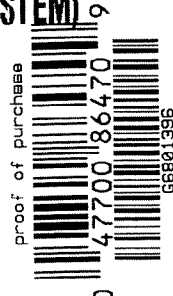


G680 1396

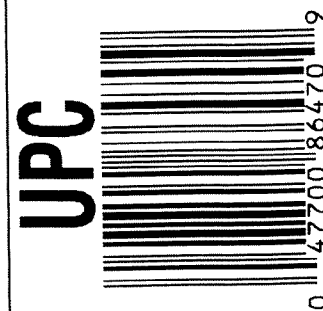
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6801396



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801396

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE		10-22-08	BN
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION		10/24/08	KB
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	KT
520	GOFF BLAST BBL / REC		10/24/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-30-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-8-09	LJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

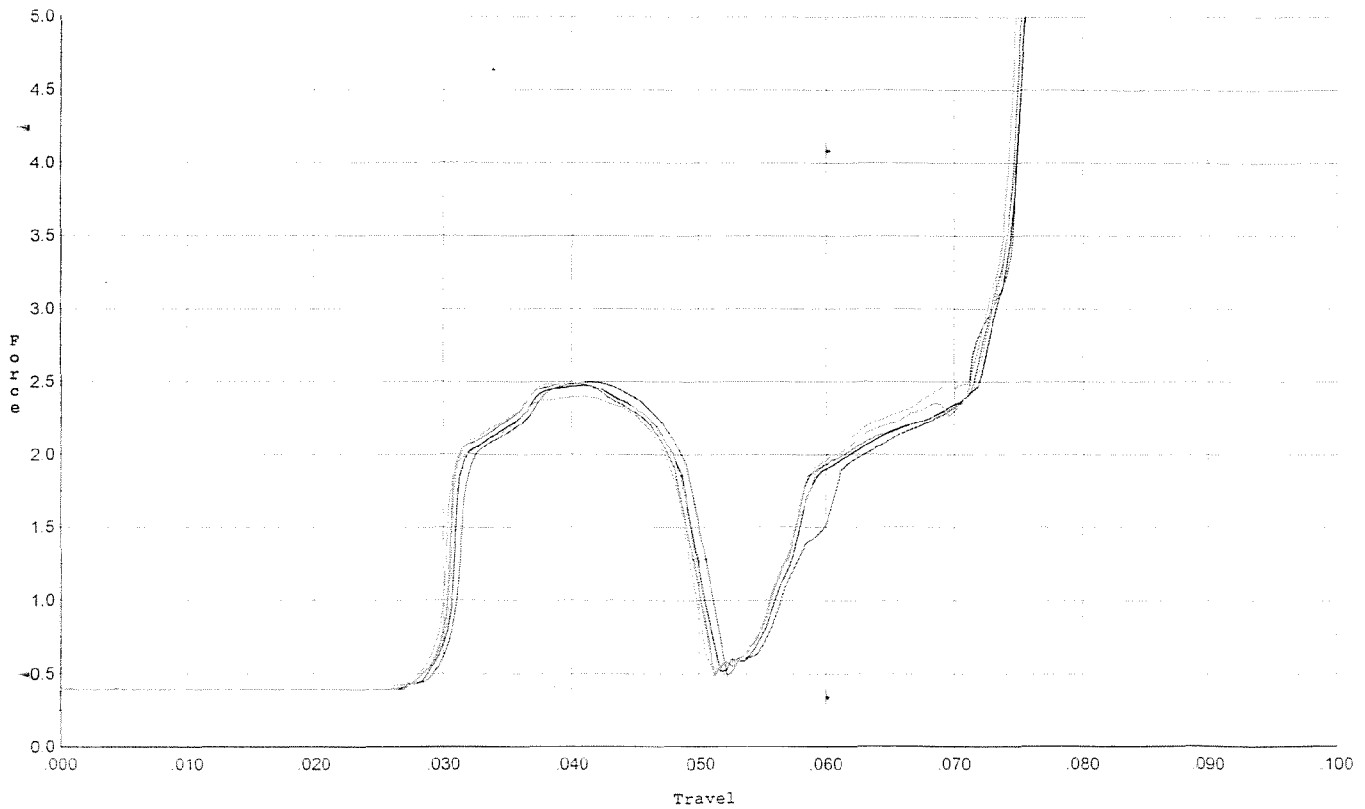
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-16-09	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	1-16-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	1-16-09	R.N.
	J) ASSEMBLE STOCK		1-8-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-16-09	R.N.
	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	1-15-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-15-09	R.N.
670	FINAL INSPECTION A) HEADSPACE		1-16-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.24</u> <u>2.25</u> <u>2.16</u> <u>2.17</u>	1-16-09	TC
	C) FUNCTION		1-16-09	R.N.
690	PACK		1/20/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



