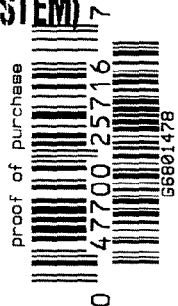


G-680 1478

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

- INSTRUCTION BOOK 3518

BM FORM



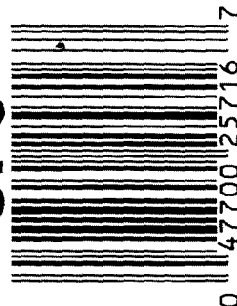
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801478

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801478

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-25-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-23-09	JF
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/25/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	Bt
542	APPLY COATINGS (BARREL ACTION)		3-29	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

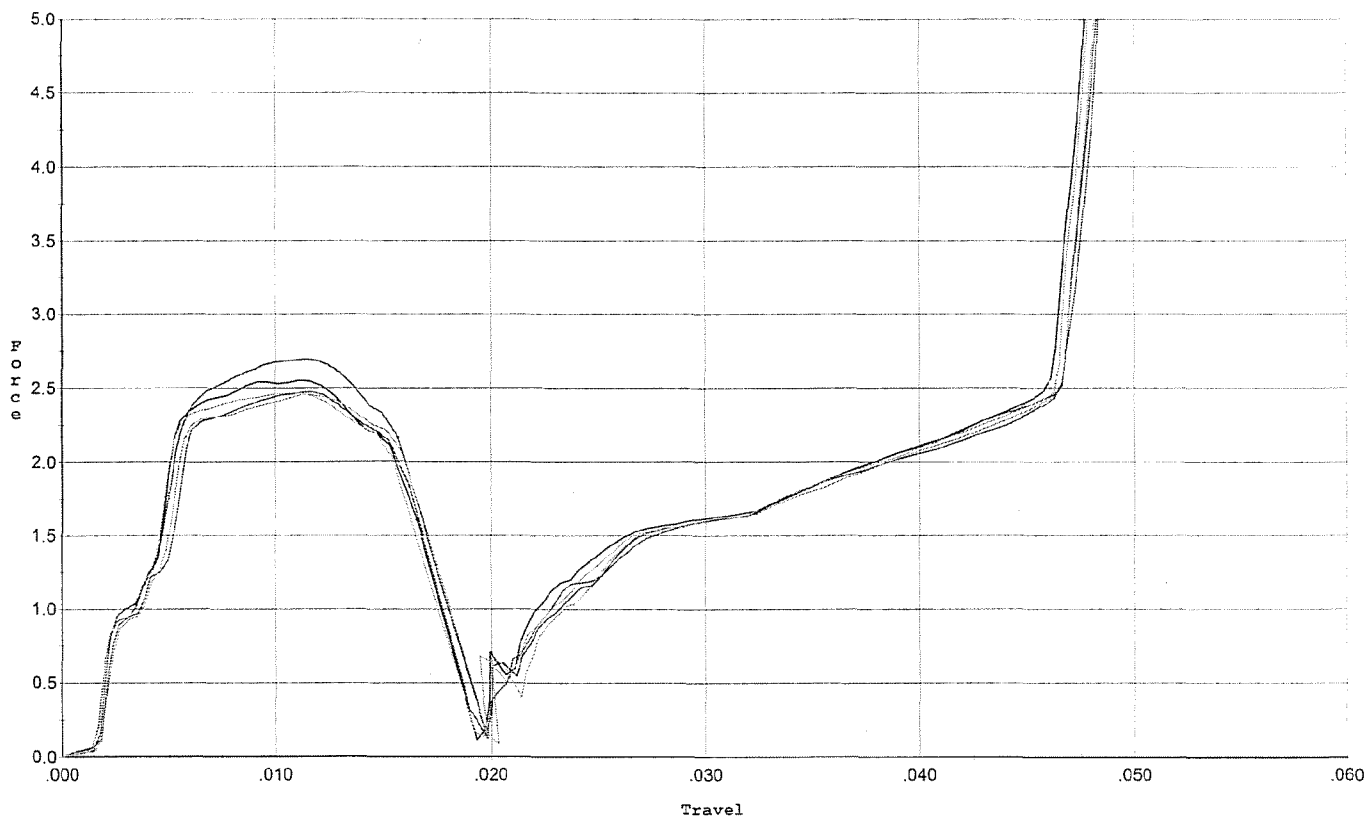
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>7</u> <u>4.5</u>	4-17-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-17-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	4-17-09	NW
	J) ASSEMBLE STOCK		4-2-09	SPN
	K) ASSEMBLE SWIVEL STUDS		4-17-09	NW
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	4-7-09	NW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-7-09	TAR
670	FINAL INSPECTION A) HEADSPACE		4-17-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.77</u> <u>2.87</u> <u>2.78</u> <u>2.73</u>	4-14-09	NW
	C) FUNCTION		4-17-09	NW
690	PACK		5/30/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



