

66868462

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

proof of purchase



owner registration sticker



BM FORM

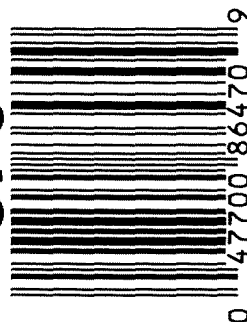
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6868462**

**UPC**



GUN SERIAL # G 6868462

| OP # | OPERATION NAME                                                 | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                       | 7-28-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                       | 7-28-09 | SP      |
| 440  | PROOF                                                          |                       | 7-28-09 | SPD     |
| 460  | CHECK HEADSPACE                                                | MAGNA - FLUX          | 7-28-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            |                       | 7-28-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          |                       | 7-29-09 | KT      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATION (18)        | 7/31/09 | (D)     |
| 490  | MAGNAFLUX BOLT                                                 |                       |         |         |
| 500  | ROLLMARK CALIBER                                               |                       | 7-31-09 | DWO     |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                   |                       | 7-29-08 | SP      |
| 520  | GOFF BLAST BBL / REC                                           |                       | 7/31/09 | SP      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                              |                       | 8/11    | —       |
| 545  | (BOLT)                                                         |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                       | 8-19-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                       | 8-19-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         | INSPECT FOR LIVE AMMO | 8-19-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                       | 8-24-09 | SP      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS   |         |         |

F004 REV 5/2006

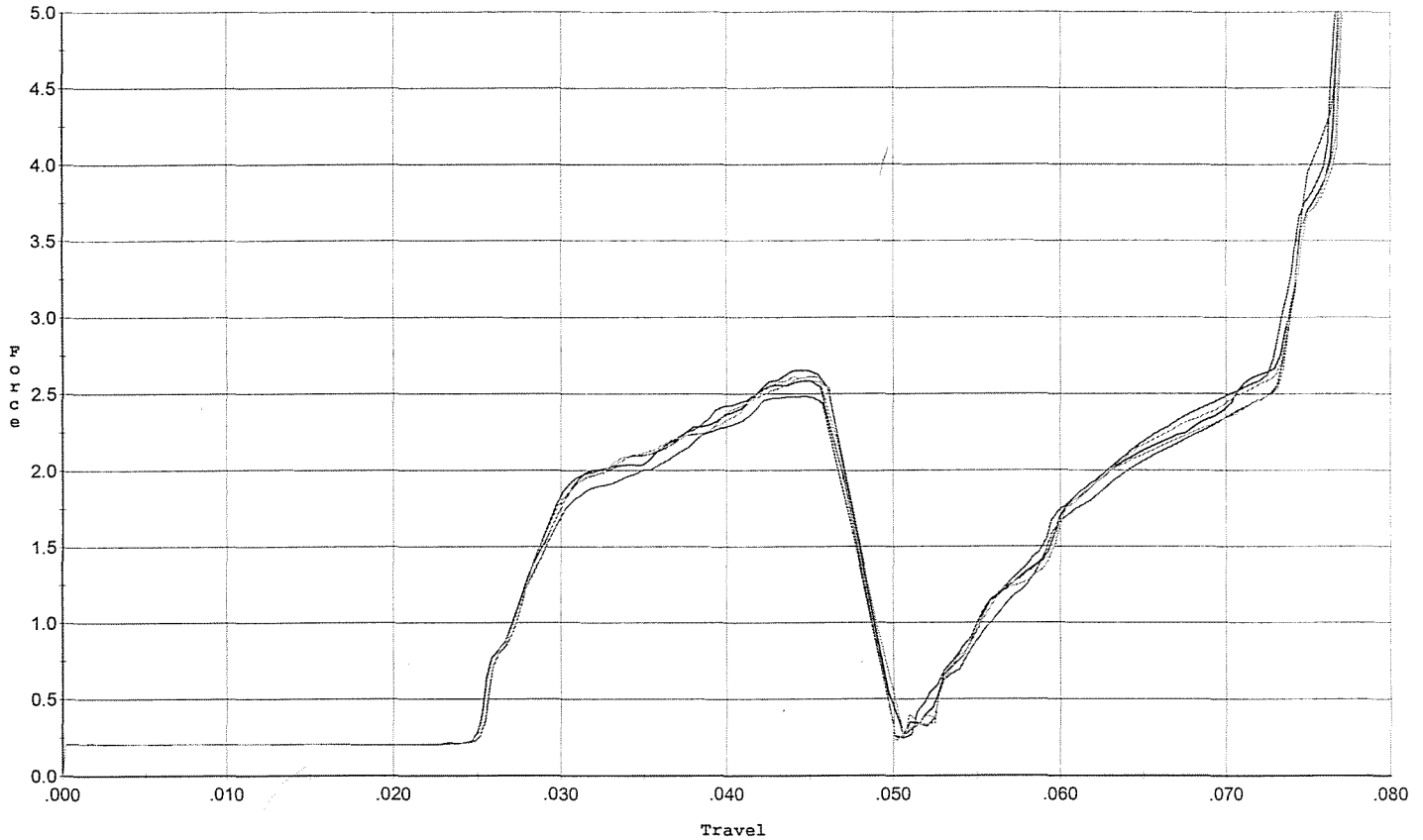
|              |                                                                       |                                           |             |             |             |            |            |         |     |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------|-------------|-------------|------------|------------|---------|-----|
| 560          | F) SAFETY ON FORCE                                                    | 10 LBS MAX                                | <u>3</u>    | <u>3</u>    | <u>4</u>    | 8-22-09    | RN         |         |     |
| CONT.        |                                                                       |                                           |             |             |             |            |            |         |     |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>6°</u>   | <u>6°</u>   | <u>6°</u>   | 8-22-09    | RN         |         |     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |             |             |             |            |            |         |     |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> | <u>.024</u> | <u>.024</u> | 8-22-09    | RN         |         |     |
|              | J) ASSEMBLE STOCK                                                     |                                           |             |             |             | 8-21-09    | RN         |         |     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |             |             |             | 8-22-09    | RN         |         |     |
|              | 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        |             | 8-21-09    | RP         |         |     |
|              |                                                                       |                                           | <u>PASS</u> | FAIL        |             |            |            |         |     |
|              | MALFUNCTION                                                           |                                           | N/A         |             |             |            |            |         |     |
|              | MALFUNCTION                                                           |                                           |             |             |             |            |            |         |     |
|              | MALFUNCTION                                                           |                                           |             |             |             |            |            |         |     |
|              | MALFUNCTION                                                           |                                           |             |             |             |            |            |         |     |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |             |             |             | 8-21-09    | R.P.D.     |         |     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |             |             |             | 8-22-09    | RN         |         |     |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>231</u>  | <u>231</u>  | <u>231</u>  | <u>222</u> | <u>223</u> | 8-22-09 | FTZ |
|              | C) FUNCTION                                                           |                                           |             |             |             |            |            | 8-22-09 | RN  |
| 690          | PACK                                                                  |                                           |             |             |             |            |            | 8/24/09 | Fm  |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



