

G6814686

**M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)**  
**BOLT ACTION CENTERFIRE RIFLE**  
**24" BARREL 7.62 NATO**

- INSTRUCTION BOOK 3518

**BM FORM**

proof of purchase



owner registration sticker



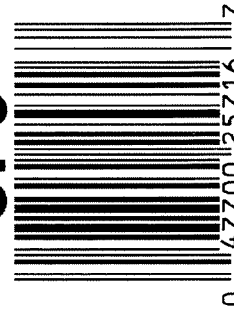
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6814686**

**UPC**



M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6814686

| OP # | OPERATION NAME                                                                                                                         | READINGS             | DATE    | INITIAL     |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|-------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                      | 3-24-09 | RT          |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                      |         |             |
| 440  | PROOF                                                                                                                                  |                      | 3-24-09 | TL          |
| 460  | CHECK HEADSPACE                                                                                                                        |                      | 3-24-09 | TL          |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                      |         |             |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA-FLUX           |         |             |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                      | 3-25-09 | J           |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR (signature) | 3/27/09 | (signature) |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                      |         |             |
| 500  | ROLLMARK CALIBER                                                                                                                       |                      | 3/27/09 | RT          |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                      | 3-27    | BH          |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                      | 3-29    | —           |
| 545  | (BOLT)                                                                                                                                 |                      |         |             |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                      |         |             |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                      | 3-30-09 | SP          |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                      | 3-30-09 | SP          |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                      | 3-30-09 | SP          |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                      | 4-22-09 | (signature) |
|      | 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

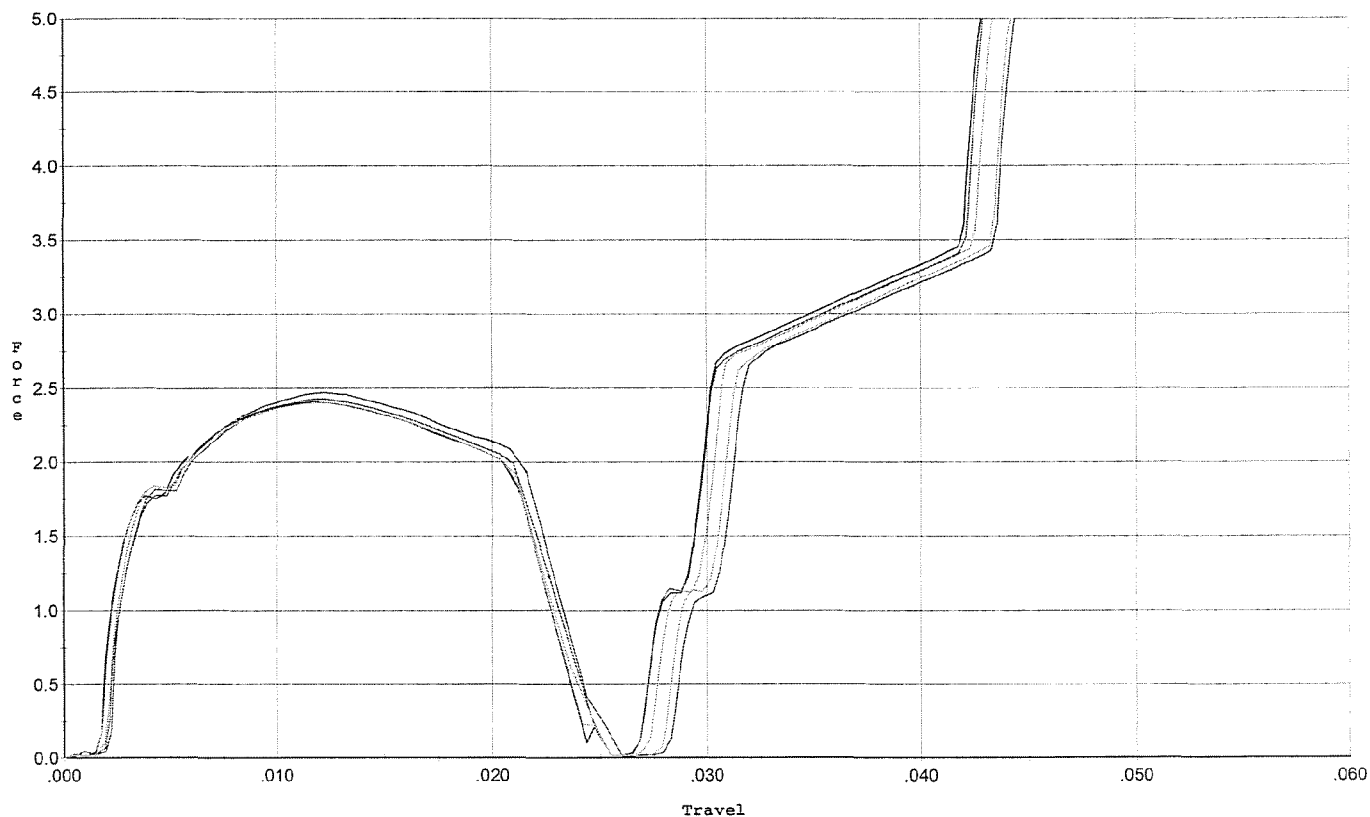
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.0</u> <u>4.0</u> <u>4.0</u>                            | 5-6-09  | LJ      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>6.0</u> <u>5.0</u> <u>5.0</u>                            | 5-6-09  | LJ      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.023</u>                         | 5-6-09  | LJ      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 4-22-09 | RP      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 5-6-09  | LJ      |
|              | 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                        | 4-24-09 | RP      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 4-24-09 | SP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 5-6-09  | LJ      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.69</u> <u>2.65</u> <u>2.64</u> <u>2.67</u> <u>2.54</u> | 4-28-09 | RP      |
|              | C) FUNCTION                                                              |                                                             | 5-6-09  | LJ      |
| 690          | PACK                                                                     |                                                             | 5-29-09 | RP      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



