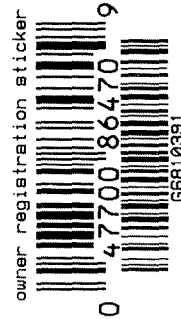
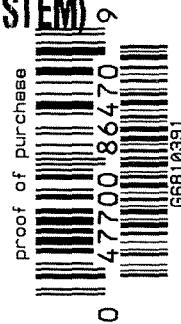


G6810391

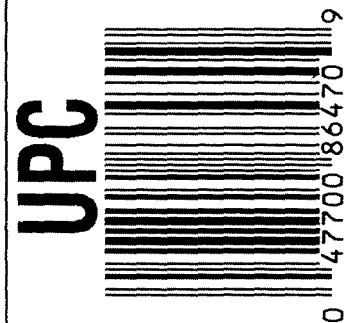
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6810391



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6810391

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-10-09	SP
430	ASSEMBLE TO STOCK		2-10-09	SP
440	PROOF		2-10-09	SP
460	CHECK HEADSPACE		2-10-09	SP
470	DIS-ASSEMBLE ACTION		2-10-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	2-11-09	RT
475	DRILL AND TAP SIGHT HOLES		2-11-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/13/09	
490	MAGNAFLUX BOLT		2/13/09	ml
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DC
542	APPLY COATINGS (BARREL ACTION)		2/20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

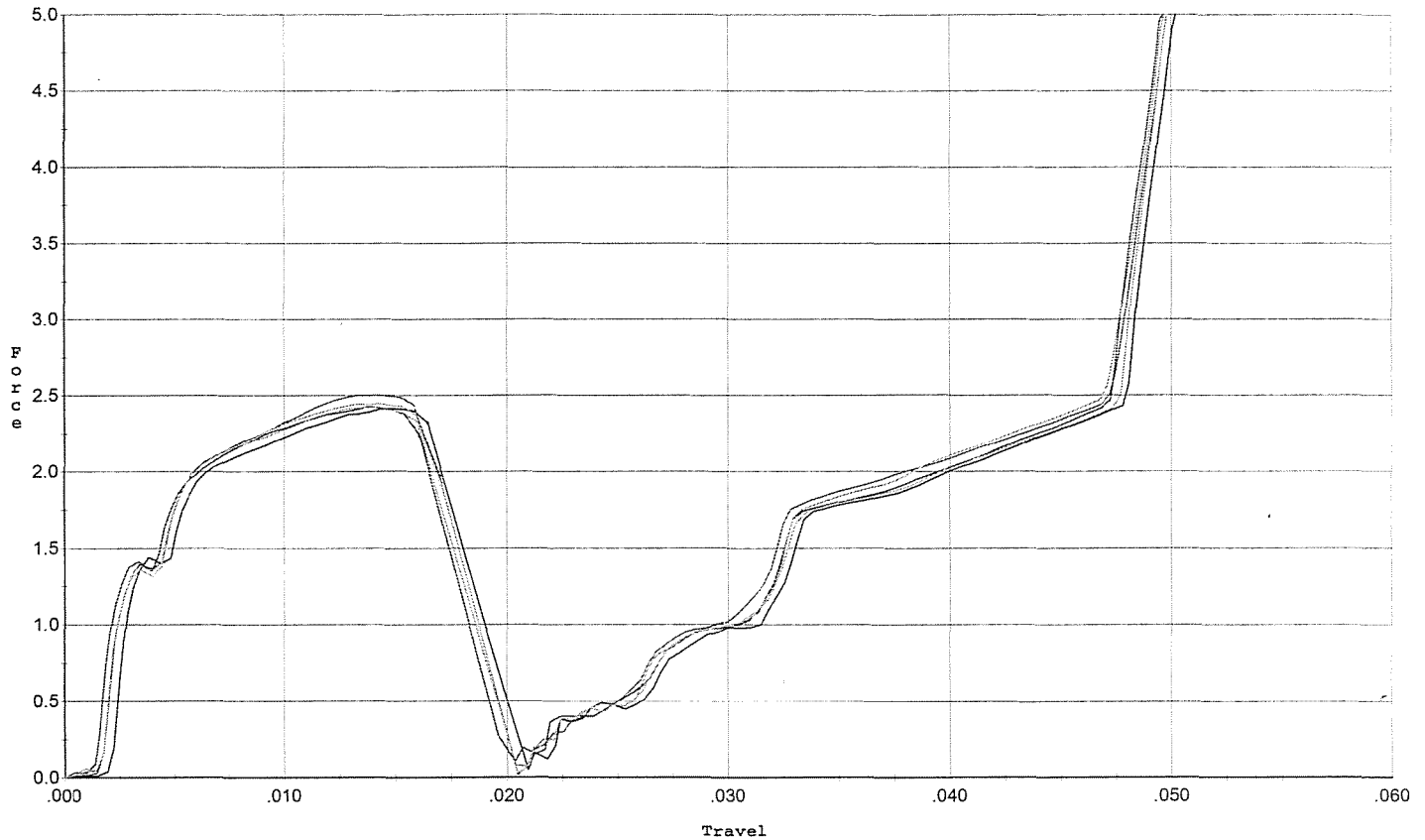
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-25-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	2-25-09	J. N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	2-25-09	LJ
	J) ASSEMBLE STOCK		2-20-09	RP
	K) ASSEMBLE SWIVEL STUDS		2-25-09	LJ
	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	PASS FAIL PASS FAIL	2-23-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-23-09	RP
670	FINAL INSPECTION A) HEADSPACE		2-25-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u> <u>2.51</u> <u>2.29</u> <u>2.38</u> <u>2.36</u>	2-24-09	WW
	C) FUNCTION		2-25-09	R. N.
690	PACK		2-27-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



