

G680 1390

**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

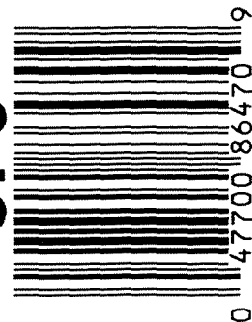
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6801390**

**UPC**



GUN SERIAL # G 6801390

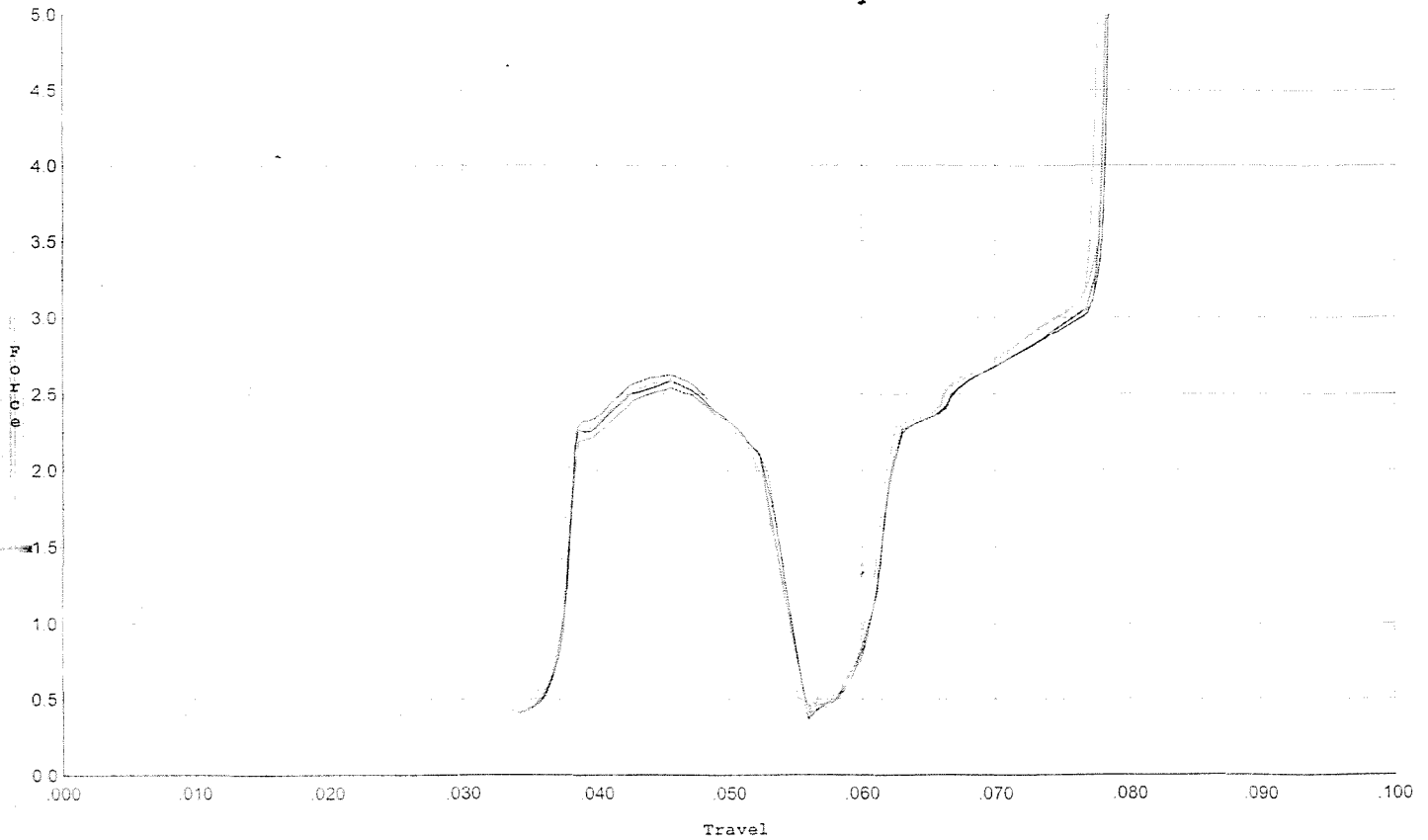
| OP #            | OPERATION NAME                                                                                                                         | READINGS   | DATE     | INITIAL |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|------------|----------|---------|
| 420             | ASSEMBLE ACTION                                                                                                                        |            | 10-14-08 | SP.D.   |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |            | 10-14-08 | SP      |
| 440             | PROOF                                                                                                                                  |            | 10-14-08 | SP.D.   |
| 460             | CHECK HEADSPACE                                                                                                                        |            | 10-14-08 | SP.D.   |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |            | 10-14-08 | SP.D.   |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA FLUX | 10-15-08 | RT      |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | 2000       | 10-15-08 | SP      |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR   |          |         |
| 490             | MAGNAFLUX BOLT                                                                                                                         |            |          |         |
| 500             | ROLLMARK CALIBER                                                                                                                       |            | 10/17/08 | RT      |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |            | 10/20/08 | DG      |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |            | 10-22    |         |
| 545             | (BOLT)                                                                                                                                 |            |          |         |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |            |          |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |            | 10-22-08 | SP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |            | 10-22-08 | SP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |            | 10-22-08 | SP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |            | 1-14-09  | SP.D.   |
|                 | 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 |                                                                                                                                        |            |          |         |