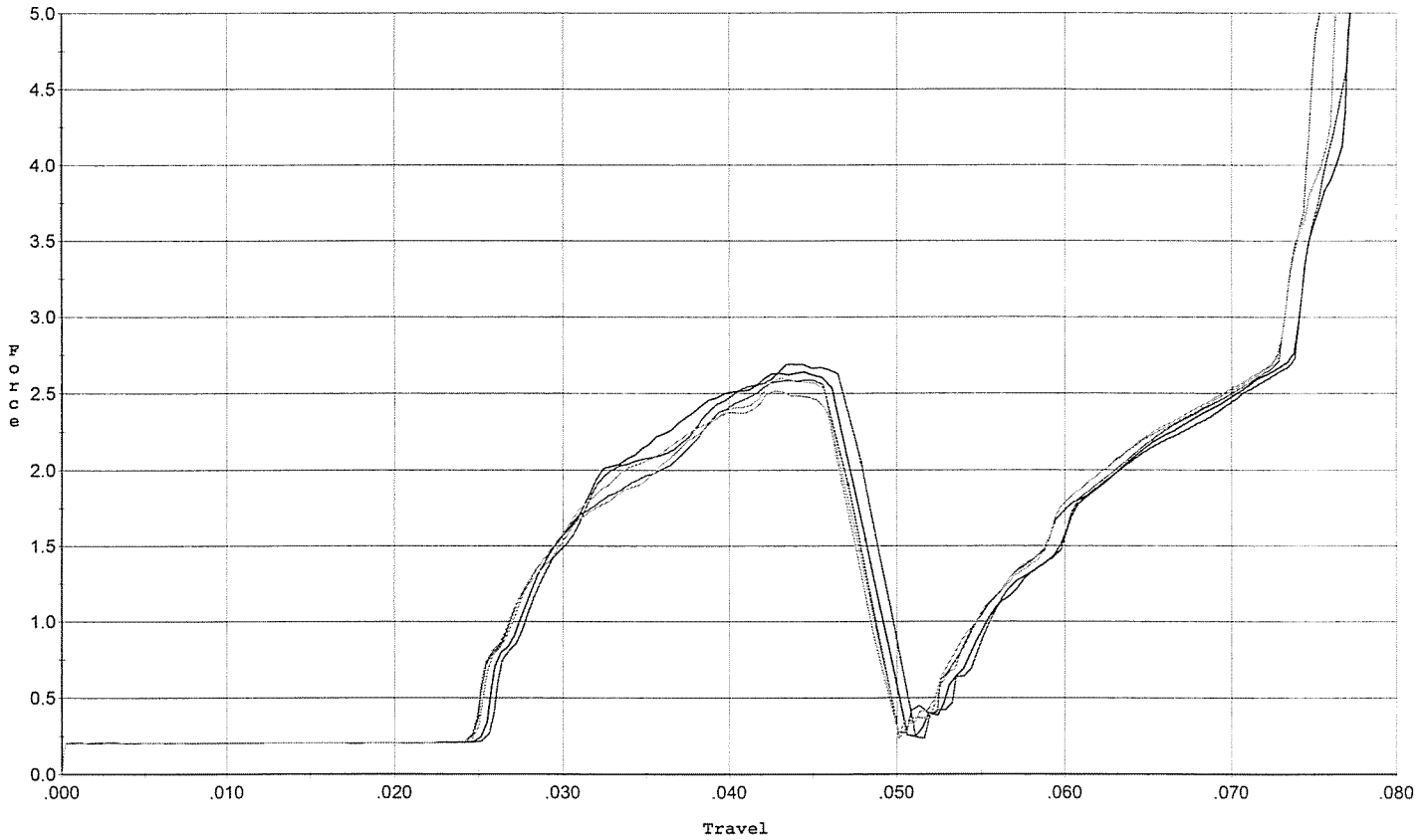
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.584      | 0.047             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 2 | 2.655      | 0.046             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 3 | 2.484      | 0.048             | 0.025           | 0.034      | 0.048             |           | Set Trigger |
| 4 | 2.612      | 0.046             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 5 | 2.612      | 0.047             | 0.025           | 0.034      | 0.049             |           | Set Trigger |

