

66807763

**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



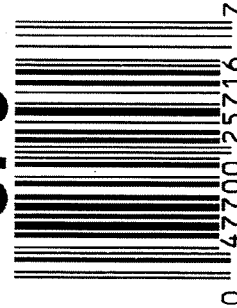
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

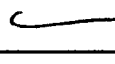
**G6807763**

**UPC**



24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807763

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                               |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|---------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 2-27-09 | SP                                                                                    |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 2-27-09 | RP                                                                                    |
| 440  | PROOF                                                                                                                                  |                                                                                             | 2-27-09 | SP                                                                                    |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA FLUX                                                                                  | 2-27-09 | RP                                                                                    |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 2-27-09 | RP                                                                                    |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 3-2-09  | RTZ                                                                                   |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/5/09  | (J)                                                                                   |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 3/5/09  | mk                                                                                    |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 3/5/09  | RT                                                                                    |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 3-2-09  | SP                                                                                    |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 3/6     | mon                                                                                   |
| 540  | APPLY COATINGS                                                                                                                         |                                                                                             | 3/16    |  |
|      | (BARREL ACTION)                                                                                                                        |                                                                                             |         |                                                                                       |
|      | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                       |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |                                                                                       |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 3-12-09 | SP                                                                                    |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-12-09 | SP                                                                                    |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-12-09 | SP                                                                                    |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-16-09 | SP                                                                                    |
|      | 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> |                                                                                             |         |                                                                                       |

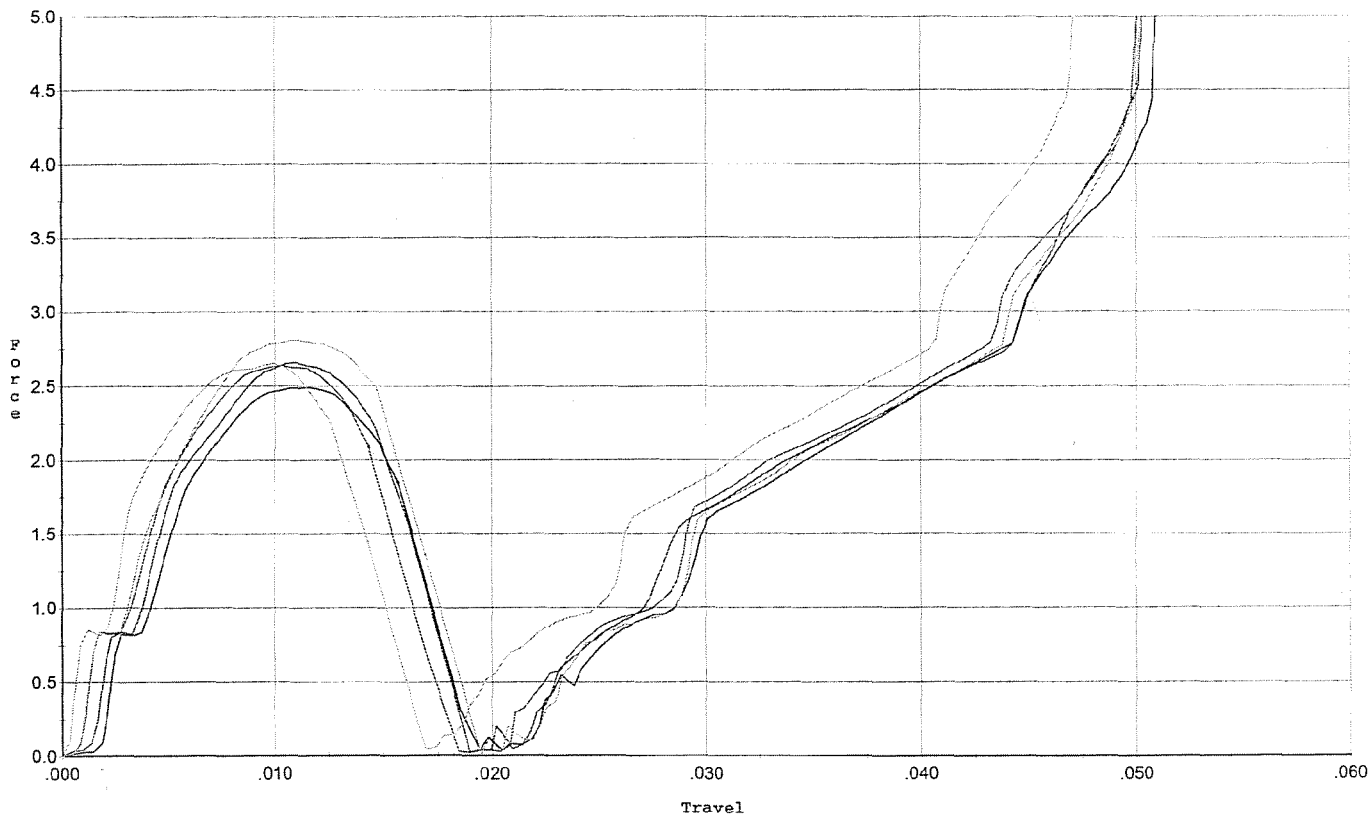
|              |                                                                       |                                           |                                                             |         |       |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|-------|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>5.5</u> <u>5.5</u> <u>5.5</u>                            | 3-20-09 | WV    |
| CONT.        | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>3.5</u> <u>3</u> <u>3.5</u>                              | 3-20-09 | WV    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |       |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.022</u> <u>.023</u> <u>.022</u>                         | 3-20-09 | WV    |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 3-16-09 | X.91. |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 3-20-09 | WV    |
|              | 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                        | 3-18-09 | RP    |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |       |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |       |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |       |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |       |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 3-18-09 | RP    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 3-20-09 | WV    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.65</u> <u>2.64</u> <u>2.64</u> <u>2.63</u> <u>2.63</u> | 3-19-09 | TC    |
|              | C) FUNCTION                                                           |                                           |                                                             | 3-20-09 | WV    |
| 690          | PACK                                                                  |                                           |                                                             | 3-20-09 | TC    |

