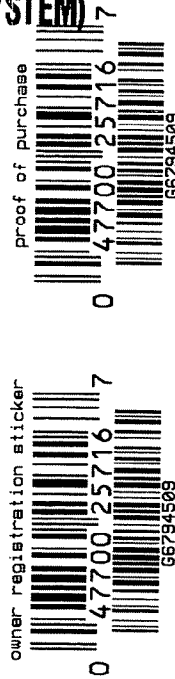


G-6794569

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

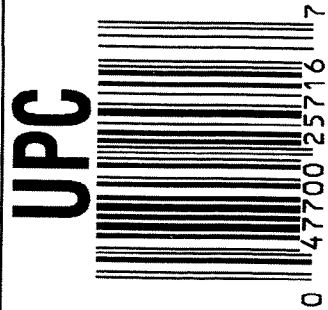
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794509



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 679 4509

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE		11-4-08	RIC
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	KA
490	MAGNAFLUX BOLT		11/3/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-18-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			

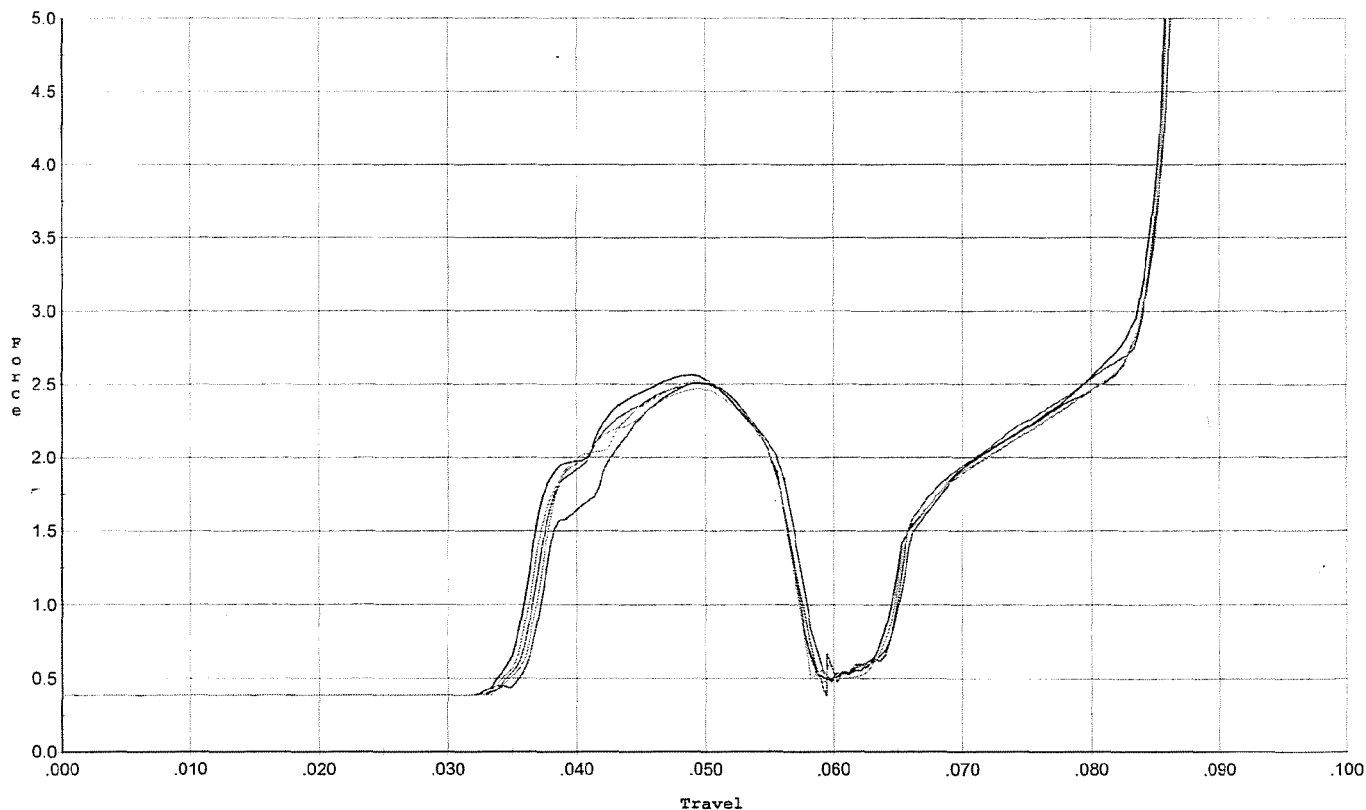
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.8</u> <u>3.5</u> <u>4.0</u>	11-20-08	L.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	11-20-08	L.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-20-08	L.D.
	J) ASSEMBLE STOCK		11-18-08	L.D.
	K) ASSEMBLE SWIVEL STUDS		11-20-08	L.D.
	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	11-19-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	L.D.
670	FINAL INSPECTION A) HEADSPACE		11-20-08	L.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.30</u> <u>2.33</u> <u>2.32</u> <u>2.36</u>	11-20-08	TL
	C) FUNCTION		11-20-08	L.D.
690	PACK		12-2-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



