

G6814684

**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



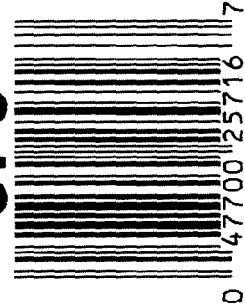
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6814684**

**UPC**



GUN SERIAL #

G 6814684

| OP #            | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------|---------------------|---------|---------|
| 420             | ASSEMBLE ACTION                                                |                     | 3-4-09  | SP      |
| 430             | ASSEMBLE TO STOCK                                              |                     | 3-4-09  | SP      |
| 440             | PROOF                                                          |                     | 3-4-09  | SP      |
| 460             | CHECK HEADSPACE                                                |                     | 3-4-09  | RP      |
| 470             | DIS-ASSEMBLE ACTION                                            |                     | 3-4-09  | RP      |
| 472             | SERIALIZE BOLT HANDLE                                          |                     | 3-5-09  | RTZ     |
| 480             | MAGNAFLUX BBL ACTION                                           | (A)                 | 3/9/09  | (A)     |
| 490             | MAGNAFLUX BOLT                                                 |                     |         |         |
| 500             | ROLLMARK CALIBER                                               |                     | 3/9/09  | RT      |
| 510             | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 3-5-09  | SP      |
| 520             | GOFF BLAST BBL / REC                                           |                     | 3-11    | TL      |
| 540             | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3-26    |         |
| 545             | (BOLT)                                                         |                     |         |         |
| 560             | RE-ASSEMBLE ACTION                                             |                     |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-27-09 | SP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 3-27-09 | SP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 3-27-09 | SP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                     |                     | 3-28-09 | SP      |
|                 | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |
| 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>7</u> <u>4.5</u> <u>4.5</u>                              | 4-1-09  | WV      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3.5</u> <u>3.5</u> <u>3.5</u>                            | 4-1-09  | WV      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.022</u> <u>.023</u>                         | 4-1-09  | WV      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-28-09 | S.P.D.  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 4-1-09  | 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                        | 3-31-09 | S.P.D.  |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-31-09 | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 4-1-09  | WV      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.34</u> <u>2.23</u> <u>2.24</u> <u>2.21</u> <u>2.43</u> | 4-1-09  | WV      |
|              | C) FUNCTION                                                              |                                                             | 4-1-09  | WV      |
| 690          | PACK                                                                     |                                                             | 4/9/09  | Fry     |

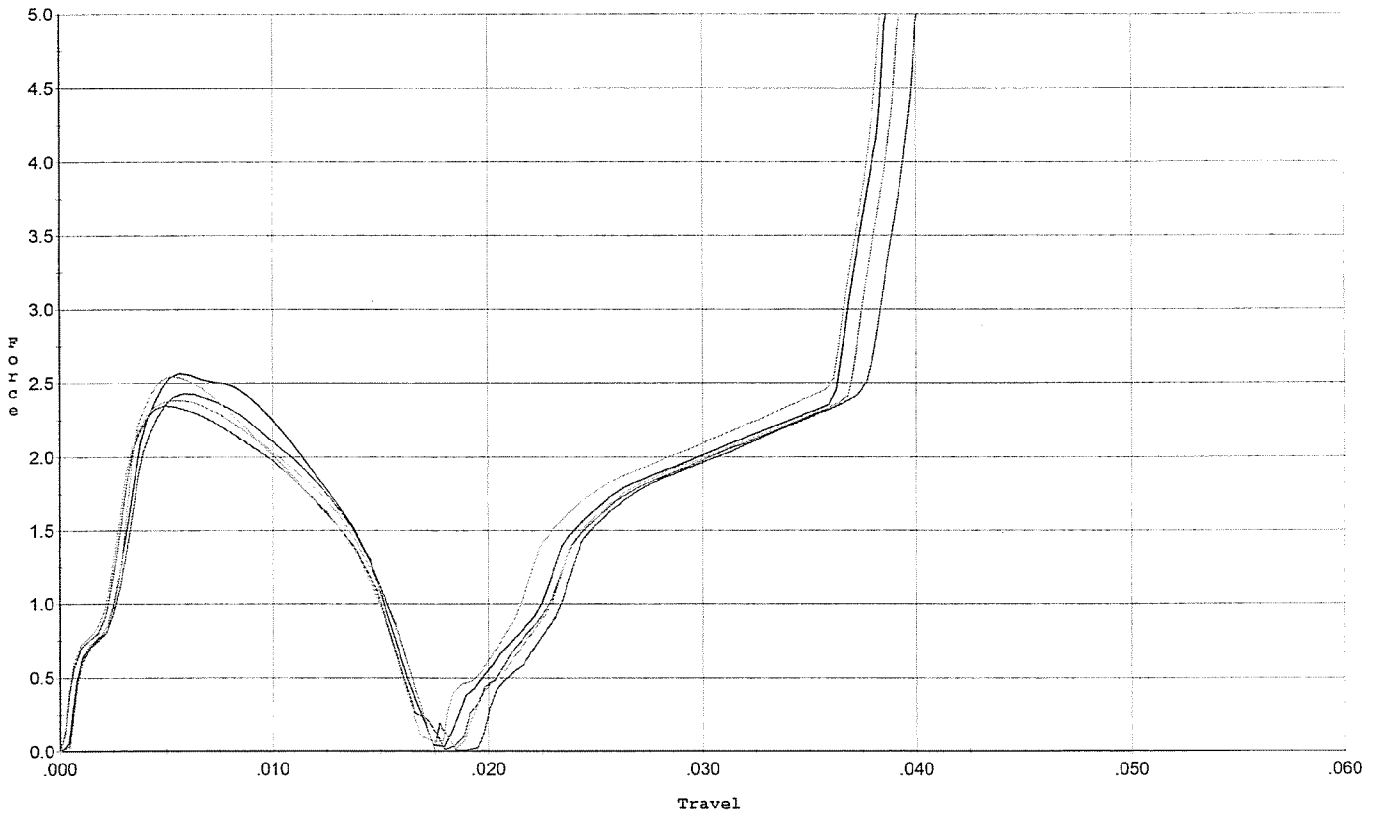
F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/27/2009