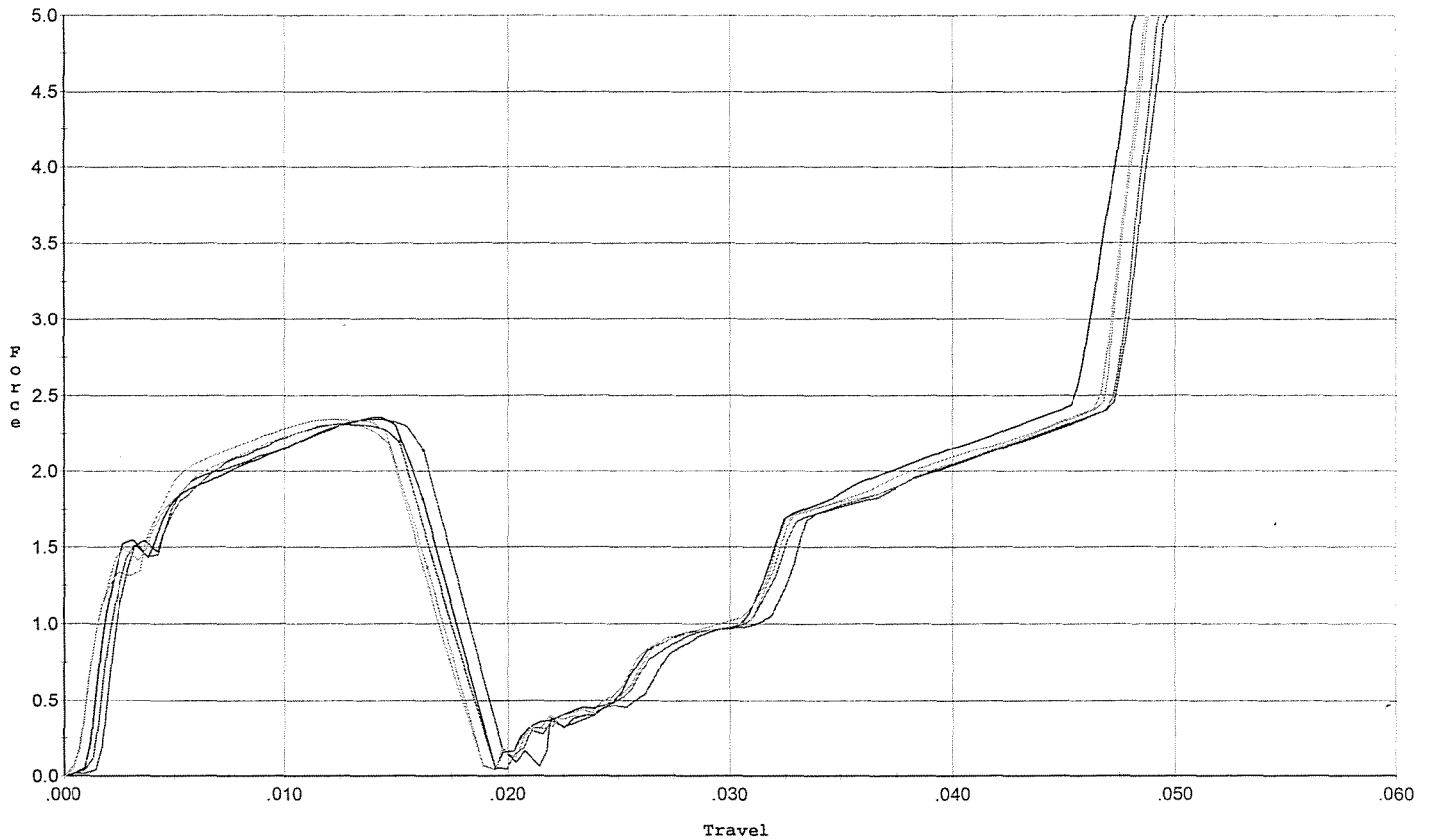
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.426	0.016	0.00	0.037	0.028		Set Trigger
2	2.415	0.016	0.002	0.037	0.028		Set Trigger
3	2.501	0.017	0.00	0.037	0.030		Set Trigger
4	2.445	0.017	0.00	0.037	0.030		Set Trigger
5	2.420	0.018	0.00	0.037	0.031		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



