

6680 1345

**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

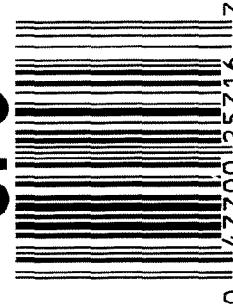
**24"**

CAPACITY

**6**

**G6801345**

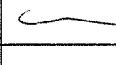
**UPC**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801345

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                               |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|---------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 3-6-09  | RT                                                                                    |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 3-6-09  | RT                                                                                    |
| 440  | PROOF                                                                                                                                  |                                                                                             | 3-6-09  | TC                                                                                    |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 3-6-09  | TC                                                                                    |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 3-6-09  | SP                                                                                    |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX                                                                                | 3-9-09  | RT                                                                                    |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 3-9-09  | SP                                                                                    |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/13/09 |    |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 3/13/09 | MR                                                                                    |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 3/13/09 | RT                                                                                    |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 3-16    | BT                                                                                    |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 3/24    |  |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                       |
| 560  | RE-ASSEMBLE ACTION<br>A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                              |                                                                                             | 3-25-09 | SP                                                                                    |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-25-09 | SP                                                                                    |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-25-09 | SP                                                                                    |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-26-09 | RT                                                                                    |
|      | 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

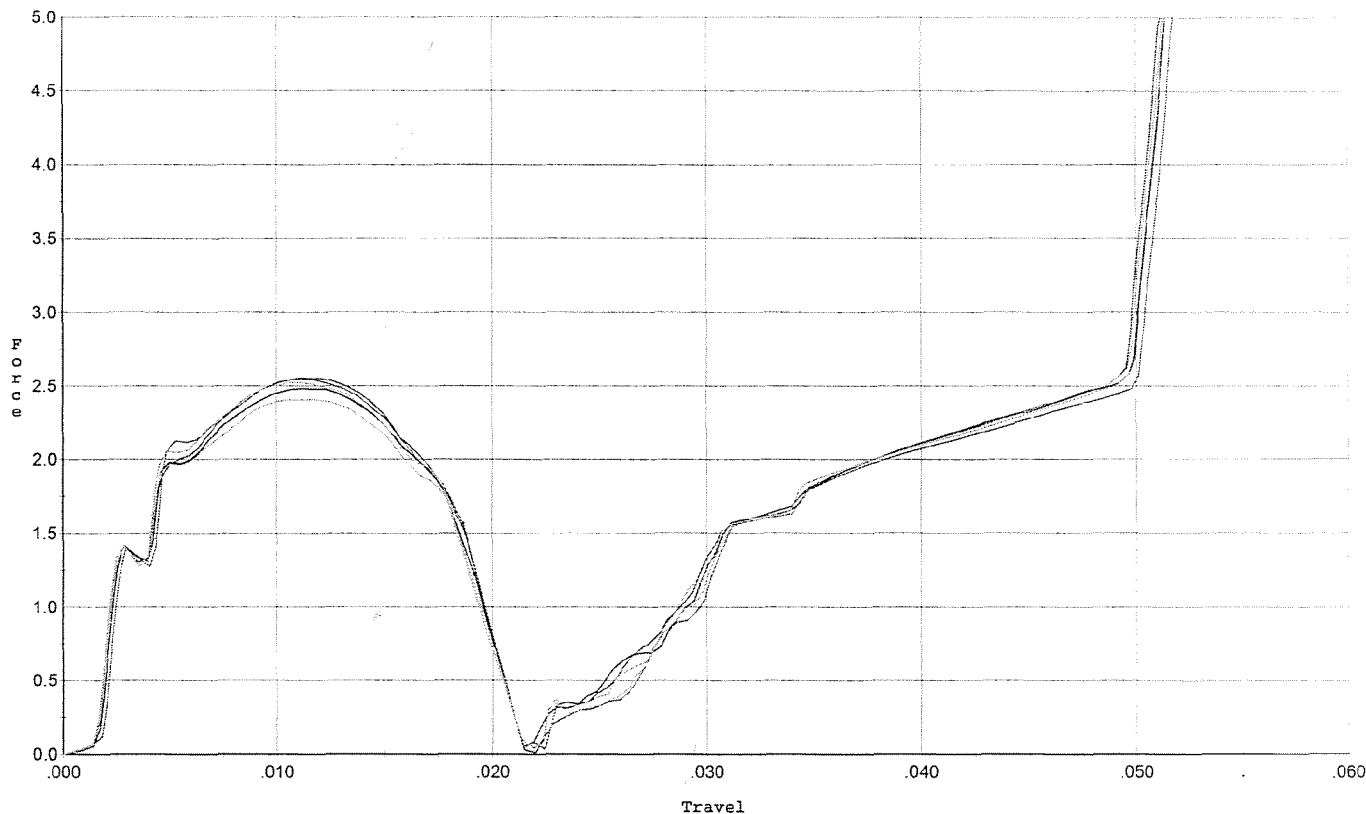
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.0</u> <u>4.0</u> <u>3.0</u>                            | 3-30-09 | XN      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.0</u> <u>4.0</u> <u>4.0</u>                            | 3-30-09 | XN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.023</u> <u>.024</u>                         | 3-30-09 | XN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-26-09 | XN      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-30-09 | 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> FAIL<br><u>PASS</u> FAIL                        | 3-27-09 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  | N/A     |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-27-09 | XN      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-30-09 | XN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.56</u> <u>2.64</u> <u>2.69</u> <u>2.63</u> <u>2.55</u> | 3-30-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3-30-09 | XN      |
| 690          | PACK                                                                     |                                                             | 3/31/09 | Fm      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



