

G6801467

**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



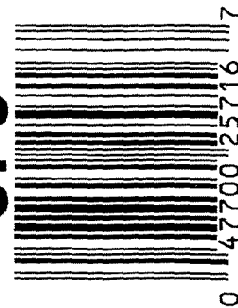
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6801407**

**UPC**



M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801407

| OP # | OPERATION NAME                                                                                                                         | READINGS     | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |              | 10-14-08 | S.P.D.  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |              | 10-14-08 | SP      |
| 440  | PROOF                                                                                                                                  |              | 10-14-08 | S.P.D.  |
| 460  | CHECK HEADSPACE                                                                                                                        |              | 10-14-08 | S.P.D.  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |              | 10-14-08 | S.P.D.  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA FLUX   | 10-15-08 | R.T.    |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |              | 10-15-08 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR (K) | 10/17/08 | (K)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |              |          |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |              | 10/17/08 | R.T.    |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |              | 10/20/08 | D.G.    |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |              | 10-22    |         |
| 545  | (BOLT)                                                                                                                                 |              |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |              |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |              | 10-22-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |              | 10-22-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |              | 10-22-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |              | 10-23-08 | S.P.D.  |
|      | 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

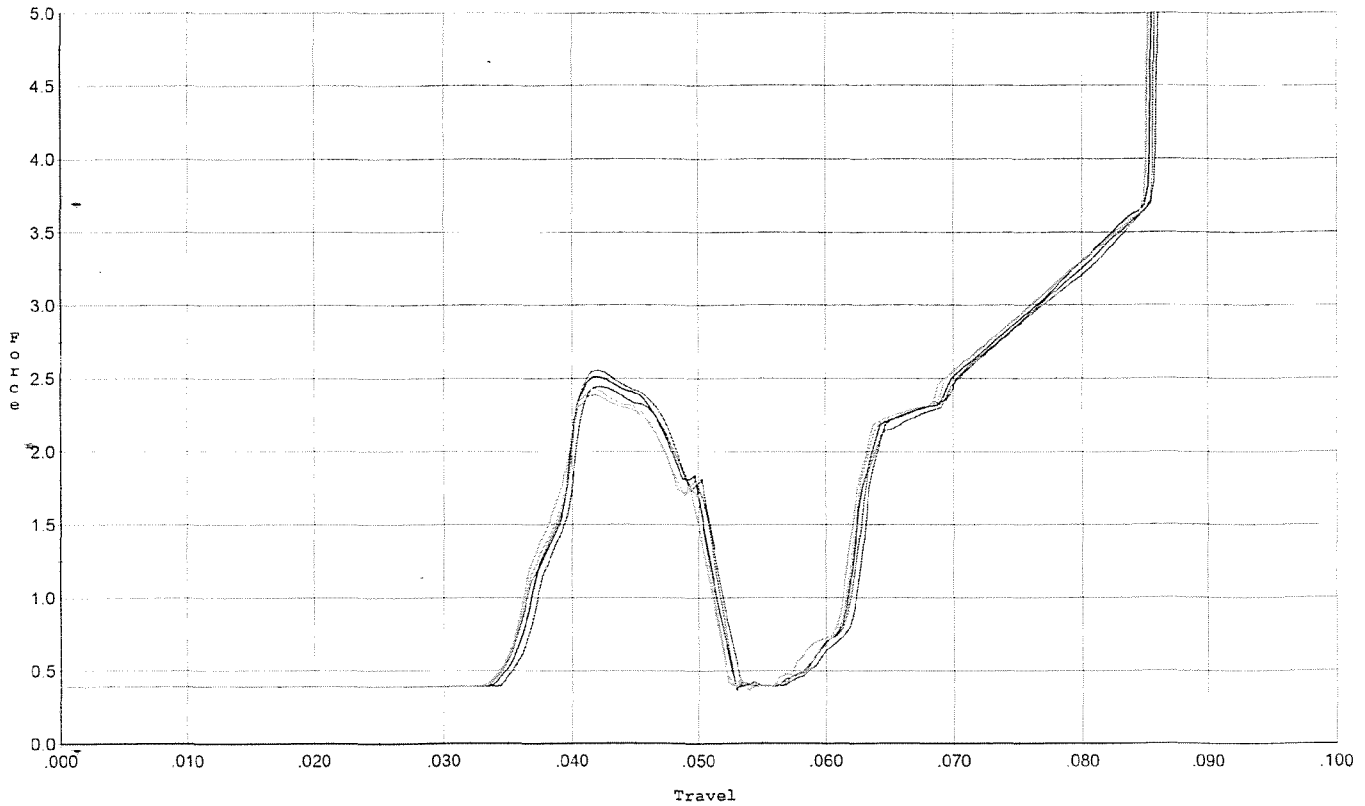
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>50</u> <u>50</u> <u>4.5</u>                              | 10-28-08 | L.D.    |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.0</u> <u>4.0</u> <u>4.5</u>                            | 10-28-08 | L.D.    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 10-28-08 | L.D.    |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 10-23-08 | L.D.    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 10-28-08 | L.D.    |
|              | 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                        | 10-27-08 | L.D.    |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 10-27-08 | TC      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 10-28-08 | R.D.    |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.40</u> <u>2.68</u> <u>2.76</u> <u>2.63</u> <u>2.40</u> | 10-28-08 | L.D.    |
|              | C) FUNCTION                                                              |                                                             | 10-28-08 | L.D.    |
| 690          | PACK                                                                     |                                                             | 11/3/08  | F.M.    |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



