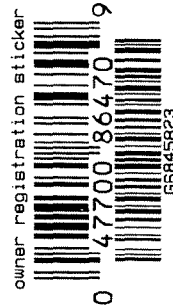


G 684 5823

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



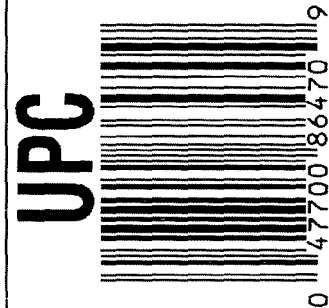
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6845823



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845823

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-16-09	SPD
430	ASSEMBLE TO STOCK		4-16-09	RP
440	PROOF		4-16-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	4-16-09	RP
470	DIS-ASSEMBLE ACTION	APP 2.4005	4-16-09	RP
472	SERIALIZE BOLT HANDLE		4-17-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(R)</u>	4/18/09	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/20/09	RT
510	DRILL AND TAP SIGHT HOLES		4-17-09	SP
520	GOFF BLAST BBL / REC		4/21/09	L.m.
540	APPLY COATINGS (BARREL ACTION)		4-22	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	4-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

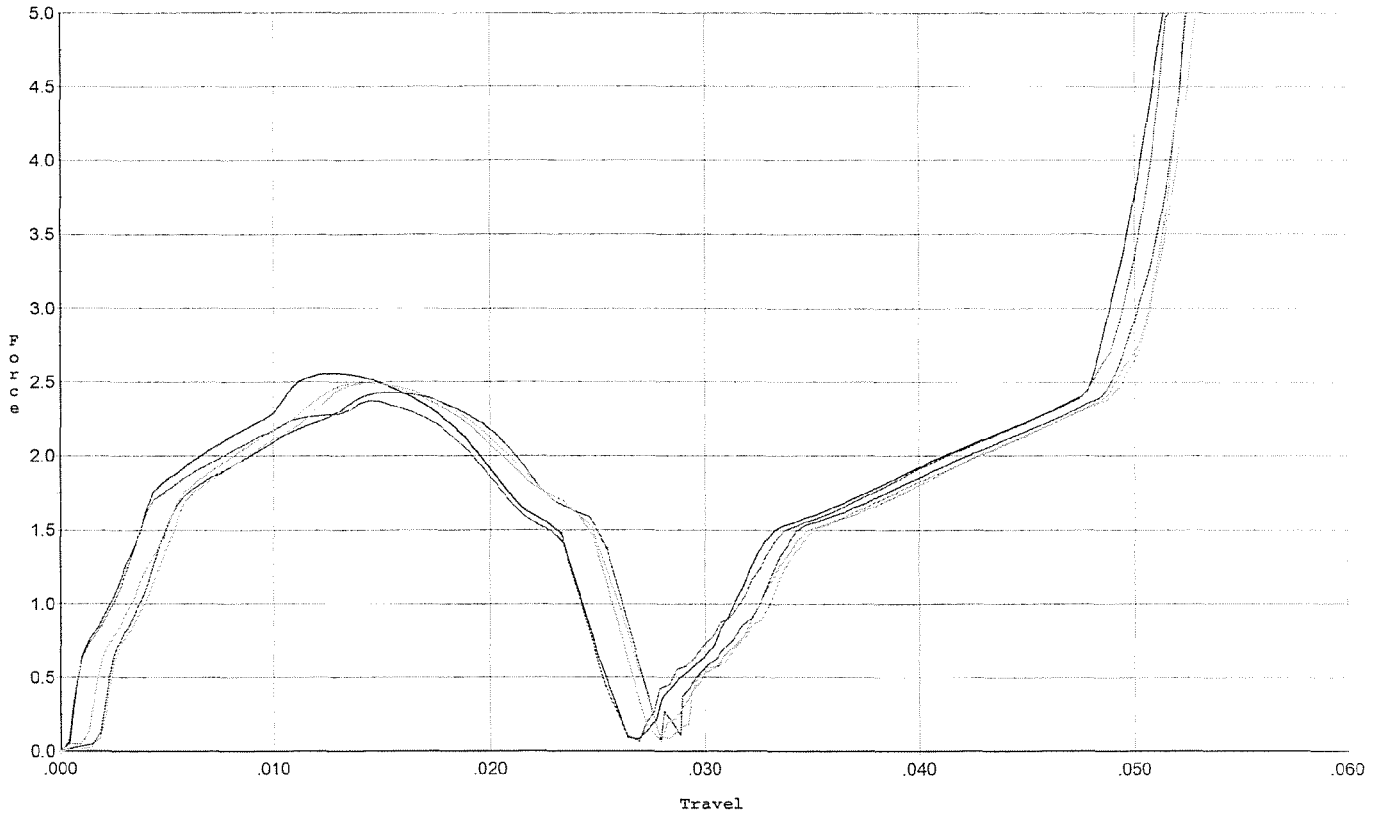
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-12-09	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	5-12-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	5-12-09	LJN
	J) ASSEMBLE STOCK		4-28-09	LJN
	K) ASSEMBLE SWIVEL STUDS		5-12-09	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	5-1-09	WZ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-1-09	TCR
670	FINAL INSPECTION A) HEADSPACE		5-12-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>234</u> <u>239</u> <u>230</u> <u>251</u> <u>248</u>	5-7-09	RP
	C) FUNCTION		5-12-09	LJN
690	PACK		7/9/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



