

56801462

**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



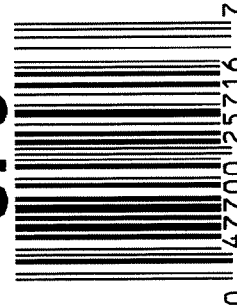
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

**G6801462**

**UPC**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801462

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 3-6-09  | RTZ     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 3-6-09  | RTZ     |
| 440  | PROOF                                                          |                     | 3-6-09  | TE      |
| 460  | CHECK HEADSPACE                                                |                     | 3-6-09  | TE      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 3-6-09  | RTZ     |
| 472  | SERIALIZE BOLT HANDLE                                          | MAGNA-FLUX          | 3-6-09  | RTZ     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   | MAR 0 2009          | 3-6-09  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR (A)        | 3-9-09  | (A)     |
| 490  | MAGNAFLUX BOLT                                                 |                     | 3-9-09  | MR      |
| 500  | ROLLMARK CALIBER                                               |                     | 3-9-09  | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 3-11    | MR      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3-20    |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-20-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 3-20-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 3-20-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 3-24-09 | SP      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

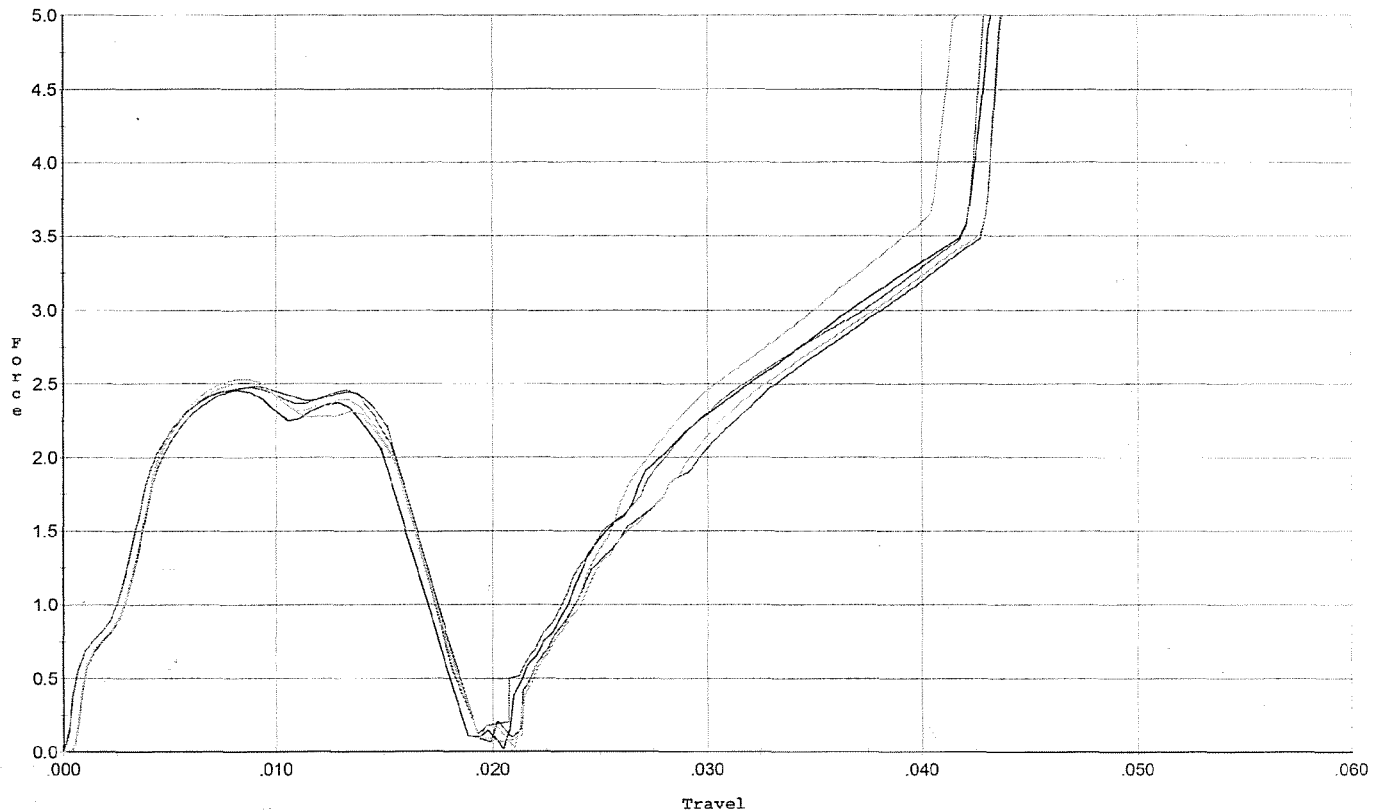
F004 REV 5/2006

| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>40</u> <u>40</u> <u>30</u>                               | 3-28-09 | XN      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>40</u> <u>40</u> <u>40</u>                               | 3-28-09 | XN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.024</u>                         | 3-28-09 | XN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-24-09 | XN      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-28-09 | 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                                              | <u>PASS</u> <u>FAIL</u><br><u>PASS</u> <u>FAIL</u>          | 3-26-09 | ZZ      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-26-09 | TC      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-28-09 | XN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.30</u> <u>2.34</u> <u>2.28</u> <u>2.29</u> <u>2.31</u> | 3-27-09 | TC      |
|              | C) FUNCTION                                                              |                                                             | 3-28-09 | XN      |
| 690          | PACK                                                                     |                                                             | 3/30/09 | Fm      |

## Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/23/2009

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



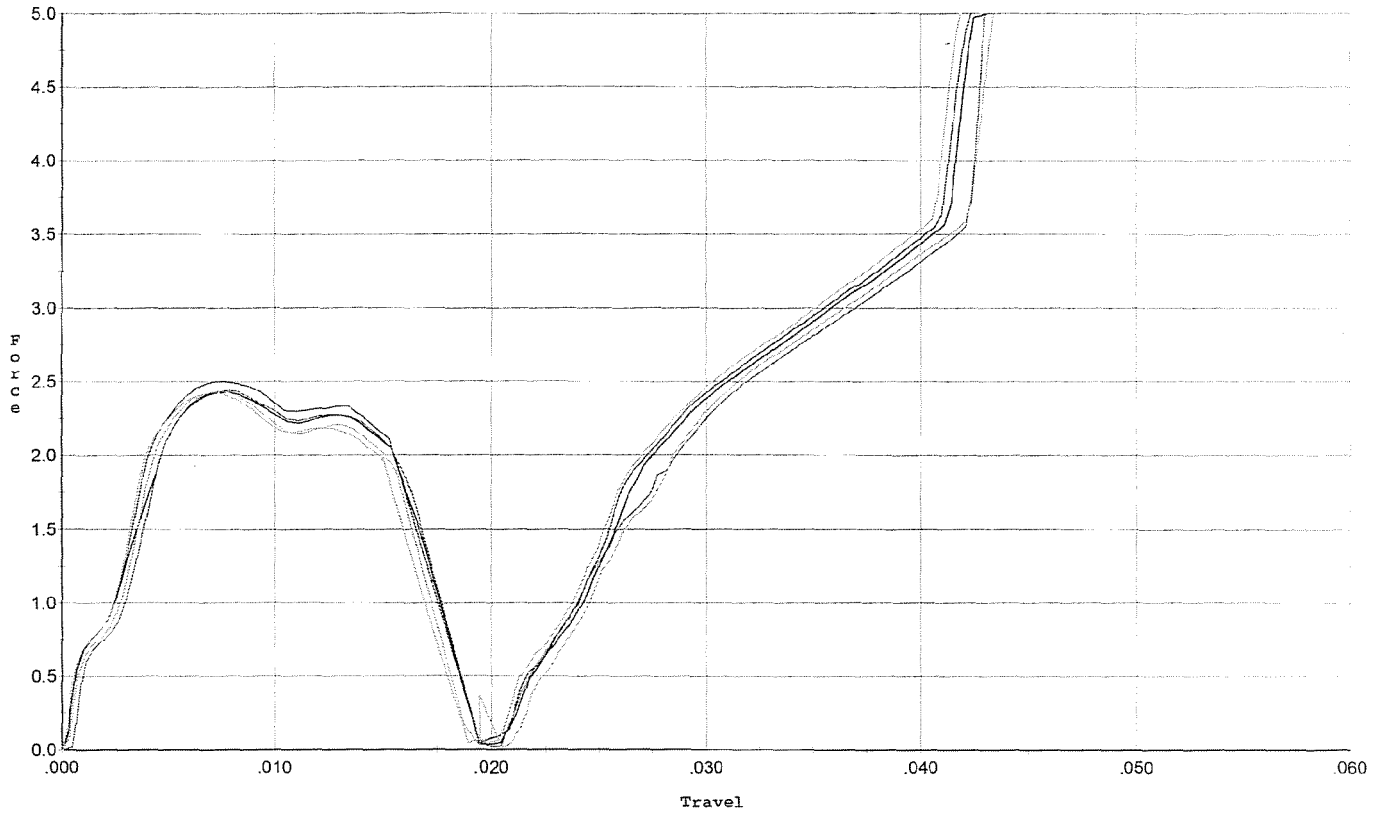
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.480      | 0.015             | 0.00            | 0.032      | 0.027             |           | Set Trigger |
| 2 | 2.455      | 0.015             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 3 | 2.475      | 0.015             | 0.00            | 0.030      | 0.028             |           | Set Trigger |
| 4 | 2.507      | 0.016             | 0.00            | 0.031      | 0.028             |           | Set Trigger |
| 5 | 2.533      | 0.015             | 0.00            | 0.029      | 0.028             |           | Set Trigger |

