

66875797

**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



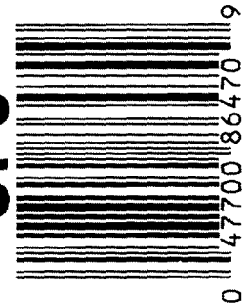
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6875797**

**UPC**



**BM FORM**

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6875797

| OP # | OPERATION NAME                                                                                                                         | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                       | 8-13-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                       | 8-13-09 | SP      |
| 440  | PROOF                                                                                                                                  |                       | 8-13-09 | SPD     |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX          | 8-13-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    | 2009                  | 8-13-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                       | 8-14-09 | RTZ     |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR              | 8/19/09 | (N)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                       |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |                       | 8/19/09 | DWO     |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                       | 8-14-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                       | 8/20    | REM     |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                       | 9/28    | —       |
| 545  | (BOLT)                                                                                                                                 |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                       | 8-28-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                       | 8-28-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO | 8-28-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                       | 9-3-09  | SPD     |
|      | 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

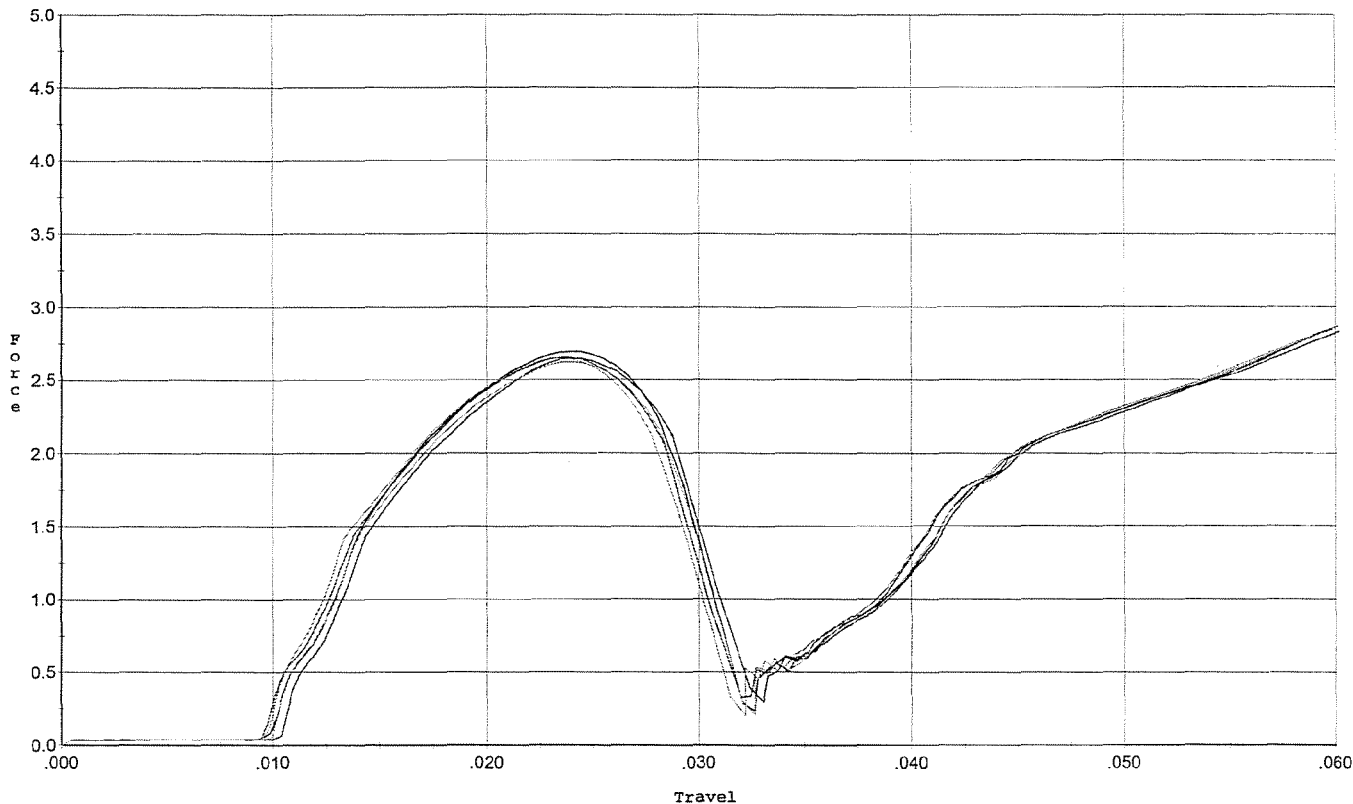
|              |                                                                       |                                           |                                                                                  |                      |                      |             |             |         |    |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|----------------------------------------------------------------------------------|----------------------|----------------------|-------------|-------------|---------|----|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>3<sup>9</sup></u>                                                             | <u>3<sup>9</sup></u> | <u>3<sup>9</sup></u> | 9/22/09     | RB          |         |    |
| CONT.        |                                                                       |                                           |                                                                                  |                      |                      |             |             |         |    |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>8<sup>9</sup></u>                                                             | <u>8<sup>9</sup></u> | <u>8<sup>9</sup></u> | 9/22/09     | RB          |         |    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                                                  |                      |                      |             |             |         |    |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.022</u>                                                                      | <u>.023</u>          | <u>.024</u>          | 9/22/09     | RB          |         |    |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                                                  |                      |                      | 9-3-09      | LRD         |         |    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                                                  |                      |                      | 9/22/09     | RB          |         |    |
|              | 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                                           |                                           | <del>PASS</del>                                                                  | FAIL                 |                      | 9/8/09      | RB          |         |    |
|              |                                                                       |                                           | <del>PASS</del>                                                                  | FAIL                 |                      |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | <div>CORRECTION</div> <div>N/A</div> <div>CORRECTION</div> <div>CORRECTION</div> |                      |                      |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |                                                                                  |                      |                      |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |                                                                                  |                      |                      |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |                                                                                  |                      |                      |             |             |         |    |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                                                  |                      |                      | 9/8/09      | TAR         |         |    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                                                  |                      |                      | 9/22/09     | RB          |         |    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.13</u>                                                                      | <u>2.30</u>          | <u>2.21</u>          | <u>2.25</u> | <u>2.25</u> | 9/21/09 | RB |
|              | C) FUNCTION                                                           |                                           |                                                                                  |                      |                      |             |             | 9/22/09 | RB |
| 690          | PACK                                                                  |                                           |                                                                                  |                      |                      |             |             | 9/28/09 | Fm |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R.P. 8/31/09

