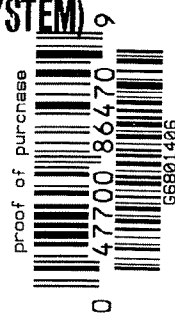


6680 1406

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



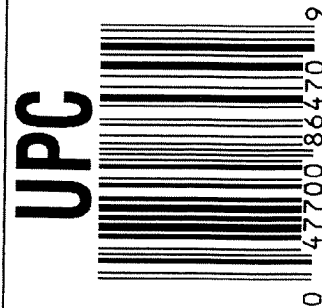
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801406



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 1406

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	ER
475	DRILL AND TAP SIGHT HOLES	24	11-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (K)	10/24/08	(K)
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10-25-08	TL
542	APPLY COATINGS (BARREL ACTION)		10-28	C
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		1-12-09	ER
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

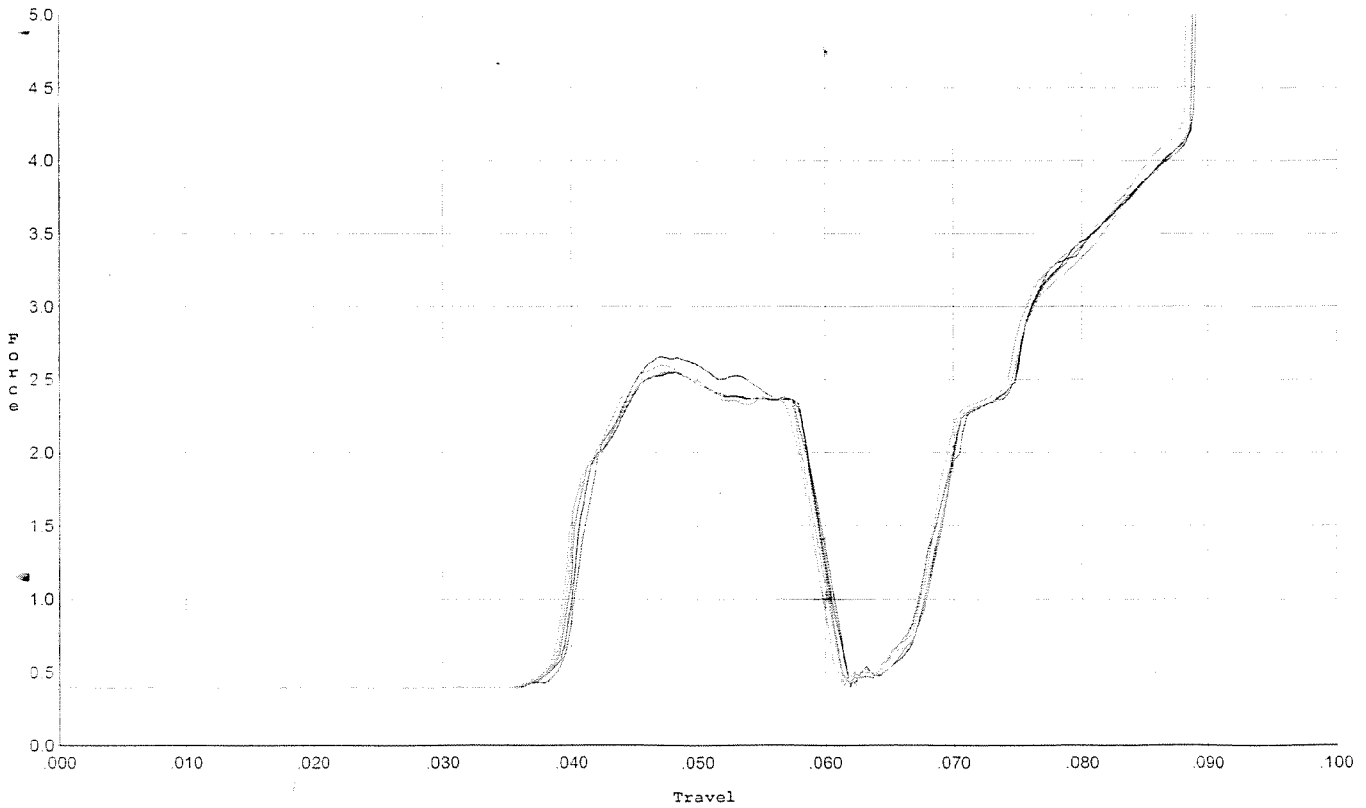
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-20-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>59</u>	1-20-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	1-20-09	L.N.
	J) ASSEMBLE STOCK		1-12-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-20-09	L.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	1-19-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-19-09	W.N.
670	FINAL INSPECTION A) HEADSPACE		1-20-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.60</u> <u>2.52</u> <u>2.55</u> <u>2.58</u>	1-20-09	L.N.
	C) FUNCTION		1-20-09	L.N.
690	PACK		1-22-09	R.N.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



