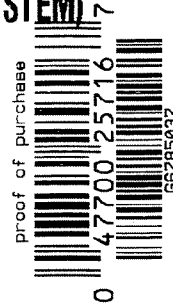


66785037

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

- INSTRUCTION BOOK 3518

BM FORM

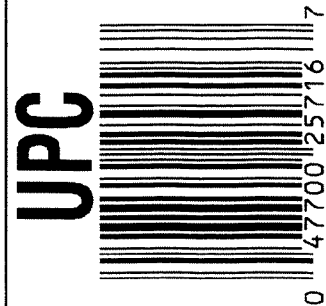


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785037



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6785037

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-22-08	SPD
430	ASSEMBLE TO STOCK		9-22-08	SP
440	PROOF		9-22-08	SPD
460	CHECK HEADSPACE		9-22-08	SPD
470	DIS-ASSEMBLE ACTION		9-22-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-23-08	BR
475	DRILL AND TAP SIGHT HOLES	2008	9-23-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (RB)	9/30/08	(RB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/30/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-4-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-4-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-4-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-27-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

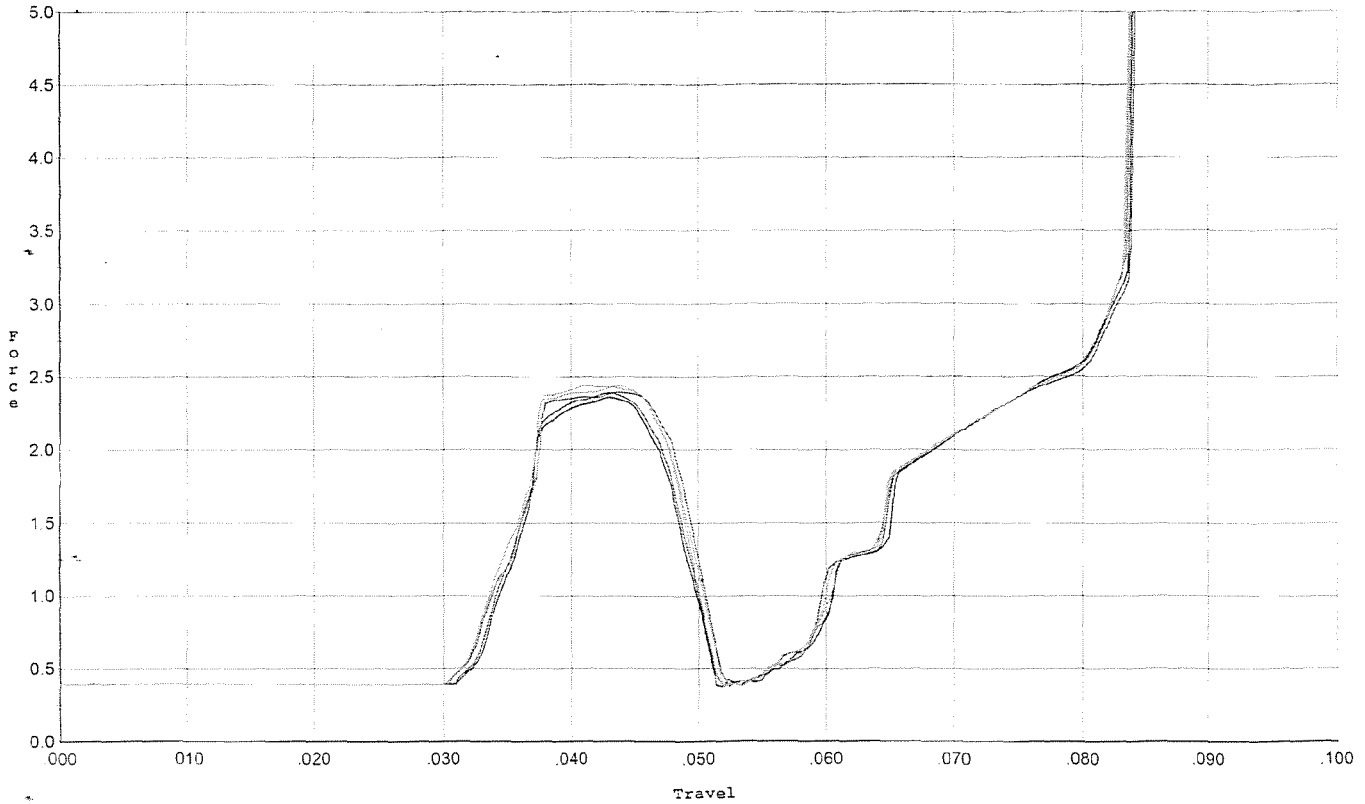
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>45</u> <u>50</u> <u>50</u>	11-3-08	LJD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>45</u> <u>40</u> <u>40</u>	11-3-08	LJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>-0.22</u> <u>-0.22</u> <u>-0.22</u>	11-3-08	LJD
	J) ASSEMBLE STOCK		10-27-08	ESN
	K) ASSEMBLE SWIVEL STUDS		11-3-08	LJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	10-29-08	LJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>NA</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-29-08	TAZ
670	FINAL INSPECTION A) HEADSPACE		11-3-08	LJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.16</u> <u>2.18</u> <u>2.28</u> <u>2.15</u>	10-29-08	TC
	C) FUNCTION		11-3-08	LJD
690	PACK		11/4/08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



