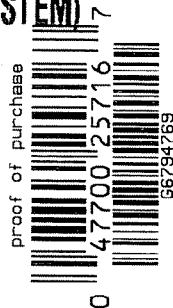


56794769

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

- INSTRUCTION BOOK 3518

BM FORM



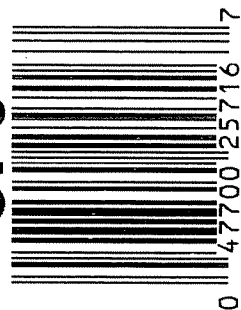
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794769

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794769

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-8-08	RSW
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (K)	10/11/08	(K)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-28-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

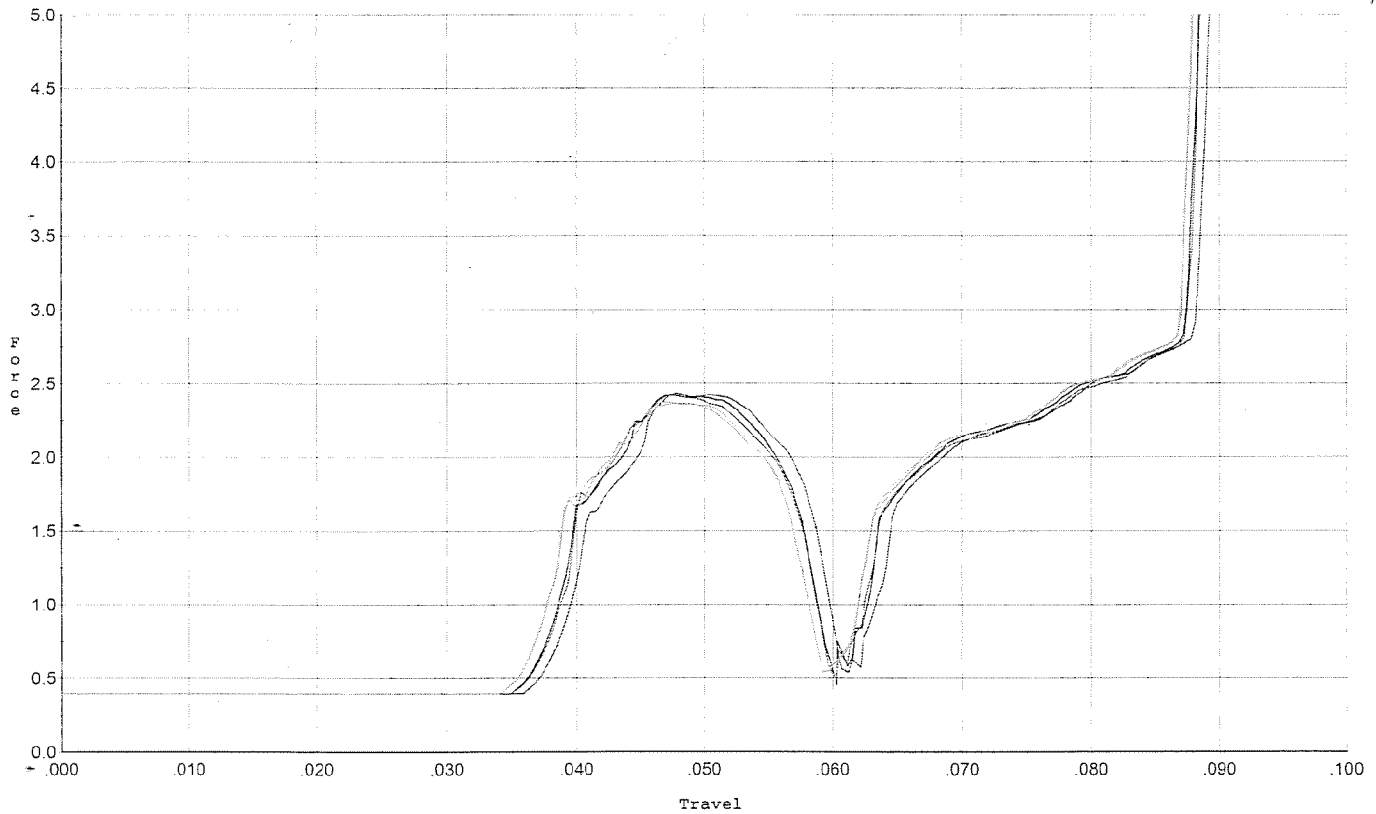
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>45</u> <u>50</u>	10-31-08	LJN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	10-31-08	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-31-08	LJN
	J) ASSEMBLE STOCK		10-28-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-31-08	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	10-29-08	LJN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NO		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-29-08	TL
670	FINAL INSPECTION A) HEADSPACE		10-31-08	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.97</u> <u>3.05</u> <u>3.07</u> <u>3.05</u> <u>3.08</u>	10-30-08	LJN
	C) FUNCTION		10-31-08	LJN
690	PACK		10/31/08	FVJ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



