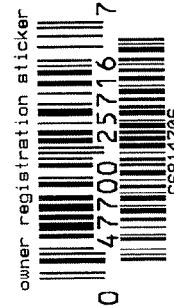


66814706

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

- INSTRUCTION BOOK 3518

BM FORM



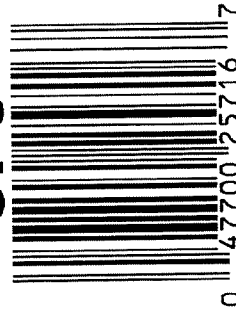
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6814706

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6814706

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	SP
472	SERIALIZE BOLT HANDLE		3-5-09	RJL
480	MAGNAFLUX BBL ACTION		3-9-09	MR
490	MAGNAFLUX BOLT		3-9-09	MR
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)		3-18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-17-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-17-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-17-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

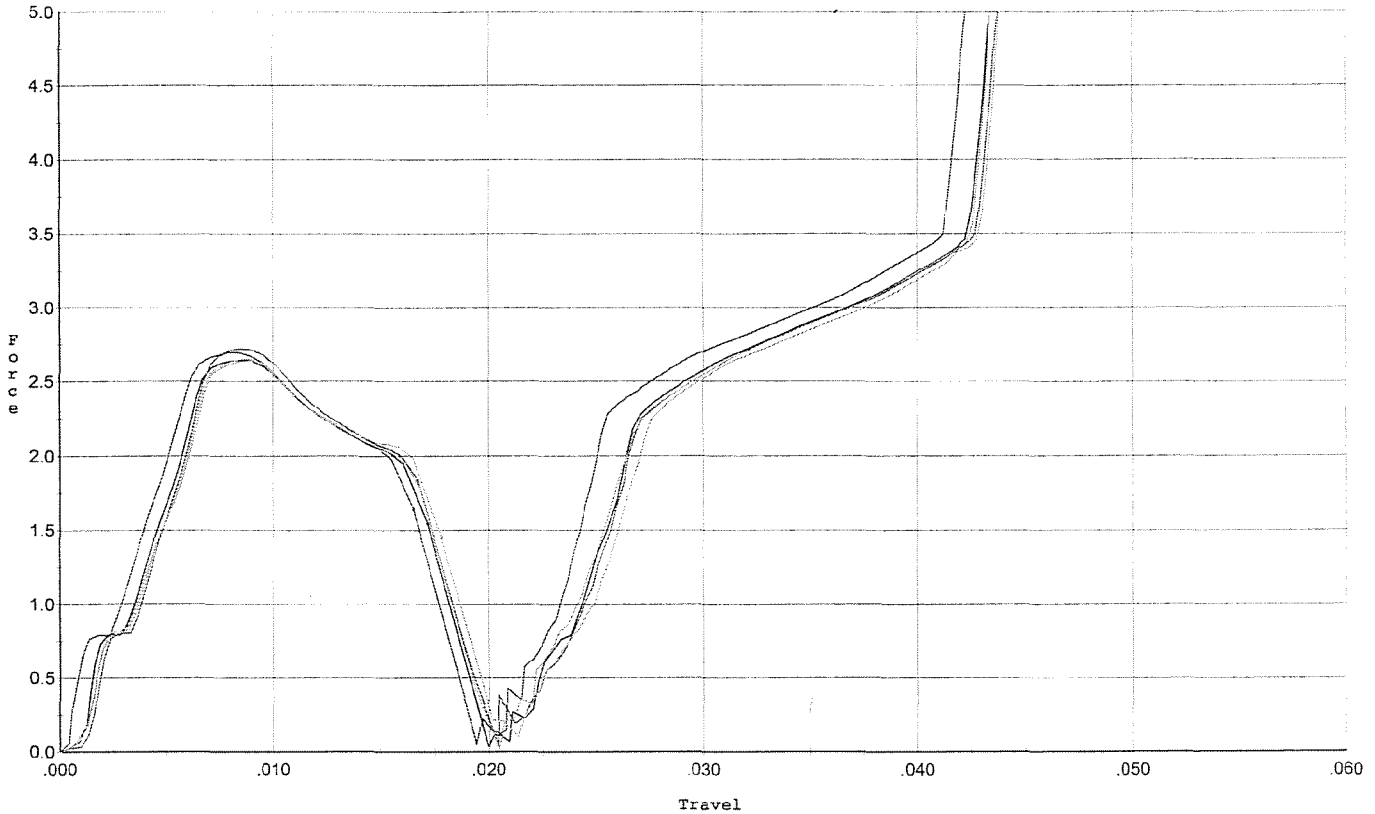
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-23-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-23-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	3-23-09	WV
	J) ASSEMBLE STOCK		3-20-09	JJ
	K) ASSEMBLE SWIVEL STUDS		3-23-09	WV
	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	3-23-09	K
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u> <u>2.67</u> <u>2.66</u> <u>2.69</u> <u>2.60</u>	3-23-09	TL
	C) FUNCTION		3-23-09	WV
690	PACK		3/25/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