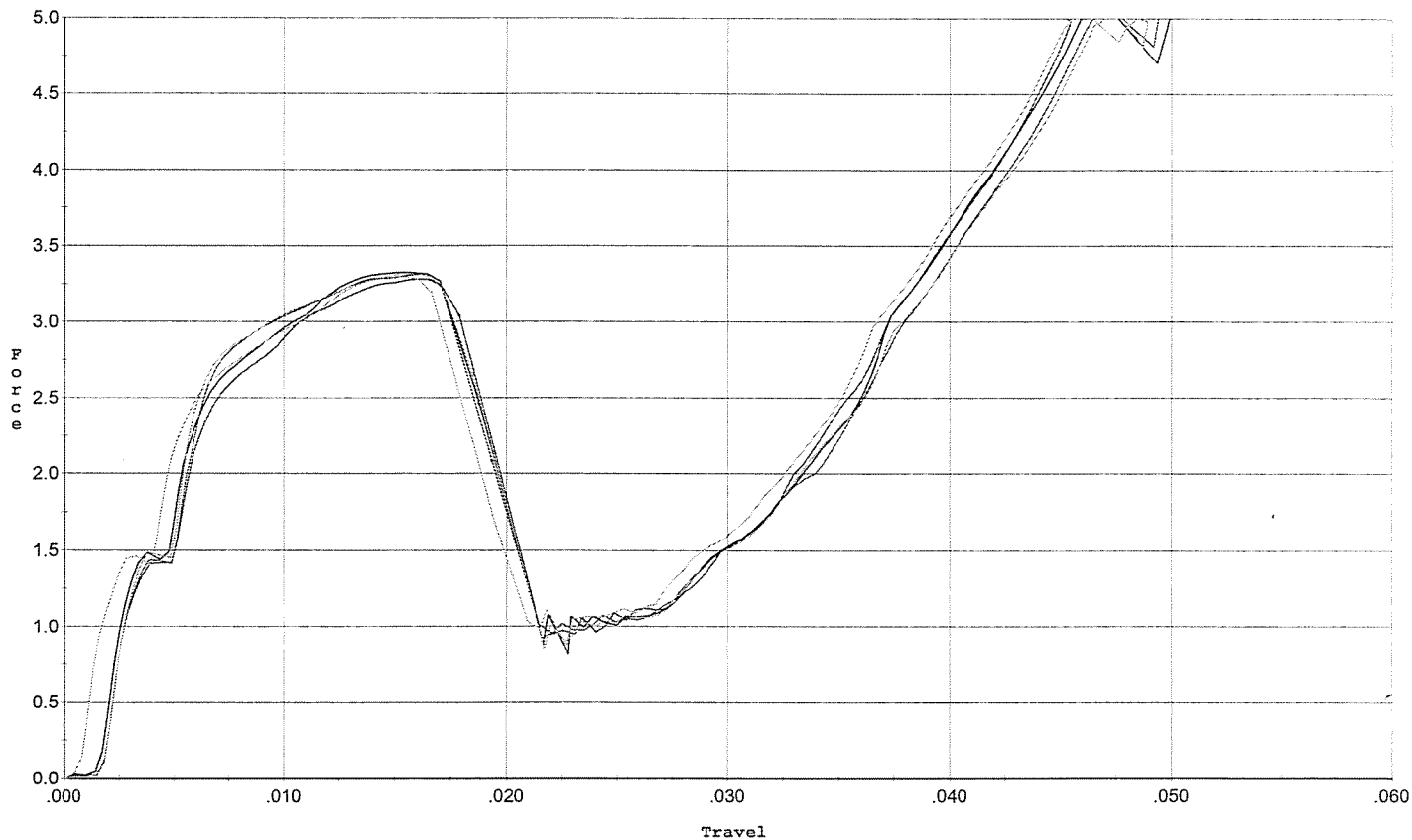
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.345	0.016	0.00	0.037	0.027		Set Trigger
2	2.354	0.016	0.00	0.037	0.027		Set Trigger
3	2.314	0.015	0.00	0.038	0.025		Set Trigger
4	2.308	0.015	0.00	0.038	0.025		Set Trigger
5	2.342	0.016	0.00	0.038	0.028		Set Trigger

