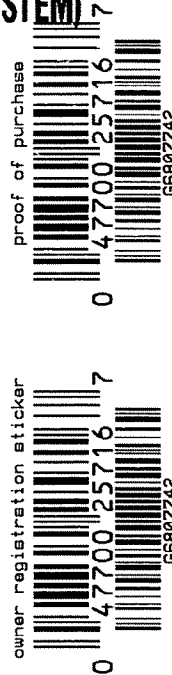


G6807742

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

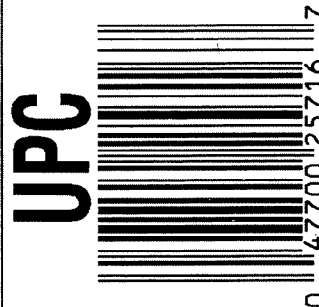
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807742



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807742

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE	MAGNA-FLUX	2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	non
540	APPLY COATINGS (BARREL ACTION)		3/9	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

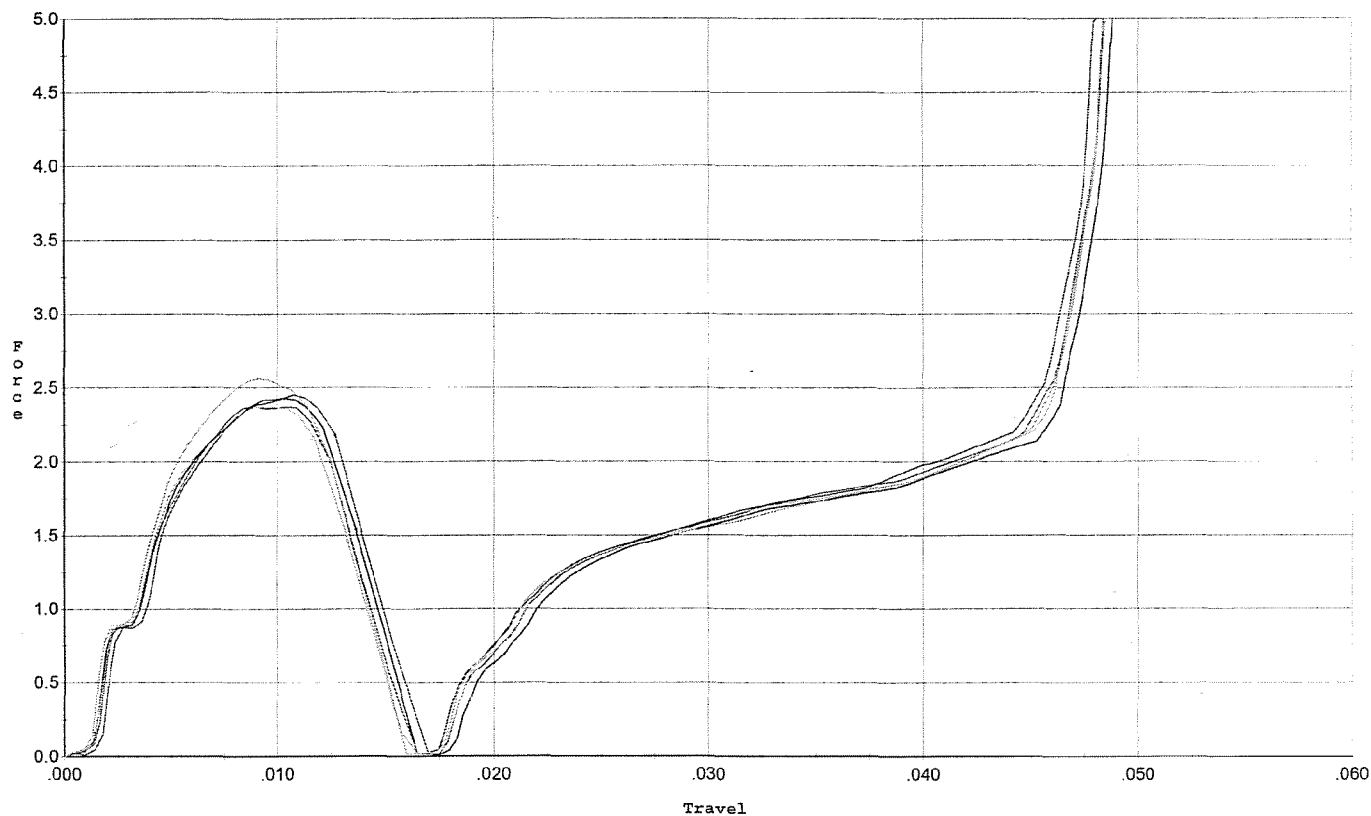
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	3-18-09	W W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-18-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-18-09	W W
	J) ASSEMBLE STOCK		3-13-09	W W
	K) ASSEMBLE SWIVEL STUDS		3-18-09	W W
	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	3-17-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	W W
670	FINAL INSPECTION A) HEADSPACE		3-18-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u> <u>2.34</u> <u>2.33</u> <u>2.36</u> <u>2.39</u>	3-18-09	TK
	C) FUNCTION		3-18-09	W W
690	PACK		3/19/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



