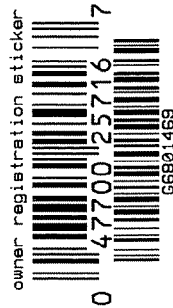
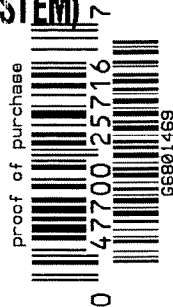


1
G6801469

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

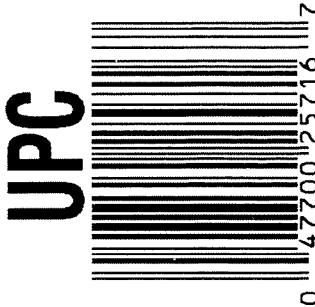
- INSTUCTION BOOK 3518



BM FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801469



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801469

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RJZ
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3-26	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	LJ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	LJ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	LJ
	D) OIL FIRING PIN ASSEMBLY		3-27-09	LJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

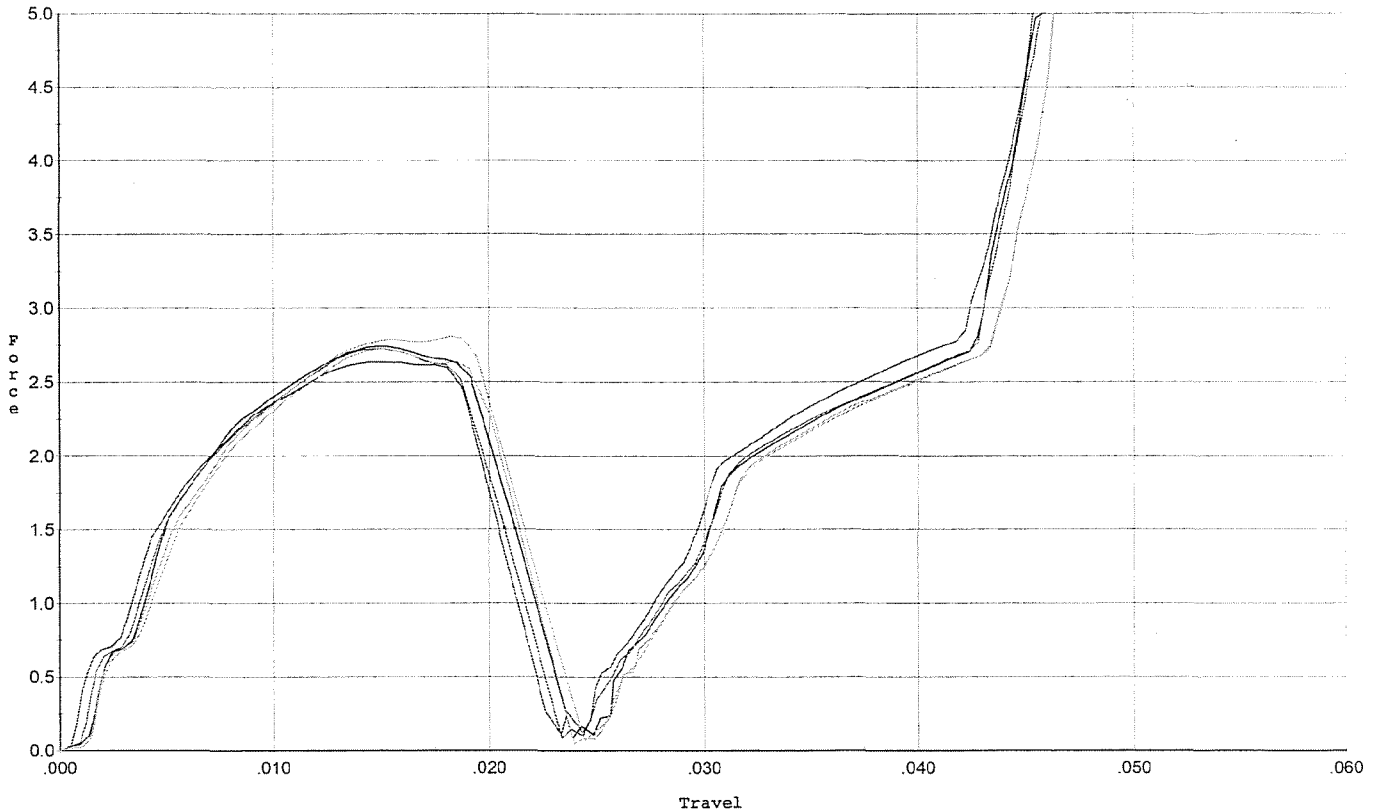
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>0</u> <u>5.5</u> <u>0</u>	3-31-09	WW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-31-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-31-09	WW
	J) ASSEMBLE STOCK		3-27-09	RJ
	K) ASSEMBLE SWIVEL STUDS		3-31-09	WW
	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	3-30-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.51</u> <u>2.47</u> <u>2.29</u> <u>2.24</u>	3-31-09	WW
	C) FUNCTION		3-31-09	WW
690	PACK		5-28-09	WW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