A-2-33

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



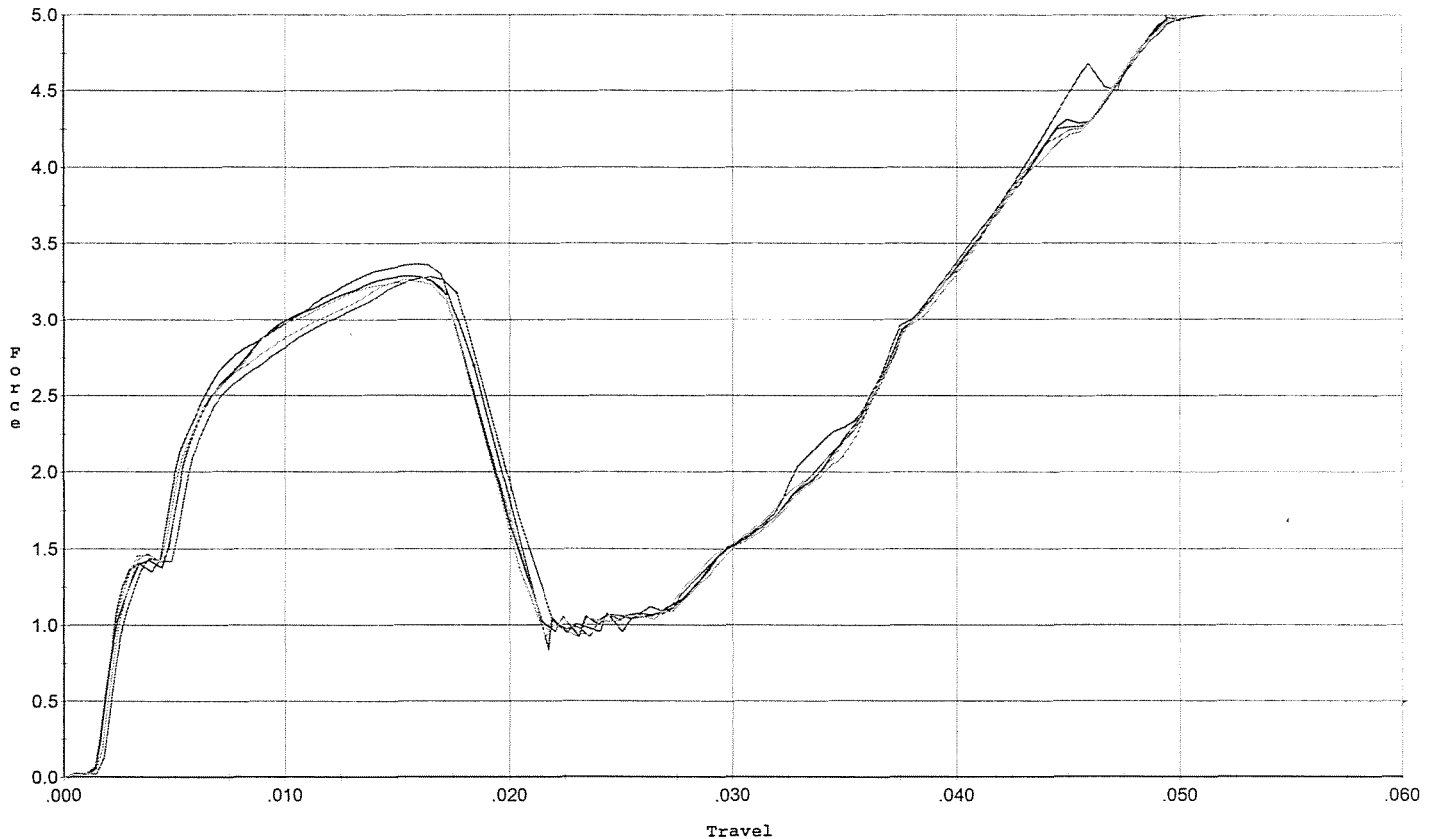
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.283	0.018	0.005	0.034	0.039		Set Trigger
2	3.327	0.019	0.00	0.034	0.042		Set Trigger
3	3.310	0.019	0.002	0.034	0.042		Set Trigger
4	3.296	0.017	0.00	0.034	0.038		Set Trigger
5	3.316	0.018	0.005	0.034	0.041		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