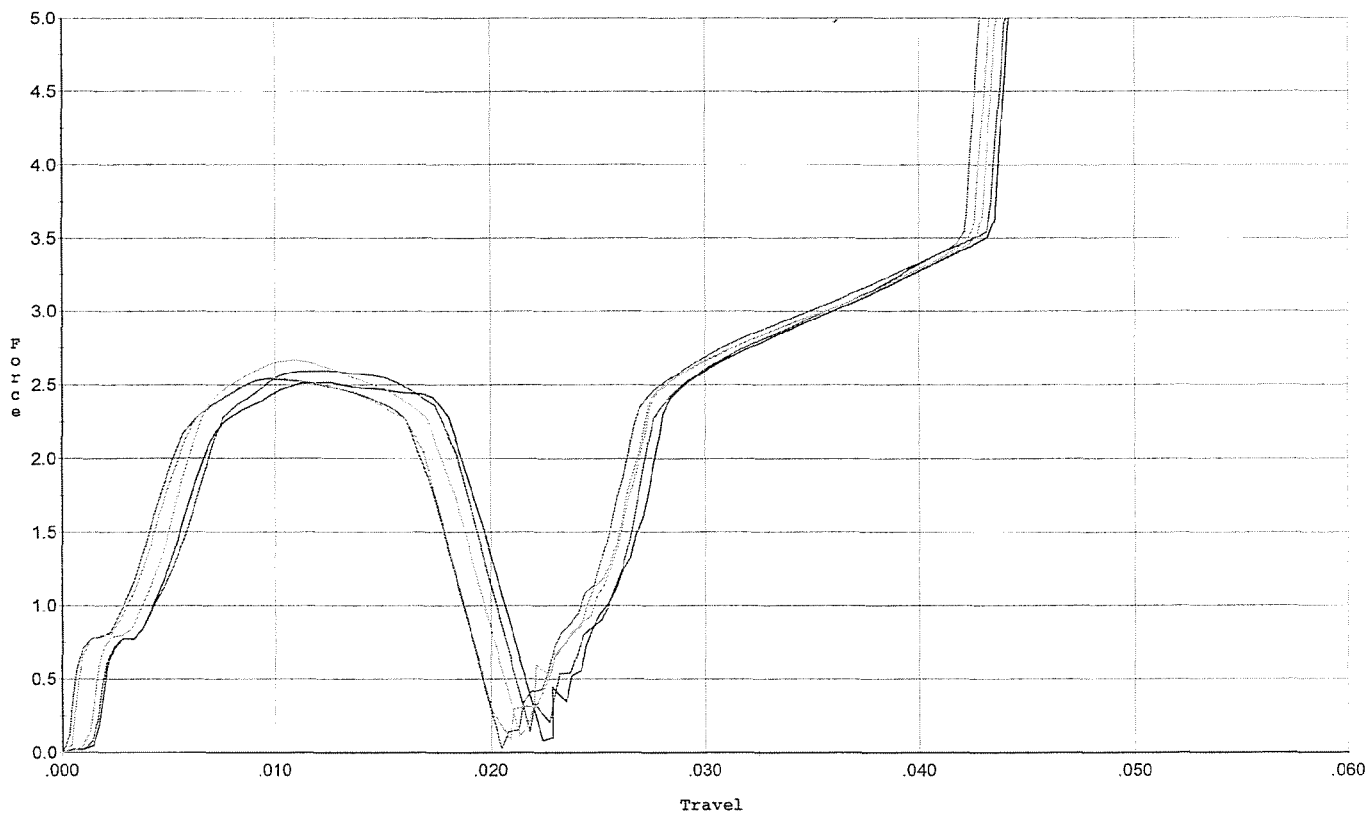
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.017	0.00	0.029	0.030		Set Trigger
2	2.644	0.017	0.00	0.030	0.029		Set Trigger
3	2.718	0.017	0.00	0.030	0.029		Set Trigger
4	2.650	0.017	0.00	0.030	0.028		Set Trigger
5	2.641	0.018	0.00	0.029	0.030		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