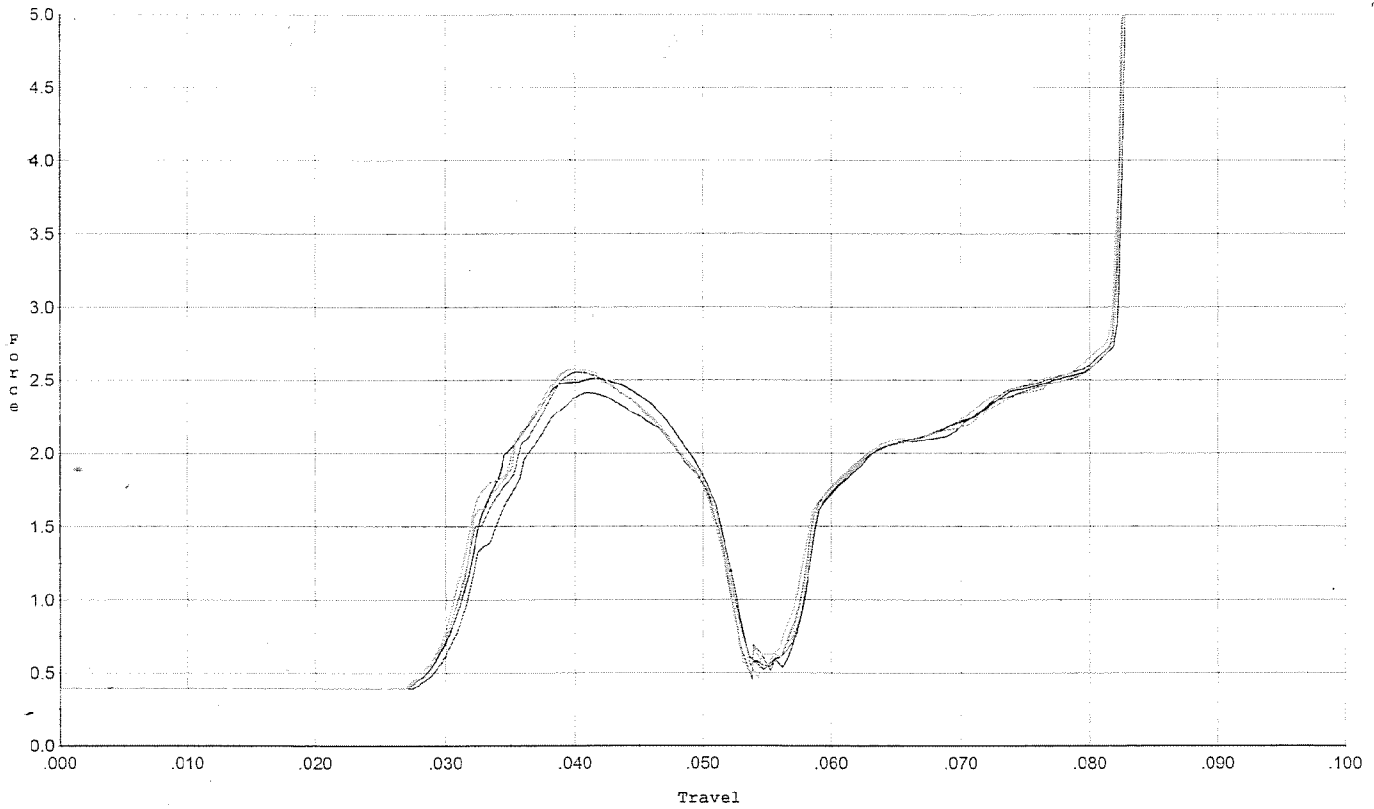
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.433	0.059	0.038	0.037	0.056		Set Trigger
2	2.422	0.058	0.037	0.037	0.056		Set Trigger
3	2.425	0.058	0.037	0.037	0.055		Set Trigger
4	2.362	0.058	0.036	0.037	0.055		Set Trigger
5	2.373	0.058	0.036	0.037	0.056		Set Trigger

