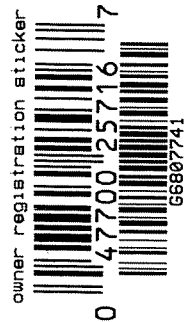
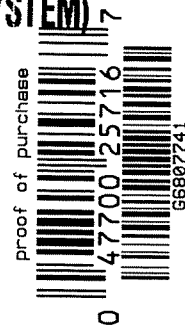


1744 0894

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

- INSTRUCTION BOOK 3518

BM FORM

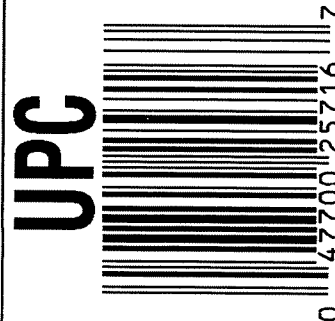


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807741



INSPECTION CHECKLIST NEW GUNS

GUN SERIAL # G 6807741

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX EXPIRATION DATE 10/2009 OPERATOR JD	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION		3/13/09	SP
490	MAGNAFLUX BOLT		3/13/09	mk
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		7/24	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

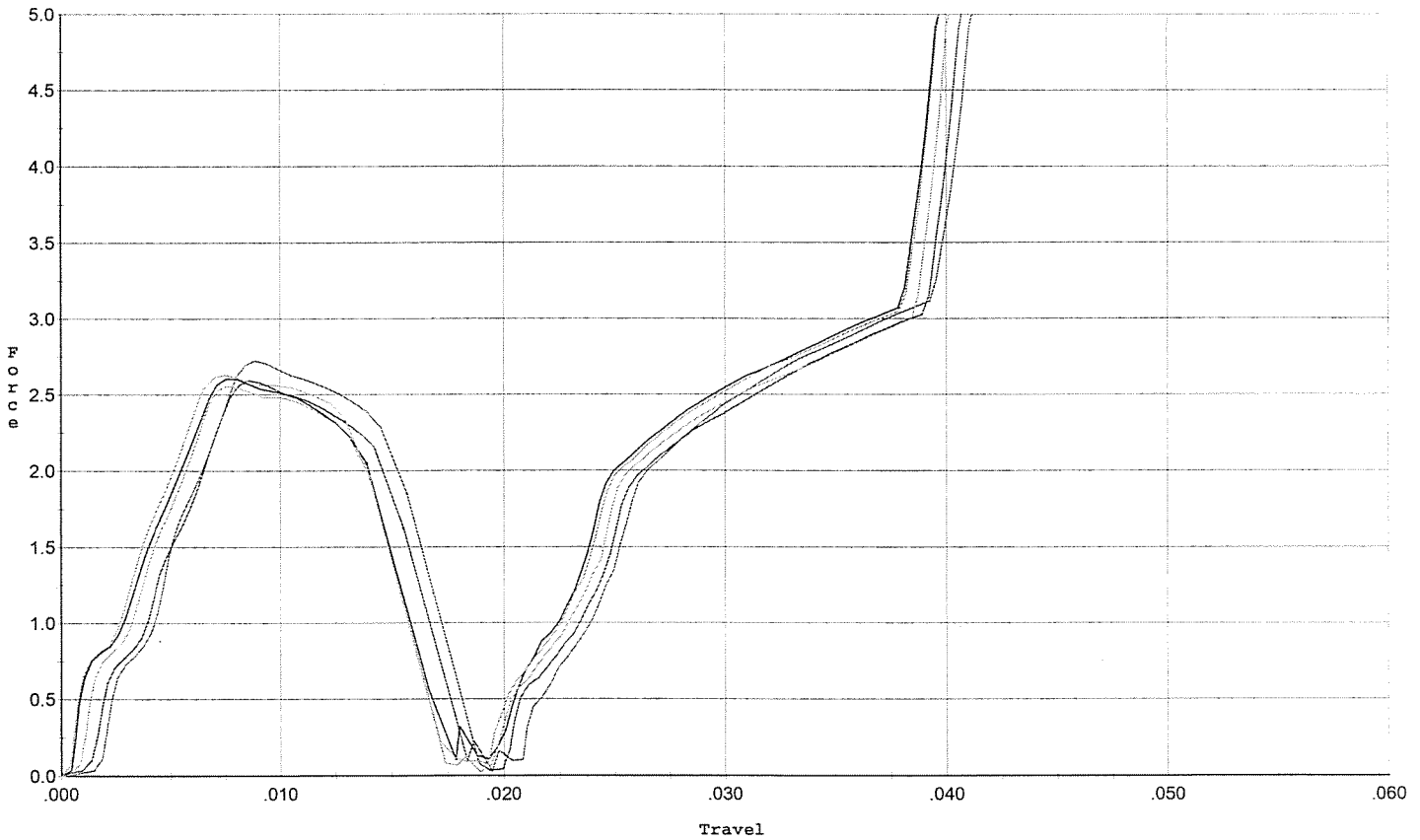
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-28-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>50</u> <u>40</u>	3-28-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-28-09	LN
	J) ASSEMBLE STOCK		3-25-09	LN
	K) ASSEMBLE SWIVEL STUDS		3-28-09	LN
	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	3-26-09	WN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-28-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.66</u> <u>2.71</u> <u>2.69</u> <u>2.54</u>	3-26-09	TL
	C) FUNCTION		3-28-09	LN
690	PACK		3-28-09	TL