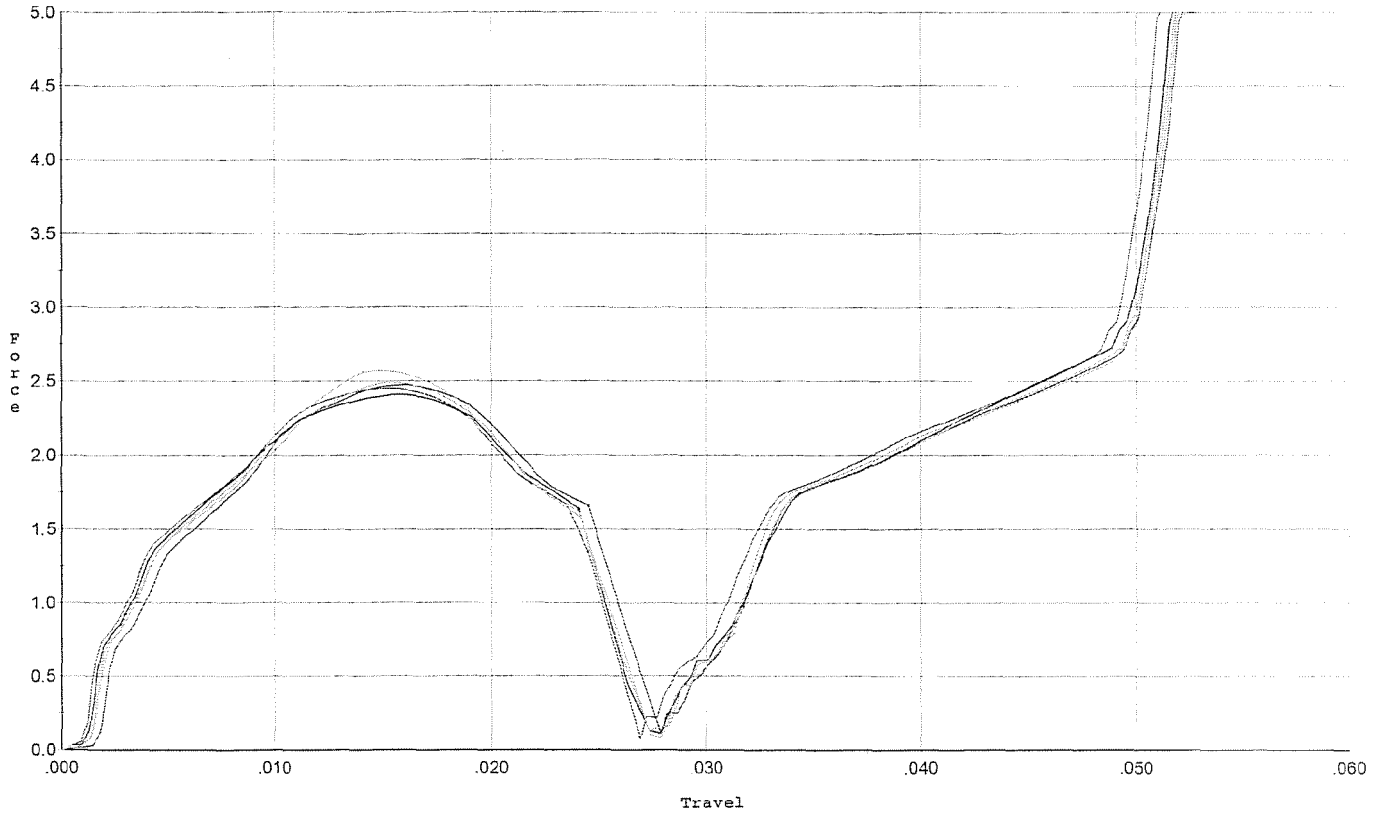
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.025	0.00	0.033	0.043		Set Trigger
2	2.559	0.023	0.00	0.034	0.043		Set Trigger
3	2.372	0.023	0.00	0.034	0.041		Set Trigger
4	2.490	0.026	0.00	0.034	0.044		Set Trigger
5	2.493	0.025	0.00	0.034	0.043		Set Trigger

