

G680 7694

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

proof of purchase



owner registration sticker



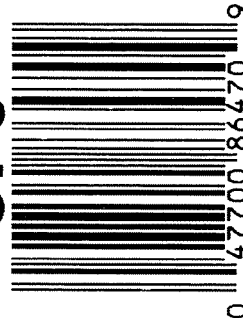
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6807694**

**UPC**



BM FORM

M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807694

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 1-21-09 | SP                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 1-21-09 | SP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                             | 1-21-09 | SP                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 1-21-09 | SP                                                                                  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 1-21-09 | SP                                                                                  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 1-22-09 | RT                                                                                  |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 1-22-09 | SP                                                                                  |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 1-23-09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 1-23-09 | MR                                                                                  |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 1-24-09 | RT                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 1-24-09 | DS                                                                                  |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 1-30    |                                                                                     |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |                                                                                     |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 1-30-09 | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 1-30-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 1-30-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 1-31-09 | 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

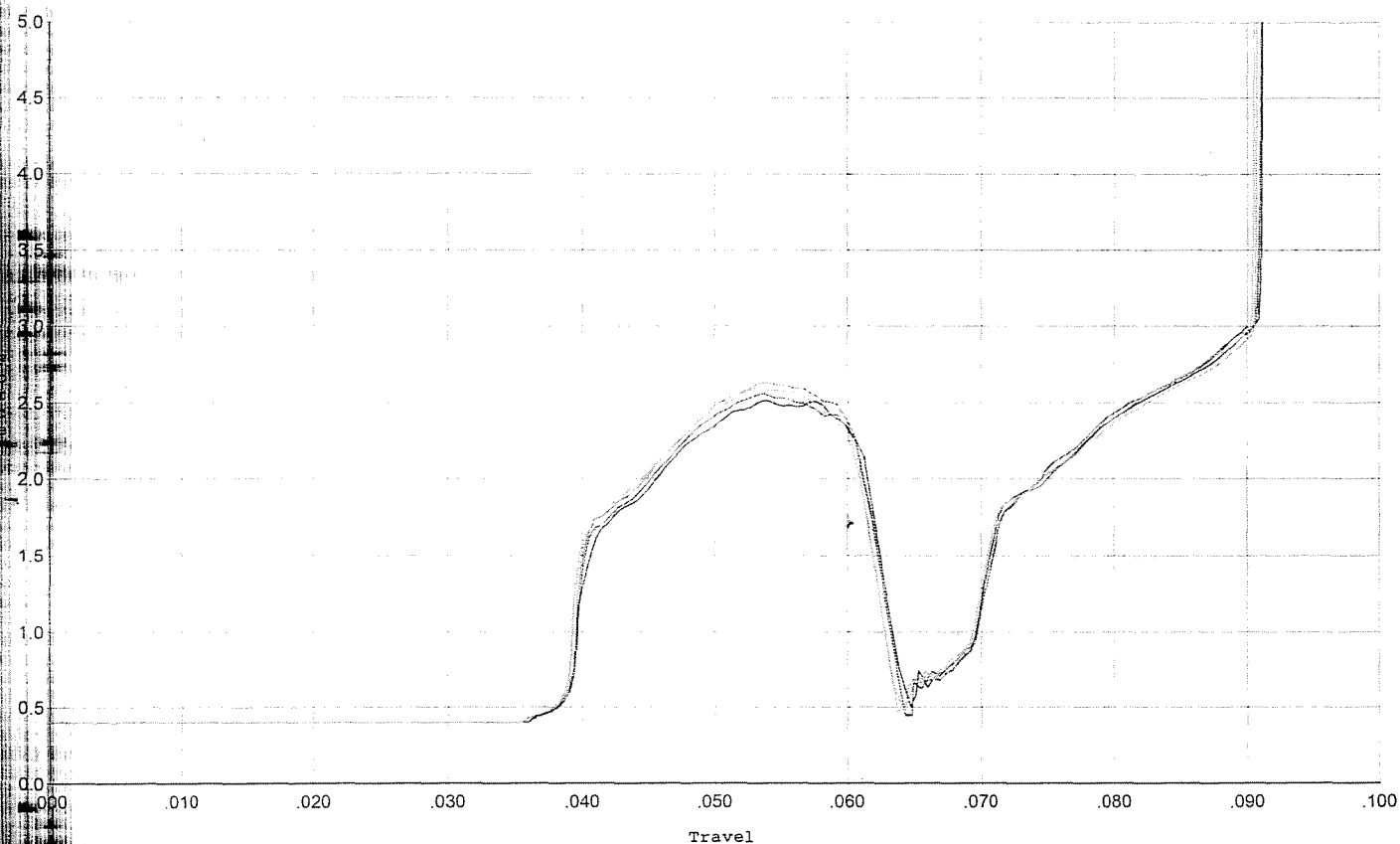
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.0</u> <u>4.0</u> <u>4.0</u>                            | 2-6-09  | LJ      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>7.0</u> <u>7.0</u> <u>7.0</u>                            | 2-6-09  | LJ      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 2-6-09  | LJ      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 1-31-09 | LJ      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 2-6-09  | LJ      |
|              | 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                        | 2-3-09  | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-3-09  | WN      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 2-6-09  | LJ      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.47</u> <u>2.45</u> <u>2.44</u> <u>2.44</u> <u>2.41</u> | 2-4-09  | WN      |
|              | C) FUNCTION                                                              |                                                             | 2-6-09  | LJ      |
| 690          | PACK                                                                     |                                                             | 2/14/09 | Fog     |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 1/21/2009

