

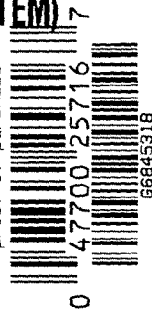
G6845318

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

- INSTRUCTION BOOK 3518

**BM FORM**

proof of purchase



owner registration sticker



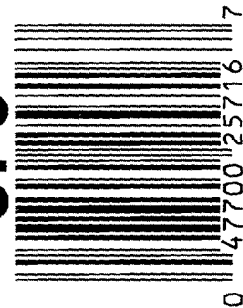
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6845318**

**UPC**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845318

| OP # | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |          | 3-17-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |          | 3-17-09 | RP      |
| 440  | PROOF                                                                                                                                  |          | 3-17-09 | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        |          | 3-17-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |          | 3-17-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-18-09 | RT      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-18-09 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | ①        | 3/20/09 | ①       |
| 490  | MAGNAFLUX BOLT                                                                                                                         |          |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |          | 3/24/09 | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |          | 3-24    | BT      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 3-28    |         |
| 545  | (BOLT)                                                                                                                                 |          |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |          |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 3-31-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 3-31-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 3-31-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 4-20-09 | 24      |
|      | 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

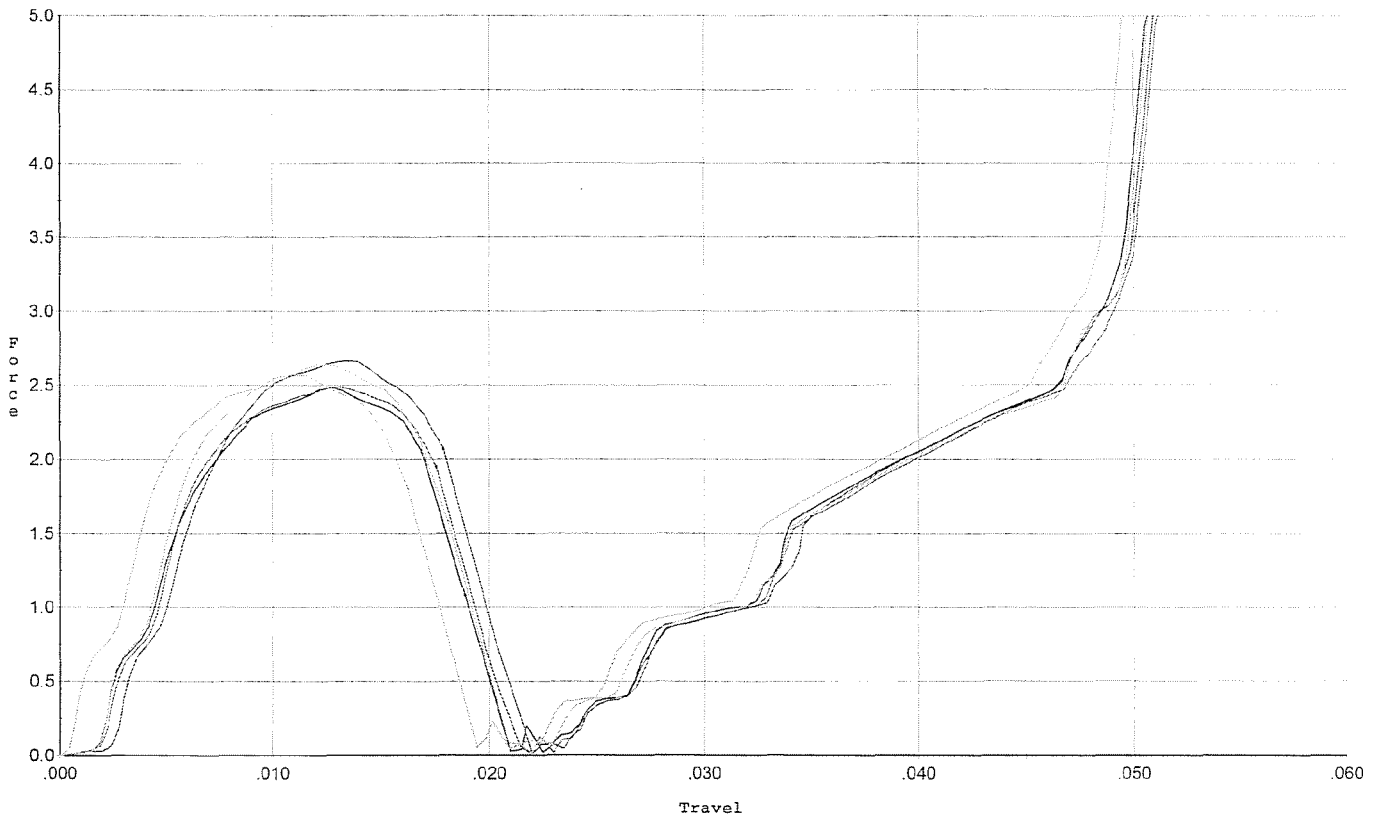
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>24</u> <u>24</u> <u>25</u>                               | 4/28/09 | RP      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>38</u> <u>38</u> <u>38</u>                               | 4/28/09 | RP      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.024</u>                         | 4/28/09 | RP      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 4-28-09 | LW      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 4/28/09 | RP      |
|              | 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                        | 4-21-09 | WV      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  | 4-21-09 | TAR     |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             |         |         |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 4/28/09 | RP      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.35</u> <u>2.50</u> <u>2.32</u> <u>2.32</u> <u>2.44</u> | 4-22-09 | WV      |
|              | C) FUNCTION                                                              |                                                             | 4/28/09 | RP      |
| 690          | PACK                                                                     |                                                             | 5/29/09 | Fuy     |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/13/2009