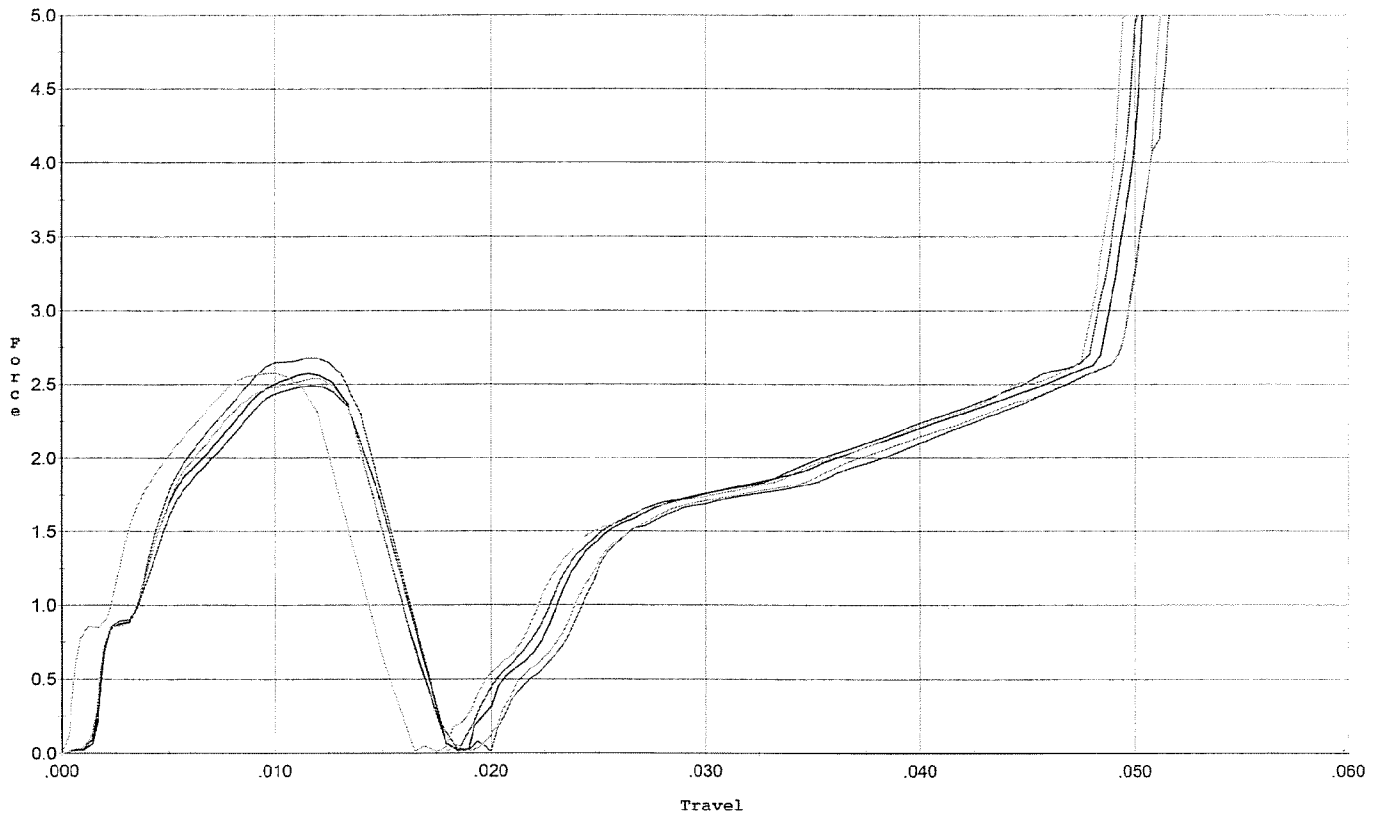
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.451	0.013	0.00	0.039	0.019		Set Trigger
2	2.426	0.014	0.00	0.040	0.021		Set Trigger
3	2.374	0.012	0.00	0.040	0.019		Set Trigger
4	2.370	0.013	0.00	0.040	0.020		Set Trigger
5	2.561	0.012	0.00	0.040	0.020		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



