

G 6801490

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

- INSTRUCTION BOOK 3518

proof of purchase

owner registration sticker



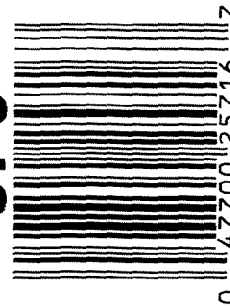
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801490

UPC



BM FORM

GUN SERIAL # G 6801490

| OP #            | OPERATION NAME                                                                                                                         | READINGS | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|----------|---------|---------|
| 420             | ASSEMBLE ACTION                                                                                                                        |          | 3-20-09 | SPD     |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |          | 3-20-09 | RP      |
| 440             | PROOF                                                                                                                                  |          | 3-20-09 | SPD     |
| 460             | CHECK HEADSPACE                                                                                                                        |          | 3-20-09 | RP      |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |          | 3-20-09 | RP      |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  |          | 3-23-09 | TC      |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 3-23-09 | SP      |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | (A)      | 3-25-09 | (A)     |
| 490             | MAGNAFLUX BOLT                                                                                                                         |          |         |         |
| 500             | ROLLMARK CALIBER                                                                                                                       |          | 3/25/09 | RT      |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |          | 3-25    | BT      |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 3-28    | —       |
| 545             | (BOLT)                                                                                                                                 |          |         |         |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |          |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 3-30-09 | TC      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 3-30-09 | TC      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 3-30-09 | TC      |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 14-2-09 | SPD     |
|                 | 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 |                                                                                                                                        |          |         |         |

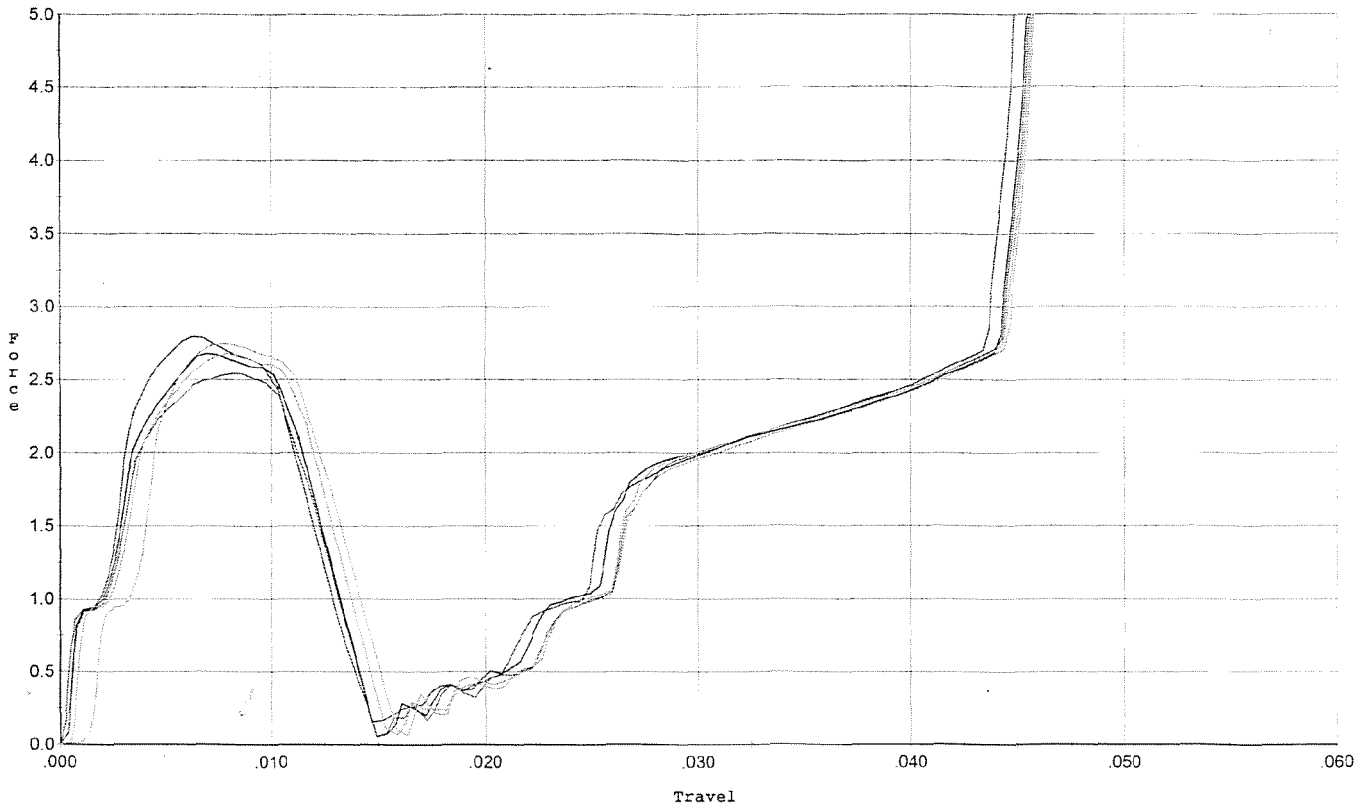
| OP #         | OPERATION NAME                                                           | READINGS                                               | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|--------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>8</u> <u>7.5</u> <u>8</u>                           | 4-18-09 | WV      |
| CONT.        |                                                                          |                                                        |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3.5</u> <u>3.5</u> <u>3.5</u>                       | 4-13-09 | WV      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                        |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.024</u> <u>.024</u>                    | 4-13-09 | WV      |
|              | J) ASSEMBLE STOCK                                                        |                                                        | 4-2-09  | RP      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                        | 4-13-09 | 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                   | 4-4-09  | RP      |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                             |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                        | 4-4-09  | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                        | 4-13-09 | WV      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>288</u> <u>284</u> <u>285</u> <u>277</u> <u>275</u> | 4-7-09  | RP      |
|              | C) FUNCTION                                                              |                                                        | 4-13-09 | WV      |
| 690          | PACK                                                                     |                                                        | 5/29/09 | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



