

G6801349

**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



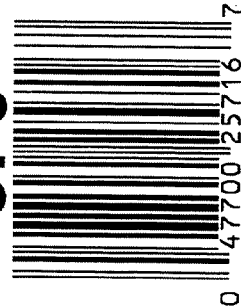
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6801349**

**UPC**



GUN SERIAL # G 6801349

| OP #            | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 420             | ASSEMBLE ACTION                                                                                                                        |          | 2-27-09 | SP      |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |          | 2-27-09 | RP      |
| 440             | PROOF                                                                                                                                  |          | 2-27-09 | SP      |
| 460             | CHECK HEADSPACE                                                                                                                        |          | 2-27-09 | SP      |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |          | 2-27-09 | SP      |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-2-09  | RT      |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | (S)      | 3/5/09  | (S)     |
| 490             | MAGNAFLUX BOLT                                                                                                                         |          | 3/8/09  | MR      |
| 500             | ROLLMARK CALIBER                                                                                                                       |          | 3/5/09  | RT      |
| 510             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-2-09  | SP      |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |          | 3/4     | mon     |
| 540             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 3/8     |         |
| 545             | (BOLT)                                                                                                                                 |          |         |         |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |          |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 3-10-09 | SP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 3-10-09 | SP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 3-10-09 | SP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 3-12-09 | L. J.   |
|                 | 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 |                                                                                                                                        |          |         |         |

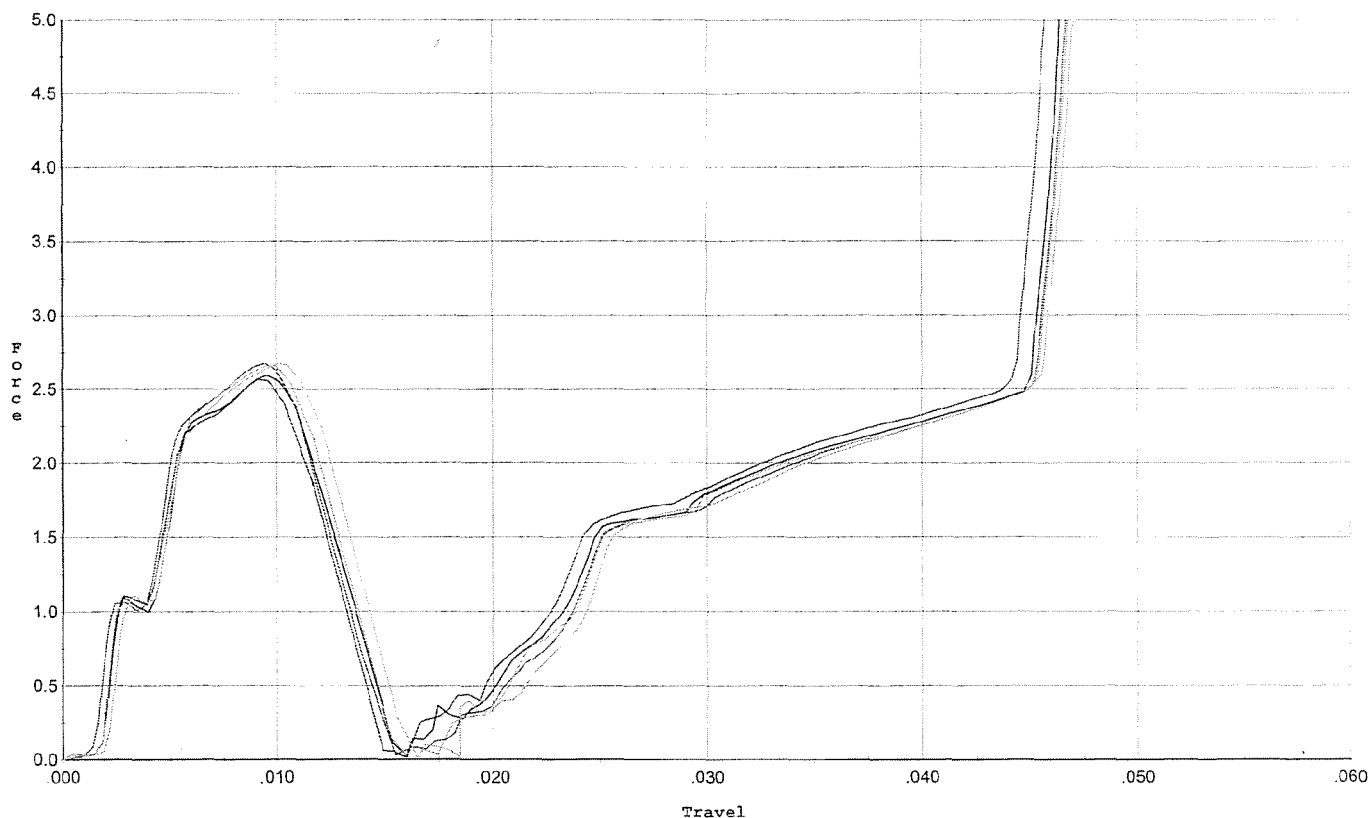
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>6</u> <u>5.5</u> <u>6</u>                                | 3-18-09 | NW      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3</u> <u>3</u> <u>3</u>                                  | 3-18-09 | NW      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.023</u>                         | 3-18-09 | NW      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-18-09 | NW      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-18-09 | NW      |
|              | 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                        | 3-17-09 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-17-09 | NW      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-18-09 | NW      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.55</u> <u>2.51</u> <u>2.61</u> <u>2.50</u> <u>2.42</u> | 3-18-09 | NW      |
|              | C) FUNCTION                                                              |                                                             | 3-18-09 | NW      |
| 690          | PACK                                                                     |                                                             | 3/19/09 | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