A-2.40

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



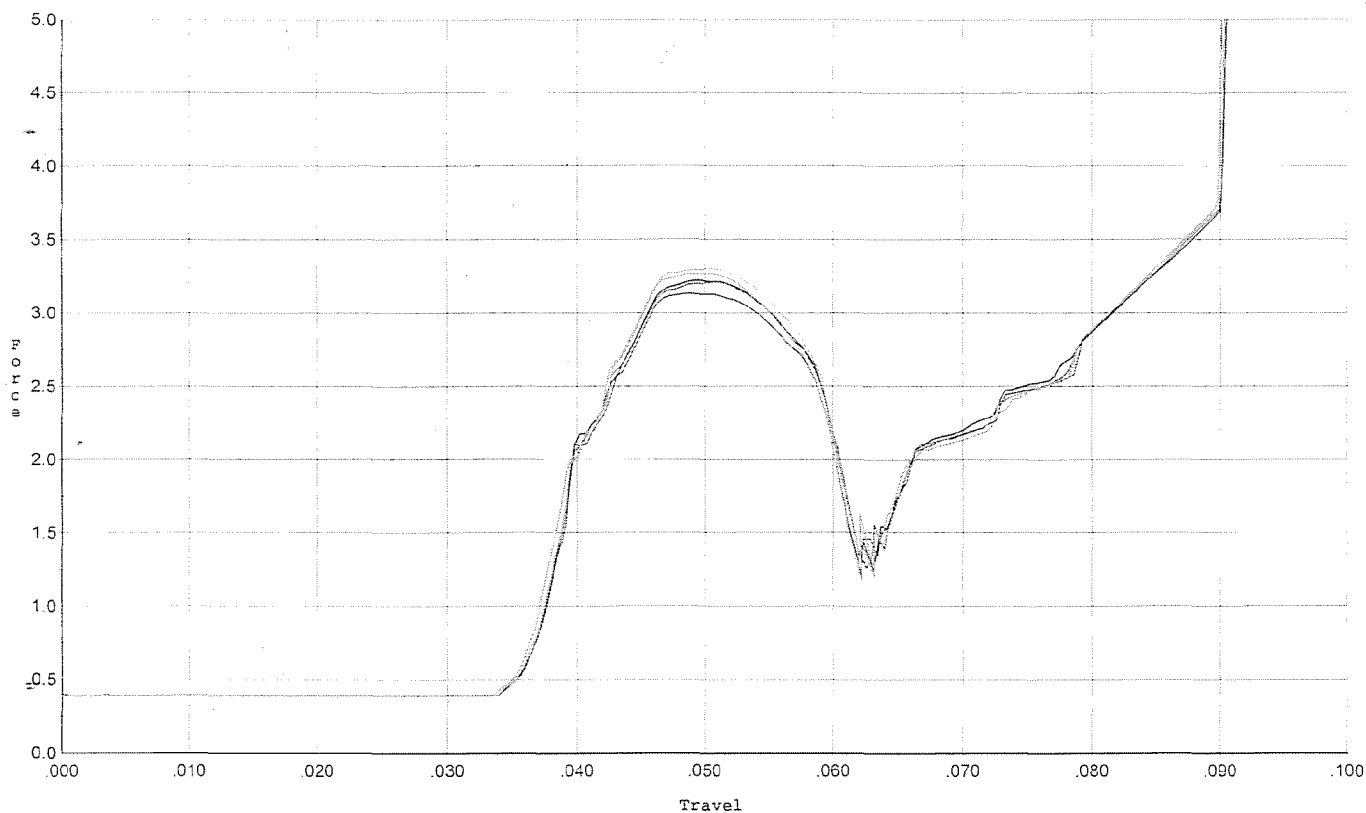
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.051	0.030	0.036	0.052		Set Trigger
2	2.512	0.052	0.030	0.035	0.057		Set Trigger
3	2.553	0.051	0.030	0.036	0.055		Set Trigger
4	2.575	0.051	0.030	0.036	0.055		Set Trigger
5	2.572	0.051	0.029	0.035	0.056		Set Trigger