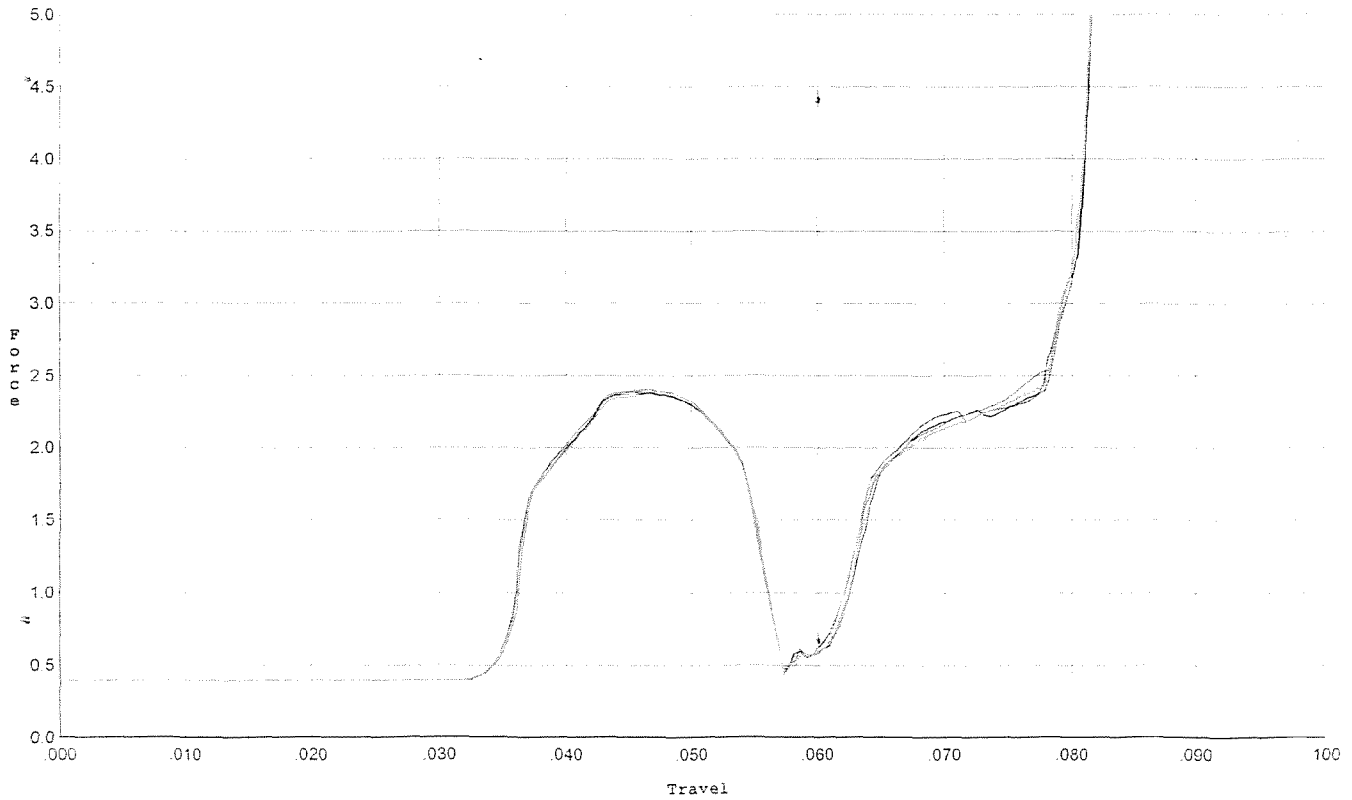
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.494	0.051	0.030	0.031	0.055		Set Trigger
2	2.472	0.049	0.029	0.031	0.053		Set Trigger
3	2.488	0.050	0.030	0.031	0.055		Set Trigger
4	2.497	0.049	0.030	0.031	0.054		Set Trigger
5	2.399	0.048	0.029	0.031	0.053		Set Trigger

