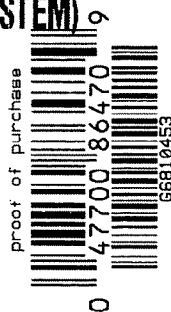


G 681 0453

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



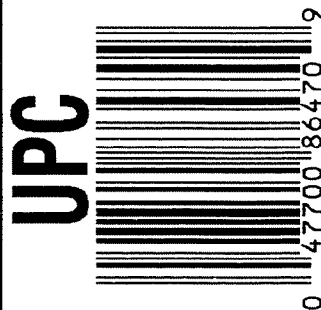
BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810453



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6810453

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-5-09	SPD
430	ASSEMBLE TO STOCK		2-5-09	SP
440	PROOF		2-5-09	SPD
460	CHECK HEADSPACE		2-5-09	SPD
470	DIS-ASSEMBLE ACTION		2-5-09	SPD
472	SERIALIZE BOLT HANDLE		2-6-09	RT
475	DRILL AND TAP SIGHT HOLES		2-6-09	TL
480	MAGNAFLUX BBL ACTION	OPERATOR AS	2/7/09	AS
490	MAGNAFLUX BOLT		2/7/09	mil
500	ROLLMARK CALIBER		2/9/09	RT
520	GOFF BLAST BBL / REC		9 Feb 09	SPD
542	APPLY COATINGS (BARREL ACTION)		2-11-	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-11-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

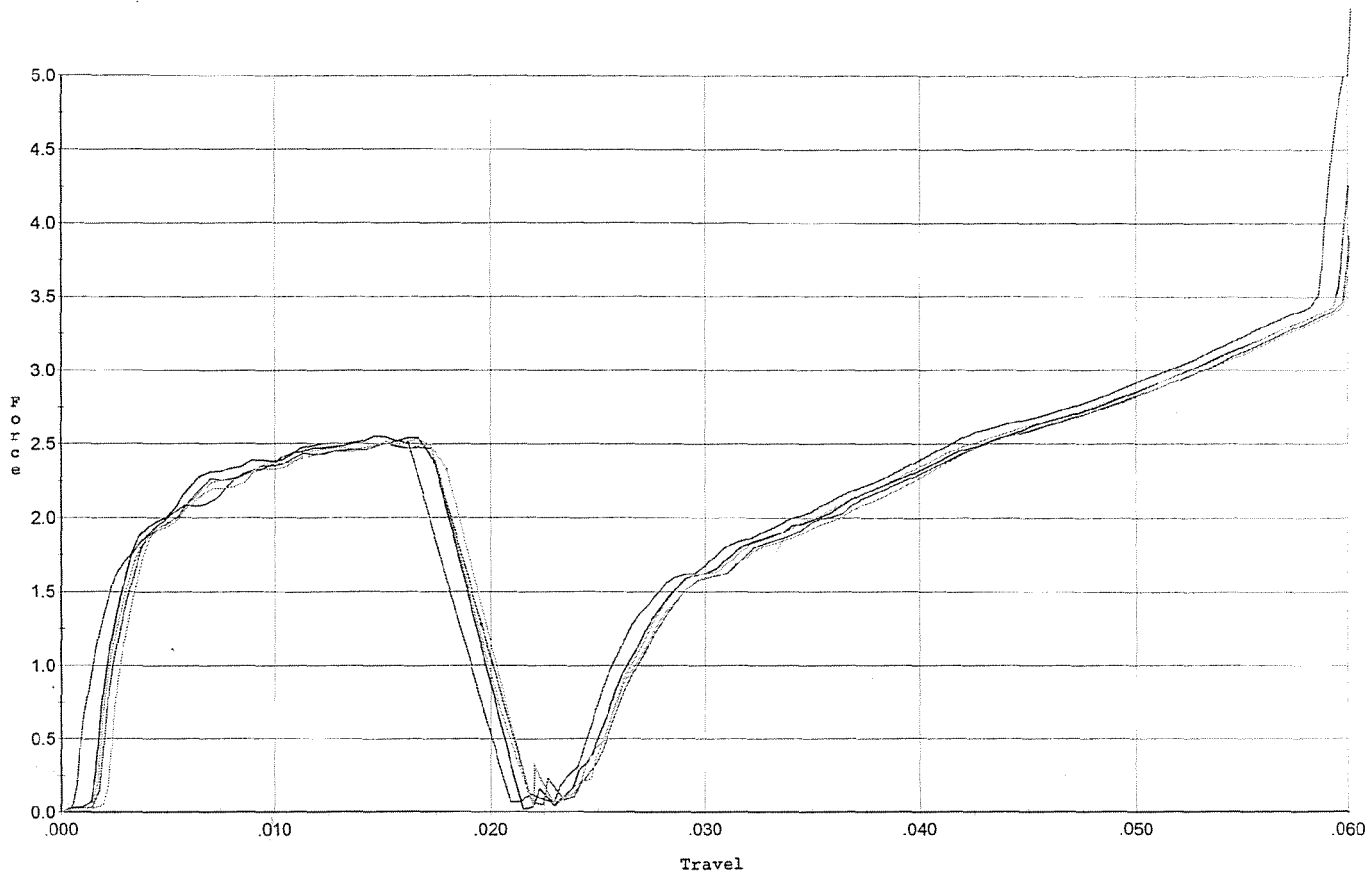
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-17-09	2 J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-17-09	2 J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.004</u> <u>.004</u> <u>.005</u>	2-17-09	2 J.
	J) ASSEMBLE STOCK		2-11-09	J.P.D.
	K) ASSEMBLE SWIVEL STUDS		2-18-09	2 J.
	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	2-14-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-14-09	2 J.
670	FINAL INSPECTION A) HEADSPACE		2-17-09	2 J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.17</u> <u>2.12</u> <u>2.13</u> <u>2.13</u> <u>2.12</u>	2-17-09	W W
	C) FUNCTION		2-17-09	2 H.
690	PACK		2/18/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



