

66801338

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



**BM FORM**

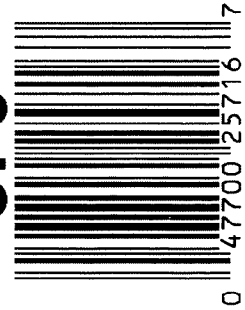
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6801338**

**UPC**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801338

| 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  | TC      |
| 460  | CHECK HEADSPACE                                                                                                                        |          | 3-6-09  | TC      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |          | 3-6-09  | RTZ     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-6-09  | RTZ     |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | (A)      | 3/9/09  | (A)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |          | 3/9/09  | nd      |
| 500  | ROLLMARK CALIBER                                                                                                                       |          | 3/9/09  | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-6-09  | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |          | 3/11    | non     |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 5-20    |         |
| 545  | (BOLT)                                                                                                                                 |          |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |          |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 3-20-09 | J       |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 3-20-09 | J       |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 3-20-09 | J       |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 3-23-09 | R, JV   |
|      | 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

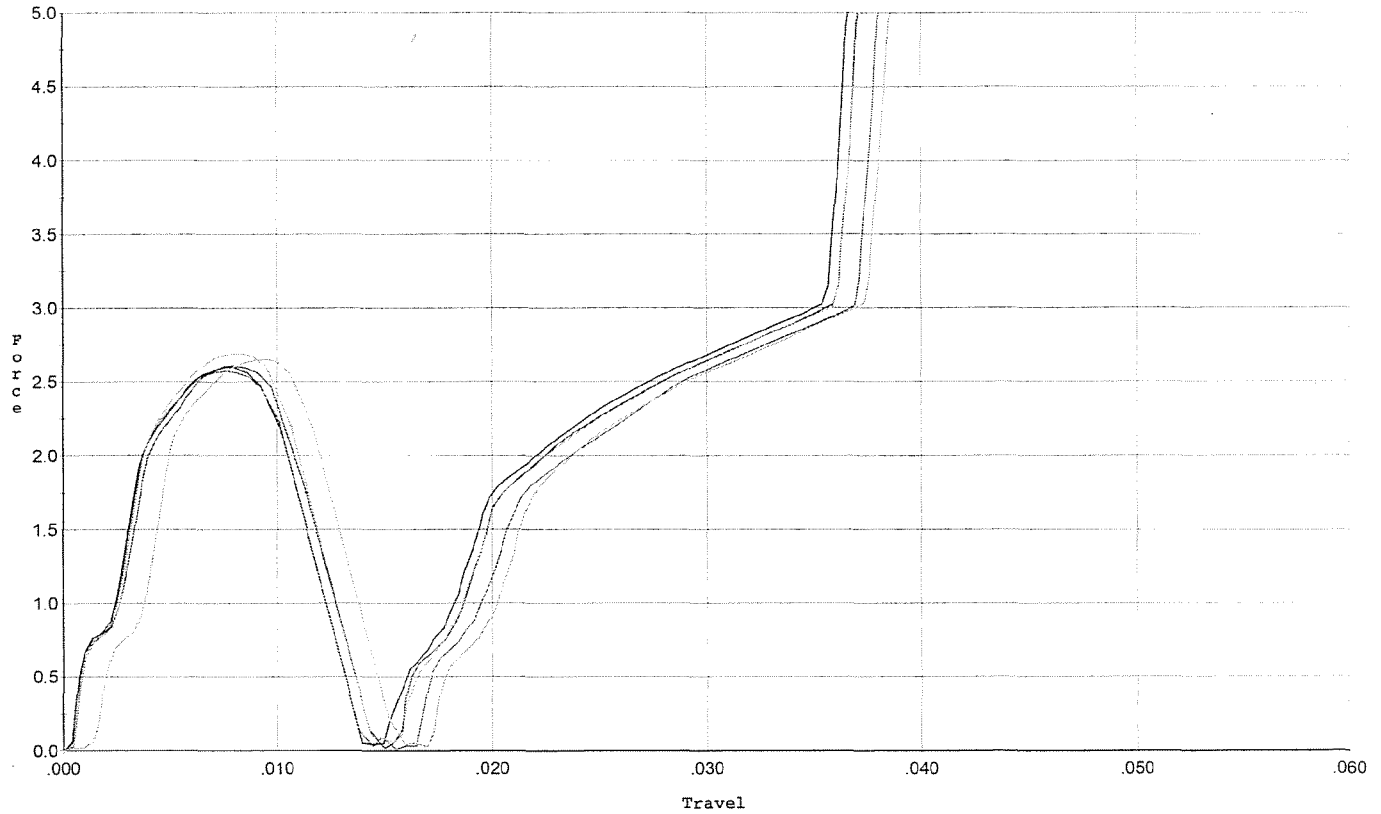
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>6.5</u> <u>7</u> <u>7</u>                                | 3-25-09 | NW      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4</u> <u>4</u> <u>4</u>                                  | 3-25-09 | NW      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.022</u>                         | 3-25-09 | NW      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-22-09 | TD      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-27-09 | TD      |
|              | 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                        | 3-24-09 | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  | n/a     |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-24-09 | NW      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-25-09 | NW      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.25</u> <u>2.27</u> <u>2.37</u> <u>2.43</u> <u>2.37</u> | 3-24-09 | TC      |
|              | C) FUNCTION                                                              |                                                             | 3-25-09 | NW      |
| 690          | PACK                                                                     |                                                             | 3-28-09 | TC      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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