F004 REV 5/2006

# 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



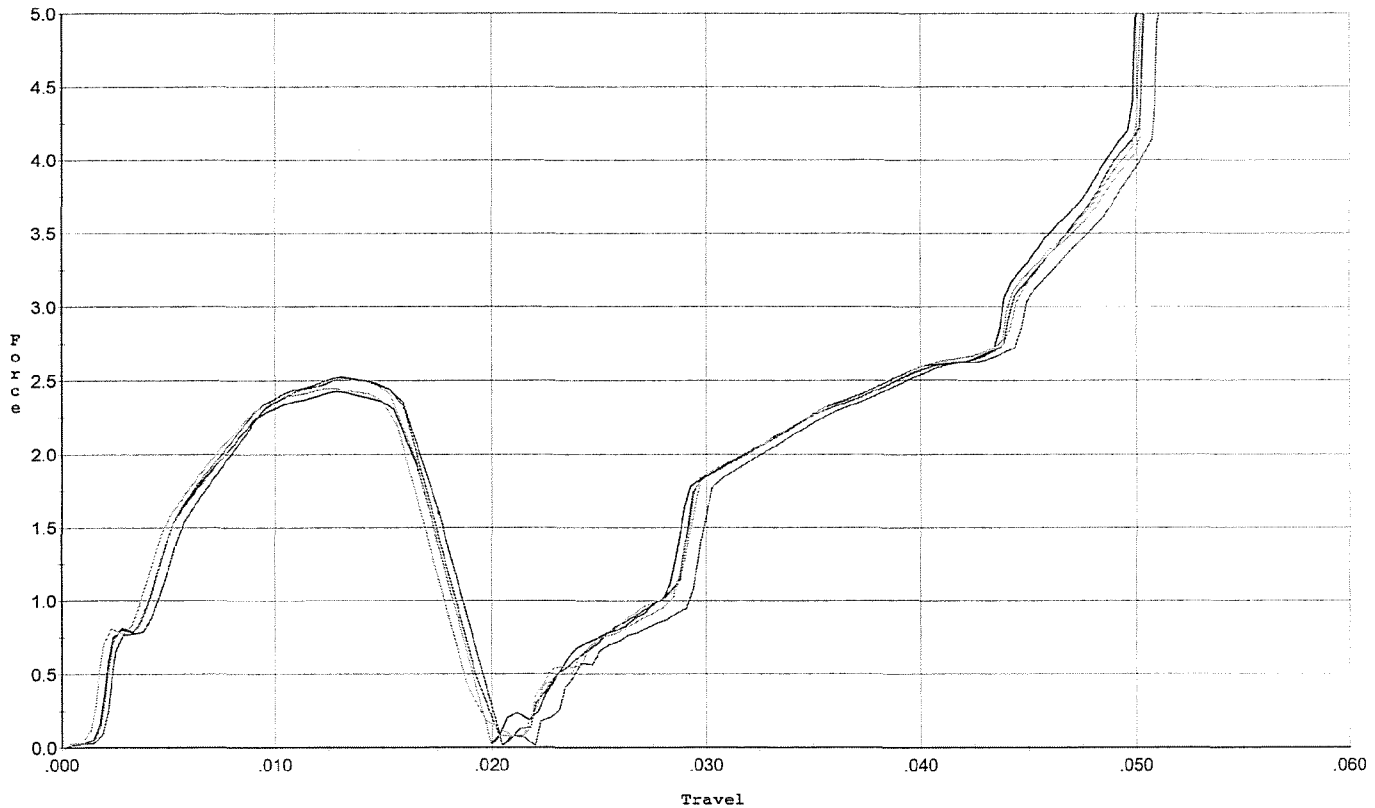
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.657      | 0.016             | 0.00            | 0.038      | 0.027             |           | Set Trigger |
| 2 | 2.488      | 0.016             | 0.00            | 0.038      | 0.025             |           | Set Trigger |
| 3 | 2.632      | 0.014             | 0.003           | 0.038      | 0.025             |           | Set Trigger |
| 4 | 2.652      | 0.014             | 0.00            | 0.037      | 0.026             |           | Set Trigger |
| 5 | 2.806      | 0.017             | 0.003           | 0.038      | 0.032             |           | Set Trigger |

