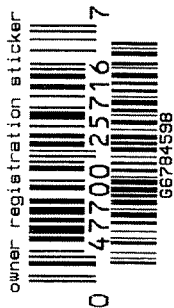


66784598

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

- INSTRUCTION BOOK 3518

**BM FORM**



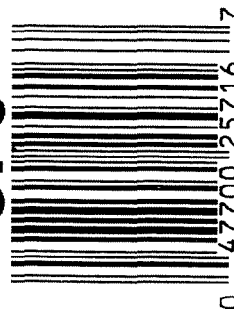
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6784598**

**UPC**



**M-24**  
**INSPECTION CHECKLIST-NEW GUNS**

GUN SERIAL #

G 6784598

| OP # | OPERATION NAME                                                                                                                         | READINGS     | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |              | 9-29-08  | SP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |              | 9-29-08  | SP      |
| 440  | PROOF                                                                                                                                  |              | 9-29-08  | SP      |
| 460  | CHECK HEADSPACE                                                                                                                        |              | 9-29-08  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |              | 9-29-08  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX | 9-30-08  | RTZ     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | 2008         | 9-30-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR (H) | 10/7/08  | (H)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |              |          |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |              | 10/2/08  | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |              | 10/3/08  | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |              | 10 9     | c       |
| 545  | (BOLT)                                                                                                                                 |              |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |              |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |              | 10-10-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |              | 10-10-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |              | 10-10-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |              | 10-31-08 | SP      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |              |          |         |

F004 REV 5/2006

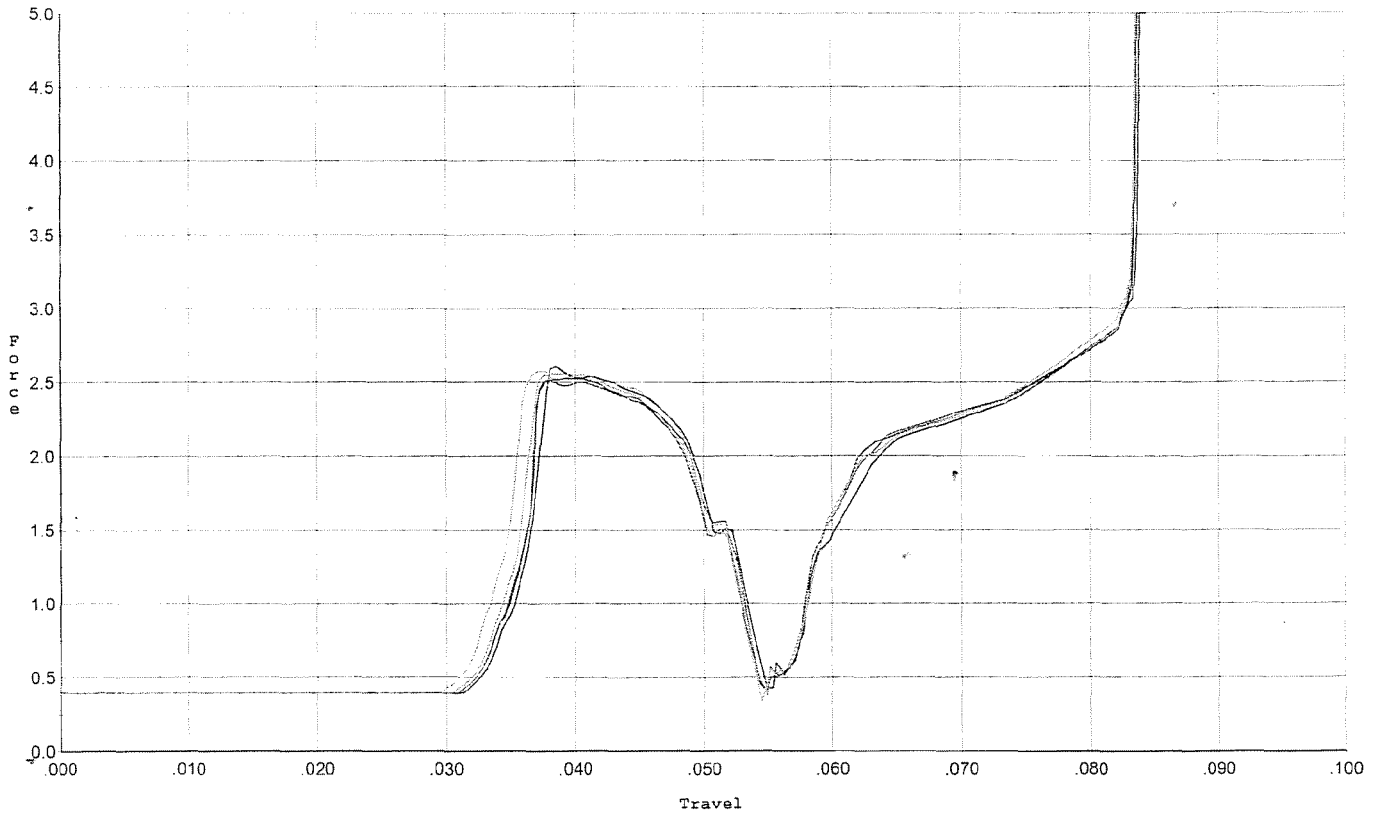
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>3.0</u> <u>3.0</u> <u>3.5</u>                            | 11-11-08 | LJD     |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.0</u> <u>4.0</u> <u>4.0</u>                            | 11-11-08 | LJD     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.033</u> <u>.033</u> <u>.033</u>                         | 11-11-08 | LJD     |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 10-31-08 | LJD     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 11-11-08 | LJD     |
|              | 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                        | 11-3-08  | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 11-3-08  | LJD     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 11-11-08 | LJD     |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.56</u> <u>2.32</u> <u>2.43</u> <u>2.32</u> <u>2.30</u> | 11-5-08  | Fm      |
|              | C) FUNCTION                                                              |                                                             | 11-11-08 | LJD     |
| 690          | PACK                                                                     |                                                             | 11/11/08 | Fm      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



