

56801366

**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



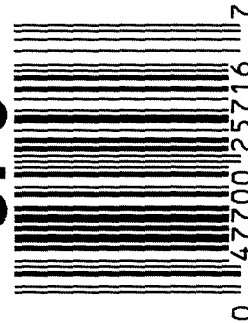
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

**G6801366**

**UPC**



GUN SERIAL # G 6801366

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 3-6-09  | RJZ     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 3-6-09  | RJZ     |
| 440  | PROOF                                                          |                     | 3-6-09  | TL      |
| 460  | CHECK HEADSPACE                                                |                     | 3-6-09  | TL      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 3-6-09  | RJZ     |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 3-6-09  | RJZ     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 3-6-09  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           |                     | 3/9/09  | MR      |
| 490  | MAGNAFLUX BOLT                                                 |                     | 3/9/09  | MR      |
| 500  | ROLLMARK CALIBER                                               |                     | 3/9/09  | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 3/11    | MR      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3-20    |         |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-20-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 3-20-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 3-20-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 3-24-09 | LJZ     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

F004 REV 5/2006

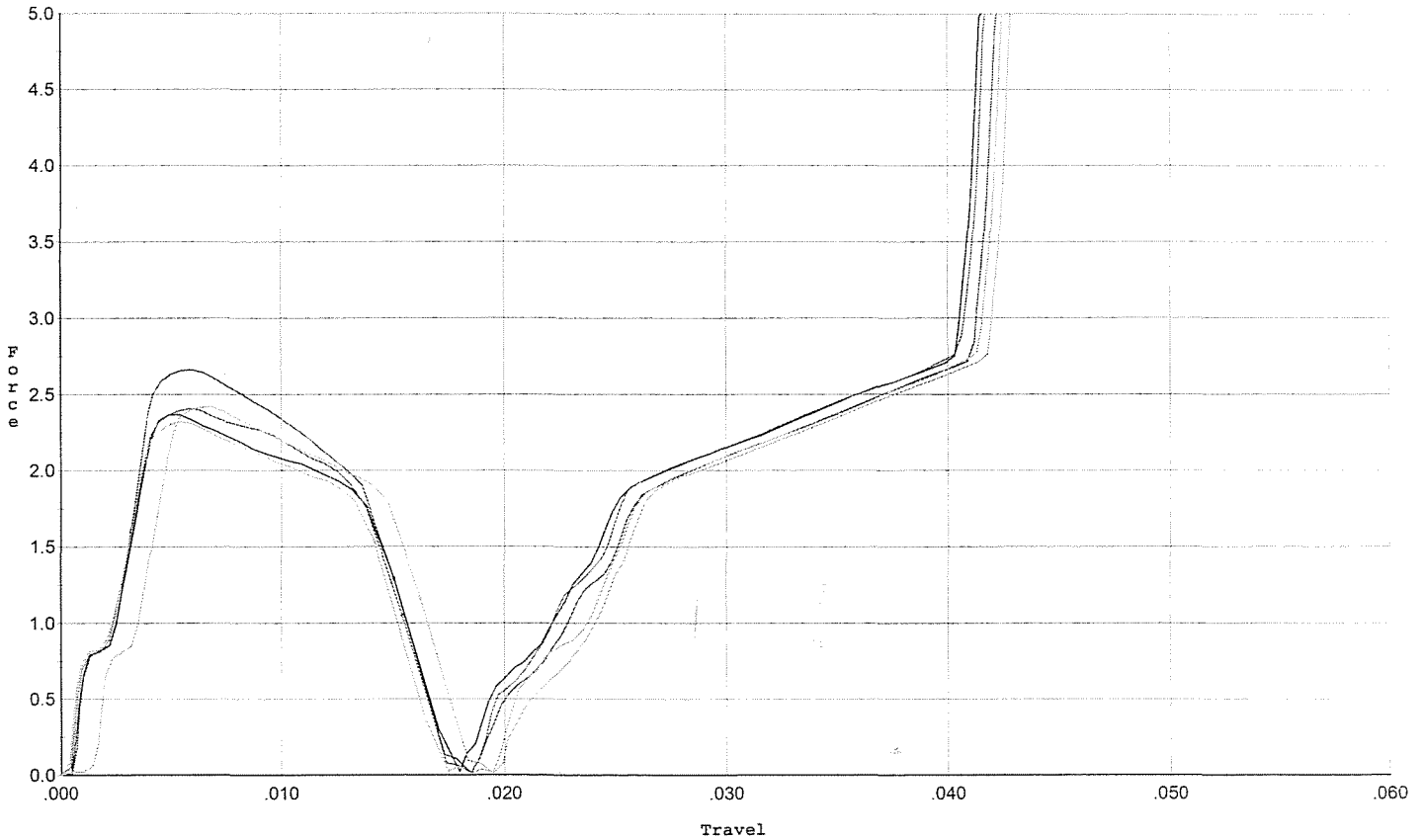
|              |                                                                       |                                           |                                                             |         |      |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|------|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>4.0</u> <u>5.0</u> <u>5.0</u>                            | 3-28-09 | L.N. |
| CONT.        |                                                                       |                                           |                                                             |         |      |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>6.0</u> <u>6.0</u> <u>6.0</u>                            | 3-28-09 | L.N. |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |      |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> <u>.023</u> <u>.023</u>                         | 3-28-09 | L.N. |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 3-24-09 | L.N. |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 3-28-09 | L.N. |
|              | 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                                           |                                           | PASS FAIL<br>PASS FAIL                                      | 3-26-09 | N/A  |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |      |
|              | MALFUNCTION                                                           | CORRECTION                                | N/A                                                         |         |      |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |      |
|              | MALFUNCTION                                                           | CORRECTION                                |                                                             |         |      |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 3-26-09 | TL   |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 3-28-09 | L.N. |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.57</u> <u>2.60</u> <u>2.63</u> <u>2.65</u> <u>2.61</u> | 3-28-09 | TL   |
|              | C) FUNCTION                                                           |                                           |                                                             | 3-28-09 | L.N. |
| 690          | PACK                                                                  |                                           |                                                             | 3/24/09 | Fm   |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