A-2.64

## 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



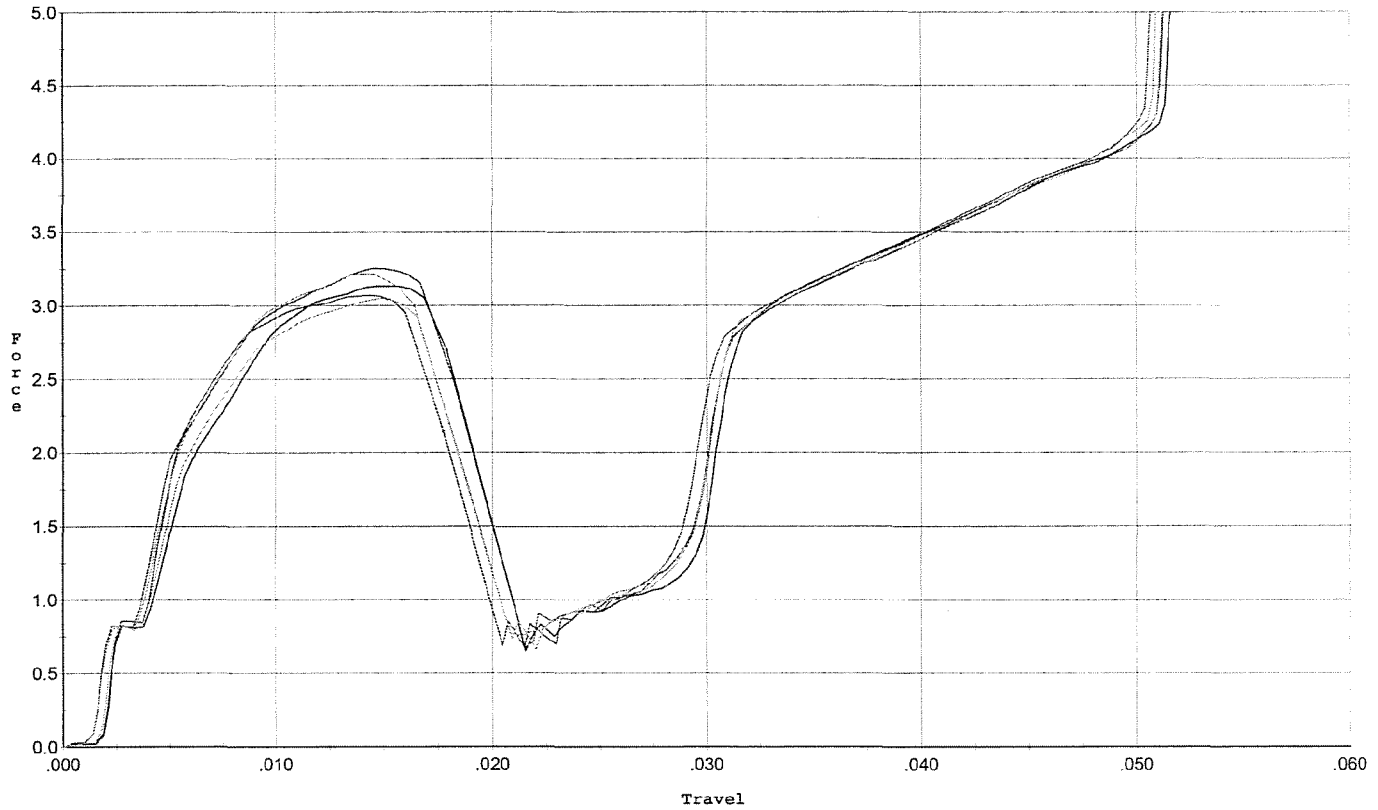
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.518      | 0.018             | 0.00            | 0.036      | 0.028             |           | Set Trigger |
| 2 | 2.427      | 0.017             | 0.00            | 0.036      | 0.027             |           | Set Trigger |
| 3 | 2.524      | 0.016             | 0.00            | 0.038      | 0.026             |           | Set Trigger |
| 4 | 2.512      | 0.016             | 0.00            | 0.037      | 0.027             |           | Set Trigger |
| 5 | 2.448      | 0.016             | 0.00            | 0.037      | 0.026             |           | Set Trigger |

