

G6863611

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

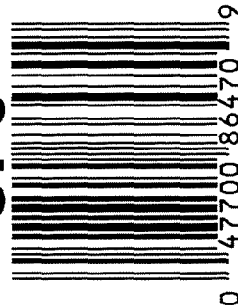
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6863611**

**UPC**



M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863611

| OP # | OPERATION NAME                                                                                                                         | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                       | 6-10-09 | SP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                       | 6-10-09 | SP      |
| 440  | PROOF                                                                                                                                  |                       | 6-10-09 | K.H.D.  |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX          | 6-10-09 | RP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    | JUN 2 2009            | 6-10-09 | RP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                       | 6-11-09 | RIC     |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR <u>JD</u>    | 6/13/09 | JD      |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                       |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |                       | 6/16/09 | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                       | 6-11-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                       | 6/16/09 | K.H.D.  |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                       | 2/2     | ✓       |
| 545  | (BOLT)                                                                                                                                 |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                       | 7-8-09  | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                       | 7-8-09  | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO | 7-8-09  | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                       | 3-25-09 | X.H.    |
|      | 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

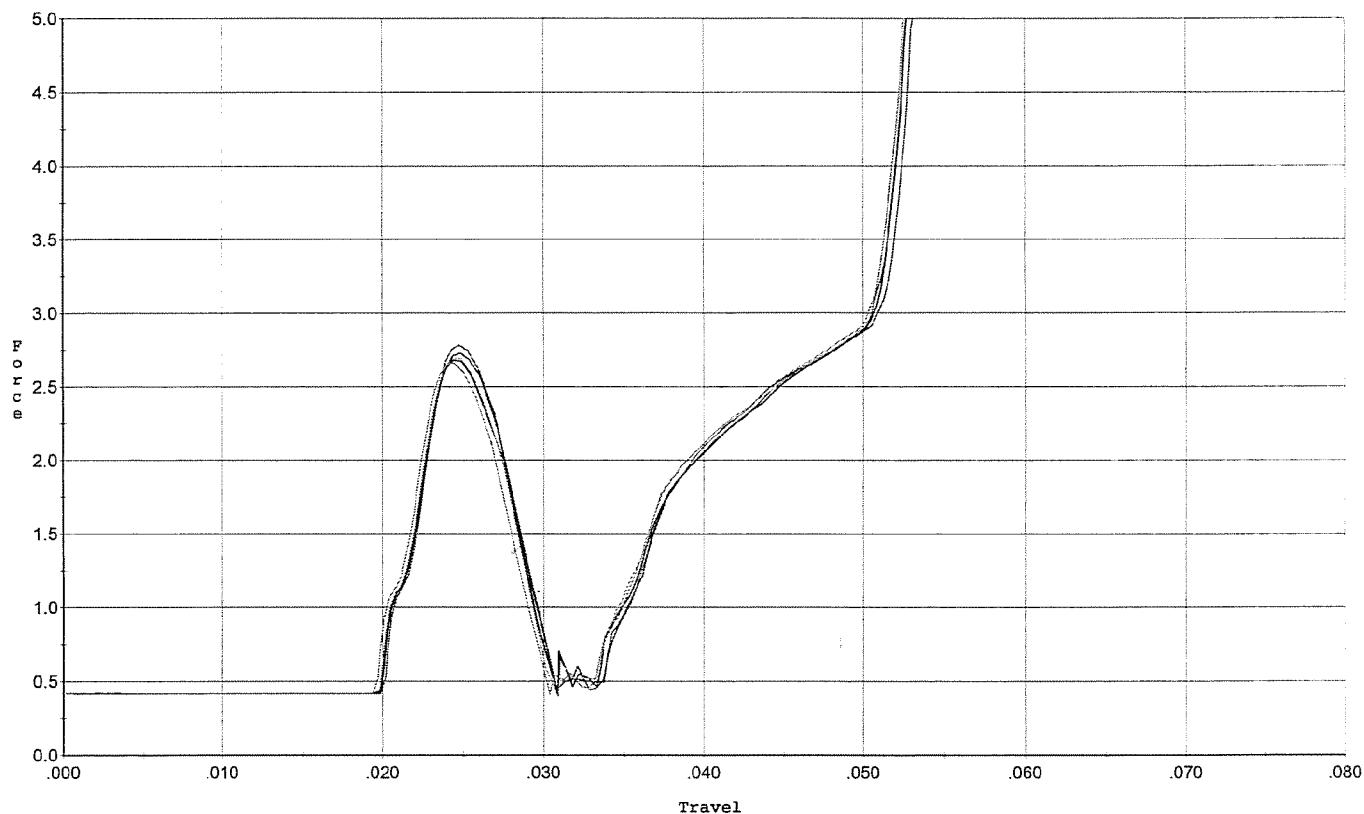
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>2.9</u> <u>2.9</u> <u>2.9</u>                            | 8/27/09 | RB      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>6.9</u> <u>6.9</u> <u>6.9</u>                            | 8/27/09 | RB      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 8/27/09 | RR      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 8-28-09 | RR      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 8/27/09 | 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                                              | <u>PASS</u> FAIL<br><u>PASS</u> FAIL                        | 8-26-09 | RR      |
|              | MALFUNCTION                                                              | CORRECTION                                                  | N/A     |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 8-26-09 | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 8/27/09 | RB      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.44</u> <u>2.44</u> <u>2.56</u> <u>2.50</u> <u>2.50</u> | 8/27/09 | RR      |
|              | C) FUNCTION                                                              |                                                             | 8/27/09 | RB      |
| 690          | PACK                                                                     |                                                             | 8-28-09 | TC      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/24/2009

