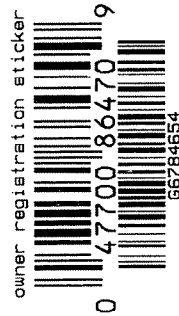


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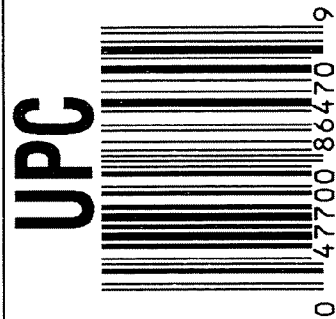
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6784654



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G678 4654

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-8-08	SPD
430	ASSEMBLE TO STOCK		9-8-08	SP
440	PROOF		9-8-08	SPD
460	CHECK HEADSPACE		9-8-08	SPD
470	DIS-ASSEMBLE ACTION		9-8-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	9-9-08	RT
475	DRILL AND TAP SIGHT HOLES	10 10 2006	9-9-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BAA	9-10-08	BTY
490	MAGNAFLUX BOLT		9/8/08	MR
500	ROLLMARK CALIBER		9/10/08	RT
520	GOFF BLAST BBL / REC		9/10/08	DS
542	APPLY COATINGS (BARREL ACTION)		9 11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-16-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2:50 LBS +/- .5 LBS		

F004 REV 5/2006

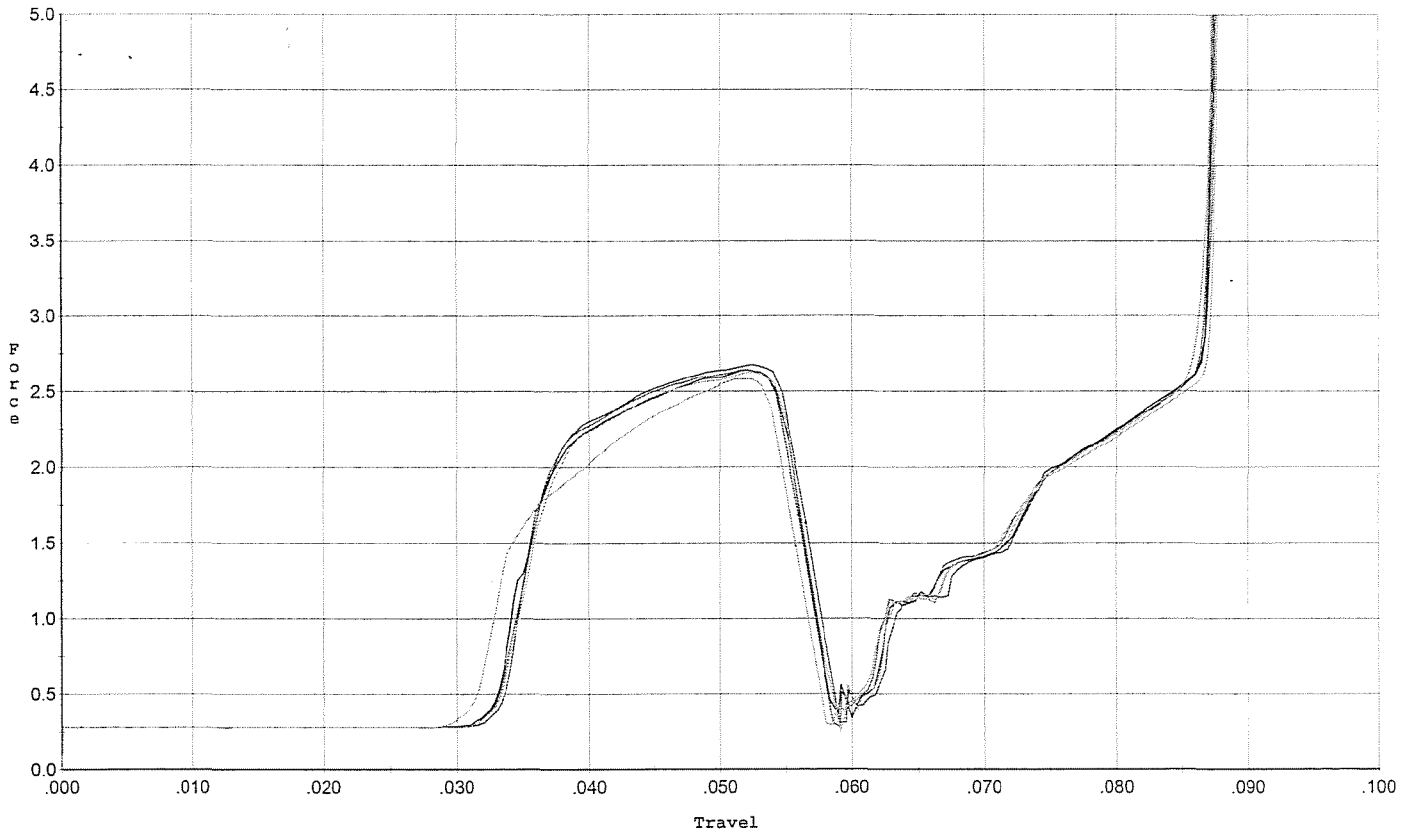
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2</u> <u>2</u> <u>2</u>	9-22-08	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-22-08	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	9-22-08	TL
	J) ASSEMBLE STOCK		9-16-08	PPD
	K) ASSEMBLE SWIVEL STUDS		9-22-08	TL
	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	9-17-08	FM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N.A</i>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-17-08	AA
670	FINAL INSPECTION A) HEADSPACE		9-22-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.53</u> <u>2.67</u> <u>2.59</u> <u>2.61</u>	9-18-08	TRU
	C) FUNCTION		9-22-08	TL
690	PACK		12-8-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