A-2147

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



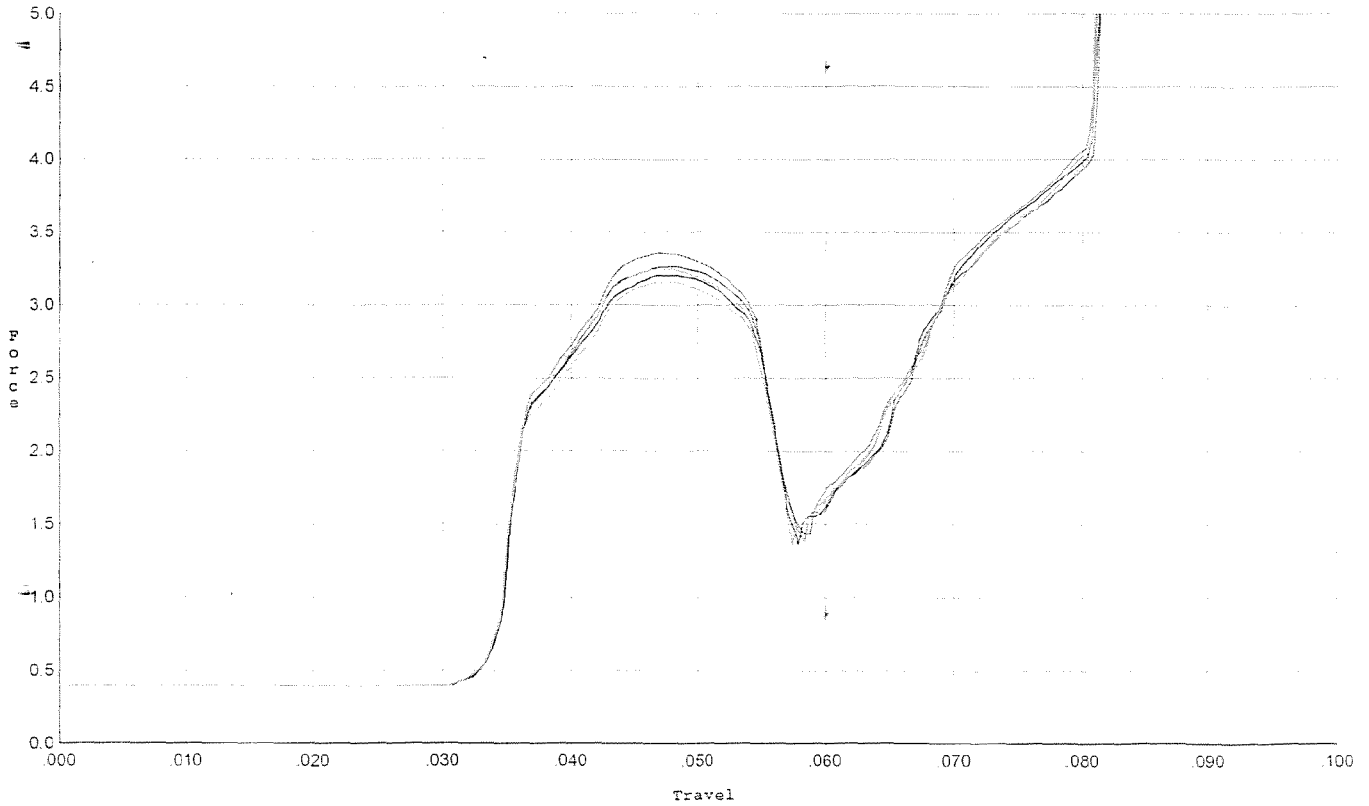
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.388	0.055	0.035	0.033	0.055		Set Trigger
2	2.376	0.054	0.035	0.033	0.054		Set Trigger
3	2.404	0.056	0.035	0.033	0.055		Set Trigger
4	2.388	0.056	0.035	0.033	0.055		Set Trigger
5	2.364	0.055	0.035	0.033	0.055		Set Trigger