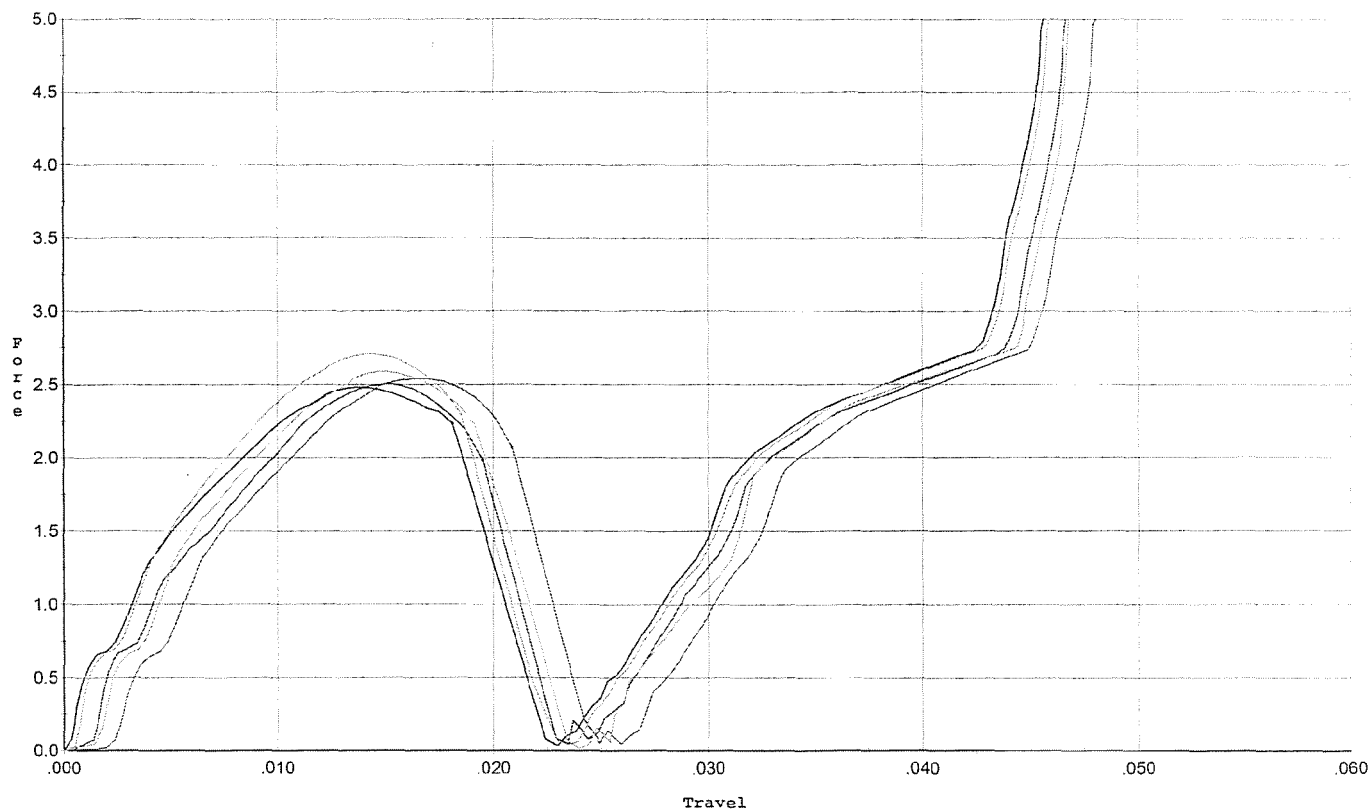
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.634	0.019	0.00	0.030	0.035		Set Trigger
2	2.739	0.021	0.00	0.030	0.039		Set Trigger
3	2.724	0.021	0.00	0.030	0.038		Set Trigger
4	2.720	0.020	0.00	0.030	0.036		Set Trigger
5	2.806	0.019	0.00	0.030	0.036		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



