

G6785009

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



BM FORM

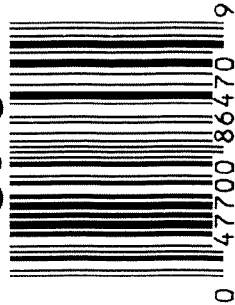
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6785009**

**UPC**



M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6785009

| OP # | OPERATION NAME                                                                                                                         | READINGS    | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|-------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |             | 9-18-08  | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |             | 9-18-08  | SP      |
| 440  | PROOF                                                                                                                                  |             | 9-18-08  | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        |             | 9-18-08  | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |             | 9-18-08  | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA-FLUX  | 9-19-08  | BSN     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | SEP 22 2008 | 9-19-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR BM | 9-22-08  | BM      |
| 490  | MAGNAFLUX BOLT                                                                                                                         |             | 9/18/08  | MR      |
| 500  | ROLLMARK CALIBER                                                                                                                       |             | 9/23/08  | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |             | 9/23/08  | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |             | 9-23     |         |
| 545  | (BOLT)                                                                                                                                 |             |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |             |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |             | 9-24-08  | JP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |             | 9-24-08  | JP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |             | 9-24-08  | JP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |             | 11-14-08 | BSN     |
|      | 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

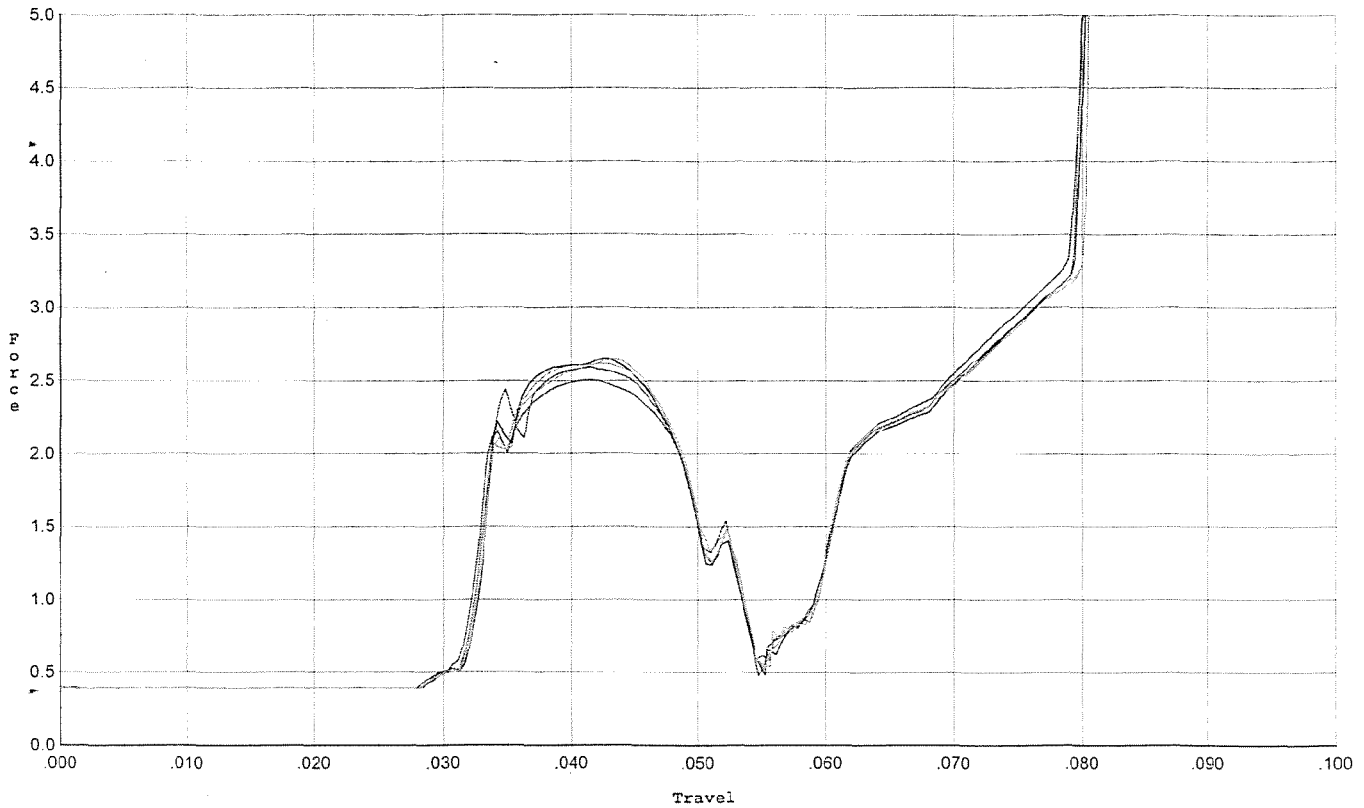
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>40</u> <u>40</u> <u>40</u>                               | 12-18-08 | L.N.    |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>50</u> <u>50</u> <u>50</u>                               | 12-18-08 | R.N.    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 12-18-08 | L.N.    |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 11-14-08 | R.N.    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 12-18-08 | L.N.    |
|              | 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                        | 12-16-08 | L.P.D.  |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 12-16-08 | R.P.    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 12-18-08 | L.N.    |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.21</u> <u>2.25</u> <u>2.33</u> <u>2.27</u> <u>2.26</u> | 12-17-08 | TL      |
|              | C) FUNCTION                                                              |                                                             | 12-18-08 | L.N.    |
| 690          | PACK                                                                     |                                                             | 1-7-09   | TL      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/062008