A-2.49

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/23/2009

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



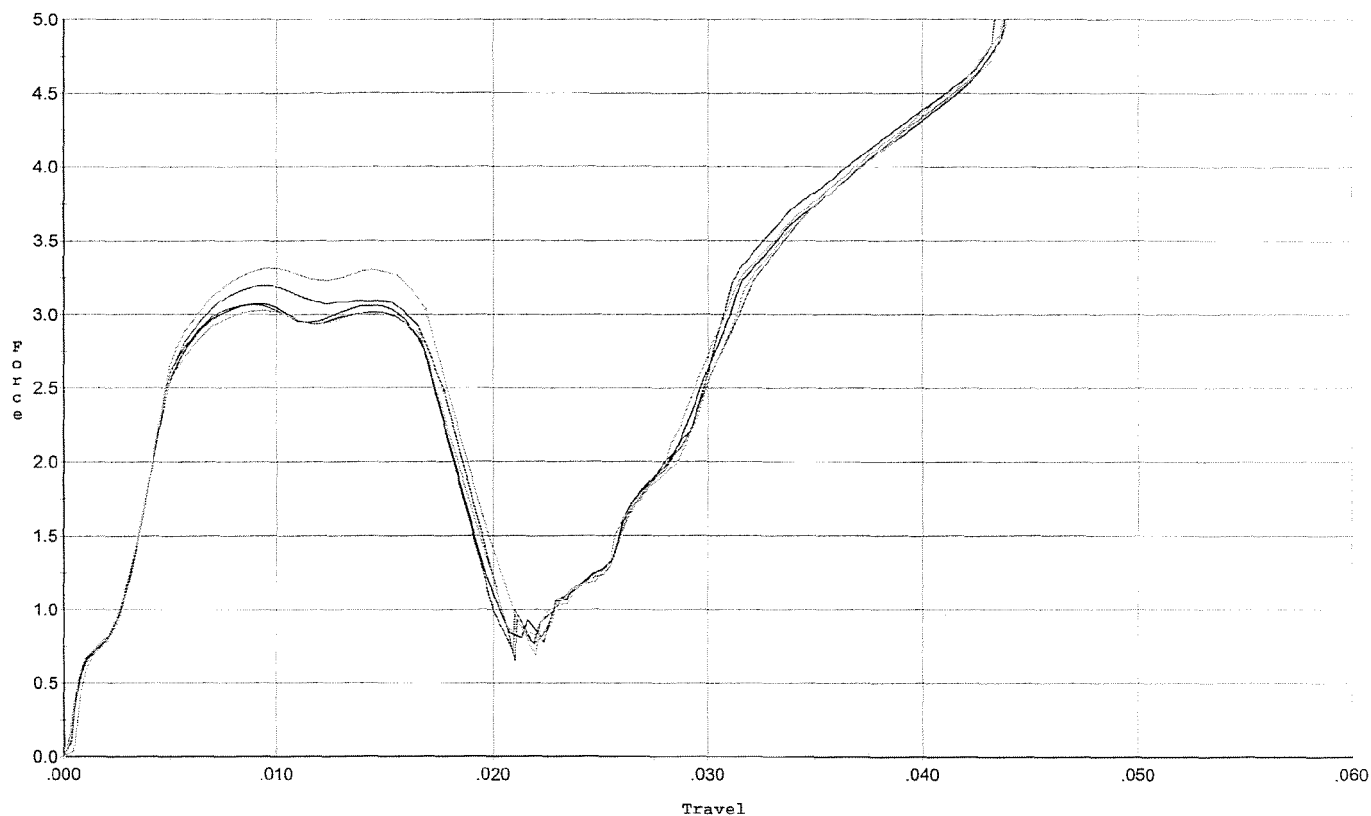
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.501      | 0.017             | 0.00            | 0.030      | 0.032             |           | Set Trigger |
| 2 | 2.428      | 0.017             | 0.00            | 0.030      | 0.030             |           | Set Trigger |
| 3 | 2.442      | 0.016             | 0.00            | 0.030      | 0.029             |           | Set Trigger |
| 4 | 2.425      | 0.015             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 5 | 2.436      | 0.016             | 0.00            | 0.031      | 0.027             |           | Set Trigger |