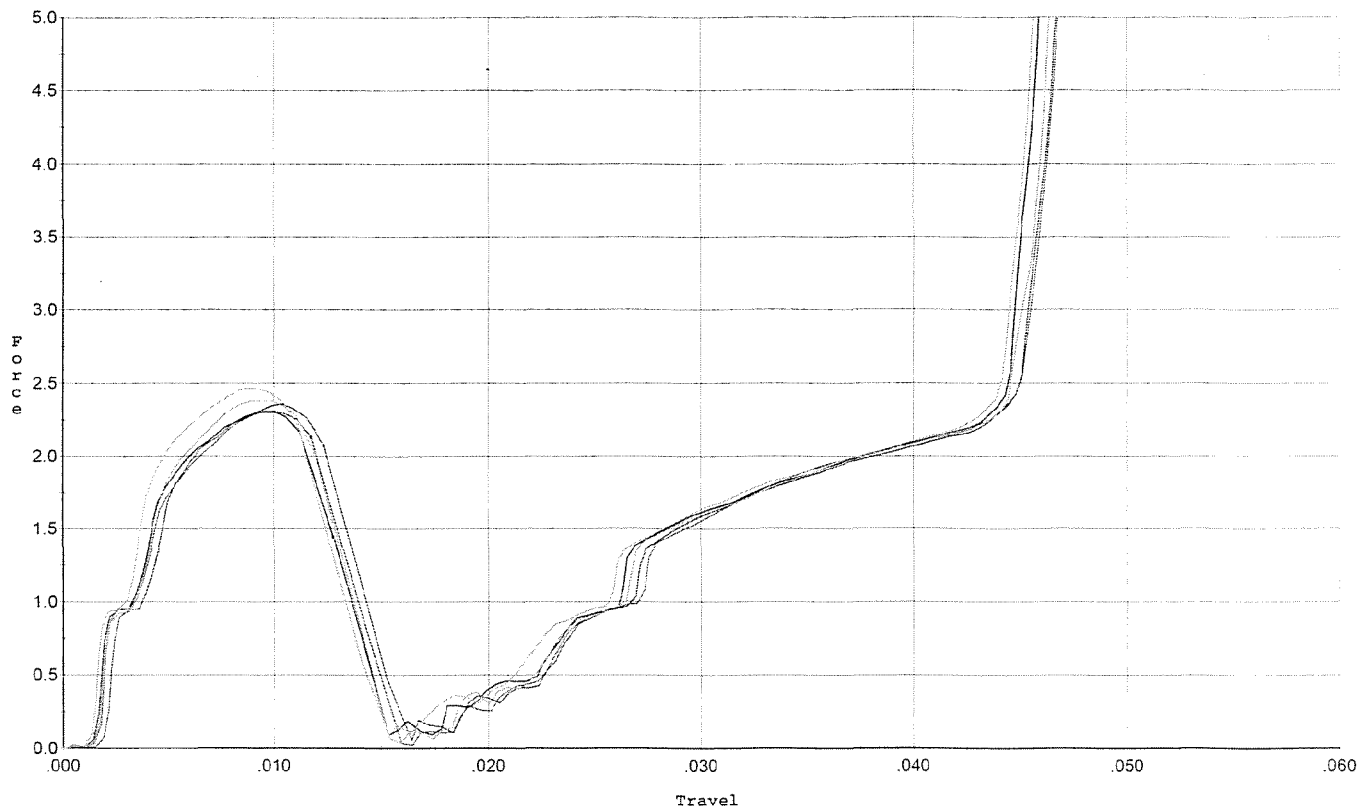
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.796      | 0.010             | 0.00            | 0.037      | 0.020             |           | Set Trigger |
| 2 | 2.677      | 0.011             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 3 | 2.545      | 0.012             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 4 | 2.680      | 0.012             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 5 | 2.750      | 0.013             | 0.00            | 0.037      | 0.022             |           | Set Trigger |

