

66863590

**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**

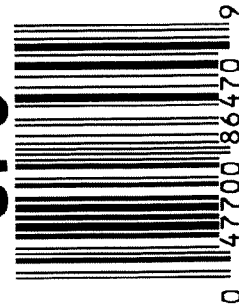
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6863590**

**UPC**



## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863590

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 7-14-09 | SPH     |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 7-14-09 | SP      |
| 440  | PROOF                                                                                                                                  |                                                                                             | 9-14-09 | SPH     |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                                                                                | 7-14-09 | SPH     |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 7-14-09 | SPH     |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 7-15-09 | RT      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 7-18-09 |         |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 7-21-09 | DWD     |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 7-15-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 7-21-09 | SPH     |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 8/4     | ✓       |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 8-11-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 8-11-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO                                                                       | 8-11-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 8-12-09 | SPH     |
|      | 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

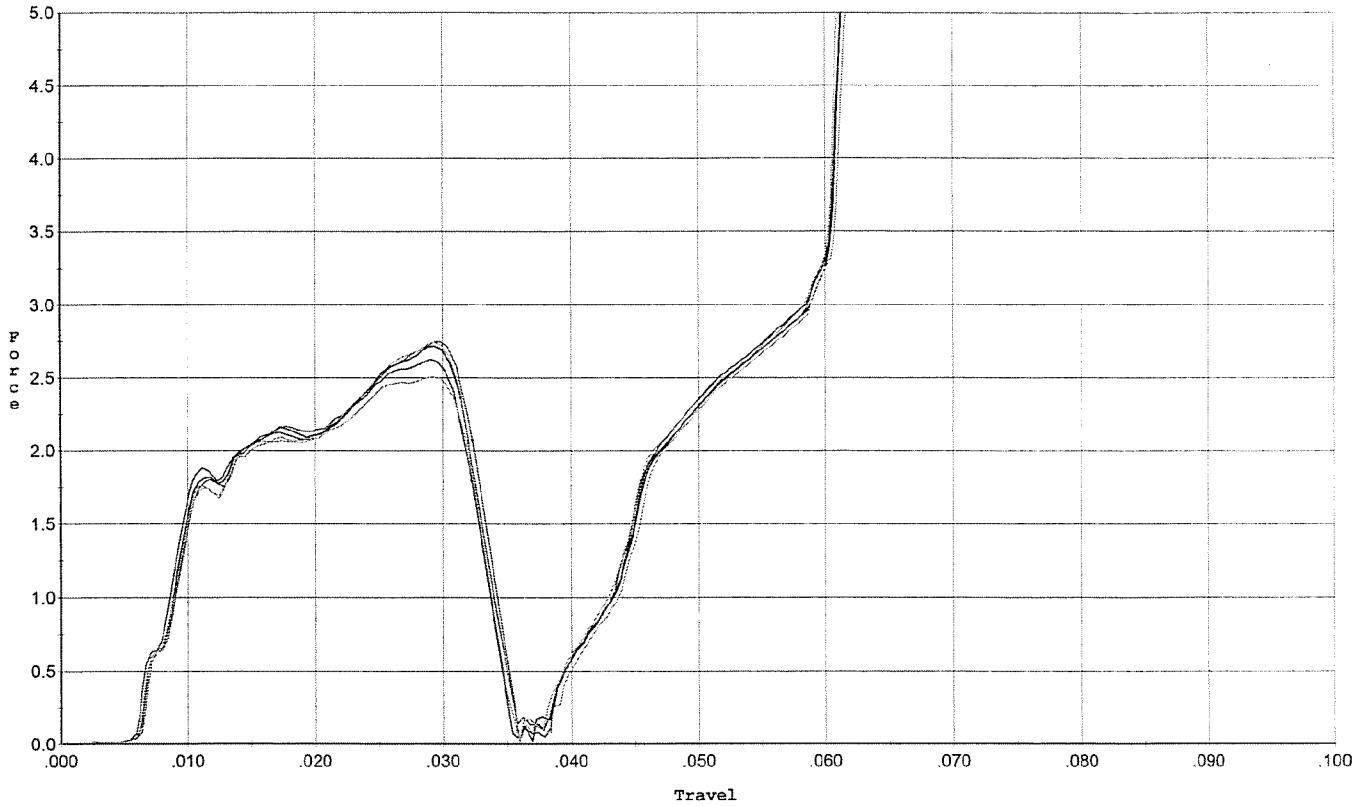
|              |                                                                       |                                           |                                                             |         |        |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|--------|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>2.0</u> <u>2.0</u> <u>2.0</u>                            | 8-17-09 | L.P.D. |
| CONT.        | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>3.0</u> <u>3.0</u> <u>3.0</u>                            | 8-17-09 | L.P.D. |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |        |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.026</u> <u>.026</u> <u>.026</u>                         | 8-17-09 | L.P.D. |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 8-12-09 | L.P.D. |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 8-17-09 | L.P.D. |
|              | 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                        | 8-17-09 | L.P.D. |
|              | MALFUNCTION                                                           | CORRECTION                                | N/A                                                         |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |        |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |        |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 8-17-09 | BP     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 8-17-09 | L.P.D. |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.65</u> <u>2.72</u> <u>2.80</u> <u>2.78</u> <u>2.76</u> | 8-17-09 | RP     |
|              | C) FUNCTION                                                           |                                           |                                                             | 8-17-09 | L.P.D. |
| 690          | PACK                                                                  |                                           |                                                             | 8/18/09 | Fm     |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/12/2009

