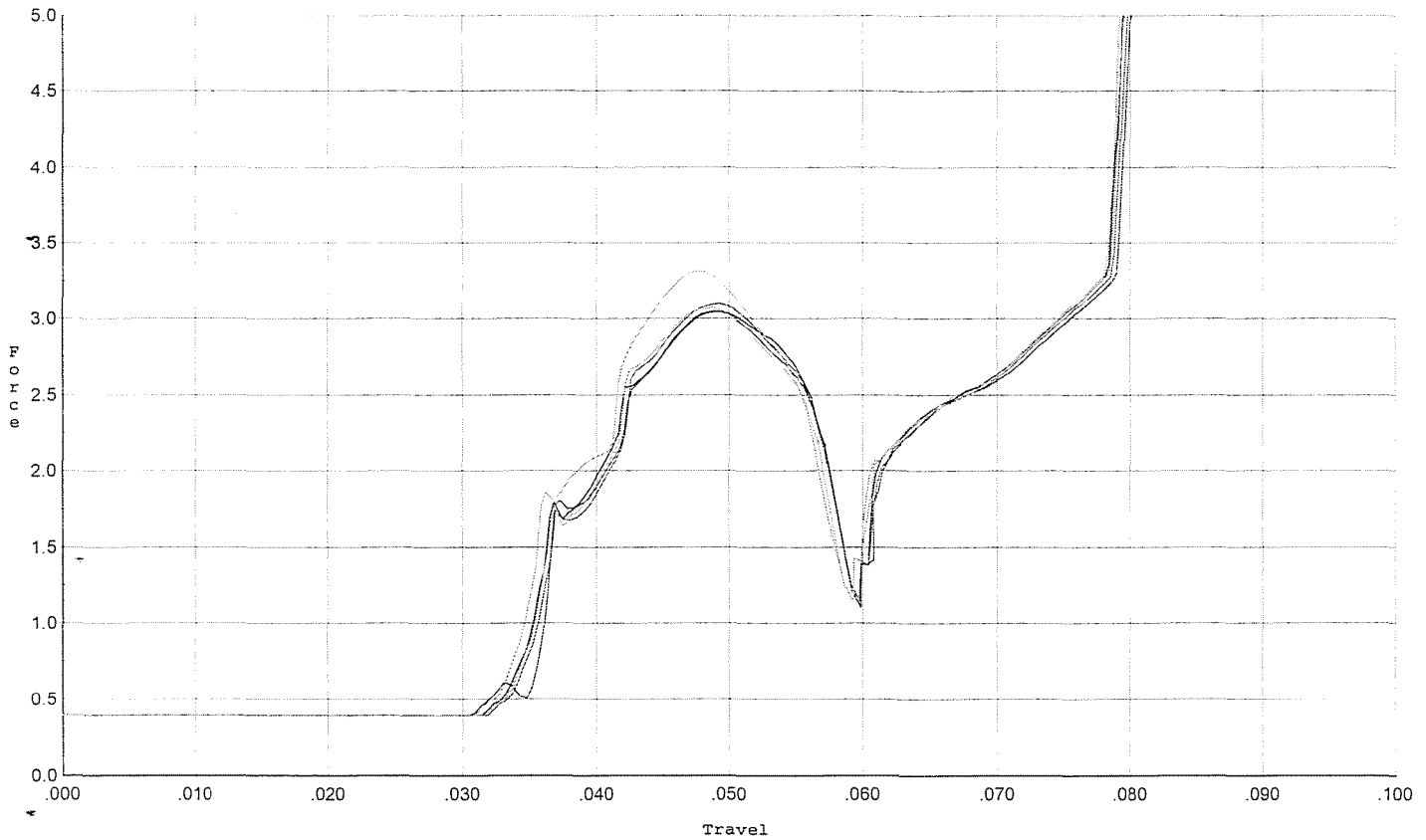
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.338	0.056	0.036	0.030	0.050		Set Trigger
2	2.374	0.056	0.035	0.031	0.050		Set Trigger
3	2.418	0.056	0.036	0.030	0.051		Set Trigger
4	2.392	0.056	0.036	0.031	0.050		Set Trigger
5	2.342	0.055	0.035	0.031	0.050		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



