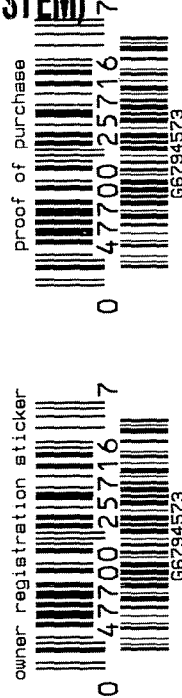


G-6794573

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

- INSTRUCTION BOOK 3518

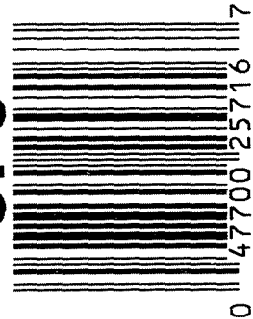
BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794573

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794573

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SP
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SP
460	CHECK HEADSPACE		9-30-08	SP
470	DIS-ASSEMBLE ACTION		9-30-08	SP
472	SERIALIZE BOLT HANDLE		10-1-08	RSW
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(K)
490	MAGNAFLUX BOLT		9/3/08	MR
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10-8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-30-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400073168

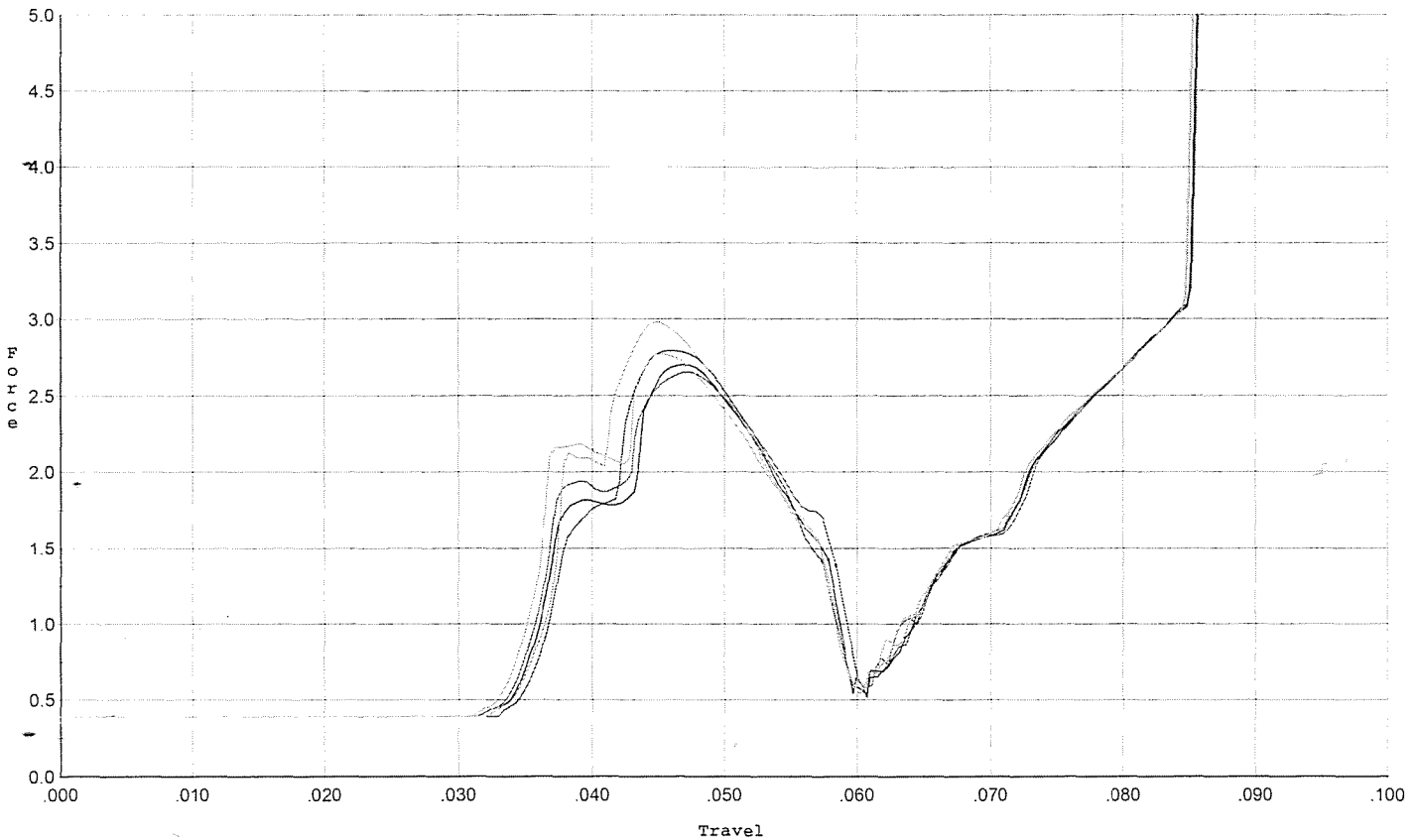
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	11-6-08	2A
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	11-6-08	2A
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-6-08	2A
	J) ASSEMBLE STOCK		10-30-08	2A
	K) ASSEMBLE SWIVEL STUDS		11-6-08	2A
	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	11-3-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	2A
670	FINAL INSPECTION A) HEADSPACE		11-6-08	2A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.41</u> <u>2.31</u> <u>2.19</u> <u>2.34</u>	11-5-08	FM
	C) FUNCTION		11-6-08	2A
690	PACK		12-1-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