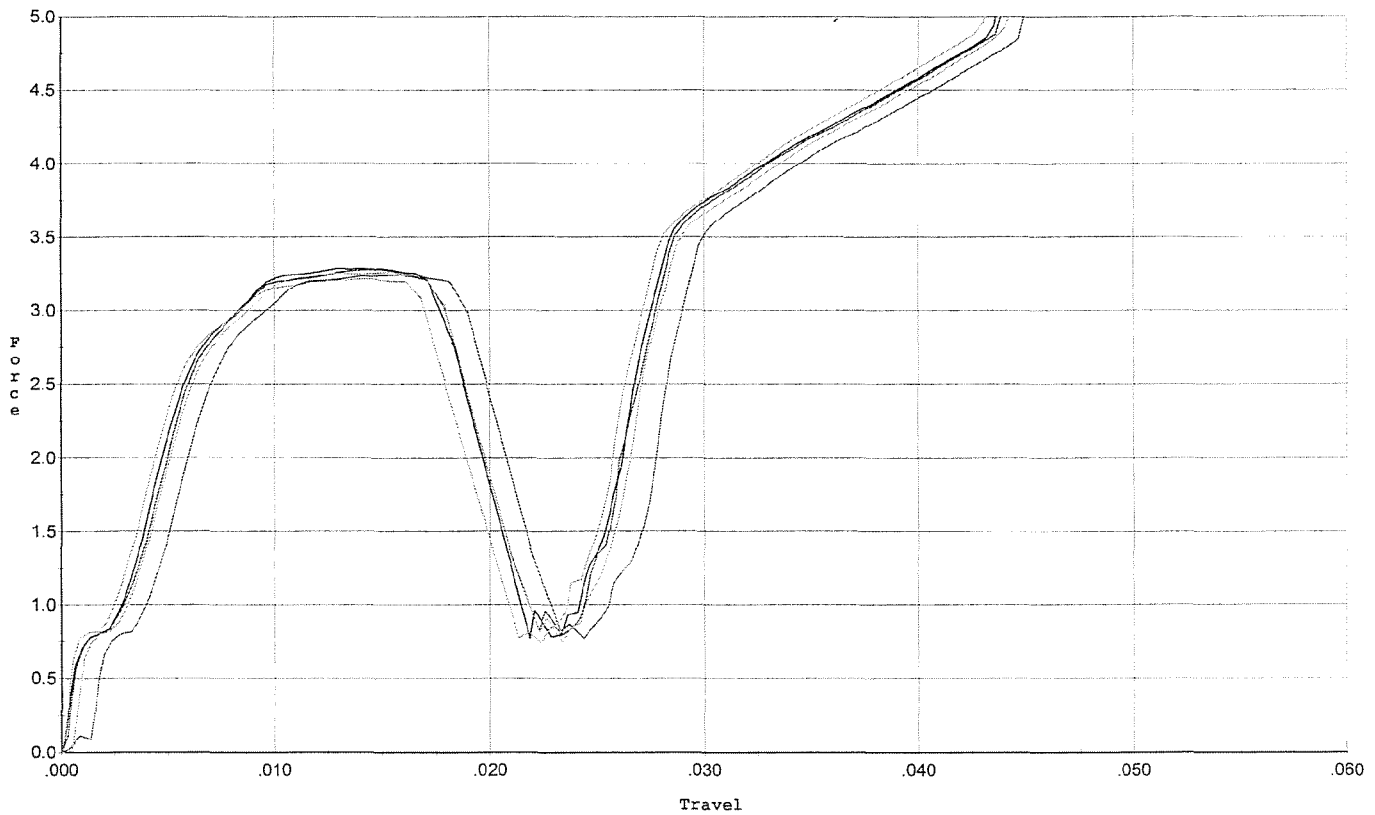
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.018	0.00	0.028	0.032		Set Trigger
2	2.518	0.020	0.00	0.028	0.034		Set Trigger
3	2.539	0.017	0.00	0.029	0.032		Set Trigger
4	2.665	0.018	0.00	0.028	0.033		Set Trigger
5	2.547	0.017	0.00	0.029	0.031		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