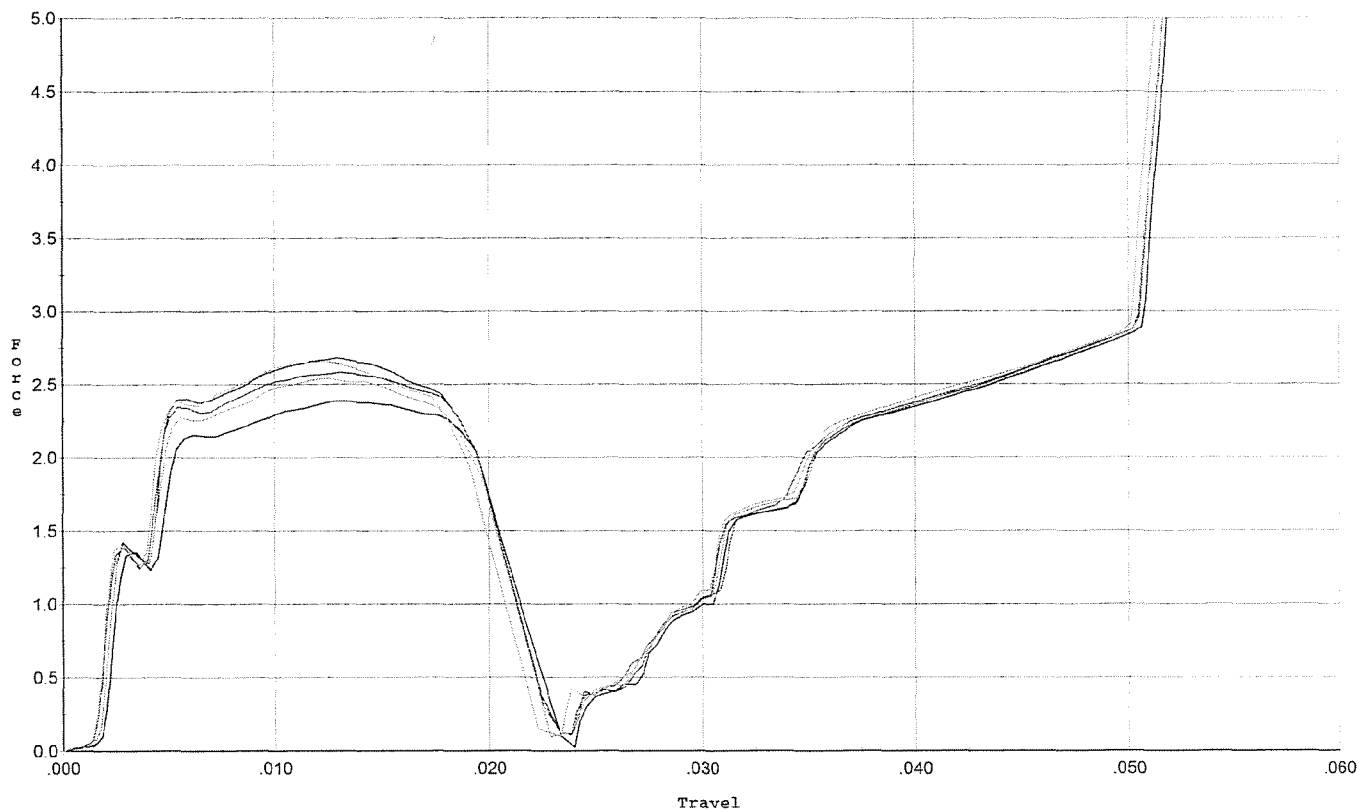
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.555      | 0.019             | 0.00            | 0.037      | 0.034             |           | Set Trigger |
| 2 | 2.481      | 0.019             | 0.004           | 0.037      | 0.033             |           | Set Trigger |
| 3 | 2.549      | 0.019             | 0.004           | 0.038      | 0.033             |           | Set Trigger |
| 4 | 2.525      | 0.019             | 0.00            | 0.037      | 0.035             |           | Set Trigger |
| 5 | 2.407      | 0.018             | 0.00            | 0.037      | 0.031             |           | Set Trigger |