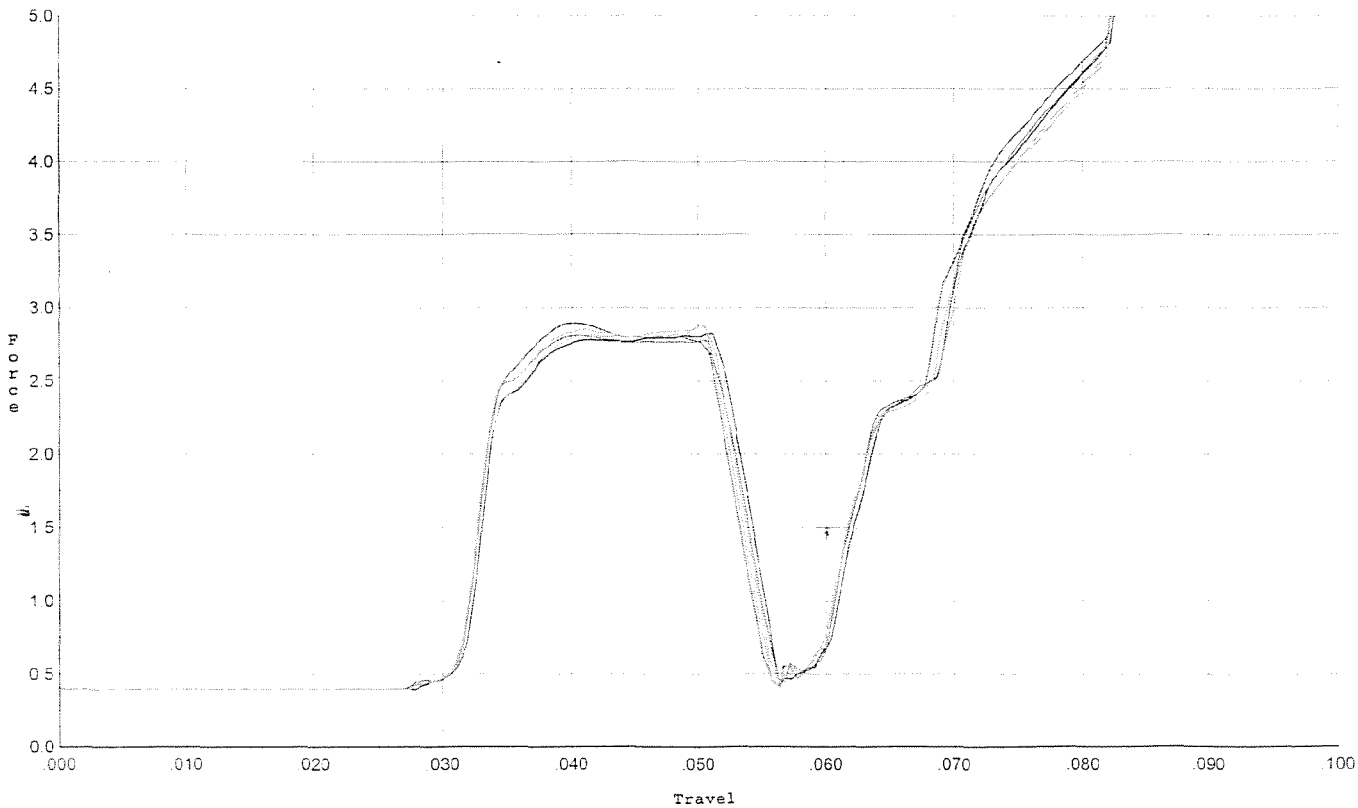
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.060	0.039	0.036	0.062		Set Trigger
2	2.546	0.058	0.039	0.036	0.059		Set Trigger
3	2.555	0.058	0.039	0.036	0.060		Set Trigger
4	2.596	0.058	0.039	0.036	0.059		Set Trigger
5	2.560	0.057	0.039	0.037	0.058		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



