

G6778817

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



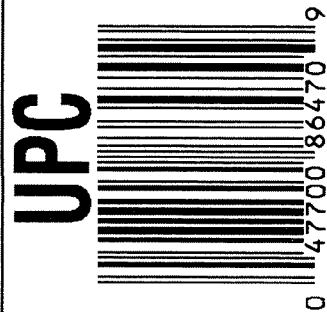
**BM FORM**

**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6778817**



M-24  
INSPECTION CHECKLIST-NEW GUNS

2

GUN SERIAL # G 6778817

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 8-19-08 | S.P.D.  |
| 430  | ASSEMBLE TO STOCK                                              |                     | 8-19-08 | SP      |
| 440  | PROOF                                                          |                     | 8-19-08 | S.P.D.  |
| 460  | CHECK HEADSPACE                                                |                     | 8-19-08 | S.P.D.  |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 8-19-08 | S.P.D.  |
| 472  | SERIALIZE BOLT HANDLE                                          | MAGNA - FLUX        | 8-20-08 | RTZ     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   | AUG 21 2008         | 8-20-08 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR BH         | 8-21-08 | BH      |
| 490  | MAGNAFLUX BOLT                                                 |                     |         |         |
| 500  | ROLLMARK CALIBER                                               |                     | 8/22/08 | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 8/25/08 | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 8-26    | cm      |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 8-27-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 8-27-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 8-27-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 9-3-08  | RTZ     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

F004 REV 5/2006

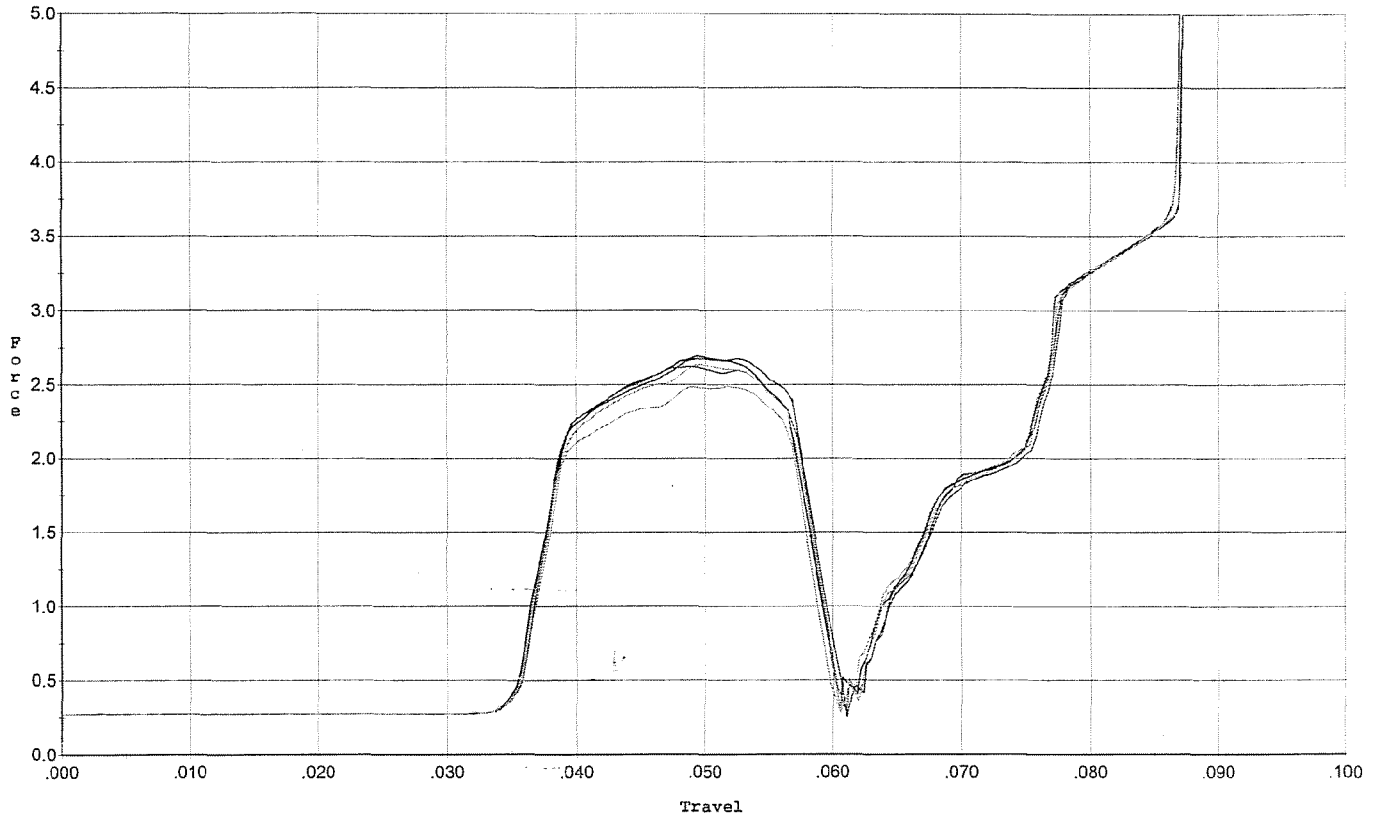
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>3</u> <u>3.5</u> <u>3</u>                                | 9-16-08  | TL      |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>6.5</u> <u>6</u> <u>6</u>                                | 9-16-08  | TL      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.025</u> <u>.024</u> <u>.025</u>                         | 9-16-08  | TL      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 9-3-08   | RJC     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 9-16-08  | TL      |
|              | 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> FAIL<br><u>PASS</u> FAIL                        | 9-8-08   | FM      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION N.A                                              |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 9-8-08   | TCE     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 9-16-08  | TL      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.35</u> <u>2.06</u> <u>2.08</u> <u>2.28</u> <u>2.10</u> | 9-9-08   | BSN     |
|              | C) FUNCTION                                                              |                                                             | 9-16-08  | TL      |
| 690          | PACK                                                                     |                                                             | 10/24/08 | FM      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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



