

66801369

**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



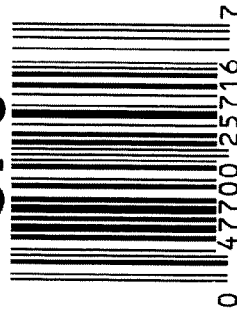
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6801369**

**UPC**



GUN SERIAL # G 6801369

| OP # | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |          | 2-27-09 | RP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |          | 2-27-09 | RP      |
| 440  | PROOF                                                                                                                                  |          | 2-27-09 | RP      |
| 460  | CHECK HEADSPACE                                                                                                                        |          | 2-27-09 | RP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |          | 2-27-09 | RP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-2-09  | KJZ     |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   |          | 3/5/09  | (A)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |          | 3/5/09  | MR      |
| 500  | ROLLMARK CALIBER                                                                                                                       |          | 3/5/09  | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-2-09  | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |          | 3/6     | mon     |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 3/9     |         |
| 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 | 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

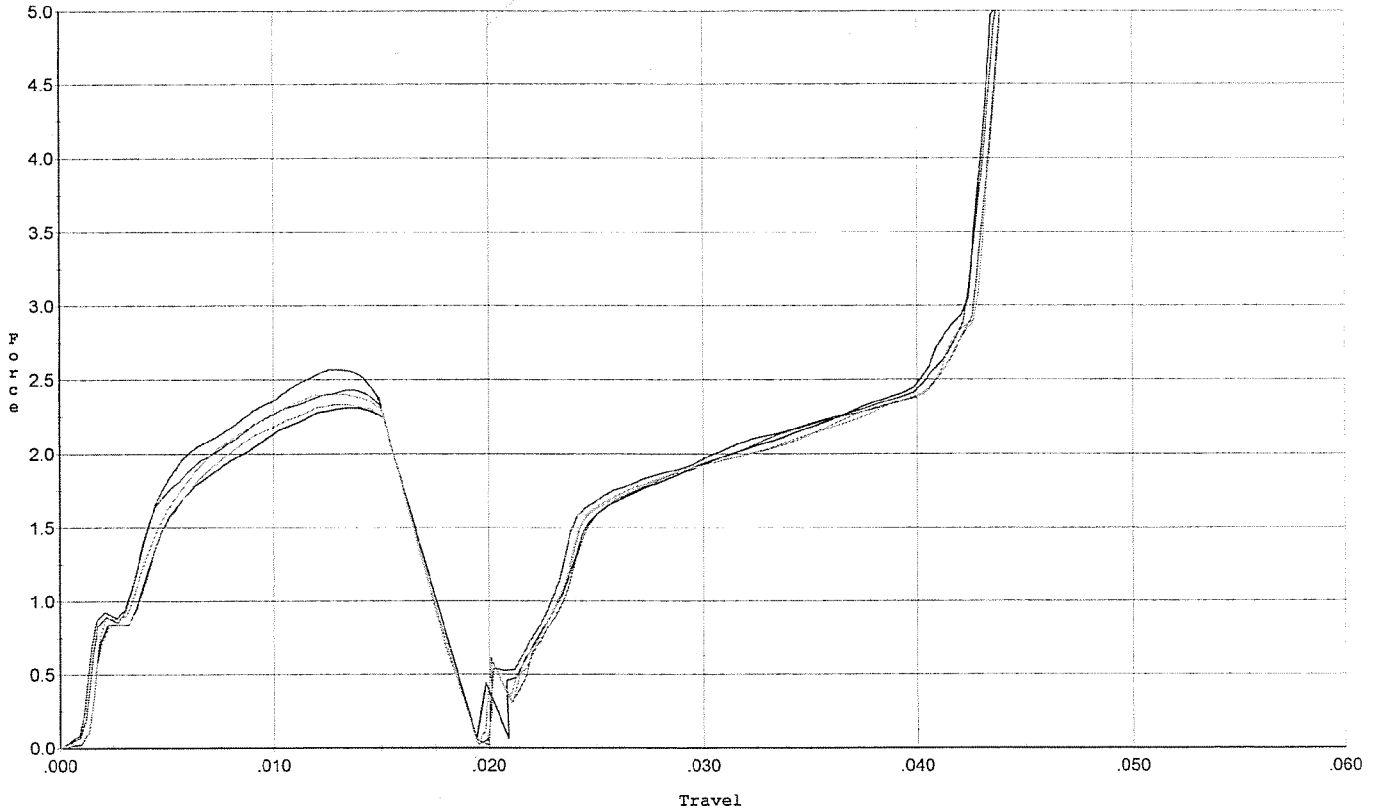
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.5</u> <u>4</u> <u>4.5</u>                              | 3-18-09 | NW      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4</u> <u>4</u> <u>4</u>                                  | 3-18-09 | NW      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>1023</u> <u>1023</u> <u>1023</u>                         | 3-18-09 | NW      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-12-09 | L.N.    |
|              | 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 | TC      |
|              | 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>2.45</u> <u>2.54</u> <u>2.49</u> <u>2.47</u> <u>2.29</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 3/11/2009