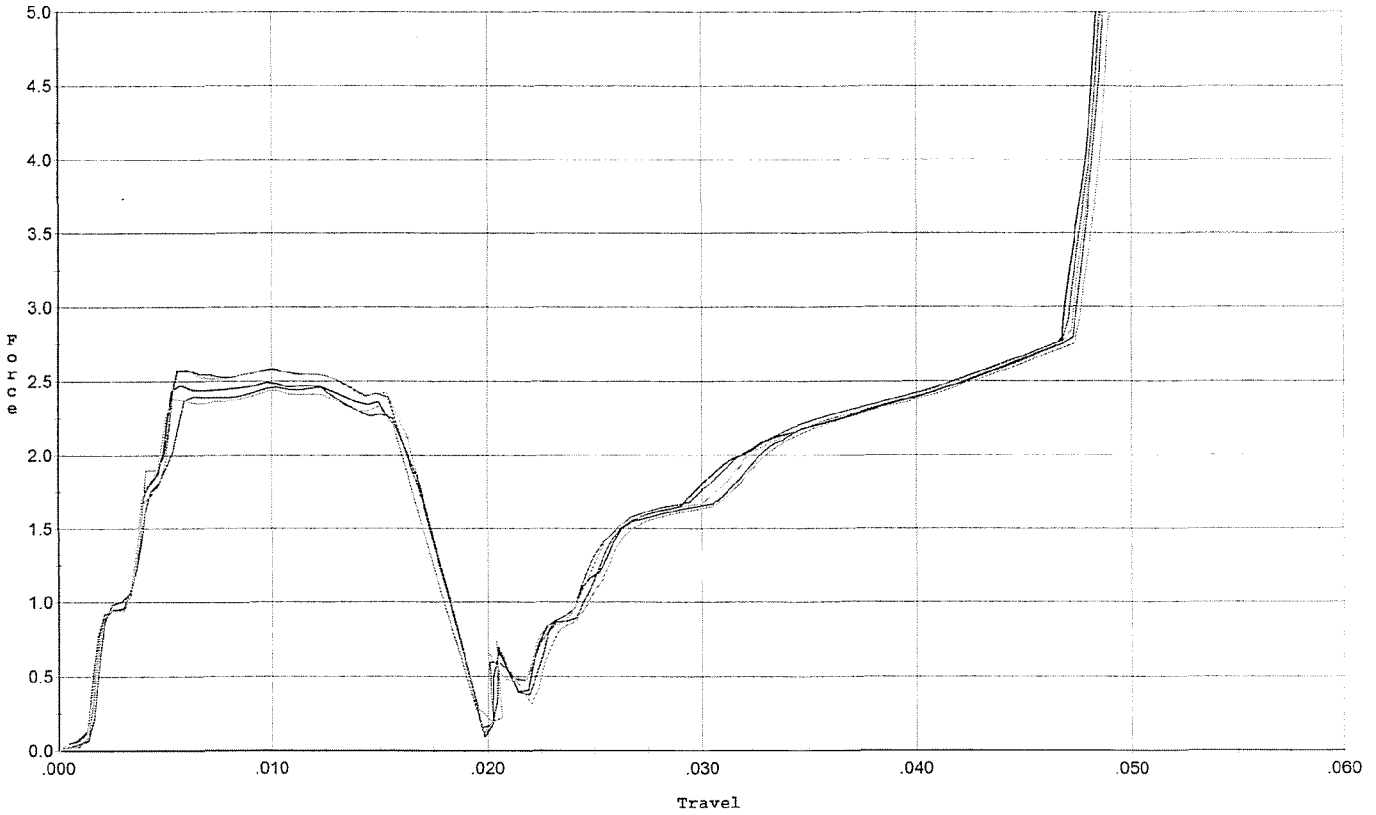
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.694	0.016	0.00	0.036	0.028		Set Trigger
2	2.553	0.017	0.00	0.036	0.029		Set Trigger
3	2.473	0.016	0.00	0.036	0.027		Set Trigger
4	2.466	0.017	0.00	0.036	0.029		Set Trigger
5	2.455	0.018	0.00	0.036	0.029		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