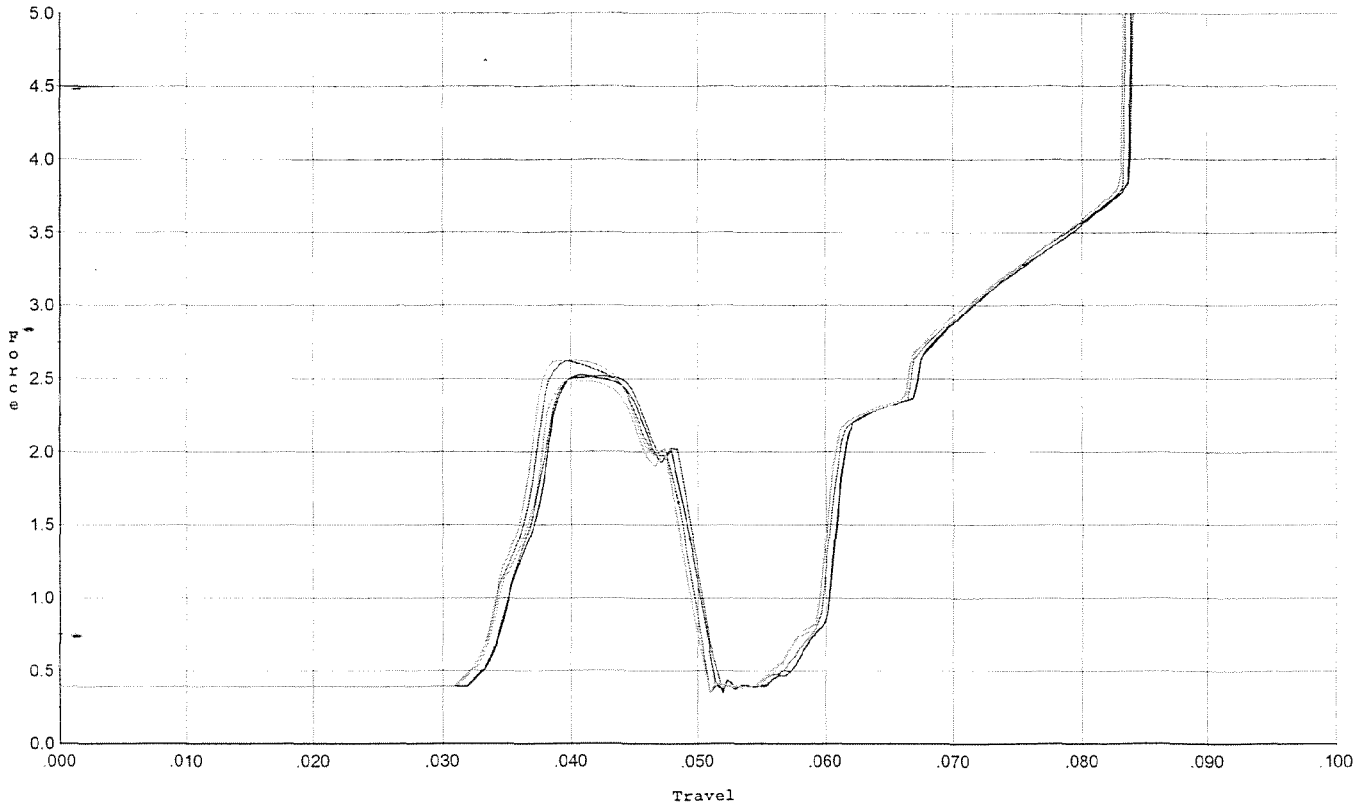
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.442      | 0.050             | 0.036           | 0.040      | 0.042             |           | Set Trigger |
| 2 | 2.510      | 0.050             | 0.036           | 0.040      | 0.042             |           | Set Trigger |
| 3 | 2.556      | 0.051             | 0.035           | 0.040      | 0.044             |           | Set Trigger |
| 4 | 2.388      | 0.050             | 0.035           | 0.040      | 0.042             |           | Set Trigger |
| 5 | 2.432      | 0.051             | 0.035           | 0.039      | 0.043             |           | Set Trigger |