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



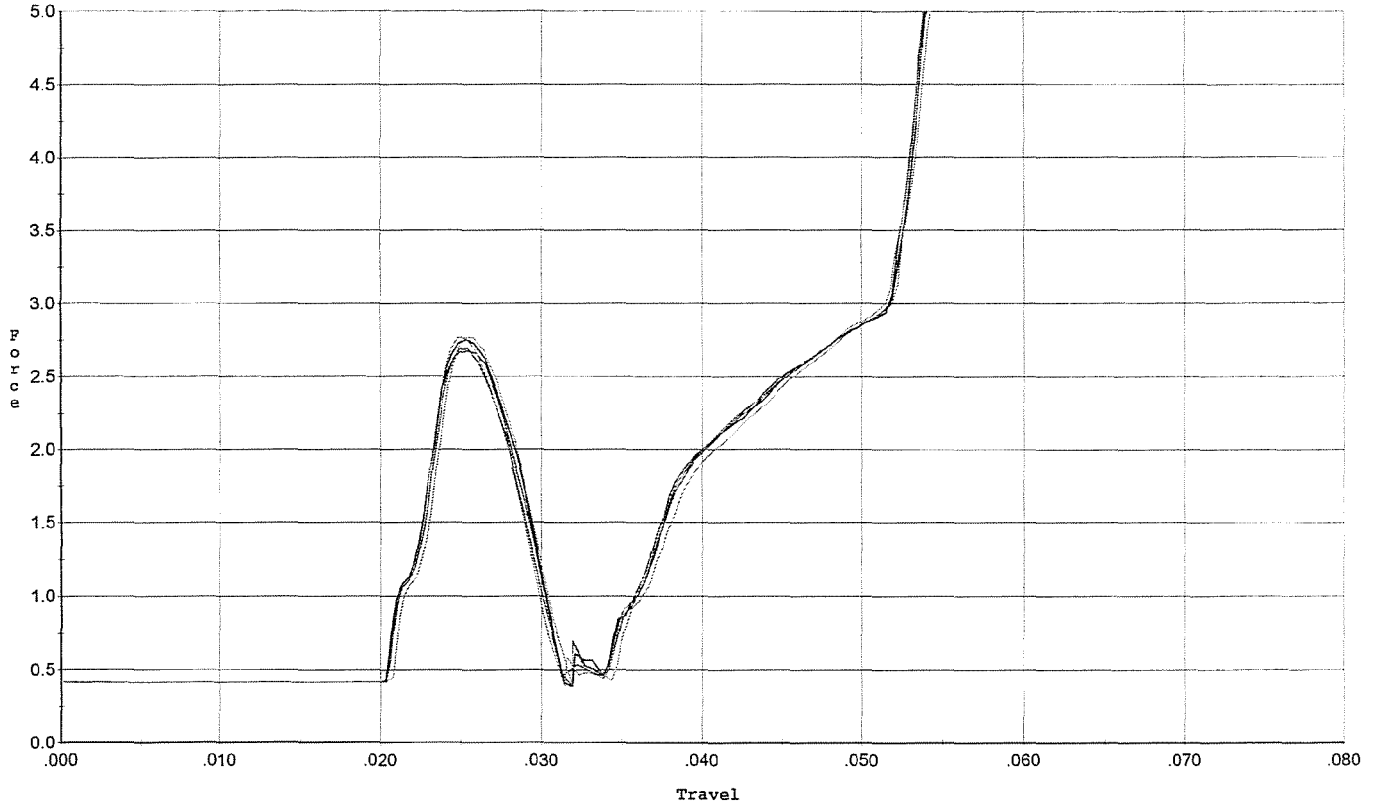
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.729      | 0.027             | 0.020           | 0.031      | 0.024             |           | Set Trigger |
| 2 | 2.682      | 0.027             | 0.020           | 0.031      | 0.024             |           | Set Trigger |
| 3 | 2.783      | 0.027             | 0.020           | 0.032      | 0.024             |           | Set Trigger |
| 4 | 2.693      | 0.027             | 0.020           | 0.031      | 0.024             |           | Set Trigger |
| 5 | 2.663      | 0.027             | 0.020           | 0.032      | 0.023             |           | Set Trigger |