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



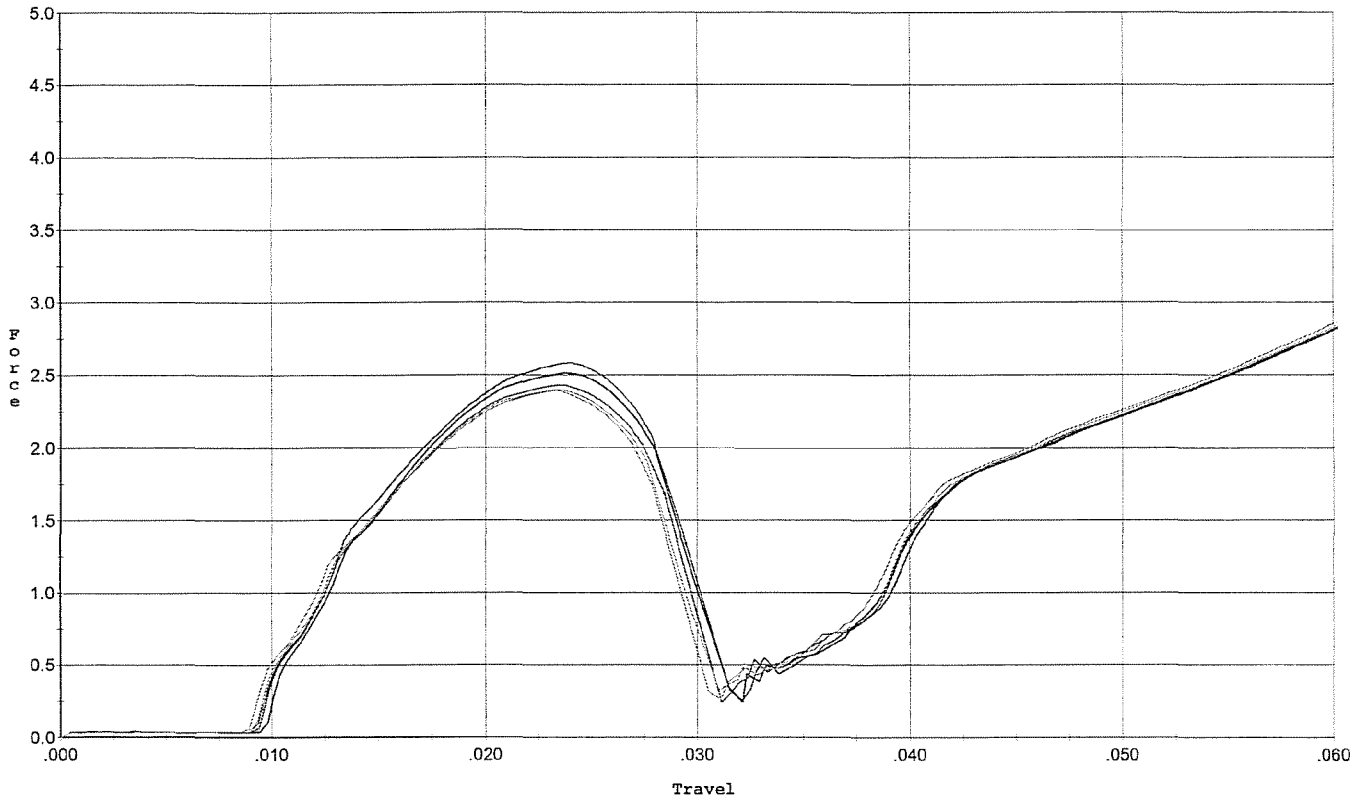
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.646      | 0.029             | 0.011           | 0.039      | 0.036             |           | Set Trigger |
| 2 | 2.695      | 0.029             | 0.010           | 0.039      | 0.038             |           | Set Trigger |
| 3 | 2.651      | 0.028             | 0.010           | 0.039      | 0.037             |           | Set Trigger |
| 4 | 2.622      | 0.030             | 0.010           | 0.039      | 0.038             |           | Set Trigger |
| 5 | 2.646      | 0.029             | 0.010           | 0.039      | 0.038             |           | Set Trigger |

