

G6810422

**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



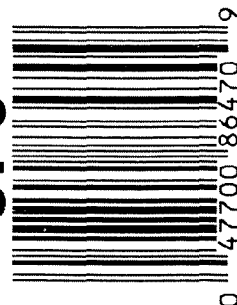
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6810422**

**UPC**



**BM FORM**

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6810422

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 2-9-09  | SP      |
| 430  | ASSEMBLE TO STOCK                                              |                     | 2-9-09  | SP      |
| 440  | PROOF                                                          |                     | 2-9-09  | SP      |
| 460  | CHECK HEADSPACE                                                |                     | 2-9-09  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 2-9-09  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                          | MAGNA - FLUX        | 2-9-09  | RT      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 2-10-09 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR (H)        | 2/13/09 | (H)     |
| 490  | MAGNAFLUX BOLT                                                 |                     | 2/13/09 | MR      |
| 500  | ROLLMARK CALIBER                                               |                     | 2/13/09 | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 2/16/09 | DC      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 2/18    |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 2-18-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 2-18-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 2-18-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 2-18-09 | SP      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

F004 REV 5/2006

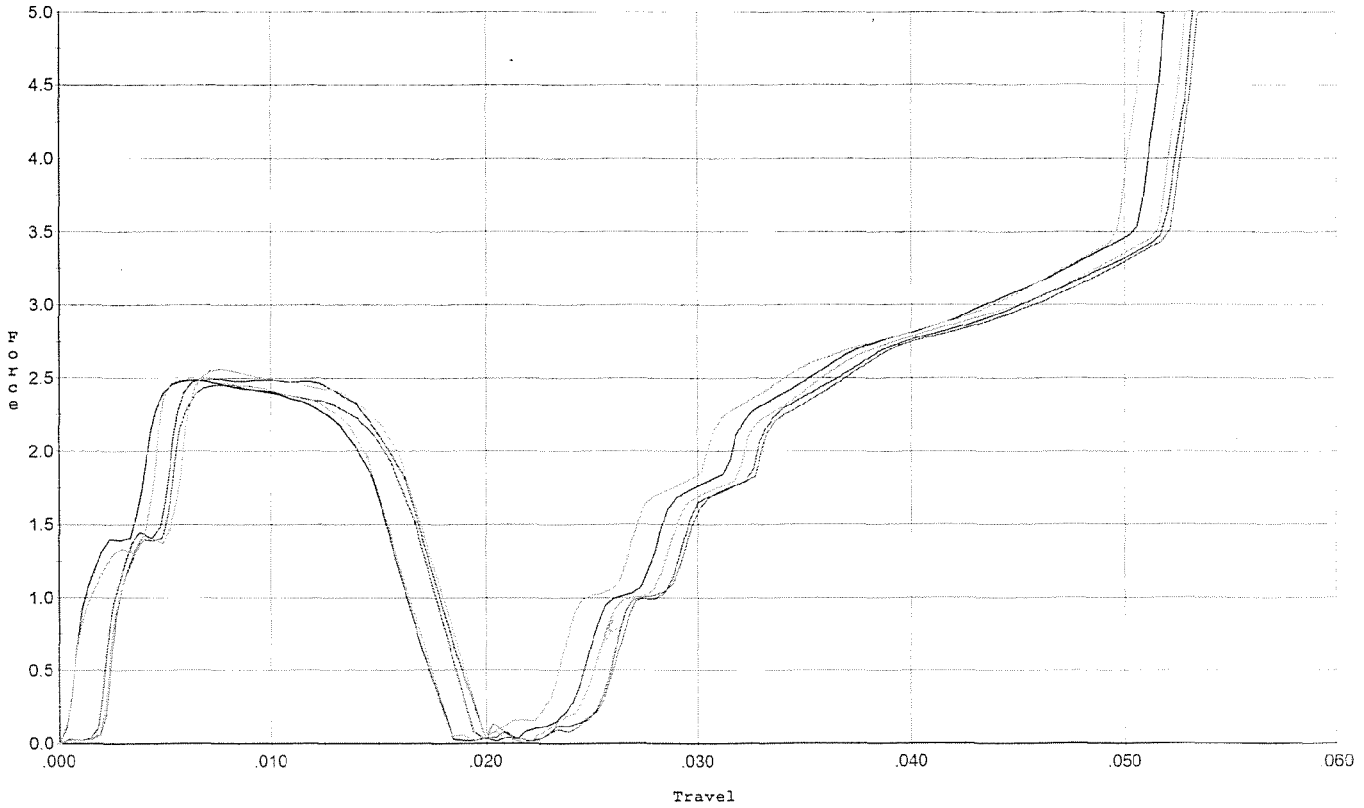
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>7</u> <u>6.5</u> <u>7</u>                                | 3-2-09  | W W     |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.5</u> <u>5</u> <u>5</u>                                | 3-2-09  | W W     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 3-2-09  | W W     |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 2-18-09 | S.P.N.  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-2-09  | W W     |
|              | 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                        | 2-20-09 | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-20-09 | W W     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-2-09  | W W     |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.44</u> <u>2.58</u> <u>2.34</u> <u>2.45</u> <u>2.58</u> | 2-23-09 | W W     |
|              | C) FUNCTION                                                              |                                                             | 3-2-09  | W W     |
| 690          | PACK                                                                     |                                                             | 3/5/09  | FM      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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