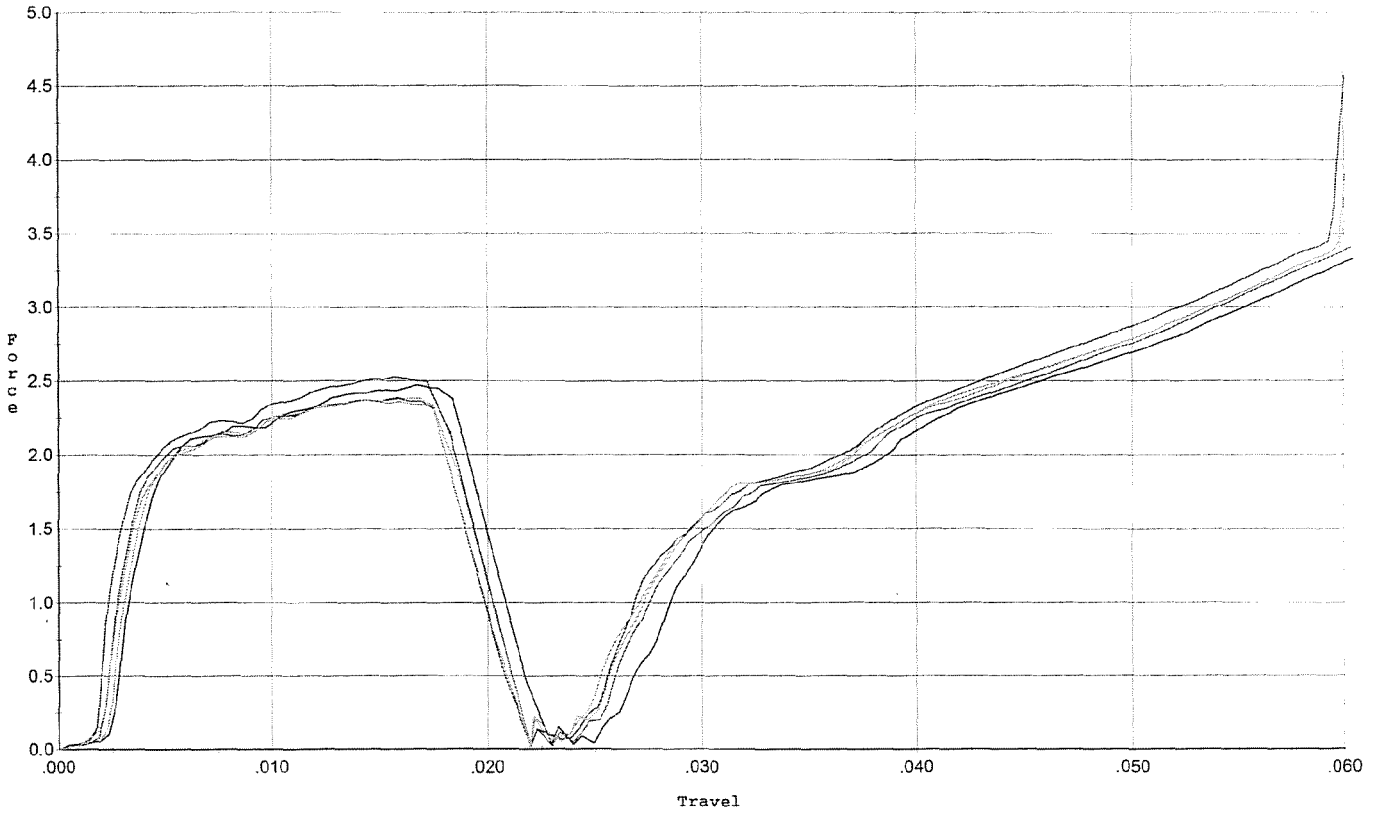
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.016	0.00	0.046	0.031		Set Trigger
2	2.553	0.017	0.00	0.045	0.033		Set Trigger
3	2.497	0.020	0.00	0.046	0.036		Set Trigger
4	2.518	0.018	0.00	0.045	0.033		Set Trigger
5	2.531	0.017	0.00	0.046	0.032		Set Trigger