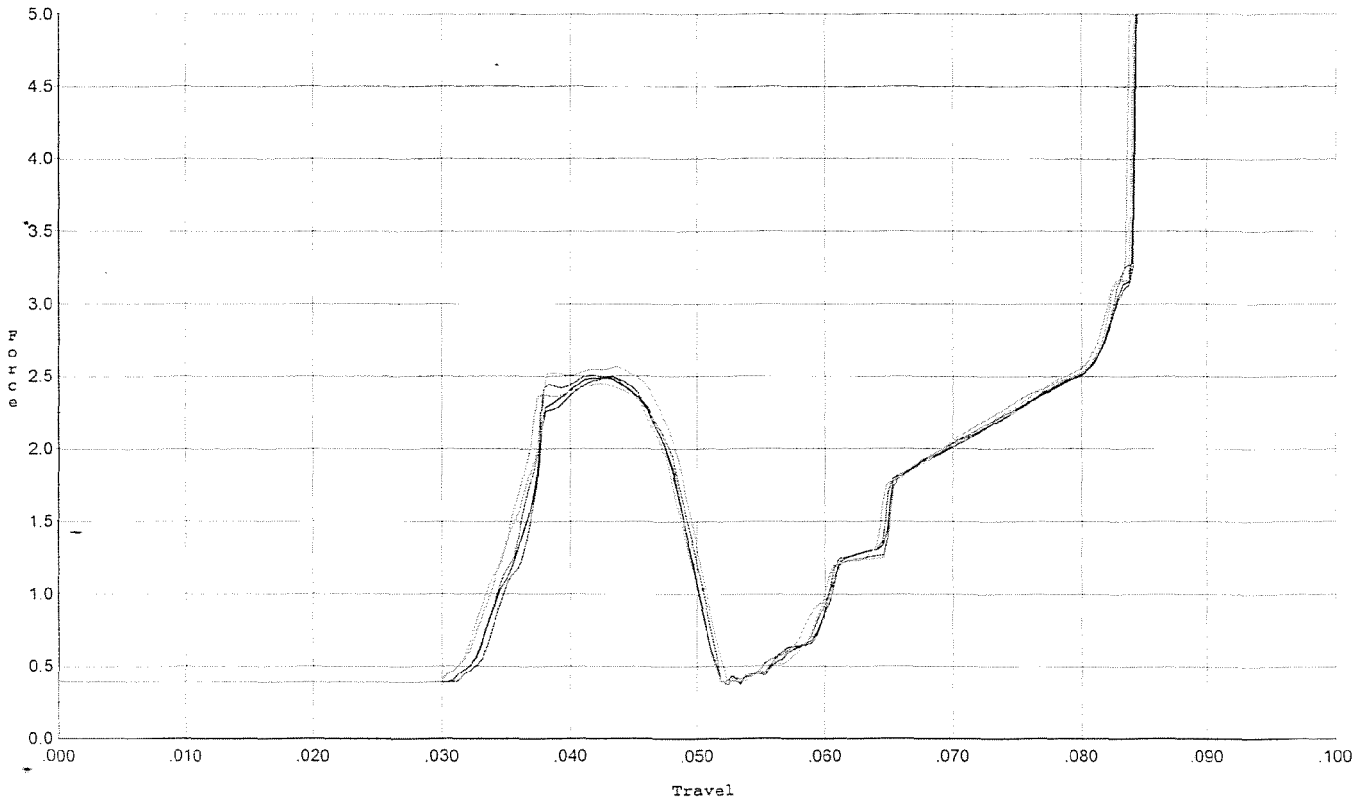
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.389	0.050	0.033	0.039	0.045		Set Trigger
2	2.358	0.050	0.033	0.039	0.044		Set Trigger
3	2.392	0.050	0.031	0.038	0.047		Set Trigger
4	2.441	0.051	0.032	0.038	0.047		Set Trigger
5	2.440	0.048	0.031	0.039	0.045		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