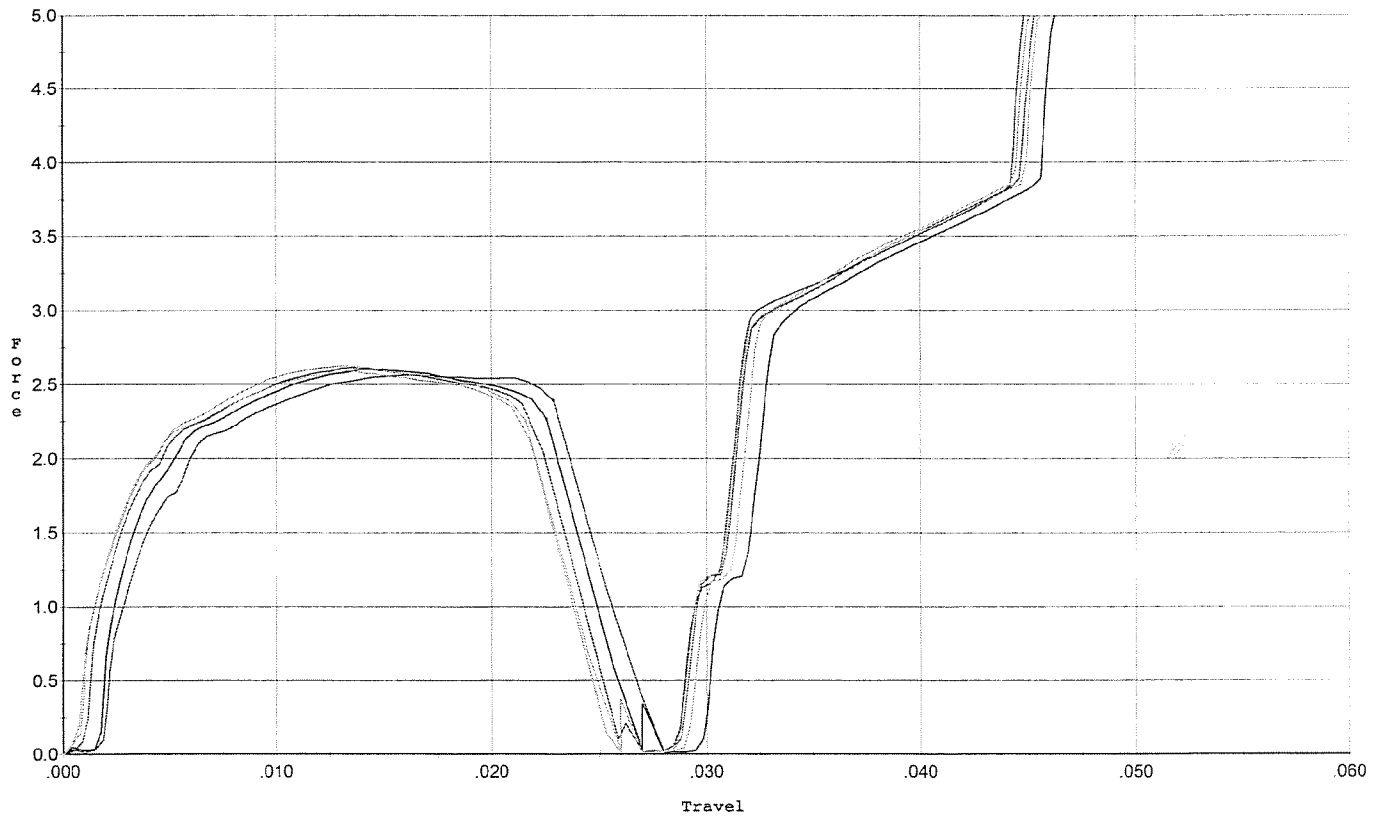
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.472      | 0.022             | 0.00            | 0.029      | 0.040             |           | Set Trigger |
| 2 | 2.411      | 0.021             | 0.00            | 0.028      | 0.039             |           | Set Trigger |
| 3 | 2.425      | 0.023             | 0.00            | 0.027      | 0.041             |           | Set Trigger |
| 4 | 2.414      | 0.021             | 0.00            | 0.029      | 0.039             |           | Set Trigger |
| 5 | 2.401      | 0.021             | 0.002           | 0.028      | 0.038             |           | Set Trigger |

