

G6810457

**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



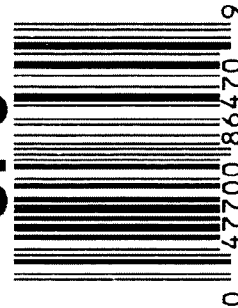
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6810457**

**UPC**



**BM FORM**

M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

06810457

| OP #            | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE     | INITIAL                                                                               |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|----------|---------------------------------------------------------------------------------------|
| 420             | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 2-5-09   | SP                                                                                    |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 2-5-09   | SP                                                                                    |
| 440             | PROOF                                                                                                                                  |                                                                                             | 2-5-09   | SP                                                                                    |
| 460             | CHECK HEADSPACE                                                                                                                        |                                                                                             | 2-5-09   | SP                                                                                    |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 2-5-09   | SP                                                                                    |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 2-6-09   | RT                                                                                    |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 2-6-09   | TS                                                                                    |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 2/7/09   |    |
| 490             | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 2/7/09   | MR                                                                                    |
| 500             | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 5/9/09   | RT                                                                                    |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 9-Feb-09 |   |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 2-11     |  |
| 545             | (BOLT)                                                                                                                                 |                                                                                             |          |                                                                                       |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |          |                                                                                       |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 2-11-09  | SP                                                                                    |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 2-11-09  | SP                                                                                    |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 2-11-09  | SP                                                                                    |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 2-11-09  | SP                                                                                    |
|                 | 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 |                                                                                                                                        |                                                                                             |          |                                                                                       |

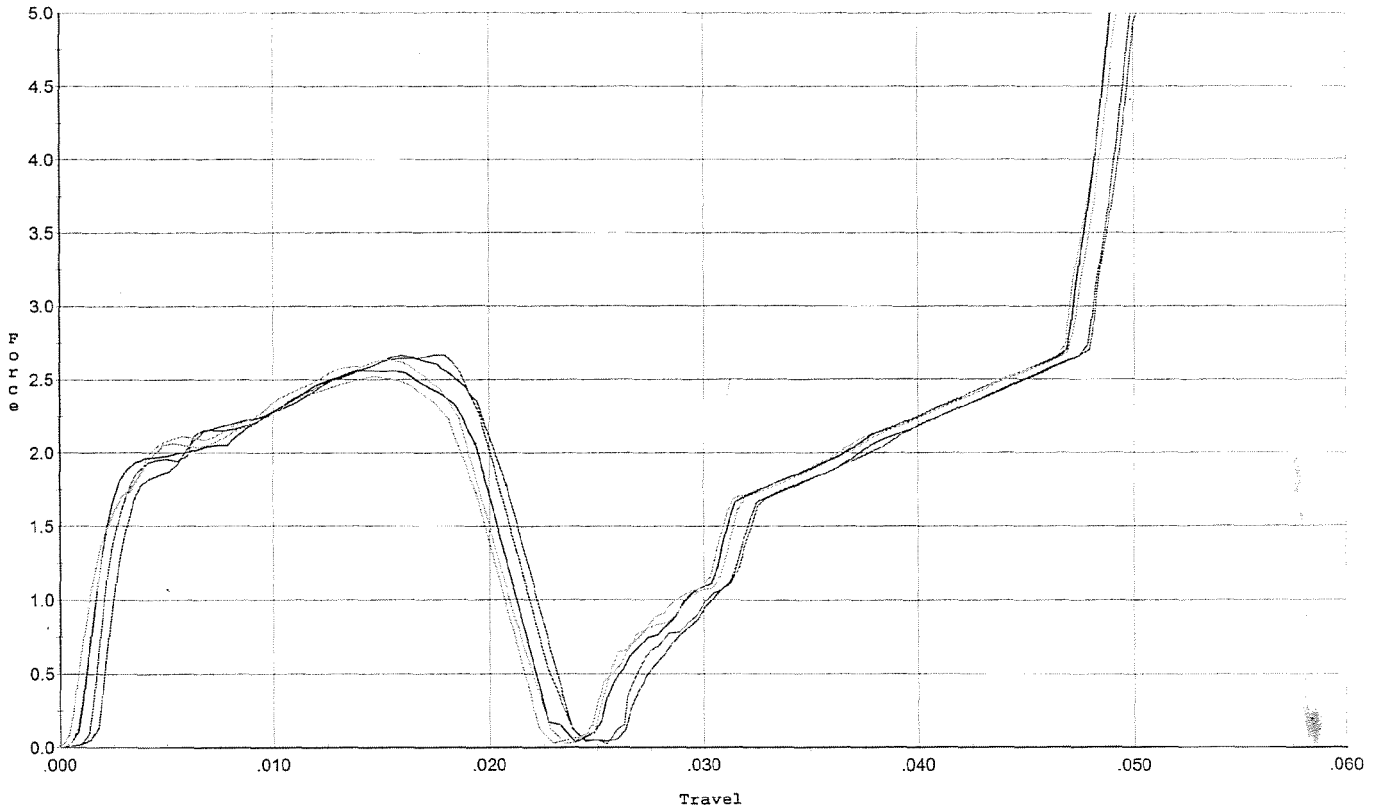
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.5</u> <u>6</u> <u>5.5</u>                              | 2-13-09 | WV      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4</u> <u>4</u> <u>4</u>                                  | 2-13-09 | WV      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.024</u>                         | 2-13-09 | WV      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 2-11-09 | SPD     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 2-13-09 | WV      |
|              | 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                        | 2-12-09 | TC      |
|              | MALFUNCTION                                                              | CORRECTION                                                  | n/A     |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-12-09 | WV      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 2-13-09 | WV      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.45</u> <u>2.52</u> <u>2.44</u> <u>2.47</u> <u>2.49</u> | 2-13-09 | WV      |
|              | C) FUNCTION                                                              |                                                             | 2-13-09 | WV      |
| 690          | PACK                                                                     |                                                             | 2/14/09 | FM      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 2/5/2009

