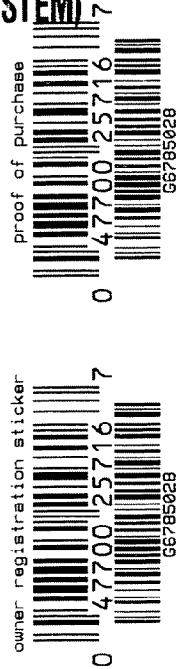


G6785028

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

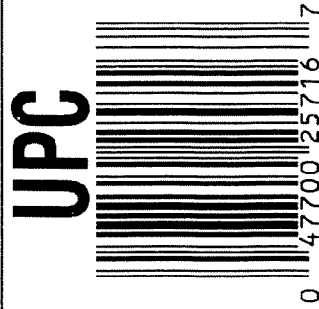
- INSTRUCTION BOOK 3518

**BM FORM**



|               |              |
|---------------|--------------|
| ORDER NO.     | <b>25716</b> |
| BARREL LENGTH | 24"          |
| CAPACITY      | 6            |

**G6785028**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6785028

| OP # | OPERATION NAME                                                                                                                         | READINGS                                    | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                             | 9-29-08 | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                             | 9-29-08 | SP      |
| 440  | PROOF                                                                                                                                  |                                             | 9-29-08 | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        |                                             | 9-29-08 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                             | 9-29-08 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                             | 9-30-08 | RTZ     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                             | 9-30-08 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | MAGNA - FLUX<br>2000<br>OPERATOR <u>(K)</u> | 10/2/08 | (K)     |
| 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 2    |         |
| 545  | (BOLT)                                                                                                                                 |                                             |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                             |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                             | 10-9-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                             | 10-9-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                             | 10-9-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                             | 11-3-08 | BSN     |
|      | 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

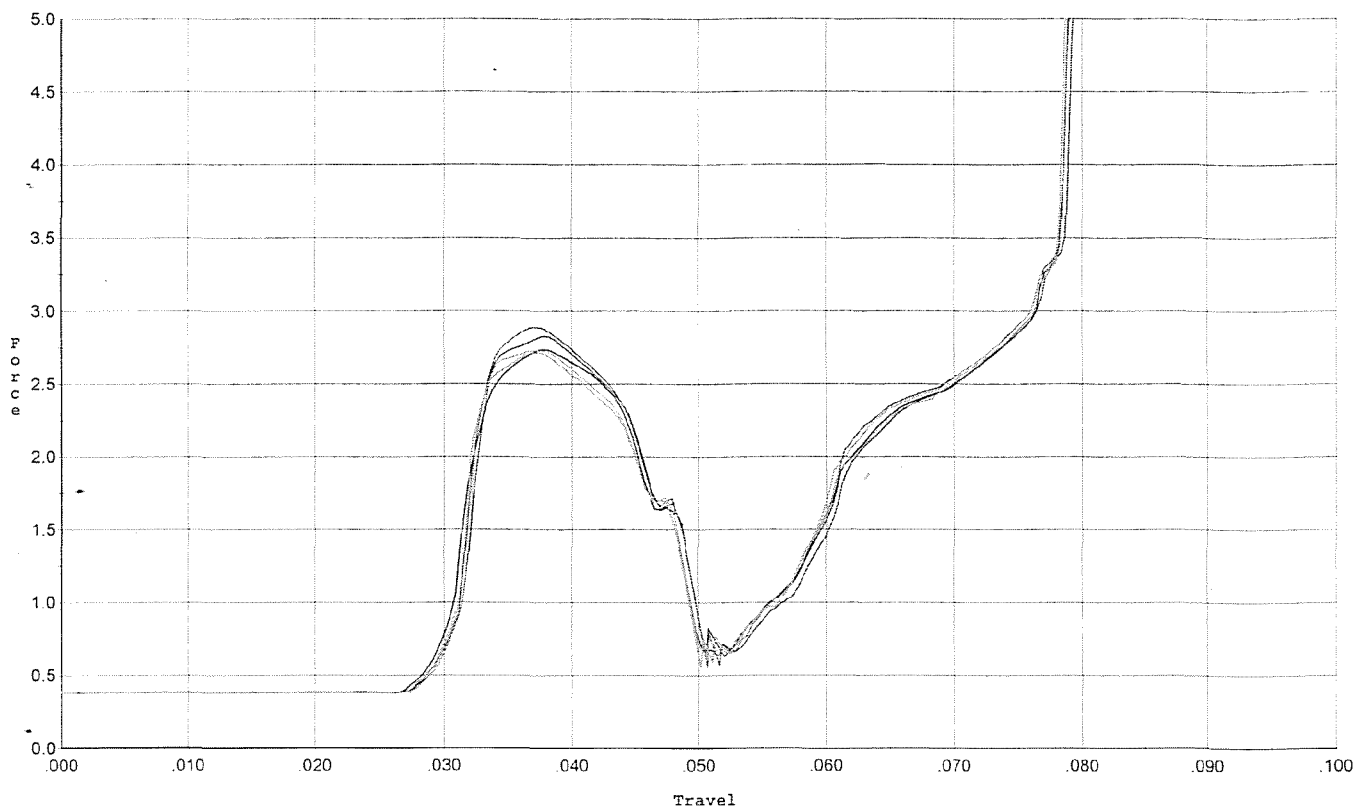
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4°</u> <u>4°</u> <u>4°</u>                               | 11-11-08 | 298     |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>50</u> <u>50</u> <u>50</u>                               | 11-11-08 | 290     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 11-11-08 | 290     |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 11-03-08 | RSD     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 11-11-08 | 290     |
|              | 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                        | 11-5-08  | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 11-5-08  | RSD     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 11-11-08 | 290     |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.56</u> <u>2.45</u> <u>2.54</u> <u>2.40</u> <u>2.41</u> | 11-6-08  | TC      |
|              | C) FUNCTION                                                              |                                                             | 11-11-08 | 290     |
| 690          | PACK                                                                     |                                                             | 11/12/08 | Fuj     |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



