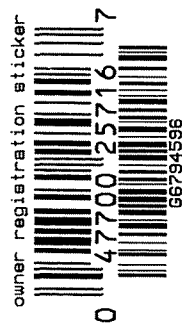
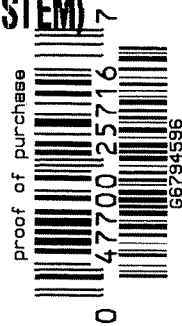


G6794596

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

- INSTRUCTION BOOK 3518

BM FORM

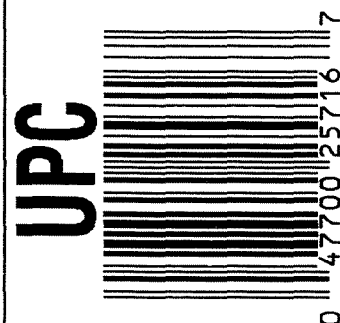


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794596



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794596

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-28-08	RSN
475	DRILL AND TAP SIGHT HOLES	2008	11-4-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	11/6/08	SP
490	MAGNAFLUX BOLT		10/27/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/6/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/5	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-18-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

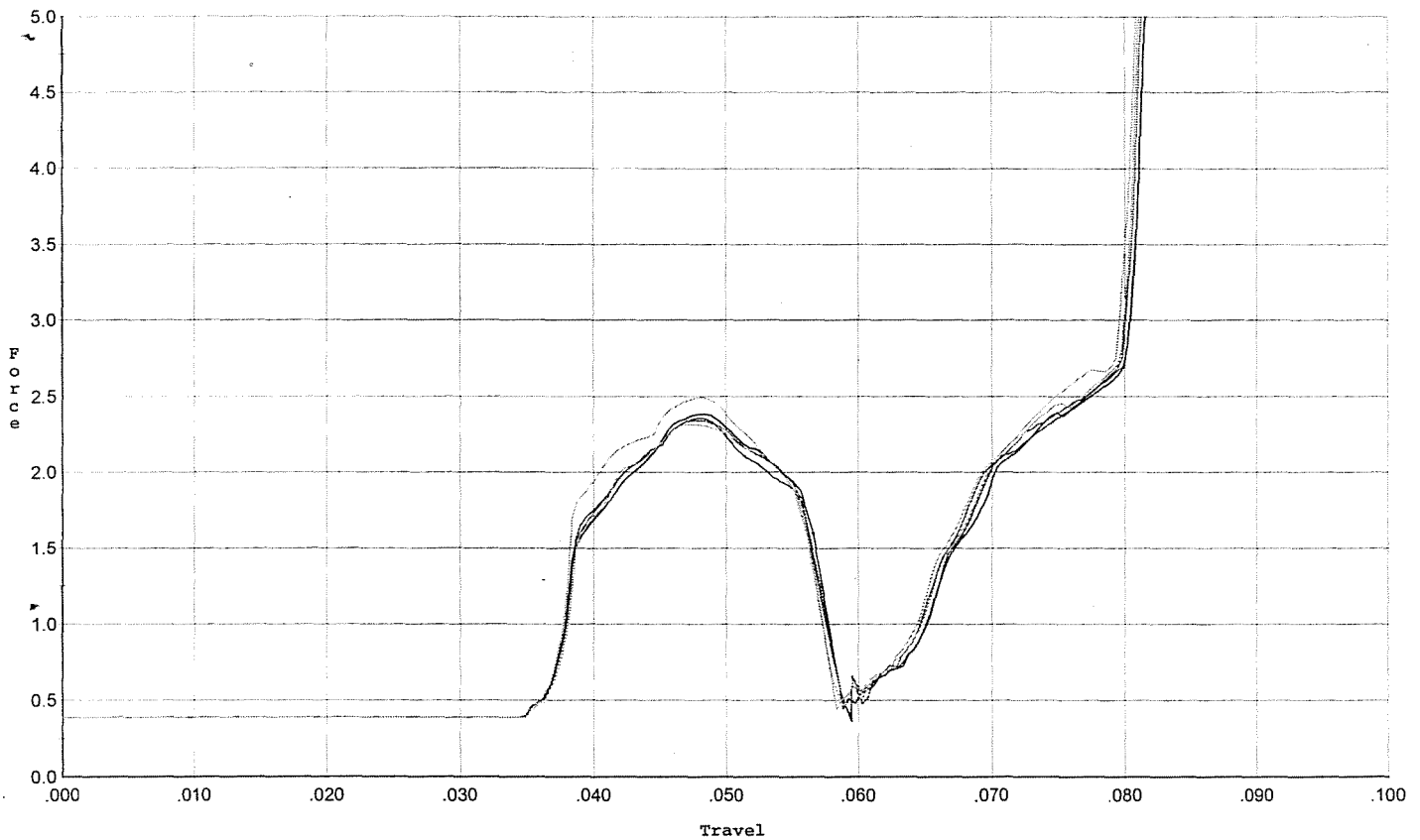
OP #	OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3.0</u>	<u>3.0</u>	<u>4.0</u>	12-2-08	L.D.		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	12-2-08	L.D.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	12-2-08	L.D.		
	J) ASSEMBLE STOCK					11-18-08	L.D.		
	K) ASSEMBLE SWIVEL STUDS					12-2-08	L.D.		
	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			11-19-08	L.D.		
			<u>PASS</u> FAIL						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					11-19-08	TL		
670	FINAL INSPECTION A) HEADSPACE					12-2-08	L.D.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u>	<u>2.53</u>	<u>2.55</u>	<u>2.59</u>	<u>2.60</u>	11-26-08	TL
	C) FUNCTION					12-2-08	L.D.		
690	PACK					12/11/08	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