A-2-71

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/24/2009

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



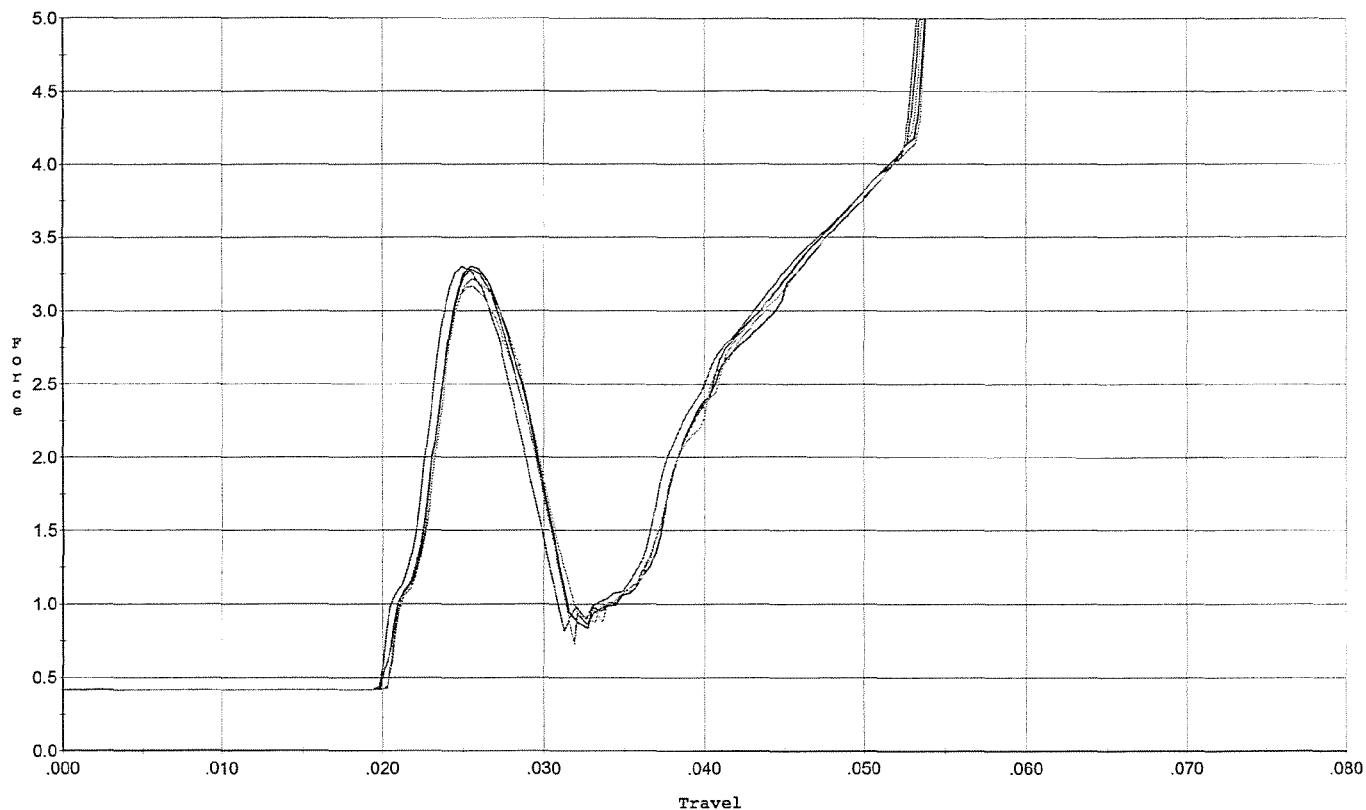
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.674      | 0.029             | 0.021           | 0.032      | 0.026             |           | Set Trigger |
| 2 | 2.753      | 0.029             | 0.021           | 0.032      | 0.026             |           | Set Trigger |
| 3 | 2.690      | 0.028             | 0.021           | 0.032      | 0.024             |           | Set Trigger |
| 4 | 2.765      | 0.028             | 0.021           | 0.032      | 0.025             |           | Set Trigger |
| 5 | 2.764      | 0.028             | 0.021           | 0.032      | 0.025             |           | Set Trigger |