A 2.44

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



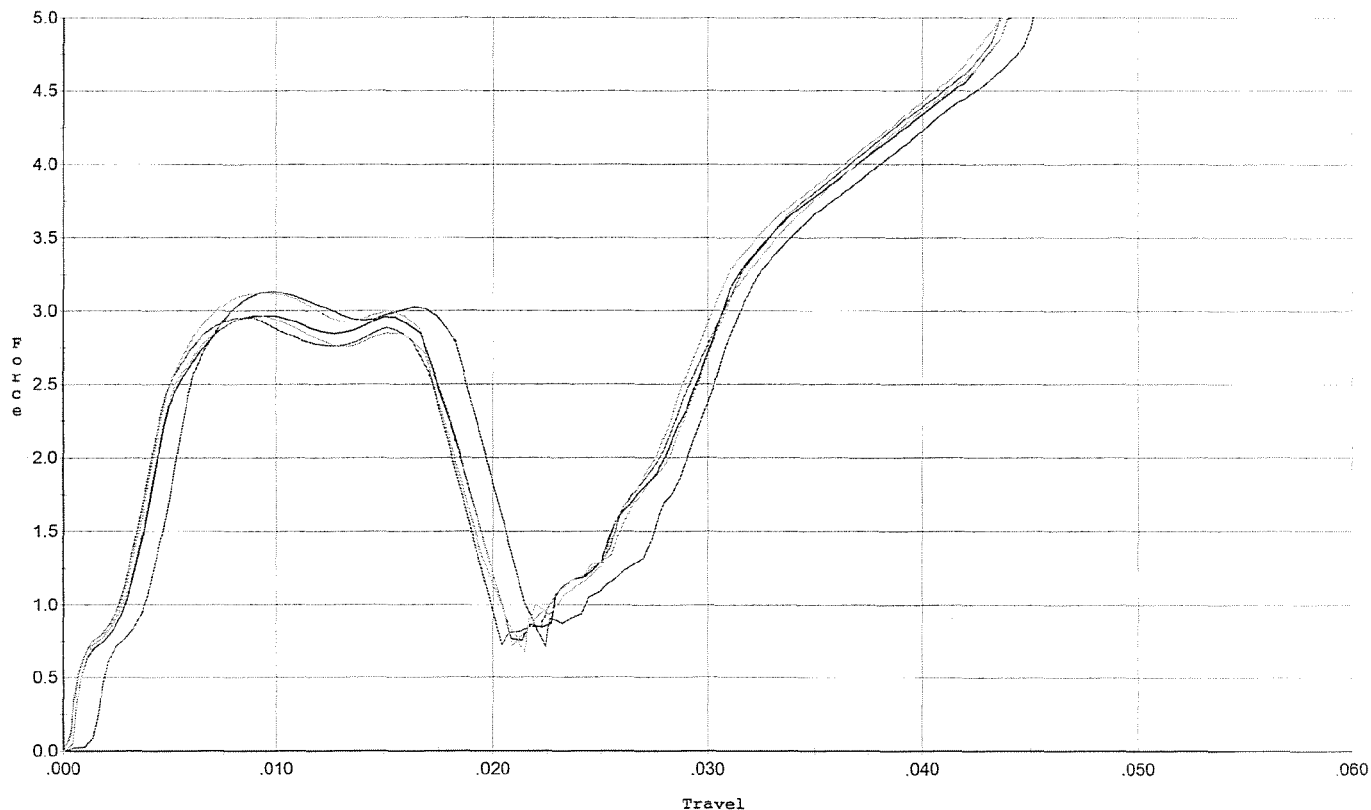
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.067      | 0.017             | 0.00            | 0.029      | 0.038             |           | Set Trigger |
| 2 | 3.073      | 0.017             | 0.00            | 0.029      | 0.038             |           | Set Trigger |
| 3 | 3.197      | 0.018             | 0.00            | 0.029      | 0.041             |           | Set Trigger |
| 4 | 3.030      | 0.017             | 0.00            | 0.029      | 0.037             |           | Set Trigger |
| 5 | 3.318      | 0.017             | 0.00            | 0.029      | 0.040             |           | Set Trigger |