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



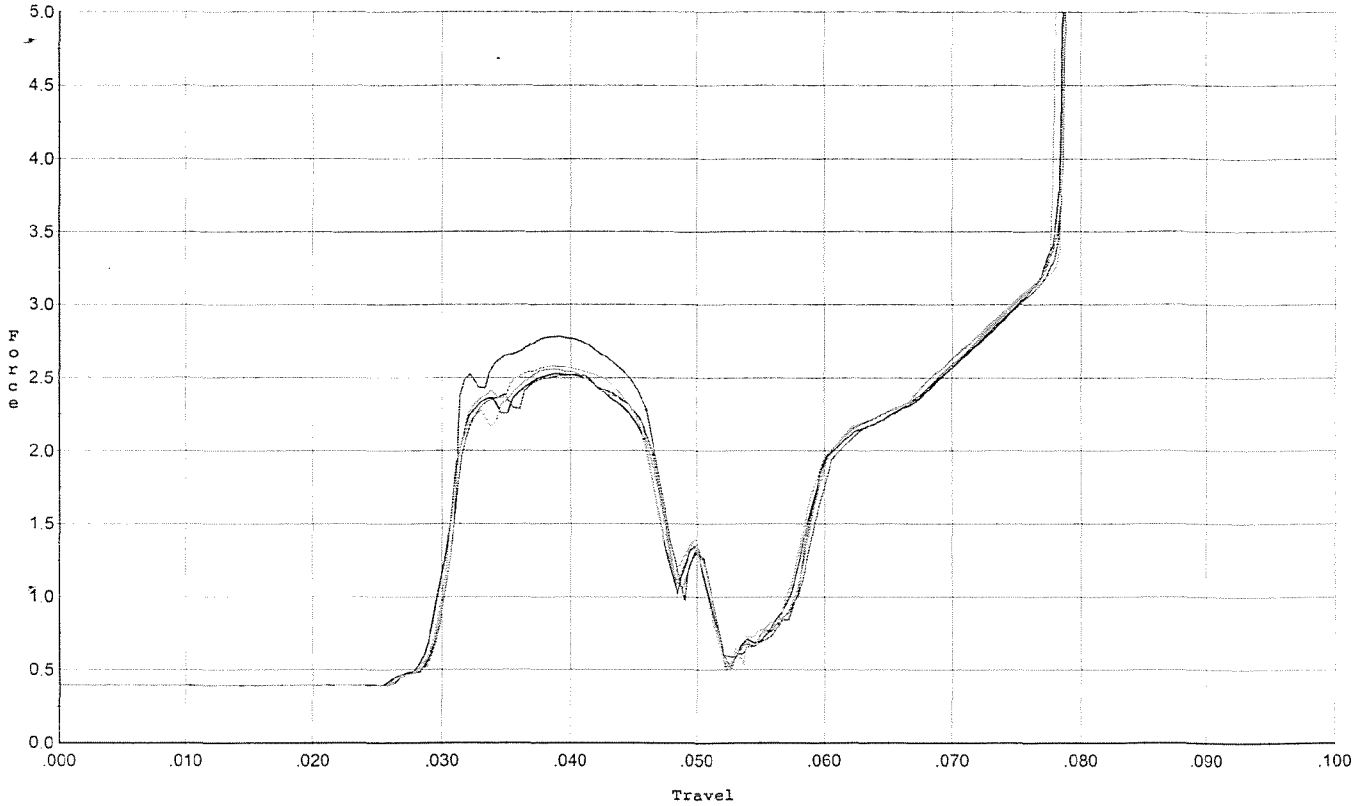
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.507      | 0.052             | 0.031           | 0.033      | 0.056             |           | Set Trigger |
| 2 | 2.651      | 0.049             | 0.032           | 0.035      | 0.053             |           | Set Trigger |
| 3 | 2.591      | 0.053             | 0.032           | 0.033      | 0.058             |           | Set Trigger |
| 4 | 2.616      | 0.053             | 0.032           | 0.033      | 0.058             |           | Set Trigger |
| 5 | 2.652      | 0.053             | 0.032           | 0.033      | 0.058             |           | Set Trigger |