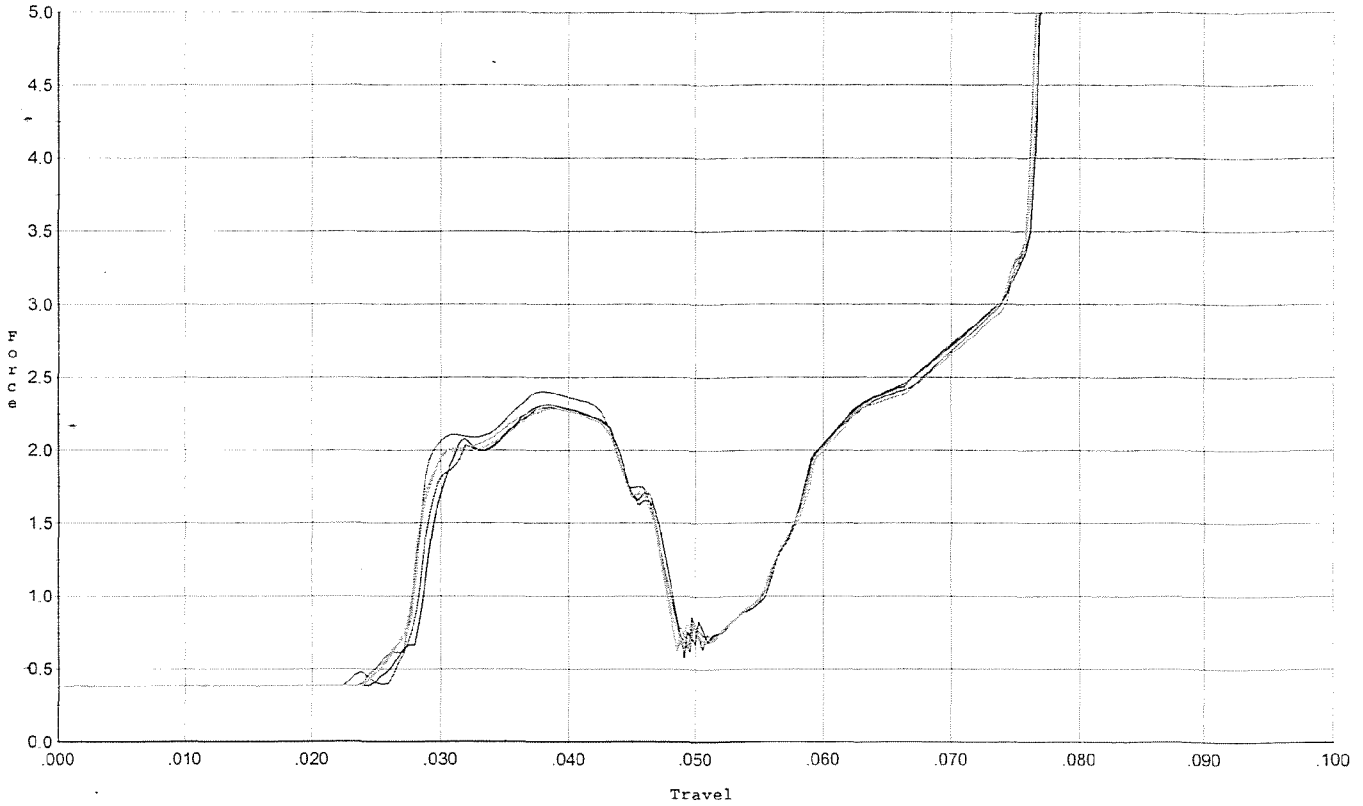
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.829      | 0.049             | 0.030           | 0.034      | 0.053             |           | Set Trigger |
| 2 | 2.739      | 0.048             | 0.029           | 0.034      | 0.052             |           | Set Trigger |
| 3 | 2.889      | 0.049             | 0.030           | 0.034      | 0.054             |           | Set Trigger |
| 4 | 2.732      | 0.048             | 0.030           | 0.034      | 0.052             |           | Set Trigger |
| 5 | 2.718      | 0.048             | 0.030           | 0.034      | 0.051             |           | Set Trigger |