A-2-S2

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



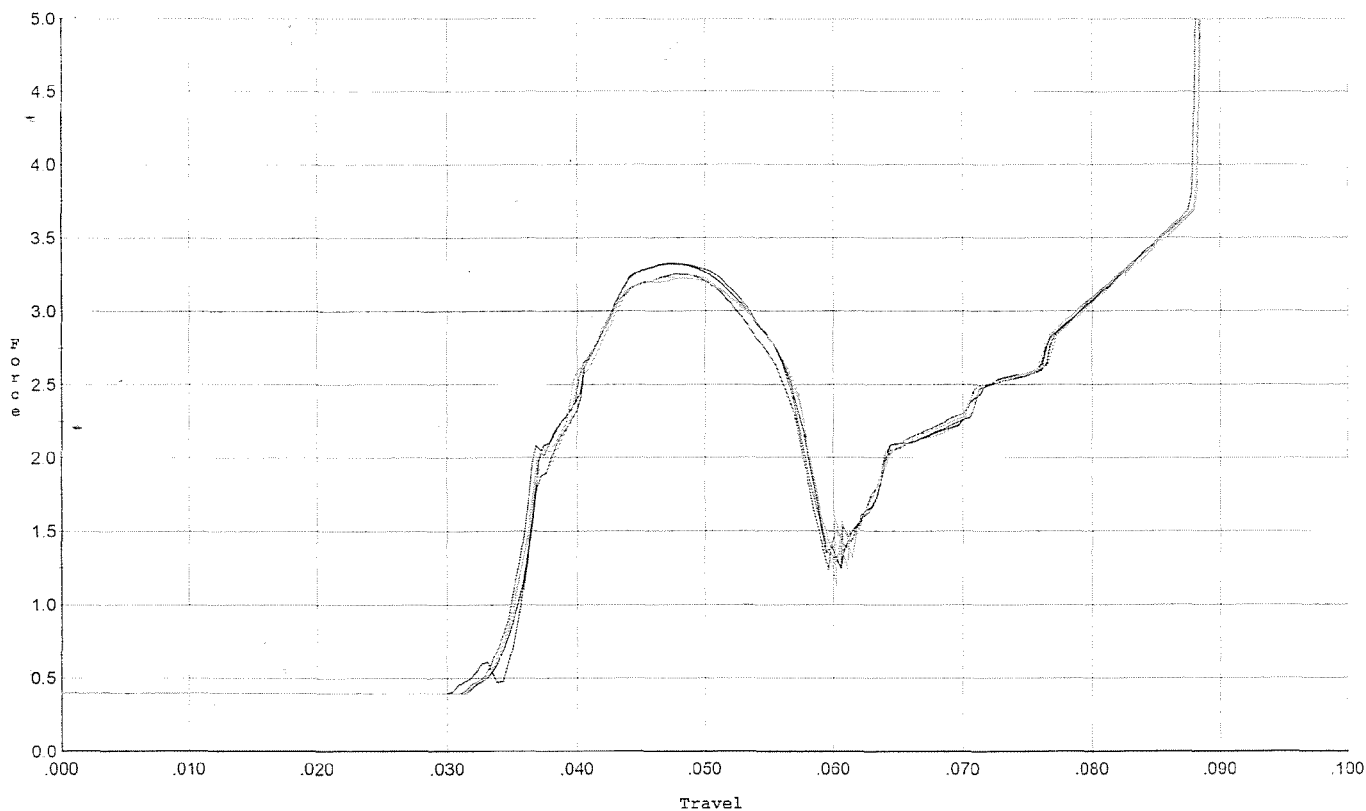
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.060	0.036	0.036	0.074		Set Trigger
2	3.218	0.060	0.036	0.036	0.077		Set Trigger
3	3.205	0.059	0.036	0.036	0.075		Set Trigger
4	3.302	0.060	0.036	0.036	0.079		Set Trigger
5	3.268	0.060	0.036	0.036	0.077		Set Trigger