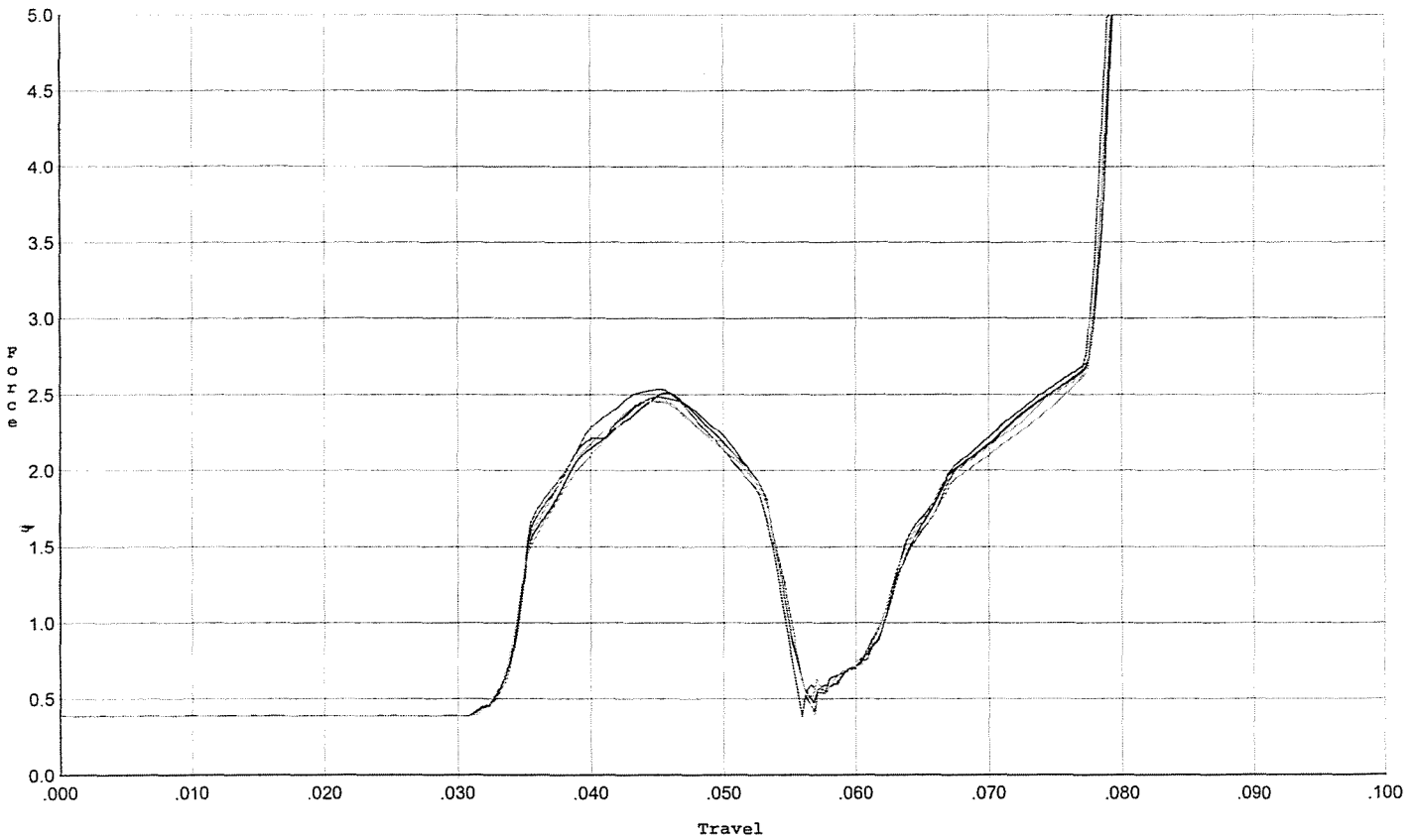
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.358	0.056	0.035	0.032	0.052		Set Trigger
2	2.385	0.057	0.035	0.032	0.053		Set Trigger
3	2.344	0.057	0.035	0.031	0.054		Set Trigger
4	2.317	0.056	0.037	0.031	0.052		Set Trigger
5	2.493	0.056	0.035	0.032	0.055		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