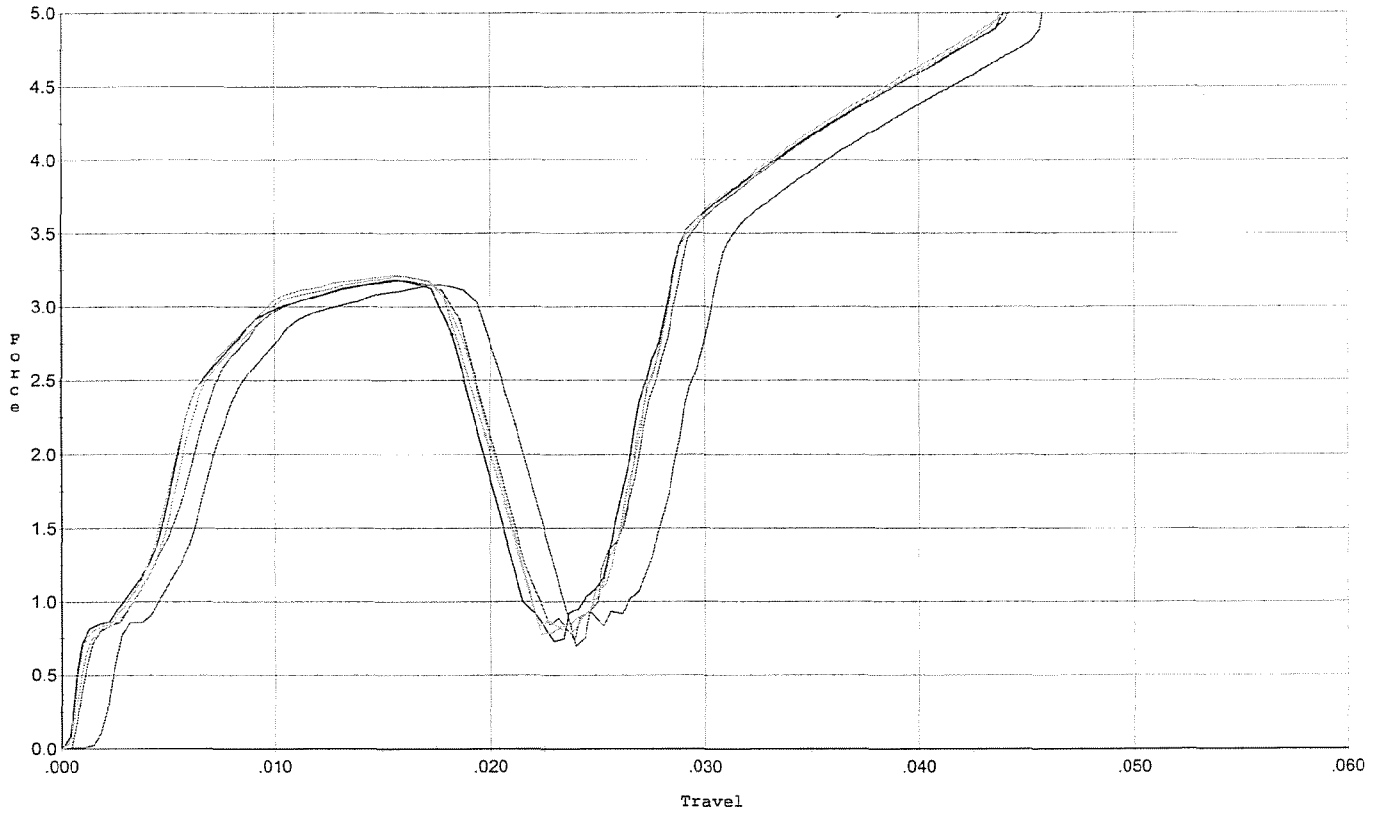
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.018	0.00	0.027	0.042		Set Trigger
2	3.285	0.018	0.00	0.027	0.043		Set Trigger
3	3.250	0.019	0.00	0.028	0.042		Set Trigger
4	3.258	0.018	0.00	0.027	0.041		Set Trigger
5	3.215	0.017	0.00	0.027	0.039		Set Trigger