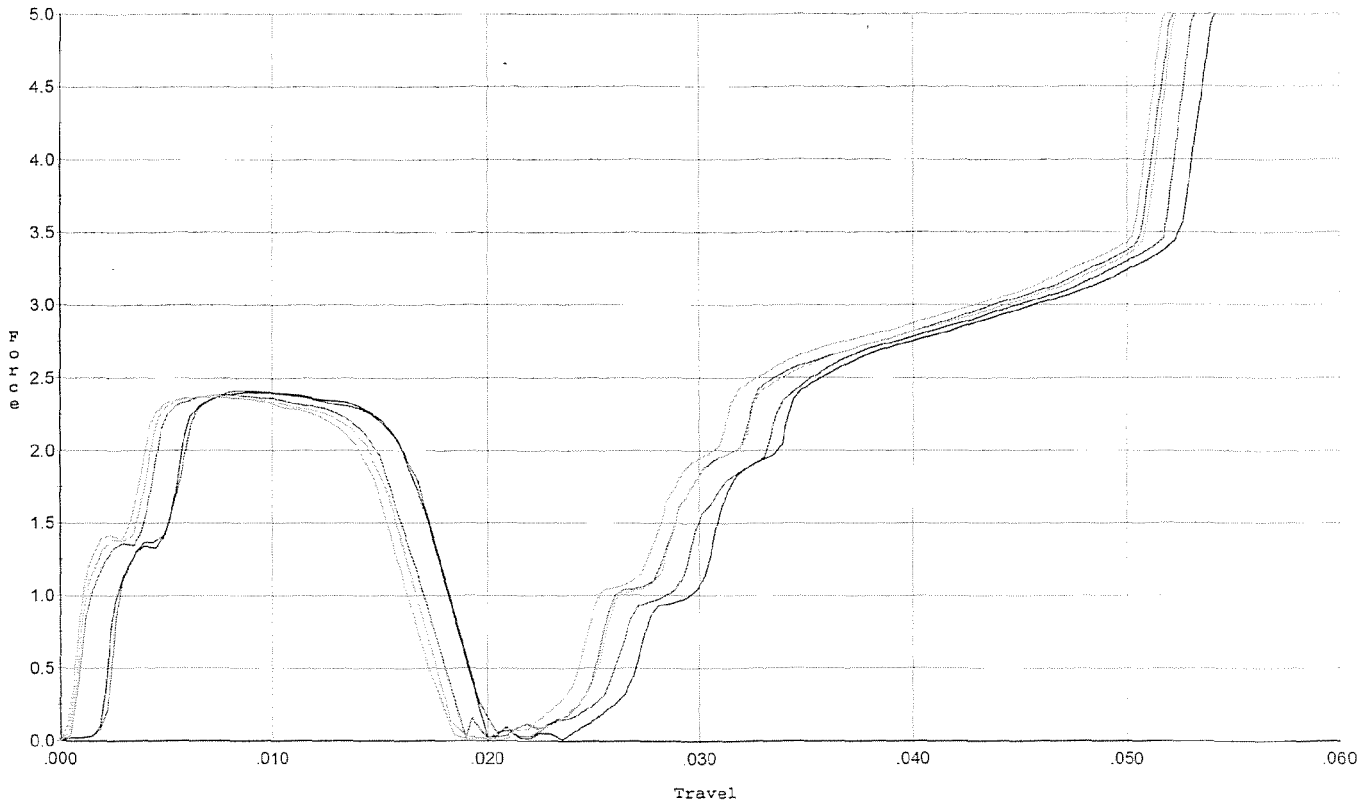
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.489      | 0.016             | 0.00            | 0.040      | 0.028             |           | Set Trigger |
| 2 | 2.485      | 0.015             | 0.00            | 0.040      | 0.027             |           | Set Trigger |
| 3 | 2.453      | 0.017             | 0.002           | 0.040      | 0.028             |           | Set Trigger |
| 4 | 2.561      | 0.018             | 0.00            | 0.039      | 0.030             |           | Set Trigger |
| 5 | 2.496      | 0.015             | 0.00            | 0.039      | 0.026             |           | Set Trigger |