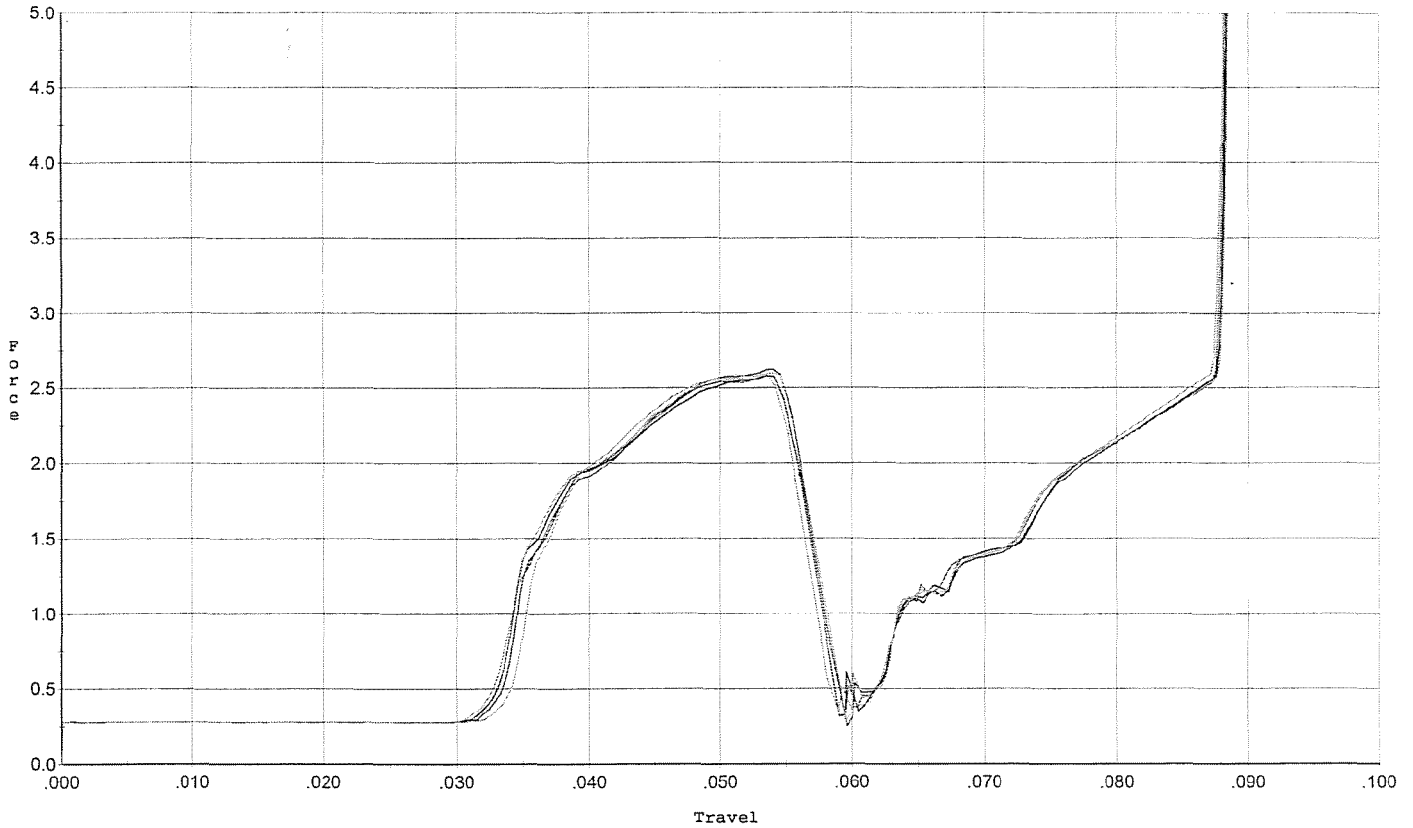
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.057	0.033	0.036	0.061		Set Trigger
2	2.642	0.055	0.033	0.036	0.059		Set Trigger
3	2.638	0.056	0.033	0.036	0.060		Set Trigger
4	2.624	0.055	0.033	0.036	0.058		Set Trigger
5	2.583	0.056	0.032	0.036	0.059		Set Trigger