A-2.78

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



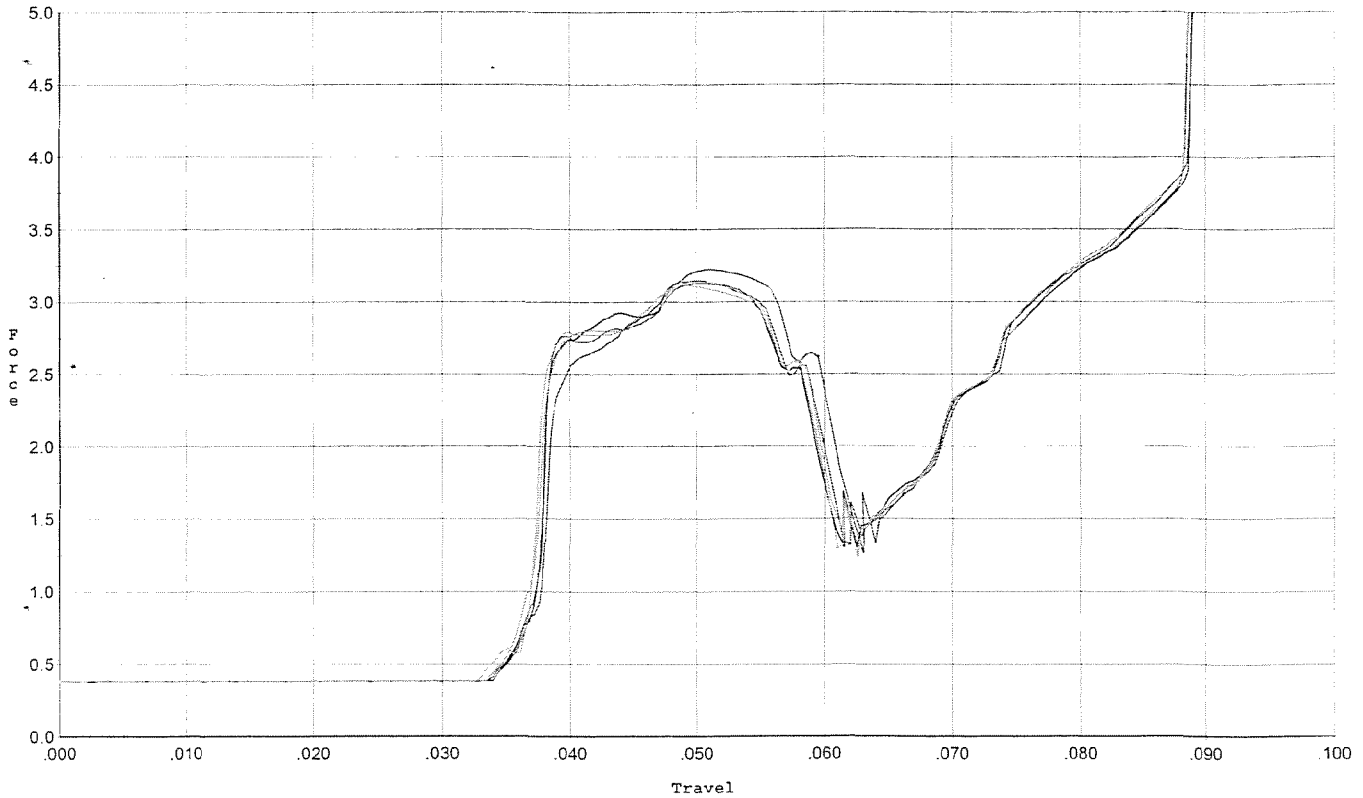
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.296      | 0.047             | 0.026           | 0.034      | 0.048             |           | Set Trigger |
| 2 | 2.315      | 0.047             | 0.027           | 0.034      | 0.049             |           | Set Trigger |
| 3 | 2.405      | 0.047             | 0.027           | 0.034      | 0.051             |           | Set Trigger |
| 4 | 2.287      | 0.046             | 0.027           | 0.034      | 0.049             |           | Set Trigger |
| 5 | 2.286      | 0.047             | 0.026           | 0.034      | 0.050             |           | Set Trigger |