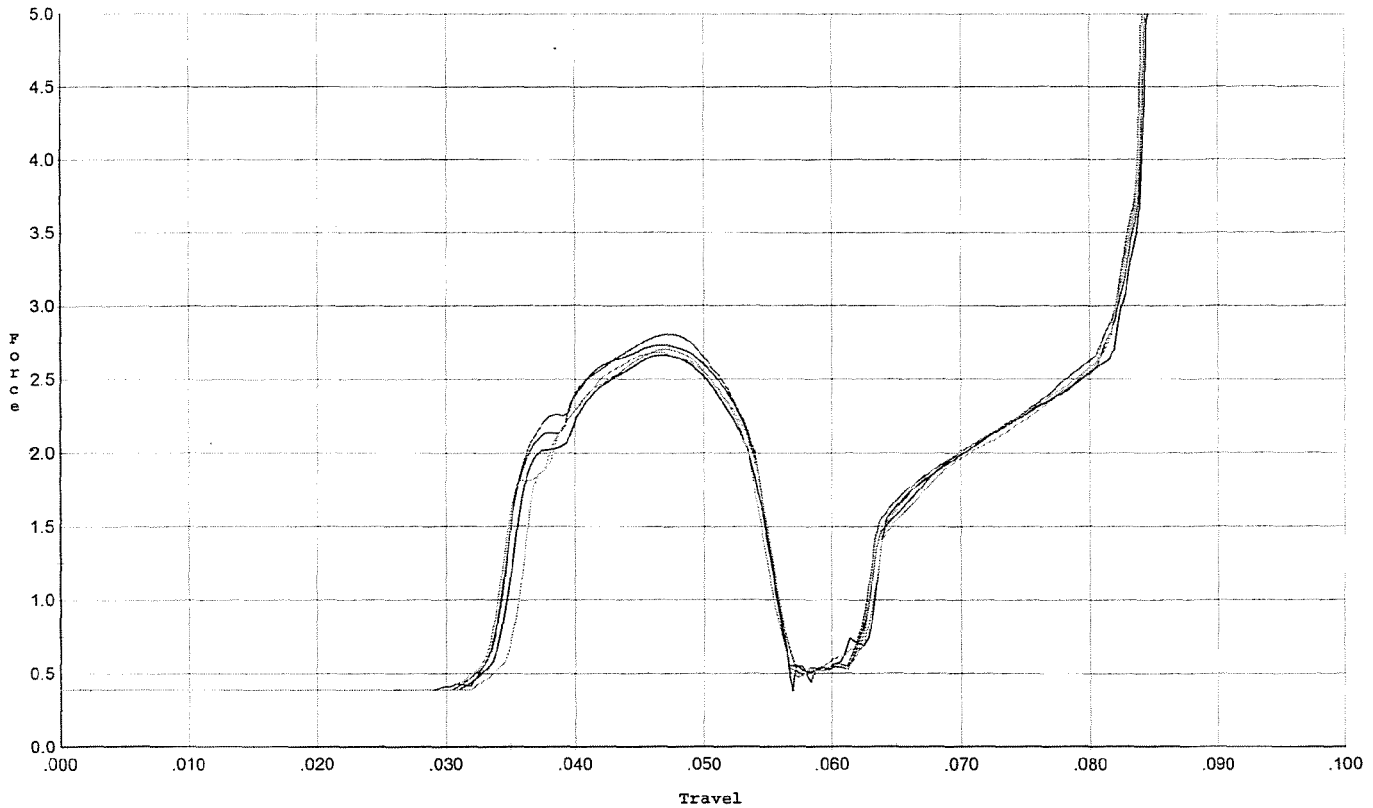
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.056	0.036	0.036	0.055		Set Trigger
2	2.564	0.056	0.034	0.036	0.059		Set Trigger
3	2.507	0.056	0.036	0.036	0.057		Set Trigger
4	2.527	0.056	0.035	0.036	0.057		Set Trigger
5	2.469	0.056	0.036	0.036	0.056		Set Trigger