A. 3-25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



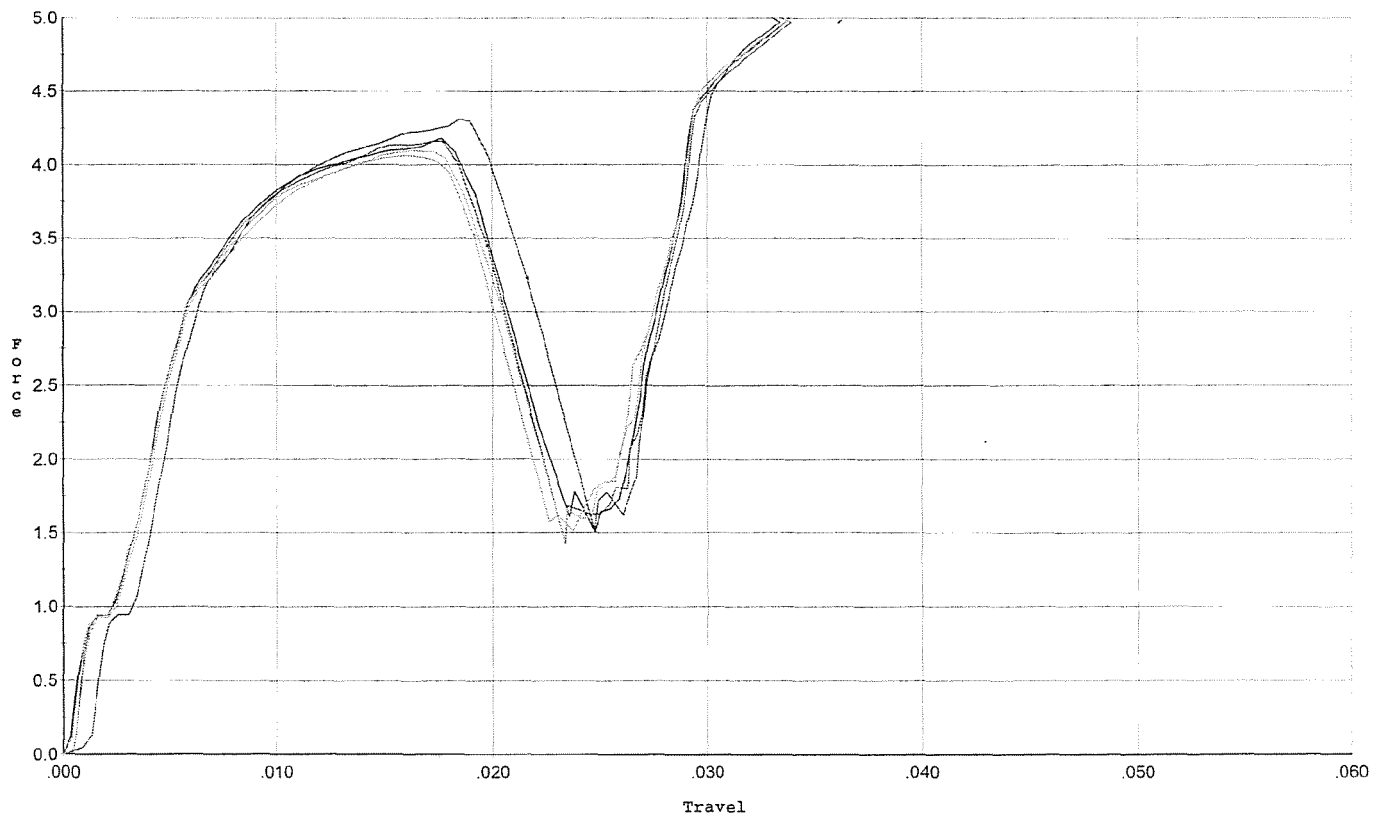
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.151	0.021	0.00	0.028	0.043		Set Trigger
2	3.183	0.018	0.00	0.027	0.040		Set Trigger
3	3.179	0.019	0.00	0.027	0.040		Set Trigger
4	3.208	0.019	0.00	0.027	0.042		Set Trigger
5	3.215	0.020	0.00	0.027	0.044		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



