

6678 5065

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



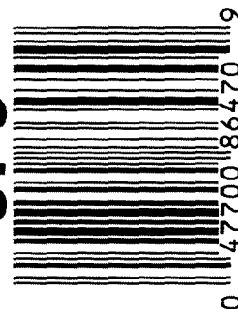
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6785065**

**UPC**



BM FORM

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

GUN SERIAL #

G 6785065

| OP # | OPERATION NAME                                                                                                                         | READINGS     | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |              | 9-8-08   | SP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |              | 9-8-08   | SP      |
| 440  | PROOF                                                                                                                                  |              | 9-8-08   | SP      |
| 460  | CHECK HEADSPACE                                                                                                                        |              | 9-8-08   | SP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |              | 9-8-08   | SP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX | 9-9-08   | SP      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | SEP 10 2008  | 9-9-08   | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR BH  | 9-10     | BH      |
| 490  | MAGNAFLUX BOLT                                                                                                                         |              | 9/8/08   | MR      |
| 500  | ROLLMARK CALIBER                                                                                                                       |              | 9/10/08  | KT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |              | 9/11/08  | DS      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |              | 9/14     |         |
| 545  | (BOLT)                                                                                                                                 |              |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |              |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |              | 10-1-08  | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |              | 10-1-08  | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |              | 10-1-08  | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |              | 10-15-08 | 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

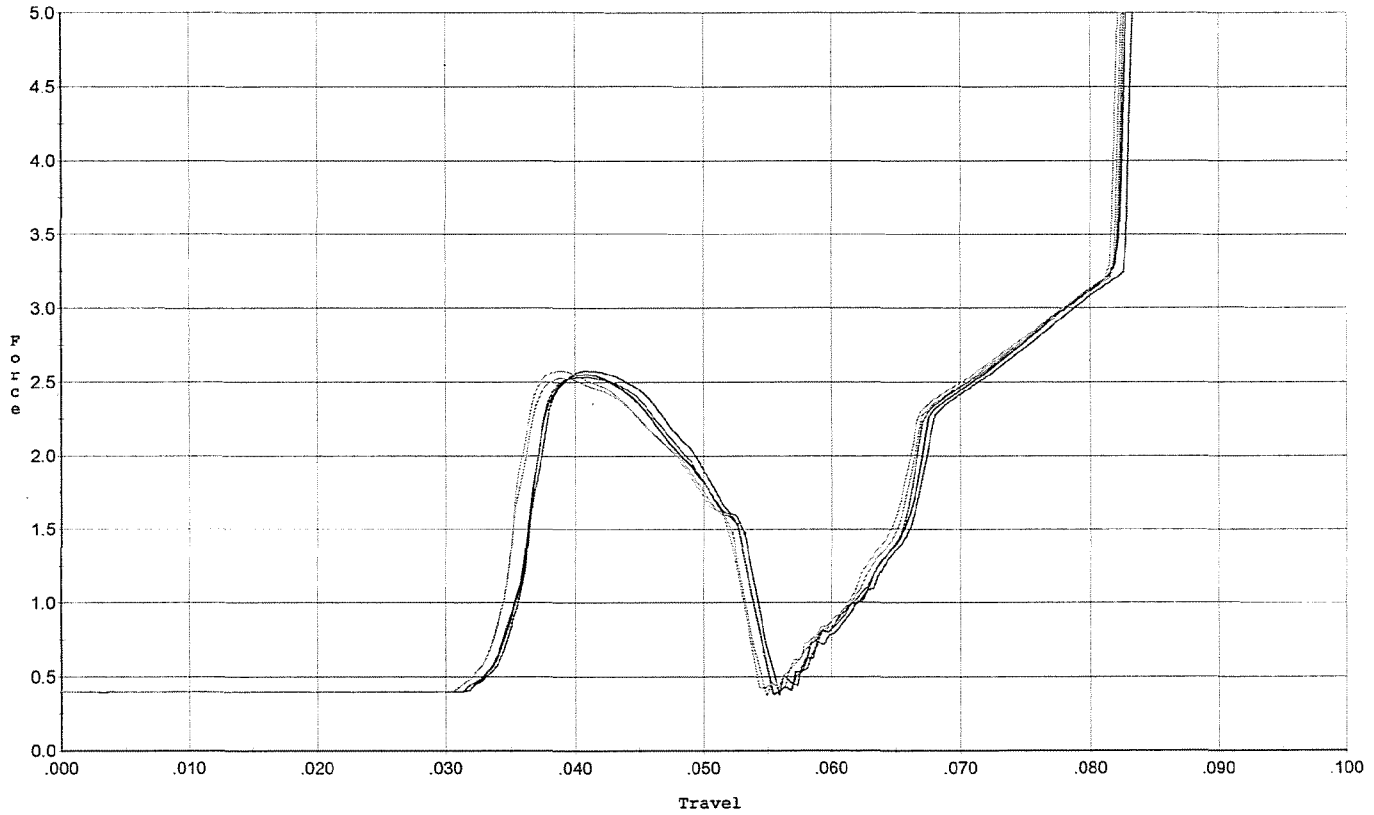
| OP #         | OPERATION NAME                                                           | READINGS                                               | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|--------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>30</u> <u>30</u> <u>35</u>                          | 12-15-08 | RN      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>50</u> <u>45</u> <u>40</u>                          | 12-15-08 | RN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                        |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.023</u>                    | 12-15-08 | RN      |
|              | J) ASSEMBLE STOCK                                                        |                                                        | 10-15-08 | L.P.D.  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                        | 12-15-08 | RN      |
|              | 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                   | 12-10-08 | L.P.D.  |
|              | MALFUNCTION                                                              | CORRECTION                                             |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                        | 12-15-08 | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                        | 12-15-08 | RN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>203</u> <u>203</u> <u>213</u> <u>210</u> <u>205</u> | 12-11-08 | RN      |
|              | C) FUNCTION                                                              |                                                        | 12-15-08 | RN      |
| 690          | PACK                                                                     |                                                        | 1-14-09  | TL      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/13/08