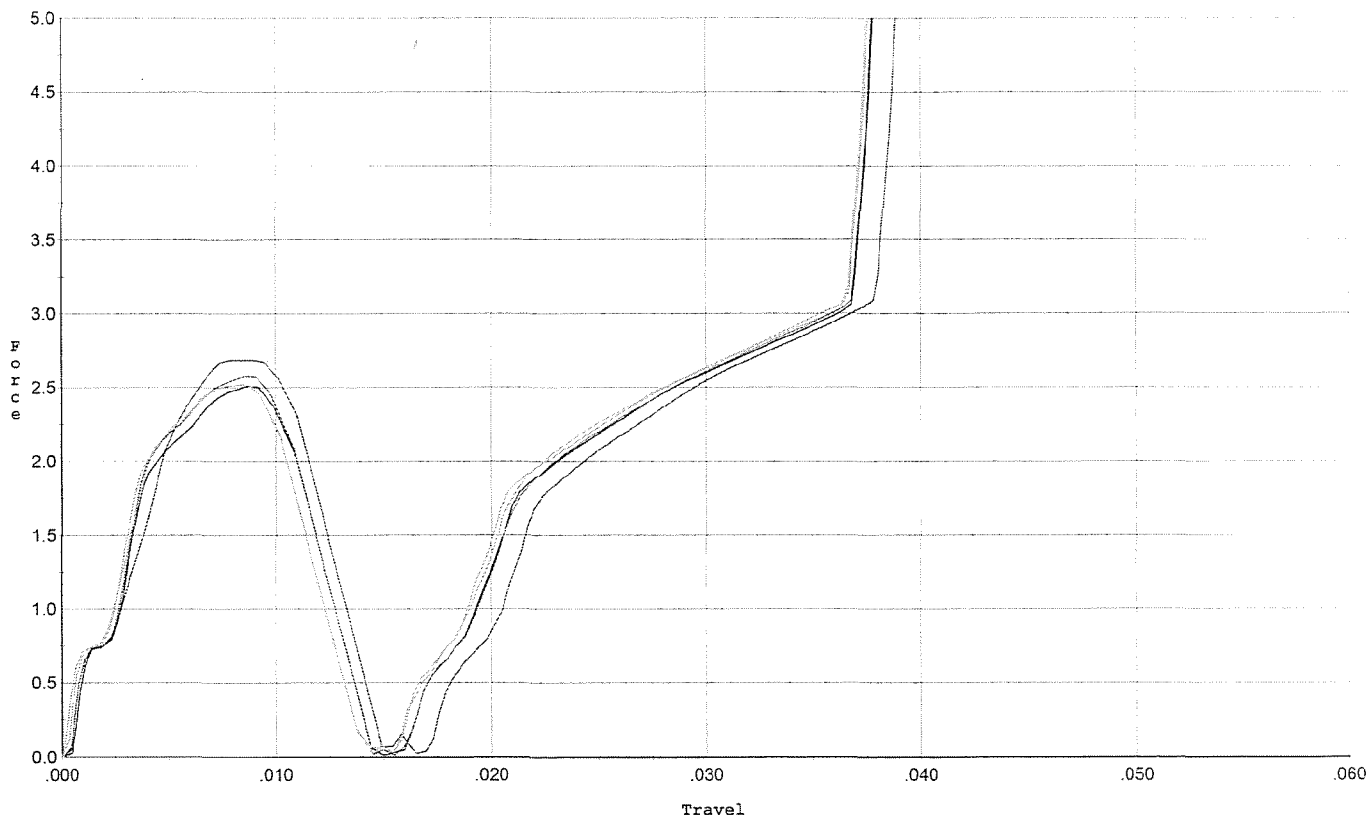
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.605      | 0.011             | 0.00            | 0.029      | 0.019             |           | Set Trigger |
| 2 | 2.595      | 0.010             | 0.00            | 0.029      | 0.018             |           | Set Trigger |
| 3 | 2.573      | 0.010             | 0.00            | 0.030      | 0.017             |           | Set Trigger |
| 4 | 2.691      | 0.011             | 0.00            | 0.029      | 0.019             |           | Set Trigger |
| 5 | 2.652      | 0.012             | 0.00            | 0.030      | 0.019             |           | Set Trigger |