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



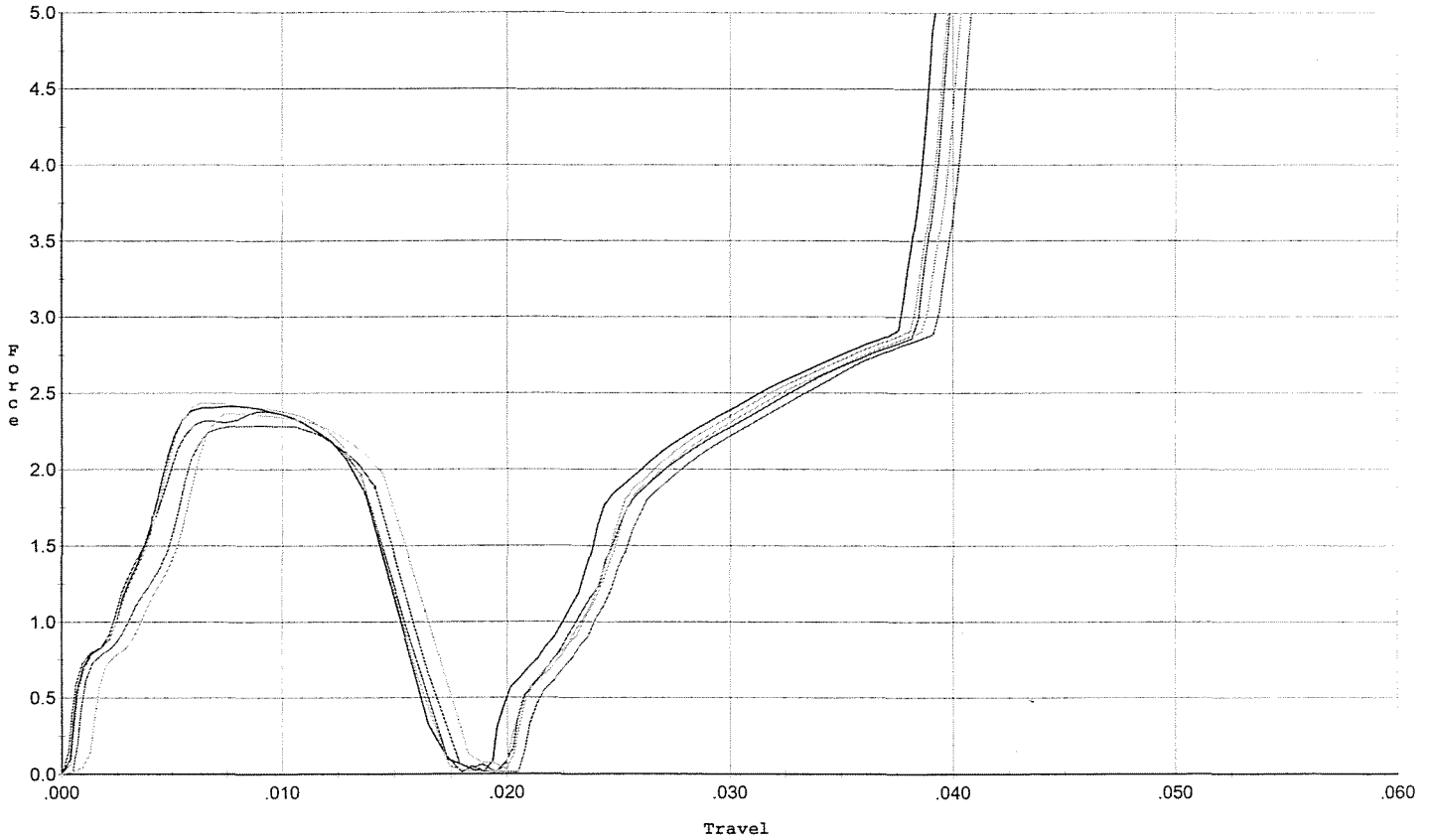
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.595	0.016	0.00	0.029	0.025		Set Trigger
2	2.604	0.014	0.00	0.029	0.024		Set Trigger
3	2.723	0.016	0.00	0.029	0.026		Set Trigger
4	2.559	0.014	0.00	0.029	0.024		Set Trigger
5	2.628	0.014	0.00	0.029	0.025		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