Avg 2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



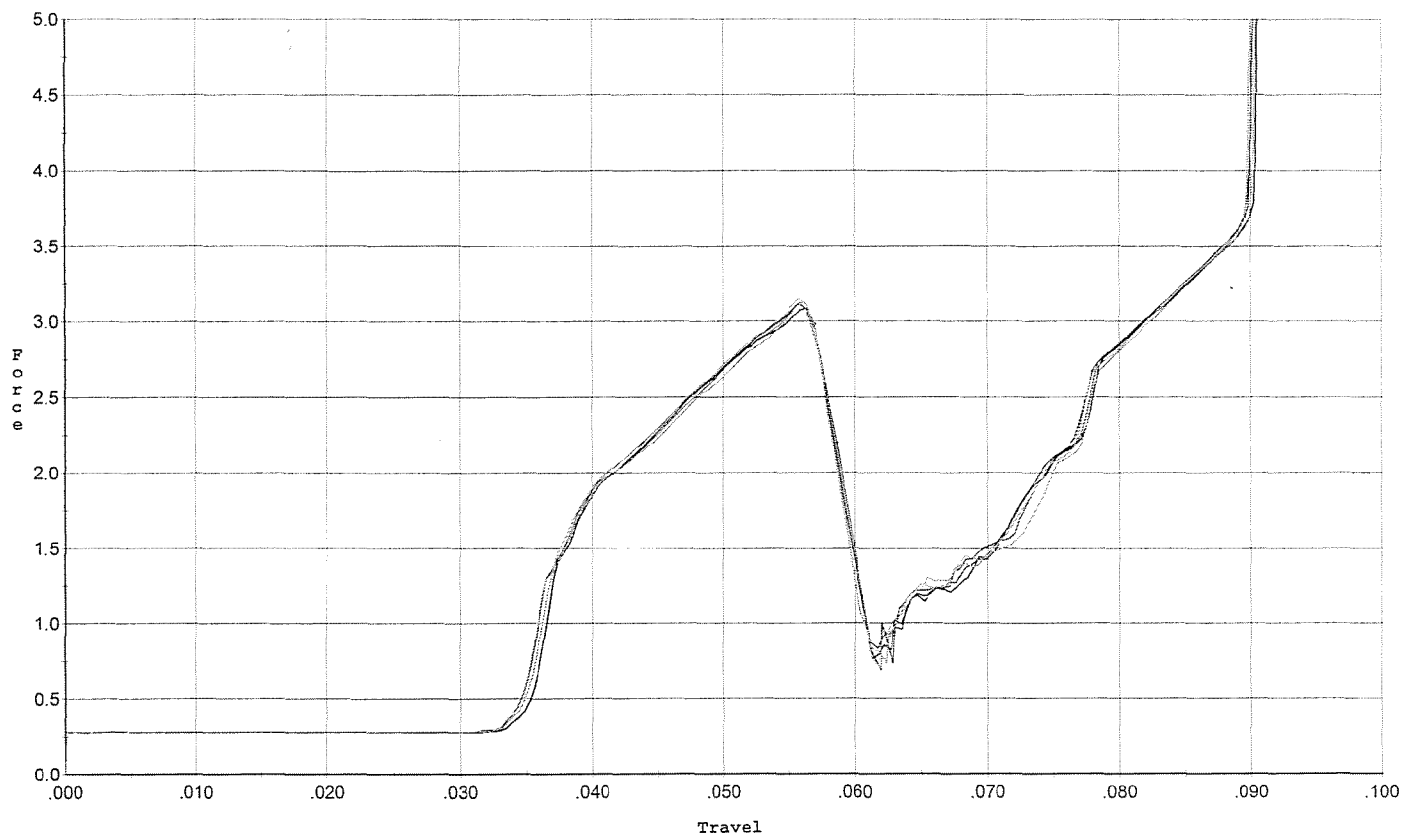
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.624	0.055	0.034	0.037	0.057		Set Trigger
2	2.581	0.056	0.033	0.037	0.058		Set Trigger
3	2.580	0.056	0.033	0.037	0.057		Set Trigger
4	2.599	0.057	0.034	0.036	0.058		Set Trigger
5	2.589	0.055	0.033	0.037	0.057		Set Trigger

