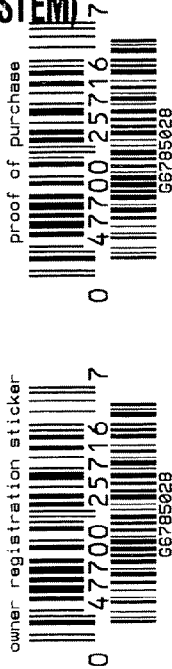


G6785028

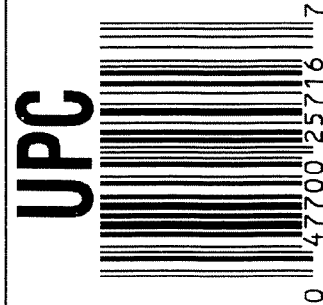
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6785028	



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6785028

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	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		9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		9-30-08	SP
480	MAGNAFLUX BBL ACTION	MAGNA - FLUX 2000 OPERATOR	10/2/08	SP
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 2	
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		11-3-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

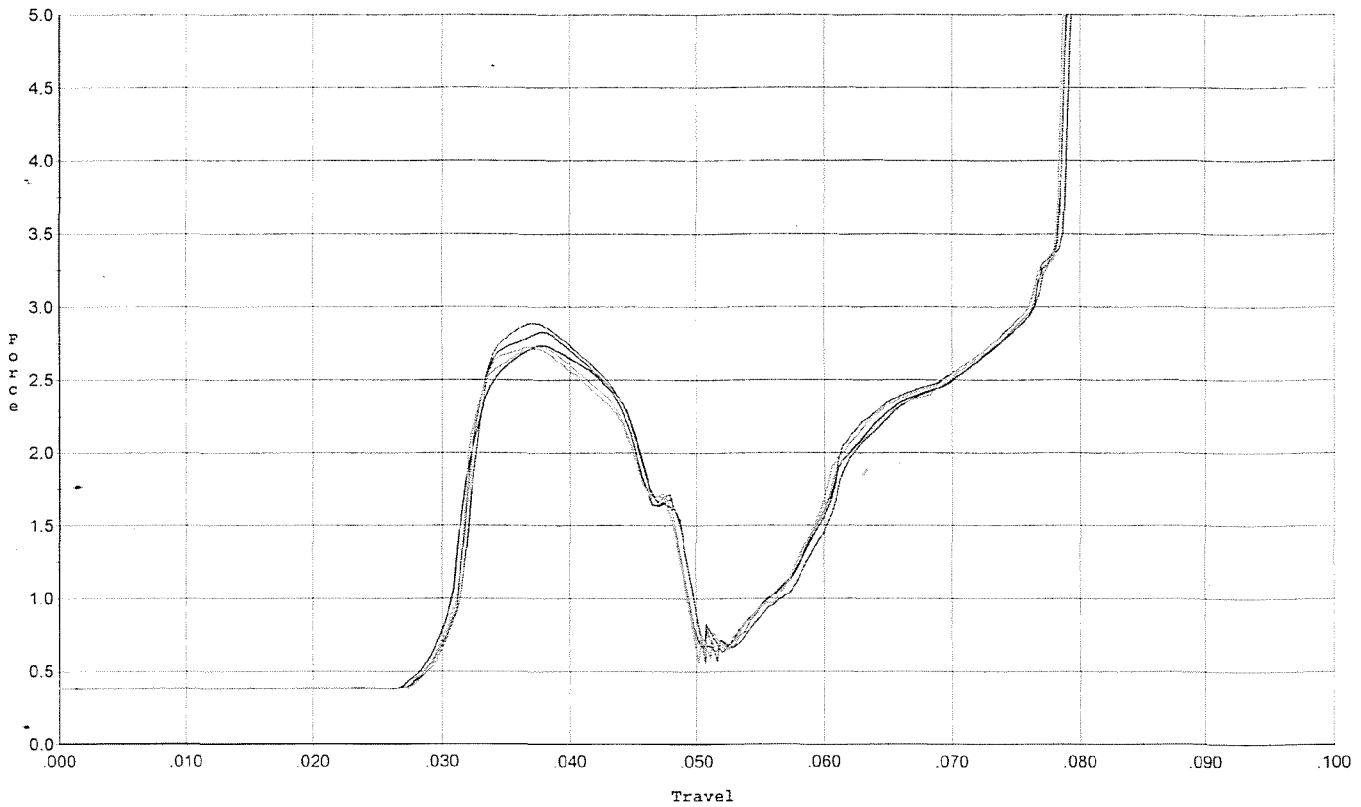
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	11-11-08	298
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-11-08	290
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	290
	J) ASSEMBLE STOCK		11-03-08	RSD
	K) ASSEMBLE SWIVEL STUDS		11-11-08	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	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	RSD
670	FINAL INSPECTION A) HEADSPACE		11-11-08	290
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.45</u> <u>2.54</u> <u>2.40</u> <u>2.41</u>	11-6-08	TC
	C) FUNCTION		11-11-08	290
690	PACK		11/12/08	Fuj