A-252

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



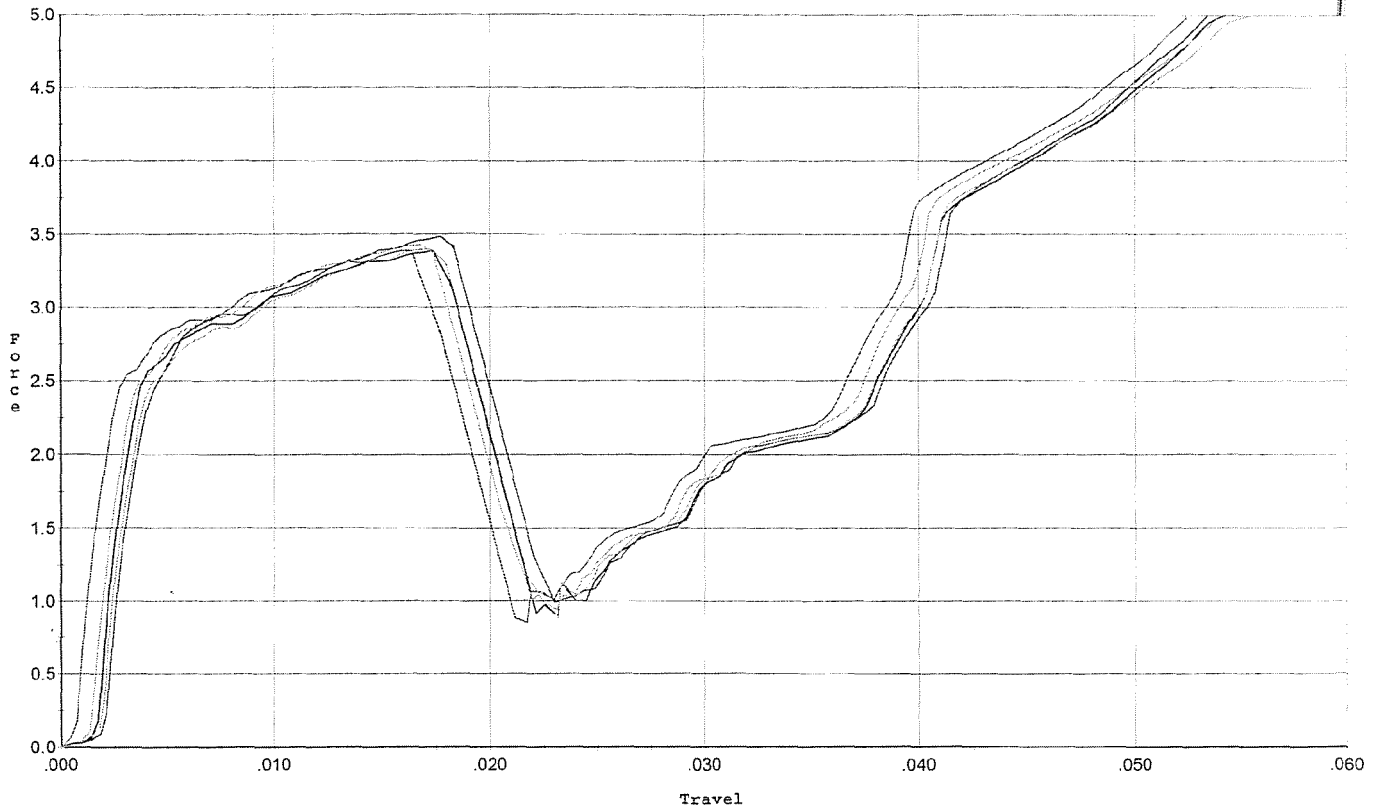
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.527	0.018	0.00	0.045	0.034		Set Trigger
2	2.472	0.018	0.00	0.047	0.032		Set Trigger
3	2.381	0.017	0.00	0.047	0.031		Set Trigger
4	2.372	0.019	0.00	0.046	0.032		Set Trigger
5	2.390	0.017	0.00	0.046	0.030		Set Trigger