A-2.50

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



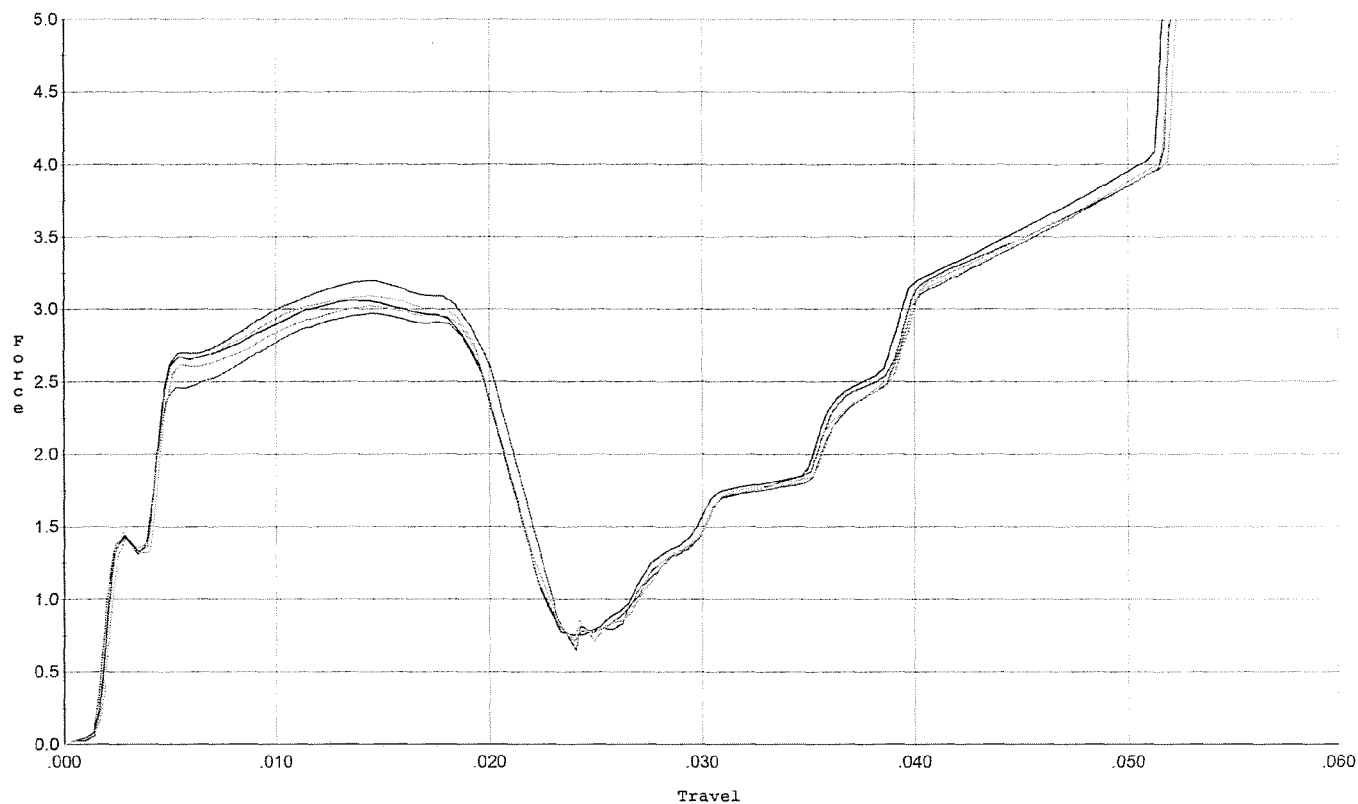
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.681      | 0.019             | 0.004           | 0.036      | 0.038             |           | Set Trigger |
| 2 | 2.387      | 0.019             | 0.00            | 0.036      | 0.034             |           | Set Trigger |
| 3 | 2.583      | 0.019             | 0.00            | 0.036      | 0.038             |           | Set Trigger |
| 4 | 2.654      | 0.019             | 0.00            | 0.036      | 0.037             |           | Set Trigger |
| 5 | 2.541      | 0.020             | 0.004           | 0.036      | 0.037             |           | Set Trigger |