|              |                                                                       |                                           |                   |      |      |         |        |         |    |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------|------|------|---------|--------|---------|----|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | 4.0               | 4.0  | 4.0  | 1-19-09 | R.N.   |         |    |
| CONT.        |                                                                       |                                           |                   |      |      |         |        |         |    |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | 5.0               | 5.0  | 6.0  | 1-19-09 | R.N.   |         |    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                   |      |      |         |        |         |    |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | .023              | .024 | .024 | 1-19-09 | R.N.   |         |    |
|              | J) ASSEMBLE STOCK                                                     |                                           |                   |      |      | 1-14-09 | L.P.H. |         |    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                   |      |      | 1-19-09 | R.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 |      | 1-15-09 | R.N.   |         |    |
|              |                                                                       |                                           | PASS              | FAIL |      |         |        |         |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION<br>N/A |      |      |         |        |         |    |
|              | MALFUNCTION                                                           |                                           |                   |      |      |         |        |         |    |
|              | MALFUNCTION                                                           |                                           |                   |      |      |         |        |         |    |
|              | MALFUNCTION                                                           |                                           |                   |      |      |         |        |         |    |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                   |      |      | 1-15-09 | TL     |         |    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                   |      |      | 1-19-09 | R.N.   |         |    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | 2.37              | 2.38 | 2.40 | 2.34    | 2.31   | 1-16-09 | TL |
|              | C) FUNCTION                                                           |                                           |                   |      |      | 1-19-09 | R.N.   |         |    |
| 690          | PACK                                                                  |                                           |                   |      |      | 1-21-09 | R.N.   |         |    |

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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