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



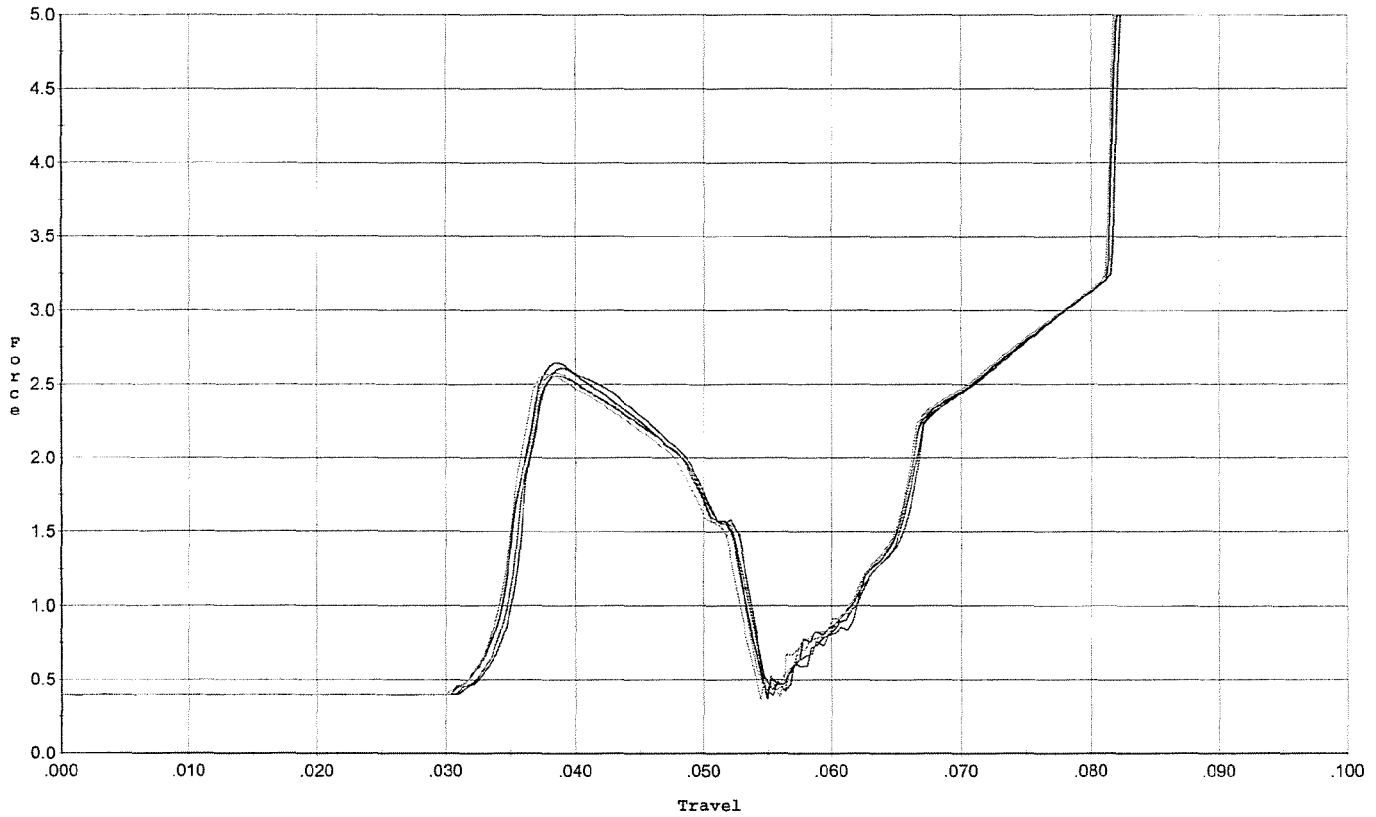
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.575      | 0.053             | 0.034           | 0.036      | 0.053             |           | Set Trigger |
| 2 | 2.550      | 0.053             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 3 | 2.534      | 0.053             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 4 | 2.578      | 0.053             | 0.033           | 0.035      | 0.053             |           | Set Trigger |
| 5 | 2.527      | 0.052             | 0.033           | 0.035      | 0.052             |           | Set Trigger |