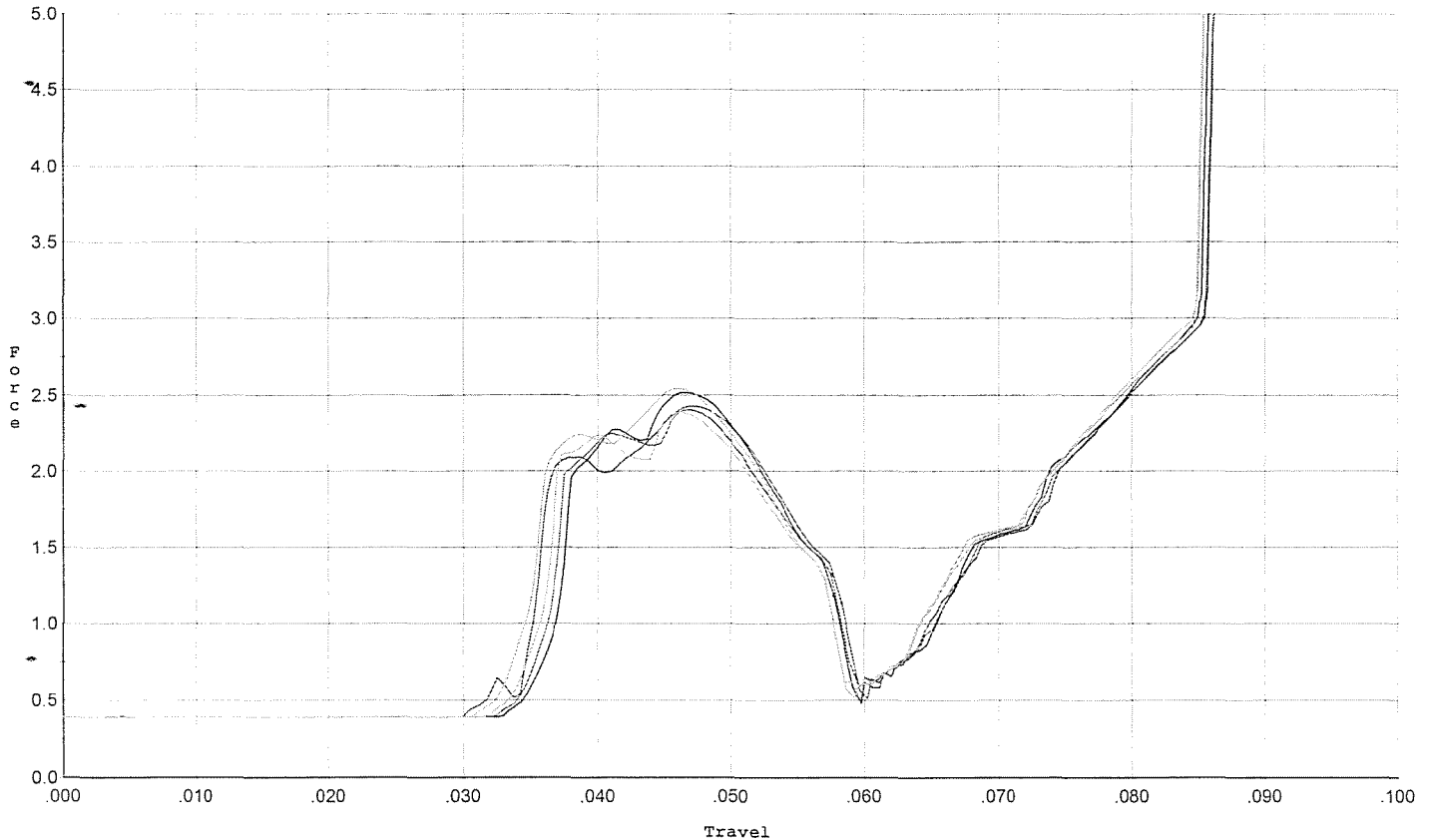
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.793	0.057	0.035	0.035	0.059		Set Trigger
2	2.703	0.058	0.035	0.035	0.060		Set Trigger
3	2.653	0.058	0.034	0.034	0.062		Set Trigger
4	2.773	0.057	0.033	0.034	0.062		Set Trigger
5	2.982	0.058	0.035	0.034	0.064		Set Trigger