Avg 2.46

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/21/08

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



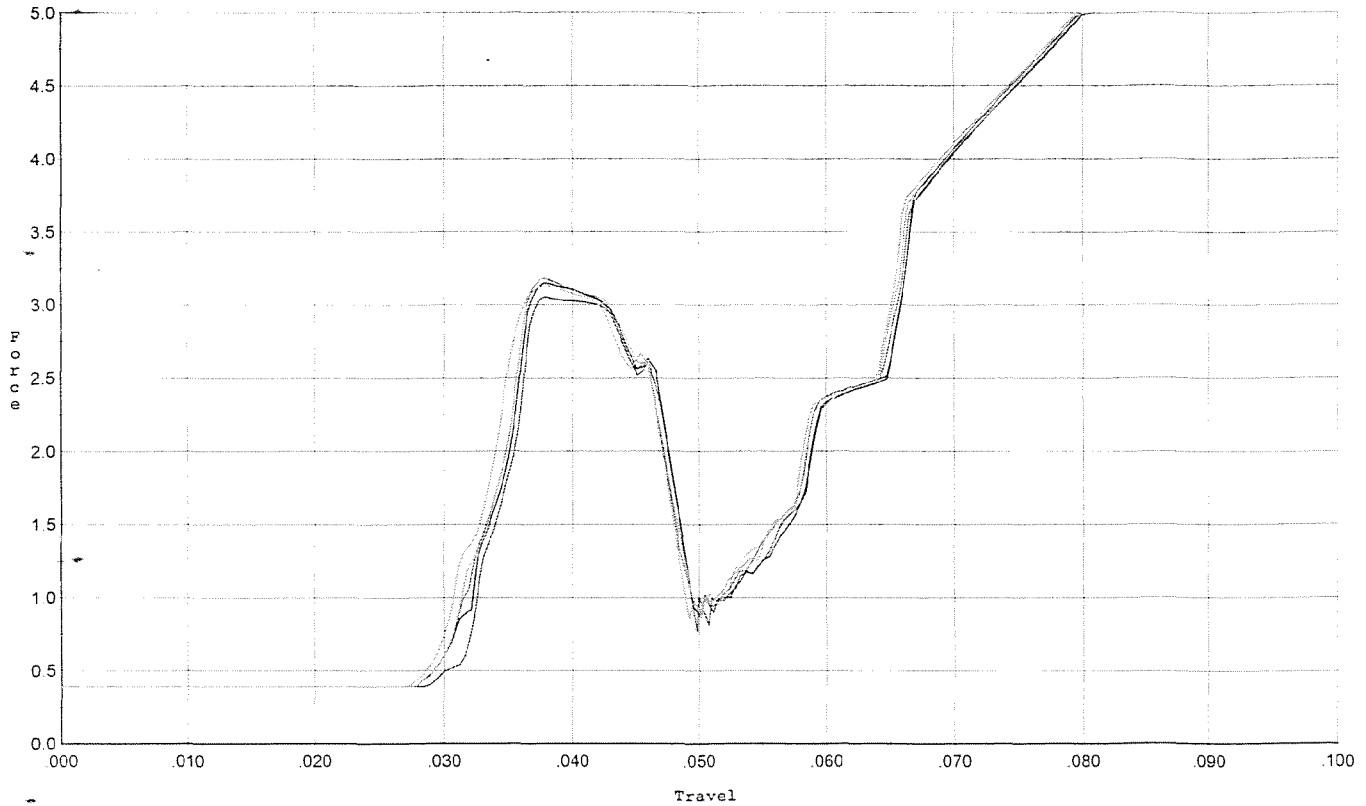
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.516      | 0.048             | 0.034           | 0.039      | 0.044             |           | Set Trigger |
| 2 | 2.524      | 0.049             | 0.034           | 0.039      | 0.044             |           | Set Trigger |
| 3 | 2.616      | 0.048             | 0.033           | 0.038      | 0.045             |           | Set Trigger |
| 4 | 2.491      | 0.048             | 0.033           | 0.039      | 0.042             |           | Set Trigger |
| 5 | 2.624      | 0.047             | 0.033           | 0.039      | 0.044             |           | Set Trigger |

