

66807744

**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



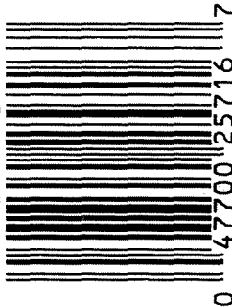
owner registration sticker



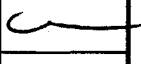
|               |              |
|---------------|--------------|
| ORDER NO.     | <b>25716</b> |
| BARREL LENGTH | <b>24"</b>   |
| CAPACITY      | <b>6</b>     |

**G6807744**

**UPC**



GUN SERIAL # G6807744

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                              |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|--------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 2-27-09 | SPD                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 2-27-09 | RP                                                                                   |
| 440  | PROOF                                                                                                                                  |                                                                                             | 2-27-09 | SPD                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                                                                                | 2-27-09 | RP                                                                                   |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 2-27-09 | RP                                                                                   |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                             | 3-2-09  | SP                                                                                   |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/5/09  |   |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 3/5/09  | ma                                                                                   |
| 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)                                                                                                      |                                                                                             | 3/11    |  |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                      |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |                                                                                      |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 3-12-09 | SP                                                                                   |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-12-09 | SP                                                                                   |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-12-09 | SP                                                                                   |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-13-09 | 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> |                                                                                             |         |                                                                                      |