A-2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



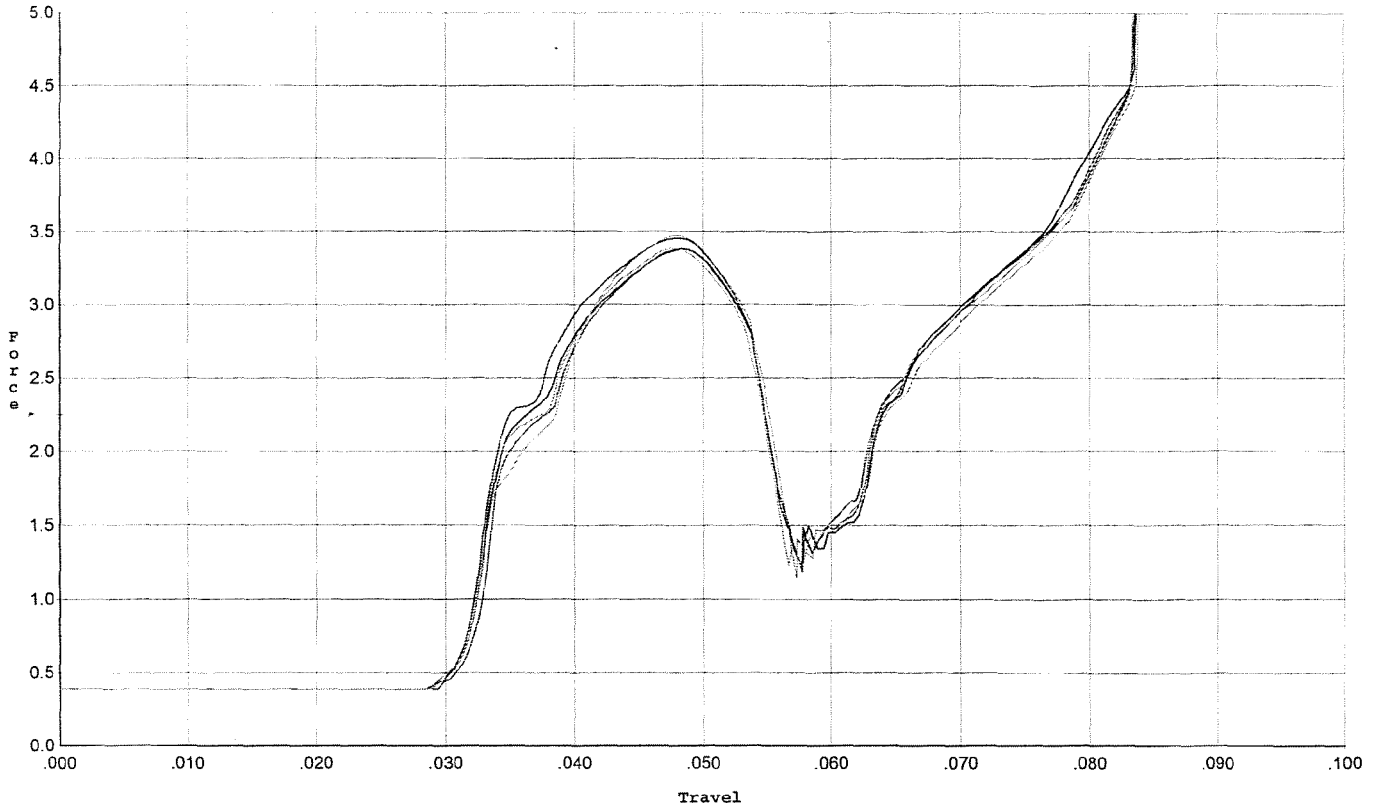
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.729	0.054	0.033	0.035	0.061		Set Trigger
2	2.664	0.055	0.034	0.035	0.059		Set Trigger
3	2.804	0.054	0.033	0.035	0.062		Set Trigger
4	2.681	0.054	0.035	0.036	0.058		Set Trigger
5	2.702	0.053	0.033	0.035	0.059		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