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



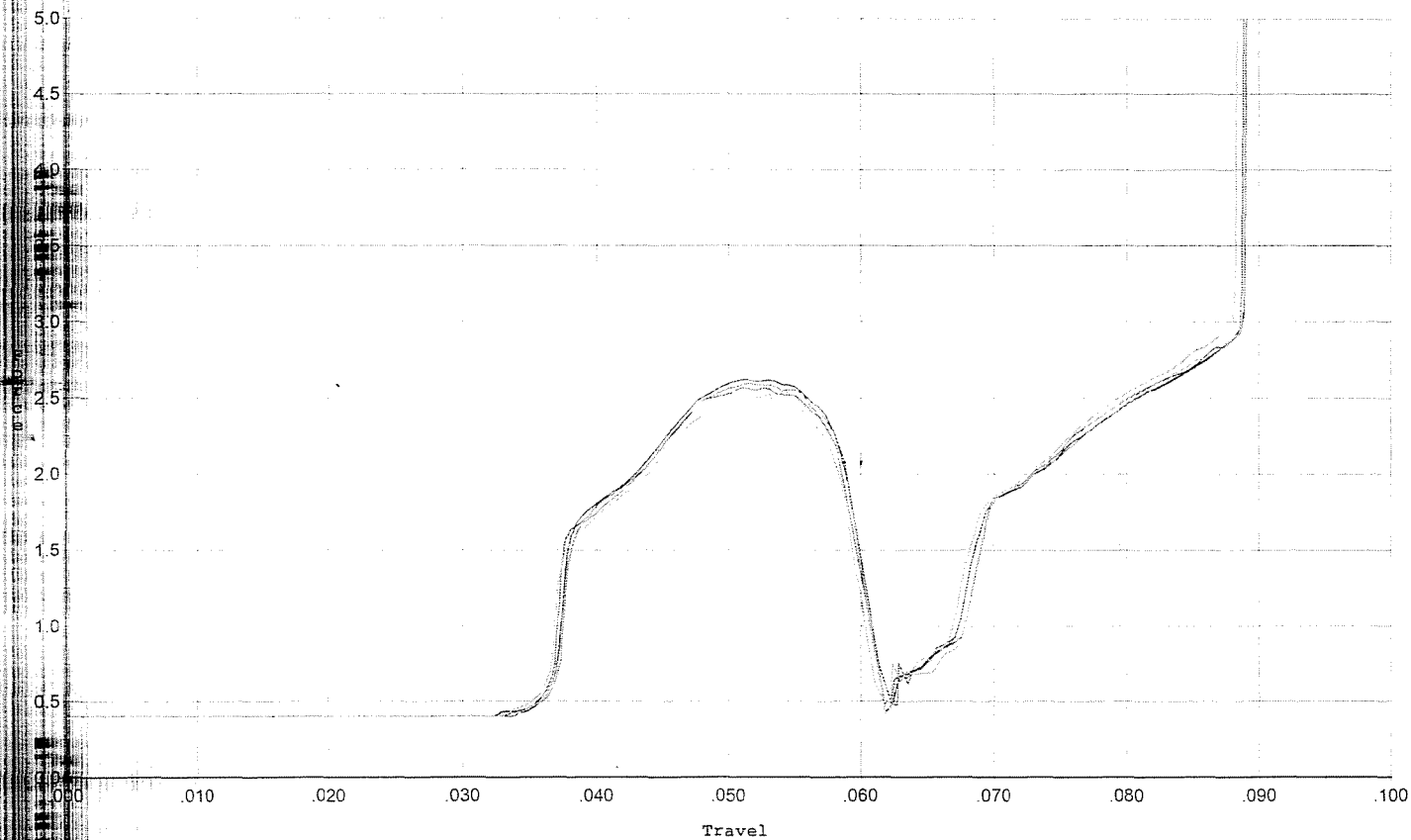
|   | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.558      | 0.062             | 0.039           | 0.035      | 0.065             |           | Set Trigger |
| 2 | 2.515      | 0.061             | 0.039           | 0.035      | 0.064             |           | Set Trigger |
| 3 | 2.632      | 0.062             | 0.039           | 0.035      | 0.067             |           | Set Trigger |
| 4 | 2.572      | 0.061             | 0.039           | 0.035      | 0.065             |           | Set Trigger |
| 5 | 2.593      | 0.061             | 0.039           | 0.035      | 0.065             |           | Set Trigger |