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



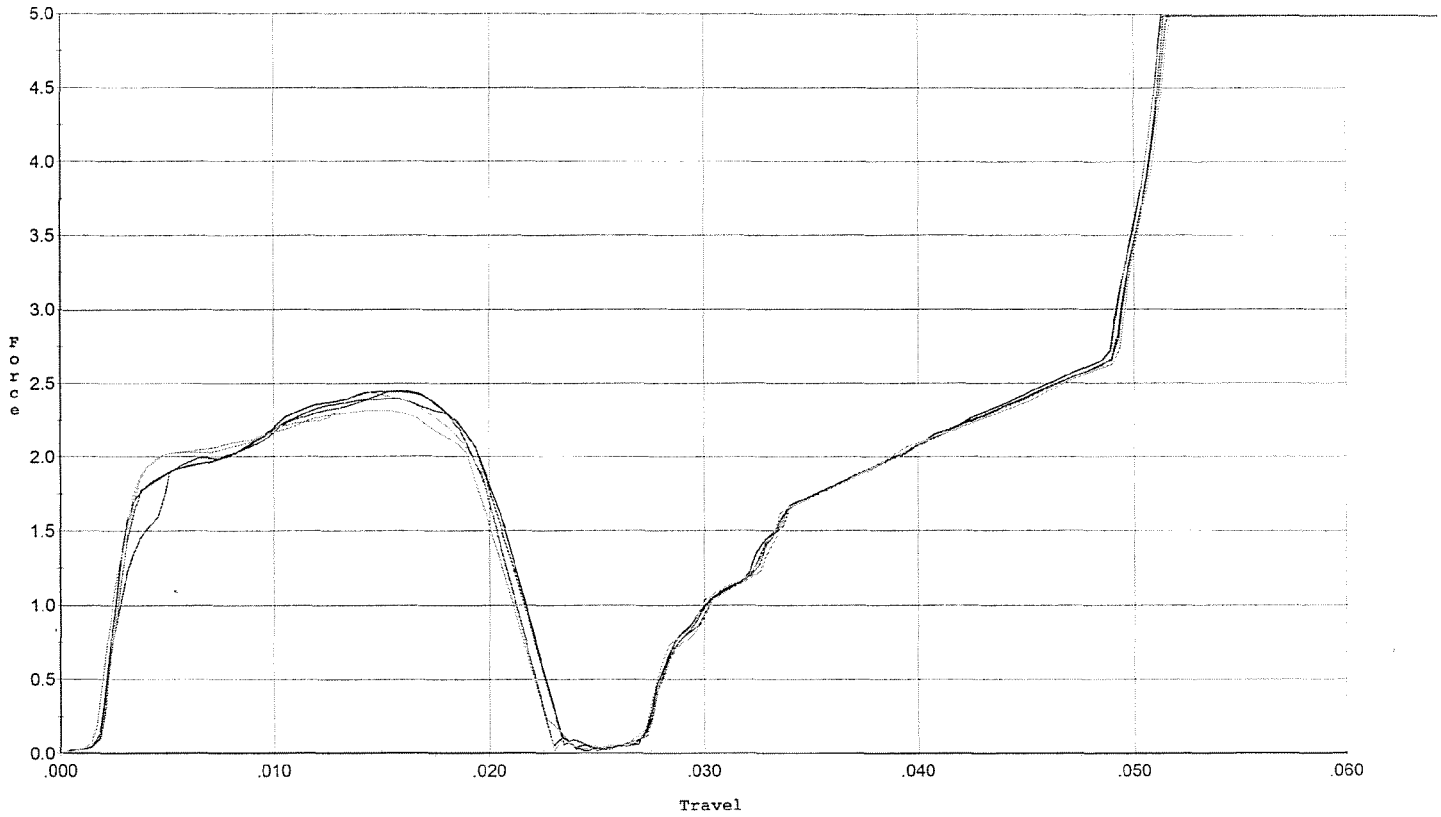
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.664      | 0.021             | 0.00            | 0.034      | 0.039             |           | Set Trigger |
| 2 | 2.562      | 0.019             | 0.00            | 0.034      | 0.037             |           | Set Trigger |
| 3 | 2.667      | 0.020             | 0.00            | 0.034      | 0.038             |           | Set Trigger |
| 4 | 2.631      | 0.019             | 0.00            | 0.035      | 0.036             |           | Set Trigger |
| 5 | 2.520      | 0.019             | 0.00            | 0.034      | 0.037             |           | Set Trigger |