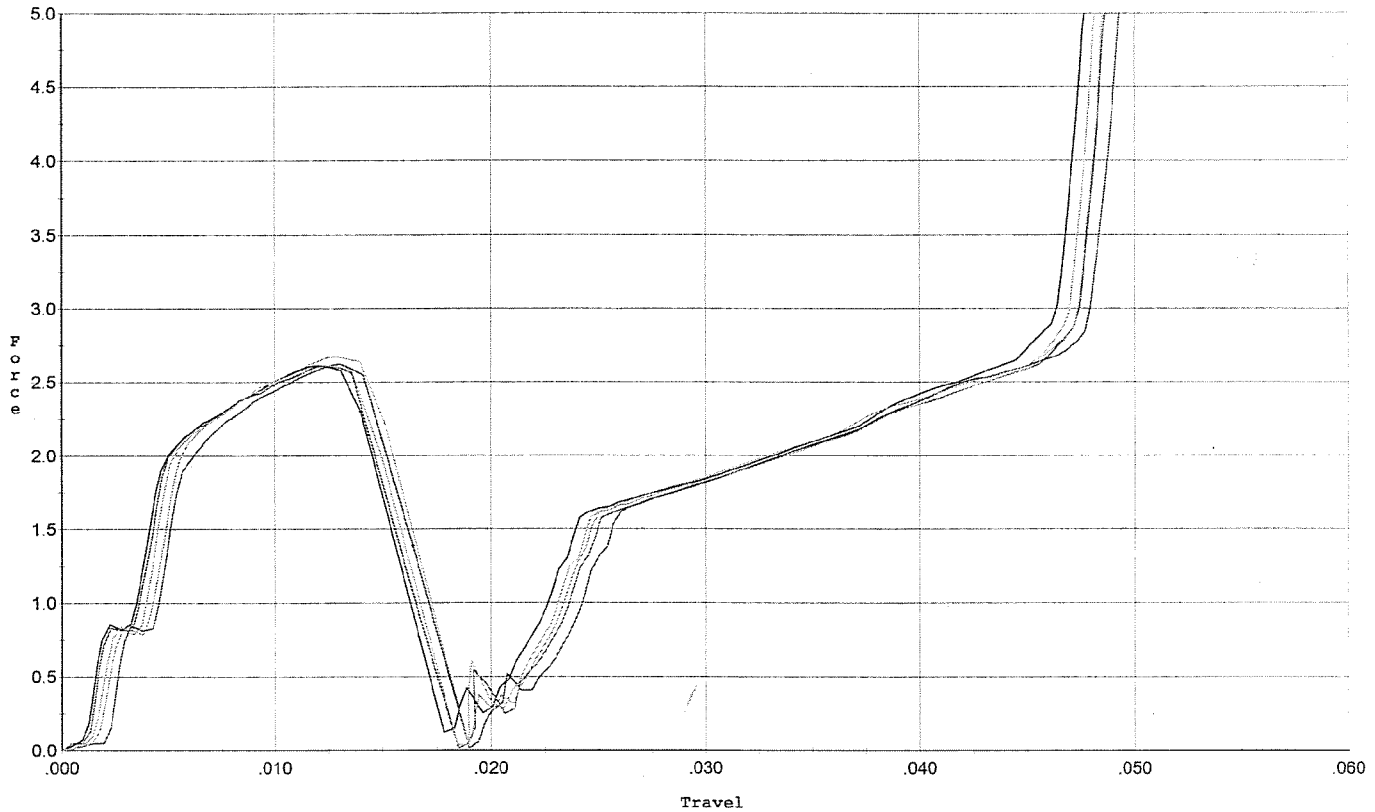
F004 REV 5/2006

| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4</u> <u>4</u> <u>4</u>                                  | 3-20-09 | WV      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3</u> <u>3</u> <u>3</u>                                  | 3-20-09 | WV      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.024</u> <u>.023</u>                         | 3-20-09 | WV      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-13-09 | RP      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-20-09 | 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                        | 3-18-09 | RP      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-18-09 | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-20-09 | WV      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.59</u> <u>2.54</u> <u>2.51</u> <u>2.49</u> <u>2.49</u> | 3-19-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3-20-09 | WV      |
| 690          | PACK                                                                     |                                                             | 3-20-09 | TL      |

## 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



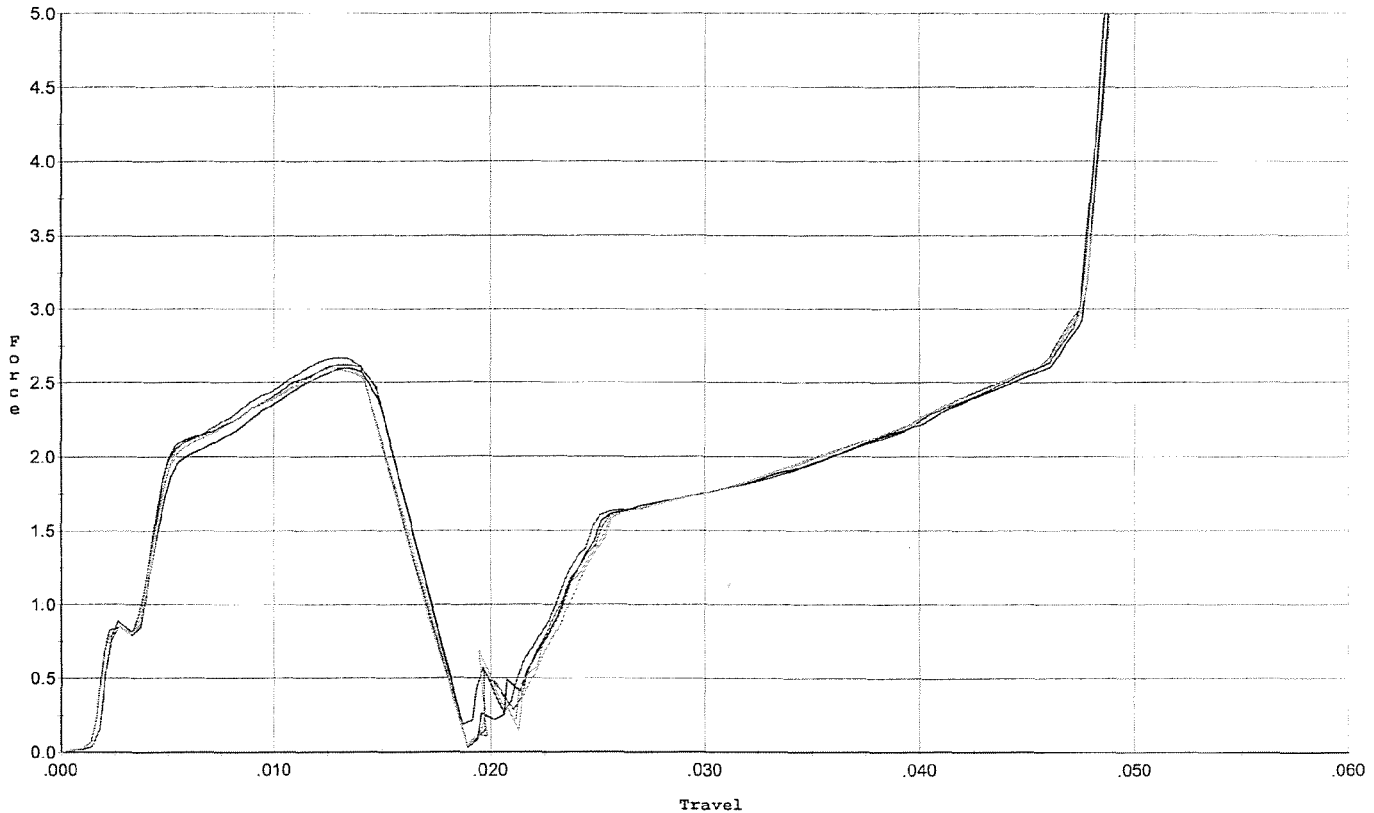
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.623      | 0.016             | 0.00            | 0.037      | 0.026             |           | Set Trigger |
| 2 | 2.612      | 0.014             | 0.00            | 0.037      | 0.024             |           | Set Trigger |
| 3 | 2.609      | 0.014             | 0.004           | 0.038      | 0.023             |           | Set Trigger |
| 4 | 2.609      | 0.015             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 5 | 2.672      | 0.015             | 0.004           | 0.036      | 0.026             |           | Set Trigger |