A-2.78

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



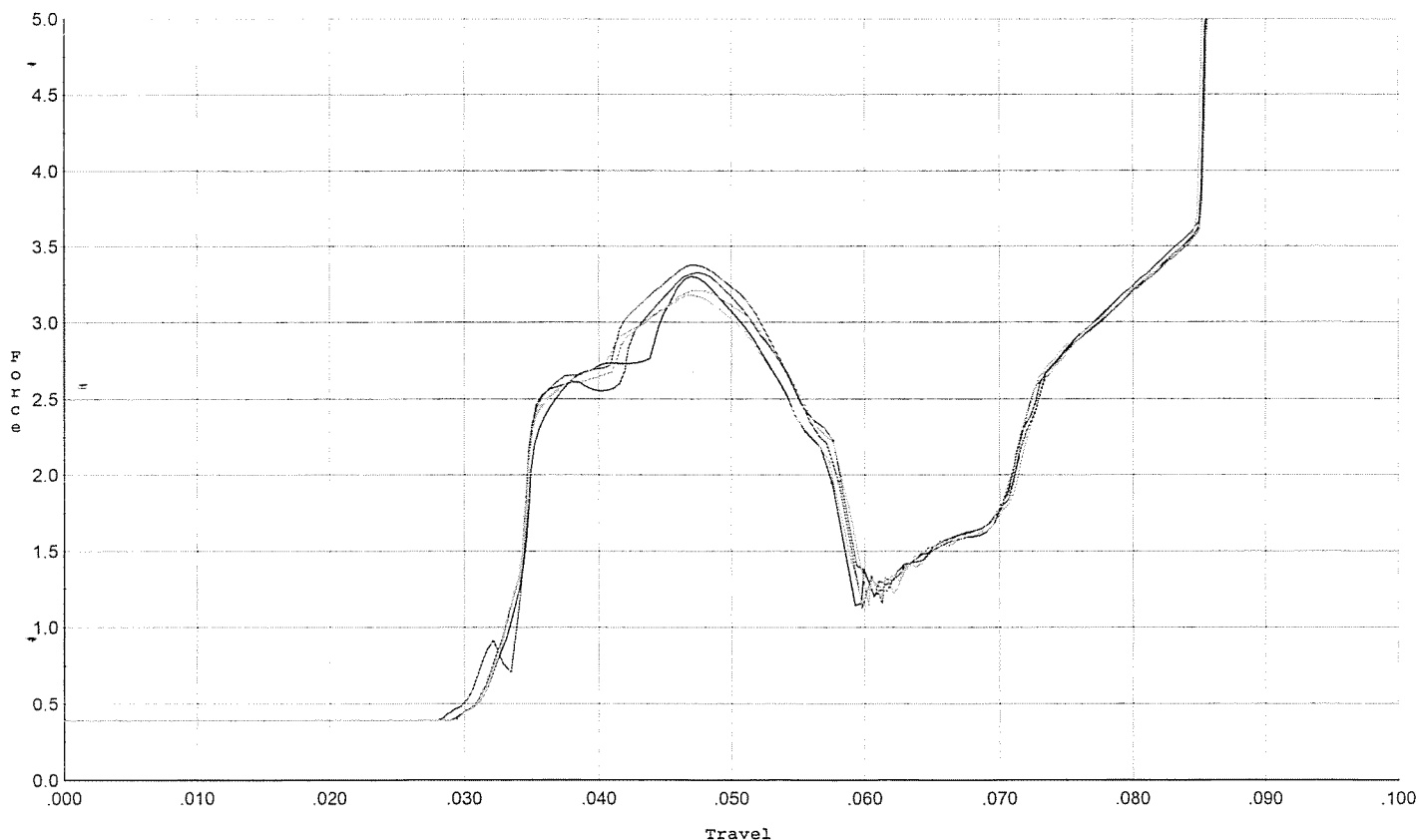
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.430	0.058	0.032	0.035	0.061		Set Trigger
2	2.518	0.058	0.035	0.035	0.058		Set Trigger
3	2.405	0.057	0.034	0.035	0.058		Set Trigger
4	2.391	0.057	0.034	0.035	0.057		Set Trigger
5	2.544	0.057	0.033	0.034	0.061		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