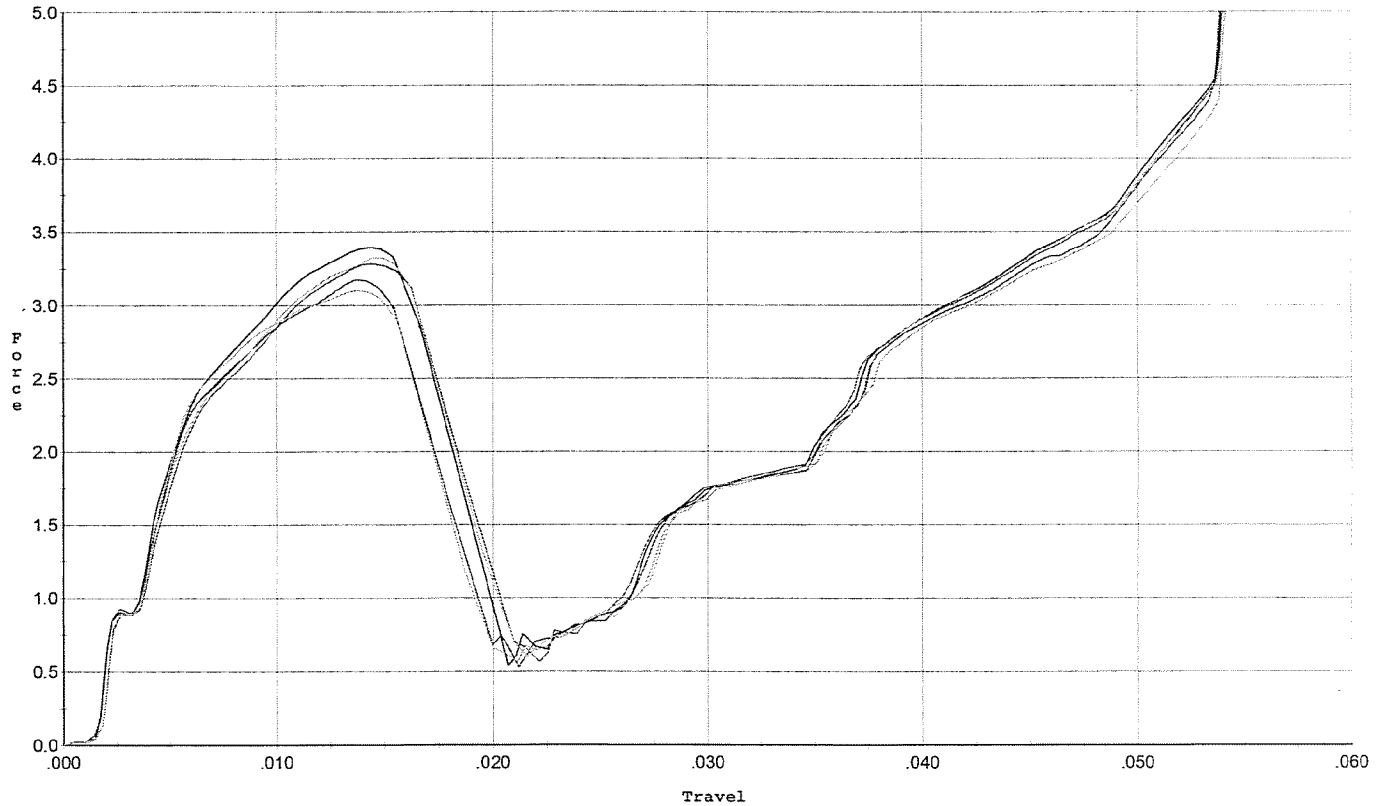
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.015	0.00	0.039	0.024		Set Trigger
2	2.572	0.013	0.00	0.040	0.022		Set Trigger
3	2.679	0.014	0.00	0.041	0.024		Set Trigger
4	2.574	0.012	0.00	0.040	0.021		Set Trigger
5	2.538	0.013	0.00	0.041	0.022		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



