

G6801463

**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



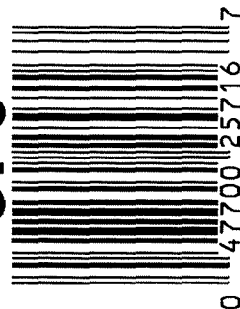
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6801463**

**UPC**



M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801463

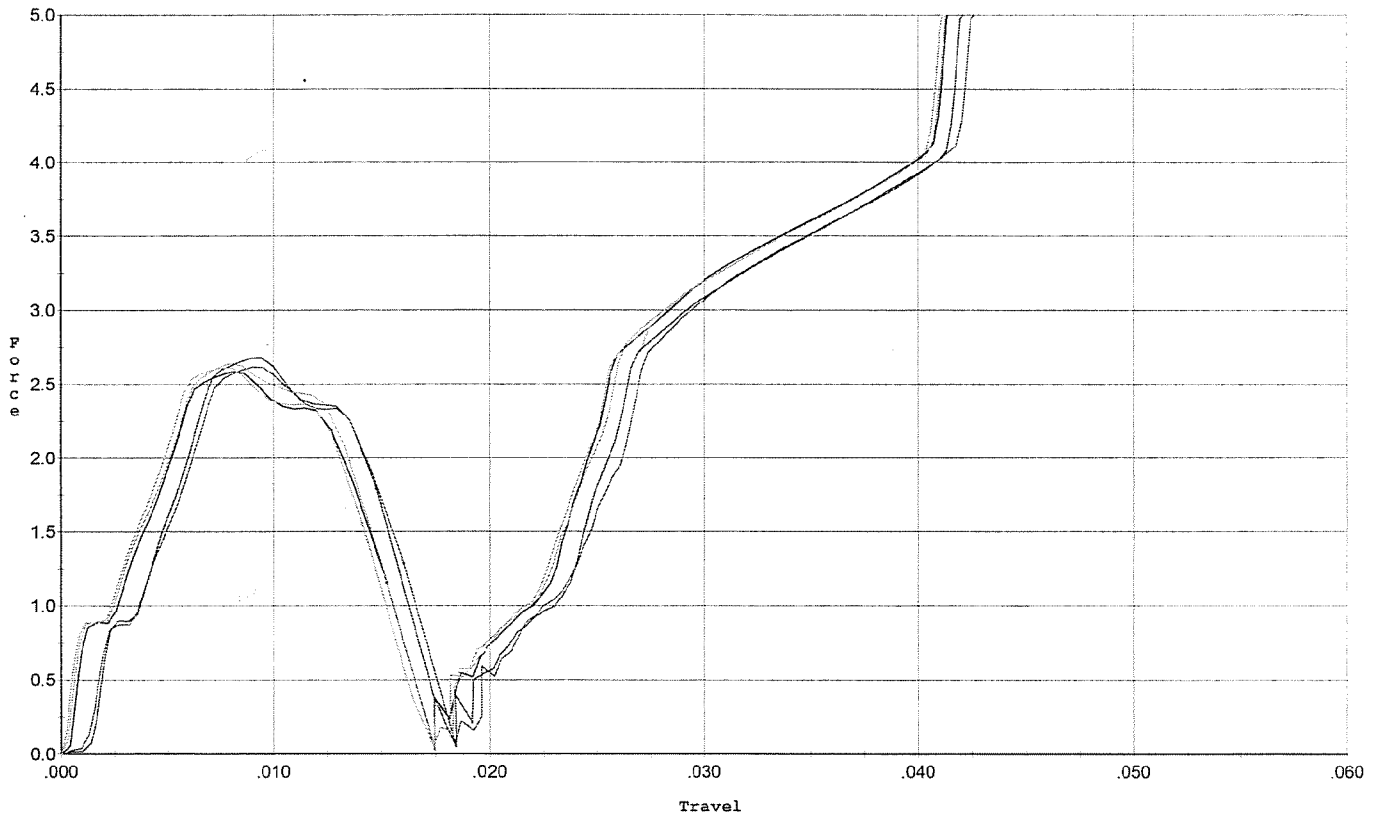
| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 3-4-09  | SP      |
| 430  | ASSEMBLE TO STOCK                                              |                     | 3-4-09  | SP      |
| 440  | PROOF                                                          |                     | 3-4-09  | SP      |
| 460  | CHECK HEADSPACE                                                |                     | 3-4-09  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 3-4-09  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 3-5-09  | RTZ     |
| 480  | MAGNAFLUX BBL ACTION                                           |                     | 3/9/09  | SP      |
| 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    | TL      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3/8     |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-19-09 | SP      |
|      | 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                                     |                     | 3-21-09 | RTZ     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>3.0</u> <u>2.8</u> <u>2.8</u>                            | 3/23/09 | RP      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>5.8</u> <u>5.6</u> <u>5.6</u>                            | 3/23/09 | RP      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.022</u> <u>.022</u> <sup>2</sup> RP         | 3/23/09 | RP      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3/21/09 | TL      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3/23/09 | RP      |
|              | 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                        | 3-23-09 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-23-09 | WW      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3/23/09 | RP      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.68</u> <u>2.66</u> <u>2.67</u> <u>2.65</u> <u>2.63</u> | 3-23-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3/23/09 | RP      |
| 690          | PACK                                                                     |                                                             | 3/24/09 | Fm      |