A-2-69

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



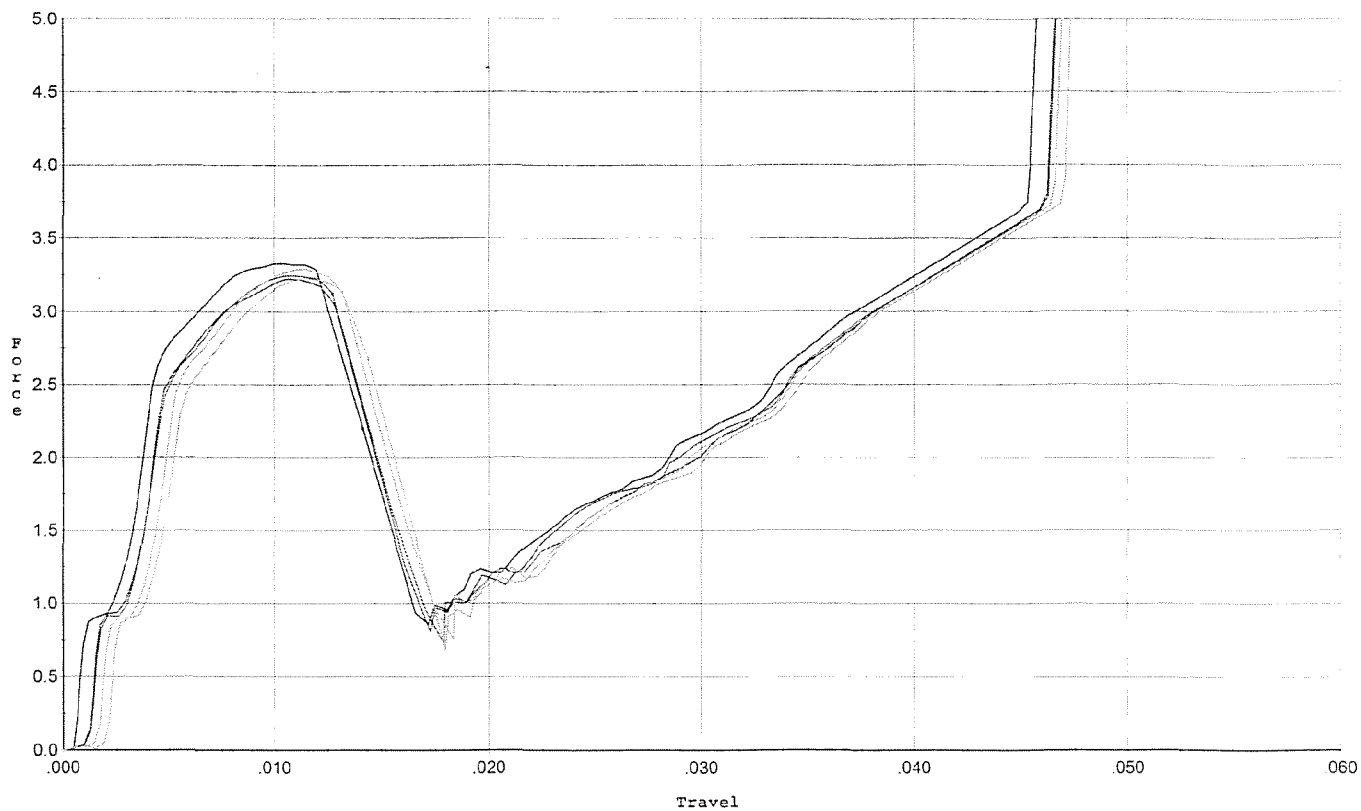
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.356      | 0.012             | 0.002           | 0.038      | 0.018             |           | Set Trigger |
| 2 | 2.305      | 0.013             | 0.00            | 0.037      | 0.019             |           | Set Trigger |
| 3 | 2.311      | 0.012             | 0.00            | 0.038      | 0.017             |           | Set Trigger |
| 4 | 2.466      | 0.011             | 0.00            | 0.038      | 0.018             |           | Set Trigger |
| 5 | 2.384      | 0.012             | 0.00            | 0.038      | 0.018             |           | Set Trigger |

