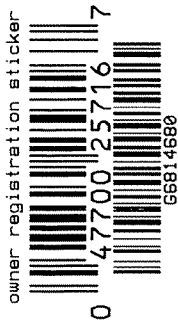
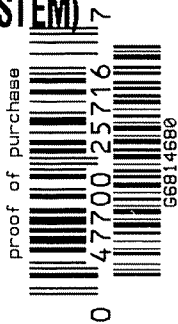


66814680

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

- INSTRUCTION BOOK 3513



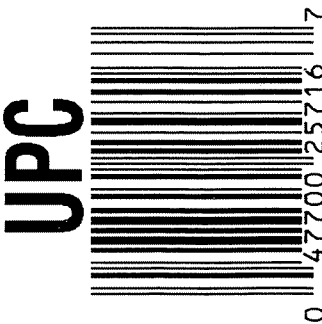
BM FORM

ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6814680



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 681 4680

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RIZ
480	MAGNAFLUX BBL ACTION	(F)	3/9/09	(N)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-31-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

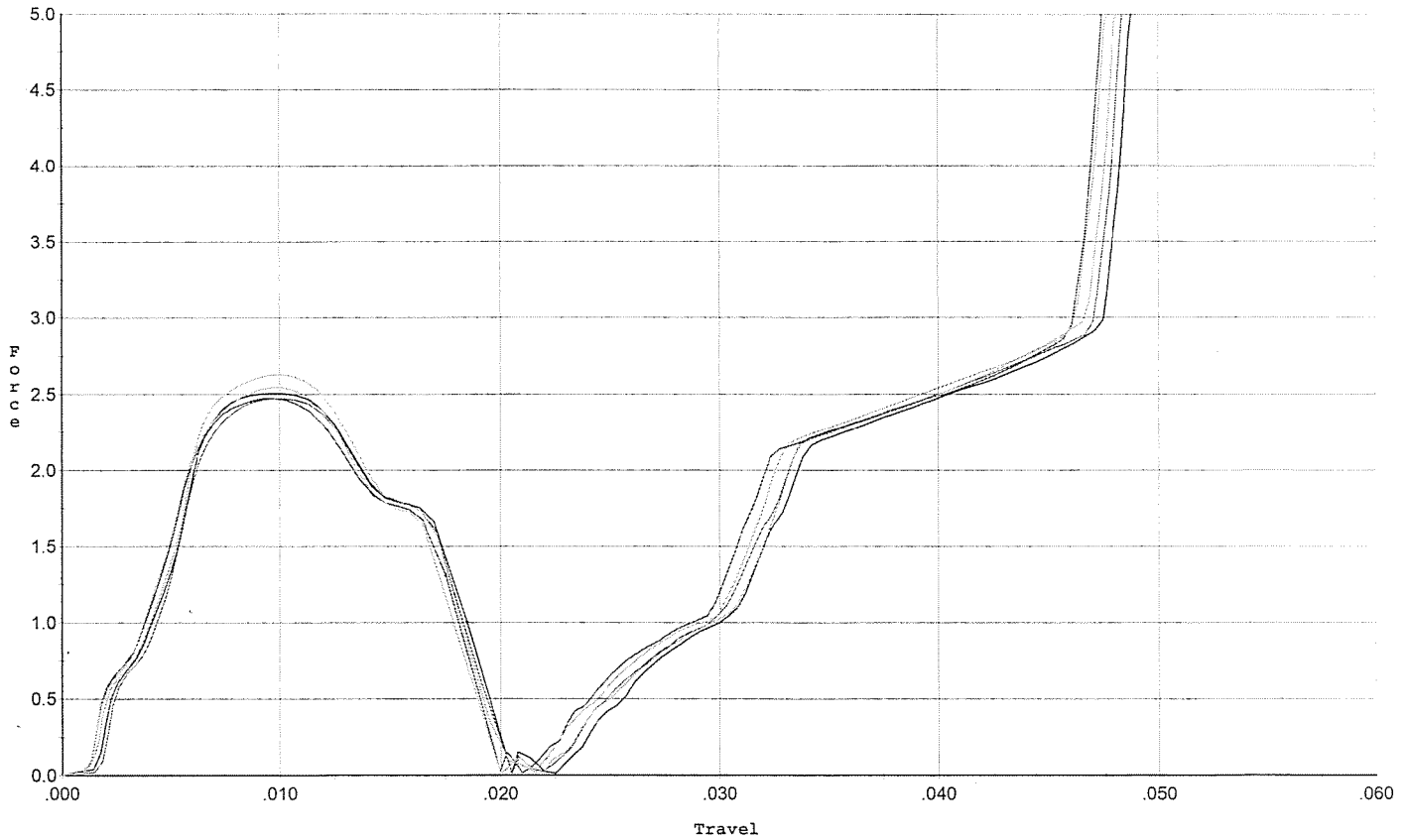
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-1-09	WW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	4-1-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	4-1-09	WW
	J) ASSEMBLE STOCK		3-31-09	R.W.
	K) ASSEMBLE SWIVEL STUDS		4-1-09	WW
	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	3-31-09	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.63</u> <u>2.54</u> <u>2.54</u> <u>2.52</u>	4-1-09	WW
	C) FUNCTION		4-1-09	WW
690	PACK		4/13/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