A-256

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



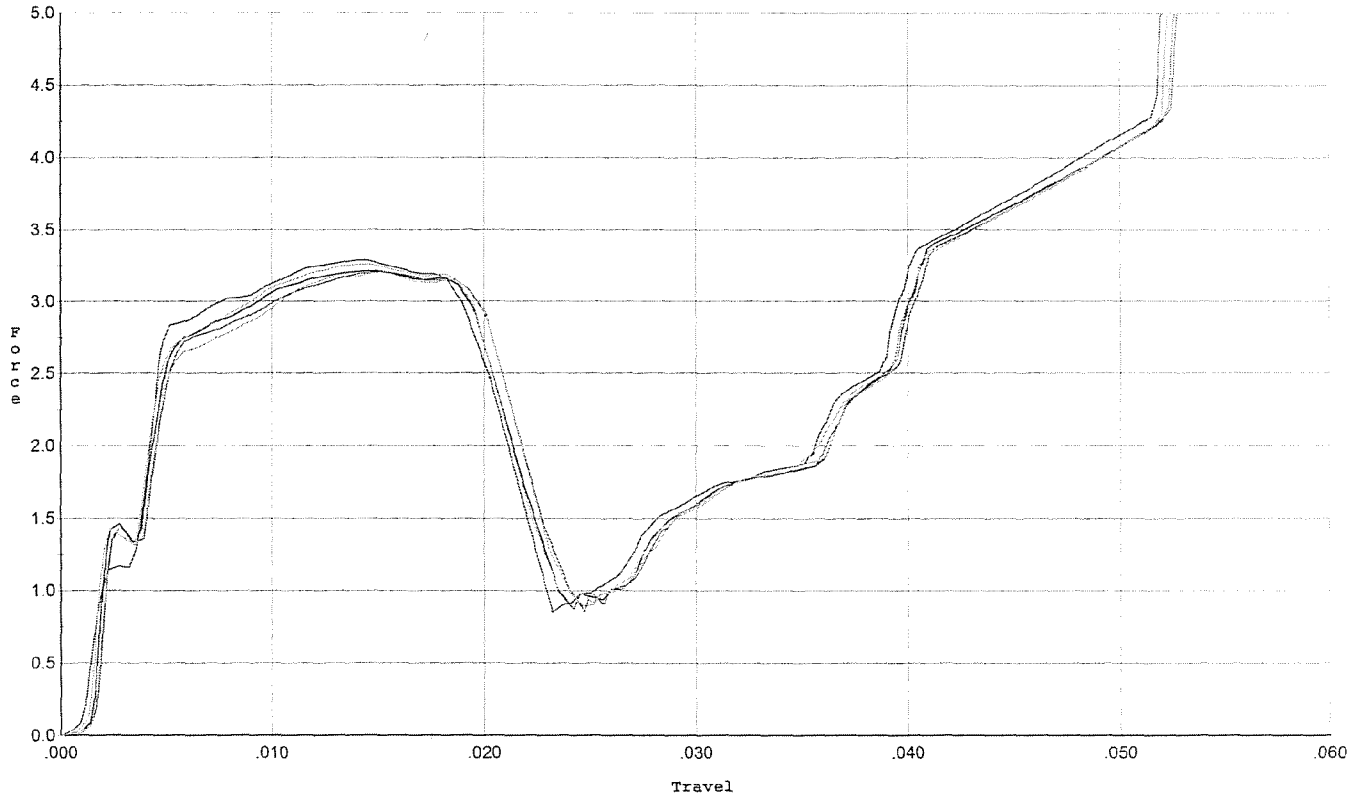
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.193      | 0.020             | 0.00            | 0.035      | 0.046             |           | Set Trigger |
| 2 | 3.057      | 0.020             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 3 | 2.969      | 0.020             | 0.00            | 0.035      | 0.043             |           | Set Trigger |
| 4 | 3.092      | 0.019             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 5 | 3.020      | 0.019             | 0.004           | 0.036      | 0.043             |           | Set Trigger |

