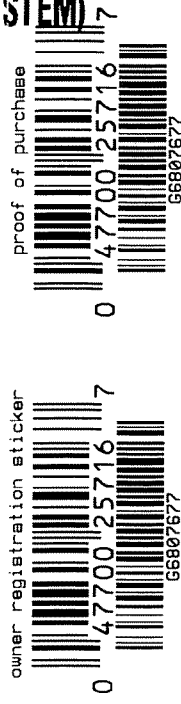


G6807677

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

- INSTRUCTION BOOK 3518

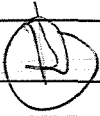
BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6807677	
UPC	

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807677

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RT
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-27-09	H
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-27-09	RT
520	GOFF BLAST BBL / REC		3-27	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-22-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

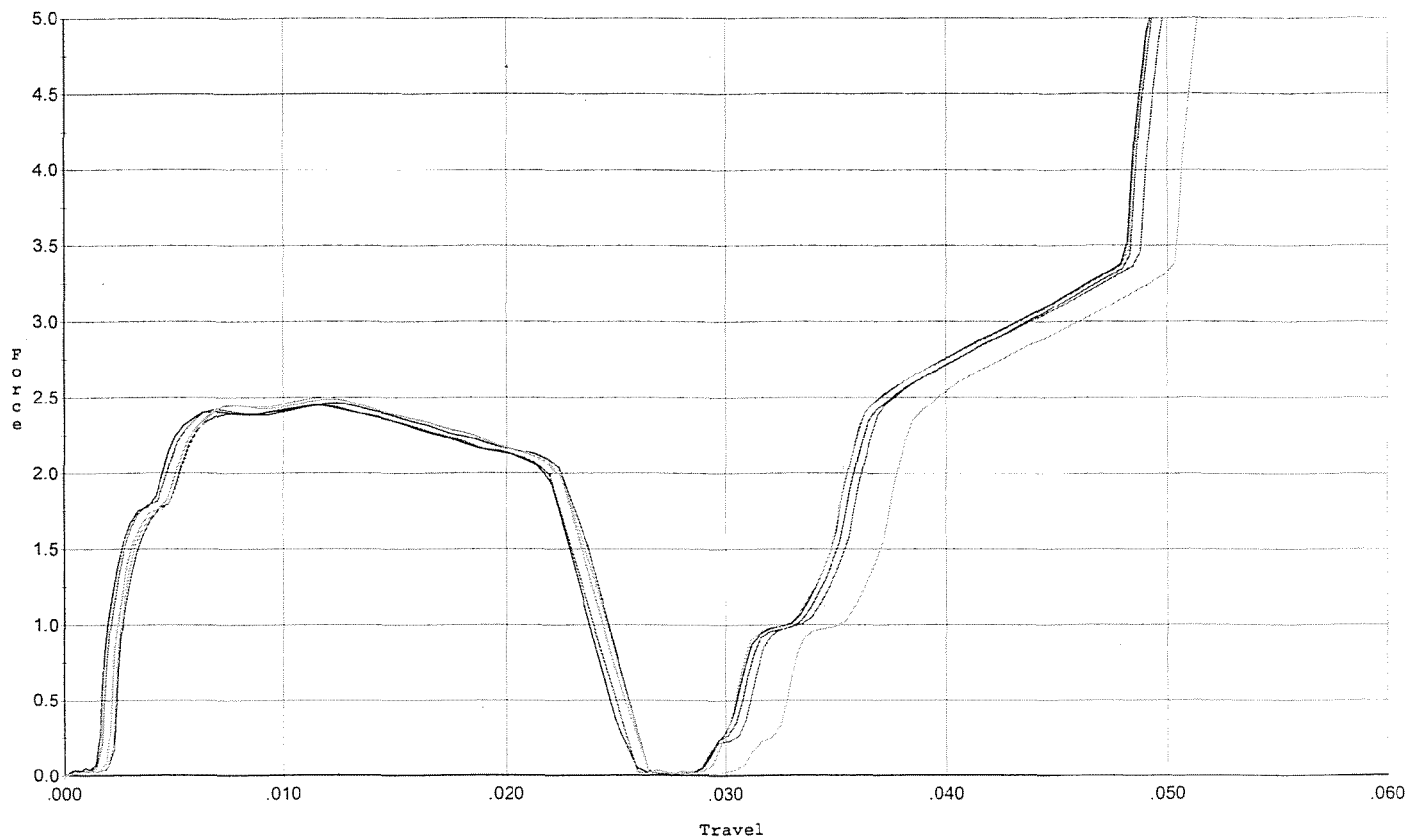
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	5-6-09	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	5-6-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-6-09	LJN
	J) ASSEMBLE STOCK		4-22-09	LJN
	K) ASSEMBLE SWIVEL STUDS		5-6-09	LJN
	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	4-24-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		5-6-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.65</u> <u>2.65</u> <u>2.63</u> <u>2.65</u>	4-28-09	NW
	C) FUNCTION		5-6-09	LJN
690	PACK		5-29-09	NW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