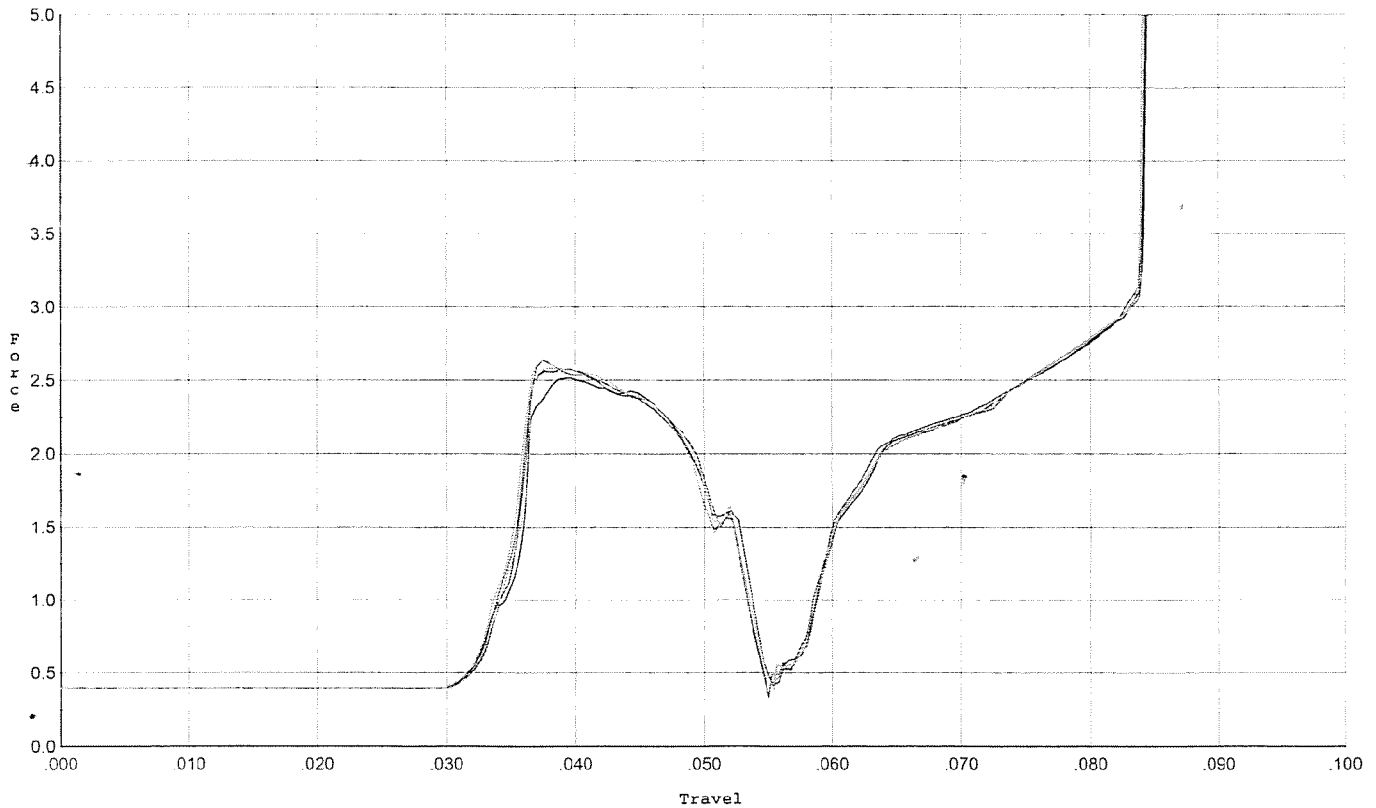
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.528      | 0.053             | 0.033           | 0.037      | 0.052             |           | Set Trigger |
| 2 | 2.610      | 0.052             | 0.034           | 0.037      | 0.051             |           | Set Trigger |
| 3 | 2.516      | 0.052             | 0.033           | 0.037      | 0.050             |           | Set Trigger |
| 4 | 2.570      | 0.053             | 0.032           | 0.035      | 0.055             |           | Set Trigger |
| 5 | 2.550      | 0.052             | 0.033           | 0.036      | 0.052             |           | Set Trigger |