Model: M/24  
 Serial No: Form #F005  
 Trigger: ~~250 lbs in 1/2~~

2-50 lbs - iwi +/- .50 lb  
 cms



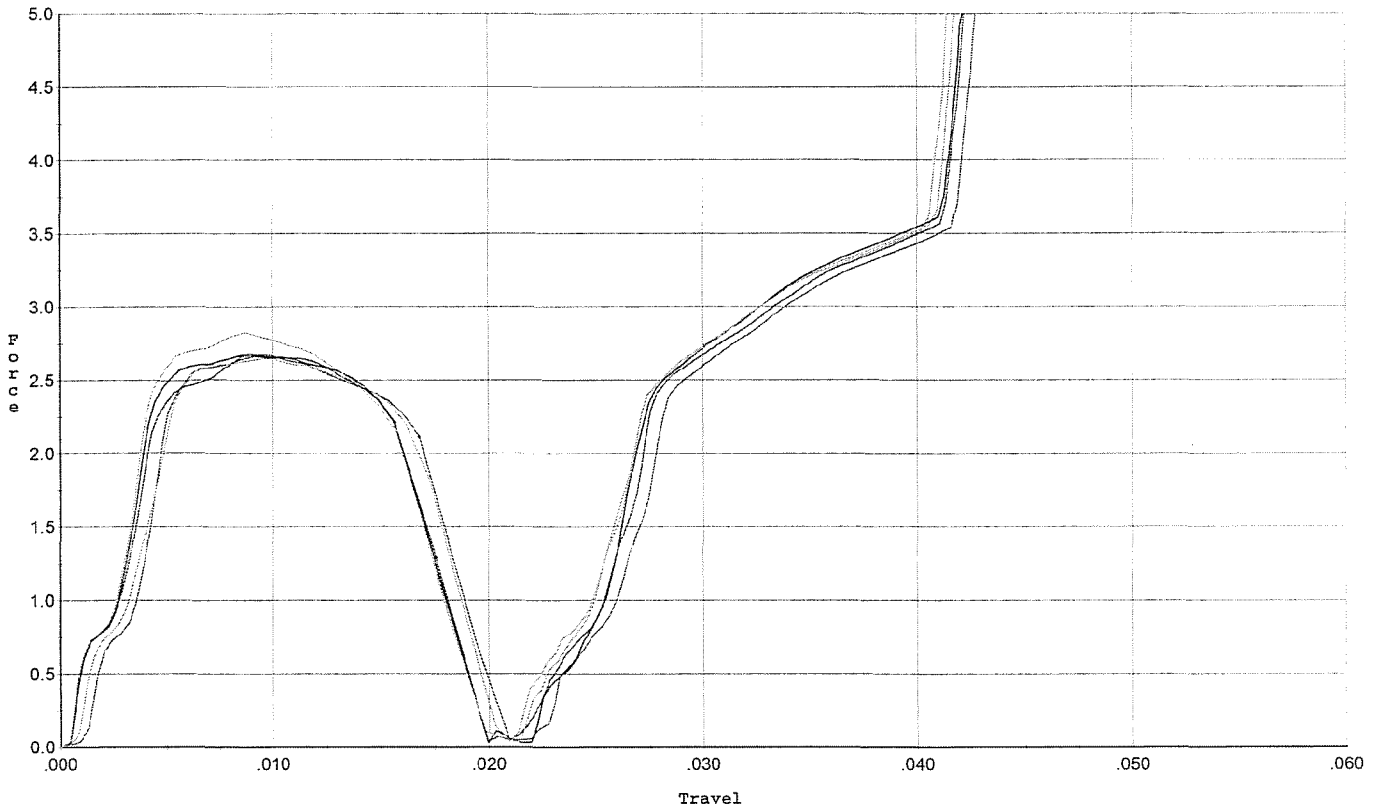
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.429      | 0.016             | 0.00            | 0.030      | 0.025             |           | Set Trigger |
| 2 | 2.564      | 0.015             | 0.00            | 0.029      | 0.025             |           | Set Trigger |
| 3 | 2.347      | 0.015             | 0.00            | 0.030      | 0.024             |           | Set Trigger |
| 4 | 2.544      | 0.016             | 0.00            | 0.029      | 0.026             |           | Set Trigger |
| 5 | 2.383      | 0.015             | 0.00            | 0.028      | 0.025             |           | Set Trigger |