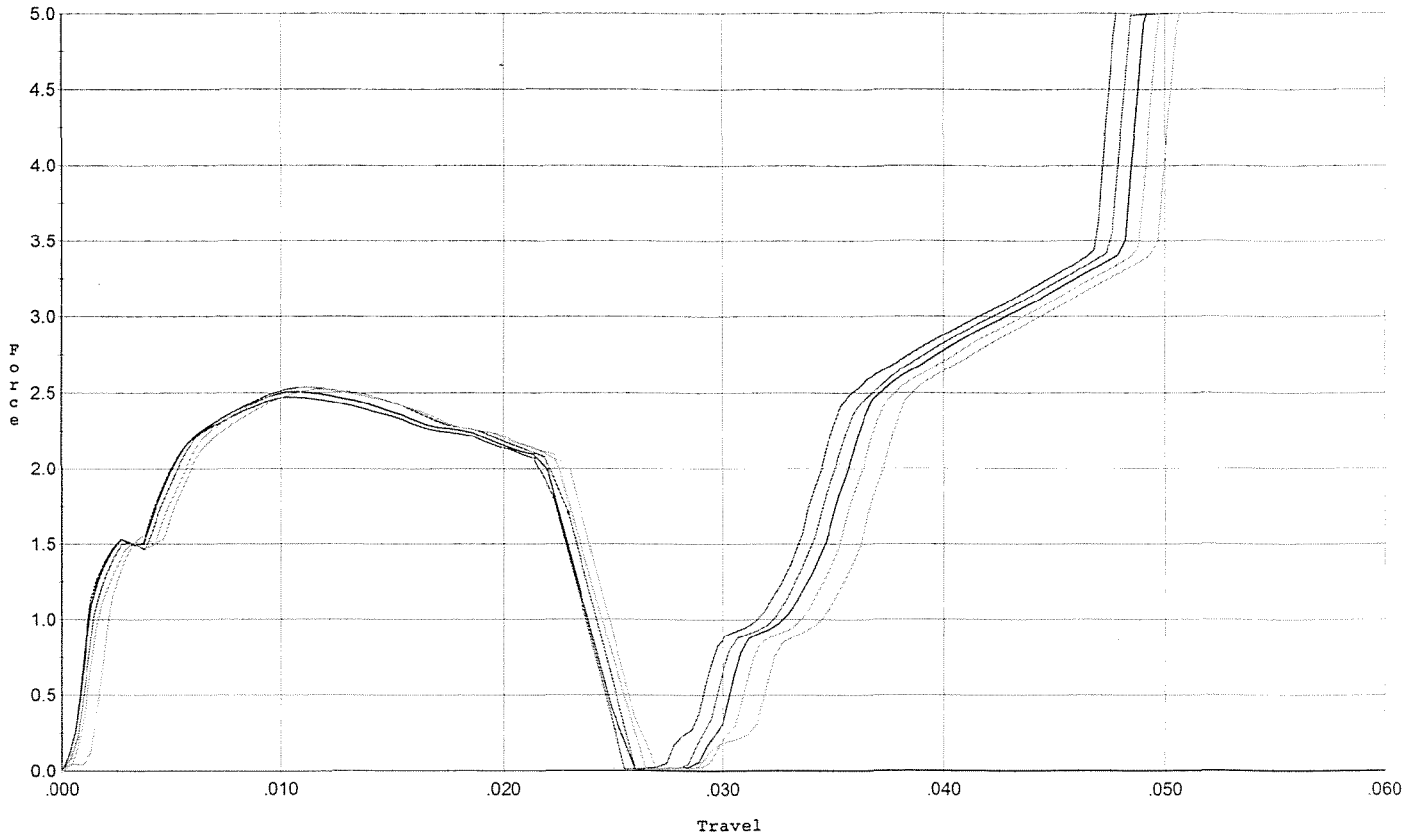
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.463	0.024	0.00	0.032	0.044		Set Trigger
2	2.445	0.022	0.00	0.032	0.043		Set Trigger
3	2.453	0.022	0.00	0.033	0.042		Set Trigger
4	2.486	0.024	0.00	0.034	0.045		Set Trigger
5	2.496	0.022	0.002	0.032	0.043		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



