

66863569

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

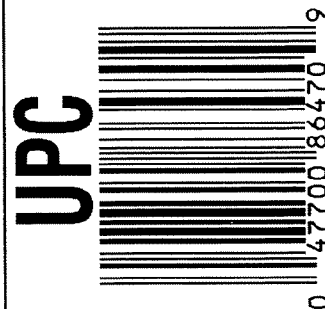


ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6863569**



BM FORM

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863569

| OP # | OPERATION NAME                                                                                                                         | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                       | 6-23-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                       | 6-23-09 | SP      |
| 440  | PROOF                                                                                                                                  |                       | 6-23-09 | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        |                       | 6-23-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                       | 6-23-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                       | 6-24-09 | RT      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   |                       | 6/26/09 | Ⓟ       |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                       |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |                       | 6/26/09 | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                       | 6-24-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                       | 6/26    | SP      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                       | 7/17    | —       |
| 545  | (BOLT)                                                                                                                                 |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                       | 7-14-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                       | 7-14-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO | 7-14-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                       | 7-14-09 | L.N.    |
|      | 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

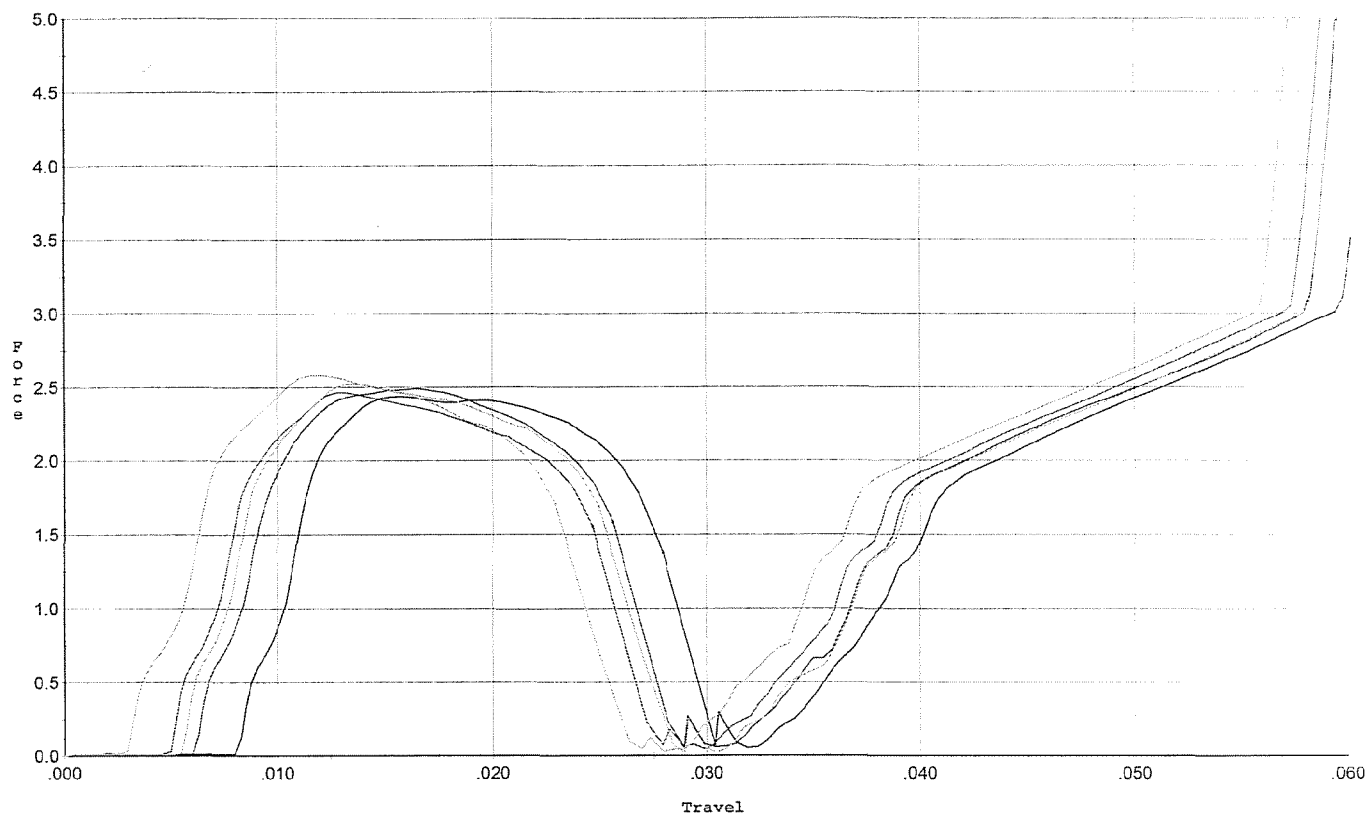
|              |                                                                       |                                           |             |             |             |             |             |        |    |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------|-------------|-------------|-------------|-------------|--------|----|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>50</u>   | <u>50</u>   | <u>50</u>   | 8-4-09      | XN          |        |    |
| CONT.        |                                                                       |                                           |             |             |             |             |             |        |    |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>60</u>   | <u>60</u>   | <u>60</u>   | 8-4-09      | XN          |        |    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |             |             |             |             |             |        |    |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> | <u>.023</u> | <u>.023</u> | 8-4-09      | XN          |        |    |
|              | J) ASSEMBLE STOCK                                                     |                                           |             |             |             | 7-14-09     | XN          |        |    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |             |             |             | 8-4-09      | XN          |        |    |
|              | 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                                           |                                           | PASS        | FAIL        |             | 7/29/09     | RF          |        |    |
|              |                                                                       |                                           | PASS        | FAIL        |             |             |             |        |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION  |             |             |             |             |        |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |        |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |        |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |        |    |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |             |             |             | 7-29-09     | XN          |        |    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |             |             |             | 8-4-09      | XN          |        |    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.37</u> | <u>2.34</u> | <u>2.29</u> | <u>2.33</u> | <u>2.31</u> | 8-4-09 | XN |
|              | C) FUNCTION                                                           |                                           |             |             |             |             |             | 8-4-09 | XN |
| 690          | PACK                                                                  |                                           |             |             |             |             |             | 8/6/09 | Fm |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