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



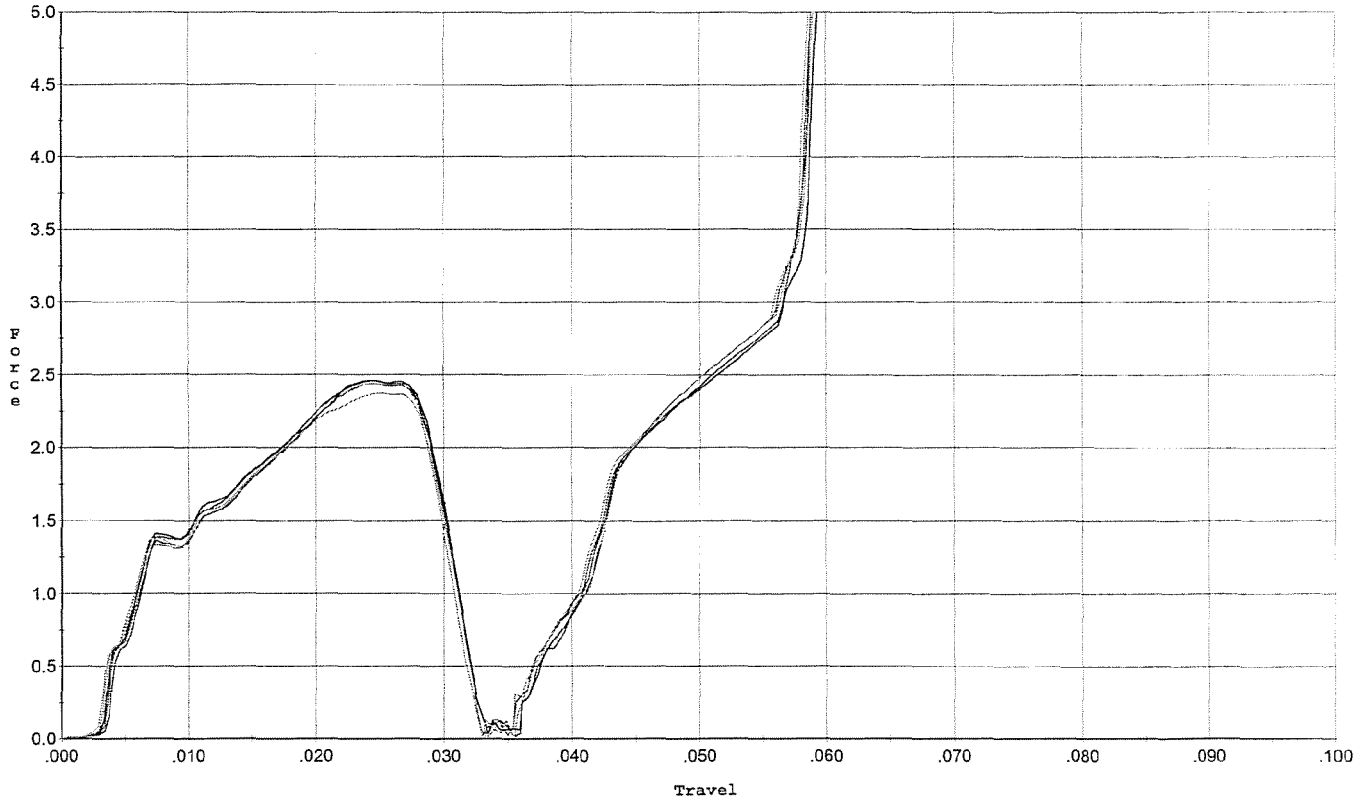
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.626      | 0.032             | 0.006           | 0.036      | 0.051             |           | Set Trigger |
| 2 | 2.716      | 0.031             | 0.006           | 0.036      | 0.050             |           | Set Trigger |
| 3 | 2.748      | 0.032             | 0.007           | 0.032      | 0.052             |           | Set Trigger |
| 4 | 2.743      | 0.031             | 0.006           | 0.036      | 0.050             |           | Set Trigger |
| 5 | 2.507      | 0.032             | 0.006           | 0.036      | 0.049             |           | Set Trigger |

