

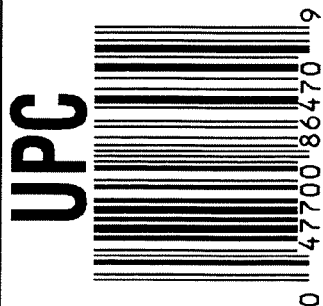
G 6863640

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



|               |              |
|---------------|--------------|
| ORDER NO.     | <b>86470</b> |
| BARREL LENGTH | 24"          |
| CAPACITY      | 6            |

**G6863640**



BM FORM

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6863640

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                     | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                              | 6-11-09 | SPD                                                                                 |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                              | 6-11-09 | SP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                              | 6-11-09 | SPD                                                                                 |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                                                                                 | 6-11-09 | SPD                                                                                 |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                              | 6-11-09 | SPD                                                                                 |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                              | 6-12-09 | RT                                                                                  |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 6/13/09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                              |         |                                                                                     |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                              | 6/16/09 | RT                                                                                  |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                              | 6-12-09 | SP                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                              | 6/15/09 | RTW                                                                                 |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                              | 7/1/09  | C                                                                                   |
| 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                                                                                                             |                                                                                              | 7-22-09 | 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

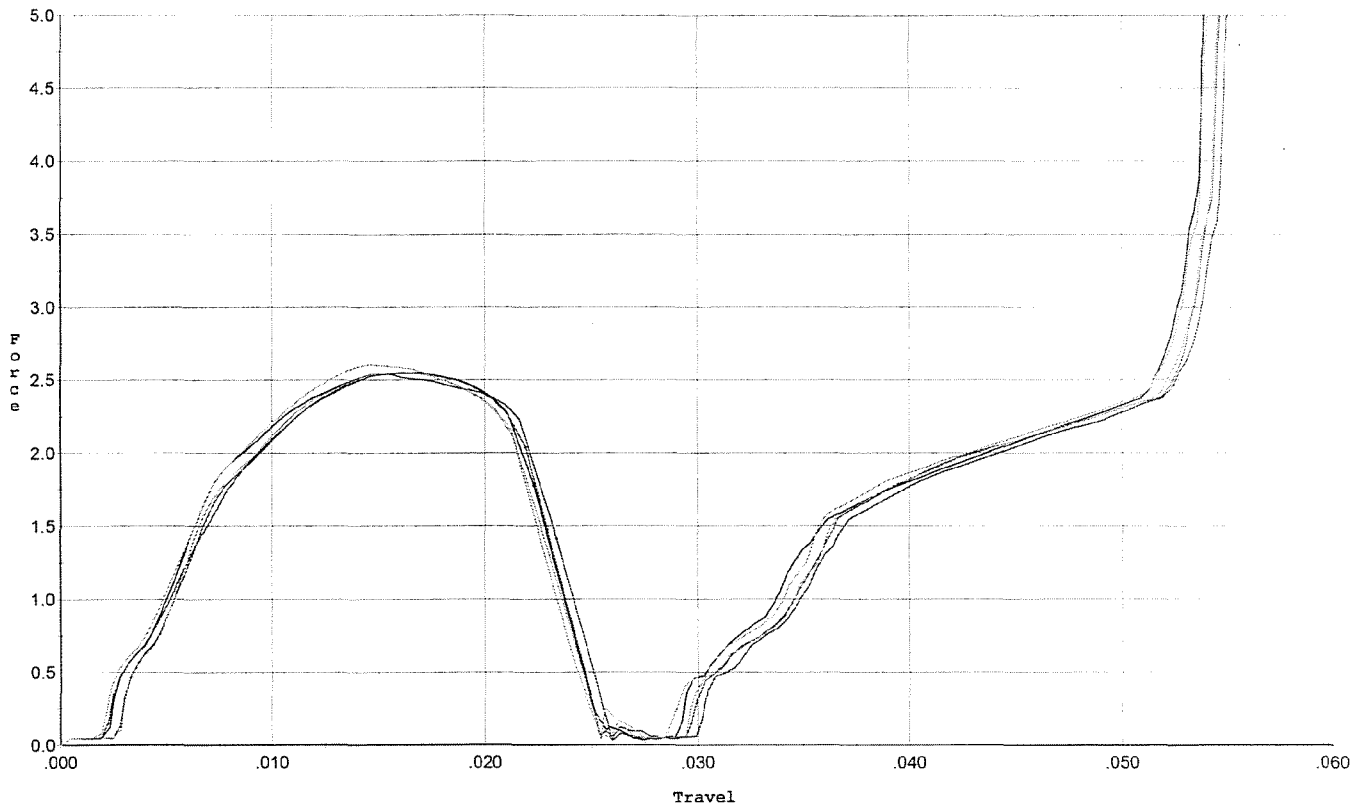
|              |                                                                       |                                           |                                                             |         |     |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|-----|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>50</u> <u>50</u> <u>50</u>                               | 8-5-09  | LN  |
| CONT.        |                                                                       |                                           |                                                             |         |     |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>60</u> <u>60</u> <u>60</u>                               | 8-5-09  | LN  |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |     |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> <u>.023</u> <u>.023</u>                         | 8-5-09  | LN  |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 7-22-09 | LN  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 8-5-09  | LN  |
|              | 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                        | 7/28    | RF  |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 7/28    | TAR |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 8-5-09  | LN  |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.65</u> <u>2.75</u> <u>2.56</u> <u>2.64</u> <u>2.62</u> | 8-4-09  | LN  |
|              | C) FUNCTION                                                           |                                           |                                                             | 8-5-09  | LN  |
| 690          | PACK                                                                  |                                           |                                                             | 8/10/09 | Em  |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