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/19/2009

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



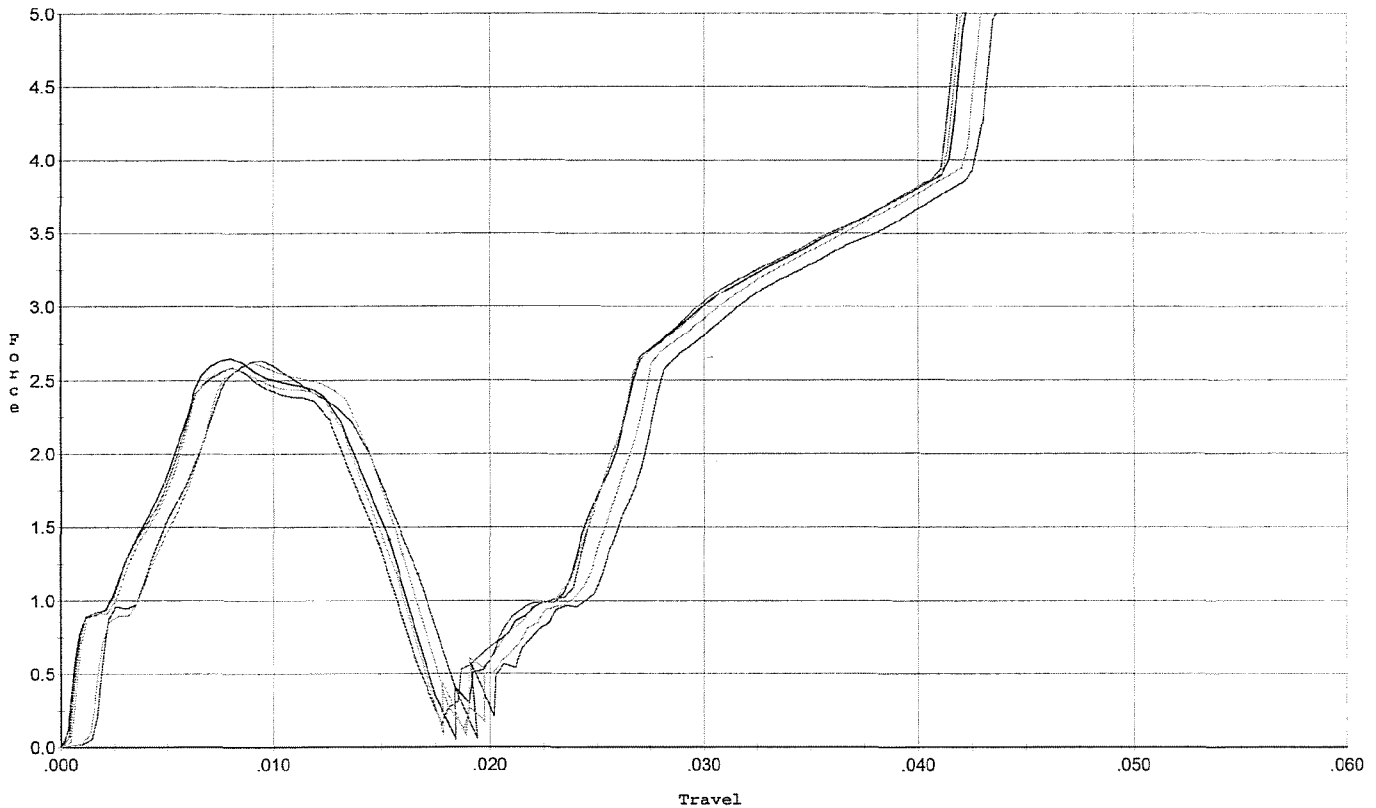
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.680      | 0.015             | 0.00            | 0.030      | 0.025             |           | Set Trigger |
| 2 | 2.586      | 0.015             | 0.00            | 0.029      | 0.026             |           | Set Trigger |
| 3 | 2.616      | 0.016             | 0.00            | 0.030      | 0.026             |           | Set Trigger |
| 4 | 2.610      | 0.014             | 0.00            | 0.030      | 0.025             |           | Set Trigger |
| 5 | 2.642      | 0.015             | 0.00            | 0.029      | 0.027             |           | Set Trigger |

