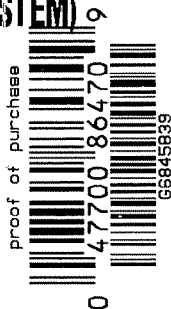


G 6845839

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

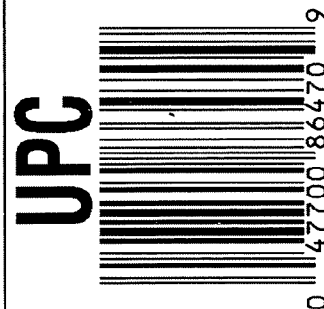


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6845839**



BM FORM

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G684 5839

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 4-16-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 4-16-09 | RP      |
| 440  | PROOF                                                          |                     | 4-16-09 | SPD     |
| 460  | CHECK HEADSPACE                                                | MAGNA - FLUX        | 4-16-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 4-16-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 4-17-09 | RT      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR (KD)       | 4-18-09 | (KD)    |
| 490  | MAGNAFLUX BOLT                                                 |                     |         |         |
| 500  | ROLLMARK CALIBER                                               |                     | 4-20-09 | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 4-17-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 4-21-09 | CJ      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 4-22-09 |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 4-29-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 4-29-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 4-29-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 4-29-09 | SPD     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

F004 REV 5/2006

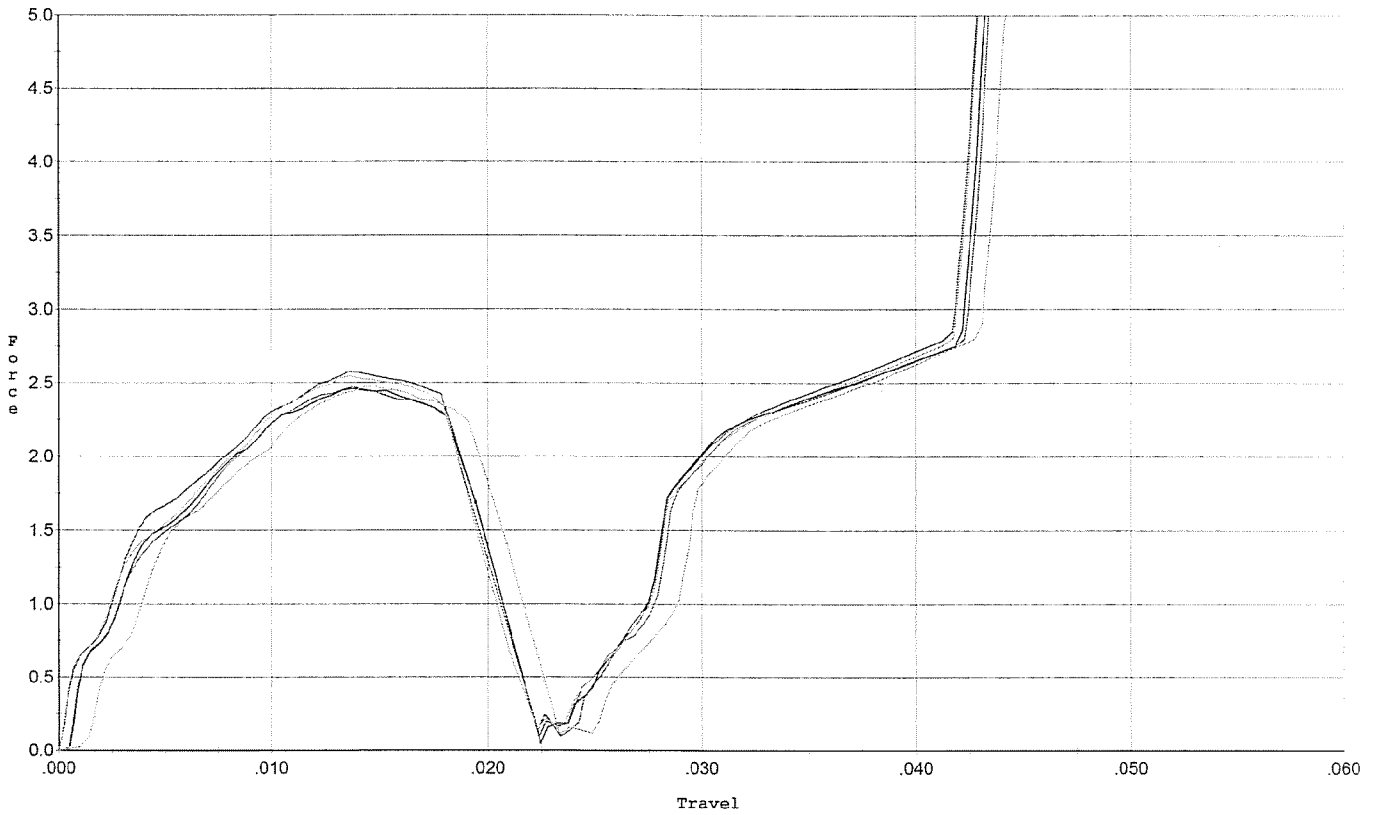
| OP #         | OPERATION NAME                                                           | READINGS                                               | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|--------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.0</u> <u>4.0</u> <u>4.0</u>                       | 5-12-09 | L.N.    |
| CONT.        |                                                                          |                                                        |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>6.0</u> <u>6.0</u> <u>6.0</u>                       | 5-12-09 | L.N.    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                        |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.023</u> <u>.023</u>                    | 5-12-09 | L.N.    |
|              | J) ASSEMBLE STOCK                                                        |                                                        | 4-29-09 | RP      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                        | 5-12-09 | L.N.    |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                        |         |         |
|              | M) IRON SIGHT<br>ALIGNMENT                                               |                                                        |         |         |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                        |         |         |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                              | <u>PASS</u> <u>PASS</u> FAIL FAIL                      | 5-1-09  | WV      |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                         |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                        | 5-1-09  | TAR     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                        | 5-12-09 | L.N.    |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>255</u> <u>257</u> <u>254</u> <u>250</u> <u>251</u> | 5-7-09  | RP      |
|              | C) FUNCTION                                                              |                                                        | 5-12-09 | L.N.    |
| 690          | PACK                                                                     |                                                        | 7/7/09  | FM      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