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/28/2008

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



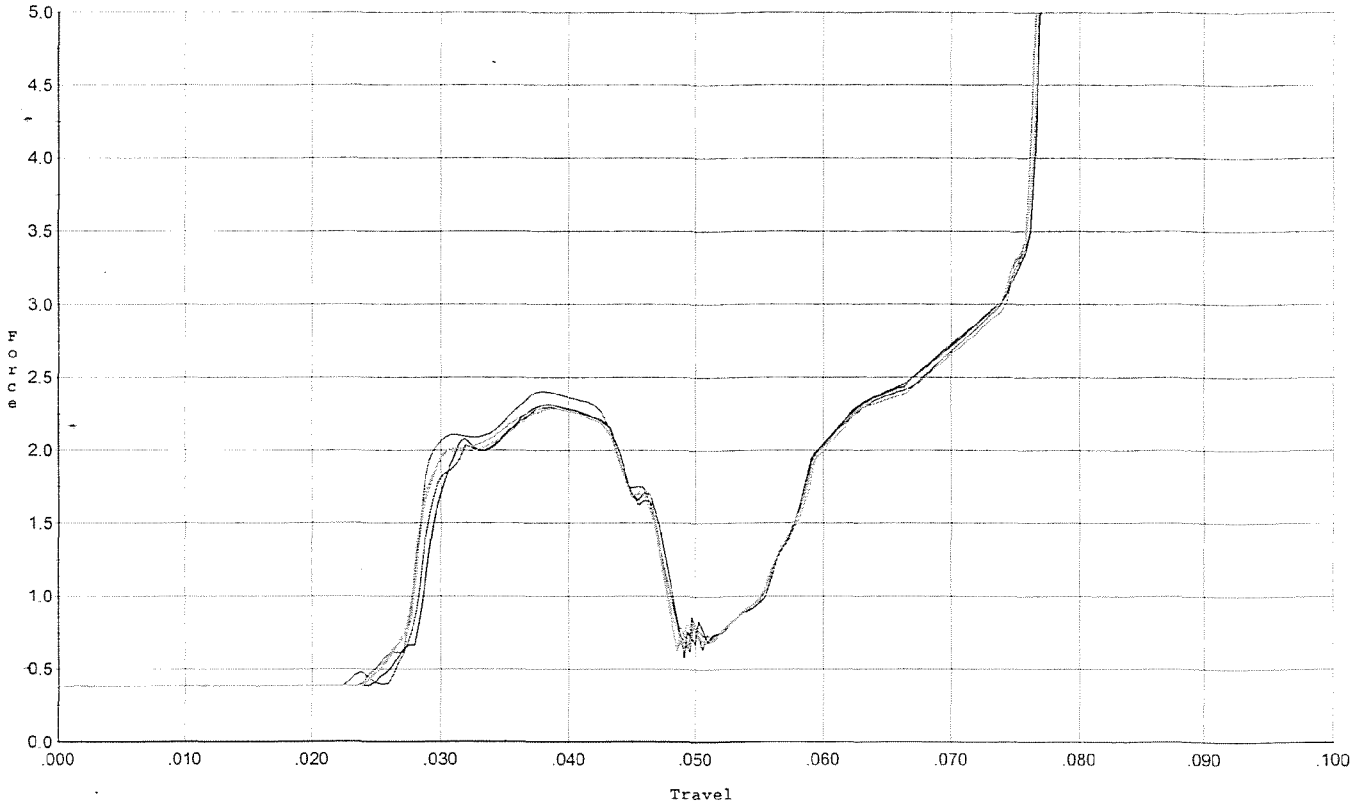
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.829	0.049	0.030	0.034	0.053		Set Trigger
2	2.739	0.048	0.029	0.034	0.052		Set Trigger
3	2.889	0.049	0.030	0.034	0.054		Set Trigger
4	2.732	0.048	0.030	0.034	0.052		Set Trigger
5	2.718	0.048	0.030	0.034	0.051		Set Trigger