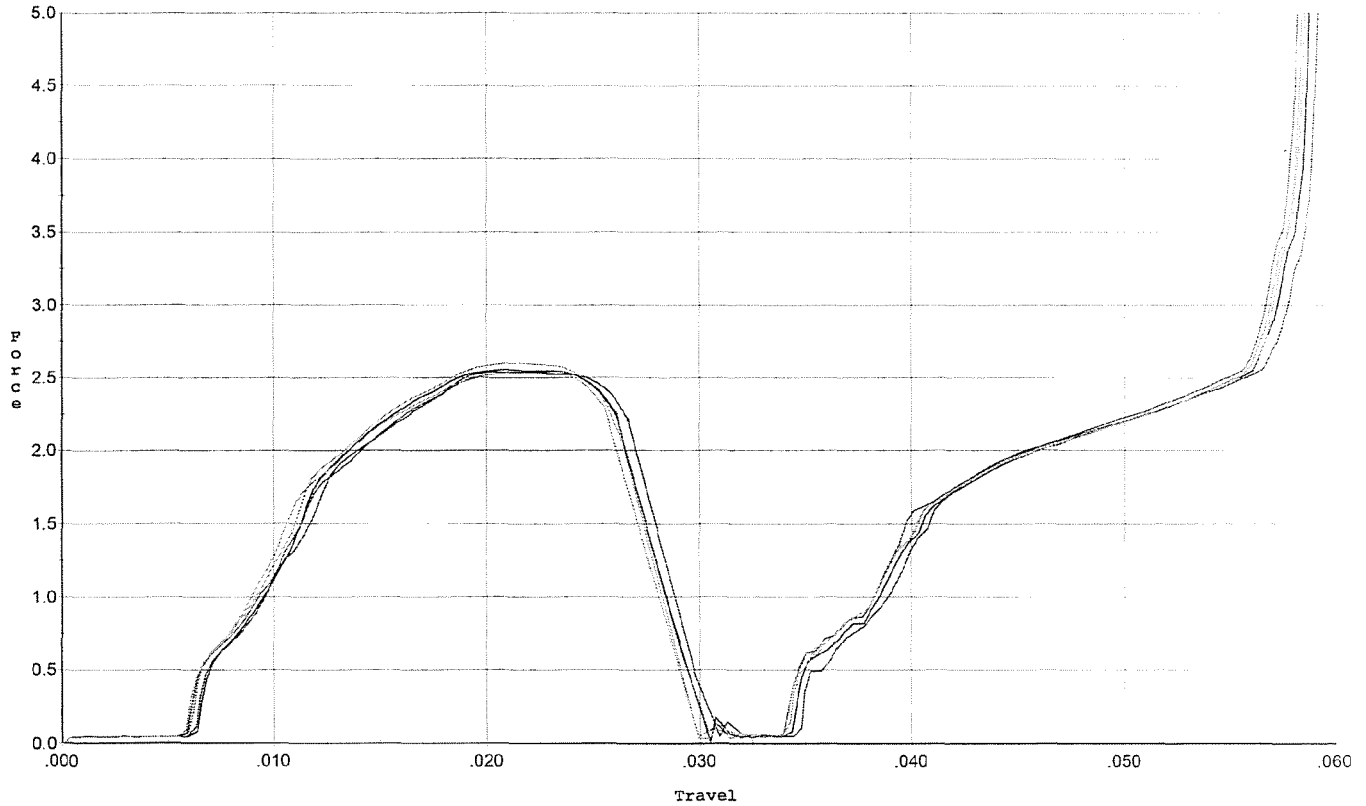
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.545      | 0.023             | 0.002           | 0.037      | 0.039             |           | Set Trigger |
| 2 | 2.549      | 0.022             | 0.002           | 0.036      | 0.038             |           | Set Trigger |
| 3 | 2.548      | 0.022             | 0.003           | 0.037      | 0.037             |           | Set Trigger |
| 4 | 2.554      | 0.023             | 0.003           | 0.037      | 0.038             |           | Set Trigger |
| 5 | 2.604      | 0.021             | 0.002           | 0.037      | 0.037             |           | Set Trigger |