A-2-42

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



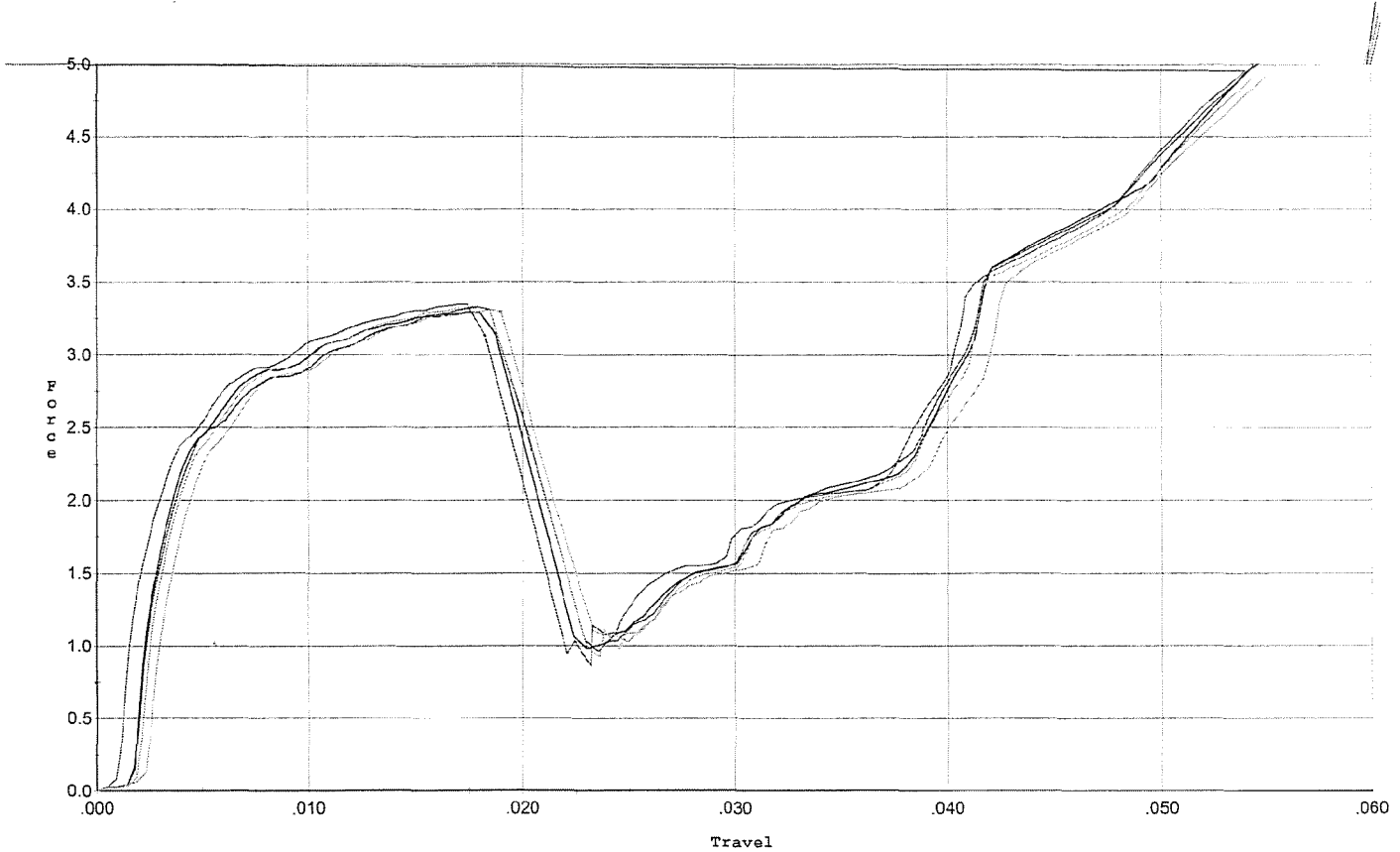
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.482	0.018	0.00	0.043	0.045		Set Trigger
2	3.388	0.018	0.00	0.042	0.044		Set Trigger
3	3.385	0.018	0.00	0.042	0.045		Set Trigger
4	3.401	0.018	0.00	0.043	0.043		Set Trigger
5	3.428	0.017	0.00	0.042	0.043		Set Trigger