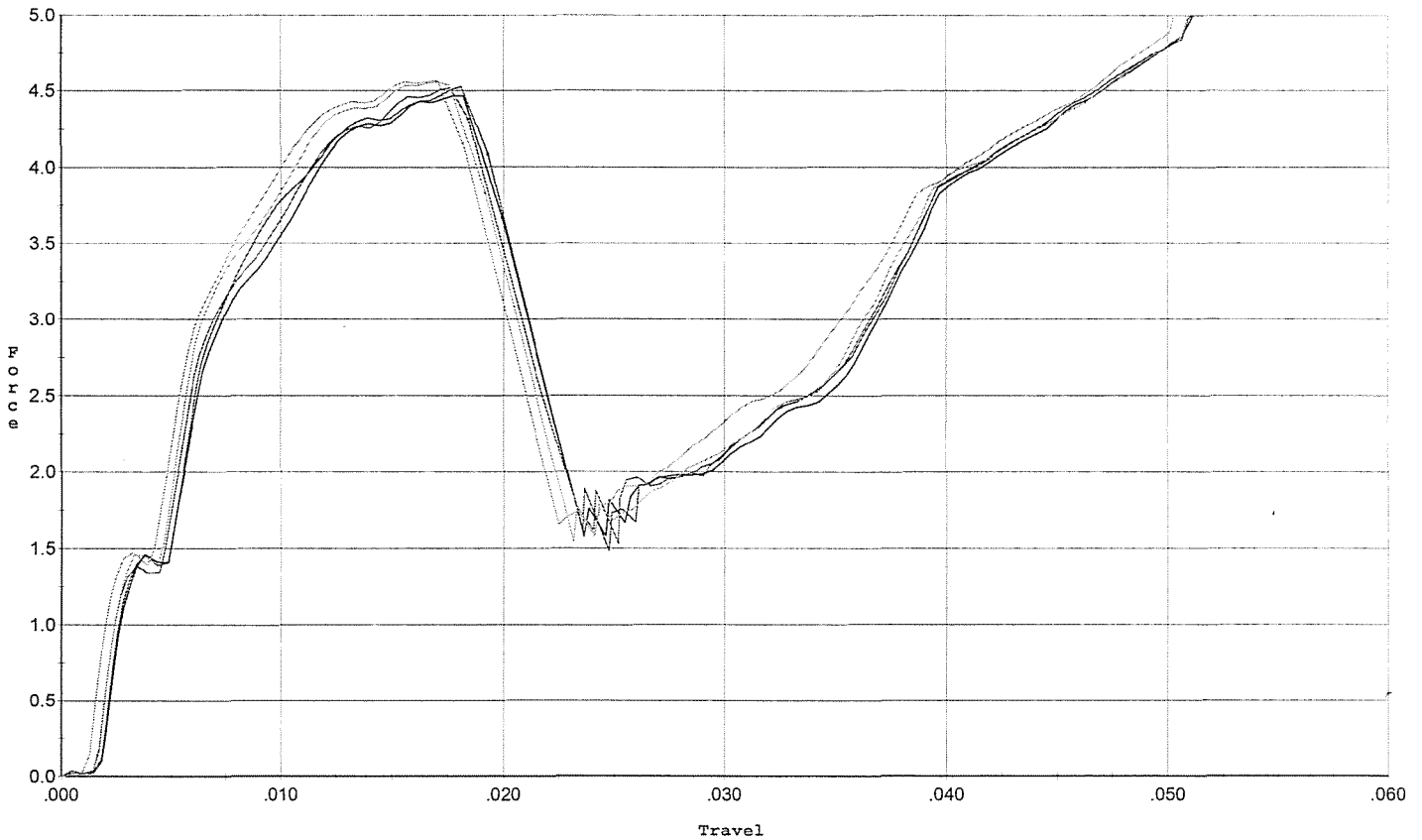
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.364	0.018	0.00	0.034	0.041		Set Trigger
2	3.288	0.017	0.00	0.035	0.038		Set Trigger
3	3.281	0.018	0.002	0.035	0.038		Set Trigger
4	3.276	0.017	0.00	0.035	0.037		Set Trigger
5	3.253	0.017	0.00	0.035	0.038		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