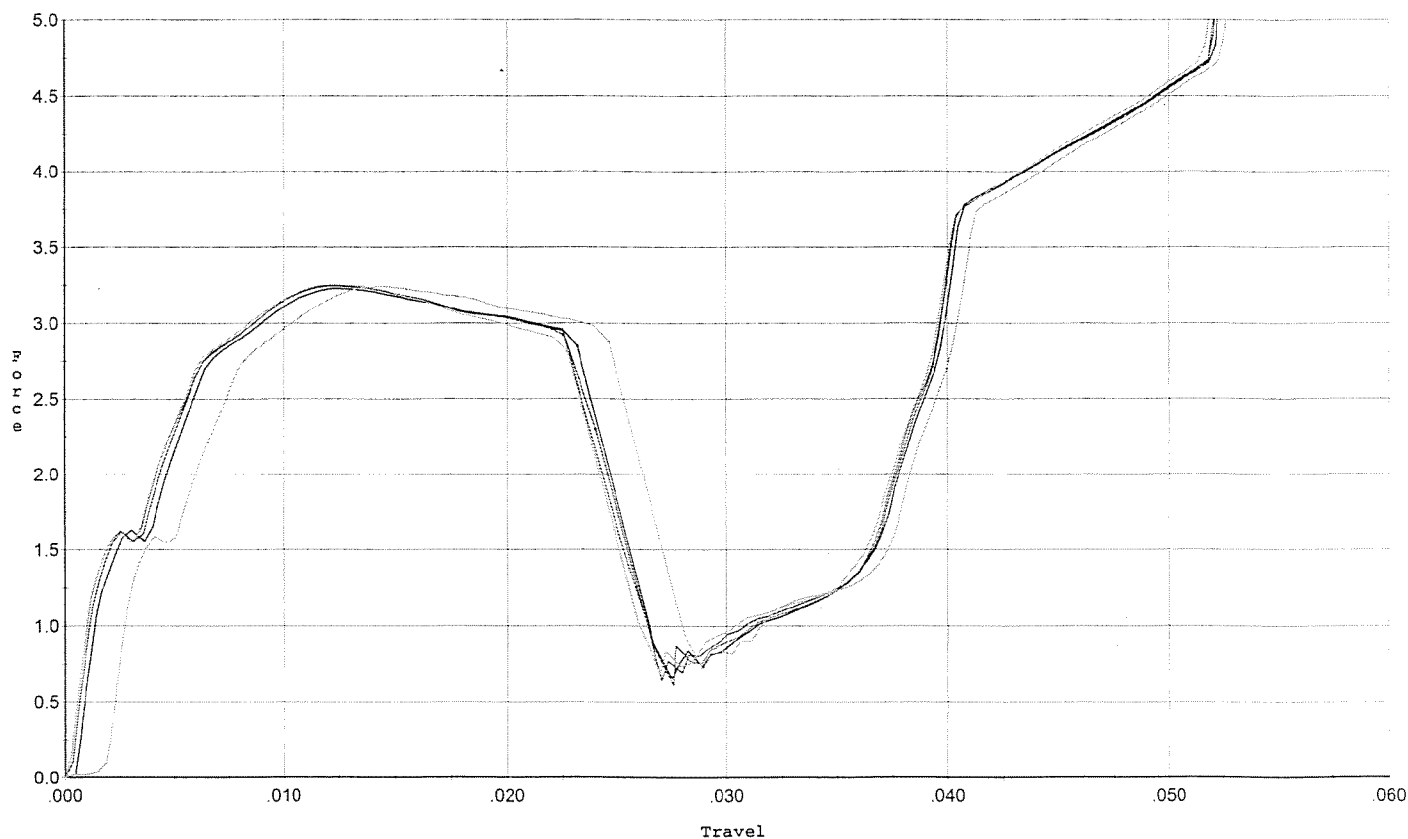
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.470	0.022	0.00	0.031	0.043		Set Trigger
2	2.507	0.022	0.004	0.033	0.043		Set Trigger
3	2.536	0.023	0.004	0.032	0.045		Set Trigger
4	2.537	0.022	0.00	0.033	0.044		Set Trigger
5	2.520	0.023	0.00	0.033	0.044		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