A-2-72

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/24/2009

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



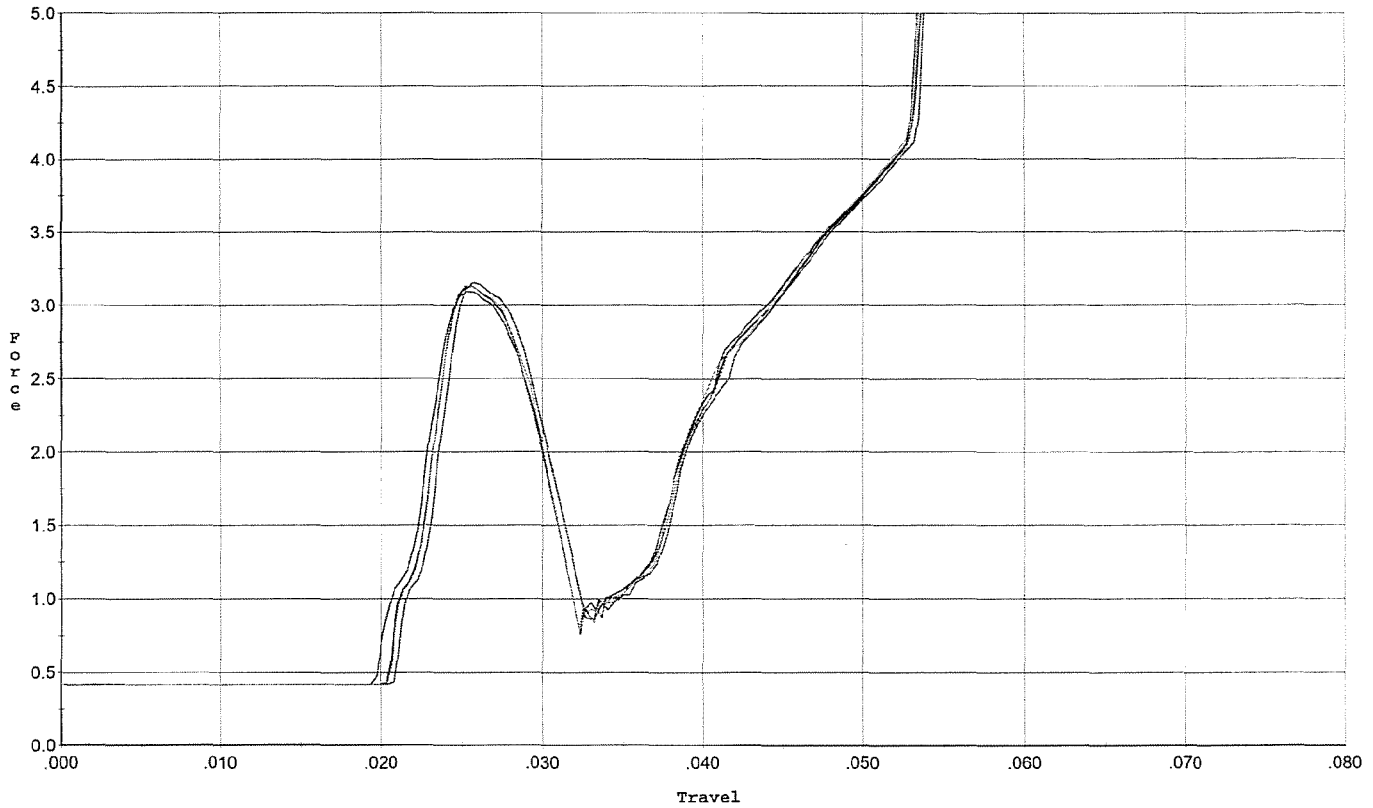
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.284      | 0.029             | 0.020           | 0.026      | 0.030             |           | Set Trigger |
| 2 | 3.303      | 0.029             | 0.021           | 0.026      | 0.030             |           | Set Trigger |
| 3 | 3.303      | 0.029             | 0.020           | 0.026      | 0.030             |           | Set Trigger |
| 4 | 3.162      | 0.029             | 0.021           | 0.026      | 0.029             |           | Set Trigger |
| 5 | 3.217      | 0.028             | 0.021           | 0.027      | 0.029             |           | Set Trigger |