A-3-13

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



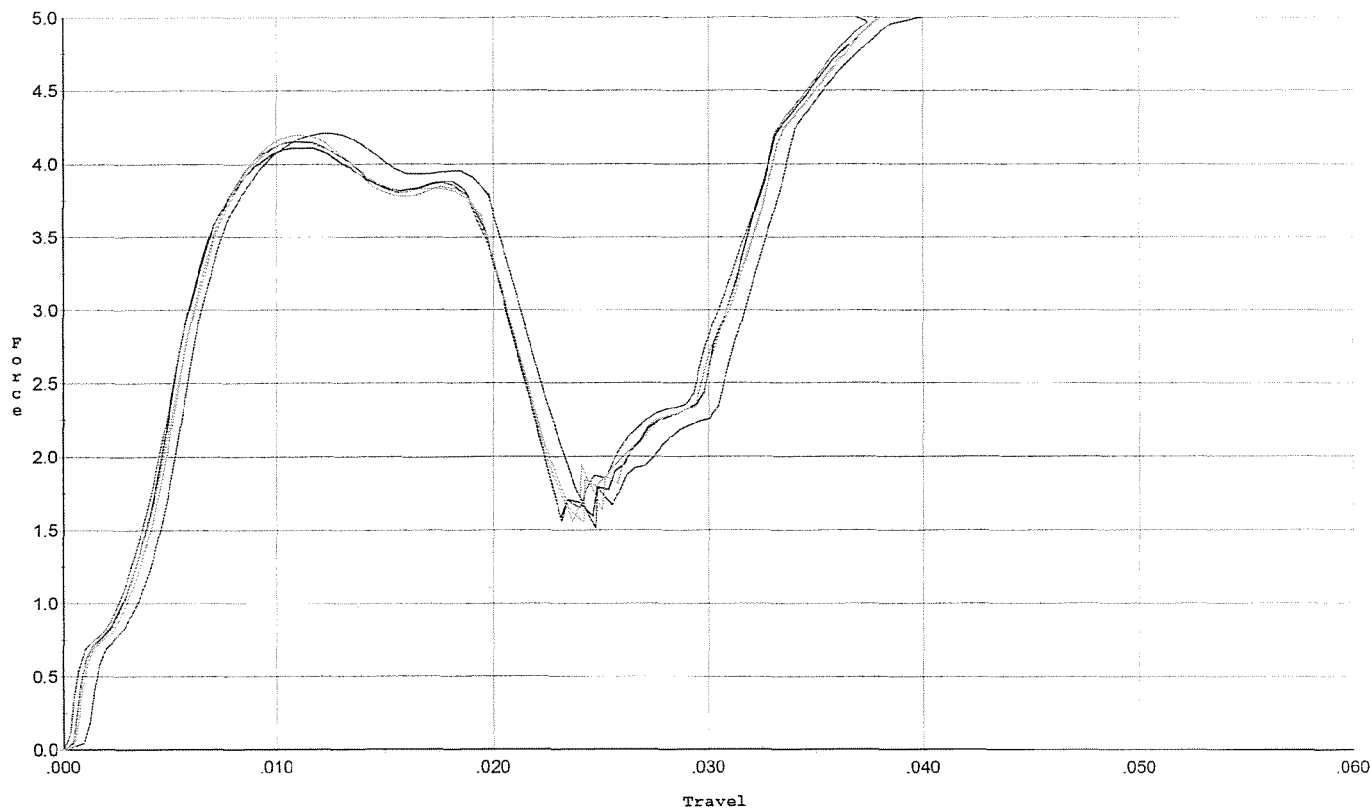
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.131      | 0.018             | 0.00            | 0.029      | 0.039             |           | Set Trigger |
| 2 | 2.965      | 0.018             | 0.00            | 0.029      | 0.040             |           | Set Trigger |
| 3 | 2.953      | 0.017             | 0.00            | 0.029      | 0.037             |           | Set Trigger |
| 4 | 3.119      | 0.018             | 0.00            | 0.029      | 0.041             |           | Set Trigger |
| 5 | 2.970      | 0.017             | 0.00            | 0.029      | 0.036             |           | Set Trigger |