A-2.45

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/27/2009

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



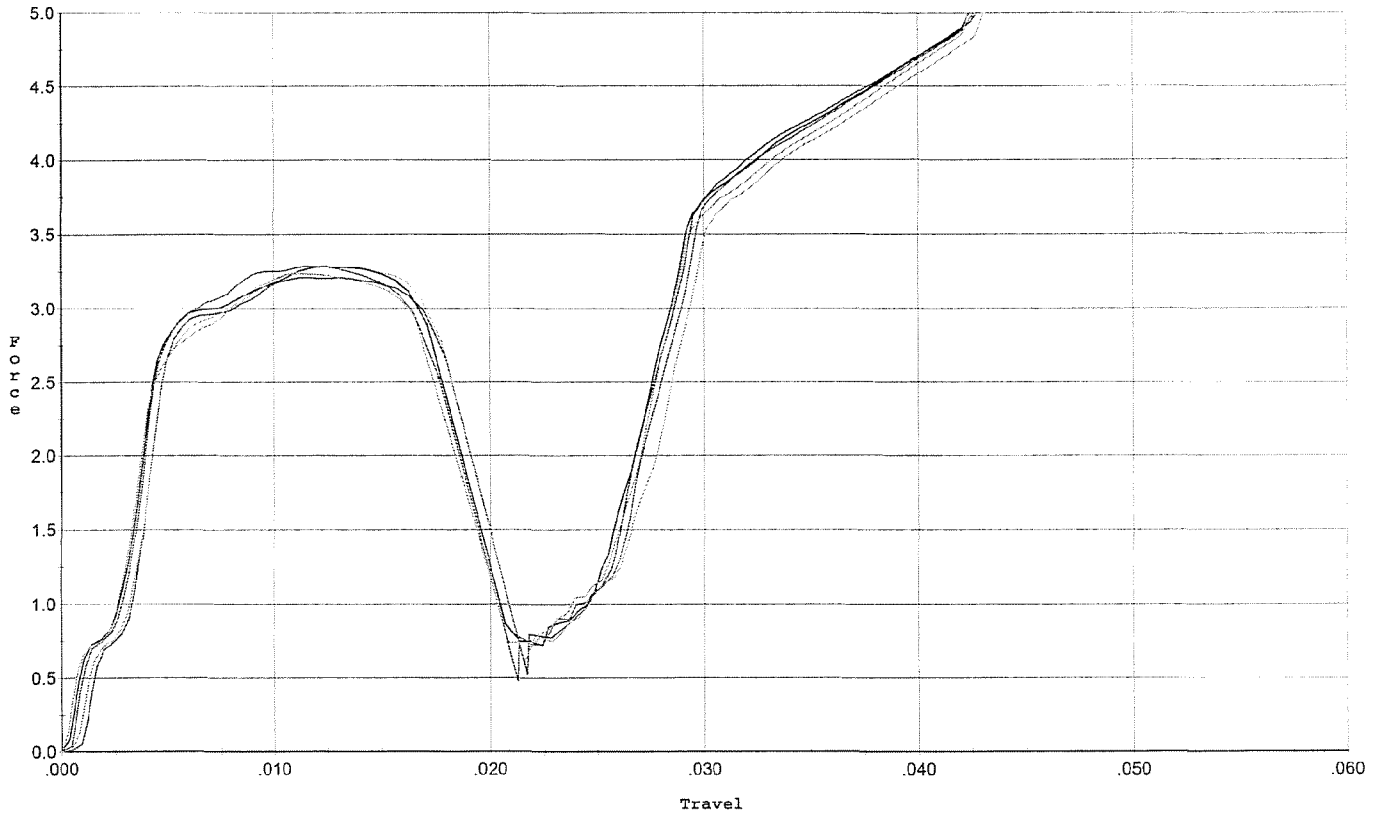
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.669      | 0.018             | 0.00            | 0.029      | 0.034             |           | Set Trigger |
| 2 | 2.682      | 0.016             | 0.00            | 0.029      | 0.031             |           | Set Trigger |
| 3 | 2.676      | 0.017             | 0.00            | 0.029      | 0.031             |           | Set Trigger |
| 4 | 2.824      | 0.016             | 0.00            | 0.029      | 0.032             |           | Set Trigger |
| 5 | 2.648      | 0.017             | 0.00            | 0.028      | 0.032             |           | Set Trigger |