A2-46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/9/2009

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



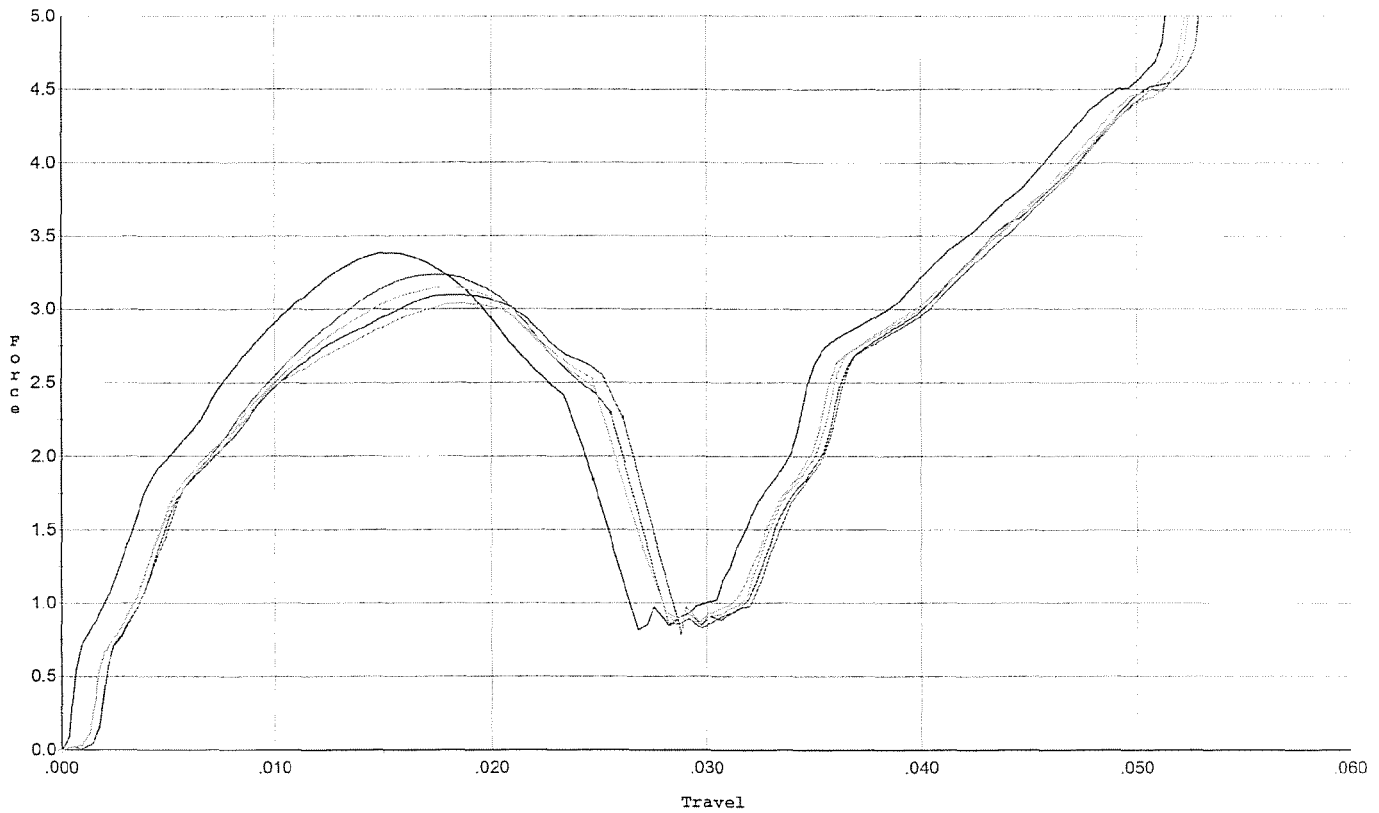
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.024	0.00	0.033	0.041		Set Trigger
2	2.409	0.024	0.00	0.033	0.041		Set Trigger
3	2.452	0.024	0.00	0.032	0.042		Set Trigger
4	2.571	0.024	0.00	0.033	0.042		Set Trigger
5	2.491	0.026	0.00	0.033	0.043		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