A-2.62

## 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



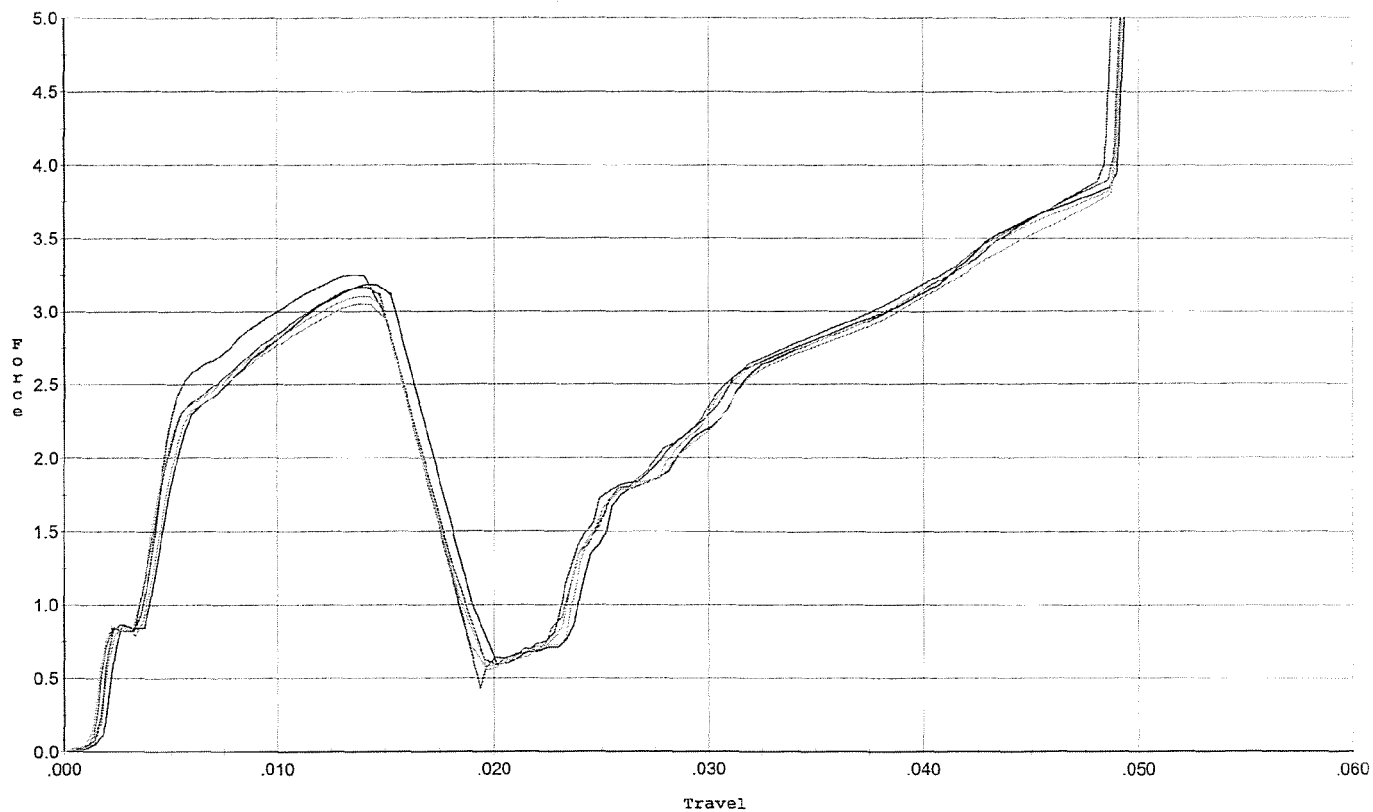
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.620      | 0.015             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 2 | 2.596      | 0.015             | 0.00            | 0.037      | 0.025             |           | Set Trigger |
| 3 | 2.668      | 0.014             | 0.00            | 0.037      | 0.024             |           | Set Trigger |
| 4 | 2.601      | 0.014             | 0.00            | 0.037      | 0.024             |           | Set Trigger |
| 5 | 2.585      | 0.016             | 0.00            | 0.037      | 0.027             |           | Set Trigger |