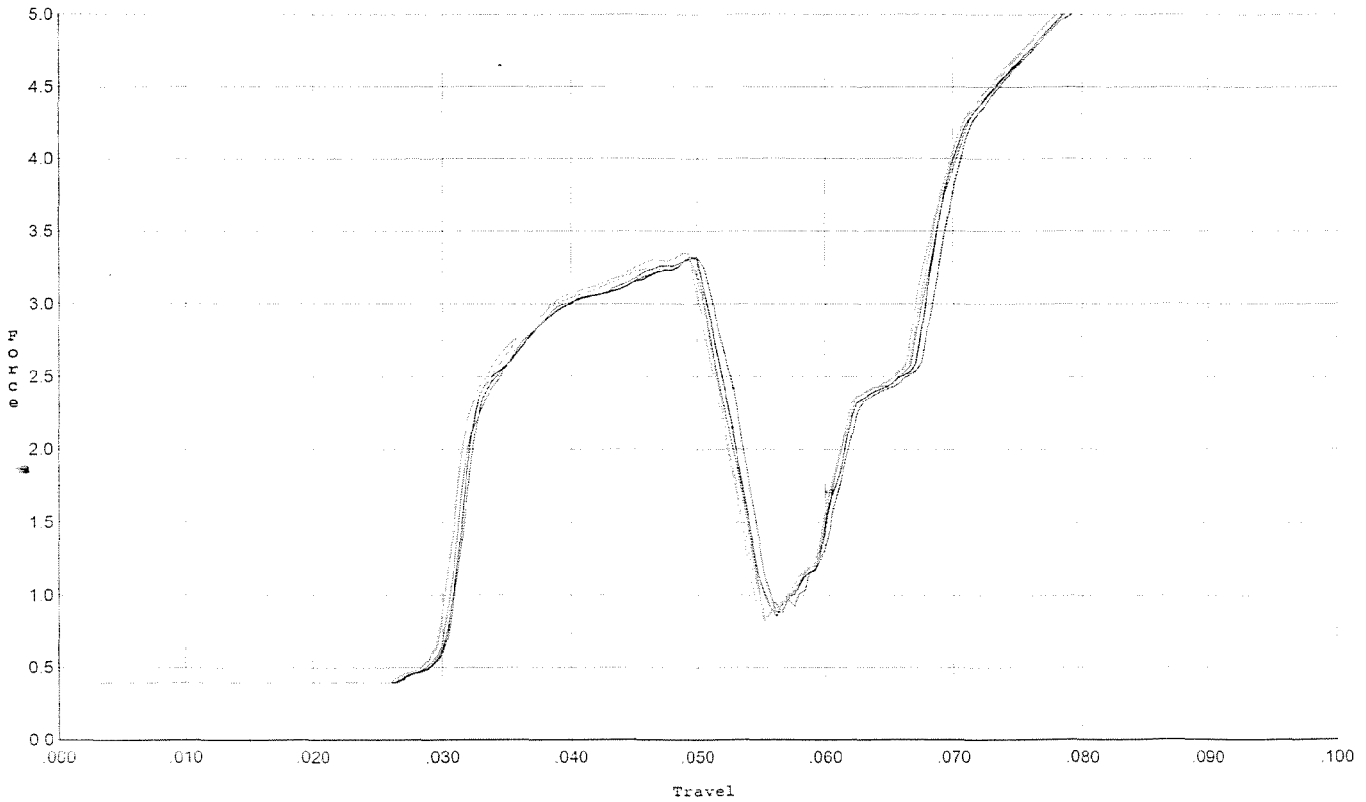
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.896	0.051	0.031	0.034	0.065		Set Trigger
2	2.828	0.054	0.032	0.033	0.068		Set Trigger
3	2.815	0.053	0.031	0.033	0.067		Set Trigger
4	2.877	0.051	0.031	0.034	0.065		Set Trigger
5	2.892	0.052	0.031	0.033	0.067		Set Trigger