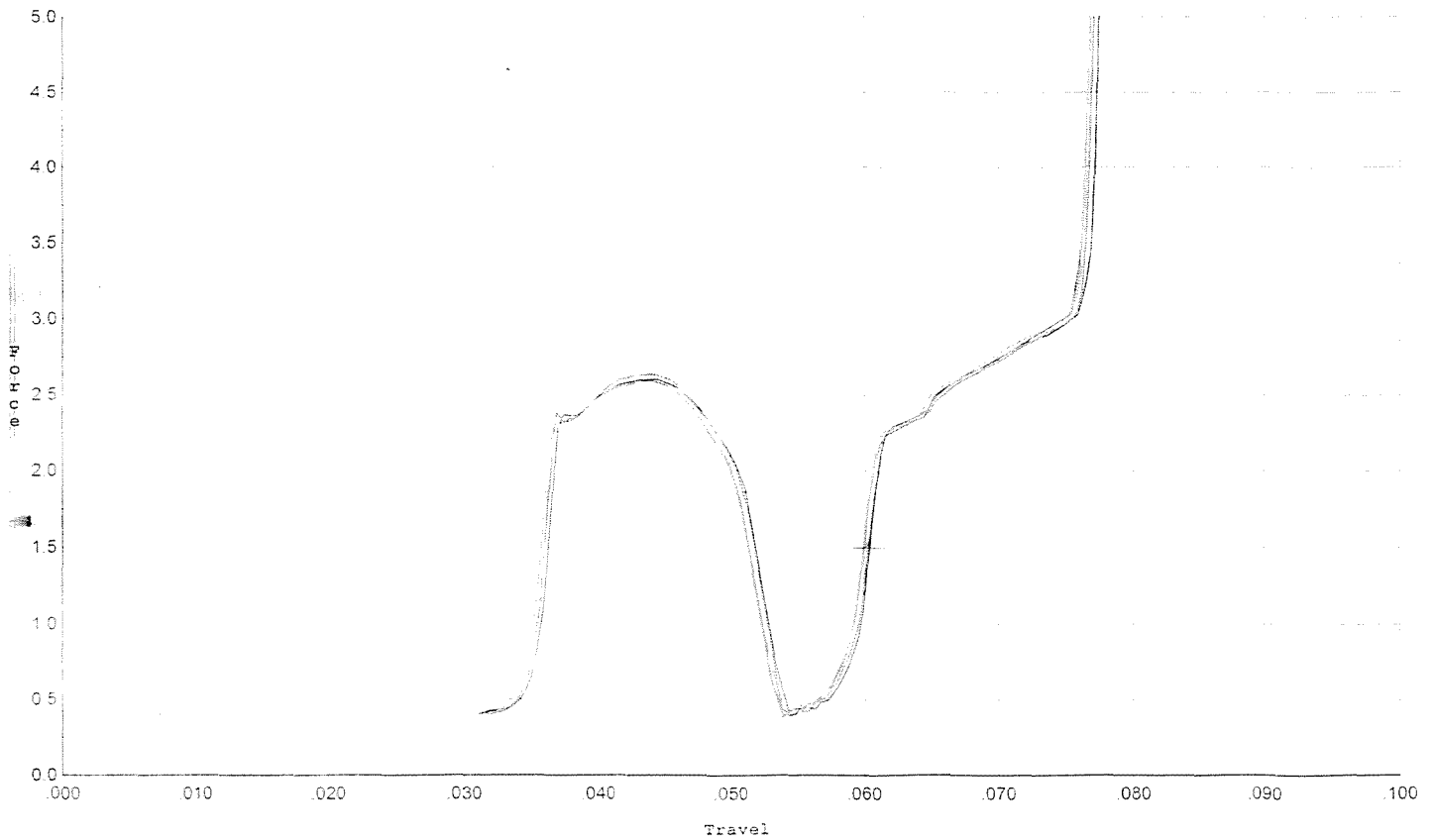
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.626      | 0.054             | 0.036           | 0.031      | 0.054             |           | Set Trigger |
| 2 | 2.582      | 0.053             | 0.036           | 0.031      | 0.053             |           | Set Trigger |
| 3 | 2.539      | 0.053             | 0.037           | 0.031      | 0.052             |           | Set Trigger |
| 4 | 2.595      | 0.053             | 0.036           | 0.031      | 0.052             |           | Set Trigger |
| 5 | 2.598      | 0.053             | 0.036           | 0.032      | 0.051             |           | Set Trigger |

A-258

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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