A-60

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/062008

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



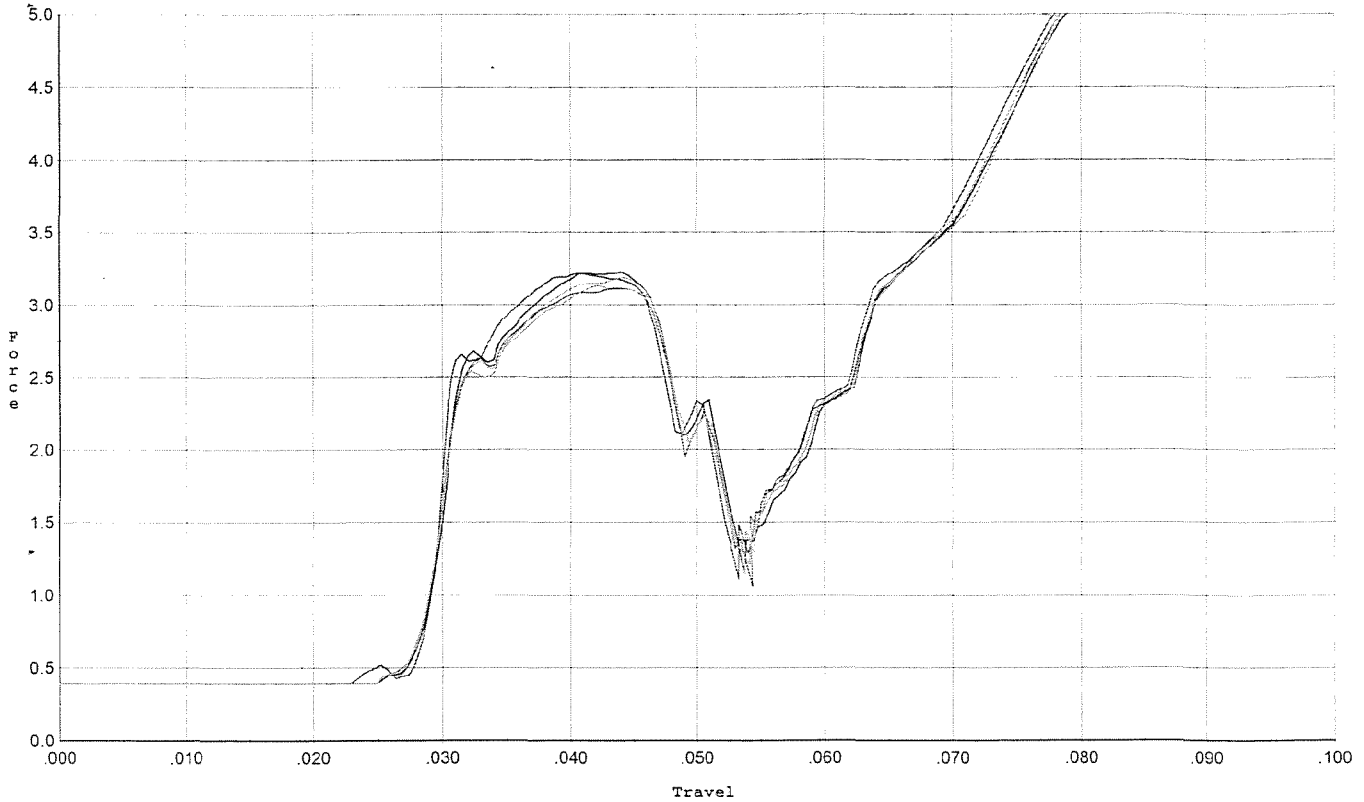
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.780      | 0.046             | 0.029           | 0.035      | 0.053             |           | Set Trigger |
| 2 | 2.526      | 0.046             | 0.029           | 0.035      | 0.050             |           | Set Trigger |
| 3 | 2.523      | 0.046             | 0.029           | 0.036      | 0.050             |           | Set Trigger |
| 4 | 2.581      | 0.046             | 0.029           | 0.036      | 0.050             |           | Set Trigger |
| 5 | 2.559      | 0.051             | 0.029           | 0.032      | 0.056             |           | Set Trigger |