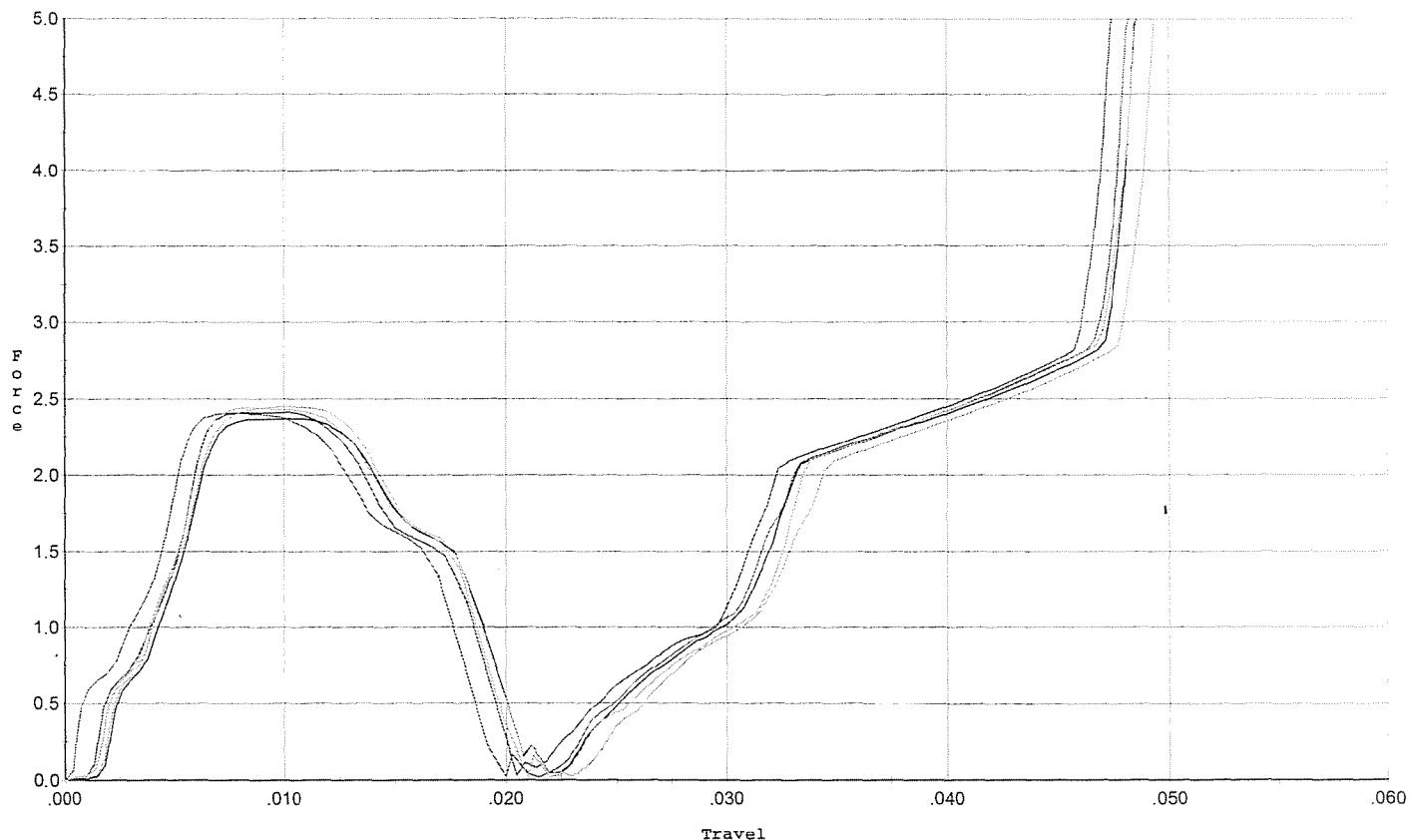
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.474	0.018	0.00	0.035	0.028		Set Trigger
2	2.507	0.018	0.00	0.035	0.029		Set Trigger
3	2.473	0.017	0.002	0.035	0.026		Set Trigger
4	2.545	0.017	0.00	0.035	0.027		Set Trigger
5	2.630	0.017	0.00	0.035	0.028		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