A-2.66

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/12/2009

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



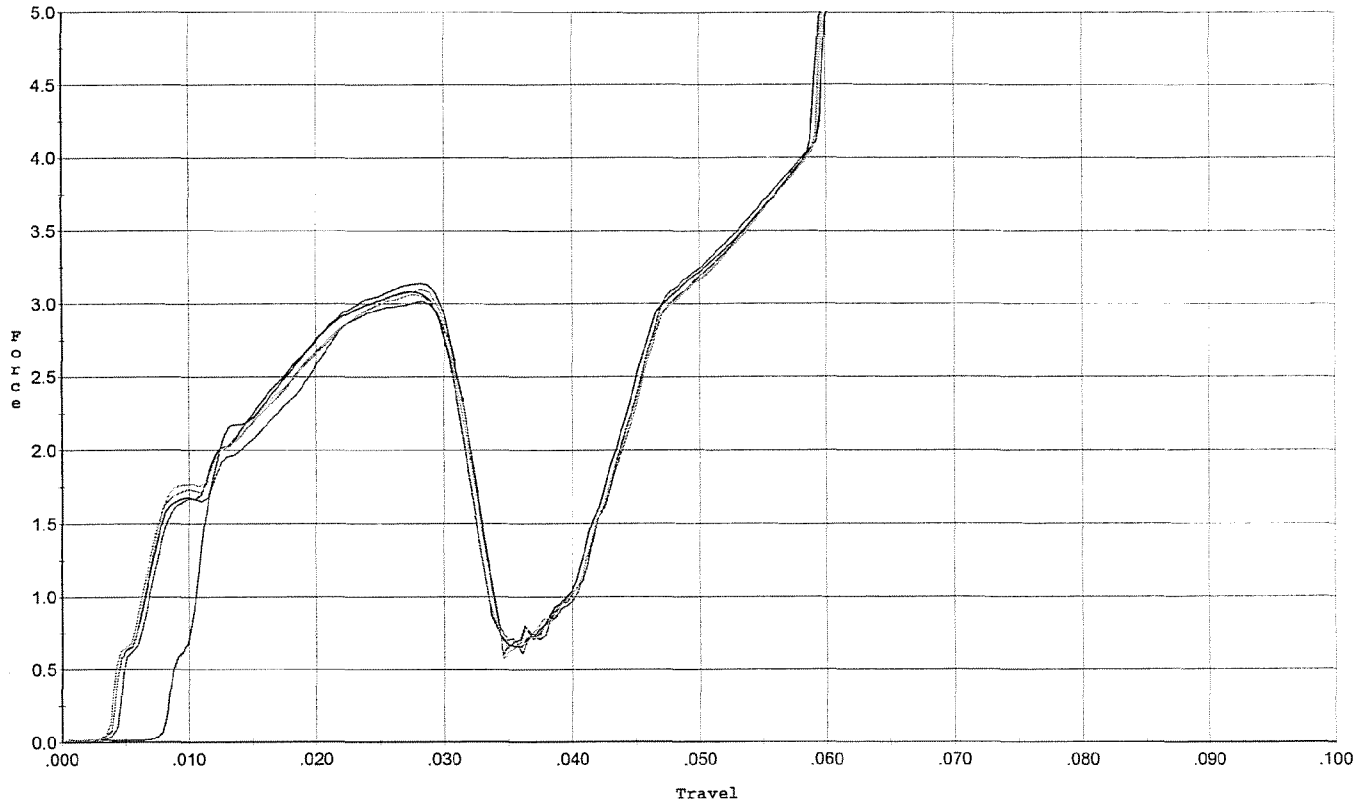
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.461      | 0.030             | 0.004           | 0.036      | 0.047             |           | Set Trigger |
| 2 | 2.459      | 0.030             | 0.003           | 0.036      | 0.047             |           | Set Trigger |
| 3 | 2.440      | 0.031             | 0.003           | 0.036      | 0.047             |           | Set Trigger |
| 4 | 2.377      | 0.031             | 0.003           | 0.036      | 0.047             |           | Set Trigger |
| 5 | 2.441      | 0.029             | 0.003           | 0.036      | 0.046             |           | Set Trigger |