A-3-25

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/24/2009

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 | 3.092      | 0.030             | 0.020           | 0.026      | 0.031             |           | Set Trigger |
| 2 | 3.126      | 0.030             | 0.021           | 0.026      | 0.031             |           | Set Trigger |
| 3 | 3.153      | 0.031             | 0.021           | 0.025      | 0.032             |           | Set Trigger |
| 4 | 3.128      | 0.029             | 0.021           | 0.026      | 0.030             |           | Set Trigger |
| 5 | 3.132      | 0.030             | 0.021           | 0.025      | 0.031             |           | Set Trigger |

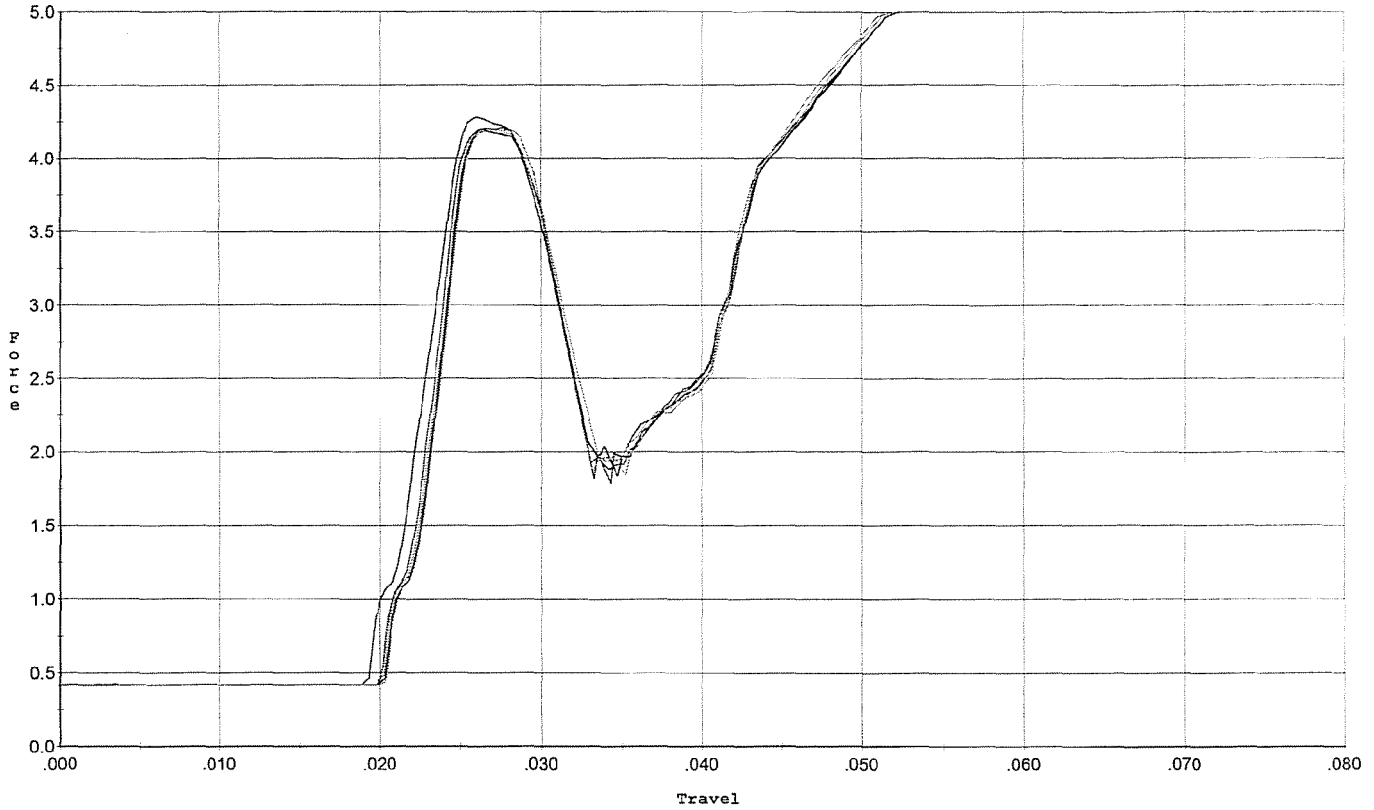
A 3-12



# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/24/2009

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



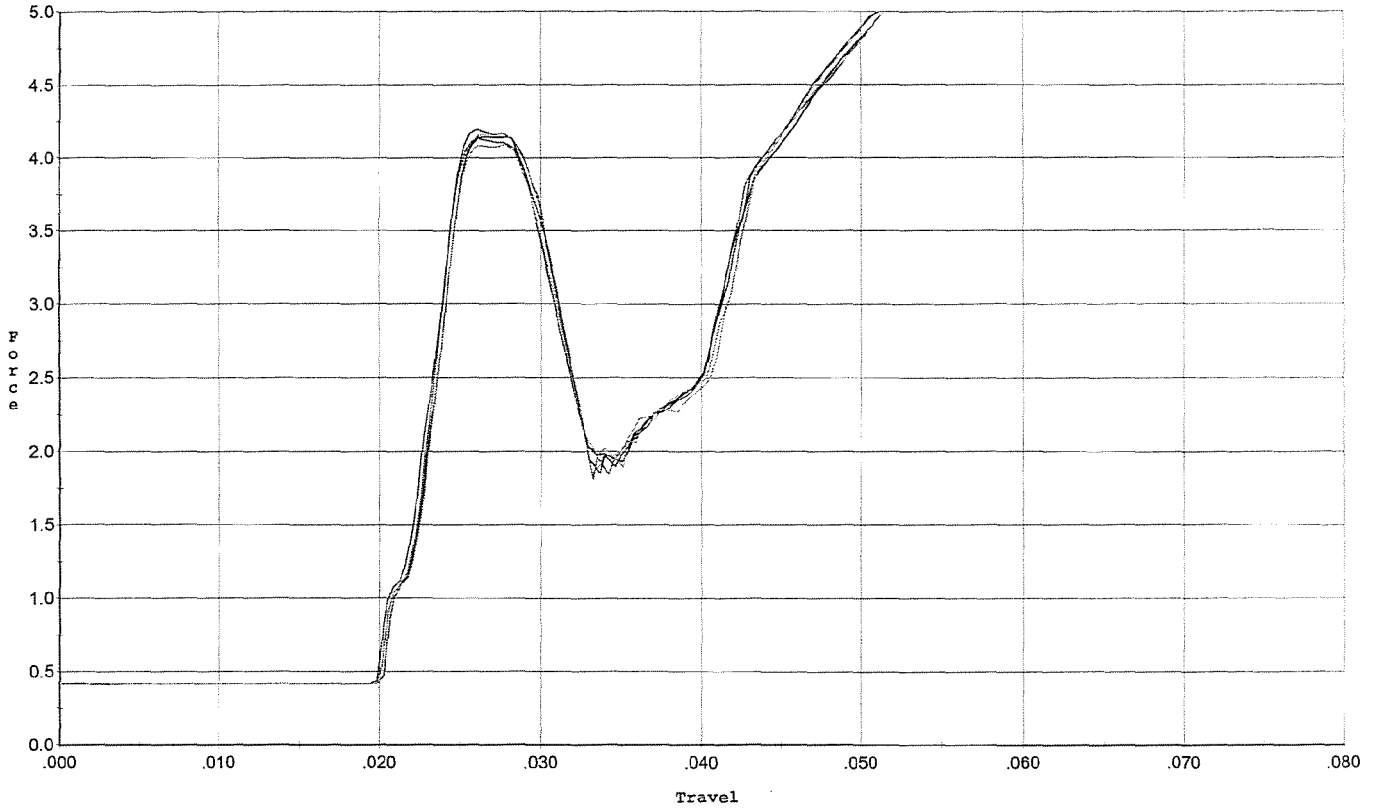
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.285      | 0.030             | 0.020           | 0.023      | 0.044             |           | Set Trigger |
| 2 | 4.190      | 0.030             | 0.021           | 0.024      | 0.041             |           | Set Trigger |
| 3 | 4.209      | 0.030             | 0.020           | 0.023      | 0.042             |           | Set Trigger |
| 4 | 4.201      | 0.030             | 0.021           | 0.024      | 0.040             |           | Set Trigger |
| 5 | 4.188      | 0.030             | 0.020           | 0.023      | 0.041             |           | Set Trigger |