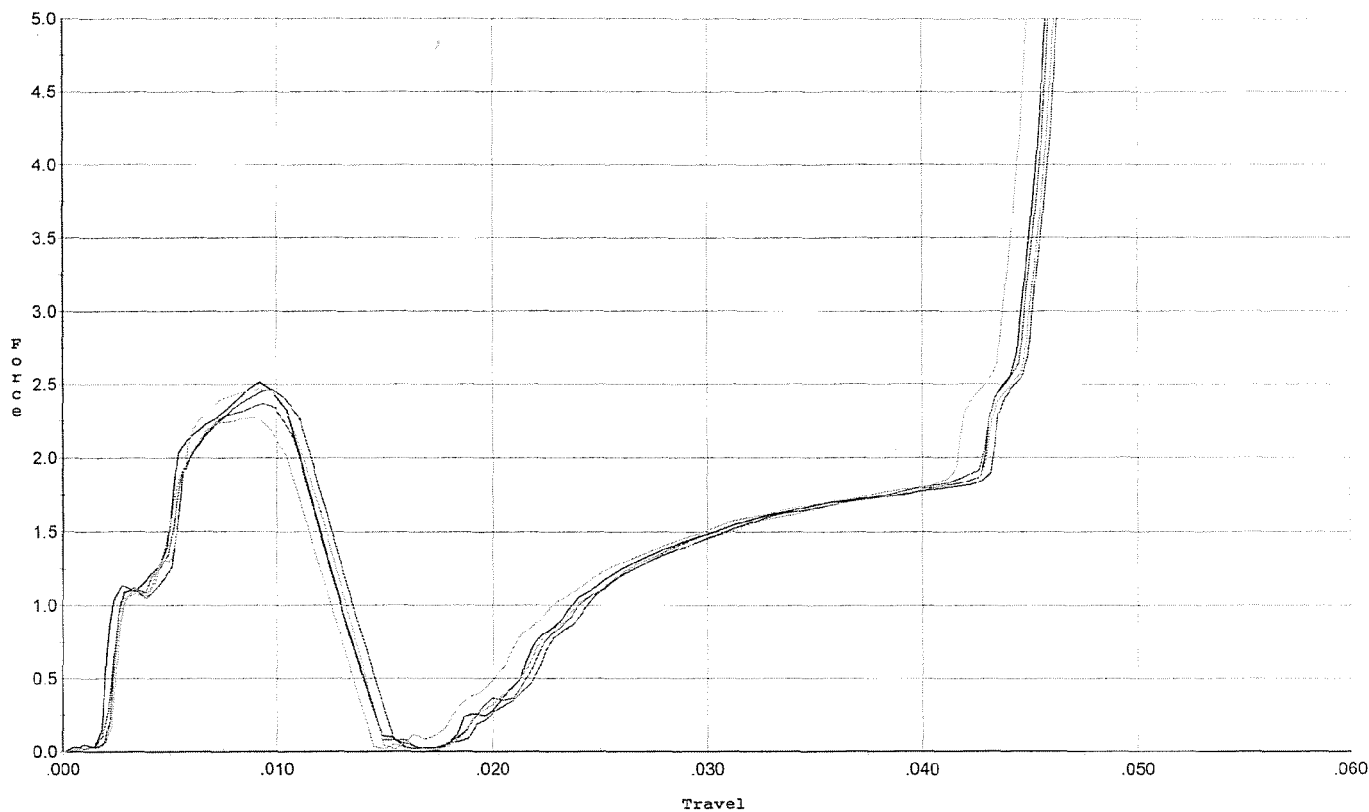
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.567      | 0.012             | 0.004           | 0.038      | 0.018             |           | Set Trigger |
| 2 | 2.593      | 0.013             | 0.004           | 0.038      | 0.020             |           | Set Trigger |
| 3 | 2.673      | 0.011             | 0.00            | 0.039      | 0.017             |           | Set Trigger |
| 4 | 2.670      | 0.012             | 0.00            | 0.038      | 0.019             |           | Set Trigger |
| 5 | 2.656      | 0.012             | 0.004           | 0.038      | 0.019             |           | Set Trigger |