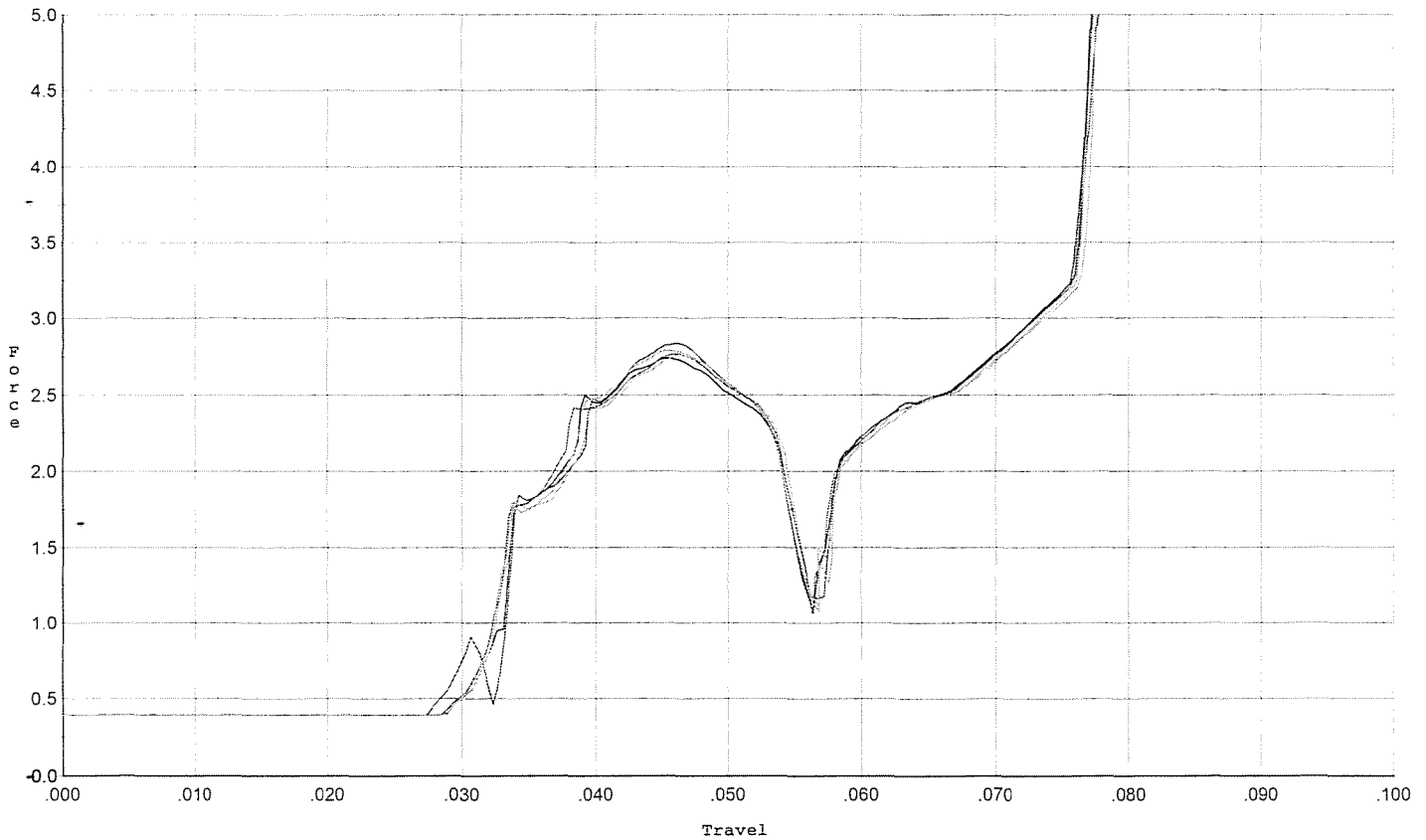
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.057	0.035	0.029	0.068		Set Trigger
2	3.047	0.057	0.034	0.028	0.070		Set Trigger
3	3.101	0.057	0.034	0.028	0.069		Set Trigger
4	3.071	0.057	0.034	0.029	0.068		Set Trigger
5	3.315	0.056	0.033	0.029	0.071		Set Trigger