A-2-49

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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



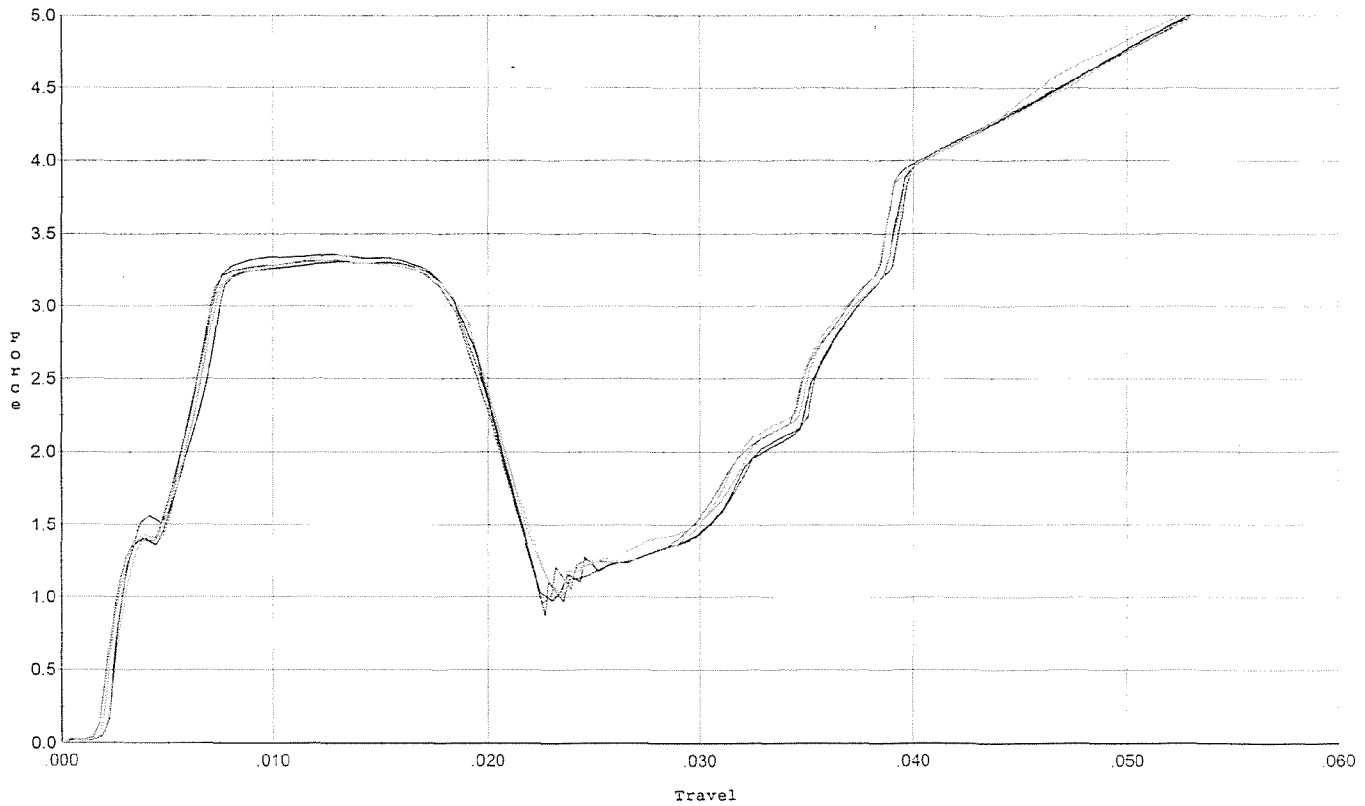
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.412      | 0.017             | 0.00            | 0.039      | 0.028             |           | Set Trigger |
| 2 | 2.399      | 0.017             | 0.00            | 0.040      | 0.029             |           | Set Trigger |
| 3 | 2.383      | 0.017             | 0.00            | 0.039      | 0.030             |           | Set Trigger |
| 4 | 2.375      | 0.015             | 0.00            | 0.040      | 0.028             |           | Set Trigger |
| 5 | 2.367      | 0.015             | 0.00            | 0.040      | 0.027             |           | Set Trigger |

