

66784986

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



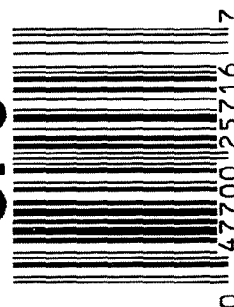
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784986

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

66784986

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                                                                                                                                     | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                                                                                                                                              | 9-18-08  | SP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                                                                                                                                              | 9-18-08  | SP      |
| 440  | PROOF                                                                                                                                  |                                                                                                                                                                                                              | 9-18-08  | SP      |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                                                                                                                                              | 9-18-08  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                                                                                                                                              | 9-18-08  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                                                                                                                                              | 10-7-08  | RT      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | <div style="border: 1px solid black; padding: 5px; width: fit-content;"> MAGNA-FLUX<br/> UCI 08 2008<br/> OPERATOR <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KA</span> </div> | 10-7-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   |                                                                                                                                                                                                              | 10/8/08  | RT      |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                                                                                                                                              | 10/8/08  | RT      |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                                                                                                                                              | 10/8/08  | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                                                                                                                                              | 10/9/08  | DS      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                                                                                                                                              | 10/13    | ✓       |
| 545  | (BOLT)                                                                                                                                 |                                                                                                                                                                                                              |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                                                                                                                                              |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                                                                                                                                              | 10/13/08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                                                                                                                                              | 10/13/08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                                                                                                                                              | 10/13/08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                                                                                                                                              | 11-12-08 | 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

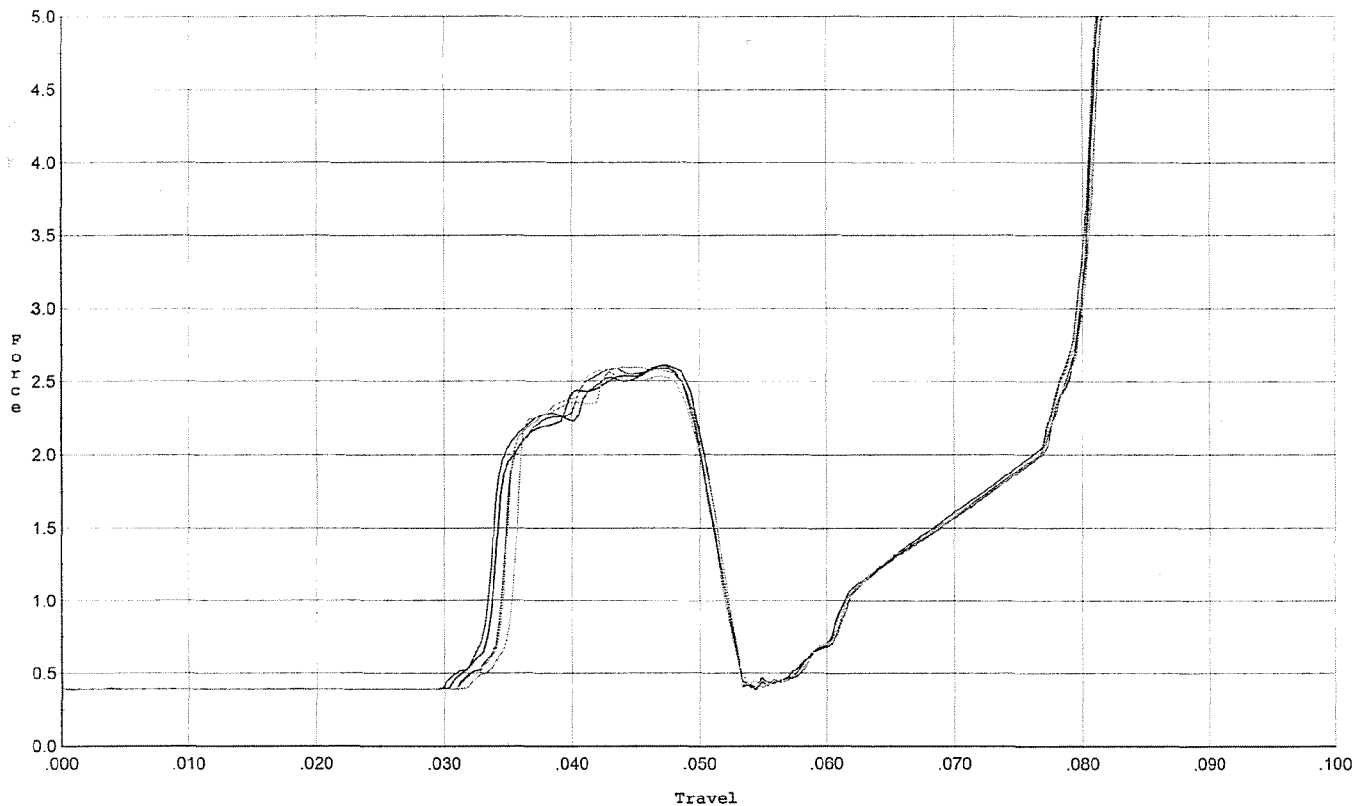
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>30</u> <u>3.5</u> <u>35</u>                              | 11-18-08 | LN      |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>40</u> <u>40</u> <u>40</u>                               | 11-18-08 | LN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 11-18-08 | LN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 11-22-08 | TC      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 11-18-08 | LN      |
|              | 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                        | 11-13-08 | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 11-13-08 | LN      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 11-15-08 | LN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.59</u> <u>2.54</u> <u>2.60</u> <u>2.60</u> <u>2.56</u> | 11-14-08 | TC      |
|              | C) FUNCTION                                                              |                                                             | 11-18-08 | LN      |
| 690          | PACK                                                                     |                                                             | 12-2-08  | TC      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 11/07/2008