A-3.41

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/6/2009

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



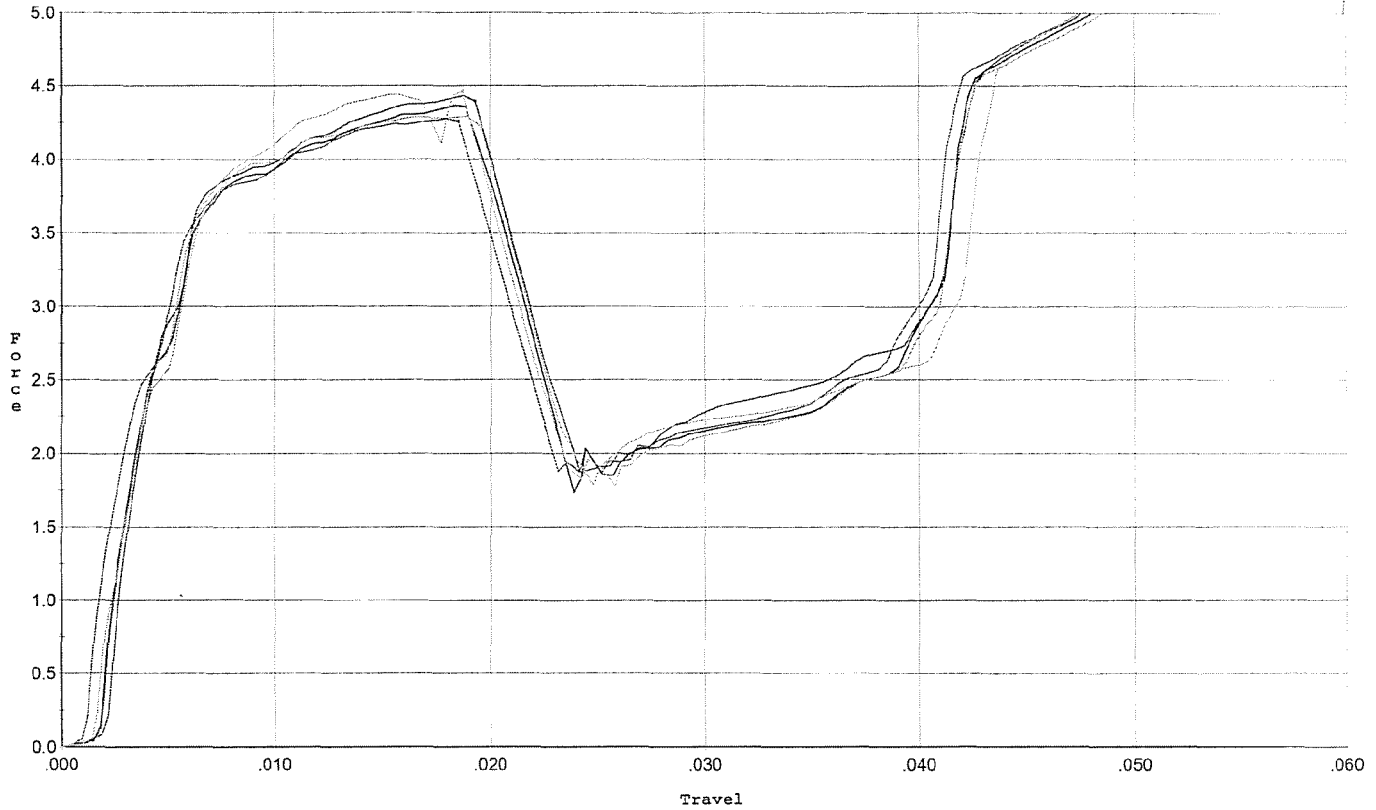
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.328	0.020	0.00	0.042	0.048		Set Trigger
2	3.296	0.019	0.00	0.042	0.044		Set Trigger
3	3.344	0.018	0.00	0.043	0.045		Set Trigger
4	3.330	0.020	0.00	0.043	0.048		Set Trigger
5	3.309	0.019	0.00	0.043	0.043		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