A-2-38

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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



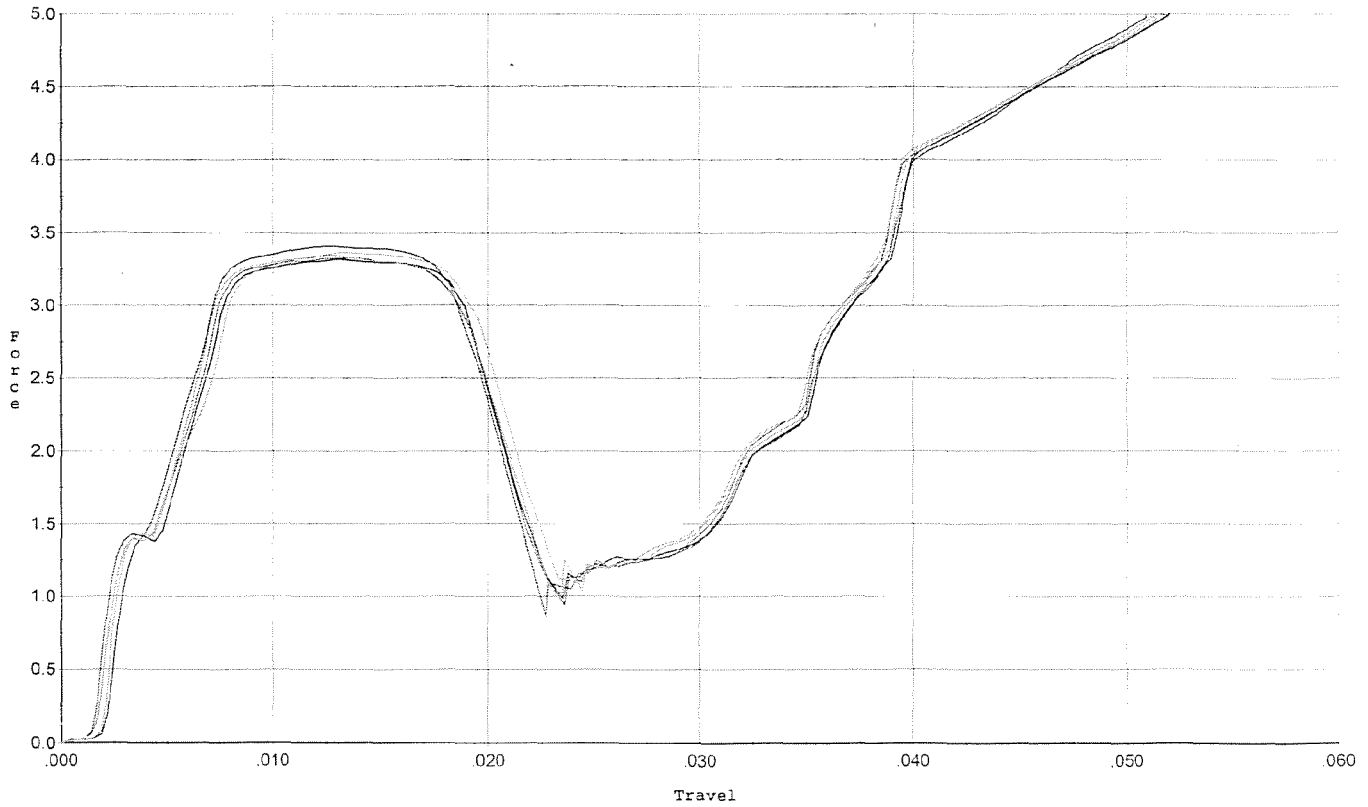
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.356      | 0.020             | 0.002           | 0.037      | 0.046             |           | Set Trigger |
| 2 | 3.301      | 0.019             | 0.002           | 0.037      | 0.044             |           | Set Trigger |
| 3 | 3.312      | 0.020             | 0.00            | 0.037      | 0.046             |           | Set Trigger |
| 4 | 3.354      | 0.019             | 0.00            | 0.037      | 0.044             |           | Set Trigger |
| 5 | 3.317      | 0.019             | 0.00            | 0.037      | 0.044             |           | Set Trigger |