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



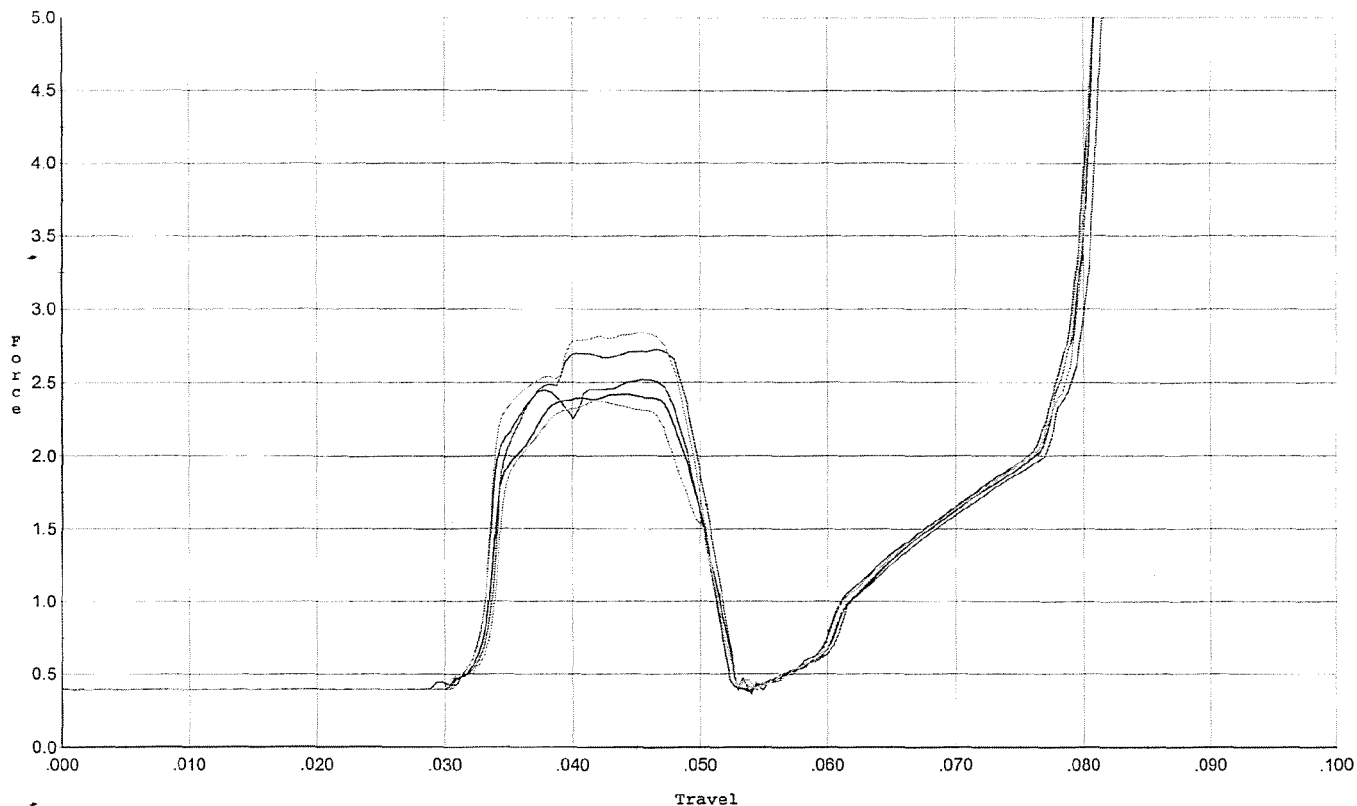
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.590      | 0.050             | 0.030           | 0.035      | 0.052             |           | Set Trigger |
| 2 | 2.607      | 0.051             | 0.031           | 0.035      | 0.053             |           | Set Trigger |
| 3 | 2.603      | 0.050             | 0.034           | 0.035      | 0.051             |           | Set Trigger |
| 4 | 2.576      | 0.050             | 0.034           | 0.035      | 0.051             |           | Set Trigger |
| 5 | 2.600      | 0.051             | 0.034           | 0.036      | 0.051             |           | Set Trigger |