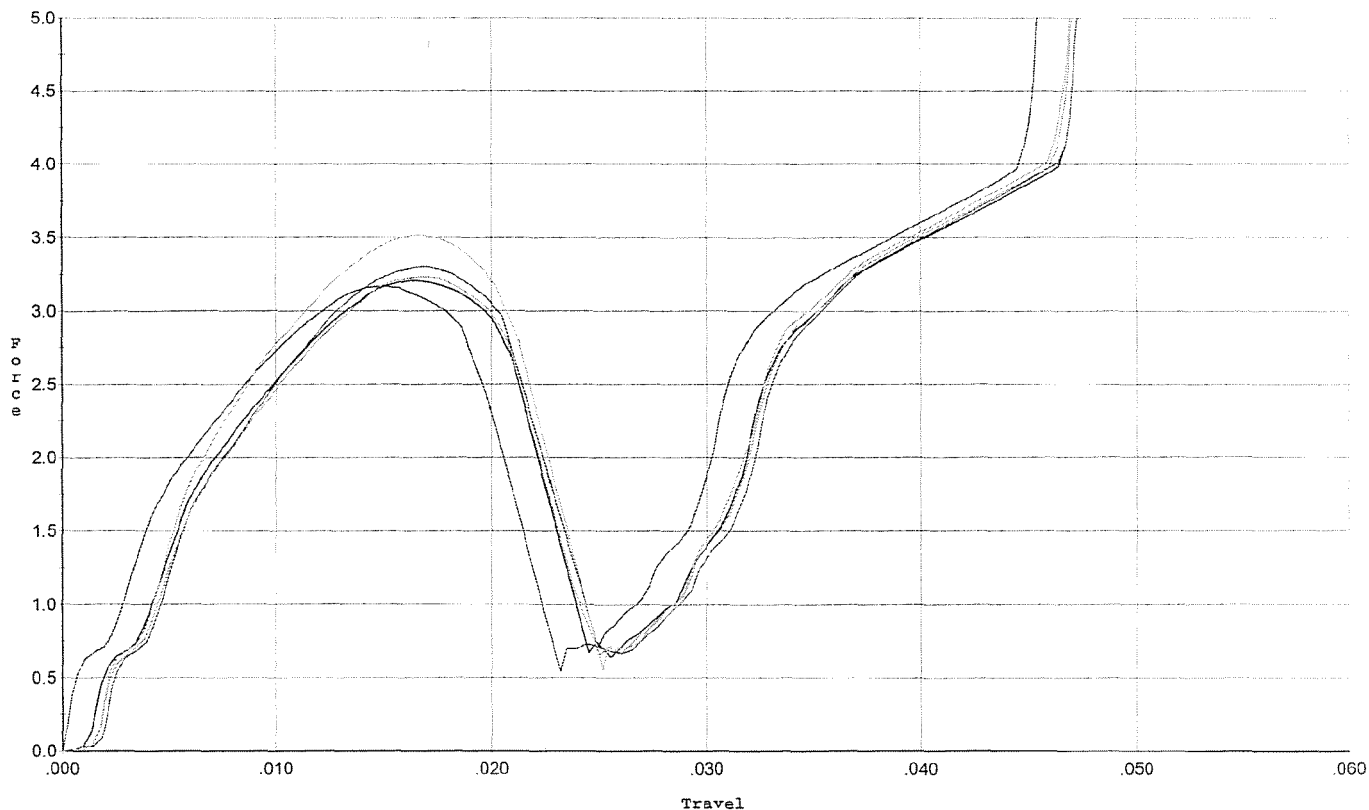
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.019	0.00	0.031	0.032		Set Trigger
2	2.482	0.018	0.00	0.031	0.031		Set Trigger
3	2.542	0.021	0.003	0.032	0.033		Set Trigger
4	2.588	0.021	0.00	0.031	0.035		Set Trigger
5	2.709	0.019	0.00	0.031	0.034		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



