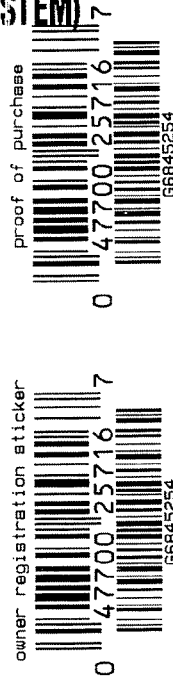


G6845254

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

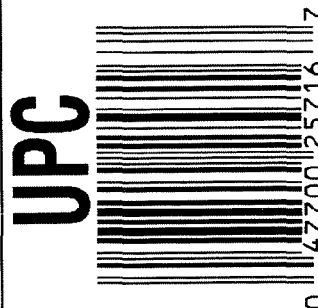
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6845254



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845254

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE		3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATION	3-20-09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-28-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-28-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-28-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-1-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

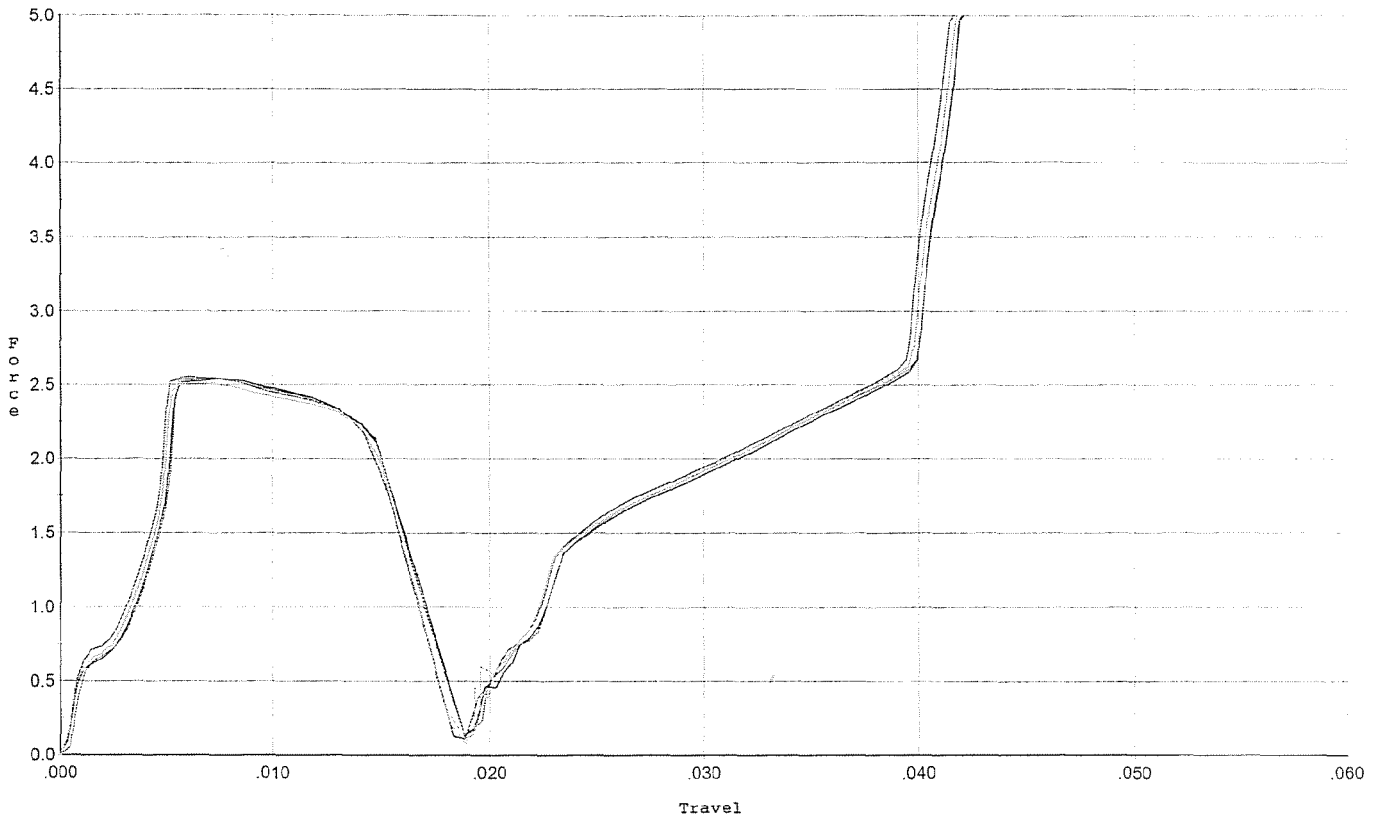
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>6.5</u>	4-13-09	W W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-13-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	4-13-09	W W
	J) ASSEMBLE STOCK		4-8-09	J.H.D.
	K) ASSEMBLE SWIVEL STUDS		4-13-09	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	4-2-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-2-09	W W
670	FINAL INSPECTION A) HEADSPACE		4-13-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.38</u> <u>2.50</u> <u>2.27</u> <u>2.48</u>	4-9-09	W W
	C) FUNCTION		4-13-09	W W
690	PACK		6/4/09	F.M.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