Avg 2.55

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/13/08

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



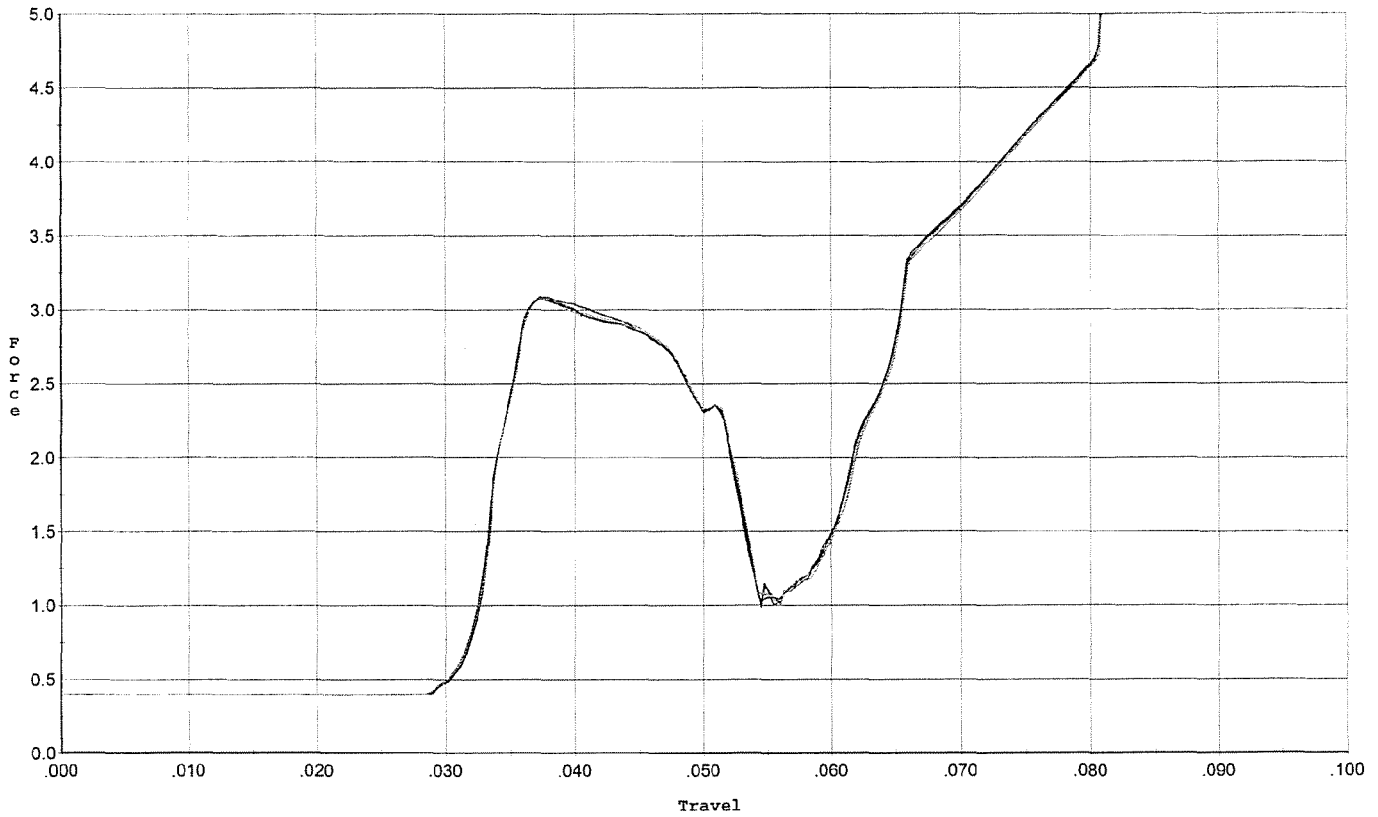
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.610      | 0.053             | 0.033           | 0.036      | 0.052             |           | Set Trigger |
| 2 | 2.648      | 0.052             | 0.033           | 0.035      | 0.053             |           | Set Trigger |
| 3 | 2.561      | 0.053             | 0.034           | 0.035      | 0.053             |           | Set Trigger |
| 4 | 2.569      | 0.052             | 0.033           | 0.035      | 0.051             |           | Set Trigger |
| 5 | 2.578      | 0.052             | 0.032           | 0.035      | 0.052             |           | Set Trigger |