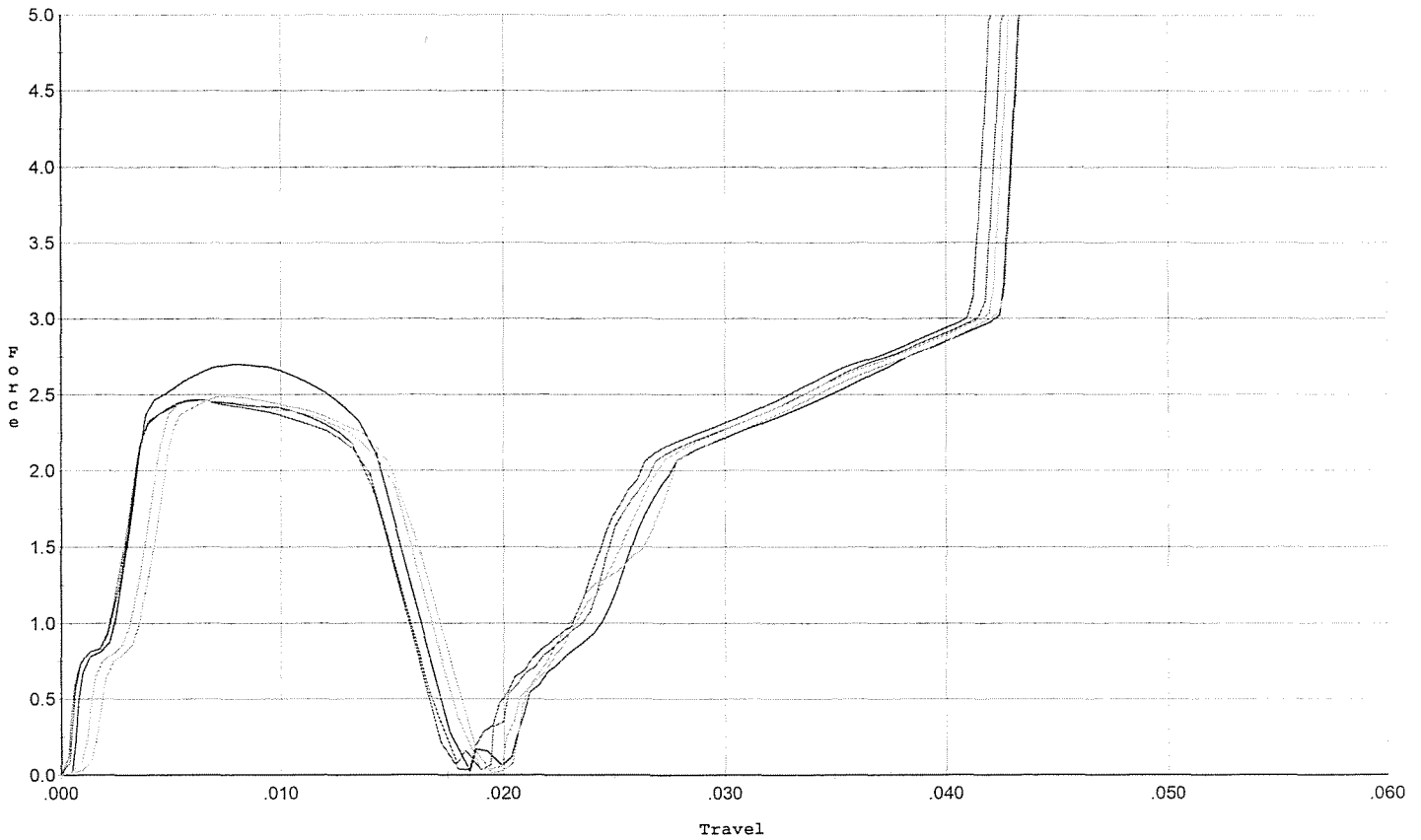
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.662      | 0.015             | 0.00            | 0.032      | 0.027             |           | Set Trigger |
| 2 | 2.373      | 0.015             | 0.00            | 0.031      | 0.025             |           | Set Trigger |
| 3 | 2.410      | 0.015             | 0.00            | 0.031      | 0.026             |           | Set Trigger |
| 4 | 2.321      | 0.014             | 0.00            | 0.032      | 0.024             |           | Set Trigger |
| 5 | 2.420      | 0.016             | 0.00            | 0.031      | 0.026             |           | Set Trigger |