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



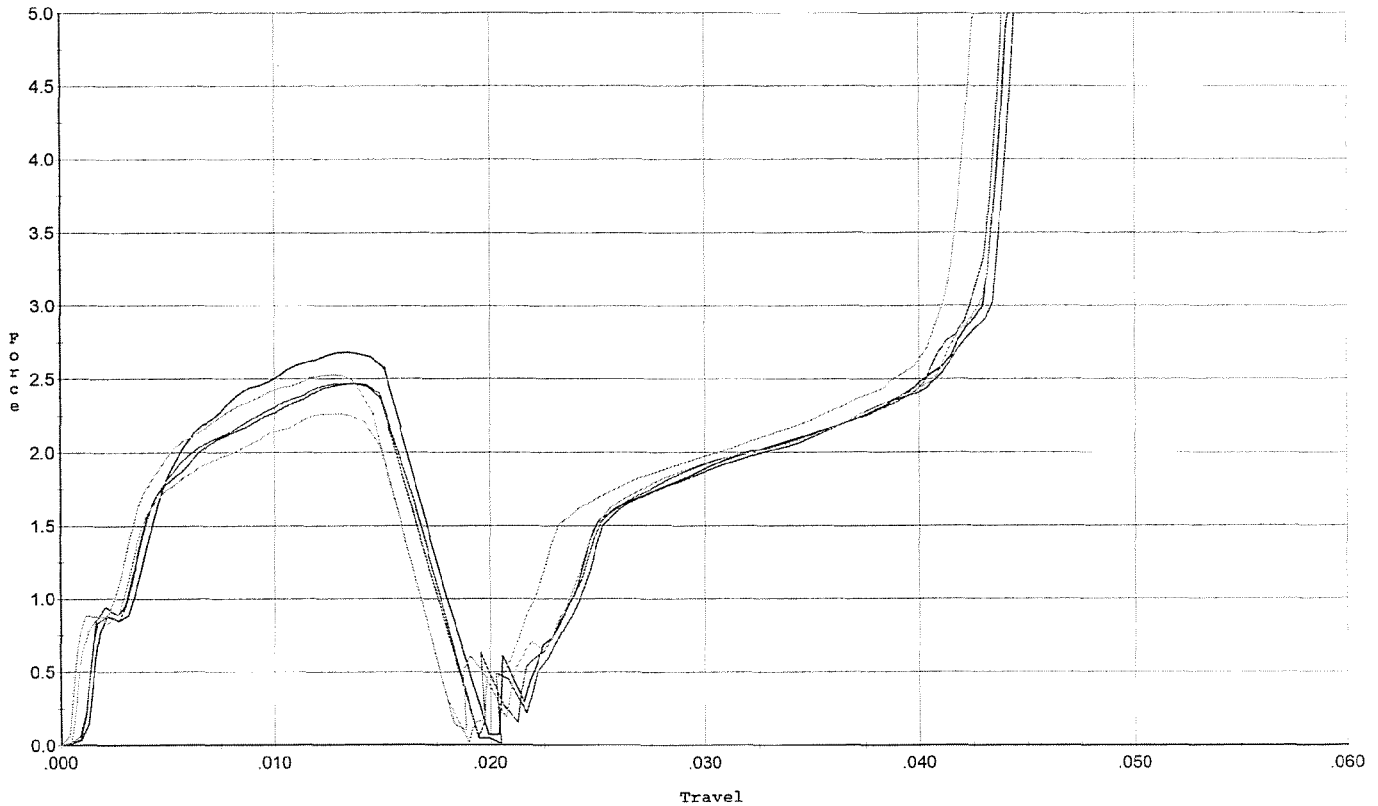
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.569      | 0.015             | 0.00            | 0.032      | 0.026             |           | Set Trigger |
| 2 | 2.311      | 0.015             | 0.004           | 0.032      | 0.023             |           | Set Trigger |
| 3 | 2.428      | 0.015             | 0.00            | 0.032      | 0.025             |           | Set Trigger |
| 4 | 2.401      | 0.015             | 0.00            | 0.032      | 0.025             |           | Set Trigger |
| 5 | 2.333      | 0.015             | 0.00            | 0.032      | 0.024             |           | Set Trigger |