A-2.62

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/19/2009

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



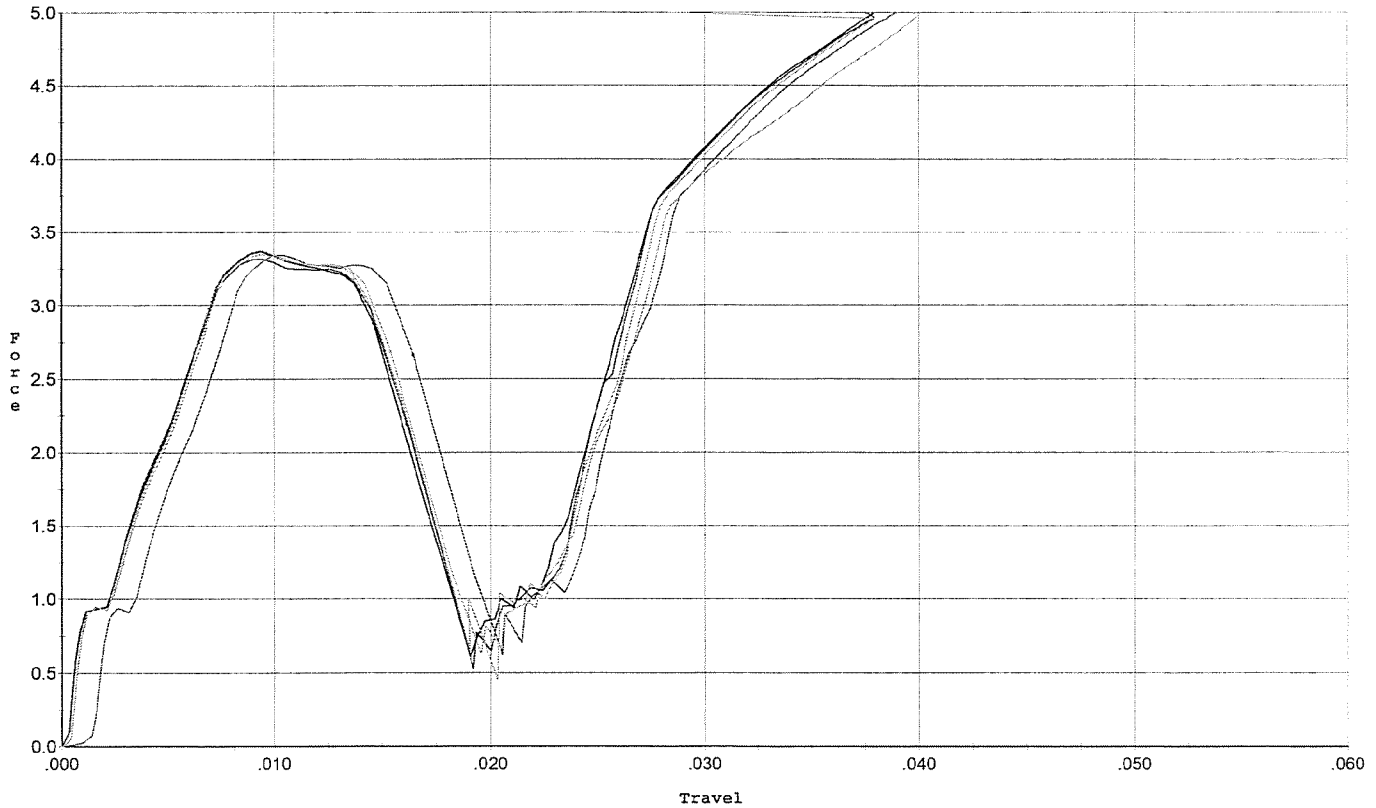
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.636      | 0.017             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 2 | 2.653      | 0.015             | 0.00            | 0.030      | 0.027             |           | Set Trigger |
| 3 | 2.591      | 0.015             | 0.00            | 0.030      | 0.026             |           | Set Trigger |
| 4 | 2.586      | 0.016             | 0.00            | 0.030      | 0.027             |           | Set Trigger |
| 5 | 2.622      | 0.016             | 0.00            | 0.030      | 0.026             |           | Set Trigger |