A-2-60

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 2/5/2009

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



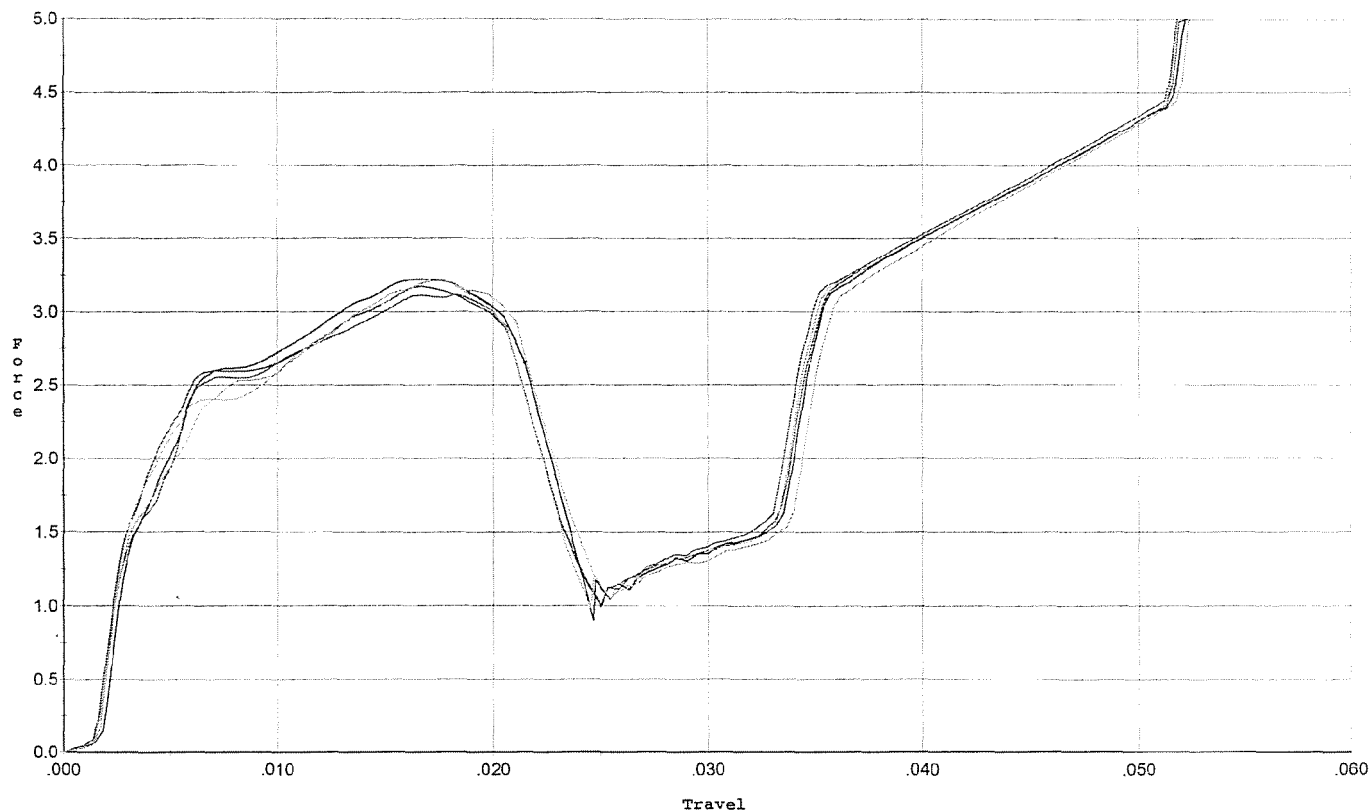
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.448      | 0.020             | 0.00            | 0.036      | 0.034             |           | Set Trigger |
| 2 | 2.444      | 0.021             | 0.00            | 0.036      | 0.037             |           | Set Trigger |
| 3 | 2.396      | 0.021             | 0.00            | 0.036      | 0.037             |           | Set Trigger |
| 4 | 2.315      | 0.021             | 0.00            | 0.037      | 0.036             |           | Set Trigger |
| 5 | 2.444      | 0.020             | 0.00            | 0.036      | 0.035             |           | Set Trigger |