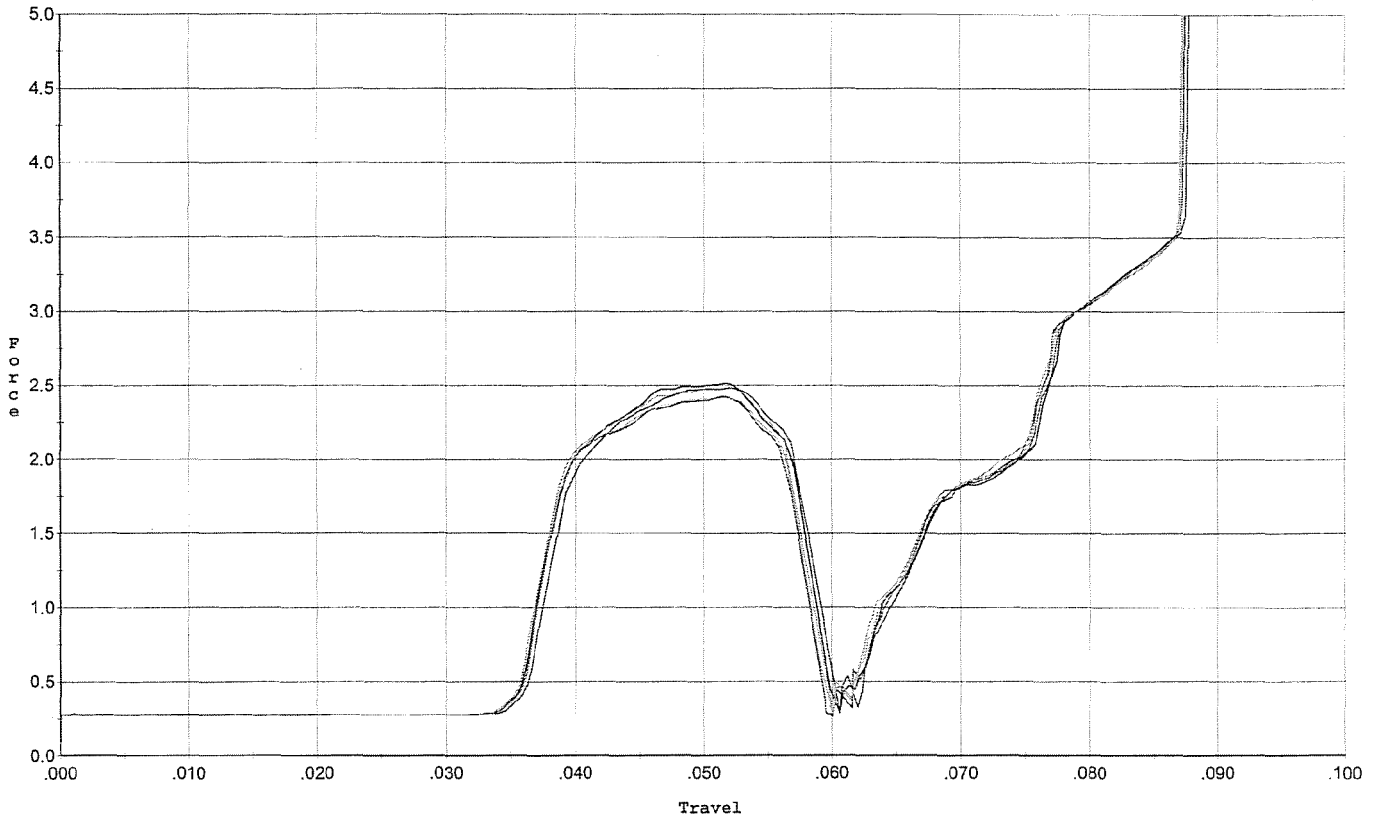
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.677      | 0.057             | 0.035           | 0.036      | 0.061             |           | Set Trigger |
| 2 | 2.694      | 0.058             | 0.035           | 0.035      | 0.062             |           | Set Trigger |
| 3 | 2.619      | 0.057             | 0.036           | 0.036      | 0.060             |           | Set Trigger |
| 4 | 2.640      | 0.058             | 0.036           | 0.036      | 0.060             |           | Set Trigger |
| 5 | 2.488      | 0.057             | 0.036           | 0.036      | 0.057             |           | Set Trigger |