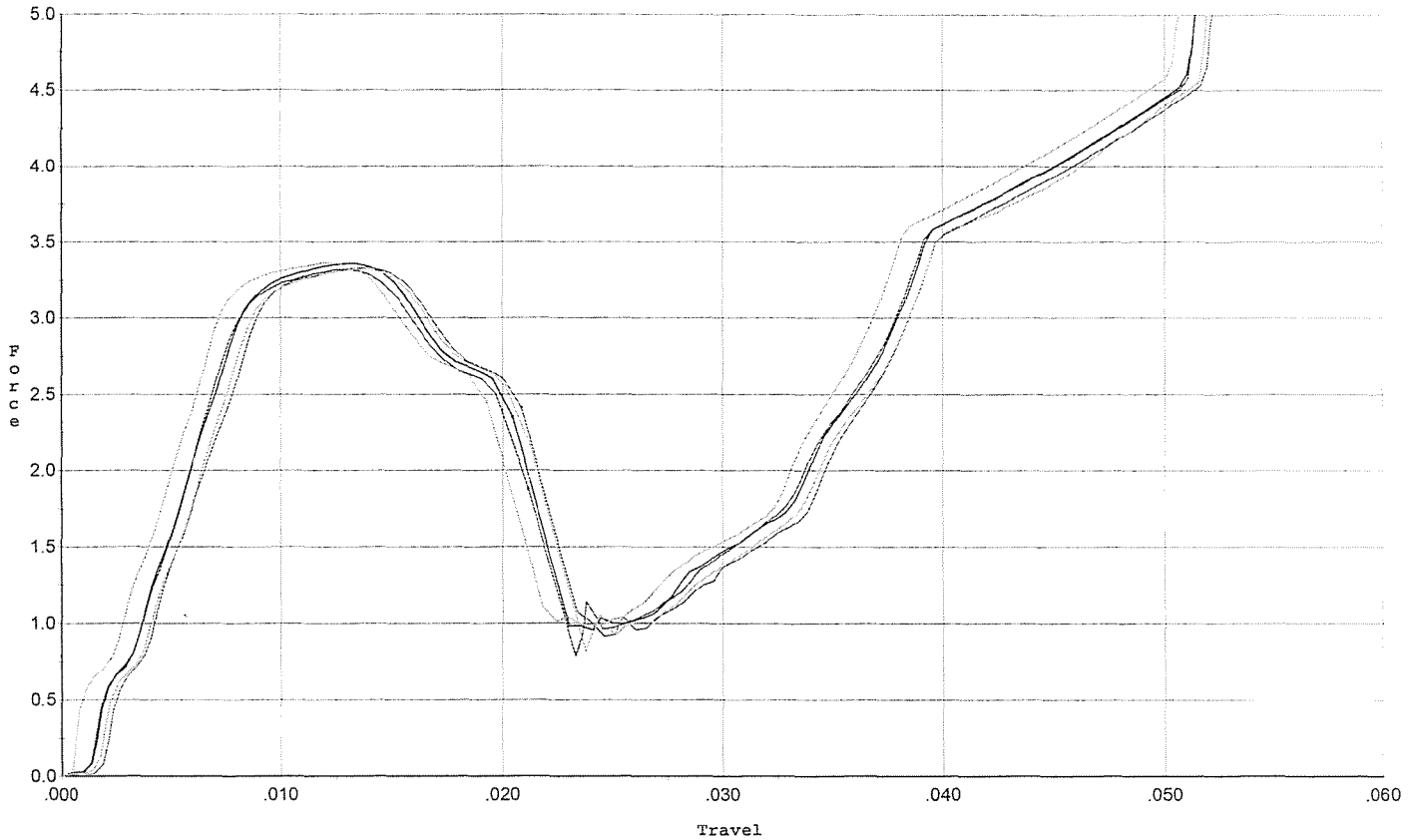
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.414	0.018	0.00	0.034	0.028		Set Trigger
2	2.372	0.019	0.00	0.035	0.029		Set Trigger
3	2.407	0.017	0.00	0.036	0.028		Set Trigger
4	2.441	0.018	0.00	0.035	0.028		Set Trigger
5	2.451	0.019	0.00	0.035	0.030		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