A 2.38

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



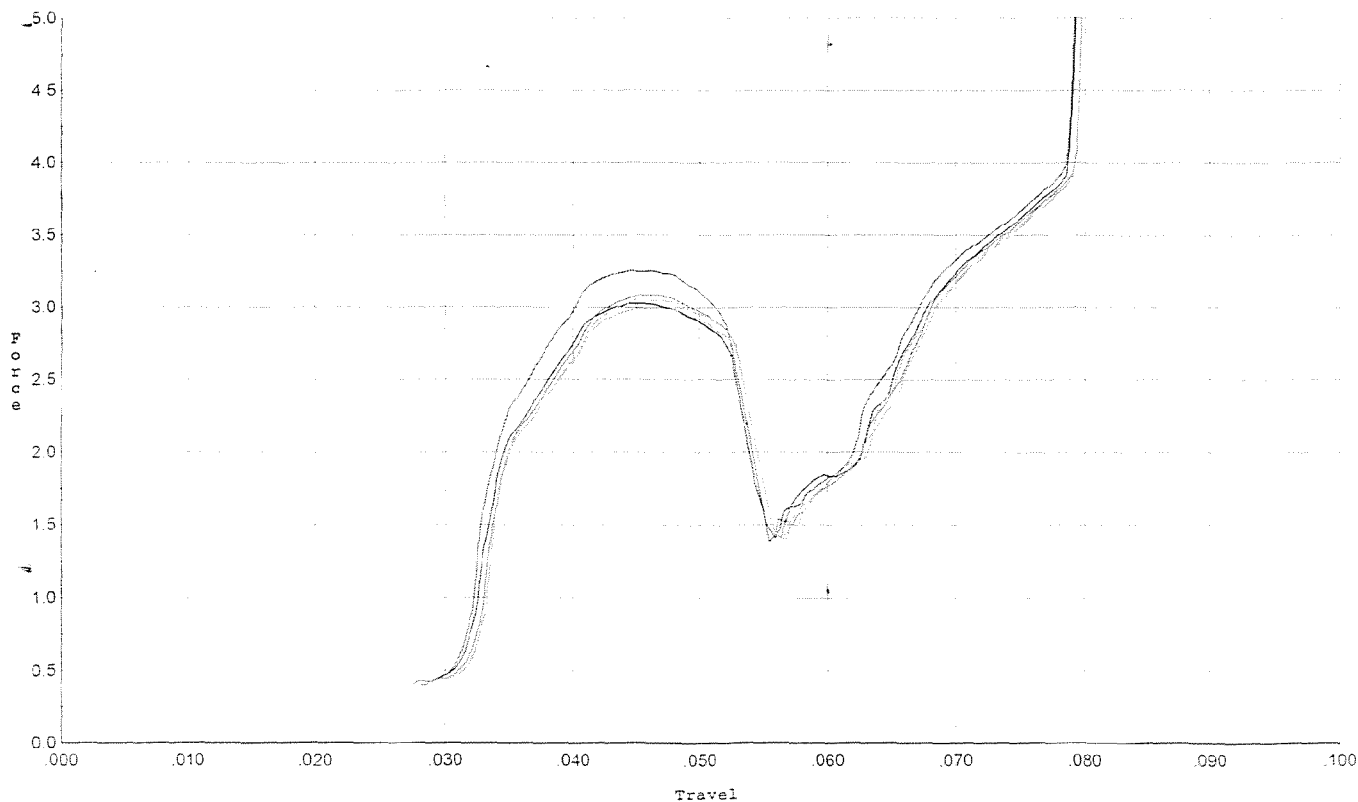
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.266	0.055	0.034	0.031	0.073		Set Trigger
2	3.203	0.055	0.034	0.031	0.072		Set Trigger
3	3.361	0.055	0.034	0.031	0.074		Set Trigger
4	3.159	0.055	0.034	0.031	0.072		Set Trigger
5	3.248	0.055	0.034	0.031	0.074		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