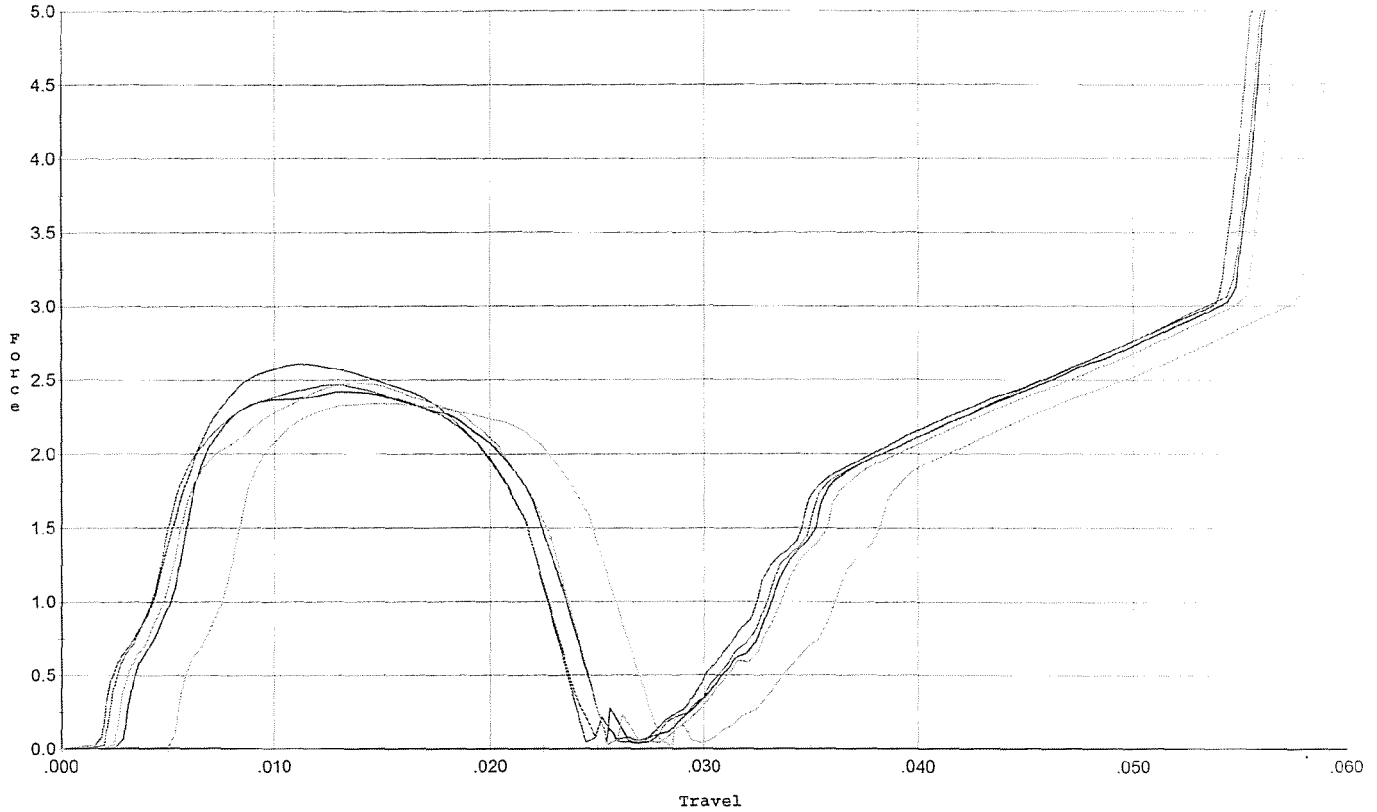
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.488      | 0.026             | 0.006           | 0.039      | 0.038             |           | Set Trigger |
| 2 | 2.436      | 0.028             | 0.008           | 0.039      | 0.039             |           | Set Trigger |
| 3 | 2.463      | 0.025             | 0.005           | 0.039      | 0.038             |           | Set Trigger |
| 4 | 2.522      | 0.025             | 0.006           | 0.039      | 0.038             |           | Set Trigger |
| 5 | 2.581      | 0.023             | 0.003           | 0.039      | 0.039             |           | Set Trigger |