A. 2-62

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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



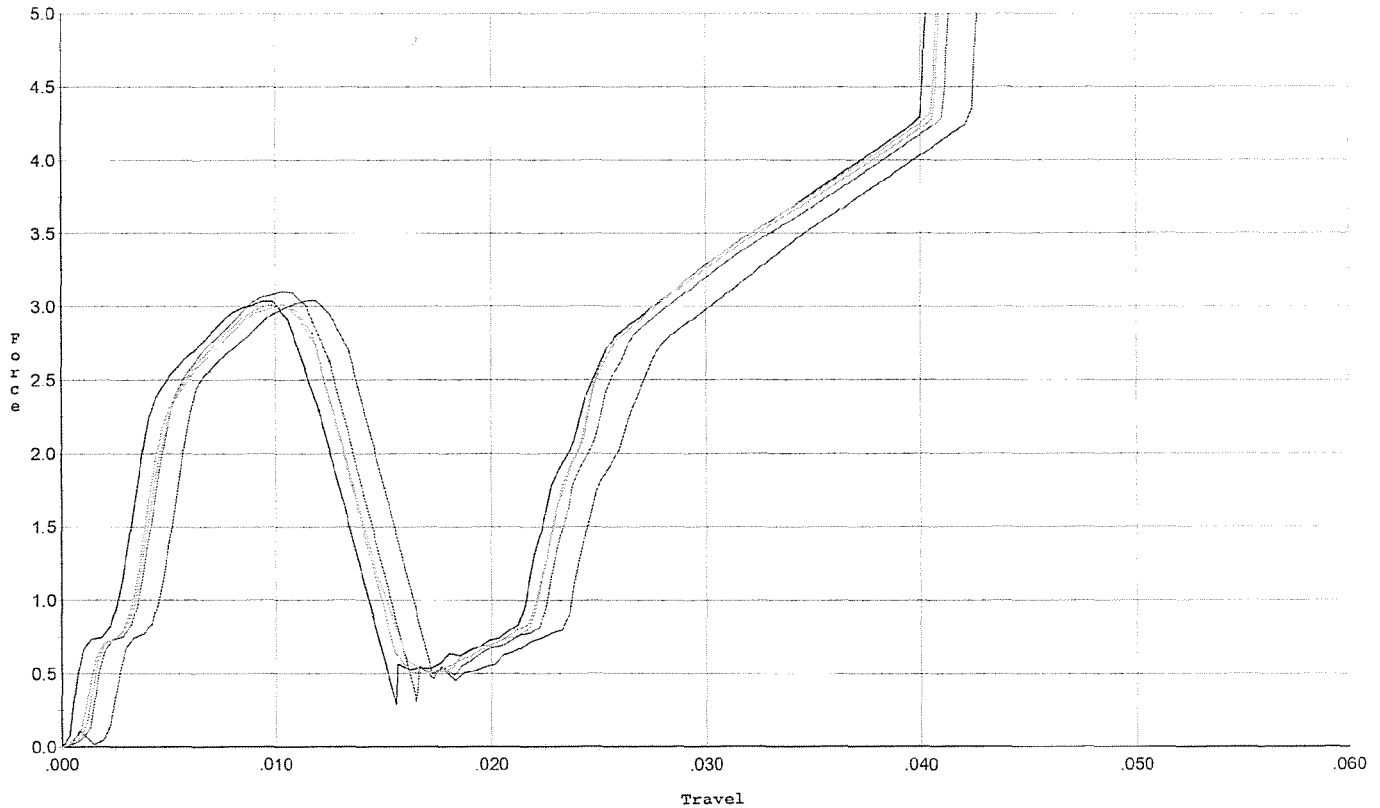
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.688      | 0.011             | 0.00            | 0.030      | 0.019             |           | Set Trigger |
| 2 | 2.507      | 0.011             | 0.00            | 0.030      | 0.018             |           | Set Trigger |
| 3 | 2.580      | 0.011             | 0.00            | 0.030      | 0.018             |           | Set Trigger |
| 4 | 2.528      | 0.010             | 0.00            | 0.030      | 0.017             |           | Set Trigger |
| 5 | 2.517      | 0.010             | 0.00            | 0.030      | 0.017             |           | Set Trigger |