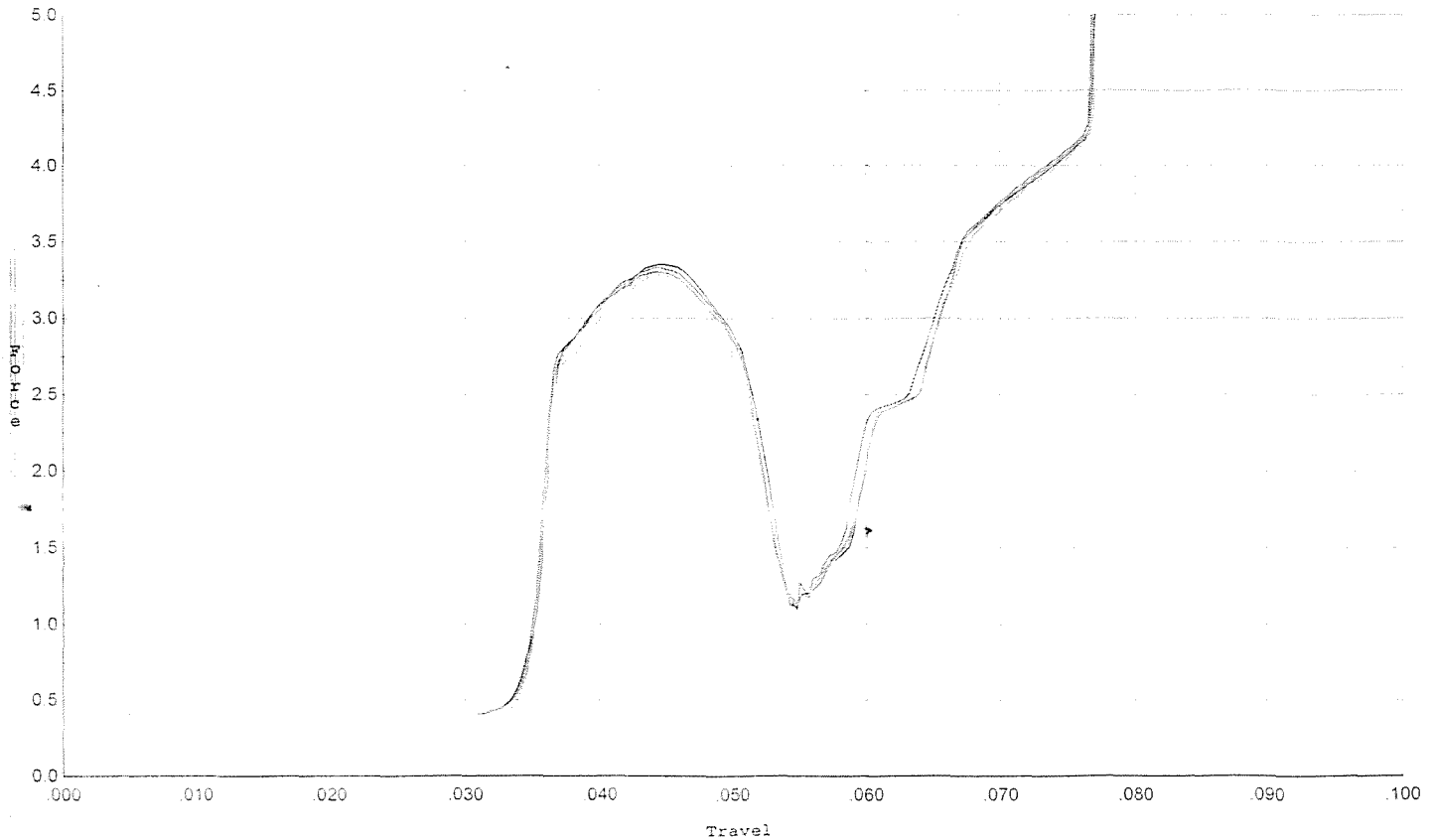
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.593      | 0.051             | 0.034           | 0.032      | 0.051             |           | Set Trigger |
| 2 | 2.602      | 0.051             | 0.035           | 0.032      | 0.052             |           | Set Trigger |
| 3 | 2.635      | 0.051             | 0.035           | 0.032      | 0.052             |           | Set Trigger |
| 4 | 2.586      | 0.051             | 0.034           | 0.032      | 0.051             |           | Set Trigger |
| 5 | 2.630      | 0.051             | 0.034           | 0.032      | 0.052             |           | Set Trigger |