Aug 2.56

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



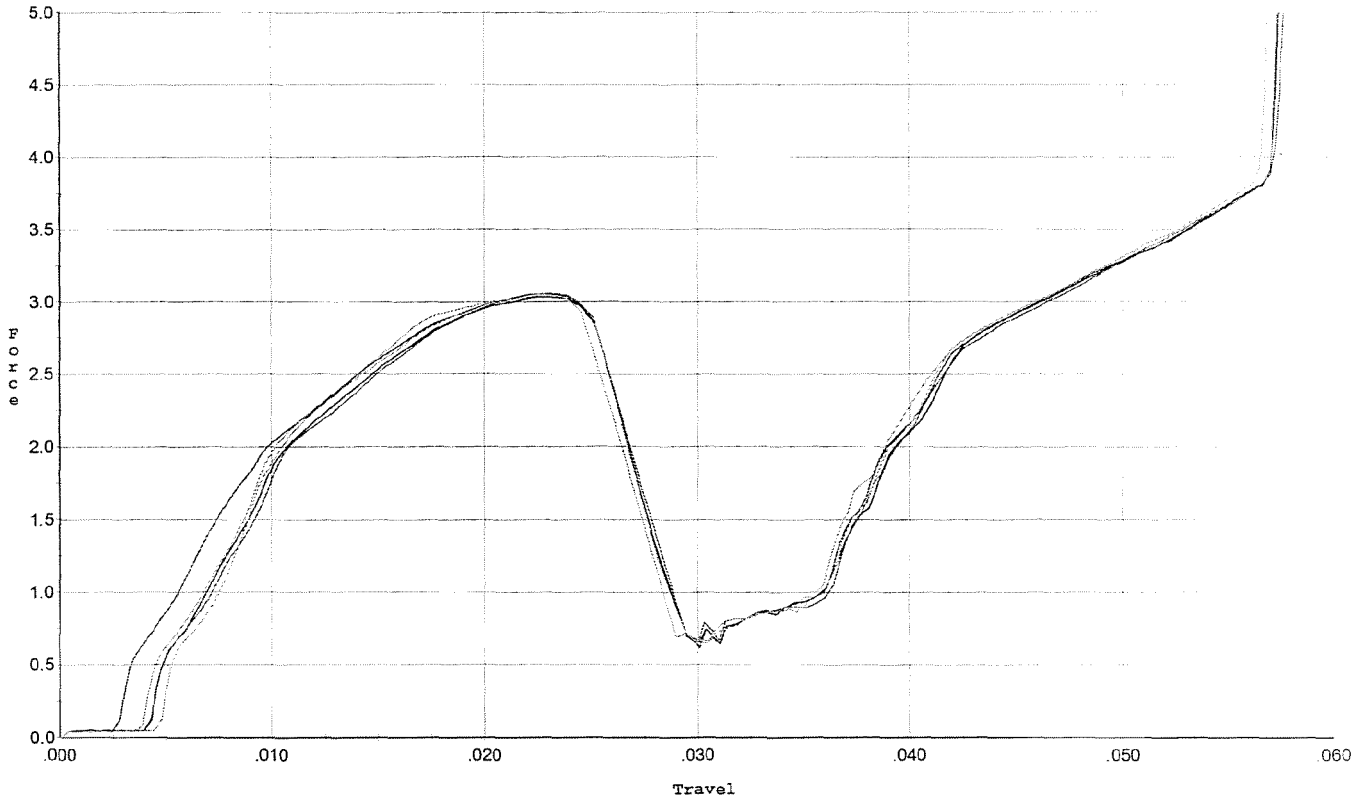
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.536      | 0.027             | 0.006           | 0.038      | 0.039             |           | Set Trigger |
| 2 | 2.551      | 0.026             | 0.007           | 0.038      | 0.038             |           | Set Trigger |
| 3 | 2.546      | 0.026             | 0.006           | 0.037      | 0.038             |           | Set Trigger |
| 4 | 2.601      | 0.026             | 0.006           | 0.038      | 0.040             |           | Set Trigger |
| 5 | 2.552      | 0.028             | 0.006           | 0.037      | 0.041             |           | Set Trigger |