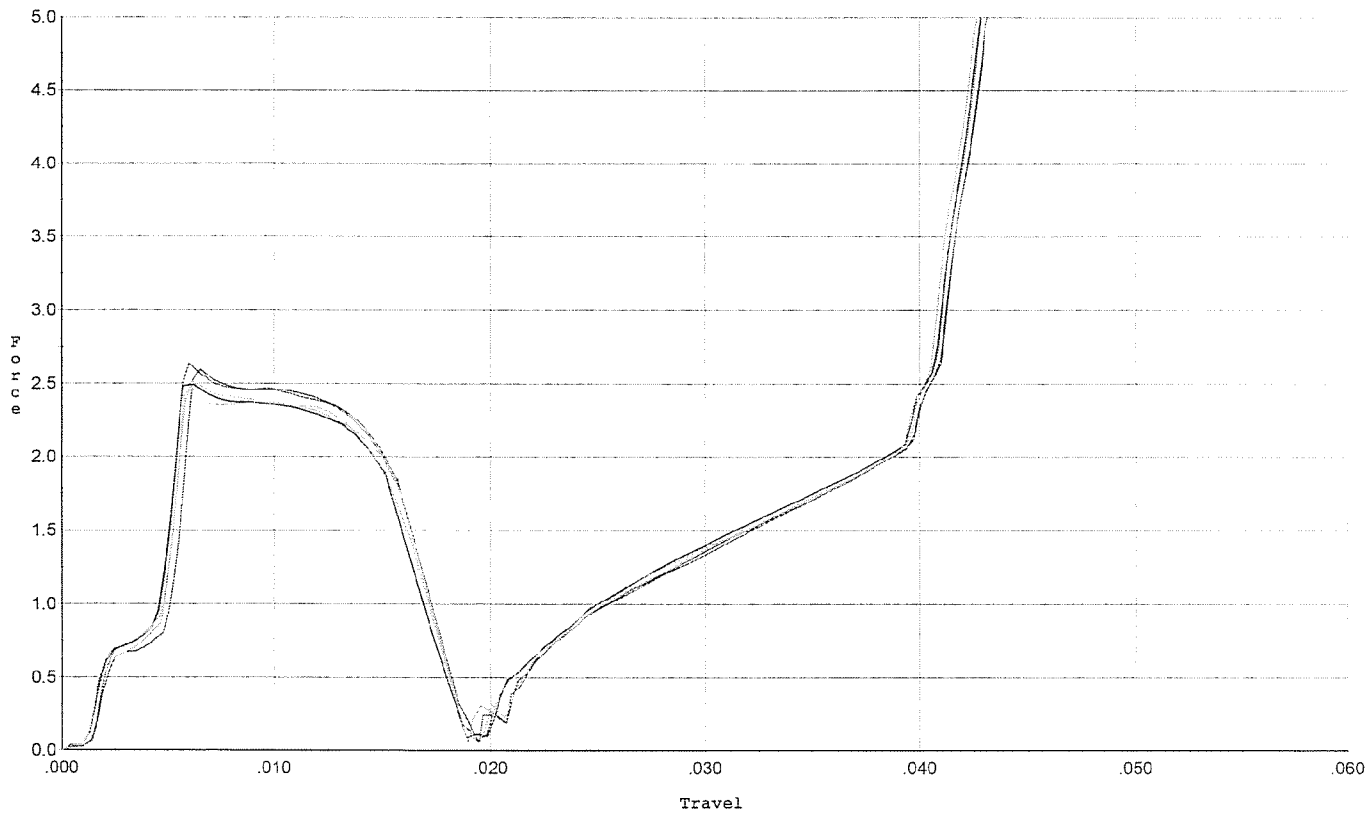
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.015	0.00	0.030	0.027		Set Trigger
2	2.538	0.017	0.00	0.031	0.029		Set Trigger
3	2.554	0.015	0.00	0.031	0.026		Set Trigger
4	2.513	0.015	0.00	0.031	0.026		Set Trigger
5	2.507	0.015	0.00	0.031	0.026		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