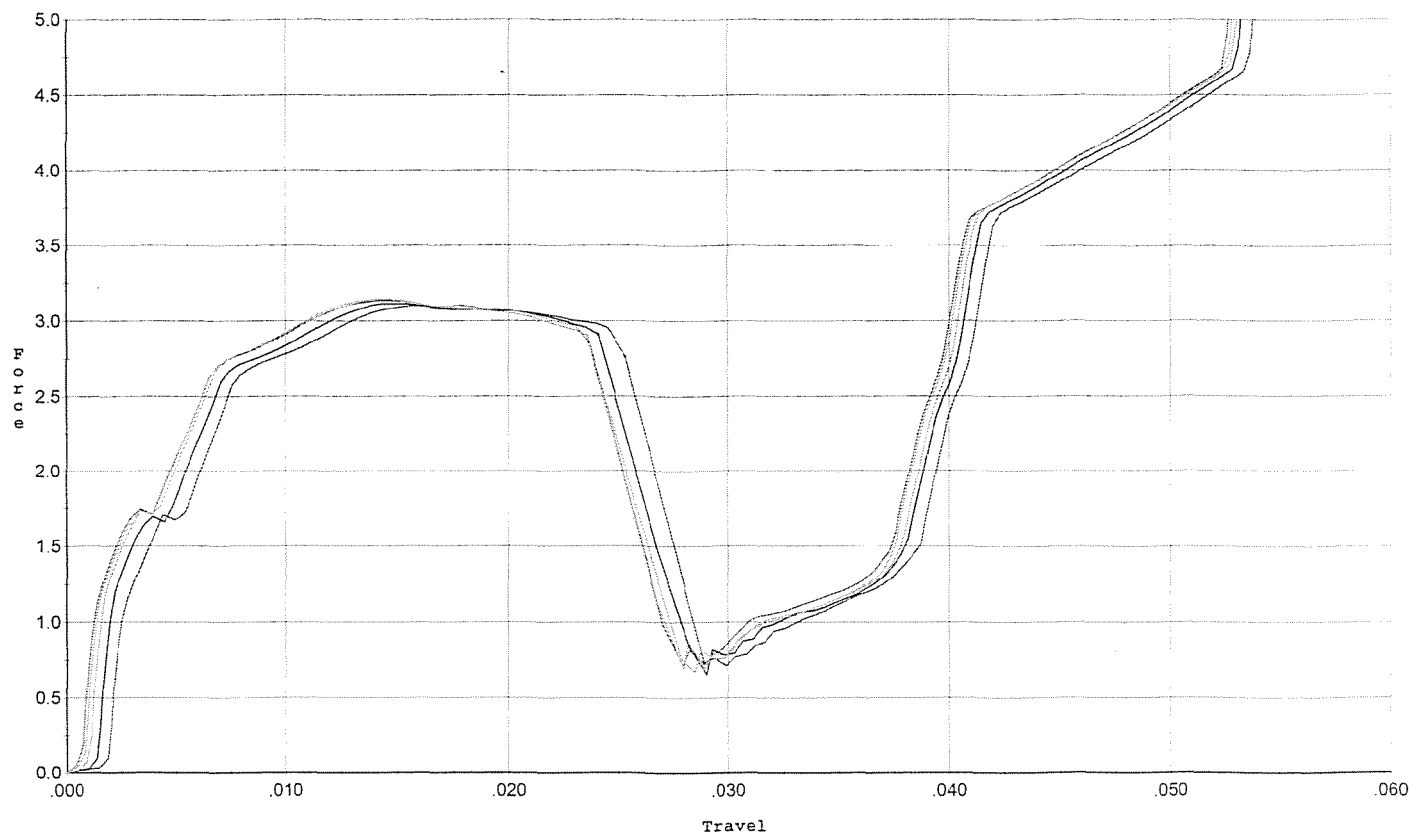
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.245	0.024	0.00	0.033	0.060		Set Trigger
2	3.228	0.023	0.00	0.033	0.057		Set Trigger
3	3.244	0.023	0.00	0.033	0.057		Set Trigger
4	3.252	0.023	0.00	0.033	0.057		Set Trigger
5	3.239	0.025	0.00	0.032	0.058		Set Trigger