A-2-63

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/3/2009

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



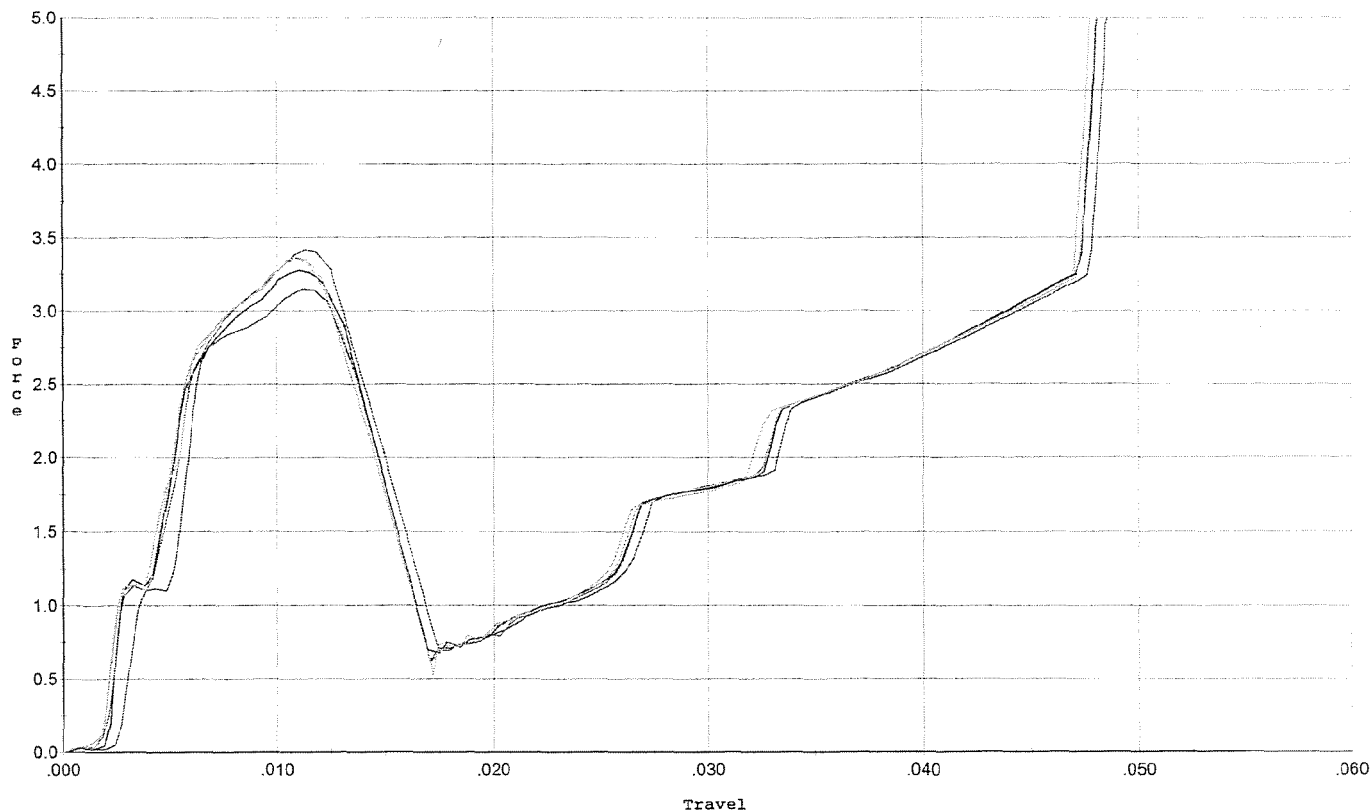
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.464      | 0.011             | 0.00            | 0.039      | 0.016             |           | Set Trigger |
| 2 | 2.515      | 0.010             | 0.00            | 0.039      | 0.016             |           | Set Trigger |
| 3 | 2.368      | 0.011             | 0.00            | 0.039      | 0.015             |           | Set Trigger |
| 4 | 2.470      | 0.012             | 0.002           | 0.037      | 0.017             |           | Set Trigger |
| 5 | 2.278      | 0.012             | 0.00            | 0.039      | 0.017             |           | Set Trigger |