A-2.78

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/28/2008

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



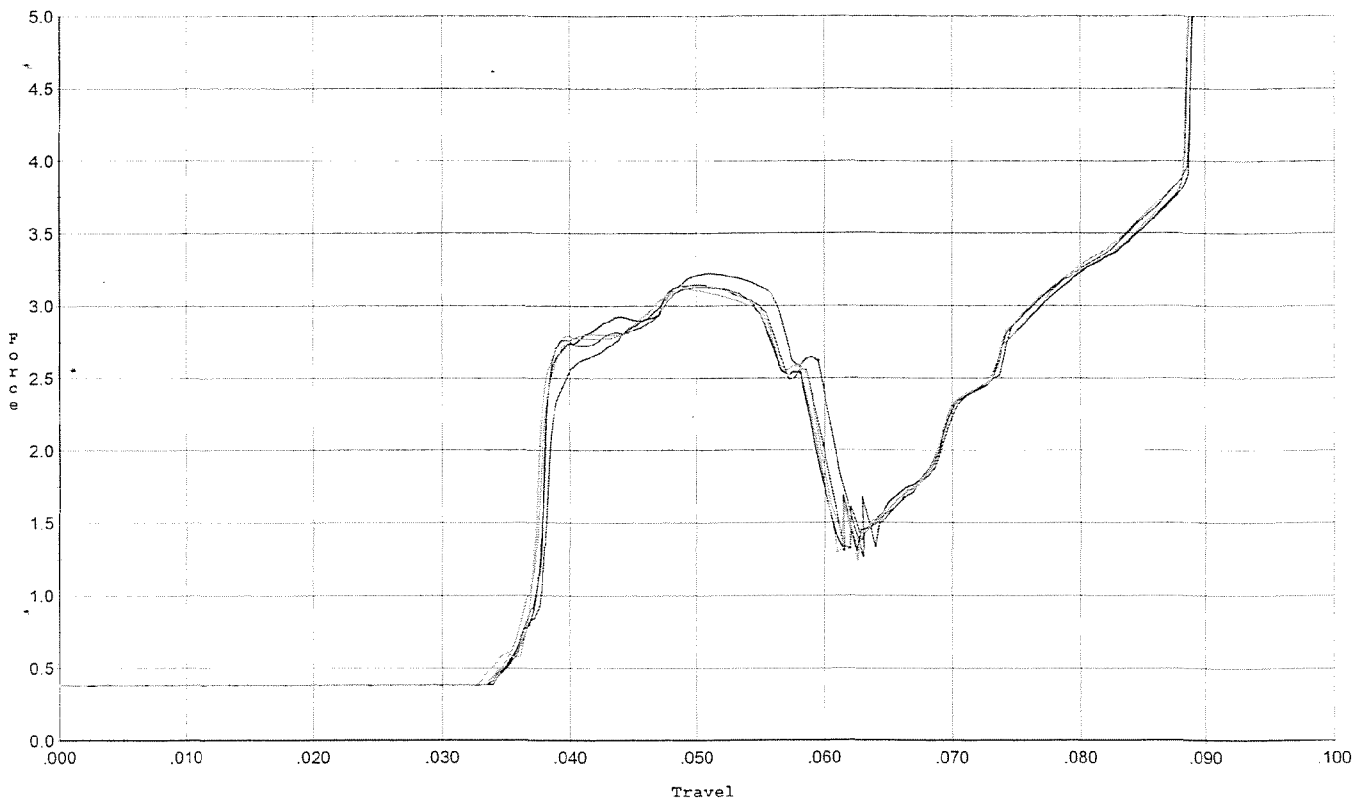
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.296	0.047	0.026	0.034	0.048		Set Trigger
2	2.315	0.047	0.027	0.034	0.049		Set Trigger
3	2.405	0.047	0.027	0.034	0.051		Set Trigger
4	2.287	0.046	0.027	0.034	0.049		Set Trigger
5	2.286	0.047	0.026	0.034	0.050		Set Trigger