A-236

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



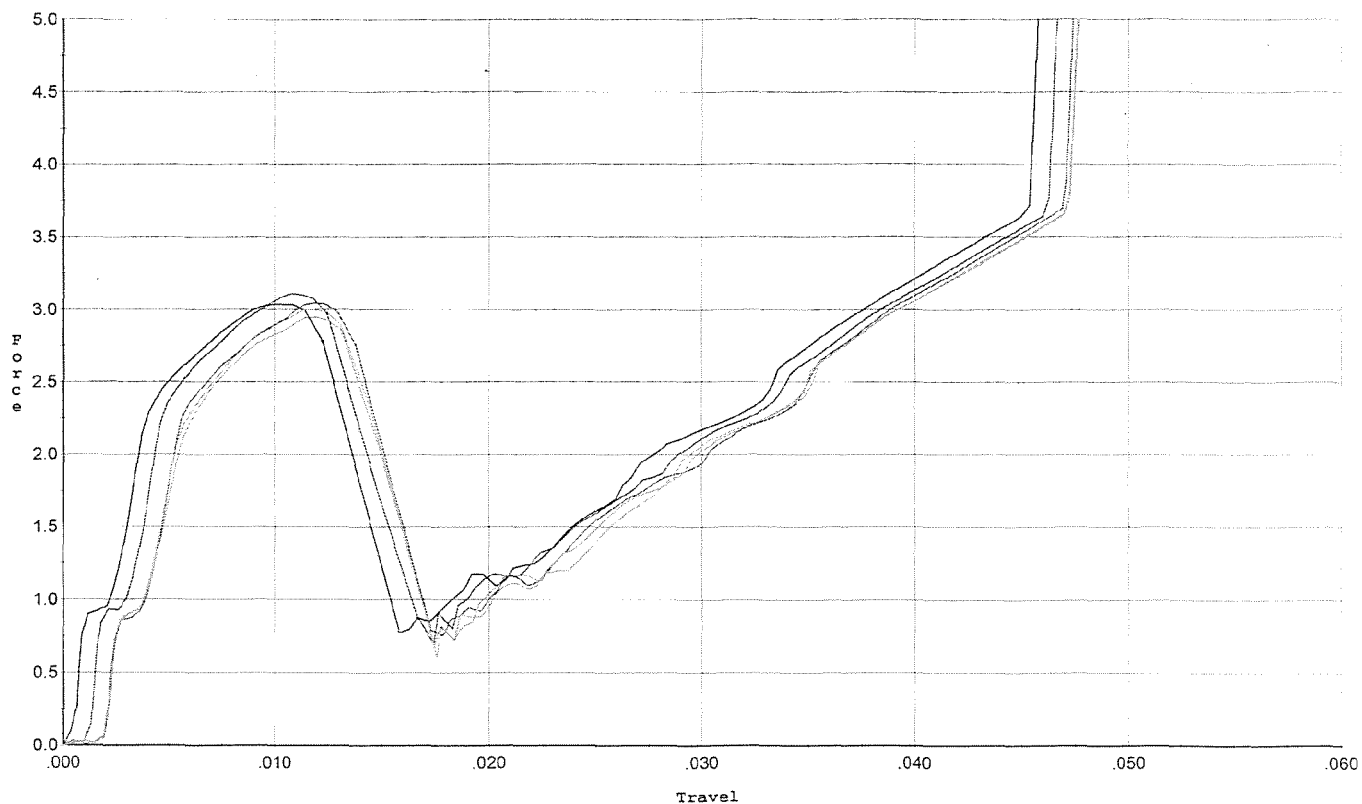
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.224      | 0.013             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 2 | 3.329      | 0.014             | 0.00            | 0.034      | 0.031             |           | Set Trigger |
| 3 | 3.245      | 0.013             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 4 | 3.288      | 0.013             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 5 | 3.223      | 0.014             | 0.00            | 0.035      | 0.028             |           | Set Trigger |