A.3.06

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



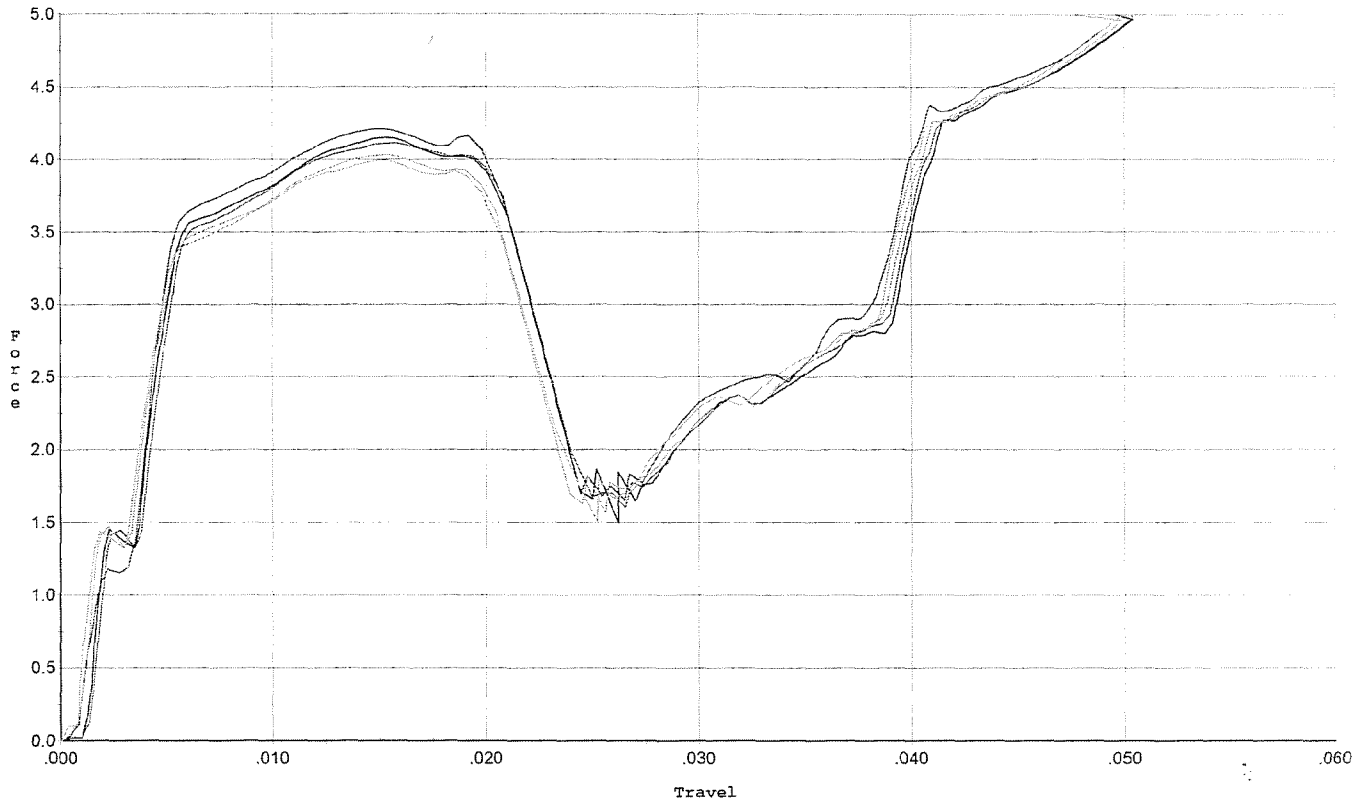
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.285      | 0.020             | 0.00            | 0.035      | 0.049             |           | Set Trigger |
| 2 | 3.211      | 0.020             | 0.00            | 0.036      | 0.046             |           | Set Trigger |
| 3 | 3.208      | 0.020             | 0.00            | 0.035      | 0.047             |           | Set Trigger |
| 4 | 3.257      | 0.019             | 0.004           | 0.035      | 0.047             |           | Set Trigger |
| 5 | 3.201      | 0.020             | 0.00            | 0.035      | 0.047             |           | Set Trigger |