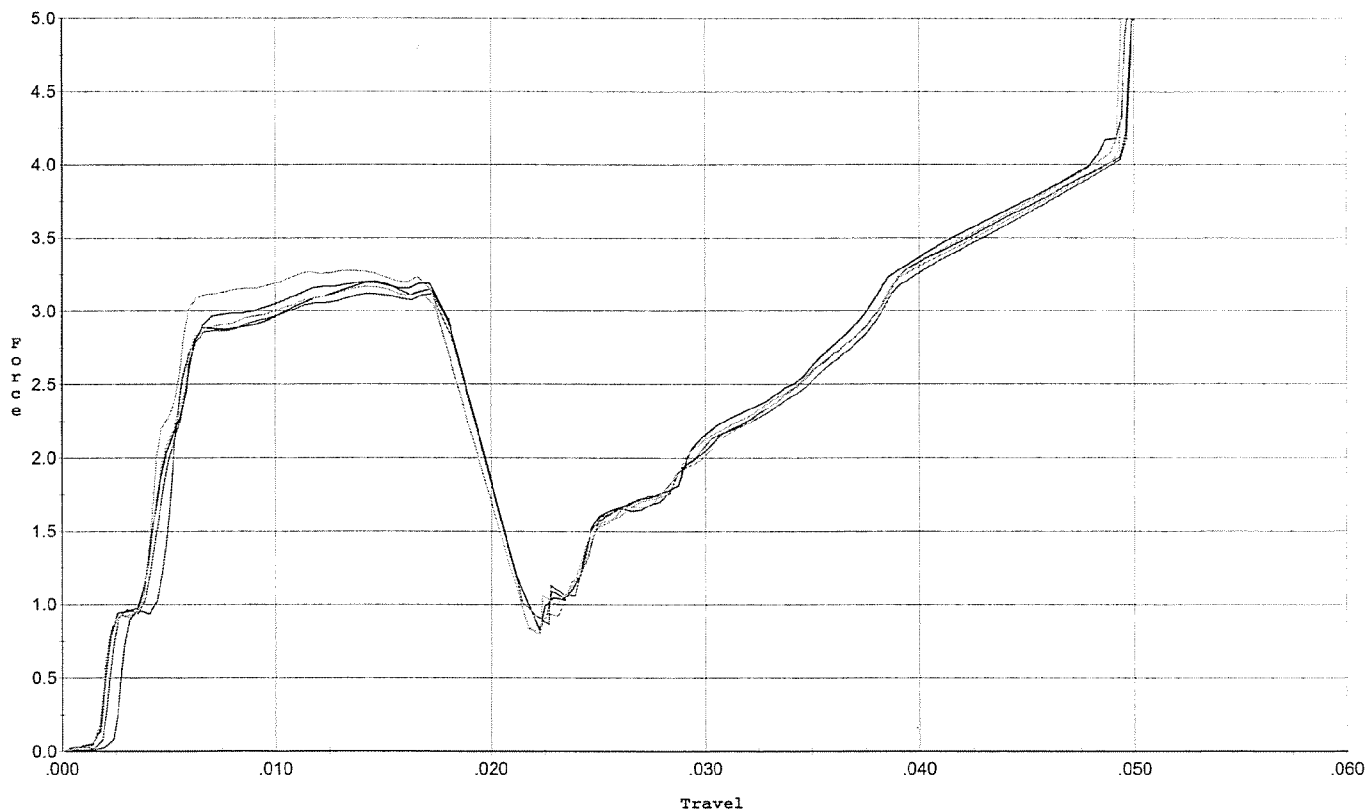
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.017	0.00	0.036	0.029		Set Trigger
2	2.491	0.016	0.00	0.036	0.028		Set Trigger
3	2.580	0.017	0.00	0.035	0.031		Set Trigger
4	2.436	0.016	0.00	0.036	0.028		Set Trigger
5	2.587	0.016	0.00	0.036	0.030		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 2/27/2009