A-2.41

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



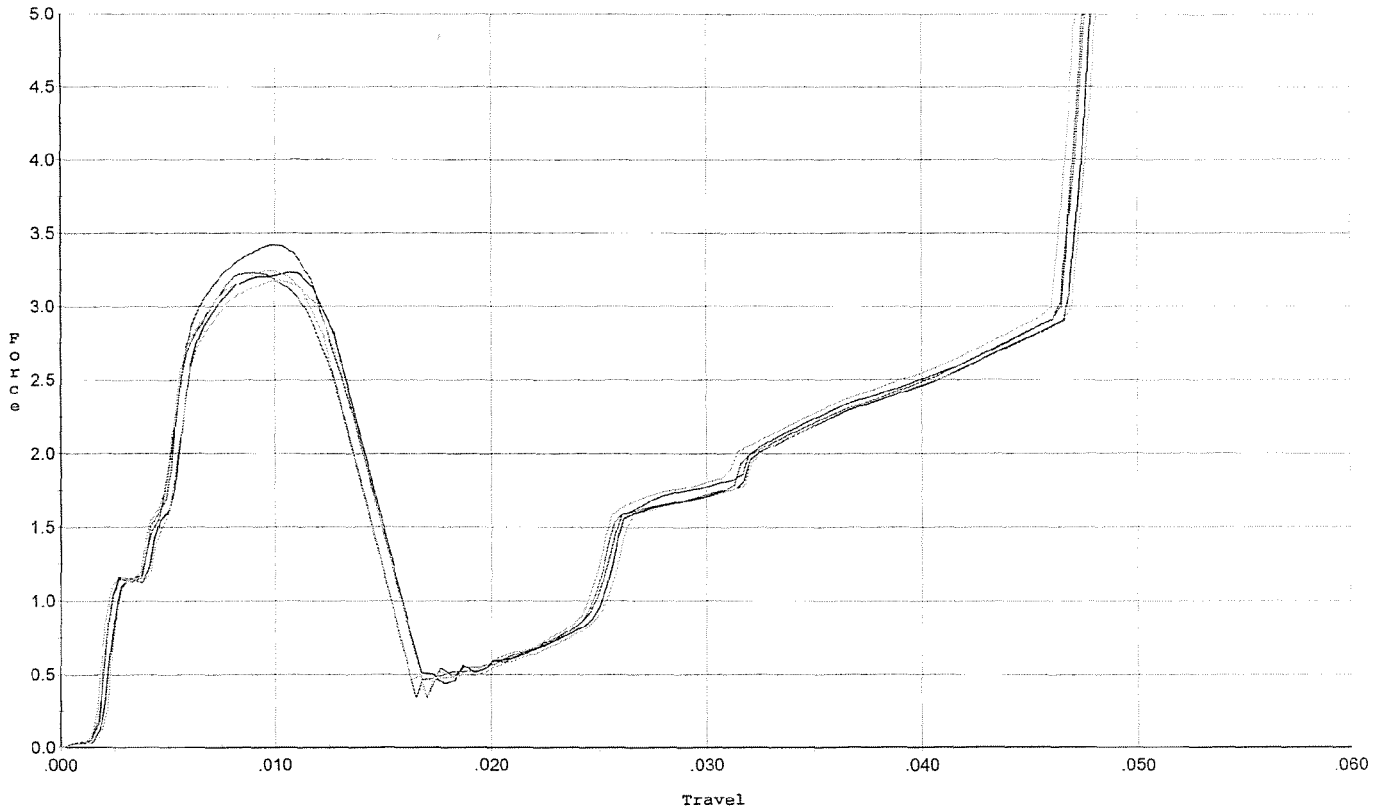
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.150      | 0.014             | 0.003           | 0.037      | 0.024             |           | Set Trigger |
| 2 | 3.278      | 0.013             | 0.00            | 0.037      | 0.026             |           | Set Trigger |
| 3 | 3.417      | 0.015             | 0.00            | 0.036      | 0.030             |           | Set Trigger |
| 4 | 3.362      | 0.013             | 0.002           | 0.036      | 0.027             |           | Set Trigger |
| 5 | 3.360      | 0.014             | 0.00            | 0.037      | 0.028             |           | Set Trigger |