A-2.58

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



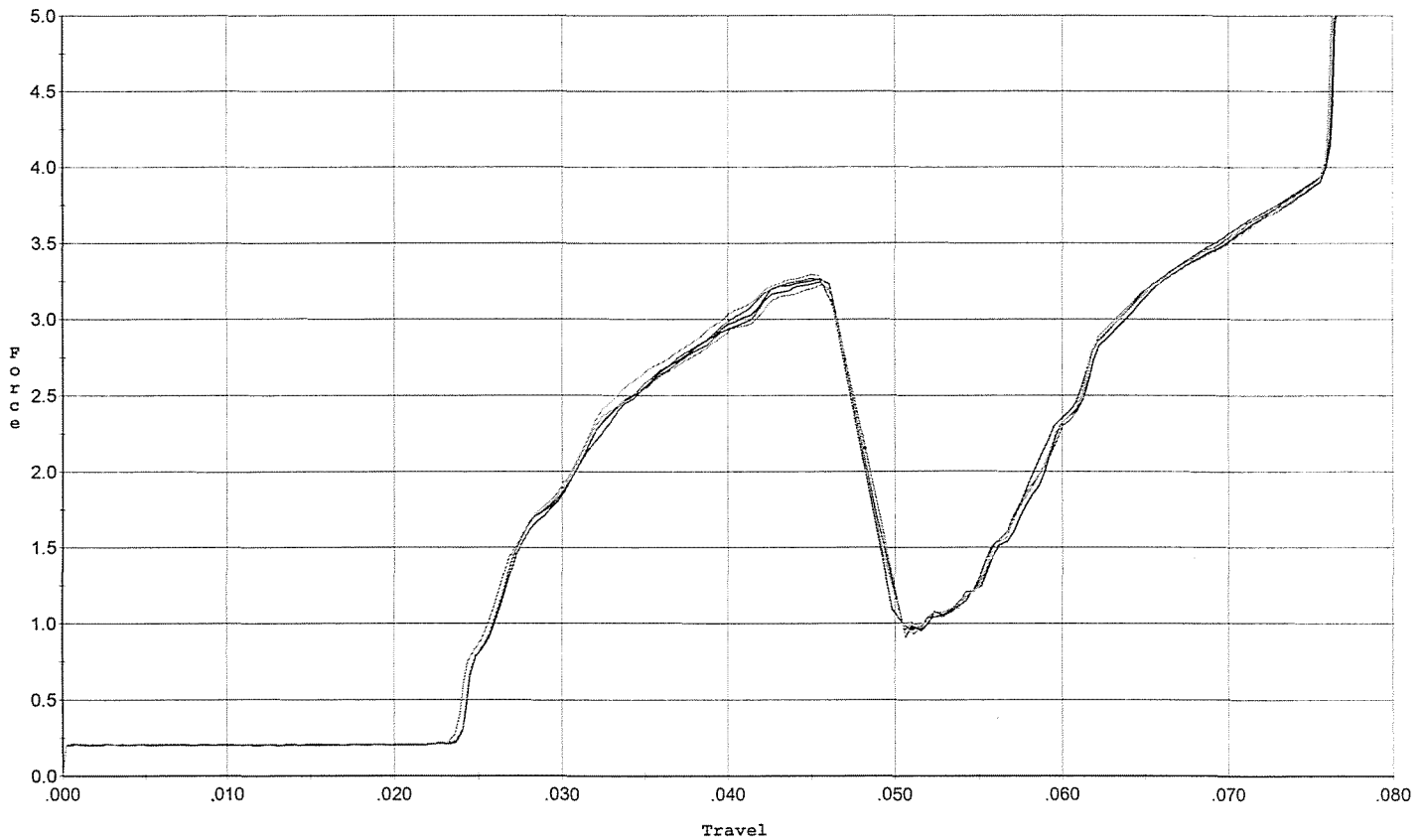
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.690      | 0.048             | 0.026           | 0.033      | 0.051             |           | Set Trigger |
| 2 | 2.639      | 0.048             | 0.025           | 0.033      | 0.051             |           | Set Trigger |
| 3 | 2.588      | 0.047             | 0.025           | 0.033      | 0.048             |           | Set Trigger |
| 4 | 2.599      | 0.048             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 5 | 2.515      | 0.046             | 0.025           | 0.034      | 0.046             |           | Set Trigger |