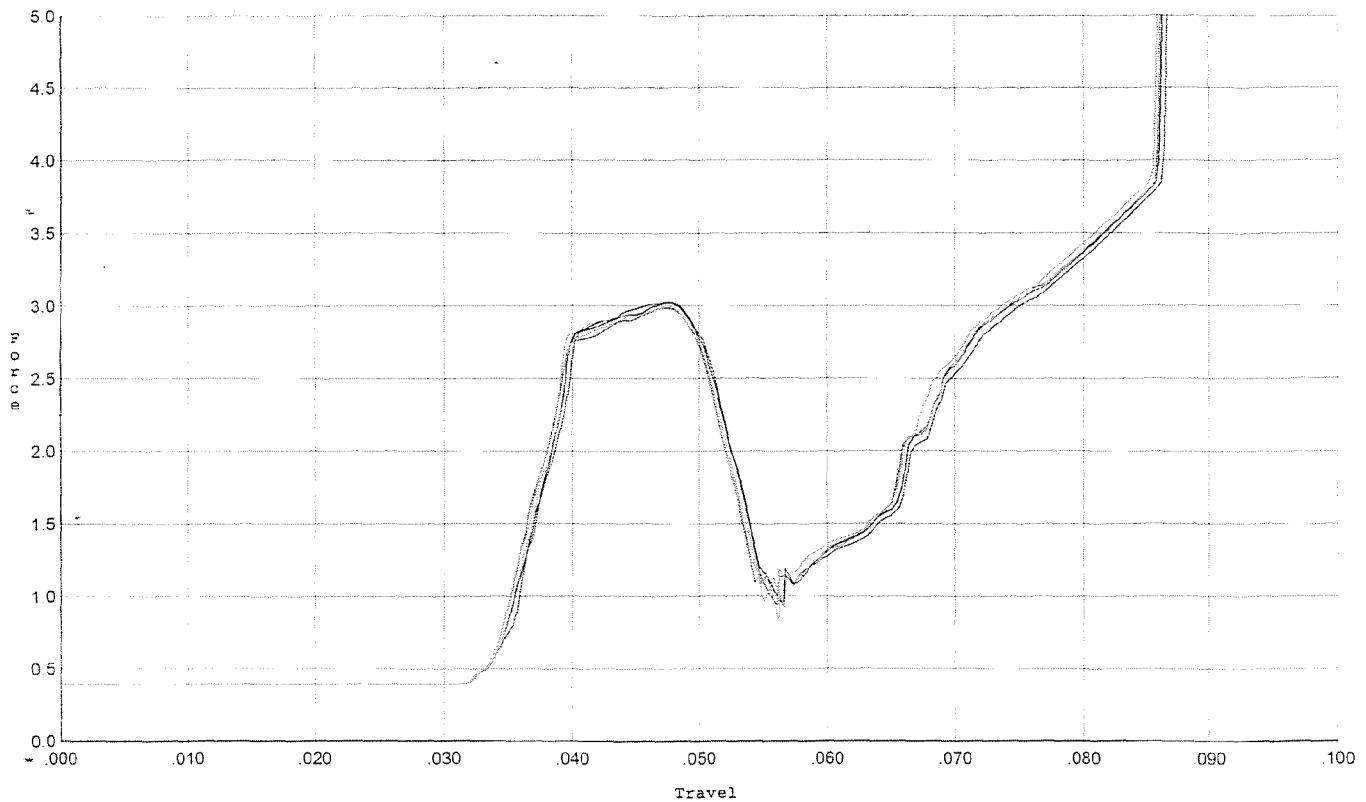
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.048	0.034	0.039	0.043		Set Trigger
2	2.488	0.050	0.033	0.039	0.045		Set Trigger
3	2.508	0.050	0.033	0.038	0.047		Set Trigger
4	2.450	0.050	0.032	0.038	0.047		Set Trigger
5	2.566	0.050	0.032	0.038	0.049		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