A-332

# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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 | 3.407      | 0.020             | 0.00            | 0.037      | 0.047             |           | Set Trigger |
| 2 | 3.317      | 0.019             | 0.002           | 0.037      | 0.043             |           | Set Trigger |
| 3 | 3.325      | 0.019             | 0.00            | 0.036      | 0.045             |           | Set Trigger |
| 4 | 3.363      | 0.020             | 0.00            | 0.036      | 0.046             |           | Set Trigger |
| 5 | 3.344      | 0.019             | 0.00            | 0.036      | 0.044             |           | Set Trigger |

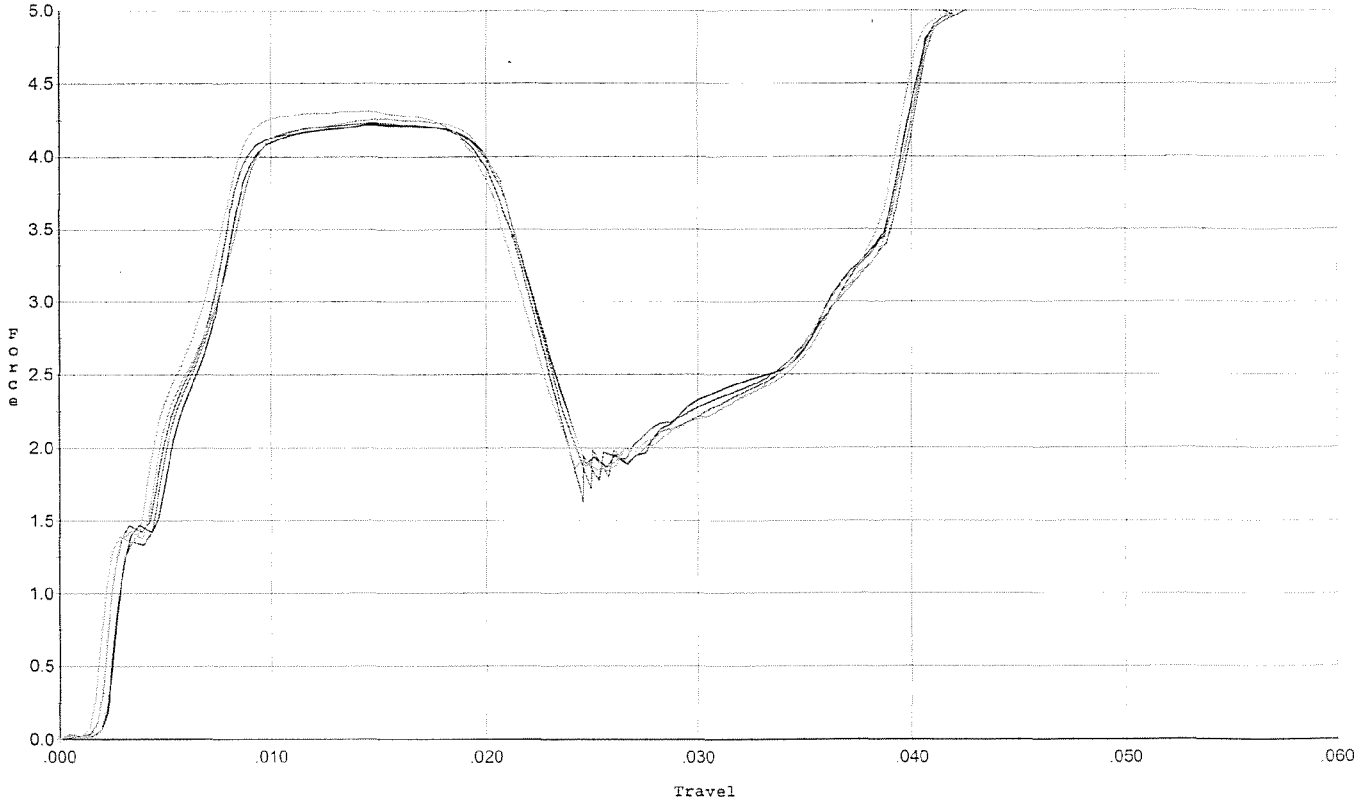
A-3.35



# Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

Model: M/24  
Serial No: Form #F005  