A-2-61

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/19/2009

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



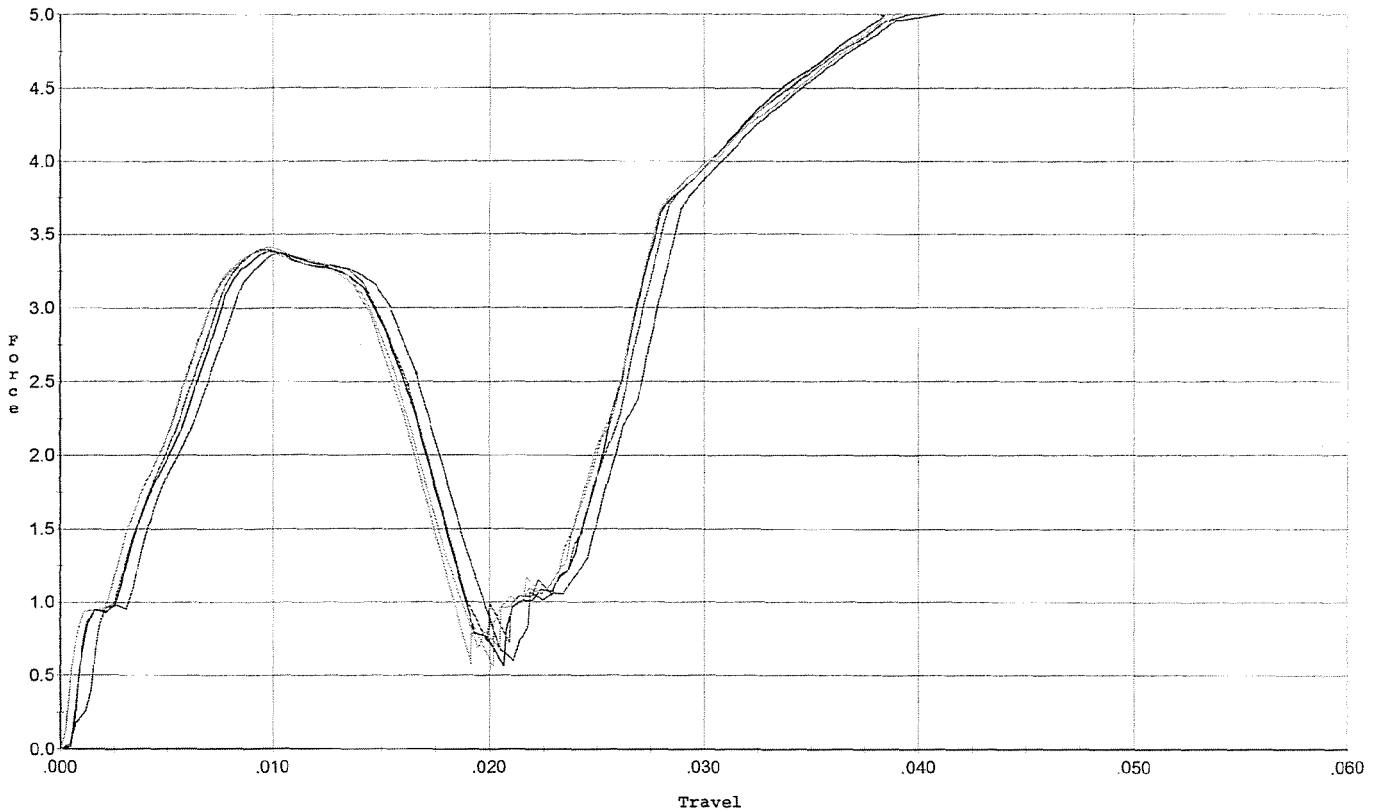
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.317      | 0.016             | 0.00            | 0.027      | 0.036             |           | Set Trigger |
| 2 | 3.369      | 0.015             | 0.00            | 0.027      | 0.033             |           | Set Trigger |
| 3 | 3.345      | 0.016             | 0.00            | 0.028      | 0.035             |           | Set Trigger |
| 4 | 3.351      | 0.015             | 0.00            | 0.027      | 0.035             |           | Set Trigger |
| 5 | 3.380      | 0.016             | 0.00            | 0.028      | 0.036             |           | Set Trigger |