Avg 2.65

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 8/31/09

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



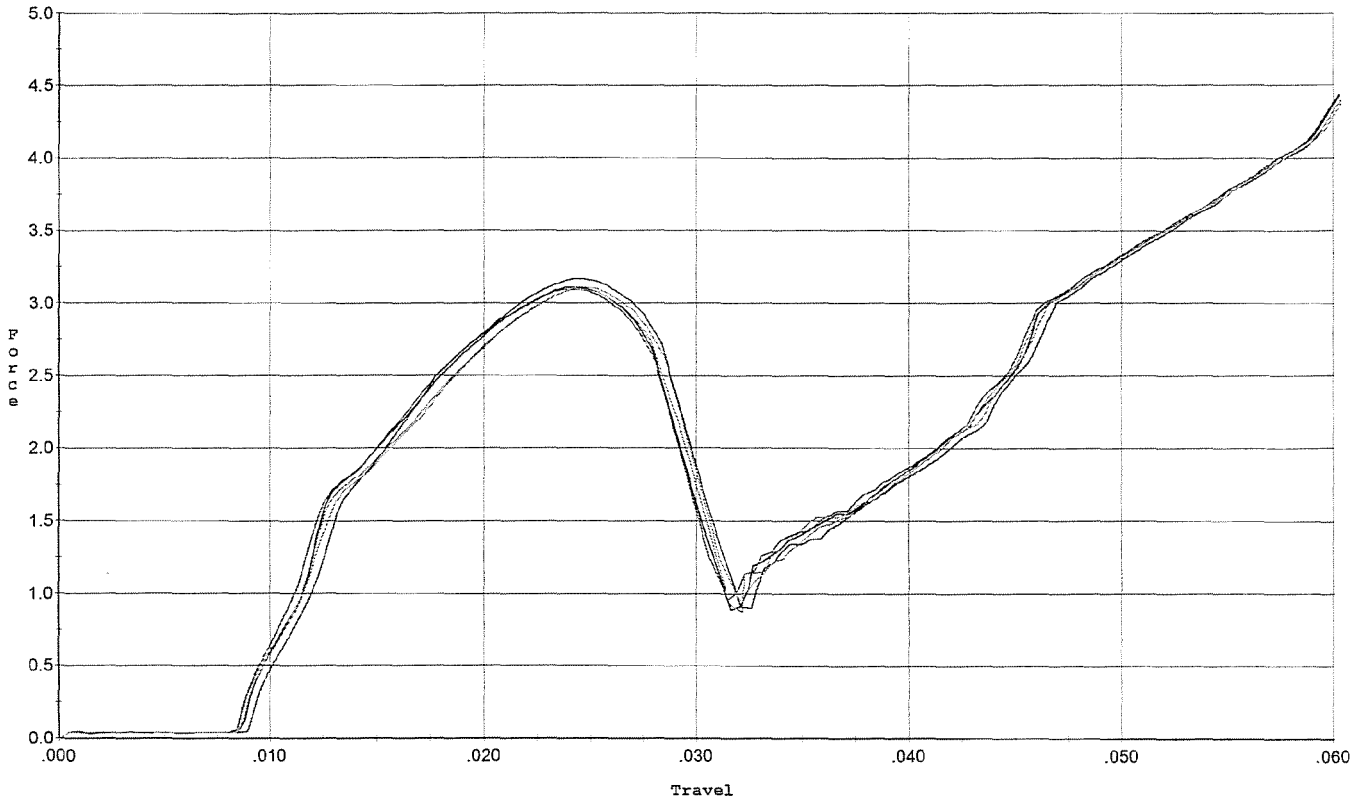
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.583      | 0.029             | 0.010           | 0.039      | 0.037             |           | Set Trigger |
| 2 | 2.514      | 0.028             | 0.010           | 0.039      | 0.034             |           | Set Trigger |
| 3 | 2.429      | 0.028             | 0.009           | 0.039      | 0.034             |           | Set Trigger |
| 4 | 2.399      | 0.028             | 0.009           | 0.039      | 0.033             |           | Set Trigger |
| 5 | 2.396      | 0.028             | 0.009           | 0.039      | 0.033             |           | Set Trigger |