Aug 3.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



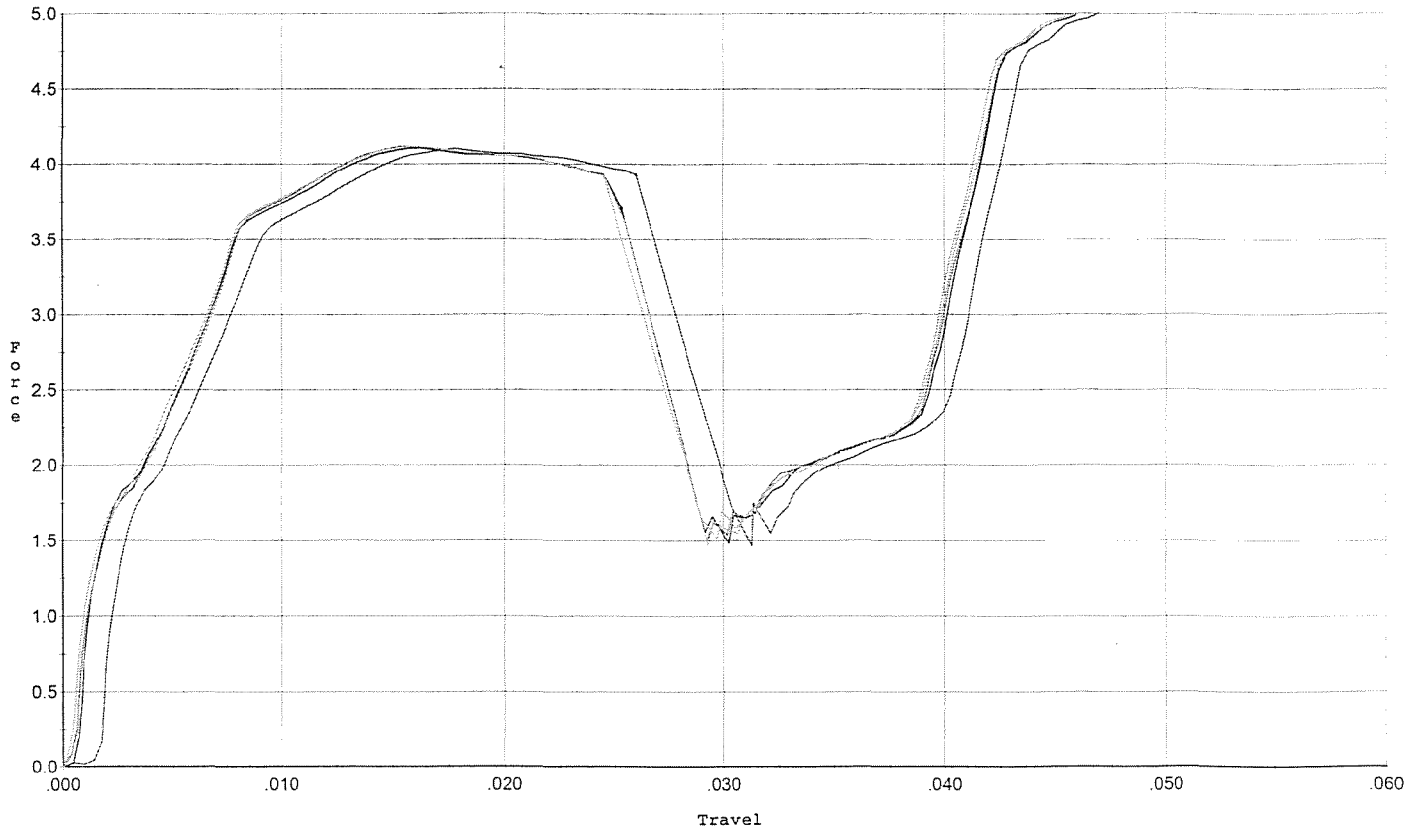
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.097	0.025	0.00	0.033	0.059		Set Trigger
2	3.112	0.024	0.00	0.033	0.057		Set Trigger
3	3.133	0.024	0.00	0.033	0.058		Set Trigger
4	3.145	0.024	0.00	0.033	0.058		Set Trigger
5	3.143	0.024	0.00	0.033	0.057		Set Trigger