AVG 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



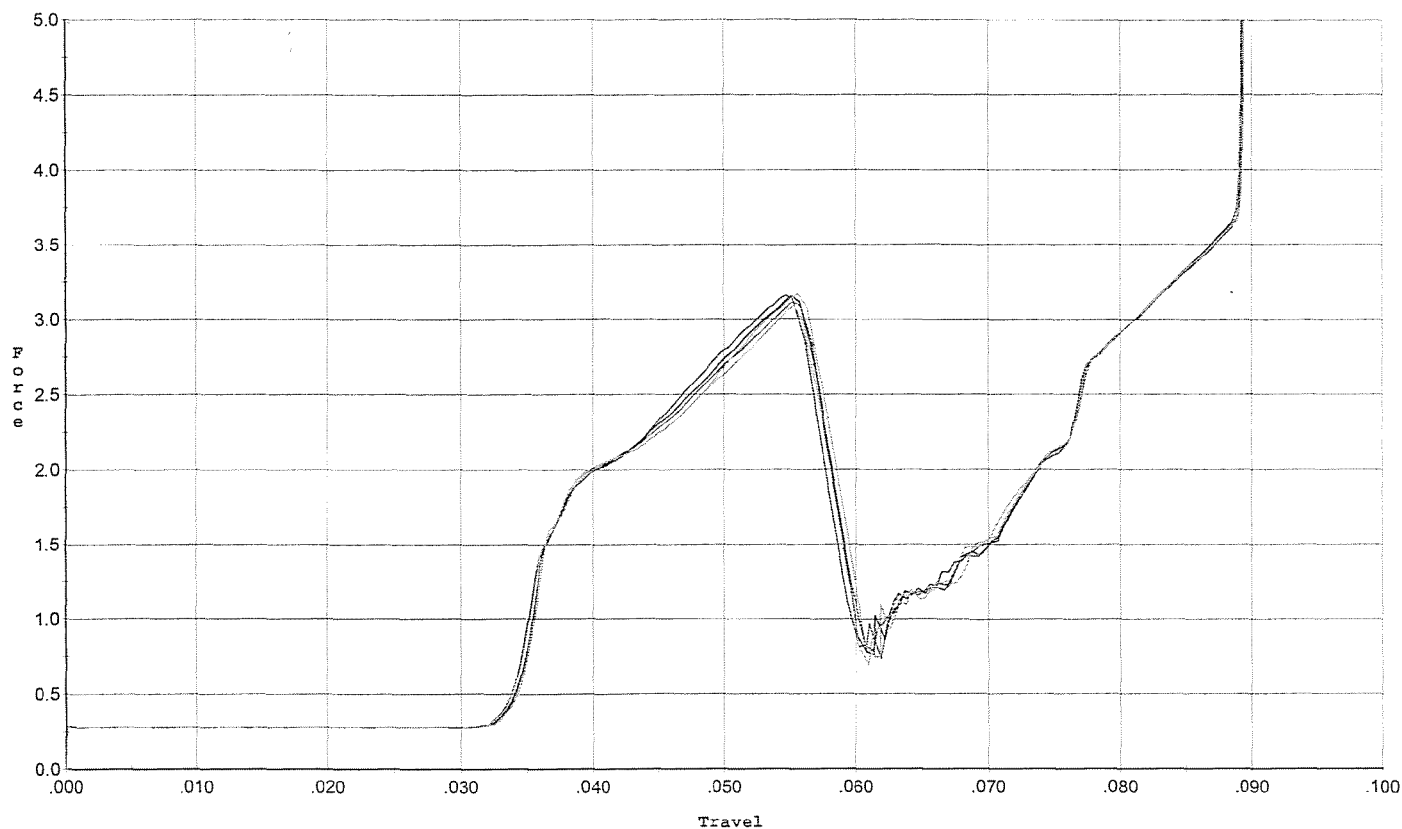
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.088	0.059	0.035	0.036	0.064		Set Trigger
2	3.122	0.057	0.035	0.037	0.062		Set Trigger
3	3.115	0.057	0.035	0.037	0.063		Set Trigger
4	3.152	0.057	0.034	0.036	0.063		Set Trigger
5	3.125	0.059	0.035	0.036	0.064		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