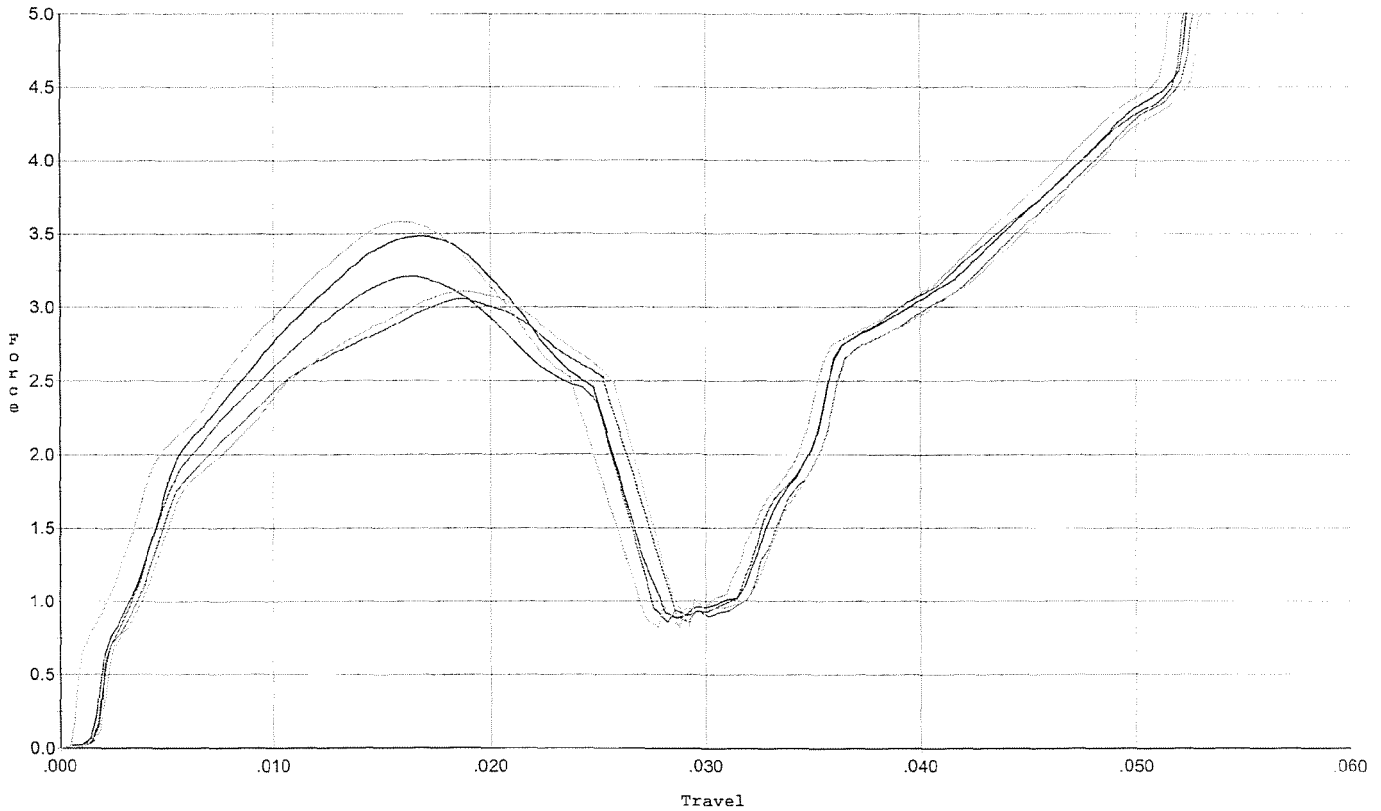
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.026	0.00	0.032	0.056		Set Trigger
2	3.386	0.025	0.00	0.032	0.058		Set Trigger
3	3.236	0.026	0.00	0.032	0.056		Set Trigger
4	3.150	0.025	0.00	0.032	0.054		Set Trigger
5	3.036	0.025	0.00	0.032	0.053		Set Trigger