A-2.61

## 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



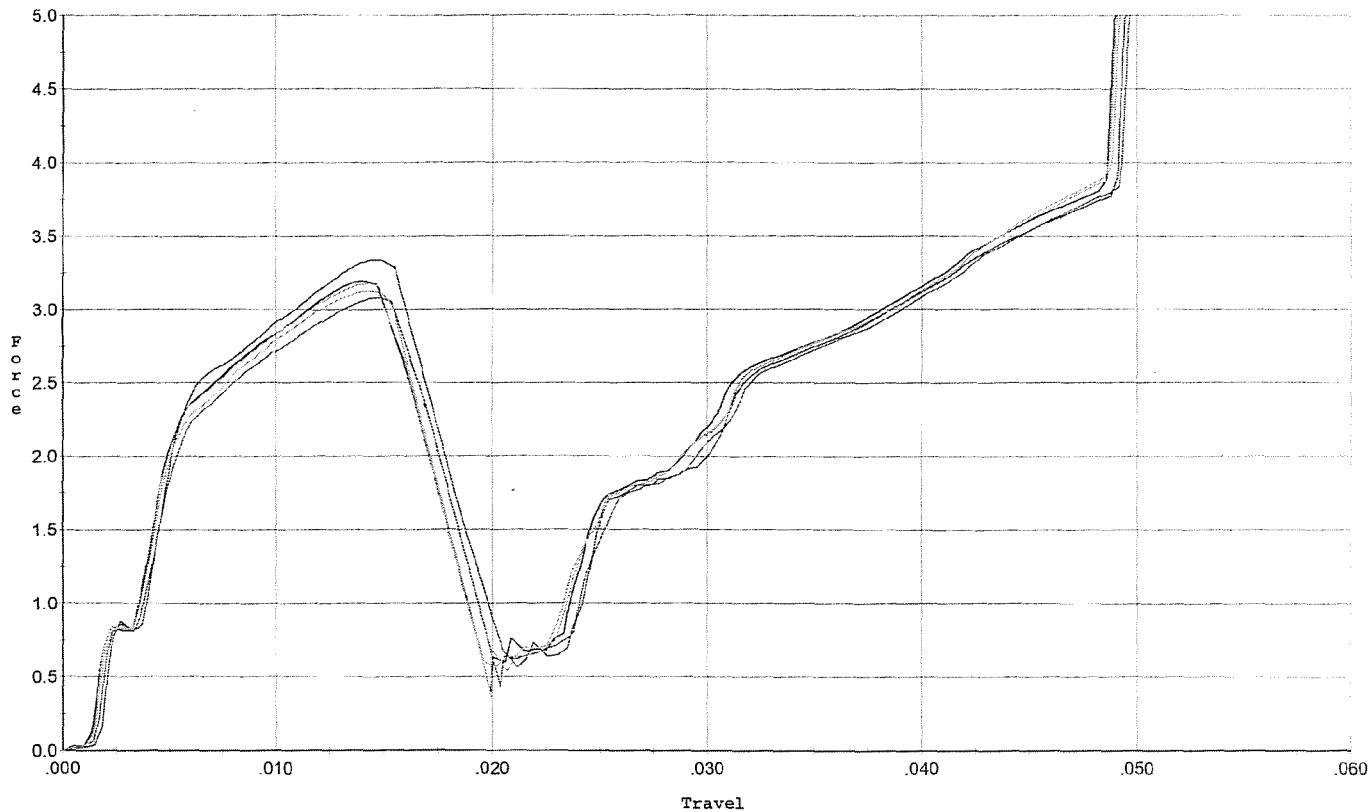
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.253      | 0.015             | 0.00            | 0.035      | 0.031             |           | Set Trigger |
| 2 | 3.186      | 0.015             | 0.004           | 0.035      | 0.030             |           | Set Trigger |
| 3 | 3.166      | 0.015             | 0.003           | 0.035      | 0.030             |           | Set Trigger |
| 4 | 3.105      | 0.015             | 0.00            | 0.035      | 0.030             |           | Set Trigger |
| 5 | 3.051      | 0.015             | 0.00            | 0.035      | 0.029             |           | Set Trigger |