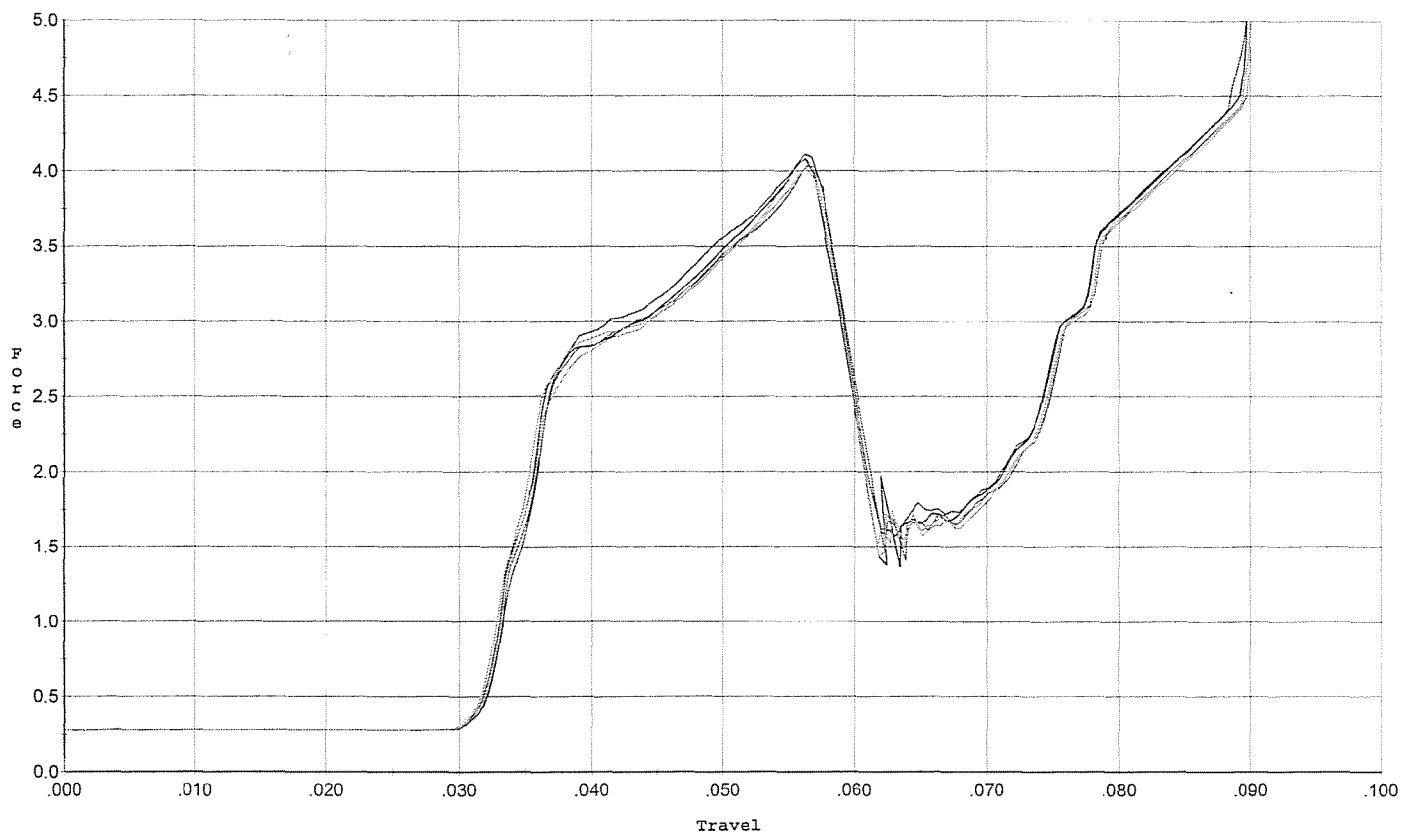
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.056	0.034	0.036	0.062		Set Trigger
2	3.158	0.057	0.034	0.036	0.064		Set Trigger
3	3.115	0.057	0.034	0.036	0.063		Set Trigger
4	3.093	0.057	0.034	0.036	0.063		Set Trigger
5	3.174	0.058	0.034	0.036	0.065		Set Trigger