A-2-59

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/062008

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



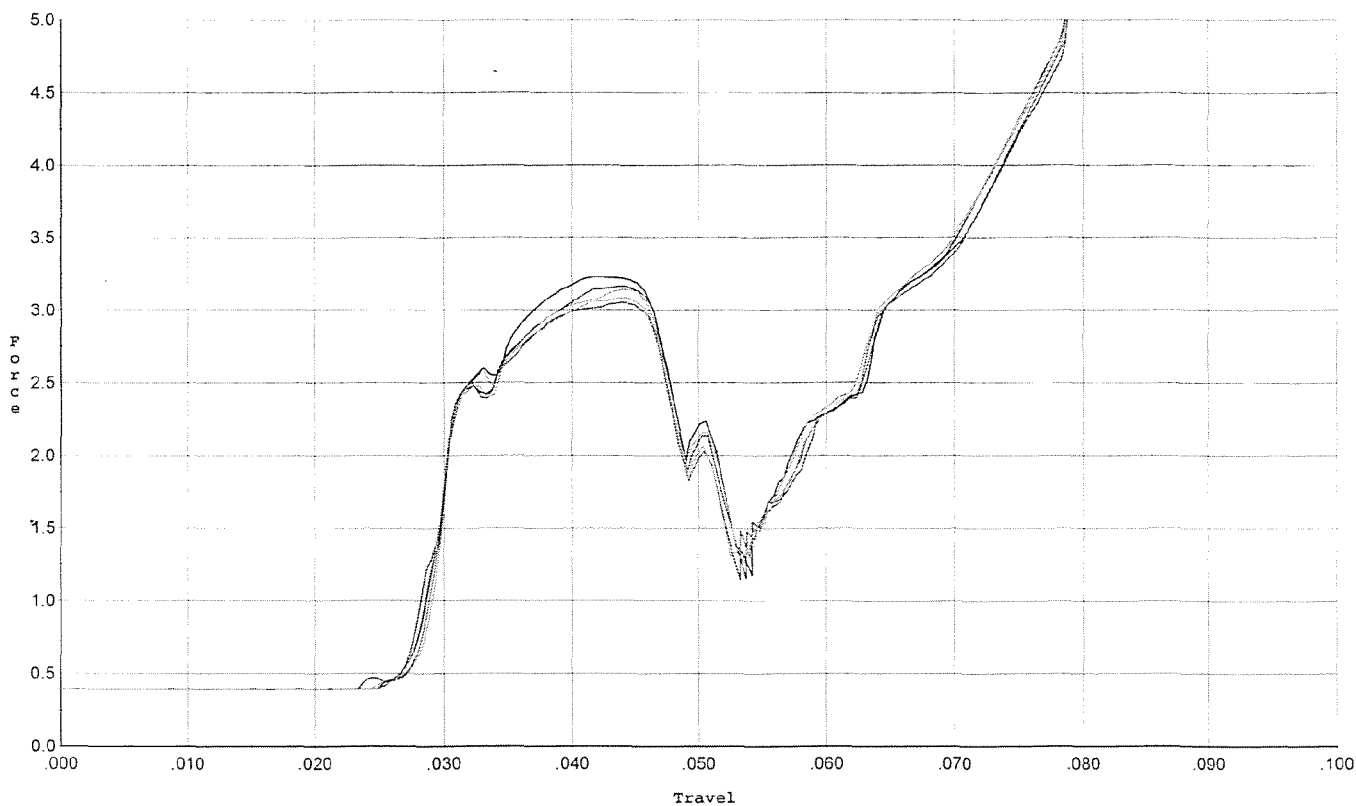
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.216      | 0.051             | 0.028           | 0.030      | 0.072             |           | Set Trigger |
| 2 | 3.226      | 0.051             | 0.028           | 0.031      | 0.072             |           | Set Trigger |
| 3 | 3.111      | 0.047             | 0.028           | 0.033      | 0.064             |           | Set Trigger |
| 4 | 3.188      | 0.047             | 0.027           | 0.033      | 0.064             |           | Set Trigger |
| 5 | 3.131      | 0.051             | 0.028           | 0.031      | 0.071             |           | Set Trigger |