A-2.43

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



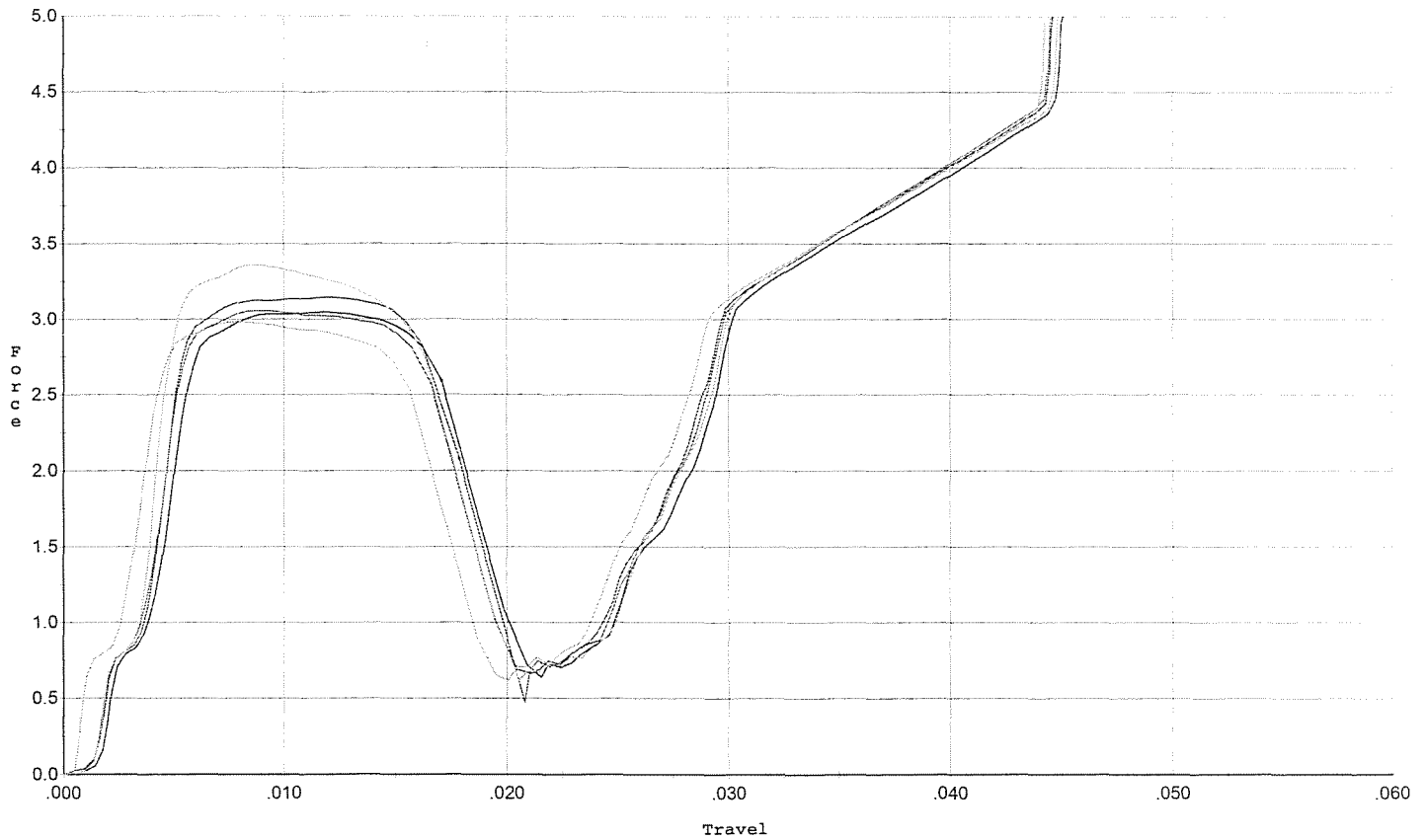
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.468      | 0.014             | 0.00            | 0.031      | 0.026             |           | Set Trigger |
| 2 | 2.701      | 0.014             | 0.00            | 0.032      | 0.028             |           | Set Trigger |
| 3 | 2.464      | 0.014             | 0.00            | 0.032      | 0.026             |           | Set Trigger |
| 4 | 2.460      | 0.015             | 0.00            | 0.031      | 0.027             |           | Set Trigger |
| 5 | 2.487      | 0.016             | 0.00            | 0.031      | 0.028             |           | Set Trigger |