Arg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



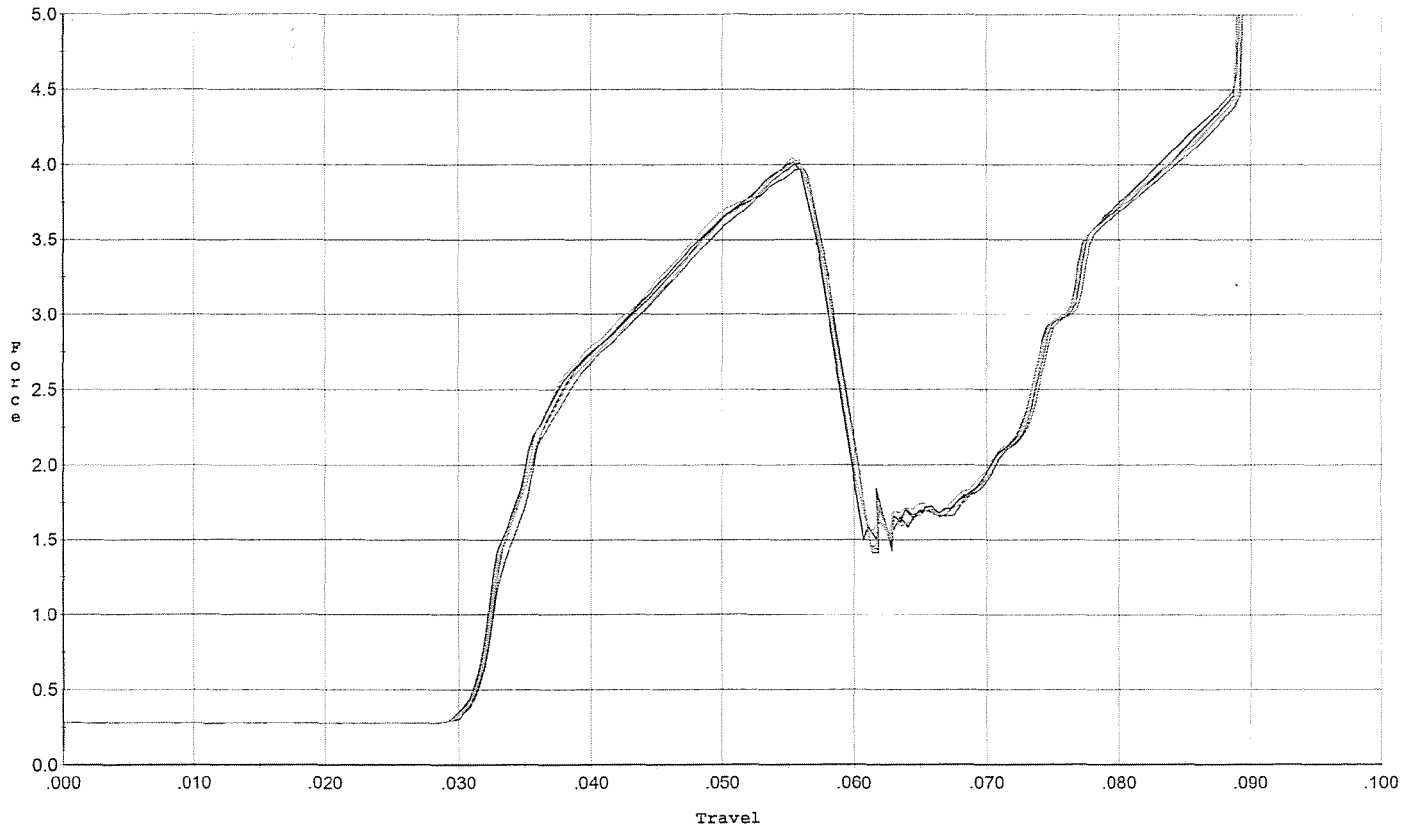
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.058	0.032	0.034	0.089		Set Trigger
2	4.077	0.059	0.032	0.034	0.090		Set Trigger
3	4.031	0.058	0.032	0.034	0.088		Set Trigger
4	4.086	0.058	0.032	0.034	0.089		Set Trigger
5	4.018	0.058	0.032	0.034	0.088		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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