A-2.40

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 2/5/2009

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



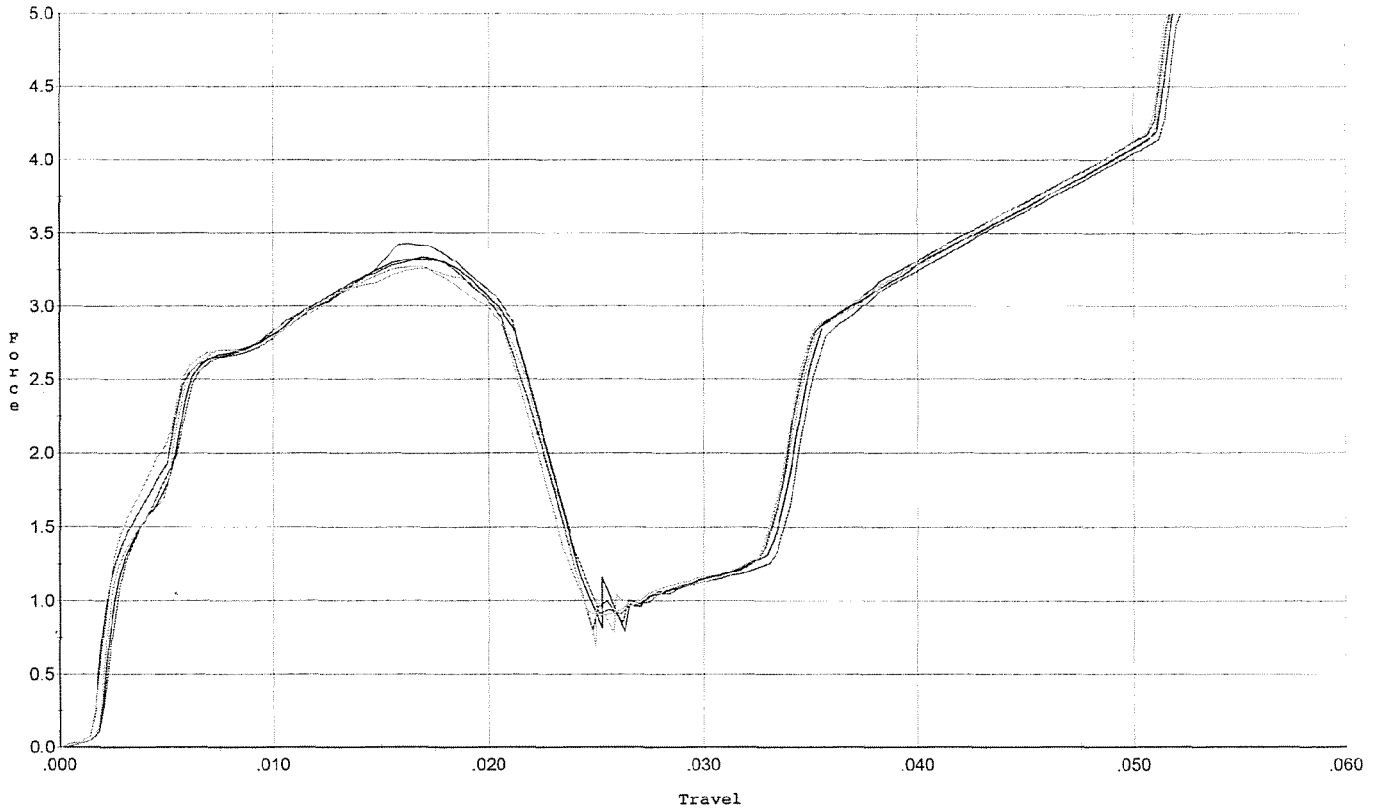
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.175      | 0.021             | 0.00            | 0.034      | 0.047             |           | Set Trigger |
| 2 | 3.223      | 0.021             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 3 | 3.118      | 0.021             | 0.00            | 0.034      | 0.046             |           | Set Trigger |
| 4 | 3.225      | 0.021             | 0.00            | 0.034      | 0.046             |           | Set Trigger |
| 5 | 3.209      | 0.021             | 0.00            | 0.034      | 0.047             |           | Set Trigger |