A-3-35

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/19/2009

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



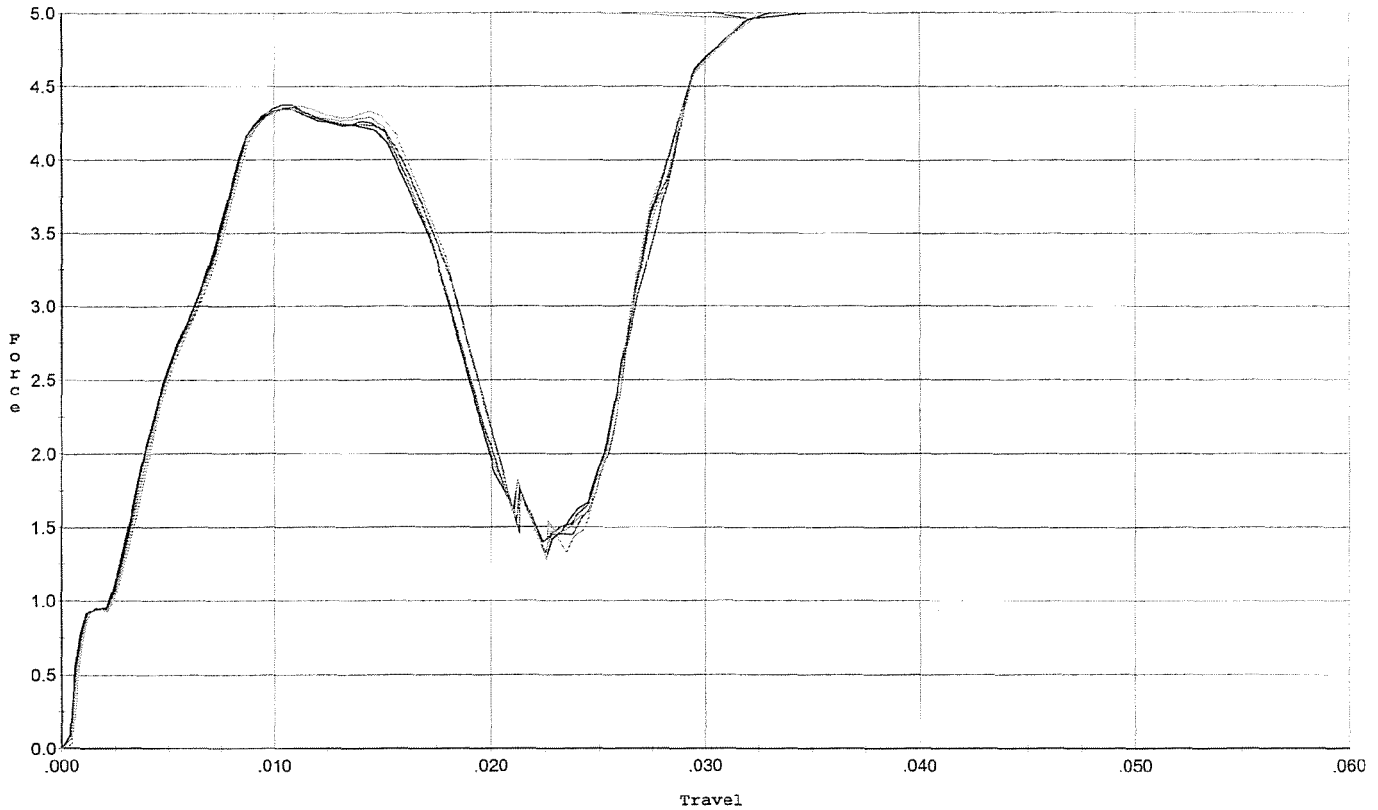
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.376      | 0.017             | 0.00            | 0.028      | 0.036             |           | Set Trigger |
| 2 | 3.390      | 0.016             | 0.00            | 0.027      | 0.036             |           | Set Trigger |
| 3 | 3.397      | 0.016             | 0.00            | 0.028      | 0.036             |           | Set Trigger |
| 4 | 3.412      | 0.016             | 0.00            | 0.027      | 0.036             |           | Set Trigger |
| 5 | 3.384      | 0.016             | 0.00            | 0.027      | 0.036             |           | Set Trigger |