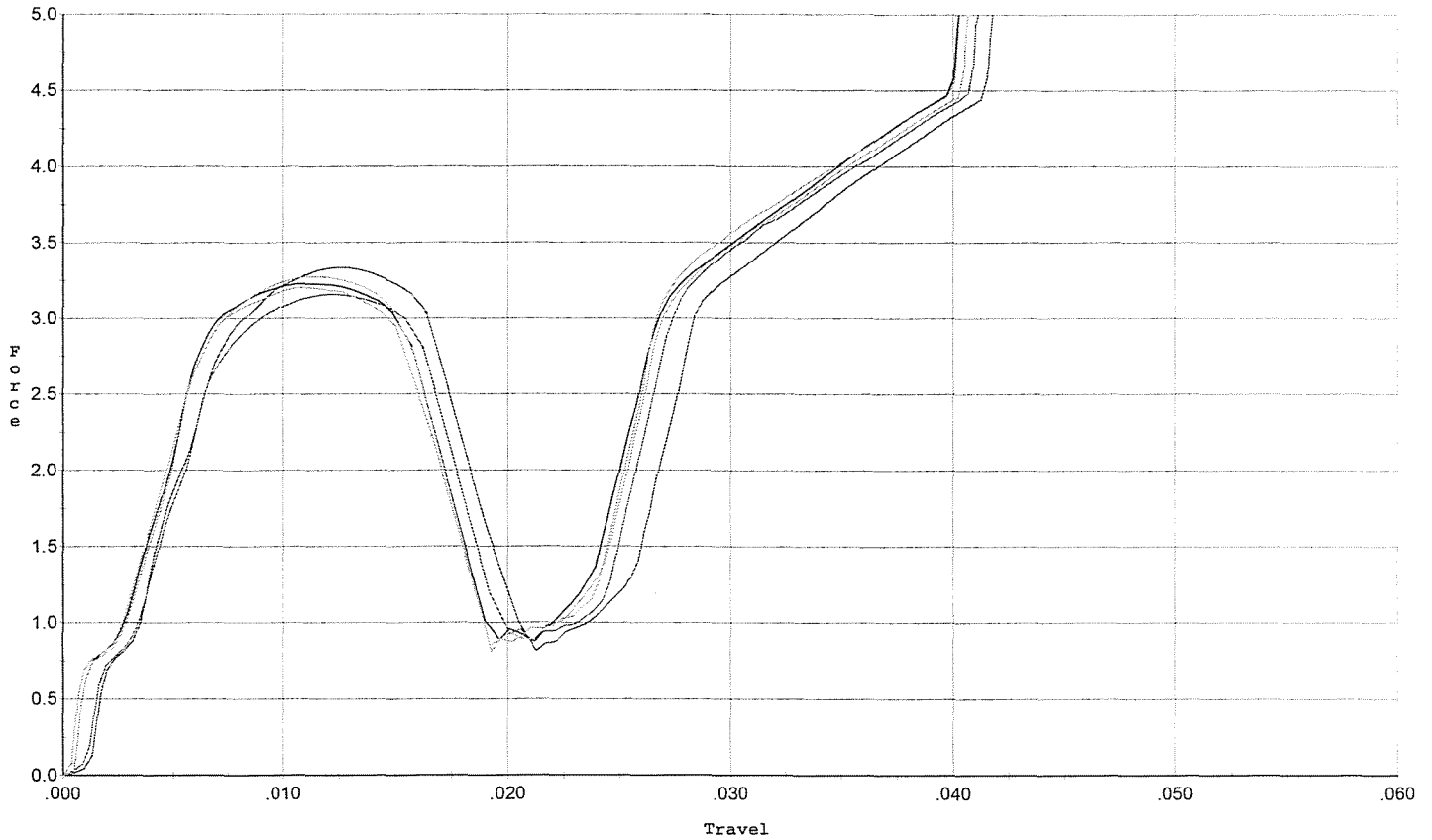
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.378	0.014	0.00	0.030	0.023		Set Trigger
2	2.418	0.014	0.00	0.029	0.024		Set Trigger
3	2.287	0.014	0.00	0.030	0.023		Set Trigger
4	2.366	0.016	0.00	0.029	0.026		Set Trigger
5	2.436	0.014	0.00	0.029	0.023		Set Trigger