A-3-15

## 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



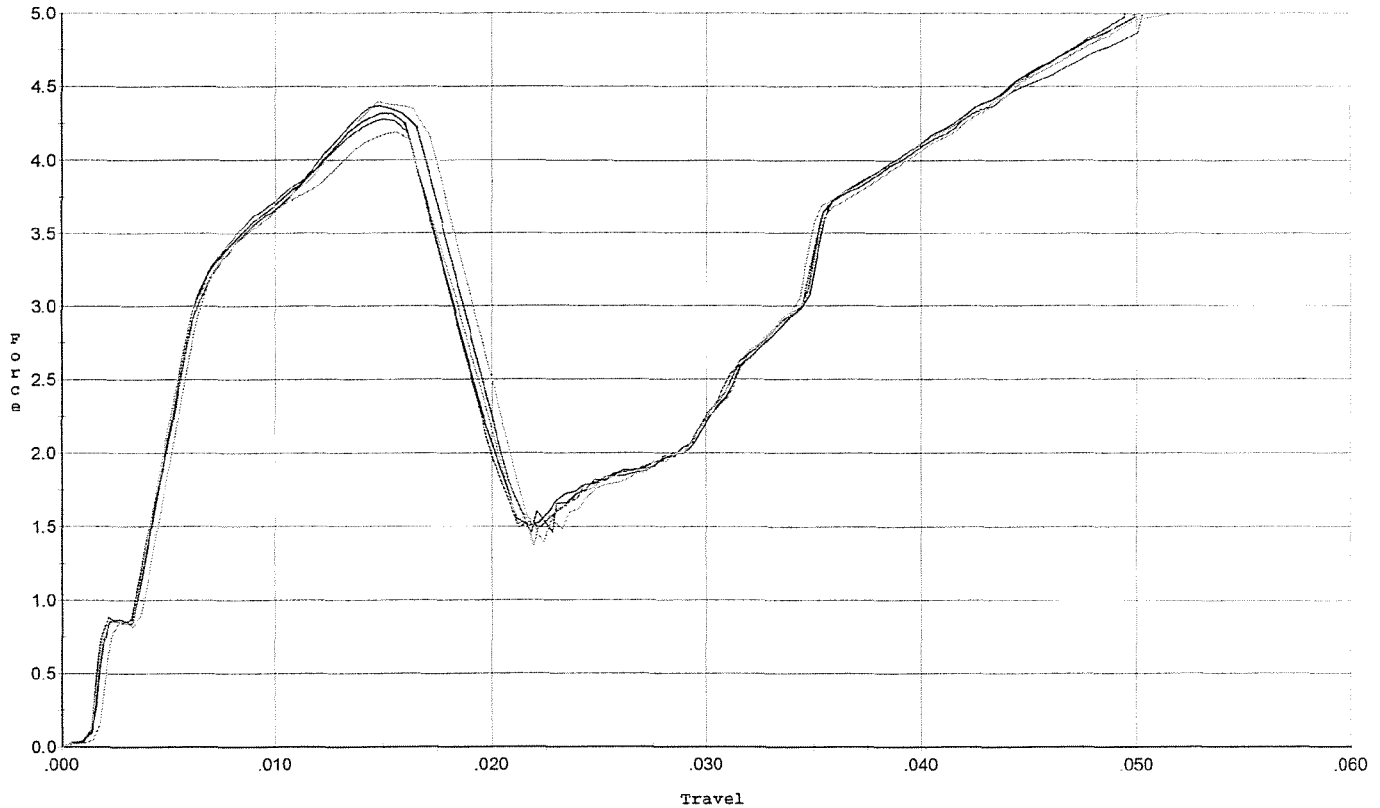
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.339      | 0.016             | 0.00            | 0.034      | 0.032             |           | Set Trigger |
| 2 | 3.194      | 0.016             | 0.004           | 0.034      | 0.033             |           | Set Trigger |
| 3 | 3.080      | 0.017             | 0.00            | 0.035      | 0.033             |           | Set Trigger |
| 4 | 3.127      | 0.016             | 0.00            | 0.035      | 0.032             |           | Set Trigger |
| 5 | 3.177      | 0.015             | 0.003           | 0.035      | 0.031             |           | Set Trigger |