A-2-40

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



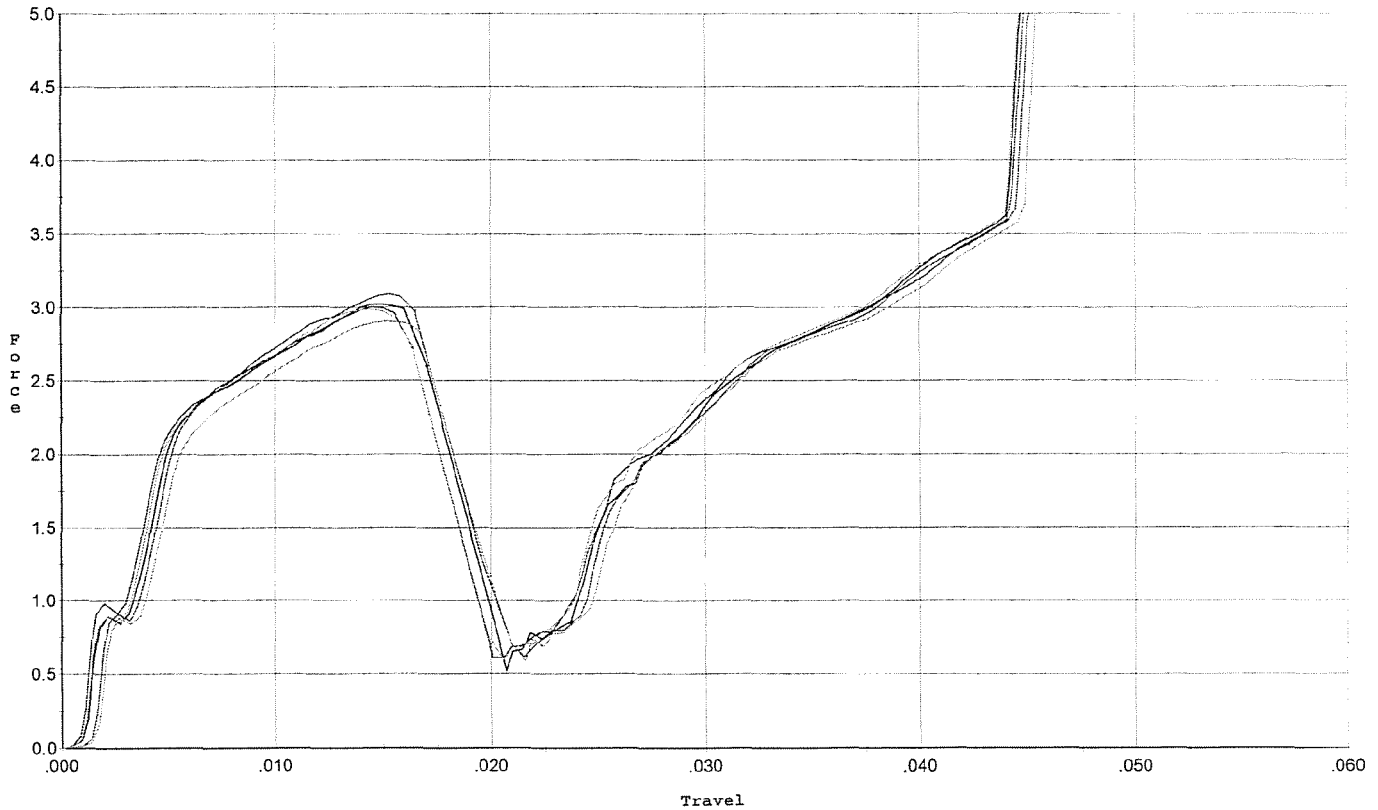
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtavel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|-----------|-------------------|-----------|-------------|
| 1 | 2.469      | 0.016             | 0.00            | 0.032     | 0.028             |           | Set Trigger |
| 2 | 2.680      | 0.015             | 0.00            | 0.032     | 0.027             |           | Set Trigger |
| 3 | 2.467      | 0.015             | 0.00            | 0.032     | 0.025             |           | Set Trigger |
| 4 | 2.265      | 0.015             | 0.00            | 0.033     | 0.024             |           | Set Trigger |
| 5 | 2.529      | 0.015             | 0.002           | 0.031     | 0.026             |           | Set Trigger |