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



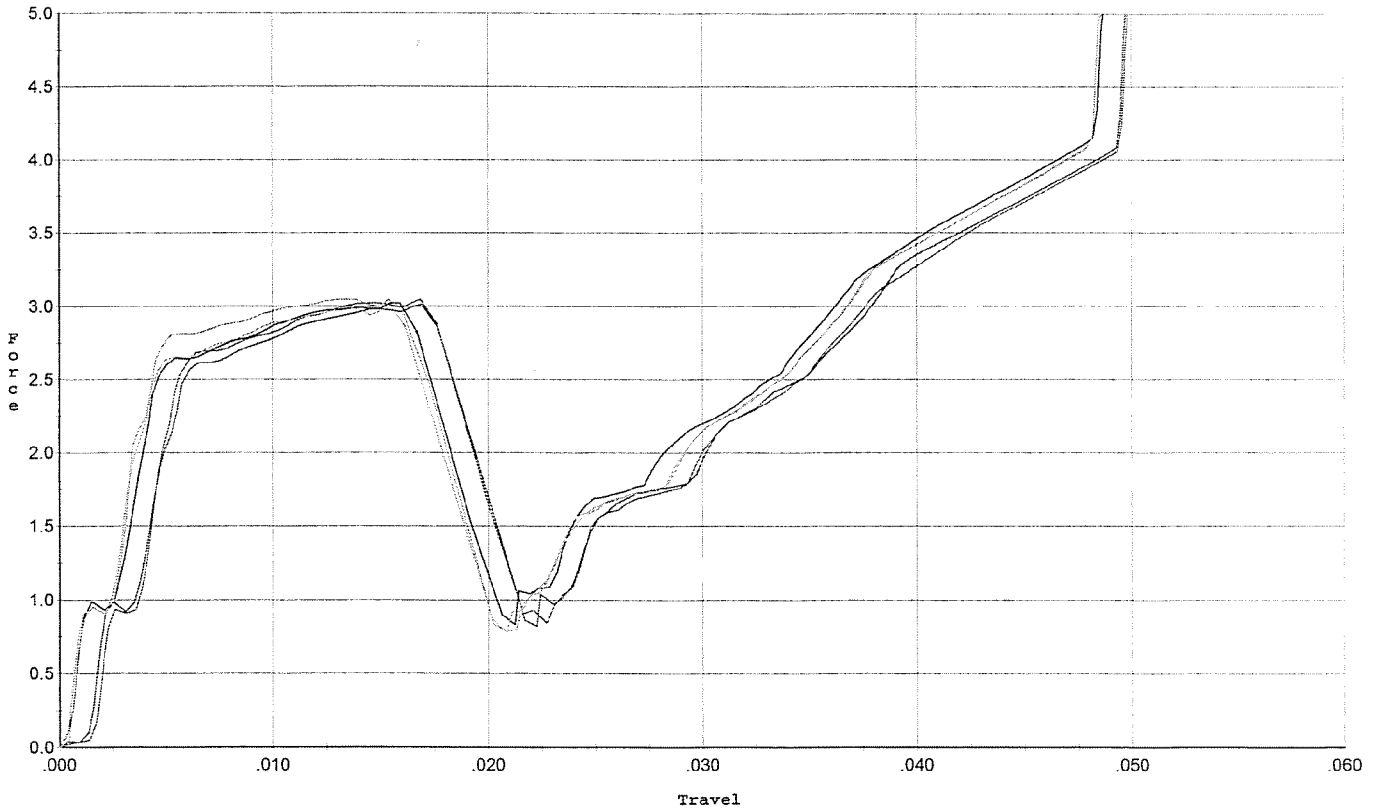
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.204	0.018	0.003	0.033	0.039		Set Trigger
2	3.193	0.018	0.00	0.033	0.040		Set Trigger
3	3.119	0.018	0.00	0.033	0.040		Set Trigger
4	3.169	0.017	0.00	0.034	0.038		Set Trigger
5	3.277	0.017	0.00	0.033	0.040		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