Avg 2.42

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



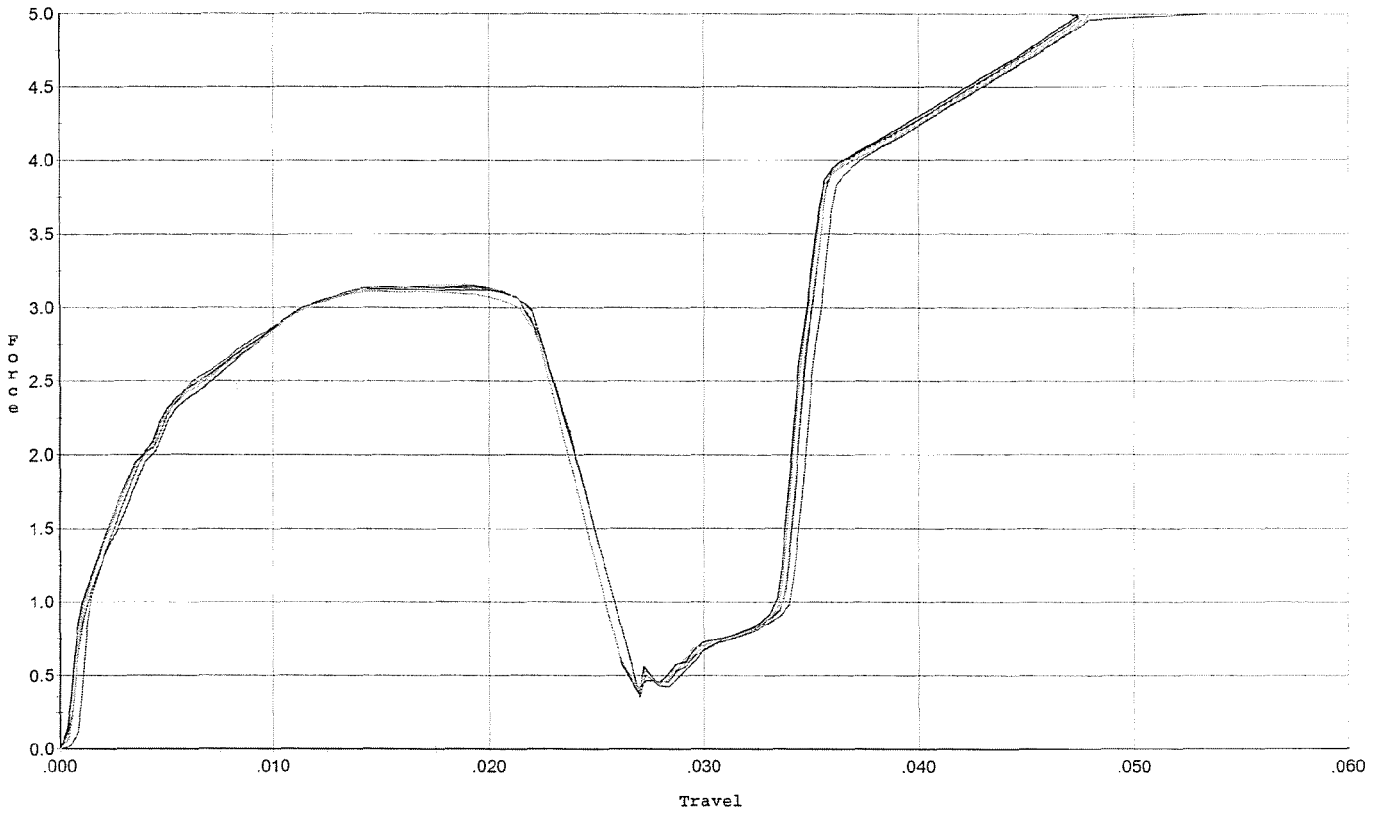
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.568      | 0.023             | 0.00            | 0.028      | 0.045             |           | Set Trigger |
| 2 | 2.604      | 0.023             | 0.00            | 0.030      | 0.045             |           | Set Trigger |
| 3 | 2.615      | 0.022             | 0.00            | 0.029      | 0.046             |           | Set Trigger |
| 4 | 2.591      | 0.022             | 0.00            | 0.030      | 0.045             |           | Set Trigger |
| 5 | 2.626      | 0.022             | 0.00            | 0.029      | 0.045             |           | Set Trigger |