A-3.08

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



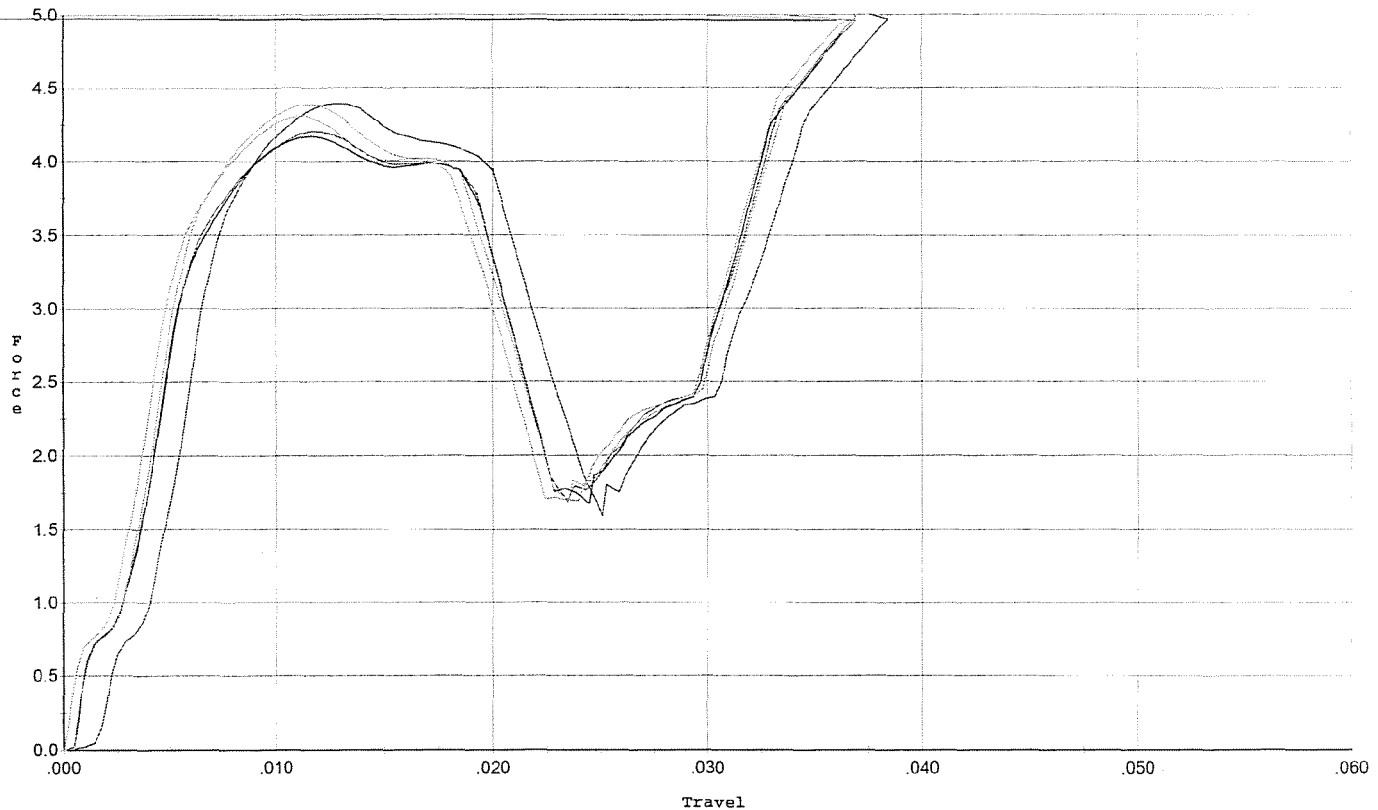
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.214      | 0.020             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 2 | 4.111      | 0.020             | 0.00            | 0.026      | 0.056             |           | Set Trigger |
| 3 | 4.150      | 0.020             | 0.00            | 0.026      | 0.056             |           | Set Trigger |
| 4 | 4.160      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 5 | 4.198      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |