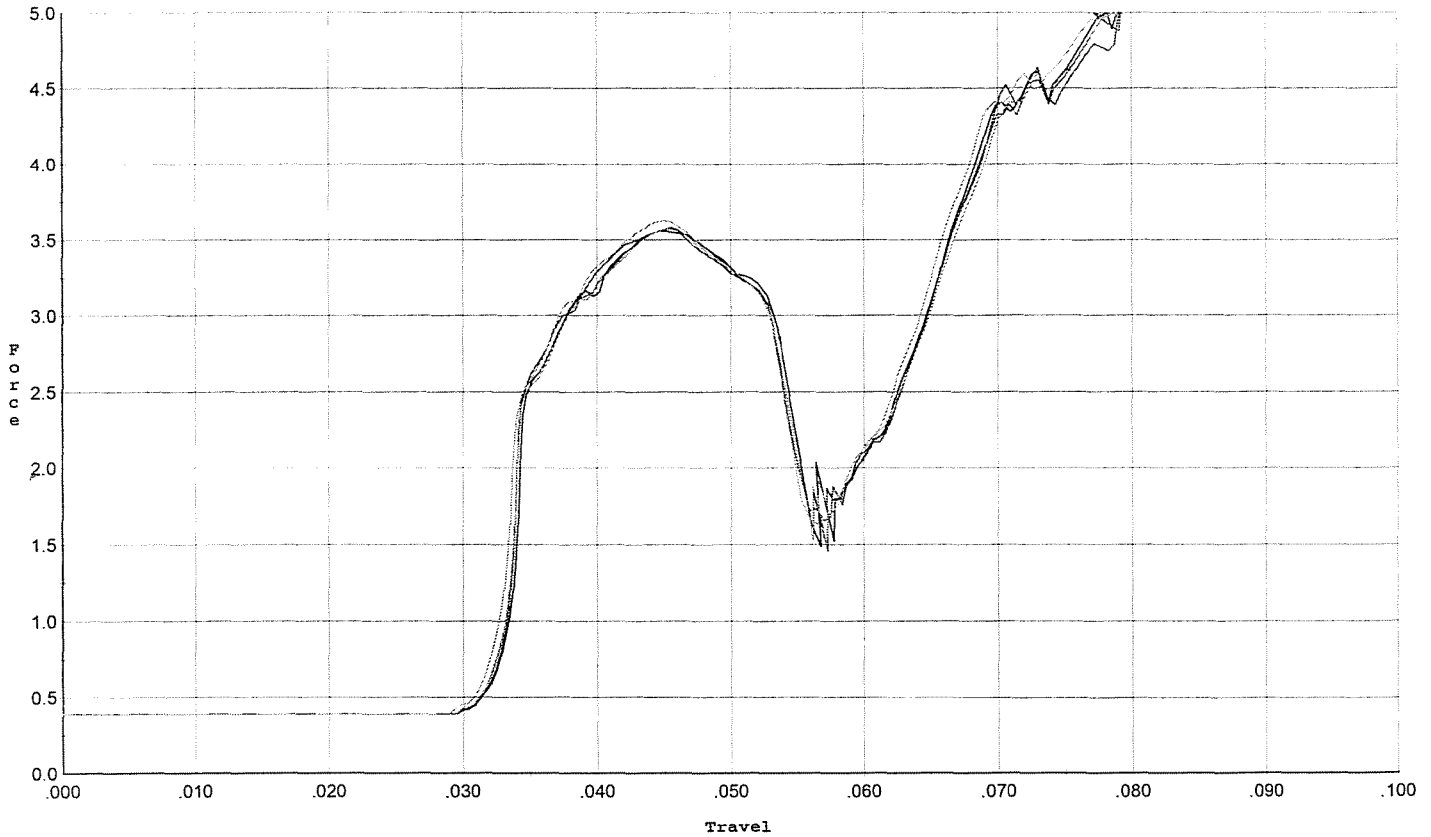
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.483	0.055	0.033	0.032	0.056		Set Trigger
2	2.513	0.053	0.033	0.033	0.054		Set Trigger
3	2.536	0.054	0.033	0.032	0.055		Set Trigger
4	2.461	0.055	0.033	0.032	0.056		Set Trigger
5	2.457	0.053	0.033	0.032	0.054		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



