

66801437

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

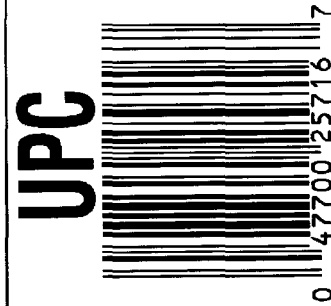
- INSTRUCTION BOOK 3518

**BM FORM**



|               |              |
|---------------|--------------|
| ORDER NO.     | <b>25716</b> |
| BARREL LENGTH | 24"          |
| CAPACITY      | 6            |

**G6801437**



## INSPECTION CHECKLIST NEW GUNS

GUN SERIAL # G6801437

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 3-4-09  | SPD                                                                                 |
| 430  | ASSEMBLE STOCK                                                                                                                         |                                                                                             | 3-4-09  | SP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                             | 3-4-09  | SPD                                                                                 |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 3-4-09  | SPD                                                                                 |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 3-4-09  | SPD                                                                                 |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 3-5-09  | RTZ                                                                                 |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/9/09  |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 3/9/09  | MR                                                                                  |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 3/9/09  | RT                                                                                  |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 3-5-09  | SP                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 3-11    | TR                                                                                  |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 3/18    | —                                                                                   |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |                                                                                     |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             |         |                                                                                     |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-19-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-19-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-25-09 | SPD                                                                                 |
|      | 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> |                                                                                             |         |                                                                                     |