A 3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



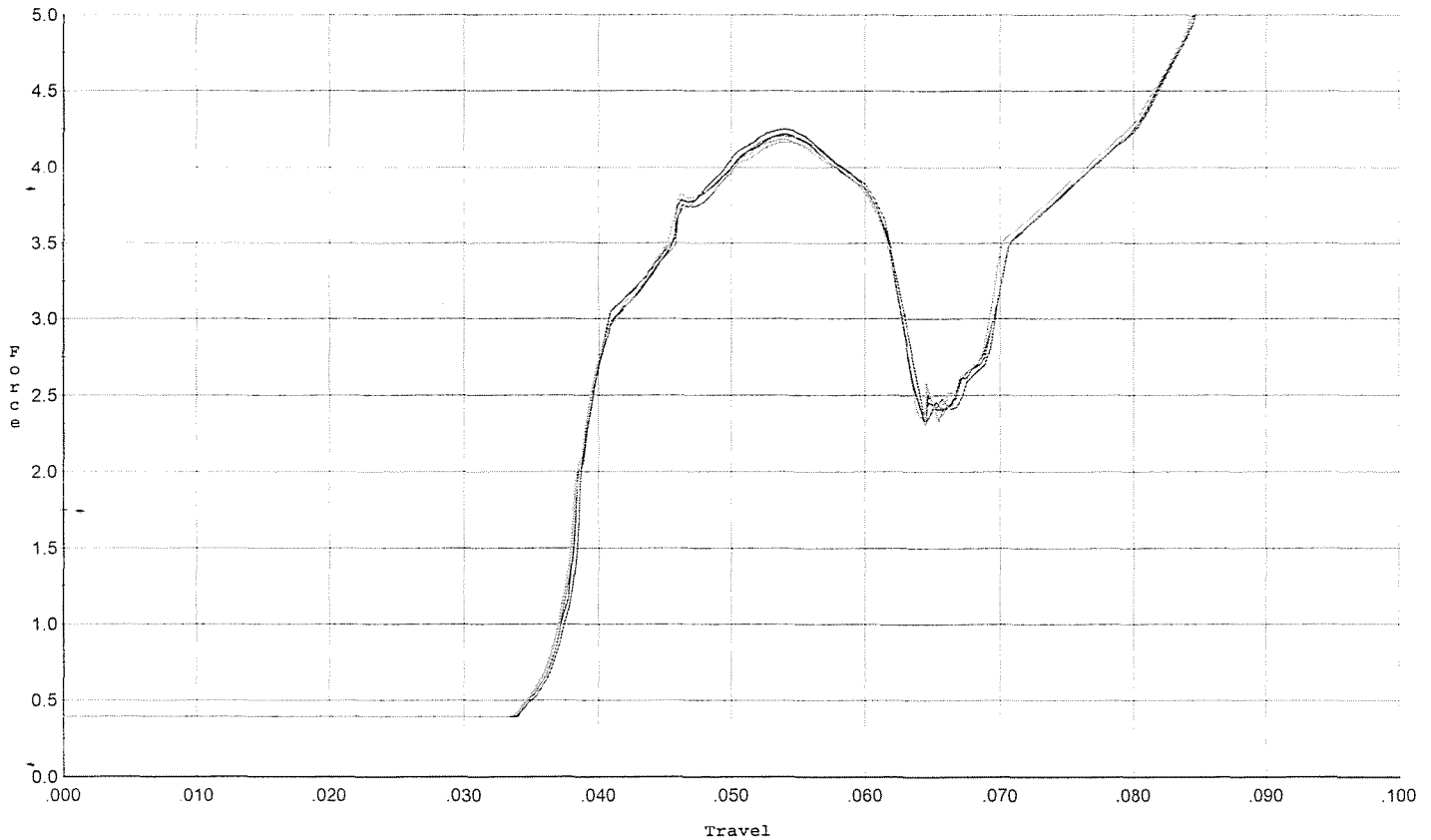
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.833	0.055	0.029	0.029	0.065		Set Trigger
2	2.740	0.054	0.031	0.029	0.063		Set Trigger
3	2.765	0.054	0.031	0.030	0.064		Set Trigger
4	2.758	0.054	0.031	0.029	0.064		Set Trigger
5	2.792	0.054	0.031	0.029	0.064		Set Trigger