A-2-31

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/28/2008

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



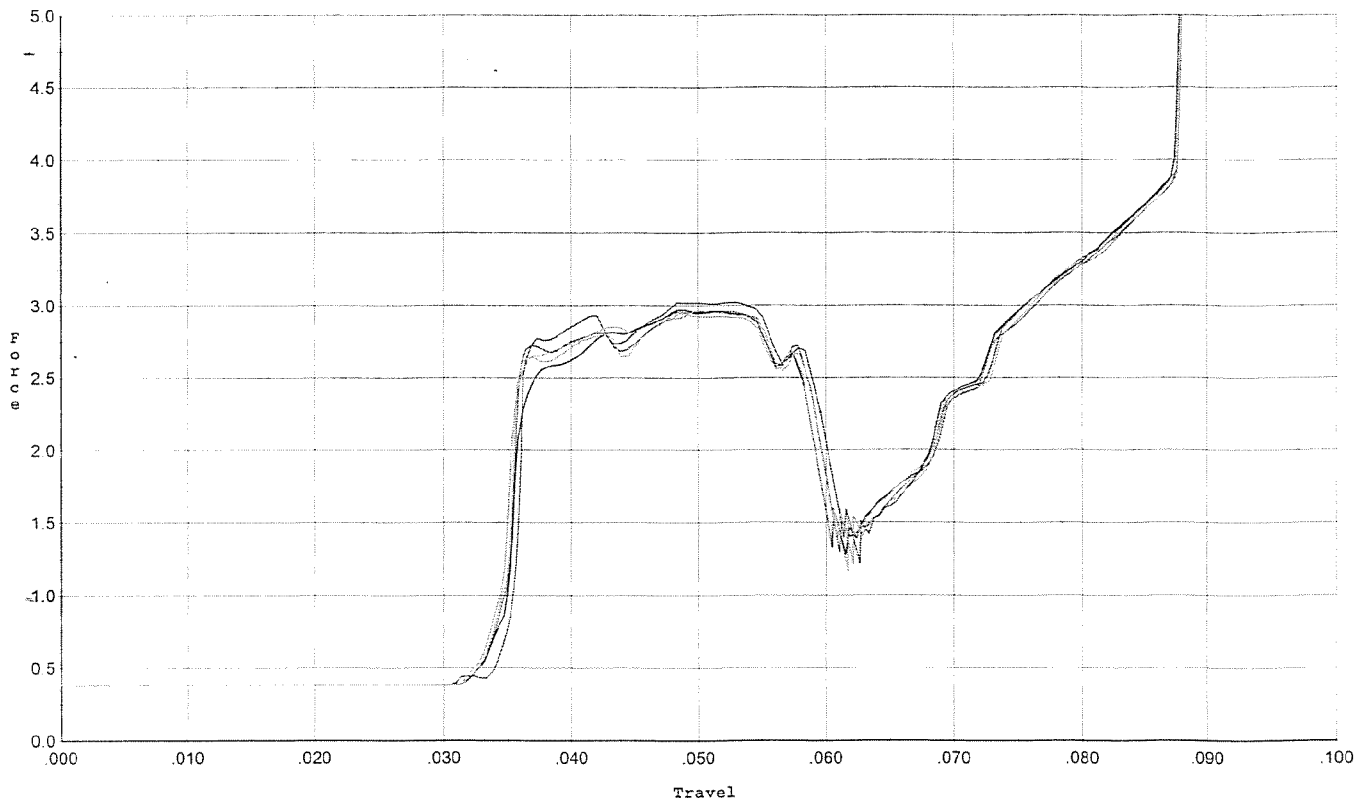
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.060	0.034	0.034	0.078		Set Trigger
2	3.145	0.058	0.036	0.036	0.075		Set Trigger
3	3.127	0.060	0.036	0.035	0.078		Set Trigger
4	3.142	0.059	0.036	0.035	0.077		Set Trigger
5	3.118	0.059	0.035	0.035	0.077		Set Trigger