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



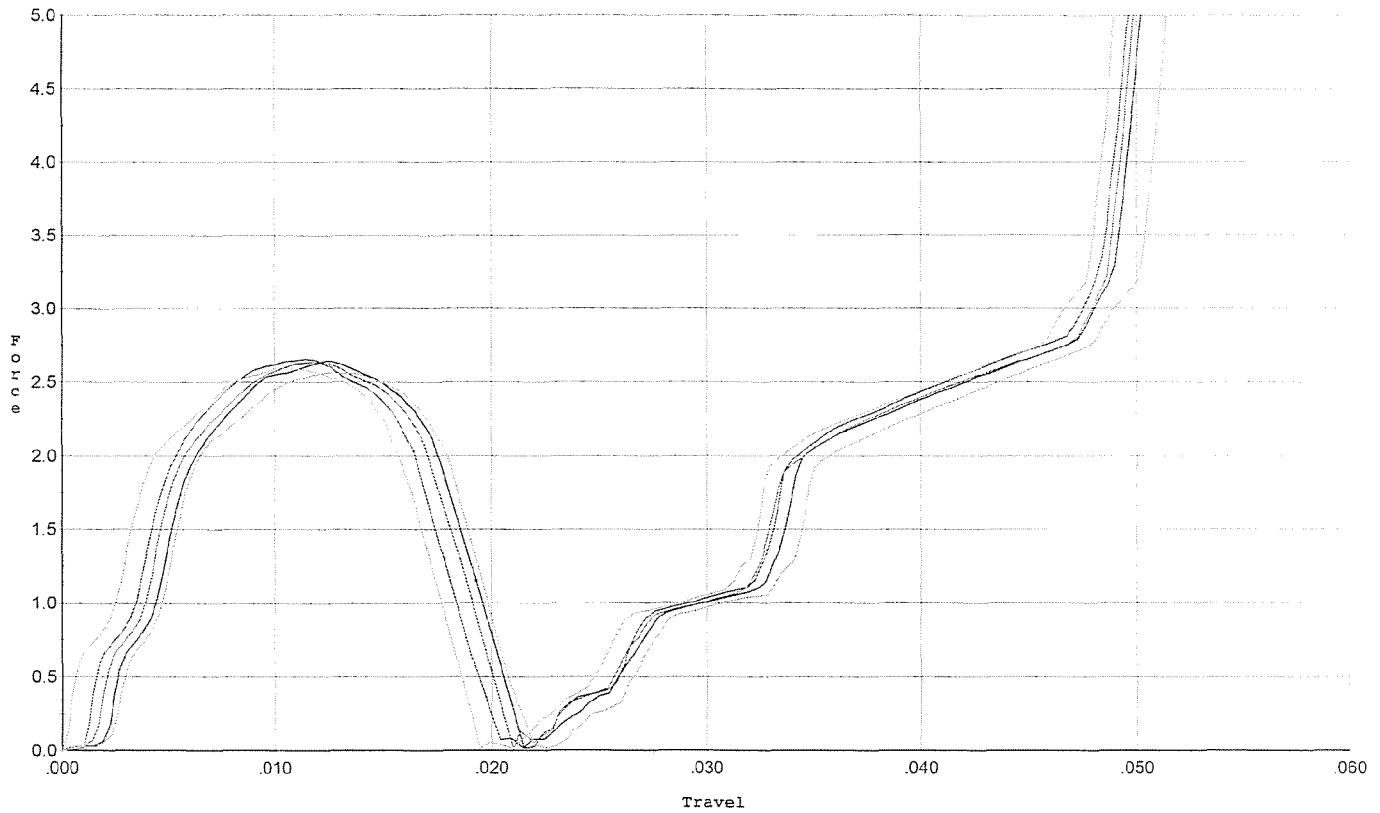
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.662      | 0.018             | 0.00            | 0.037      | 0.030             |           | Set Trigger |
| 2 | 2.488      | 0.019             | 0.00            | 0.037      | 0.030             |           | Set Trigger |
| 3 | 2.488      | 0.018             | 0.00            | 0.038      | 0.029             |           | Set Trigger |
| 4 | 2.638      | 0.018             | 0.00            | 0.037      | 0.031             |           | Set Trigger |
| 5 | 2.567      | 0.016             | 0.00            | 0.038      | 0.029             |           | Set Trigger |