Trigger: 4.0 lbs ini +/- .20 lb



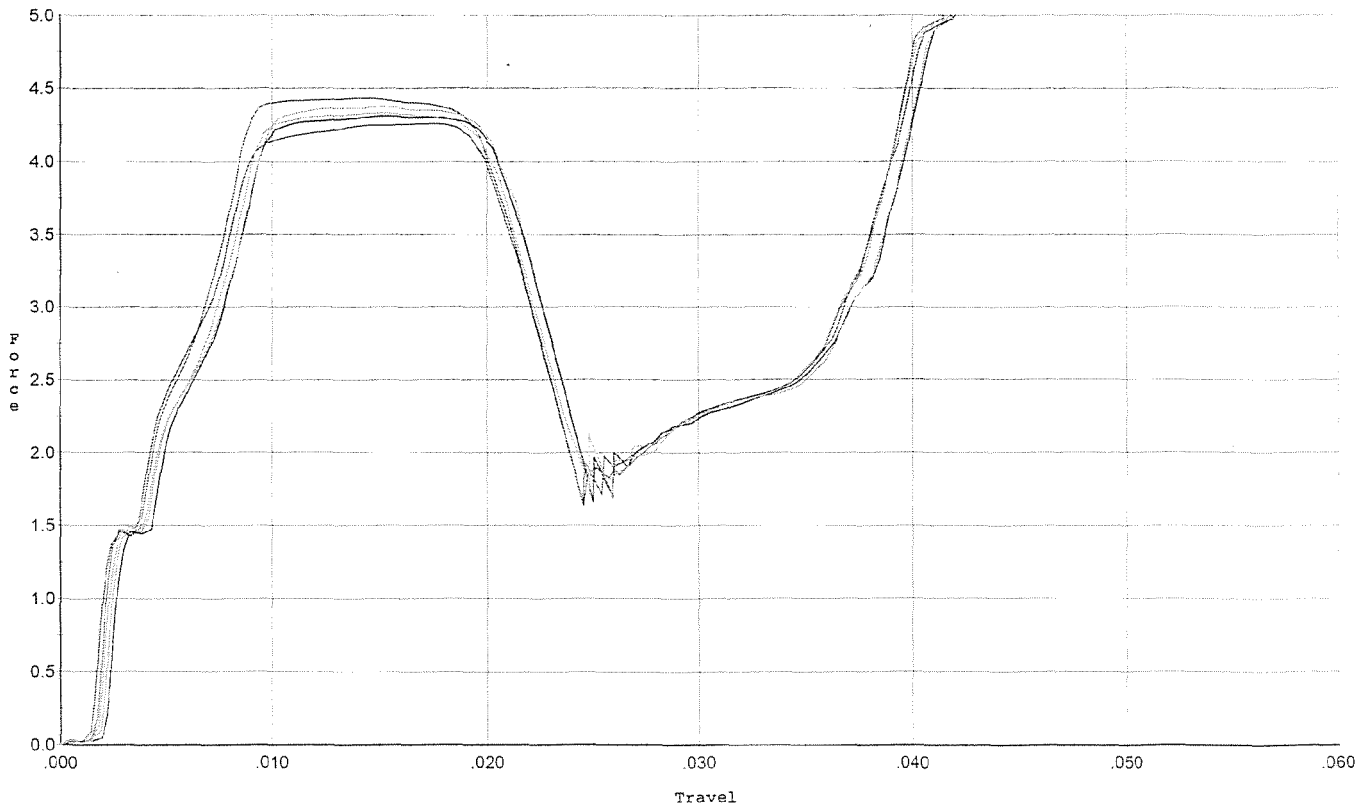
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.218      | 0.021             | 0.00            | 0.030      | 0.061             |           | Set Trigger |
| 2 | 4.227      | 0.021             | 0.002           | 0.030      | 0.059             |           | Set Trigger |
| 3 | 4.234      | 0.021             | 0.002           | 0.030      | 0.059             |           | Set Trigger |
| 4 | 4.312      | 0.020             | 0.00            | 0.031      | 0.060             |           | Set Trigger |
| 5 | 4.258      | 0.021             | 0.00            | 0.030      | 0.060             |           | Set Trigger |

A. 4.25

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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