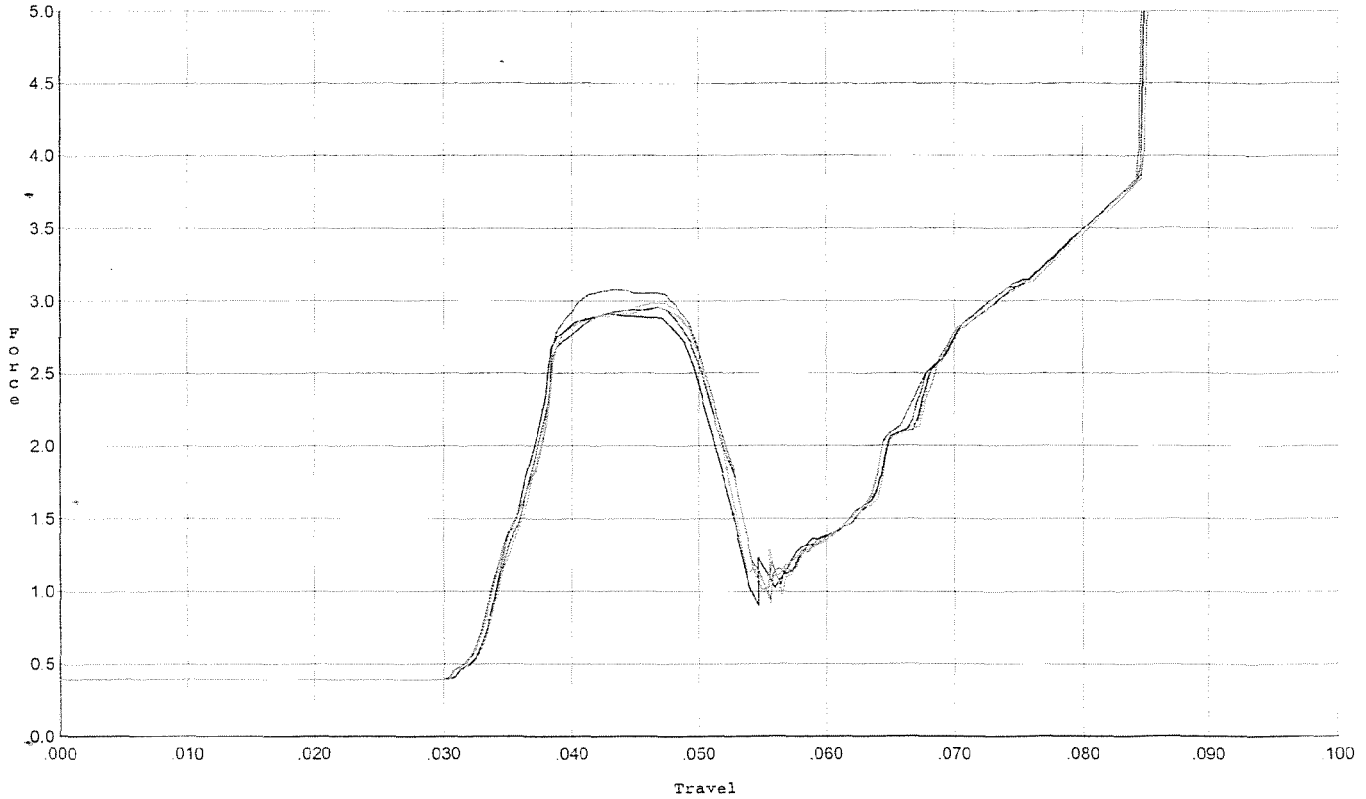
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.027	0.053	0.034	0.038	0.059		Set Trigger
2	3.023	0.053	0.034	0.037	0.060		Set Trigger
3	2.984	0.053	0.034	0.037	0.059		Set Trigger
4	2.993	0.054	0.034	0.037	0.060		Set Trigger
5	3.004	0.053	0.034	0.037	0.059		Set Trigger