Aug 2.59

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/13/08

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



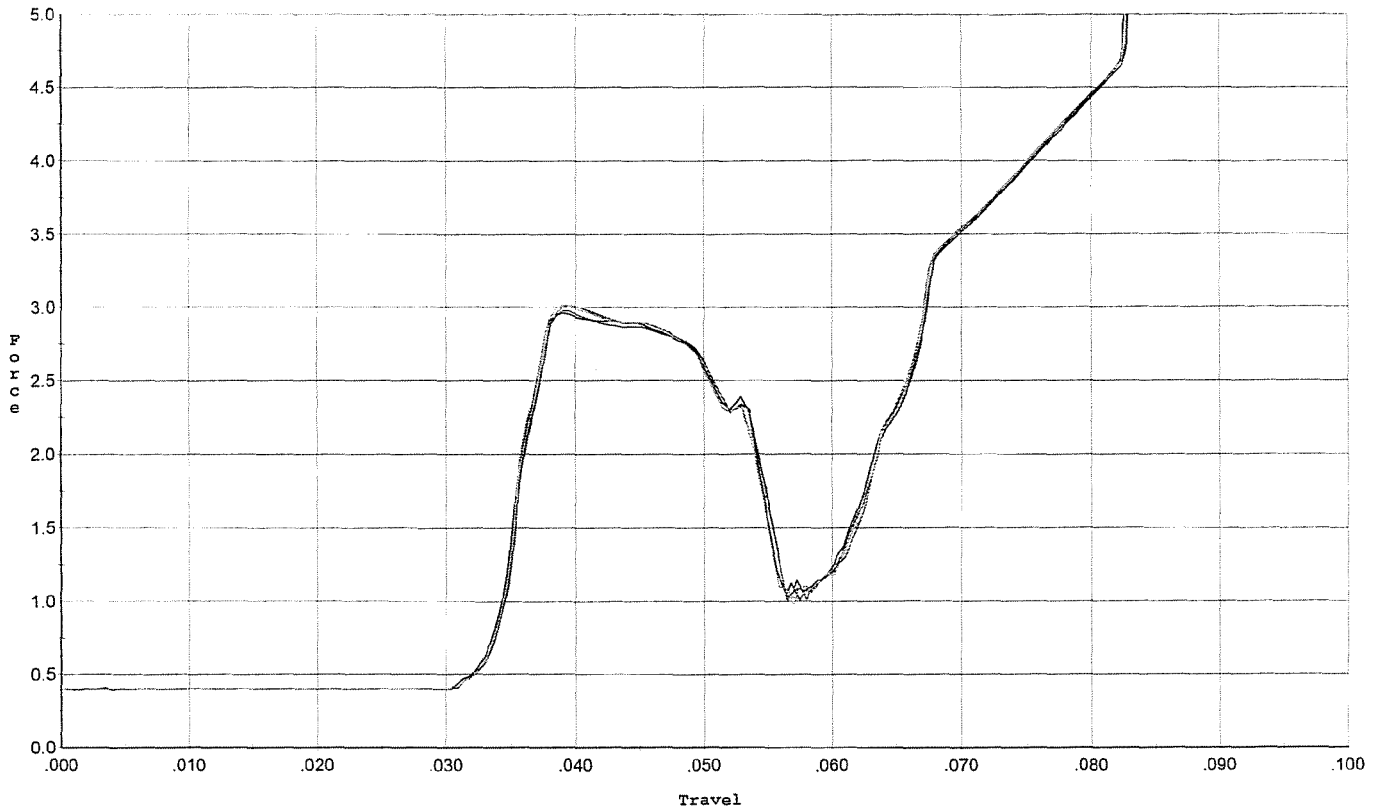
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.073      | 0.052             | 0.031           | 0.033      | 0.065             |           | Set Trigger |
| 2 | 3.088      | 0.053             | 0.032           | 0.033      | 0.066             |           | Set Trigger |
| 3 | 3.080      | 0.052             | 0.031           | 0.033      | 0.064             |           | Set Trigger |
| 4 | 3.081      | 0.053             | 0.031           | 0.033      | 0.066             |           | Set Trigger |
| 5 | 3.077      | 0.053             | 0.031           | 0.033      | 0.066             |           | Set Trigger |