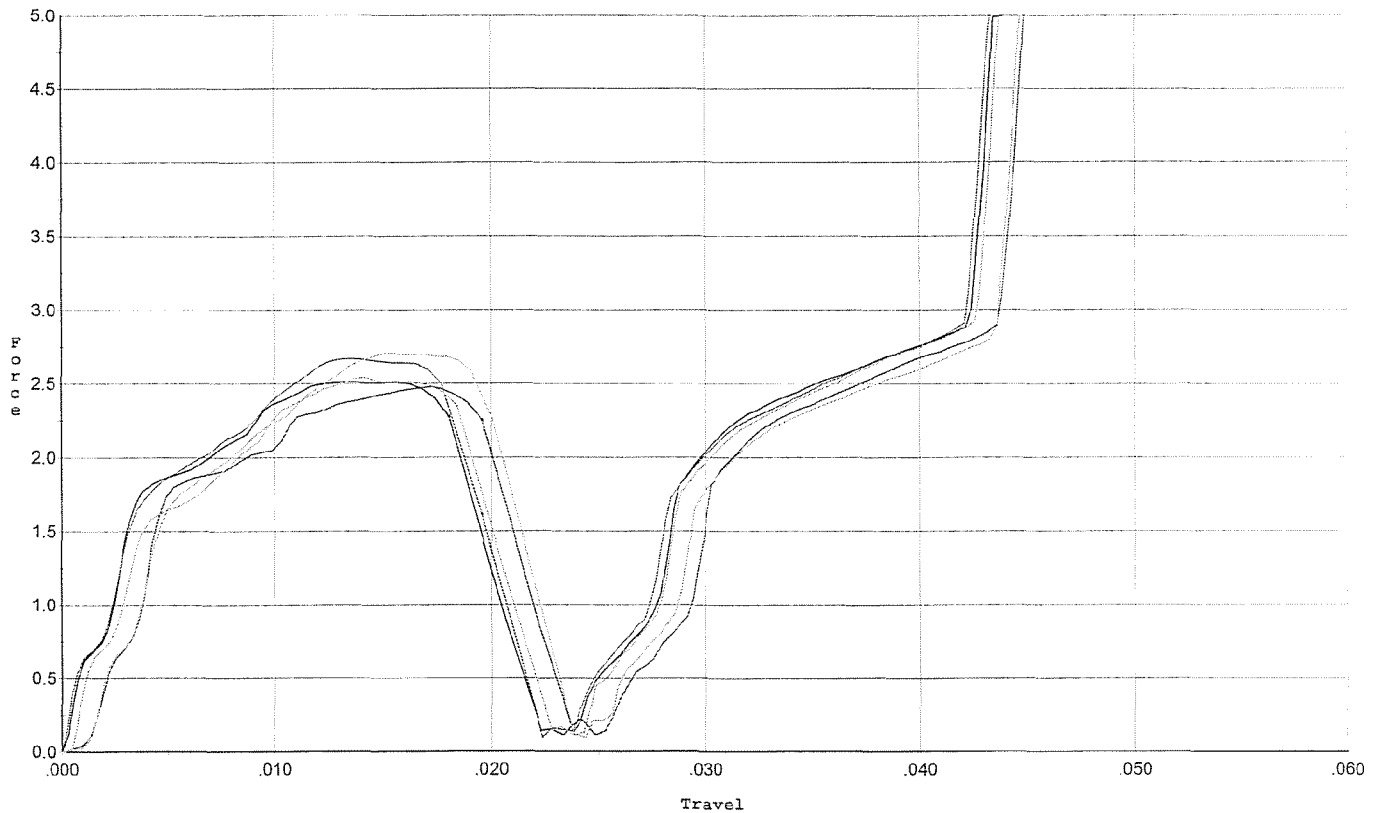
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.577      | 0.019             | 0.00            | 0.028      | 0.036             |           | Set Trigger |
| 2 | 2.461      | 0.019             | 0.00            | 0.028      | 0.034             |           | Set Trigger |
| 3 | 2.474      | 0.018             | 0.00            | 0.029      | 0.031             |           | Set Trigger |
| 4 | 2.546      | 0.018             | 0.00            | 0.028      | 0.032             |           | Set Trigger |
| 5 | 2.480      | 0.021             | 0.00            | 0.029      | 0.035             |           | Set Trigger |