A-2-56

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/20/2009

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



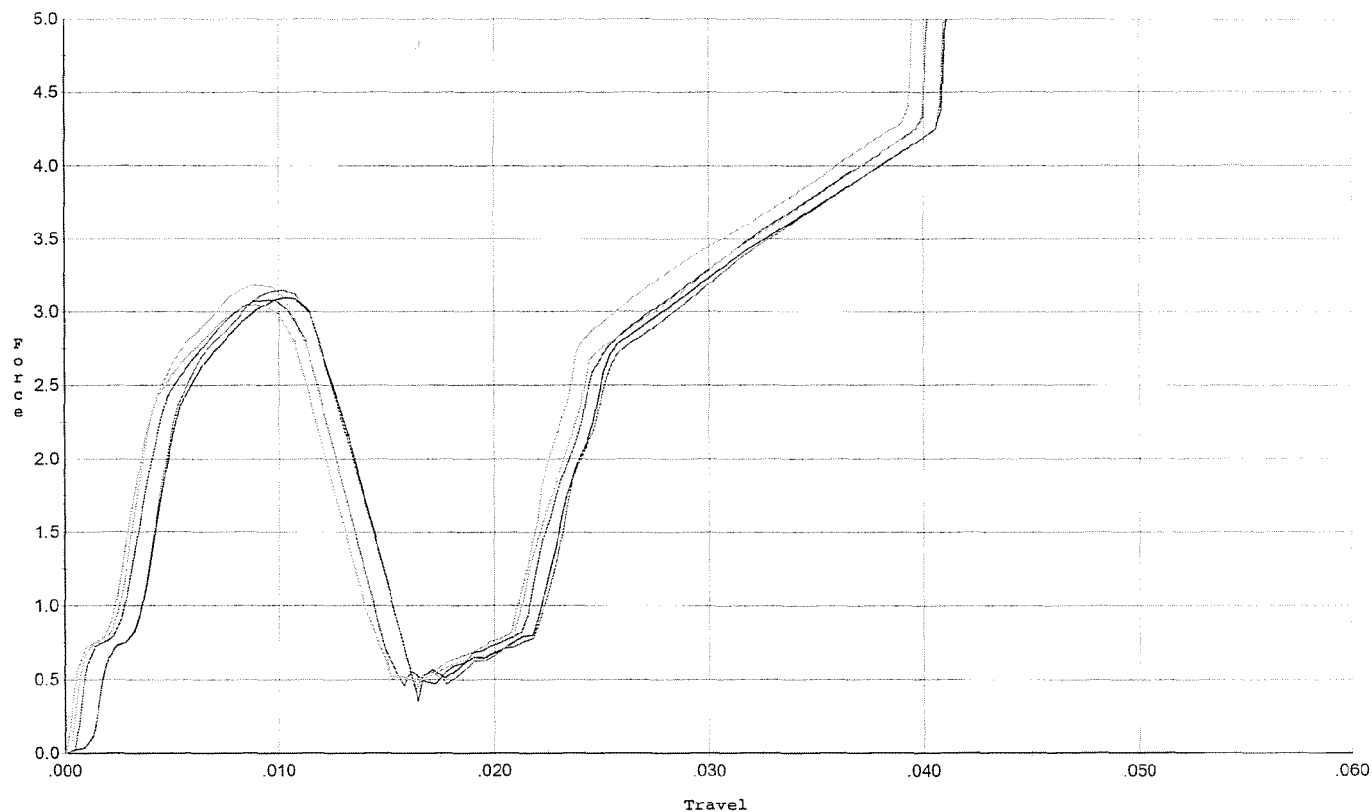
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.045      | 0.013             | 0.00            | 0.030      | 0.024             |           | Set Trigger |
| 2 | 3.036      | 0.012             | 0.00            | 0.030      | 0.024             |           | Set Trigger |
| 3 | 3.100      | 0.013             | 0.00            | 0.030      | 0.024             |           | Set Trigger |
| 4 | 3.004      | 0.012             | 0.00            | 0.030      | 0.022             |           | Set Trigger |
| 5 | 3.013      | 0.012             | 0.00            | 0.030      | 0.022             |           | Set Trigger |