A-3-26

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



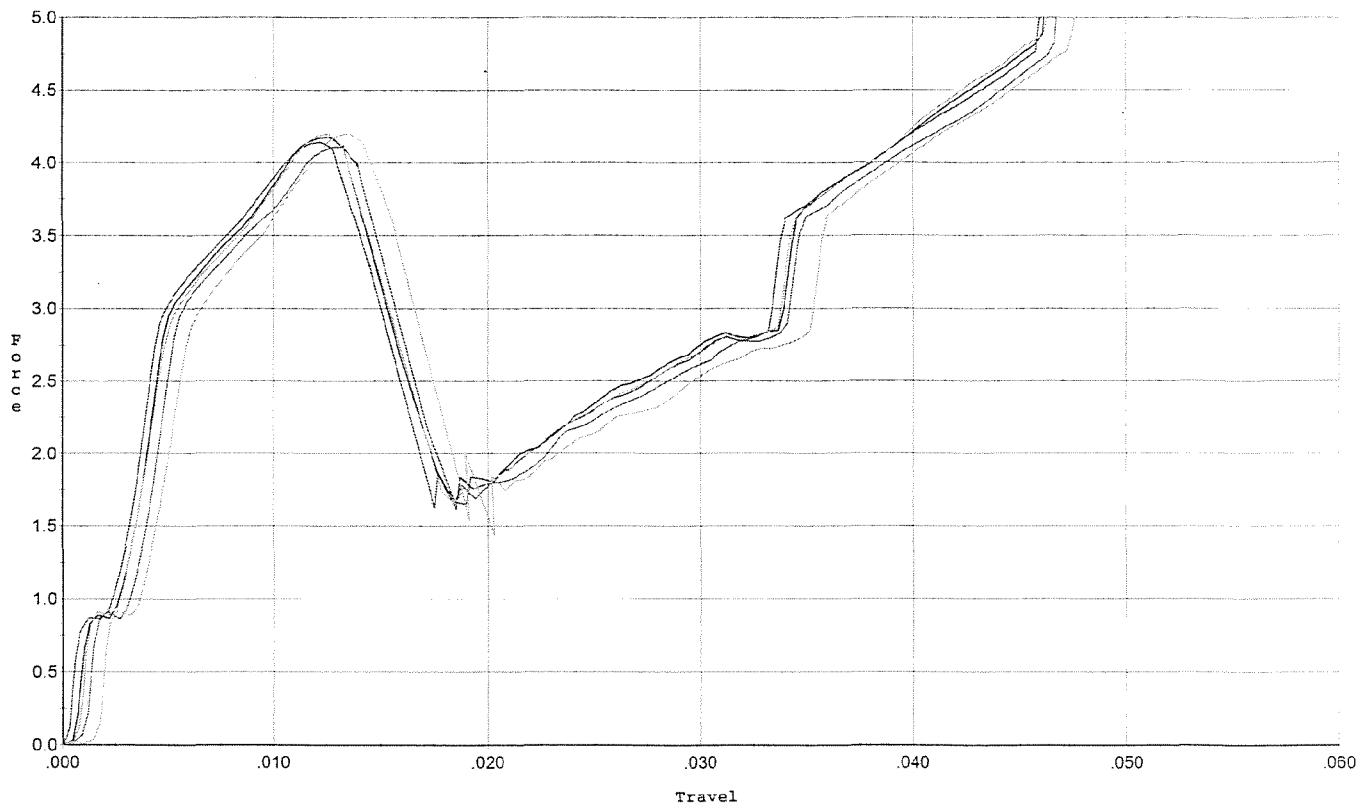
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.109      | 0.012             | 0.00            | 0.035      | 0.025             |           | Set Trigger |
| 2 | 3.036      | 0.012             | 0.00            | 0.035      | 0.025             |           | Set Trigger |
| 3 | 3.045      | 0.014             | 0.00            | 0.035      | 0.026             |           | Set Trigger |
| 4 | 2.997      | 0.014             | 0.002           | 0.036      | 0.027             |           | Set Trigger |
| 5 | 2.949      | 0.015             | 0.00            | 0.036      | 0.027             |           | Set Trigger |