A-2.56

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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



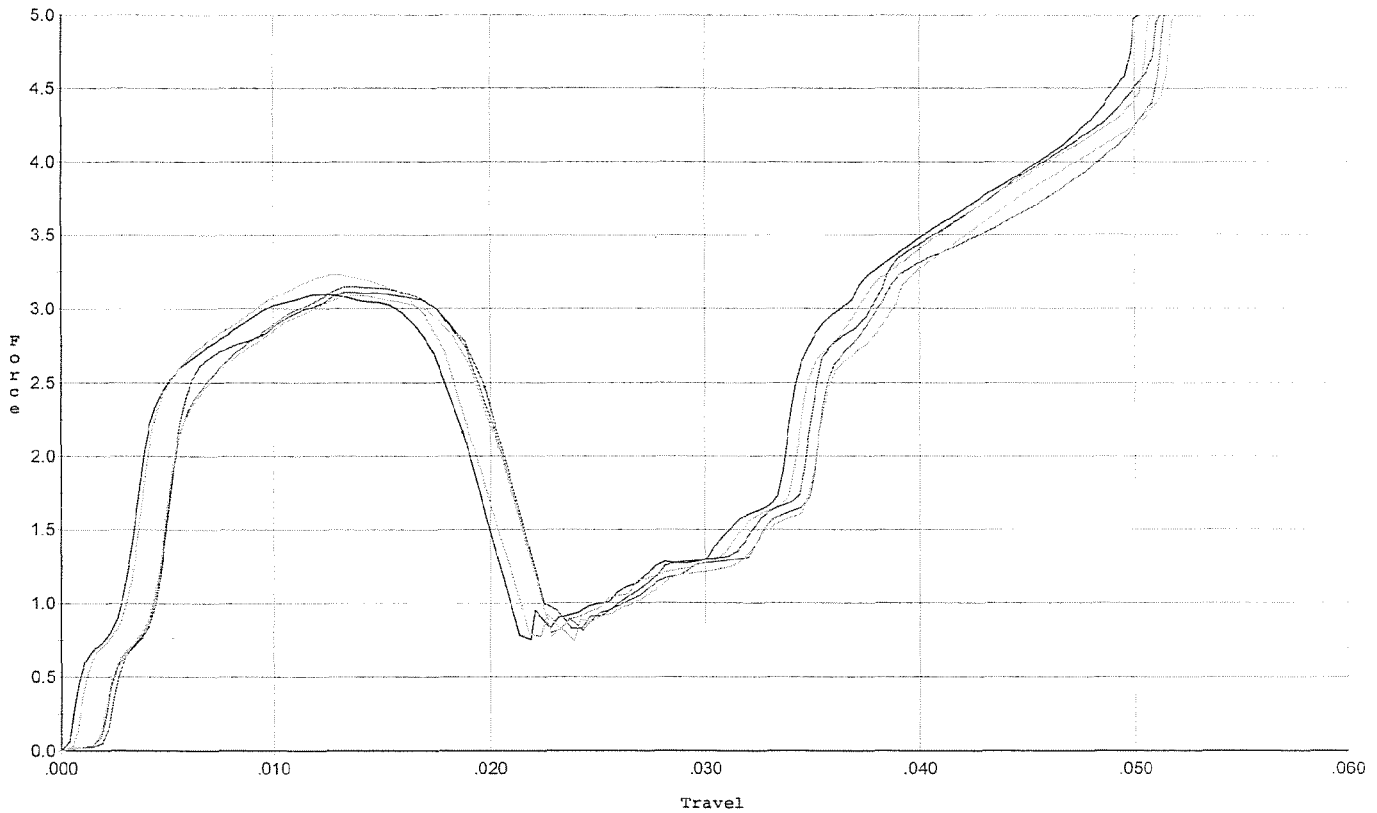
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.657      | 0.016             | 0.00            | 0.037      | 0.030             |           | Set Trigger |
| 2 | 2.645      | 0.019             | 0.00            | 0.036      | 0.033             |           | Set Trigger |
| 3 | 2.637      | 0.019             | 0.00            | 0.036      | 0.033             |           | Set Trigger |
| 4 | 2.598      | 0.016             | 0.00            | 0.037      | 0.031             |           | Set Trigger |
| 5 | 2.566      | 0.018             | 0.002           | 0.037      | 0.030             |           | Set Trigger |