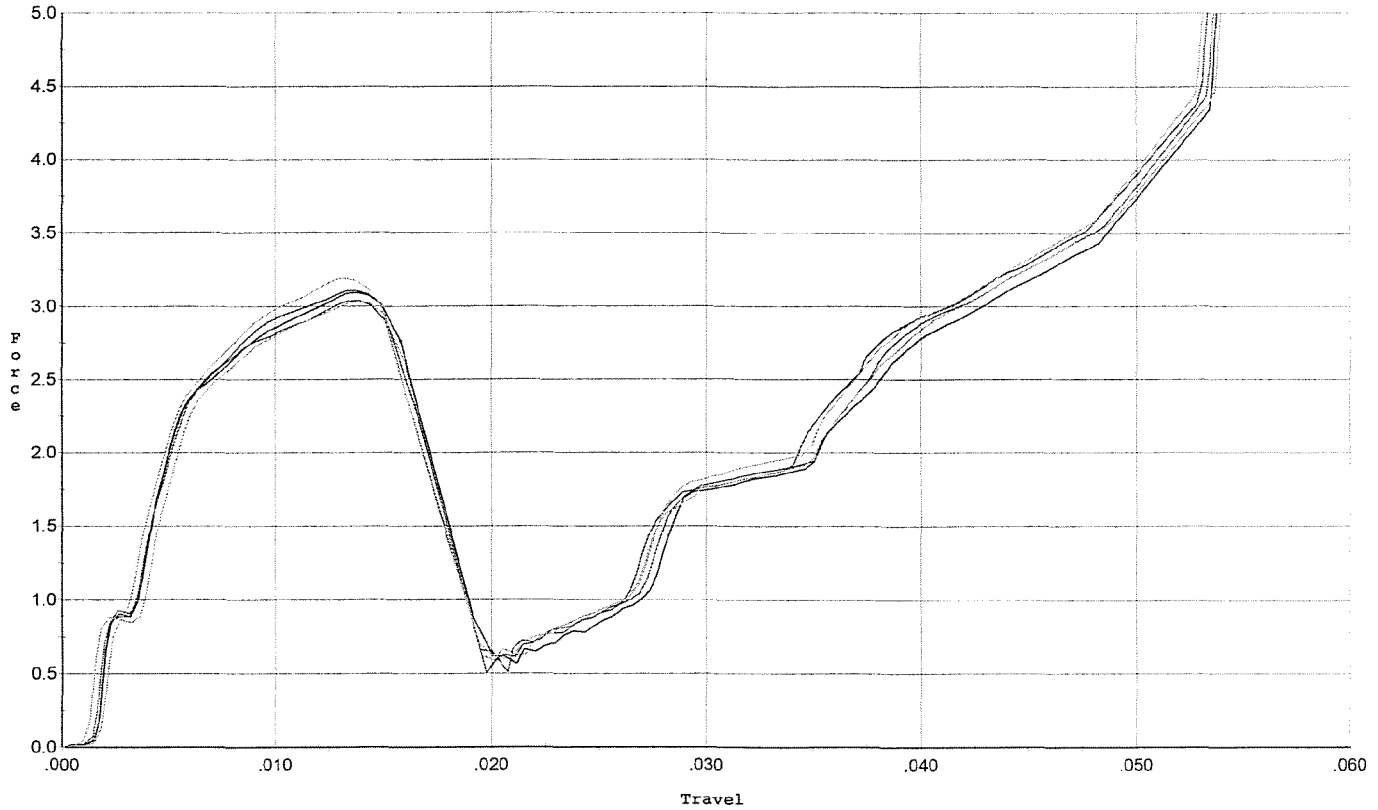
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.174	0.015	0.00	0.039	0.031		Set Trigger
2	3.394	0.017	0.00	0.038	0.036		Set Trigger
3	3.283	0.016	0.00	0.039	0.034		Set Trigger
4	3.323	0.016	0.00	0.039	0.034		Set Trigger
5	3.102	0.016	0.00	0.040	0.031		Set Trigger