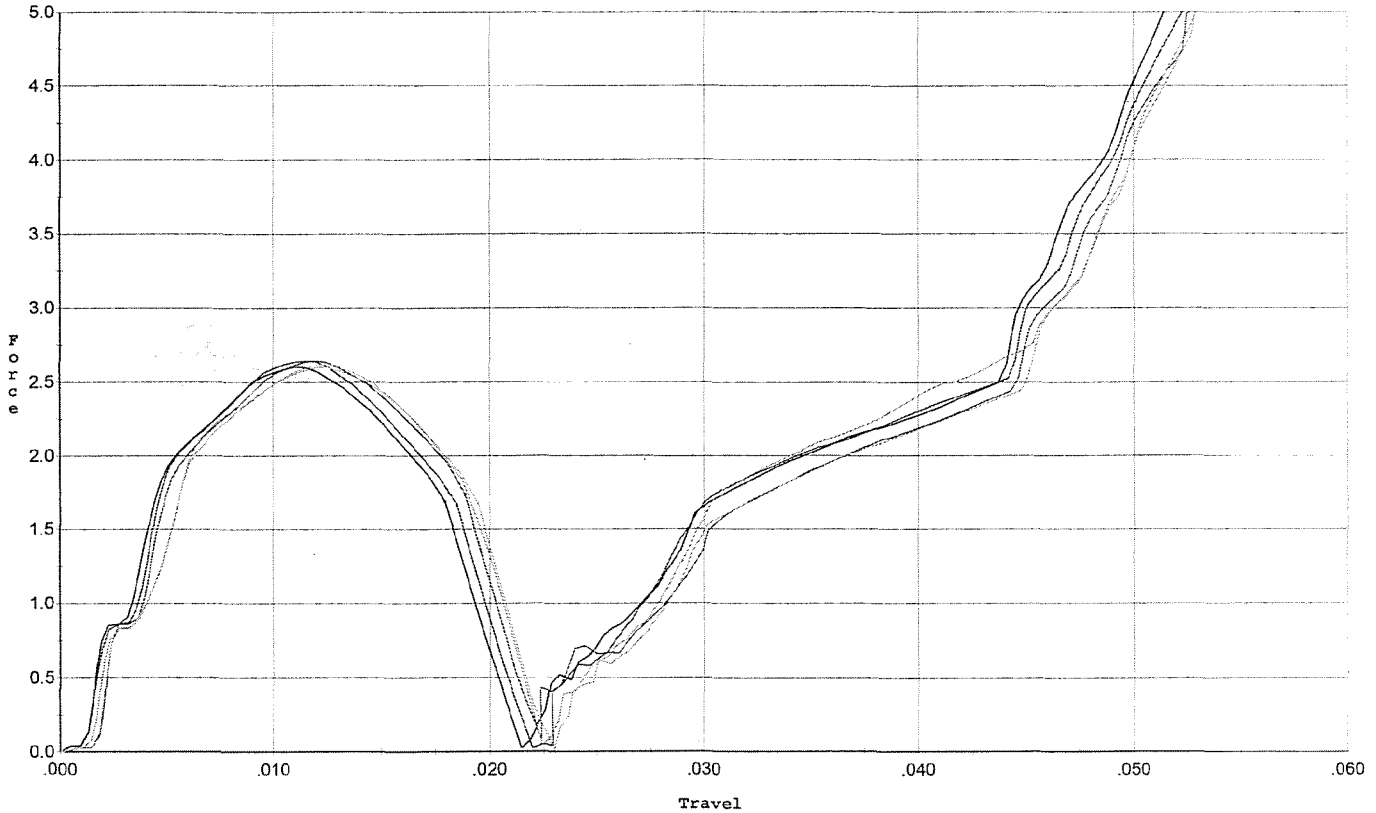
F004 REV 5/2006

| OP #         | OPERATION NAME                                                           | REMARKS                                                     | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.0</u> <u>5.0</u> <u>5.0</u>                            | 3-28-09 | DN      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>5.0</u> <u>5.0</u> <u>5.0</u>                            | 3-28-09 | DN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.022</u> <u>.028</u>                         | 3-28-09 | DN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-28-09 | DN      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-28-09 | DN      |
|              | 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>PASS</u> FAIL FAIL                           | 3-26-09 | WY      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-26-09 | TL      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-28-09 | DN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.51</u> <u>2.45</u> <u>2.54</u> <u>2.43</u> <u>2.57</u> | 3-27-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3-28-09 | DN      |
| 690          | PACK                                                                     |                                                             | 3/28/09 | FM      |

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



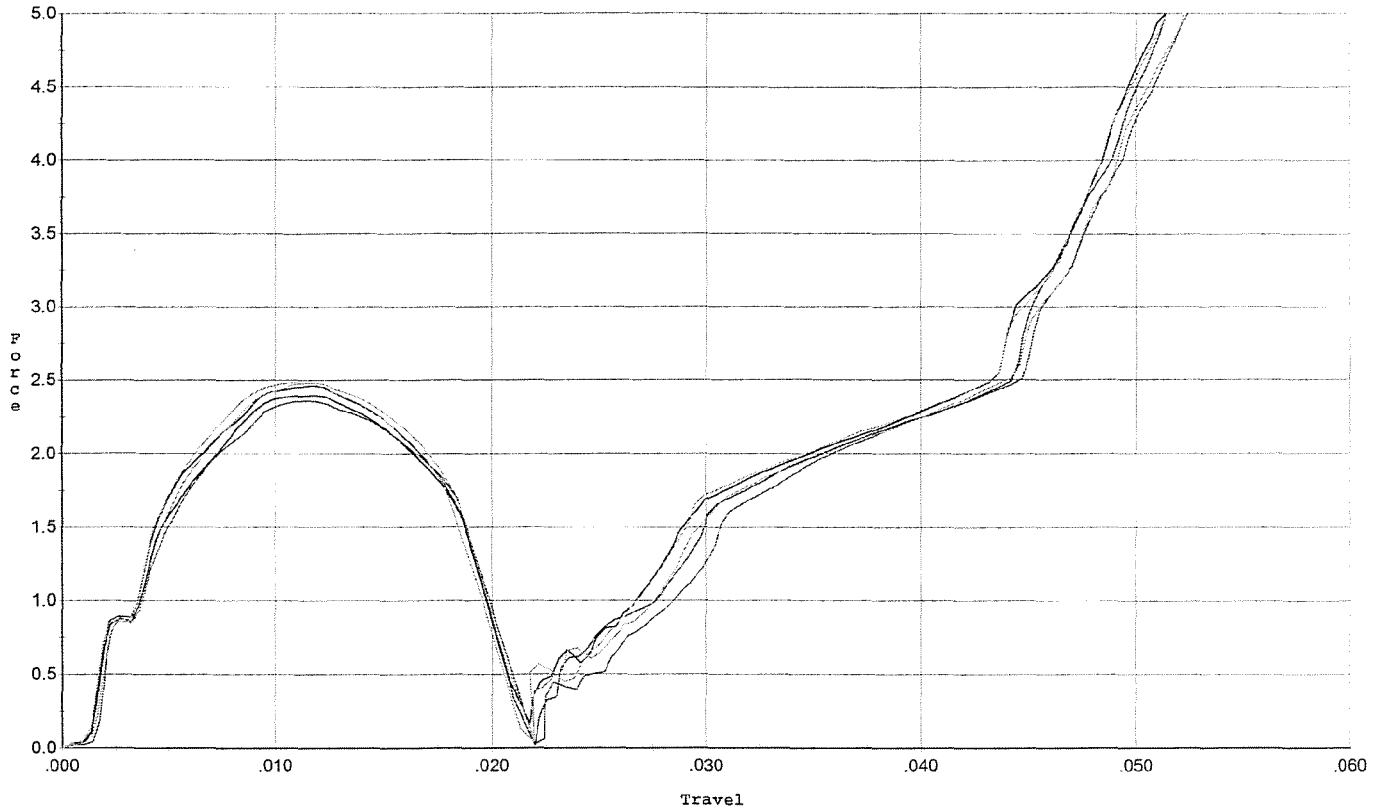
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.642      | 0.018             | 0.00            | 0.038      | 0.033             |           | Set Trigger |
| 2 | 2.603      | 0.018             | 0.00            | 0.038      | 0.032             |           | Set Trigger |
| 3 | 2.644      | 0.019             | 0.00            | 0.037      | 0.033             |           | Set Trigger |
| 4 | 2.622      | 0.019             | 0.00            | 0.037      | 0.034             |           | Set Trigger |
| 5 | 2.601      | 0.020             | 0.00            | 0.037      | 0.035             |           | Set Trigger |