A. 3.22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



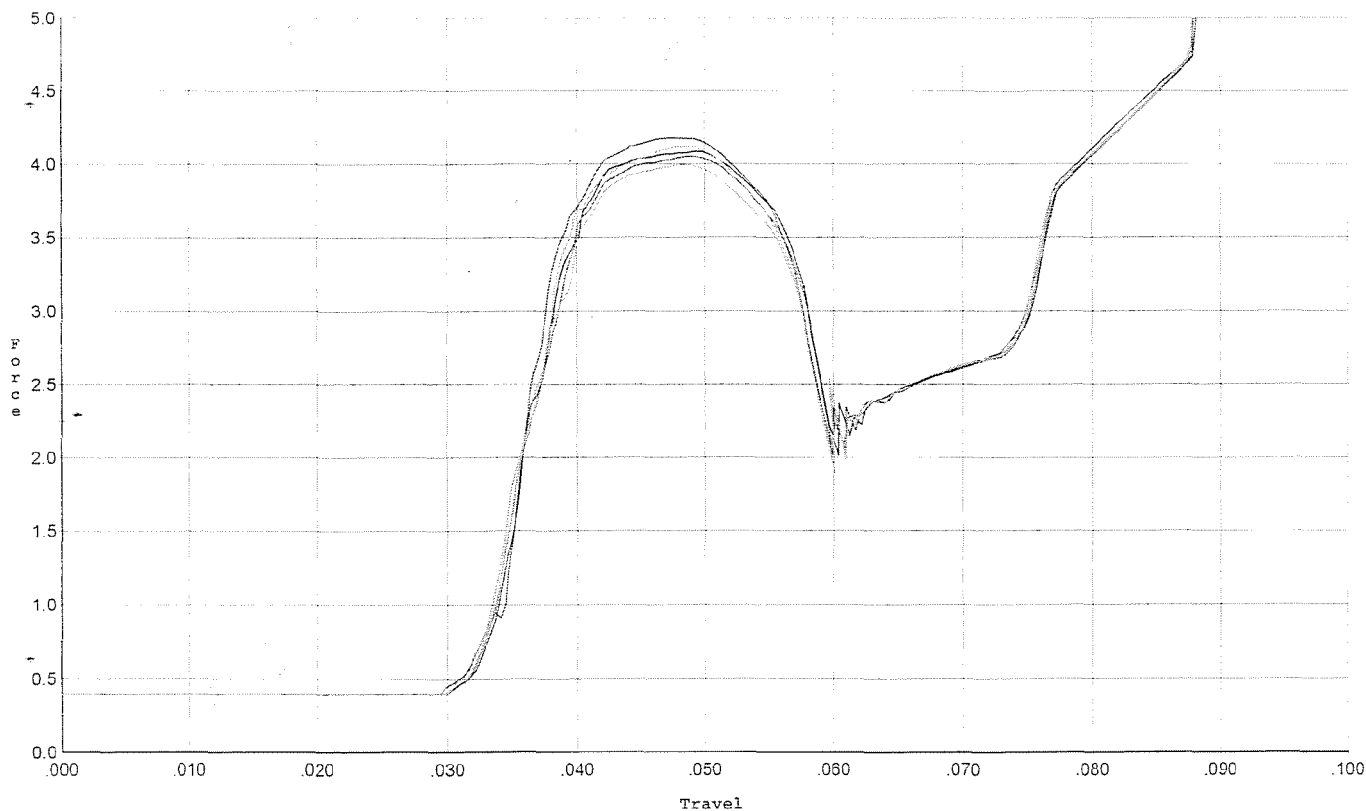
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.320	0.057	0.033	0.036	0.075		Set Trigger
2	3.326	0.058	0.034	0.035	0.077		Set Trigger
3	3.250	0.057	0.034	0.035	0.075		Set Trigger
4	3.223	0.057	0.034	0.035	0.076		Set Trigger
5	3.243	0.057	0.034	0.035	0.076		Set Trigger