A-3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/28/2008

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



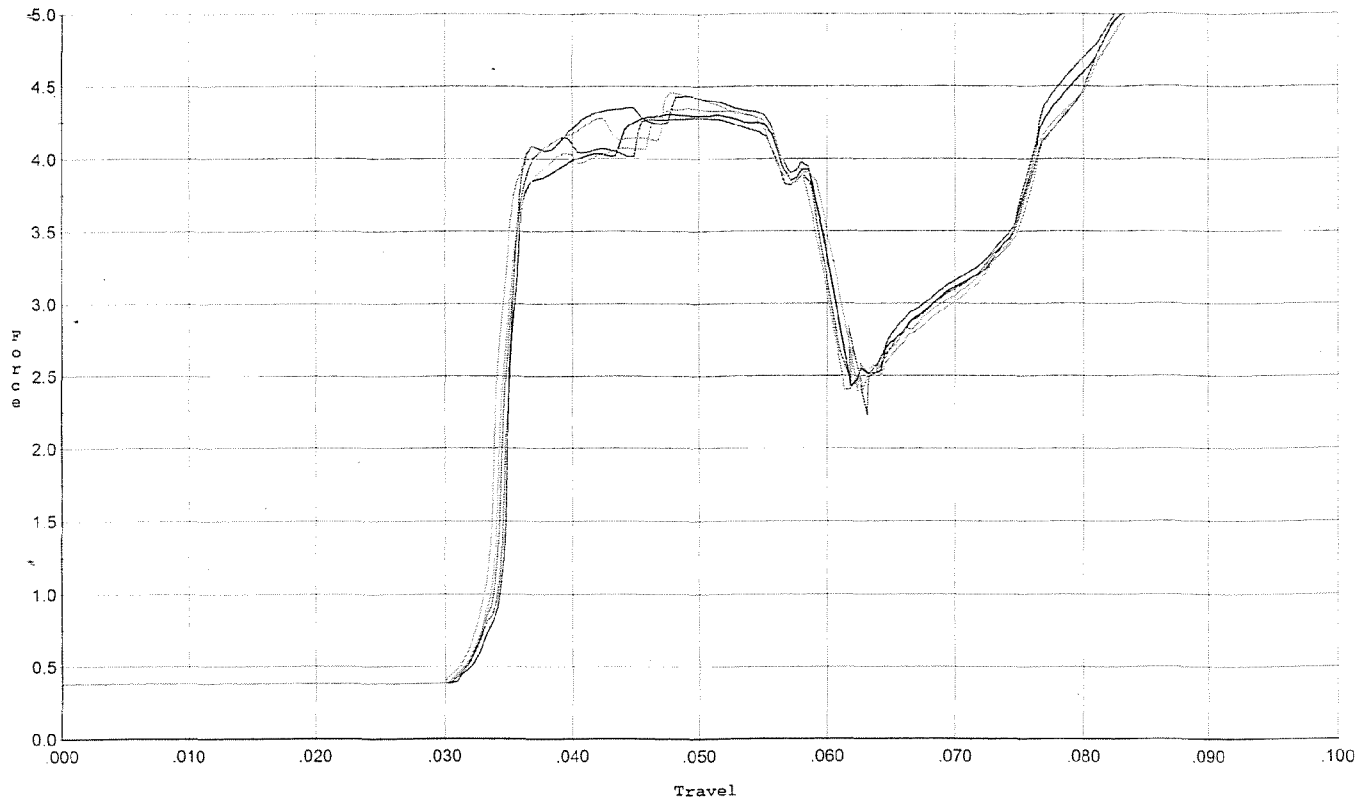
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.022	0.060	0.034	0.034	0.082		Set Trigger
2	2.968	0.058	0.034	0.034	0.078		Set Trigger
3	2.961	0.059	0.033	0.034	0.080		Set Trigger
4	2.945	0.058	0.033	0.034	0.078		Set Trigger
5	2.966	0.059	0.032	0.034	0.081		Set Trigger