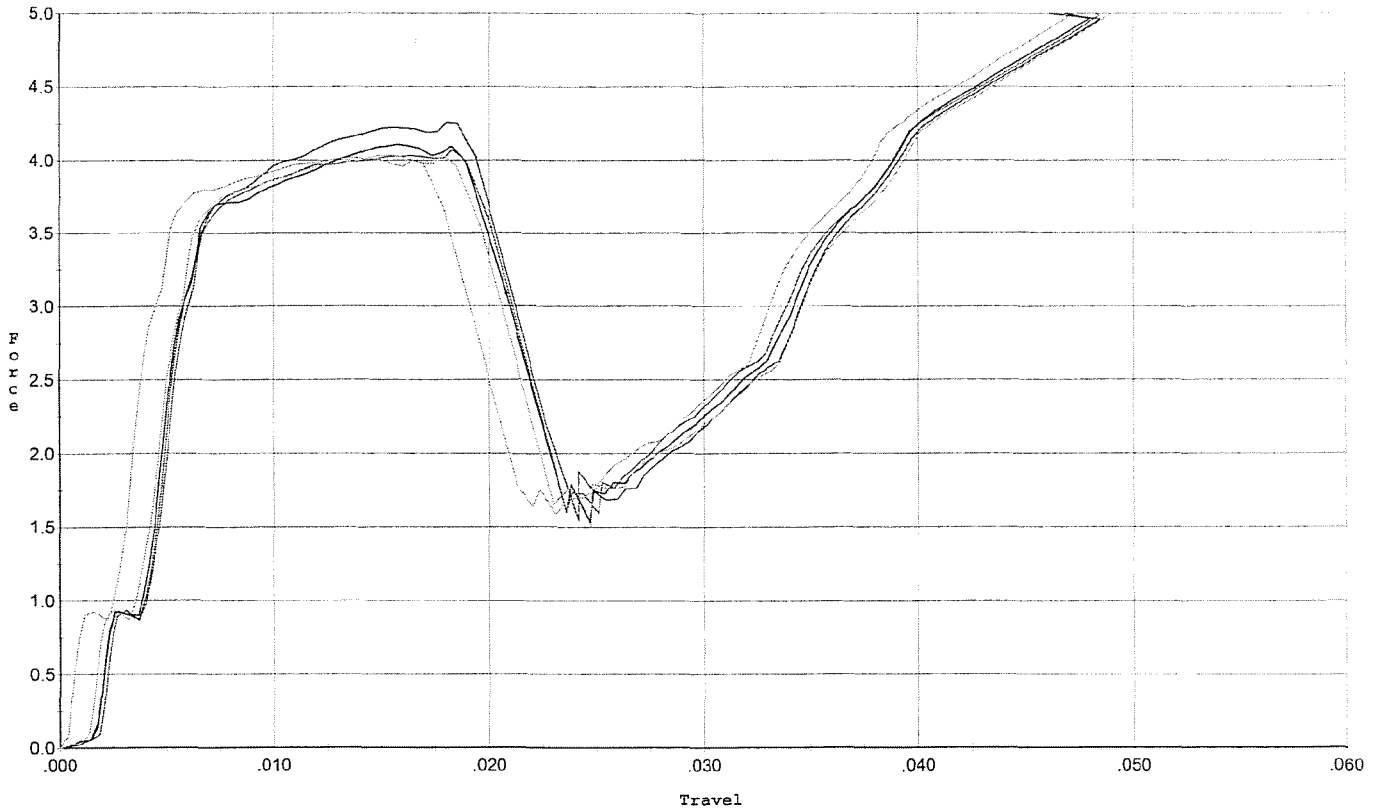
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.014	0.020	0.00	0.033	0.041		Set Trigger
2	3.021	0.017	0.00	0.034	0.037		Set Trigger
3	3.048	0.018	0.00	0.034	0.037		Set Trigger
4	3.004	0.016	0.00	0.034	0.036		Set Trigger
5	3.048	0.017	0.00	0.033	0.039		Set Trigger