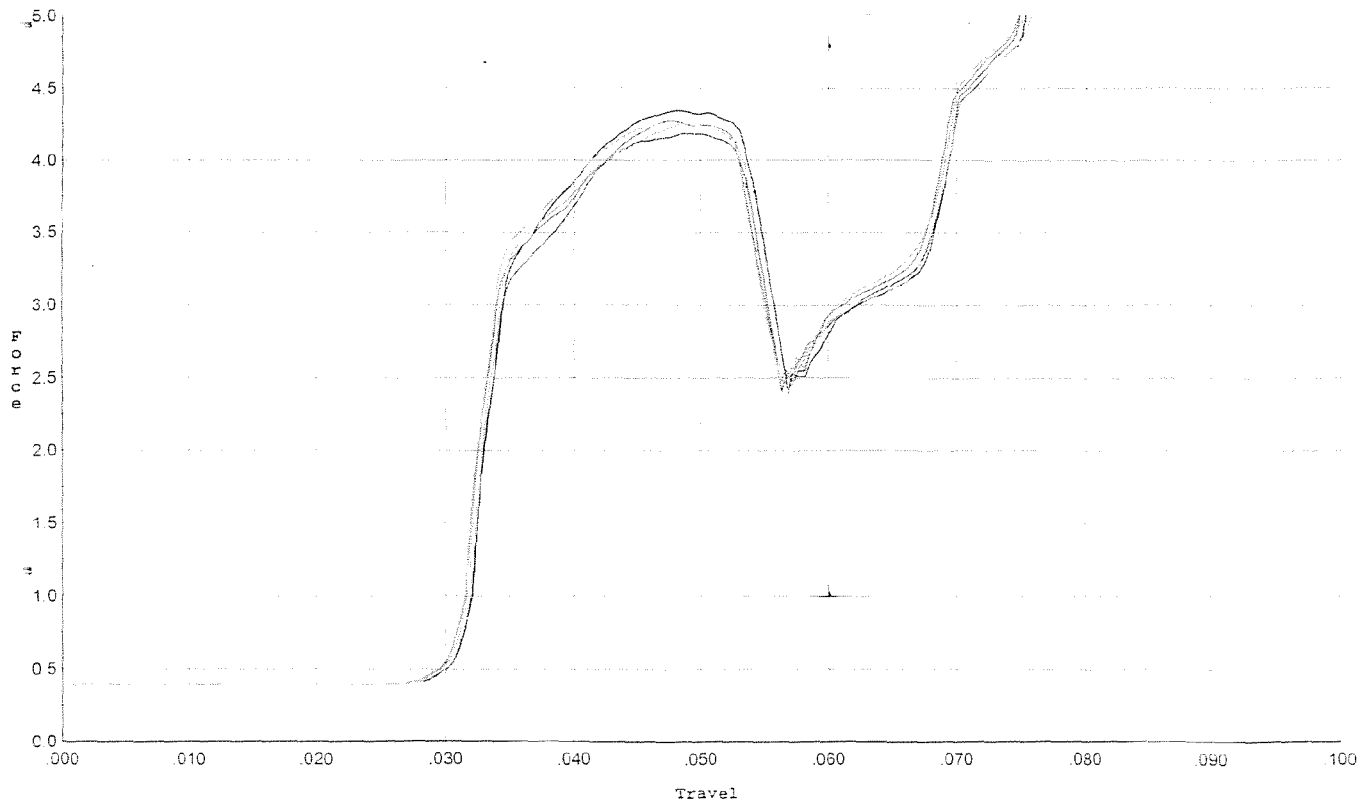
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.256	0.054	0.031	0.031	0.074		Set Trigger
2	3.027	0.052	0.032	0.032	0.067		Set Trigger
3	3.084	0.053	0.032	0.032	0.068		Set Trigger
4	2.995	0.053	0.032	0.032	0.067		Set Trigger
5	3.058	0.053	0.032	0.032	0.067		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