Aug 2.55

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



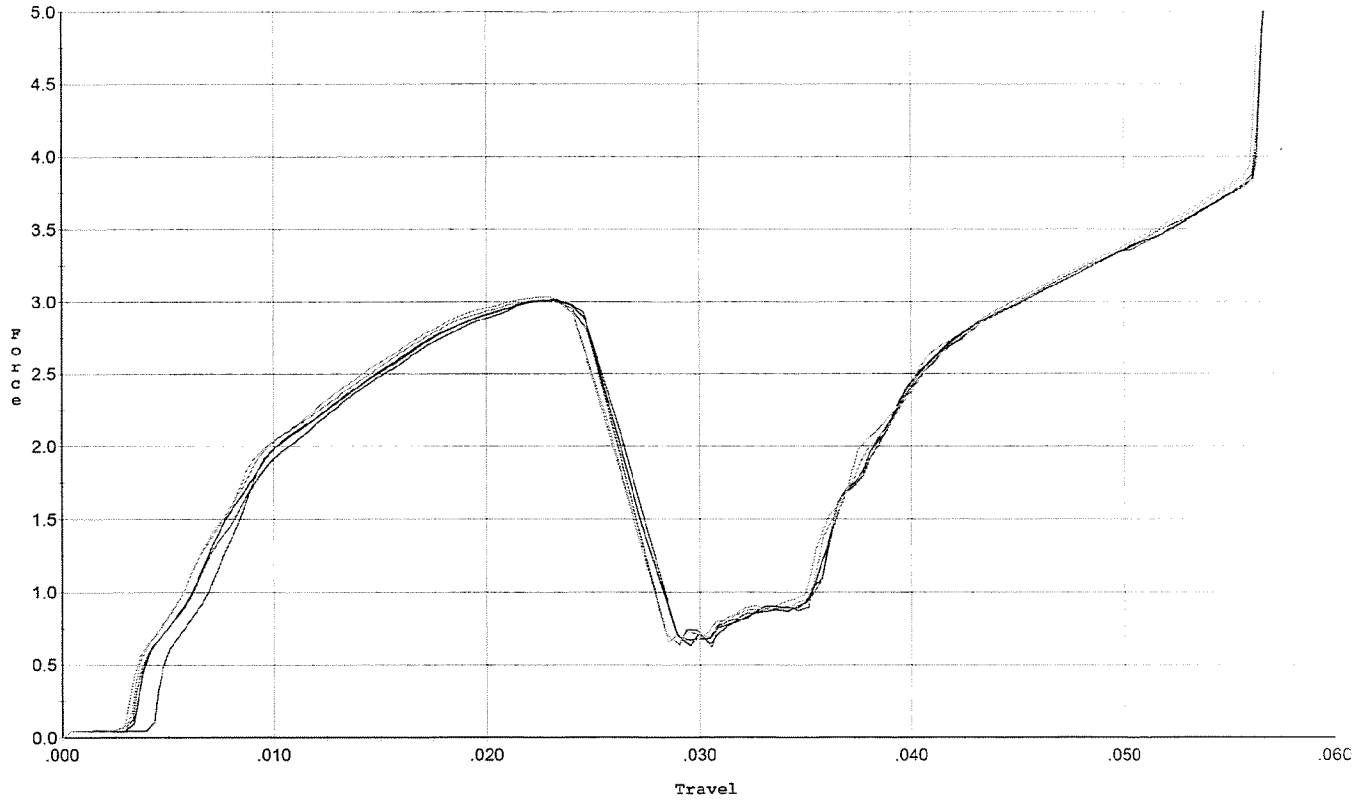
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.054      | 0.025             | 0.003           | 0.036      | 0.049             |           | Set Trigger |
| 2 | 3.031      | 0.025             | 0.004           | 0.036      | 0.046             |           | Set Trigger |
| 3 | 3.048      | 0.025             | 0.004           | 0.036      | 0.045             |           | Set Trigger |
| 4 | 3.058      | 0.025             | 0.005           | 0.036      | 0.046             |           | Set Trigger |
| 5 | 3.048      | 0.027             | 0.004           | 0.036      | 0.049             |           | Set Trigger |