A-3.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



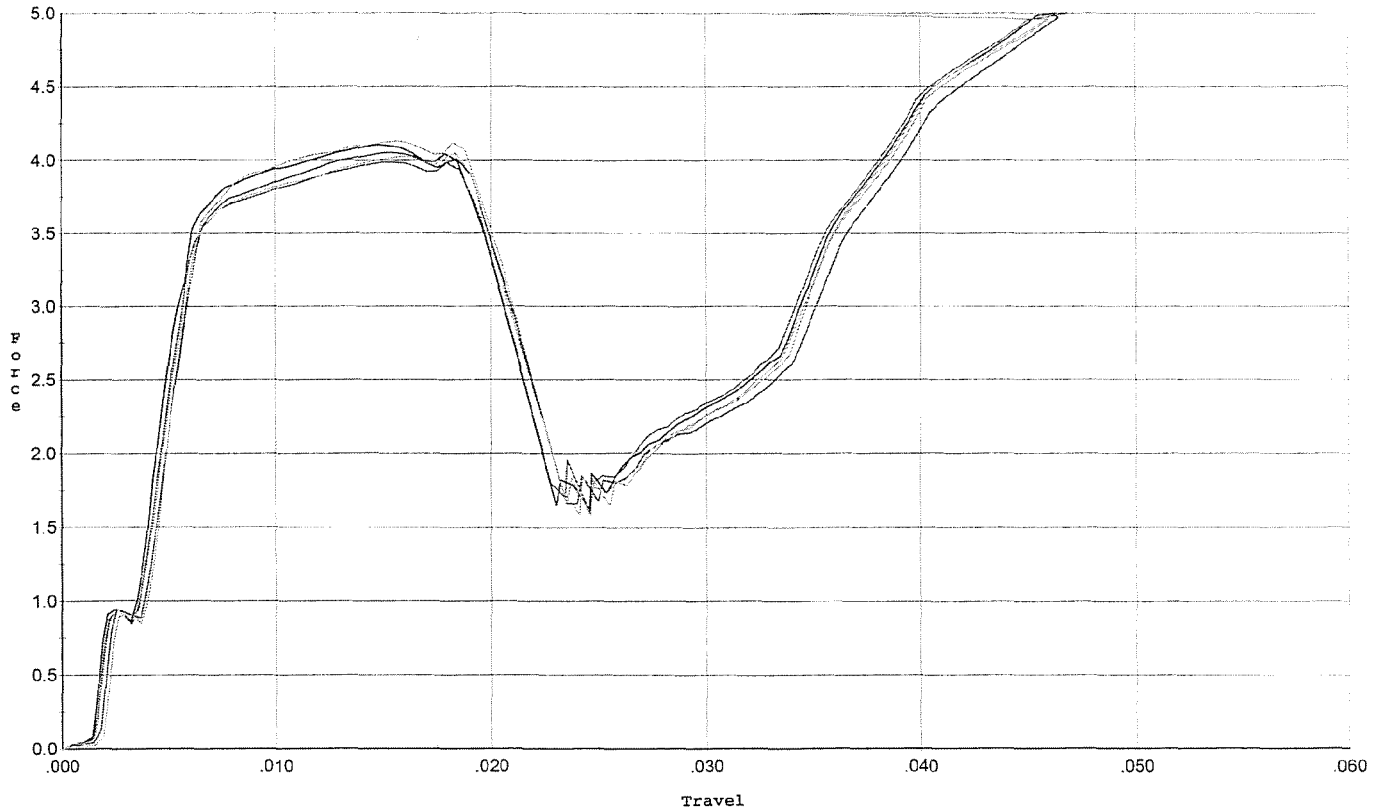
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.256	0.019	0.004	0.031	0.056		Set Trigger
2	4.107	0.021	0.004	0.030	0.058		Set Trigger
3	4.071	0.020	0.00	0.030	0.056		Set Trigger
4	4.038	0.020	0.00	0.031	0.055		Set Trigger
5	4.017	0.018	0.00	0.031	0.053		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