A-2.43

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/12/2009

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



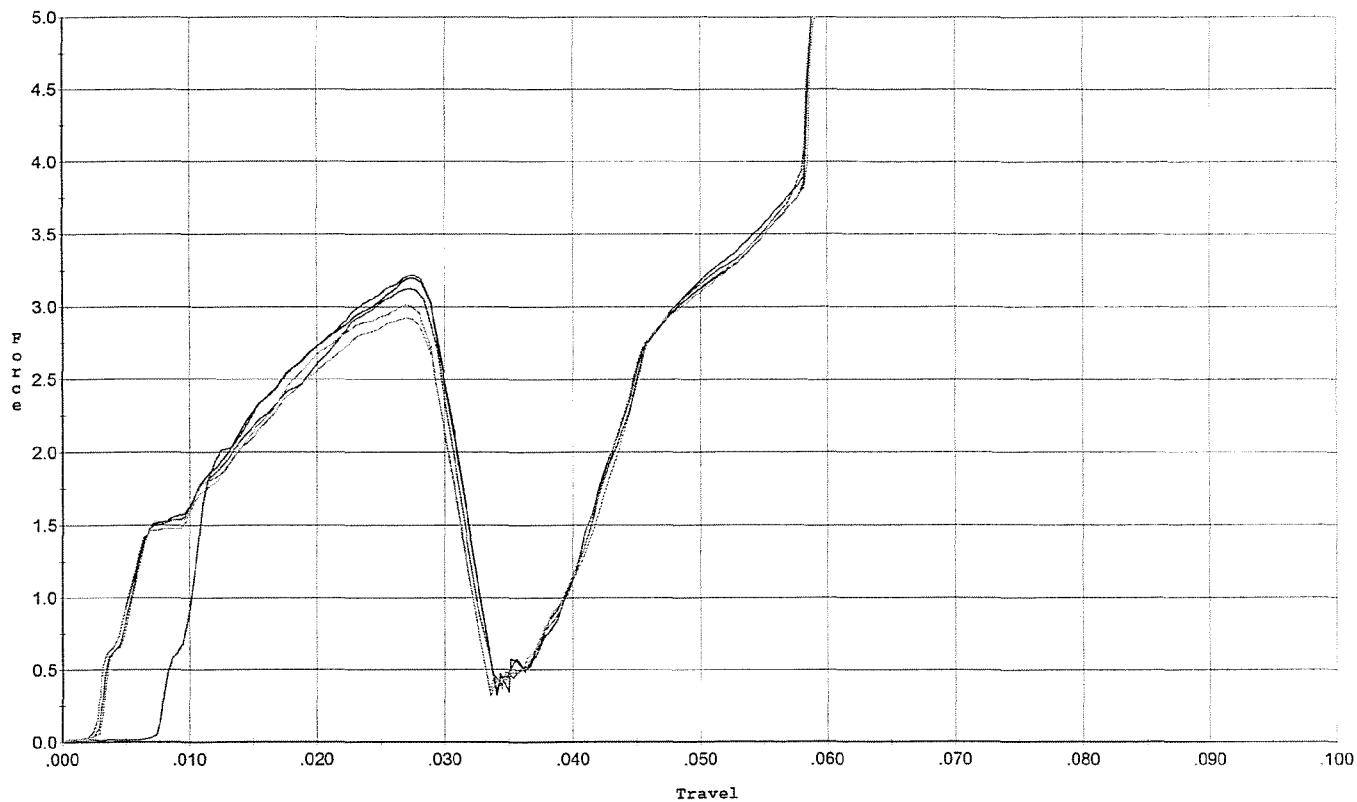
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.139      | 0.031             | 0.008           | 0.030      | 0.055             |           | Set Trigger |
| 2 | 3.082      | 0.031             | 0.004           | 0.034      | 0.059             |           | Set Trigger |
| 3 | 3.014      | 0.031             | 0.004           | 0.030      | 0.058             |           | Set Trigger |
| 4 | 3.099      | 0.032             | 0.004           | 0.030      | 0.061             |           | Set Trigger |
| 5 | 3.061      | 0.031             | 0.004           | 0.034      | 0.058             |           | Set Trigger |