Avg 2.62

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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



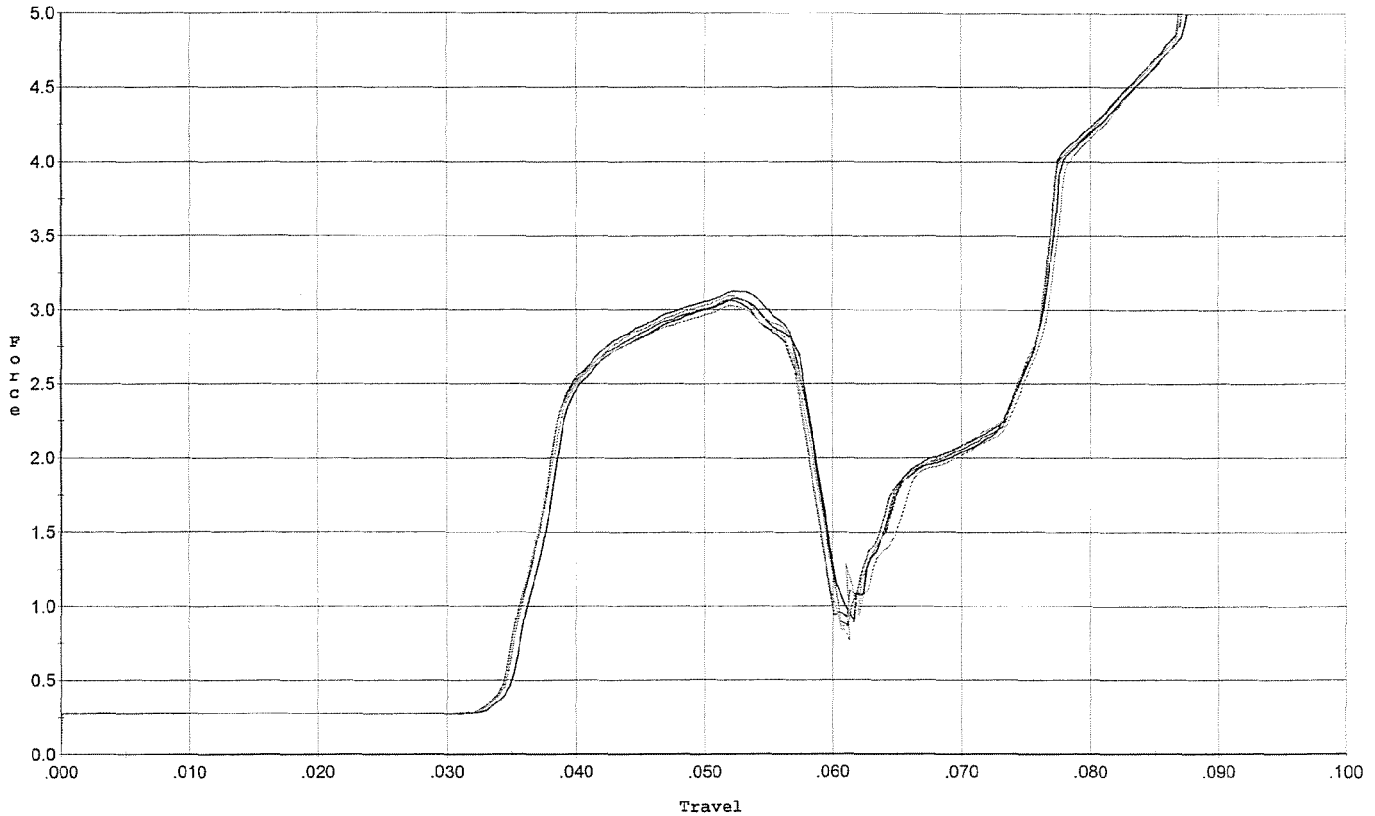
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.484      | 0.058             | 0.036           | 0.036      | 0.057             |           | Set Trigger |
| 2 | 2.514      | 0.057             | 0.036           | 0.036      | 0.056             |           | Set Trigger |
| 3 | 2.421      | 0.057             | 0.036           | 0.036      | 0.054             |           | Set Trigger |
| 4 | 2.430      | 0.056             | 0.036           | 0.036      | 0.054             |           | Set Trigger |
| 5 | 2.501      | 0.056             | 0.036           | 0.036      | 0.055             |           | Set Trigger |