Aug 3.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



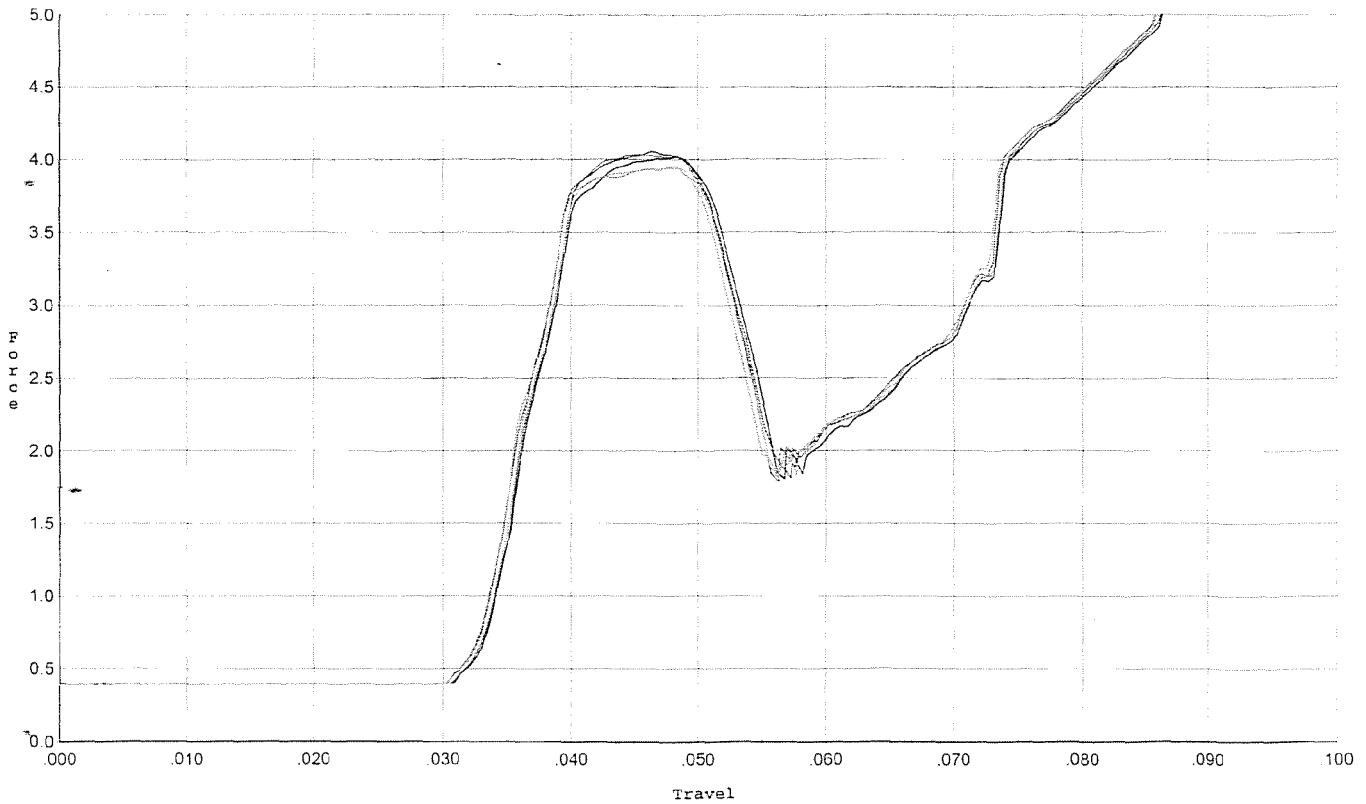
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.954	0.053	0.033	0.036	0.060		Set Trigger
2	2.912	0.053	0.033	0.037	0.059		Set Trigger
3	3.079	0.053	0.033	0.036	0.062		Set Trigger
4	2.985	0.052	0.033	0.037	0.060		Set Trigger
5	2.954	0.053	0.033	0.037	0.060		Set Trigger