A-3.04

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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 | 3.078      | 0.011             | 0.00            | 0.030      | 0.022             |           | Set Trigger |
| 2 | 3.096      | 0.013             | 0.00            | 0.030      | 0.025             |           | Set Trigger |
| 3 | 3.147      | 0.014             | 0.00            | 0.029      | 0.025             |           | Set Trigger |
| 4 | 3.181      | 0.011             | 0.00            | 0.030      | 0.023             |           | Set Trigger |
| 5 | 3.046      | 0.011             | 0.00            | 0.029      | 0.021             |           | Set Trigger |

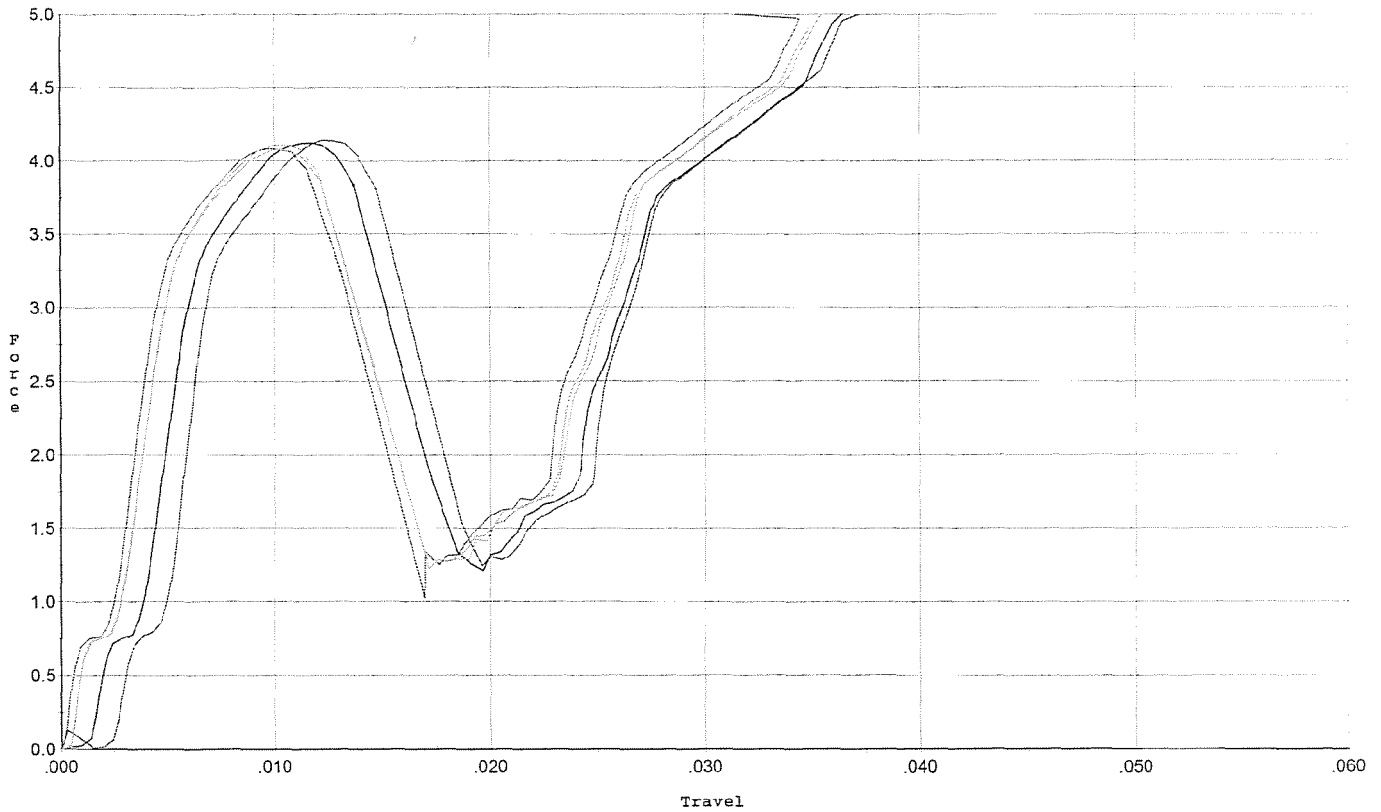
A-3.11



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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