17-2.60

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 1/14/2009

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



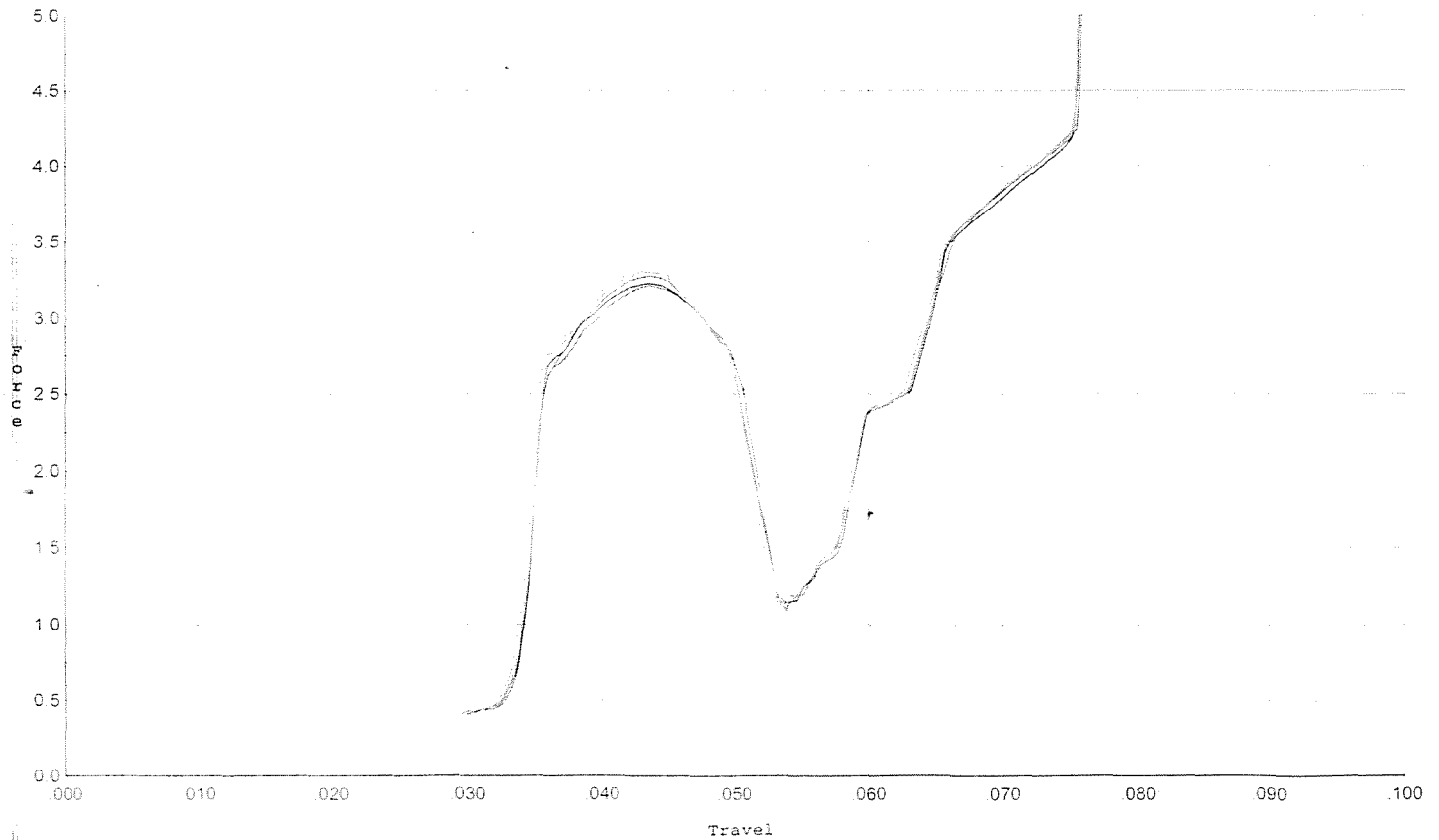
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.299      | 0.051             | 0.034           | 0.031      | 0.063             |           | Set Trigger |
| 2 | 3.350      | 0.052             | 0.034           | 0.030      | 0.065             |           | Set Trigger |
| 3 | 3.332      | 0.051             | 0.034           | 0.031      | 0.063             |           | Set Trigger |
| 4 | 3.280      | 0.052             | 0.034           | 0.030      | 0.064             |           | Set Trigger |
| 5 | 3.299      | 0.051             | 0.034           | 0.031      | 0.062             |           | Set Trigger |