H-2-48

# 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



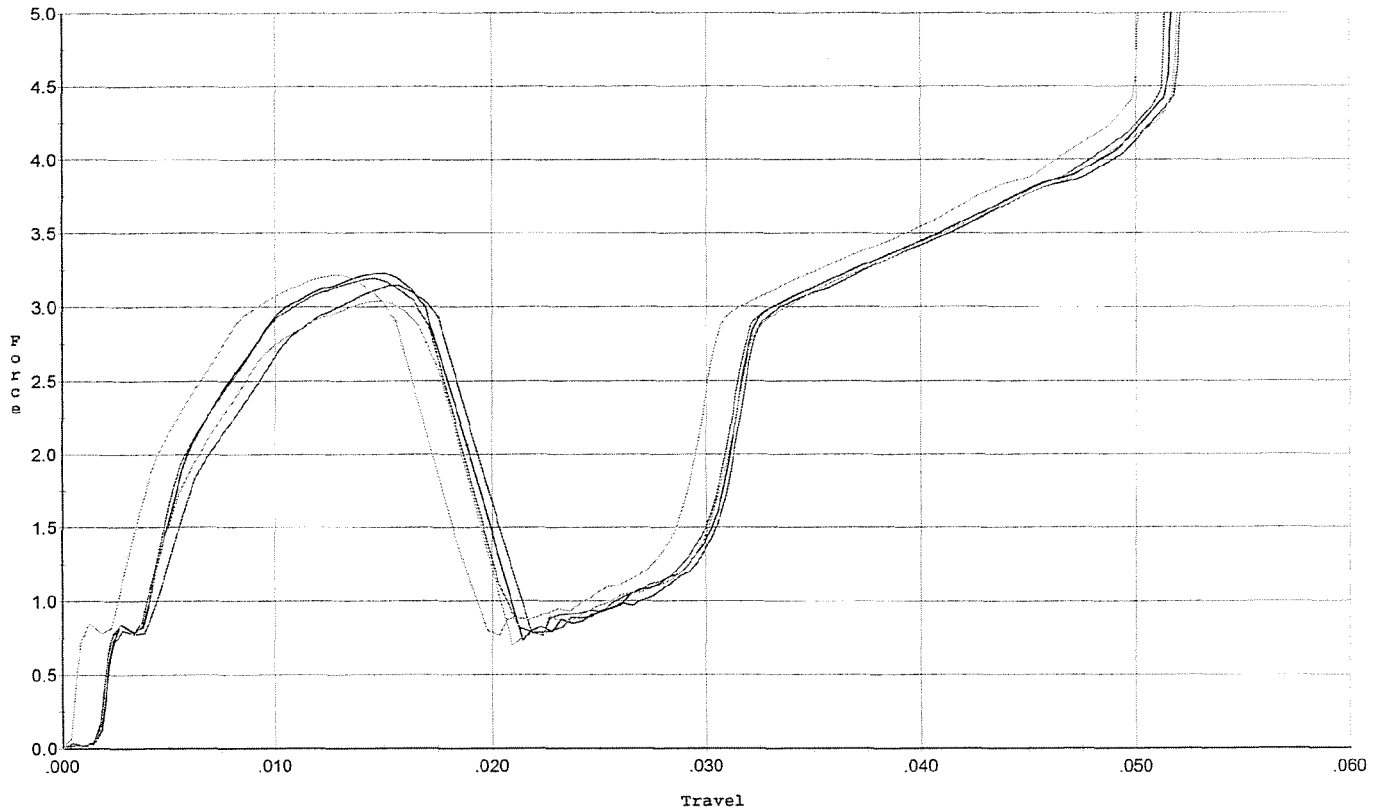
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.253      | 0.018             | 0.004           | 0.034      | 0.038             |           | Set Trigger |
| 2 | 3.131      | 0.018             | 0.004           | 0.035      | 0.036             |           | Set Trigger |
| 3 | 3.069      | 0.018             | 0.004           | 0.035      | 0.036             |           | Set Trigger |
| 4 | 3.047      | 0.018             | 0.00            | 0.035      | 0.036             |           | Set Trigger |
| 5 | 3.215      | 0.016             | 0.00            | 0.035      | 0.034             |           | Set Trigger |