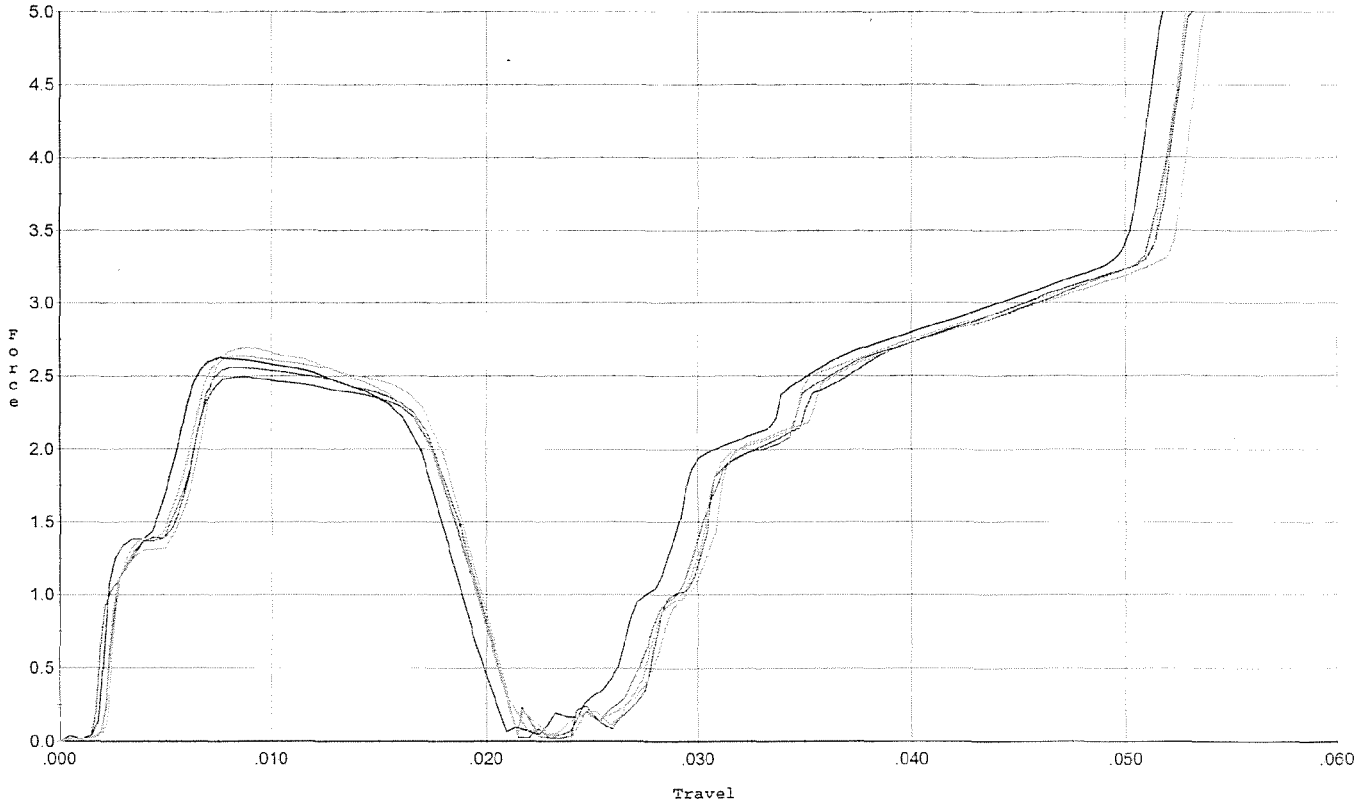
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.261      | 0.021             | 0.00            | 0.031      | 0.064             |           | Set Trigger |
| 2 | 4.313      | 0.022             | 0.002           | 0.031      | 0.063             |           | Set Trigger |
| 3 | 4.434      | 0.021             | 0.00            | 0.031      | 0.064             |           | Set Trigger |
| 4 | 4.333      | 0.021             | 0.00            | 0.031      | 0.061             |           | Set Trigger |
| 5 | 4.374      | 0.021             | 0.002           | 0.030      | 0.063             |           | Set Trigger |

A-434

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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