Aug 2.46

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 8/31/09

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



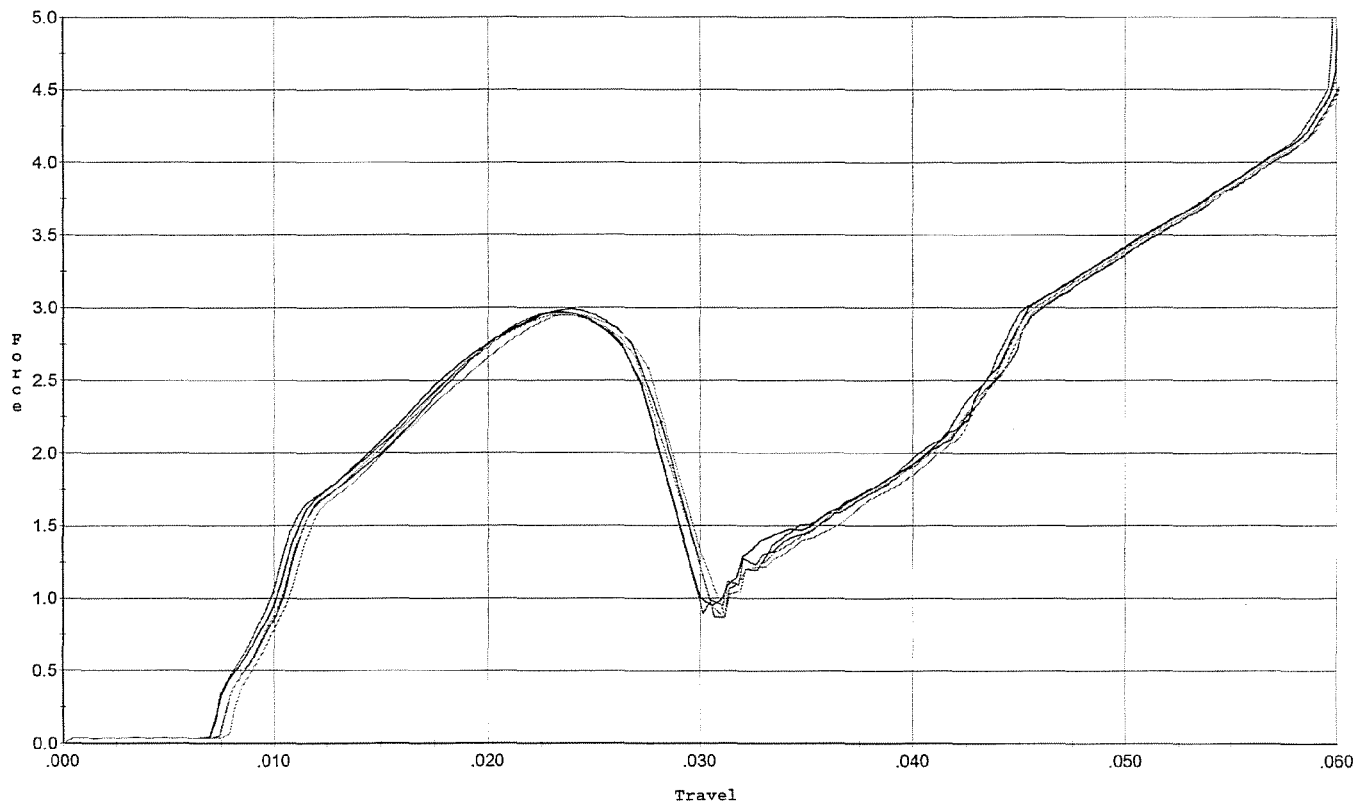
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.166      | 0.028             | 0.009           | 0.036      | 0.044             |           | Set Trigger |
| 2 | 3.108      | 0.028             | 0.009           | 0.036      | 0.043             |           | Set Trigger |
| 3 | 3.096      | 0.028             | 0.009           | 0.036      | 0.044             |           | Set Trigger |
| 4 | 3.109      | 0.029             | 0.009           | 0.036      | 0.044             |           | Set Trigger |
| 5 | 3.091      | 0.029             | 0.009           | 0.036      | 0.045             |           | Set Trigger |