Avg 2.55

## Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/27/08

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



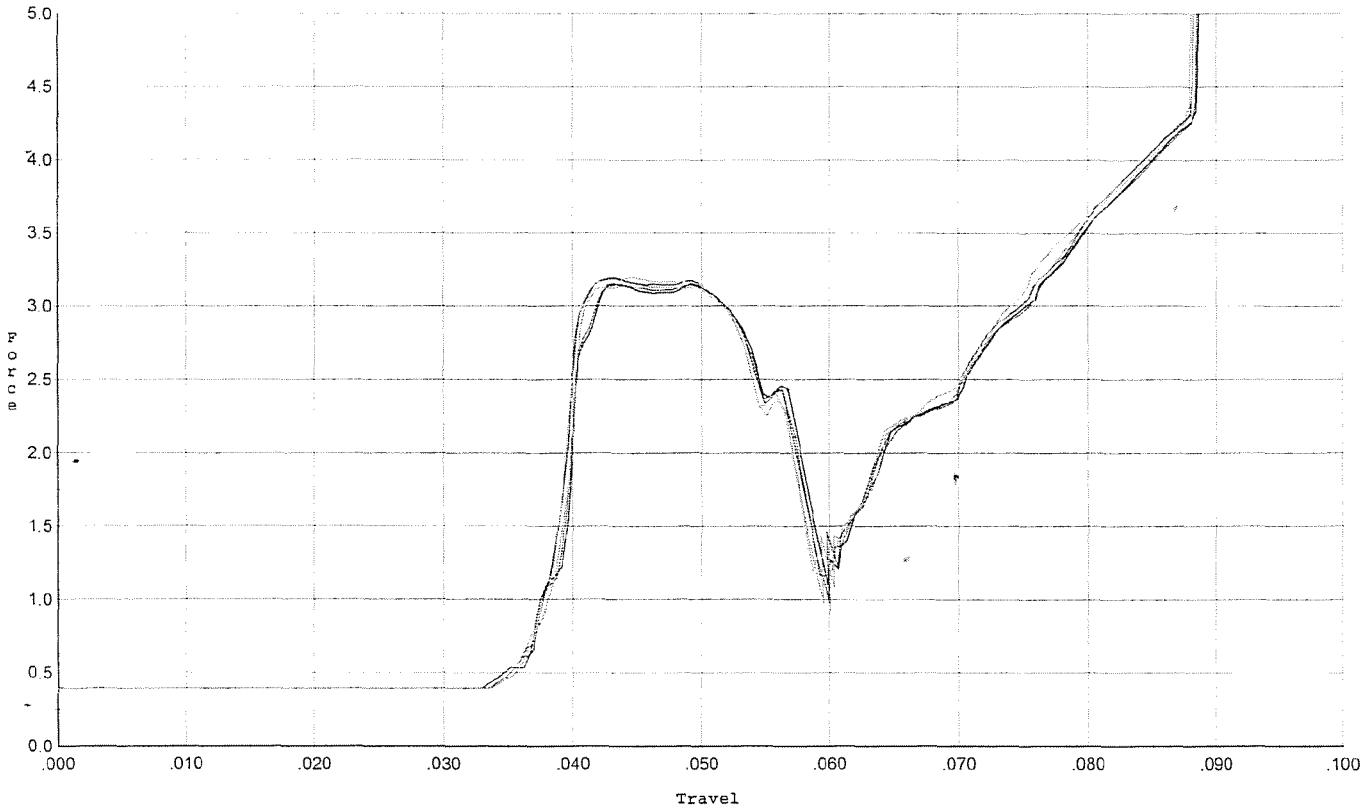
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.574      | 0.052             | 0.033           | 0.036      | 0.053             |           | Set Trigger |
| 2 | 2.515      | 0.053             | 0.033           | 0.036      | 0.053             |           | Set Trigger |
| 3 | 2.639      | 0.053             | 0.033           | 0.036      | 0.054             |           | Set Trigger |
| 4 | 2.633      | 0.052             | 0.033           | 0.036      | 0.054             |           | Set Trigger |
| 5 | 2.584      | 0.052             | 0.033           | 0.036      | 0.053             |           | Set Trigger |