A- 3.17

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/062008

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



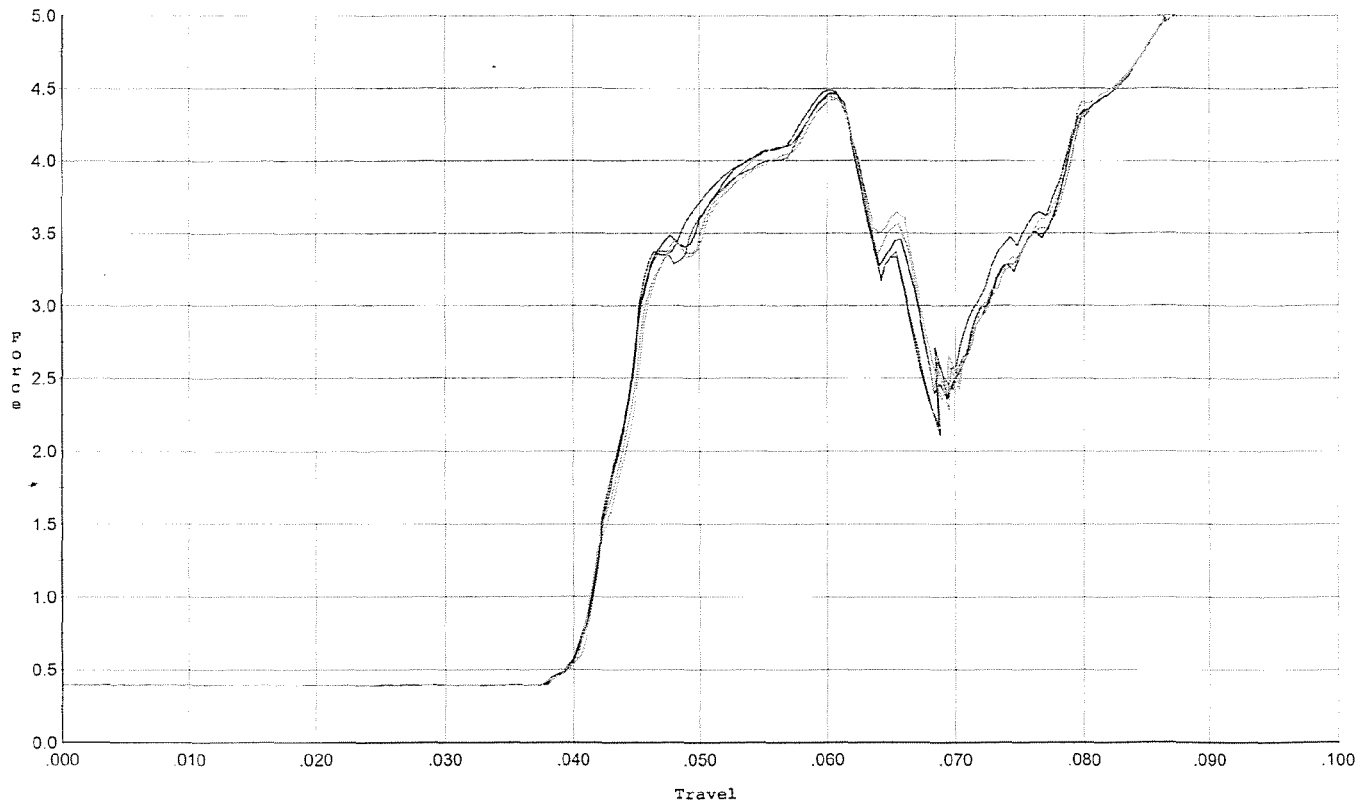
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.161      | 0.048             | 0.027           | 0.033      | 0.064             |           | Set Trigger |
| 2 | 3.227      | 0.051             | 0.027           | 0.031      | 0.073             |           | Set Trigger |
| 3 | 3.051      | 0.047             | 0.028           | 0.034      | 0.061             |           | Set Trigger |
| 4 | 3.082      | 0.047             | 0.027           | 0.033      | 0.062             |           | Set Trigger |
| 5 | 3.139      | 0.047             | 0.028           | 0.034      | 0.061             |           | Set Trigger |