A-2.77

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



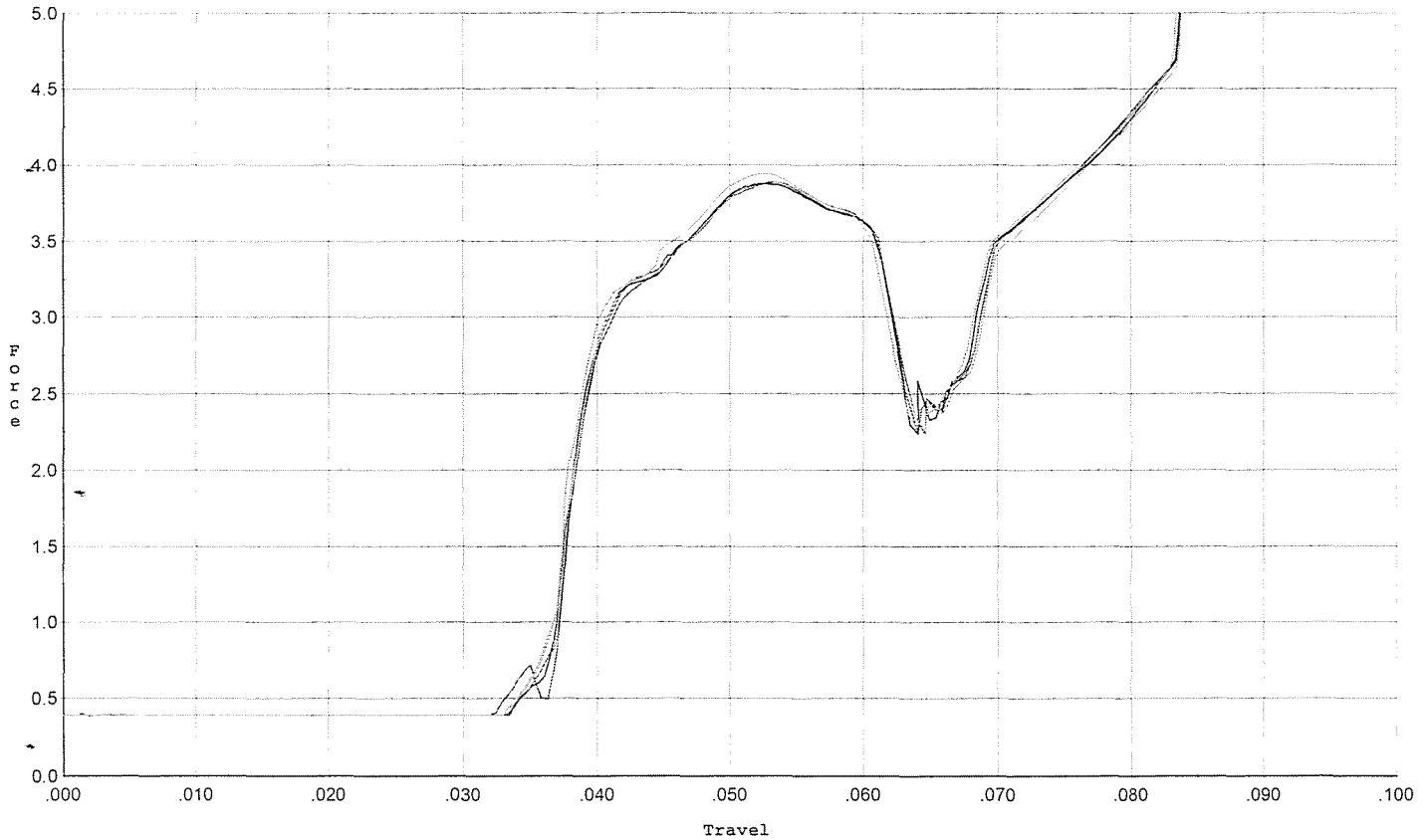
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.249	0.062	0.036	0.027	0.104		Set Trigger
2	4.218	0.062	0.034	0.027	0.103		Set Trigger
3	4.204	0.063	0.034	0.026	0.106		Set Trigger
4	4.167	0.062	0.034	0.026	0.104		Set Trigger
5	4.182	0.062	0.034	0.026	0.104		Set Trigger