Aug 3.04

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



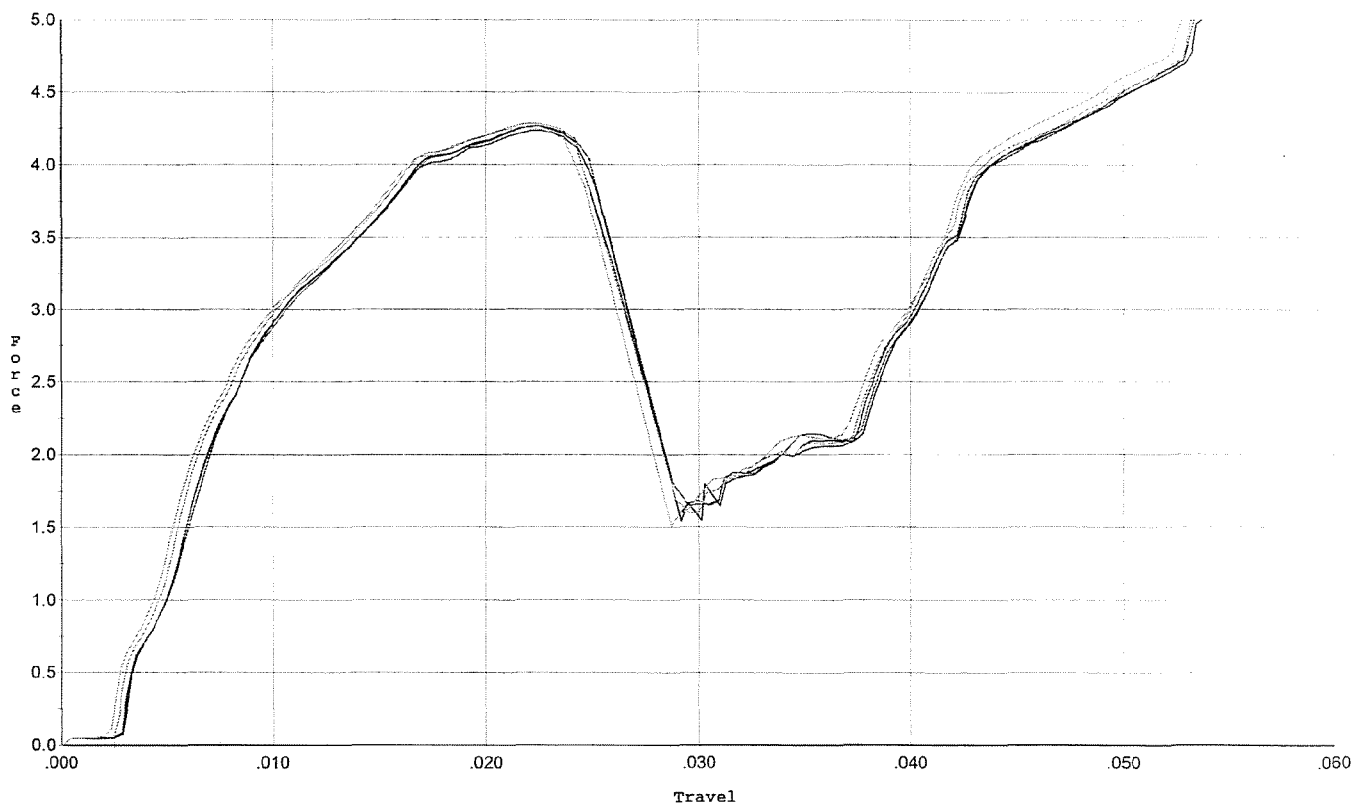
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.005      | 0.026             | 0.004           | 0.035      | 0.047             |           | Set Trigger |
| 2 | 3.014      | 0.025             | 0.004           | 0.036      | 0.046             |           | Set Trigger |
| 3 | 3.011      | 0.025             | 0.003           | 0.036      | 0.046             |           | Set Trigger |
| 4 | 3.034      | 0.026             | 0.003           | 0.035      | 0.049             |           | Set Trigger |
| 5 | 3.015      | 0.026             | 0.003           | 0.035      | 0.049             |           | Set Trigger |