A.3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



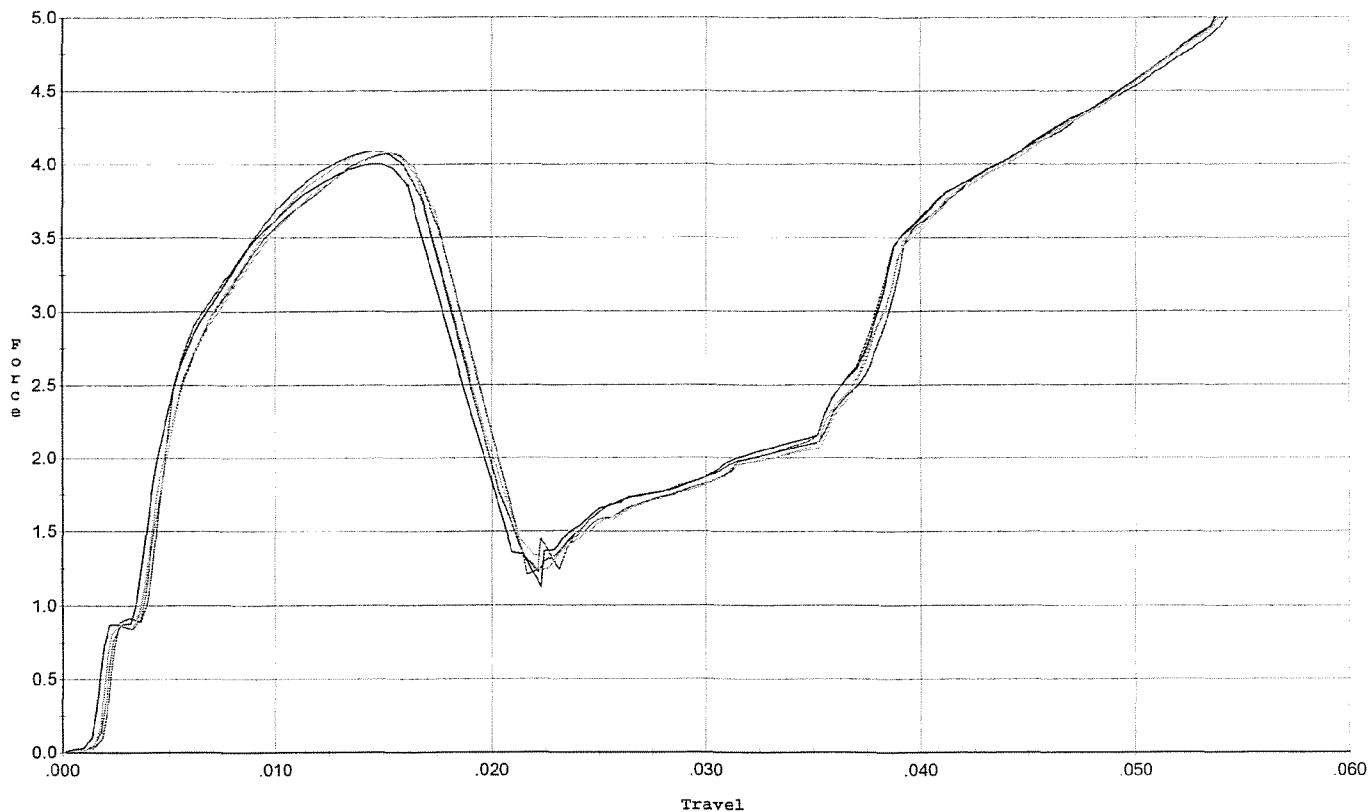
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.107	0.016	0.00	0.039	0.033		Set Trigger
2	3.095	0.016	0.00	0.039	0.032		Set Trigger
3	3.039	0.015	0.00	0.040	0.030		Set Trigger
4	3.193	0.015	0.00	0.039	0.031		Set Trigger
5	3.035	0.016	0.00	0.039	0.031		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- m1.0 lb