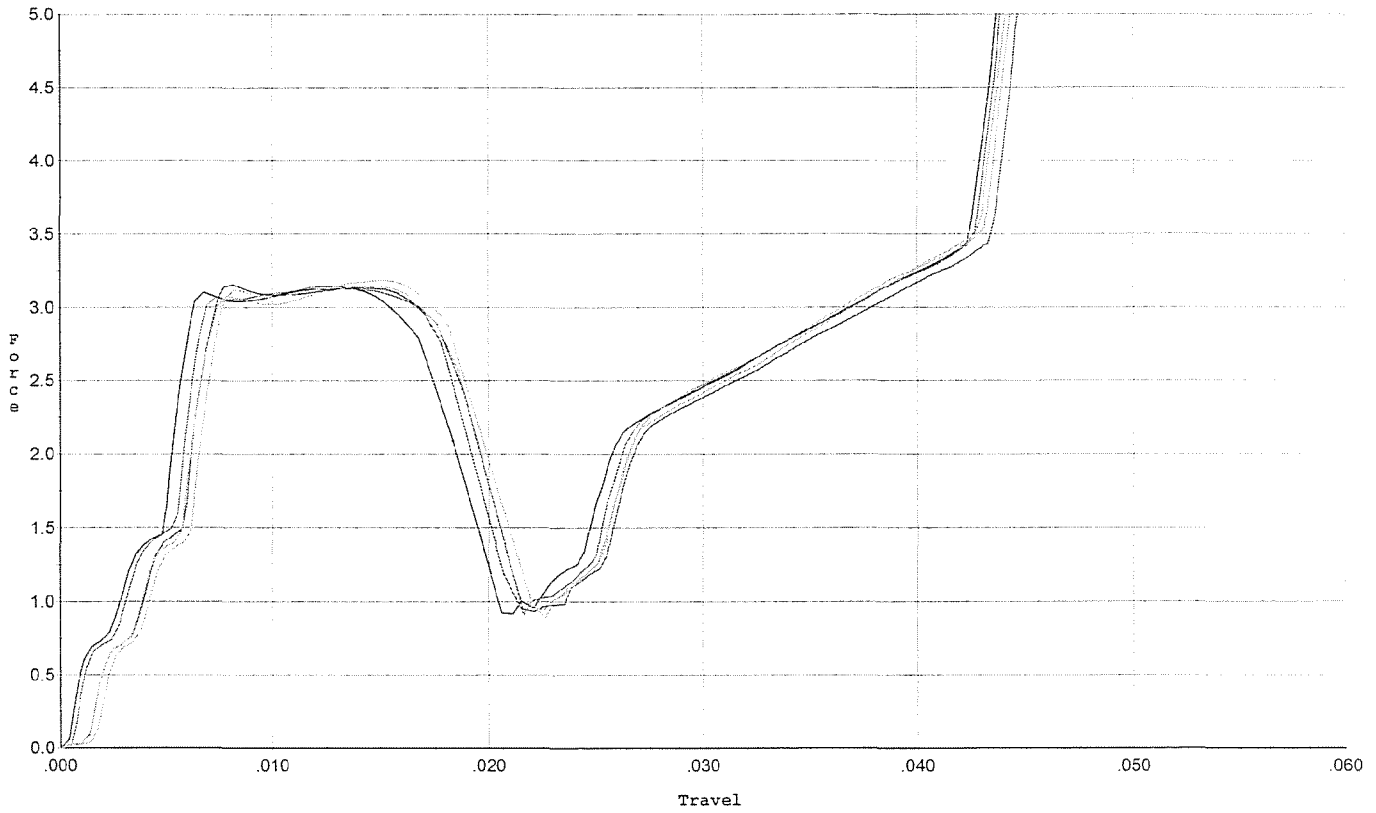
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.016	0.00	0.032	0.025		Set Trigger
2	2.493	0.015	0.00	0.032	0.024		Set Trigger
3	2.634	0.016	0.00	0.032	0.026		Set Trigger
4	2.510	0.016	0.00	0.032	0.026		Set Trigger
5	2.466	0.016	0.00	0.032	0.026		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