A 3.23

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/2/2009

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



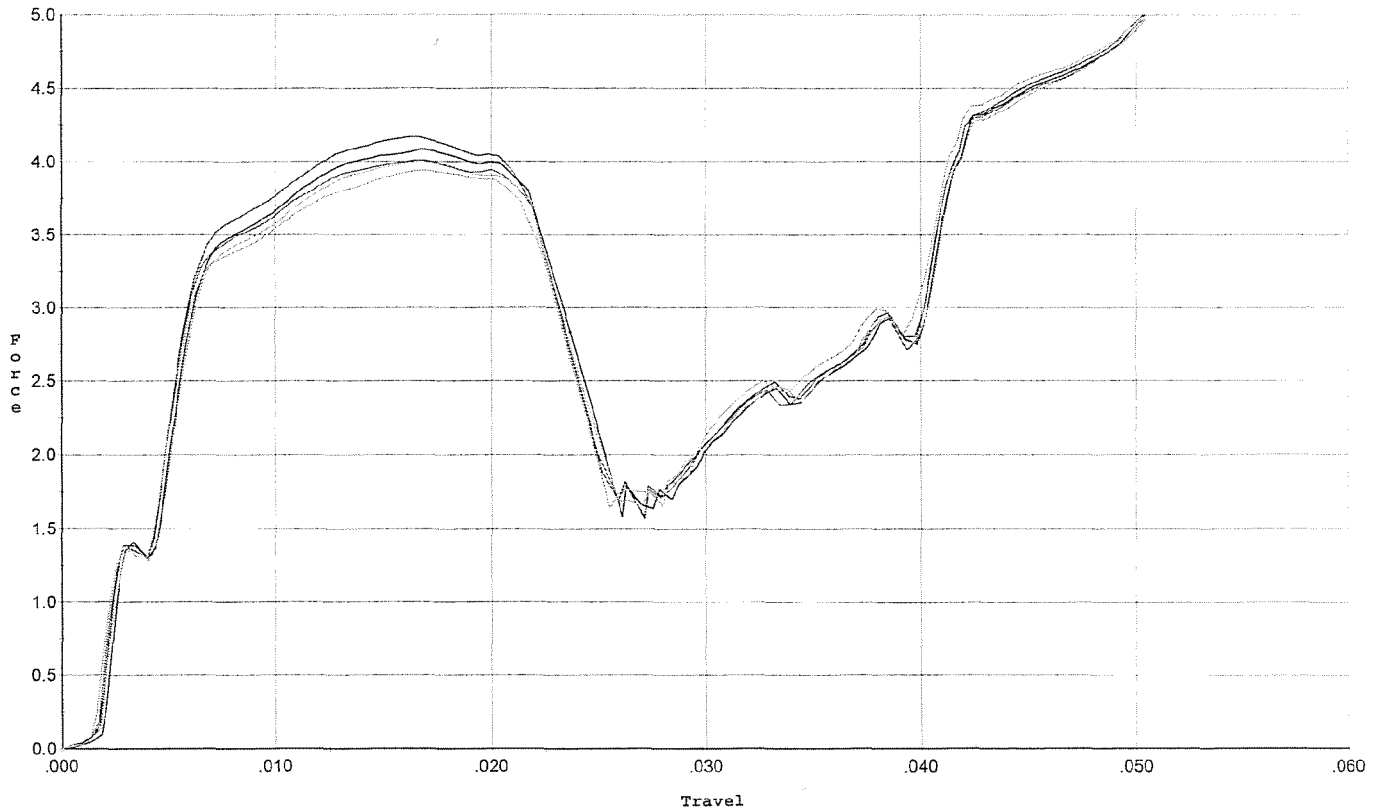
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.211      | 0.021             | 0.00            | 0.032      | 0.064             |           | Set Trigger |
| 2 | 4.149      | 0.021             | 0.004           | 0.032      | 0.063             |           | Set Trigger |
| 3 | 4.112      | 0.021             | 0.00            | 0.032      | 0.061             |           | Set Trigger |
| 4 | 3.995      | 0.021             | 0.003           | 0.032      | 0.061             |           | Set Trigger |
| 5 | 4.033      | 0.020             | 0.00            | 0.033      | 0.060             |           | Set Trigger |