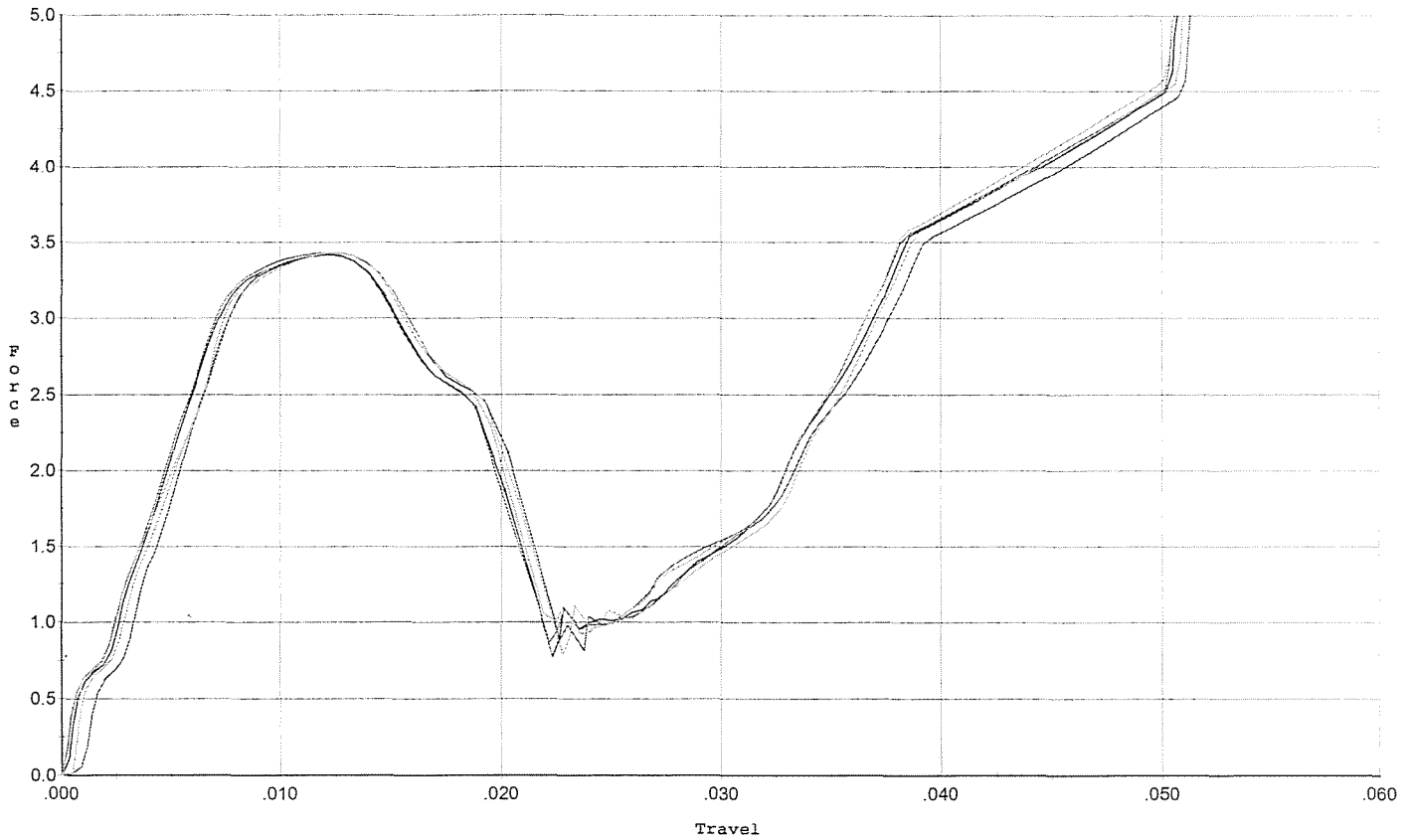
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.319	0.021	0.00	0.034	0.046		Set Trigger
2	3.358	0.020	0.00	0.034	0.045		Set Trigger
3	3.334	0.021	0.002	0.035	0.045		Set Trigger
4	3.320	0.021	0.00	0.034	0.045		Set Trigger
5	3.363	0.019	0.00	0.034	0.044		Set Trigger