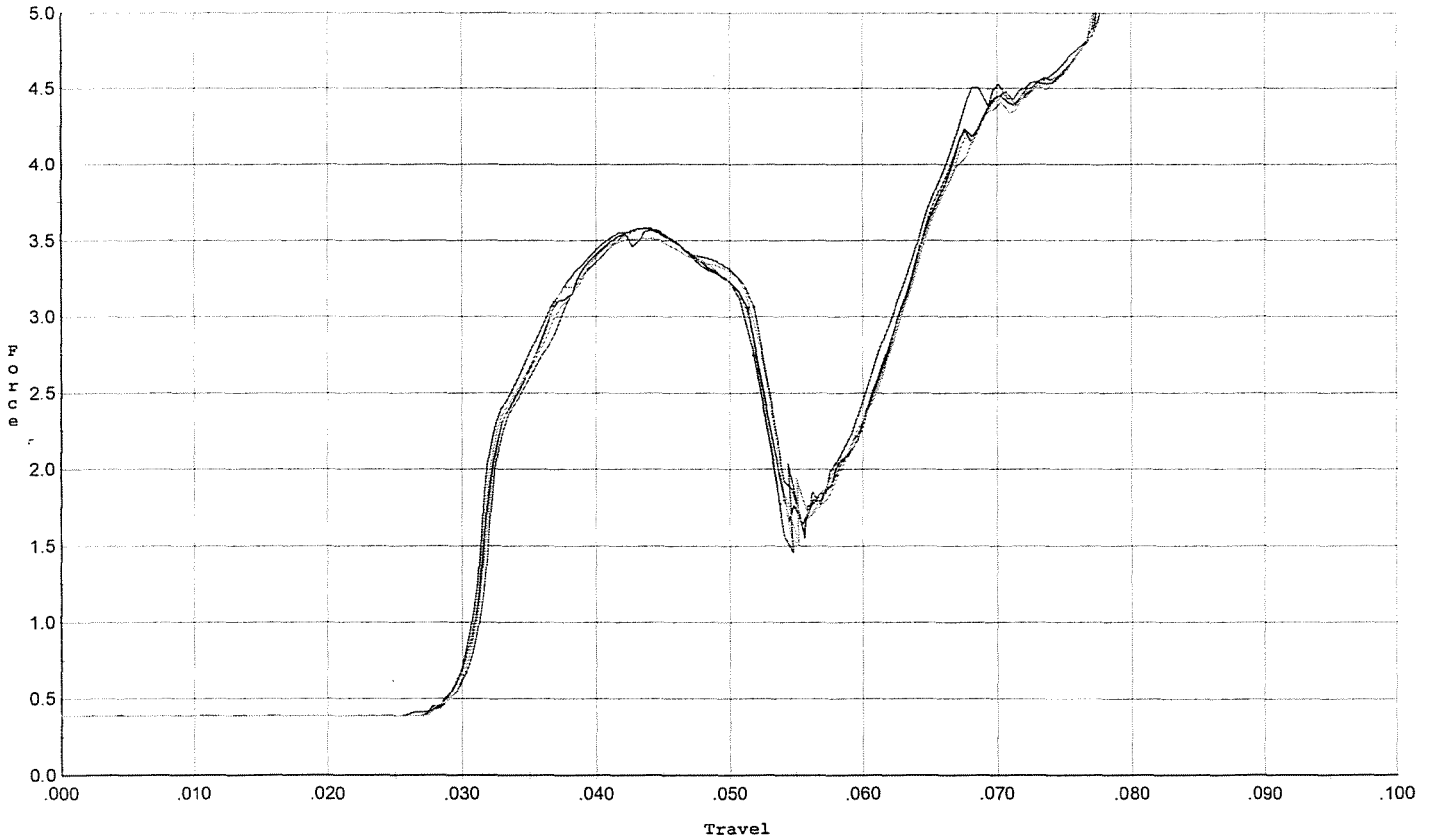
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.576	0.054	0.032	0.030	0.079		Set Trigger
2	3.559	0.054	0.032	0.030	0.078		Set Trigger
3	3.574	0.053	0.032	0.031	0.076		Set Trigger
4	3.584	0.054	0.032	0.030	0.079		Set Trigger
5	3.627	0.053	0.031	0.030	0.078		Set Trigger