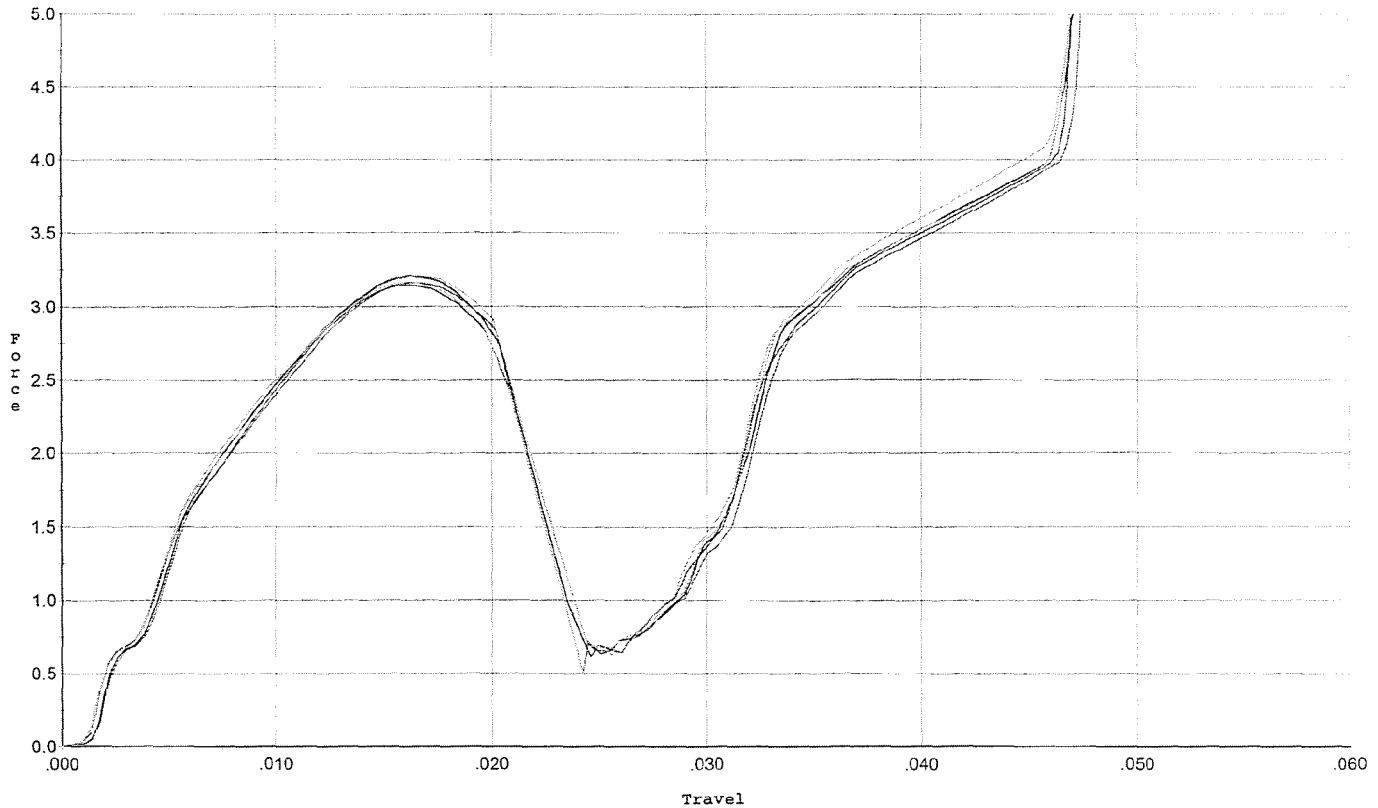
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.165	0.020	0.00	0.029	0.043		Set Trigger
2	3.205	0.021	0.00	0.030	0.043		Set Trigger
3	3.299	0.023	0.00	0.030	0.047		Set Trigger
4	3.519	0.021	0.00	0.029	0.047		Set Trigger
5	3.232	0.021	0.00	0.030	0.042		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