A. 4.16

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



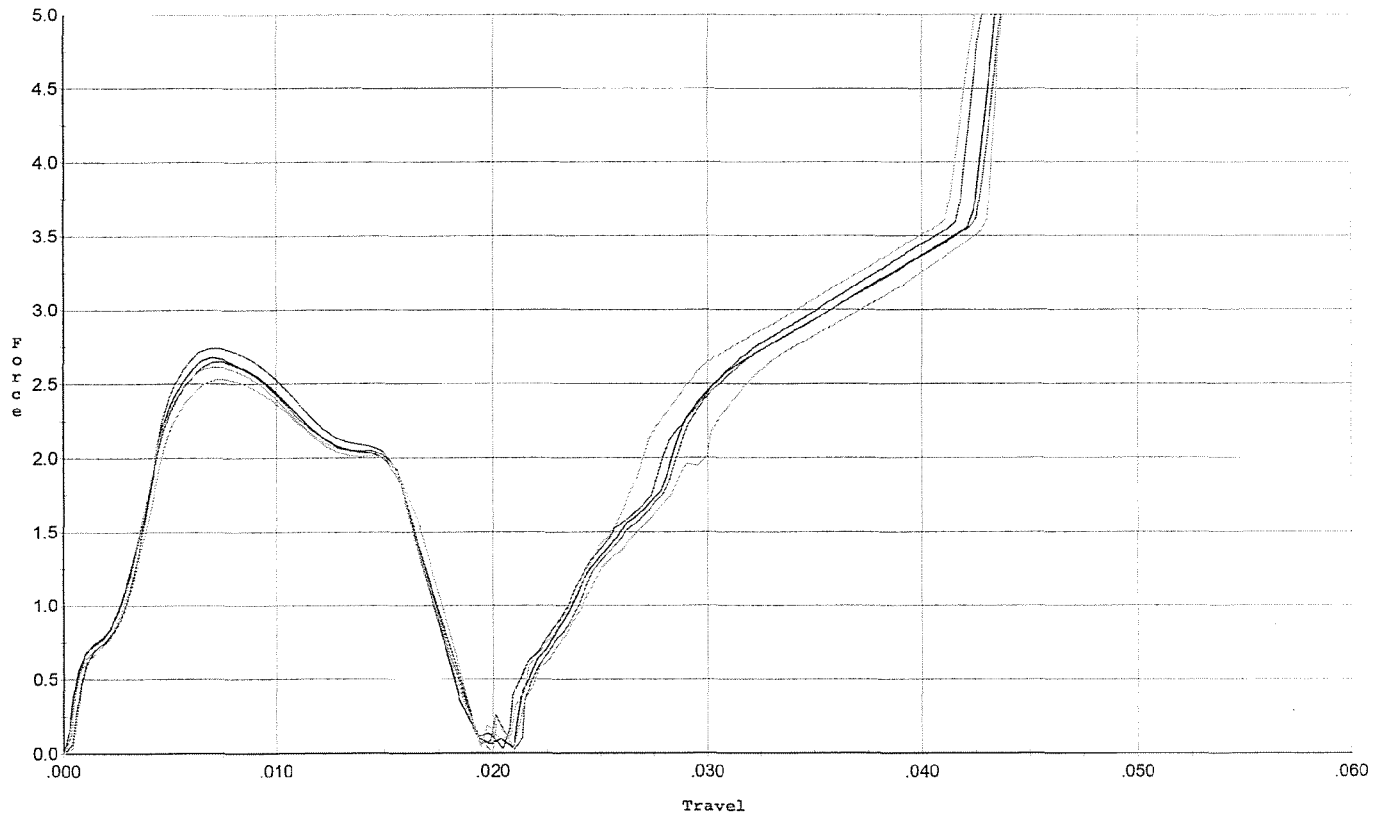
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.393      | 0.020             | 0.00            | 0.027      | 0.057             |           | Set Trigger |
| 2 | 4.170      | 0.019             | 0.00            | 0.026      | 0.056             |           | Set Trigger |
| 3 | 4.204      | 0.019             | 0.00            | 0.026      | 0.056             |           | Set Trigger |
| 4 | 4.306      | 0.020             | 0.00            | 0.026      | 0.059             |           | Set Trigger |
| 5 | 4.384      | 0.020             | 0.00            | 0.026      | 0.061             |           | Set Trigger |