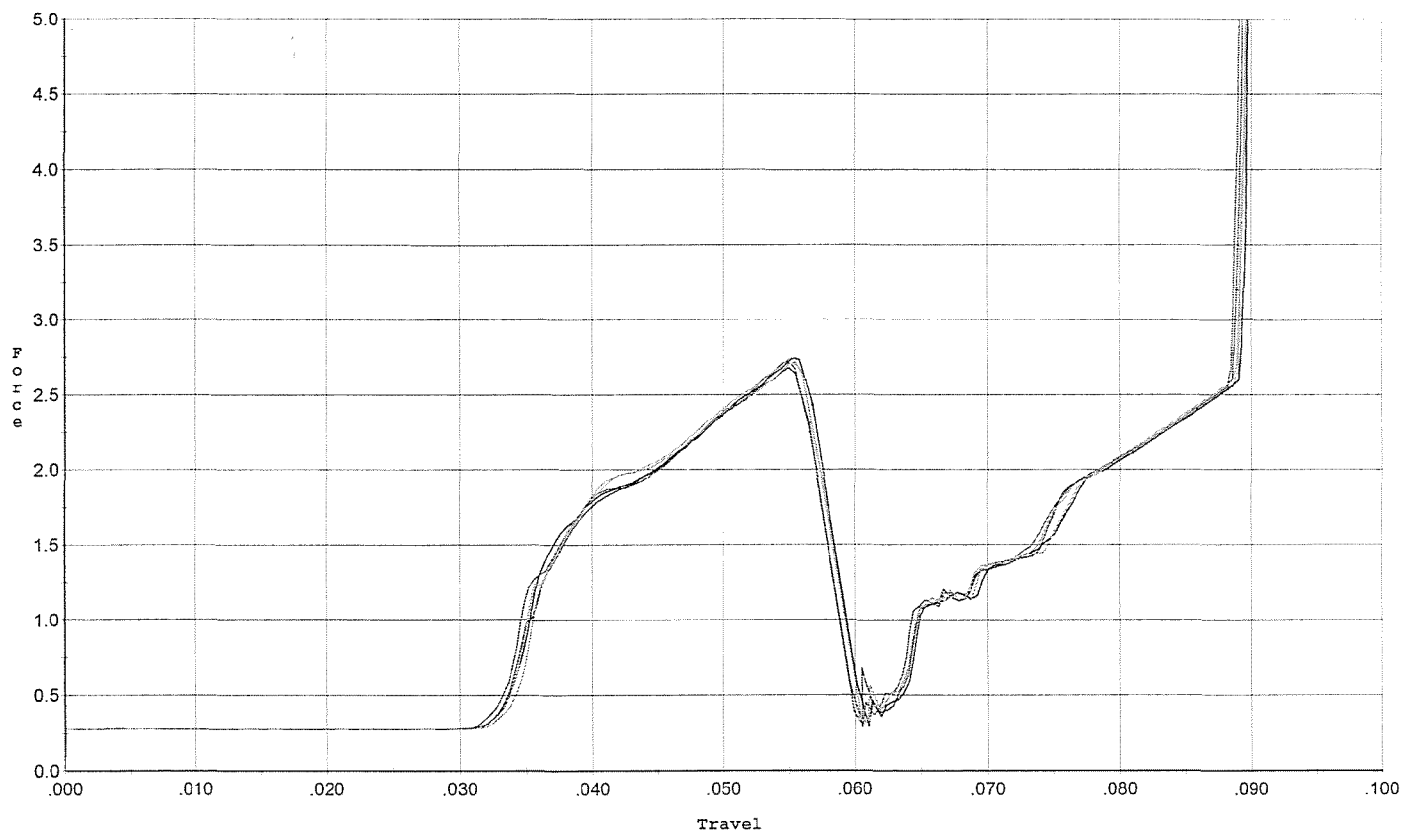
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.011	0.058	0.031	0.033	0.089		Set Trigger
2	4.018	0.057	0.031	0.034	0.088		Set Trigger
3	3.974	0.059	0.031	0.034	0.089		Set Trigger
4	4.031	0.059	0.031	0.034	0.090		Set Trigger
5	4.046	0.057	0.031	0.034	0.087		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 8/29/08