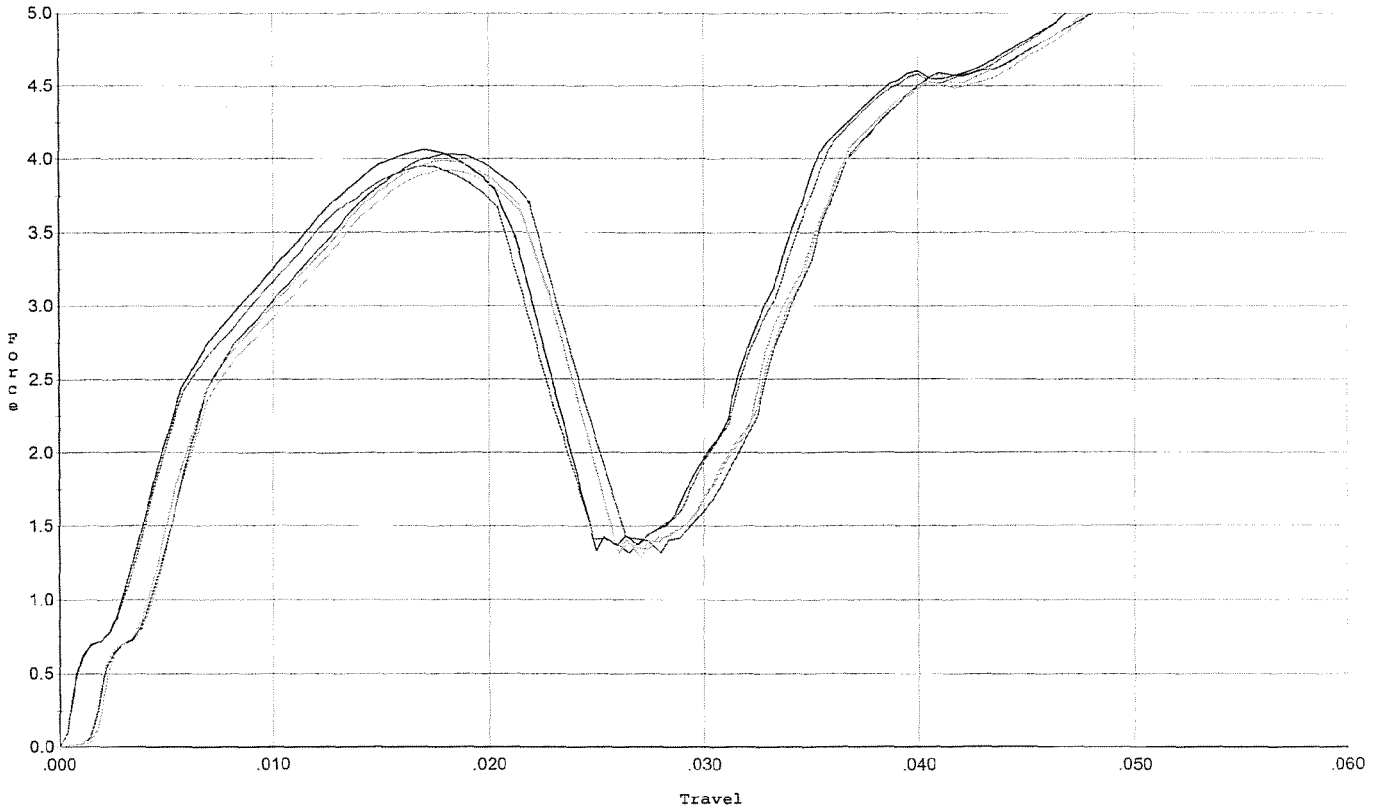
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.148	0.021	0.00	0.030	0.041		Set Trigger
2	3.207	0.020	0.00	0.030	0.041		Set Trigger
3	3.163	0.020	0.00	0.031	0.040		Set Trigger
4	3.169	0.021	0.00	0.030	0.042		Set Trigger
5	3.209	0.020	0.00	0.030	0.041		Set Trigger