A.3.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/9/2009

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



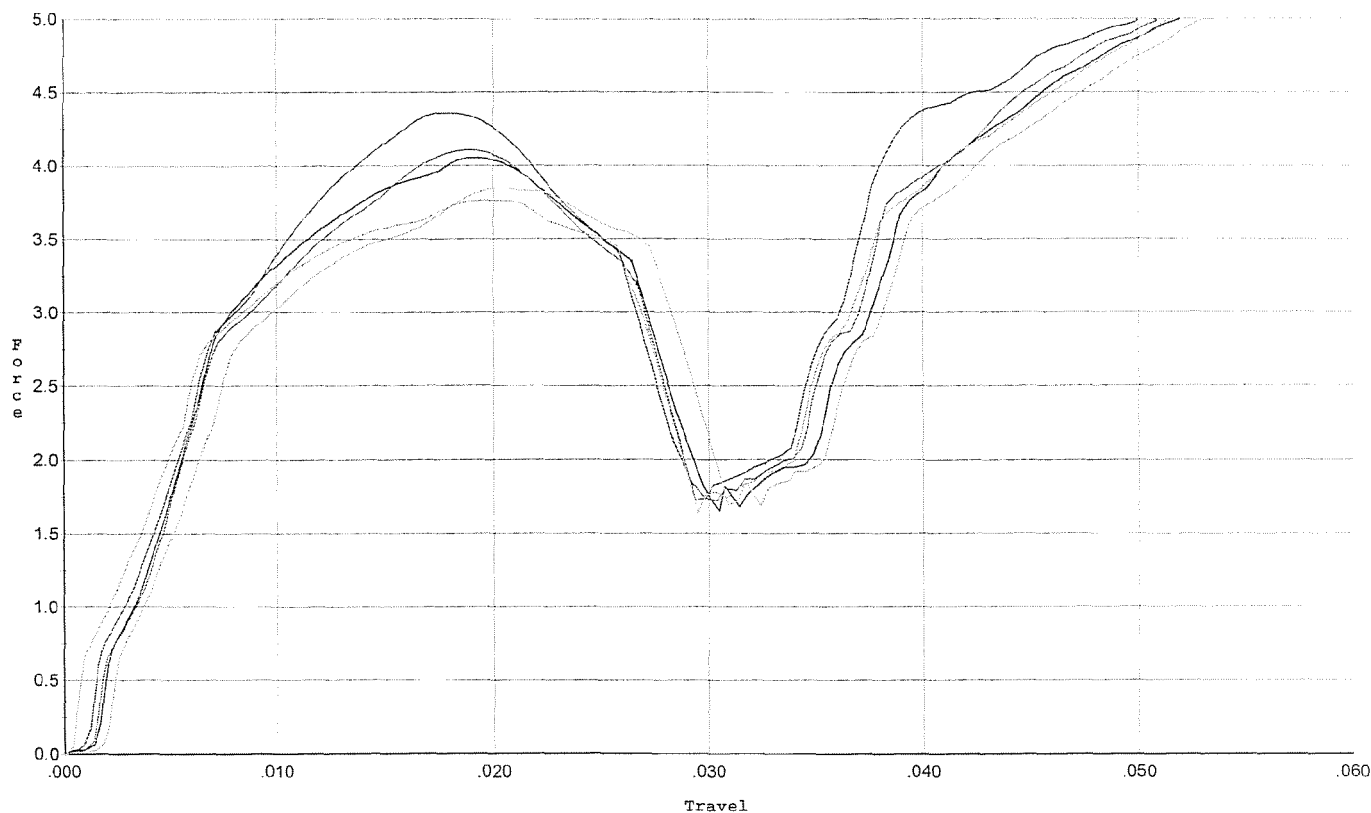
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.025	0.00	0.032	0.054		Set Trigger
2	3.482	0.025	0.00	0.032	0.058		Set Trigger
3	3.052	0.025	0.00	0.032	0.053		Set Trigger
4	3.109	0.026	0.00	0.032	0.055		Set Trigger
5	3.583	0.024	0.00	0.032	0.058		Set Trigger