A 3.39

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/19/2009

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



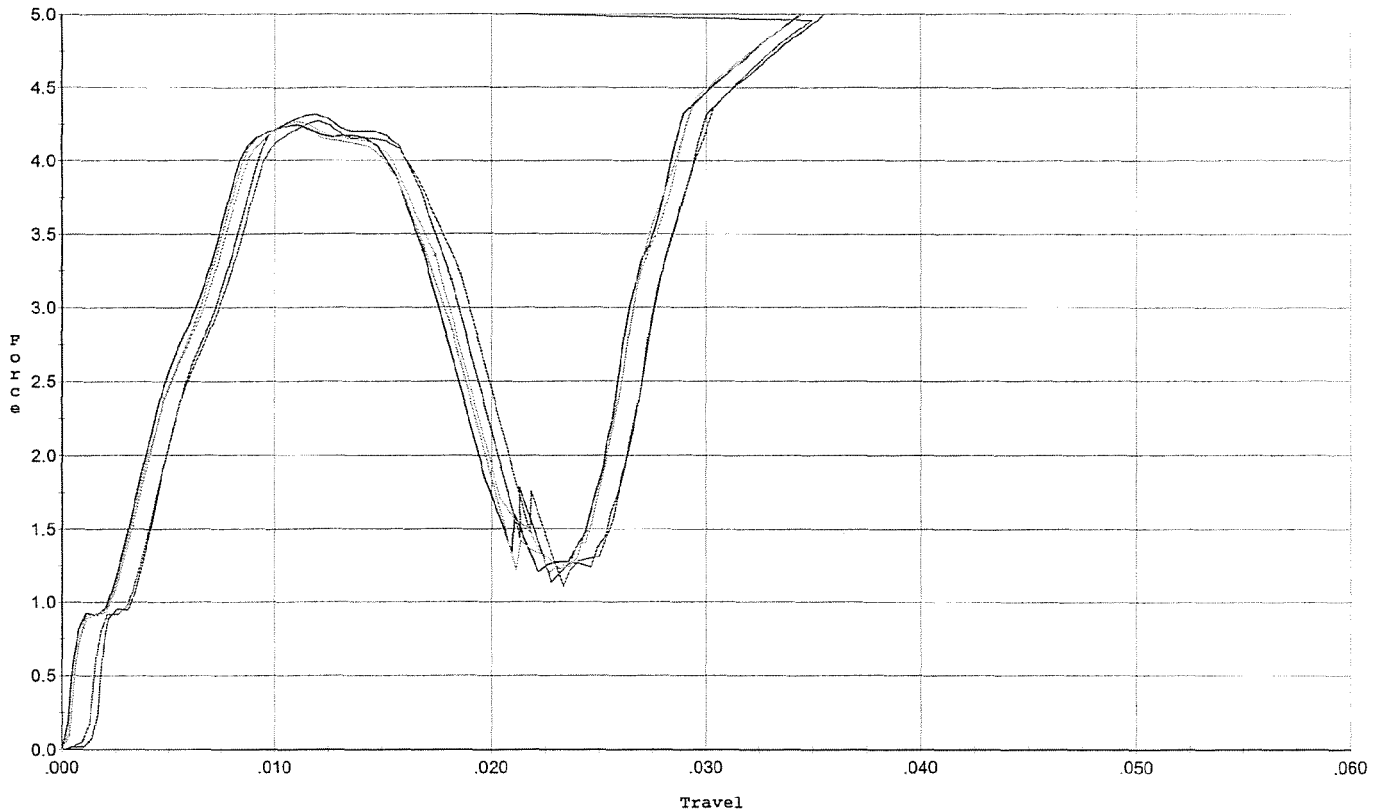
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.375      | 0.017             | 0.00            | 0.025      | 0.049             |           | Set Trigger |
| 2 | 4.355      | 0.017             | 0.00            | 0.026      | 0.049             |           | Set Trigger |
| 3 | 4.358      | 0.018             | 0.00            | 0.025      | 0.052             |           | Set Trigger |
| 4 | 4.371      | 0.018             | 0.00            | 0.025      | 0.051             |           | Set Trigger |
| 5 | 4.345      | 0.017             | 0.00            | 0.026      | 0.049             |           | Set Trigger |