A-2-31

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



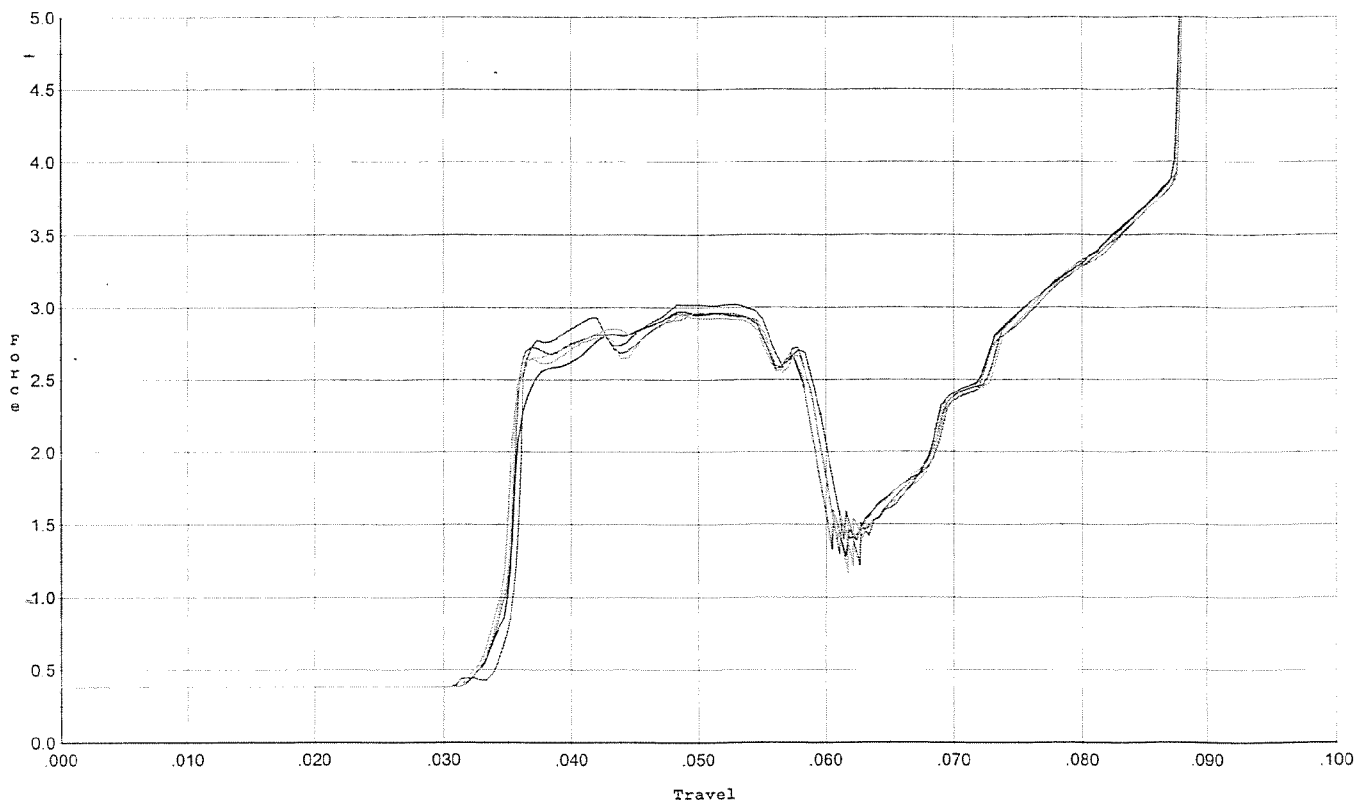
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.225      | 0.060             | 0.034           | 0.034      | 0.078             |           | Set Trigger |
| 2 | 3.145      | 0.058             | 0.036           | 0.036      | 0.075             |           | Set Trigger |
| 3 | 3.127      | 0.060             | 0.036           | 0.035      | 0.078             |           | Set Trigger |
| 4 | 3.142      | 0.059             | 0.036           | 0.035      | 0.077             |           | Set Trigger |
| 5 | 3.118      | 0.059             | 0.035           | 0.035      | 0.077             |           | Set Trigger |