A2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



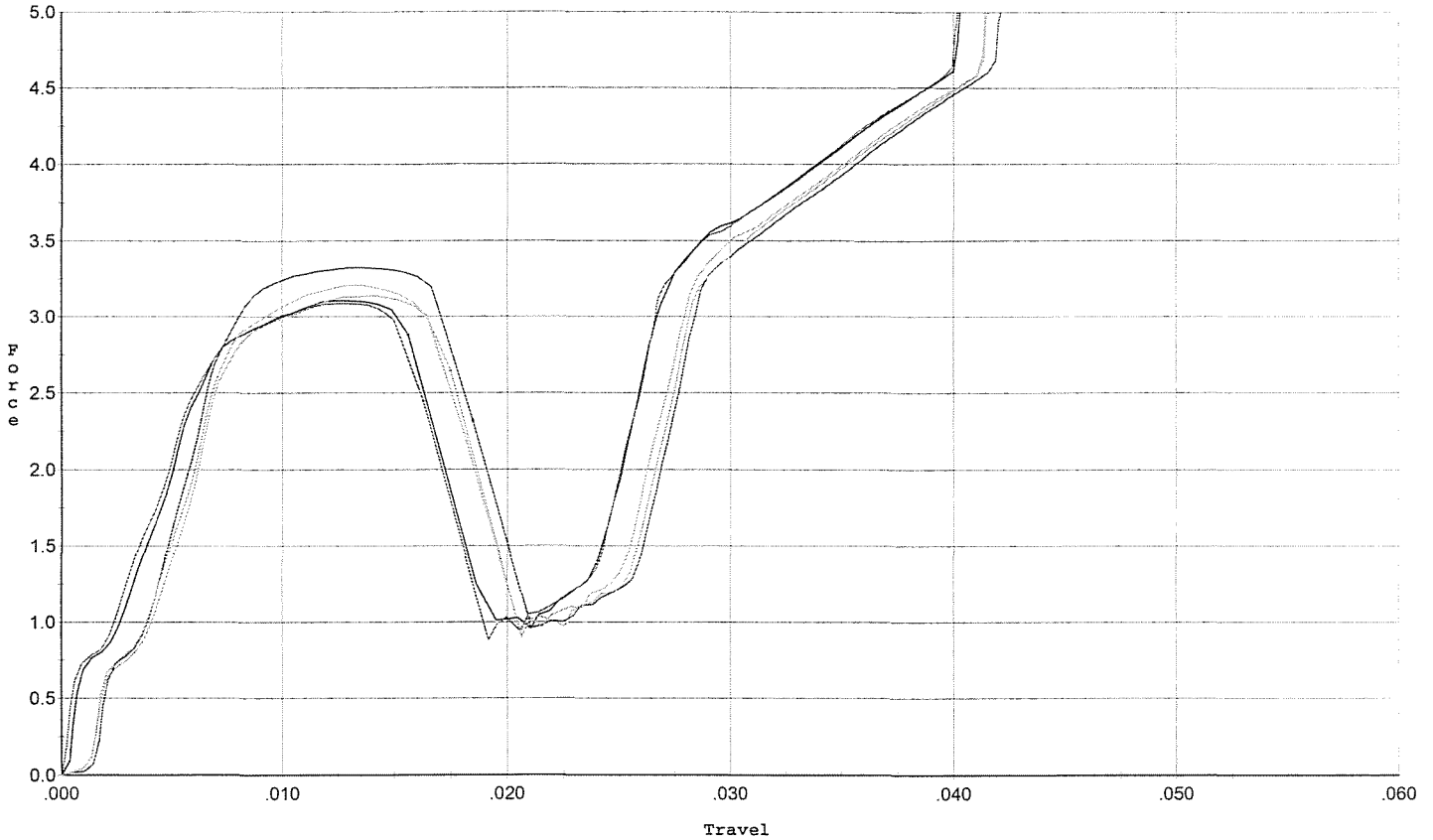
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.336	0.016	0.00	0.027	0.036		Set Trigger
2	3.226	0.016	0.00	0.026	0.035		Set Trigger
3	3.155	0.016	0.00	0.027	0.034		Set Trigger
4	3.274	0.016	0.00	0.026	0.035		Set Trigger
5	3.203	0.017	0.00	0.026	0.036		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