Avg 2.58

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



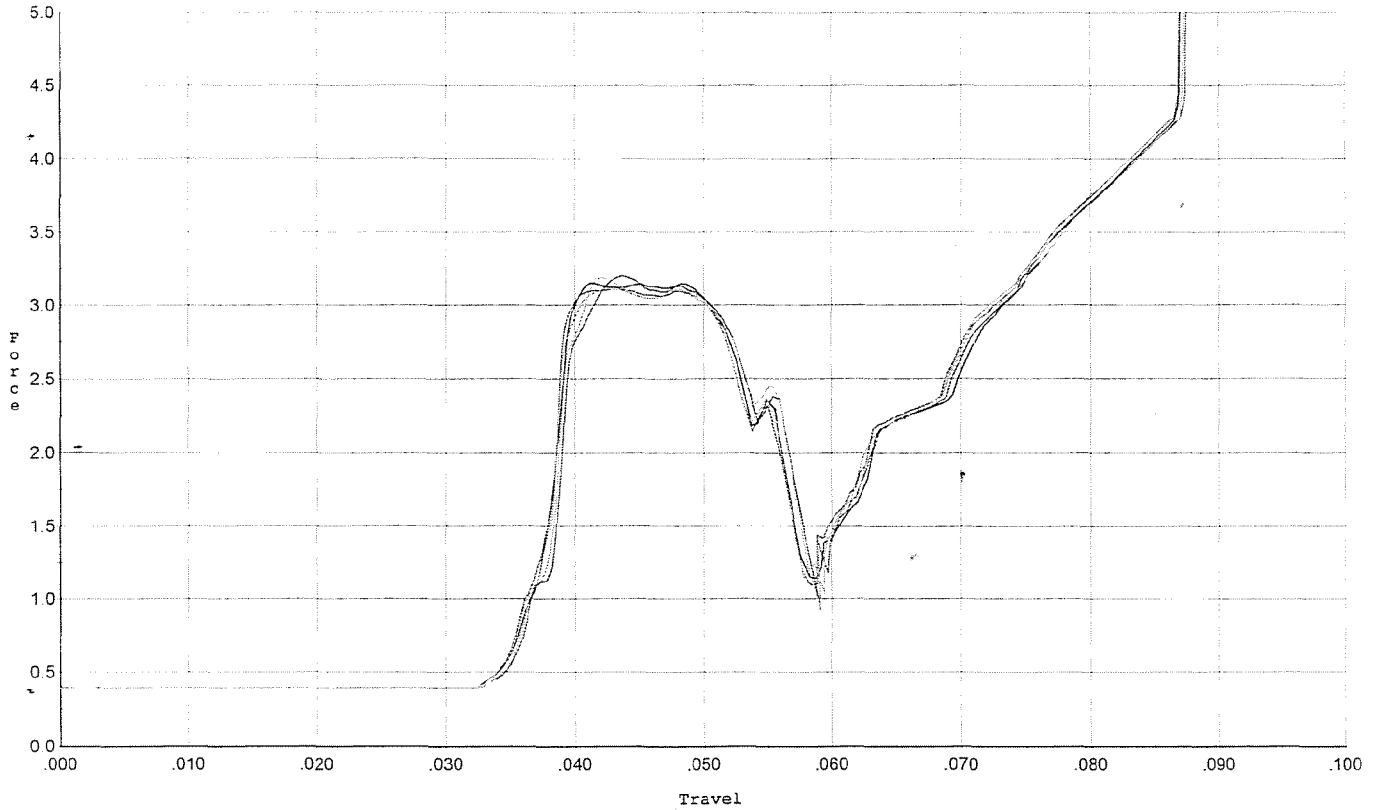
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.196      | 0.058             | 0.037           | 0.037      | 0.071             |           | Set Trigger |
| 2 | 3.155      | 0.057             | 0.037           | 0.037      | 0.068             |           | Set Trigger |
| 3 | 3.149      | 0.057             | 0.036           | 0.036      | 0.069             |           | Set Trigger |
| 4 | 3.196      | 0.057             | 0.036           | 0.036      | 0.069             |           | Set Trigger |
| 5 | 3.140      | 0.057             | 0.037           | 0.037      | 0.067             |           | Set Trigger |