A-2-50

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



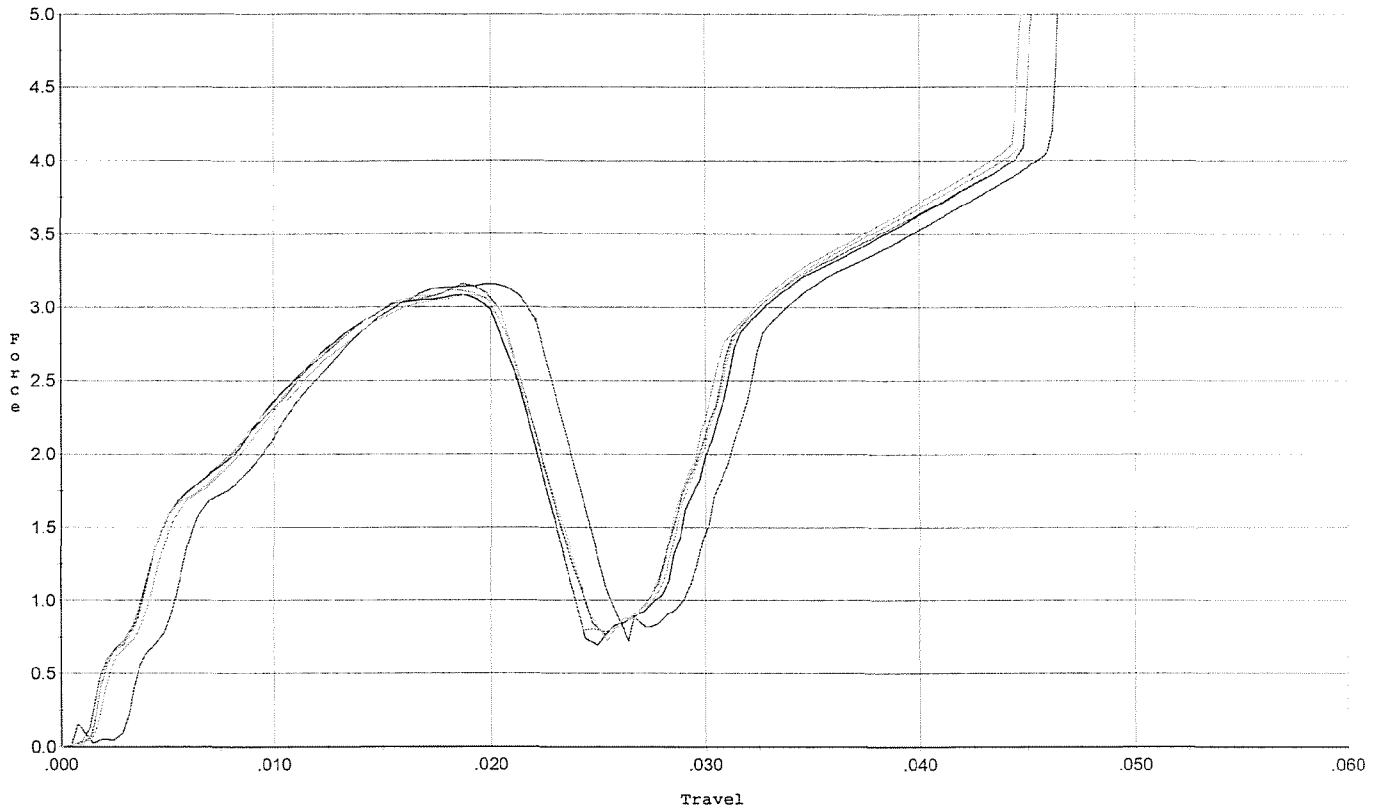
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.480      | 0.020             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 2 | 2.515      | 0.018             | 0.00            | 0.029      | 0.034             |           | Set Trigger |
| 3 | 2.670      | 0.020             | 0.00            | 0.028      | 0.038             |           | Set Trigger |
| 4 | 2.707      | 0.020             | 0.00            | 0.029      | 0.037             |           | Set Trigger |
| 5 | 2.539      | 0.018             | 0.00            | 0.029      | 0.033             |           | Set Trigger |