A-3.02

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



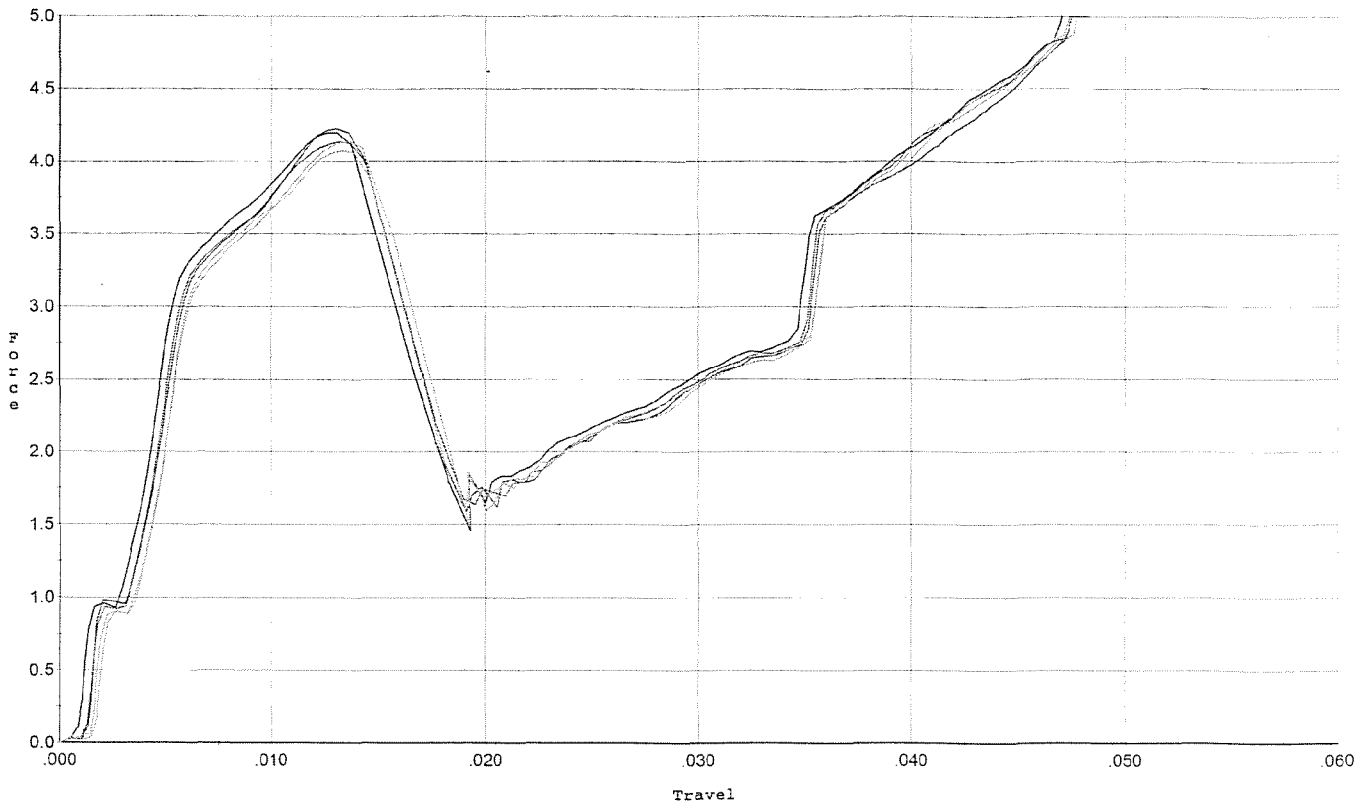
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.142      | 0.014             | 0.00            | 0.032      | 0.038             |           | Set Trigger |
| 2 | 4.177      | 0.013             | 0.00            | 0.032      | 0.034             |           | Set Trigger |
| 3 | 4.106      | 0.014             | 0.00            | 0.032      | 0.035             |           | Set Trigger |
| 4 | 4.198      | 0.015             | 0.00            | 0.032      | 0.038             |           | Set Trigger |
| 5 | 4.199      | 0.016             | 0.00            | 0.032      | 0.040             |           | Set Trigger |

A-4.16

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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