A-2 F6

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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



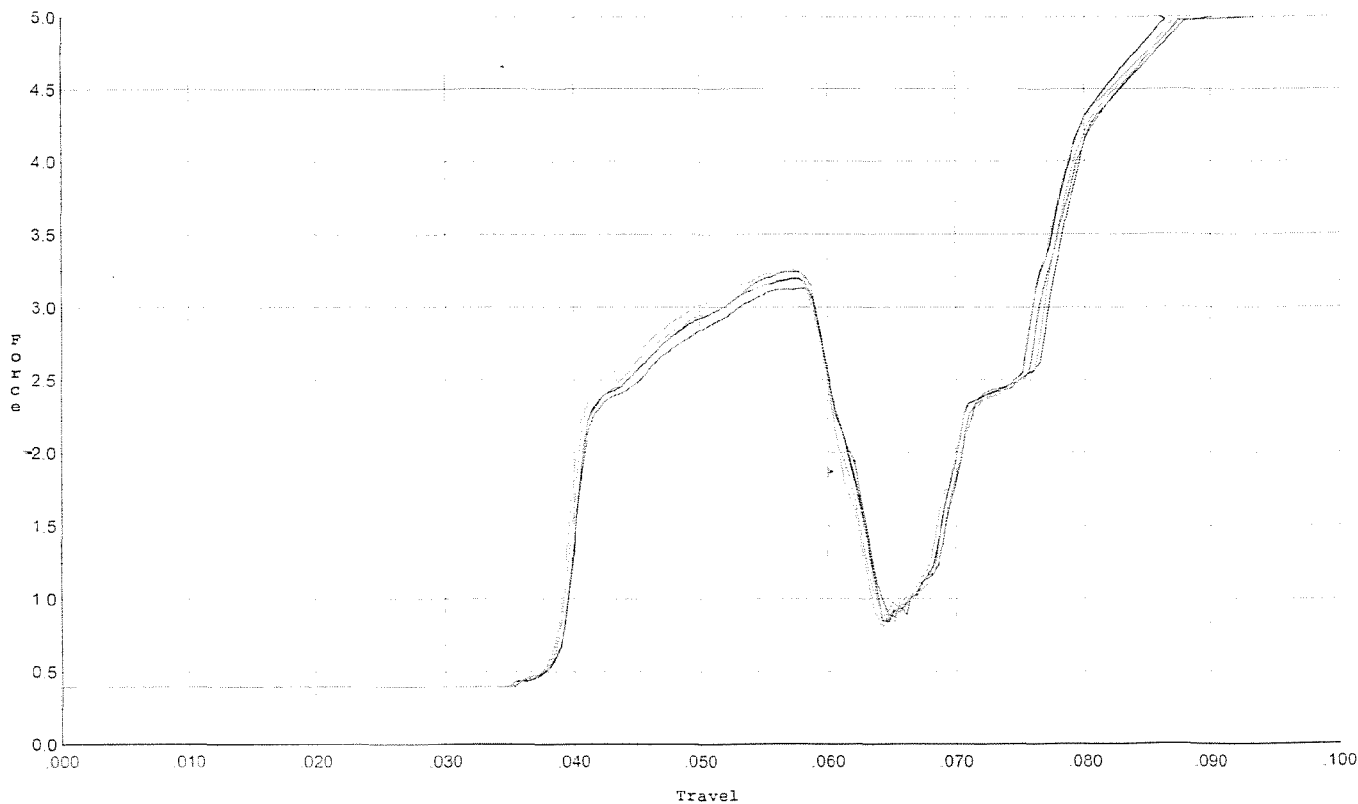
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.323	0.053	0.030	0.032	0.075		Set Trigger
2	3.326	0.053	0.030	0.032	0.074		Set Trigger
3	3.295	0.053	0.030	0.032	0.075		Set Trigger
4	3.287	0.053	0.030	0.031	0.075		Set Trigger
5	3.350	0.050	0.030	0.032	0.072		Set Trigger