A2-60

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



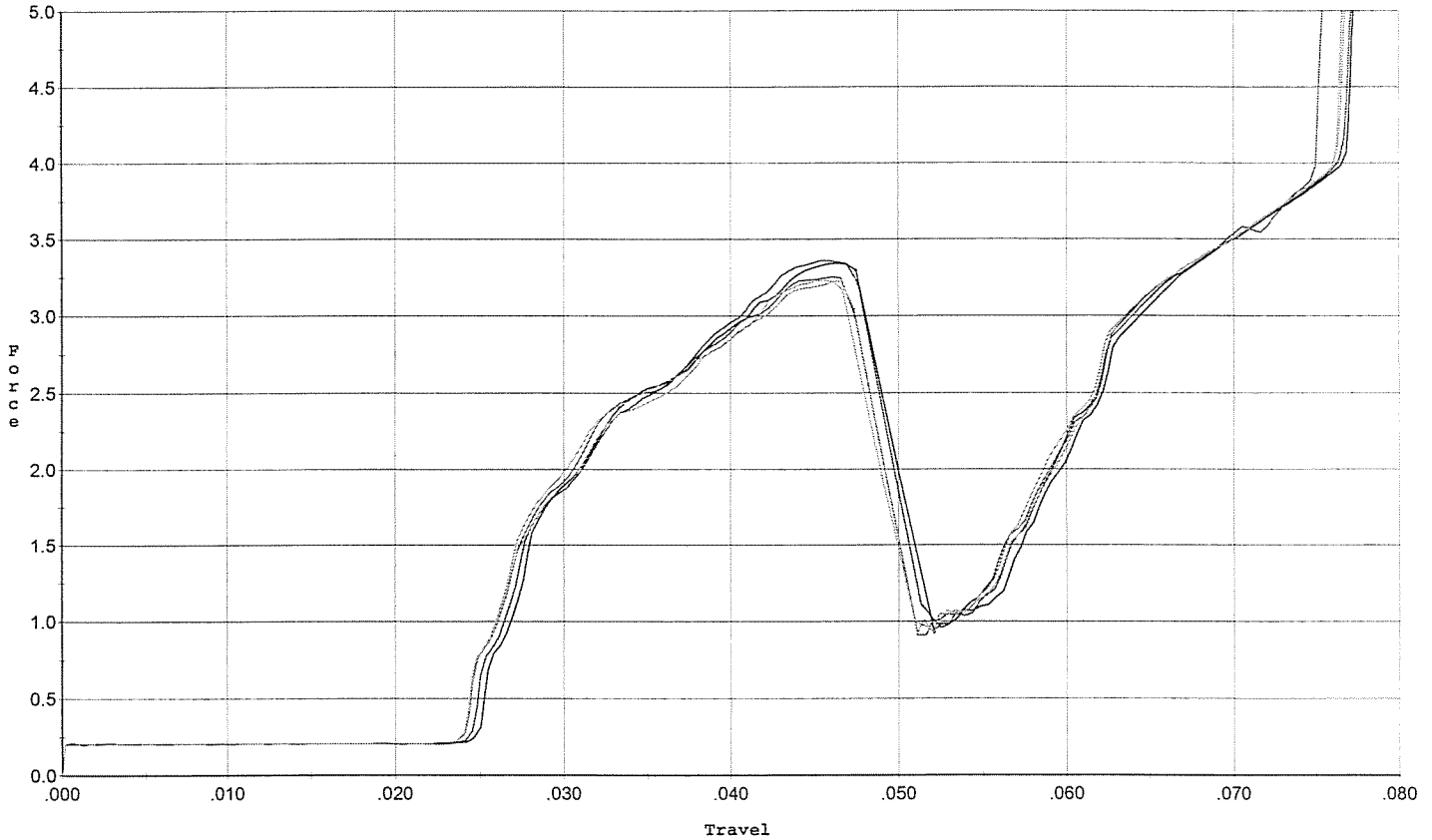
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.246      | 0.046             | 0.024           | 0.032      | 0.059             |           | Set Trigger |
| 2 | 3.265      | 0.048             | 0.024           | 0.032      | 0.063             |           | Set Trigger |
| 3 | 3.269      | 0.046             | 0.024           | 0.032      | 0.060             |           | Set Trigger |
| 4 | 3.295      | 0.046             | 0.024           | 0.032      | 0.061             |           | Set Trigger |
| 5 | 3.227      | 0.048             | 0.024           | 0.031      | 0.063             |           | Set Trigger |