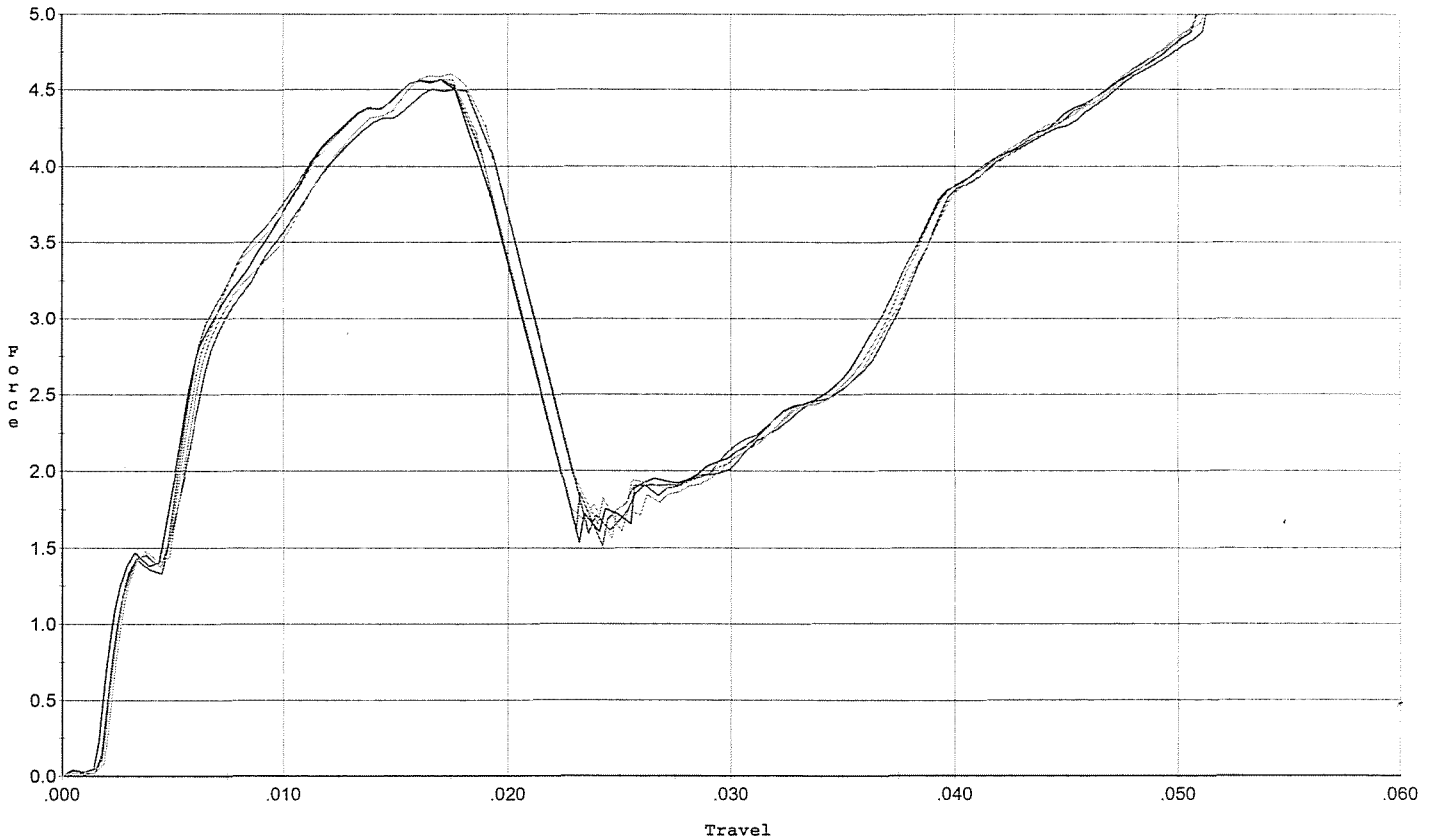
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.528	0.019	0.00	0.032	0.054		Set Trigger
2	4.465	0.020	0.005	0.032	0.055		Set Trigger
3	4.518	0.018	0.005	0.032	0.052		Set Trigger
4	4.557	0.019	0.005	0.032	0.055		Set Trigger
5	4.566	0.018	0.00	0.032	0.053		Set Trigger