A-2-70

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/27/2009

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



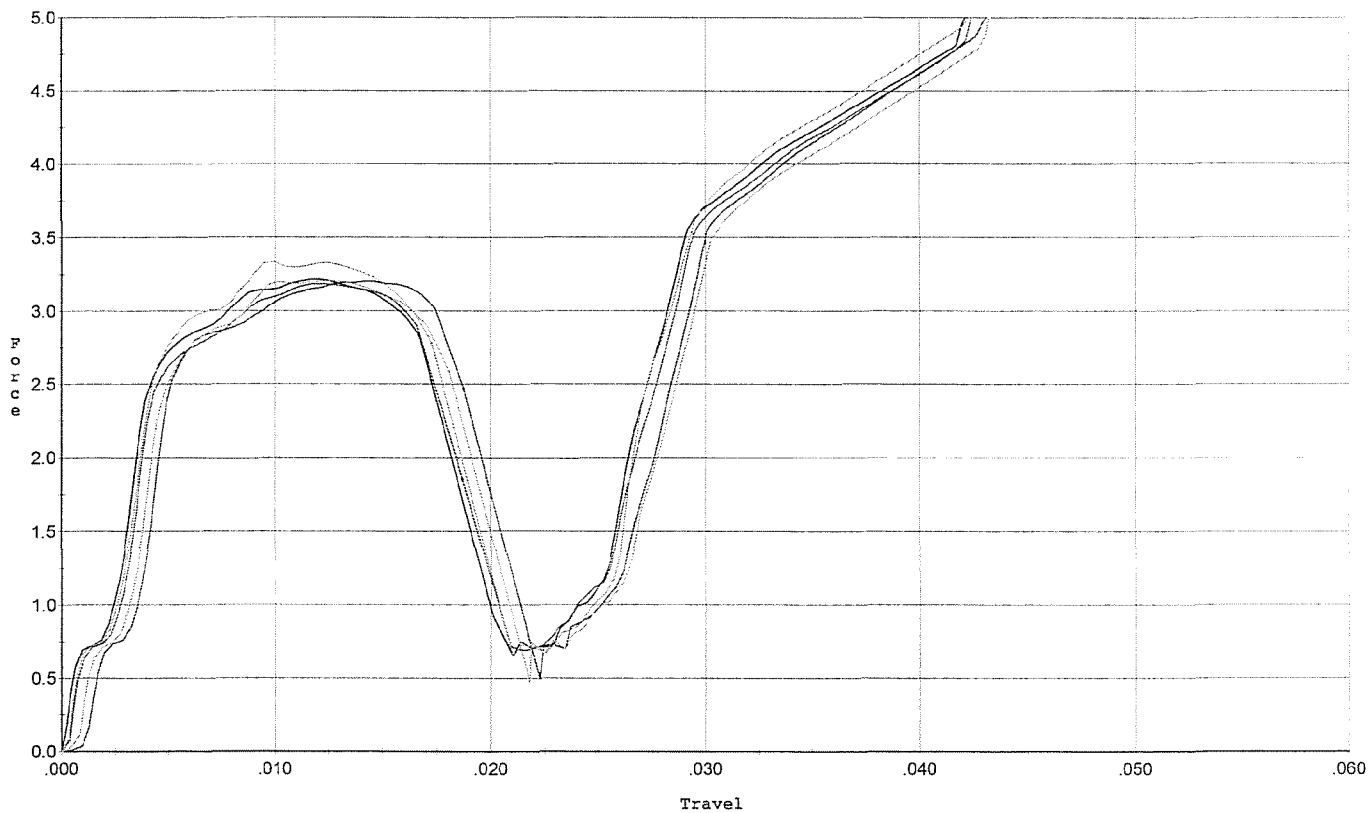
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.209      | 0.018             | 0.00            | 0.027      | 0.041             |           | Set Trigger |
| 2 | 3.286      | 0.017             | 0.00            | 0.027      | 0.041             |           | Set Trigger |
| 3 | 3.286      | 0.018             | 0.00            | 0.028      | 0.042             |           | Set Trigger |
| 4 | 3.281      | 0.018             | 0.00            | 0.028      | 0.041             |           | Set Trigger |
| 5 | 3.234      | 0.019             | 0.00            | 0.027      | 0.043             |           | Set Trigger |