Aug 3.01

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



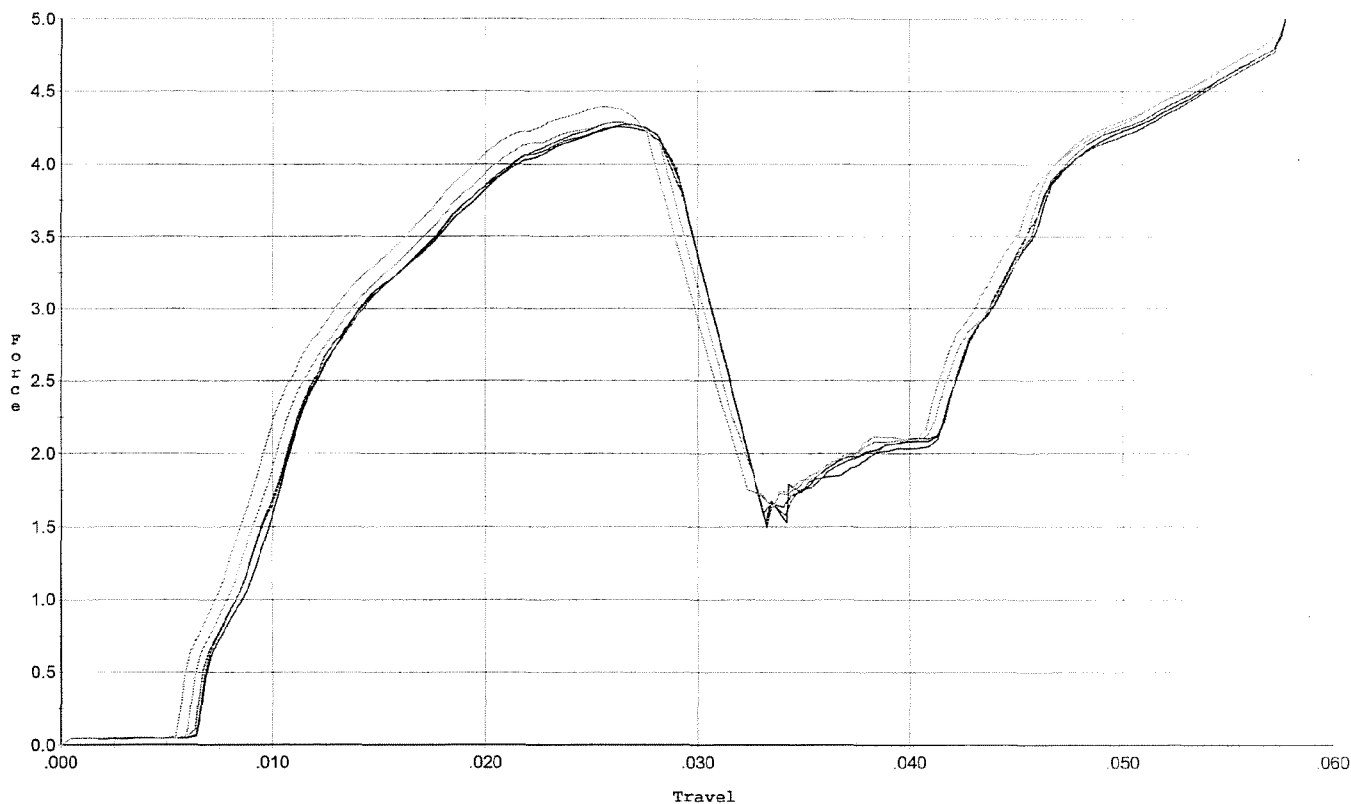
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.234      | 0.026             | 0.003           | 0.030      | 0.069             |           | Set Trigger |
| 2 | 4.264      | 0.025             | 0.003           | 0.030      | 0.067             |           | Set Trigger |
| 3 | 4.266      | 0.025             | 0.003           | 0.030      | 0.066             |           | Set Trigger |
| 4 | 4.255      | 0.025             | 0.002           | 0.030      | 0.067             |           | Set Trigger |
| 5 | 4.284      | 0.026             | 0.003           | 0.030      | 0.071             |           | Set Trigger |