A-2-57

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 1/21/2009

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



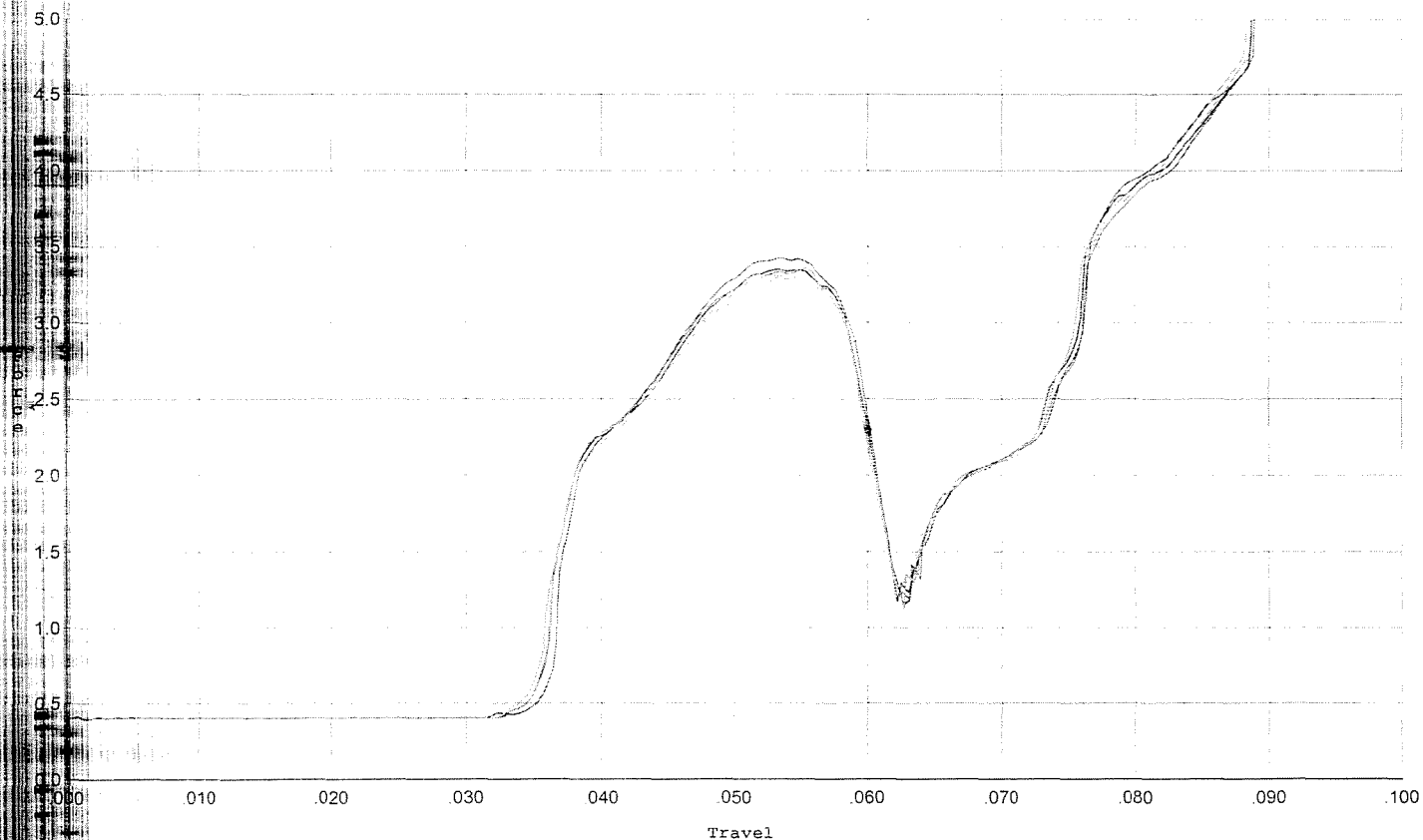
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.568      | 0.060             | 0.037           | 0.036      | 0.065             |           | Set Trigger |
| 2 | 2.618      | 0.059             | 0.037           | 0.036      | 0.065             |           | Set Trigger |
| 3 | 2.596      | 0.059             | 0.037           | 0.036      | 0.064             |           | Set Trigger |
| 4 | 2.521      | 0.059             | 0.037           | 0.036      | 0.063             |           | Set Trigger |
| 5 | 2.542      | 0.058             | 0.036           | 0.036      | 0.062             |           | Set Trigger |