Aug 3.11

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R.P. 8/31/09

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



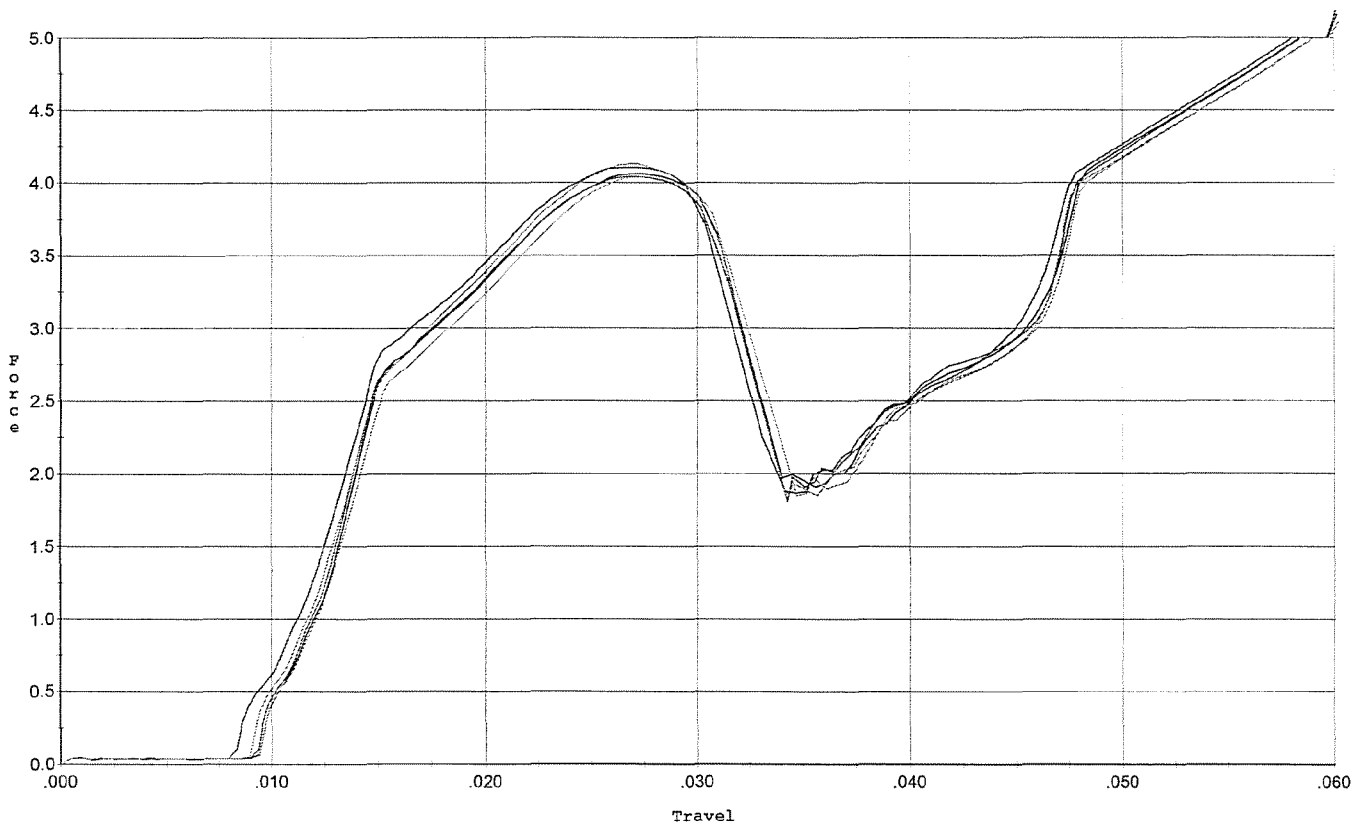
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.991      | 0.028             | 0.008           | 0.036      | 0.044             |           | Set Trigger |
| 2 | 2.967      | 0.027             | 0.007           | 0.036      | 0.043             |           | Set Trigger |
| 3 | 2.975      | 0.027             | 0.007           | 0.036      | 0.043             |           | Set Trigger |
| 4 | 2.951      | 0.028             | 0.008           | 0.036      | 0.042             |           | Set Trigger |
| 5 | 2.950      | 0.029             | 0.008           | 0.036      | 0.044             |           | Set Trigger |