A-3.17

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



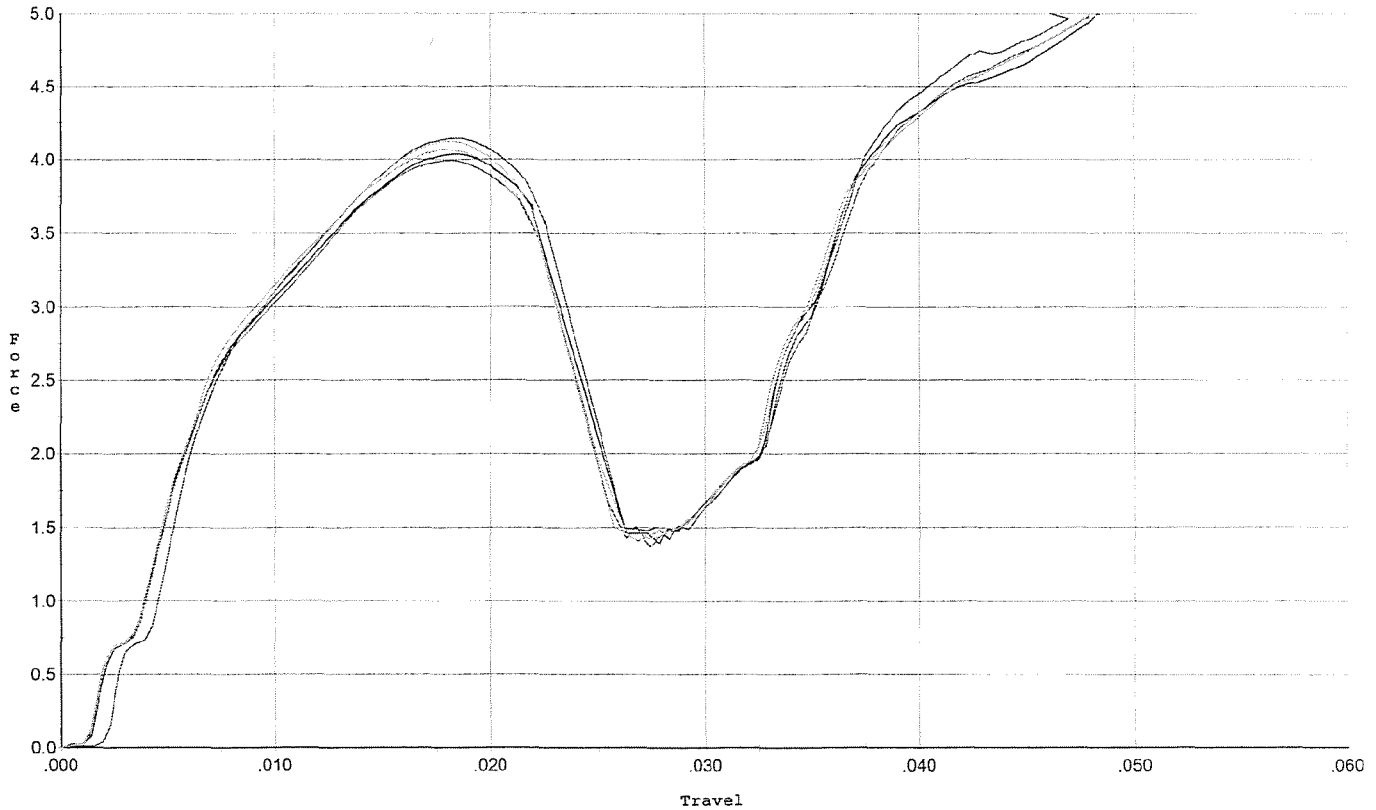
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.031	0.022	0.00	0.028	0.056		Set Trigger
2	4.057	0.021	0.00	0.028	0.057		Set Trigger
3	3.948	0.020	0.00	0.028	0.054		Set Trigger
4	3.925	0.023	0.00	0.028	0.057		Set Trigger
5	3.985	0.023	0.00	0.028	0.058		Set Trigger