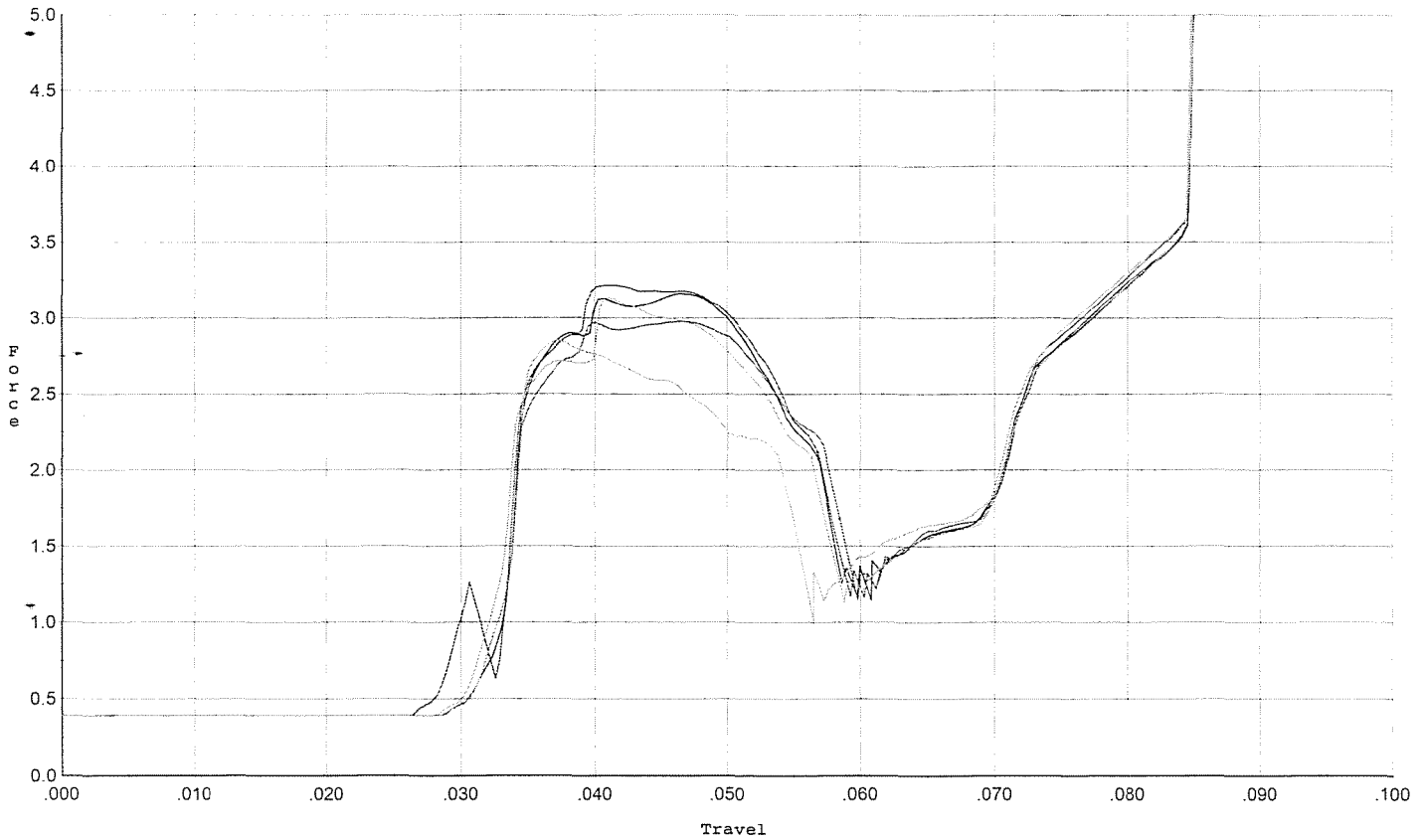
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.058	0.031	0.033	0.080		Set Trigger
2	3.302	0.058	0.032	0.033	0.078		Set Trigger
3	3.376	0.058	0.031	0.033	0.082		Set Trigger
4	3.180	0.057	0.031	0.033	0.078		Set Trigger
5	3.210	0.059	0.032	0.033	0.082		Set Trigger