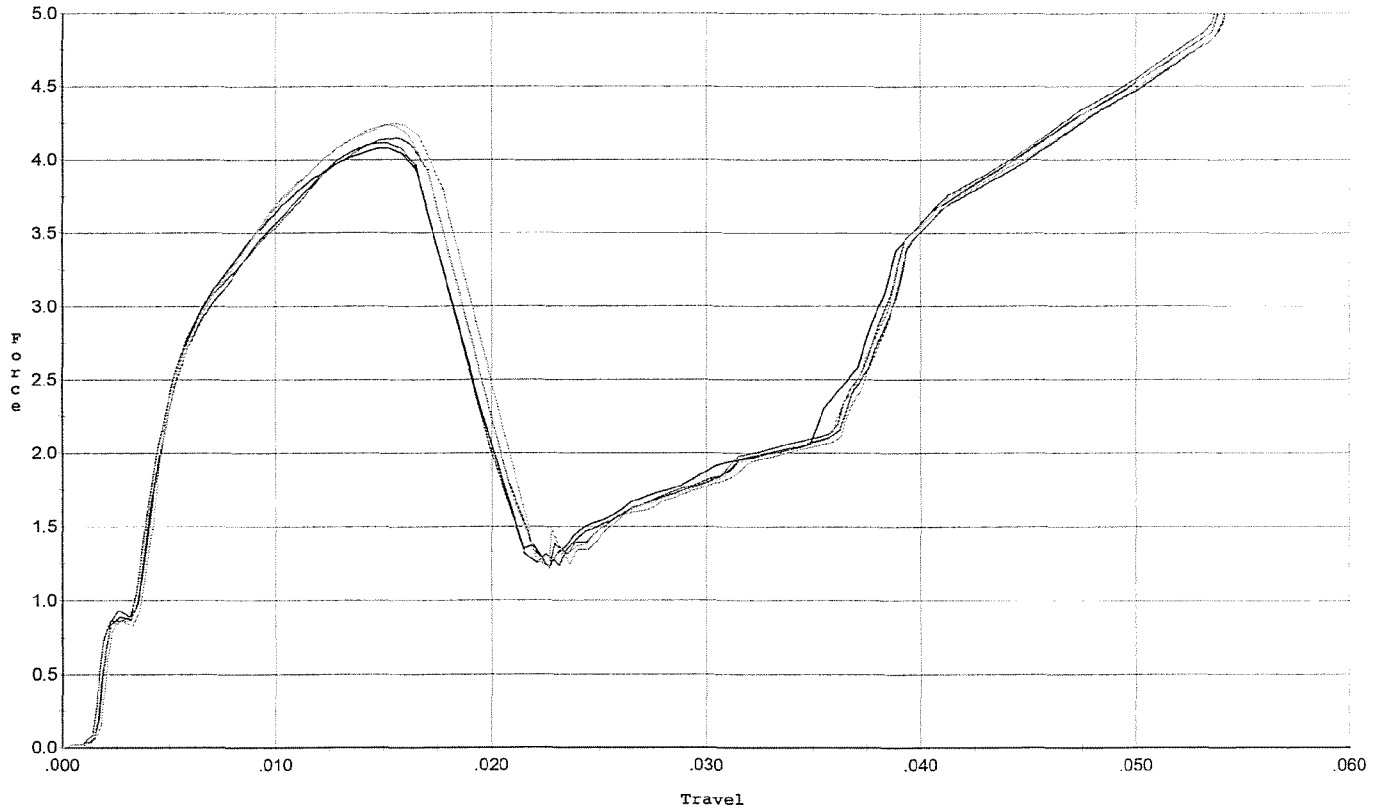
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.017	0.00	0.038	0.043		Set Trigger
2	4.003	0.016	0.003	0.037	0.041		Set Trigger
3	4.077	0.018	0.00	0.037	0.045		Set Trigger
4	4.083	0.017	0.00	0.037	0.044		Set Trigger
5	4.091	0.017	0.00	0.037	0.042		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- m1.0 lb