A-3.07

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/12/2009

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



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.220      | 0.031             | 0.008           | 0.034      | 0.054             |           | Set Trigger |
| 2 | 3.196      | 0.031             | 0.003           | 0.034      | 0.060             |           | Set Trigger |
| 3 | 3.125      | 0.029             | 0.003           | 0.034      | 0.056             |           | Set Trigger |
| 4 | 3.014      | 0.029             | 0.003           | 0.035      | 0.054             |           | Set Trigger |
| 5 | 2.924      | 0.031             | 0.003           | 0.034      | 0.057             |           | Set Trigger |

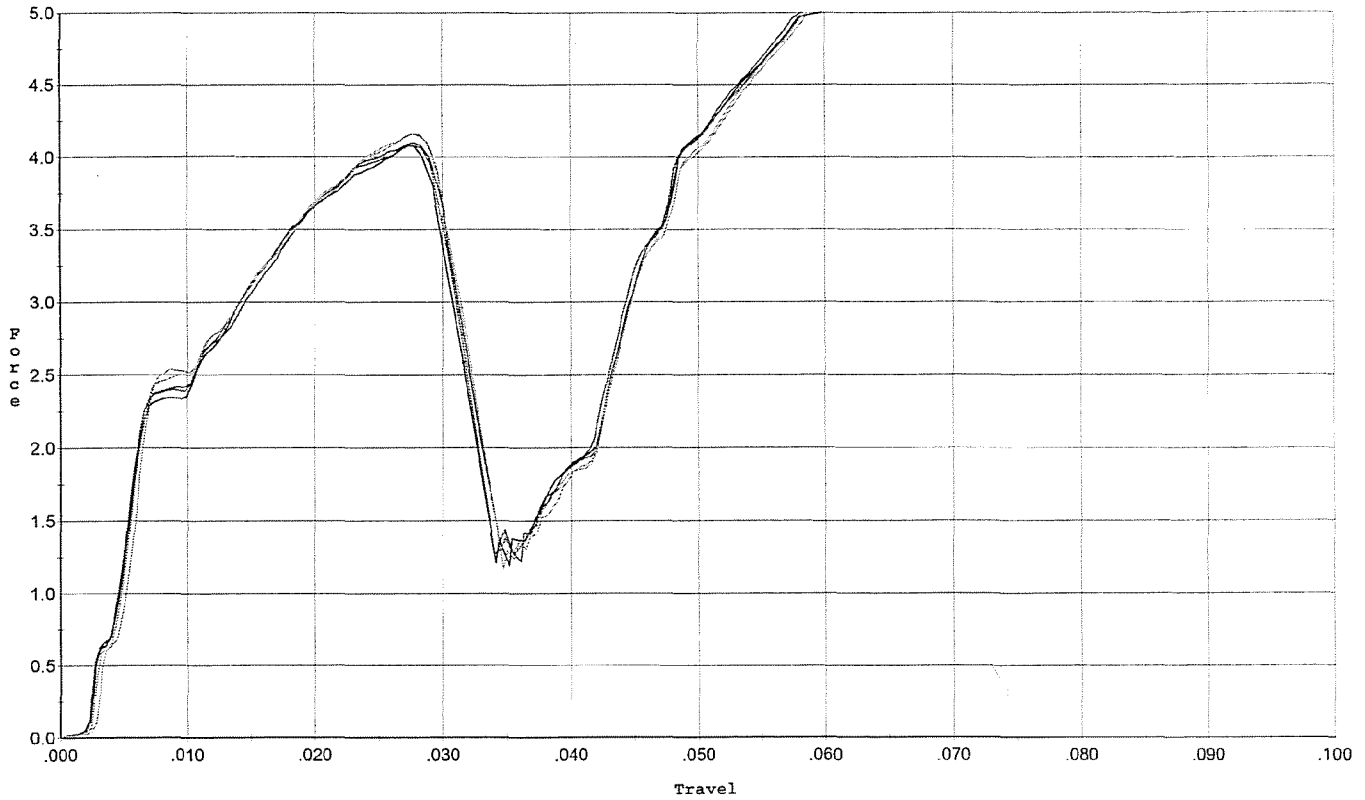
A-3-09



# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/12/2009