A-3.27

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



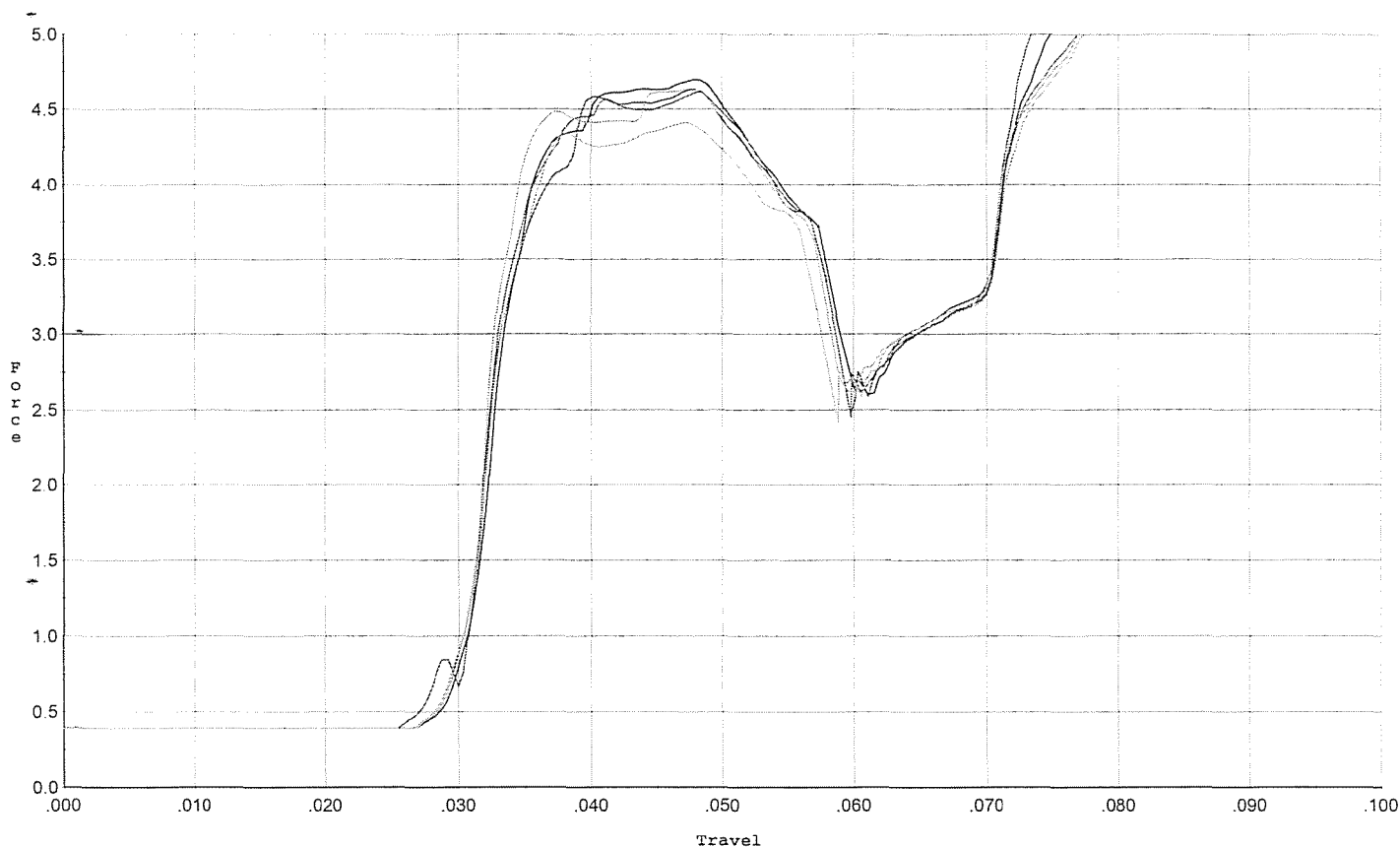
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.217	0.057	0.029	0.033	0.082		Set Trigger
2	3.161	0.057	0.031	0.033	0.079		Set Trigger
3	2.977	0.058	0.031	0.032	0.080		Set Trigger
4	2.858	0.055	0.031	0.034	0.067		Set Trigger
5	3.136	0.056	0.031	0.033	0.077		Set Trigger