Aug 2, 98

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



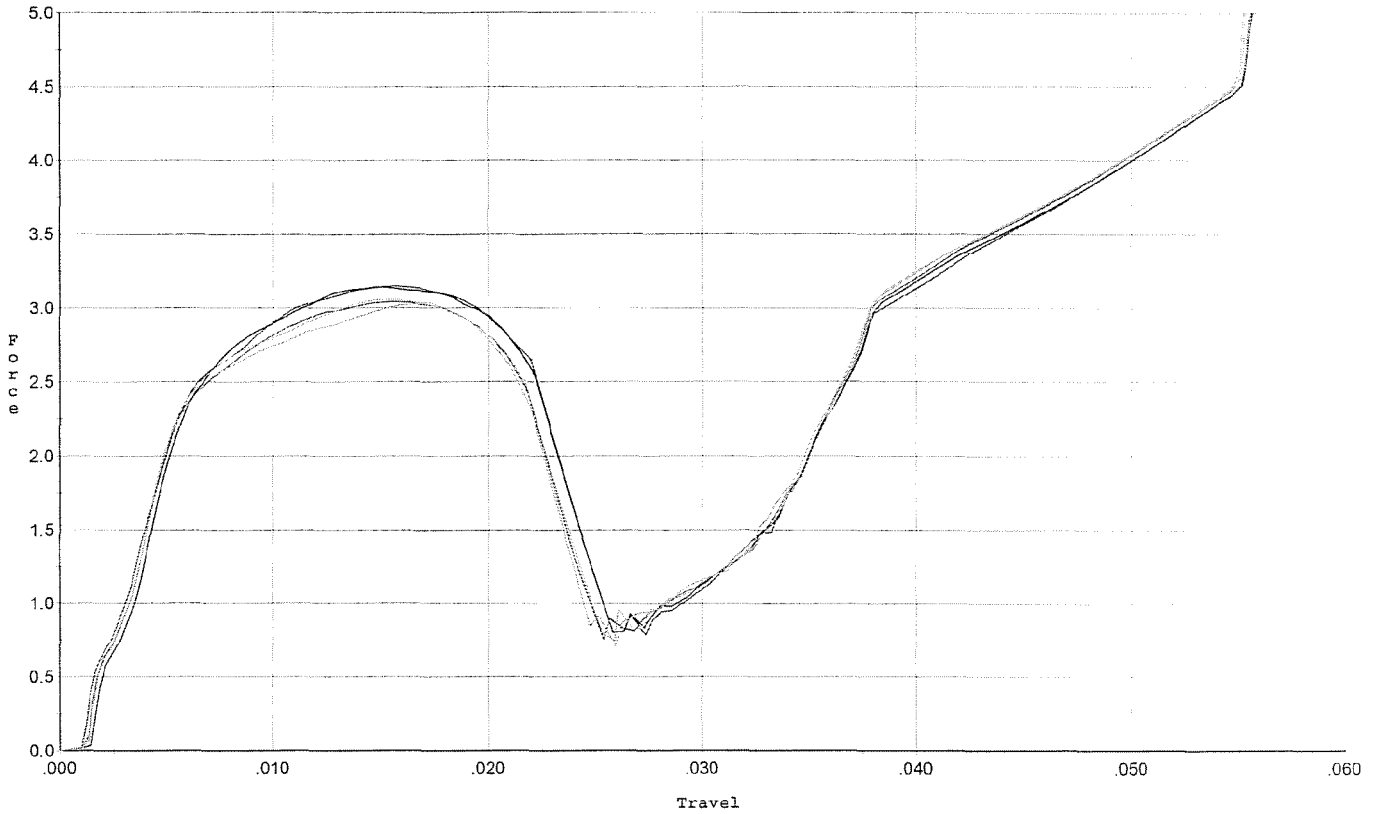
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.607      | 0.022             | 0.002           | 0.038      | 0.039             |           | Set Trigger |
| 2 | 2.420      | 0.023             | 0.003           | 0.038      | 0.039             |           | Set Trigger |
| 3 | 2.465      | 0.022             | 0.002           | 0.039      | 0.037             |           | Set Trigger |
| 4 | 2.341      | 0.025             | 0.005           | 0.039      | 0.036             |           | Set Trigger |
| 5 | 2.477      | 0.023             | 0.003           | 0.039      | 0.038             |           | Set Trigger |