Avg 2.97

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



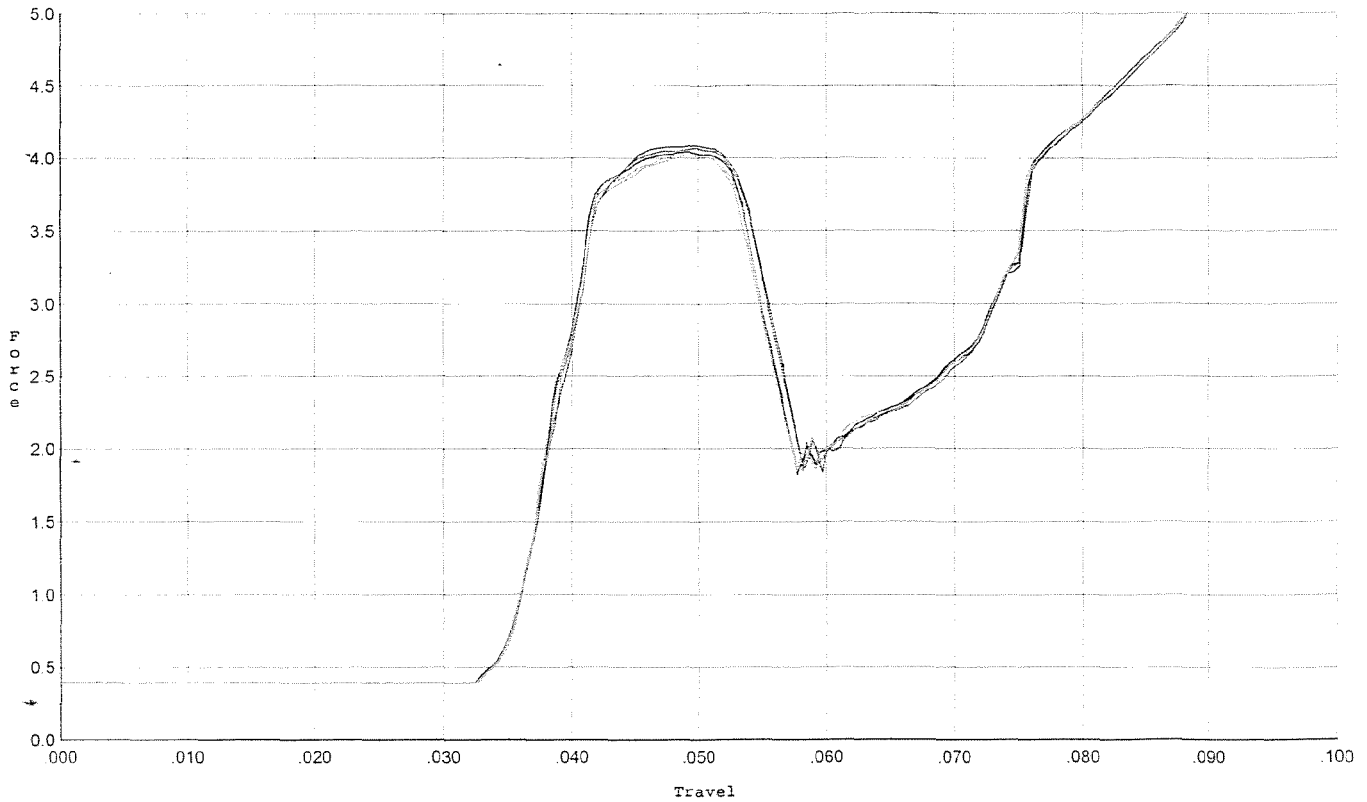
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.054	0.033	0.035	0.081		Set Trigger
2	4.018	0.055	0.031	0.035	0.082		Set Trigger
3	4.034	0.054	0.031	0.035	0.082		Set Trigger
4	3.956	0.054	0.033	0.035	0.081		Set Trigger
5	3.942	0.054	0.031	0.035	0.080		Set Trigger