A-2-56

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 1/21/2009

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



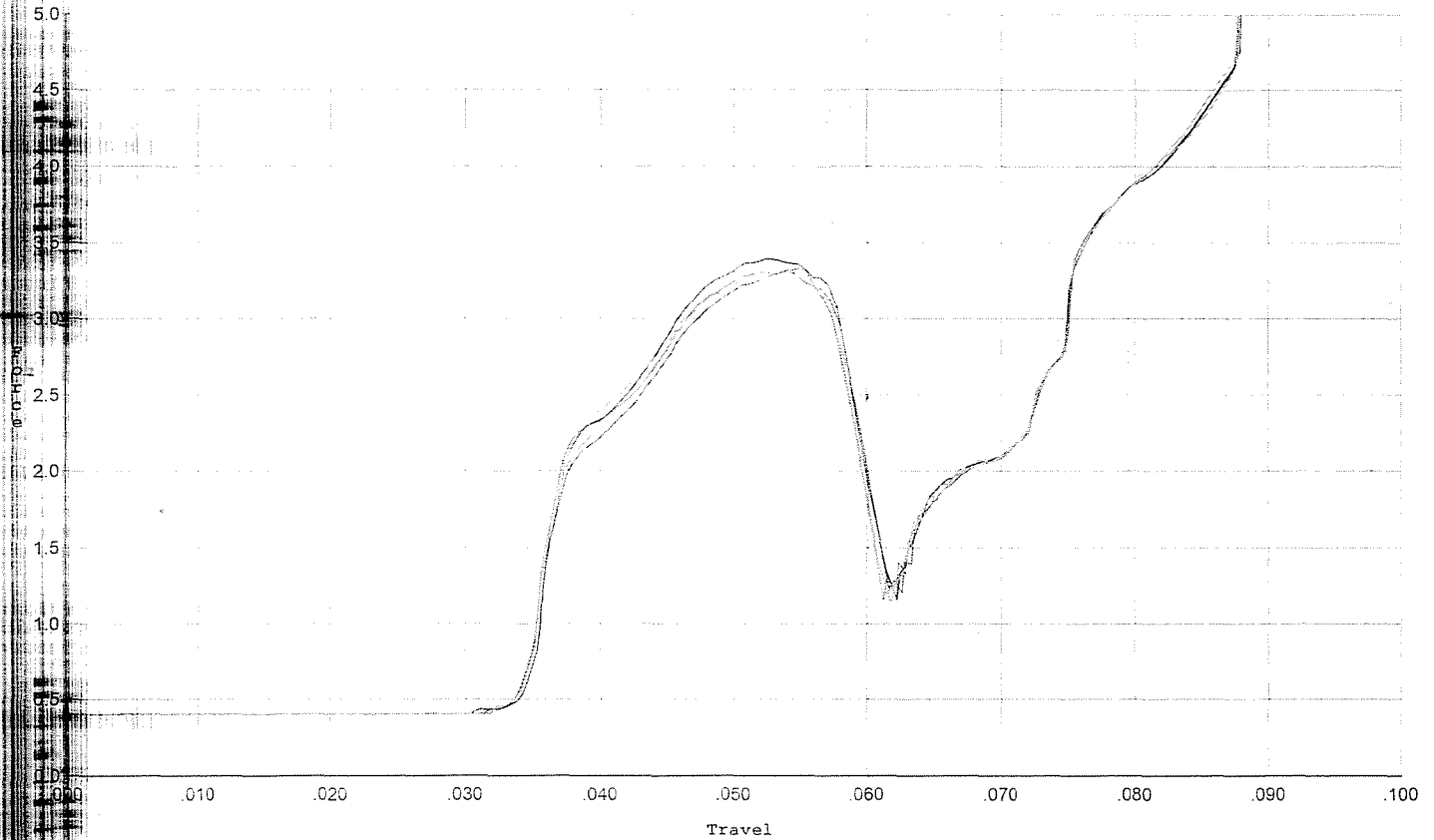
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.424      | 0.059             | 0.036           | 0.034      | 0.081             |           | Set Trigger |
| 2 | 3.353      | 0.060             | 0.035           | 0.034      | 0.081             |           | Set Trigger |
| 3 | 3.361      | 0.060             | 0.035           | 0.034      | 0.082             |           | Set Trigger |
| 4 | 3.356      | 0.058             | 0.035           | 0.034      | 0.079             |           | Set Trigger |
| 5 | 3.312      | 0.058             | 0.035           | 0.034      | 0.078             |           | Set Trigger |