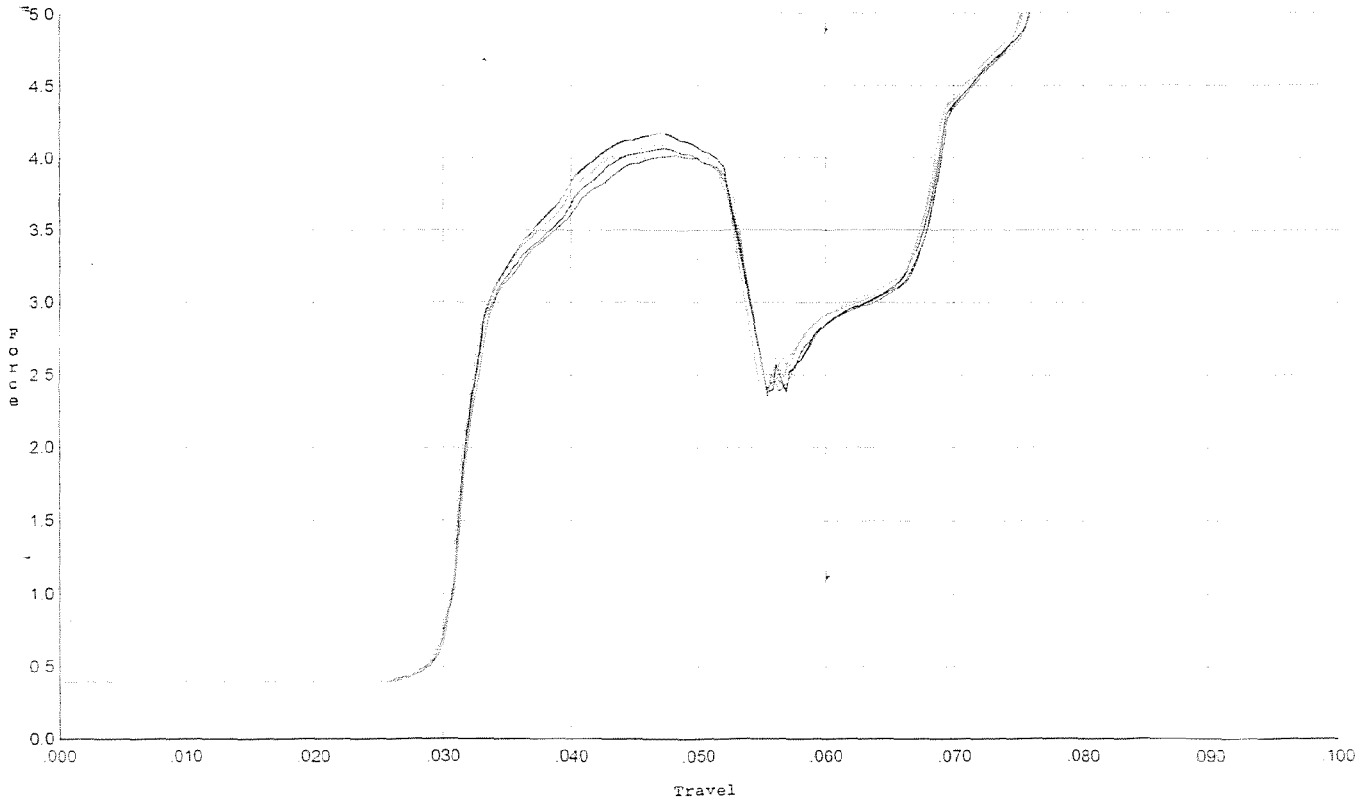
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.054	0.031	0.025	0.095		Set Trigger
2	4.345	0.054	0.031	0.025	0.099		Set Trigger
3	4.276	0.053	0.031	0.026	0.095		Set Trigger
4	4.250	0.053	0.031	0.026	0.096		Set Trigger
5	4.294	0.053	0.031	0.026	0.096		Set Trigger