A-2-58

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



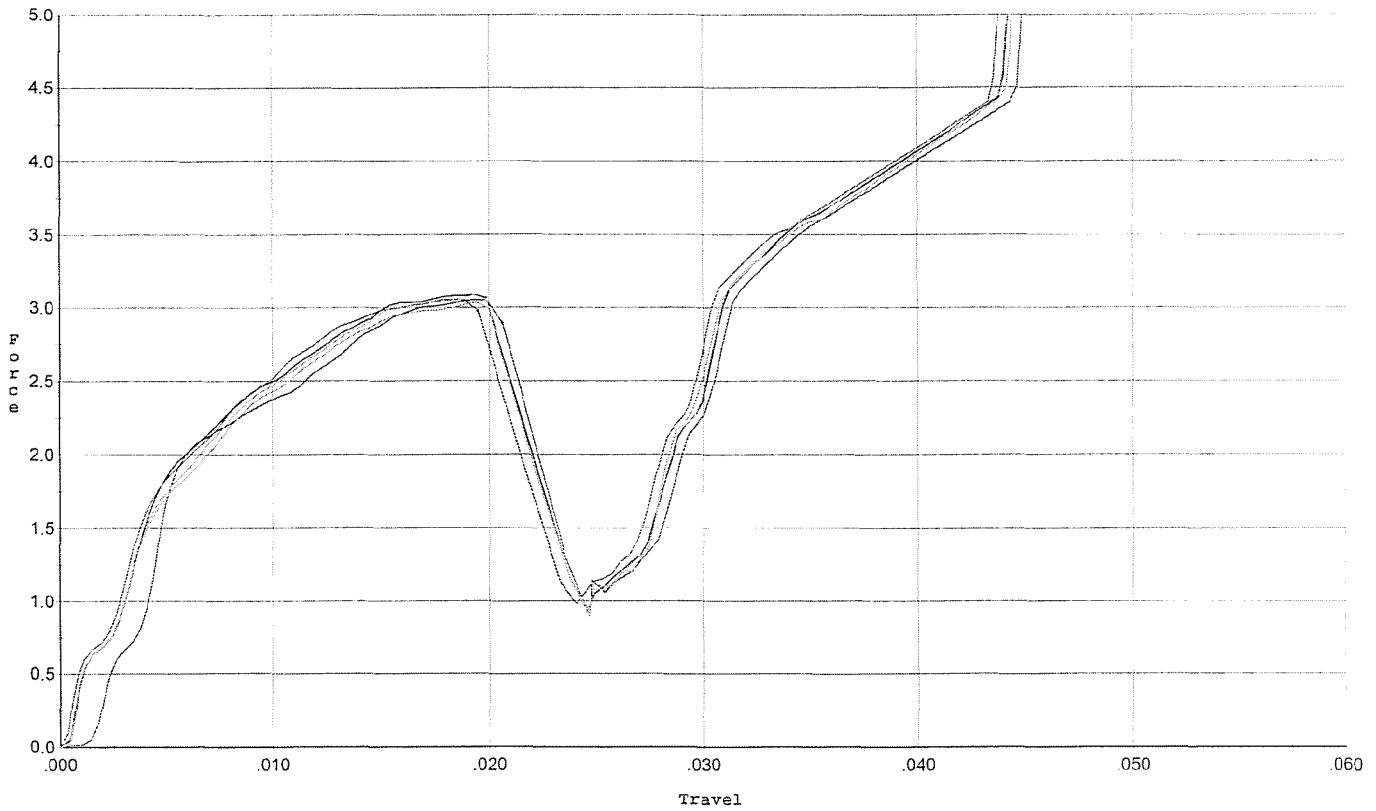
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.155      | 0.022             | 0.00            | 0.028      | 0.043             |           | Set Trigger |
| 2 | 3.082      | 0.021             | 0.00            | 0.028      | 0.043             |           | Set Trigger |
| 3 | 3.158      | 0.020             | 0.00            | 0.028      | 0.042             |           | Set Trigger |
| 4 | 3.085      | 0.020             | 0.00            | 0.028      | 0.040             |           | Set Trigger |
| 5 | 3.119      | 0.021             | 0.00            | 0.028      | 0.042             |           | Set Trigger |