A-2.51

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



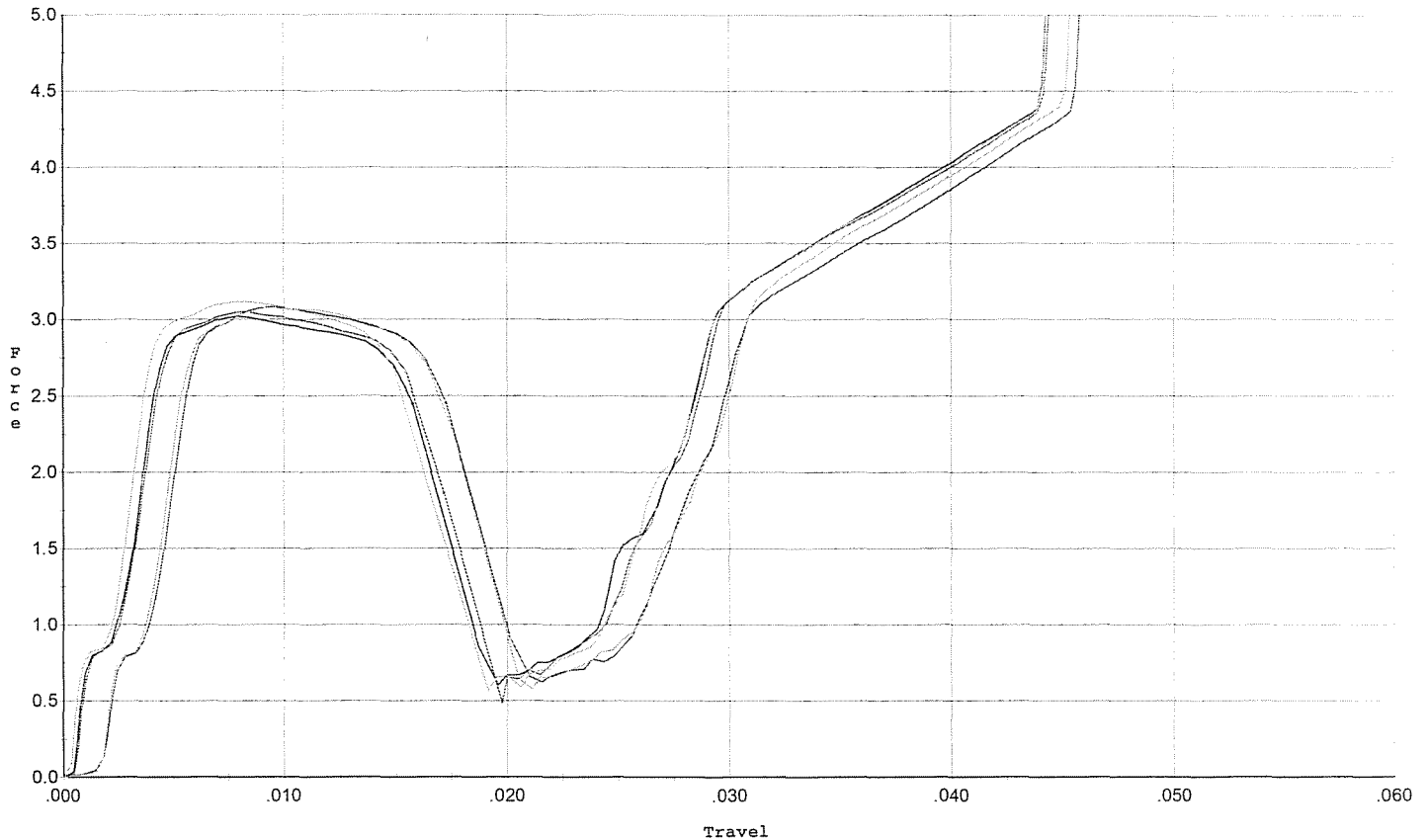
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.144      | 0.018             | 0.00            | 0.029      | 0.039             |           | Set Trigger |
| 2 | 3.049      | 0.017             | 0.00            | 0.030      | 0.036             |           | Set Trigger |
| 3 | 3.055      | 0.017             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 4 | 3.361      | 0.016             | 0.00            | 0.030      | 0.038             |           | Set Trigger |
| 5 | 2.985      | 0.016             | 0.00            | 0.030      | 0.034             |           | Set Trigger |