A-3.25

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/27/2009

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 | 3.200      | 0.019             | 0.00            | 0.028      | 0.042             |           | Set Trigger |
| 2 | 3.215      | 0.017             | 0.00            | 0.027      | 0.039             |           | Set Trigger |
| 3 | 3.184      | 0.019             | 0.00            | 0.027      | 0.043             |           | Set Trigger |
| 4 | 3.204      | 0.018             | 0.00            | 0.028      | 0.041             |           | Set Trigger |
| 5 | 3.338      | 0.017             | 0.00            | 0.027      | 0.042             |           | Set Trigger |

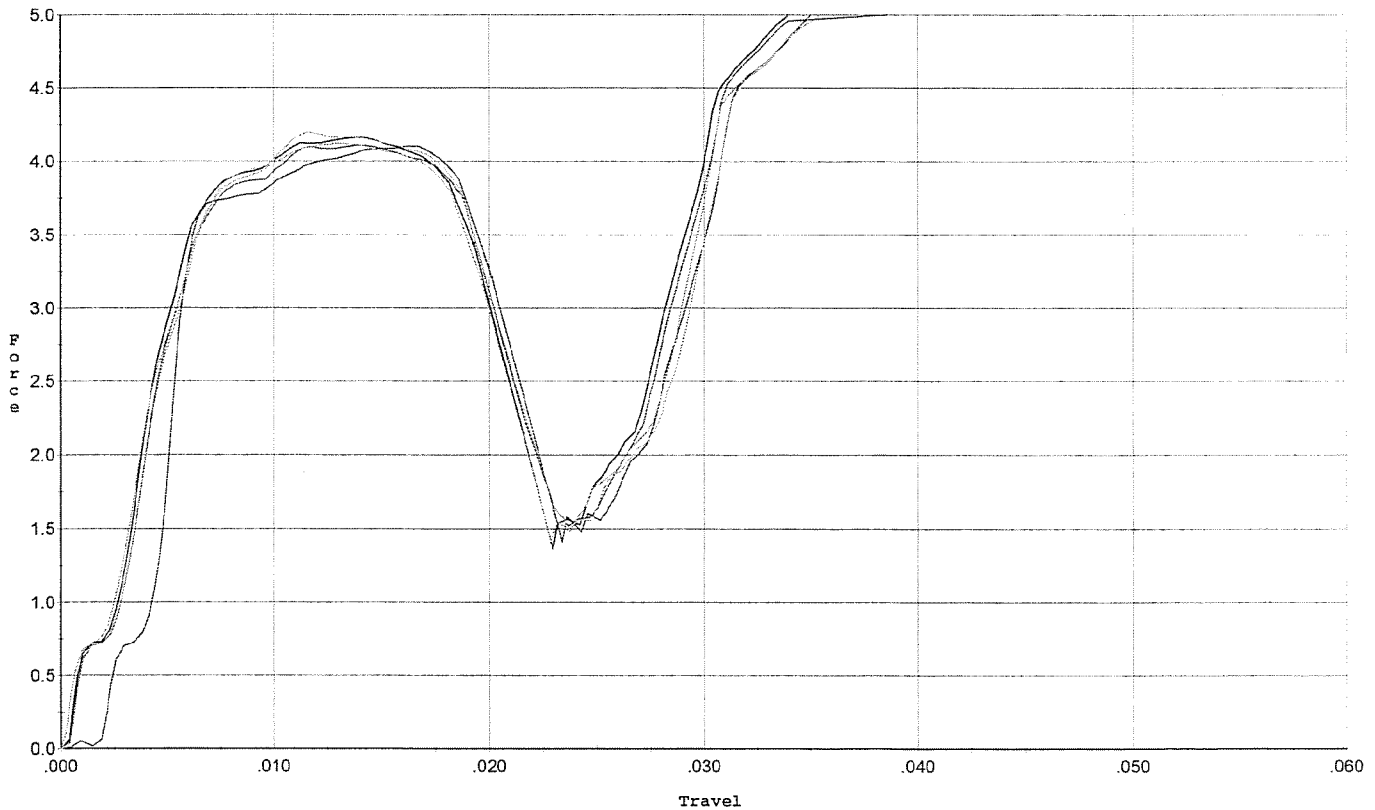