A-3-19

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 2/5/2009

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



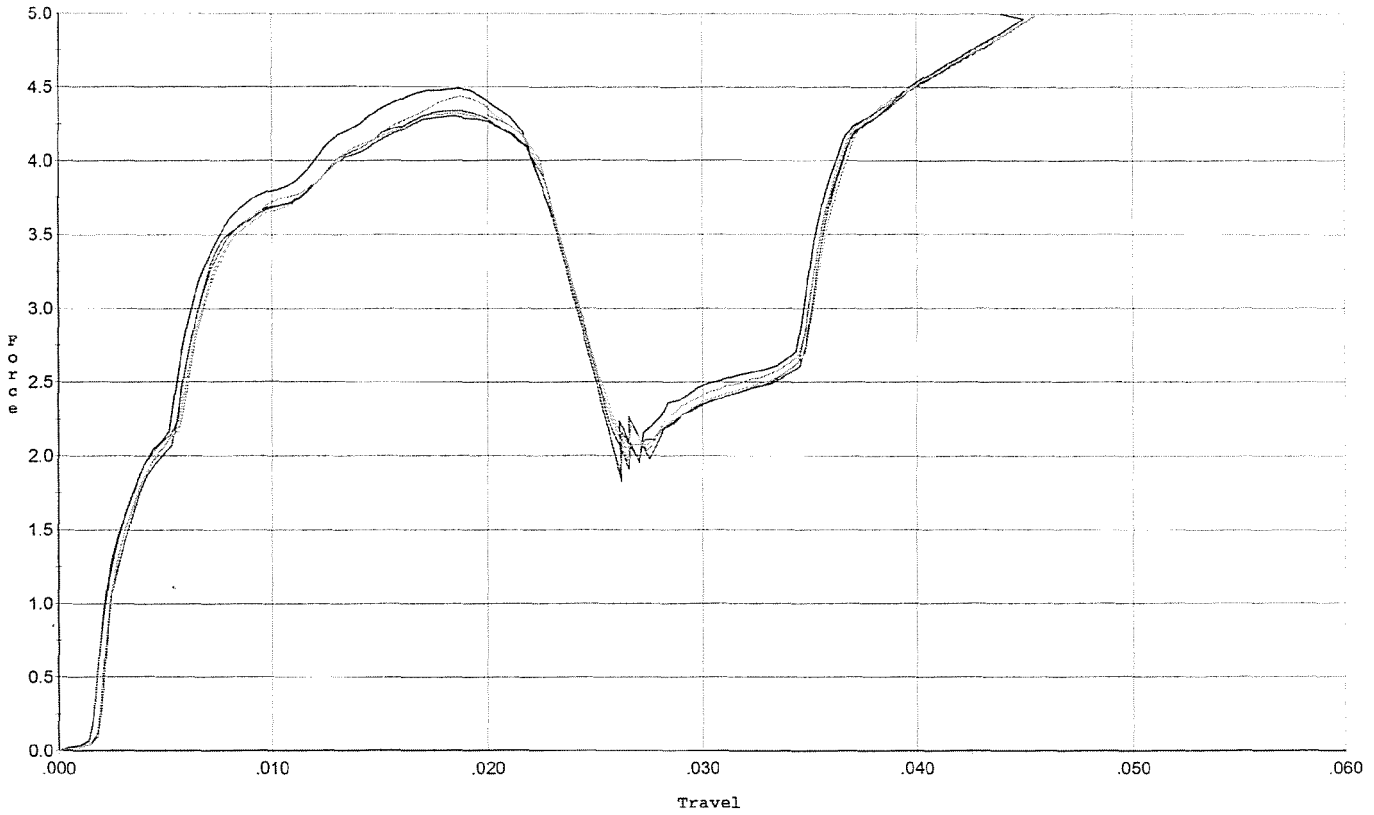
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.321      | 0.022             | 0.00            | 0.034      | 0.052             |           | Set Trigger |
| 2 | 3.333      | 0.021             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 3 | 3.427      | 0.021             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 4 | 3.258      | 0.022             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 5 | 3.272      | 0.021             | 0.00            | 0.034      | 0.048             |           | Set Trigger |