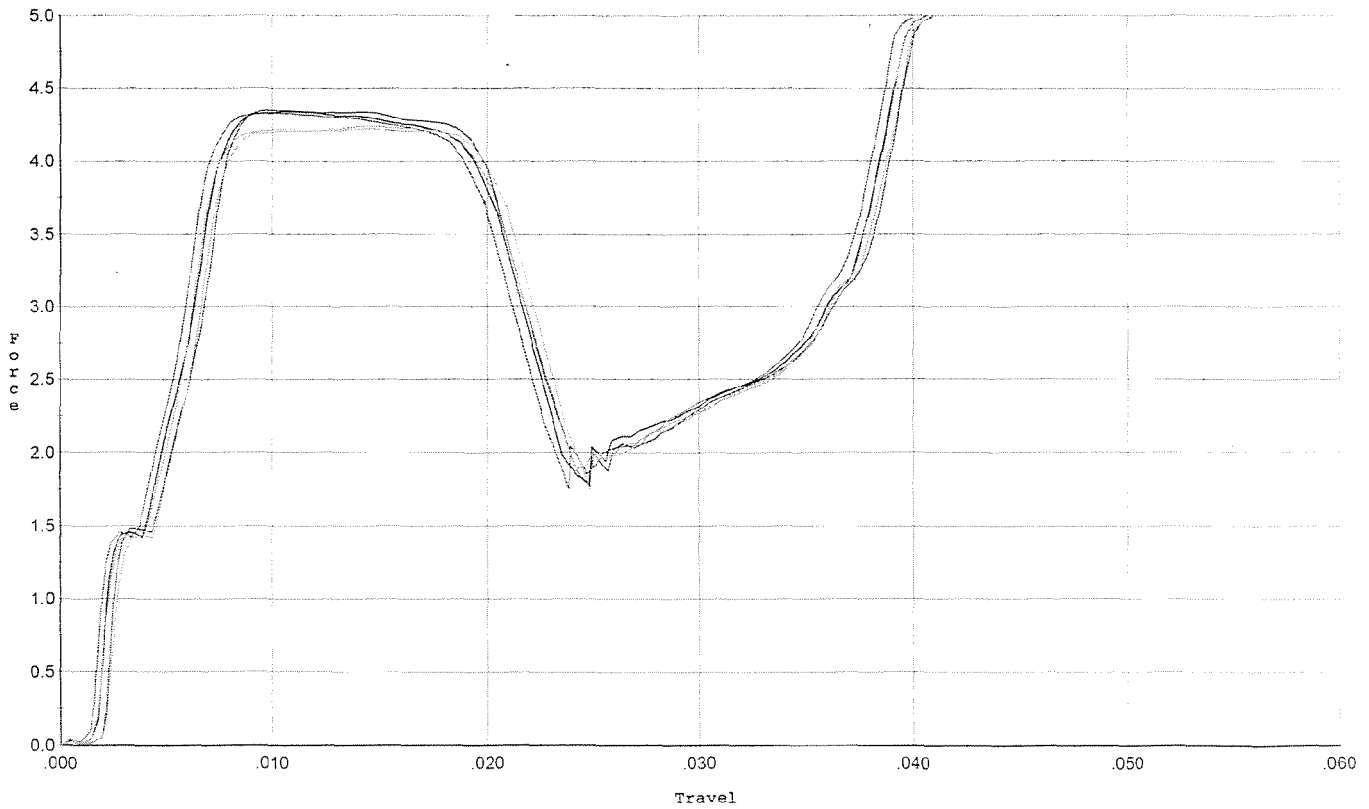
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.493      | 0.019             | 0.00            | 0.038      | 0.034             |           | Set Trigger |
| 2 | 2.624      | 0.017             | 0.00            | 0.038      | 0.031             |           | Set Trigger |
| 3 | 2.558      | 0.019             | 0.00            | 0.038      | 0.033             |           | Set Trigger |
| 4 | 2.693      | 0.019             | 0.00            | 0.038      | 0.034             |           | Set Trigger |
| 5 | 2.636      | 0.018             | 0.005           | 0.038      | 0.032             |           | Set Trigger |

A-2-60

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/16/2009

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 | 4.350      | 0.020             | 0.002           | 0.033      | 0.059             |           | Set Trigger |
| 2 | 4.339      | 0.020             | 0.00            | 0.032      | 0.061             |           | Set Trigger |
| 3 | 4.328      | 0.020             | 0.00            | 0.033      | 0.060             |           | Set Trigger |
| 4 | 4.226      | 0.021             | 0.002           | 0.033      | 0.061             |           | Set Trigger |
| 5 | 4.240      | 0.020             | 0.00            | 0.033      | 0.060             |           | Set Trigger |

A-429