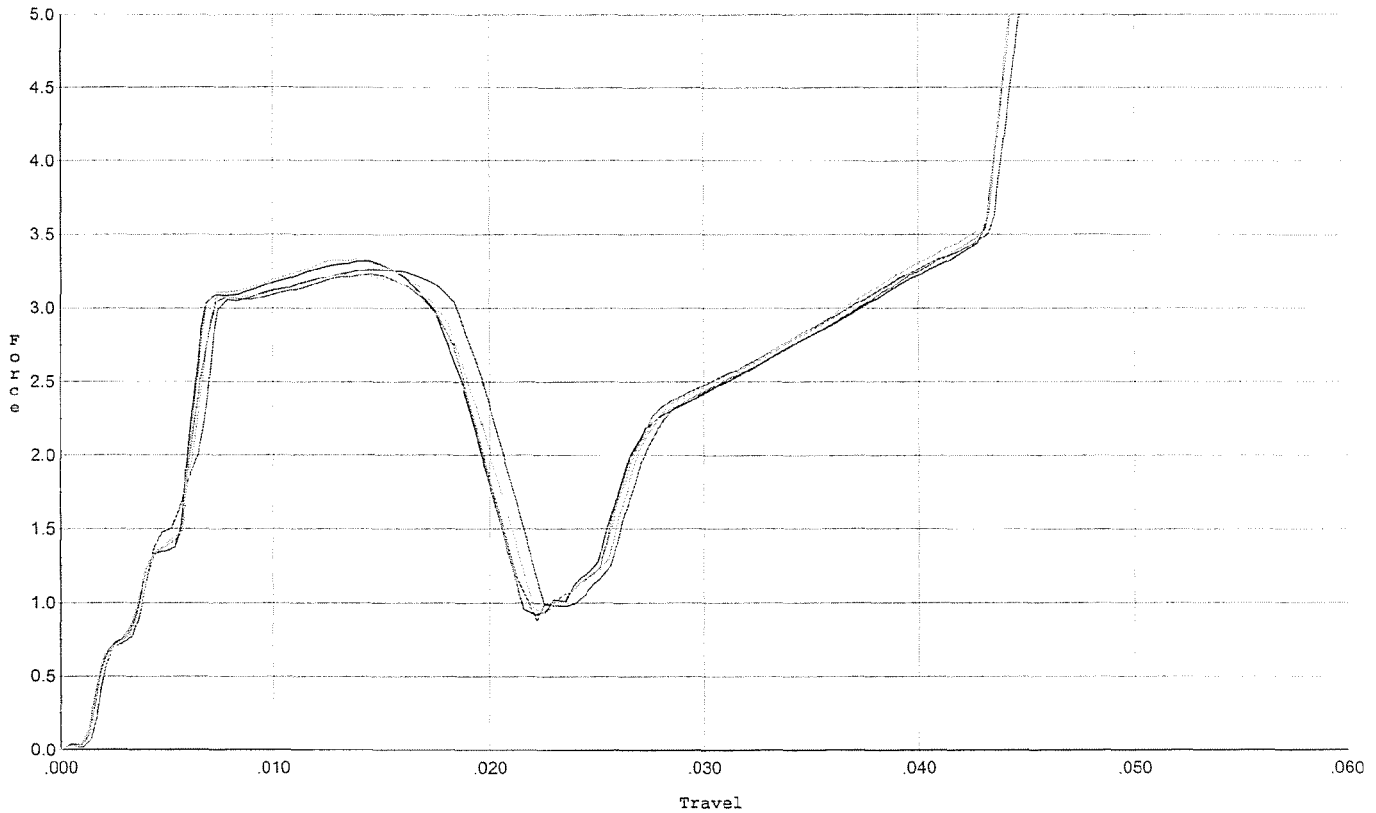
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.019	0.00	0.029	0.040		Set Trigger
2	3.129	0.018	0.00	0.028	0.040		Set Trigger
3	3.142	0.018	0.00	0.028	0.039		Set Trigger
4	3.143	0.019	0.00	0.028	0.039		Set Trigger
5	3.185	0.018	0.00	0.028	0.038		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