A 3.32

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 2/5/2009

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



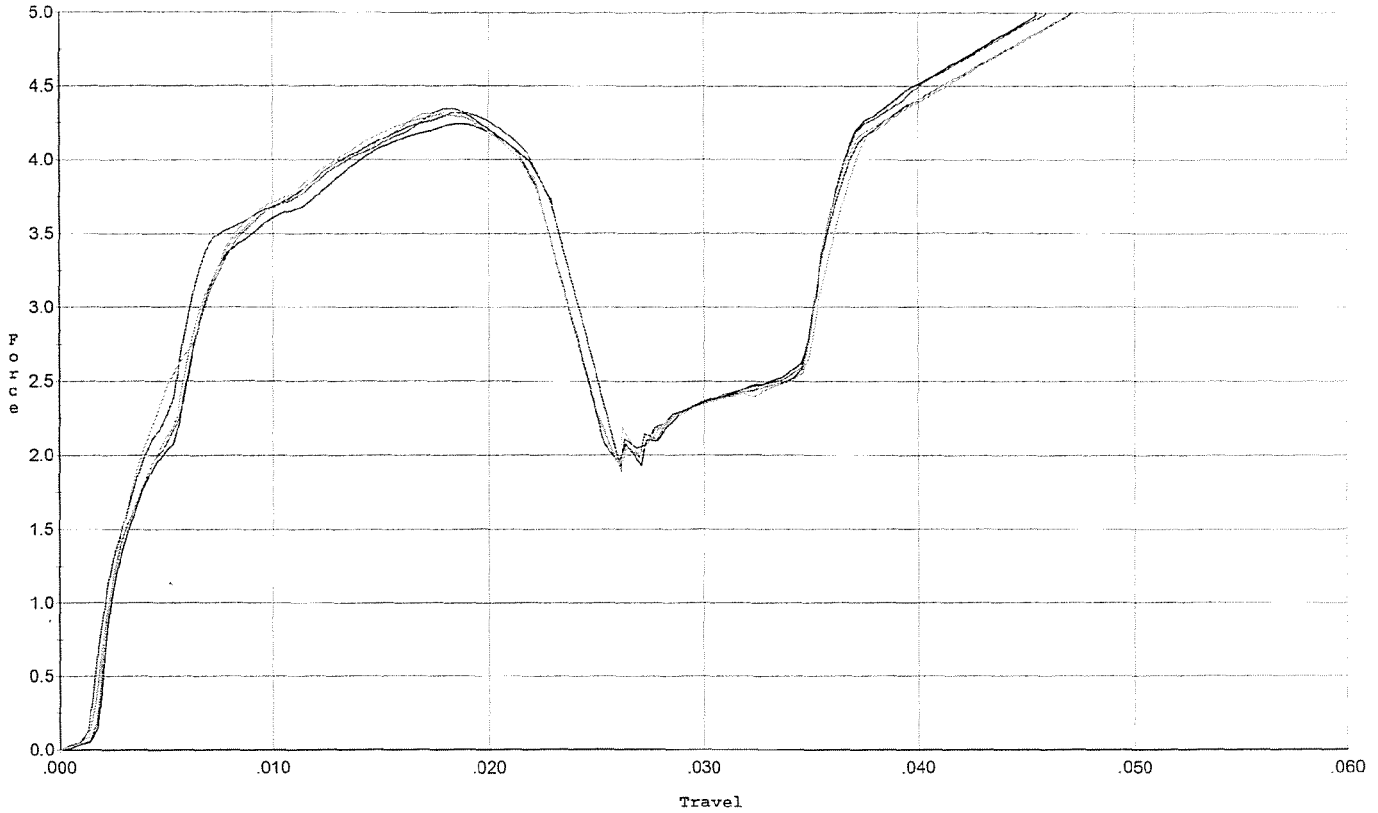
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.302      | 0.023             | 0.00            | 0.030      | 0.067             |           | Set Trigger |
| 2 | 4.490      | 0.023             | 0.00            | 0.030      | 0.071             |           | Set Trigger |
| 3 | 4.339      | 0.023             | 0.00            | 0.030      | 0.068             |           | Set Trigger |
| 4 | 4.437      | 0.023             | 0.00            | 0.030      | 0.067             |           | Set Trigger |
| 5 | 4.326      | 0.022             | 0.00            | 0.030      | 0.066             |           | Set Trigger |