A.3.22



## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/27/2009

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



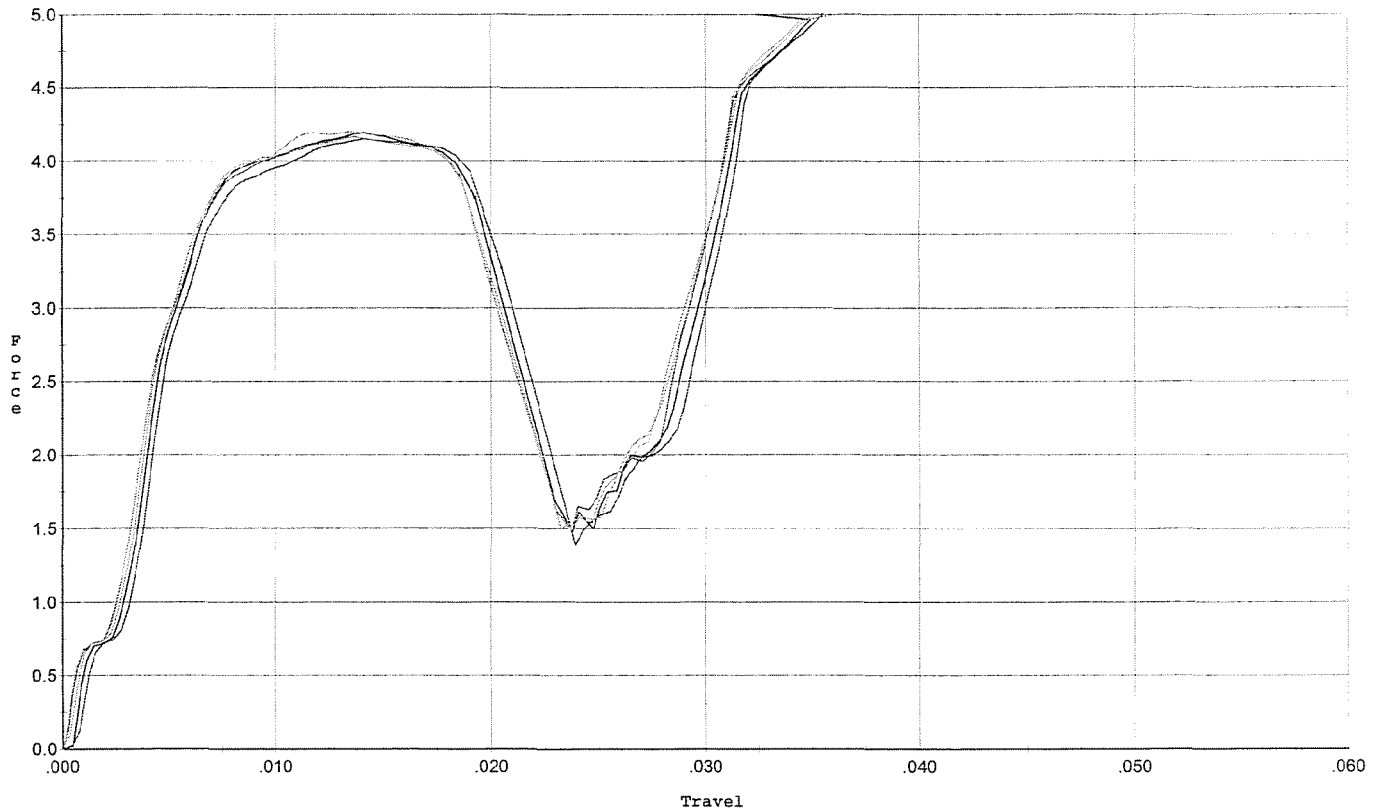
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.104      | 0.020             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 2 | 4.162      | 0.019             | 0.00            | 0.025      | 0.057             |           | Set Trigger |
| 3 | 4.109      | 0.019             | 0.00            | 0.025      | 0.054             |           | Set Trigger |
| 4 | 4.201      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 5 | 4.122      | 0.020             | 0.00            | 0.025      | 0.057             |           | Set Trigger |