A 4.20

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



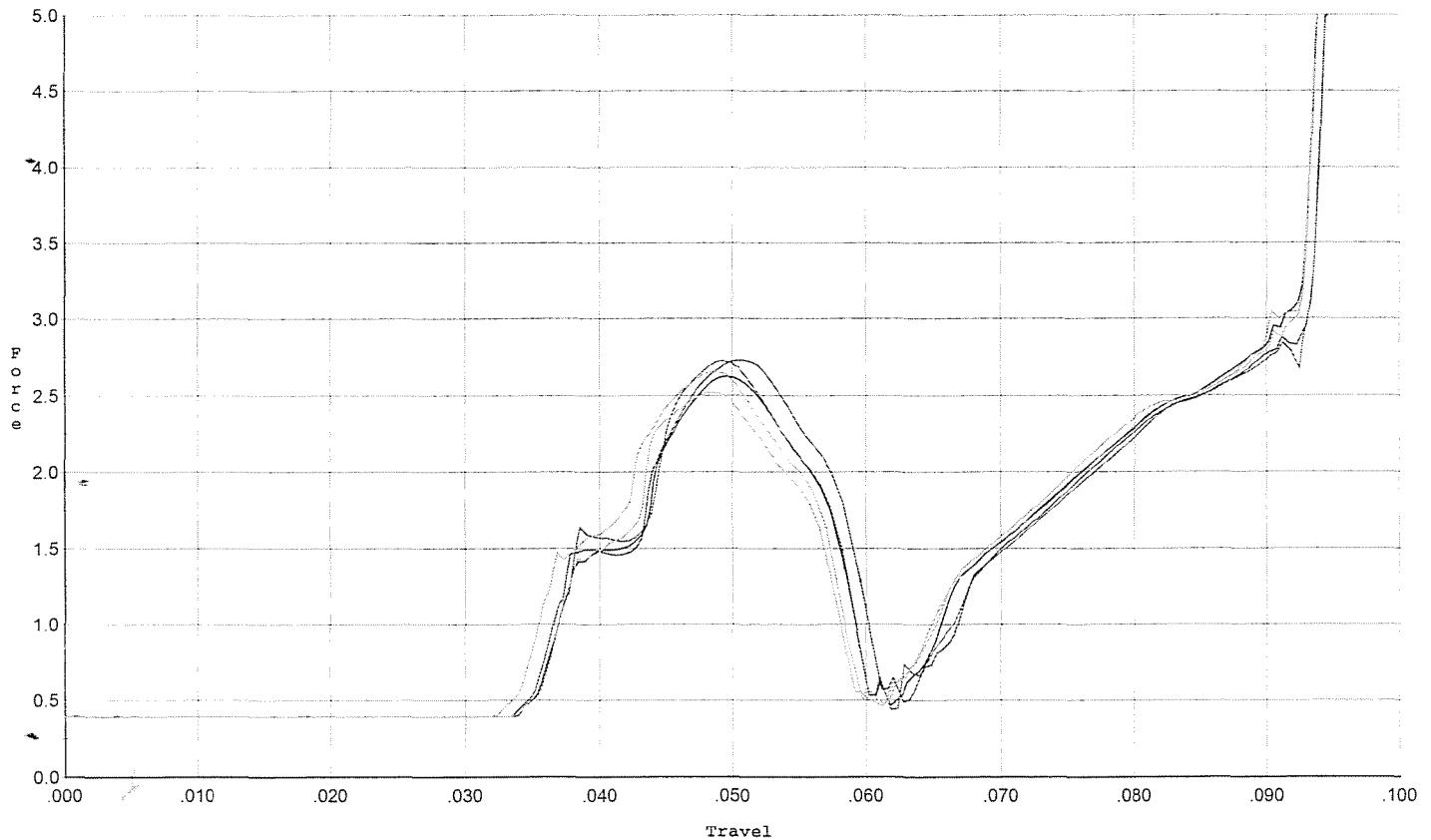
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.887	0.061	0.033	0.026	0.099		Set Trigger
2	3.874	0.061	0.034	0.026	0.099		Set Trigger
3	3.883	0.061	0.034	0.026	0.099		Set Trigger
4	3.892	0.061	0.034	0.026	0.099		Set Trigger
5	3.940	0.061	0.035	0.026	0.099		Set Trigger