Avg 2.47

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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



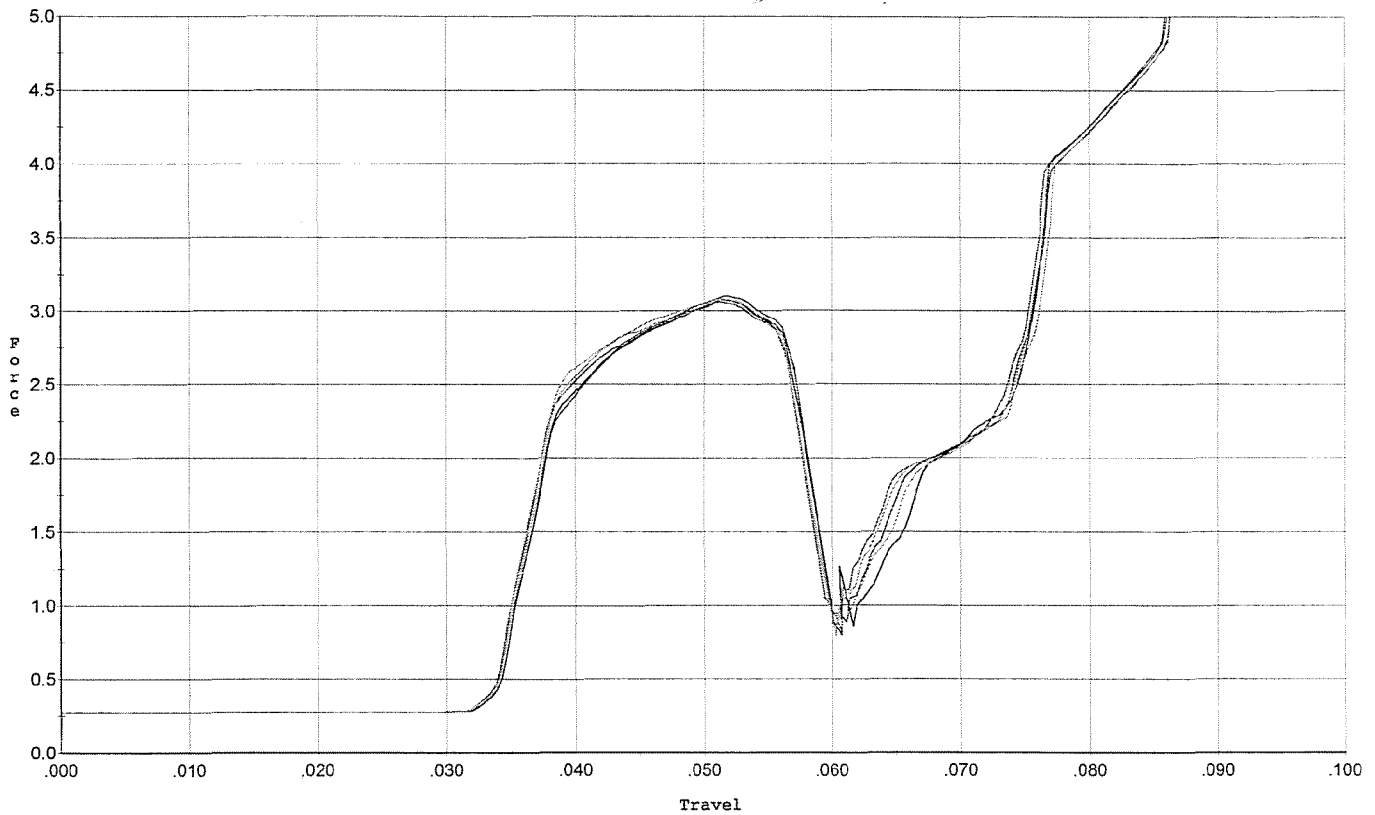
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.128      | 0.058             | 0.035           | 0.034      | 0.071             |           | Set Trigger |
| 2 | 3.077      | 0.057             | 0.035           | 0.035      | 0.069             |           | Set Trigger |
| 3 | 3.066      | 0.057             | 0.034           | 0.035      | 0.069             |           | Set Trigger |
| 4 | 3.032      | 0.057             | 0.035           | 0.035      | 0.068             |           | Set Trigger |
| 5 | 3.092      | 0.059             | 0.035           | 0.034      | 0.071             |           | Set Trigger |