A-3.15

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



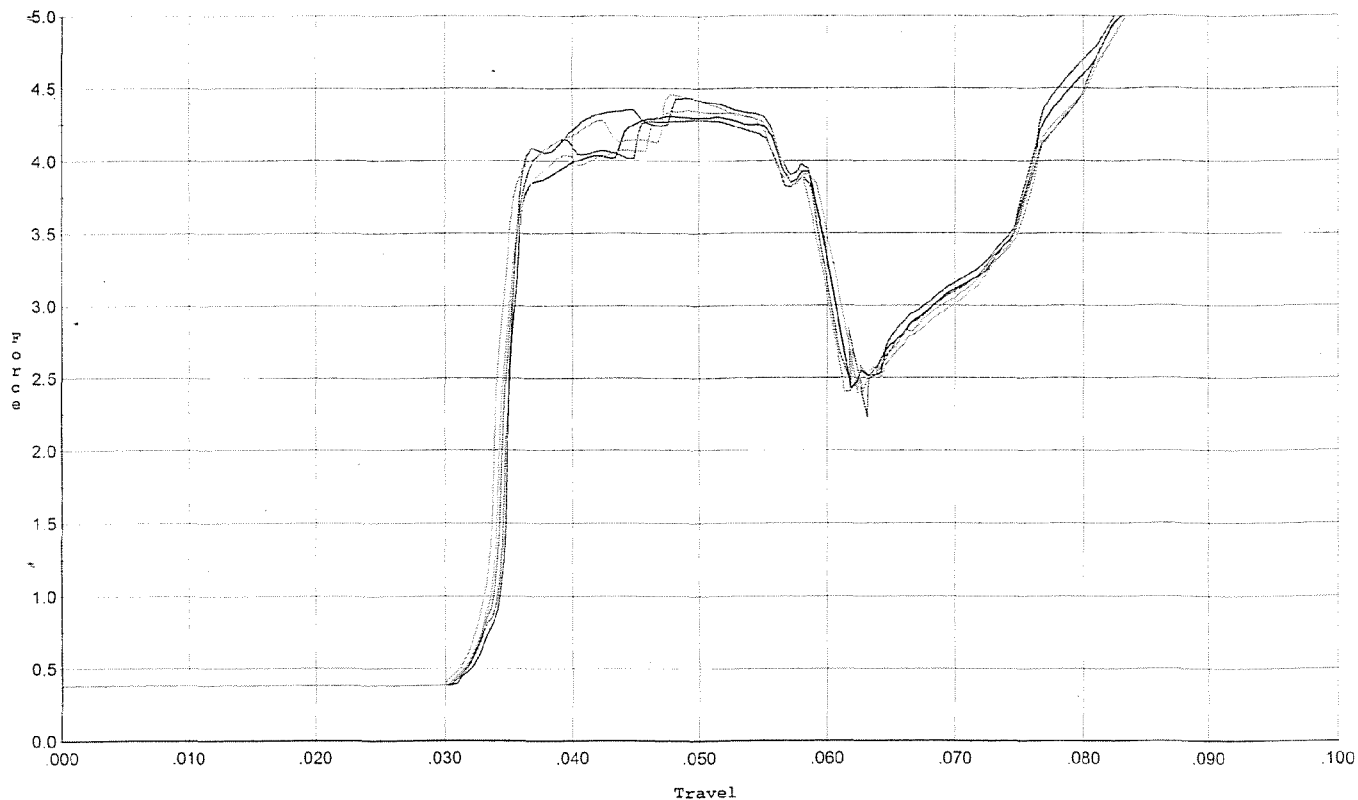
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.022      | 0.060             | 0.034           | 0.034      | 0.082             |           | Set Trigger |
| 2 | 2.968      | 0.058             | 0.034           | 0.034      | 0.078             |           | Set Trigger |
| 3 | 2.961      | 0.059             | 0.033           | 0.034      | 0.080             |           | Set Trigger |
| 4 | 2.945      | 0.058             | 0.033           | 0.034      | 0.078             |           | Set Trigger |
| 5 | 2.966      | 0.059             | 0.032           | 0.034      | 0.081             |           | Set Trigger |