A-2-48

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



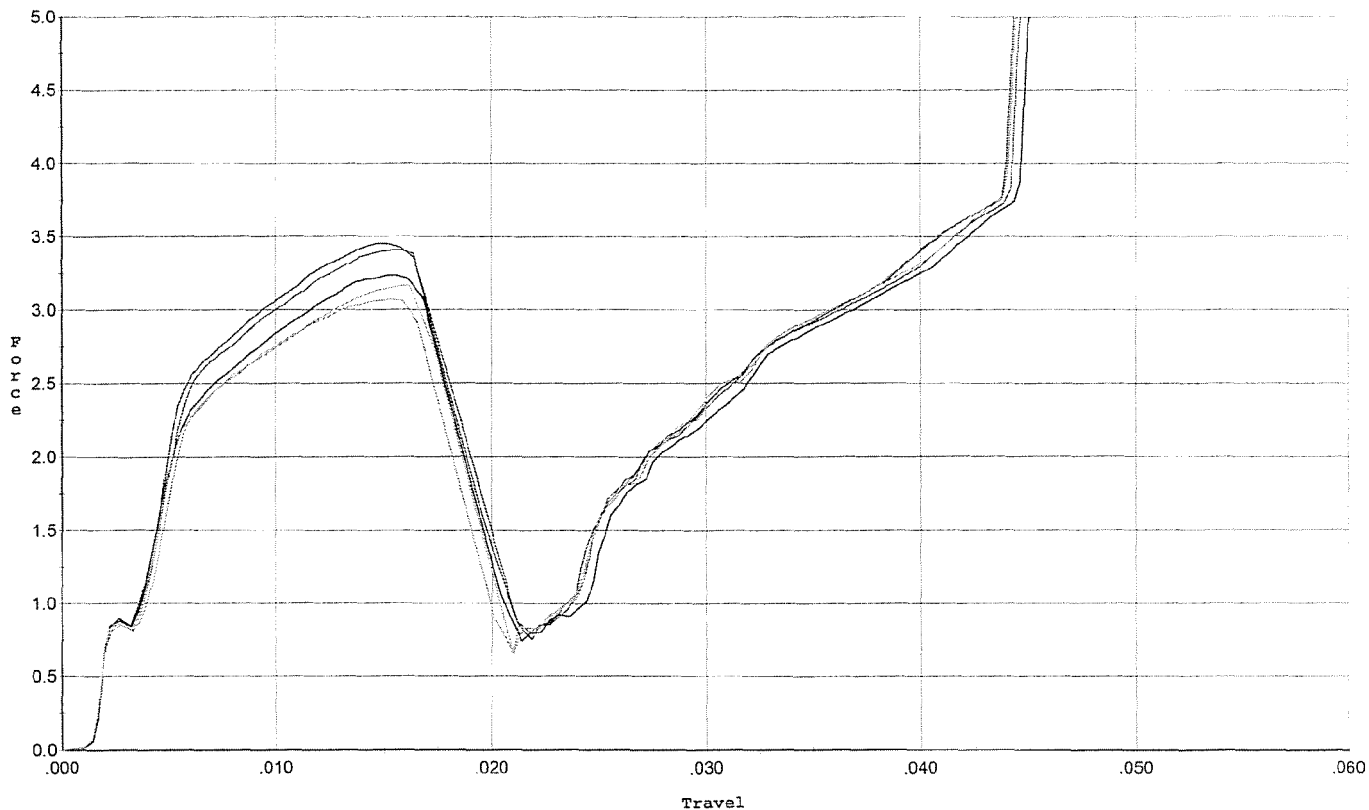
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.001      | 0.016             | 0.00            | 0.030      | 0.033             |           | Set Trigger |
| 2 | 3.019      | 0.017             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 3 | 3.089      | 0.016             | 0.00            | 0.030      | 0.033             |           | Set Trigger |
| 4 | 2.987      | 0.016             | 0.00            | 0.030      | 0.033             |           | Set Trigger |
| 5 | 2.904      | 0.017             | 0.00            | 0.030      | 0.032             |           | Set Trigger |