A-3.14

# Trigger Profile [ lbs,inch ]

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

**Model:** M/24  
**Serial No:** Form #F005  
**Trigger:** 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 | 3.146      | 0.018             | 0.00            | 0.035      | 0.034             |           | Set Trigger |
| 2 | 3.229      | 0.019             | 0.00            | 0.035      | 0.039             |           | Set Trigger |
| 3 | 3.193      | 0.017             | 0.00            | 0.035      | 0.035             |           | Set Trigger |
| 4 | 3.215      | 0.016             | 0.00            | 0.035      | 0.034             |           | Set Trigger |
| 5 | 3.040      | 0.018             | 0.002           | 0.035      | 0.034             |           | Set Trigger |

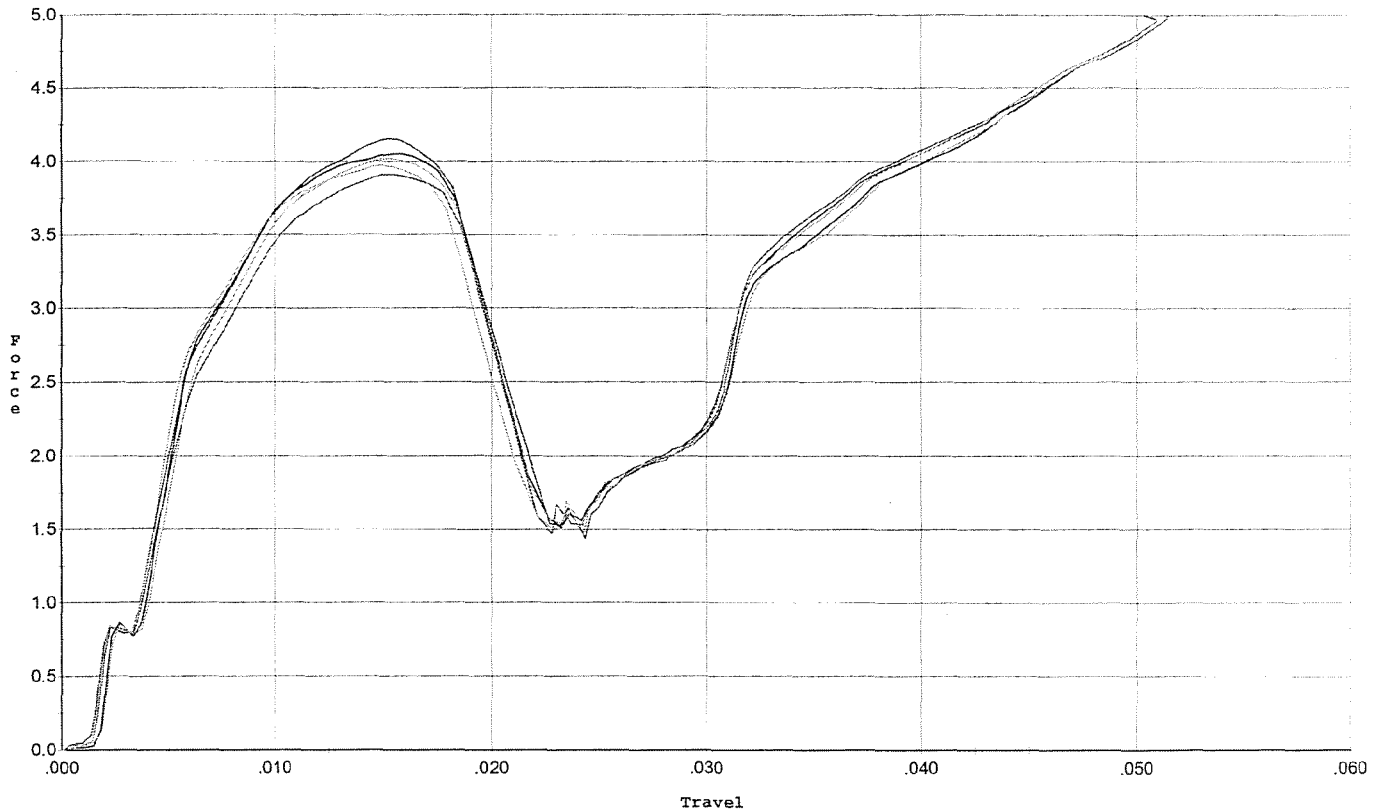
A-3-16



# 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



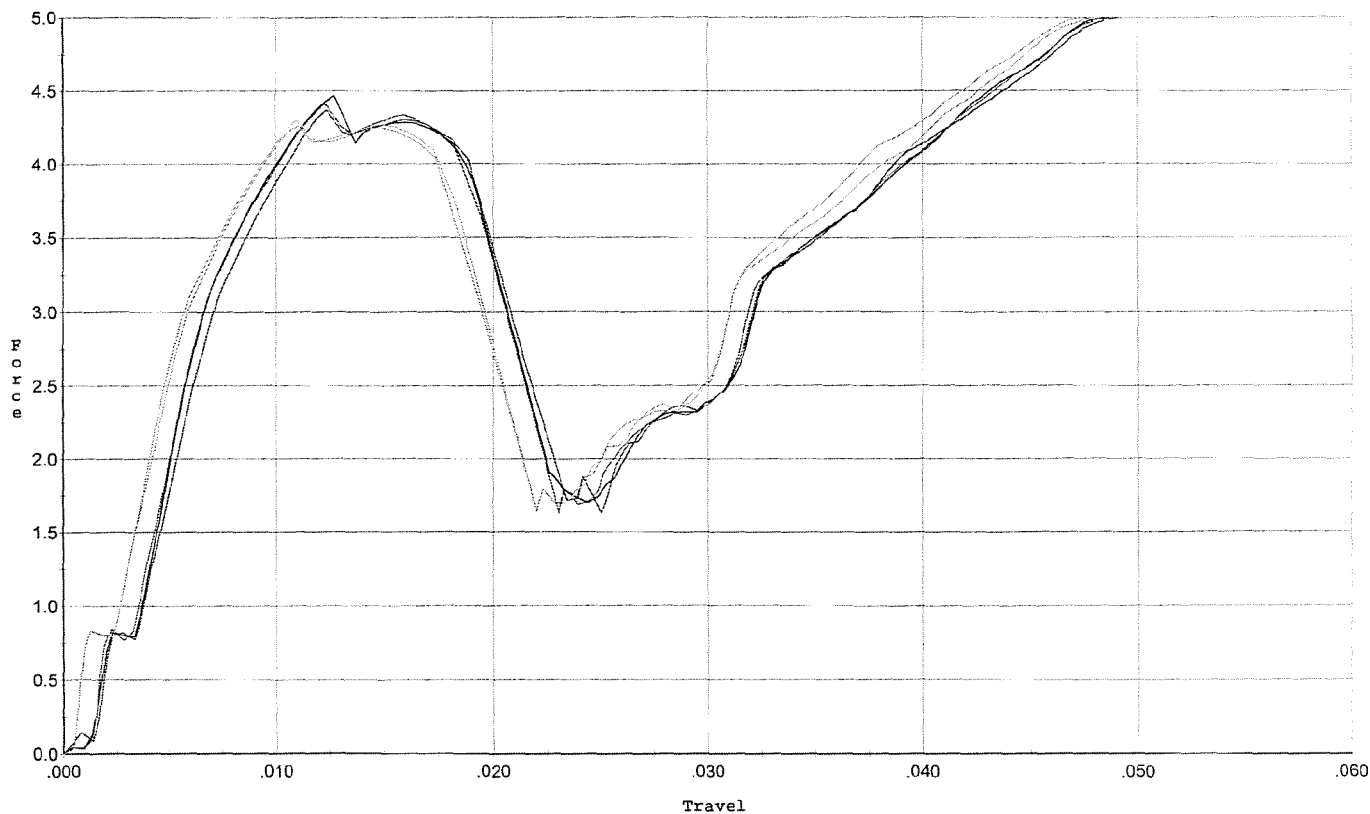
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.155      | 0.018             | 0.004           | 0.033      | 0.048             |           | Set Trigger |
| 2 | 4.051      | 0.018             | 0.00            | 0.033      | 0.048             |           | Set Trigger |
| 3 | 3.909      | 0.019             | 0.004           | 0.032      | 0.047             |           | Set Trigger |
| 4 | 3.972      | 0.018             | 0.004           | 0.033      | 0.046             |           | Set Trigger |
| 5 | 4.018      | 0.018             | 0.00            | 0.033      | 0.047             |           | Set Trigger |