A-297

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/28/2008

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



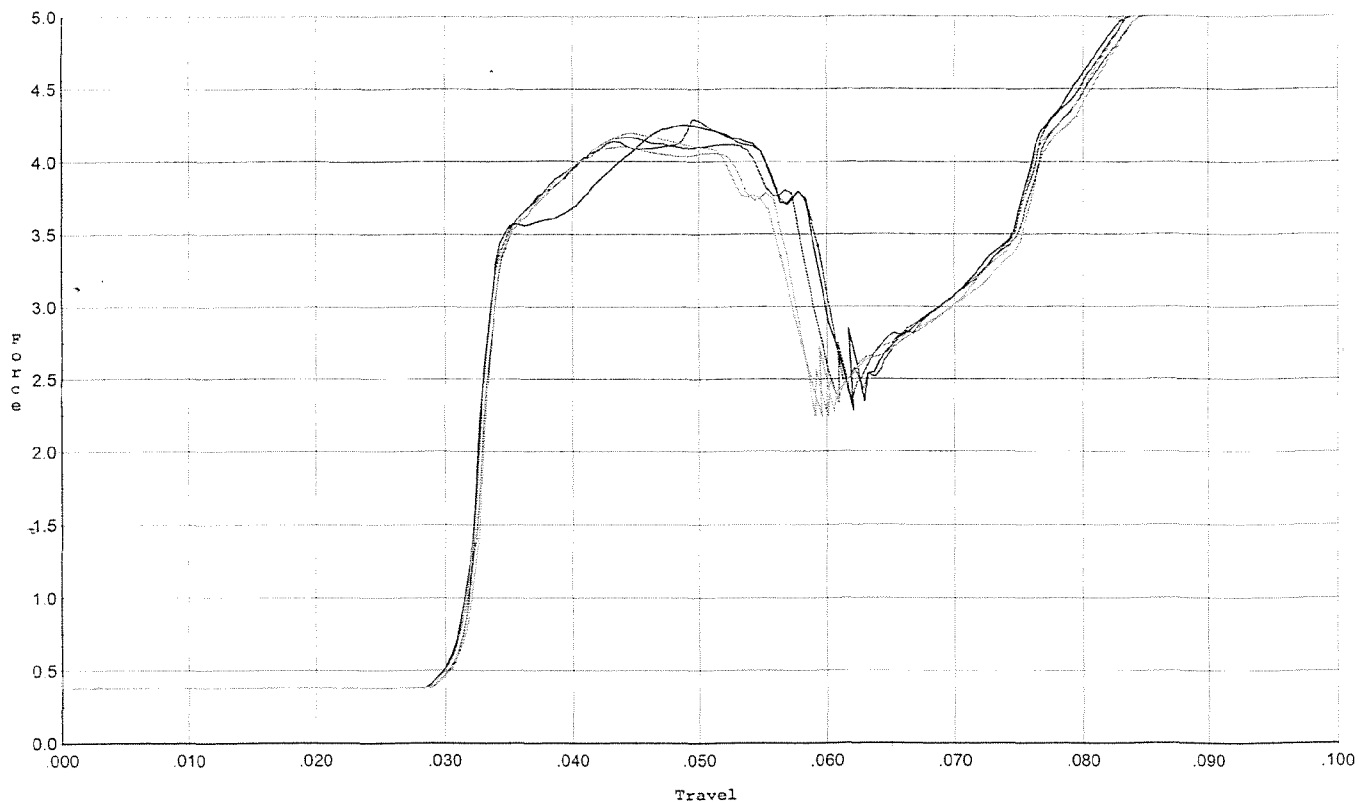
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.431	0.060	0.032	0.032	0.118		Set Trigger
2	4.308	0.060	0.033	0.032	0.115		Set Trigger
3	4.280	0.059	0.032	0.033	0.114		Set Trigger
4	4.350	0.060	0.032	0.032	0.119		Set Trigger
5	4.456	0.059	0.032	0.032	0.118		Set Trigger