A-533

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



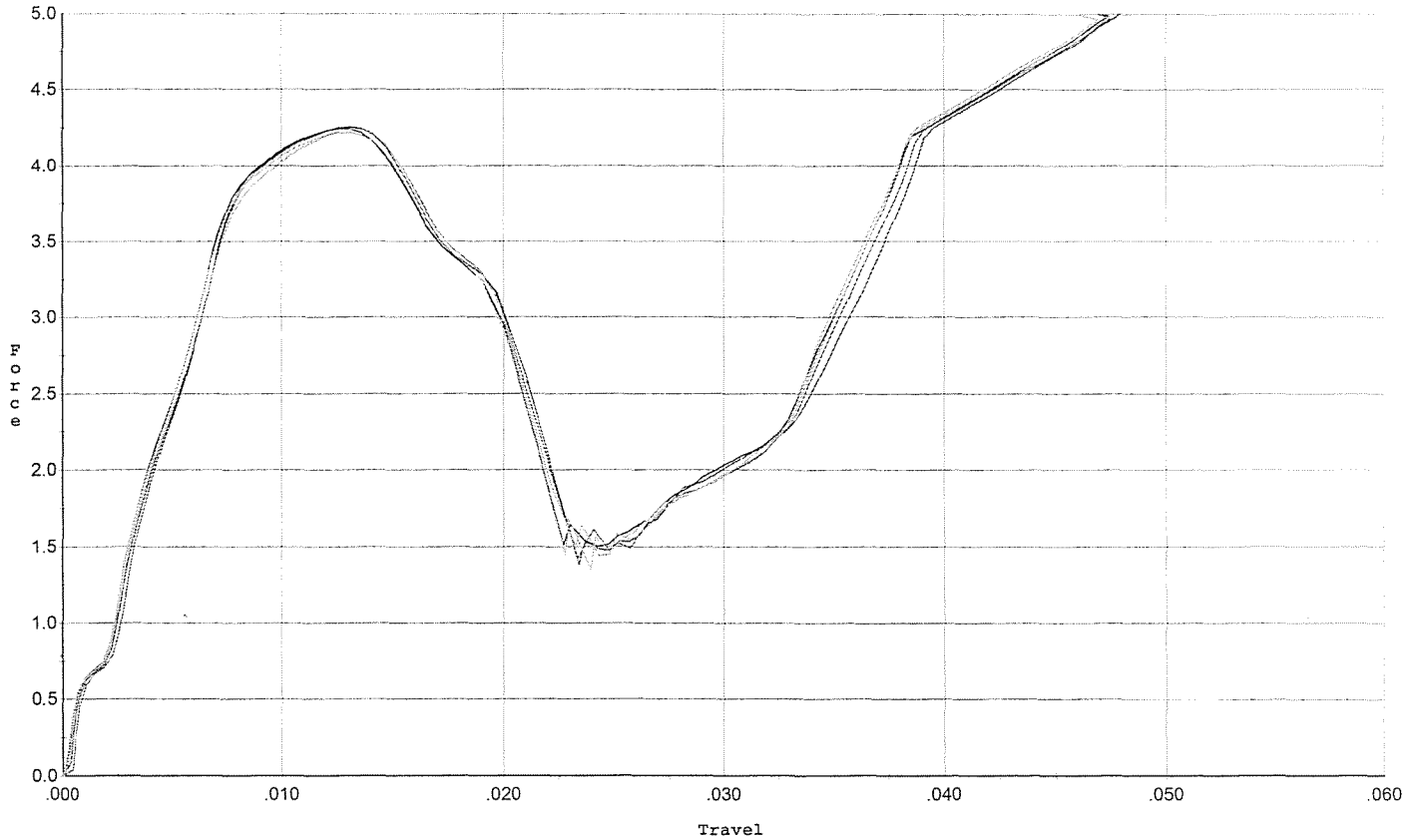
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.424	0.020	0.00	0.034	0.045		Set Trigger
2	3.418	0.020	0.00	0.034	0.046		Set Trigger
3	3.433	0.019	0.00	0.034	0.044		Set Trigger
4	3.428	0.021	0.00	0.034	0.047		Set Trigger
5	3.435	0.019	0.00	0.034	0.045		Set Trigger