A-3.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



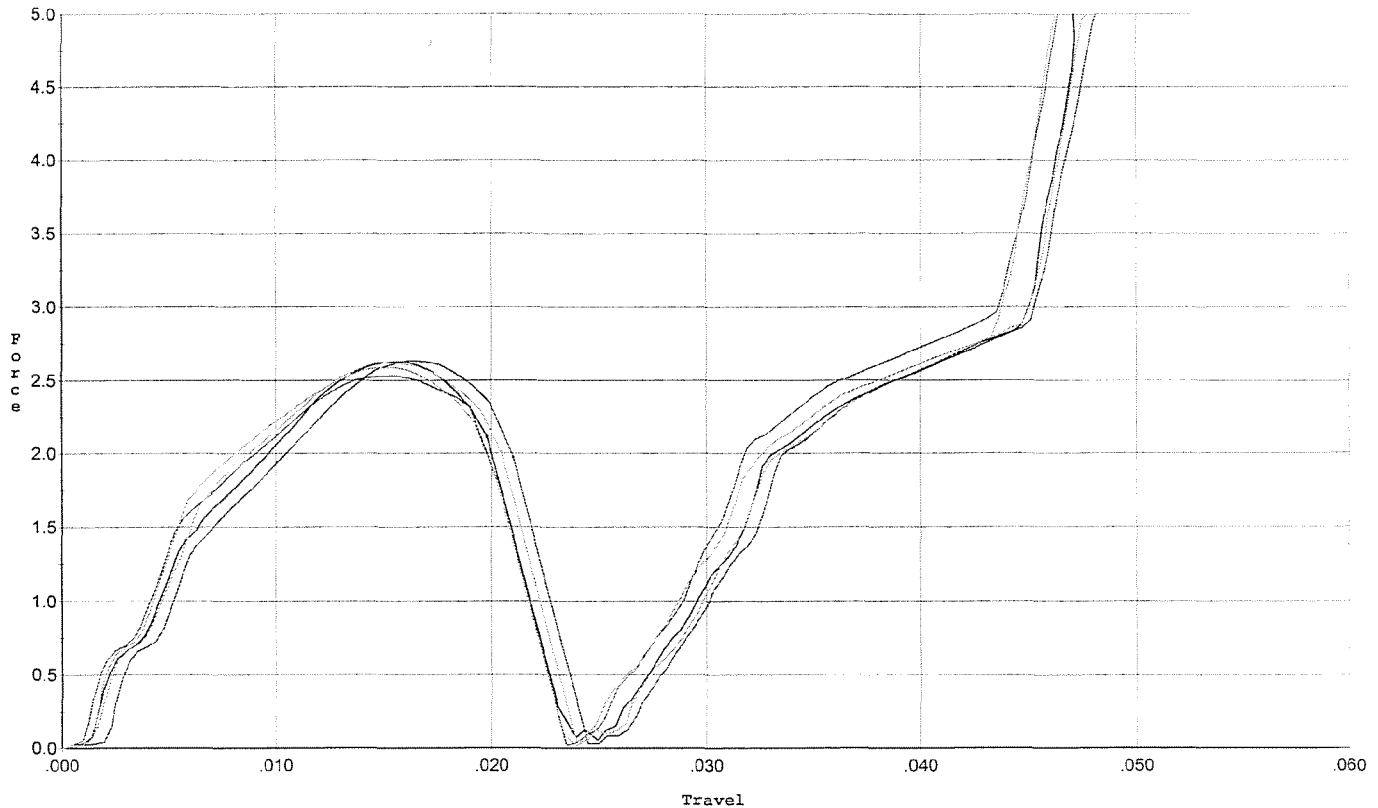
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.143	0.023	0.002	0.028	0.059		Set Trigger
2	4.038	0.022	0.00	0.028	0.057		Set Trigger
3	3.992	0.022	0.00	0.028	0.057		Set Trigger
4	4.125	0.022	0.00	0.028	0.058		Set Trigger
5	4.069	0.022	0.00	0.028	0.058		Set Trigger