Aug 2.60

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



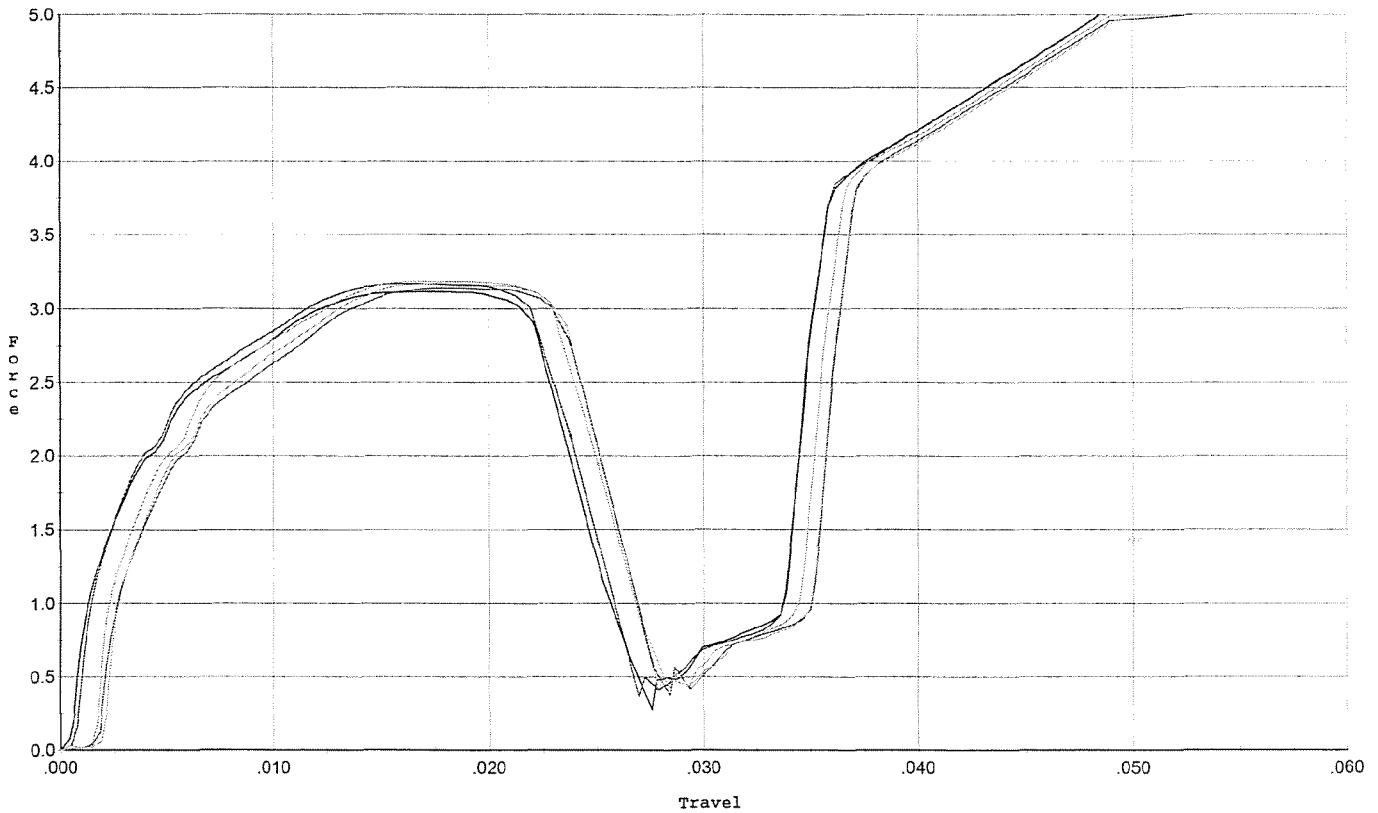
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.129      | 0.024             | 0.00            | 0.030      | 0.058             |           | Set Trigger |
| 2 | 3.147      | 0.022             | 0.00            | 0.030      | 0.054             |           | Set Trigger |
| 3 | 3.143      | 0.024             | 0.00            | 0.031      | 0.057             |           | Set Trigger |
| 4 | 3.112      | 0.022             | 0.00            | 0.031      | 0.054             |           | Set Trigger |
| 5 | 3.158      | 0.022             | 0.00            | 0.031      | 0.054             |           | Set Trigger |