A-3-58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



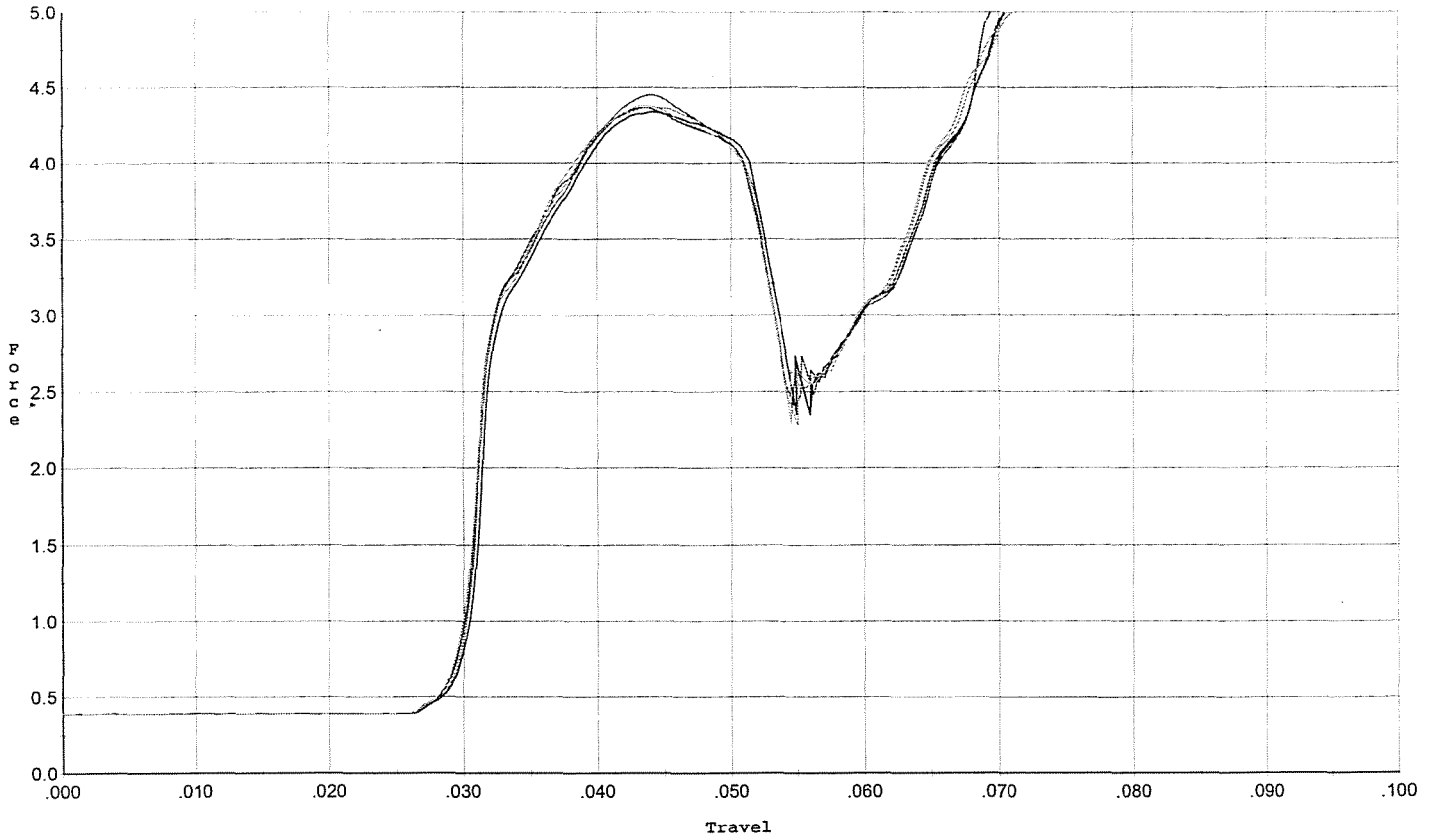
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.567	0.052	0.030	0.030	0.078		Set Trigger
2	3.580	0.051	0.030	0.030	0.077		Set Trigger
3	3.578	0.052	0.030	0.030	0.077		Set Trigger
4	3.513	0.052	0.030	0.030	0.078		Set Trigger
5	3.584	0.051	0.030	0.030	0.077		Set Trigger