A-436

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/28/2008

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



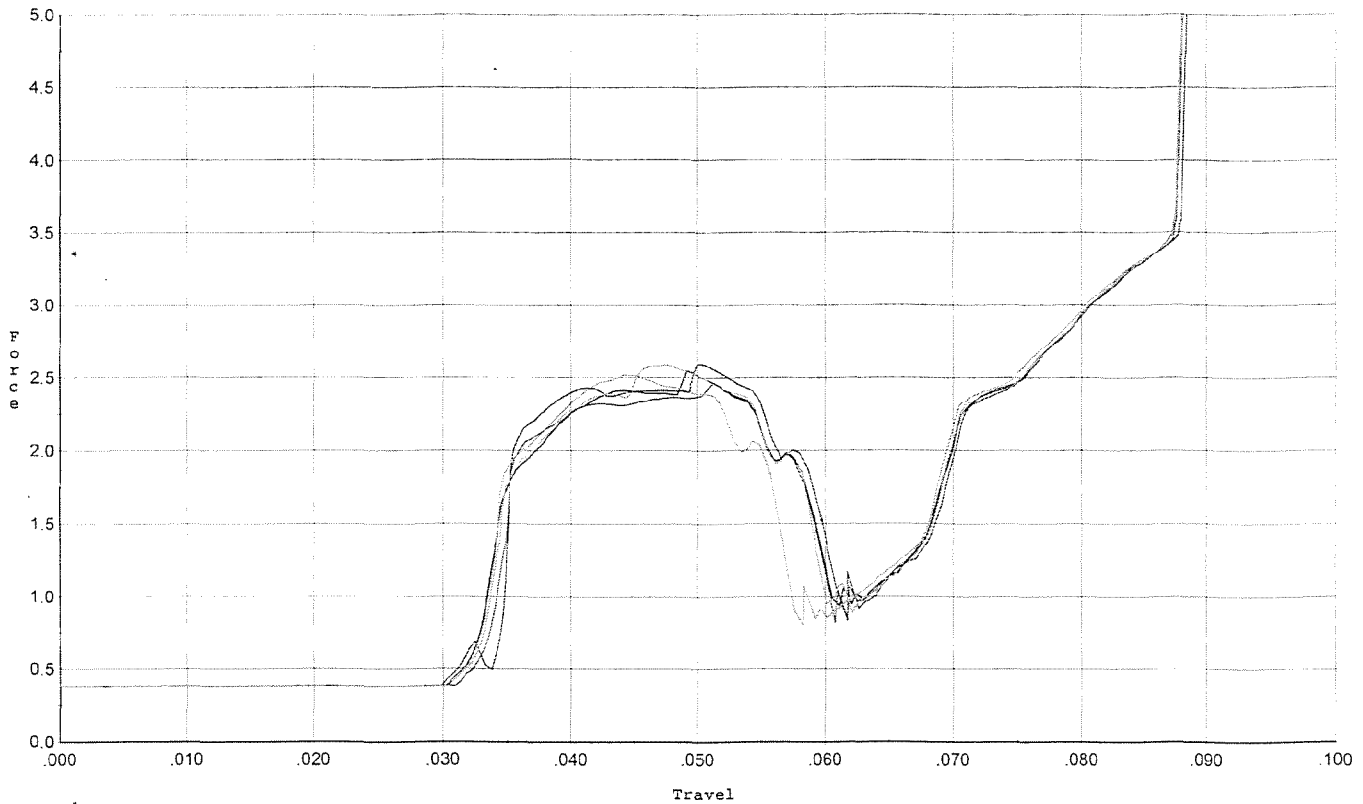
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.291	0.059	0.031	0.032	0.118		Set Trigger
2	4.255	0.058	0.030	0.032	0.114		Set Trigger
3	4.166	0.057	0.031	0.033	0.110		Set Trigger
4	4.196	0.056	0.031	0.033	0.106		Set Trigger
5	4.104	0.057	0.031	0.033	0.106		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/28/2008