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.016	0.00	0.038	0.042		Set Trigger
2	4.080	0.017	0.00	0.037	0.043		Set Trigger
3	4.150	0.017	0.00	0.037	0.045		Set Trigger
4	4.236	0.017	0.00	0.037	0.045		Set Trigger
5	4.247	0.018	0.00	0.037	0.047		Set Trigger

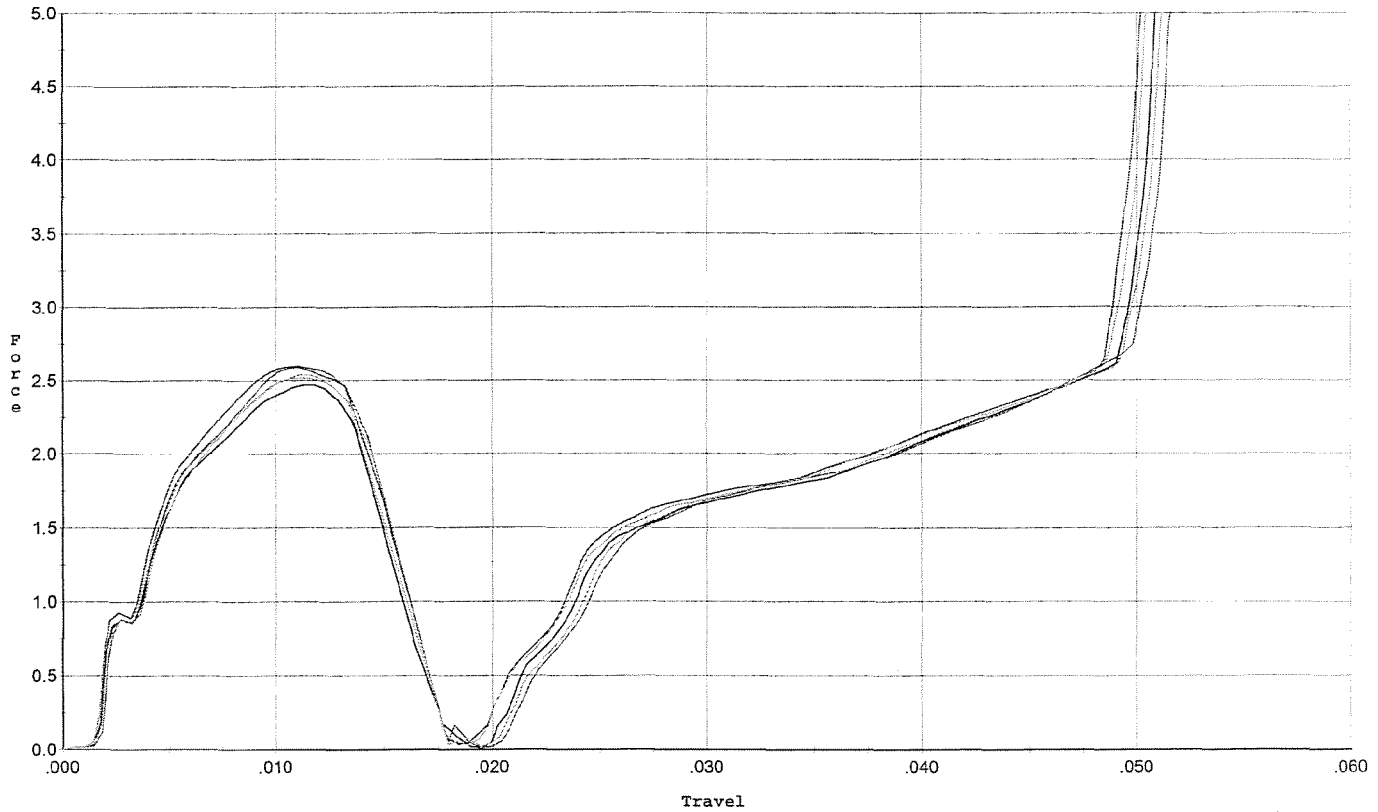
A-4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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