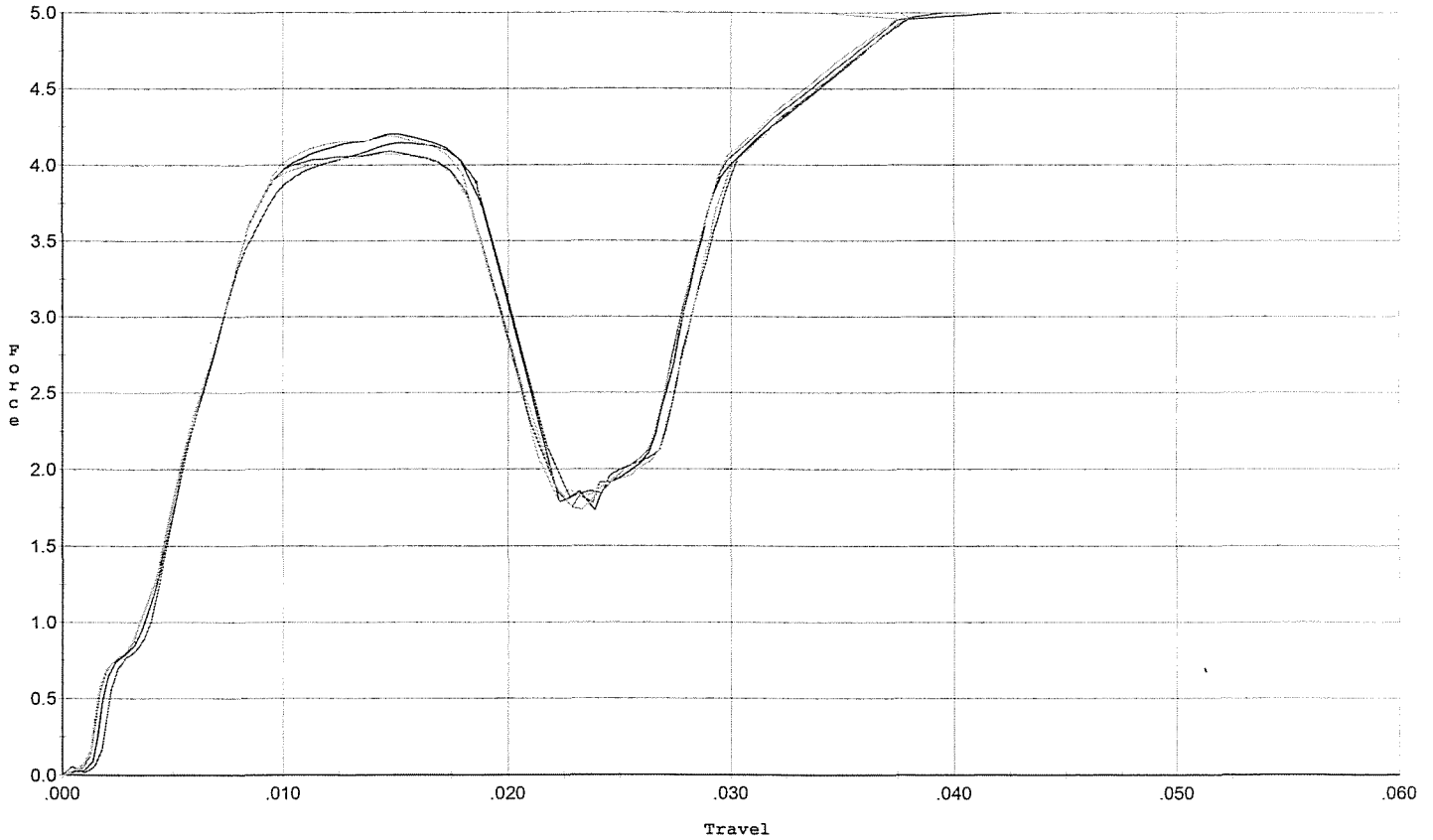
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.325	0.018	0.00	0.027	0.040		Set Trigger
2	3.106	0.016	0.00	0.026	0.034		Set Trigger
3	3.088	0.016	0.00	0.026	0.035		Set Trigger
4	3.209	0.018	0.00	0.027	0.038		Set Trigger
5	3.137	0.017	0.00	0.027	0.036		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