A-3.12

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/29/2009

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 | 3.055      | 0.021             | 0.00            | 0.027      | 0.041             |           | Set Trigger |
| 2 | 3.089      | 0.020             | 0.00            | 0.027      | 0.042             |           | Set Trigger |
| 3 | 3.054      | 0.019             | 0.00            | 0.027      | 0.041             |           | Set Trigger |
| 4 | 3.090      | 0.020             | 0.00            | 0.027      | 0.042             |           | Set Trigger |
| 5 | 3.036      | 0.020             | 0.00            | 0.027      | 0.041             |           | Set Trigger |

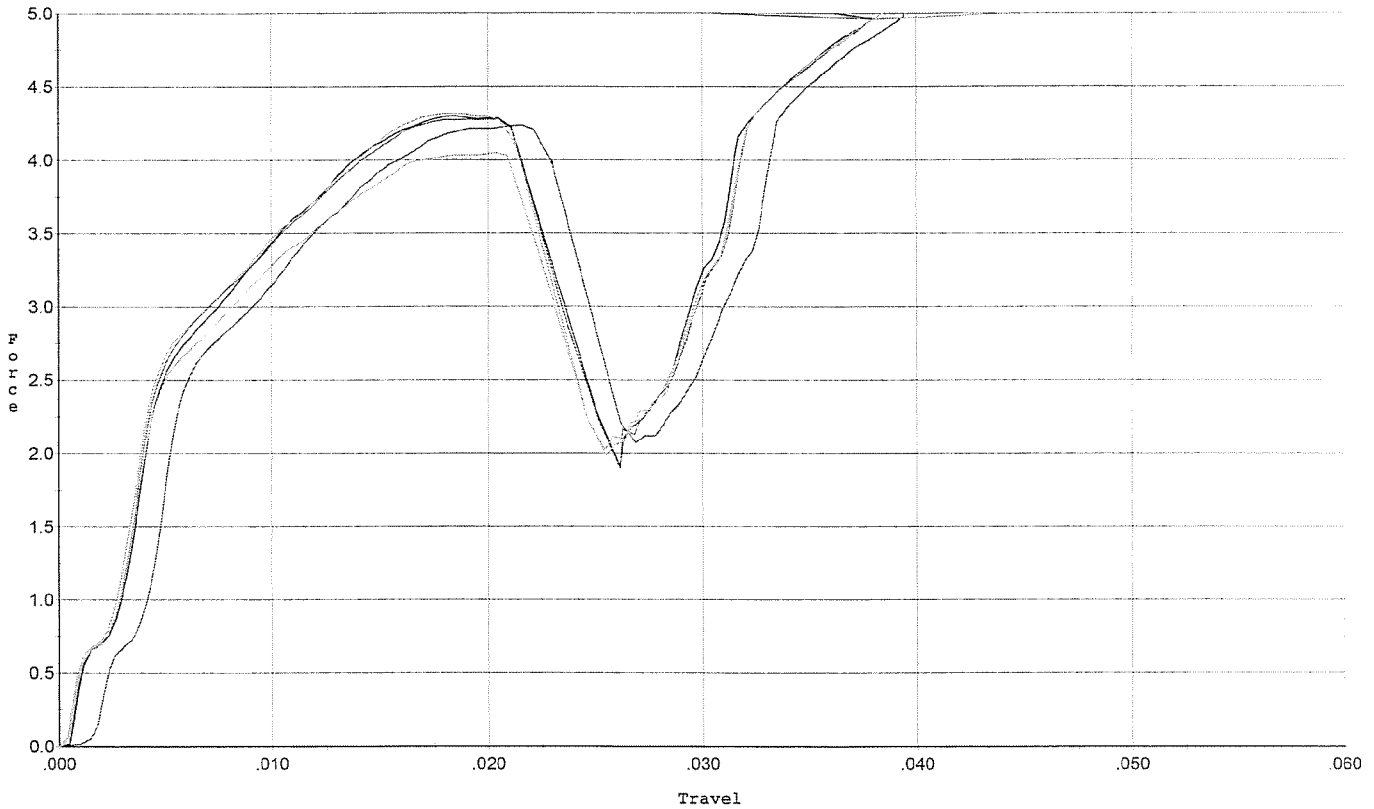