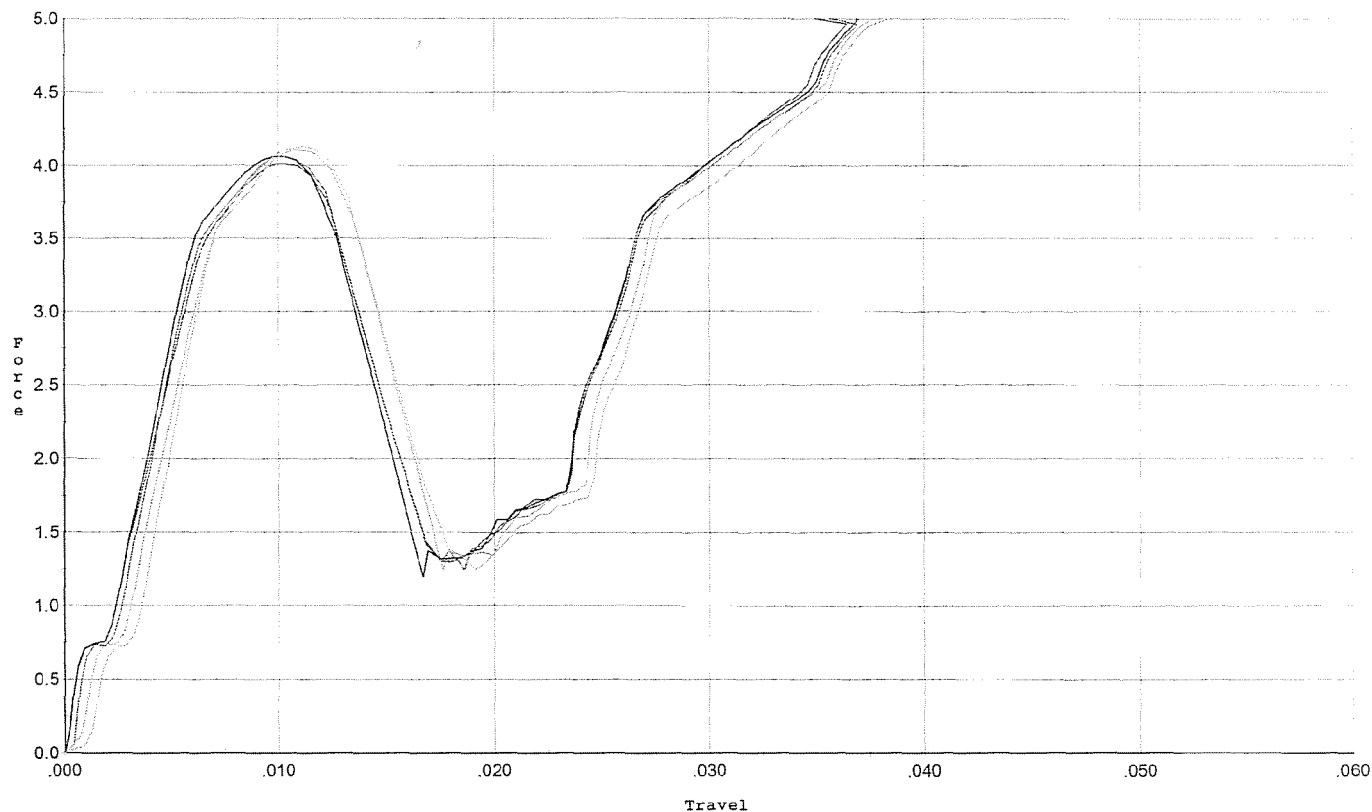
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.139      | 0.015             | 0.003           | 0.027      | 0.034             |           | Set Trigger |
| 2 | 4.123      | 0.014             | 0.00            | 0.027      | 0.033             |           | Set Trigger |
| 3 | 4.084      | 0.013             | 0.00            | 0.026      | 0.034             |           | Set Trigger |
| 4 | 4.079      | 0.015             | 0.00            | 0.026      | 0.037             |           | Set Trigger |
| 5 | 4.108      | 0.014             | 0.00            | 0.027      | 0.036             |           | Set Trigger |

A-4.10

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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