A-3-26

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



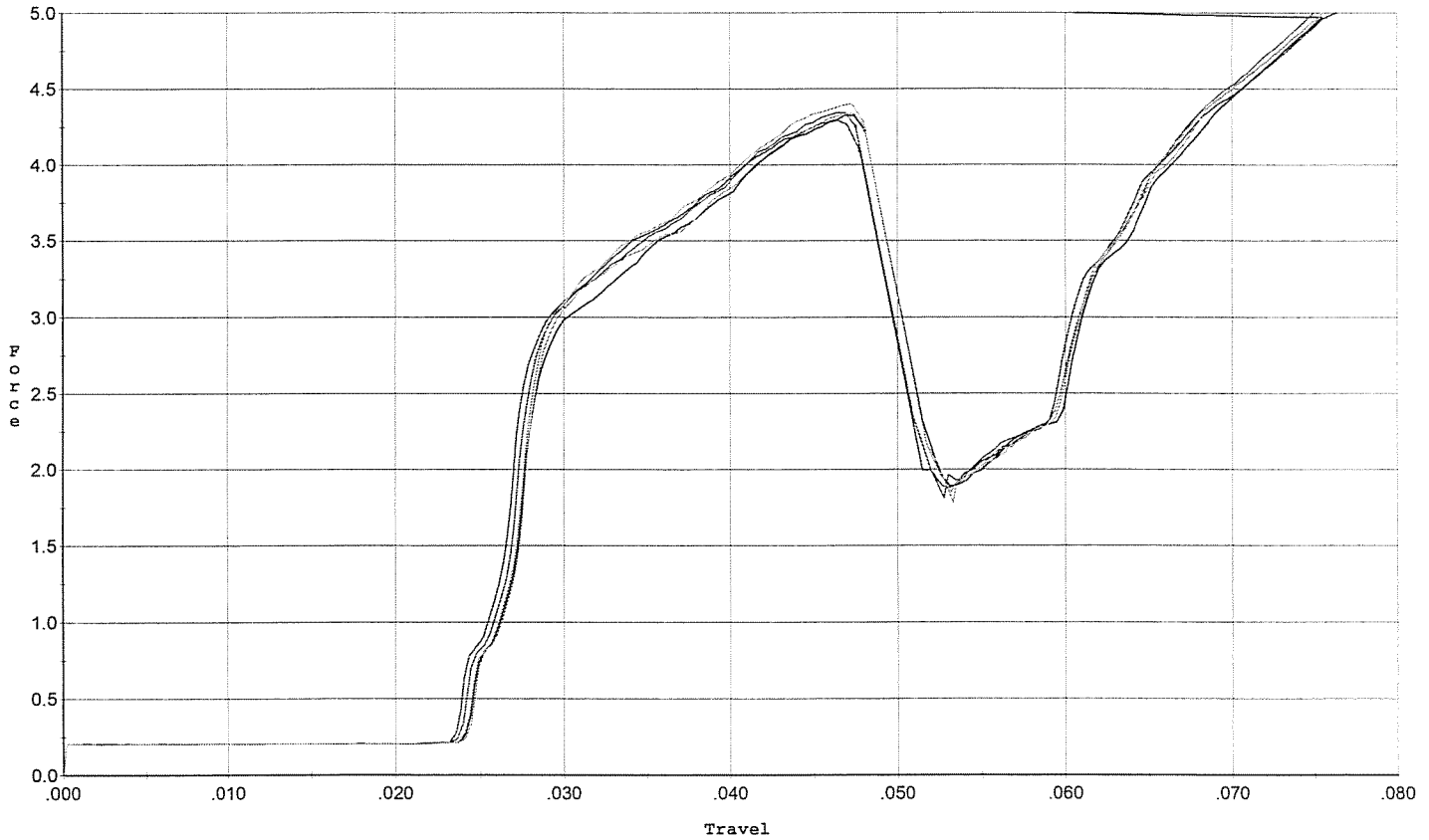
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.360      | 0.048             | 0.025           | 0.031      | 0.063             |           | Set Trigger |
| 2 | 3.341      | 0.047             | 0.025           | 0.031      | 0.063             |           | Set Trigger |
| 3 | 3.253      | 0.047             | 0.024           | 0.031      | 0.062             |           | Set Trigger |
| 4 | 3.231      | 0.047             | 0.024           | 0.032      | 0.061             |           | Set Trigger |
| 5 | 3.221      | 0.047             | 0.024           | 0.031      | 0.061             |           | Set Trigger |