Aug 2.46

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



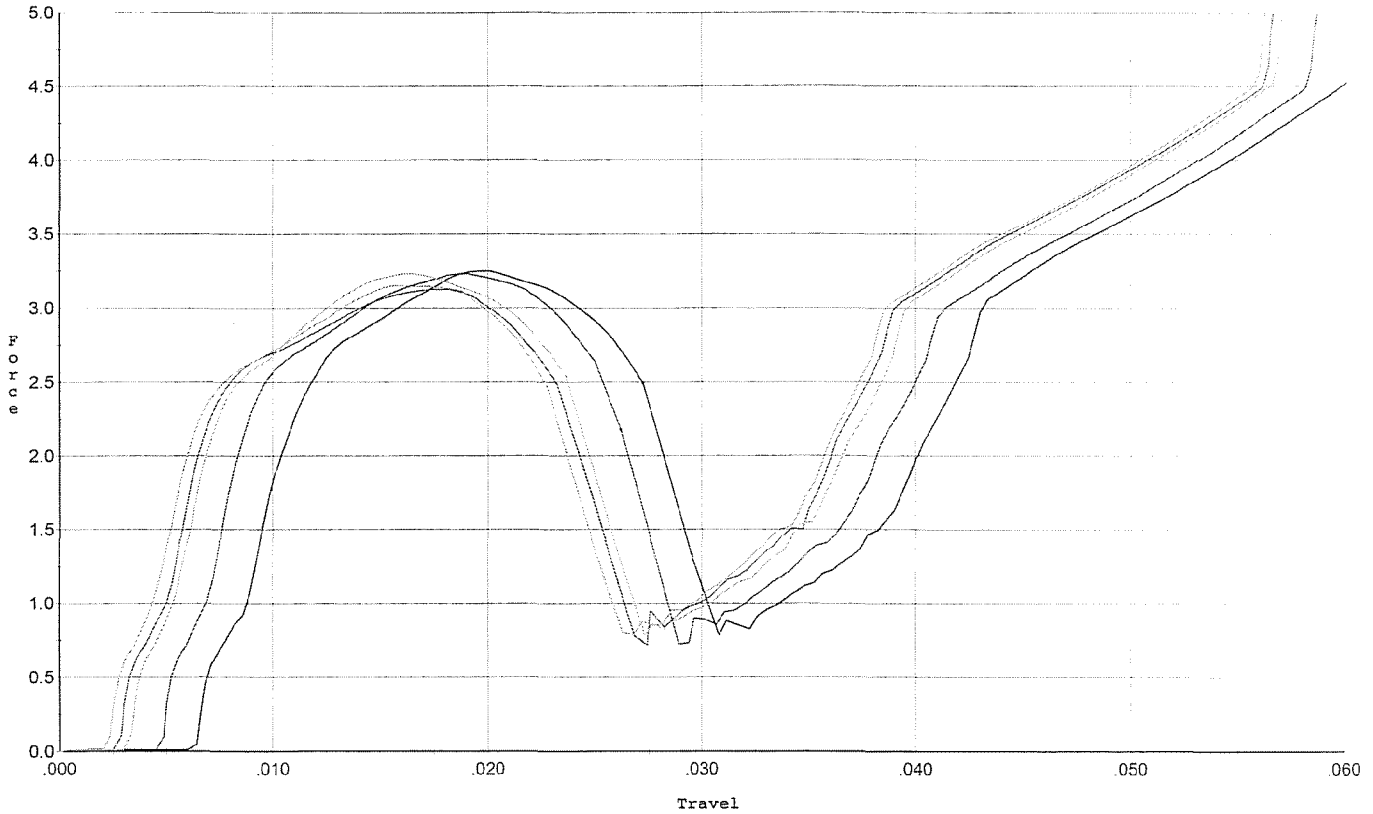
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.148      | 0.022             | 0.00            | 0.036      | 0.050             |           | Set Trigger |
| 2 | 3.139      | 0.022             | 0.00            | 0.036      | 0.050             |           | Set Trigger |
| 3 | 3.041      | 0.022             | 0.00            | 0.036      | 0.048             |           | Set Trigger |
| 4 | 3.059      | 0.022             | 0.00            | 0.036      | 0.048             |           | Set Trigger |
| 5 | 3.031      | 0.022             | 0.00            | 0.036      | 0.048             |           | Set Trigger |