A2-59

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 11/07/2008

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



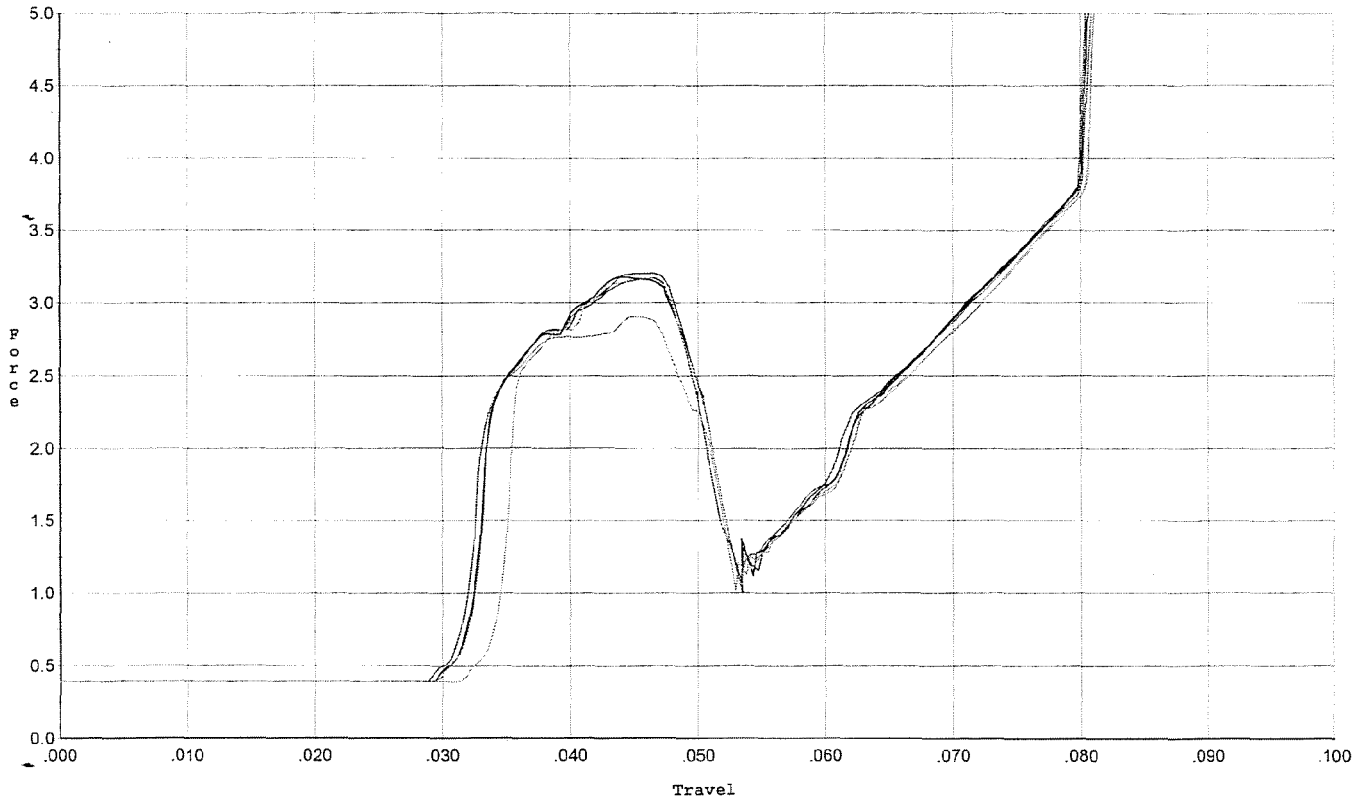
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.519      | 0.050             | 0.032           | 0.035      | 0.052             |           | Set Trigger |
| 2 | 2.420      | 0.051             | 0.033           | 0.035      | 0.052             |           | Set Trigger |
| 3 | 2.723      | 0.050             | 0.033           | 0.035      | 0.055             |           | Set Trigger |
| 4 | 2.838      | 0.049             | 0.032           | 0.035      | 0.056             |           | Set Trigger |
| 5 | 2.374      | 0.050             | 0.031           | 0.036      | 0.048             |           | Set Trigger |