Avg 3.07

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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 | 3.103      | 0.057             | 0.034           | 0.034      | 0.070             |           | Set Trigger |
| 2 | 3.073      | 0.058             | 0.034           | 0.034      | 0.070             |           | Set Trigger |
| 3 | 3.060      | 0.056             | 0.034           | 0.034      | 0.069             |           | Set Trigger |
| 4 | 3.084      | 0.056             | 0.034           | 0.034      | 0.069             |           | Set Trigger |
| 5 | 3.077      | 0.056             | 0.034           | 0.034      | 0.069             |           | Set Trigger |

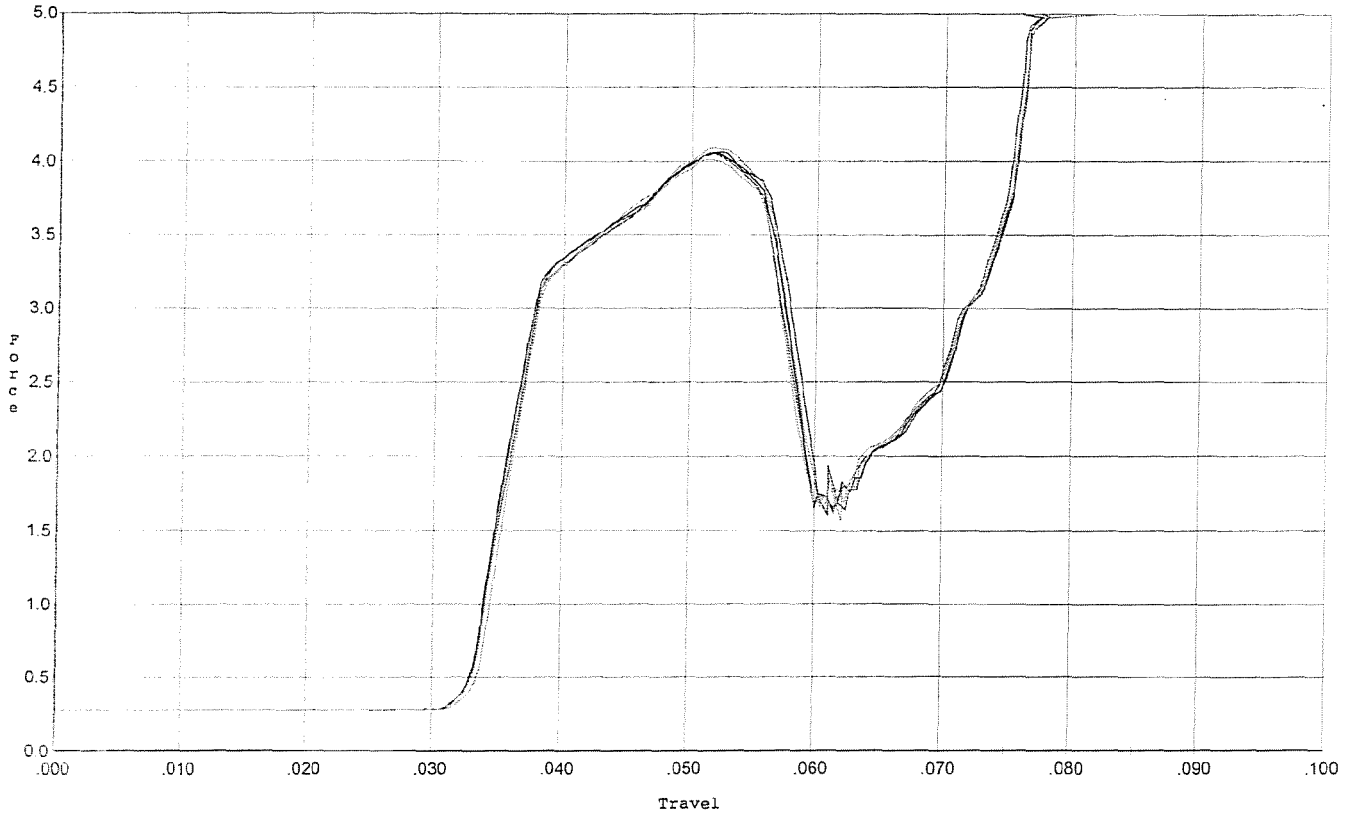
Avg 3.07



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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