A-4.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



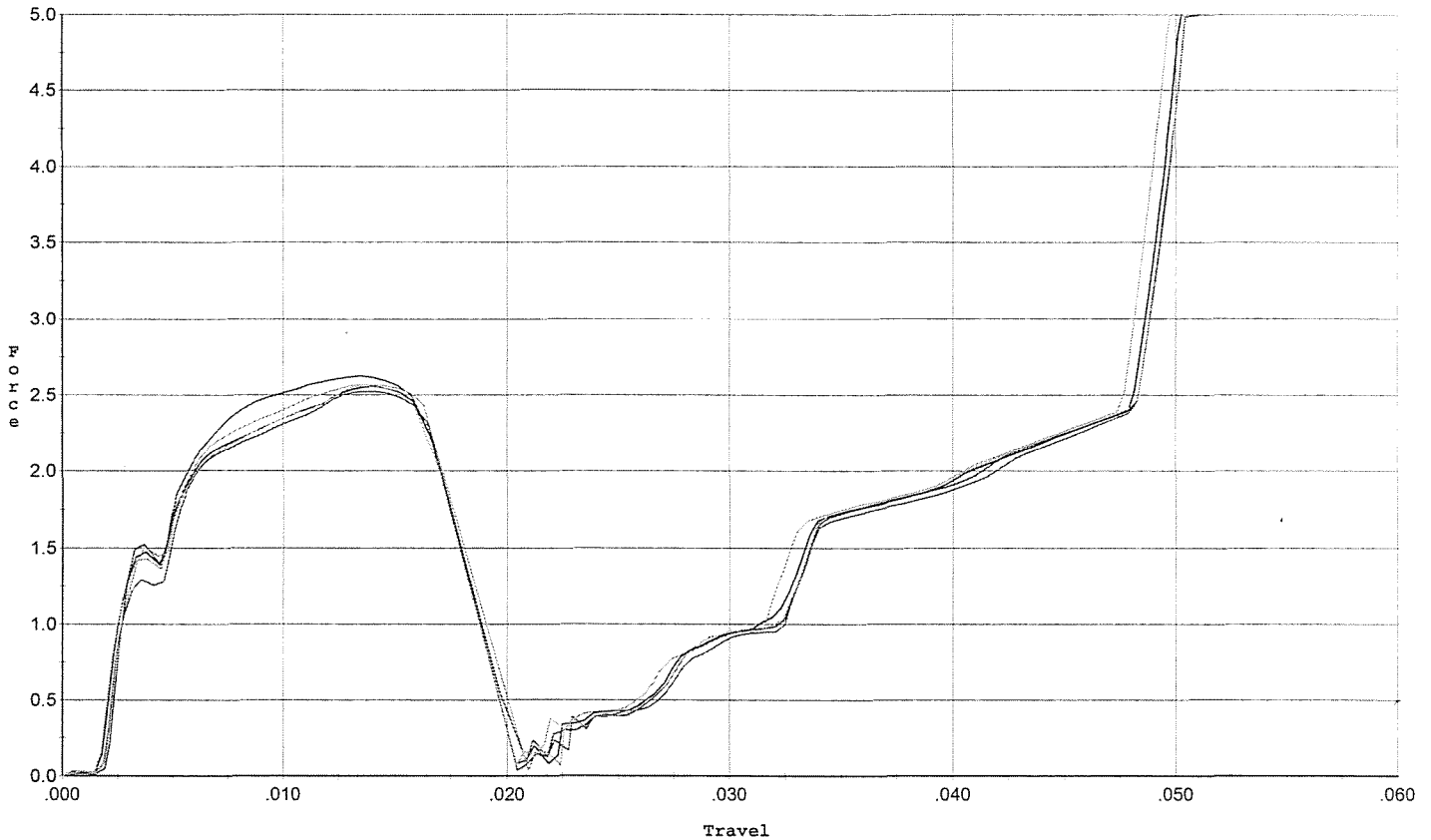
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.501	0.019	0.002	0.032	0.054		Set Trigger
2	4.564	0.019	0.00	0.032	0.055		Set Trigger
3	4.566	0.019	0.00	0.032	0.053		Set Trigger
4	4.567	0.019	0.002	0.032	0.053		Set Trigger
5	4.604	0.019	0.00	0.032	0.053		Set Trigger