A.3.00

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



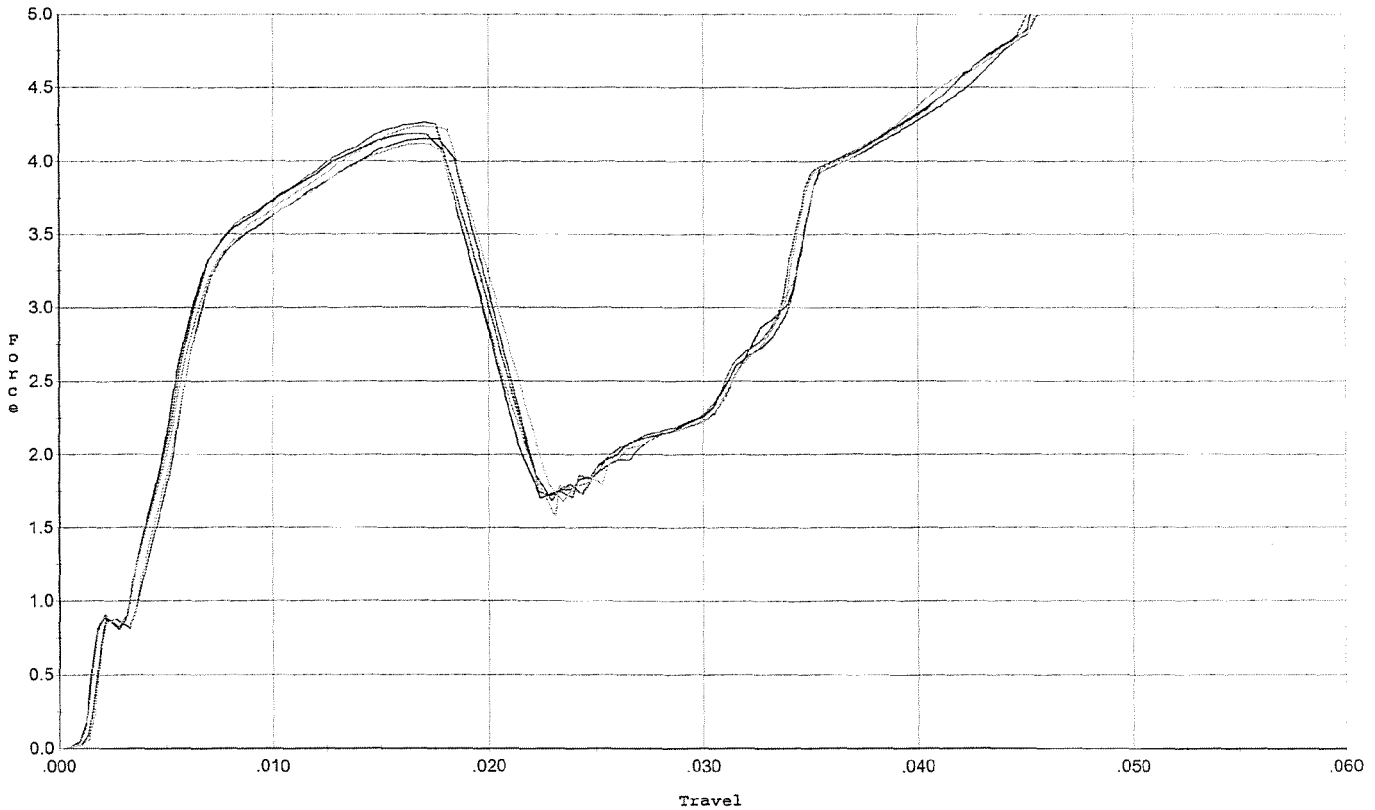
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.452      | 0.016             | 0.00            | 0.029      | 0.037             |           | Set Trigger |
| 2 | 3.234      | 0.017             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 3 | 3.405      | 0.019             | 0.00            | 0.029      | 0.041             |           | Set Trigger |
| 4 | 3.162      | 0.017             | 0.00            | 0.029      | 0.035             |           | Set Trigger |
| 5 | 3.071      | 0.017             | 0.00            | 0.030      | 0.033             |           | Set Trigger |