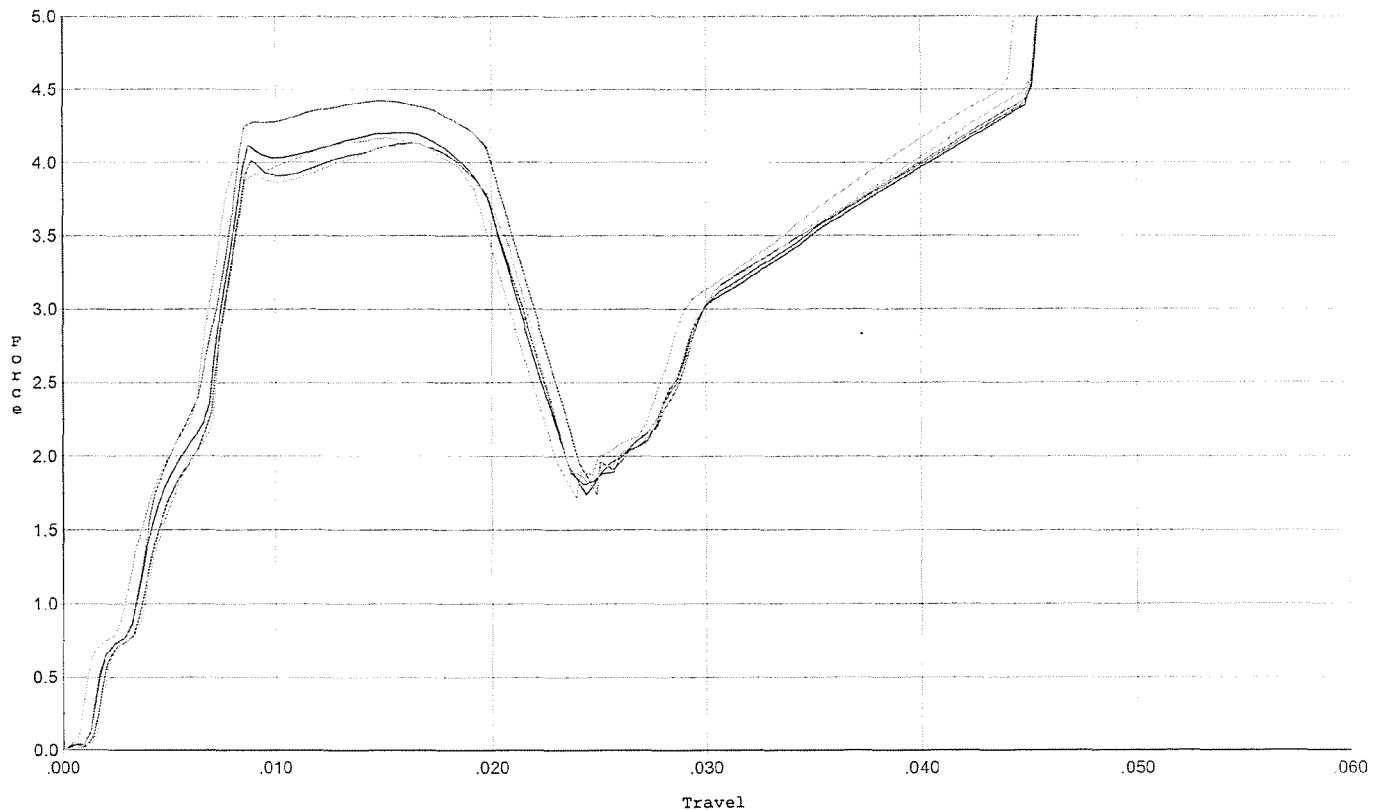
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.266	0.020	0.00	0.028	0.043		Set Trigger
2	3.318	0.019	0.00	0.028	0.041		Set Trigger
3	3.230	0.018	0.00	0.028	0.040		Set Trigger
4	3.227	0.020	0.00	0.028	0.043		Set Trigger
5	3.331	0.018	0.00	0.028	0.041		Set Trigger