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



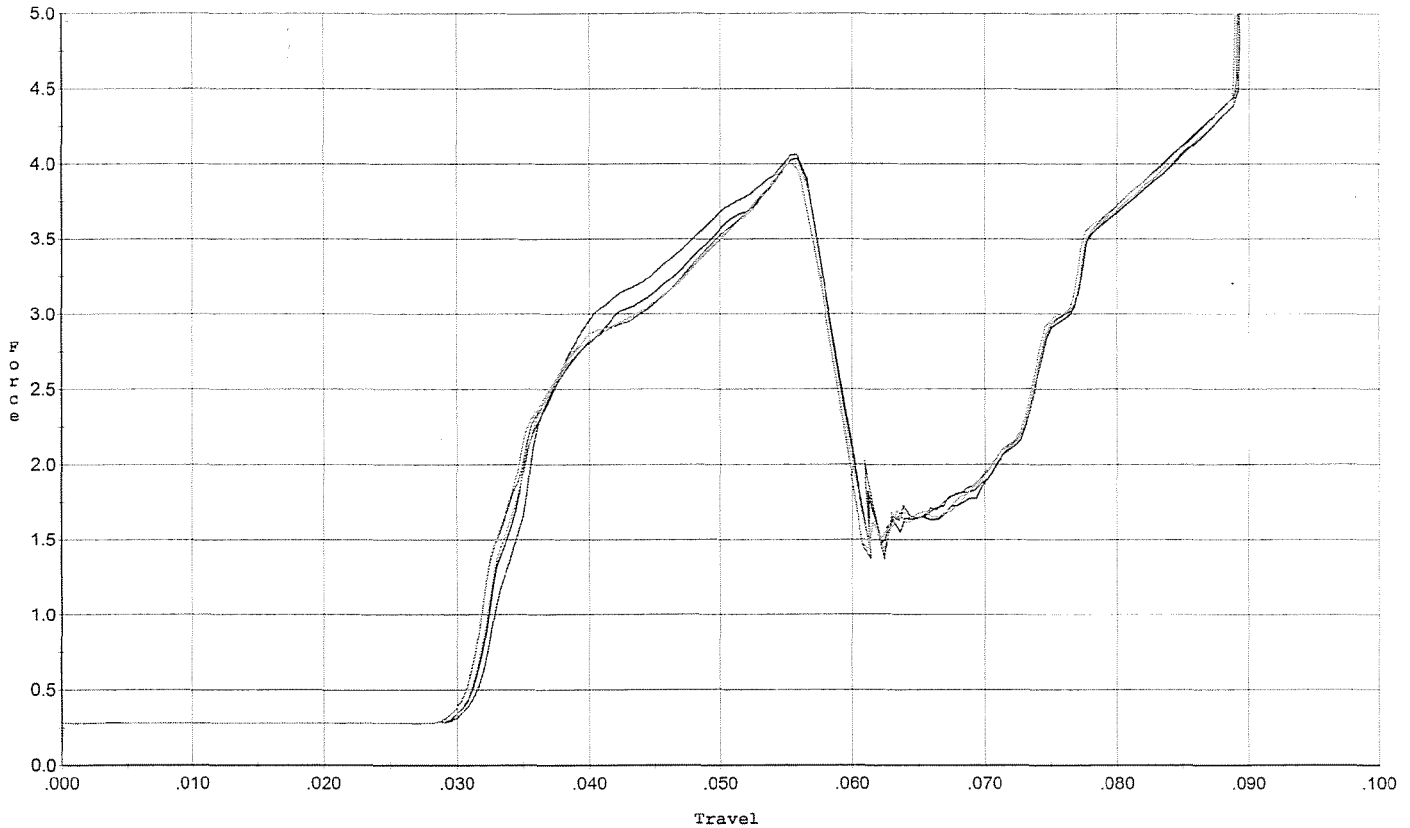
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.056	0.033	0.037	0.056		Set Trigger
2	2.742	0.057	0.034	0.037	0.057		Set Trigger
3	2.726	0.057	0.033	0.036	0.056		Set Trigger
4	2.742	0.058	0.034	0.037	0.058		Set Trigger
5	2.714	0.058	0.034	0.037	0.057		Set Trigger

AVG 2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/29/08

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	4.061	0.057	0.031	0.034	0.087		Set Trigger
2	4.035	0.057	0.031	0.034	0.086		Set Trigger
3	4.013	0.058	0.031	0.034	0.088		Set Trigger
4	4.019	0.057	0.031	0.034	0.086		Set Trigger
5	4.013	0.058	0.030	0.034	0.088		Set Trigger

Avg 4.02