Aug 2.55

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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



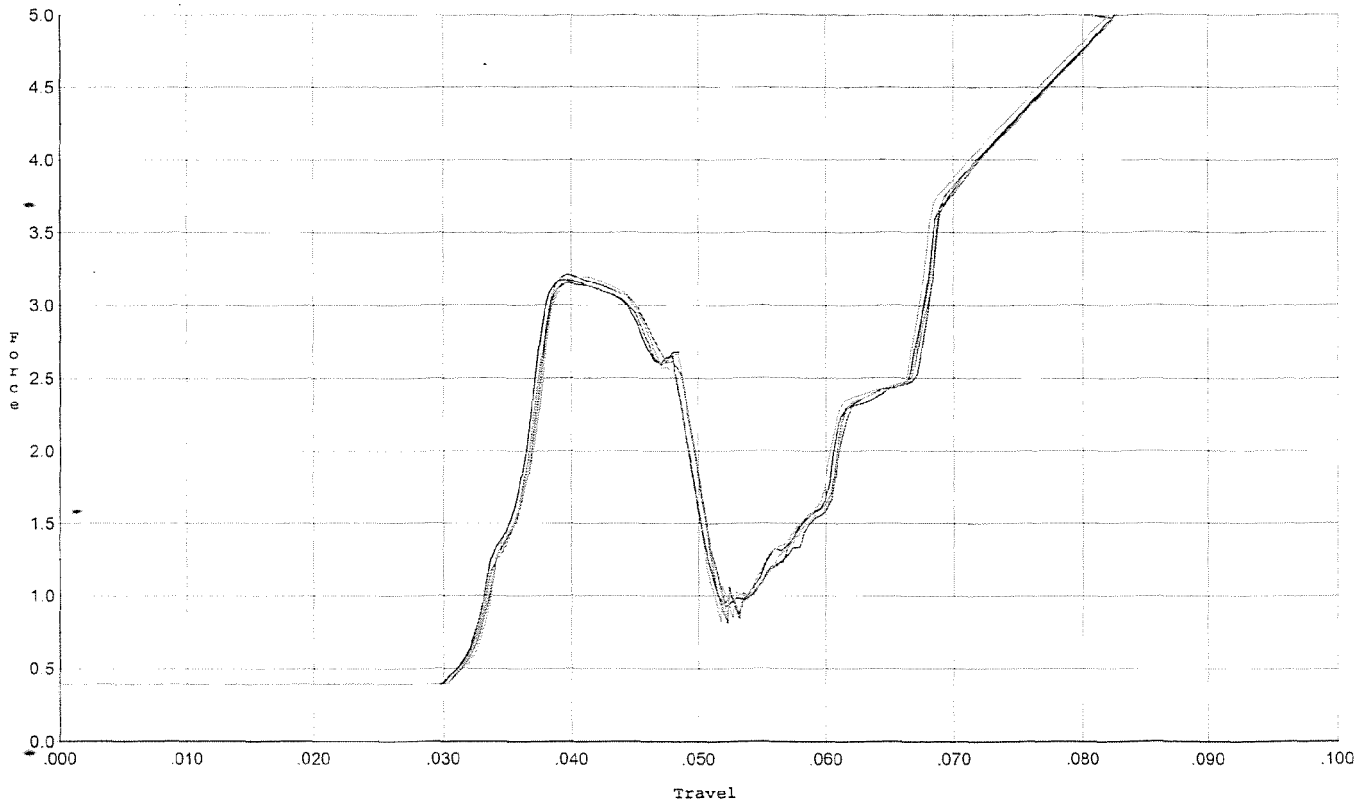
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.055      | 0.047             | 0.032           | 0.036      | 0.051             |           | Set Trigger |
| 2 | 3.147      | 0.047             | 0.030           | 0.036      | 0.053             |           | Set Trigger |
| 3 | 3.181      | 0.046             | 0.030           | 0.036      | 0.052             |           | Set Trigger |
| 4 | 3.180      | 0.046             | 0.030           | 0.036      | 0.052             |           | Set Trigger |
| 5 | 3.135      | 0.046             | 0.030           | 0.036      | 0.053             |           | Set Trigger |