A-4.14

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/27/2009

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



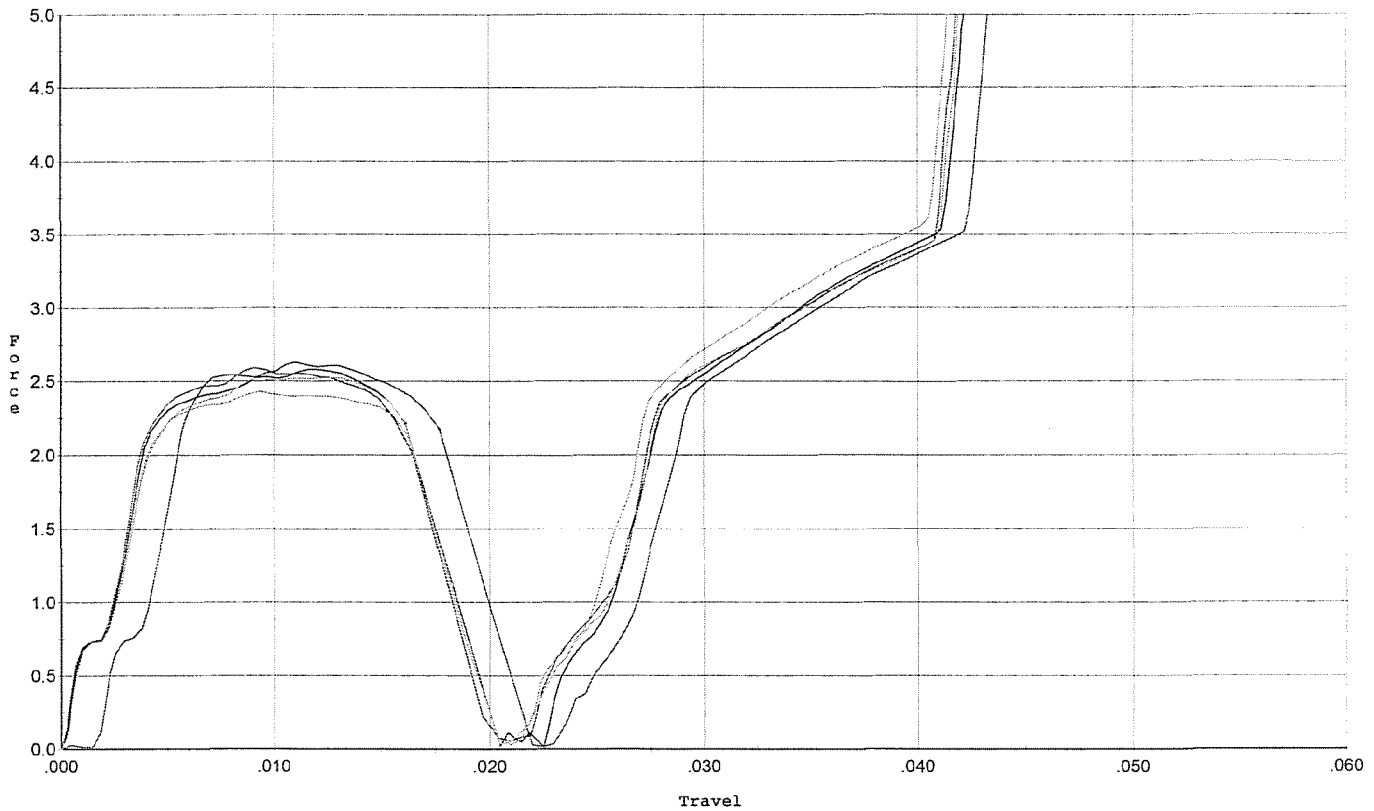
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.150      | 0.021             | 0.00            | 0.026      | 0.060             |           | Set Trigger |
| 2 | 4.191      | 0.019             | 0.00            | 0.026      | 0.057             |           | Set Trigger |
| 3 | 4.165      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 4 | 4.163      | 0.019             | 0.00            | 0.026      | 0.055             |           | Set Trigger |
| 5 | 4.199      | 0.020             | 0.00            | 0.025      | 0.061             |           | Set Trigger |