A-4-21

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/24/2009

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



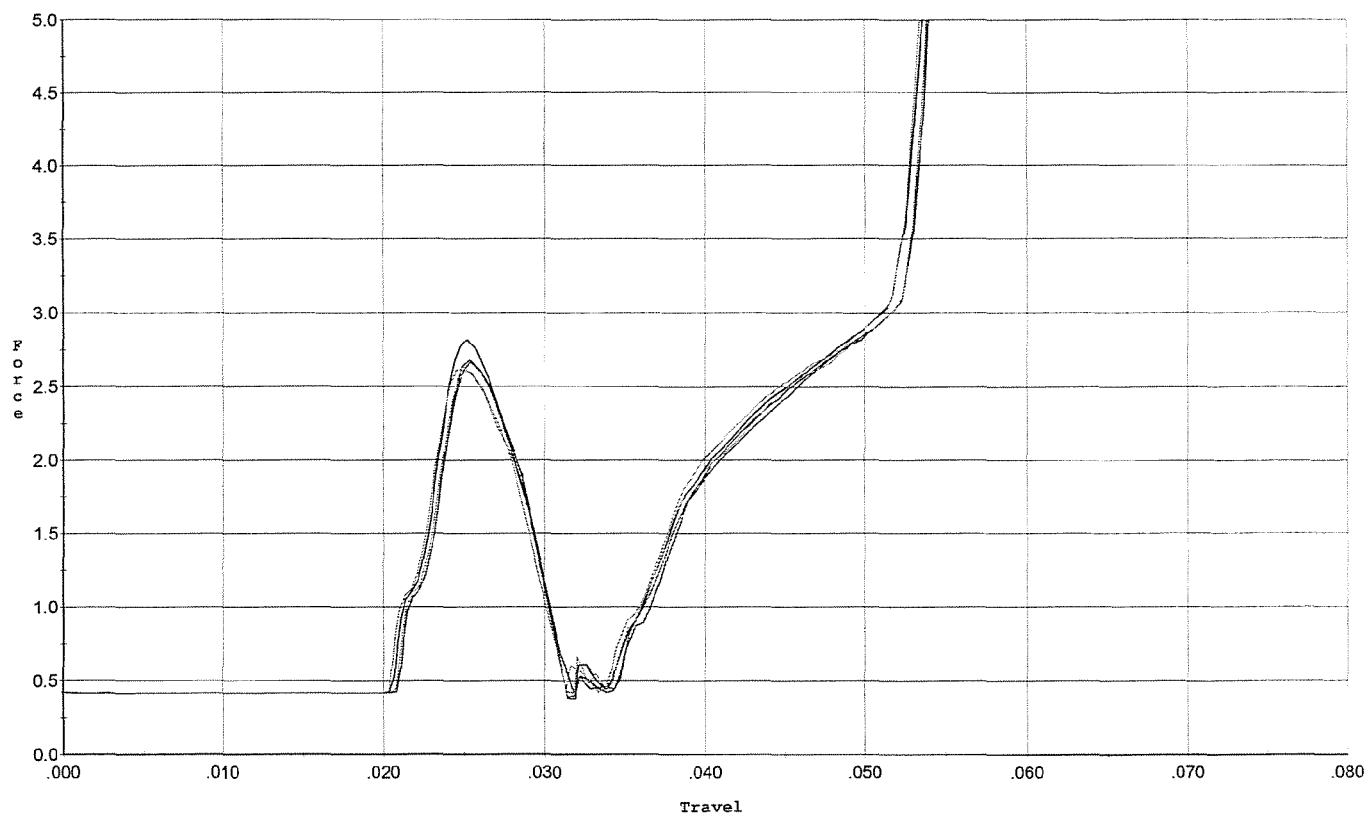
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.199      | 0.029             | 0.020           | 0.023      | 0.040             |           | Set Trigger |
| 2 | 4.147      | 0.030             | 0.020           | 0.023      | 0.041             |           | Set Trigger |
| 3 | 4.134      | 0.030             | 0.020           | 0.023      | 0.042             |           | Set Trigger |
| 4 | 4.159      | 0.030             | 0.020           | 0.023      | 0.041             |           | Set Trigger |
| 5 | 4.091      | 0.031             | 0.020           | 0.023      | 0.042             |           | Set Trigger |