A3.11

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/23/2009

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 | 3.081      | 0.017             | 0.00            | 0.030      | 0.036             |           | Set Trigger |
| 2 | 3.018      | 0.016             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 3 | 3.051      | 0.017             | 0.00            | 0.029      | 0.038             |           | Set Trigger |
| 4 | 3.115      | 0.017             | 0.00            | 0.030      | 0.039             |           | Set Trigger |
| 5 | 3.079      | 0.018             | 0.00            | 0.030      | 0.037             |           | Set Trigger |

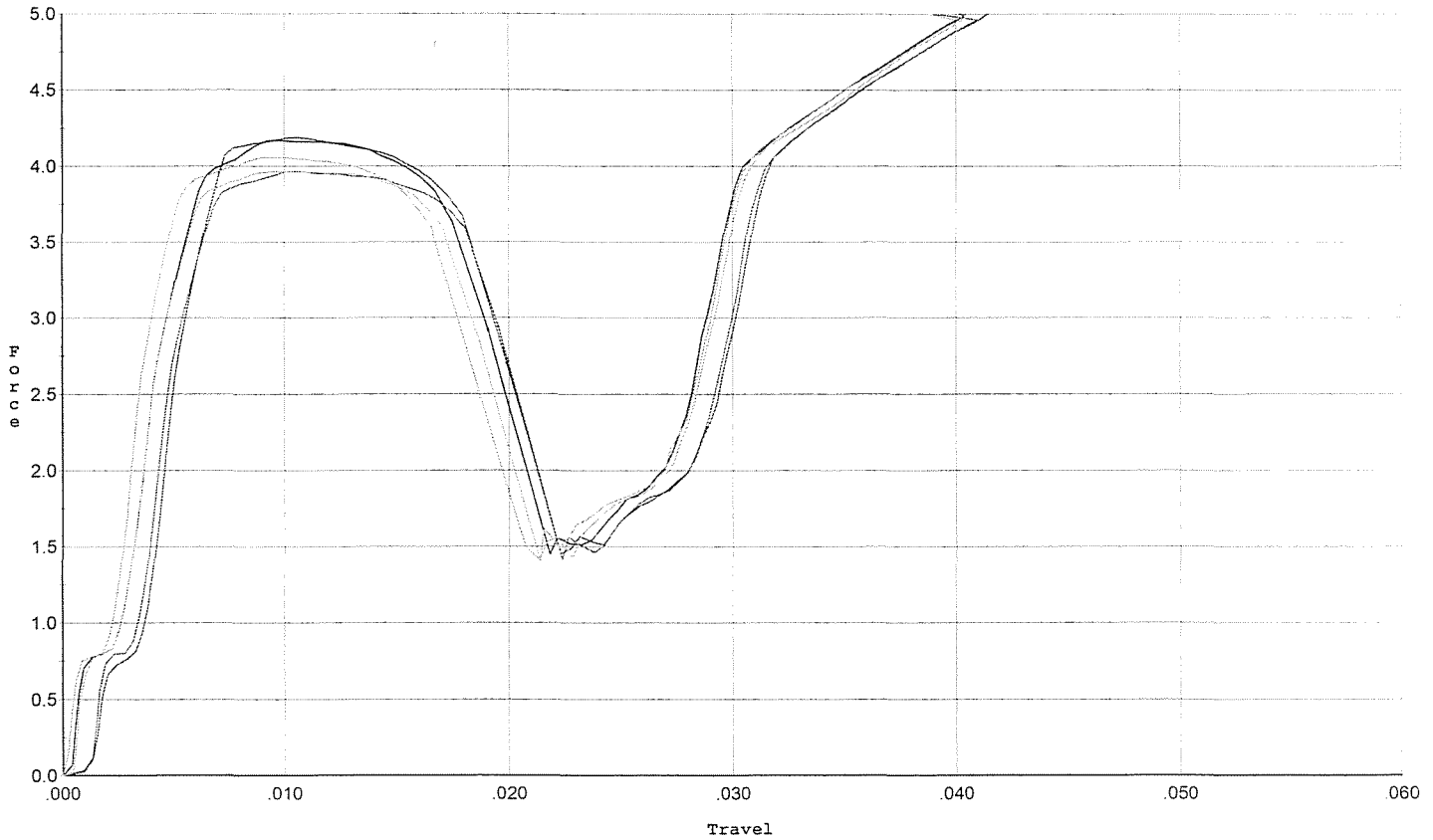
A-3.06



## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