A-2.62

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



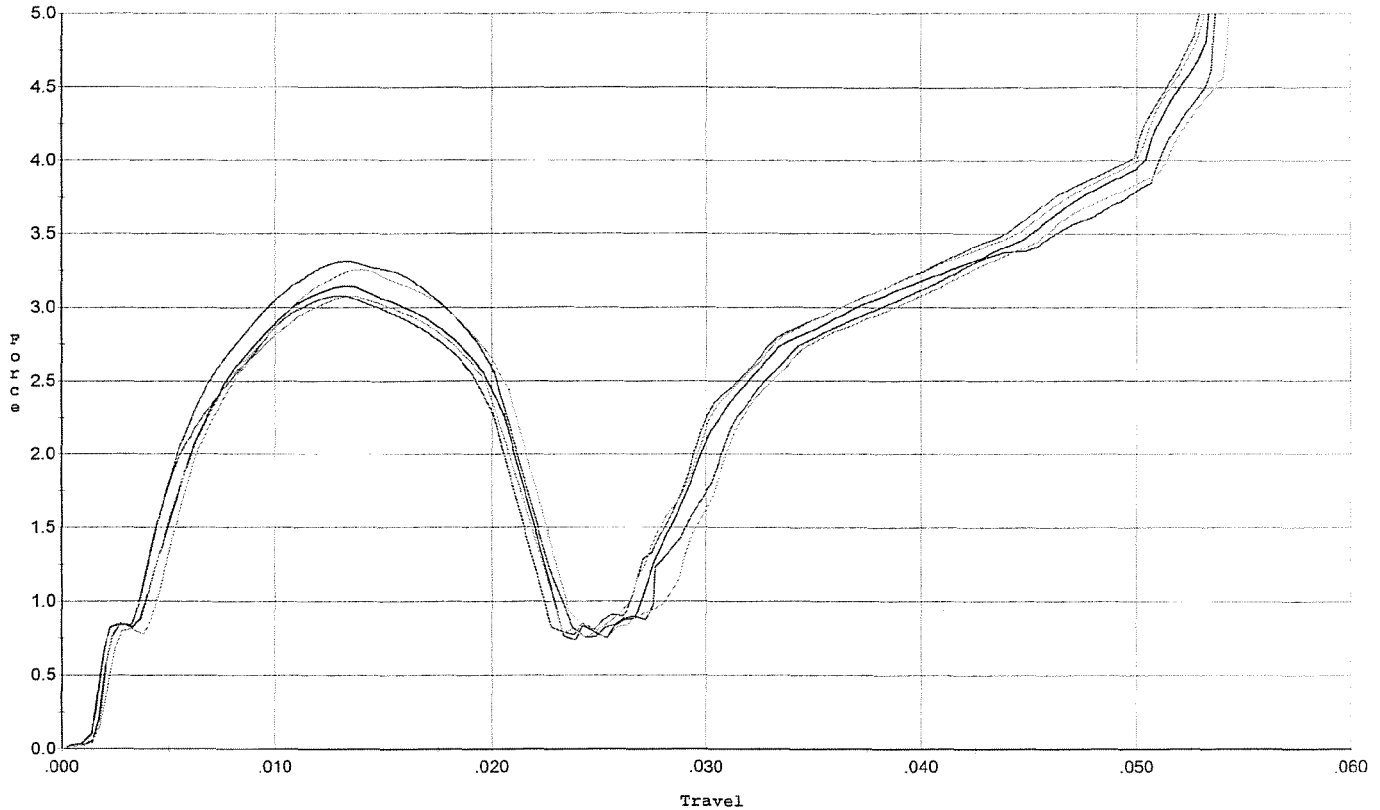
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.458      | 0.019             | 0.00            | 0.038      | 0.032             |           | Set Trigger |
| 2 | 2.396      | 0.019             | 0.00            | 0.037      | 0.031             |           | Set Trigger |
| 3 | 2.358      | 0.018             | 0.00            | 0.038      | 0.030             |           | Set Trigger |
| 4 | 2.484      | 0.019             | 0.00            | 0.037      | 0.033             |           | Set Trigger |
| 5 | 2.482      | 0.018             | 0.00            | 0.038      | 0.031             |           | Set Trigger |