A-3-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



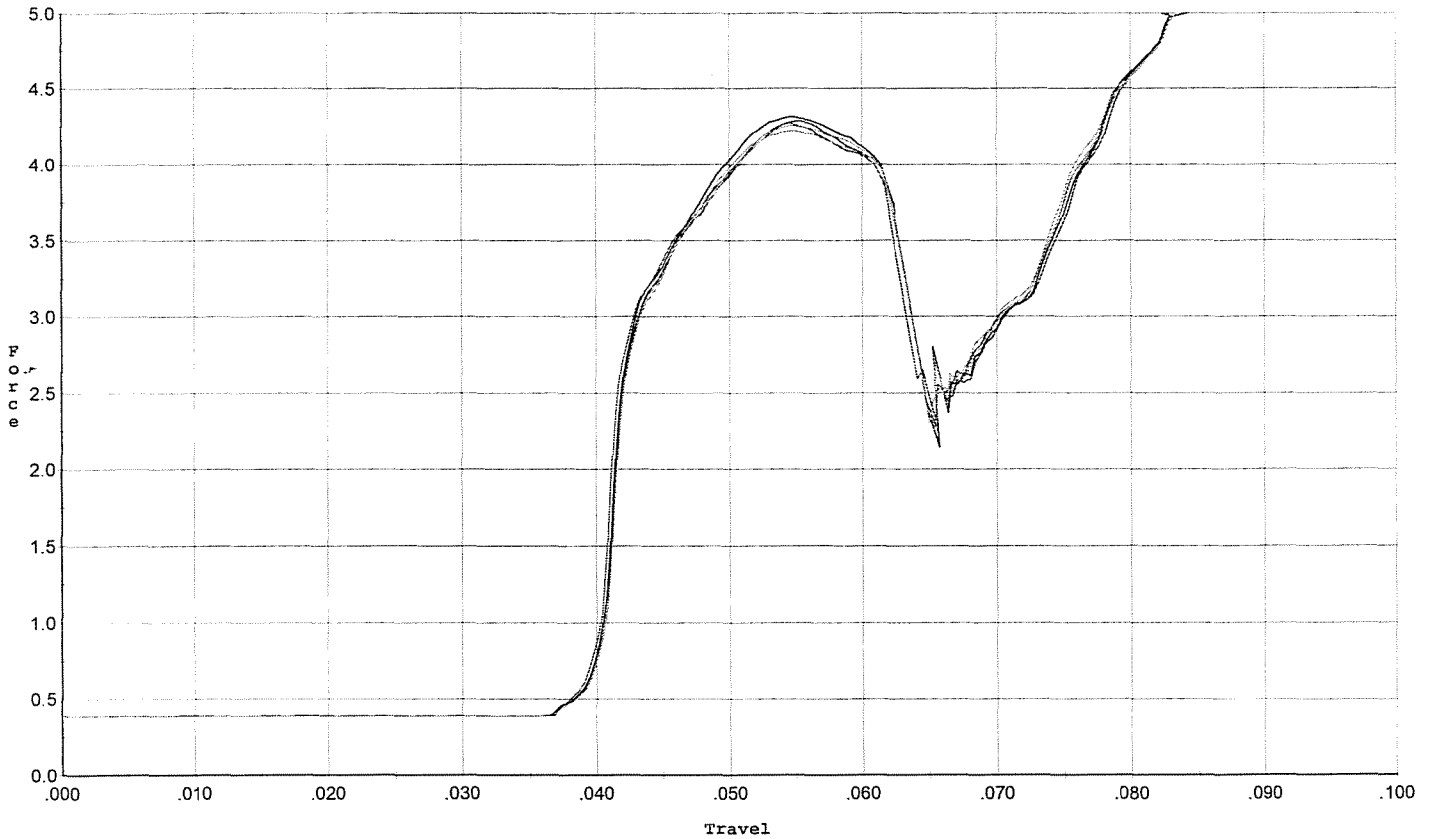
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.369	0.052	0.029	0.029	0.096		Set Trigger
2	4.337	0.053	0.029	0.029	0.098		Set Trigger
3	4.450	0.052	0.029	0.029	0.096		Set Trigger
4	4.383	0.052	0.029	0.029	0.097		Set Trigger
5	4.369	0.052	0.029	0.029	0.096		Set Trigger