Avg 3.13

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



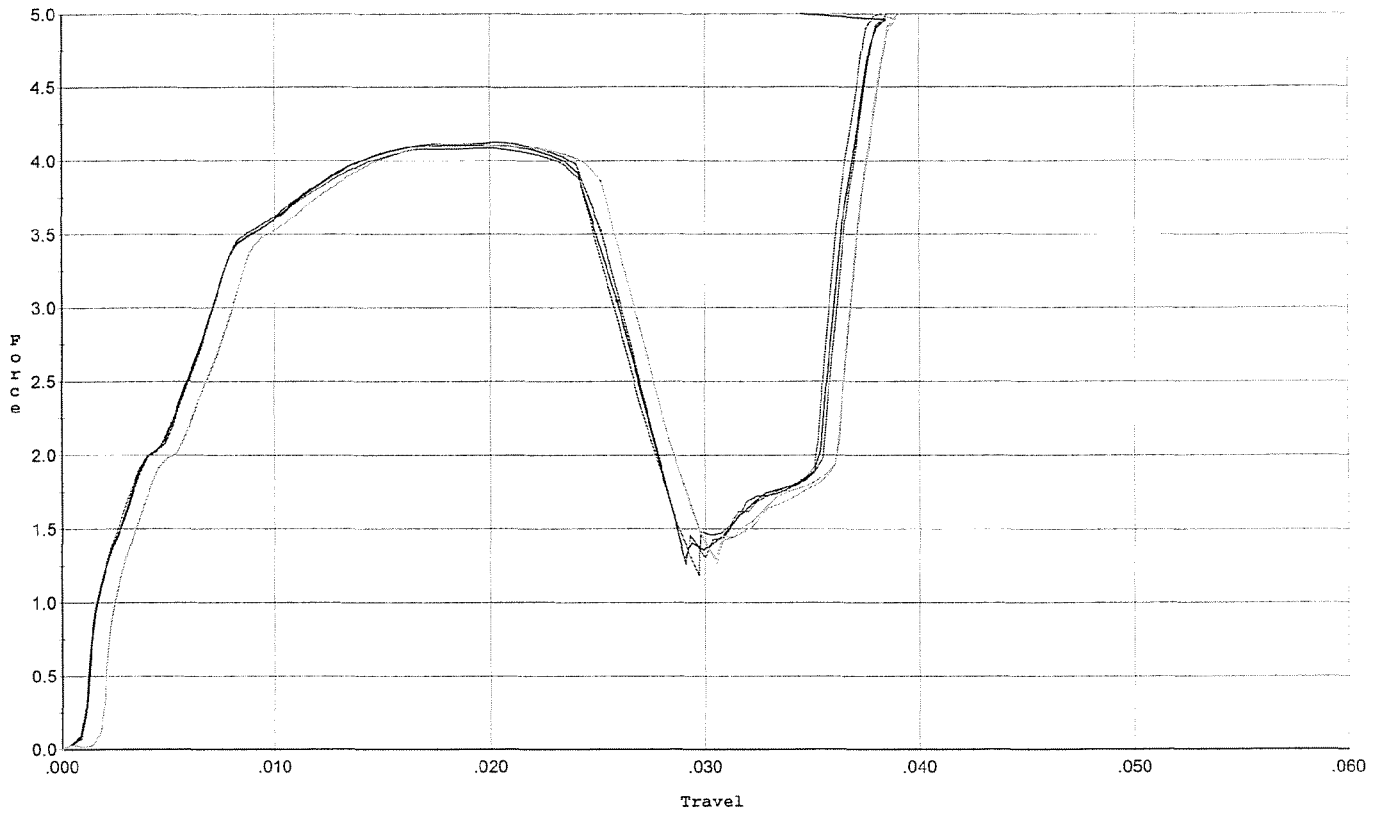
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.167      | 0.024             | 0.00            | 0.030      | 0.058             |           | Set Trigger |
| 2 | 3.115      | 0.022             | 0.00            | 0.031      | 0.053             |           | Set Trigger |
| 3 | 3.140      | 0.024             | 0.00            | 0.031      | 0.054             |           | Set Trigger |
| 4 | 3.172      | 0.024             | 0.002           | 0.031      | 0.054             |           | Set Trigger |
| 5 | 3.184      | 0.025             | 0.00            | 0.030      | 0.059             |           | Set Trigger |