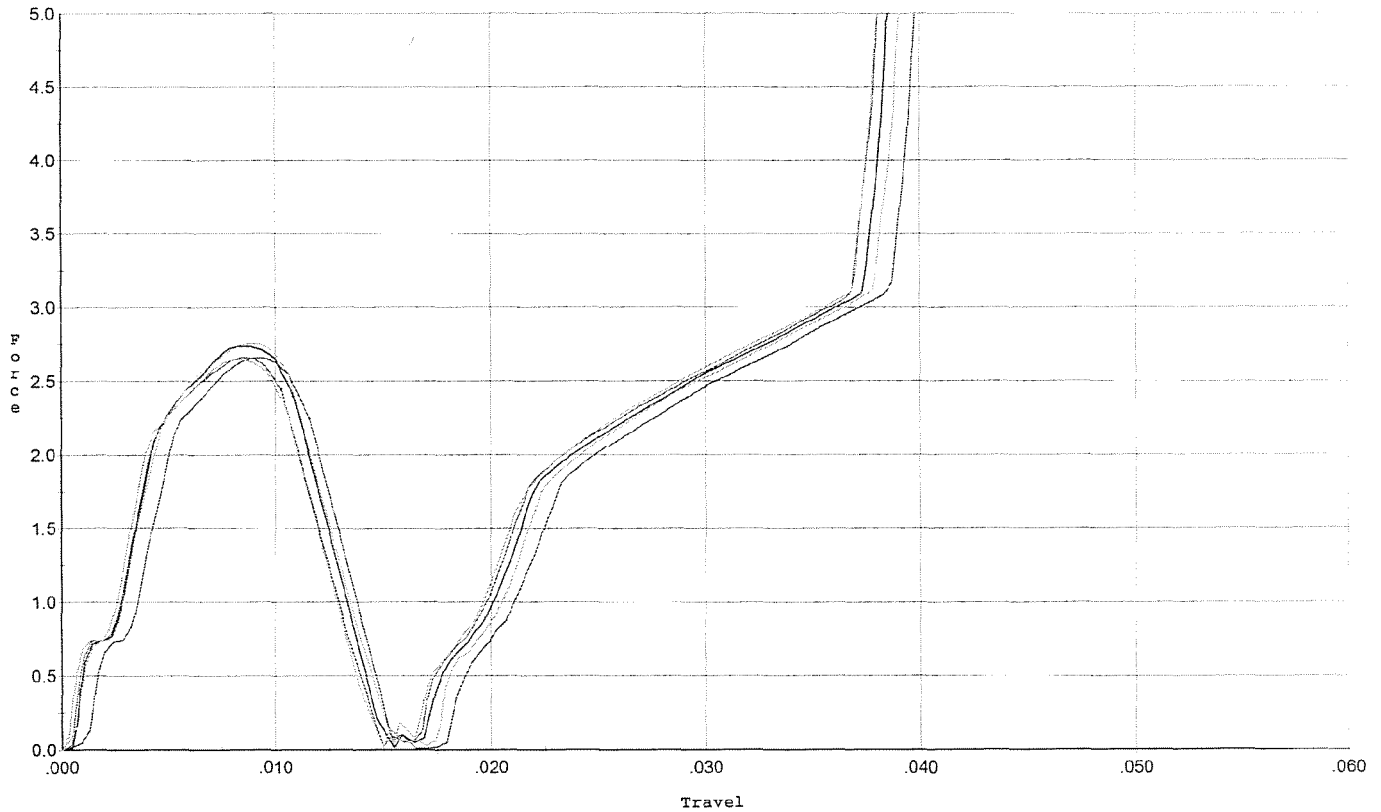
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.012      | 0.012             | 0.00            | 0.027      | 0.031             |           | Set Trigger |
| 2 | 4.061      | 0.013             | 0.00            | 0.027      | 0.032             |           | Set Trigger |
| 3 | 4.062      | 0.012             | 0.00            | 0.027      | 0.030             |           | Set Trigger |
| 4 | 4.131      | 0.013             | 0.00            | 0.027      | 0.032             |           | Set Trigger |
| 5 | 4.108      | 0.013             | 0.00            | 0.027      | 0.033             |           | Set Trigger |

A-4.07

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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