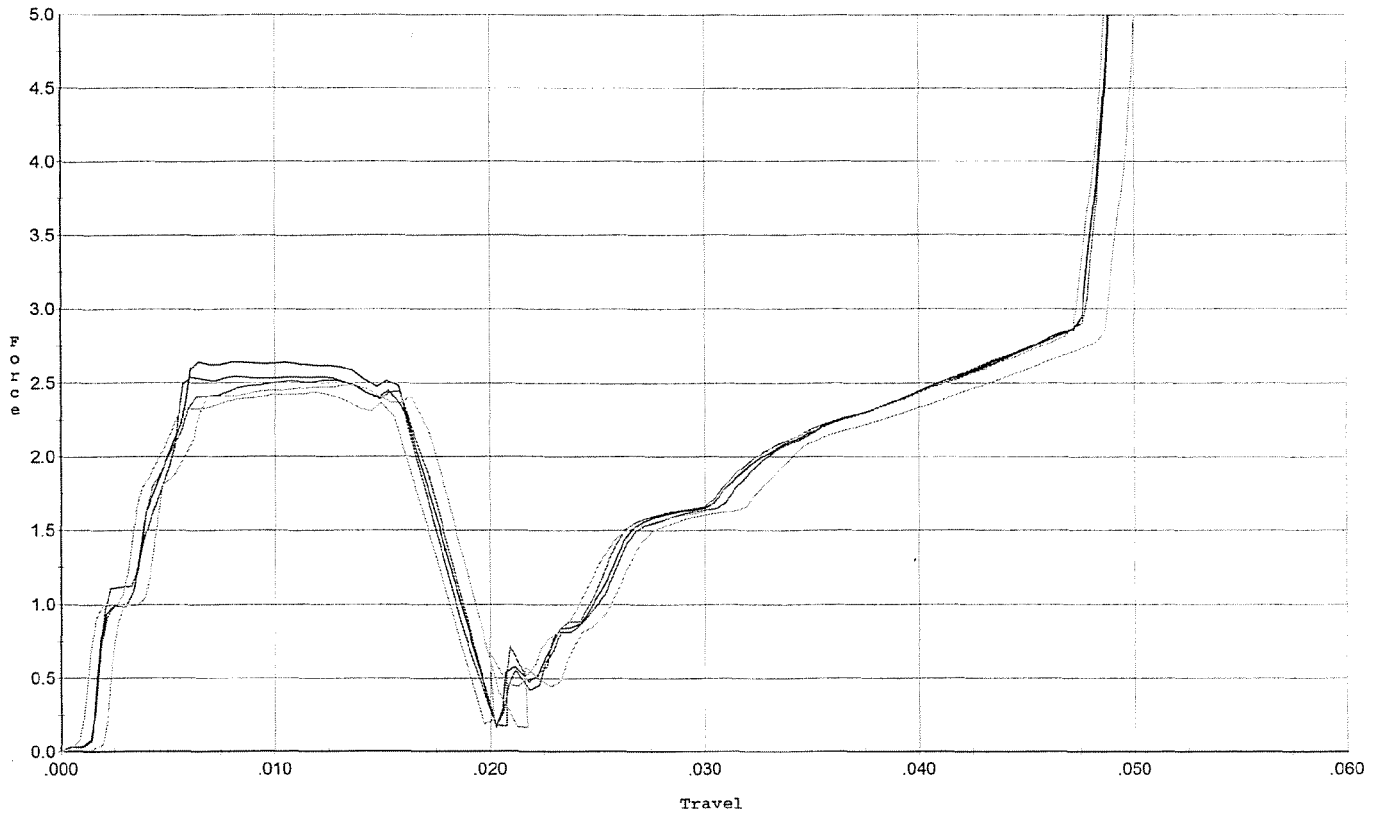
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.021	0.004	0.031	0.058		Set Trigger
2	4.104	0.020	0.00	0.031	0.056		Set Trigger
3	3.985	0.020	0.00	0.031	0.054		Set Trigger
4	4.048	0.019	0.00	0.031	0.053		Set Trigger
5	4.128	0.020	0.002	0.031	0.058		Set Trigger