A-2.62

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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



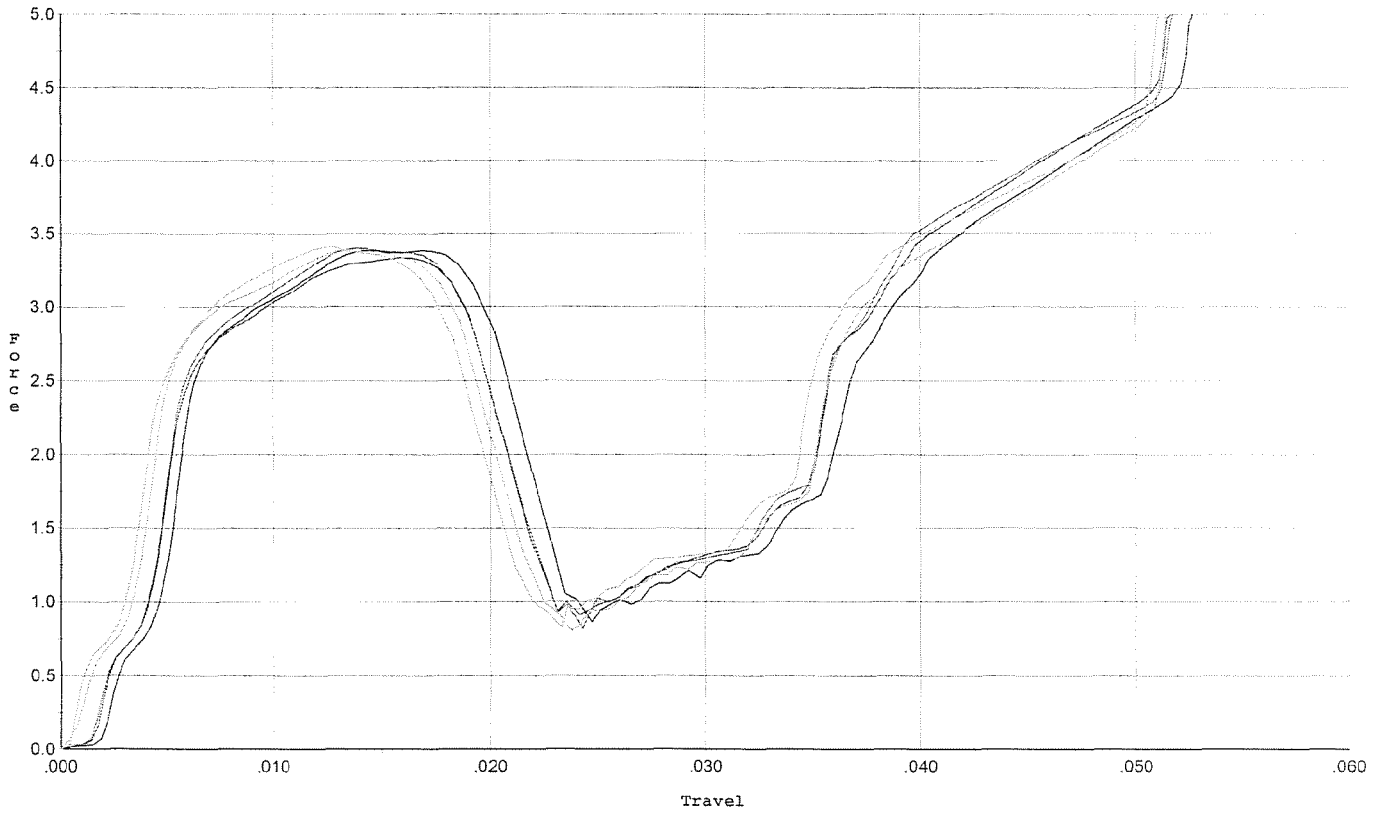
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.110      | 0.020             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 2 | 3.098      | 0.019             | 0.00            | 0.034      | 0.042             |           | Set Trigger |
| 3 | 3.150      | 0.020             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 4 | 3.089      | 0.020             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 5 | 3.231      | 0.020             | 0.00            | 0.035      | 0.045             |           | Set Trigger |