A-3.31

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/3/2009

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



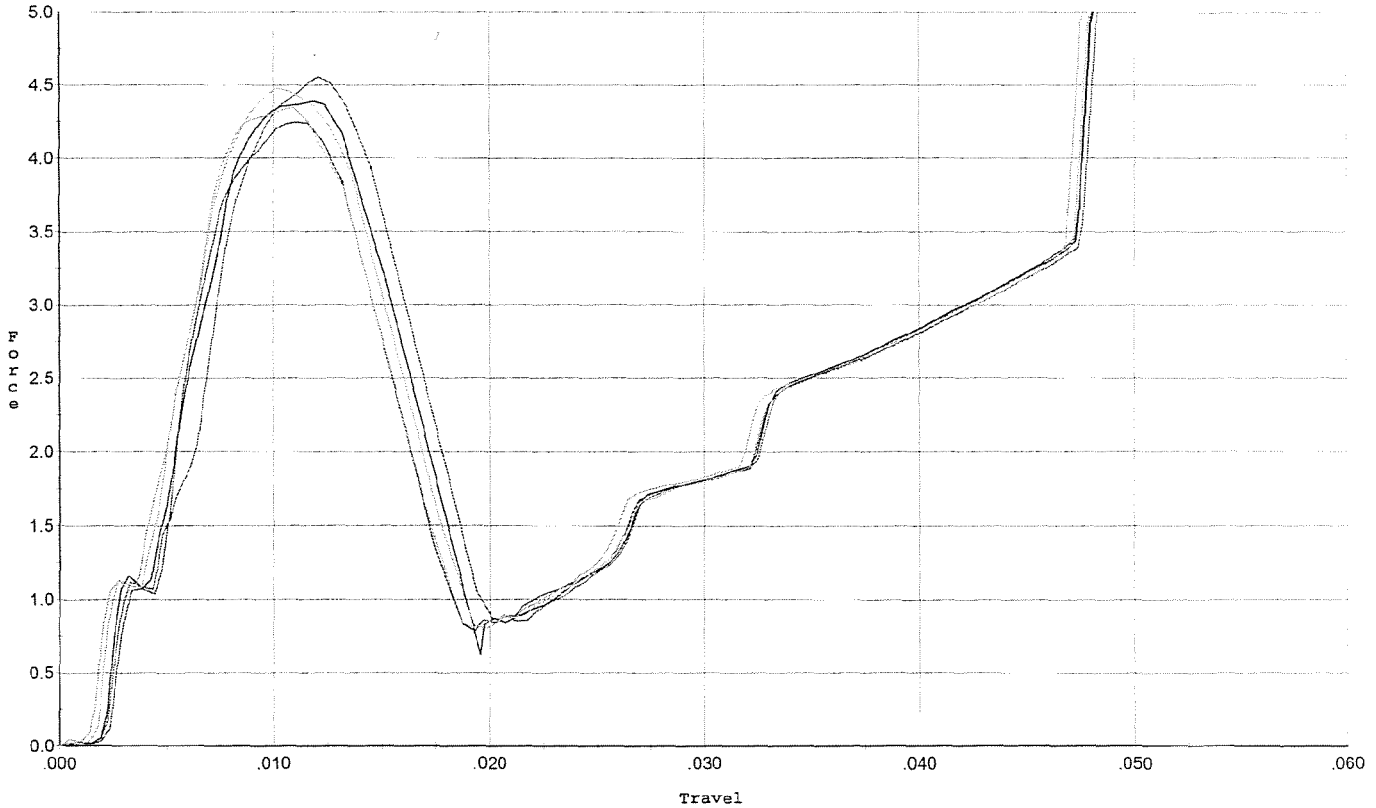
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.421      | 0.013             | 0.00            | 0.036      | 0.027             |           | Set Trigger |
| 2 | 3.235      | 0.013             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 3 | 3.231      | 0.013             | 0.00            | 0.037      | 0.024             |           | Set Trigger |
| 4 | 3.180      | 0.013             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 5 | 3.245      | 0.012             | 0.00            | 0.037      | 0.024             |           | Set Trigger |