A-3-31

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 1/14/2009

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



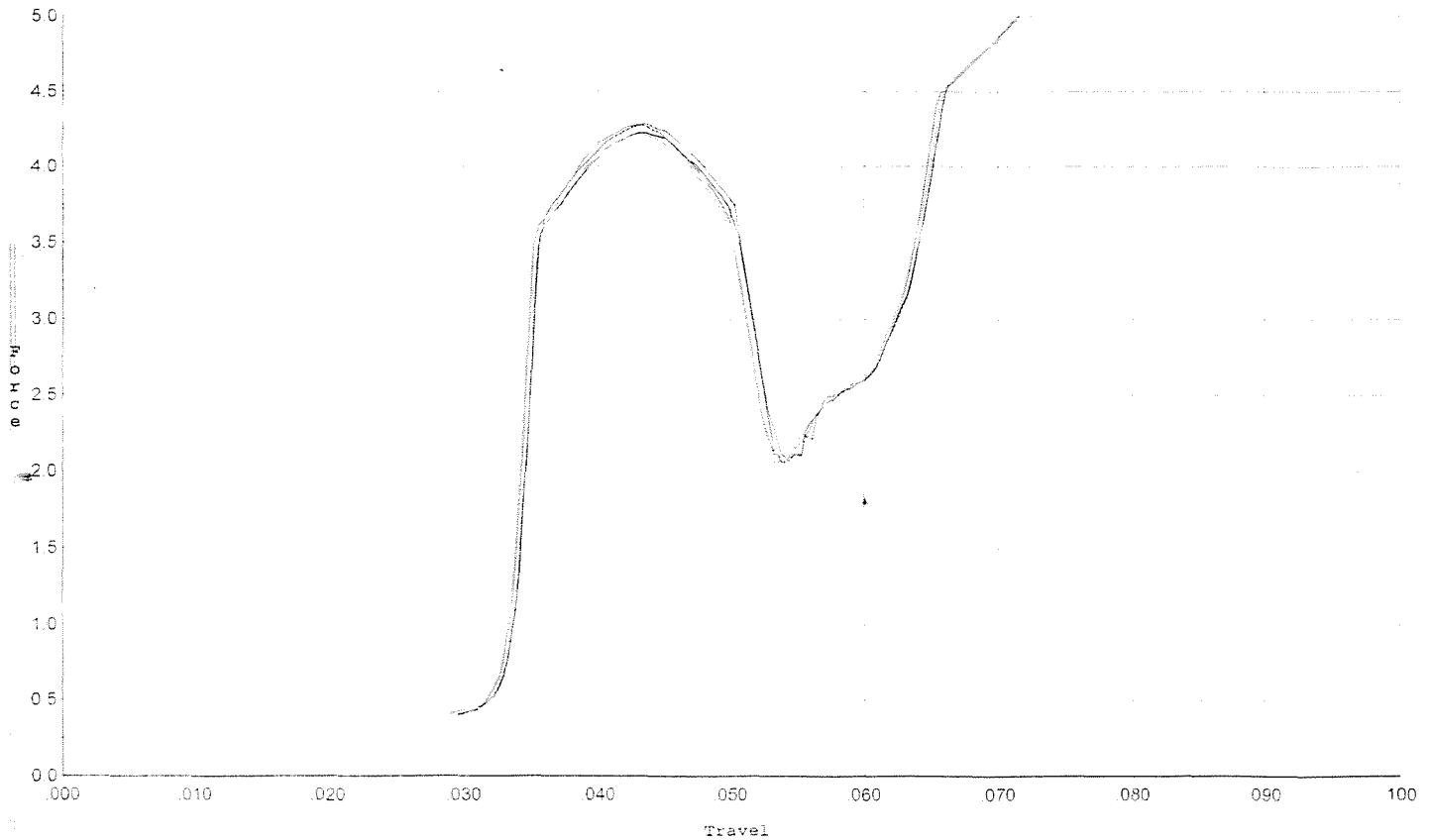
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.212      | 0.051             | 0.033           | 0.030      | 0.062             |           | Set Trigger |
| 2 | 3.225      | 0.050             | 0.033           | 0.031      | 0.061             |           | Set Trigger |
| 3 | 3.274      | 0.050             | 0.033           | 0.031      | 0.061             |           | Set Trigger |
| 4 | 3.306      | 0.050             | 0.033           | 0.031      | 0.063             |           | Set Trigger |
| 5 | 3.299      | 0.050             | 0.033           | 0.031      | 0.062             |           | Set Trigger |

A.S.26

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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