**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 | 4.099      | 0.030             | 0.002           | 0.027      | 0.079             |           | Set Trigger |
| 2 | 4.085      | 0.032             | 0.010           | 0.027      | 0.082             |           | Set Trigger |
| 3 | 4.078      | 0.030             | 0.011           | 0.027      | 0.080             |           | Set Trigger |
| 4 | 4.158      | 0.031             | 0.003           | 0.026      | 0.083             |           | Set Trigger |
| 5 | 4.158      | 0.030             | 0.011           | 0.027      | 0.079             |           | Set Trigger |

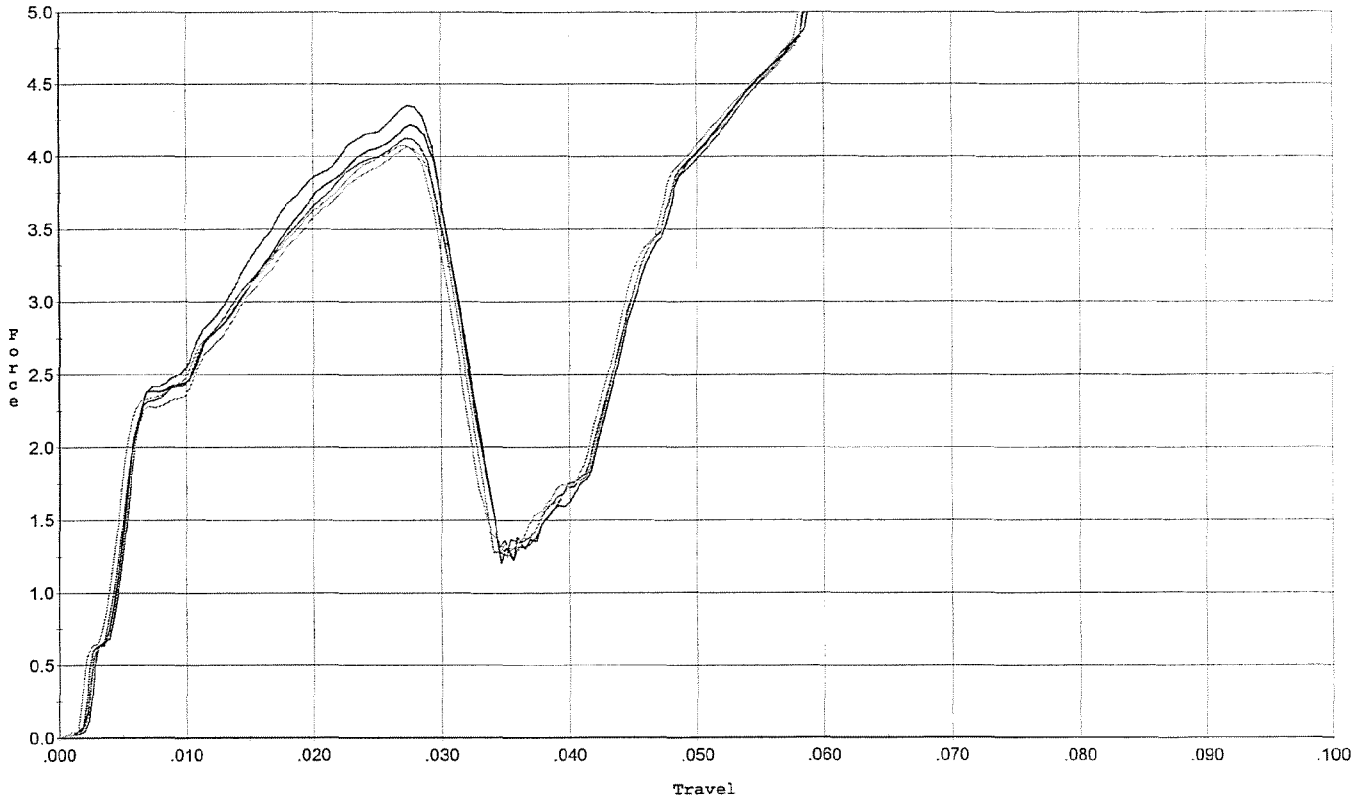
A-4.11

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/12/2009

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

+/- 1.0 lb.