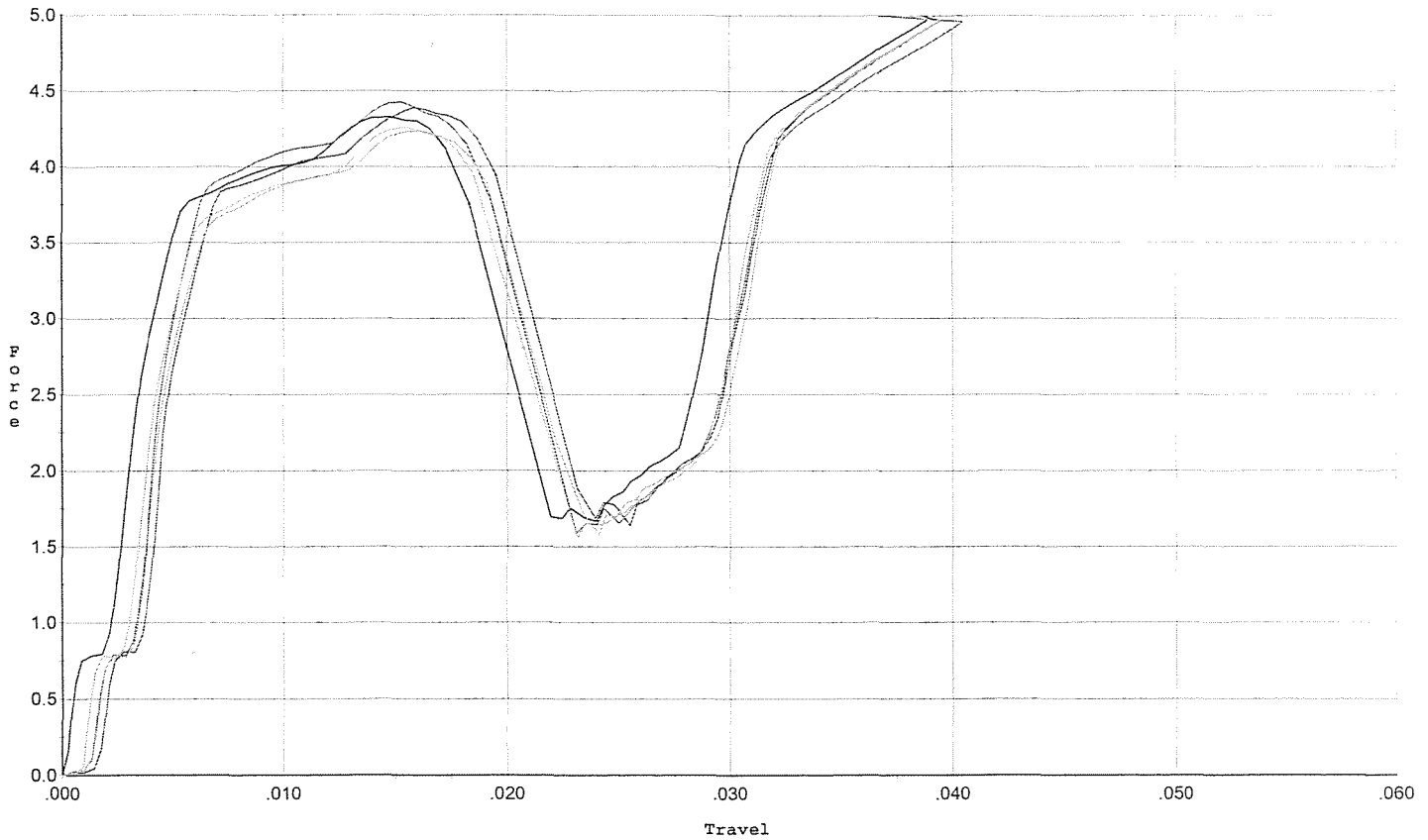
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.189      | 0.020             | 0.00            | 0.028      | 0.056             |           | Set Trigger |
| 2 | 4.171      | 0.019             | 0.00            | 0.027      | 0.056             |           | Set Trigger |
| 3 | 3.965      | 0.020             | 0.00            | 0.028      | 0.054             |           | Set Trigger |
| 4 | 3.964      | 0.019             | 0.00            | 0.028      | 0.053             |           | Set Trigger |
| 5 | 4.058      | 0.017             | 0.00            | 0.028      | 0.049             |           | Set Trigger |

A-4.06

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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