A-3.18

## 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



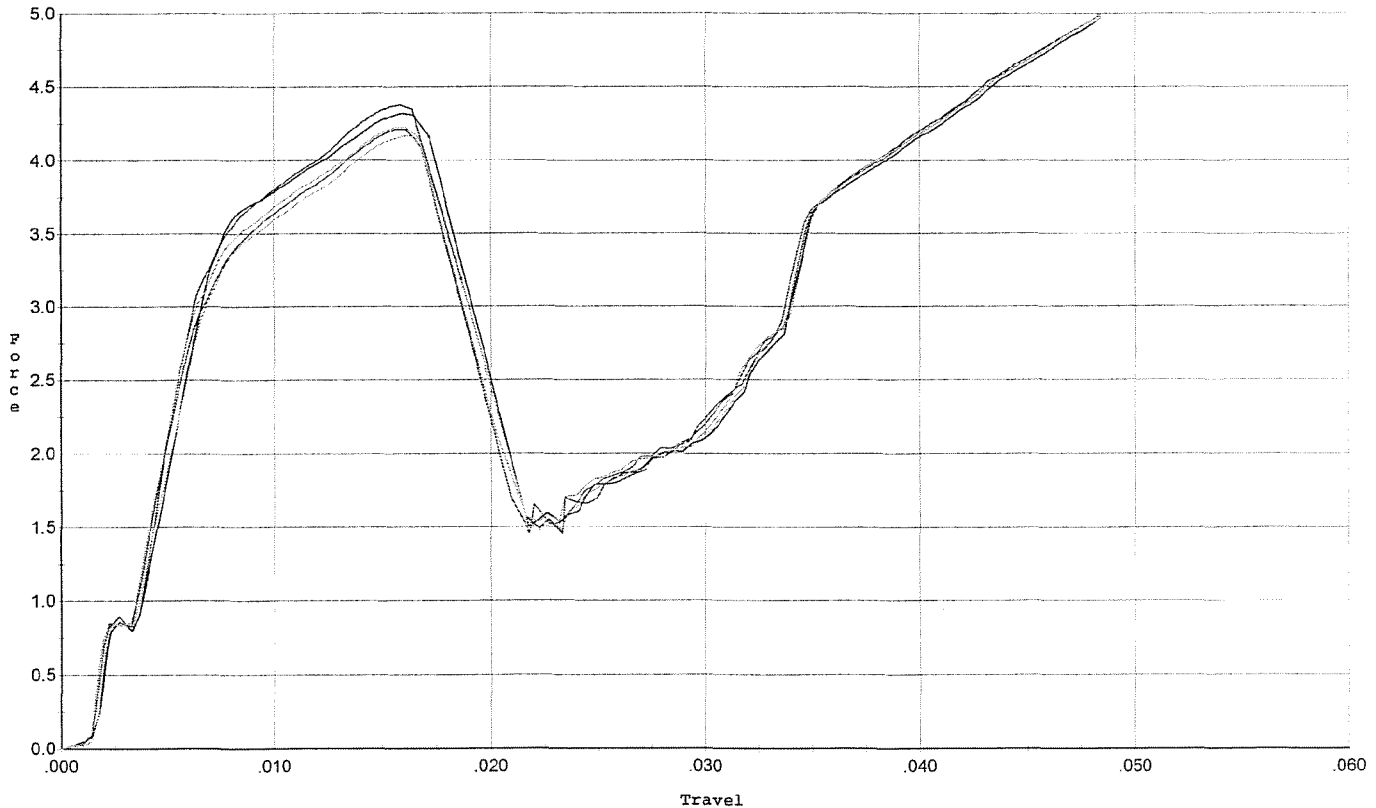
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.366      | 0.017             | 0.00            | 0.033      | 0.045             |           | Set Trigger |
| 2 | 4.318      | 0.016             | 0.00            | 0.033      | 0.042             |           | Set Trigger |
| 3 | 4.278      | 0.016             | 0.003           | 0.033      | 0.043             |           | Set Trigger |
| 4 | 4.398      | 0.017             | 0.00            | 0.032      | 0.046             |           | Set Trigger |
| 5 | 4.188      | 0.018             | 0.00            | 0.032      | 0.048             |           | Set Trigger |