A-3.27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



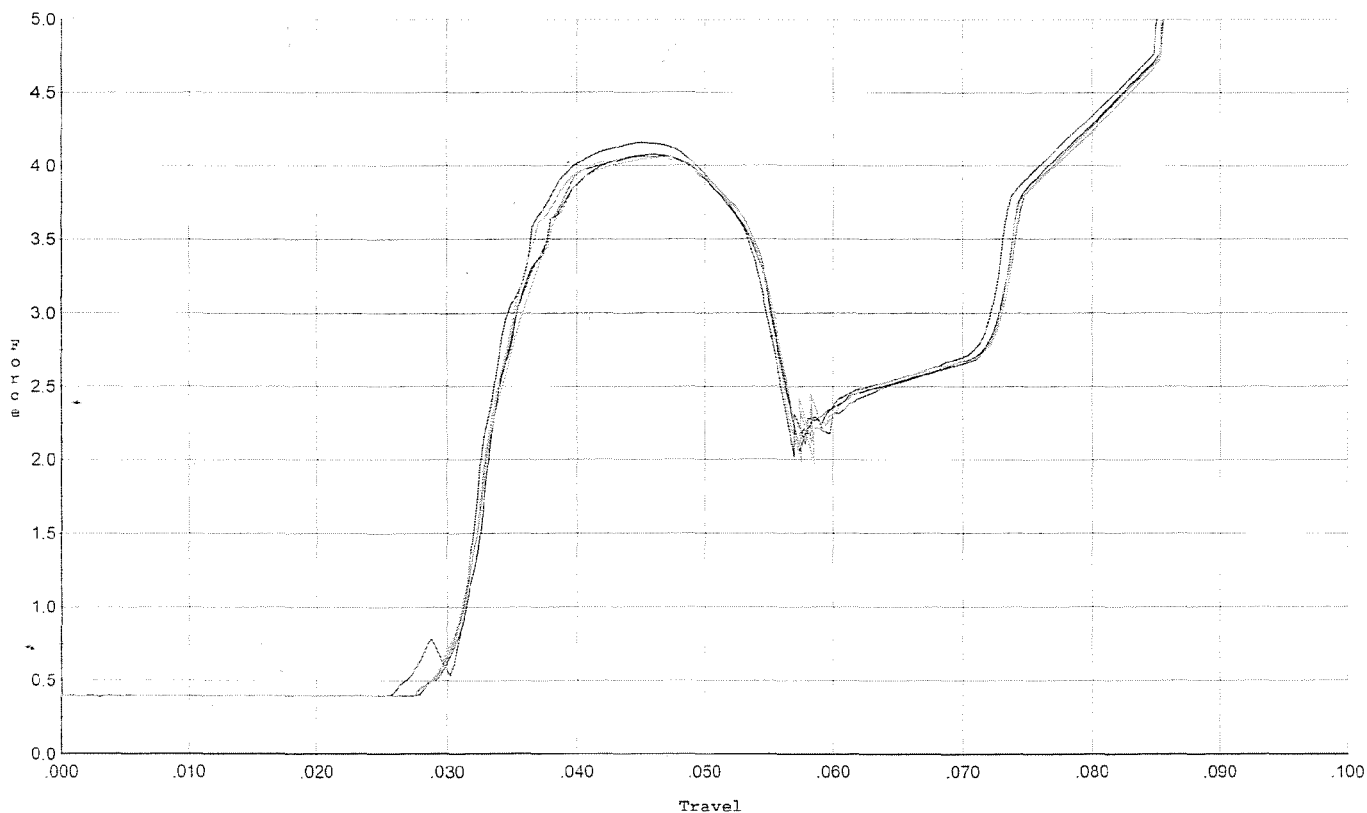
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.177	0.057	0.032	0.034	0.098		Set Trigger
2	4.085	0.058	0.033	0.034	0.098		Set Trigger
3	4.051	0.058	0.032	0.034	0.097		Set Trigger
4	3.994	0.057	0.032	0.034	0.095		Set Trigger
5	4.118	0.057	0.032	0.034	0.097		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