A - 4.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



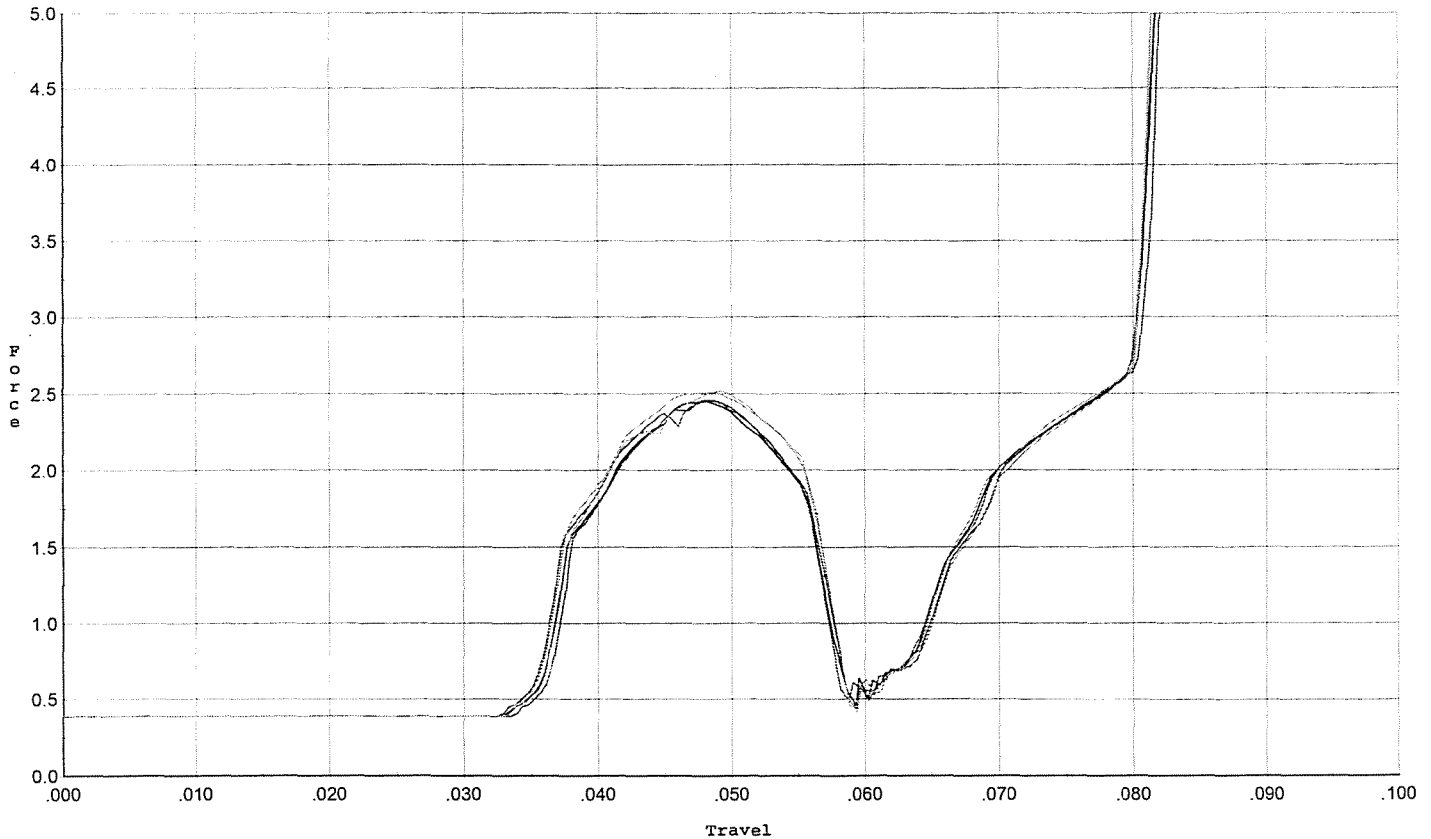
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.281	0.062	0.040	0.029	0.100		Set Trigger
2	4.310	0.062	0.040	0.029	0.101		Set Trigger
3	4.270	0.062	0.039	0.029	0.098		Set Trigger
4	4.253	0.062	0.040	0.029	0.100		Set Trigger
5	4.220	0.063	0.040	0.029	0.100		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