A-3.26

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



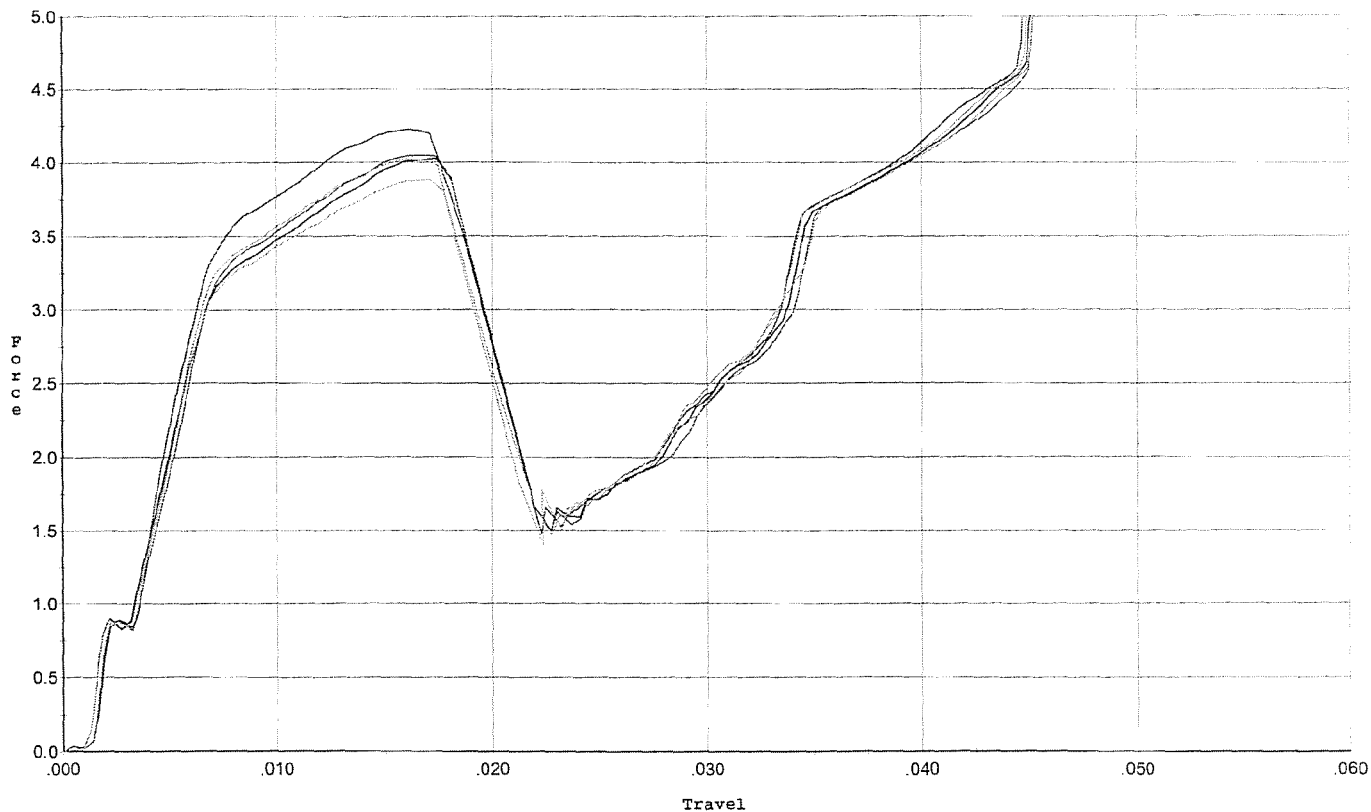
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.151      | 0.018             | 0.004           | 0.027      | 0.049             |           | Set Trigger |
| 2 | 4.185      | 0.018             | 0.00            | 0.028      | 0.049             |           | Set Trigger |
| 3 | 4.260      | 0.020             | 0.00            | 0.027      | 0.054             |           | Set Trigger |
| 4 | 4.235      | 0.018             | 0.00            | 0.027      | 0.049             |           | Set Trigger |
| 5 | 4.118      | 0.018             | 0.00            | 0.028      | 0.048             |           | Set Trigger |