A-3.06



## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



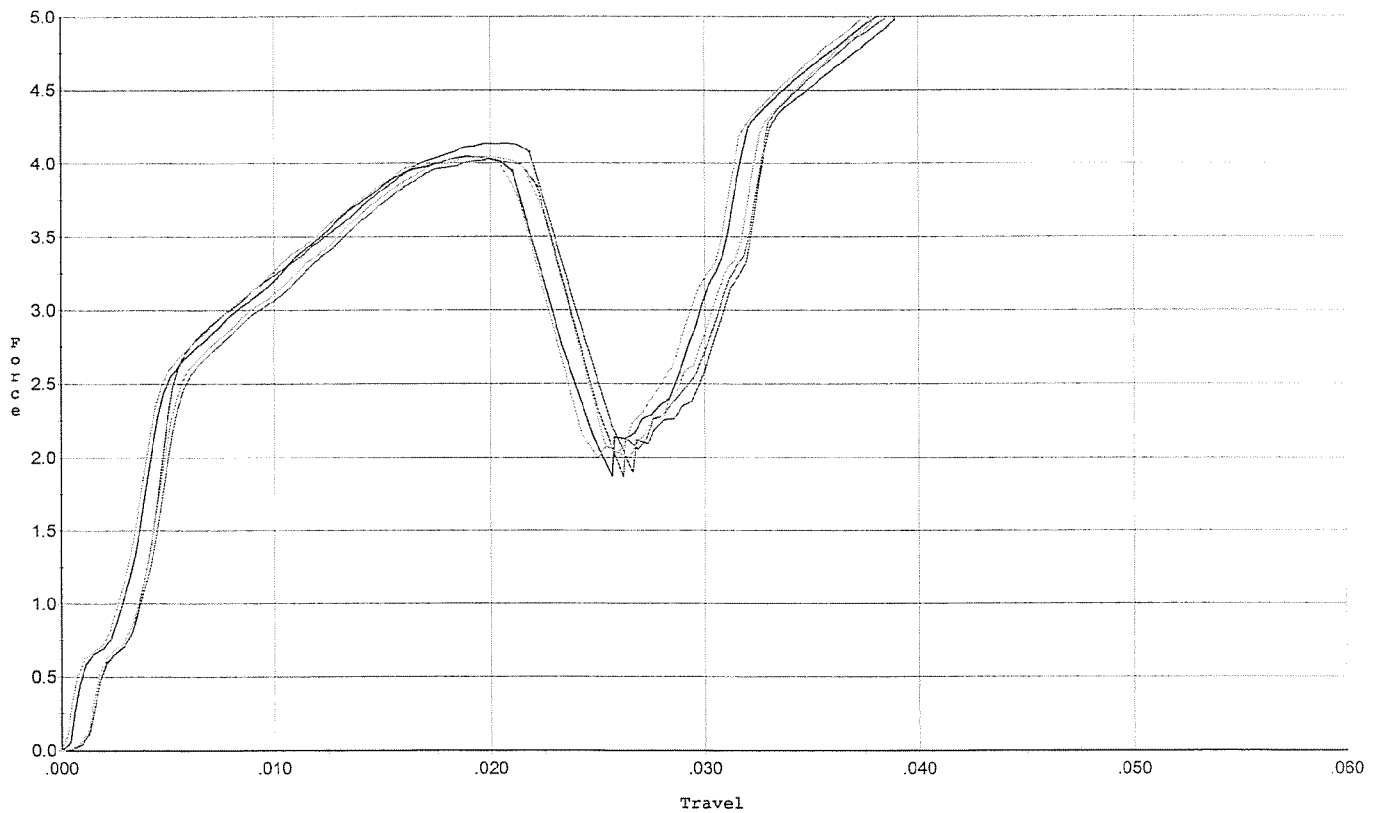
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.238      | 0.023             | 0.00            | 0.020      | 0.063             |           | Set Trigger |
| 2 | 4.301      | 0.021             | 0.00            | 0.020      | 0.061             |           | Set Trigger |
| 3 | 4.278      | 0.021             | 0.00            | 0.020      | 0.061             |           | Set Trigger |
| 4 | 4.050      | 0.022             | 0.00            | 0.020      | 0.062             |           | Set Trigger |
| 5 | 4.318      | 0.021             | 0.00            | 0.020      | 0.062             |           | Set Trigger |