Aug 3.08

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



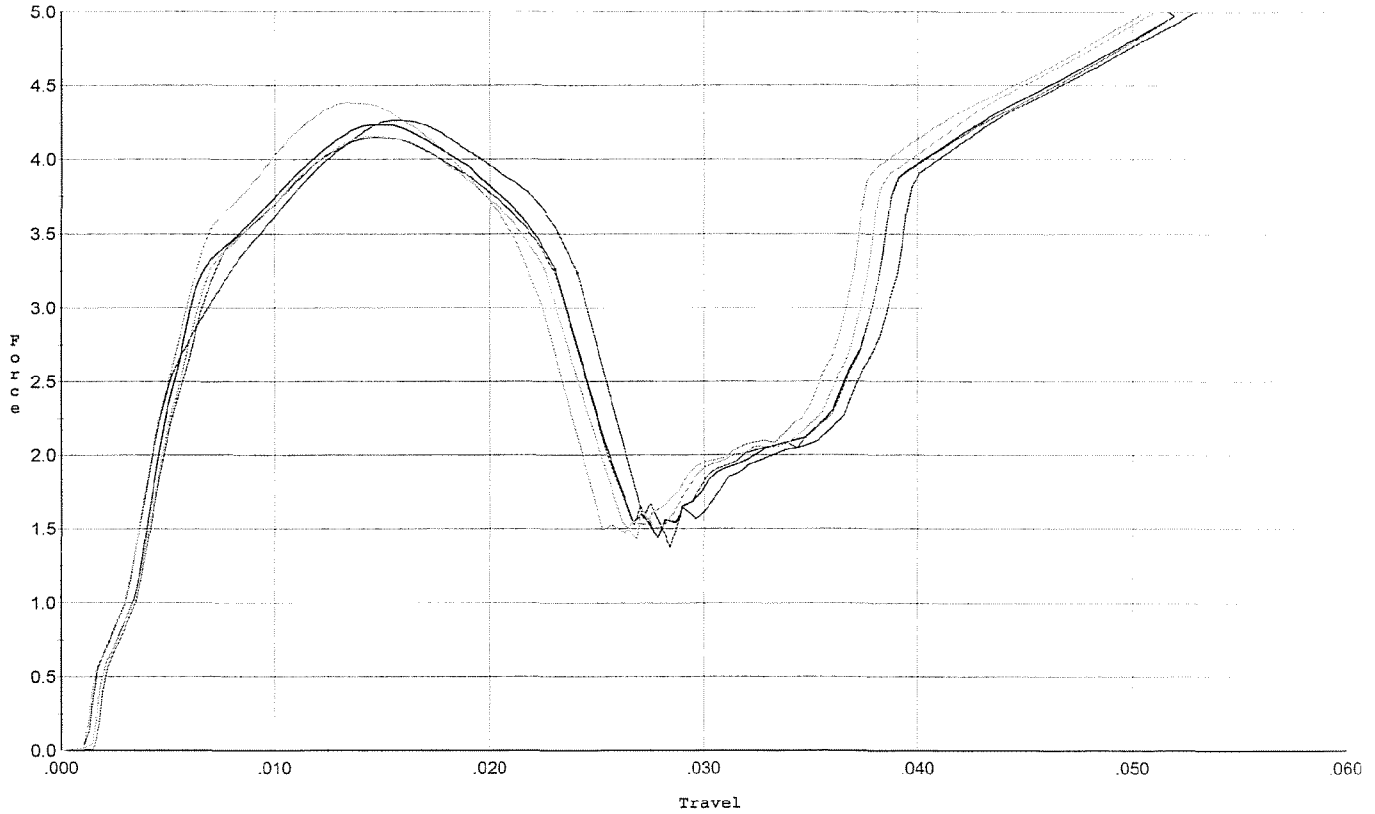
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.234      | 0.026             | 0.005           | 0.037      | 0.053             |           | Set Trigger |
| 2 | 3.253      | 0.027             | 0.007           | 0.037      | 0.052             |           | Set Trigger |
| 3 | 3.126      | 0.025             | 0.003           | 0.036      | 0.052             |           | Set Trigger |
| 4 | 3.231      | 0.024             | 0.003           | 0.036      | 0.050             |           | Set Trigger |
| 5 | 3.153      | 0.023             | 0.002           | 0.036      | 0.049             |           | Set Trigger |