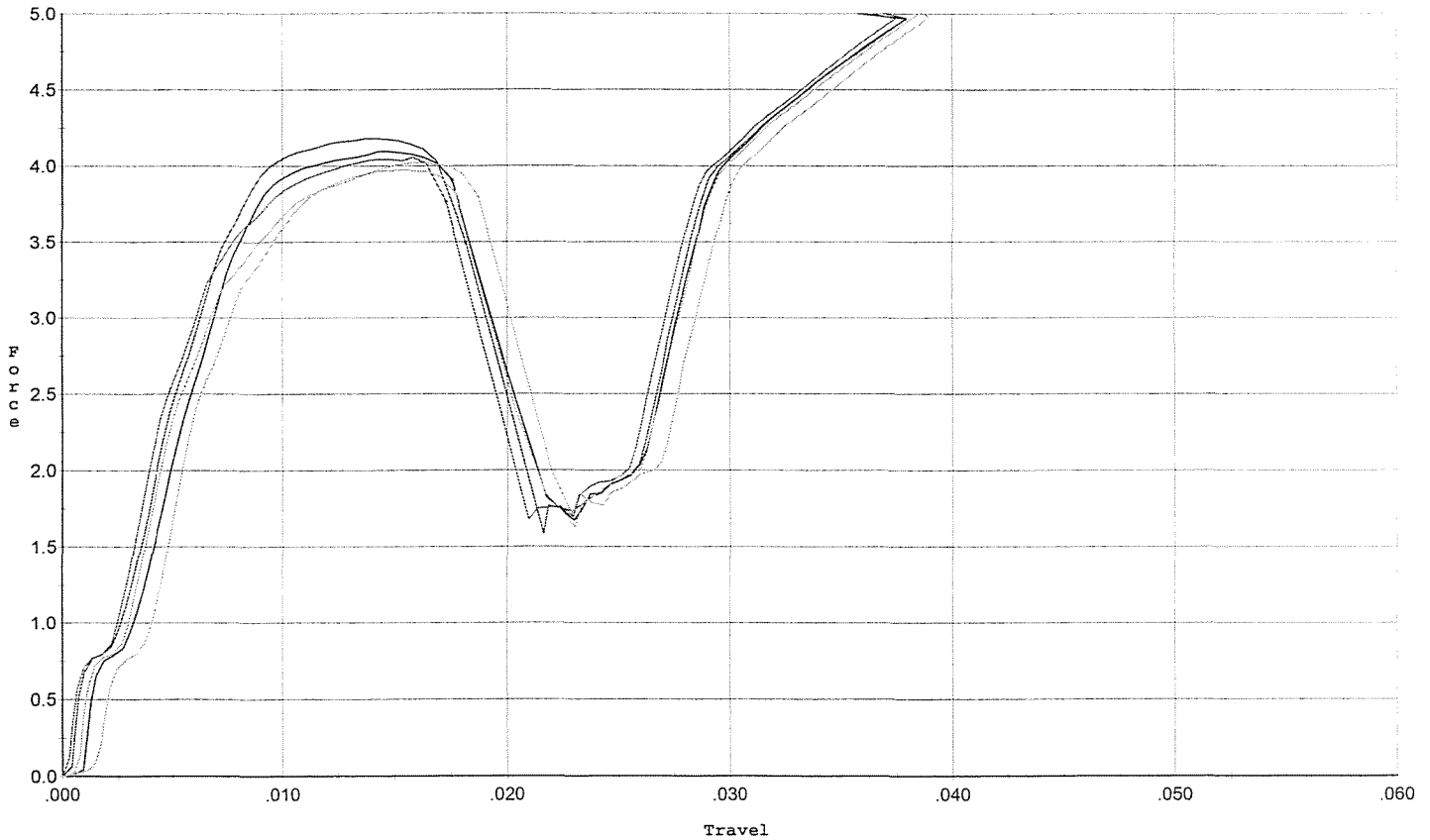
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.146	0.019	0.00	0.025	0.050		Set Trigger
2	4.203	0.019	0.00	0.024	0.051		Set Trigger
3	4.090	0.018	0.00	0.025	0.049		Set Trigger
4	4.074	0.018	0.00	0.025	0.049		Set Trigger
5	4.189	0.018	0.00	0.025	0.049		Set Trigger