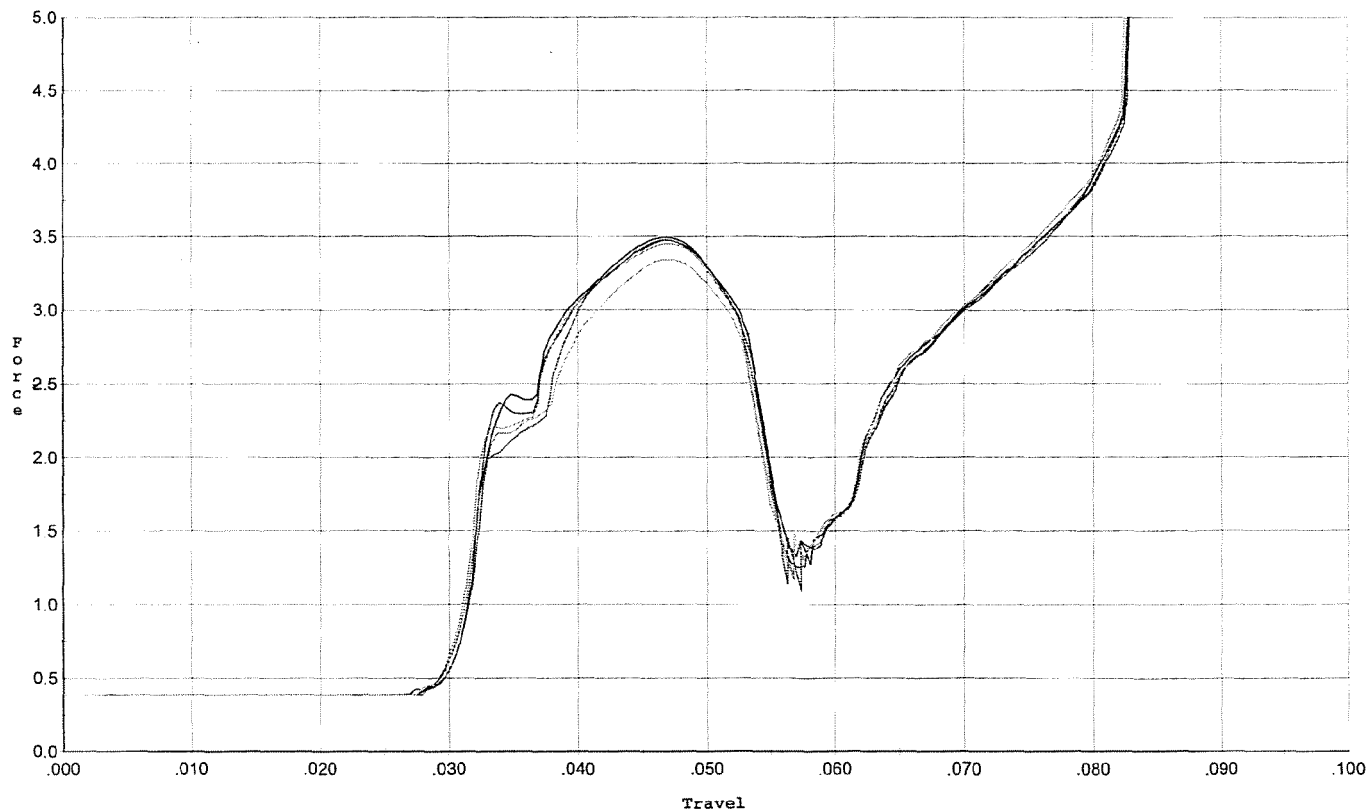
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.455	0.054	0.031	0.033	0.076		Set Trigger
2	3.383	0.054	0.031	0.033	0.074		Set Trigger
3	3.385	0.054	0.032	0.033	0.073		Set Trigger
4	3.386	0.054	0.031	0.033	0.073		Set Trigger
5	3.476	0.055	0.032	0.033	0.076		Set Trigger