7.3.36

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/21/2009

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 | 3.331      | 0.060             | 0.034           | 0.034      | 0.081             |           | Set Trigger |
| 2 | 3.393      | 0.058             | 0.035           | 0.034      | 0.080             |           | Set Trigger |
| 3 | 3.310      | 0.059             | 0.034           | 0.034      | 0.080             |           | Set Trigger |
| 4 | 3.311      | 0.058             | 0.034           | 0.034      | 0.080             |           | Set Trigger |
| 5 | 3.350      | 0.058             | 0.034           | 0.034      | 0.080             |           | Set Trigger |

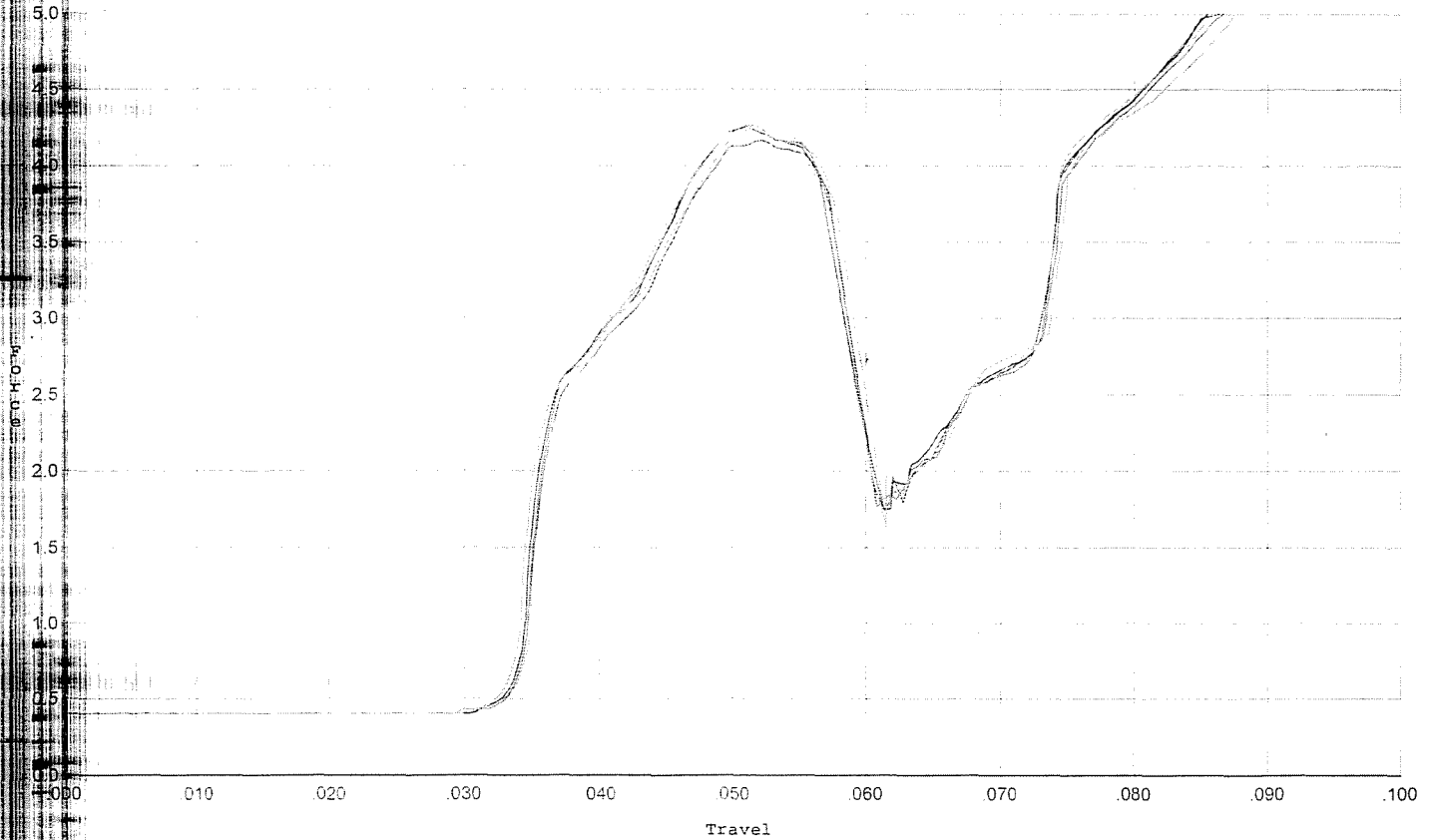
A-3.33