A-3.26

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



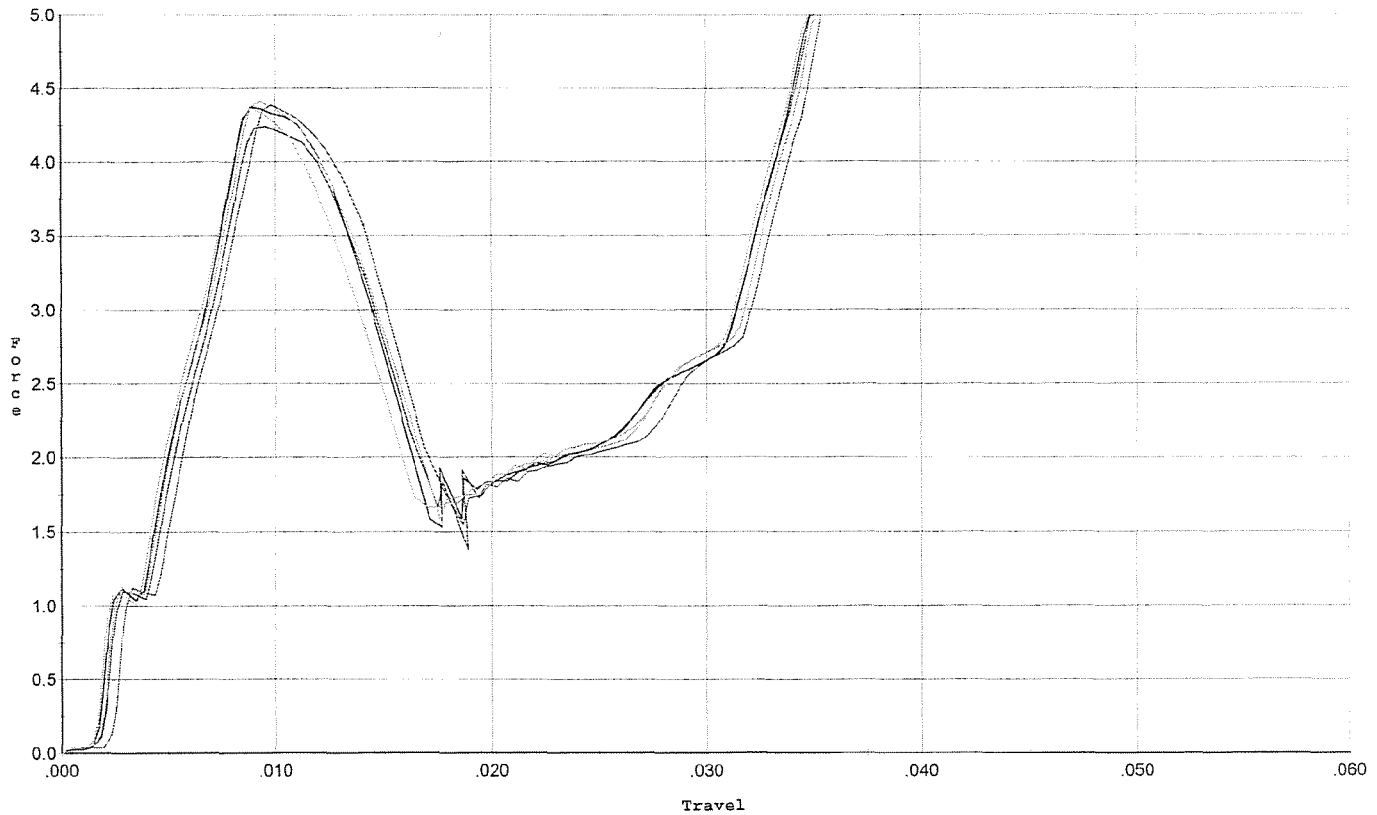
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.242      | 0.013             | 0.002           | 0.035      | 0.031             |           | Set Trigger |
| 2 | 4.388      | 0.015             | 0.002           | 0.034      | 0.037             |           | Set Trigger |
| 3 | 4.552      | 0.015             | 0.002           | 0.034      | 0.036             |           | Set Trigger |
| 4 | 4.477      | 0.014             | 0.004           | 0.034      | 0.034             |           | Set Trigger |
| 5 | 4.345      | 0.013             | 0.00            | 0.035      | 0.033             |           | Set Trigger |