Aug 3.15

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



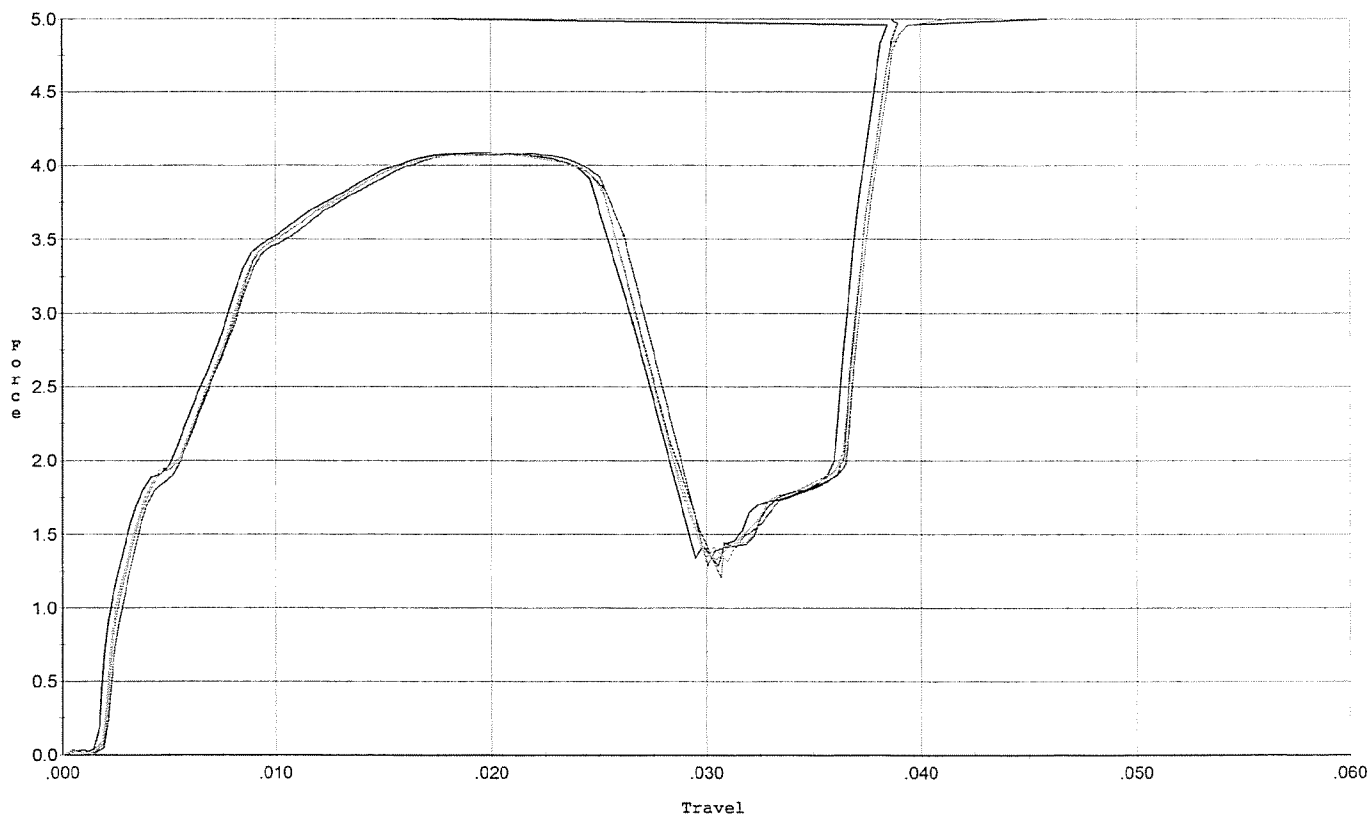
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.124      | 0.025             | 0.00            | 0.022      | 0.076             |           | Set Trigger |
| 2 | 4.104      | 0.026             | 0.00            | 0.022      | 0.078             |           | Set Trigger |
| 3 | 4.083      | 0.024             | 0.00            | 0.023      | 0.072             |           | Set Trigger |
| 4 | 4.110      | 0.025             | 0.00            | 0.023      | 0.074             |           | Set Trigger |
| 5 | 4.113      | 0.025             | 0.00            | 0.023      | 0.074             |           | Set Trigger |