A-3-41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



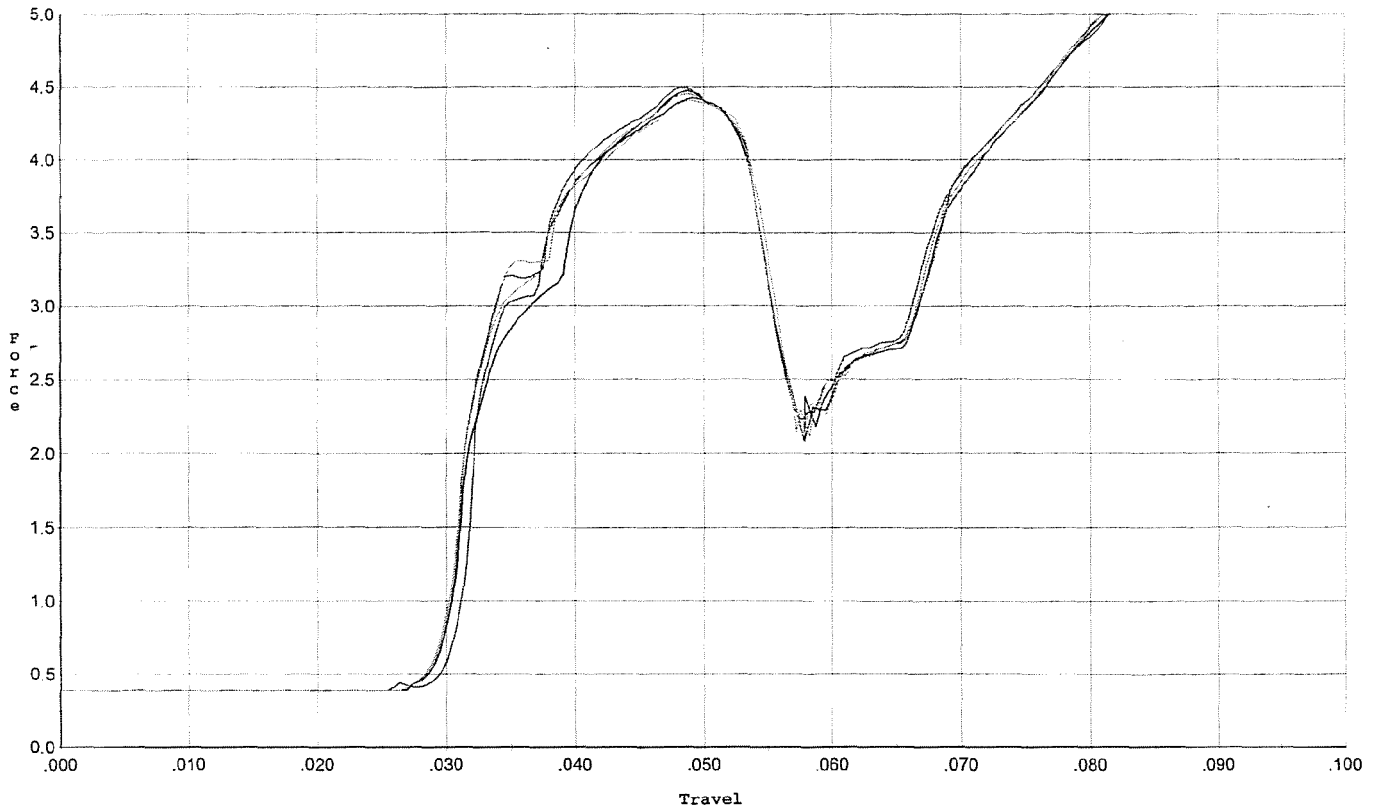
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.473	0.053	0.030	0.032	0.077		Set Trigger
2	3.491	0.053	0.030	0.032	0.078		Set Trigger
3	3.474	0.054	0.030	0.032	0.076		Set Trigger
4	3.449	0.053	0.030	0.032	0.075		Set Trigger
5	3.339	0.053	0.030	0.033	0.073		Set Trigger