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/21/2009

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



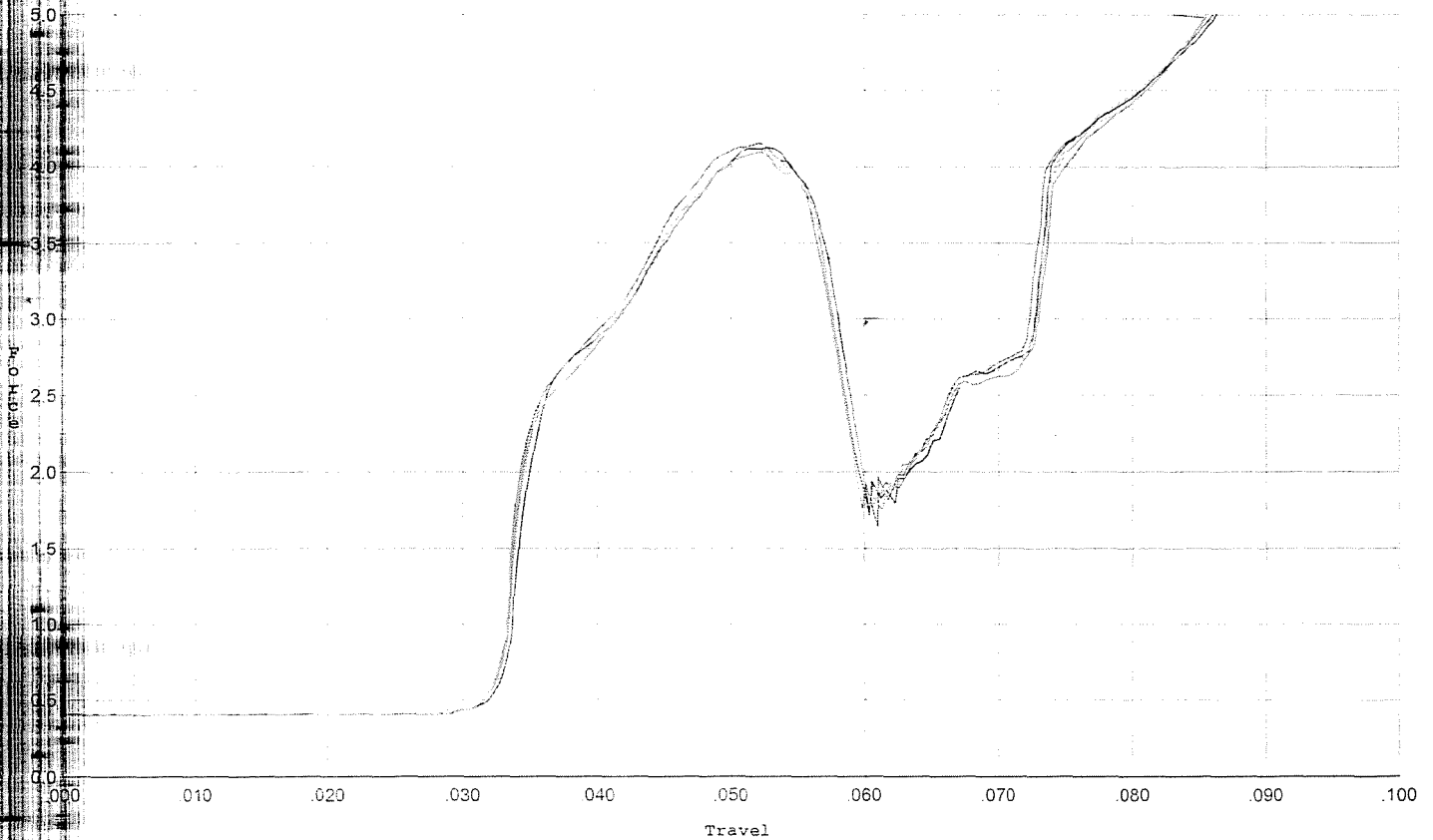
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.166      | 0.057             | 0.034           | 0.032      | 0.093             |           | Set Trigger |
| 2 | 4.257      | 0.057             | 0.034           | 0.033      | 0.094             |           | Set Trigger |
| 3 | 4.265      | 0.057             | 0.034           | 0.033      | 0.096             |           | Set Trigger |
| 4 | 4.258      | 0.057             | 0.033           | 0.033      | 0.094             |           | Set Trigger |
| 5 | 4.265      | 0.058             | 0.034           | 0.033      | 0.096             |           | Set Trigger |