A-3-13

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.338      | 0.019             | 0.00            | 0.035      | 0.043             |           | Set Trigger |
| 2 | 3.385      | 0.020             | 0.002           | 0.035      | 0.046             |           | Set Trigger |
| 3 | 3.404      | 0.019             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 4 | 3.415      | 0.018             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 5 | 3.383      | 0.019             | 0.00            | 0.035      | 0.044             |           | Set Trigger |

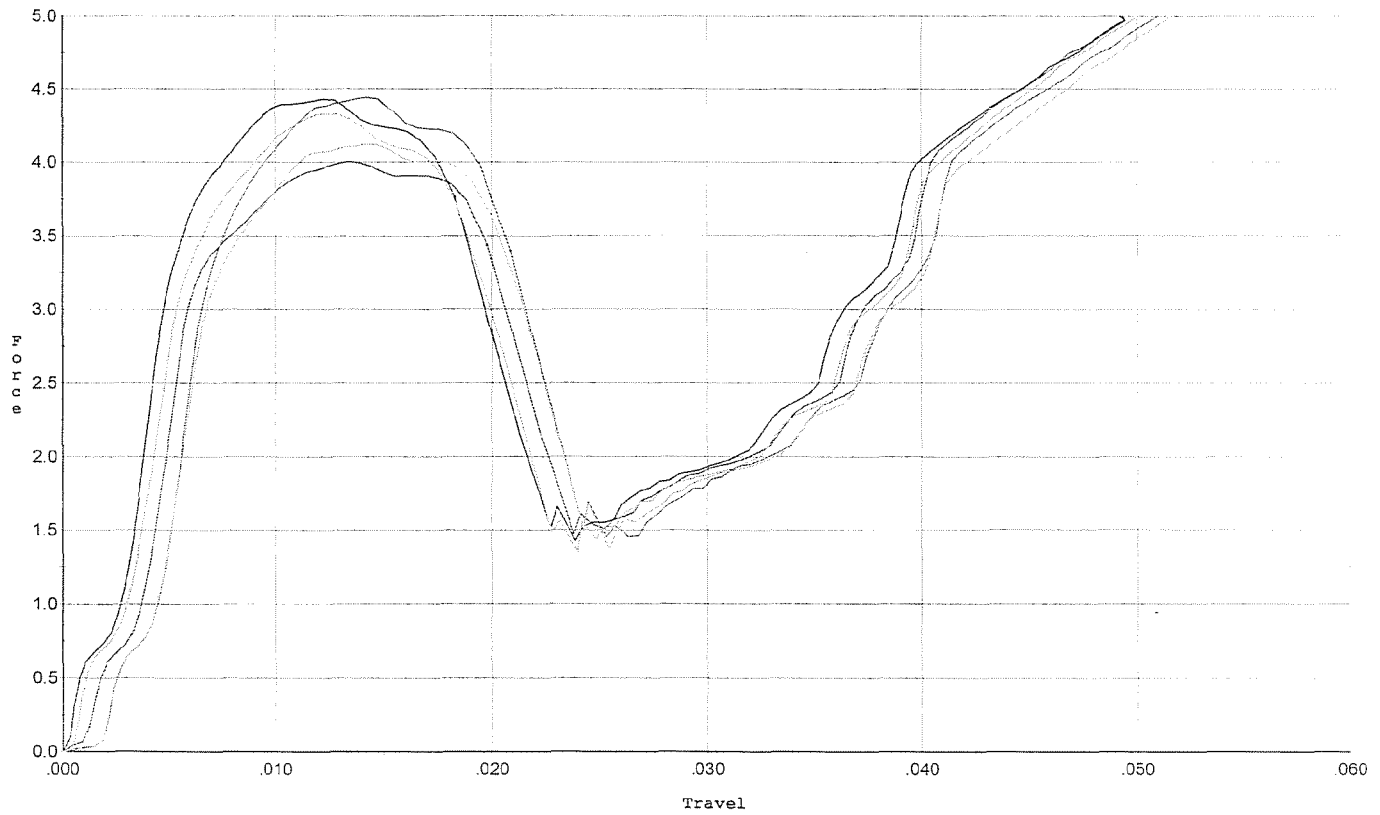
A-338



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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