A 4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



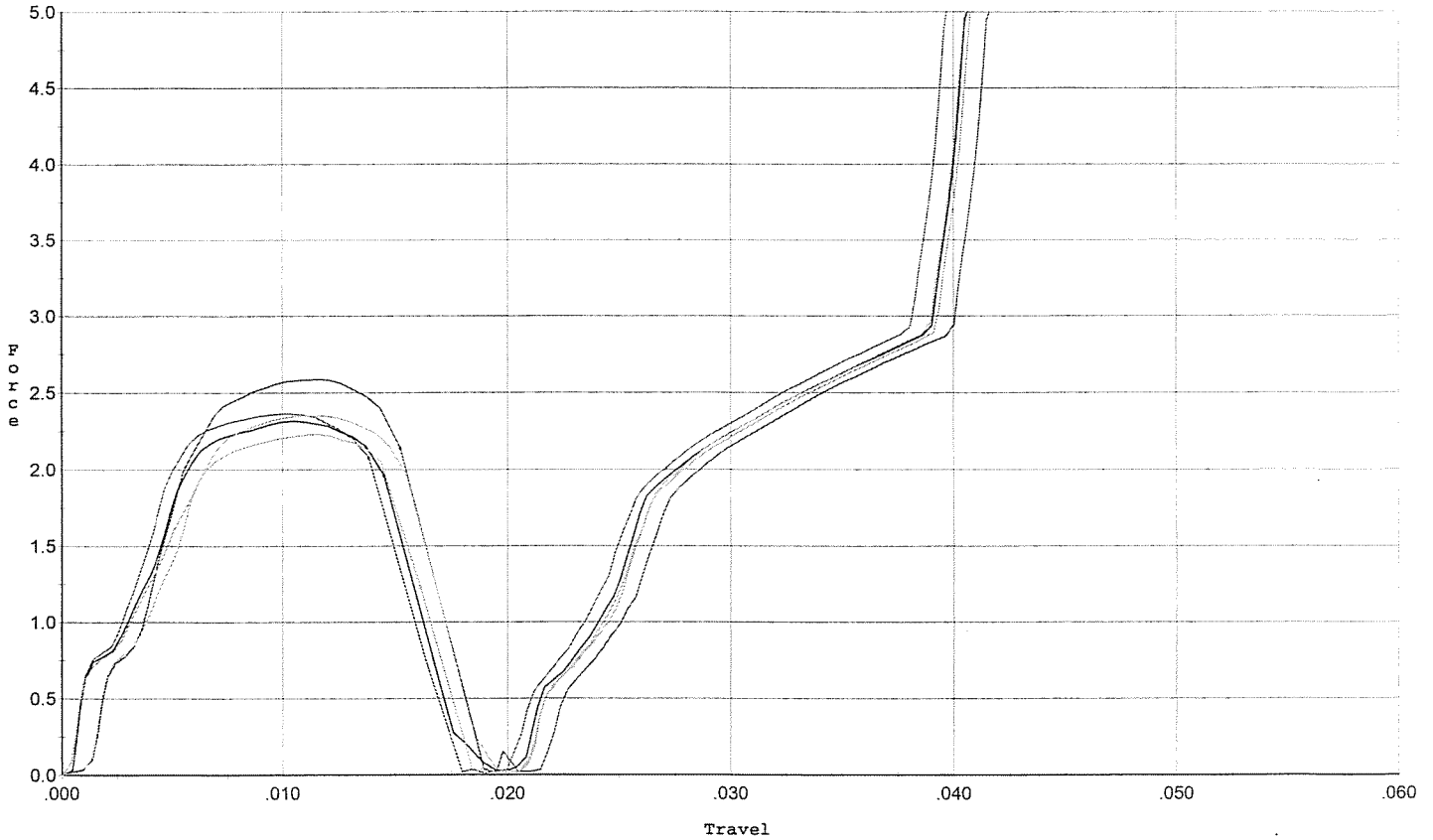
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.182	0.018	0.00	0.025	0.051		Set Trigger
2	4.094	0.018	0.00	0.025	0.047		Set Trigger
3	4.058	0.017	0.00	0.025	0.048		Set Trigger
4	4.021	0.019	0.00	0.025	0.048		Set Trigger
5	3.972	0.018	0.00	0.025	0.047		Set Trigger