Aug 3.08

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/13/08

**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 | 2.975      | 0.055             | 0.033           | 0.034      | 0.066             |           | Set Trigger |
| 2 | 2.964      | 0.054             | 0.033           | 0.034      | 0.065             |           | Set Trigger |
| 3 | 3.013      | 0.055             | 0.033           | 0.034      | 0.067             |           | Set Trigger |
| 4 | 3.014      | 0.054             | 0.033           | 0.034      | 0.066             |           | Set Trigger |
| 5 | 3.003      | 0.054             | 0.033           | 0.034      | 0.065             |           | Set Trigger |

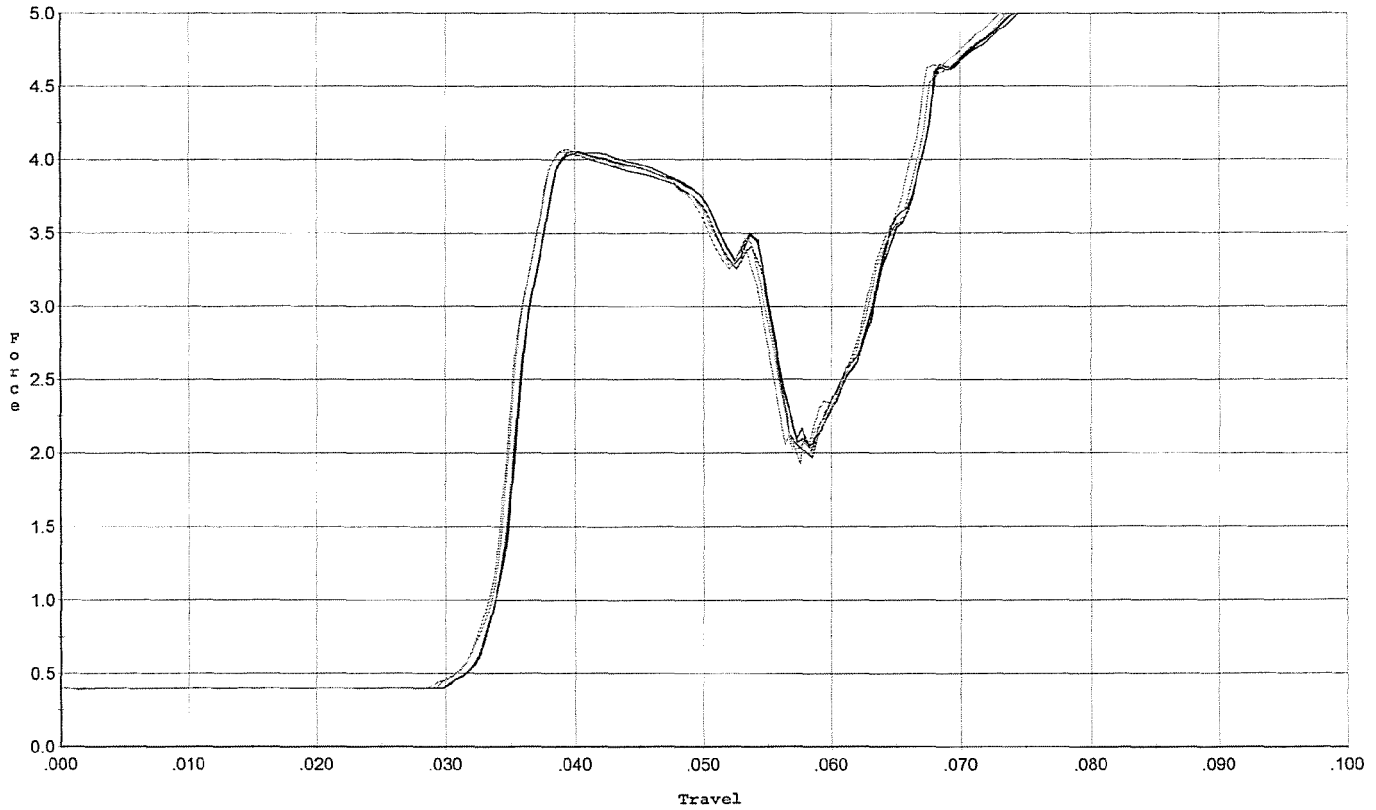
AUG 2.99



# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/13/08

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



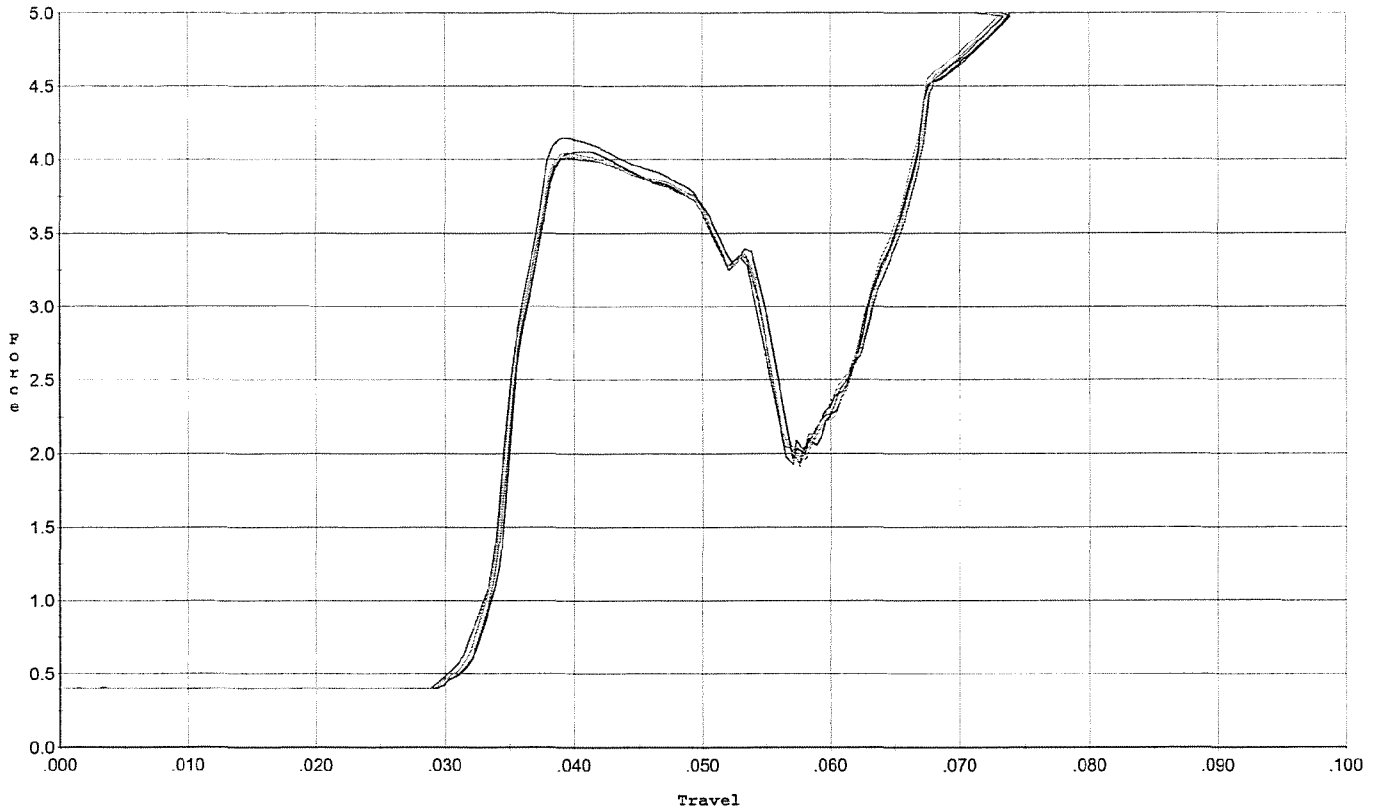
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.042      | 0.054             | 0.033           | 0.032      | 0.088             |           | Set Trigger |
| 2 | 4.058      | 0.054             | 0.033           | 0.032      | 0.088             |           | Set Trigger |
| 3 | 4.036      | 0.055             | 0.033           | 0.032      | 0.088             |           | Set Trigger |
| 4 | 4.074      | 0.055             | 0.032           | 0.032      | 0.090             |           | Set Trigger |
| 5 | 4.053      | 0.054             | 0.032           | 0.032      | 0.088             |           | Set Trigger |