A-297

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



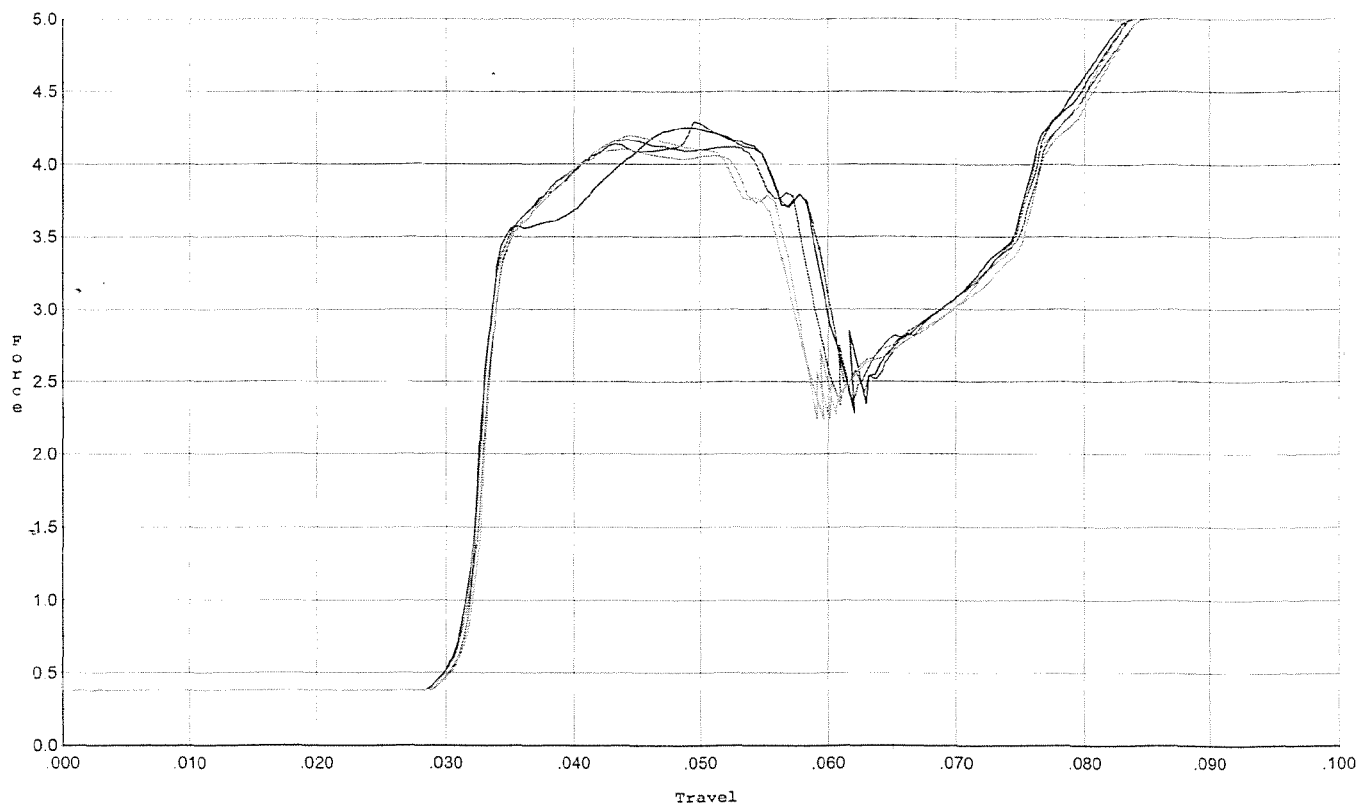
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.431      | 0.060             | 0.032           | 0.032      | 0.118             |           | Set Trigger |
| 2 | 4.308      | 0.060             | 0.033           | 0.032      | 0.115             |           | Set Trigger |
| 3 | 4.280      | 0.059             | 0.032           | 0.033      | 0.114             |           | Set Trigger |
| 4 | 4.350      | 0.060             | 0.032           | 0.032      | 0.119             |           | Set Trigger |
| 5 | 4.456      | 0.059             | 0.032           | 0.032      | 0.118             |           | Set Trigger |