Avg 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



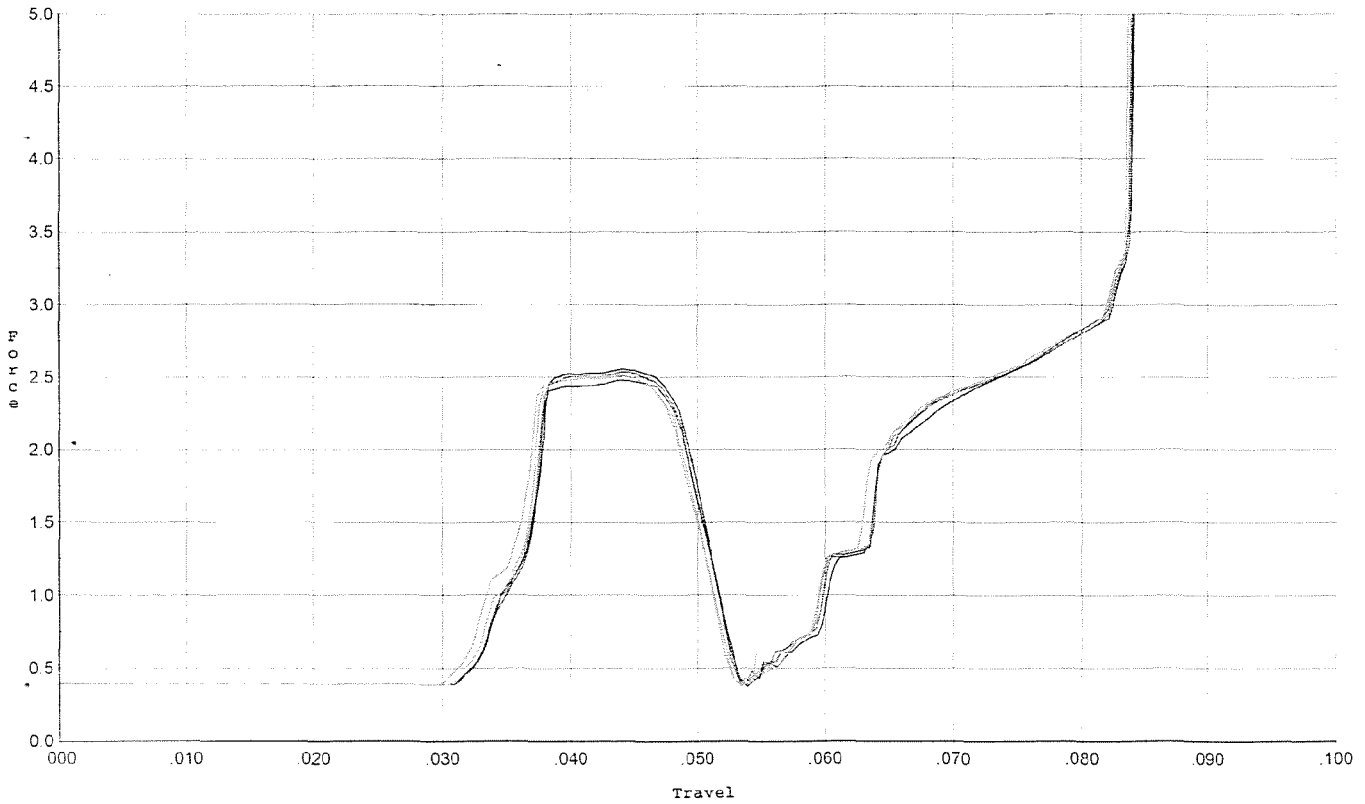
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.057	0.035	0.036	0.084		Set Trigger
2	4.040	0.053	0.035	0.037	0.078		Set Trigger
3	4.069	0.054	0.035	0.037	0.079		Set Trigger
4	4.022	0.054	0.035	0.037	0.078		Set Trigger
5	4.021	0.053	0.033	0.037	0.077		Set Trigger