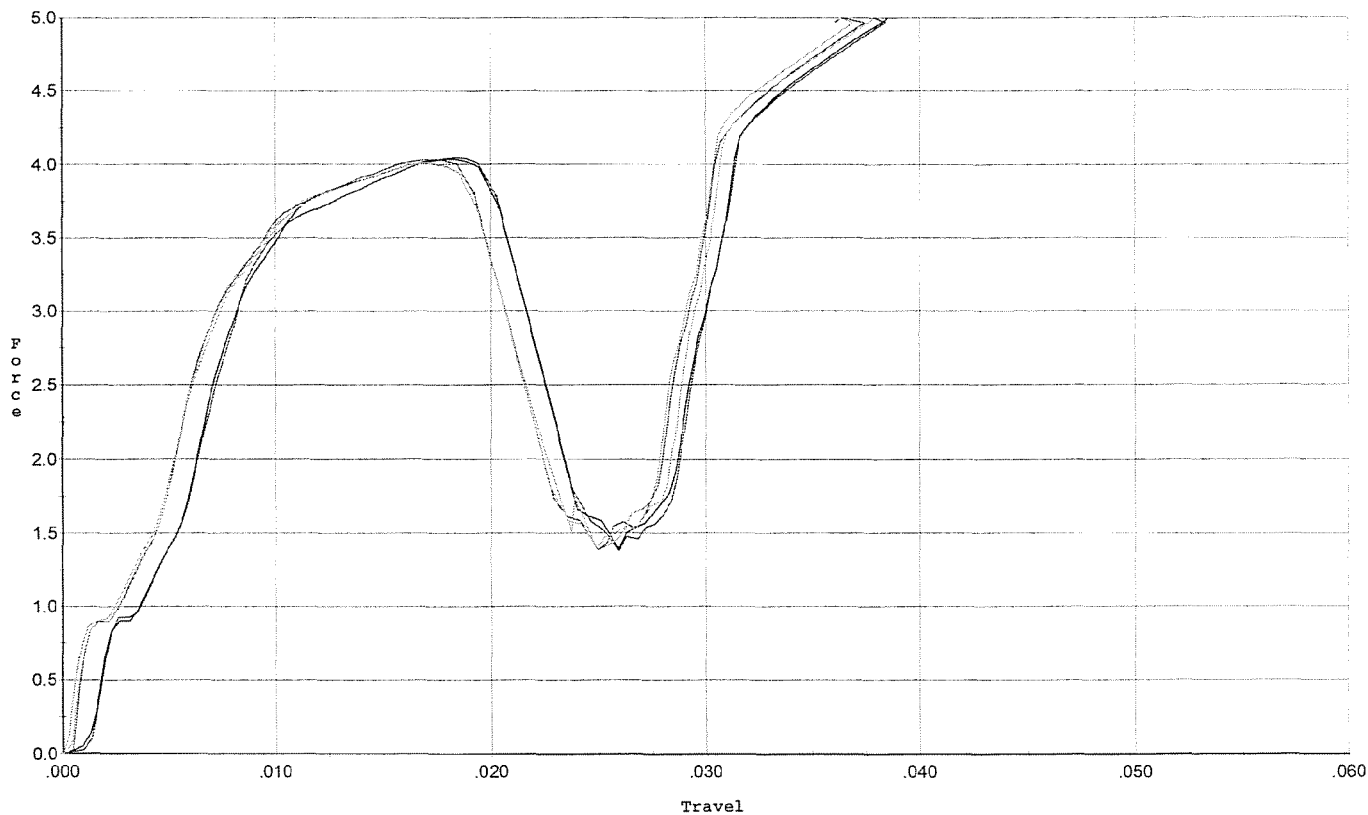
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.309	0.022	0.00	0.025	0.062		Set Trigger
2	4.180	0.019	0.00	0.025	0.056		Set Trigger
3	4.159	0.020	0.00	0.025	0.057		Set Trigger
4	4.098	0.020	0.00	0.025	0.057		Set Trigger
5	4.063	0.019	0.00	0.026	0.054		Set Trigger