A-3-07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



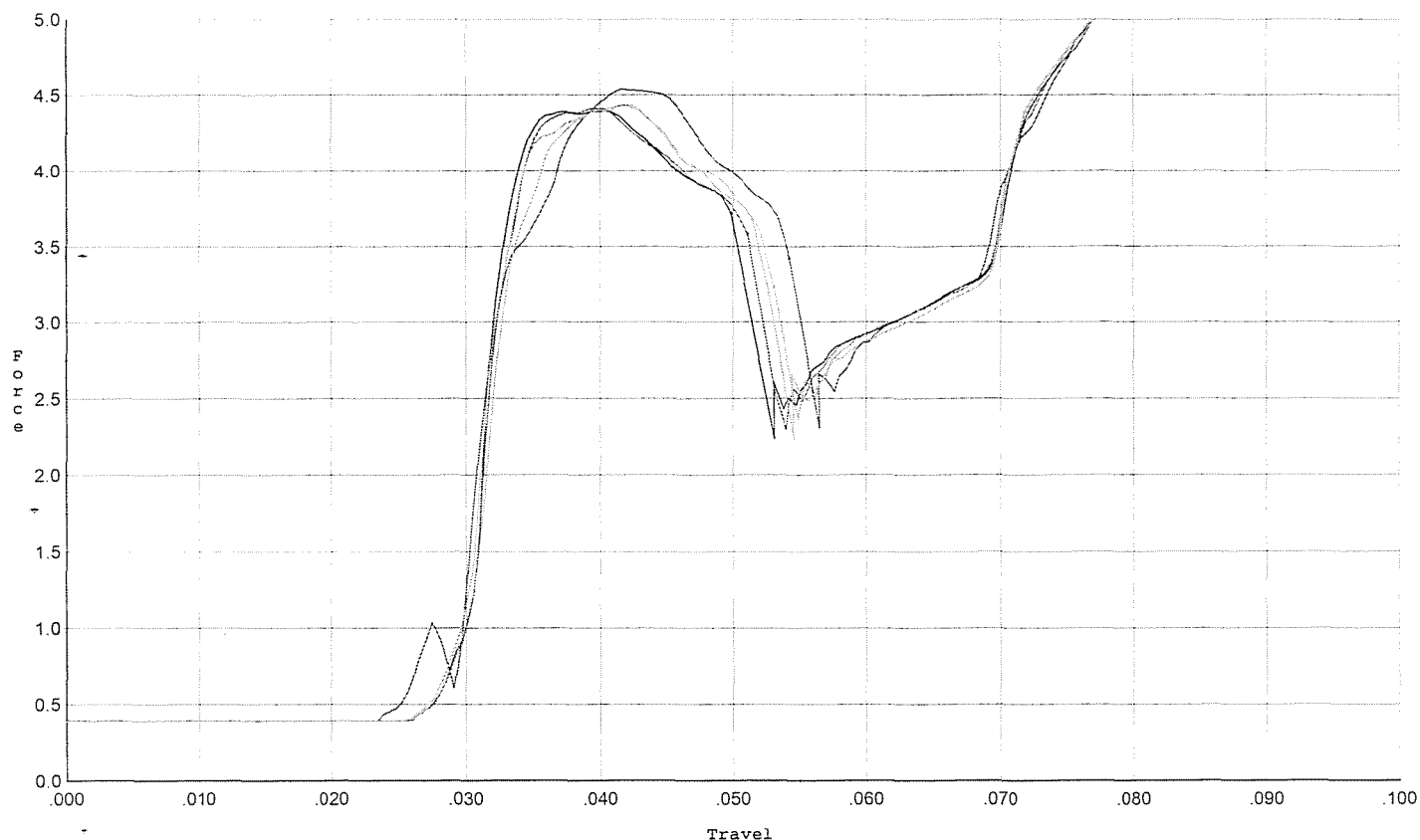
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.627	0.058	0.028	0.024	0.121		Set Trigger
2	4.694	0.057	0.029	0.029	0.121		Set Trigger
3	4.608	0.058	0.029	0.029	0.121		Set Trigger
4	4.413	0.057	0.029	0.030	0.115		Set Trigger
5	4.631	0.057	0.029	0.029	0.120		Set Trigger