A-4.37

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/5/2009

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



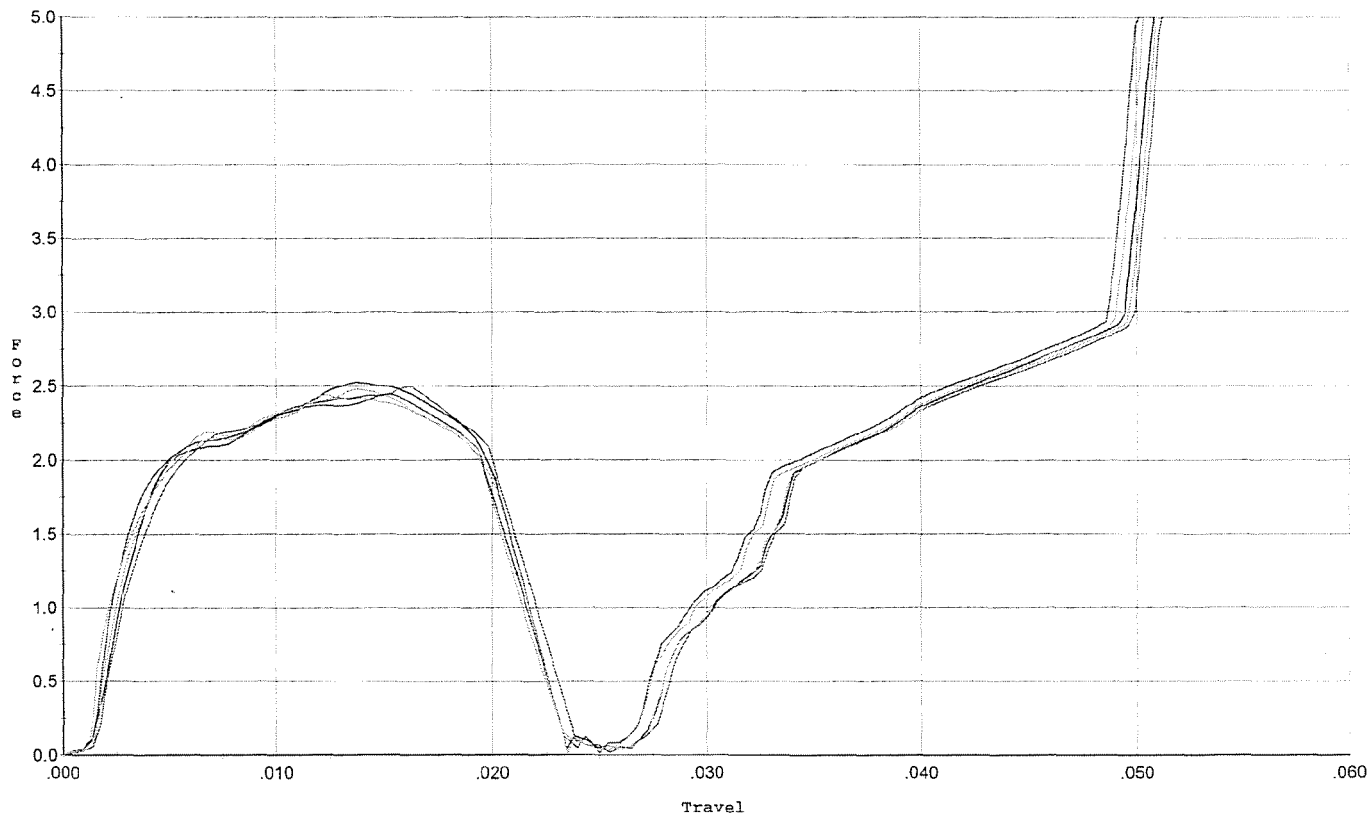
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.324      | 0.022             | 0.00            | 0.030      | 0.066             |           | Set Trigger |
| 2 | 4.246      | 0.023             | 0.00            | 0.030      | 0.066             |           | Set Trigger |
| 3 | 4.349      | 0.023             | 0.00            | 0.030      | 0.067             |           | Set Trigger |
| 4 | 4.325      | 0.022             | 0.00            | 0.031      | 0.066             |           | Set Trigger |
| 5 | 4.313      | 0.022             | 0.00            | 0.030      | 0.065             |           | Set Trigger |