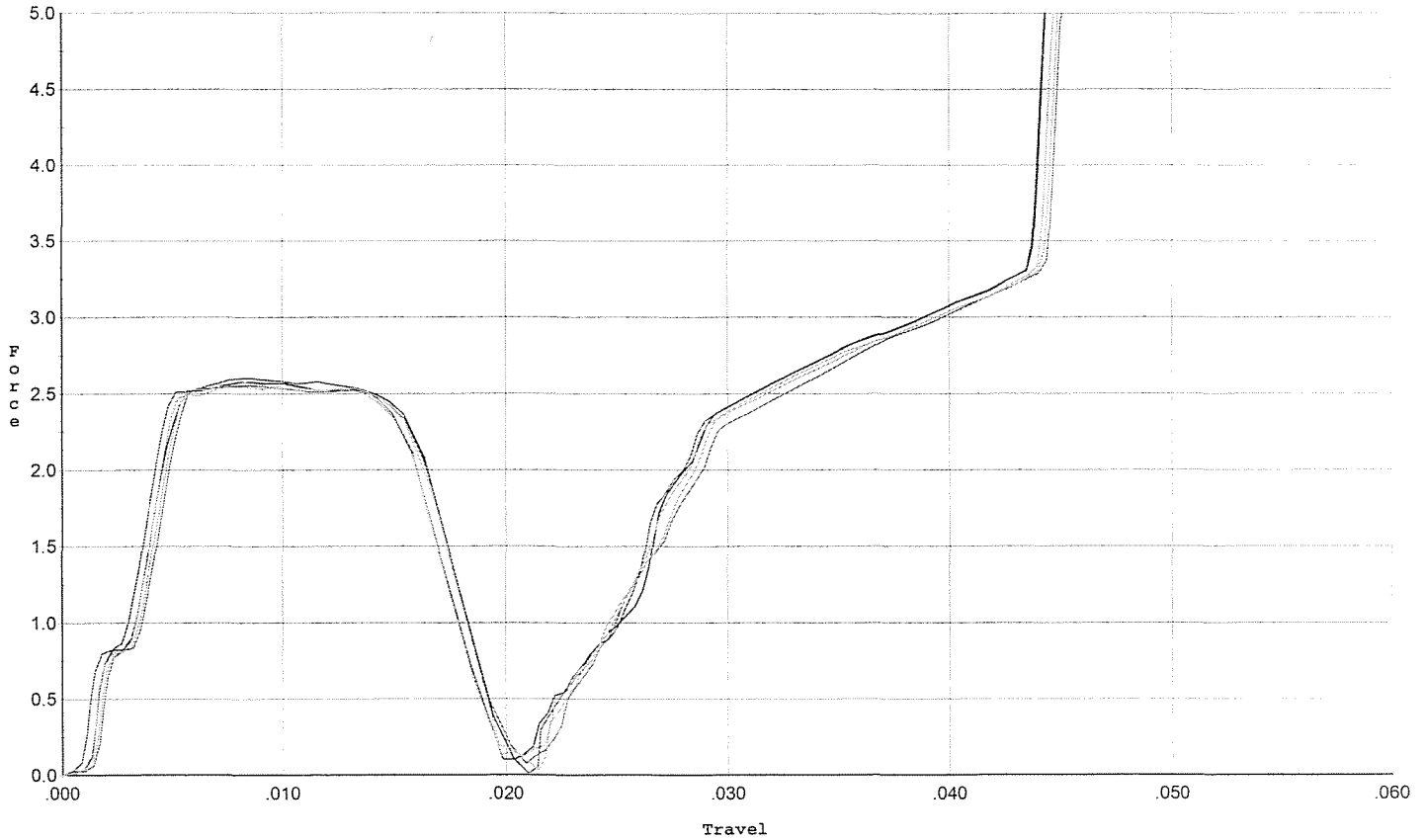
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.390      | 0.019             | 0.00            | 0.027      | 0.057             |           | Set Trigger |
| 2 | 4.325      | 0.018             | 0.00            | 0.027      | 0.056             |           | Set Trigger |
| 3 | 4.426      | 0.019             | 0.00            | 0.027      | 0.058             |           | Set Trigger |
| 4 | 4.258      | 0.021             | 0.00            | 0.027      | 0.061             |           | Set Trigger |
| 5 | 4.236      | 0.019             | 0.00            | 0.027      | 0.055             |           | Set Trigger |