Aug 3.14

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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 | 3.155      | 0.048             | 0.032           | 0.037      | 0.054             |           | Set Trigger |
| 2 | 3.172      | 0.048             | 0.032           | 0.037      | 0.054             |           | Set Trigger |
| 3 | 3.211      | 0.049             | 0.032           | 0.037      | 0.055             |           | Set Trigger |
| 4 | 3.193      | 0.048             | 0.033           | 0.037      | 0.054             |           | Set Trigger |
| 5 | 3.163      | 0.048             | 0.032           | 0.038      | 0.053             |           | Set Trigger |

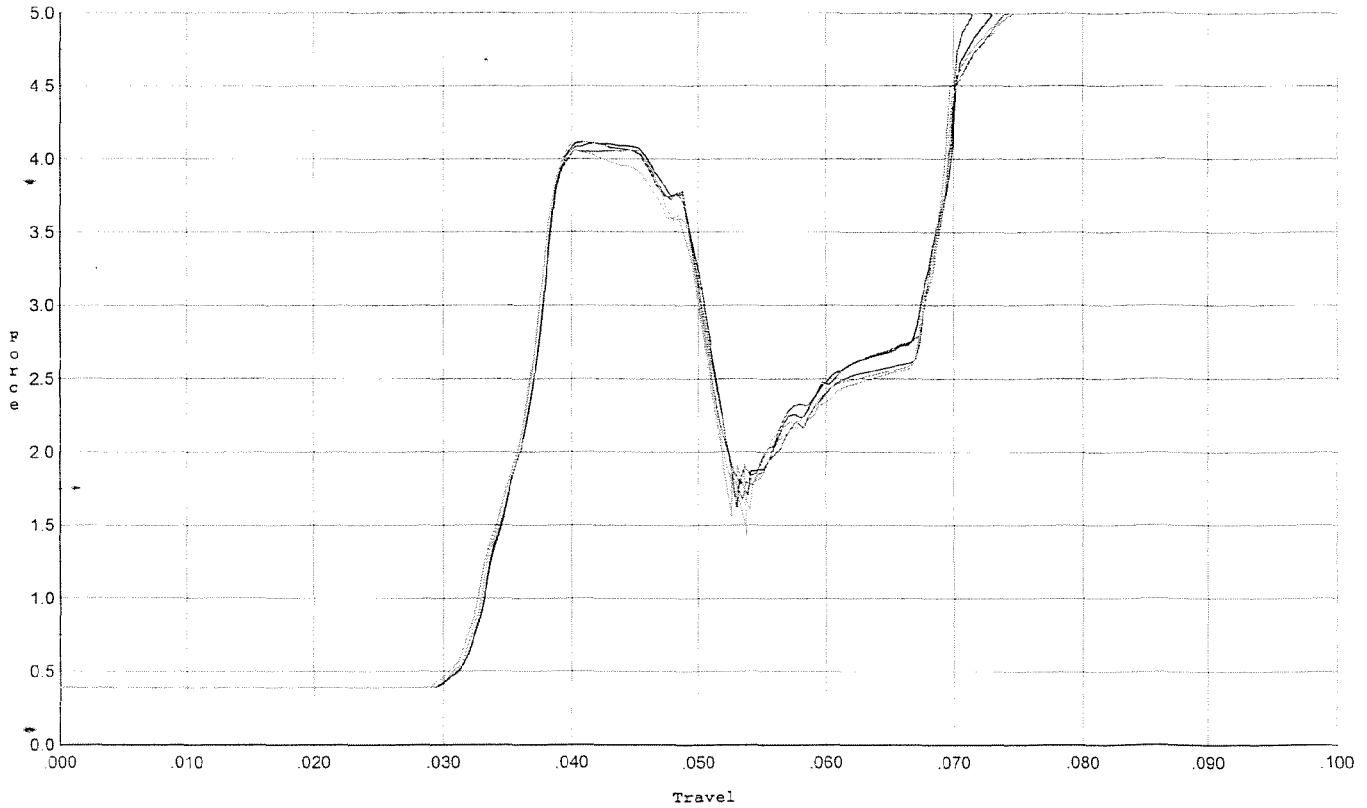
Aug 3.17



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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