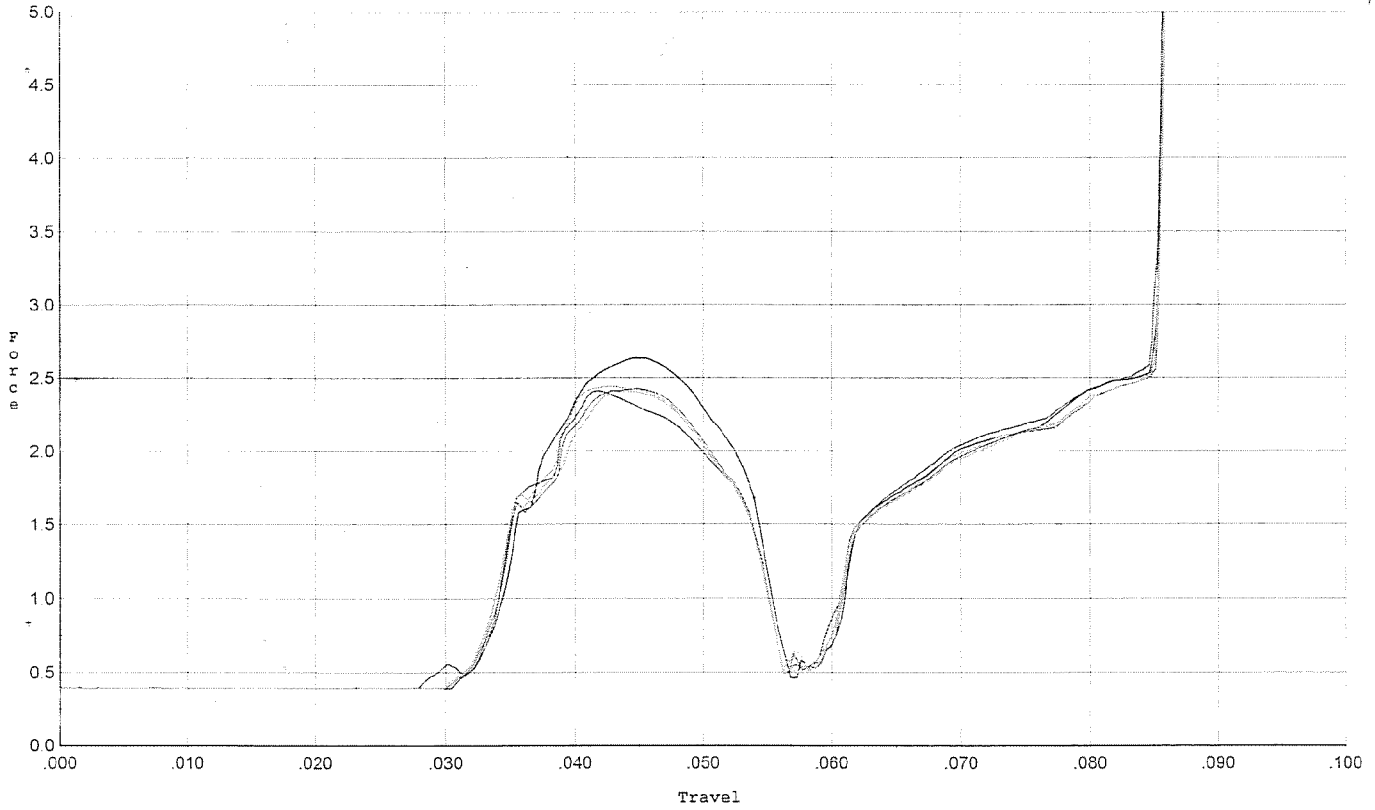
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.158	0.055	0.028	0.032	0.099		Set Trigger
2	4.075	0.055	0.030	0.033	0.095		Set Trigger
3	4.062	0.054	0.030	0.033	0.095		Set Trigger
4	4.051	0.055	0.030	0.033	0.097		Set Trigger
5	4.080	0.055	0.030	0.033	0.096		Set Trigger