Aug 3.18

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



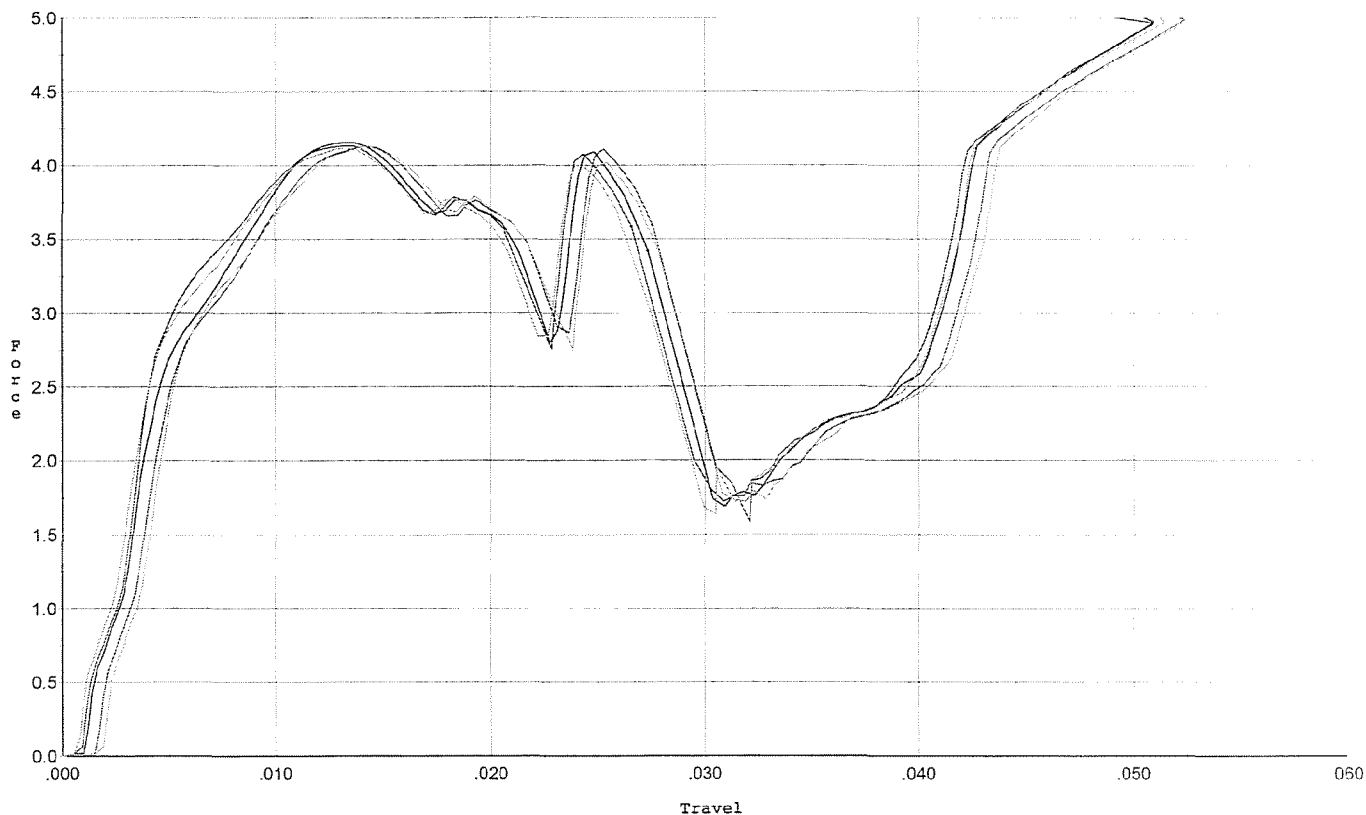
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.264      | 0.024             | 0.00            | 0.034      | 0.070             |           | Set Trigger |
| 2 | 4.234      | 0.023             | 0.00            | 0.035      | 0.067             |           | Set Trigger |
| 3 | 4.147      | 0.023             | 0.002           | 0.035      | 0.065             |           | Set Trigger |
| 4 | 4.158      | 0.023             | 0.00            | 0.034      | 0.064             |           | Set Trigger |
| 5 | 4.385      | 0.022             | 0.00            | 0.034      | 0.067             |           | Set Trigger |