A-4.29

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



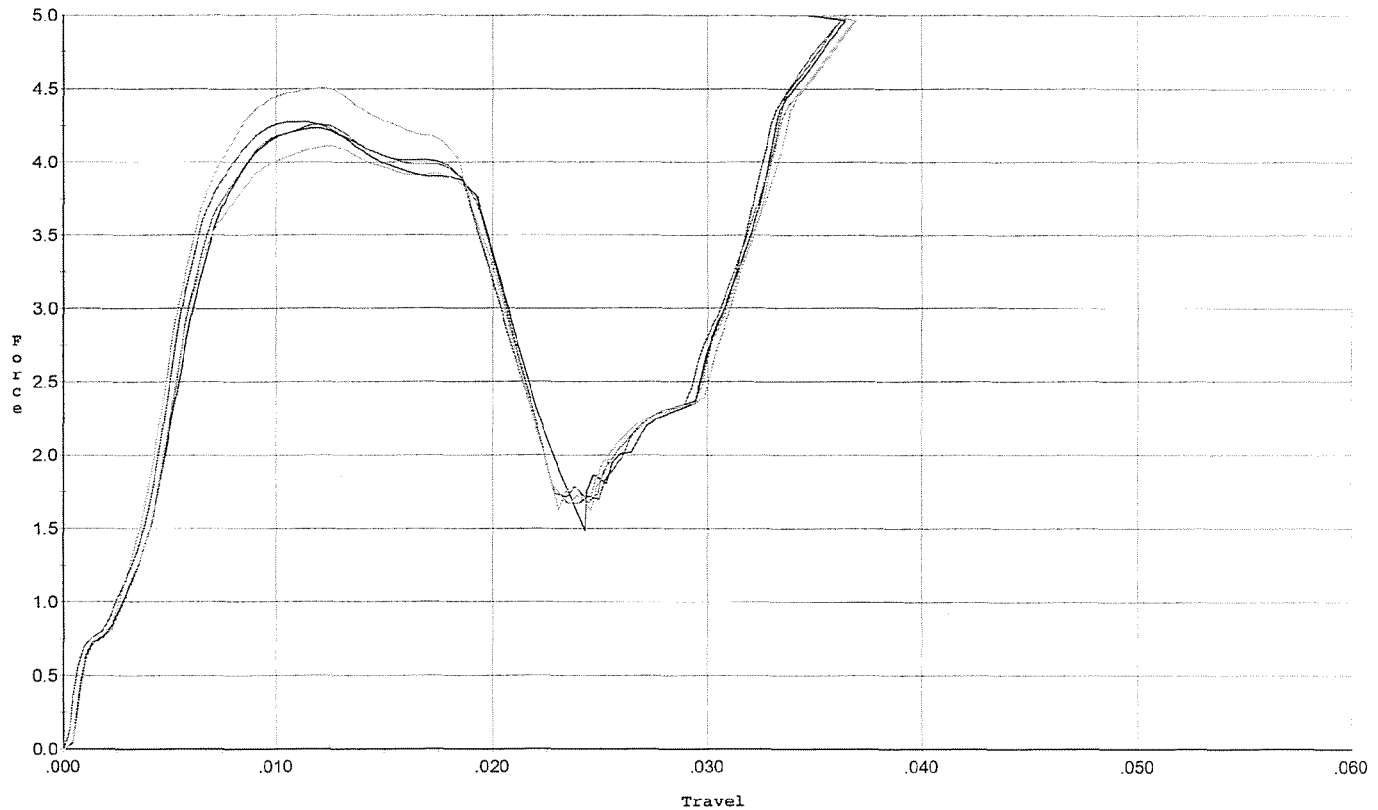
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.651      | 0.016             | 0.00            | 0.030      | 0.028             |           | Set Trigger |
| 2 | 2.679      | 0.016             | 0.00            | 0.031      | 0.029             |           | Set Trigger |
| 3 | 2.742      | 0.016             | 0.00            | 0.031      | 0.029             |           | Set Trigger |
| 4 | 2.534      | 0.017             | 0.00            | 0.030      | 0.029             |           | Set Trigger |
| 5 | 2.615      | 0.016             | 0.00            | 0.031      | 0.028             |           | Set Trigger |

A-2-64

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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 | 4.274      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 2 | 4.232      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 3 | 4.258      | 0.019             | 0.00            | 0.026      | 0.056             |           | Set Trigger |
| 4 | 4.507      | 0.018             | 0.00            | 0.027      | 0.056             |           | Set Trigger |
| 5 | 4.108      | 0.020             | 0.00            | 0.026      | 0.057             |           | Set Trigger |

A-4.27