A-331

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



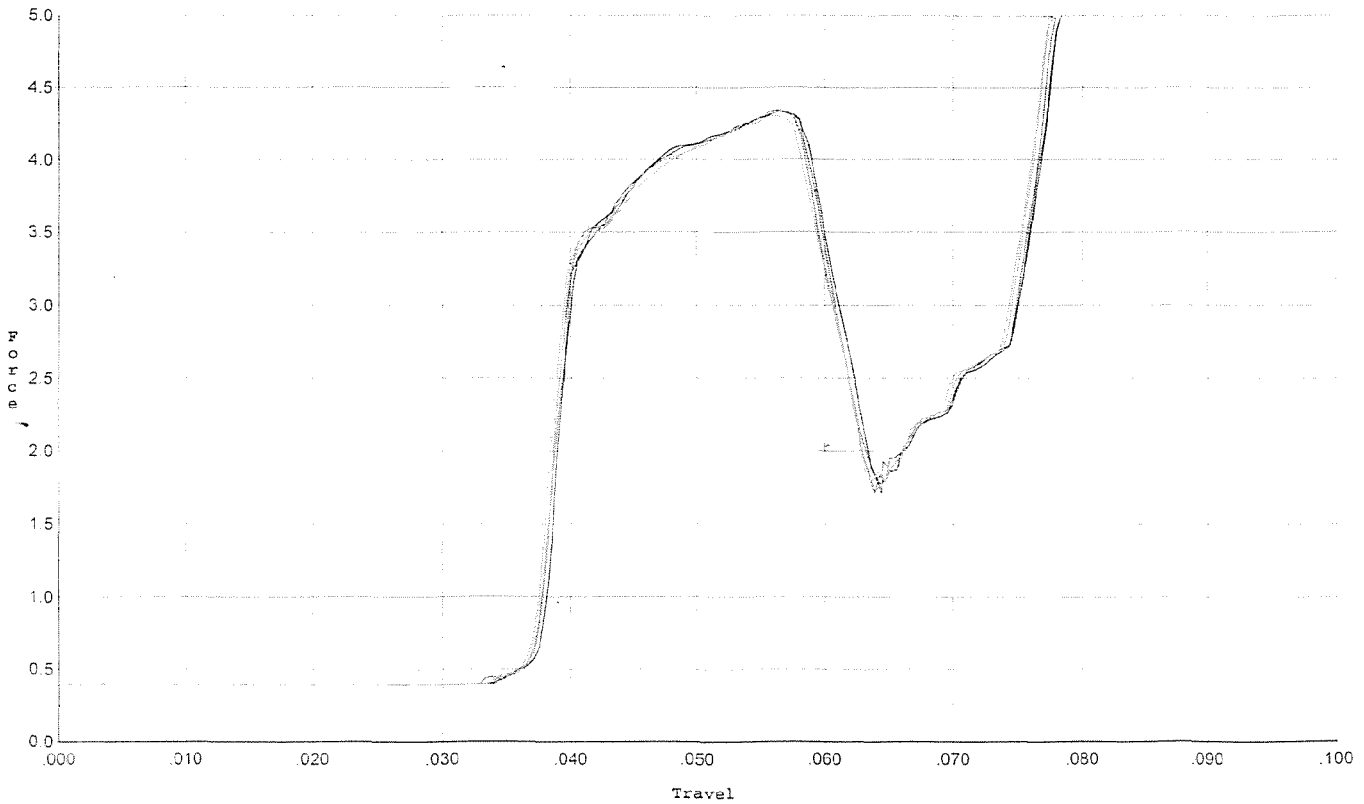
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.062	0.039	0.034	0.076		Set Trigger
2	3.194	0.062	0.039	0.034	0.077		Set Trigger
3	3.243	0.059	0.039	0.035	0.072		Set Trigger
4	3.258	0.059	0.038	0.035	0.074		Set Trigger
5	3.205	0.059	0.039	0.035	0.073		Set Trigger