Aug 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



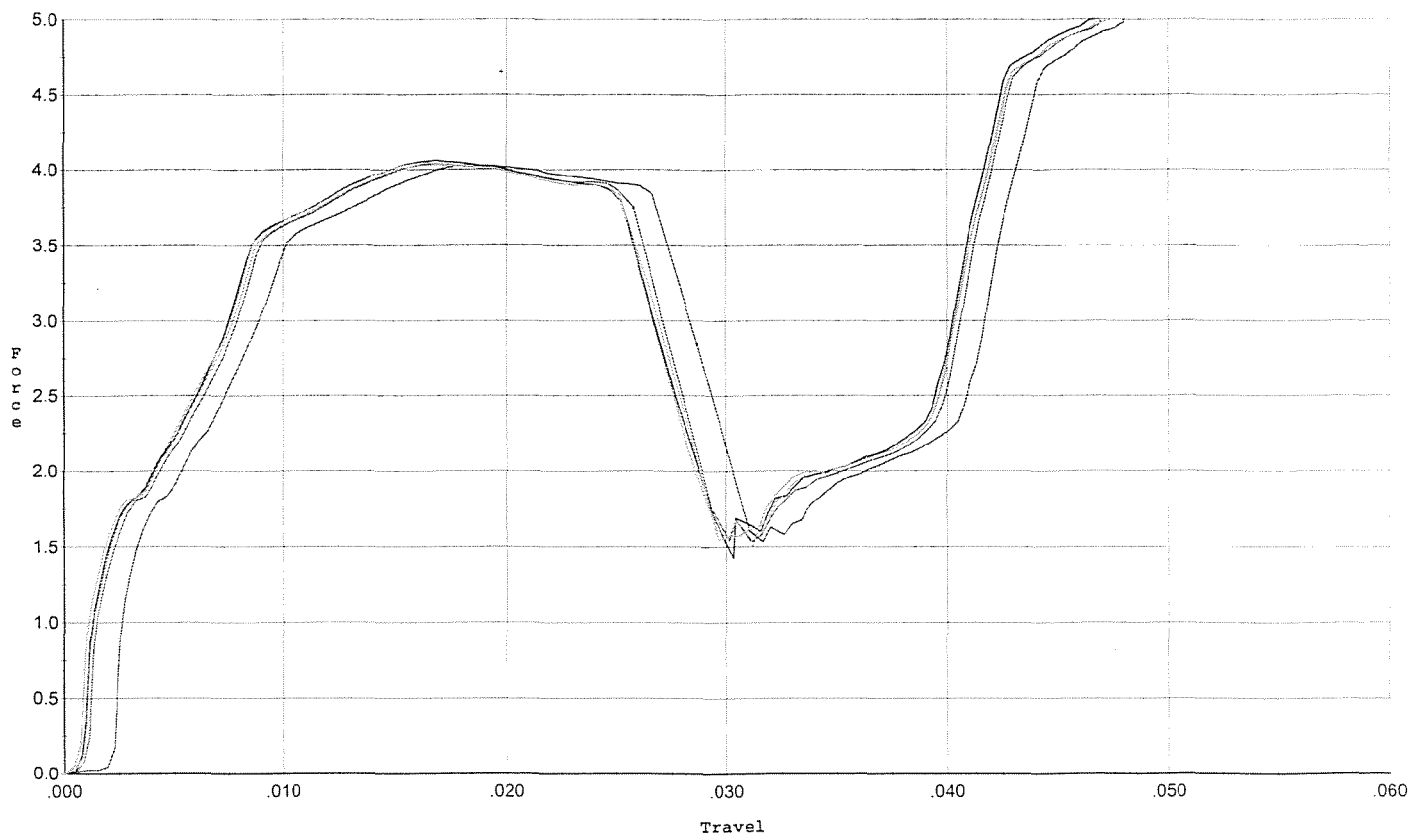
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.026	0.00	0.028	0.078		Set Trigger
2	4.106	0.025	0.00	0.029	0.079		Set Trigger
3	4.120	0.025	0.00	0.030	0.079		Set Trigger
4	4.118	0.025	0.00	0.030	0.077		Set Trigger
5	4.113	0.025	0.00	0.030	0.079		Set Trigger