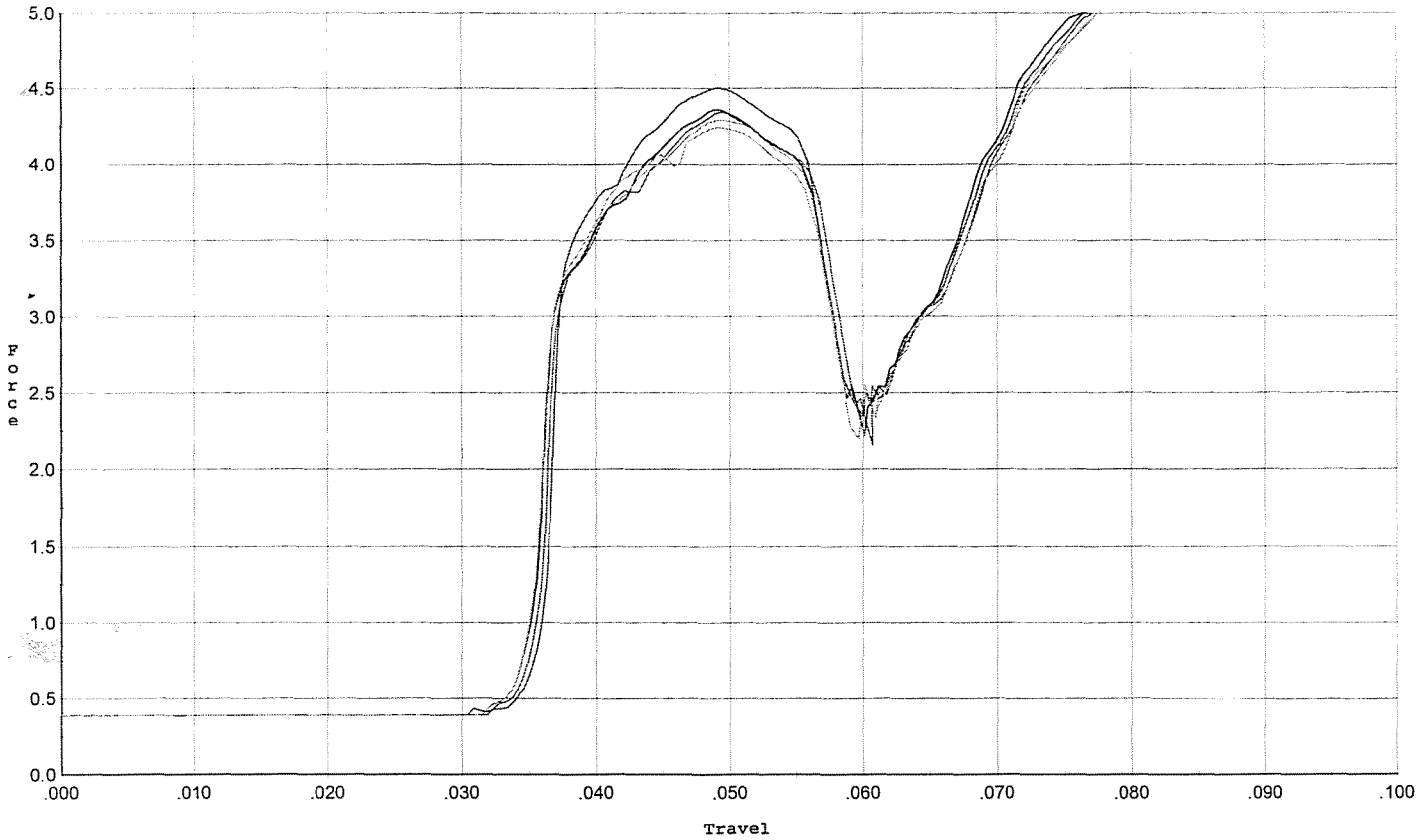
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.057	0.036	0.032	0.056		Set Trigger
2	2.450	0.056	0.036	0.032	0.055		Set Trigger
3	2.452	0.056	0.035	0.032	0.056		Set Trigger
4	2.511	0.057	0.036	0.032	0.058		Set Trigger
5	2.518	0.056	0.036	0.032	0.057		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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	4.504	0.056	0.035	0.028	0.097		Set Trigger
2	4.361	0.056	0.034	0.028	0.097		Set Trigger
3	4.346	0.057	0.034	0.028	0.097		Set Trigger
4	4.291	0.056	0.034	0.028	0.096		Set Trigger
5	4.243	0.057	0.034	0.028	0.096		Set Trigger

A-4.34