A-406

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



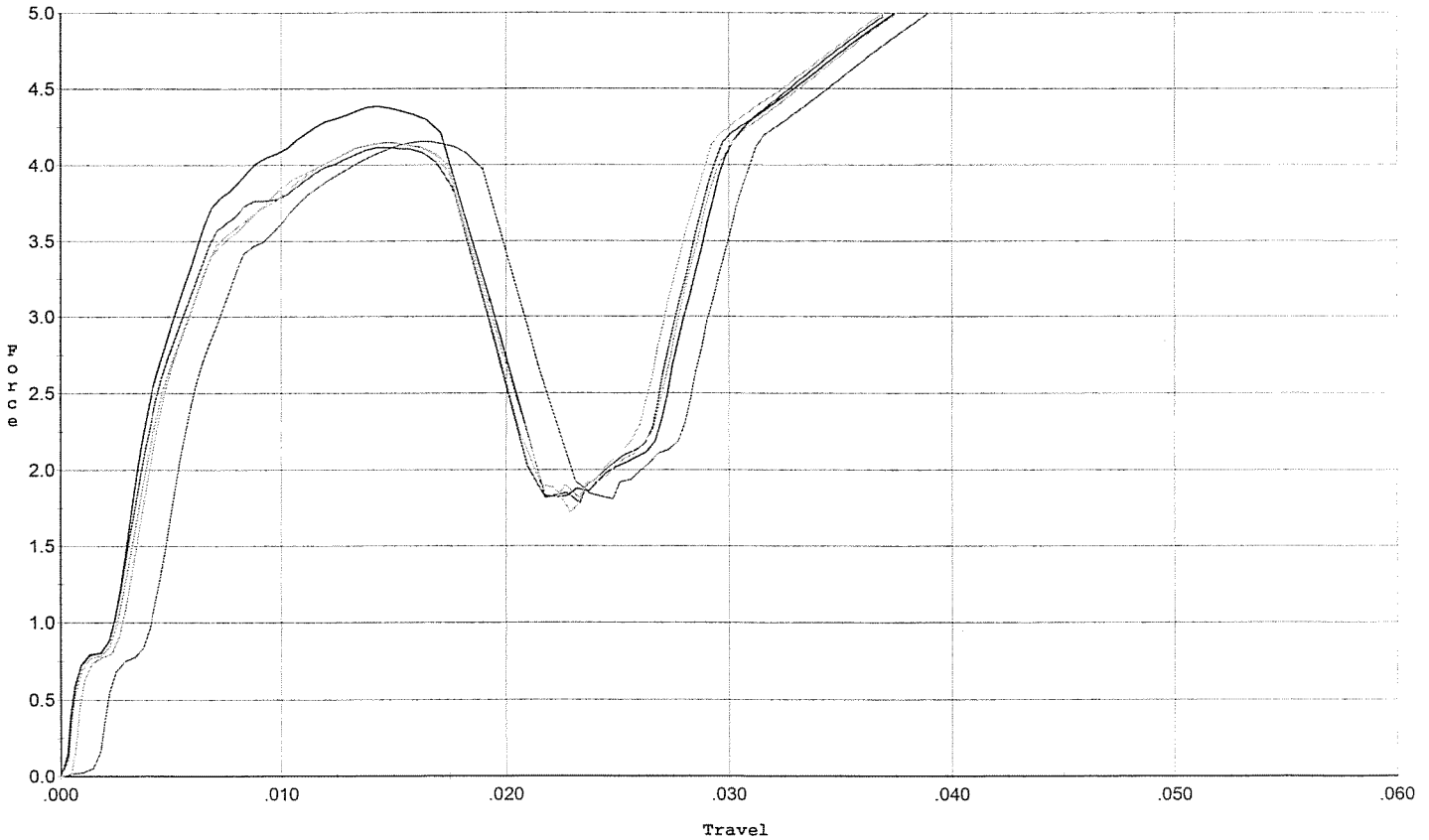
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.587	0.015	0.00	0.030	0.027		Set Trigger
2	2.317	0.015	0.00	0.030	0.024		Set Trigger
3	2.362	0.014	0.00	0.029	0.024		Set Trigger
4	2.352	0.016	0.00	0.029	0.025		Set Trigger
5	2.229	0.016	0.00	0.029	0.025		Set Trigger

A-2-36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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	4.115	0.018	0.00	0.025	0.050		Set Trigger
2	4.385	0.019	0.00	0.024	0.058		Set Trigger
3	4.155	0.019	0.00	0.025	0.051		Set Trigger
4	4.150	0.018	0.00	0.025	0.050		Set Trigger
5	4.146	0.017	0.00	0.025	0.049		Set Trigger

A-4.19