A-257

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 11/07/2008

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



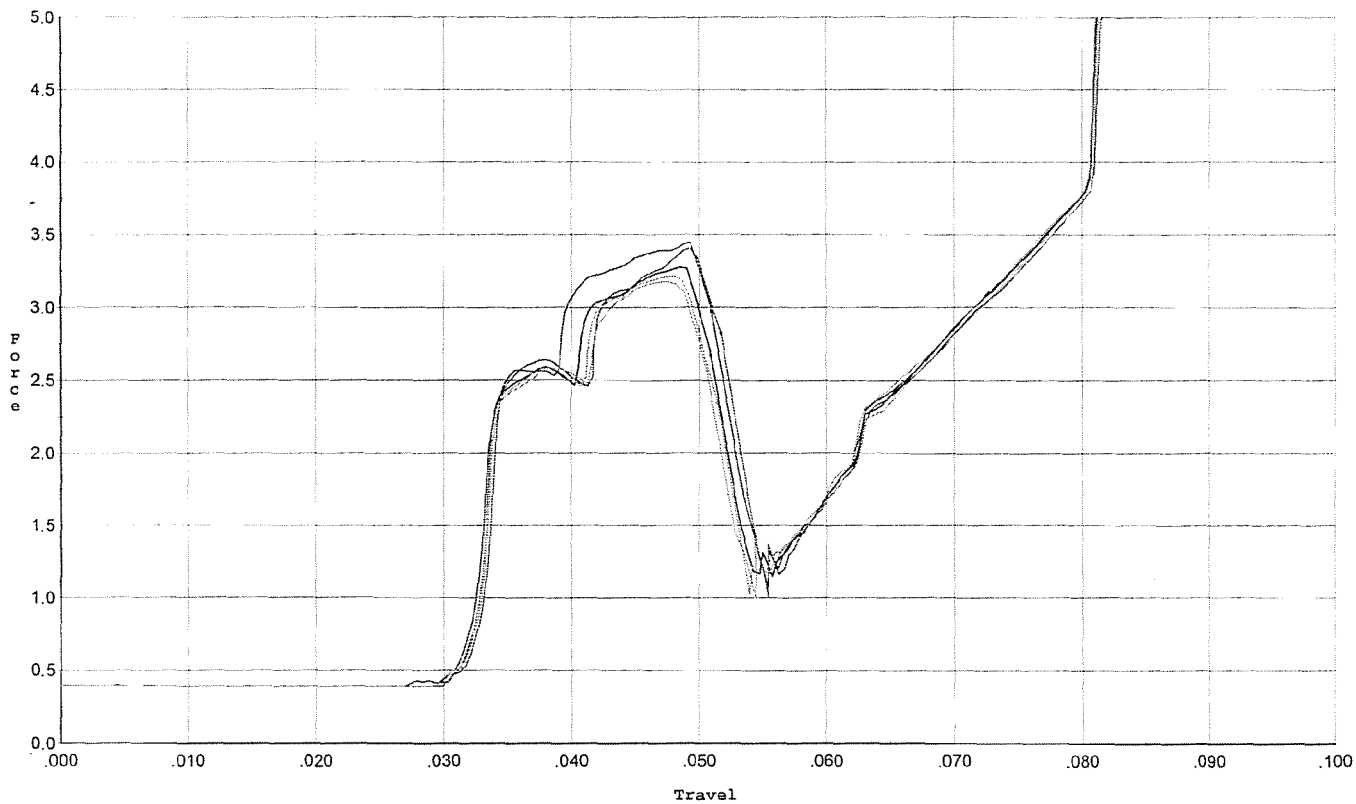
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.203      | 0.050             | 0.030           | 0.033      | 0.064             |           | Set Trigger |
| 2 | 3.179      | 0.050             | 0.032           | 0.033      | 0.064             |           | Set Trigger |
| 3 | 3.173      | 0.050             | 0.031           | 0.034      | 0.063             |           | Set Trigger |
| 4 | 3.169      | 0.050             | 0.032           | 0.035      | 0.059             |           | Set Trigger |
| 5 | 2.908      | 0.051             | 0.030           | 0.034      | 0.061             |           | Set Trigger |