A-3.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



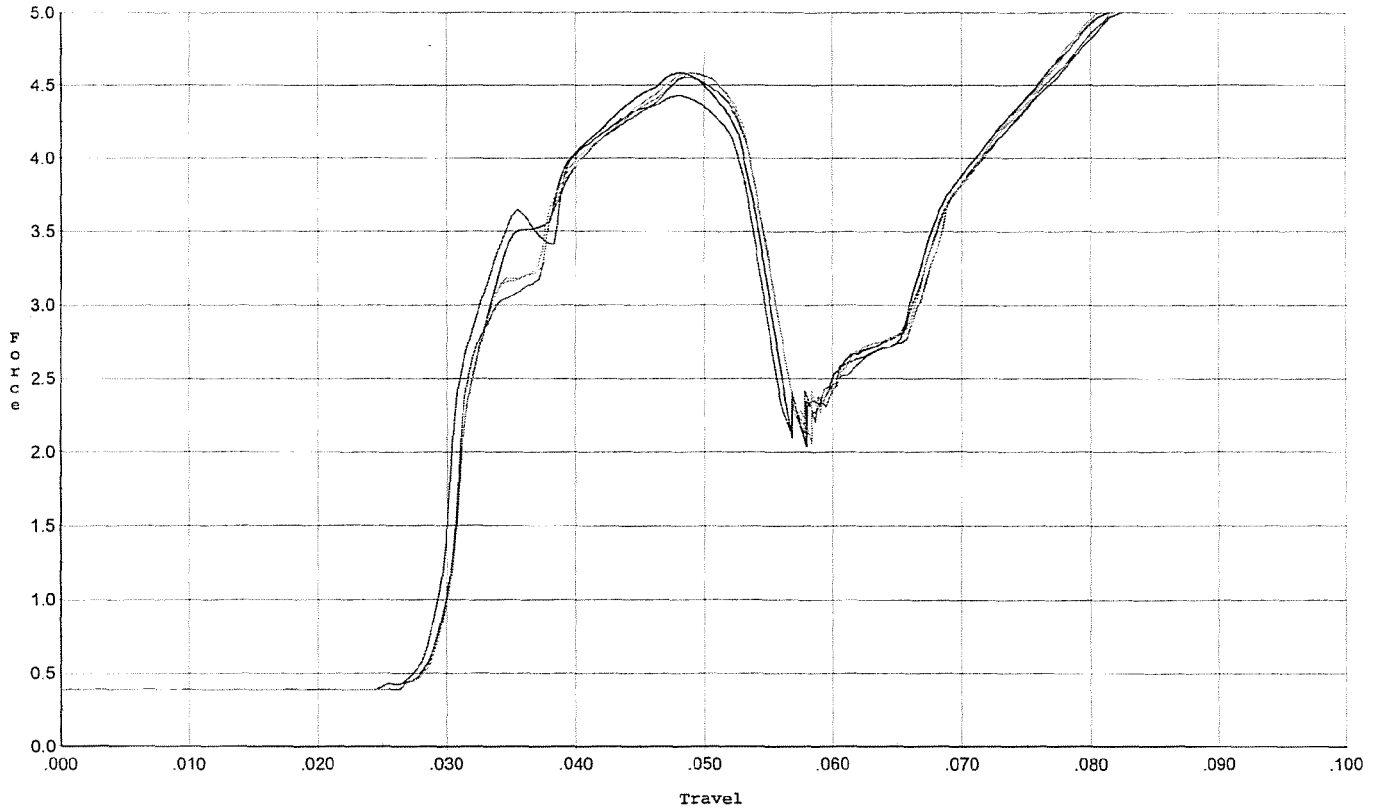
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.425	0.053	0.030	0.032	0.097		Set Trigger
2	4.477	0.053	0.029	0.031	0.097		Set Trigger
3	4.498	0.053	0.029	0.031	0.100		Set Trigger
4	4.450	0.053	0.029	0.031	0.100		Set Trigger
5	4.406	0.054	0.029	0.031	0.102		Set Trigger