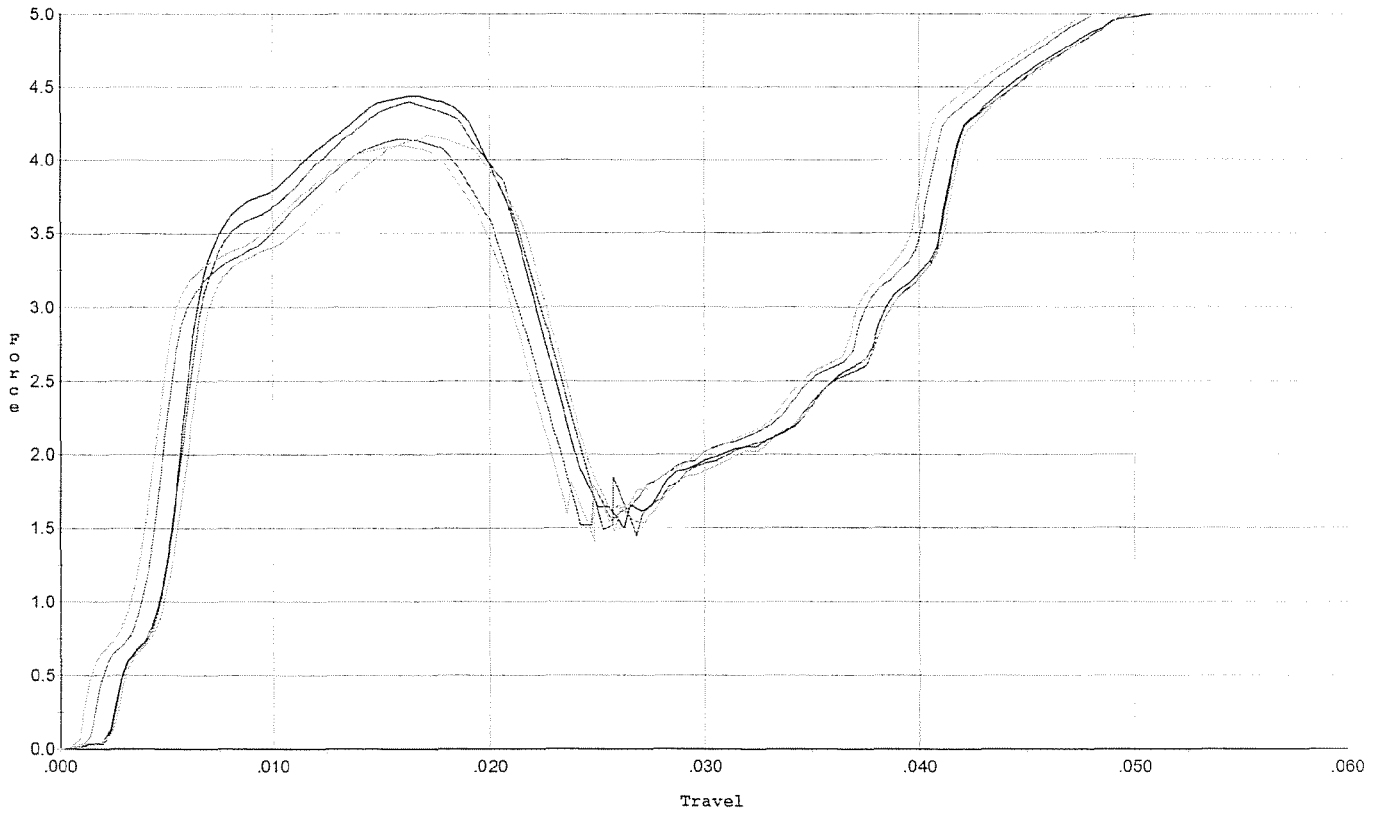
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.005      | 0.020             | 0.00            | 0.033      | 0.054             |           | Set Trigger |
| 2 | 4.431      | 0.018             | 0.00            | 0.033      | 0.056             |           | Set Trigger |
| 3 | 4.443      | 0.021             | 0.00            | 0.033      | 0.059             |           | Set Trigger |
| 4 | 4.126      | 0.021             | 0.00            | 0.033      | 0.057             |           | Set Trigger |
| 5 | 4.331      | 0.020             | 0.00            | 0.033      | 0.058             |           | Set Trigger |