A-3-12

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 11/07/2008

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



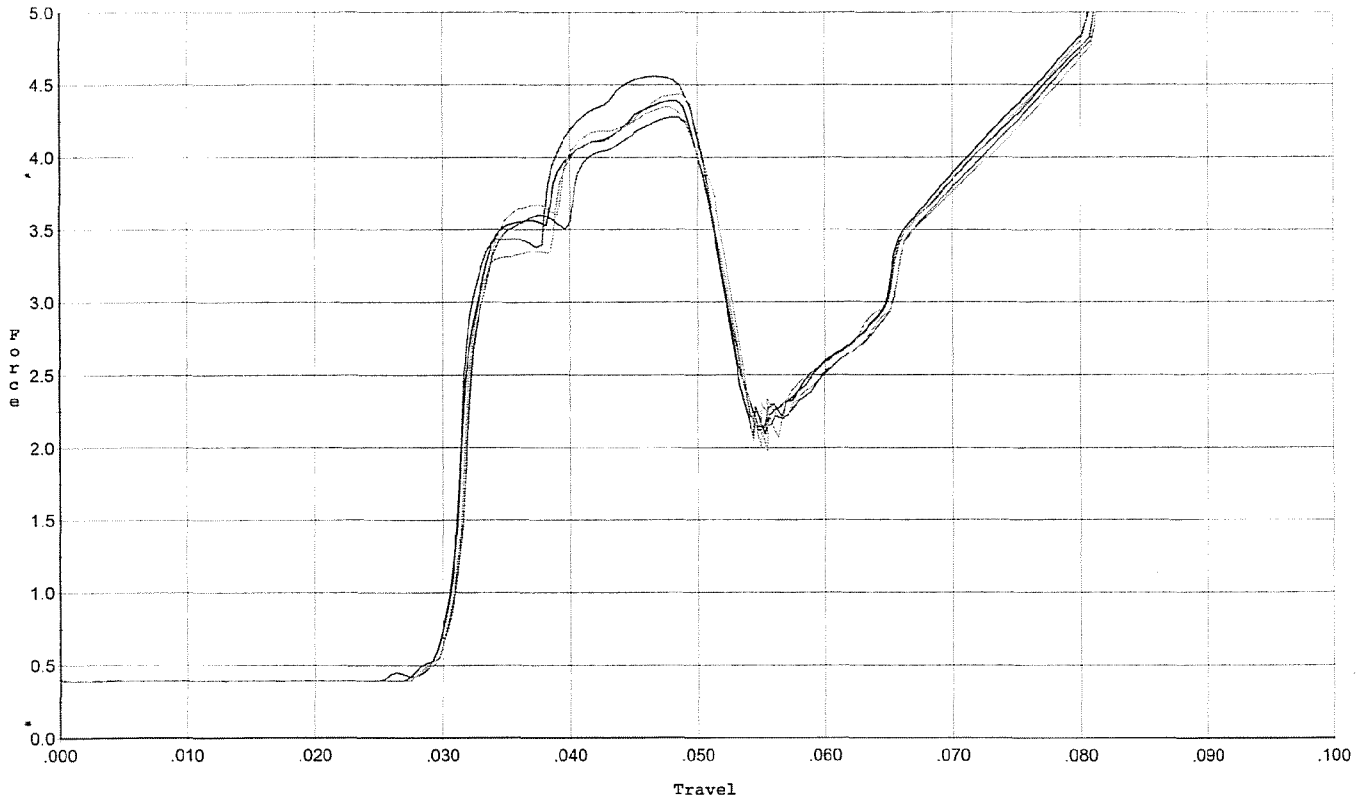
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.447      | 0.051             | 0.031           | 0.033      | 0.069             |           | Set Trigger |
| 2 | 3.276      | 0.051             | 0.032           | 0.033      | 0.065             |           | Set Trigger |
| 3 | 3.407      | 0.052             | 0.032           | 0.034      | 0.067             |           | Set Trigger |
| 4 | 3.176      | 0.051             | 0.032           | 0.034      | 0.062             |           | Set Trigger |
| 5 | 3.217      | 0.051             | 0.032           | 0.033      | 0.065             |           | Set Trigger |