A 4.23

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



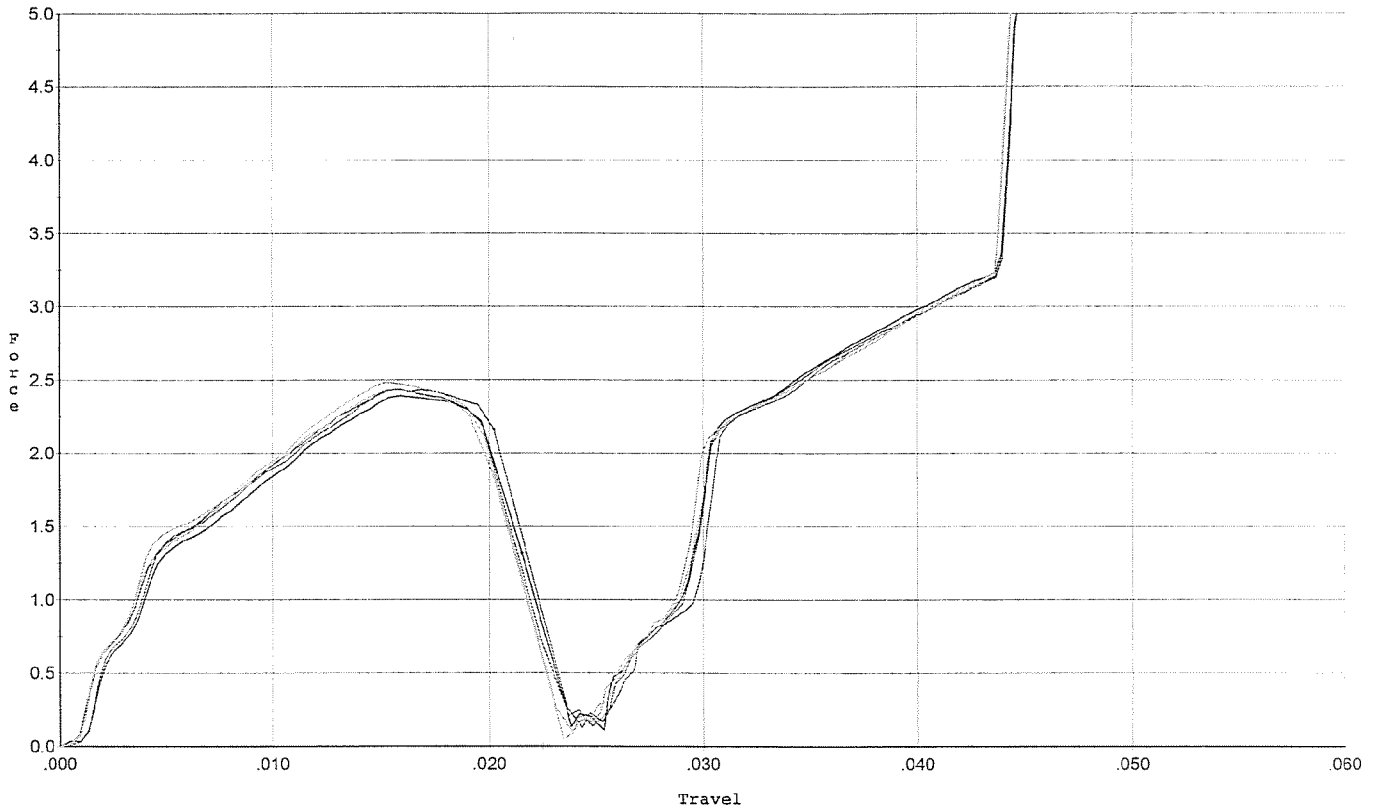
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.137      | 0.022             | 0.00            | 0.021      | 0.060             |           | Set Trigger |
| 2 | 4.048      | 0.021             | 0.00            | 0.021      | 0.058             |           | Set Trigger |
| 3 | 4.026      | 0.022             | 0.00            | 0.020      | 0.059             |           | Set Trigger |
| 4 | 4.047      | 0.022             | 0.00            | 0.020      | 0.060             |           | Set Trigger |
| 5 | 4.041      | 0.021             | 0.00            | 0.020      | 0.059             |           | Set Trigger |

A.4.06

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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