Aug 2.96

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 8/31/09

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



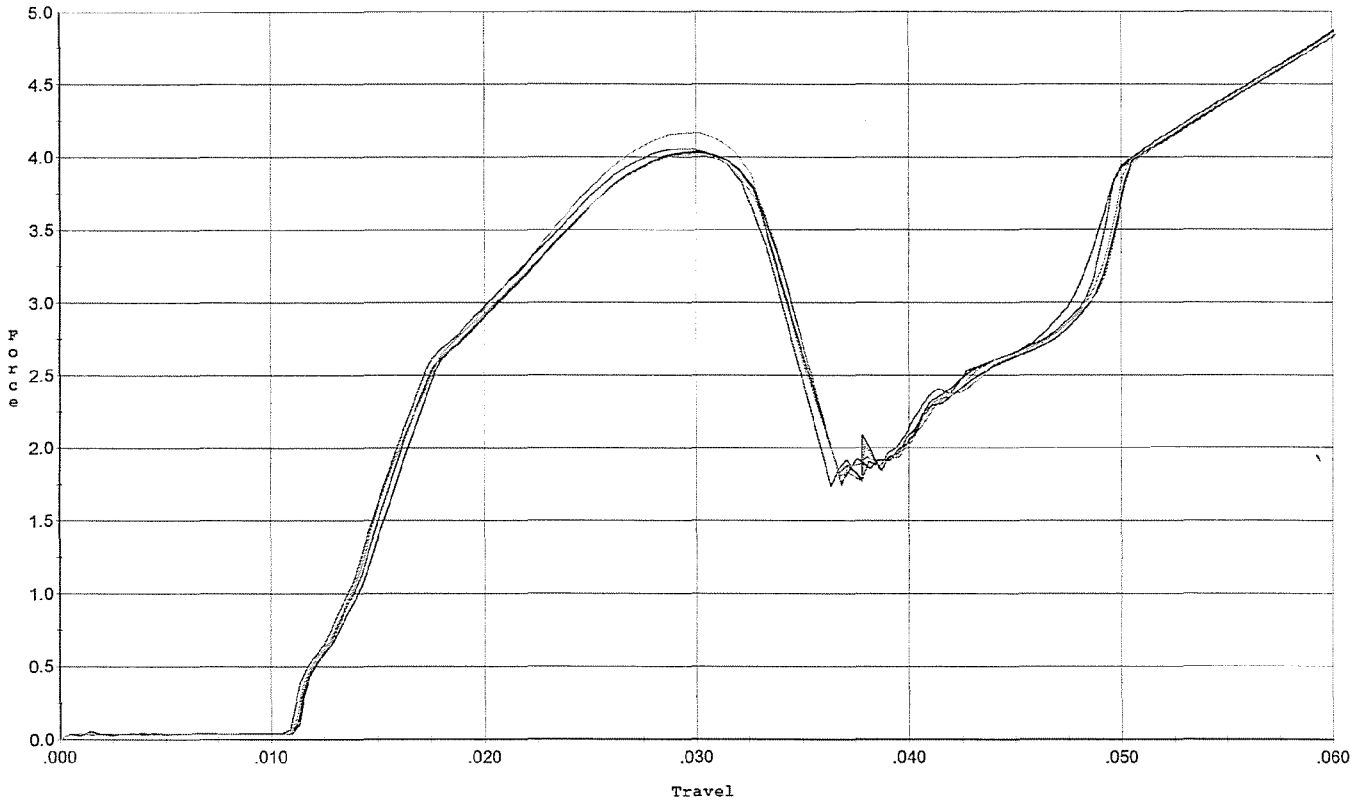
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.104      | 0.030             | 0.008           | 0.030      | 0.064             |           | Set Trigger |
| 2 | 4.061      | 0.031             | 0.010           | 0.029      | 0.064             |           | Set Trigger |
| 3 | 4.043      | 0.031             | 0.009           | 0.030      | 0.065             |           | Set Trigger |
| 4 | 4.042      | 0.033             | 0.010           | 0.029      | 0.066             |           | Set Trigger |
| 5 | 4.128      | 0.031             | 0.009           | 0.029      | 0.065             |           | Set Trigger |