A-2.43

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



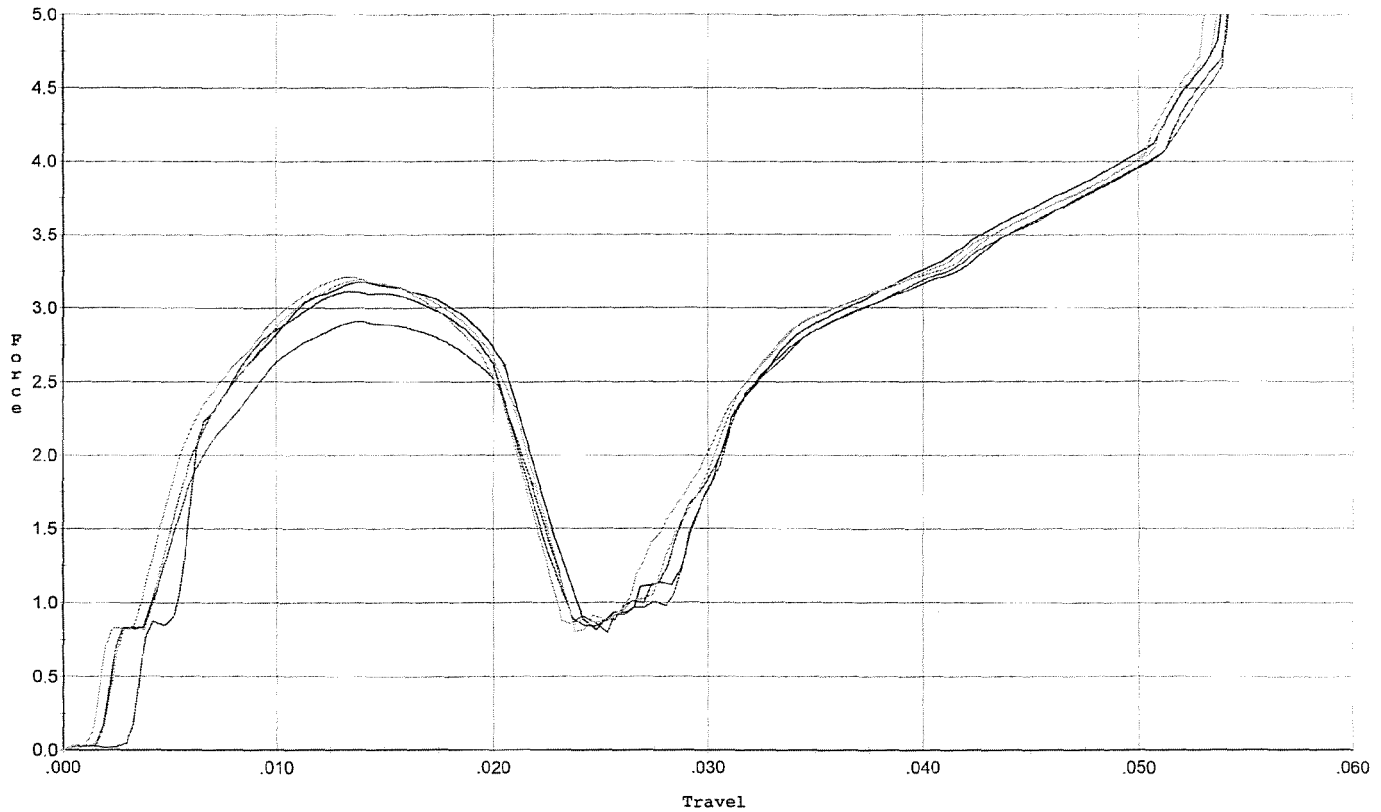
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.312      | 0.020             | 0.00            | 0.035      | 0.045             |           | Set Trigger |
| 2 | 3.143      | 0.021             | 0.00            | 0.035      | 0.043             |           | Set Trigger |
| 3 | 3.080      | 0.020             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 4 | 3.260      | 0.021             | 0.00            | 0.035      | 0.045             |           | Set Trigger |
| 5 | 3.074      | 0.021             | 0.00            | 0.035      | 0.043             |           | Set Trigger |