A-4.5+

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



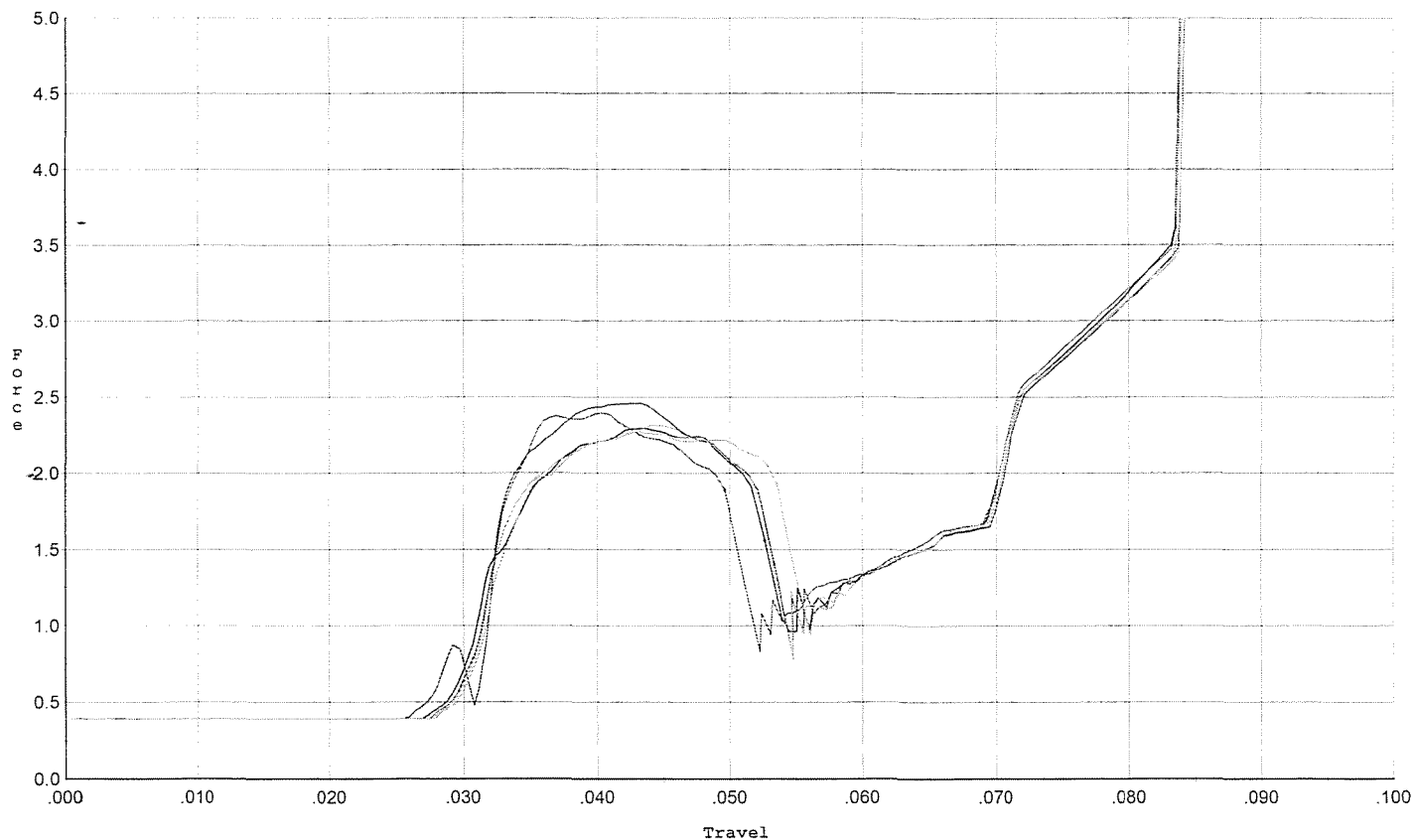
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.539	0.054	0.026	0.030	0.108		Set Trigger
2	4.393	0.050	0.028	0.032	0.091		Set Trigger
3	4.411	0.051	0.028	0.032	0.094		Set Trigger
4	4.435	0.053	0.028	0.031	0.100		Set Trigger
5	4.432	0.053	0.028	0.031	0.100		Set Trigger