A-4.02

# 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



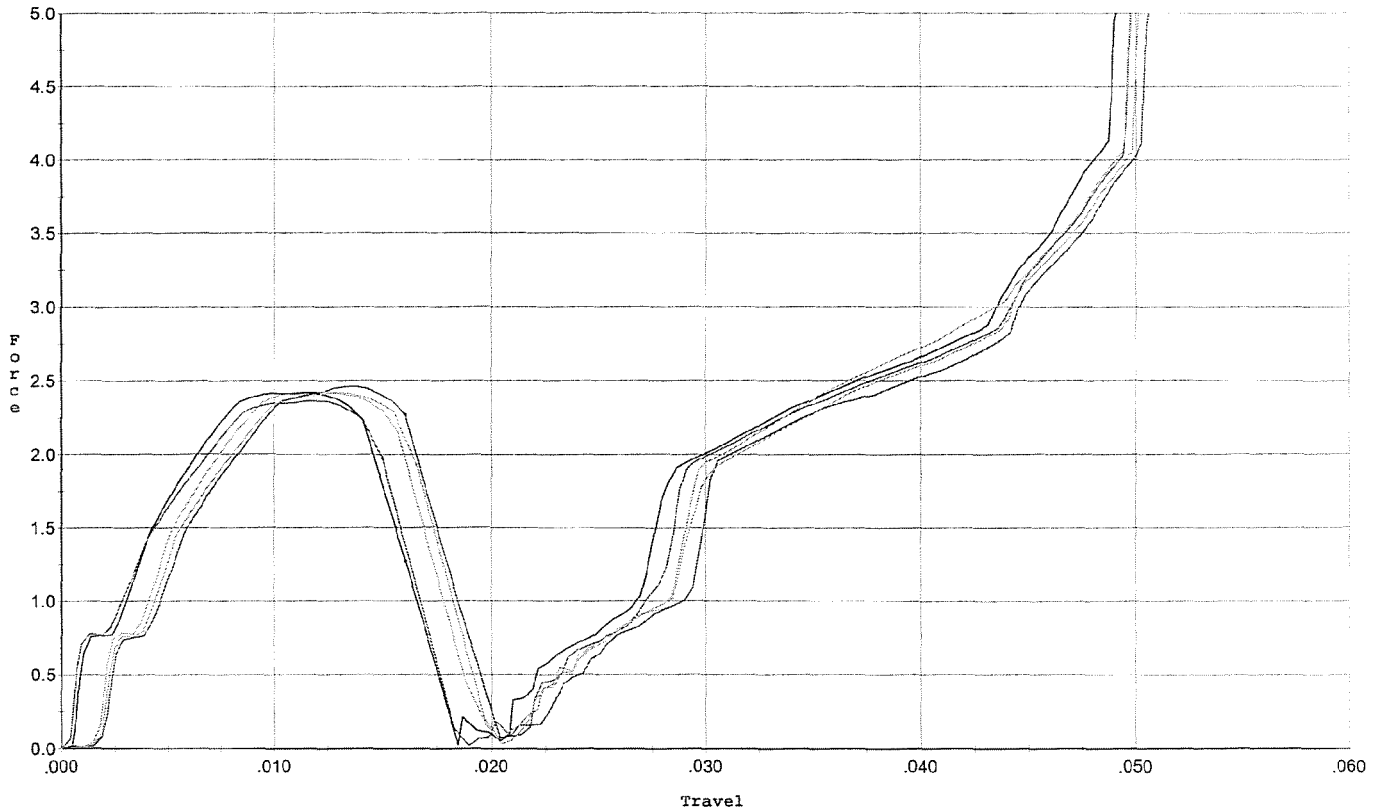
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.370      | 0.019             | 0.00            | 0.033      | 0.052             |           | Set Trigger |
| 2 | 4.464      | 0.019             | 0.004           | 0.032      | 0.054             |           | Set Trigger |
| 3 | 4.417      | 0.019             | 0.00            | 0.032      | 0.055             |           | Set Trigger |
| 4 | 4.301      | 0.018             | 0.003           | 0.032      | 0.053             |           | Set Trigger |
| 5 | 4.259      | 0.019             | 0.003           | 0.032      | 0.055             |           | Set Trigger |