A-4.32

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/23/2009

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



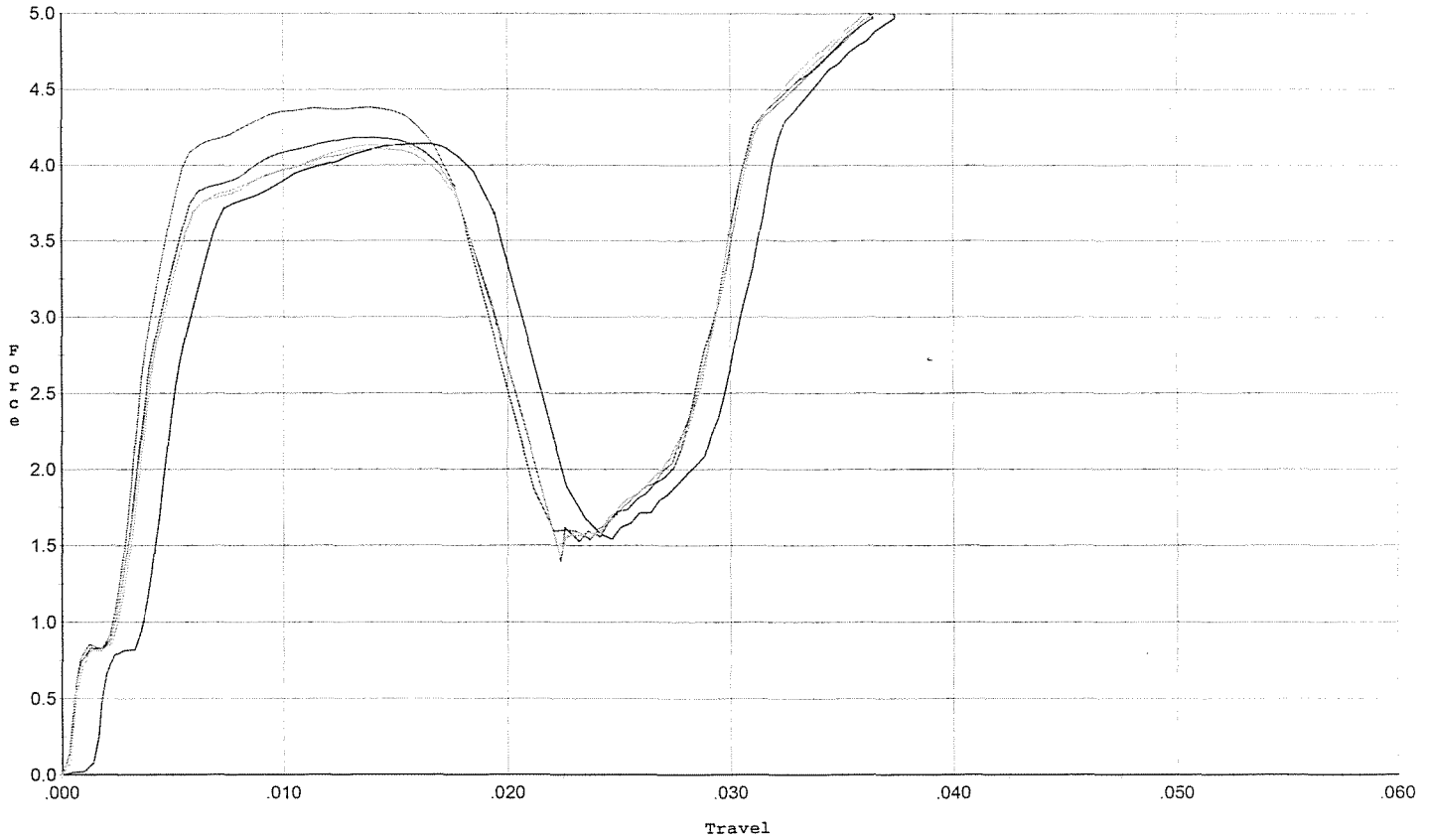
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.601      | 0.016             | 0.00            | 0.031      | 0.030             |           | Set Trigger |
| 2 | 2.575      | 0.016             | 0.00            | 0.031      | 0.031             |           | Set Trigger |
| 3 | 2.553      | 0.016             | 0.00            | 0.032      | 0.030             |           | Set Trigger |
| 4 | 2.579      | 0.017             | 0.00            | 0.031      | 0.031             |           | Set Trigger |
| 5 | 2.543      | 0.016             | 0.00            | 0.032      | 0.029             |           | Set Trigger |

A. 2.57

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/23/2009

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 | 4.183      | 0.020             | 0.00            | 0.027      | 0.059             |           | Set Trigger |
| 2 | 4.141      | 0.019             | 0.00            | 0.028      | 0.055             |           | Set Trigger |
| 3 | 4.383      | 0.018             | 0.00            | 0.028      | 0.056             |           | Set Trigger |
| 4 | 4.136      | 0.019             | 0.00            | 0.028      | 0.057             |           | Set Trigger |
| 5 | 4.110      | 0.019             | 0.00            | 0.027      | 0.057             |           | Set Trigger |

A-4.19