A. 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



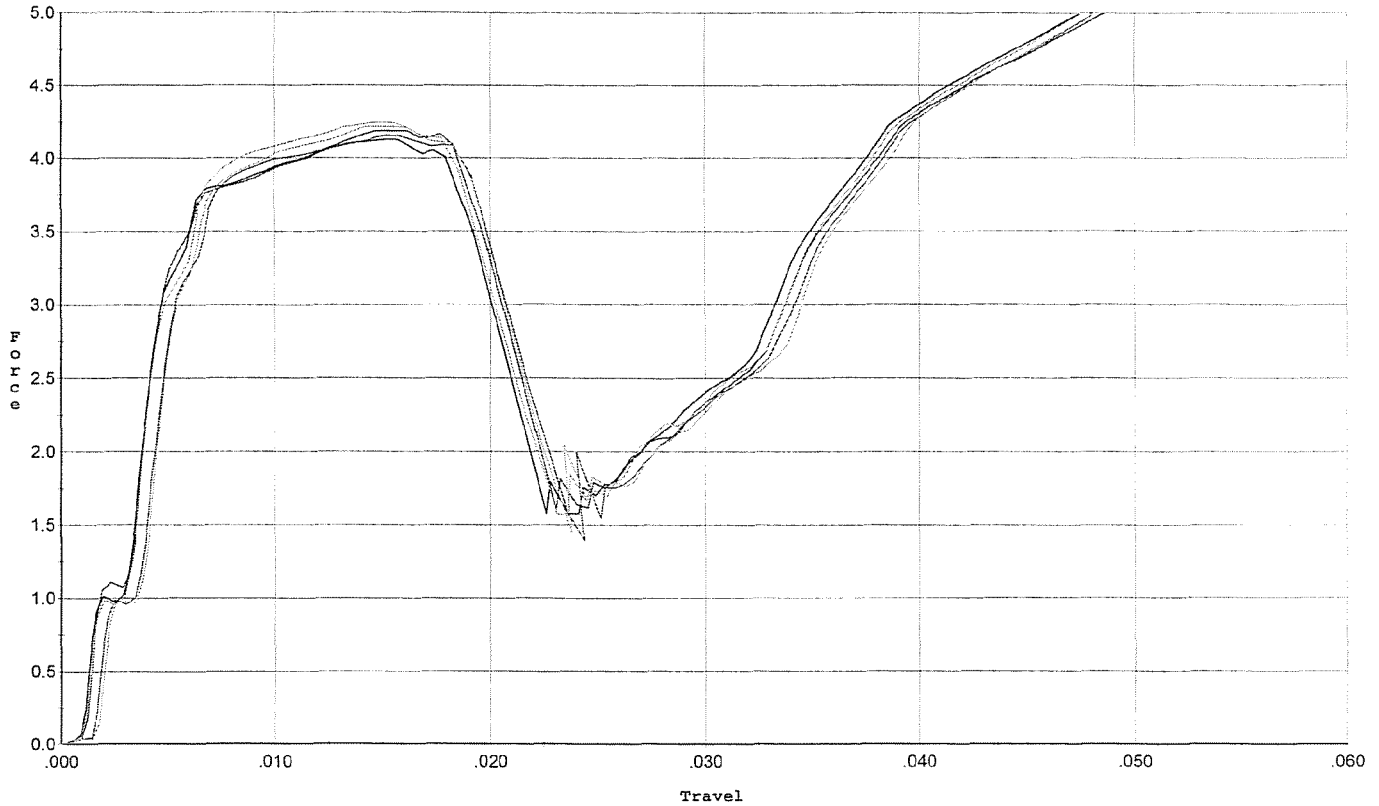
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.016	0.00	0.036	0.030		Set Trigger
2	2.645	0.018	0.00	0.035	0.034		Set Trigger
3	2.519	0.017	0.00	0.035	0.032		Set Trigger
4	2.485	0.017	0.002	0.036	0.030		Set Trigger
5	2.440	0.017	0.00	0.036	0.032		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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	4.188	0.020	0.00	0.030	0.059		Set Trigger
2	4.128	0.019	0.00	0.031	0.056		Set Trigger
3	4.156	0.019	0.00	0.031	0.055		Set Trigger
4	4.215	0.019	0.00	0.031	0.055		Set Trigger
5	4.245	0.019	0.00	0.031	0.055		Set Trigger

A. 4.18