A-3-30

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 11/07/2008

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



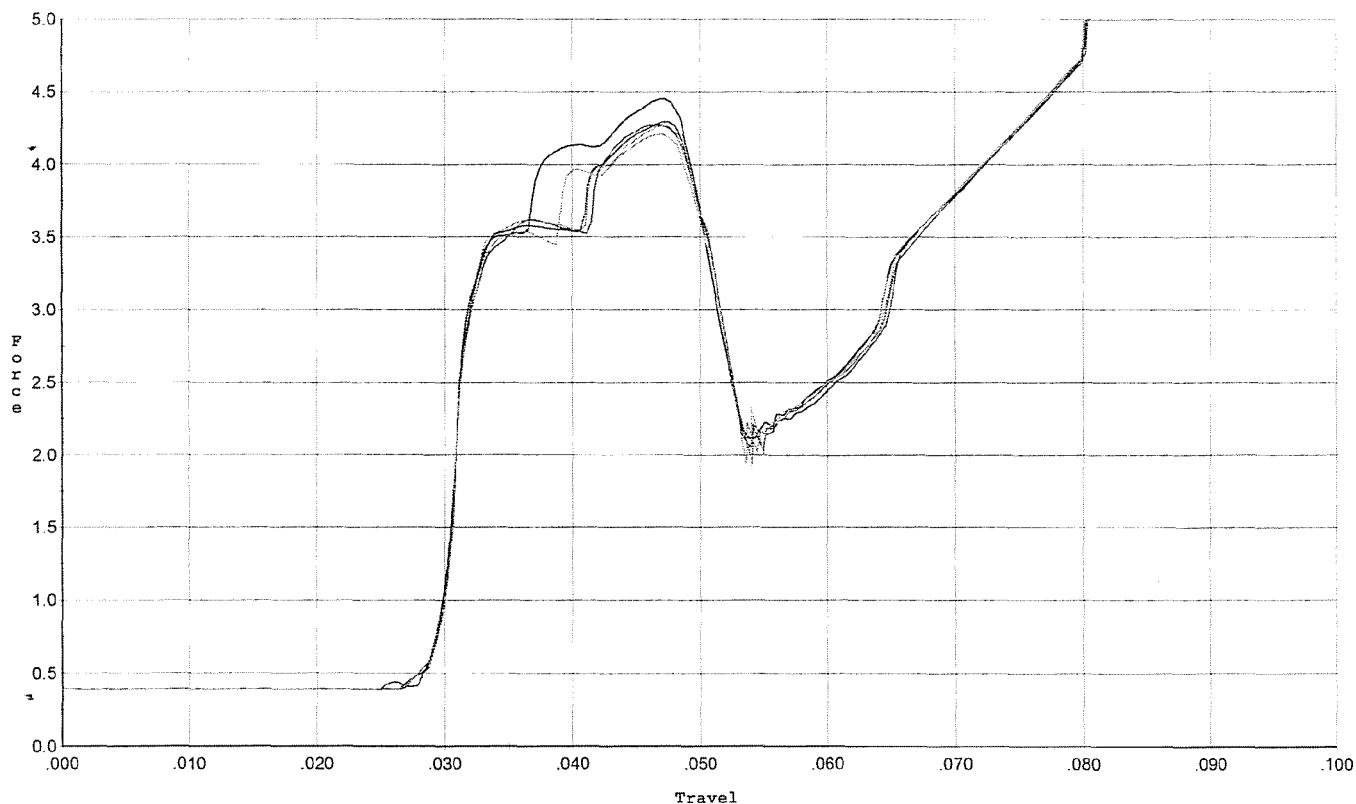
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.560      | 0.051             | 0.029           | 0.031      | 0.092             |           | Set Trigger |
| 2 | 4.393      | 0.051             | 0.030           | 0.031      | 0.090             |           | Set Trigger |
| 3 | 4.277      | 0.051             | 0.030           | 0.032      | 0.088             |           | Set Trigger |
| 4 | 4.436      | 0.051             | 0.030           | 0.032      | 0.091             |           | Set Trigger |
| 5 | 4.351      | 0.052             | 0.030           | 0.031      | 0.091             |           | Set Trigger |