A-320

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



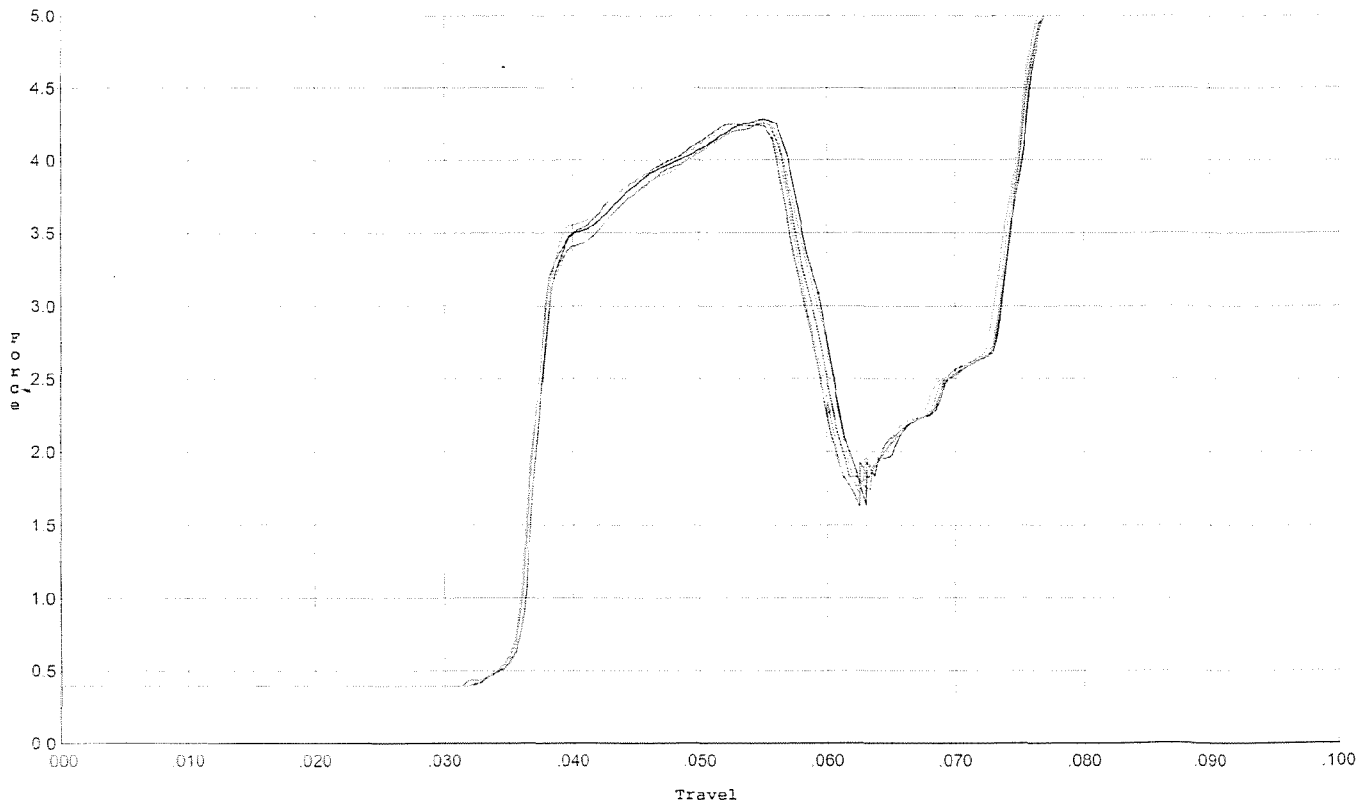
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.333	0.059	0.037	0.031	0.099		Set Trigger
2	4.334	0.059	0.038	0.031	0.098		Set Trigger
3	4.342	0.058	0.037	0.031	0.097		Set Trigger
4	4.302	0.061	0.037	0.029	0.103		Set Trigger
5	4.335	0.058	0.037	0.030	0.096		Set Trigger

A-4.32

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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