A - 3.89

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



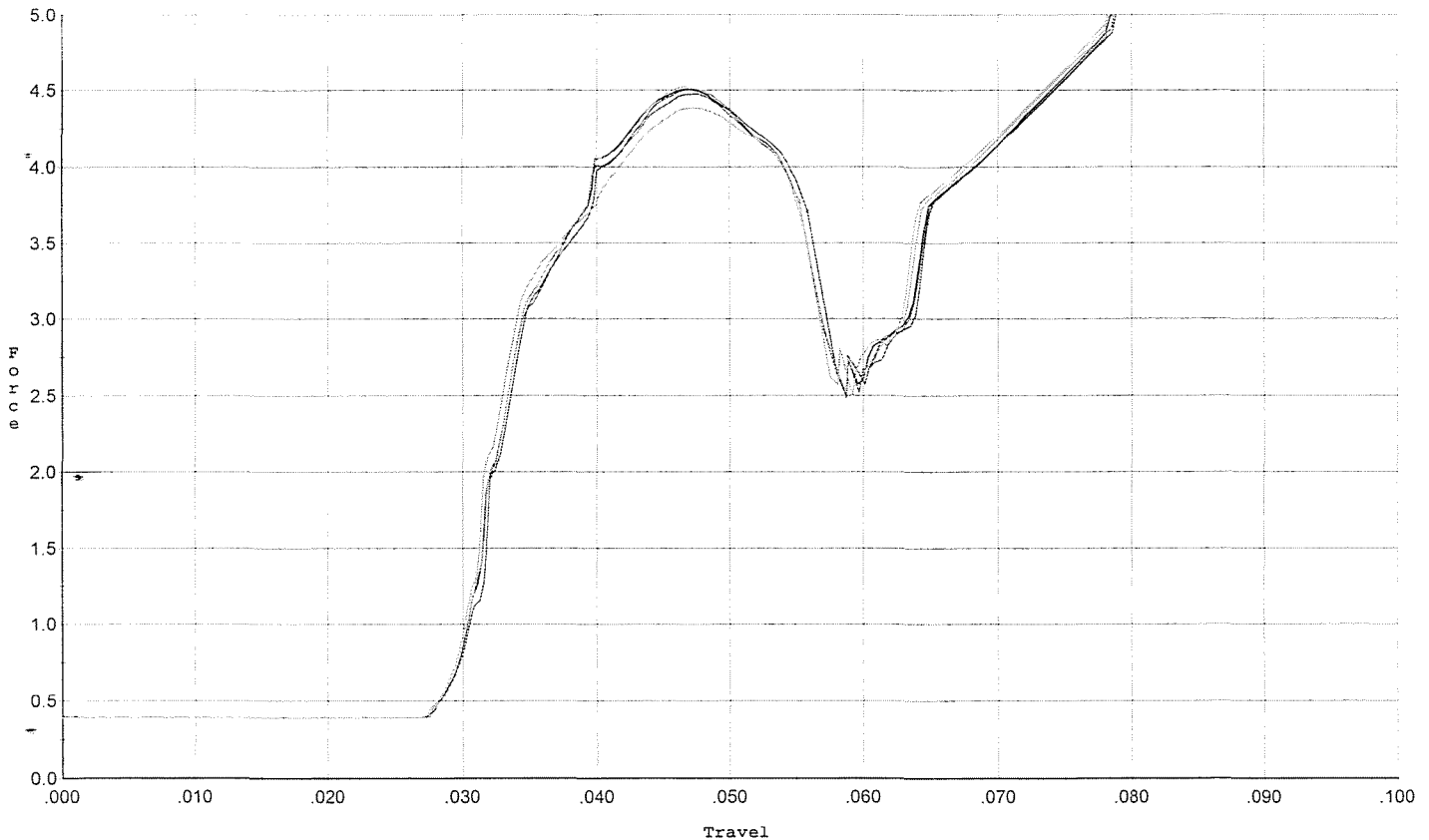
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.731	0.060	0.035	0.041	0.062		Set Trigger
2	2.625	0.058	0.036	0.041	0.058		Set Trigger
3	2.726	0.058	0.036	0.041	0.059		Set Trigger
4	2.521	0.058	0.036	0.042	0.056		Set Trigger
5	2.656	0.057	0.034	0.041	0.059		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.505	0.056	0.028	0.026	0.107		Set Trigger
2	4.506	0.055	0.028	0.026	0.106		Set Trigger
3	4.474	0.055	0.028	0.027	0.106		Set Trigger
4	4.522	0.055	0.028	0.026	0.106		Set Trigger
5	4.385	0.055	0.028	0.026	0.106		Set Trigger

A 4.47