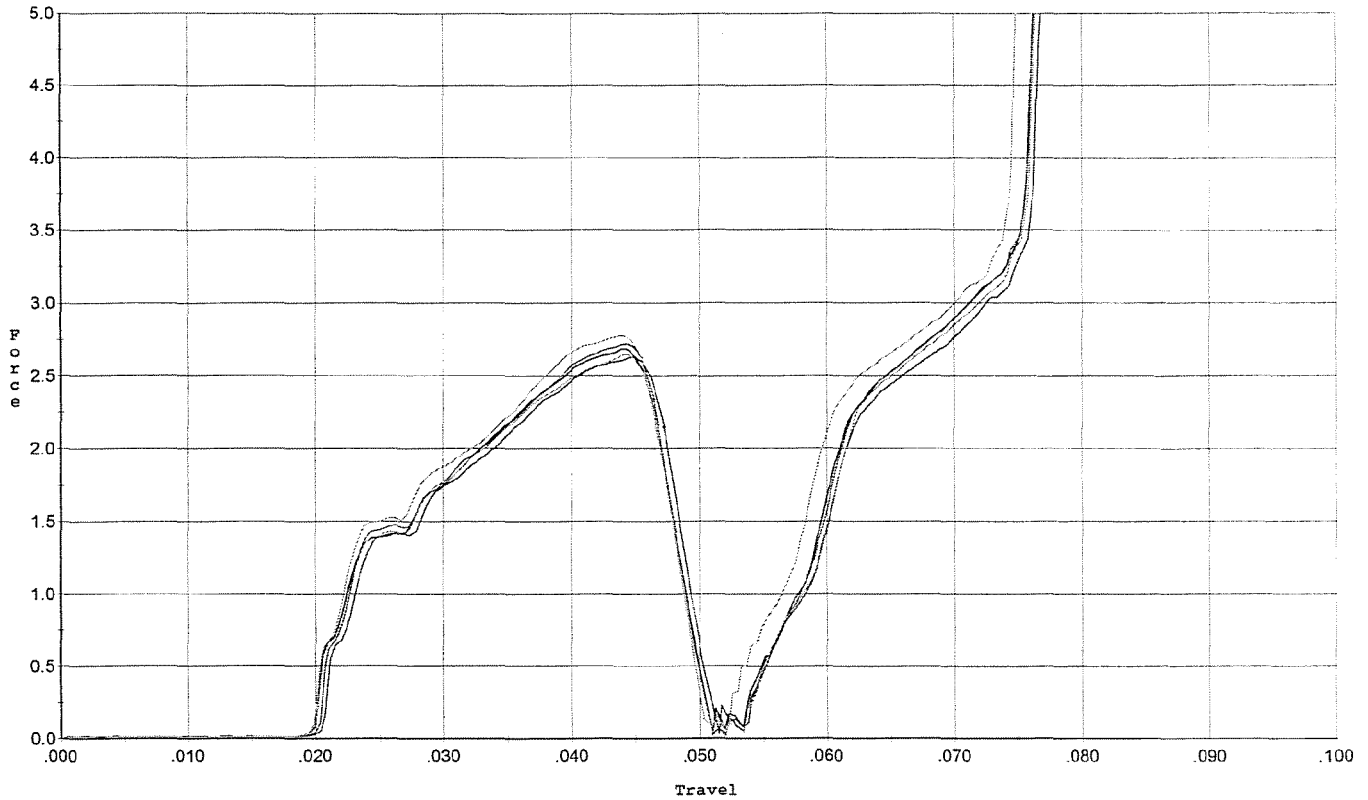
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.353      | 0.029             | 0.00            | 0.026      | 0.081             |           | Set Trigger |
| 2 | 4.217      | 0.032             | 0.011           | 0.026      | 0.086             |           | Set Trigger |
| 3 | 4.124      | 0.030             | 0.00            | 0.027      | 0.081             |           | Set Trigger |
| 4 | 4.065      | 0.031             | 0.00            | 0.026      | 0.080             |           | Set Trigger |
| 5 | 4.075      | 0.029             | 0.00            | 0.027      | 0.079             |           | Set Trigger |