A-3-42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



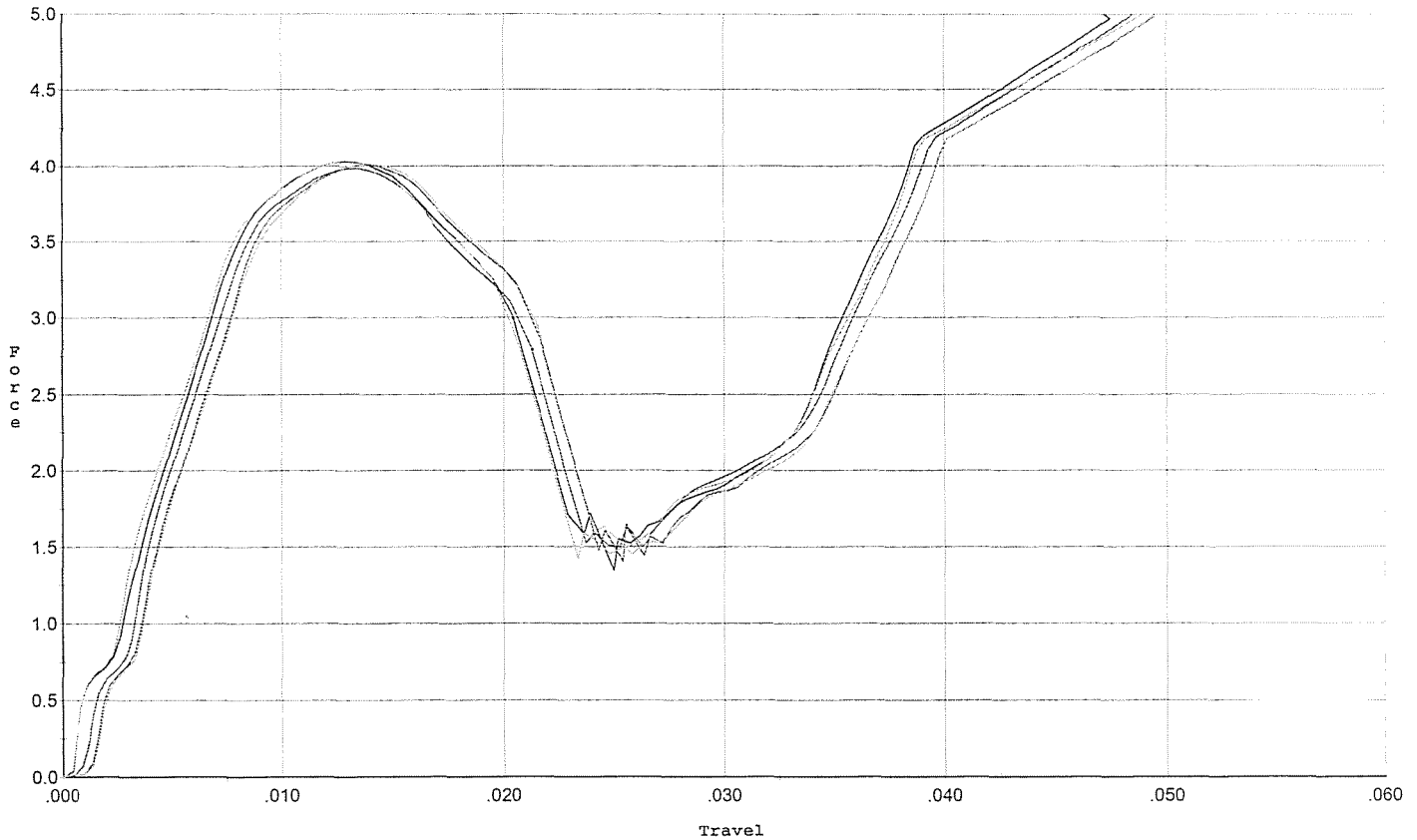
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.021	0.00	0.032	0.059		Set Trigger
2	4.242	0.020	0.00	0.032	0.057		Set Trigger
3	4.256	0.020	0.00	0.033	0.055		Set Trigger
4	4.218	0.020	0.00	0.032	0.057		Set Trigger
5	4.239	0.020	0.00	0.032	0.056		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