A-4.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



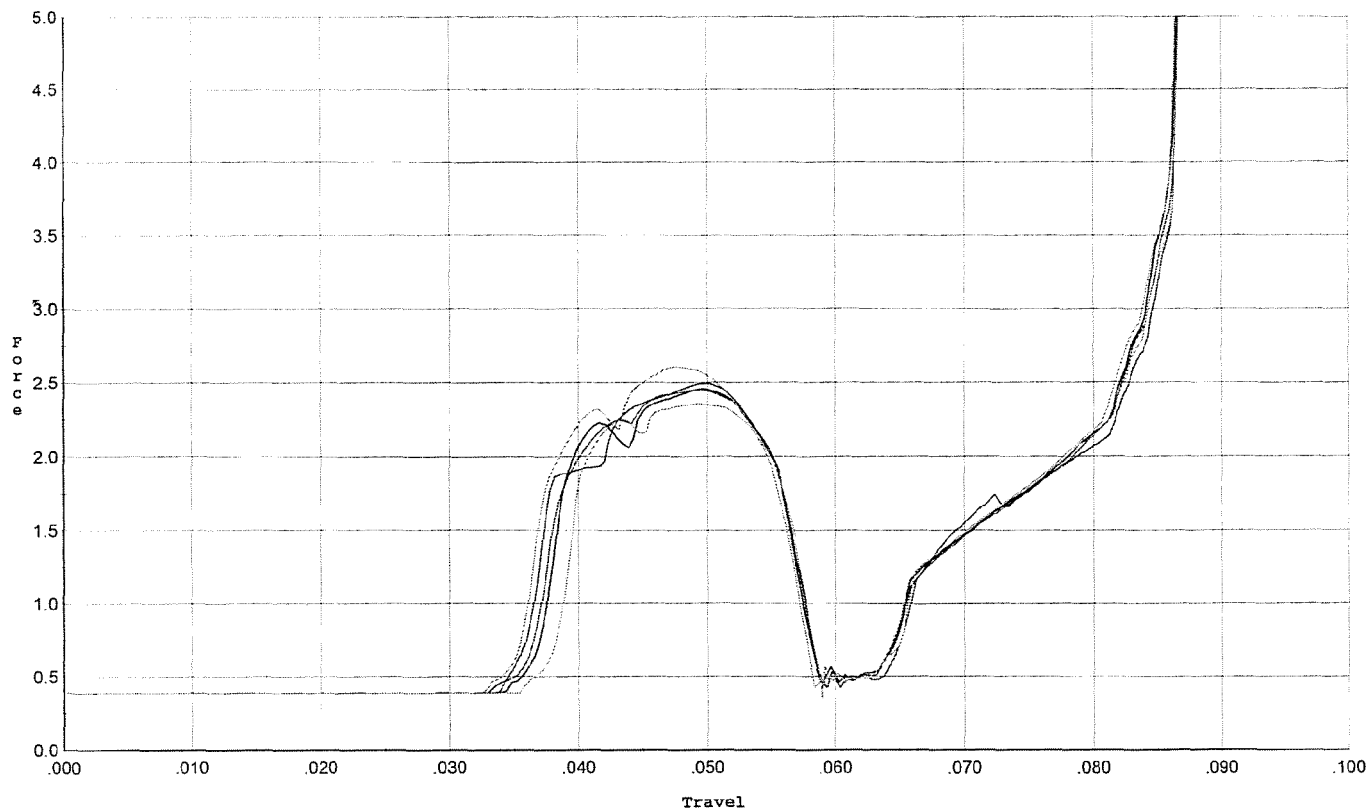
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.427	0.053	0.028	0.030	0.103		Set Trigger
2	4.587	0.054	0.029	0.031	0.104		Set Trigger
3	4.557	0.055	0.029	0.030	0.105		Set Trigger
4	4.587	0.053	0.029	0.031	0.102		Set Trigger
5	4.582	0.055	0.029	0.031	0.105		Set Trigger