Aug 4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



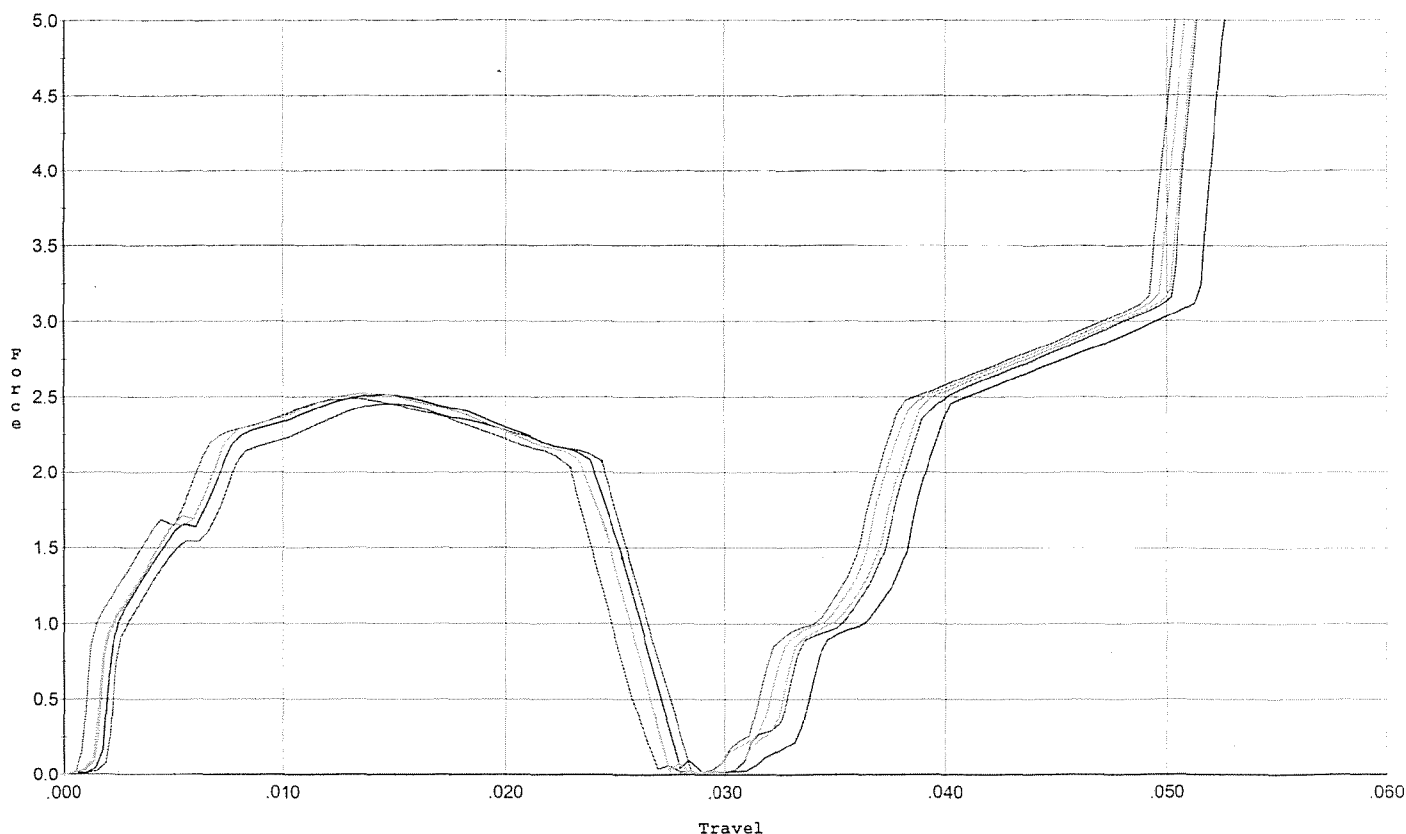
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.031	0.029	0.00	0.026	0.083		Set Trigger
2	4.060	0.025	0.00	0.030	0.076		Set Trigger
3	4.041	0.026	0.00	0.029	0.077		Set Trigger
4	4.031	0.027	0.00	0.030	0.081		Set Trigger
5	4.047	0.025	0.00	0.030	0.077		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