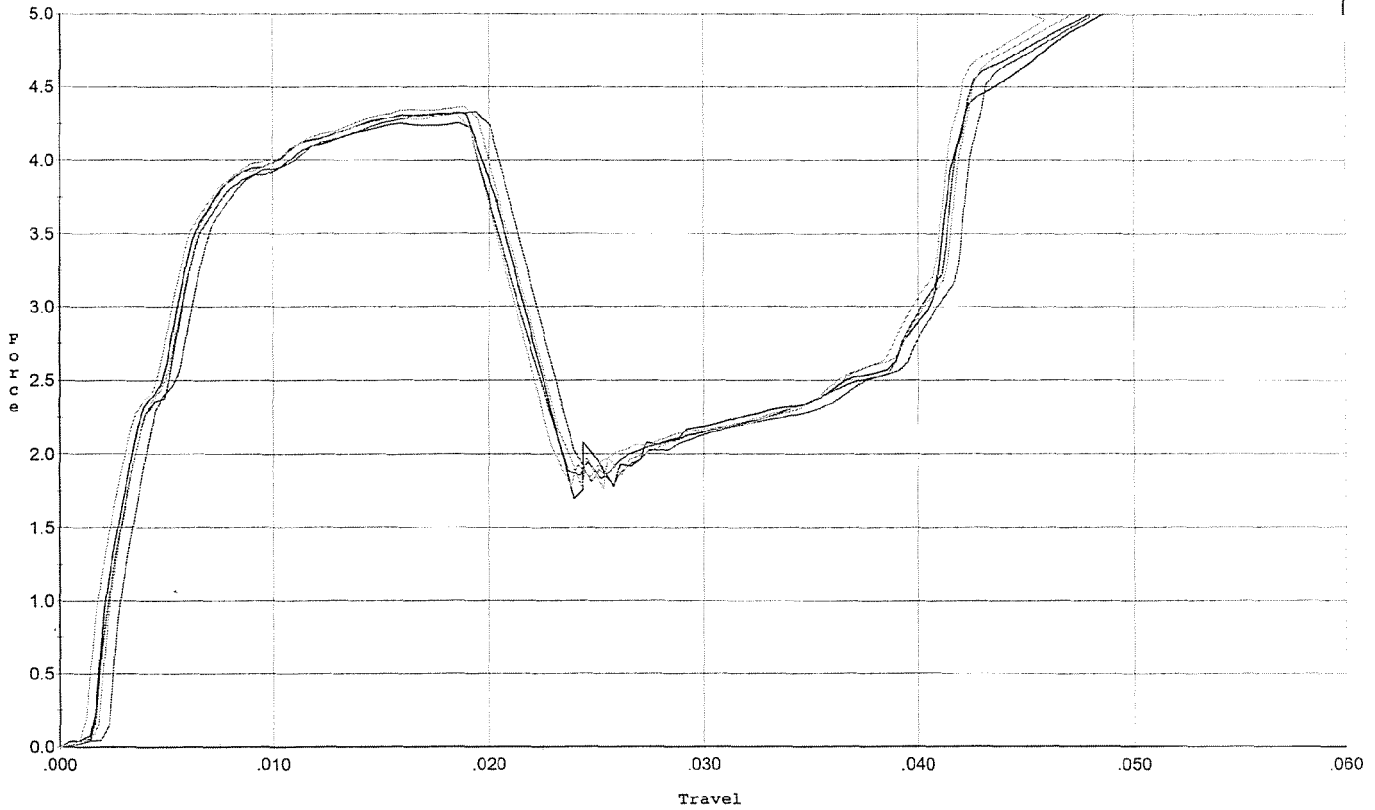
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.432	0.019	0.00	0.040	0.059		Set Trigger
2	4.363	0.021	0.00	0.040	0.062		Set Trigger
3	4.275	0.019	0.00	0.040	0.056		Set Trigger
4	4.466	0.019	0.00	0.039	0.058		Set Trigger
5	4.292	0.020	0.00	0.040	0.059		Set Trigger