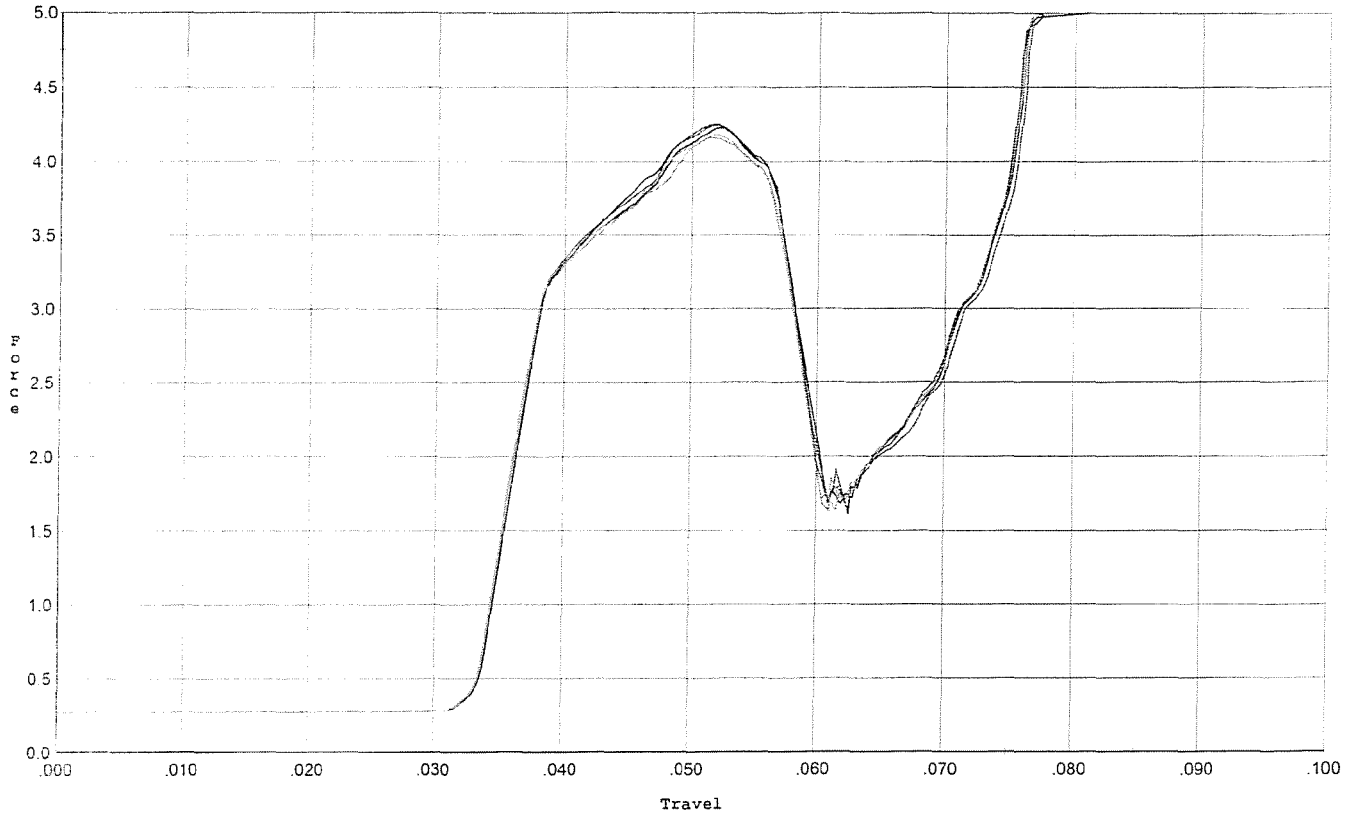
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.064      | 0.058             | 0.033           | 0.032      | 0.091             |           | Set Trigger |
| 2 | 4.058      | 0.057             | 0.033           | 0.032      | 0.090             |           | Set Trigger |
| 3 | 4.057      | 0.056             | 0.033           | 0.033      | 0.087             |           | Set Trigger |
| 4 | 4.015      | 0.056             | 0.033           | 0.033      | 0.087             |           | Set Trigger |
| 5 | 4.093      | 0.056             | 0.033           | 0.033      | 0.088             |           | Set Trigger |