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



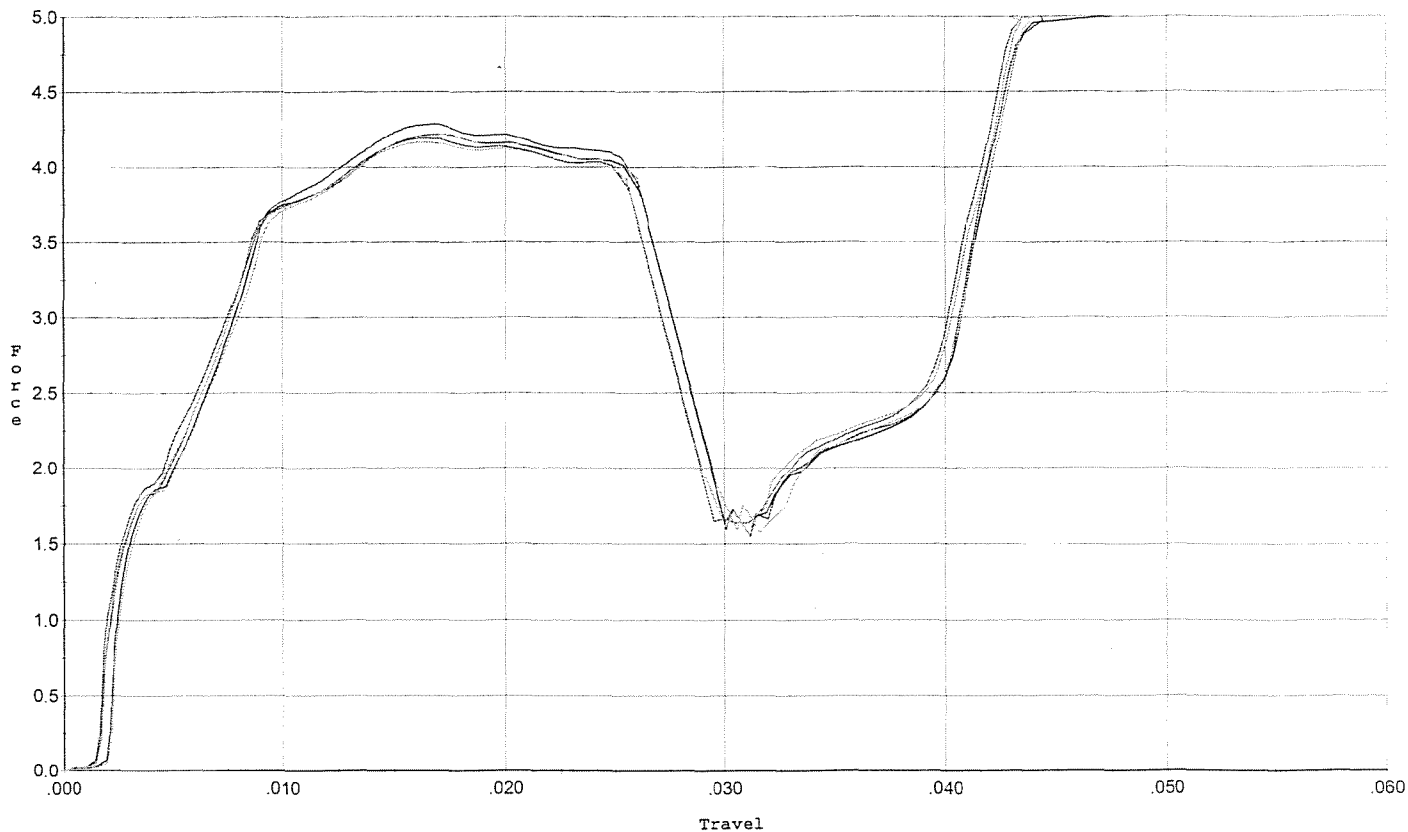
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.024	0.00	0.033	0.044		Set Trigger
2	2.515	0.025	0.00	0.034	0.047		Set Trigger
3	2.487	0.023	0.00	0.033	0.044		Set Trigger
4	2.523	0.025	0.00	0.033	0.046		Set Trigger
5	2.522	0.025	0.00	0.032	0.046		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 2/16/09

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.288	0.026	0.00	0.026	0.081		Set Trigger
2	4.216	0.026	0.00	0.026	0.079		Set Trigger
3	4.190	0.026	0.00	0.029	0.078		Set Trigger
4	4.218	0.026	0.00	0.026	0.078		Set Trigger
5	4.165	0.026	0.00	0.029	0.077		Set Trigger

AVG 4.21