Avg 3.16

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



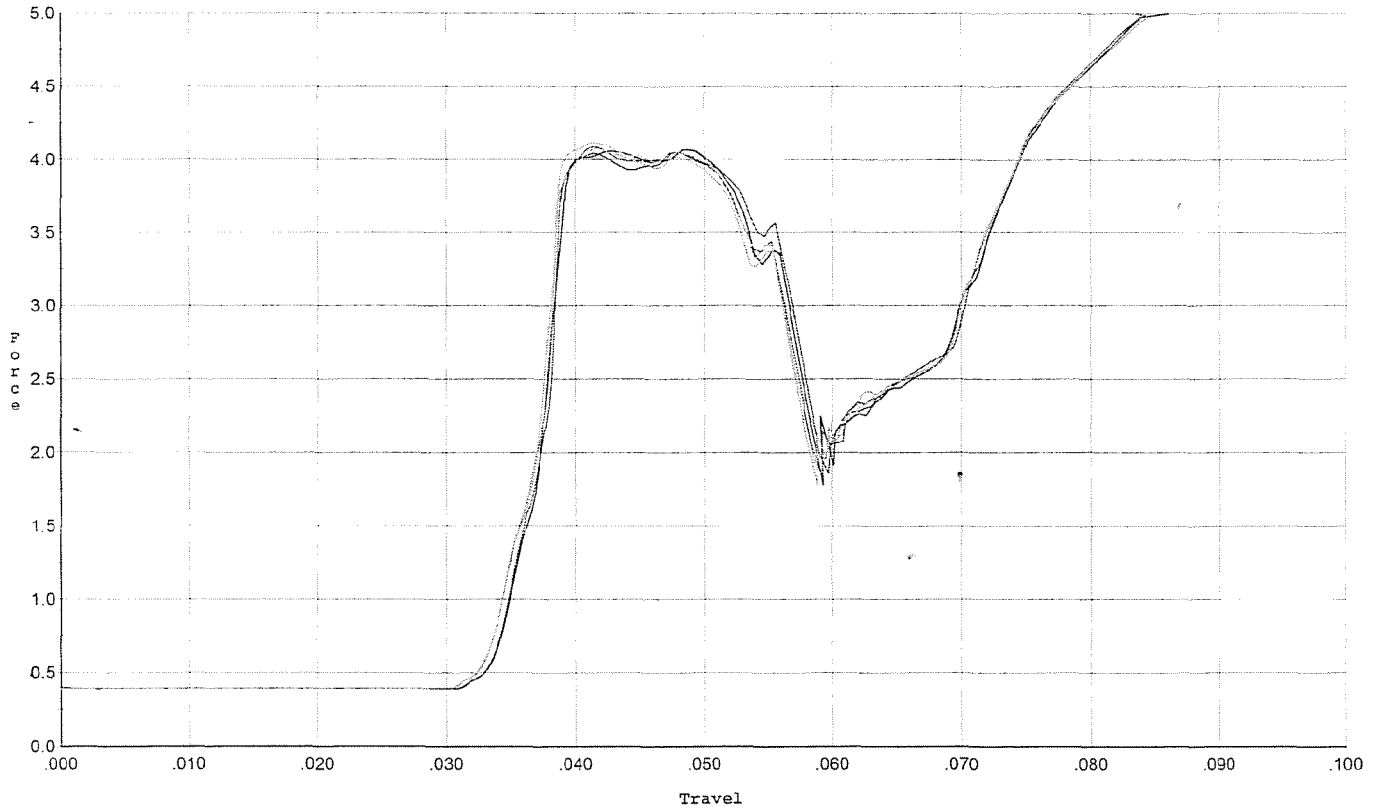
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.201      | 0.056             | 0.036           | 0.036      | 0.067             |           | Set Trigger |
| 2 | 3.153      | 0.056             | 0.035           | 0.036      | 0.068             |           | Set Trigger |
| 3 | 3.107      | 0.056             | 0.035           | 0.036      | 0.068             |           | Set Trigger |
| 4 | 3.188      | 0.056             | 0.035           | 0.036      | 0.068             |           | Set Trigger |
| 5 | 3.109      | 0.056             | 0.035           | 0.036      | 0.067             |           | Set Trigger |