A-4.40

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/07/2008

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



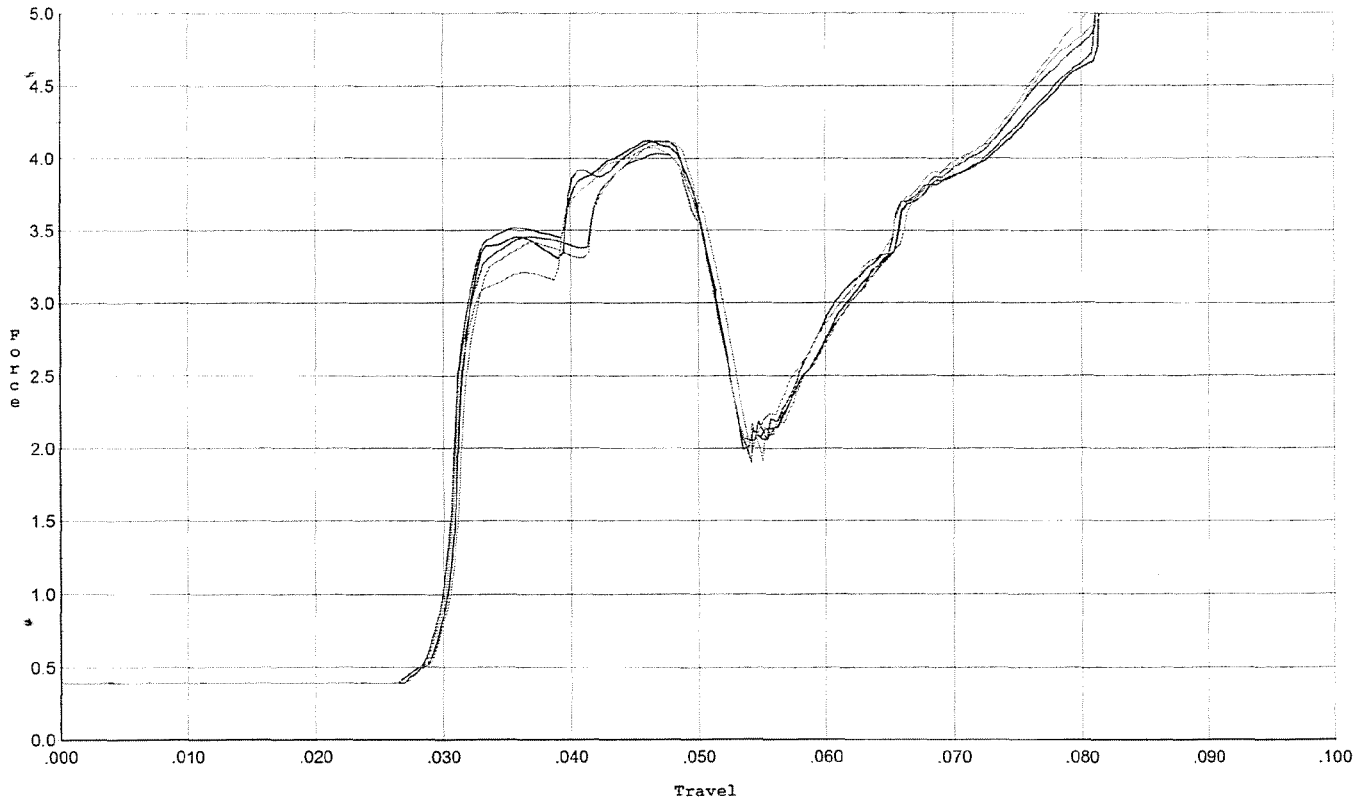
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.294      | 0.051             | 0.028           | 0.031      | 0.088             |           | Set Trigger |
| 2 | 4.455      | 0.050             | 0.029           | 0.031      | 0.089             |           | Set Trigger |
| 3 | 4.274      | 0.051             | 0.029           | 0.031      | 0.089             |           | Set Trigger |
| 4 | 4.210      | 0.051             | 0.029           | 0.031      | 0.089             |           | Set Trigger |
| 5 | 4.269      | 0.051             | 0.029           | 0.031      | 0.088             |           | Set Trigger |

A-430

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/07/2008

Model: M/24  
Serial No: Form #F005  
Trigger: set to 4.0 lbs +/- 1.0 lbs for target & accuracy