A. 4.14

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** cms 8/24/2009

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



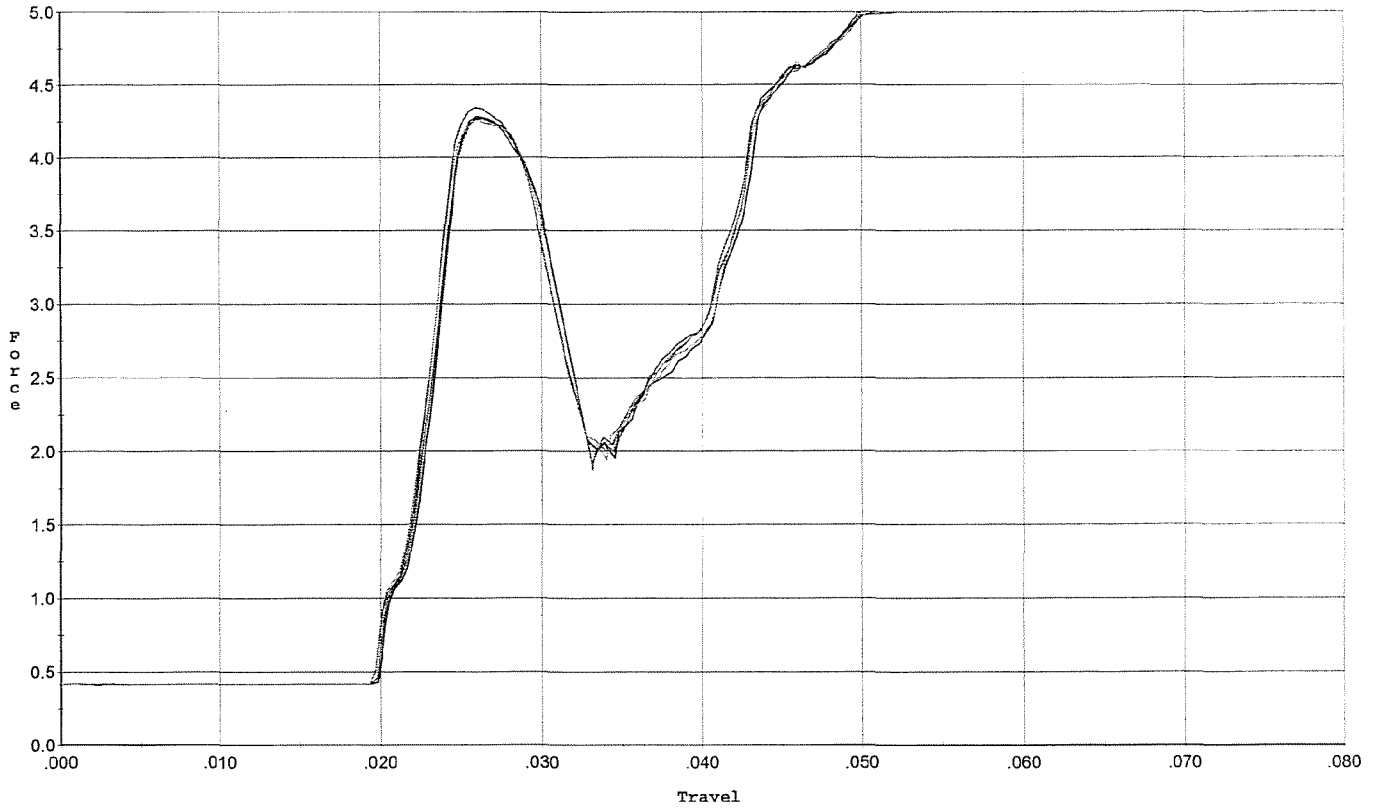
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.668      | 0.029             | 0.021           | 0.032      | 0.024             |           | Set Trigger |
| 2 | 2.818      | 0.029             | 0.021           | 0.031      | 0.026             |           | Set Trigger |
| 3 | 2.680      | 0.029             | 0.021           | 0.031      | 0.025             |           | Set Trigger |
| 4 | 2.603      | 0.028             | 0.021           | 0.032      | 0.023             |           | Set Trigger |
| 5 | 2.631      | 0.028             | 0.021           | 0.031      | 0.024             |           | Set Trigger |

A2.68

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/24/2009

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 | 4.281      | 0.029             | 0.020           | 0.023      | 0.040             |           | Set Trigger |
| 2 | 4.268      | 0.030             | 0.020           | 0.023      | 0.042             |           | Set Trigger |
| 3 | 4.345      | 0.029             | 0.020           | 0.023      | 0.041             |           | Set Trigger |
| 4 | 4.263      | 0.030             | 0.020           | 0.023      | 0.043             |           | Set Trigger |
| 5 | 4.259      | 0.029             | 0.020           | 0.023      | 0.041             |           | Set Trigger |

A-4.28