Avg 3.15

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



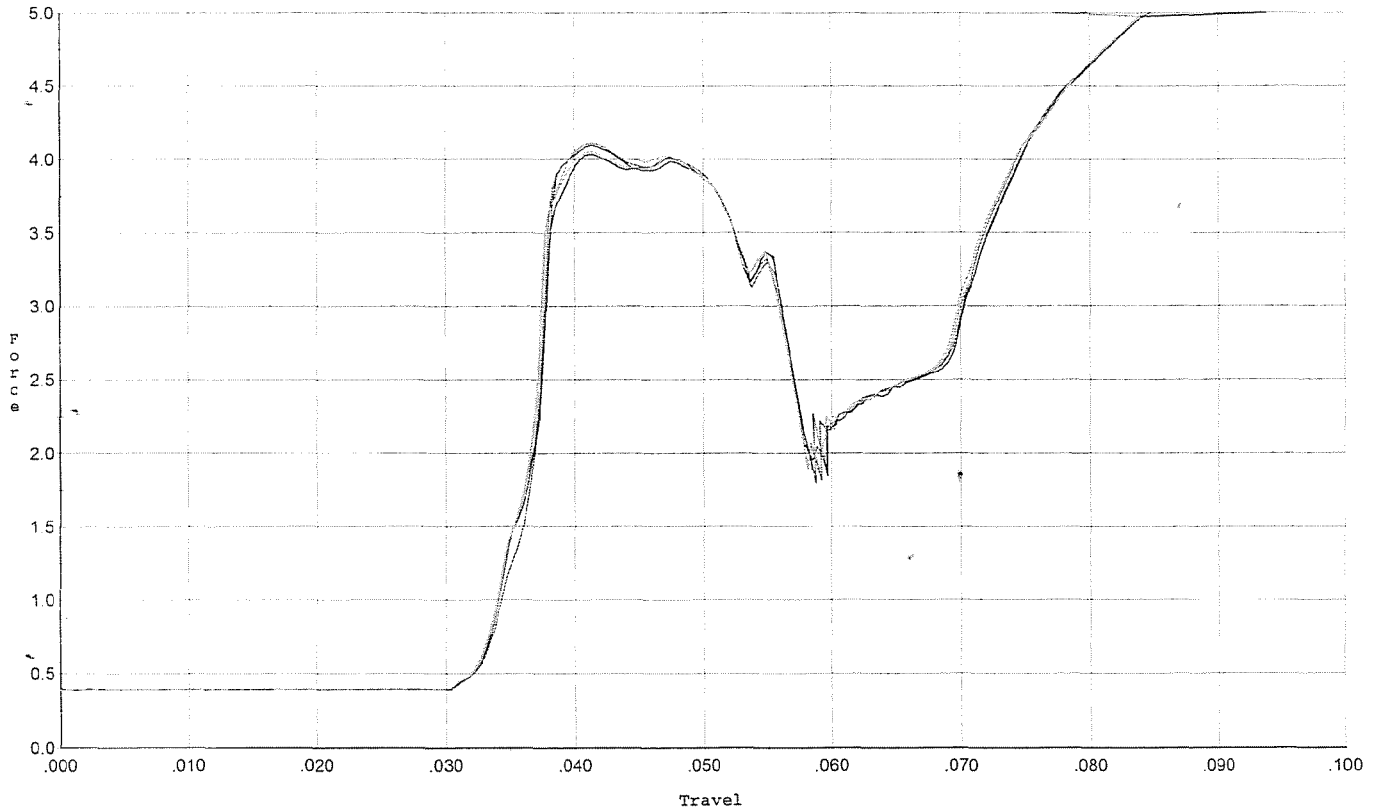
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.050      | 0.057             | 0.034           | 0.034      | 0.092             |           | Set Trigger |
| 2 | 4.068      | 0.056             | 0.034           | 0.035      | 0.090             |           | Set Trigger |
| 3 | 4.088      | 0.057             | 0.033           | 0.034      | 0.092             |           | Set Trigger |
| 4 | 4.117      | 0.055             | 0.033           | 0.034      | 0.089             |           | Set Trigger |
| 5 | 4.079      | 0.055             | 0.033           | 0.034      | 0.088             |           | Set Trigger |