A-4.17

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/27/2009

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



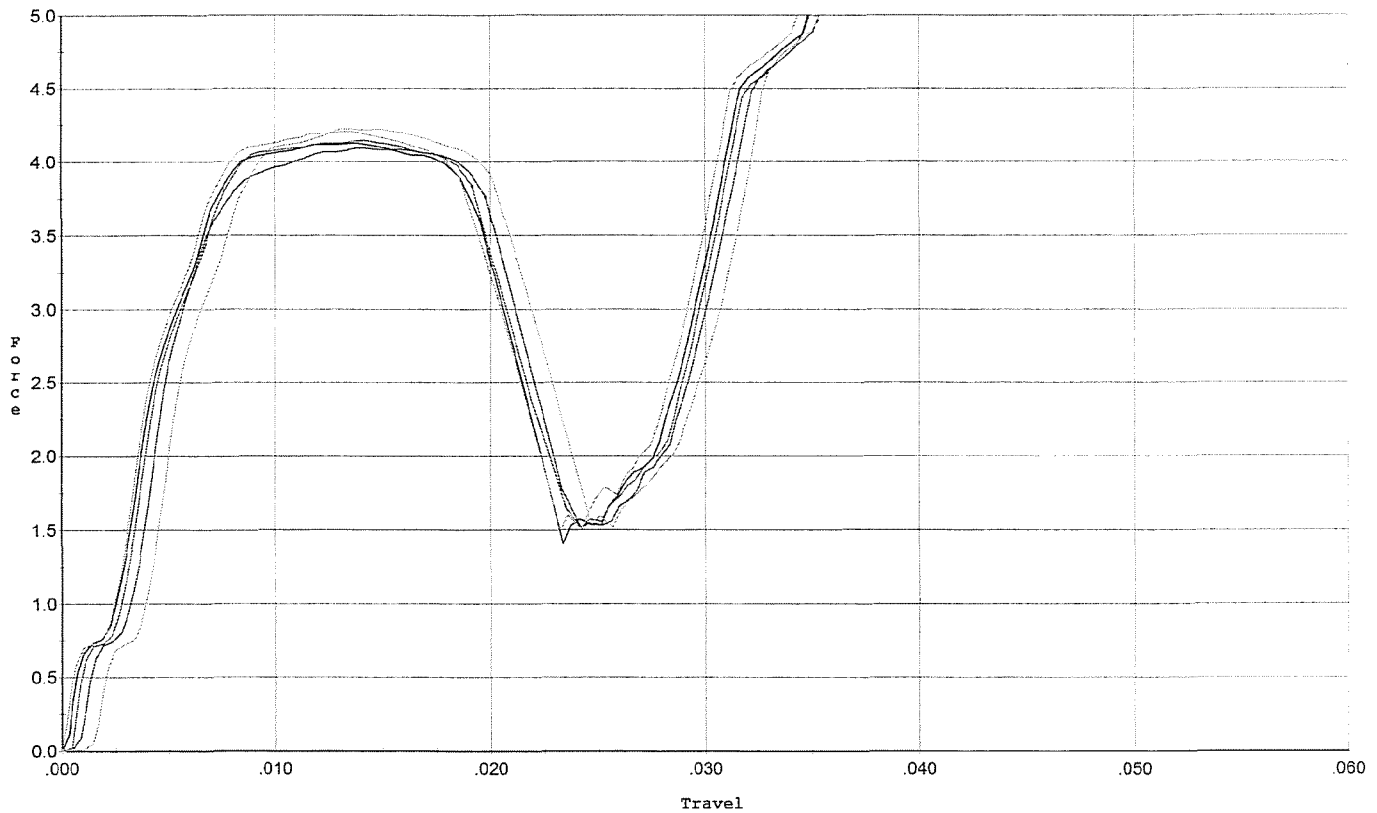
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.629      | 0.018             | 0.002           | 0.029      | 0.032             |           | Set Trigger |
| 2 | 2.578      | 0.016             | 0.00            | 0.029      | 0.031             |           | Set Trigger |
| 3 | 2.590      | 0.016             | 0.00            | 0.028      | 0.032             |           | Set Trigger |
| 4 | 2.523      | 0.018             | 0.00            | 0.028      | 0.034             |           | Set Trigger |
| 5 | 2.429      | 0.016             | 0.00            | 0.028      | 0.030             |           | Set Trigger |

A-2-55

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/27/2009

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 | 4.091      | 0.020             | 0.00            | 0.016      | 0.057             |           | Set Trigger |
| 2 | 4.128      | 0.020             | 0.00            | 0.017      | 0.058             |           | Set Trigger |
| 3 | 4.145      | 0.019             | 0.00            | 0.017      | 0.056             |           | Set Trigger |
| 4 | 4.223      | 0.022             | 0.00            | 0.016      | 0.063             |           | Set Trigger |
| 5 | 4.204      | 0.020             | 0.00            | 0.016      | 0.061             |           | Set Trigger |

A 4.15