A-4.31

## 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



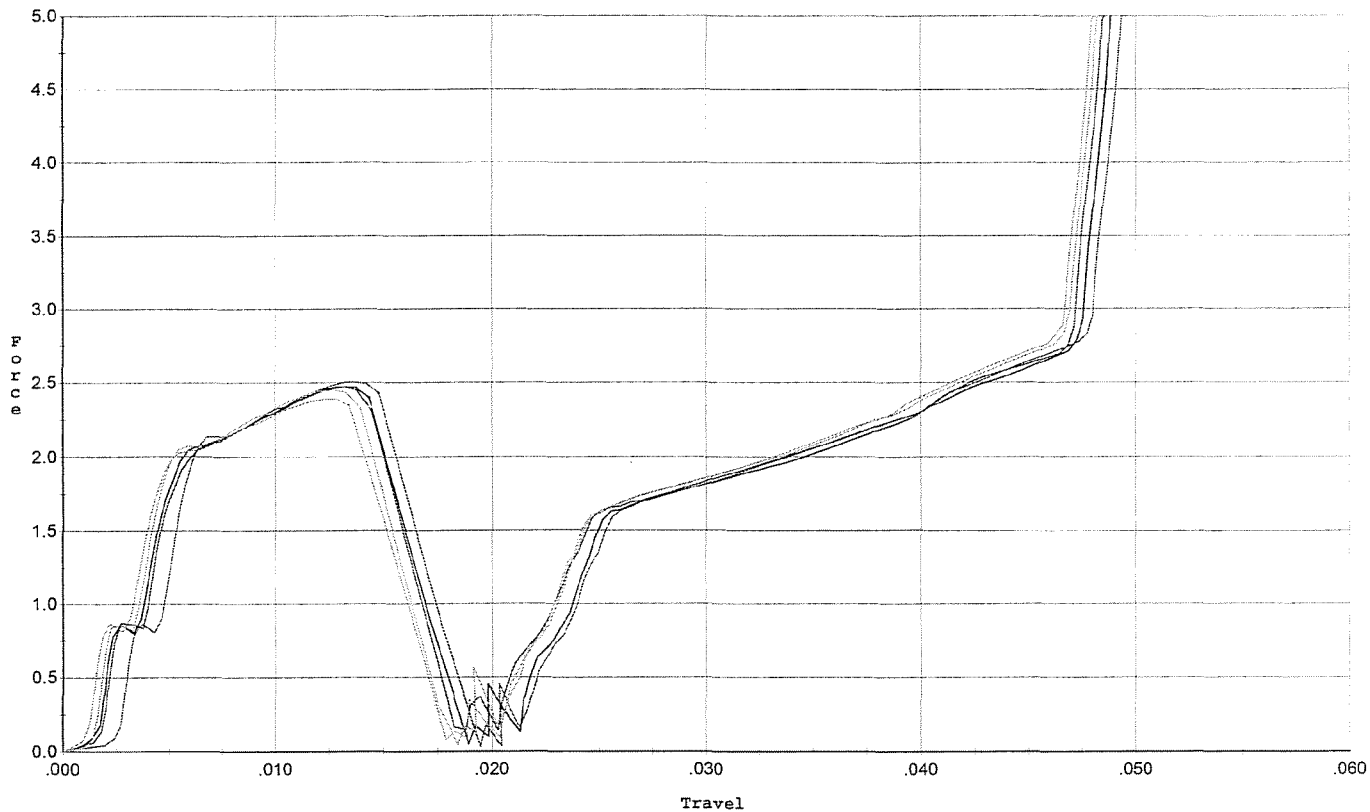
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.374      | 0.019             | 0.00            | 0.032      | 0.050             |           | Set Trigger |
| 2 | 4.319      | 0.017             | 0.00            | 0.032      | 0.046             |           | Set Trigger |
| 3 | 4.209      | 0.017             | 0.004           | 0.032      | 0.044             |           | Set Trigger |
| 4 | 4.169      | 0.019             | 0.00            | 0.032      | 0.048             |           | Set Trigger |
| 5 | 4.226      | 0.017             | 0.00            | 0.032      | 0.044             |           | Set Trigger |