A-4-31

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 2/5/2009

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



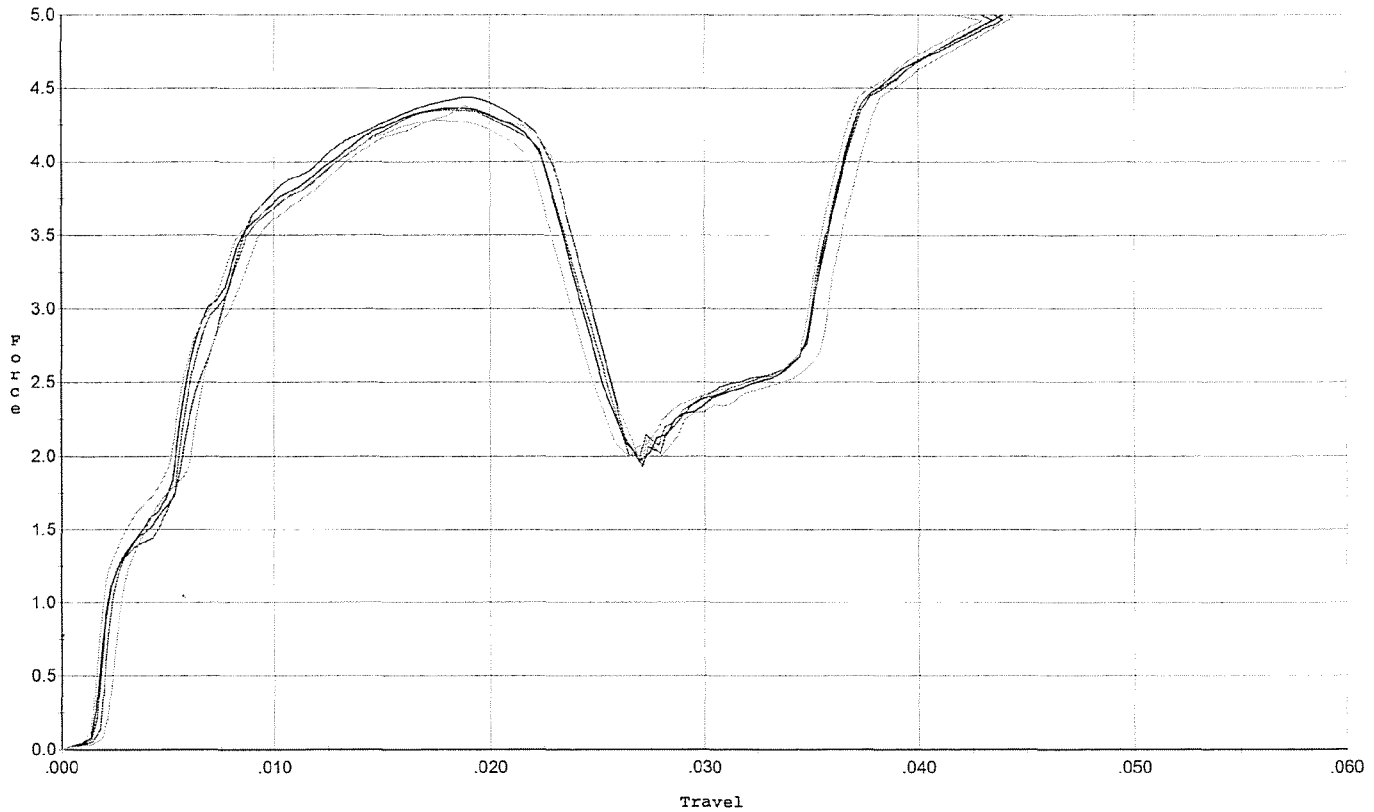
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.449      | 0.021             | 0.00            | 0.034      | 0.039             |           | Set Trigger |
| 2 | 2.524      | 0.020             | 0.00            | 0.035      | 0.037             |           | Set Trigger |
| 3 | 2.497      | 0.022             | 0.00            | 0.035      | 0.039             |           | Set Trigger |
| 4 | 2.442      | 0.020             | 0.00            | 0.035      | 0.037             |           | Set Trigger |
| 5 | 2.482      | 0.019             | 0.00            | 0.035      | 0.036             |           | Set Trigger |

A-2-47

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/5/2009

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 | 4.436      | 0.023             | 0.00            | 0.030      | 0.069             |           | Set Trigger |
| 2 | 4.360      | 0.022             | 0.00            | 0.030      | 0.066             |           | Set Trigger |
| 3 | 4.348      | 0.022             | 0.00            | 0.031      | 0.065             |           | Set Trigger |
| 4 | 4.281      | 0.022             | 0.00            | 0.031      | 0.065             |           | Set Trigger |
| 5 | 4.380      | 0.023             | 0.00            | 0.031      | 0.066             |           | Set Trigger |

A-4.36