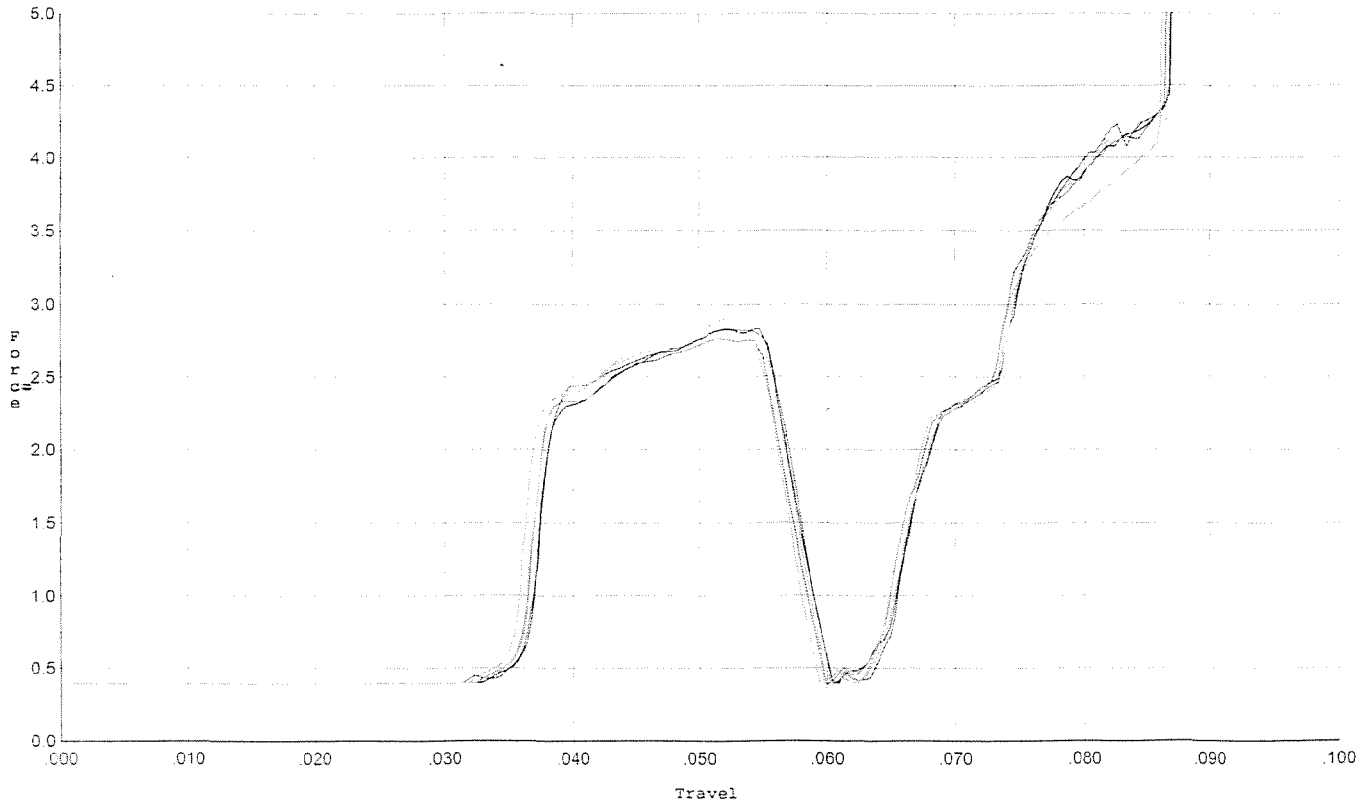
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.056	0.035	0.032	0.092		Set Trigger
2	4.281	0.059	0.036	0.030	0.101		Set Trigger
3	4.255	0.056	0.036	0.032	0.092		Set Trigger
4	4.273	0.057	0.035	0.032	0.095		Set Trigger
5	4.266	0.060	0.035	0.030	0.101		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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