A-3-17

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



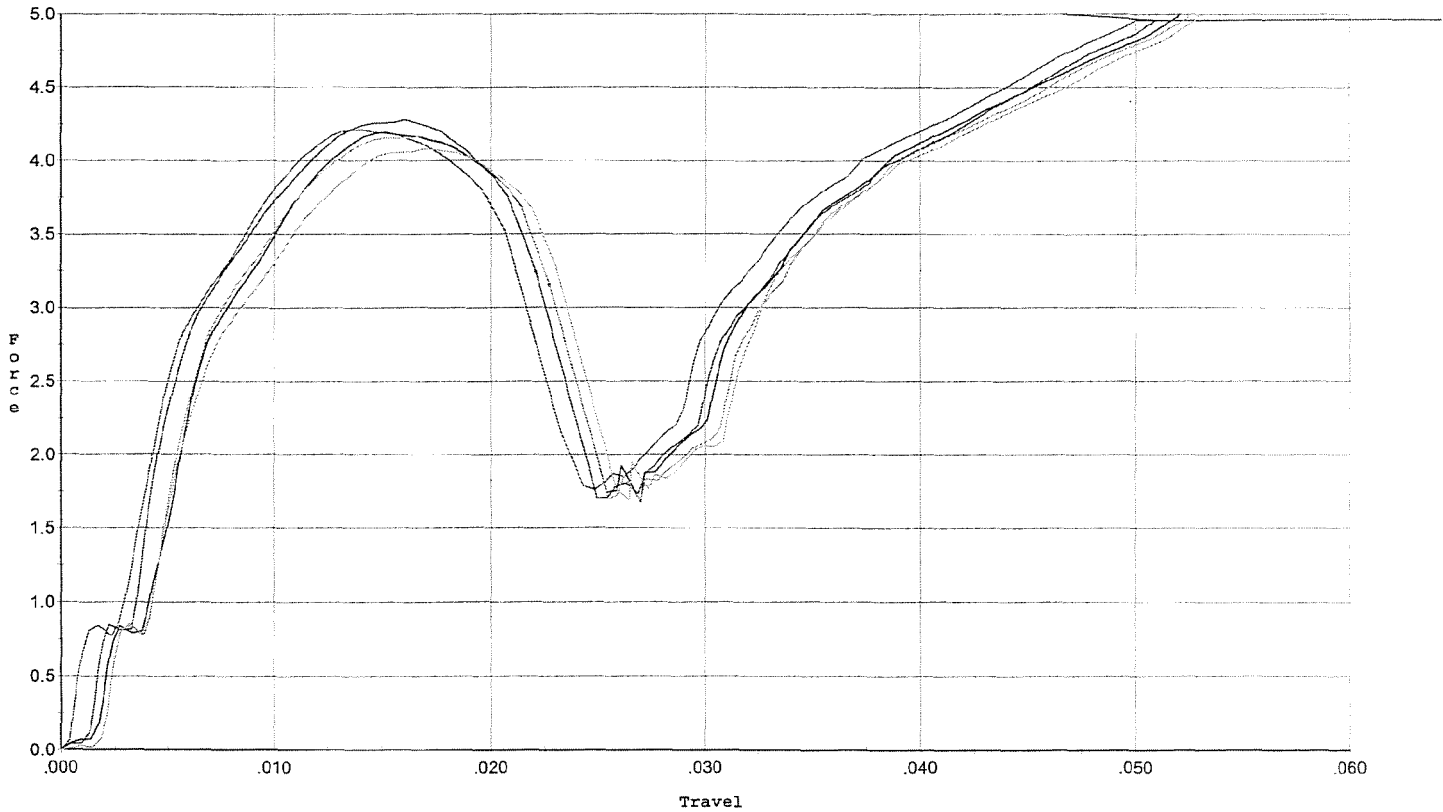
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.112      | 0.020             | 0.003           | 0.036      | 0.040             |           | Set Trigger |
| 2 | 3.174      | 0.021             | 0.004           | 0.035      | 0.044             |           | Set Trigger |
| 3 | 2.907      | 0.022             | 0.00            | 0.035      | 0.043             |           | Set Trigger |
| 4 | 3.190      | 0.021             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 5 | 3.210      | 0.020             | 0.004           | 0.035      | 0.044             |           | Set Trigger |