A 4.36

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/19/2009

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



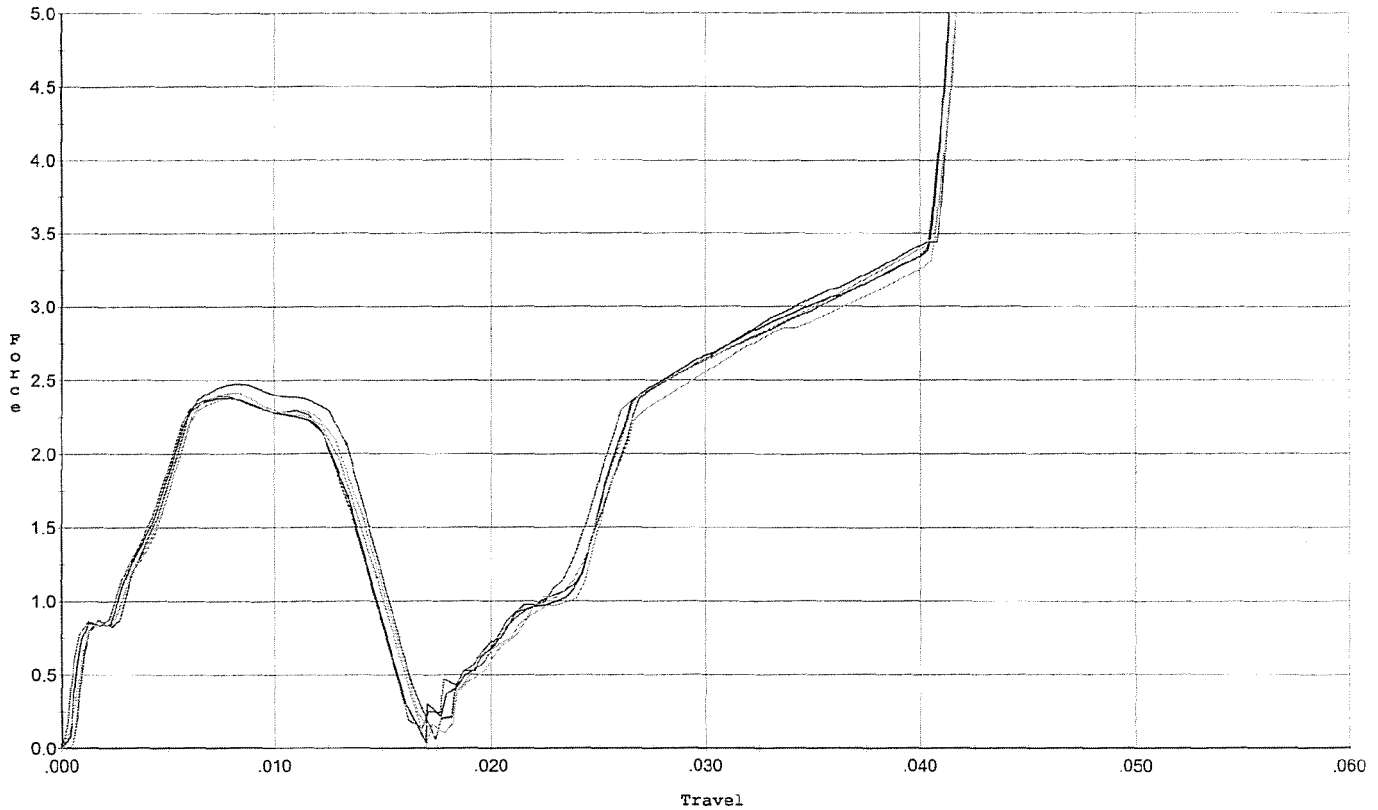
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.318      | 0.018             | 0.00            | 0.027      | 0.049             |           | Set Trigger |
| 2 | 4.246      | 0.017             | 0.00            | 0.026      | 0.047             |           | Set Trigger |
| 3 | 4.273      | 0.019             | 0.00            | 0.027      | 0.050             |           | Set Trigger |
| 4 | 4.267      | 0.017             | 0.00            | 0.026      | 0.048             |           | Set Trigger |
| 5 | 4.241      | 0.018             | 0.00            | 0.026      | 0.050             |           | Set Trigger |