Aug 4.07

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 8/31/09

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



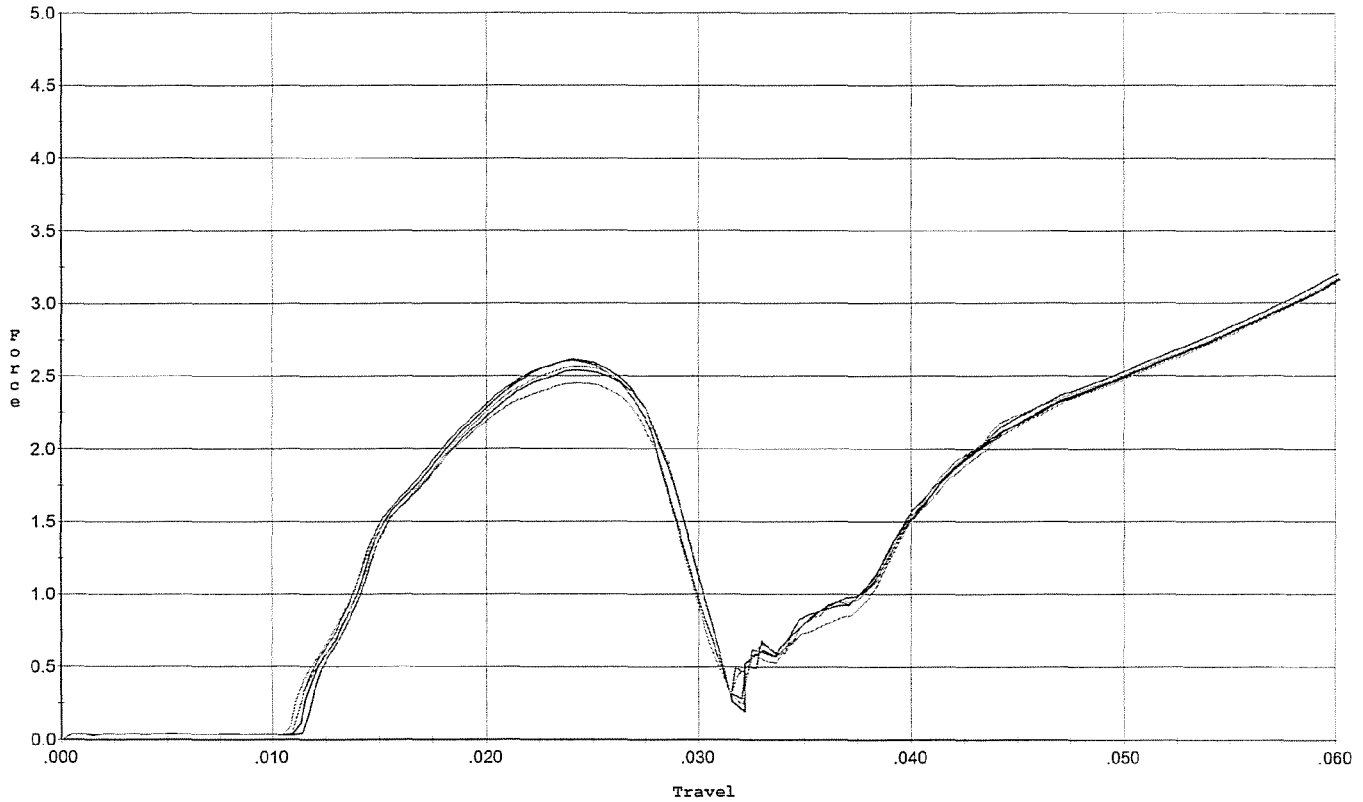
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.031      | 0.033             | 0.011           | 0.030      | 0.063             |           | Set Trigger |
| 2 | 4.036      | 0.034             | 0.011           | 0.030      | 0.066             |           | Set Trigger |
| 3 | 4.058      | 0.033             | 0.011           | 0.029      | 0.065             |           | Set Trigger |
| 4 | 4.166      | 0.034             | 0.011           | 0.029      | 0.067             |           | Set Trigger |
| 5 | 4.020      | 0.033             | 0.011           | 0.030      | 0.063             |           | Set Trigger |