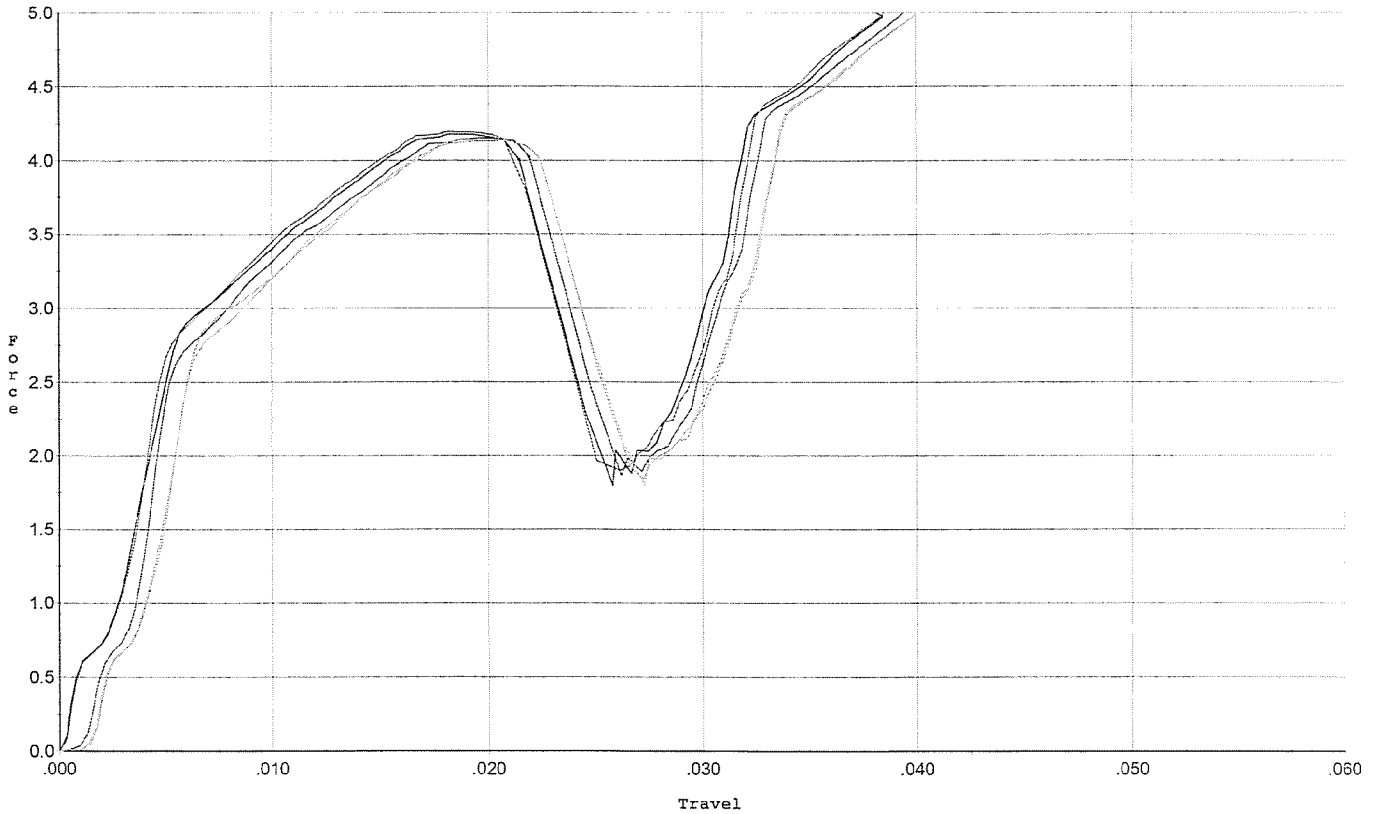
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.431      | 0.020             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 2 | 2.391      | 0.021             | 0.00            | 0.029      | 0.034             |           | Set Trigger |
| 3 | 2.436      | 0.020             | 0.00            | 0.030      | 0.032             |           | Set Trigger |
| 4 | 2.433      | 0.020             | 0.00            | 0.029      | 0.033             |           | Set Trigger |
| 5 | 2.483      | 0.020             | 0.00            | 0.029      | 0.033             |           | Set Trigger |

A. 2.43

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/29/2009

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 | 4.152      | 0.022             | 0.00            | 0.021      | 0.061             |           | Set Trigger |
| 2 | 4.179      | 0.021             | 0.00            | 0.020      | 0.061             |           | Set Trigger |
| 3 | 4.195      | 0.022             | 0.00            | 0.020      | 0.063             |           | Set Trigger |
| 4 | 4.134      | 0.022             | 0.00            | 0.021      | 0.061             |           | Set Trigger |
| 5 | 4.135      | 0.022             | 0.00            | 0.021      | 0.061             |           | Set Trigger |

A-4.15