A-3-27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



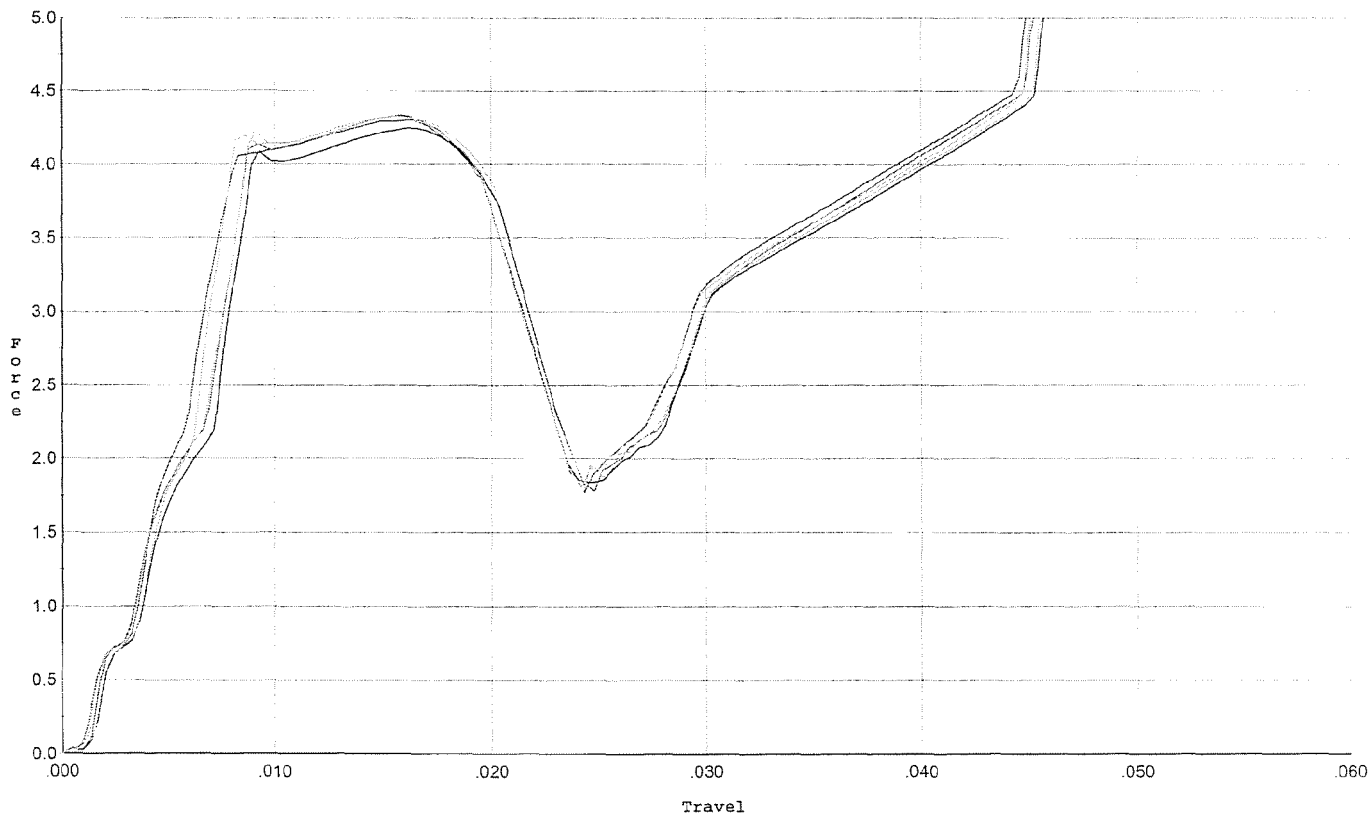
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.022	0.00	0.026	0.058		Set Trigger
2	4.203	0.020	0.00	0.026	0.055		Set Trigger
3	4.425	0.020	0.00	0.026	0.058		Set Trigger
4	4.128	0.021	0.00	0.026	0.056		Set Trigger
5	4.169	0.019	0.00	0.026	0.054		Set Trigger