A-3.11

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



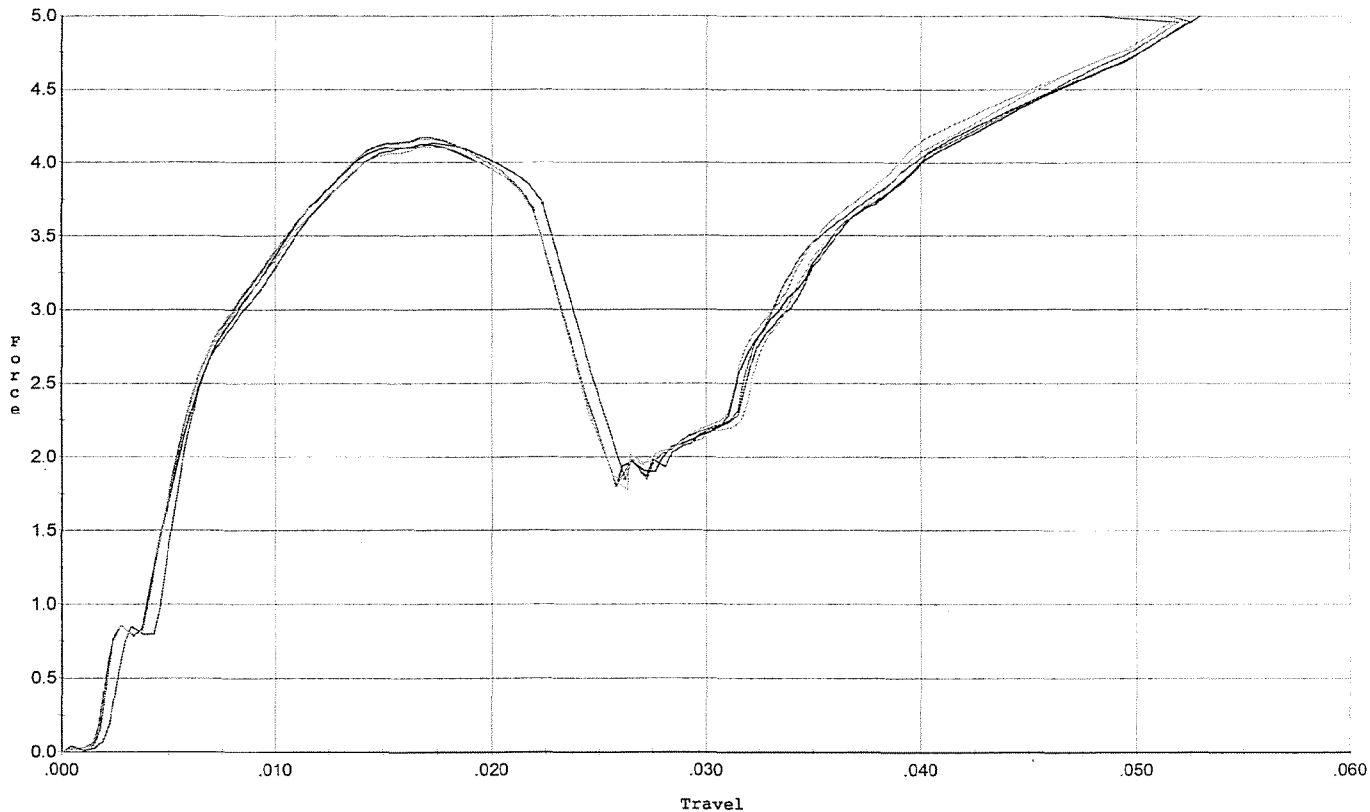
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.277      | 0.022             | 0.00            | 0.032      | 0.063             |           | Set Trigger |
| 2 | 4.193      | 0.023             | 0.00            | 0.032      | 0.062             |           | Set Trigger |
| 3 | 4.207      | 0.021             | 0.00            | 0.032      | 0.059             |           | Set Trigger |
| 4 | 4.079      | 0.023             | 0.002           | 0.032      | 0.062             |           | Set Trigger |
| 5 | 4.169      | 0.023             | 0.00            | 0.032      | 0.062             |           | Set Trigger |