Avg 4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



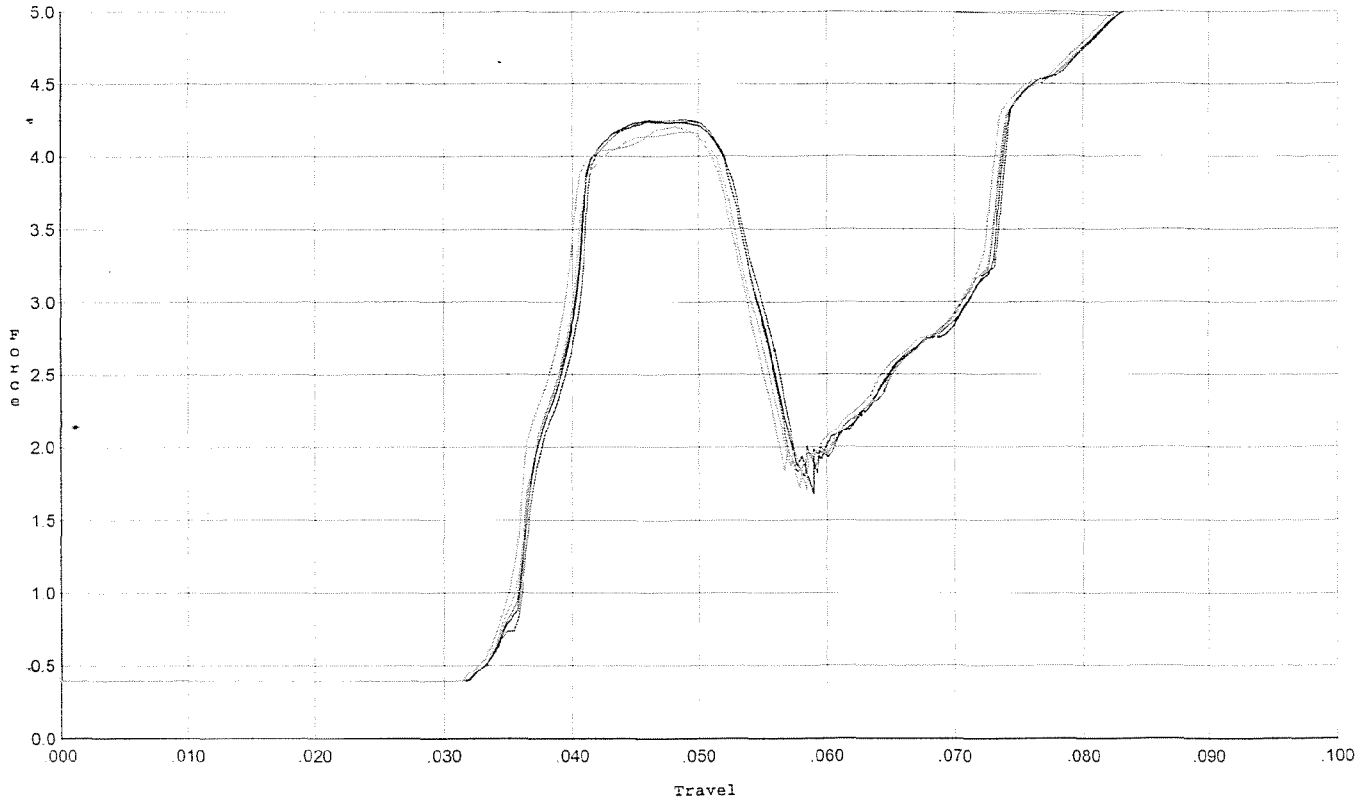
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.479	0.051	0.033	0.038	0.049		Set Trigger
2	2.555	0.050	0.033	0.038	0.048		Set Trigger
3	2.536	0.051	0.033	0.038	0.050		Set Trigger
4	2.507	0.049	0.033	0.038	0.047		Set Trigger
5	2.520	0.050	0.032	0.037	0.050		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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	4.245	0.056	0.034	0.035	0.085		Set Trigger
2	4.240	0.055	0.034	0.036	0.084		Set Trigger
3	4.252	0.055	0.034	0.035	0.085		Set Trigger
4	4.166	0.052	0.034	0.036	0.077		Set Trigger
5	4.204	0.053	0.034	0.036	0.079		Set Trigger

Avg 4.22