A-4-10

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



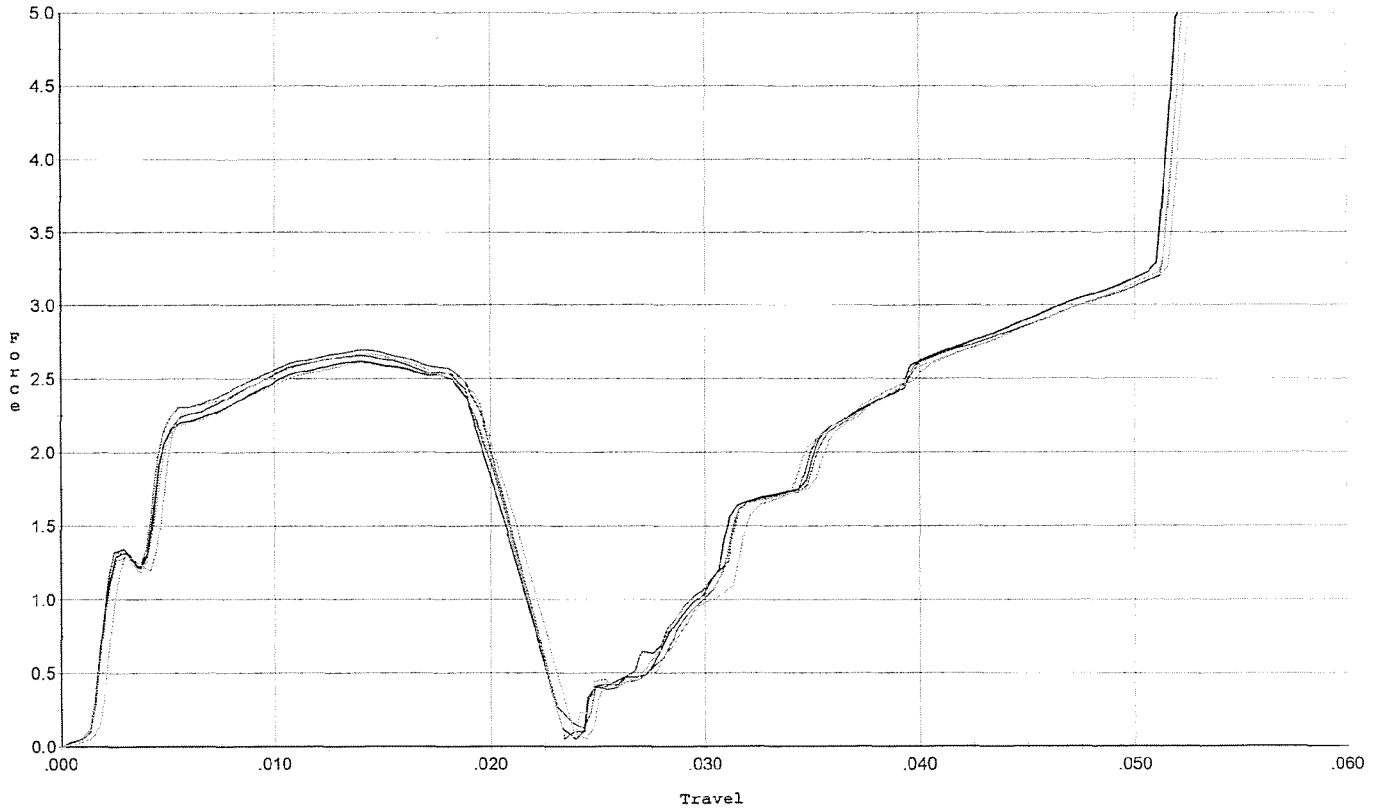
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.166      | 0.022             | 0.004           | 0.032      | 0.064             |           | Set Trigger |
| 2 | 4.085      | 0.024             | 0.00            | 0.032      | 0.068             |           | Set Trigger |
| 3 | 4.007      | 0.022             | 0.004           | 0.032      | 0.062             |           | Se: Trigger |
| 4 | 3.998      | 0.022             | 0.00            | 0.032      | 0.061             |           | Set Trigger |
| 5 | 3.939      | 0.022             | 0.004           | 0.032      | 0.063             |           | Set Trigger |