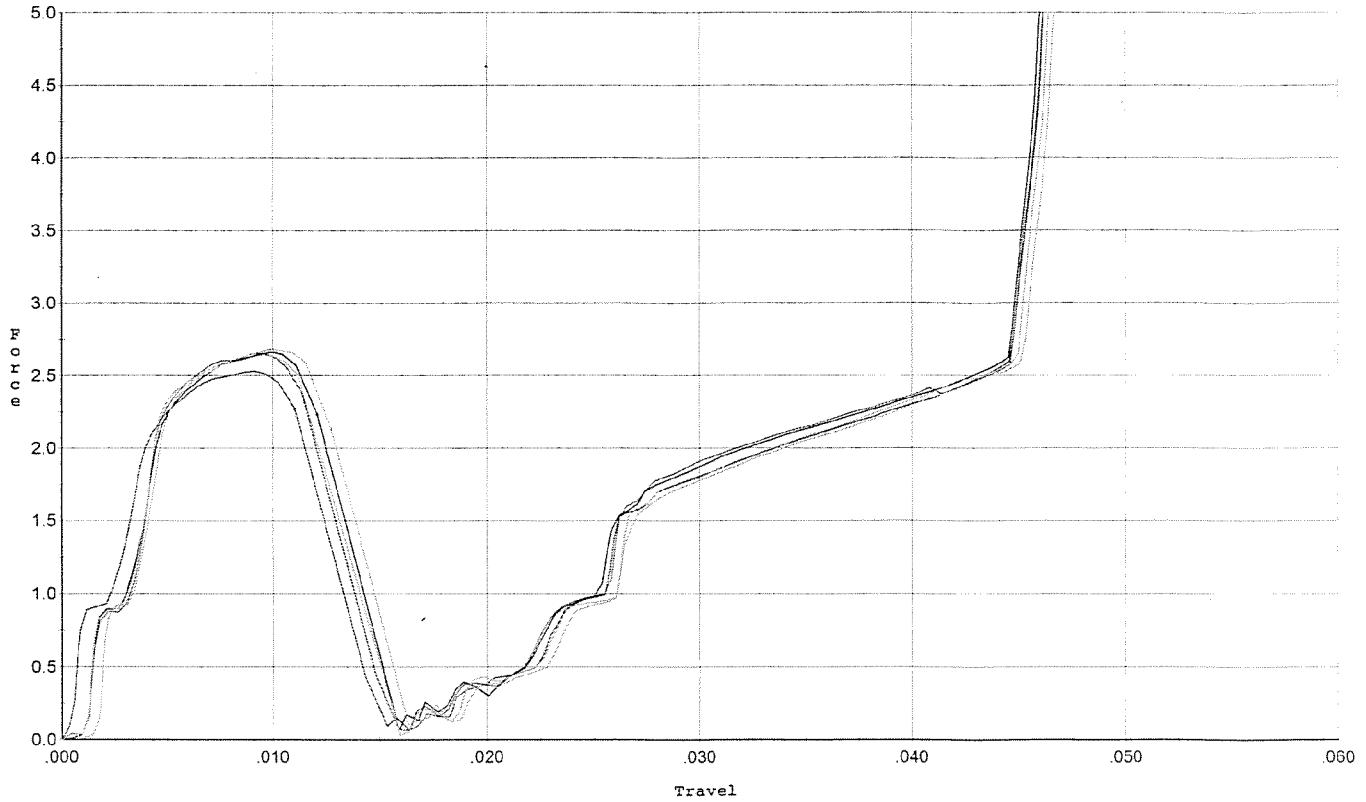
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.225      | 0.014             | 0.003           | 0.032      | 0.037             |           | Set Trigger |
| 2 | 4.199      | 0.014             | 0.00            | 0.032      | 0.036             |           | Set Trigger |
| 3 | 4.139      | 0.014             | 0.00            | 0.032      | 0.037             |           | Set Trigger |
| 4 | 4.076      | 0.015             | 0.00            | 0.033      | 0.036             |           | Set Trigger |
| 5 | 4.141      | 0.016             | 0.00            | 0.032      | 0.039             |           | Set Trigger |