A-4-26

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/19/2009

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



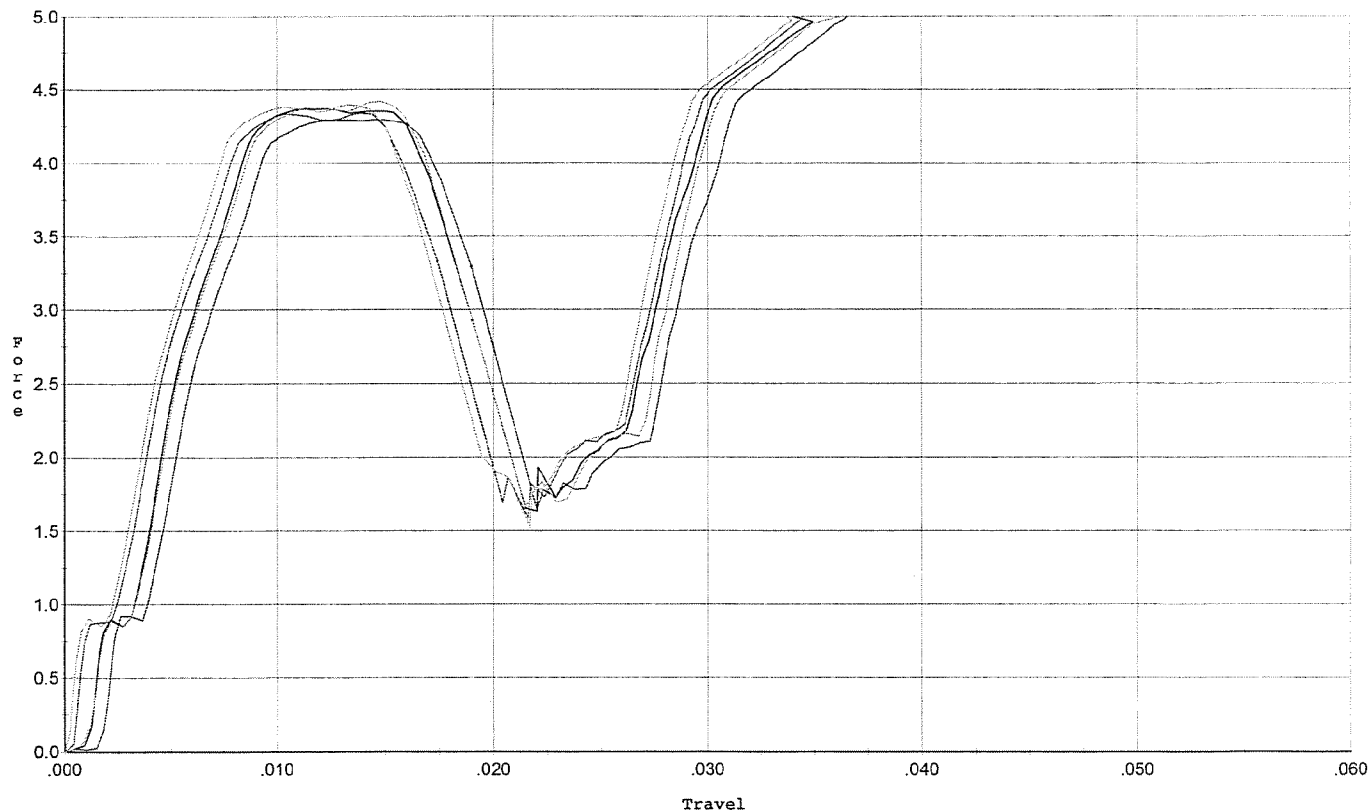
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.473      | 0.013             | 0.00            | 0.031      | 0.023             |           | Set Trigger |
| 2 | 2.380      | 0.013             | 0.003           | 0.031      | 0.022             |           | Set Trigger |
| 3 | 2.392      | 0.014             | 0.00            | 0.031      | 0.023             |           | Set Trigger |
| 4 | 2.374      | 0.014             | 0.00            | 0.031      | 0.023             |           | Set Trigger |
| 5 | 2.414      | 0.015             | 0.00            | 0.031      | 0.024             |           | Set Trigger |

A-2-40

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/19/2009

**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 | 4.292      | 0.019             | 0.004           | 0.024      | 0.052             |           | Set Trigger |
| 2 | 4.370      | 0.019             | 0.00            | 0.024      | 0.054             |           | Set Trigger |
| 3 | 4.338      | 0.017             | 0.002           | 0.023      | 0.051             |           | Set Trigger |
| 4 | 4.395      | 0.016             | 0.00            | 0.024      | 0.048             |           | Set Trigger |
| 5 | 4.418      | 0.019             | 0.00            | 0.024      | 0.054             |           | Set Trigger |

A-4136