for final test
cms



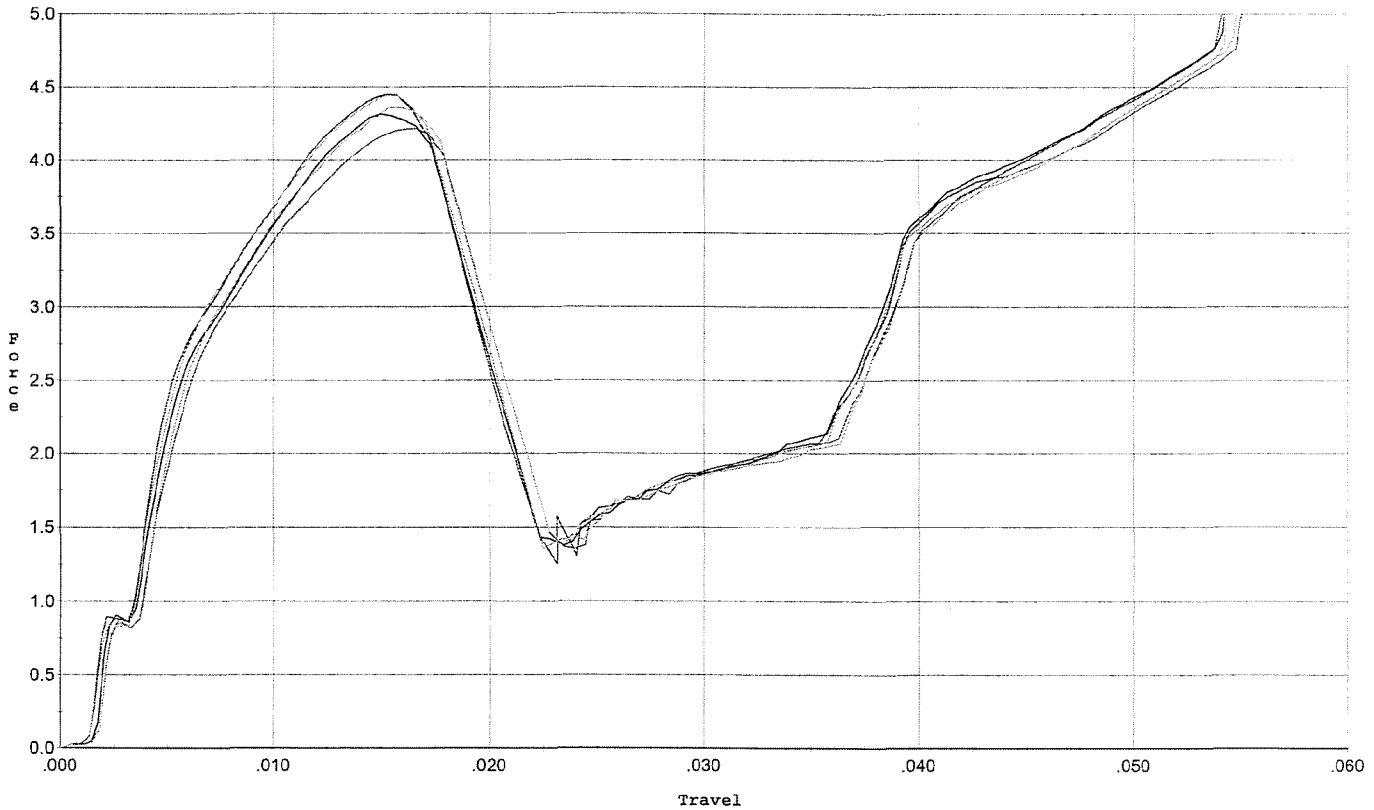
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.598	0.015	0.00	0.039	0.025		Set Trigger
2	2.471	0.014	0.00	0.040	0.022		Set Trigger
3	2.591	0.014	0.00	0.041	0.023		Set Trigger
4	2.540	0.013	0.00	0.040	0.022		Set Trigger
5	2.519	0.014	0.00	0.040	0.023		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.449	0.017	0.003	0.037	0.047		Set Trigger
2	4.314	0.017	0.00	0.037	0.046		Set Trigger
3	4.215	0.018	0.00	0.037	0.046		Set Trigger
4	4.361	0.018	0.00	0.037	0.047		Set Trigger
5	4.444	0.019	0.00	0.036	0.053		Set Trigger

A-4.35