Avg 4.26

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



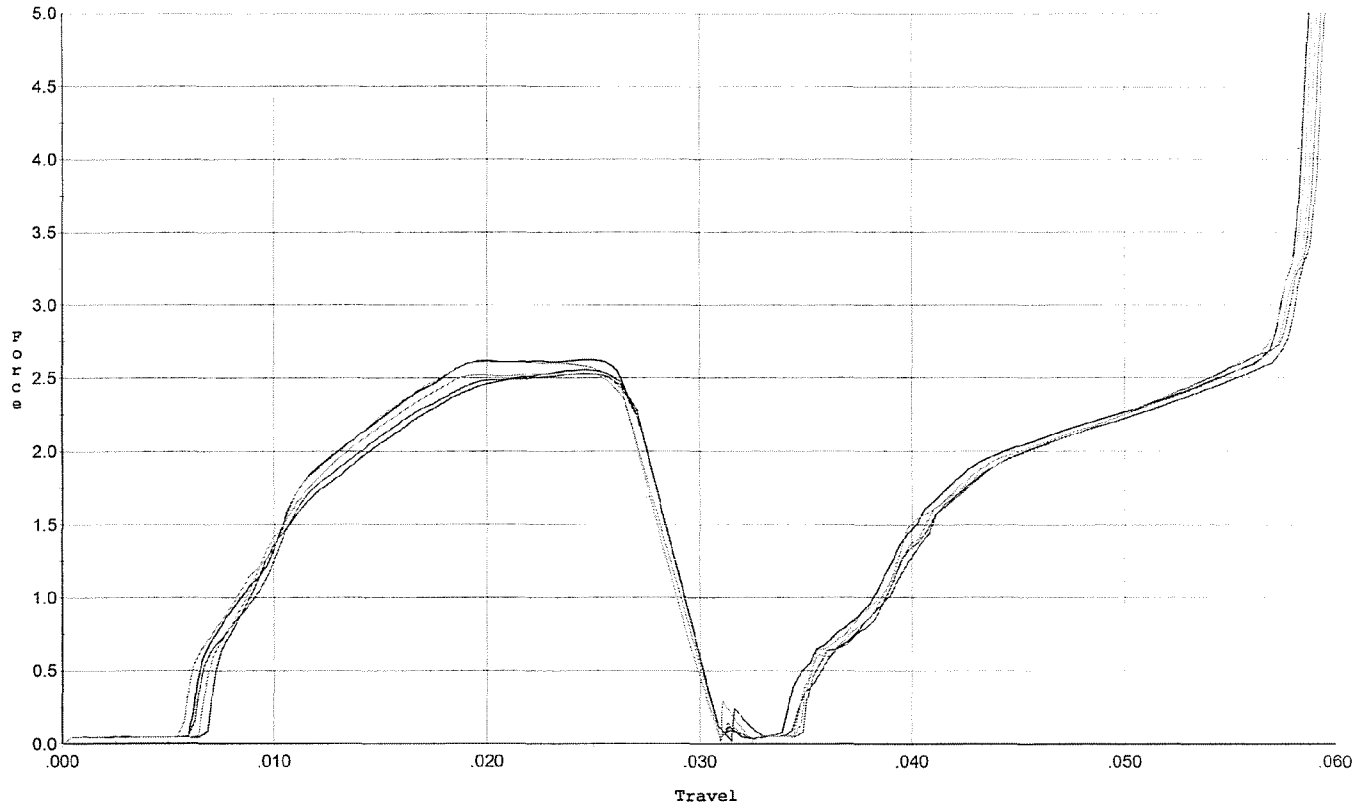
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.255      | 0.029             | 0.007           | 0.027      | 0.070             |           | Set Trigger |
| 2 | 4.271      | 0.029             | 0.007           | 0.027      | 0.069             |           | Set Trigger |
| 3 | 4.285      | 0.029             | 0.006           | 0.026      | 0.070             |           | Set Trigger |
| 4 | 4.283      | 0.028             | 0.006           | 0.026      | 0.069             |           | Set Trigger |
| 5 | 4.393      | 0.028             | 0.006           | 0.026      | 0.070             |           | Set Trigger |