Avg 4.08

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



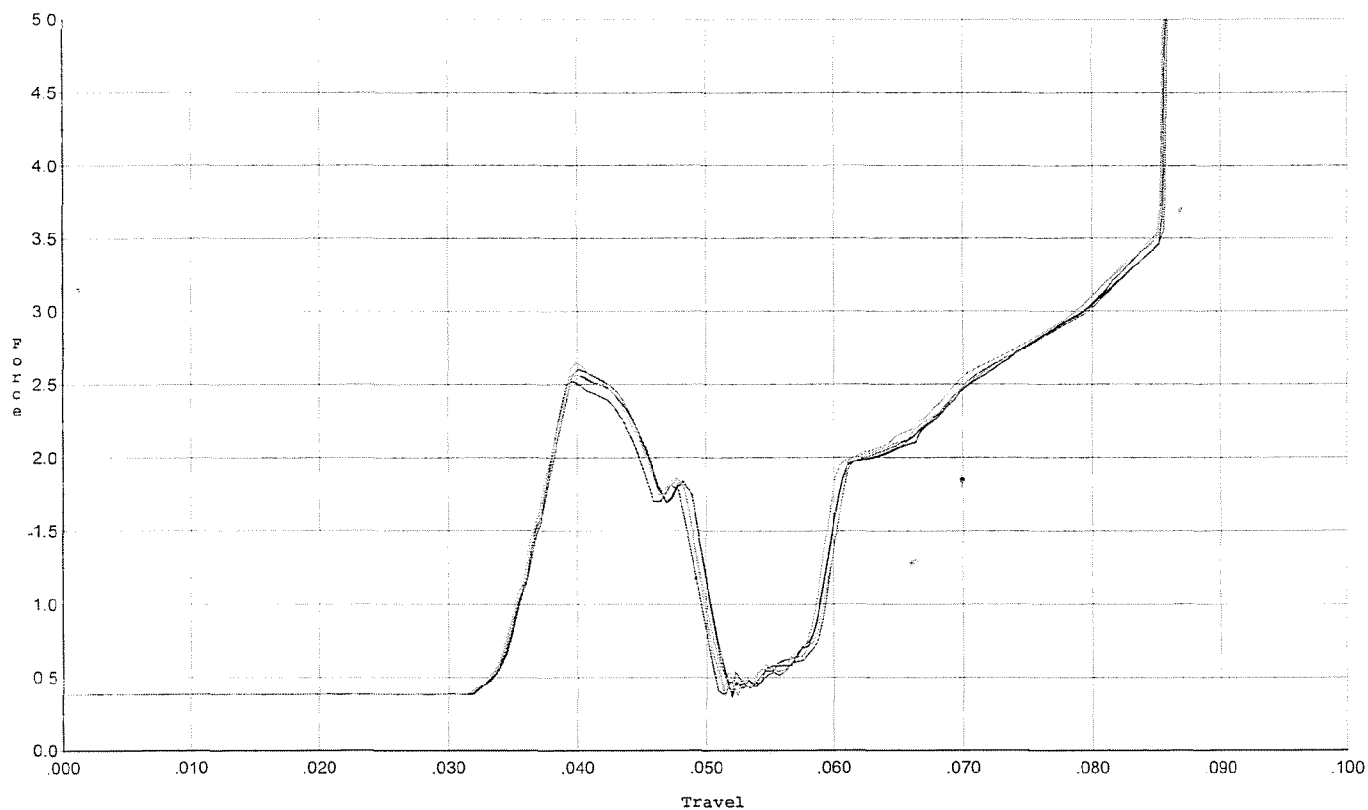
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.093      | 0.056             | 0.033           | 0.034      | 0.089             |           | Set Trigger |
| 2 | 4.034      | 0.055             | 0.033           | 0.034      | 0.089             |           | Set Trigger |
| 3 | 4.109      | 0.056             | 0.033           | 0.034      | 0.090             |           | Set Trigger |
| 4 | 4.055      | 0.056             | 0.033           | 0.034      | 0.090             |           | Set Trigger |
| 5 | 4.115      | 0.056             | 0.033           | 0.034      | 0.091             |           | Set Trigger |

Aug 4.08

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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