A-3-28

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



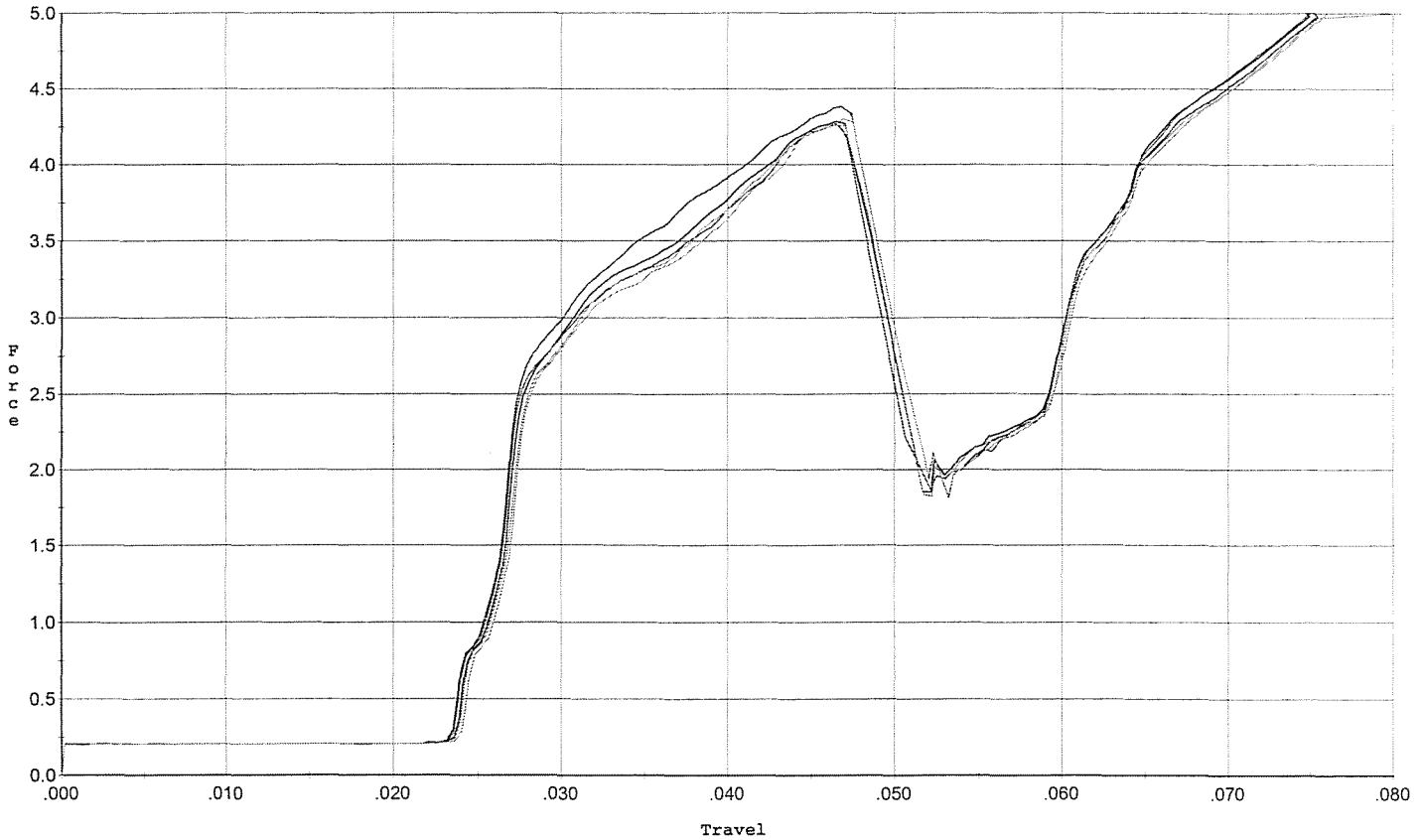
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.292      | 0.048             | 0.024           | 0.028      | 0.087             |           | Set Trigger |
| 2 | 4.327      | 0.048             | 0.024           | 0.029      | 0.085             |           | Set Trigger |
| 3 | 4.342      | 0.048             | 0.024           | 0.028      | 0.086             |           | Set Trigger |
| 4 | 4.402      | 0.048             | 0.024           | 0.028      | 0.088             |           | Set Trigger |
| 5 | 4.339      | 0.048             | 0.024           | 0.028      | 0.086             |           | Set Trigger |