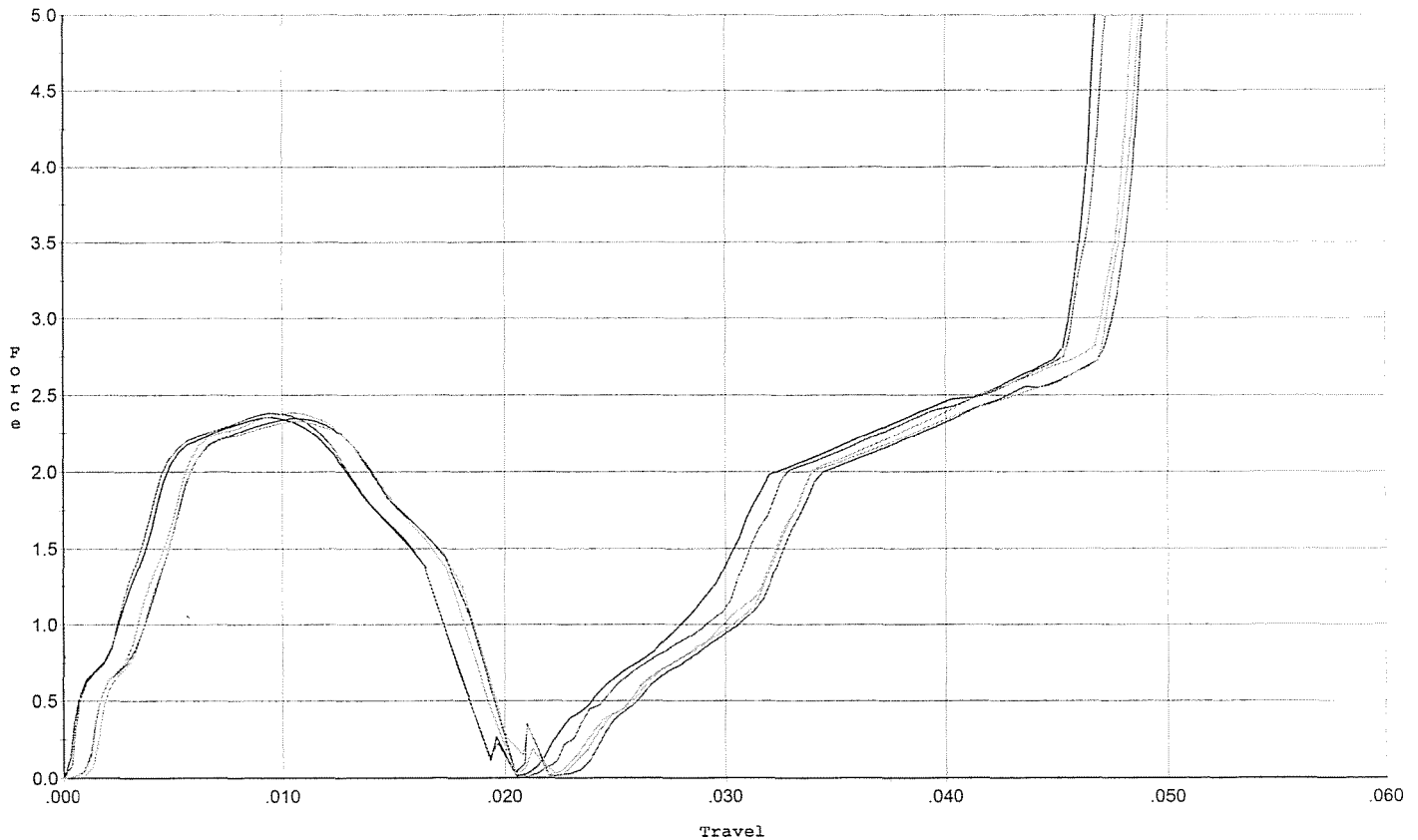
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.988	0.021	0.00	0.032	0.056		Set Trigger
2	4.031	0.020	0.00	0.032	0.055		Set Trigger
3	4.010	0.022	0.00	0.032	0.057		Set Trigger
4	4.018	0.022	0.00	0.032	0.056		Set Trigger
5	4.028	0.021	0.00	0.032	0.057		Set Trigger