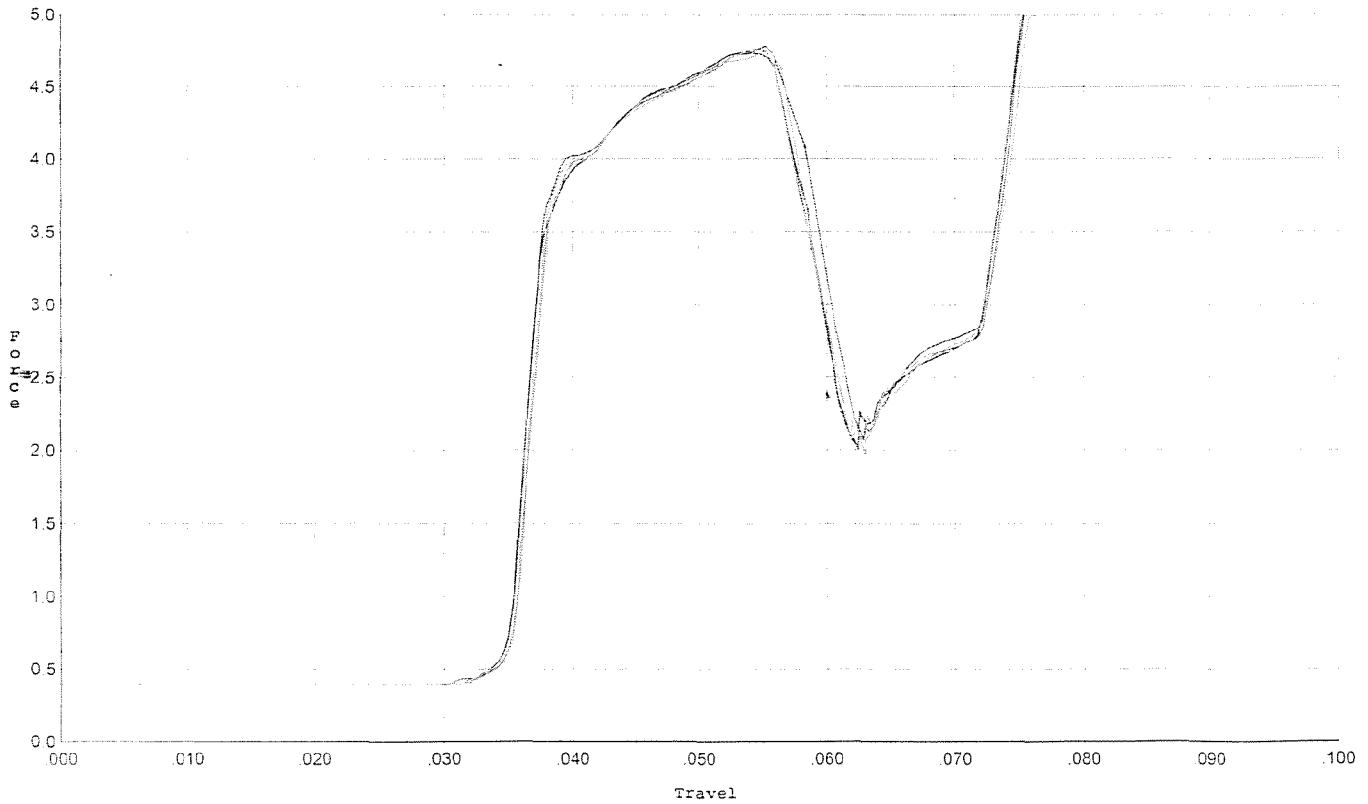
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.834	0.057	0.036	0.036	0.066		Set Trigger
2	2.834	0.055	0.036	0.036	0.064		Set Trigger
3	2.764	0.055	0.036	0.036	0.063		Set Trigger
4	2.904	0.056	0.035	0.036	0.066		Set Trigger
5	2.814	0.055	0.035	0.036	0.065		Set Trigger

A-2-83

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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	4.780	0.058	0.035	0.025	0.112		Set Trigger
2	4.755	0.058	0.035	0.025	0.111		Set Trigger
3	4.730	0.059	0.035	0.026	0.110		Set Trigger
4	4.754	0.056	0.035	0.027	0.105		Set Trigger
5	4.743	0.056	0.035	0.026	0.104		Set Trigger

A- 4.75