A 4.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



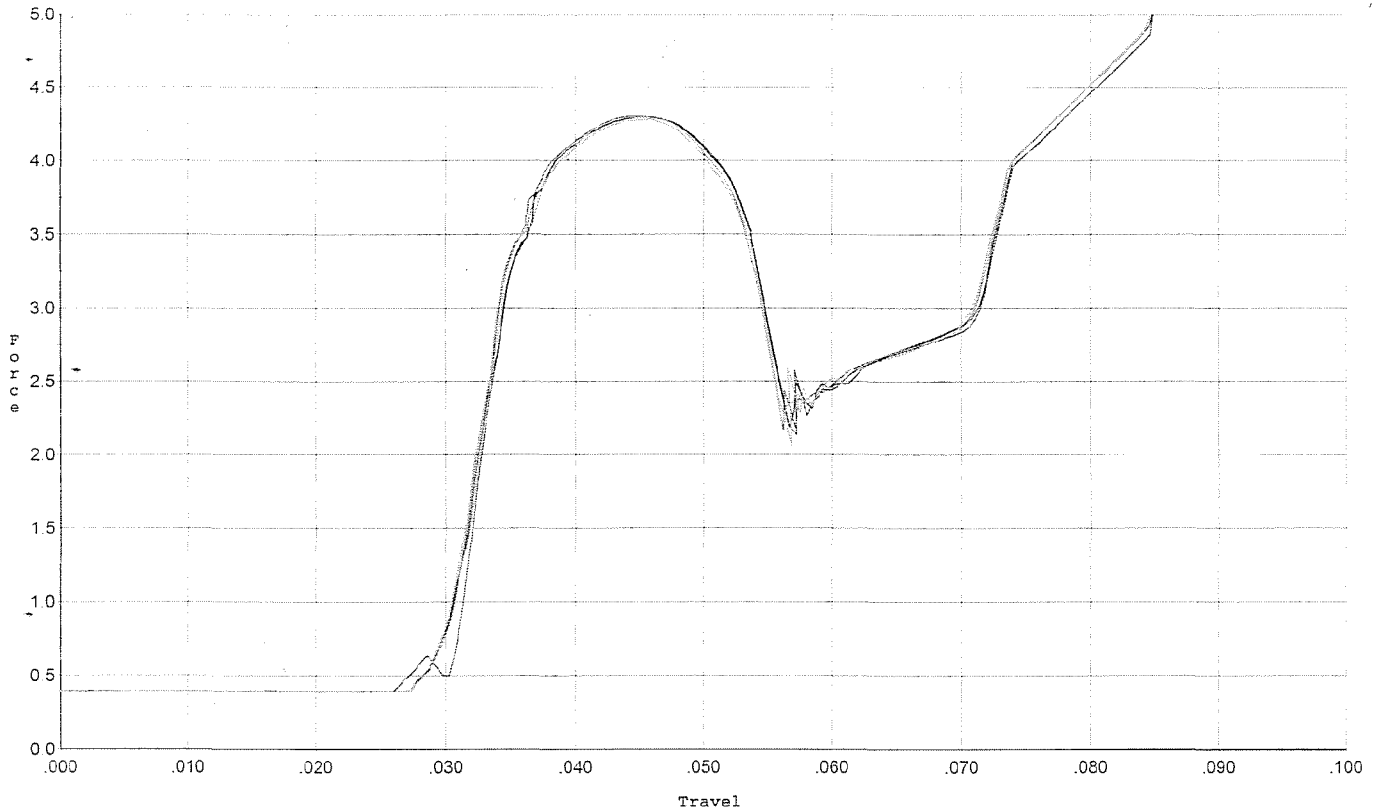
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.413	0.055	0.033	0.036	0.055		Set Trigger
2	2.638	0.054	0.033	0.036	0.058		Set Trigger
3	2.426	0.055	0.033	0.037	0.055		Set Trigger
4	2.407	0.055	0.032	0.036	0.055		Set Trigger
5	2.444	0.055	0.032	0.036	0.056		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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	4.296	0.054	0.031	0.033	0.098		Set Trigger
2	4.292	0.054	0.029	0.032	0.098		Set Trigger
3	4.303	0.054	0.029	0.032	0.099		Set Trigger
4	4.293	0.054	0.028	0.032	0.099		Set Trigger
5	4.278	0.054	0.028	0.032	0.098		Set Trigger

A 4.29