Avg 4.10

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



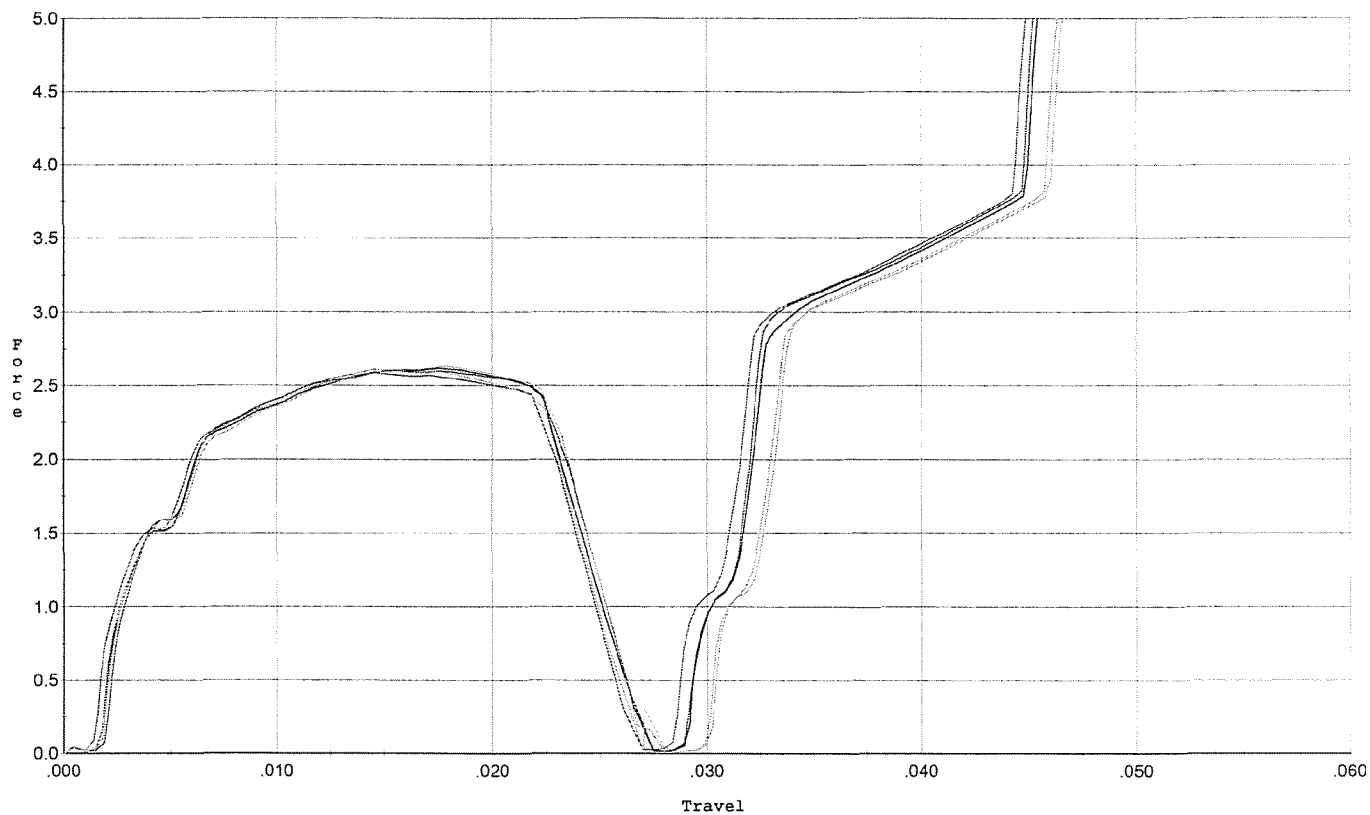
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.080      | 0.026             | 0.00            | 0.023      | 0.076             |           | Set Trigger |
| 2 | 4.082      | 0.027             | 0.00            | 0.022      | 0.078             |           | Set Trigger |
| 3 | 4.078      | 0.025             | 0.002           | 0.023      | 0.073             |           | Set Trigger |
| 4 | 4.076      | 0.025             | 0.00            | 0.023      | 0.073             |           | Set Trigger |
| 5 | 4.072      | 0.025             | 0.00            | 0.023      | 0.073             |           | Set Trigger |

Avg 4.07

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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