A-4.15

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 2/27/2009

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



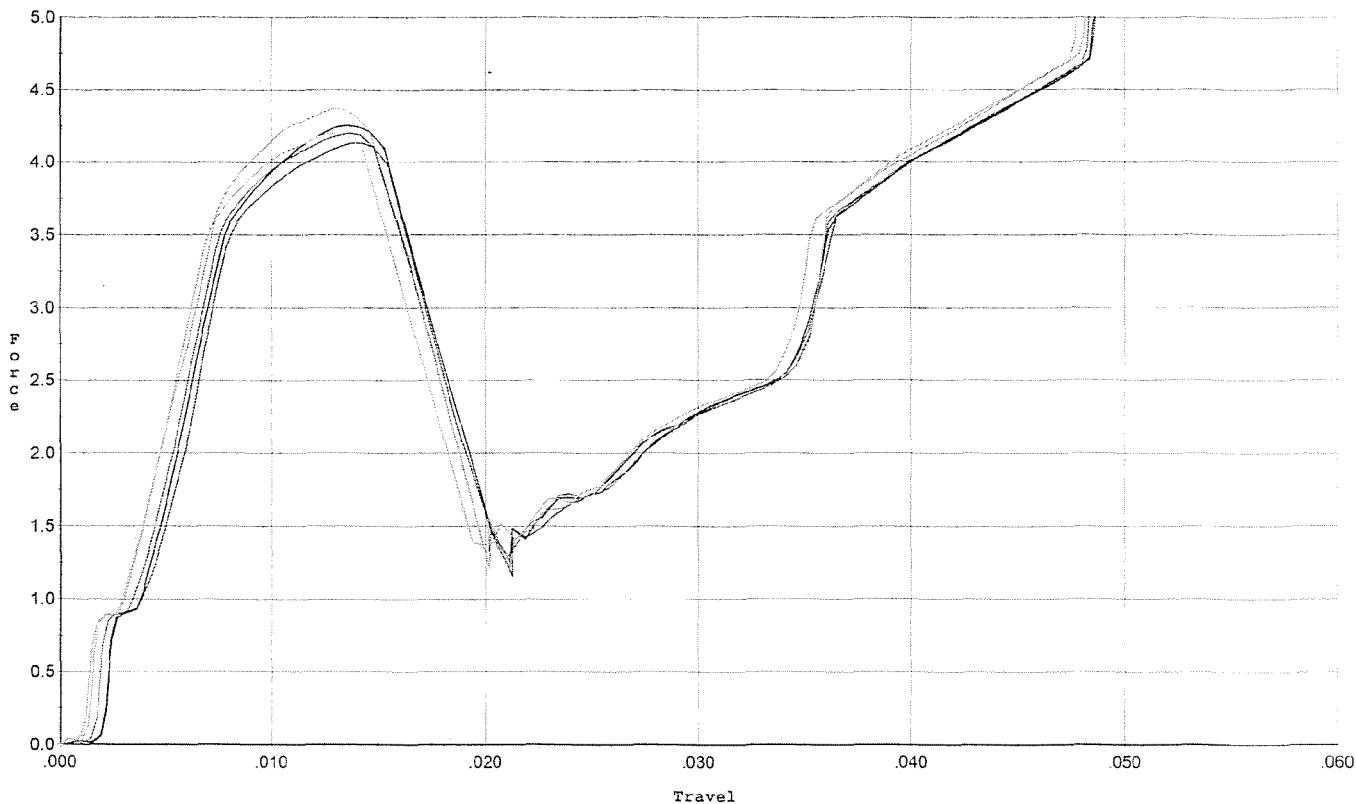
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.531      | 0.011             | 0.00            | 0.038      | 0.019             |           | Set Trigger |
| 2 | 2.661      | 0.012             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 3 | 2.655      | 0.011             | 0.00            | 0.038      | 0.020             |           | Set Trigger |
| 4 | 2.641      | 0.014             | 0.00            | 0.037      | 0.023             |           | Set Trigger |
| 5 | 2.682      | 0.013             | 0.00            | 0.037      | 0.022             |           | Set Trigger |

A-2-63

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/27/2009

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 | 4.131      | 0.015             | 0.00            | 0.033      | 0.038             |           | Set Trigger |
| 2 | 4.257      | 0.015             | 0.00            | 0.033      | 0.039             |           | Set Trigger |
| 3 | 4.200      | 0.017             | 0.00            | 0.033      | 0.042             |           | Set Trigger |
| 4 | 4.197      | 0.017             | 0.00            | 0.033      | 0.044             |           | Set Trigger |
| 5 | 4.369      | 0.016             | 0.00            | 0.033      | 0.044             |           | Set Trigger |

A-4.23