A-4.19

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



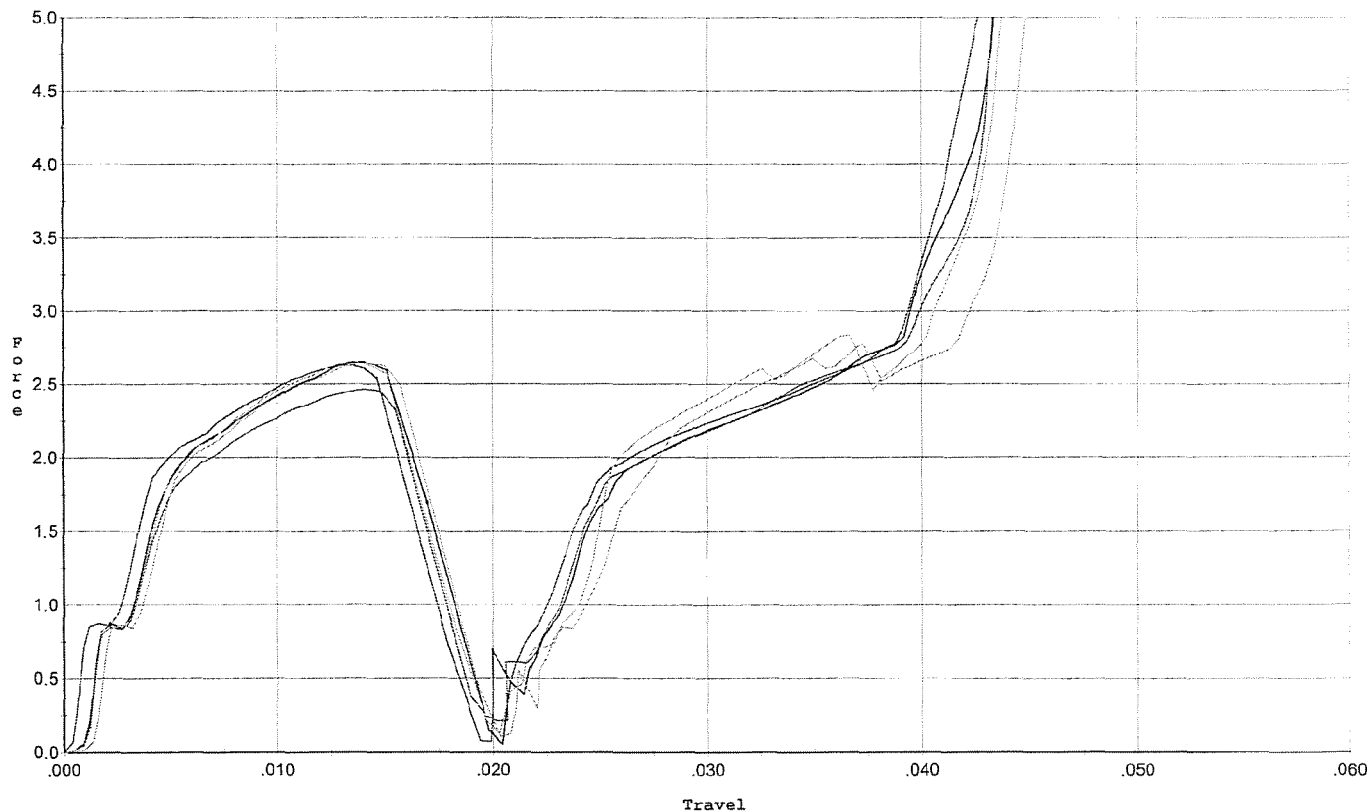
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.222      | 0.019             | 0.00            | 0.027      | 0.051             |           | Set Trigger |
| 2 | 4.025      | 0.018             | 0.00            | 0.028      | 0.047             |           | Set Trigger |
| 3 | 4.049      | 0.018             | 0.00            | 0.028      | 0.047             |           | Set Trigger |
| 4 | 3.885      | 0.018             | 0.00            | 0.028      | 0.045             |           | Set Trigger |
| 5 | 4.018      | 0.017             | 0.004           | 0.028      | 0.045             |           | Set Trigger |