A. 4.24

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/21/2009

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



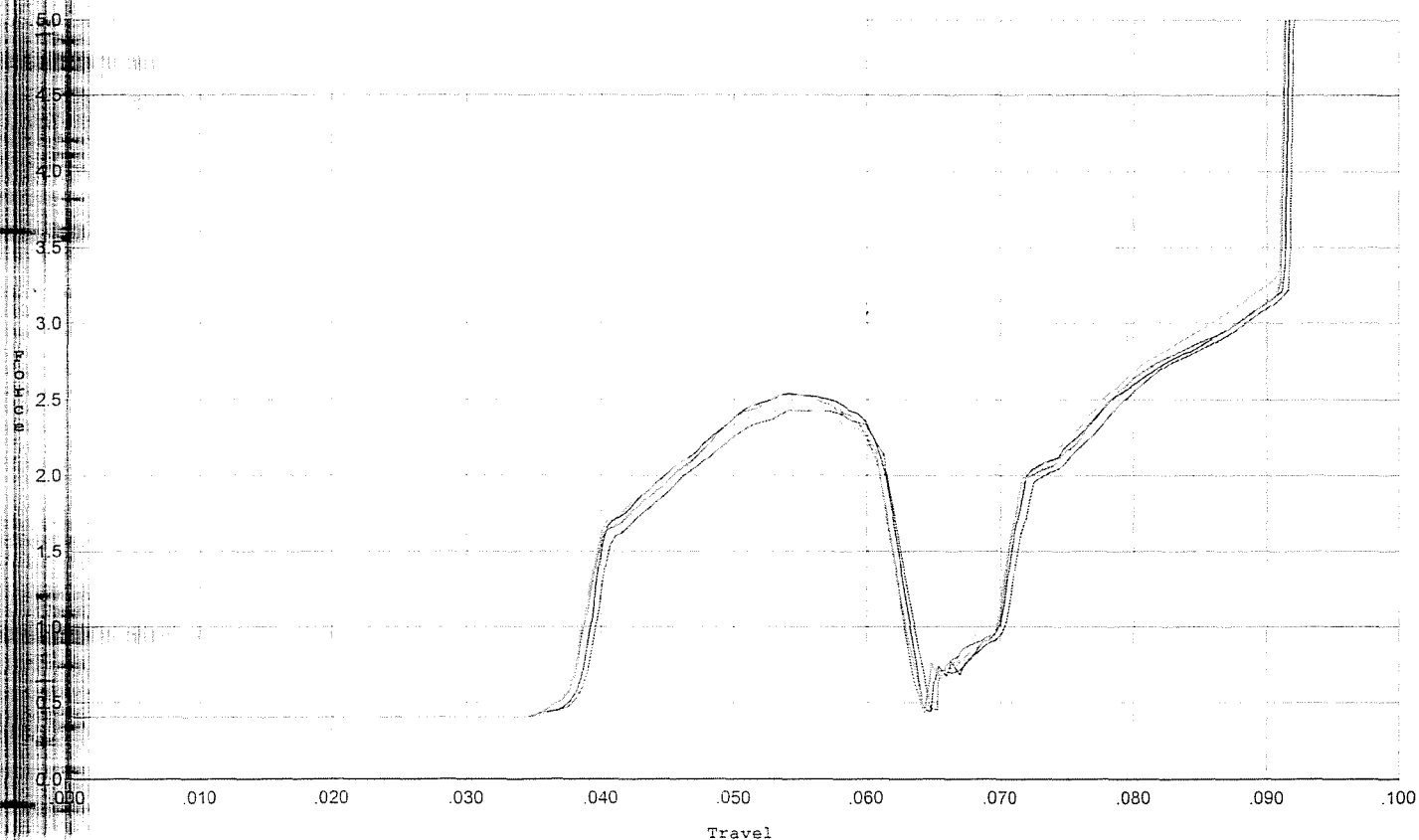
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.154      | 0.057             | 0.032           | 0.032      | 0.095             |           | Set Trigger |
| 2 | 4.125      | 0.057             | 0.033           | 0.032      | 0.094             |           | Set Trigger |
| 3 | 4.099      | 0.056             | 0.032           | 0.033      | 0.092             |           | Set Trigger |
| 4 | 4.112      | 0.058             | 0.032           | 0.032      | 0.096             |           | Set Trigger |
| 5 | 4.090      | 0.057             | 0.032           | 0.032      | 0.093             |           | Set Trigger |