Avg 4.05

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

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



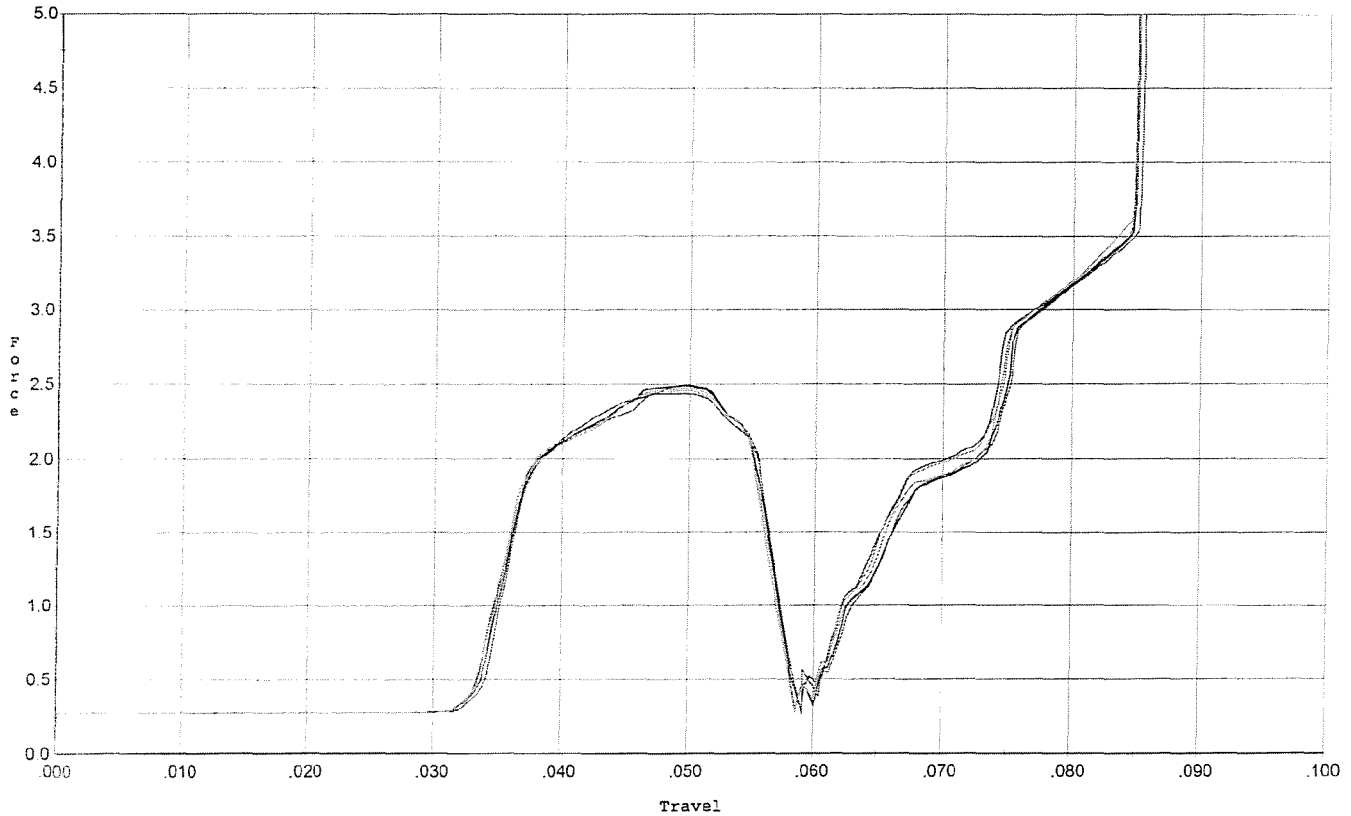
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.250      | 0.057             | 0.033           | 0.032      | 0.092             |           | Set Trigger |
| 2 | 4.227      | 0.057             | 0.033           | 0.032      | 0.091             |           | Set Trigger |
| 3 | 4.245      | 0.057             | 0.033           | 0.032      | 0.092             |           | Set Trigger |
| 4 | 4.178      | 0.057             | 0.033           | 0.032      | 0.091             |           | Set Trigger |
| 5 | 4.161      | 0.057             | 0.033           | 0.032      | 0.092             |           | Set Trigger |