A 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



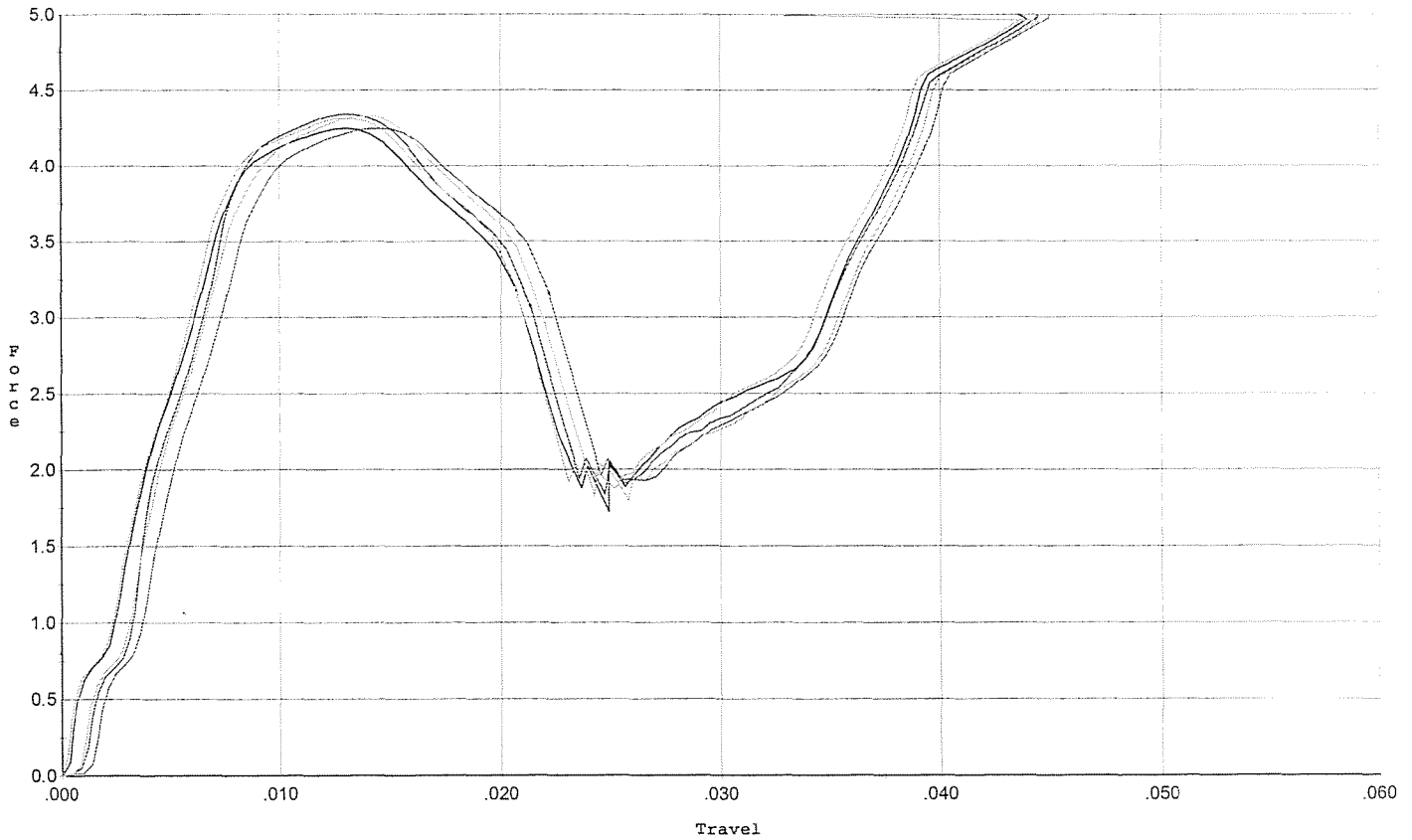
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.350	0.018	0.00	0.035	0.029		Set Trigger
2	2.358	0.016	0.00	0.035	0.027		Set Trigger
3	2.384	0.016	0.00	0.035	0.028		Set Trigger
4	2.388	0.017	0.00	0.036	0.028		Set Trigger
5	2.330	0.018	0.00	0.035	0.028		Set Trigger

A-2.36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lb for target accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.343	0.021	0.00	0.031	0.061		Set Trigger
2	4.250	0.021	0.00	0.031	0.060		Set Trigger
3	4.252	0.022	0.00	0.031	0.062		Set Trigger
4	4.331	0.022	0.00	0.031	0.063		Set Trigger
5	4.315	0.021	0.00	0.031	0.061		Set Trigger

A-429