A-4.11

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/21/2009

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



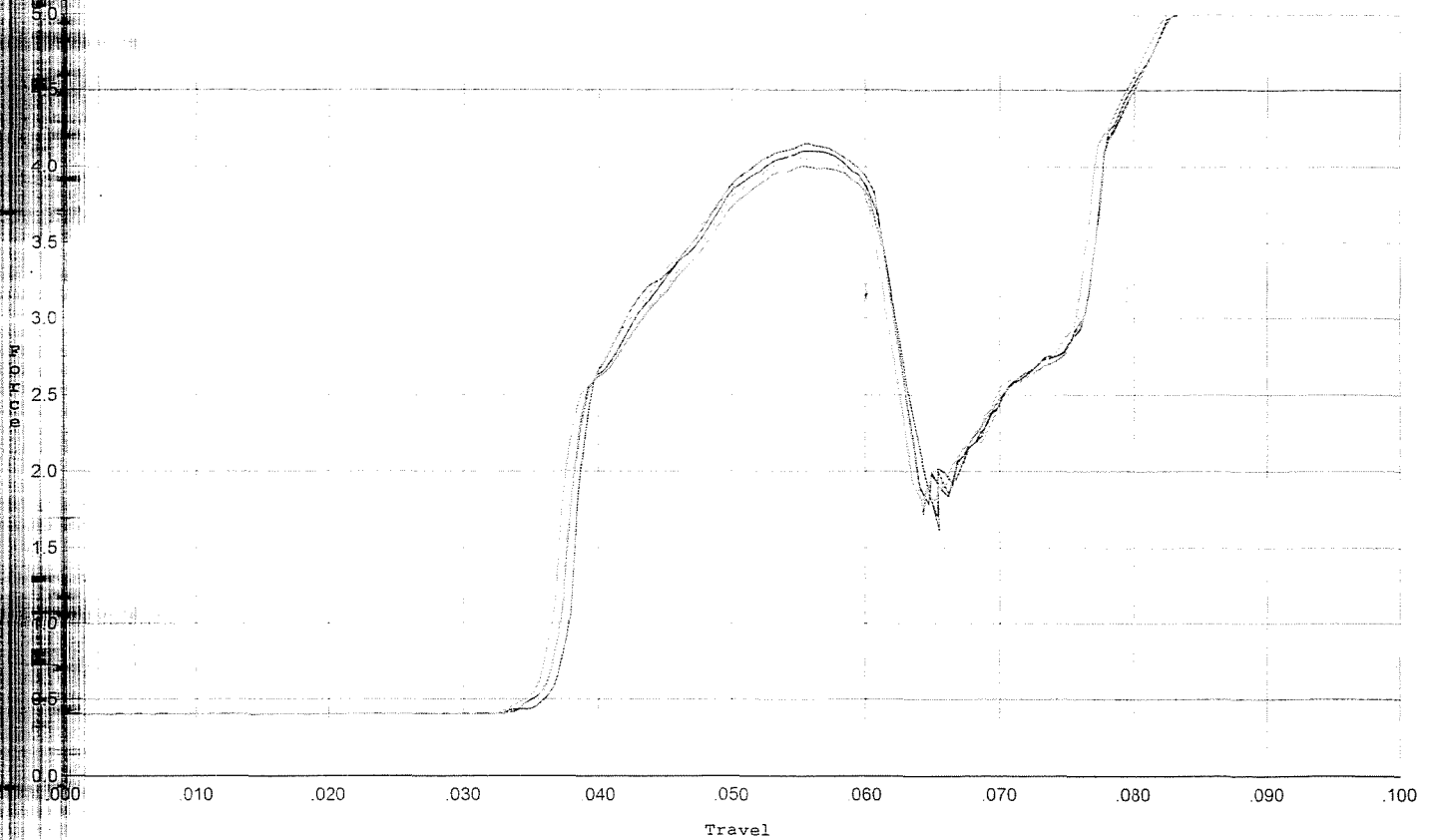
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.434      | 0.061             | 0.039           | 0.036      | 0.063             |           | Set Trigger |
| 2 | 2.541      | 0.061             | 0.038           | 0.036      | 0.066             |           | Set Trigger |
| 3 | 2.531      | 0.061             | 0.038           | 0.036      | 0.064             |           | Set Trigger |
| 4 | 2.441      | 0.061             | 0.038           | 0.036      | 0.064             |           | Set Trigger |
| 5 | 2.528      | 0.061             | 0.038           | 0.036      | 0.065             |           | Set Trigger |

A-2.49

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/21/2009

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 | 4.154      | 0.061             | 0.037           | 0.033      | 0.099             |           | Set Trigger |
| 2 | 4.104      | 0.061             | 0.036           | 0.033      | 0.100             |           | Set Trigger |
| 3 | 4.007      | 0.061             | 0.036           | 0.033      | 0.098             |           | Set Trigger |
| 4 | 4.060      | 0.061             | 0.036           | 0.033      | 0.099             |           | Set Trigger |
| 5 | 4.088      | 0.060             | 0.036           | 0.033      | 0.099             |           | Set Trigger |

A - 4.08