Avg 4.05

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/13/08

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



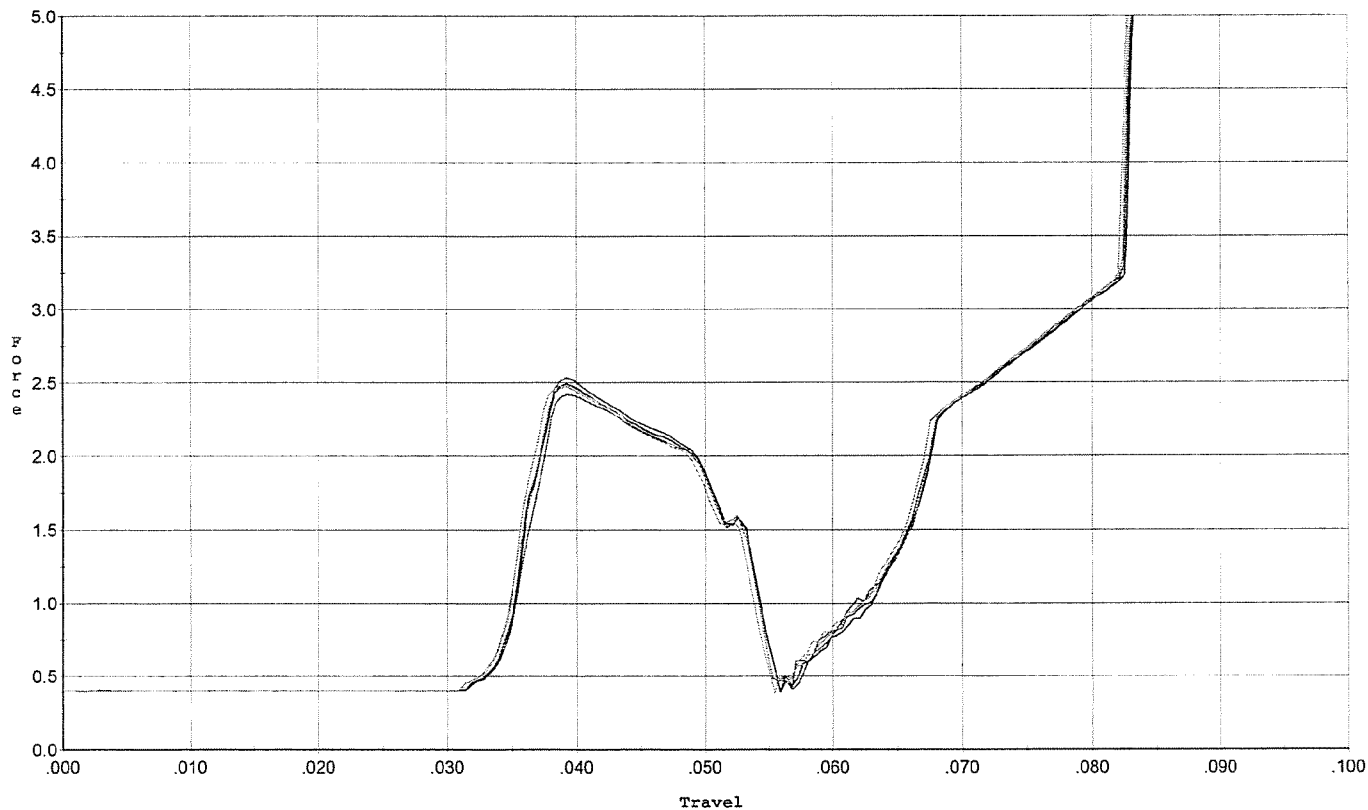
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.147      | 0.055             | 0.032           | 0.032      | 0.090             |           | Set Trigger |
| 2 | 4.053      | 0.055             | 0.032           | 0.032      | 0.089             |           | Set Trigger |
| 3 | 4.013      | 0.054             | 0.032           | 0.032      | 0.087             |           | Set Trigger |
| 4 | 4.047      | 0.054             | 0.032           | 0.032      | 0.088             |           | Set Trigger |
| 5 | 4.026      | 0.054             | 0.032           | 0.032      | 0.088             |           | Set Trigger |