A-4.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



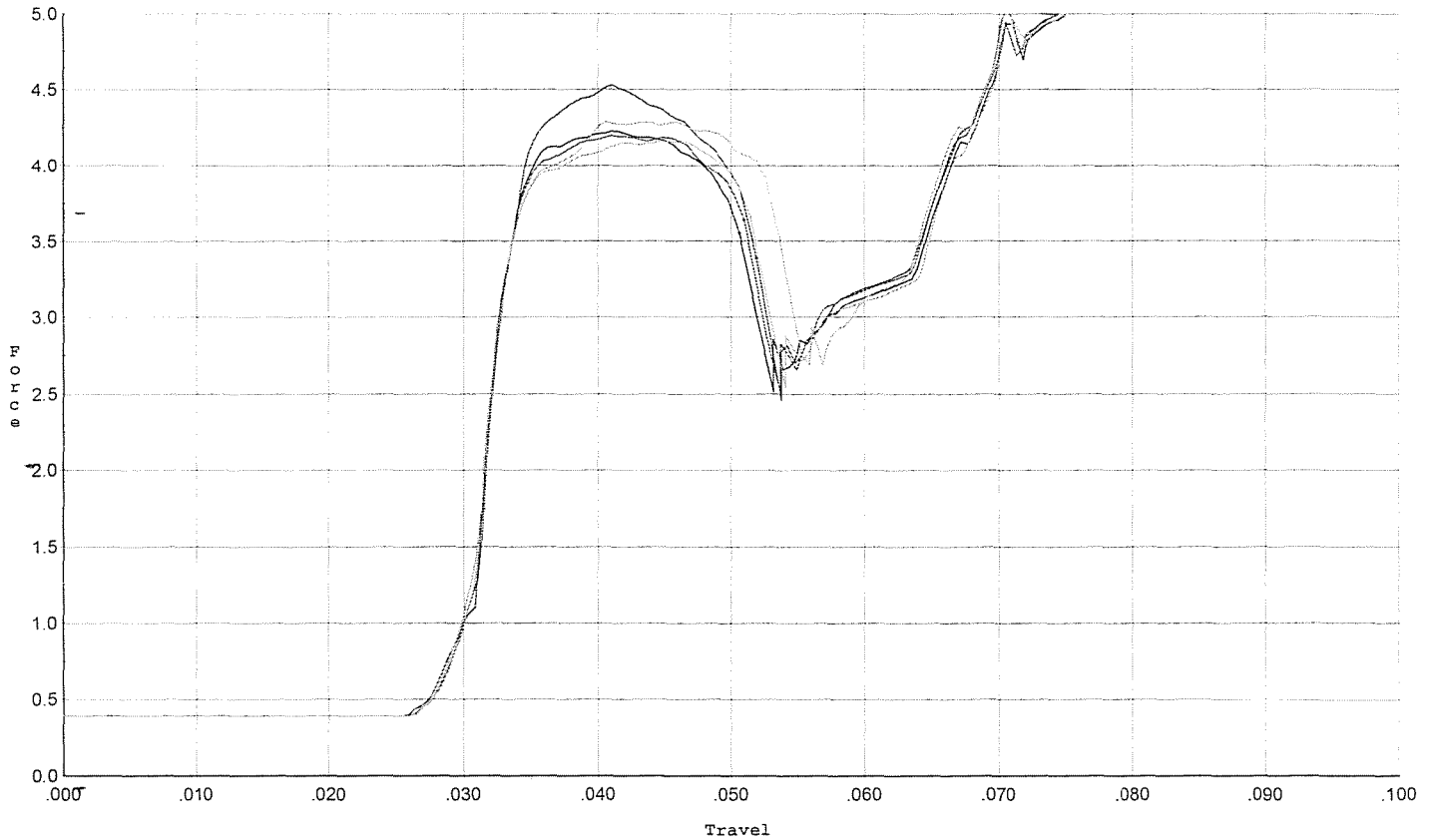
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.053	0.028	0.035	0.060		Set Trigger
2	2.296	0.053	0.029	0.036	0.057		Set Trigger
3	2.396	0.050	0.030	0.037	0.052		Set Trigger
4	2.278	0.052	0.030	0.036	0.055		Set Trigger
5	2.318	0.054	0.030	0.034	0.059		Set Trigger

A-2-34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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	4.528	0.052	0.028	0.032	0.098		Set Trigger
2	4.228	0.051	0.029	0.033	0.090		Set Trigger
3	4.197	0.051	0.029	0.032	0.092		Set Trigger
4	4.161	0.051	0.029	0.032	0.093		Set Trigger
5	4.288	0.054	0.028	0.031	0.103		Set Trigger

A 4.28