A.3.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



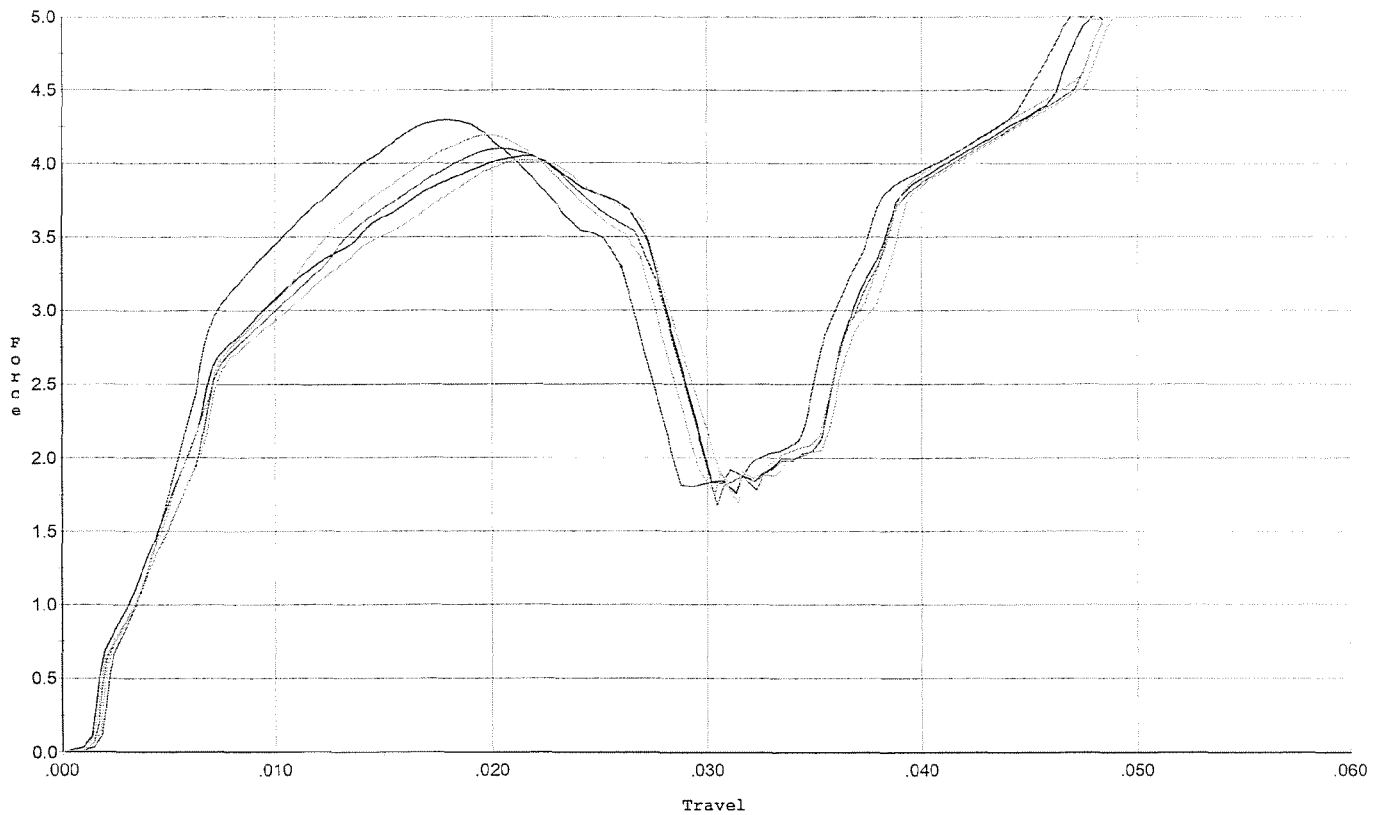
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.360	0.026	0.00	0.026	0.075		Set Trigger
2	4.055	0.026	0.00	0.026	0.074		Set Trigger
3	4.108	0.027	0.00	0.026	0.074		Set Trigger
4	3.850	0.029	0.00	0.025	0.077		Set Trigger
5	3.761	0.027	0.00	0.025	0.075		Set Trigger