A. 4.40

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



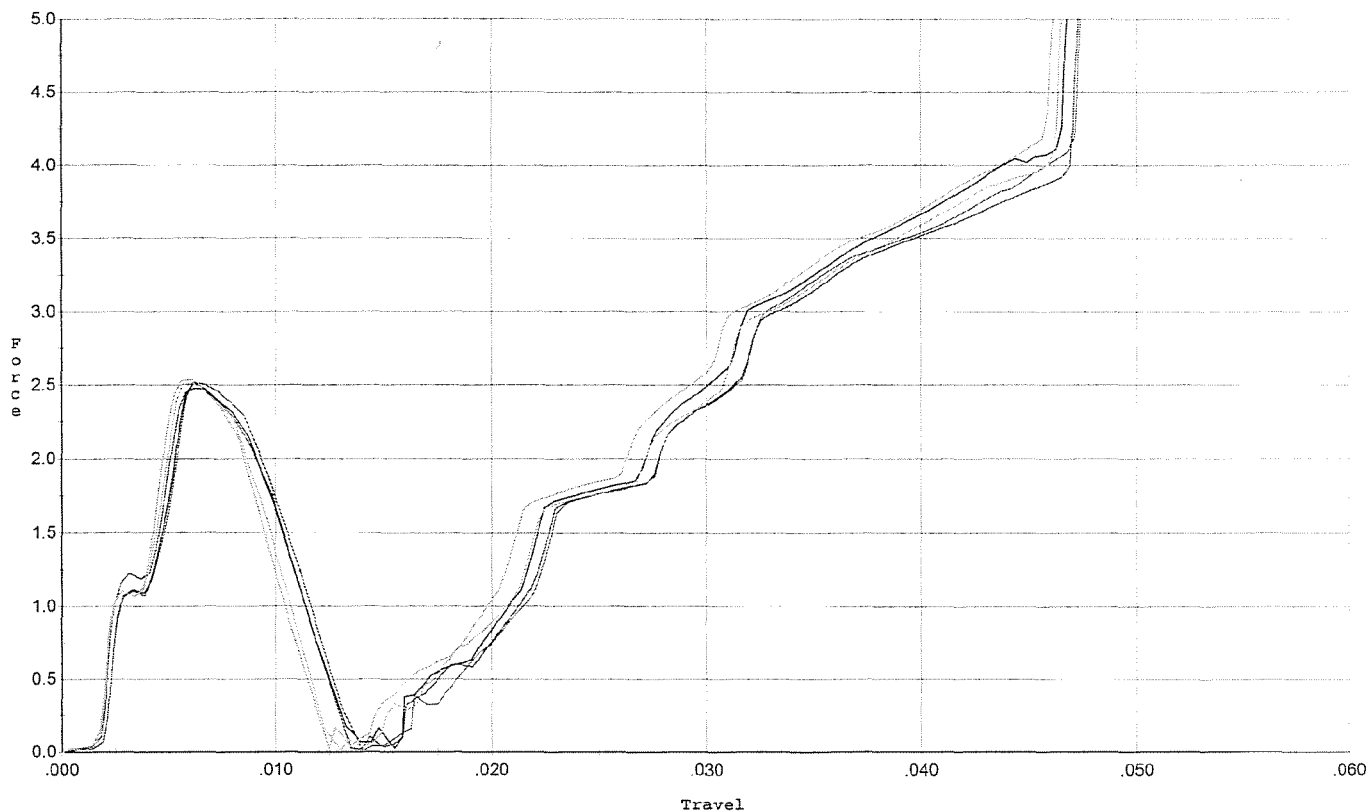
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.241      | 0.014             | 0.004           | 0.031      | 0.033             |           | Set Trigger |
| 2 | 4.374      | 0.014             | 0.00            | 0.031      | 0.035             |           | Set Trigger |
| 3 | 4.387      | 0.014             | 0.005           | 0.031      | 0.033             |           | Set Trigger |
| 4 | 4.371      | 0.014             | 0.004           | 0.031      | 0.034             |           | Set Trigger |
| 5 | 4.411      | 0.016             | 0.004           | 0.030      | 0.038             |           | Set Trigger |

A.4.35

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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