A-3.13

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/062008

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



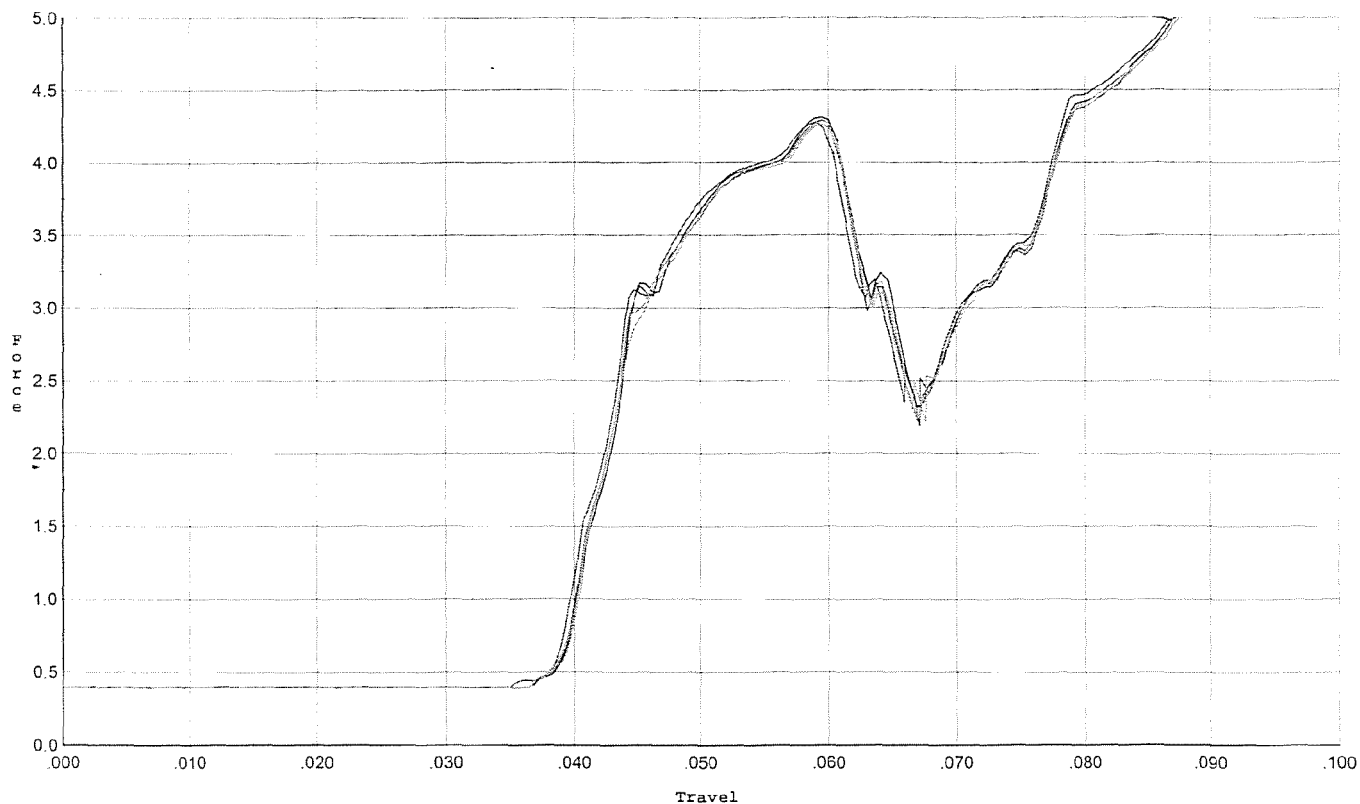
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.490      | 0.061             | 0.040           | 0.034      | 0.093             |           | Set Trigger |
| 2 | 4.467      | 0.062             | 0.040           | 0.033      | 0.095             |           | Set Trigger |
| 3 | 4.464      | 0.063             | 0.040           | 0.033      | 0.095             |           | Set Trigger |
| 4 | 4.421      | 0.066             | 0.041           | 0.030      | 0.104             |           | Set Trigger |
| 5 | 4.445      | 0.066             | 0.041           | 0.030      | 0.106             |           | Set Trigger |