A-4.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



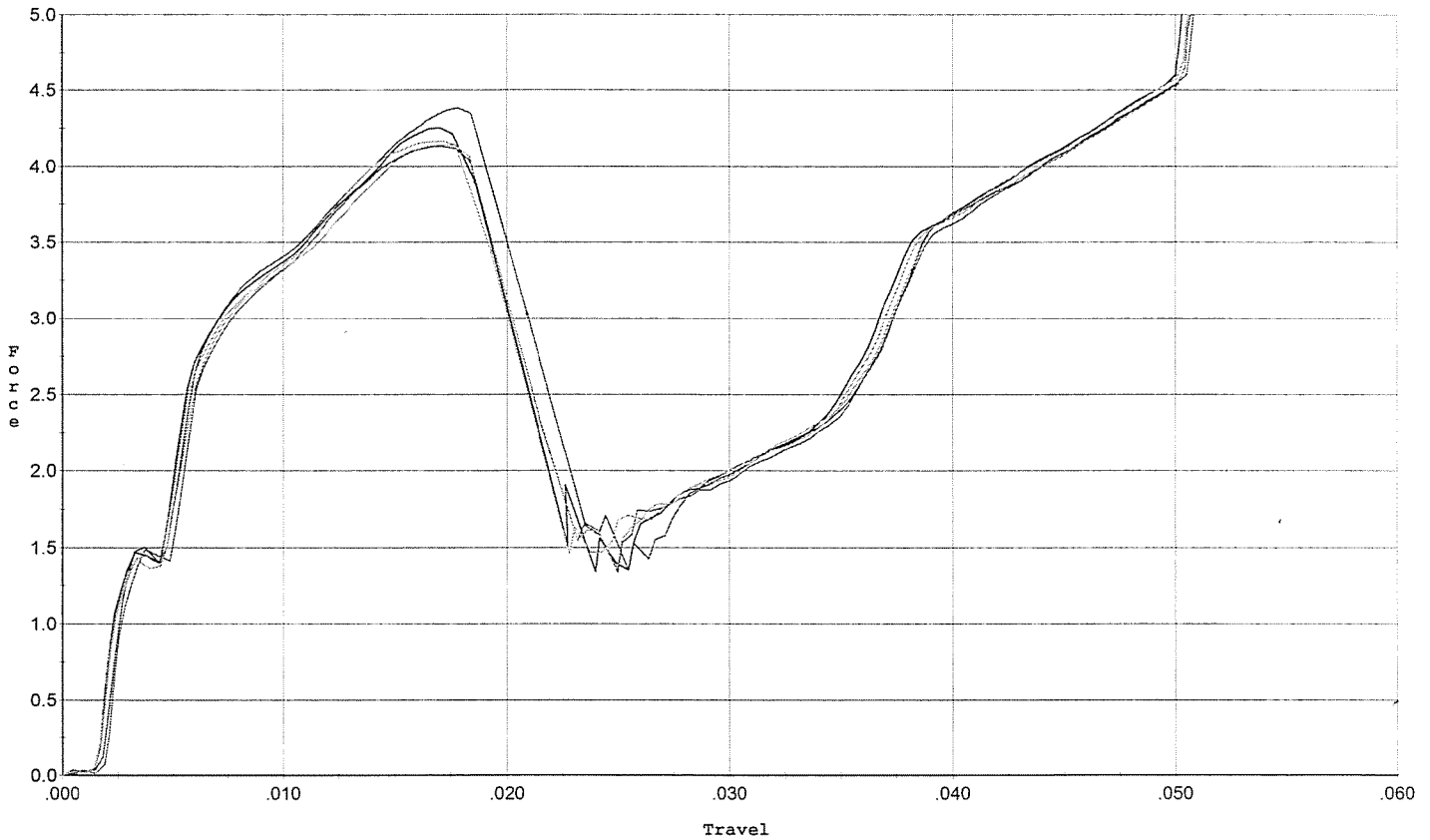
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.017	0.002	0.038	0.030		Set Trigger
2	2.555	0.017	0.002	0.038	0.029		Set Trigger
3	2.523	0.016	0.002	0.038	0.028		Set Trigger
4	2.557	0.017	0.002	0.037	0.030		Set Trigger
5	2.569	0.016	0.00	0.038	0.029		Set Trigger

A-256

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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	4.383	0.021	0.00	0.032	0.057		Set Trigger
2	4.252	0.019	0.005	0.032	0.049		Set Trigger
3	4.130	0.018	0.005	0.033	0.048		Set Trigger
4	4.165	0.019	0.00	0.033	0.051		Set Trigger
5	4.142	0.018	0.00	0.033	0.048		Set Trigger

A. 4.27