A. 4.27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



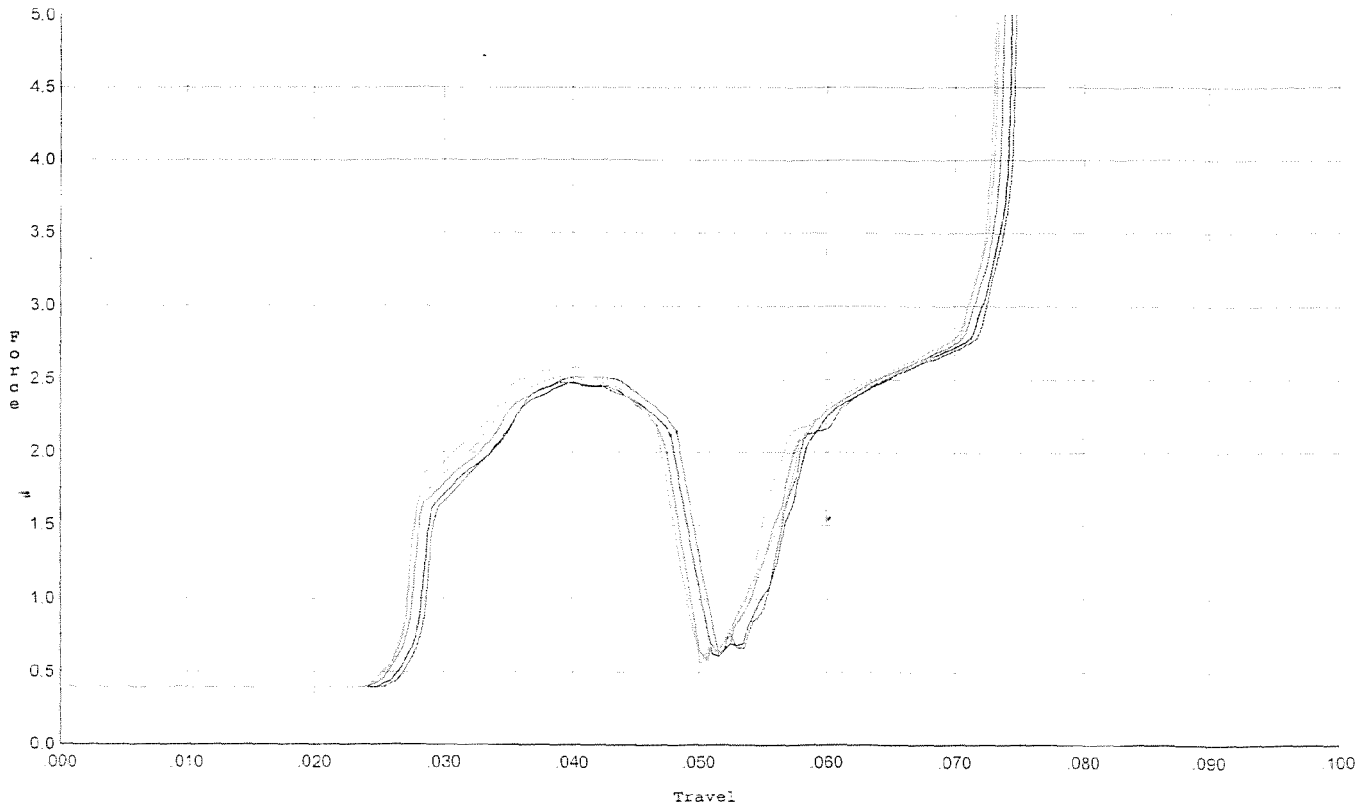
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.054	0.030	0.029	0.094		Set Trigger
2	4.170	0.053	0.030	0.028	0.096		Set Trigger
3	4.014	0.053	0.030	0.029	0.092		Set Trigger
4	4.172	0.053	0.030	0.029	0.095		Set Trigger
5	4.090	0.052	0.030	0.029	0.092		Set Trigger