A-445

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/062008

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



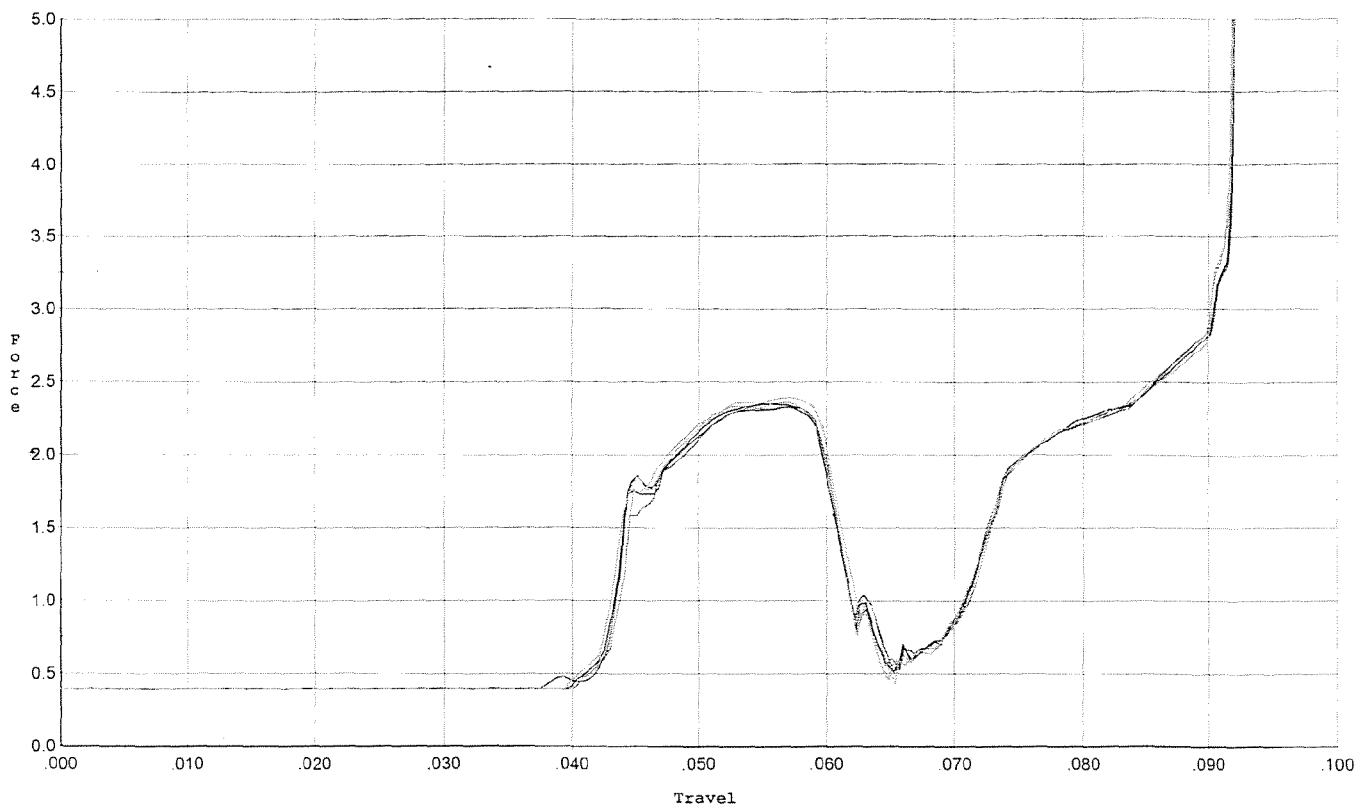
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.277      | 0.060             | 0.039           | 0.034      | 0.090             |           | Set Trigger |
| 2 | 4.309      | 0.061             | 0.039           | 0.034      | 0.091             |           | Set Trigger |
| 3 | 4.291      | 0.061             | 0.039           | 0.033      | 0.091             |           | Set Trigger |
| 4 | 4.265      | 0.061             | 0.039           | 0.034      | 0.090             |           | Set Trigger |
| 5 | 4.285      | 0.061             | 0.039           | 0.033      | 0.090             |           | Set Trigger |