A 4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



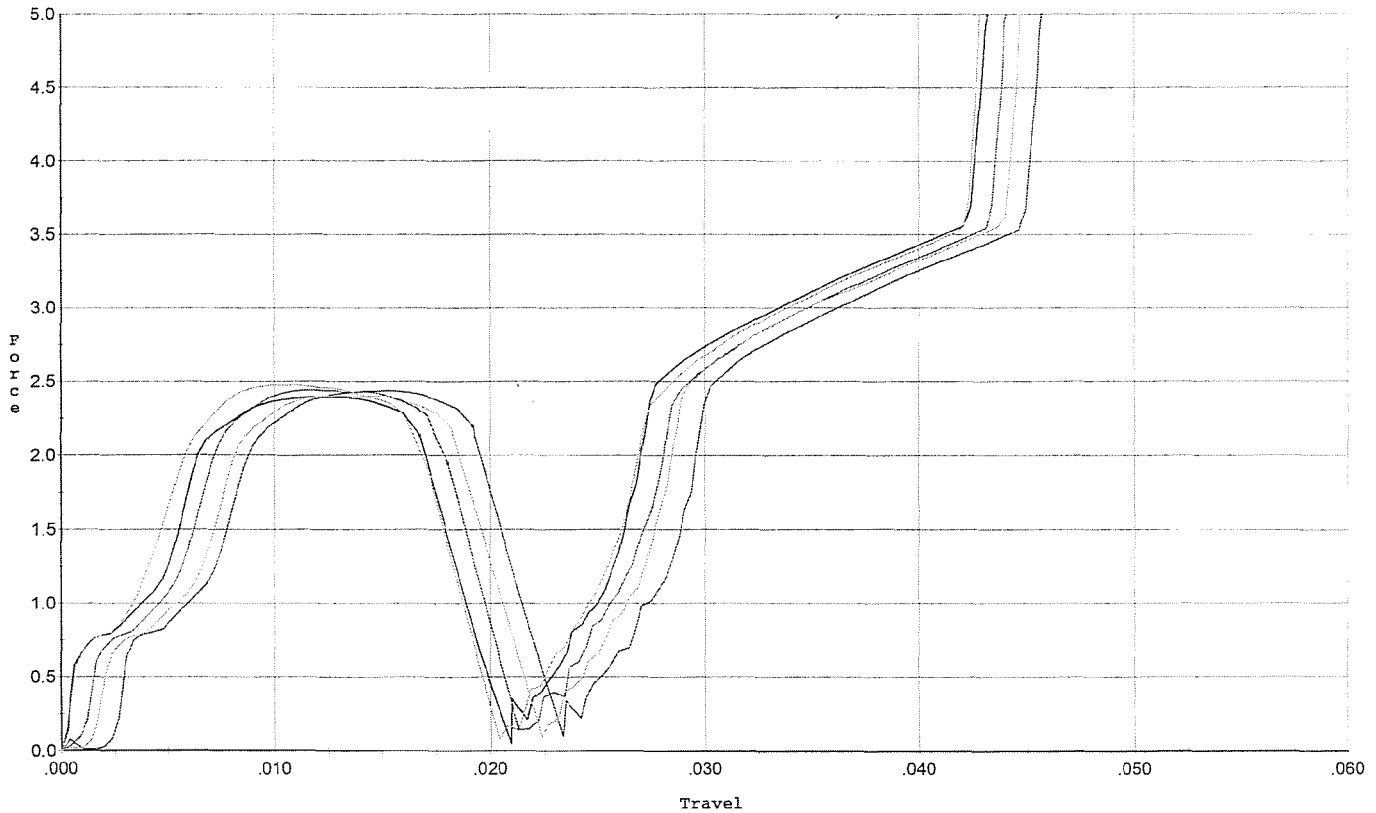
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.047	0.020	0.00	0.027	0.053		Set Trigger
2	4.036	0.020	0.00	0.027	0.053		Set Trigger
3	4.034	0.019	0.00	0.027	0.052		Set Trigger
4	4.009	0.019	0.00	0.027	0.052		Set Trigger
5	4.009	0.019	0.00	0.027	0.052		Set Trigger