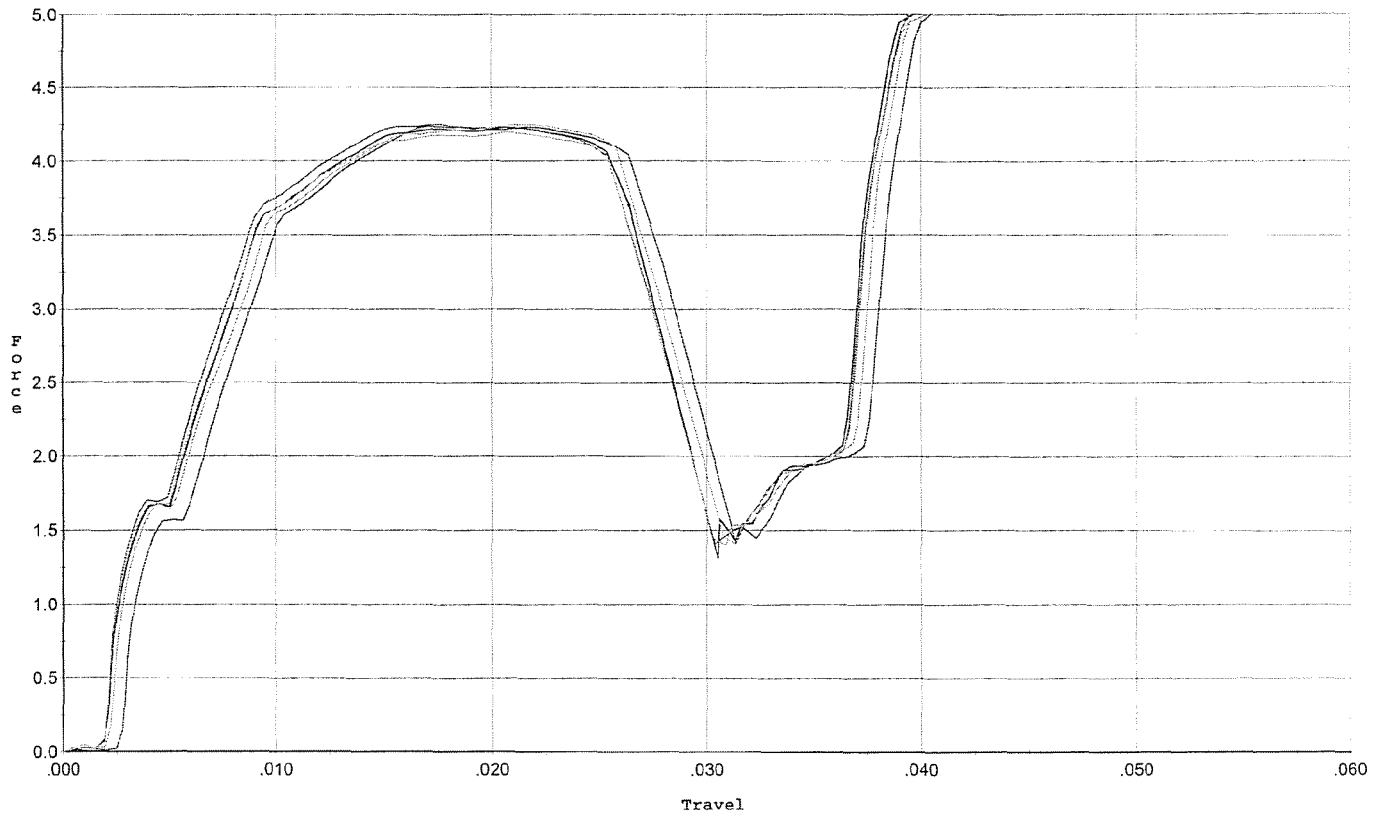
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.608      | 0.024             | 0.00            | 0.028      | 0.046             |           | Set Trigger |
| 2 | 2.616      | 0.022             | 0.00            | 0.029      | 0.044             |           | Set Trigger |
| 3 | 2.582      | 0.023             | 0.00            | 0.028      | 0.045             |           | Set Trigger |
| 4 | 2.610      | 0.022             | 0.00            | 0.030      | 0.044             |           | Set Trigger |
| 5 | 2.628      | 0.023             | 0.002           | 0.030      | 0.045             |           | Set Trigger |

Avg 2.60

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 2/14/09

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 | 4.235      | 0.028             | 0.003           | 0.021      | 0.082             |           | Set Trigger |
| 2 | 4.226      | 0.026             | 0.00            | 0.021      | 0.079             |           | Set Trigger |
| 3 | 4.249      | 0.027             | 0.002           | 0.021      | 0.083             |           | Set Trigger |
| 4 | 4.196      | 0.027             | 0.005           | 0.021      | 0.082             |           | Set Trigger |
| 5 | 4.245      | 0.028             | 0.00            | 0.021      | 0.083             |           | Set Trigger |

Aug 4.23