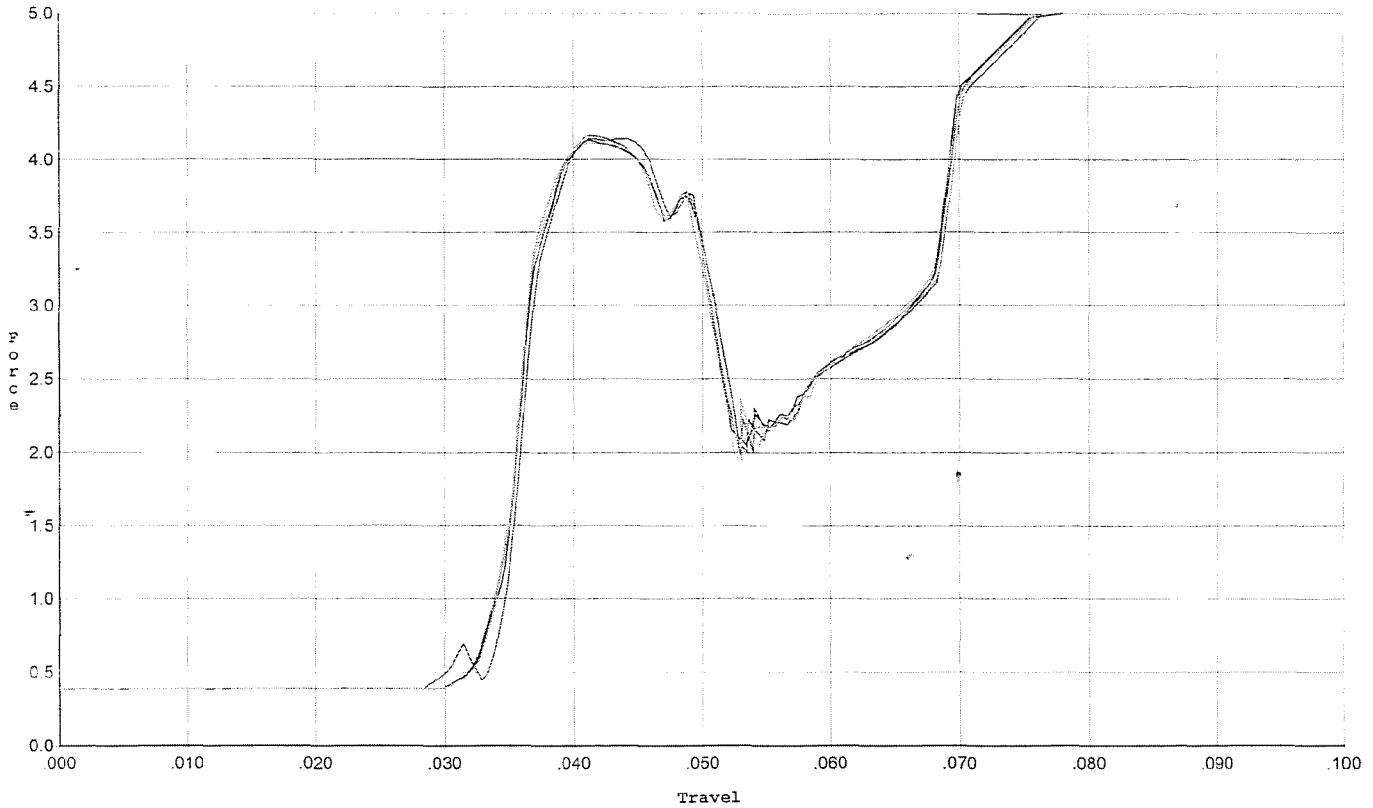
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.522      | 0.049             | 0.034           | 0.040      | 0.042             |           | Set Trigger |
| 2 | 2.563      | 0.049             | 0.034           | 0.040      | 0.042             |           | Set Trigger |
| 3 | 2.604      | 0.049             | 0.034           | 0.040      | 0.043             |           | Set Trigger |
| 4 | 2.653      | 0.048             | 0.034           | 0.040      | 0.042             |           | Set Trigger |
| 5 | 2.563      | 0.048             | 0.034           | 0.040      | 0.042             |           | Set Trigger |

Aug 2.58

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/27/08

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 | 4.145      | 0.051             | 0.031           | 0.036      | 0.074             |           | Set Trigger |
| 2 | 4.136      | 0.050             | 0.033           | 0.036      | 0.071             |           | Set Trigger |
| 3 | 4.168      | 0.049             | 0.033           | 0.036      | 0.072             |           | Set Trigger |
| 4 | 4.118      | 0.049             | 0.033           | 0.036      | 0.072             |           | Set Trigger |
| 5 | 4.165      | 0.050             | 0.033           | 0.036      | 0.073             |           | Set Trigger |

Aug 4.14