Avg 4.06

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 8/31/09

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



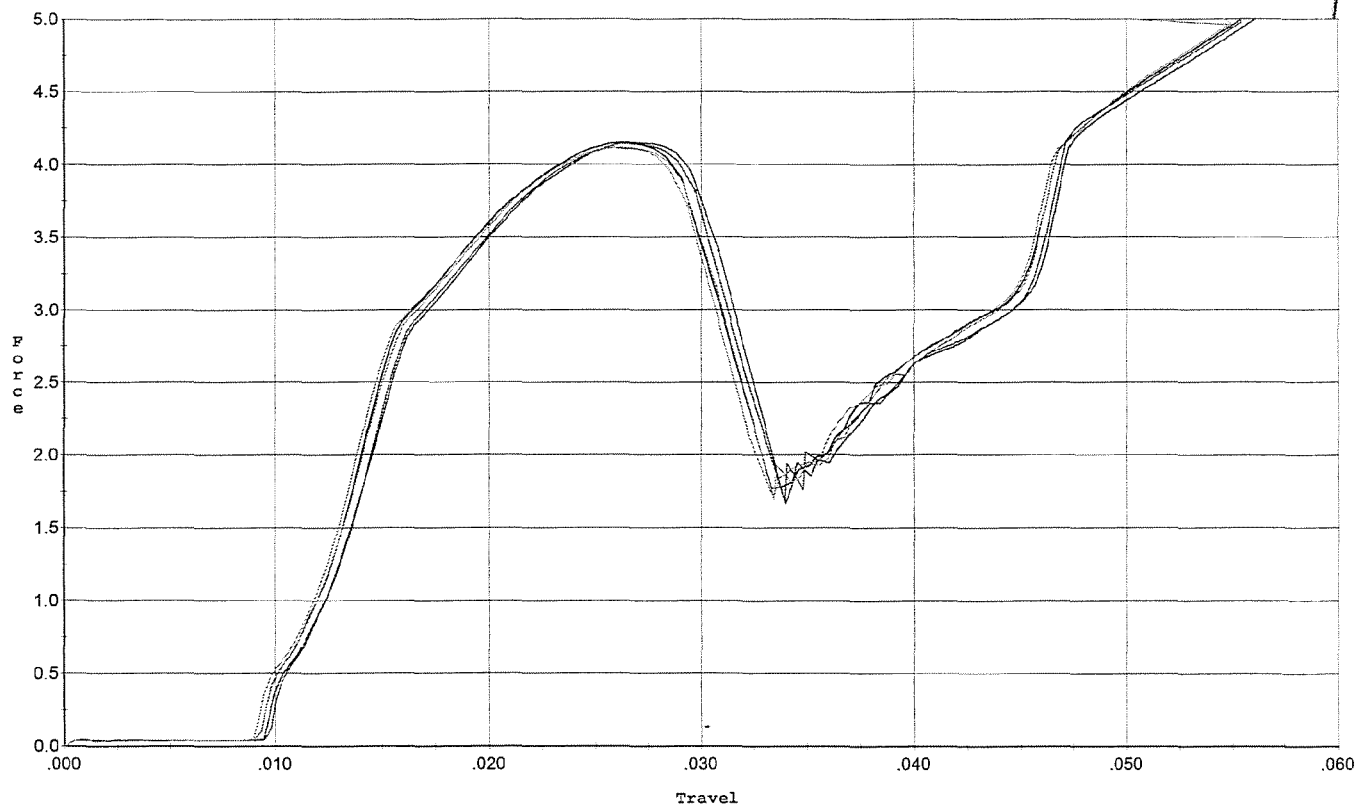
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.539      | 0.029             | 0.012           | 0.038      | 0.033             |           | Set Trigger |
| 2 | 2.615      | 0.029             | 0.011           | 0.038      | 0.034             |           | Set Trigger |
| 3 | 2.607      | 0.028             | 0.011           | 0.038      | 0.033             |           | Set Trigger |
| 4 | 2.567      | 0.029             | 0.011           | 0.038      | 0.033             |           | Set Trigger |
| 5 | 2.452      | 0.028             | 0.011           | 0.038      | 0.032             |           | Set Trigger |

Avg 2.55

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 8/31/09

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 | 4.150      | 0.031             | 0.010           | 0.029      | 0.063             |           | Set Trigger |
| 2 | 4.147      | 0.031             | 0.009           | 0.031      | 0.064             |           | Set Trigger |
| 3 | 4.142      | 0.030             | 0.010           | 0.030      | 0.060             |           | Set Trigger |
| 4 | 4.111      | 0.029             | 0.009           | 0.032      | 0.060             |           | Set Trigger |
| 5 | 4.120      | 0.031             | 0.009           | 0.029      | 0.063             |           | Set Trigger |

Avg 4.13