Avg 4.23

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



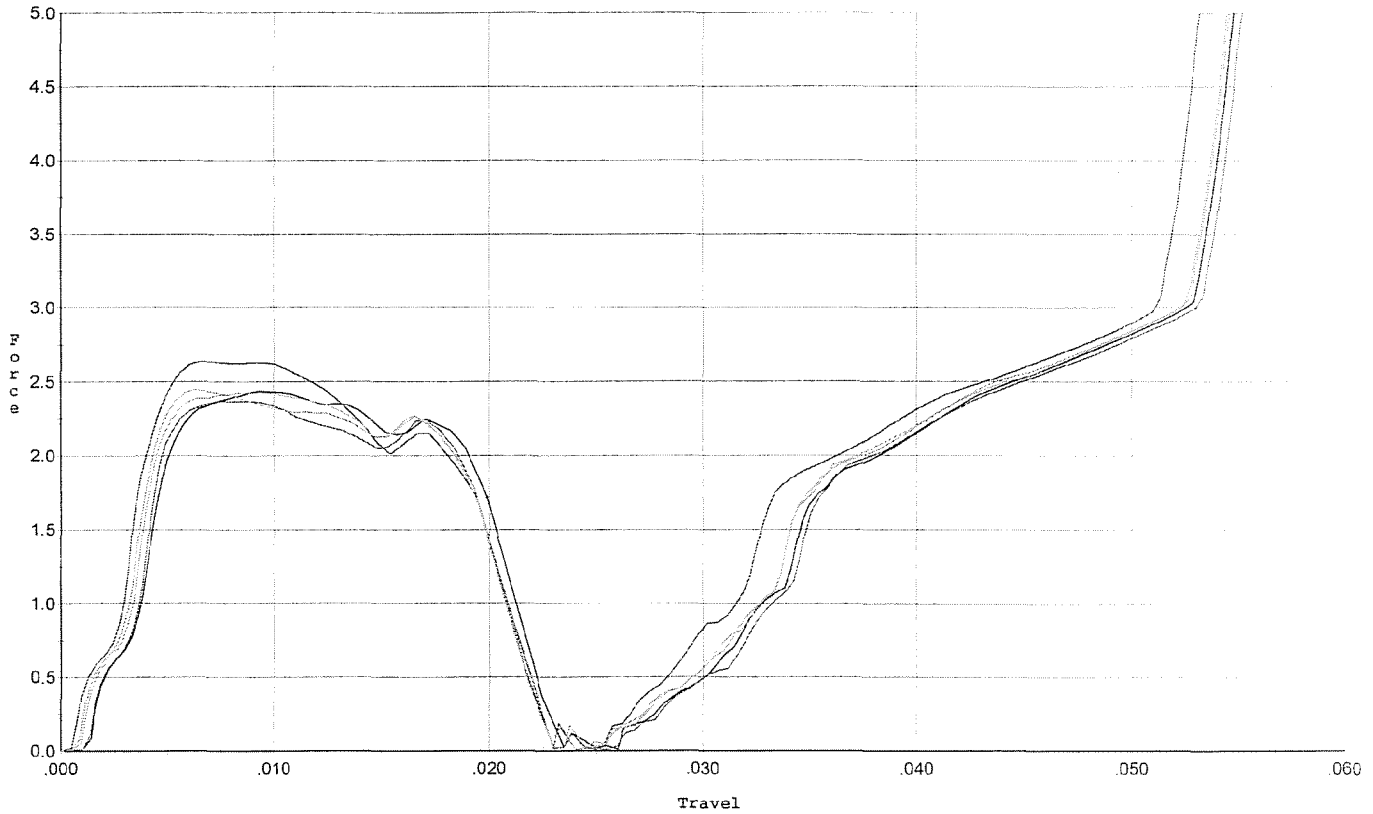
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.136      | 0.027             | 0.00            | 0.034      | 0.080             |           | Set Trigger |
| 2 | 4.155      | 0.027             | 0.00            | 0.033      | 0.081             |           | Set Trigger |
| 3 | 4.131      | 0.028             | 0.002           | 0.034      | 0.081             |           | Set Trigger |
| 4 | 4.131      | 0.028             | 0.002           | 0.034      | 0.081             |           | Set Trigger |
| 5 | 4.121      | 0.027             | 0.00            | 0.034      | 0.082             |           | Set Trigger |

Avg 4.13

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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