A-4.28

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/062008

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



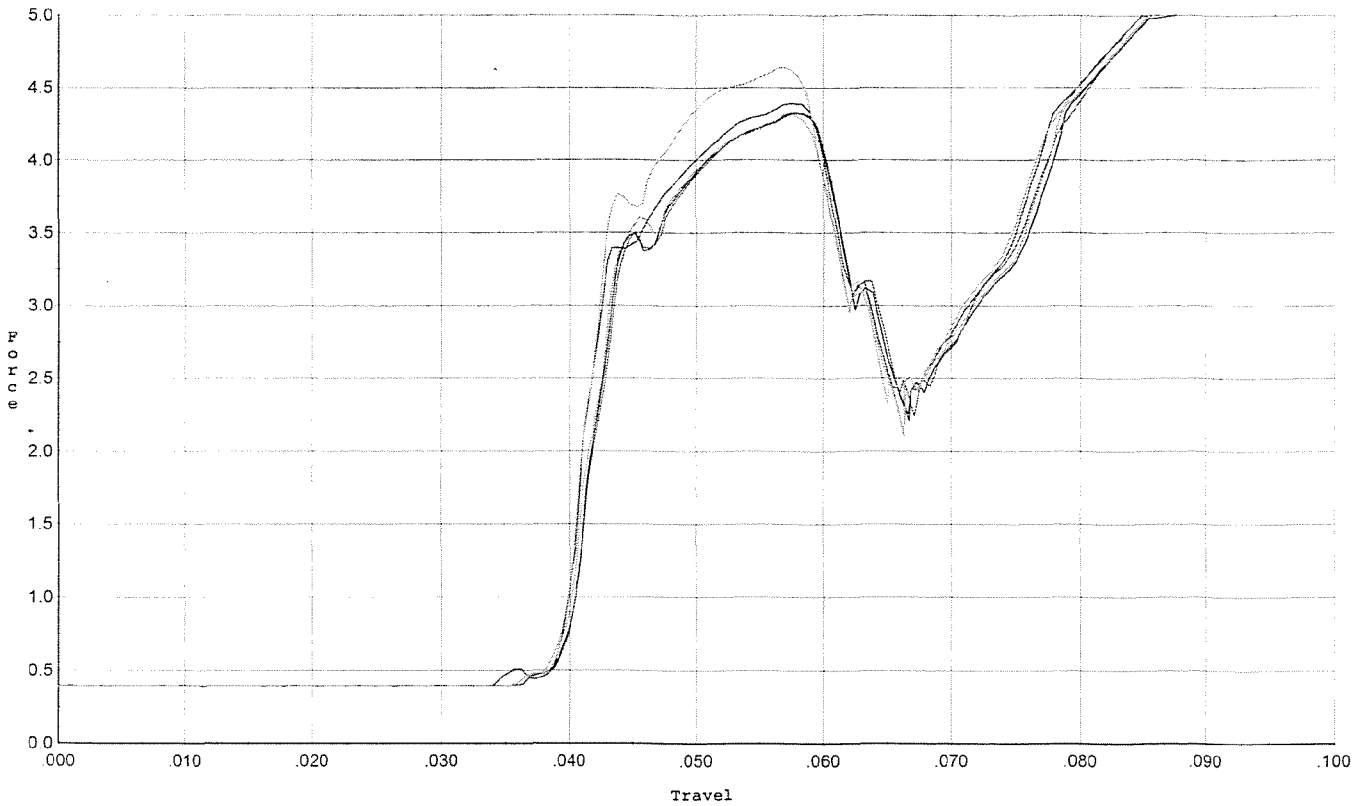
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.329      | 0.060             | 0.043           | 0.038      | 0.053             |           | Set Trigger |
| 2 | 2.348      | 0.061             | 0.042           | 0.038      | 0.054             |           | Set Trigger |
| 3 | 2.326      | 0.060             | 0.043           | 0.038      | 0.053             |           | Set Trigger |
| 4 | 2.394      | 0.060             | 0.042           | 0.038      | 0.054             |           | Set Trigger |
| 5 | 2.366      | 0.060             | 0.041           | 0.038      | 0.054             |           | Set Trigger |

A-2-35

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/062008

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 | 4.391      | 0.060             | 0.039           | 0.034      | 0.094             |           | Set Trigger |
| 2 | 4.326      | 0.061             | 0.039           | 0.034      | 0.094             |           | Set Trigger |
| 3 | 4.323      | 0.061             | 0.039           | 0.034      | 0.093             |           | Set Trigger |
| 4 | 4.639      | 0.059             | 0.039           | 0.034      | 0.096             |           | Set Trigger |
| 5 | 4.328      | 0.060             | 0.039           | 0.034      | 0.093             |           | Set Trigger |

A-4.40