A-436

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/28/2008

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



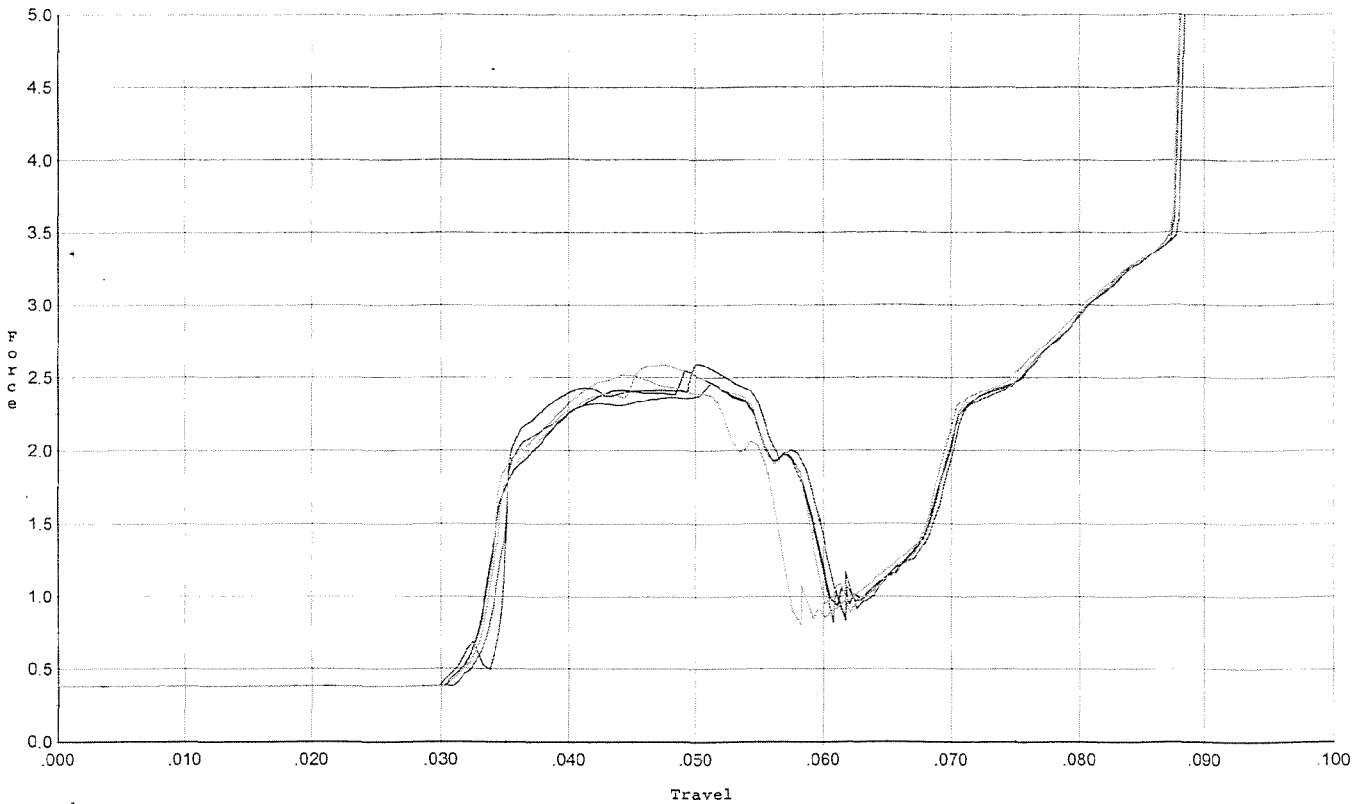
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.291      | 0.059             | 0.031           | 0.032      | 0.118             |           | Set Trigger |
| 2 | 4.255      | 0.058             | 0.030           | 0.032      | 0.114             |           | Set Trigger |
| 3 | 4.166      | 0.057             | 0.031           | 0.033      | 0.110             |           | Set Trigger |
| 4 | 4.196      | 0.056             | 0.031           | 0.033      | 0.106             |           | Set Trigger |
| 5 | 4.104      | 0.057             | 0.031           | 0.033      | 0.106             |           | Set Trigger |

A-4.20

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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