A. 4.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



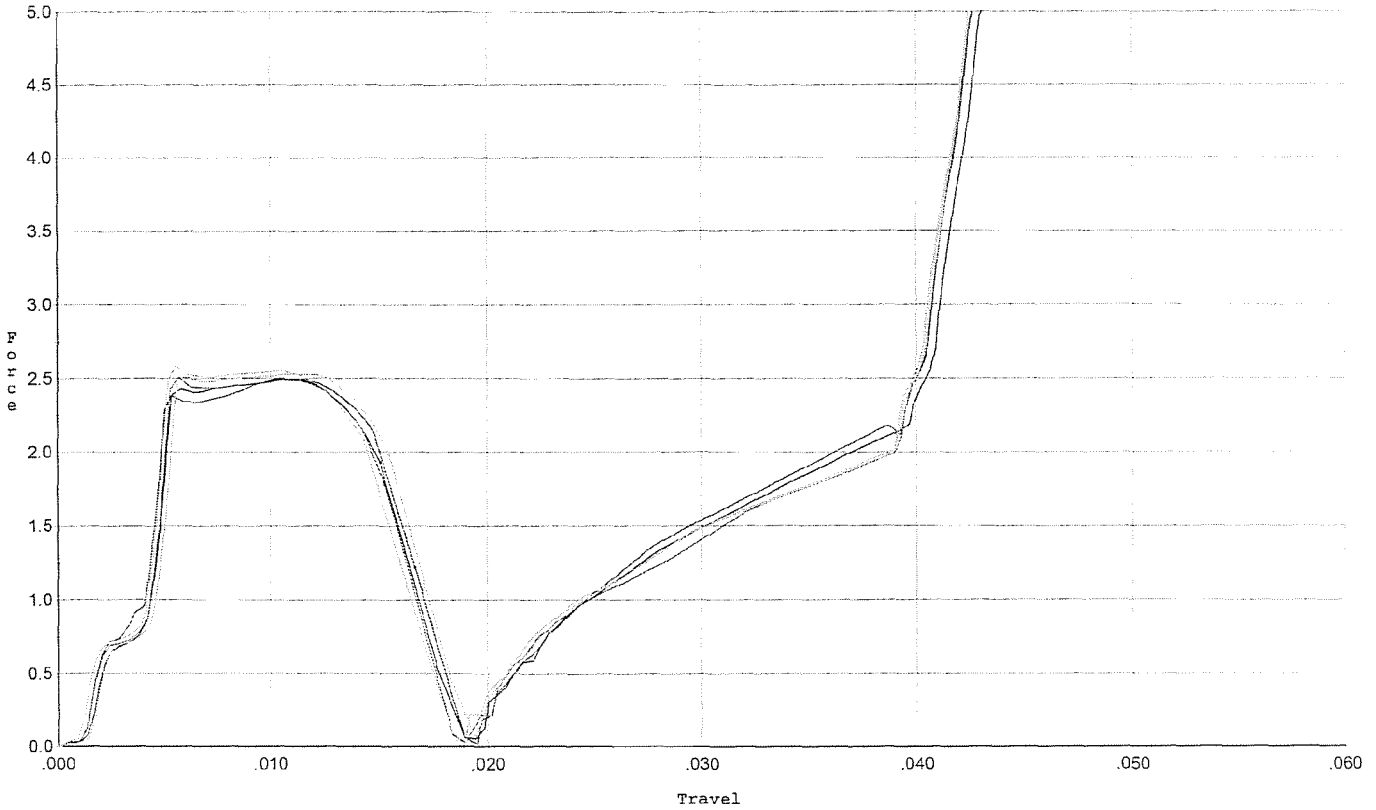
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.334	0.020	0.00	0.026	0.056		Set Trigger
2	4.245	0.020	0.00	0.026	0.056		Set Trigger
3	4.299	0.021	0.00	0.026	0.060		Set Trigger
4	4.325	0.019	0.00	0.026	0.056		Set Trigger
5	4.323	0.020	0.00	0.026	0.057		Set Trigger