A-4-26

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 4/13/2009

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



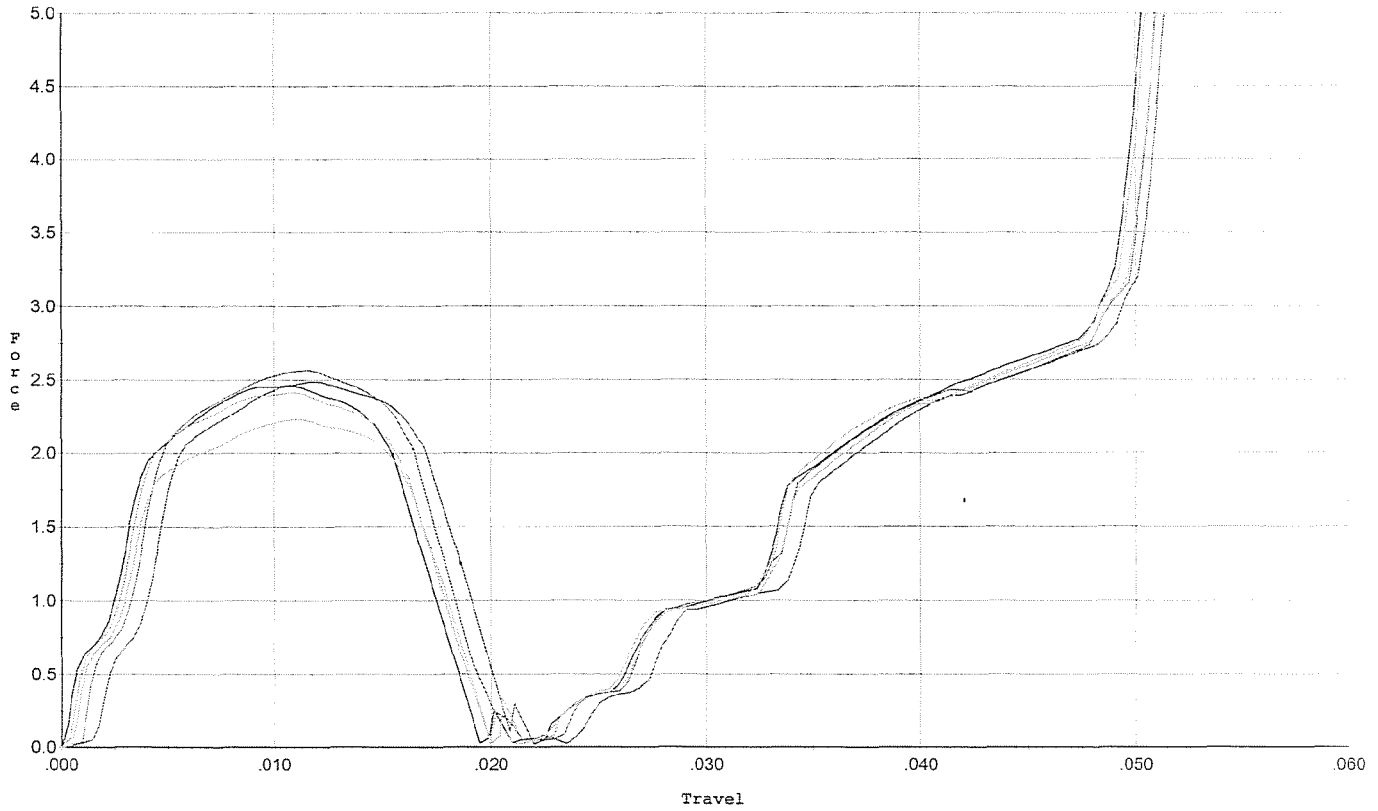
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.400      | 0.023             | 0.002           | 0.032      | 0.063             |           | Set Trigger |
| 2 | 4.437      | 0.021             | 0.00            | 0.033      | 0.059             |           | Set Trigger |
| 3 | 4.139      | 0.022             | 0.00            | 0.033      | 0.059             |           | Set Trigger |
| 4 | 4.099      | 0.021             | 0.00            | 0.033      | 0.057             |           | Set Trigger |
| 5 | 4.166      | 0.022             | 0.00            | 0.033      | 0.057             |           | Set Trigger |

A-424

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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