A.4.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



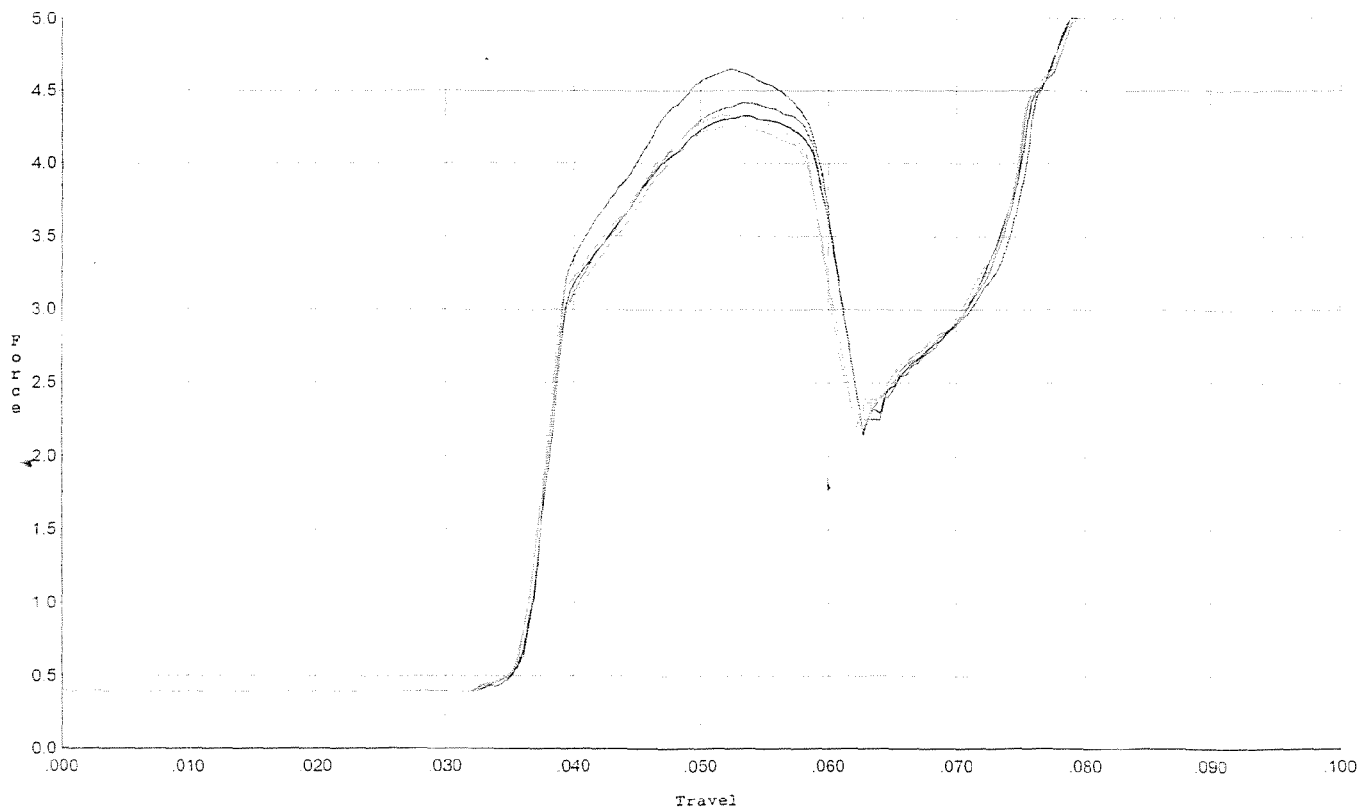
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.048	0.027	0.030	0.056		Set Trigger
2	2.475	0.048	0.027	0.030	0.055		Set Trigger
3	2.478	0.047	0.027	0.030	0.055		Set Trigger
4	2.522	0.047	0.026	0.030	0.055		Set Trigger
5	2.577	0.047	0.026	0.030	0.056		Set Trigger

A-2-SI

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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	4.649	0.060	0.036	0.028	0.107		Set Trigger
2	4.326	0.060	0.036	0.028	0.103		Set Trigger
3	4.416	0.060	0.036	0.027	0.104		Set Trigger
4	4.331	0.058	0.036	0.028	0.100		Set Trigger
5	4.256	0.059	0.036	0.028	0.098		Set Trigger

A-4139