A-4.36

# 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 test



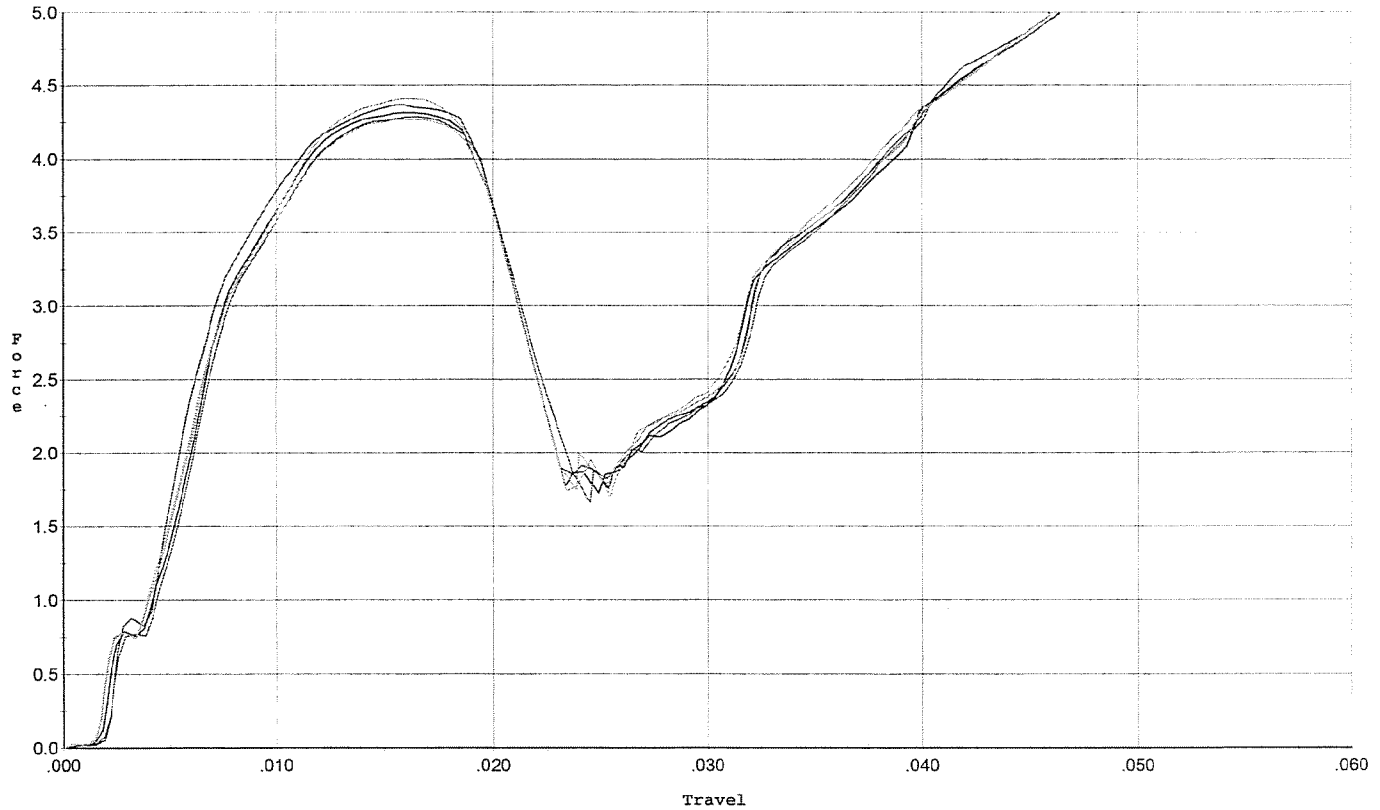
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.461      | 0.016             | 0.002           | 0.037      | 0.025             |           | Set Trigger |
| 2 | 2.417      | 0.016             | 0.00            | 0.037      | 0.027             |           | Set Trigger |
| 3 | 2.363      | 0.015             | 0.00            | 0.038      | 0.025             |           | Set Trigger |
| 4 | 2.426      | 0.016             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 5 | 2.418      | 0.017             | 0.00            | 0.036      | 0.026             |           | Set Trigger |

A-2-41

# 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 | 4.369      | 0.019             | 0.002           | 0.032      | 0.054             |           | Set Trigger |
| 2 | 4.315      | 0.020             | 0.00            | 0.032      | 0.053             |           | Set Trigger |
| 3 | 4.285      | 0.019             | 0.00            | 0.032      | 0.052             |           | Set Trigger |
| 4 | 4.267      | 0.020             | 0.00            | 0.032      | 0.053             |           | Set Trigger |
| 5 | 4.410      | 0.020             | 0.00            | 0.032      | 0.054             |           | Set Trigger |

A - 4.32