A-4.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



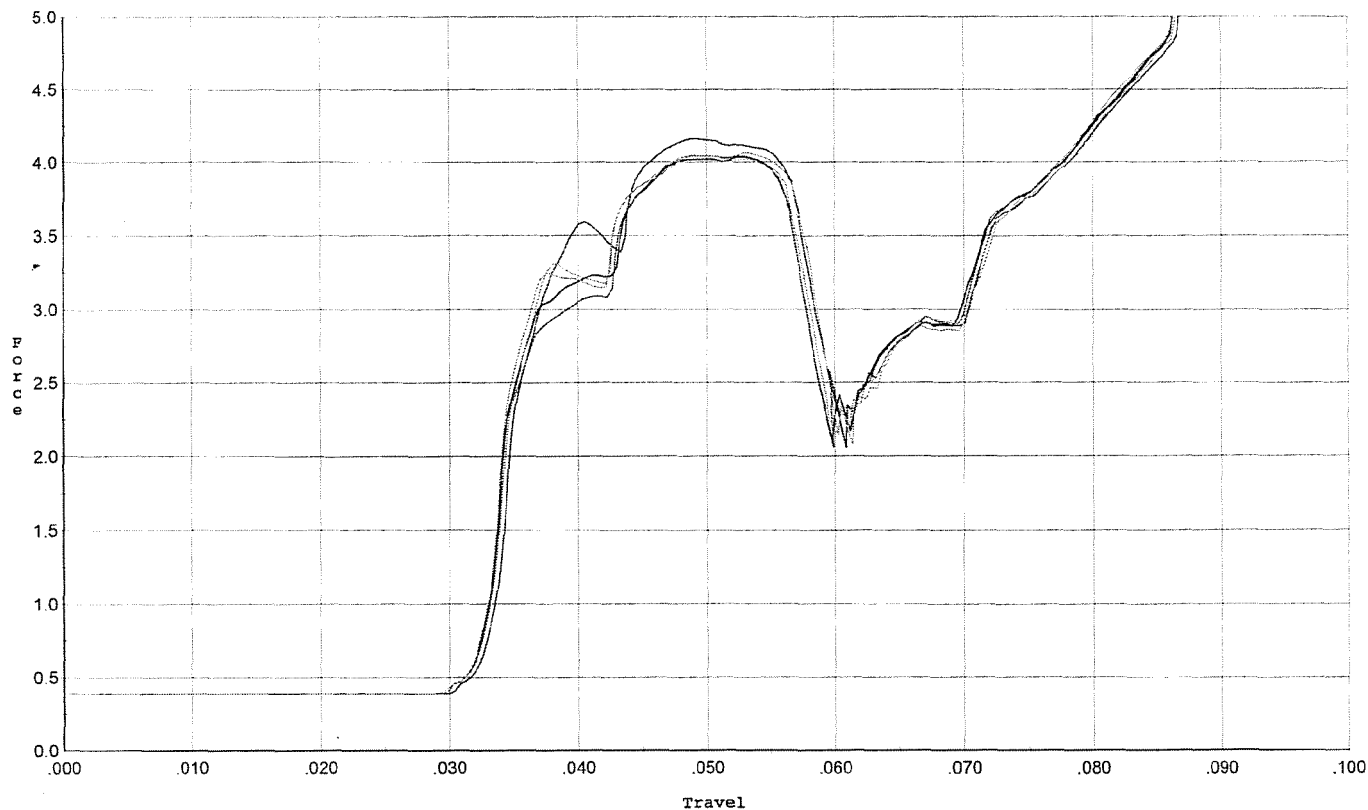
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.492	0.057	0.035	0.036	0.058		Set Trigger
2	2.455	0.056	0.035	0.037	0.055		Set Trigger
3	2.449	0.056	0.034	0.037	0.056		Set Trigger
4	2.353	0.057	0.038	0.037	0.054		Set Trigger
5	2.604	0.056	0.033	0.036	0.060		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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	4.158	0.057	0.032	0.033	0.099		Set Trigger
2	4.036	0.056	0.032	0.033	0.096		Set Trigger
3	4.043	0.056	0.032	0.033	0.095		Set Trigger
4	4.061	0.058	0.032	0.032	0.101		Set Trigger
5	4.046	0.058	0.032	0.032	0.100		Set Trigger

A. 4.06