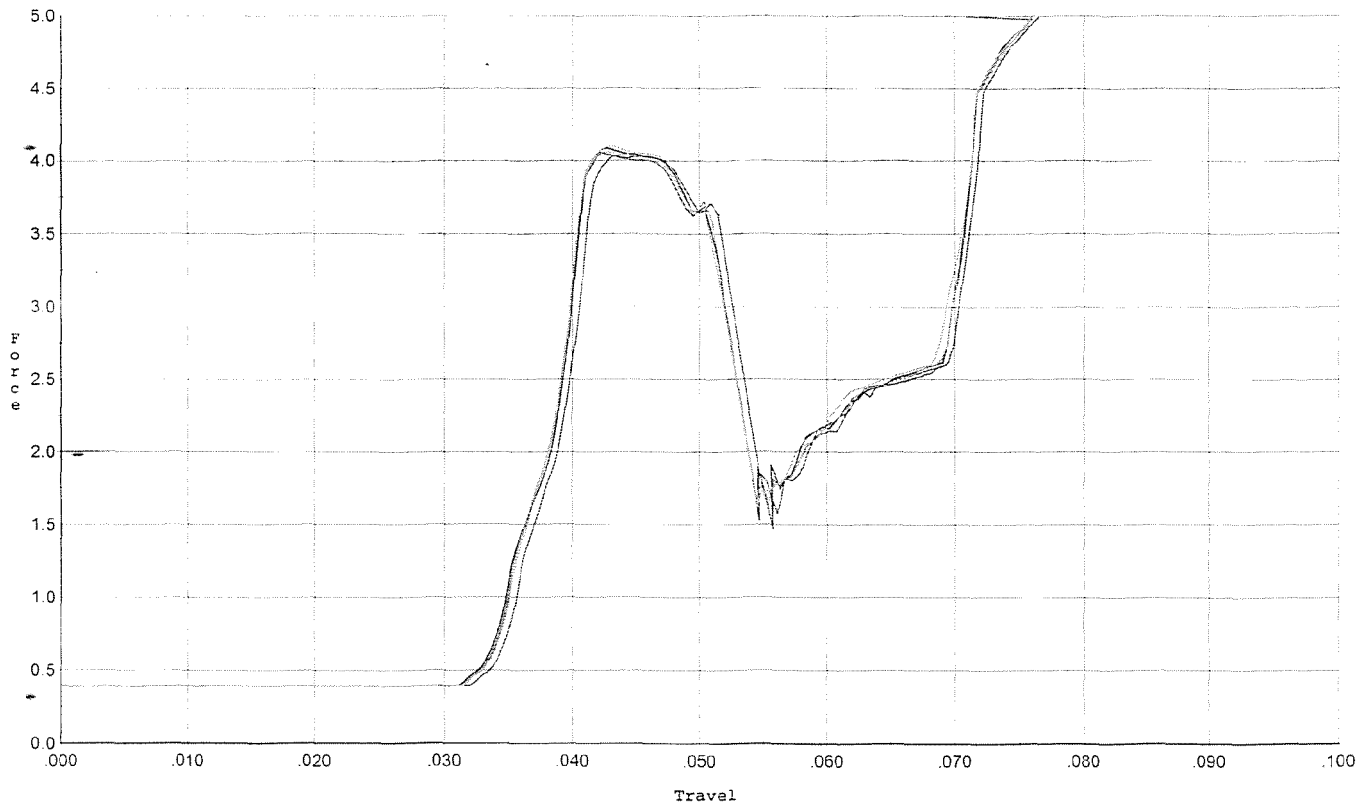
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.106      | 0.049             | 0.032           | 0.034      | 0.069             |           | Set Trigger |
| 2 | 4.113      | 0.050             | 0.032           | 0.035      | 0.072             |           | Set Trigger |
| 3 | 4.063      | 0.049             | 0.032           | 0.036      | 0.069             |           | Set Trigger |
| 4 | 4.055      | 0.049             | 0.032           | 0.036      | 0.070             |           | Set Trigger |
| 5 | 4.119      | 0.049             | 0.032           | 0.036      | 0.071             |           | Set Trigger |

Aug 4.09

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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