Avg 4.21

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/20/08

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



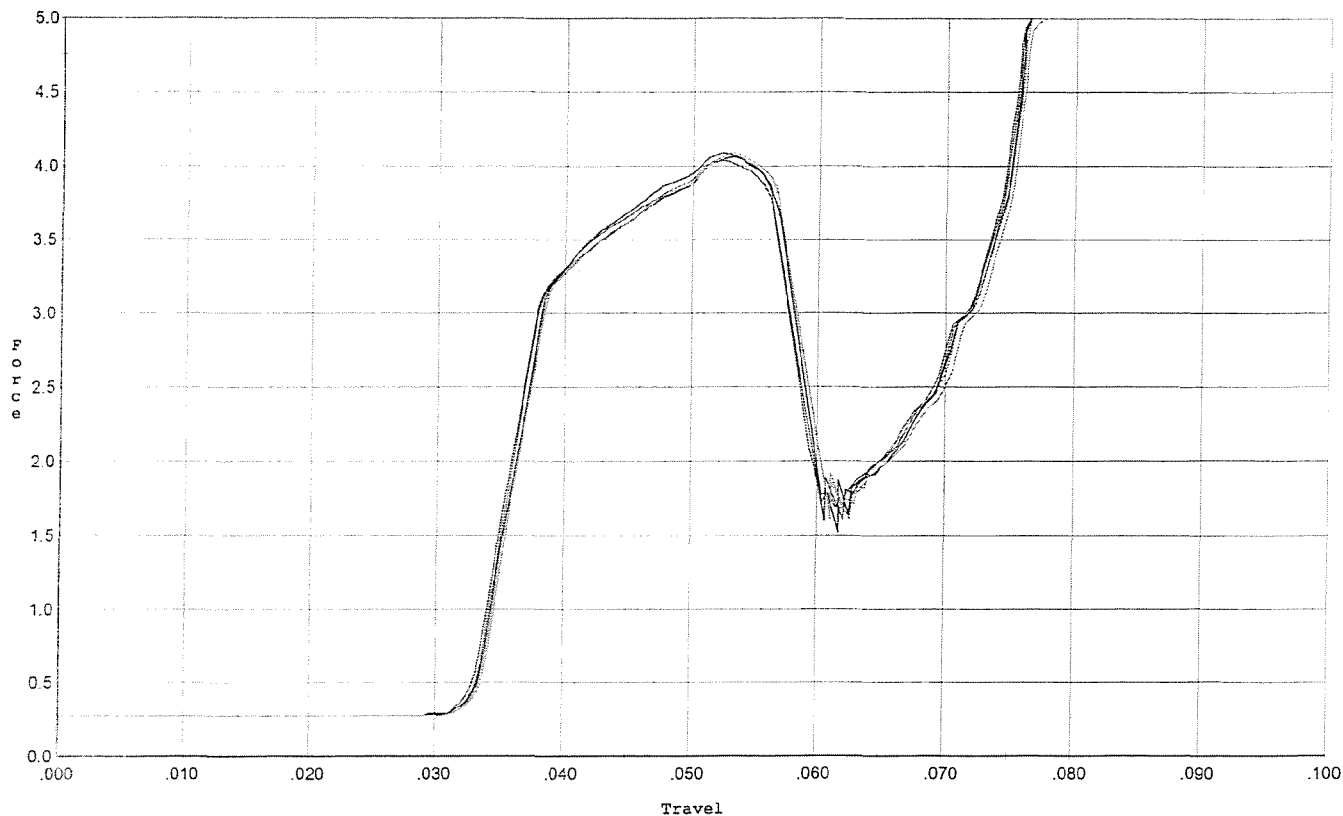
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.493      | 0.055             | 0.033           | 0.035      | 0.056             |           | Set Trigger |
| 2 | 2.489      | 0.056             | 0.034           | 0.035      | 0.056             |           | Set Trigger |
| 3 | 2.436      | 0.055             | 0.034           | 0.035      | 0.055             |           | Set Trigger |
| 4 | 2.457      | 0.055             | 0.034           | 0.035      | 0.055             |           | Set Trigger |
| 5 | 2.472      | 0.056             | 0.034           | 0.035      | 0.056             |           | Set Trigger |

Avg 2.46

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/20/08

Model: M/24  
Serial No: Form #F005  
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.089      | 0.056             | 0.033           | 0.032      | 0.089             |           | Set Trigger |
| 2 | 4.066      | 0.057             | 0.033           | 0.032      | 0.090             |           | Set Trigger |
| 3 | 4.039      | 0.056             | 0.033           | 0.032      | 0.089             |           | Set Trigger |
| 4 | 4.058      | 0.057             | 0.033           | 0.032      | 0.089             |           | Set Trigger |
| 5 | 4.093      | 0.059             | 0.033           | 0.032      | 0.093             |           | Set Trigger |

Avg 4.06