A-4.04

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



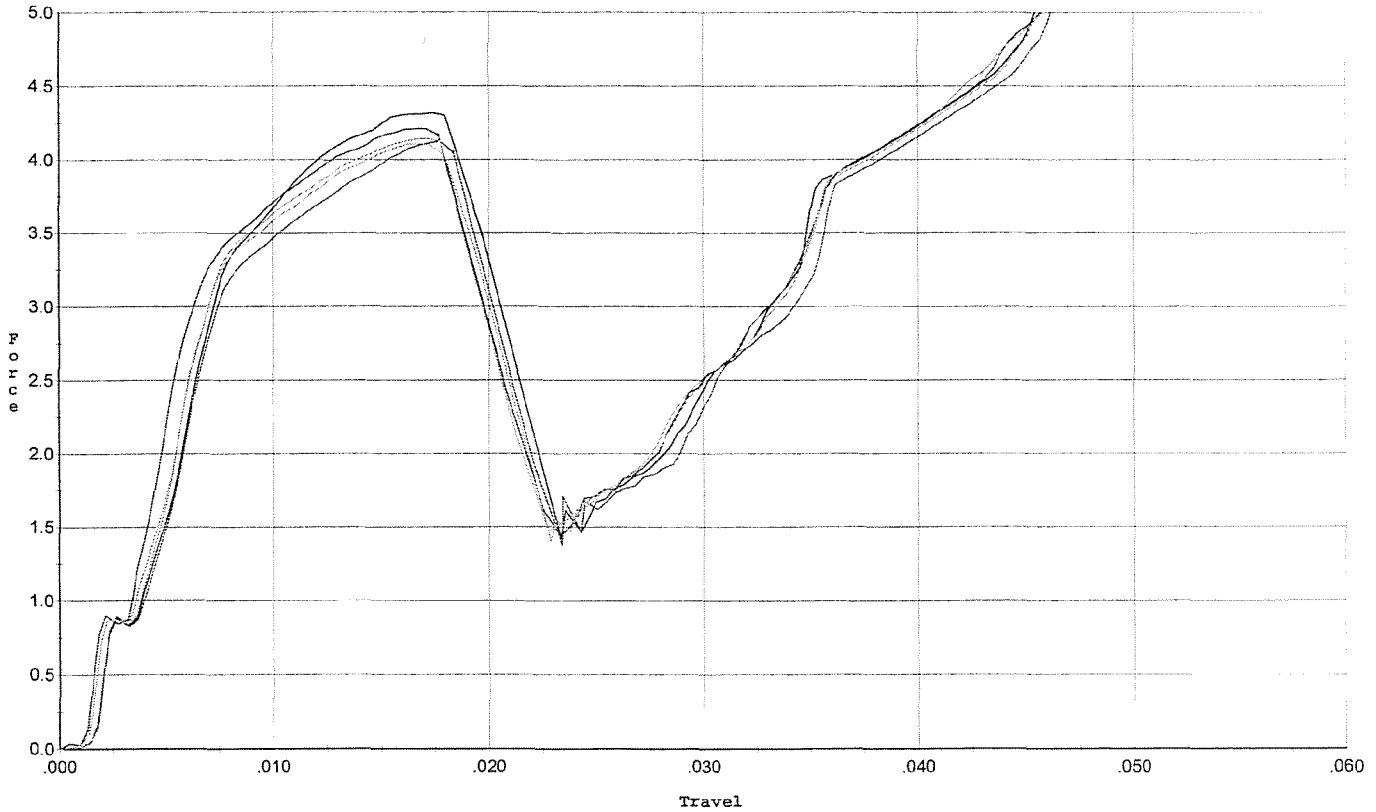
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.628      | 0.015             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 2 | 2.650      | 0.017             | 0.00            | 0.030      | 0.030             |           | Set Trigger |
| 3 | 2.464      | 0.015             | 0.00            | 0.031      | 0.026             |           | Set Trigger |
| 4 | 2.653      | 0.015             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 5 | 2.646      | 0.016             | 0.00            | 0.031      | 0.028             |           | Set Trigger |

A-2-60

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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 | 4.211      | 0.018             | 0.00            | 0.028      | 0.048             |           | Set Trigger |
| 2 | 4.318      | 0.020             | 0.00            | 0.028      | 0.053             |           | Set Trigger |
| 3 | 4.124      | 0.018             | 0.00            | 0.029      | 0.047             |           | Set Trigger |
| 4 | 4.108      | 0.018             | 0.004           | 0.028      | 0.047             |           | Set Trigger |
| 5 | 4.144      | 0.019             | 0.00            | 0.028      | 0.051             |           | Set Trigger |

A-4.18