AH-36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



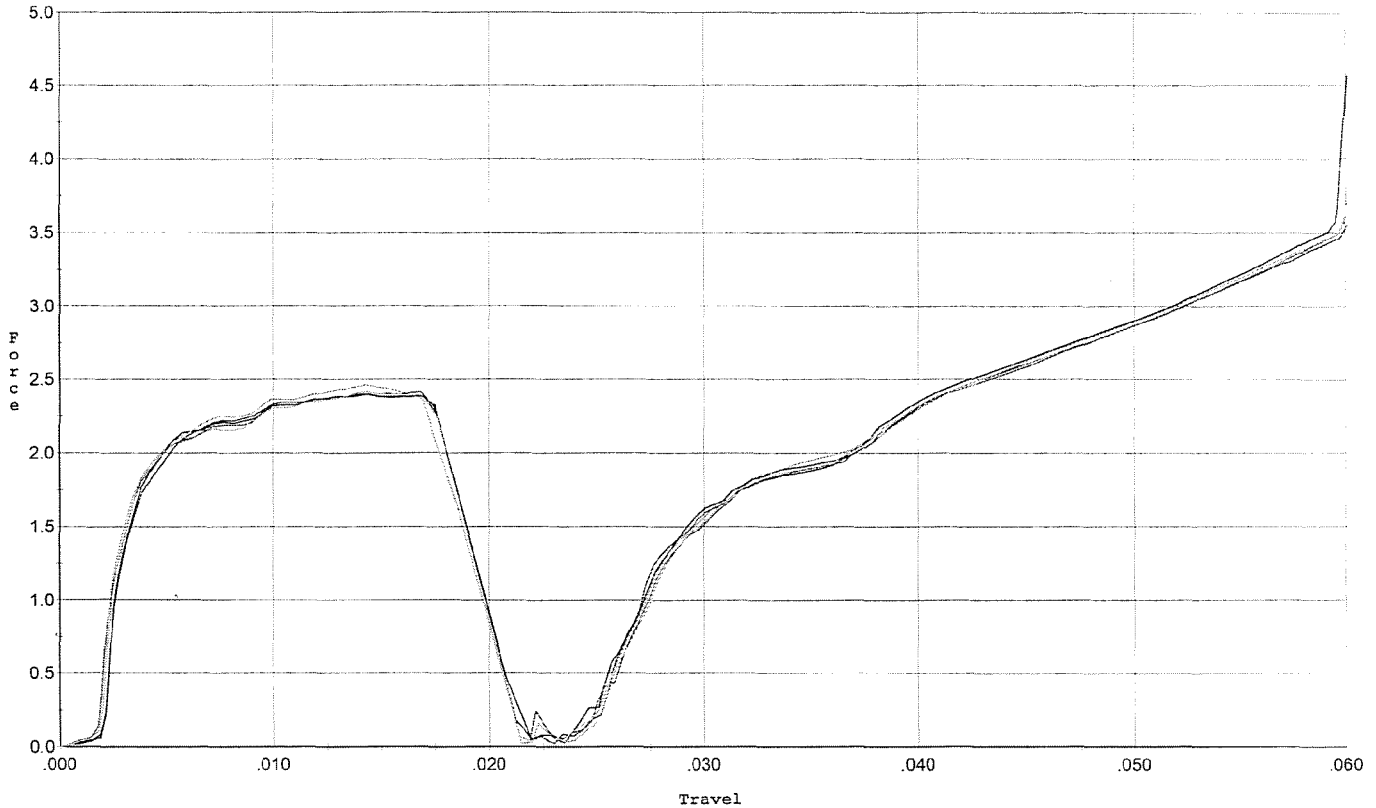
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.252	0.019	0.00	0.040	0.057		Set Trigger
2	4.323	0.020	0.00	0.040	0.062		Set Trigger
3	4.329	0.020	0.00	0.039	0.059		Set Trigger
4	4.323	0.019	0.00	0.038	0.059		Set Trigger
5	4.361	0.019	0.00	0.039	0.059		Set Trigger