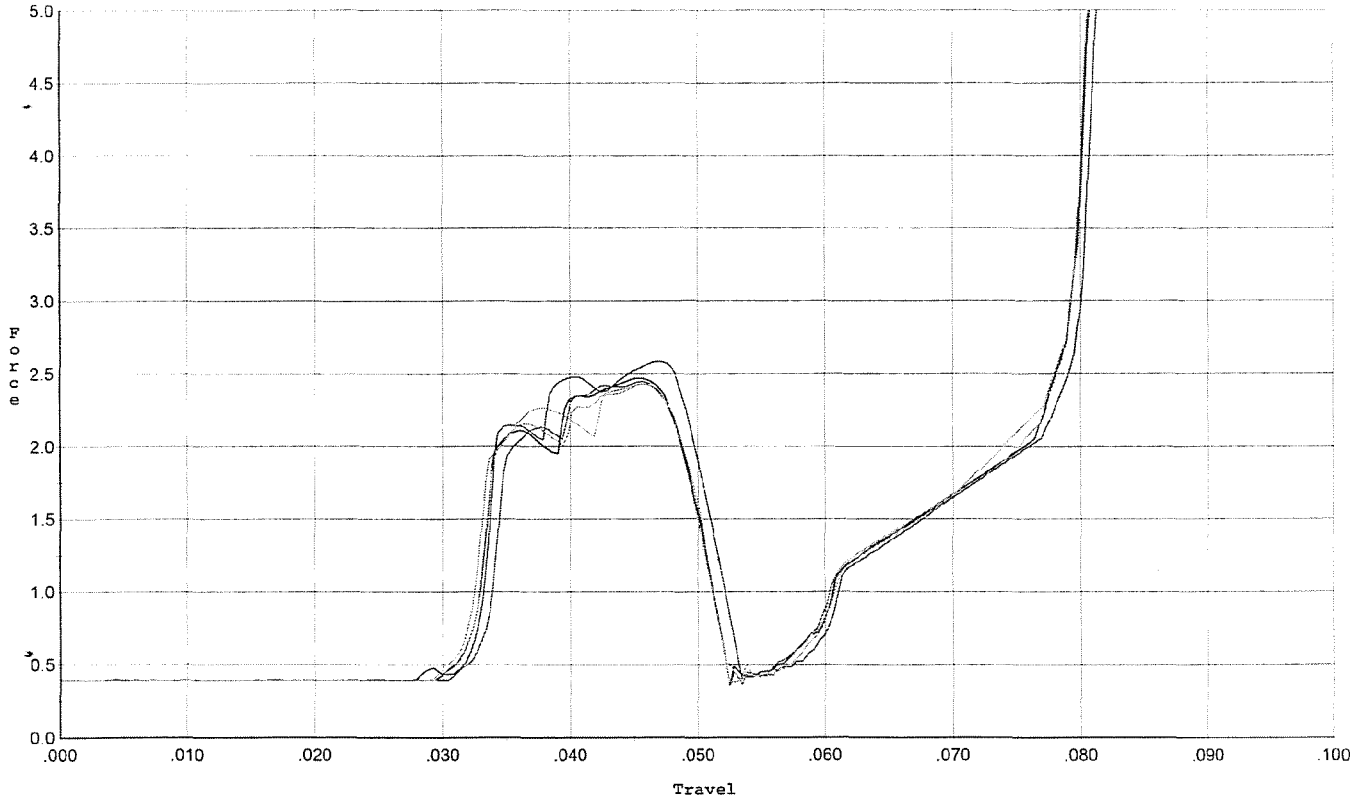
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.119      | 0.051             | 0.029           | 0.031      | 0.089             |           | Set Trigger |
| 2 | 4.123      | 0.051             | 0.029           | 0.031      | 0.087             |           | Set Trigger |
| 3 | 4.031      | 0.052             | 0.029           | 0.031      | 0.087             |           | Set Trigger |
| 4 | 4.076      | 0.050             | 0.029           | 0.032      | 0.083             |           | Set Trigger |
| 5 | 4.110      | 0.052             | 0.030           | 0.032      | 0.087             |           | Set Trigger |

A. 4.09

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/07/2008

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 | 2.586      | 0.052             | 0.032           | 0.034      | 0.055             |           | Set Trigger |
| 2 | 2.468      | 0.050             | 0.032           | 0.035      | 0.051             |           | Set Trigger |
| 3 | 2.446      | 0.050             | 0.033           | 0.035      | 0.049             |           | Set Trigger |
| 4 | 2.432      | 0.050             | 0.032           | 0.035      | 0.051             |           | Set Trigger |
| 5 | 2.429      | 0.051             | 0.032           | 0.035      | 0.051             |           | Set Trigger |

A-2.46