A-430

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



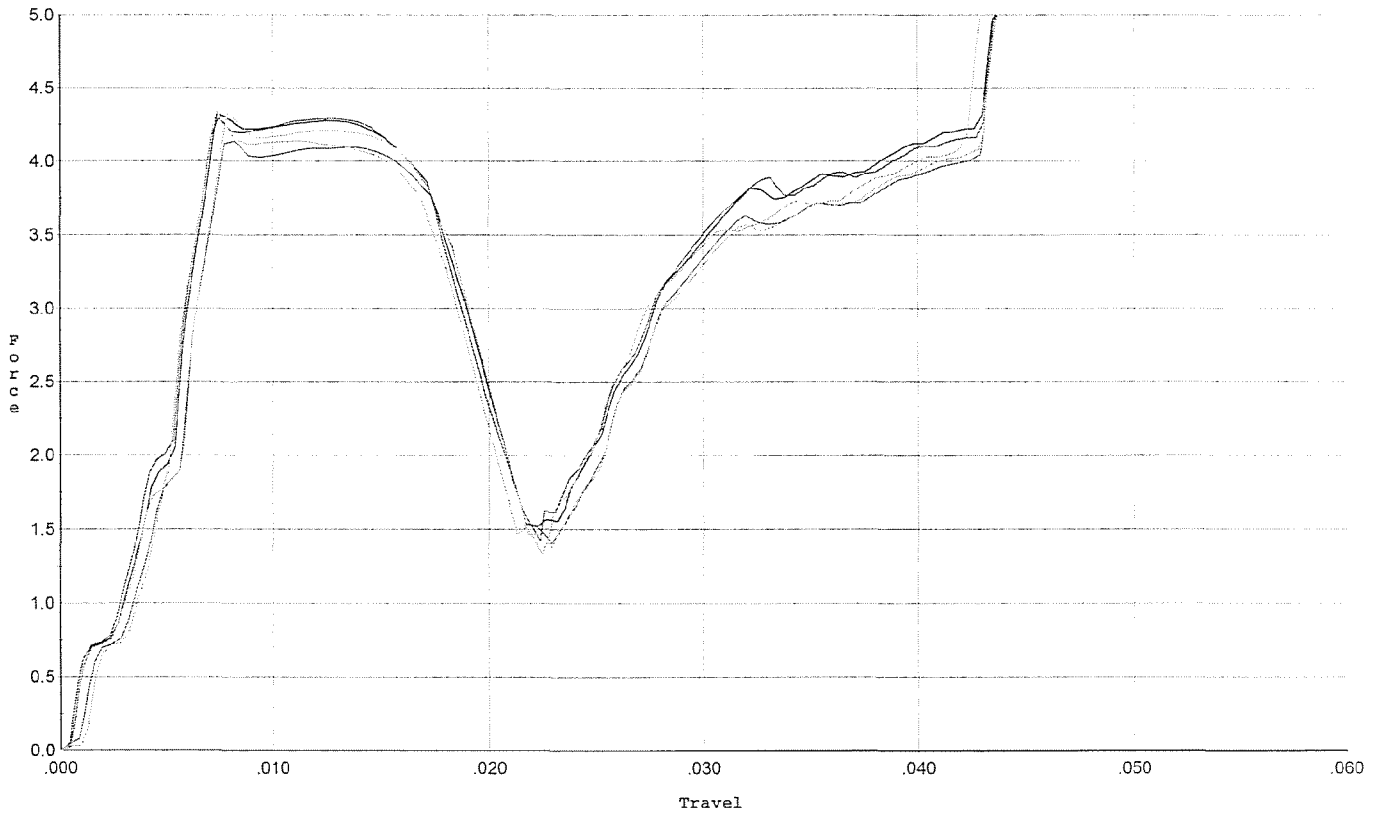
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.017	0.00	0.031	0.028		Set Trigger
2	2.495	0.015	0.00	0.032	0.025		Set Trigger
3	2.509	0.015	0.00	0.032	0.026		Set Trigger
4	2.585	0.014	0.00	0.032	0.025		Set Trigger
5	2.534	0.015	0.00	0.031	0.026		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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	4.290	0.017	0.00	0.026	0.049		Set Trigger
2	4.329	0.019	0.00	0.026	0.054		Set Trigger
3	4.134	0.018	0.00	0.026	0.050		Set Trigger
4	4.346	0.018	0.00	0.026	0.050		Set Trigger
5	4.341	0.018	0.00	0.026	0.050		Set Trigger

A-4.28