A.4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



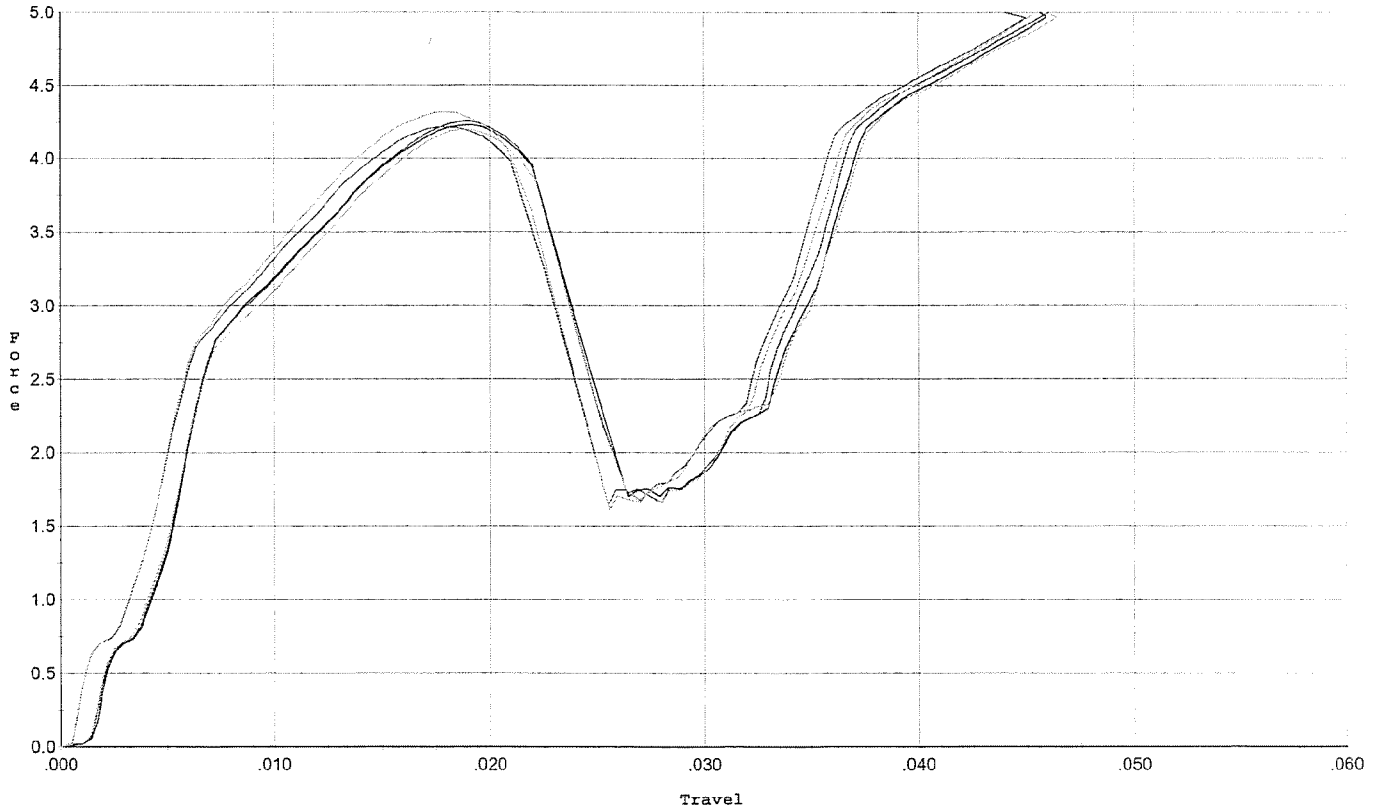
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.631	0.021	0.00	0.032	0.034		Set Trigger
2	2.627	0.020	0.00	0.031	0.033		Set Trigger
3	2.524	0.020	0.00	0.031	0.034		Set Trigger
4	2.621	0.020	0.00	0.032	0.035		Set Trigger
5	2.588	0.020	0.00	0.031	0.035		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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	4.258	0.022	0.00	0.027	0.059		Set Trigger
2	4.229	0.022	0.00	0.027	0.059		Set Trigger
3	4.215	0.023	0.00	0.027	0.063		Set Trigger
4	4.199	0.022	0.00	0.027	0.059		Set Trigger
5	4.318	0.022	0.00	0.027	0.062		Set Trigger

A-4.24