A. 4.16

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/12/2009

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



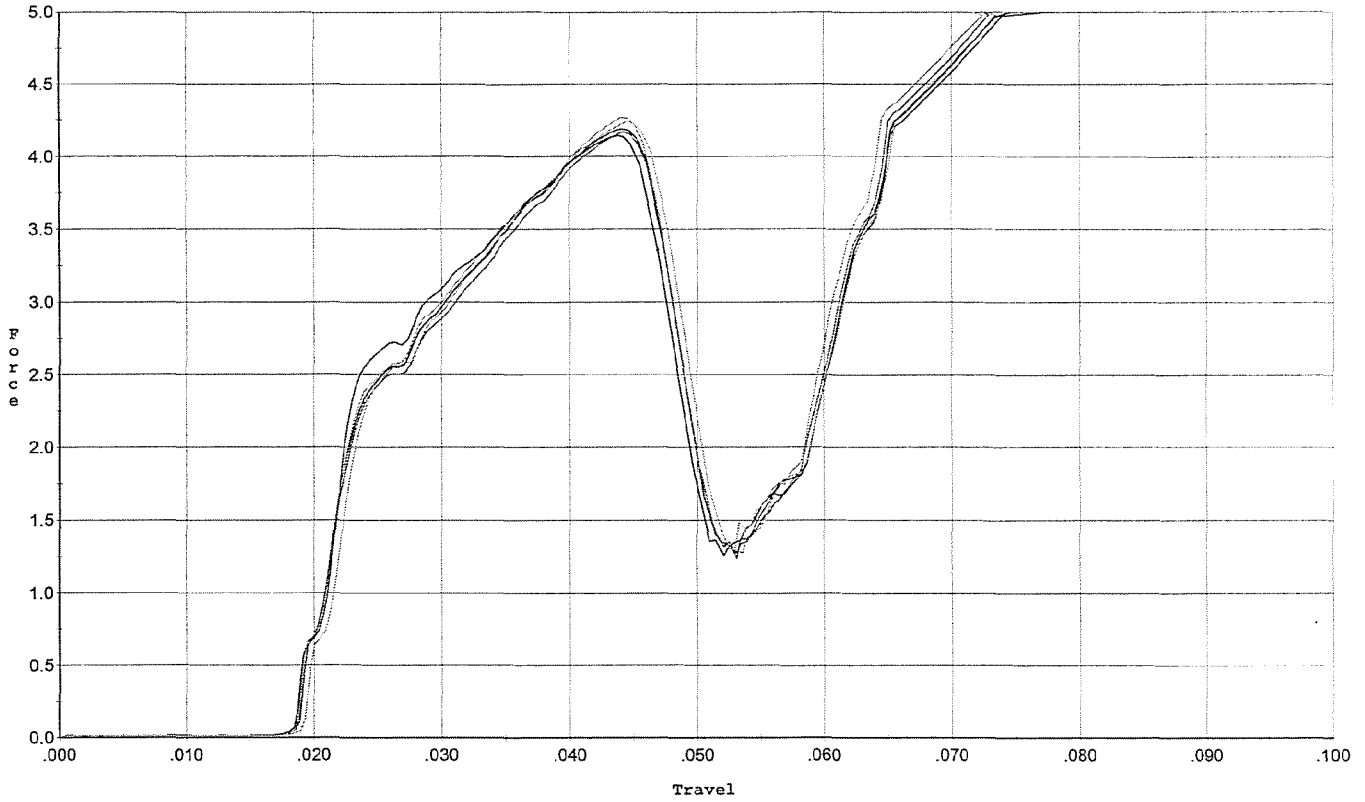
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.629      | 0.047             | 0.021           | 0.033      | 0.052             |           | Set Trigger |
| 2 | 2.685      | 0.047             | 0.020           | 0.033      | 0.052             |           | Set Trigger |
| 3 | 2.715      | 0.046             | 0.020           | 0.033      | 0.052             |           | Set Trigger |
| 4 | 2.780      | 0.047             | 0.020           | 0.032      | 0.055             |           | Set Trigger |
| 5 | 2.644      | 0.047             | 0.020           | 0.033      | 0.052             |           | Set Trigger |

A-2-69

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/12/2009

**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 | 4.189      | 0.047             | 0.019           | 0.028      | 0.089             |           | Set Trigger |
| 2 | 4.145      | 0.047             | 0.019           | 0.029      | 0.086             |           | Set Trigger |
| 3 | 4.169      | 0.047             | 0.019           | 0.028      | 0.086             |           | Set Trigger |
| 4 | 4.243      | 0.048             | 0.019           | 0.028      | 0.088             |           | Set Trigger |
| 5 | 4.268      | 0.047             | 0.019           | 0.028      | 0.088             |           | Set Trigger |

A-4-20