A. 4.25

## 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



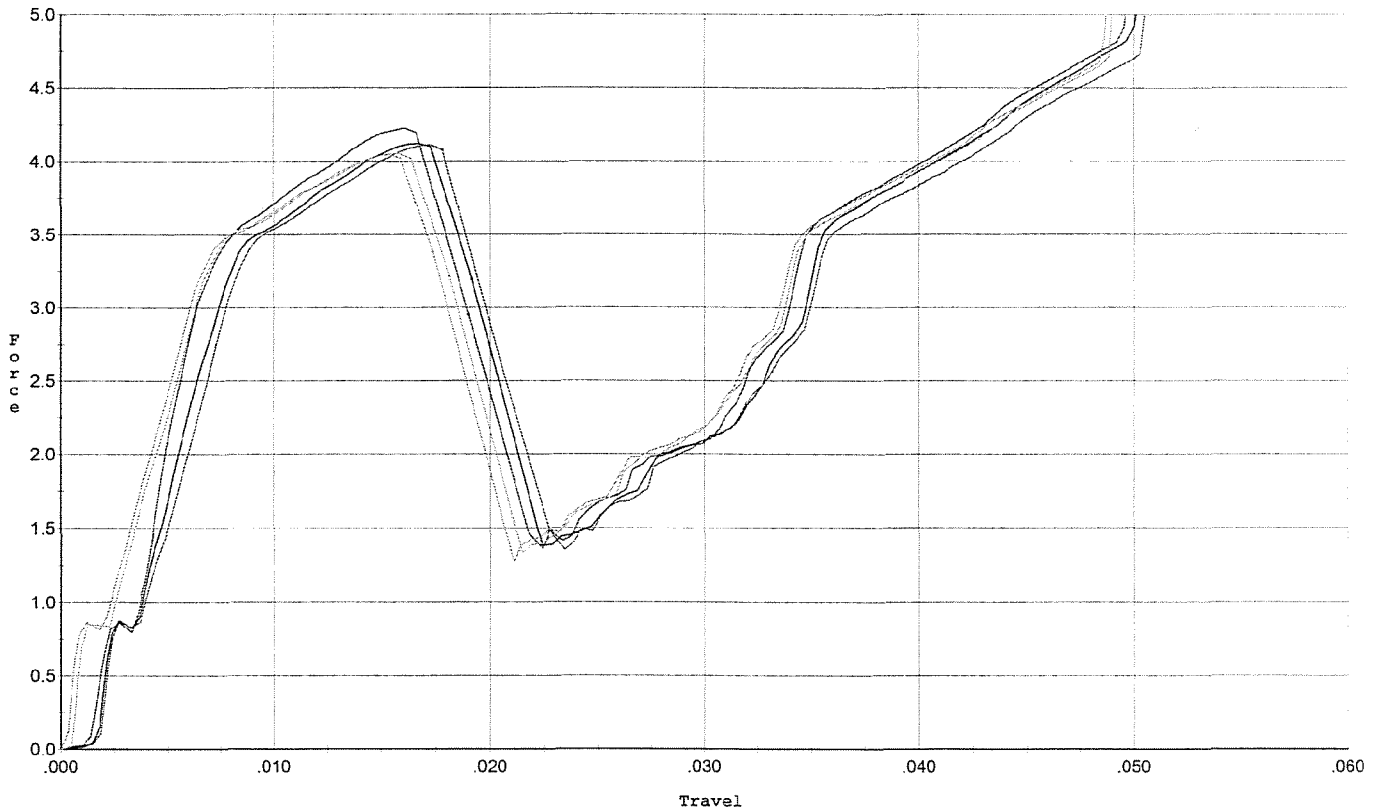
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.467      | 0.014             | 0.004           | 0.037      | 0.023             |           | Set Trigger |
| 2 | 2.471      | 0.014             | 0.00            | 0.037      | 0.023             |           | Set Trigger |
| 3 | 2.504      | 0.015             | 0.00            | 0.037      | 0.023             |           | Set Trigger |
| 4 | 2.447      | 0.014             | 0.00            | 0.037      | 0.023             |           | Set Trigger |
| 5 | 2.390      | 0.015             | 0.00            | 0.037      | 0.025             |           | Set Trigger |

A-2.45

## 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 | 4.227      | 0.019             | 0.00            | 0.032      | 0.050             |           | Set Trigger |
| 2 | 4.121      | 0.019             | 0.00            | 0.032      | 0.049             |           | Set Trigger |
| 3 | 4.112      | 0.018             | 0.002           | 0.032      | 0.045             |           | Set Trigger |
| 4 | 4.052      | 0.018             | 0.002           | 0.032      | 0.049             |           | Set Trigger |
| 5 | 4.045      | 0.017             | 0.00            | 0.032      | 0.047             |           | Set Trigger |

A. 4.11