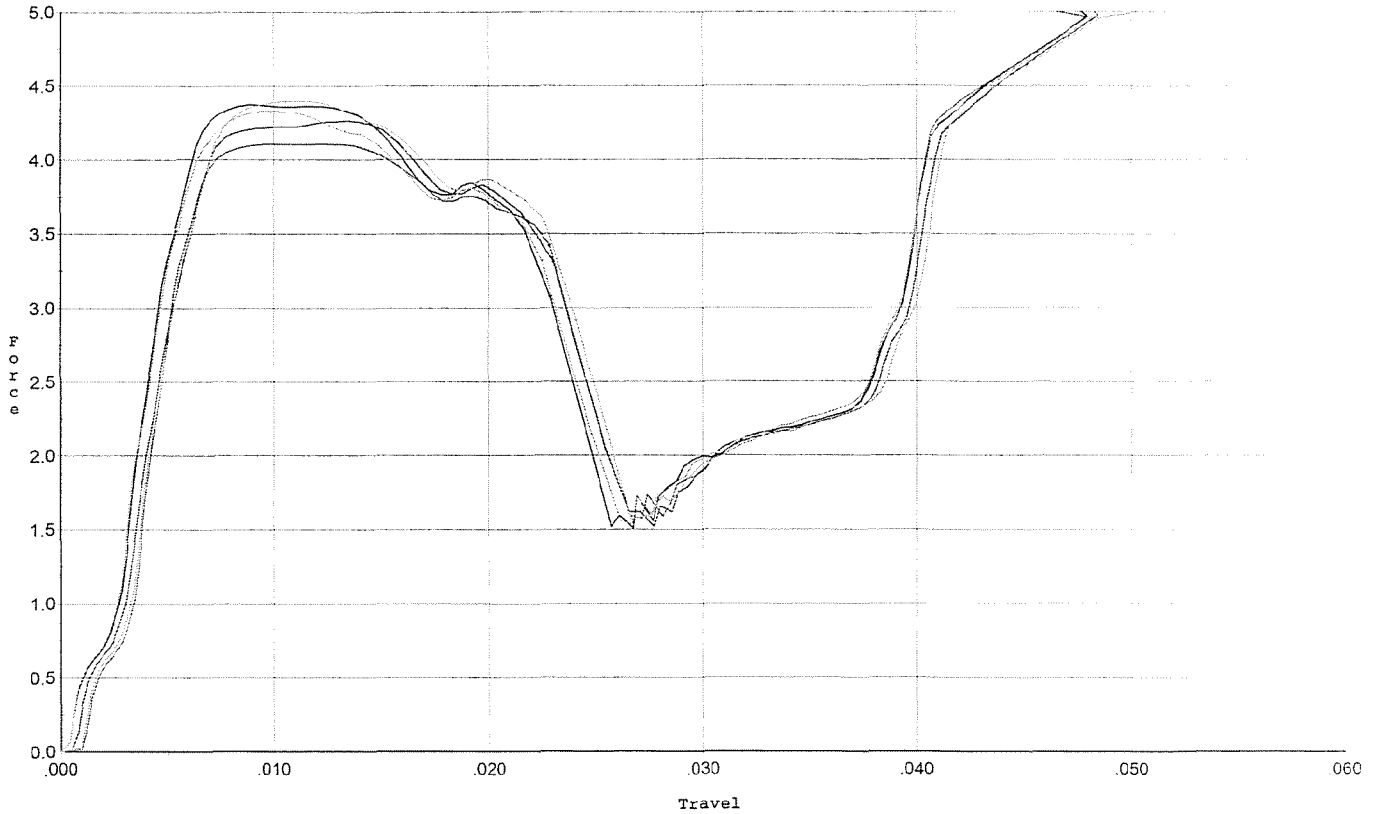
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.636      | 0.019             | 0.00            | 0.038      | 0.037             |           | Set Trigger |
| 2 | 2.434      | 0.020             | 0.00            | 0.039      | 0.035             |           | Set Trigger |
| 3 | 2.367      | 0.019             | 0.00            | 0.040      | 0.033             |           | Set Trigger |
| 4 | 2.423      | 0.019             | 0.00            | 0.039      | 0.035             |           | Set Trigger |
| 5 | 2.445      | 0.019             | 0.00            | 0.039      | 0.035             |           | Set Trigger |

Aug 2.46

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/15/09

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 | 4.264      | 0.023             | 0.00            | 0.034      | 0.070             |           | Set Trigger |
| 2 | 4.374      | 0.023             | 0.00            | 0.034      | 0.072             |           | Set Trigger |
| 3 | 4.109      | 0.023             | 0.00            | 0.033      | 0.068             |           | Set Trigger |
| 4 | 4.398      | 0.024             | 0.00            | 0.033      | 0.074             |           | Set Trigger |
| 5 | 4.330      | 0.022             | 0.00            | 0.034      | 0.070             |           | Set Trigger |

Aug 4.29