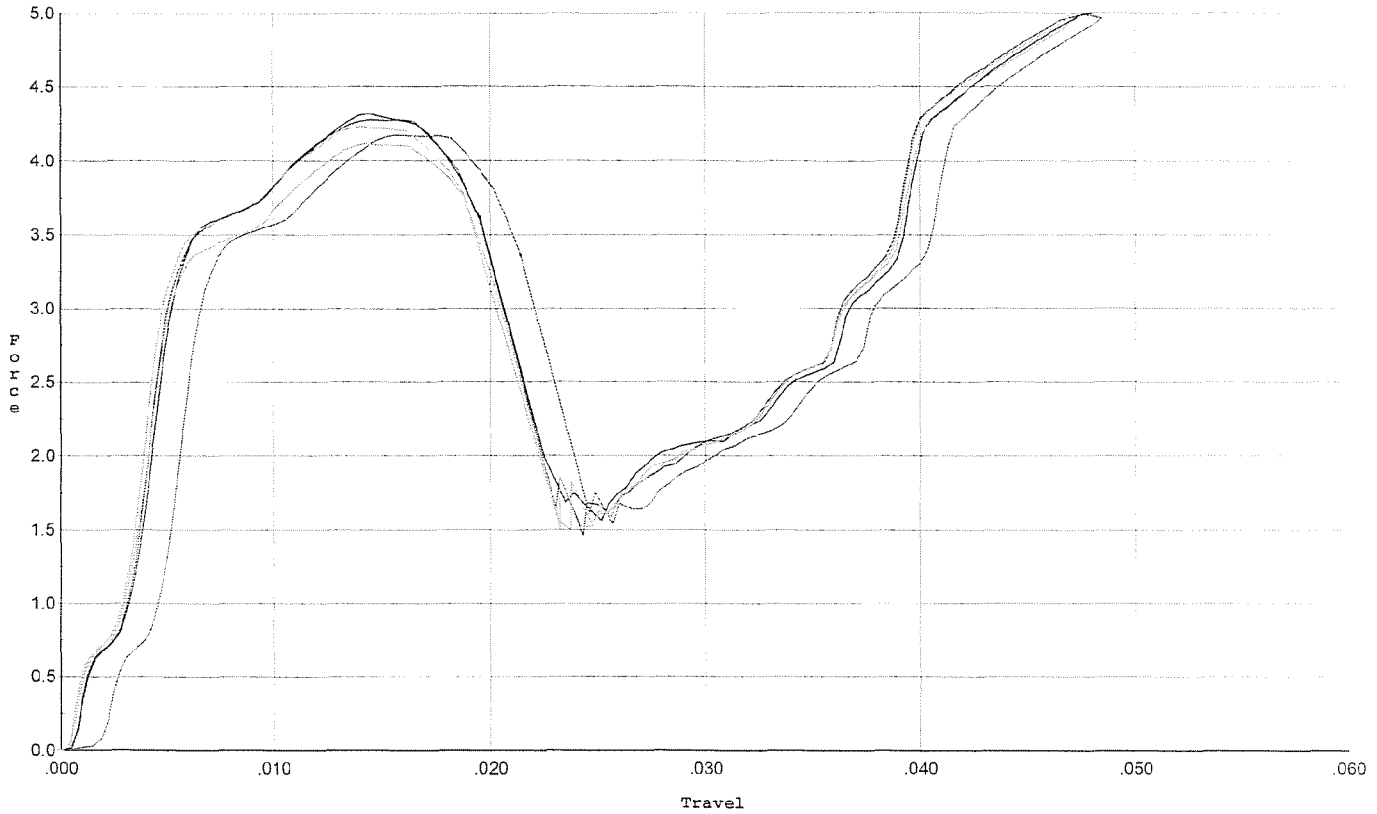
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.488      | 0.019             | 0.00            | 0.037      | 0.031             |           | Set Trigger |
| 2 | 2.465      | 0.015             | 0.00            | 0.038      | 0.028             |           | Set Trigger |
| 3 | 2.568      | 0.016             | 0.00            | 0.038      | 0.030             |           | Set Trigger |
| 4 | 2.234      | 0.018             | 0.00            | 0.038      | 0.029             |           | Set Trigger |
| 5 | 2.415      | 0.016             | 0.00            | 0.039      | 0.029             |           | Set Trigger |

A.2.43

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 4/13/2009

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 | 4.277      | 0.020             | 0.00            | 0.032      | 0.057             |           | Set Trigger |
| 2 | 4.319      | 0.019             | 0.00            | 0.033      | 0.057             |           | Set Trigger |
| 3 | 4.174      | 0.021             | 0.00            | 0.033      | 0.058             |           | Set Trigger |
| 4 | 4.231      | 0.019             | 0.00            | 0.033      | 0.055             |           | Set Trigger |
| 5 | 4.115      | 0.020             | 0.00            | 0.033      | 0.057             |           | Set Trigger |

A-4-22