AUG 4.05

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R, Putch 10/13/08

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



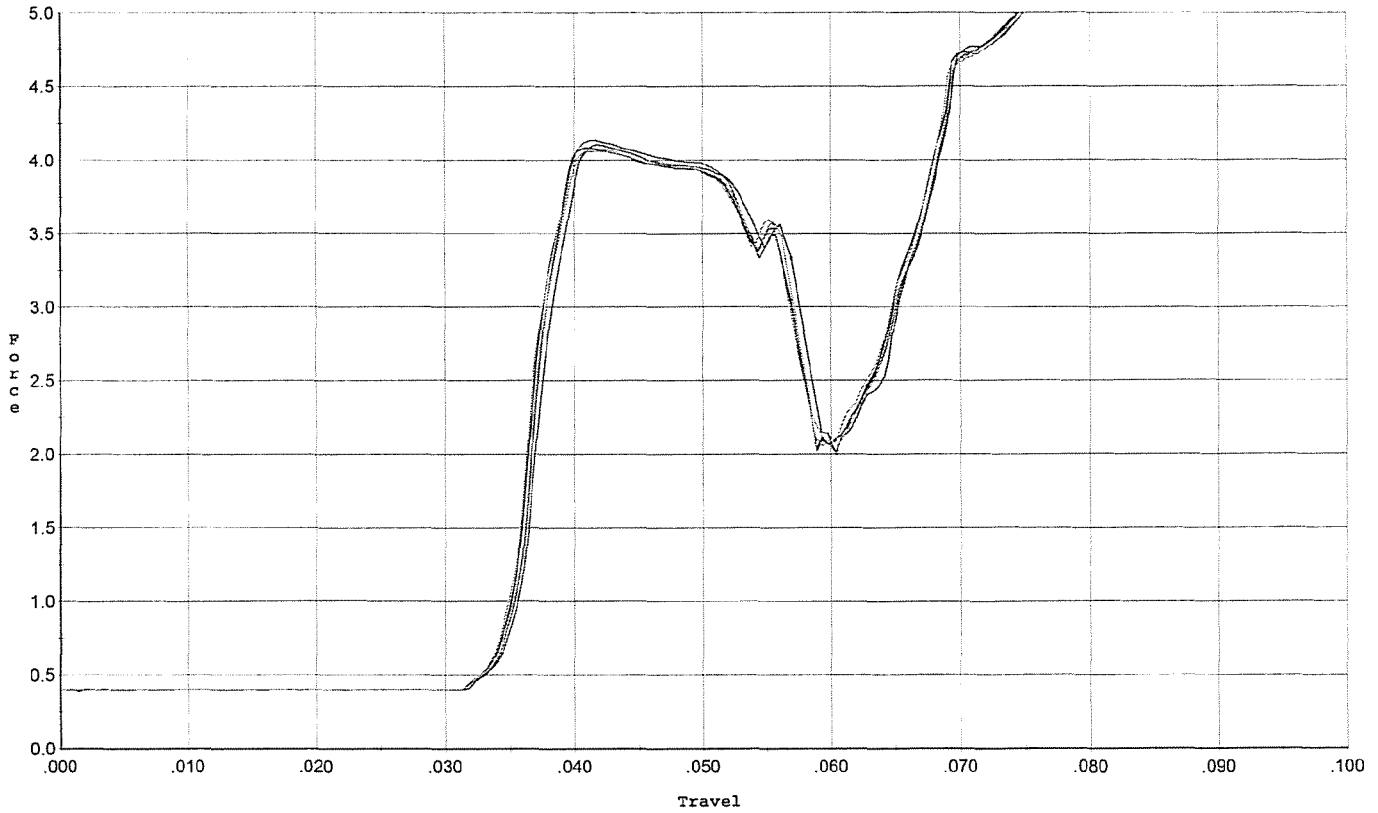
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.533      | 0.053             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 2 | 2.492      | 0.053             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 3 | 2.422      | 0.053             | 0.034           | 0.036      | 0.051             |           | Set Trigger |
| 4 | 2.480      | 0.053             | 0.034           | 0.035      | 0.051             |           | Set Trigger |
| 5 | 2.477      | 0.053             | 0.034           | 0.035      | 0.052             |           | Set Trigger |

Aug 2.48

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R, Putch 10/13/08

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 | 4.106      | 0.057             | 0.034           | 0.031      | 0.093             |           | Set Trigger |
| 2 | 4.082      | 0.057             | 0.034           | 0.031      | 0.093             |           | Set Trigger |
| 3 | 4.134      | 0.057             | 0.034           | 0.031      | 0.093             |           | Set Trigger |
| 4 | 4.080      | 0.056             | 0.034           | 0.031      | 0.092             |           | Set Trigger |
| 5 | 4.061      | 0.056             | 0.034           | 0.031      | 0.091             |           | Set Trigger |

Avg 4.09

86470  
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)  
BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO  
WITH BIPOD  
Original Crib 39 9/2/2008 10:53:10 AM  
PR864700690