Aug 4.29

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



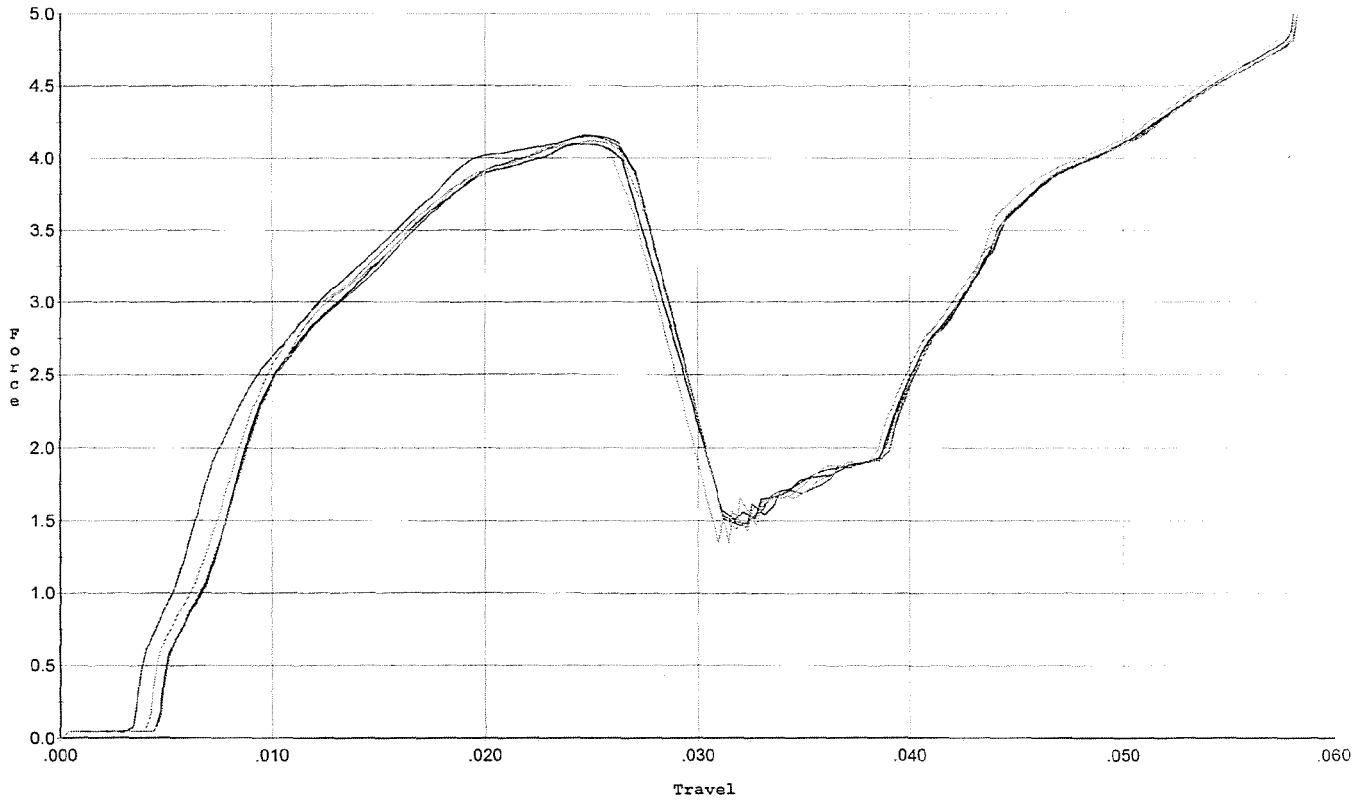
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.555      | 0.027             | 0.007           | 0.037      | 0.040             |           | Set Trigger |
| 2 | 2.626      | 0.027             | 0.006           | 0.037      | 0.043             |           | Set Trigger |
| 3 | 2.527      | 0.027             | 0.006           | 0.037      | 0.041             |           | Set Trigger |
| 4 | 2.539      | 0.026             | 0.007           | 0.037      | 0.040             |           | Set Trigger |
| 5 | 2.609      | 0.029             | 0.006           | 0.037      | 0.045             |           | Set Trigger |

Avg 2.57

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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 | 4.158      | 0.027             | 0.004           | 0.033      | 0.070             |           | Set Trigger |
| 2 | 4.098      | 0.029             | 0.005           | 0.033      | 0.070             |           | Set Trigger |
| 3 | 4.148      | 0.027             | 0.005           | 0.033      | 0.066             |           | Set Trigger |
| 4 | 4.104      | 0.027             | 0.004           | 0.033      | 0.067             |           | Set Trigger |
| 5 | 4.118      | 0.027             | 0.005           | 0.033      | 0.068             |           | Set Trigger |

Avg 4.12