A-4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/6/2009

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



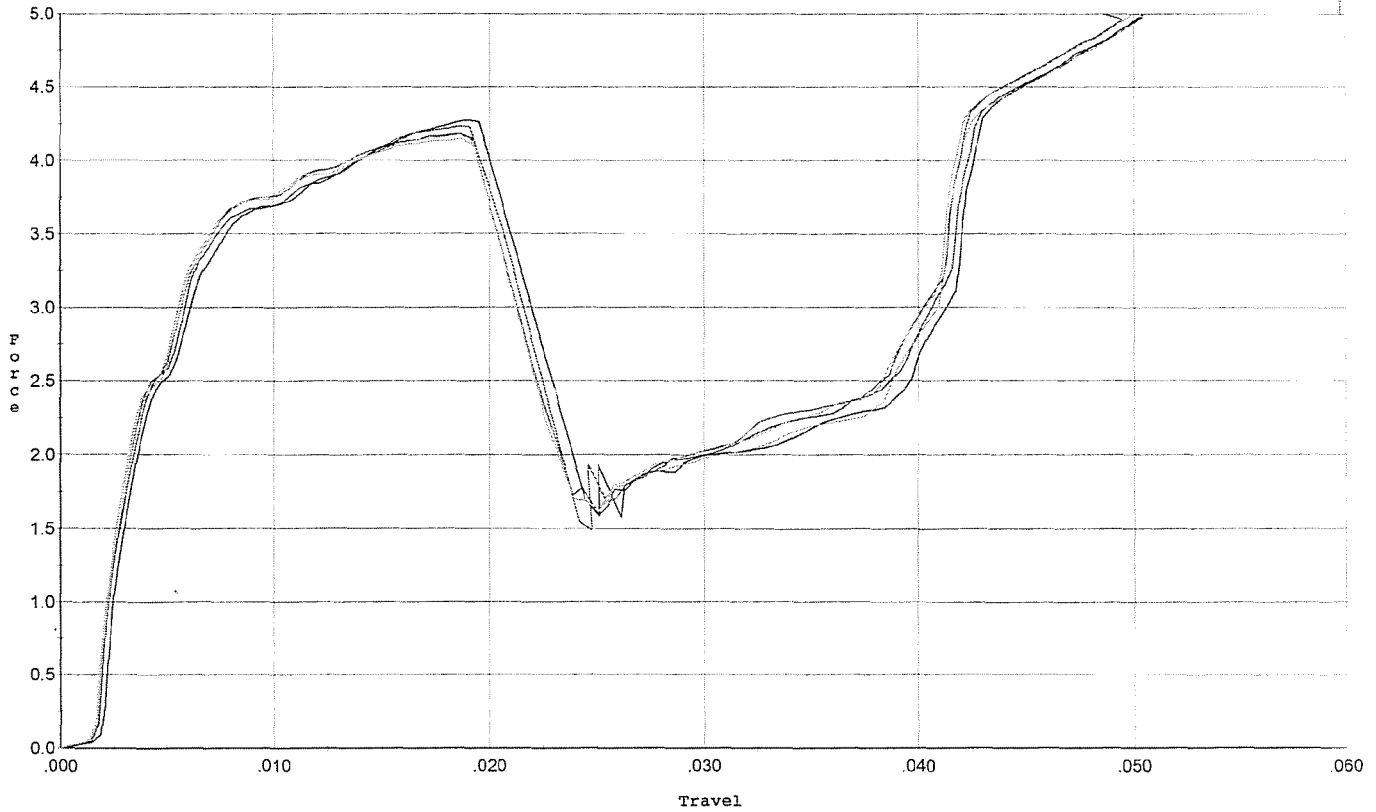
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.399	0.018	0.00	0.046	0.031		Set Trigger
2	2.401	0.017	0.00	0.045	0.031		Set Trigger
3	2.415	0.017	0.00	0.046	0.032		Set Trigger
4	2.413	0.019	0.00	0.046	0.033		Set Trigger
5	2.464	0.018	0.00	0.046	0.032		Set Trigger

A-2-41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/6/2009

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	4.180	0.019	0.00	0.041	0.056		Set Trigger
2	4.275	0.022	0.00	0.041	0.063		Set Trigger
3	4.232	0.021	0.00	0.040	0.061		Set Trigger
4	4.176	0.019	0.00	0.041	0.056		Set Trigger
5	4.148	0.019	0.00	0.041	0.056		Set Trigger

A-4.20