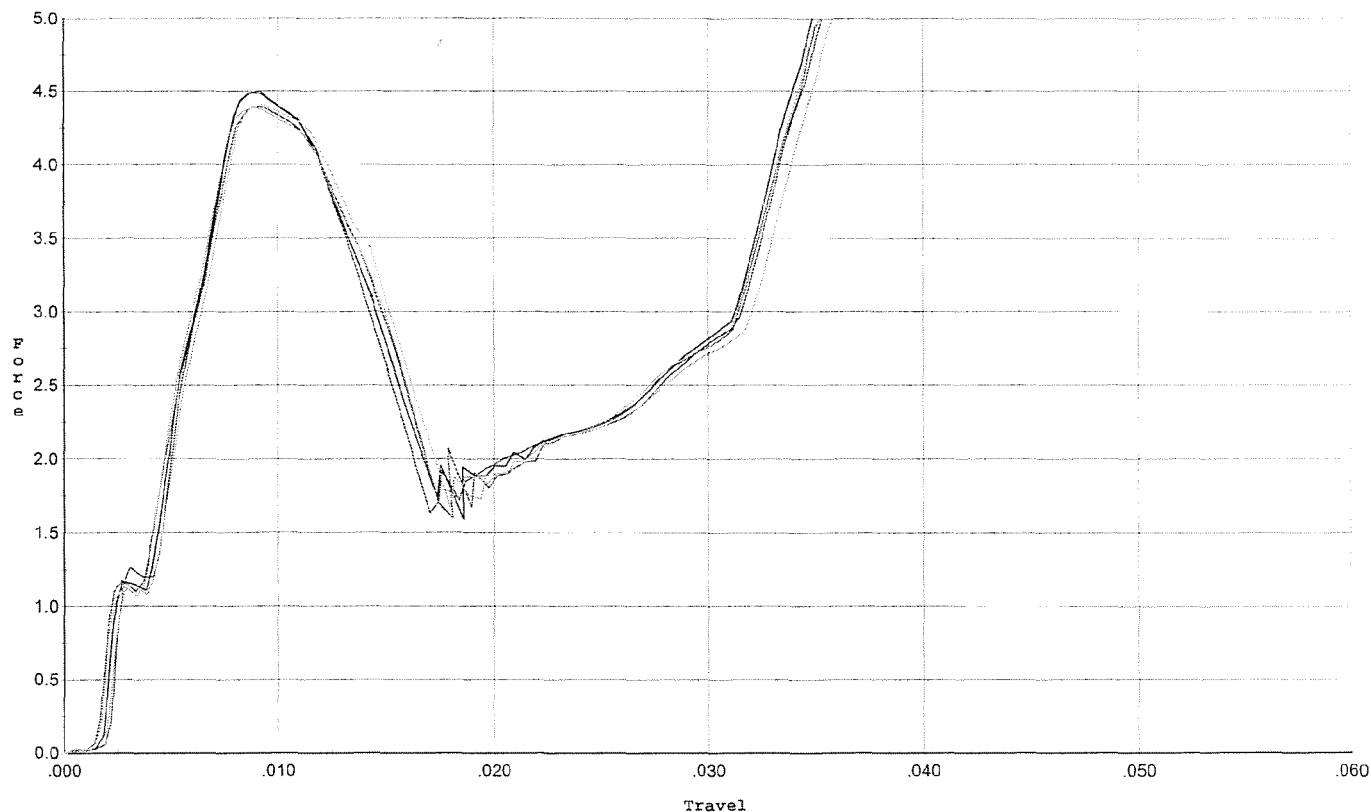
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.477      | 0.010             | 0.00            | 0.039      | 0.014             |           | Set Trigger |
| 2 | 2.516      | 0.010             | 0.00            | 0.039      | 0.013             |           | Set Trigger |
| 3 | 2.519      | 0.011             | 0.002           | 0.039      | 0.015             |           | Set Trigger |
| 4 | 2.509      | 0.010             | 0.00            | 0.039      | 0.013             |           | Set Trigger |
| 5 | 2.535      | 0.008             | 0.00            | 0.039      | 0.011             |           | Set Trigger |

A-2.51

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/3/2009

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 | 4.499      | 0.015             | 0.004           | 0.029      | 0.037             |           | Set Trigger |
| 2 | 4.488      | 0.014             | 0.004           | 0.029      | 0.036             |           | Set Trigger |
| 3 | 4.393      | 0.015             | 0.00            | 0.029      | 0.038             |           | Set Trigger |
| 4 | 4.409      | 0.014             | 0.00            | 0.029      | 0.035             |           | Set Trigger |
| 5 | 4.390      | 0.015             | 0.00            | 0.029      | 0.038             |           | Set Trigger |

A-4.43