A - 4.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



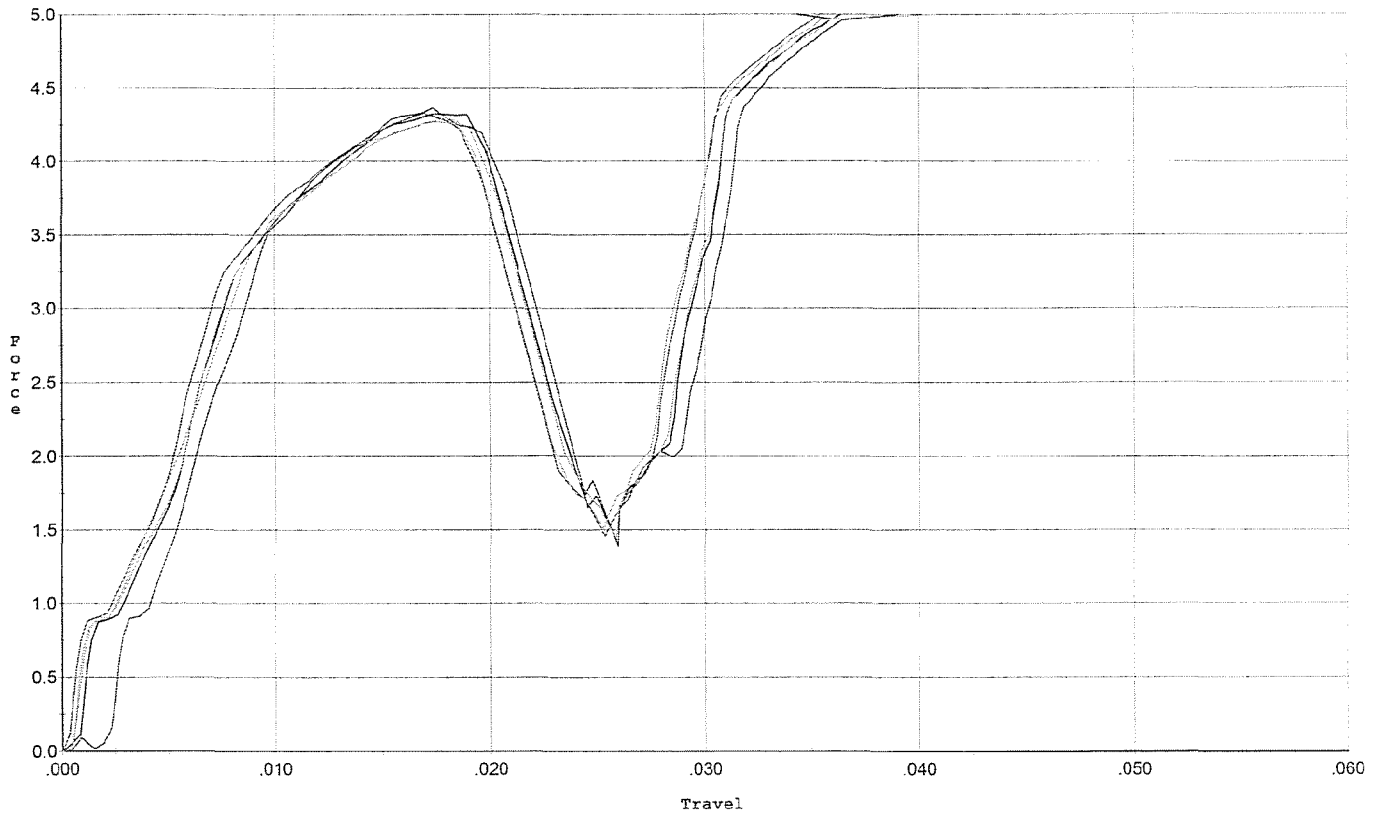
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.019	0.002	0.030	0.030		Set Trigger
2	2.395	0.017	0.00	0.029	0.029		Set Trigger
3	2.439	0.018	0.00	0.029	0.030		Set Trigger
4	2.402	0.020	0.00	0.029	0.032		Set Trigger
5	2.474	0.017	0.00	0.029	0.031		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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	4.364	0.021	0.00	0.026	0.056		Set Trigger
2	4.323	0.020	0.00	0.026	0.055		Set Trigger
3	4.325	0.020	0.00	0.026	0.055		Set Trigger
4	4.295	0.019	0.00	0.026	0.054		Set Trigger
5	4.268	0.020	0.00	0.026	0.056		Set Trigger

A-4.31