A-4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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



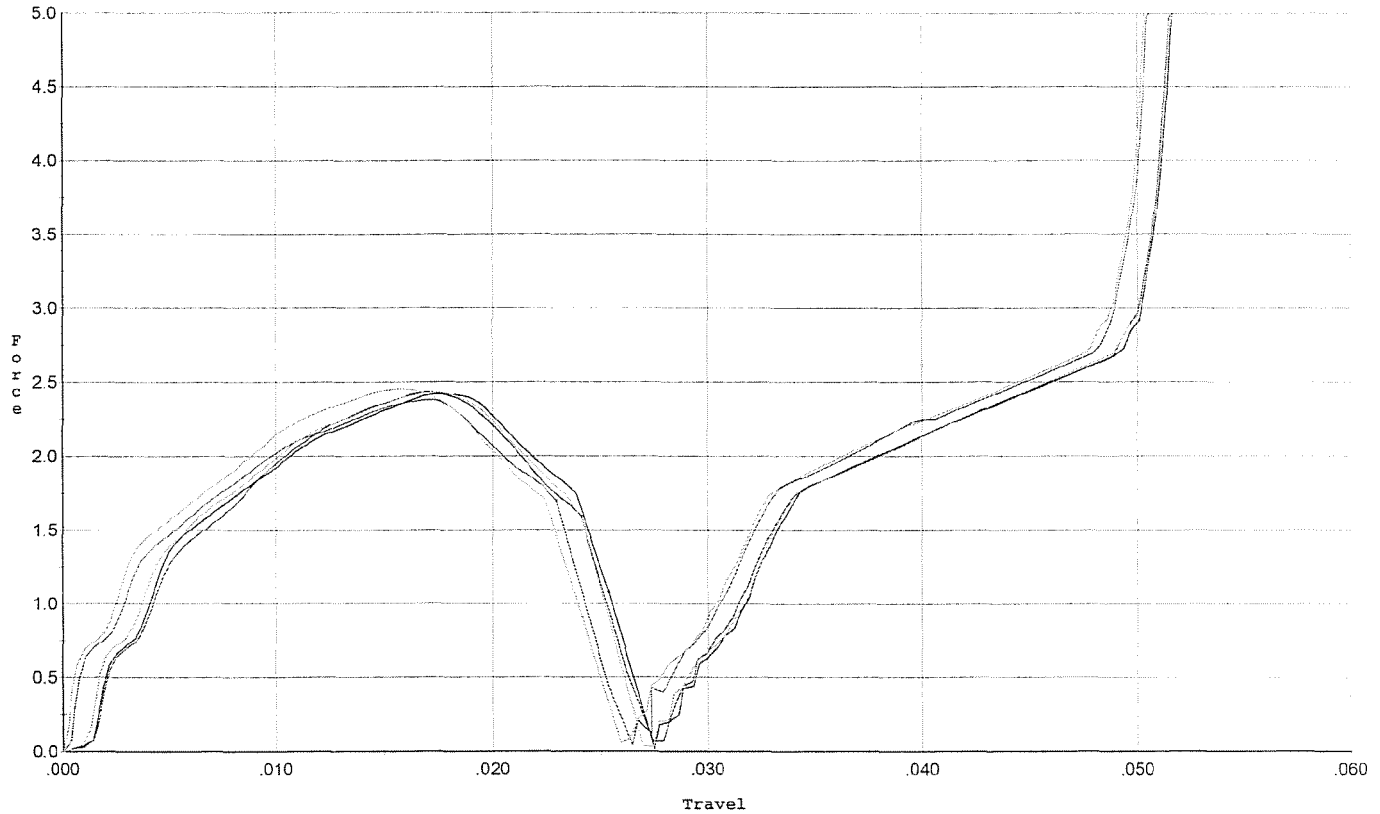
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.291	0.026	0.00	0.023	0.075		Set Trigger
2	4.049	0.027	0.00	0.021	0.076		Set Trigger
3	4.098	0.028	0.00	0.022	0.076		Set Trigger
4	4.023	0.027	0.00	0.022	0.073		Set Trigger
5	4.191	0.027	0.00	0.022	0.075		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/9/2009