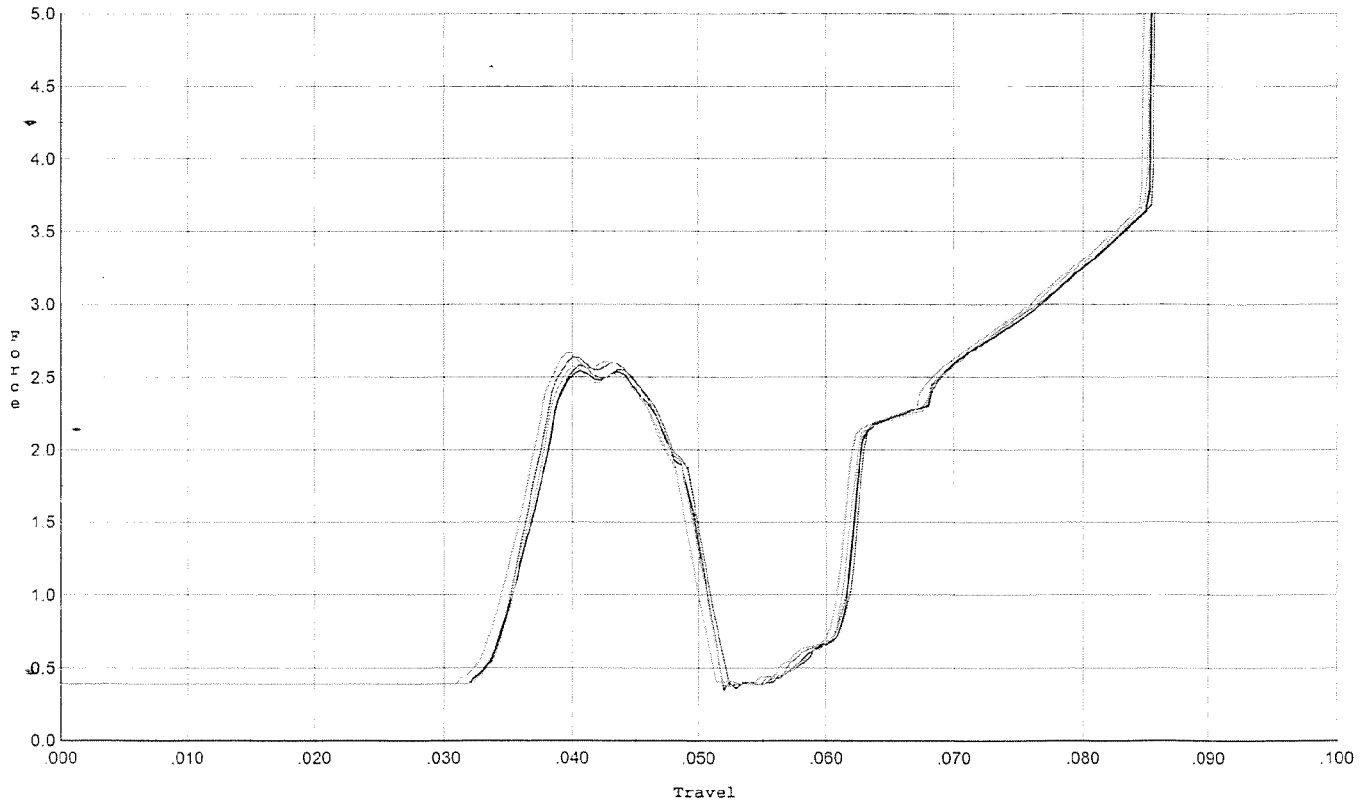
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.038      | 0.051             | 0.034           | 0.037      | 0.070             |           | Set Trigger |
| 2 | 4.087      | 0.051             | 0.034           | 0.037      | 0.071             |           | Set Trigger |
| 3 | 4.052      | 0.051             | 0.034           | 0.037      | 0.070             |           | Set Trigger |
| 4 | 4.101      | 0.051             | 0.034           | 0.037      | 0.070             |           | Set Trigger |
| 5 | 4.061      | 0.052             | 0.034           | 0.037      | 0.071             |           | Set Trigger |

Aug 4.06

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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