A-4-18

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/13/2009

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



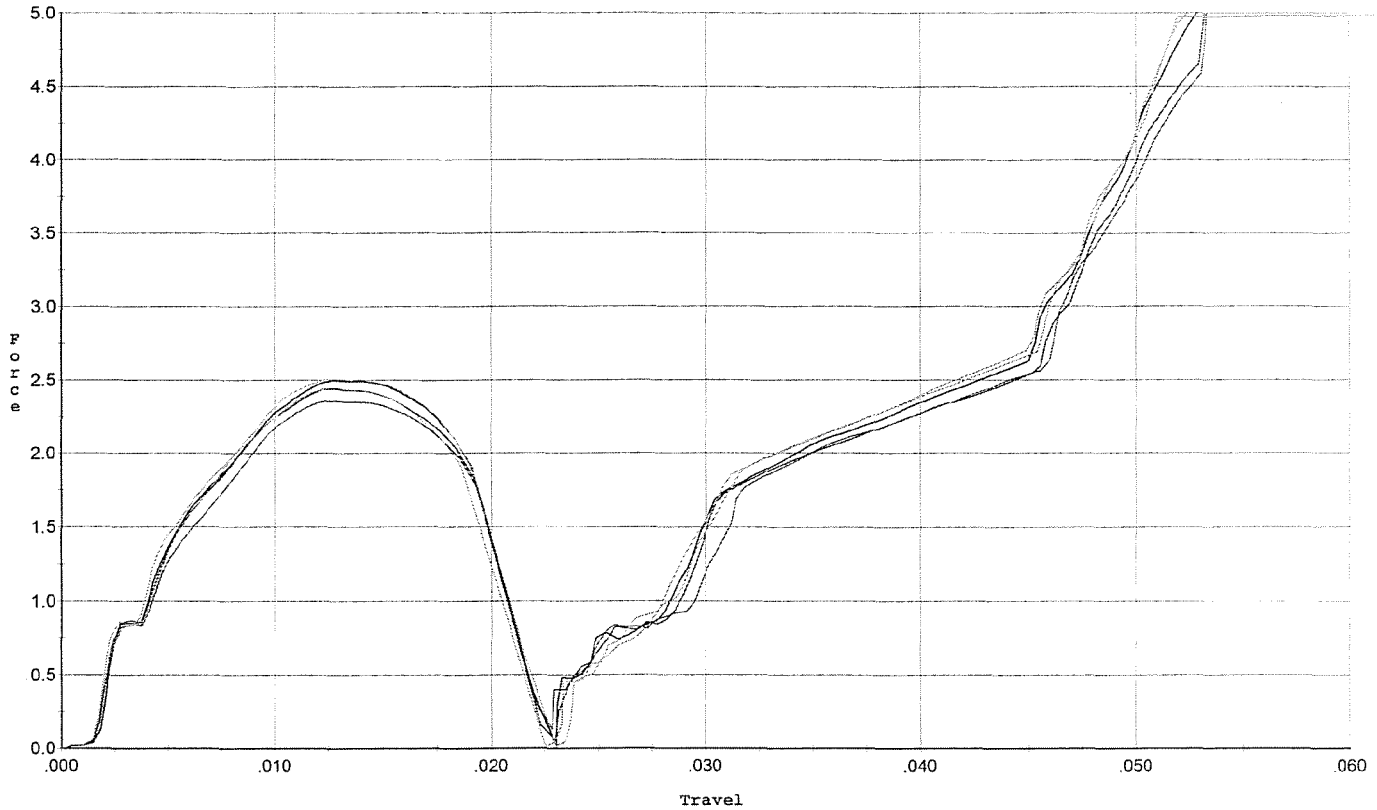
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.134      | 0.022             | 0.005           | 0.033      | 0.060             |           | Set Trigger |
| 2 | 4.127      | 0.022             | 0.00            | 0.033      | 0.060             |           | Set Trigger |
| 3 | 4.170      | 0.022             | 0.00            | 0.033      | 0.060             |           | Set Trigger |
| 4 | 4.110      | 0.022             | 0.00            | 0.033      | 0.059             |           | Set Trigger |
| 5 | 4.161      | 0.022             | 0.00            | 0.033      | 0.060             |           | Set Trigger |