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



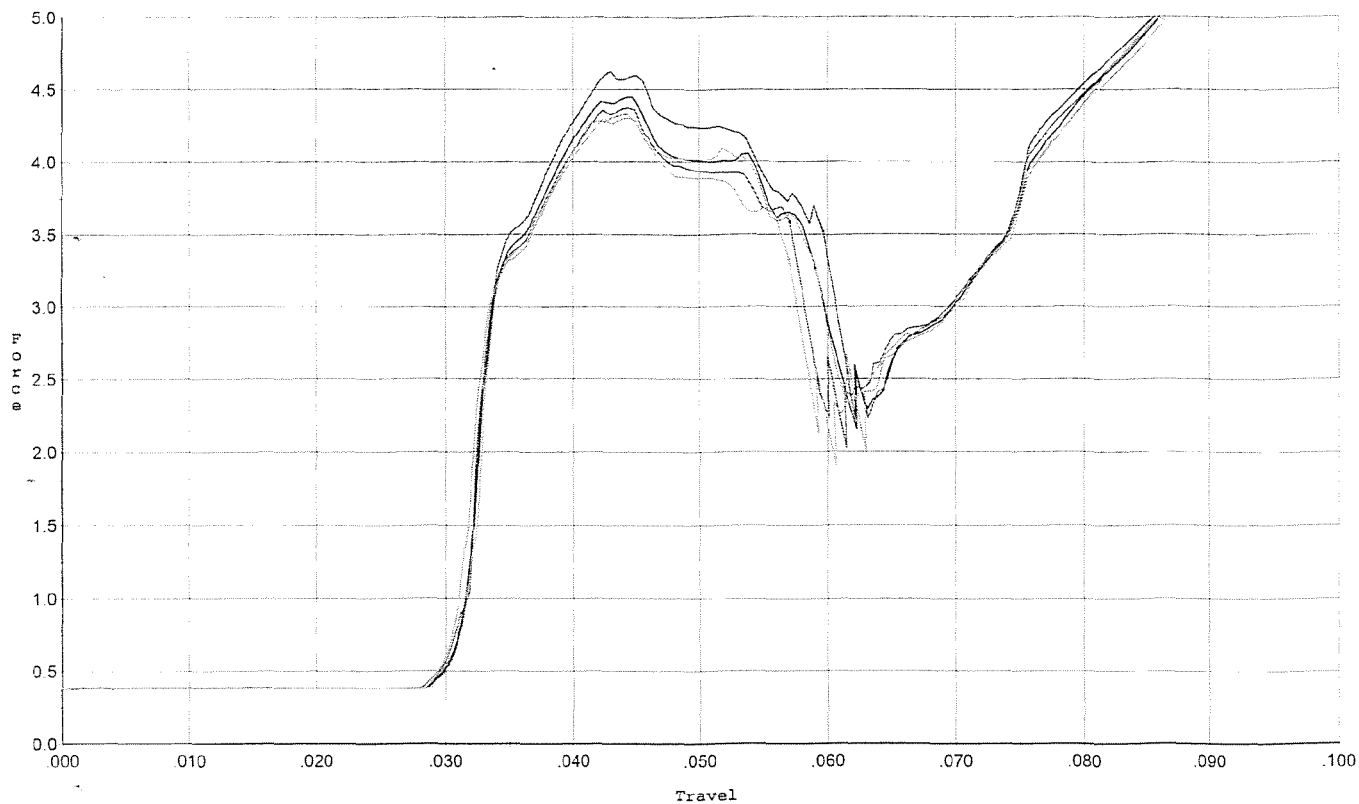
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.595	0.060	0.032	0.035	0.071		Set Trigger
2	2.548	0.059	0.031	0.034	0.069		Set Trigger
3	2.464	0.059	0.033	0.034	0.068		Set Trigger
4	2.587	0.058	0.033	0.035	0.068		Set Trigger
5	2.518	0.056	0.031	0.036	0.063		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/28/2008

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	4.623	0.060	0.030	0.031	0.123		Set Trigger
2	4.446	0.059	0.031	0.032	0.116		Set Trigger
3	4.374	0.057	0.031	0.032	0.109		Set Trigger
4	4.298	0.057	0.031	0.033	0.106		Set Trigger
5	4.328	0.059	0.030	0.031	0.116		Set Trigger

A 4.41