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



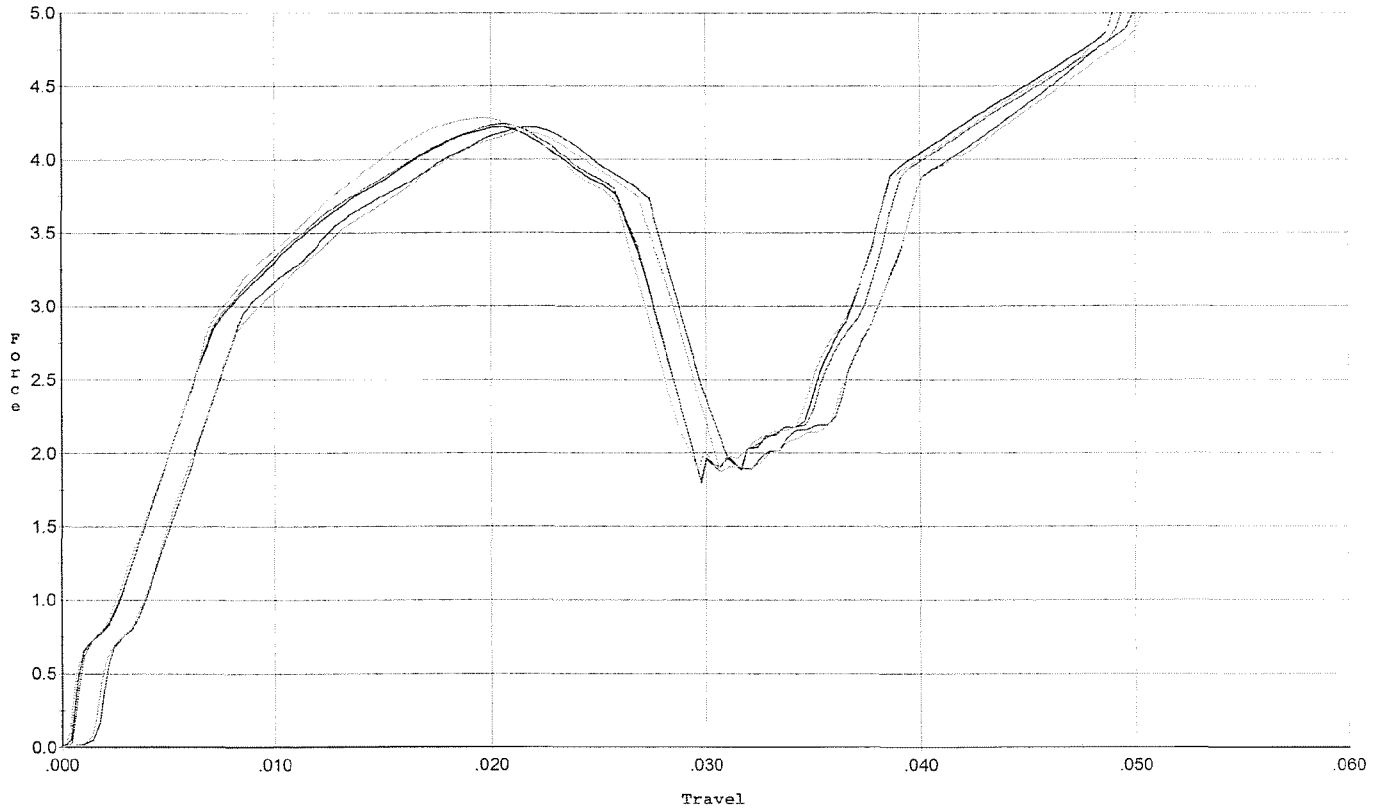
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.431	0.024	0.00	0.033	0.040		Set Trigger
2	2.421	0.025	0.00	0.033	0.042		Set Trigger
3	2.381	0.023	0.00	0.033	0.039		Set Trigger
4	2.431	0.024	0.00	0.033	0.041		Set Trigger
5	2.456	0.024	0.00	0.032	0.043		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/9/2009

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	4.221	0.027	0.00	0.022	0.078		Set Trigger
2	4.223	0.027	0.00	0.022	0.079		Set Trigger
3	4.244	0.027	0.00	0.022	0.079		Set Trigger
4	4.285	0.026	0.00	0.023	0.077		Set Trigger
5	4.188	0.028	0.00	0.022	0.080		Set Trigger

A-4.23