A 4.34

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



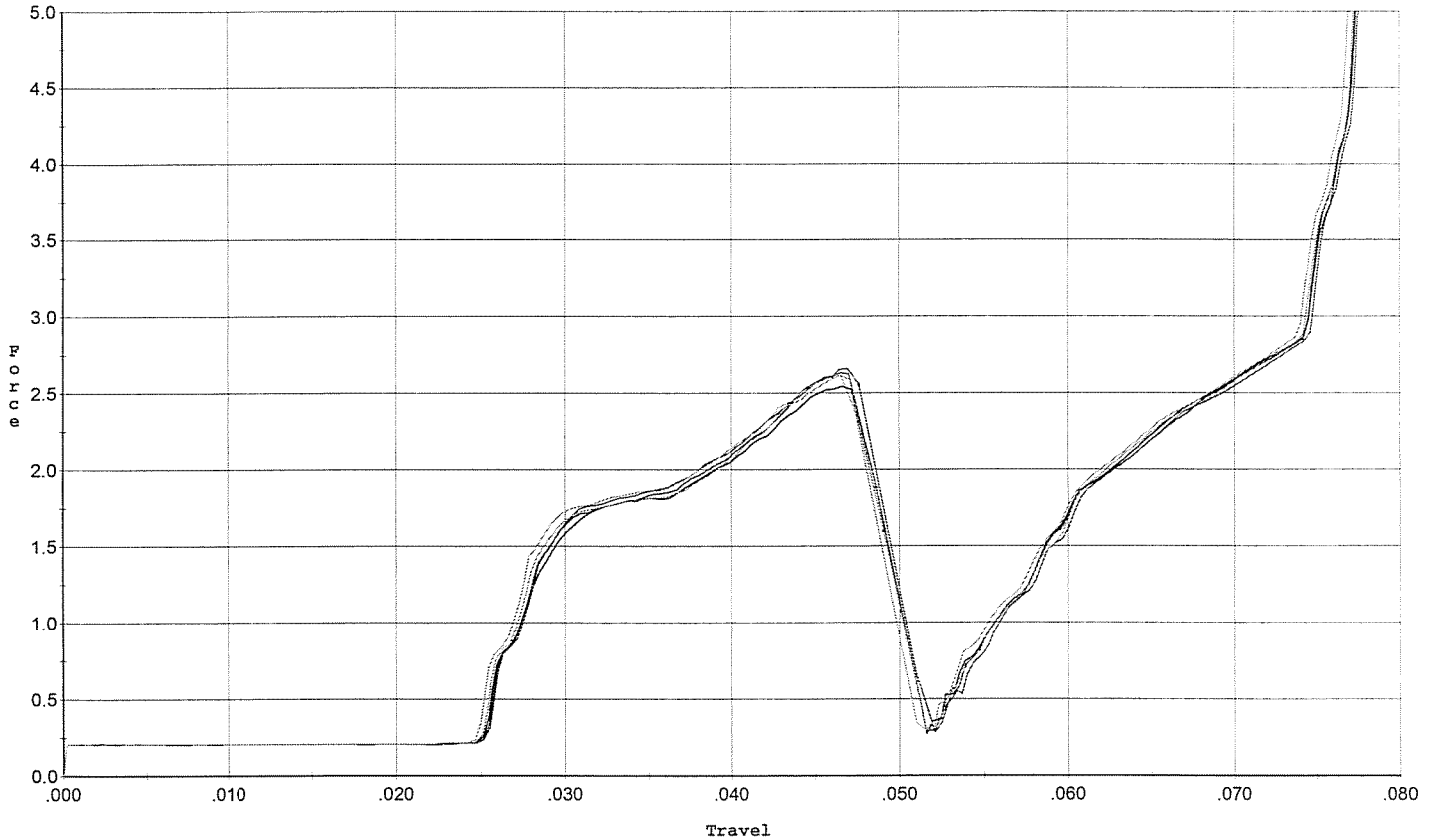
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.382      | 0.047             | 0.024           | 0.028      | 0.086             |           | Set Trigger |
| 2 | 4.283      | 0.049             | 0.024           | 0.028      | 0.086             |           | Set Trigger |
| 3 | 4.272      | 0.047             | 0.024           | 0.028      | 0.082             |           | Set Trigger |
| 4 | 4.303      | 0.047             | 0.024           | 0.028      | 0.082             |           | Set Trigger |
| 5 | 4.260      | 0.048             | 0.024           | 0.028      | 0.084             |           | Set Trigger |

A-4-30

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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