A-4.14

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

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



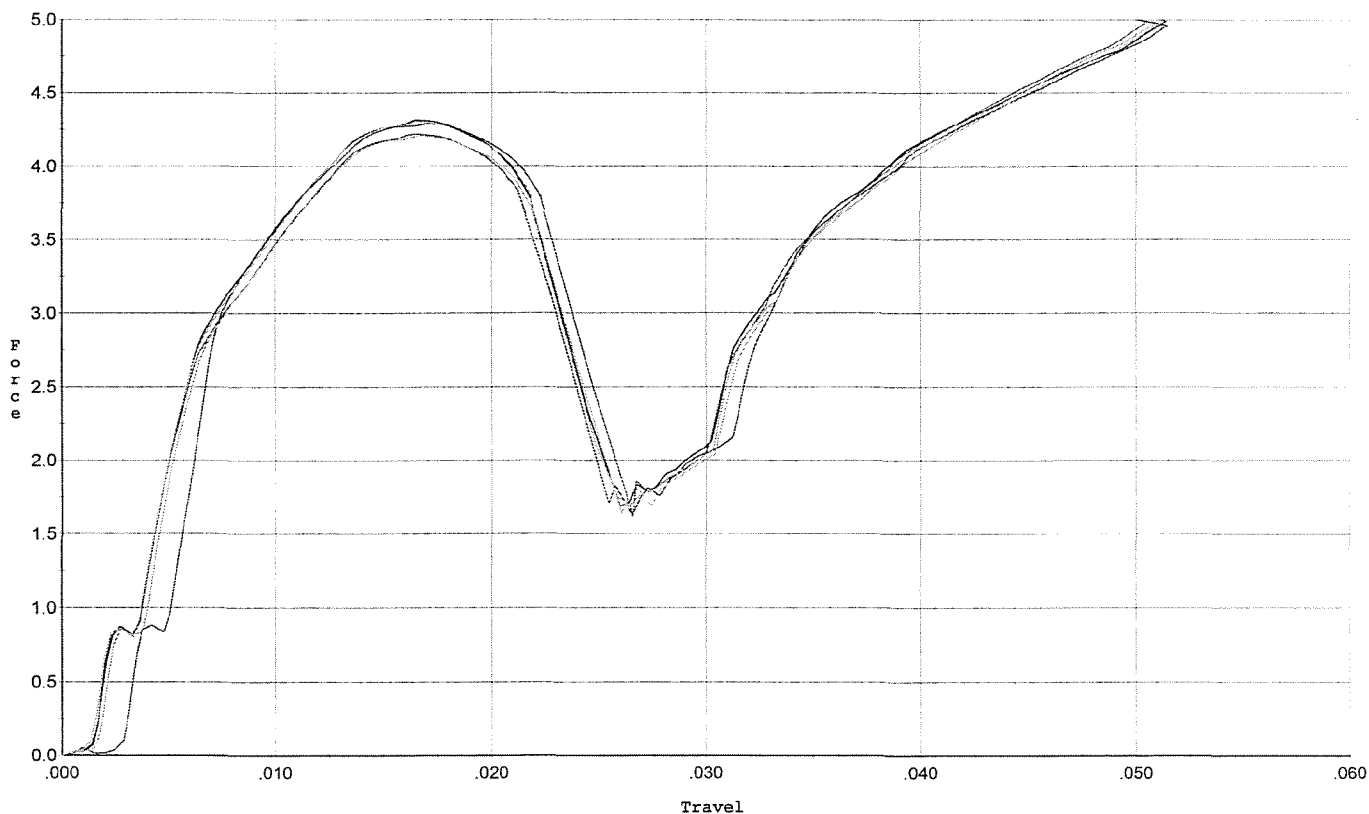
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.446      | 0.019             | 0.00            | 0.038      | 0.032             |           | Set Trigger |
| 2 | 2.501      | 0.019             | 0.004           | 0.037      | 0.032             |           | Set Trigger |
| 3 | 2.359      | 0.019             | 0.00            | 0.038      | 0.031             |           | Set Trigger |
| 4 | 2.510      | 0.019             | 0.00            | 0.038      | 0.033             |           | Set Trigger |
| 5 | 2.439      | 0.020             | 0.00            | 0.037      | 0.033             |           | Set Trigger |

A-2.45

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/13/2009

**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 | 4.289      | 0.022             | 0.003           | 0.033      | 0.061             |           | Set Trigger |
| 2 | 4.314      | 0.022             | 0.00            | 0.032      | 0.062             |           | Set Trigger |
| 3 | 4.221      | 0.023             | 0.00            | 0.032      | 0.063             |           | Set Trigger |
| 4 | 4.305      | 0.022             | 0.00            | 0.033      | 0.062             |           | Set Trigger |
| 5 | 4.210      | 0.022             | 0.00            | 0.032      | 0.061             |           | Set Trigger |

A-4.26