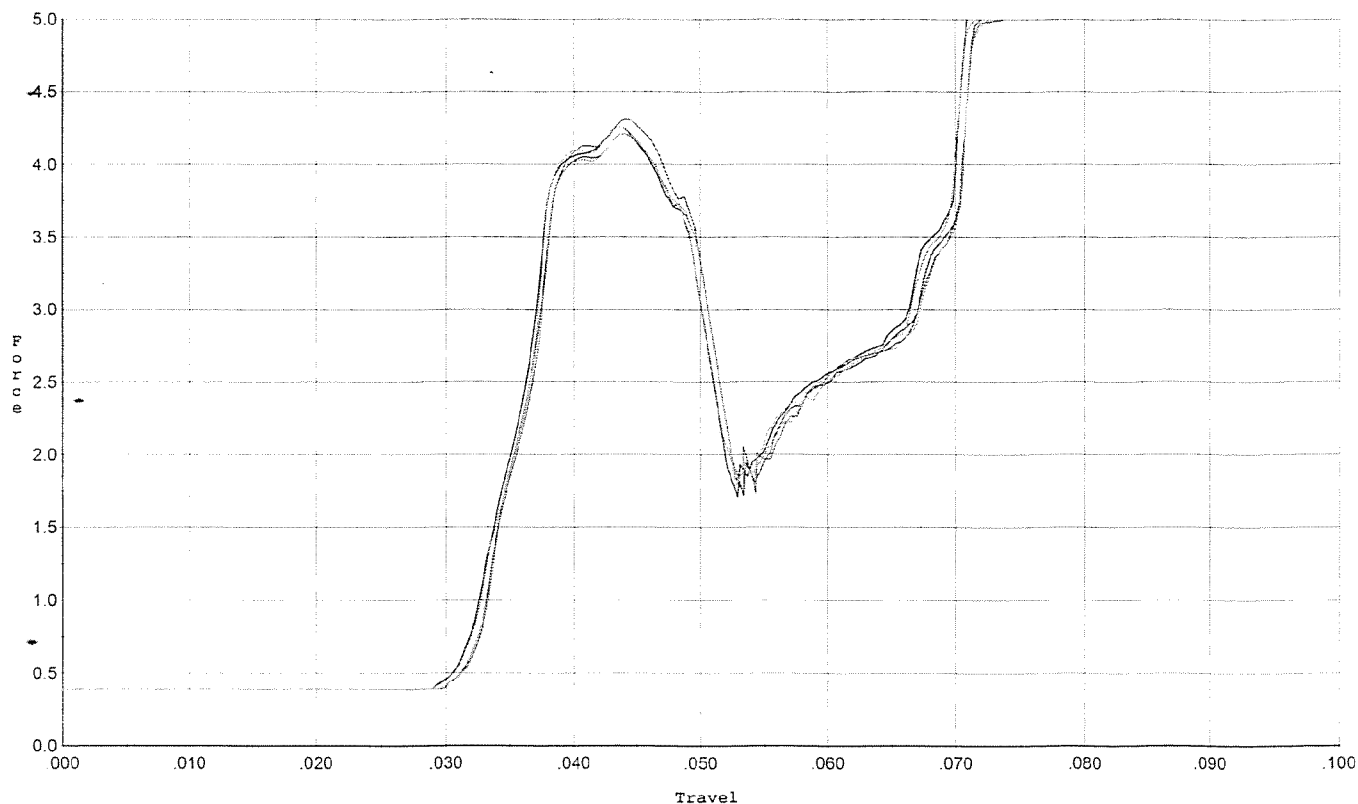
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.581      | 0.049             | 0.034           | 0.039      | 0.045             |           | Set Trigger |
| 2 | 2.546      | 0.050             | 0.034           | 0.039      | 0.045             |           | Set Trigger |
| 3 | 2.634      | 0.050             | 0.034           | 0.039      | 0.047             |           | Set Trigger |
| 4 | 2.573      | 0.050             | 0.034           | 0.039      | 0.046             |           | Set Trigger |
| 5 | 2.666      | 0.048             | 0.033           | 0.039      | 0.046             |           | Set Trigger |

Aug 260

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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 | 4.209      | 0.050             | 0.032           | 0.033      | 0.073             |           | Set Trigger |
| 2 | 4.258      | 0.049             | 0.031           | 0.033      | 0.073             |           | Set Trigger |
| 3 | 4.309      | 0.050             | 0.032           | 0.034      | 0.073             |           | Set Trigger |
| 4 | 4.213      | 0.050             | 0.032           | 0.034      | 0.073             |           | Set Trigger |
| 5 | 4.258      | 0.049             | 0.031           | 0.033      | 0.072             |           | Set Trigger |

Avg 4.24