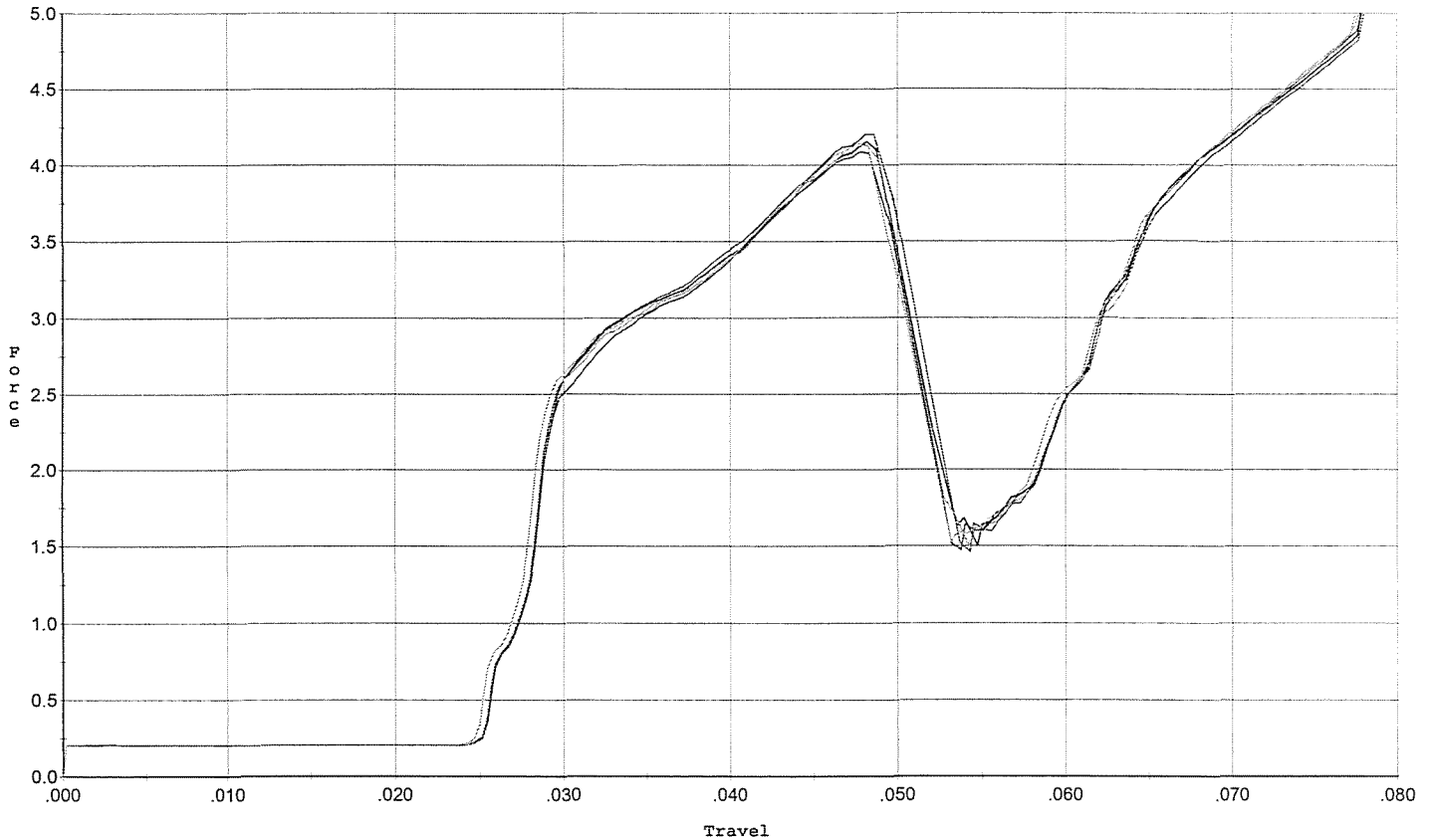
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.632      | 0.049             | 0.025           | 0.033      | 0.050             |           | Set Trigger |
| 2 | 2.545      | 0.049             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 3 | 2.661      | 0.048             | 0.026           | 0.033      | 0.049             |           | Set Trigger |
| 4 | 2.616      | 0.047             | 0.025           | 0.033      | 0.049             |           | Set Trigger |
| 5 | 2.614      | 0.049             | 0.025           | 0.033      | 0.050             |           | Set Trigger |

A.2.61

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/20/2009

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 | 4.087      | 0.050             | 0.025           | 0.029      | 0.080             |           | Set Trigger |
| 2 | 4.153      | 0.049             | 0.025           | 0.029      | 0.080             |           | Set Trigger |
| 3 | 4.201      | 0.050             | 0.025           | 0.029      | 0.082             |           | Set Trigger |
| 4 | 4.144      | 0.050             | 0.025           | 0.029      | 0.083             |           | Set Trigger |
| 5 | 4.134      | 0.049             | 0.025           | 0.029      | 0.079             |           | Set Trigger |

A 4.14