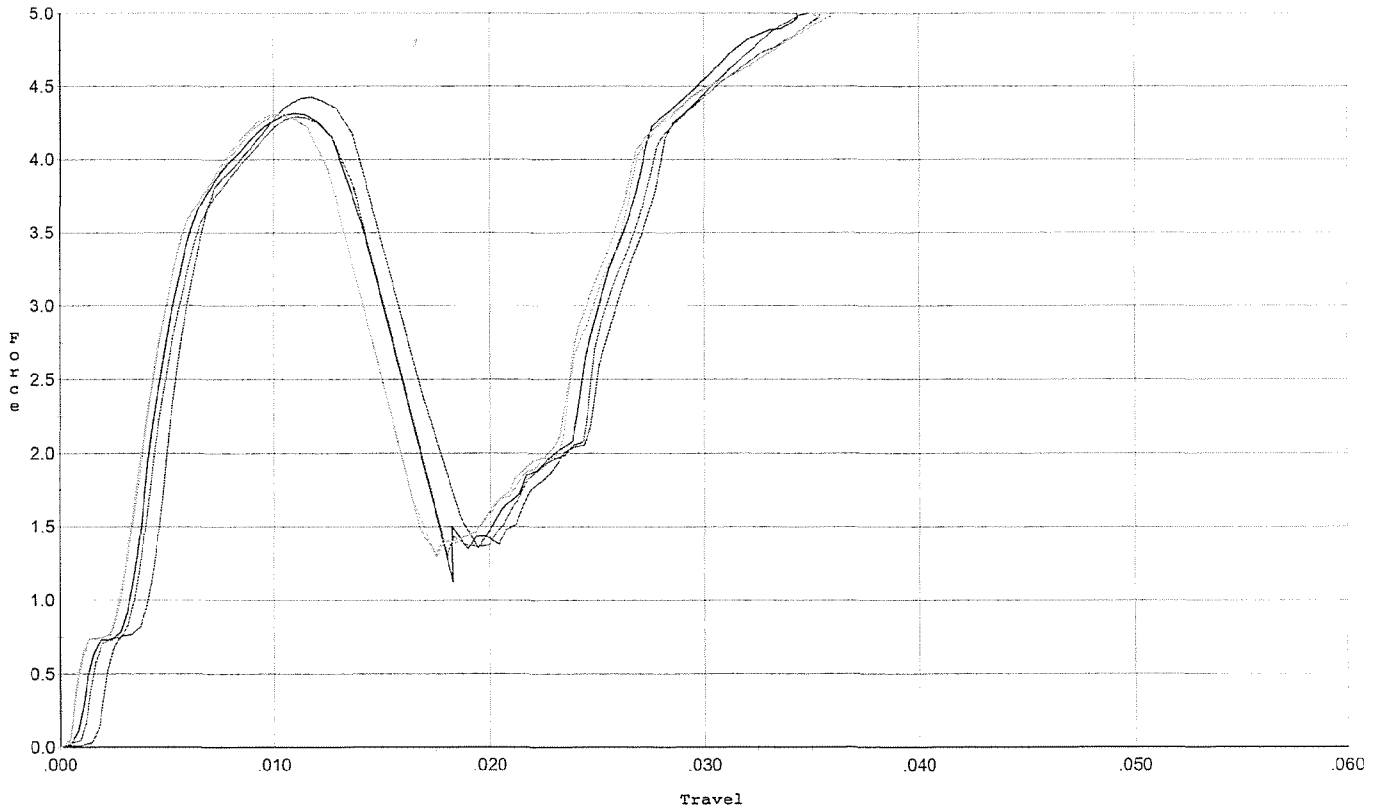
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.657      | 0.012             | 0.00            | 0.031      | 0.019             |           | Set Trigger |
| 2 | 2.737      | 0.011             | 0.00            | 0.030      | 0.019             |           | Set Trigger |
| 3 | 2.661      | 0.010             | 0.00            | 0.030      | 0.018             |           | Set Trigger |
| 4 | 2.761      | 0.011             | 0.00            | 0.031      | 0.019             |           | Set Trigger |
| 5 | 2.646      | 0.010             | 0.00            | 0.030      | 0.018             |           | Set Trigger |

A-2.69

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/20/2009

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 | 4.427      | 0.014             | 0.00            | 0.027      | 0.035             |           | Set Trigger |
| 2 | 4.315      | 0.014             | 0.00            | 0.026      | 0.037             |           | Set Trigger |
| 3 | 4.293      | 0.014             | 0.00            | 0.027      | 0.035             |           | Set Trigger |
| 4 | 4.311      | 0.013             | 0.00            | 0.026      | 0.033             |           | Set Trigger |
| 5 | 4.298      | 0.013             | 0.00            | 0.026      | 0.033             |           | Set Trigger |

A-4-32