A-4.03

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



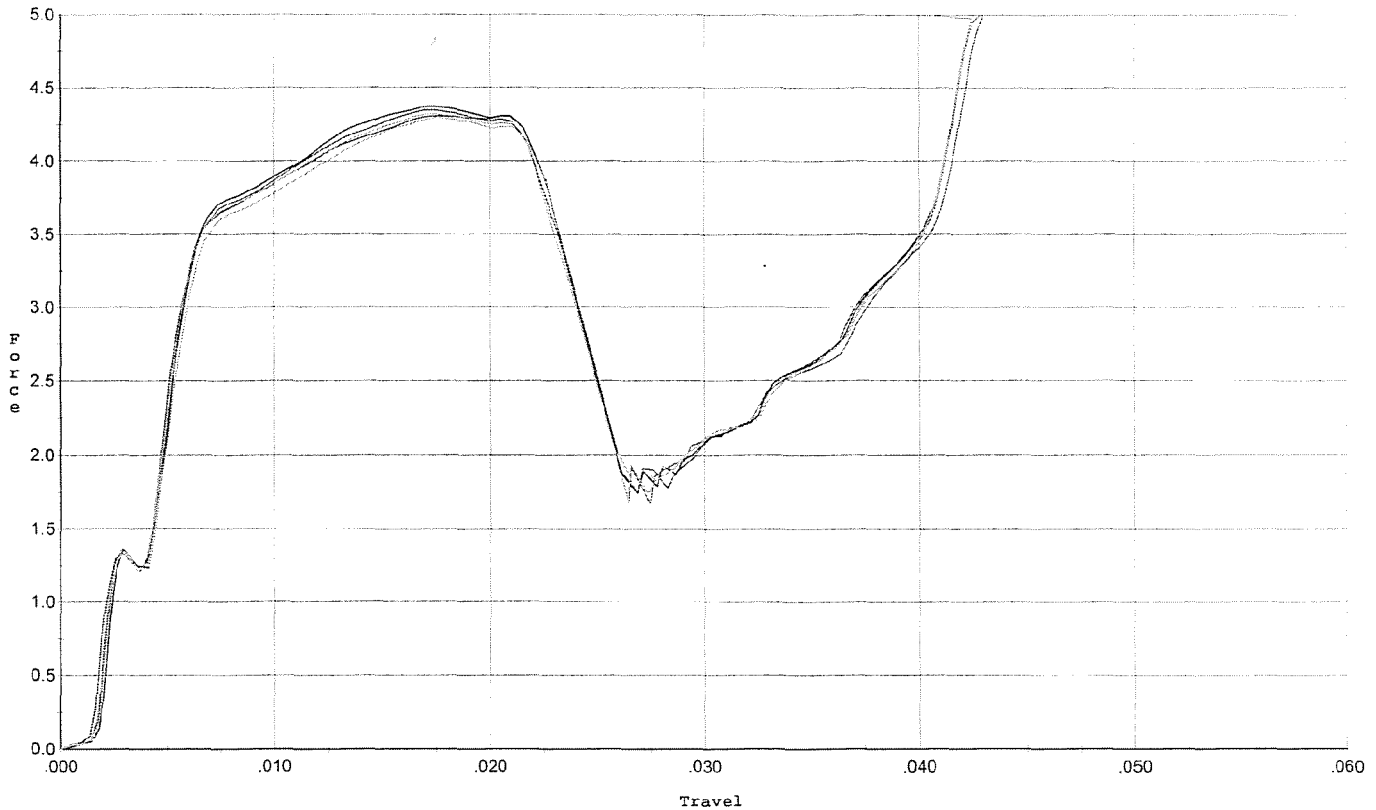
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.659      | 0.020             | 0.00            | 0.036      | 0.040             |           | Set Trigger |
| 2 | 2.618      | 0.021             | 0.00            | 0.036      | 0.040             |           | Set Trigger |
| 3 | 2.696      | 0.020             | 0.004           | 0.036      | 0.039             |           | Set Trigger |
| 4 | 2.604      | 0.020             | 0.00            | 0.036      | 0.038             |           | Set Trigger |
| 5 | 2.669      | 0.021             | 0.004           | 0.036      | 0.041             |           | Set Trigger |

A-2.64

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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 | 4.307      | 0.023             | 0.00            | 0.031      | 0.069             |           | Set Trigger |
| 2 | 4.373      | 0.023             | 0.004           | 0.031      | 0.069             |           | Set Trigger |
| 3 | 4.347      | 0.023             | 0.00            | 0.031      | 0.071             |           | Set Trigger |
| 4 | 4.296      | 0.023             | 0.004           | 0.031      | 0.068             |           | Set Trigger |
| 5 | 4.320      | 0.024             | 0.00            | 0.031      | 0.072             |           | Set Trigger |

A-4.32