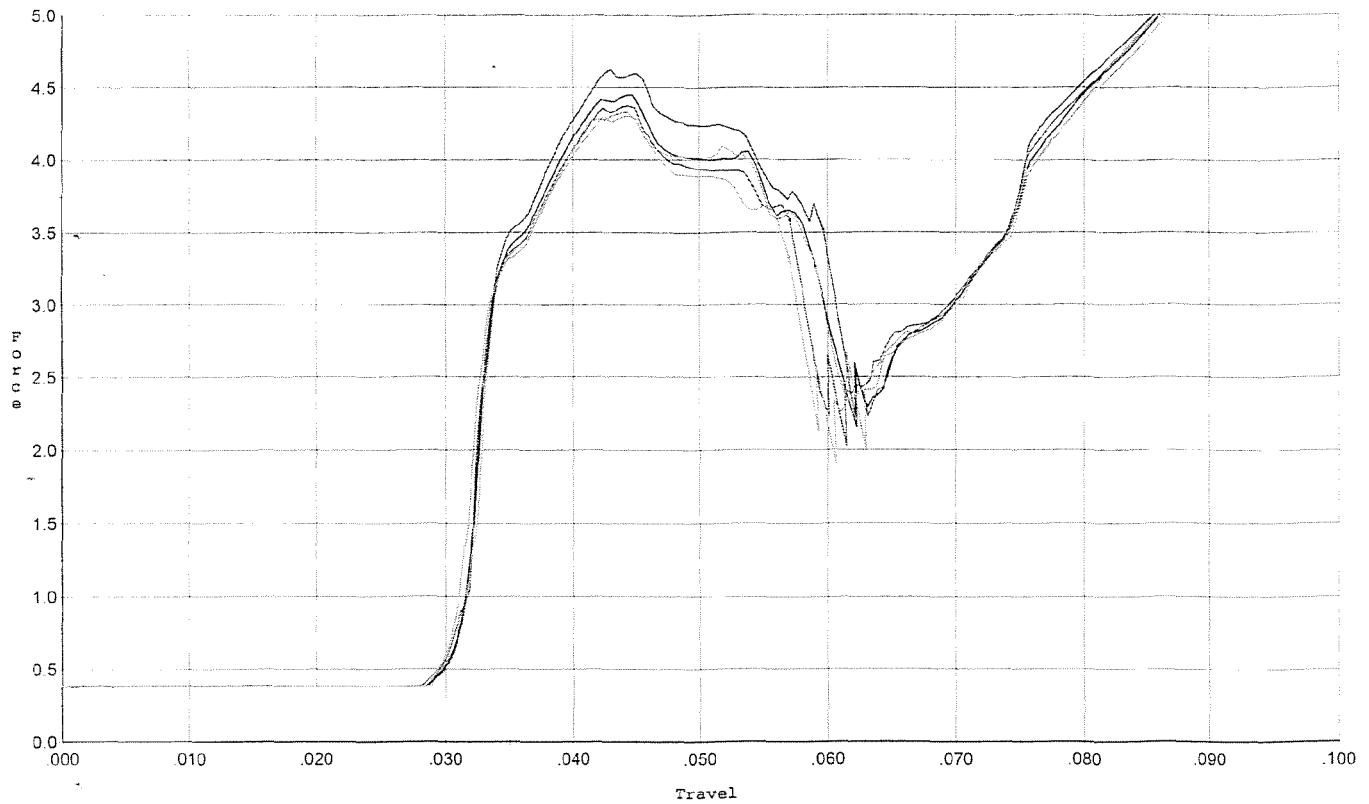
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.595      | 0.060             | 0.032           | 0.035      | 0.071             |           | Set Trigger |
| 2 | 2.548      | 0.059             | 0.031           | 0.034      | 0.069             |           | Set Trigger |
| 3 | 2.464      | 0.059             | 0.033           | 0.034      | 0.068             |           | Set Trigger |
| 4 | 2.587      | 0.058             | 0.033           | 0.035      | 0.068             |           | Set Trigger |
| 5 | 2.518      | 0.056             | 0.031           | 0.036      | 0.063             |           | Set Trigger |

A-254

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/28/2008

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 | 4.623      | 0.060             | 0.030           | 0.031      | 0.123             |           | Set Trigger |
| 2 | 4.446      | 0.059             | 0.031           | 0.032      | 0.116             |           | Set Trigger |
| 3 | 4.374      | 0.057             | 0.031           | 0.032      | 0.109             |           | Set Trigger |
| 4 | 4.298      | 0.057             | 0.031           | 0.033      | 0.106             |           | Set Trigger |
| 5 | 4.328      | 0.059             | 0.030           | 0.031      | 0.116             |           | Set Trigger |

A 4.41