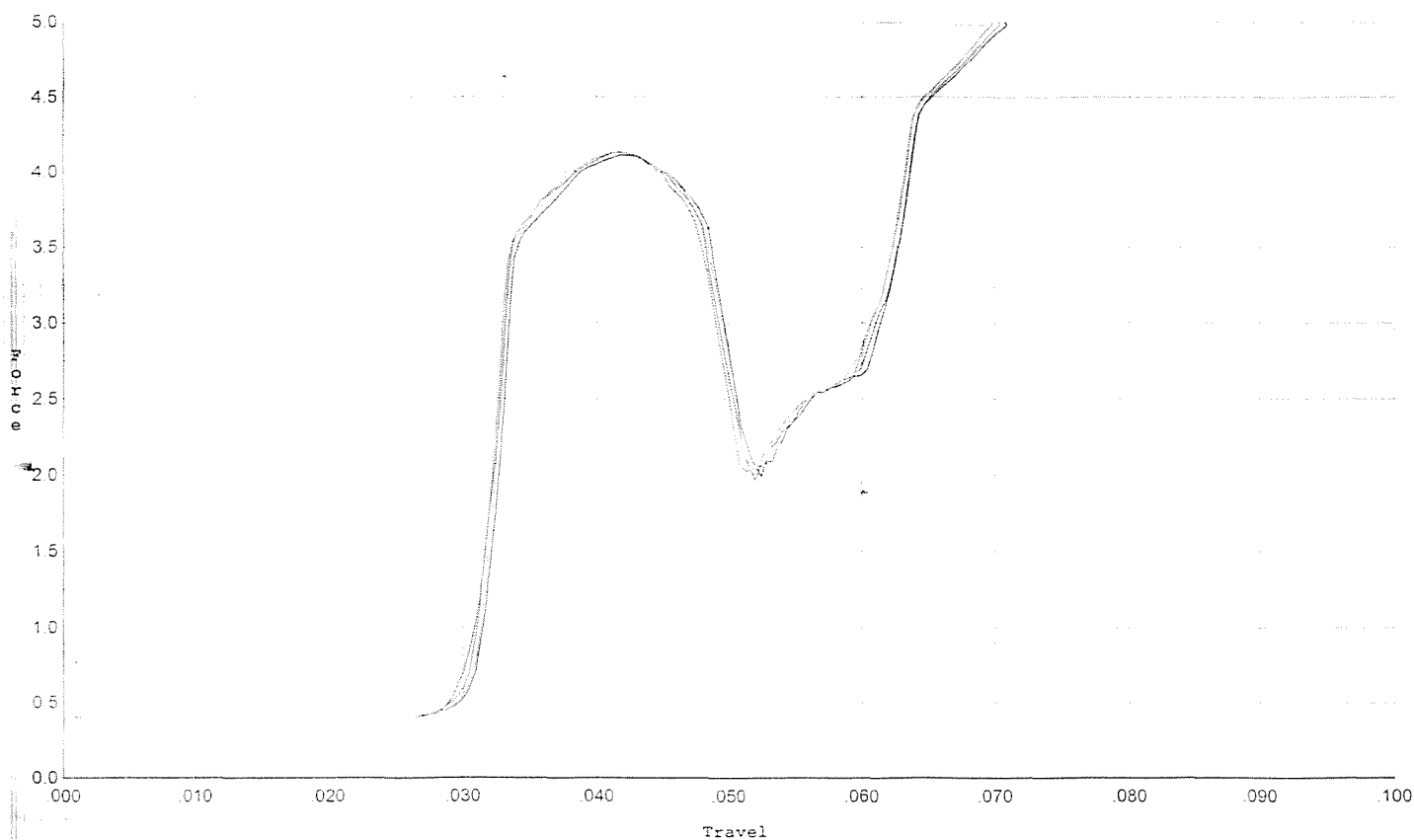
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.285      | 0.050             | 0.033           | 0.028      | 0.080             |           | Set Trigger |
| 2 | 4.229      | 0.051             | 0.033           | 0.028      | 0.080             |           | Set Trigger |
| 3 | 4.281      | 0.050             | 0.032           | 0.028      | 0.080             |           | Set Trigger |
| 4 | 4.216      | 0.050             | 0.033           | 0.028      | 0.078             |           | Set Trigger |
| 5 | 4.221      | 0.050             | 0.033           | 0.028      | 0.079             |           | Set Trigger |

A-4.24

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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



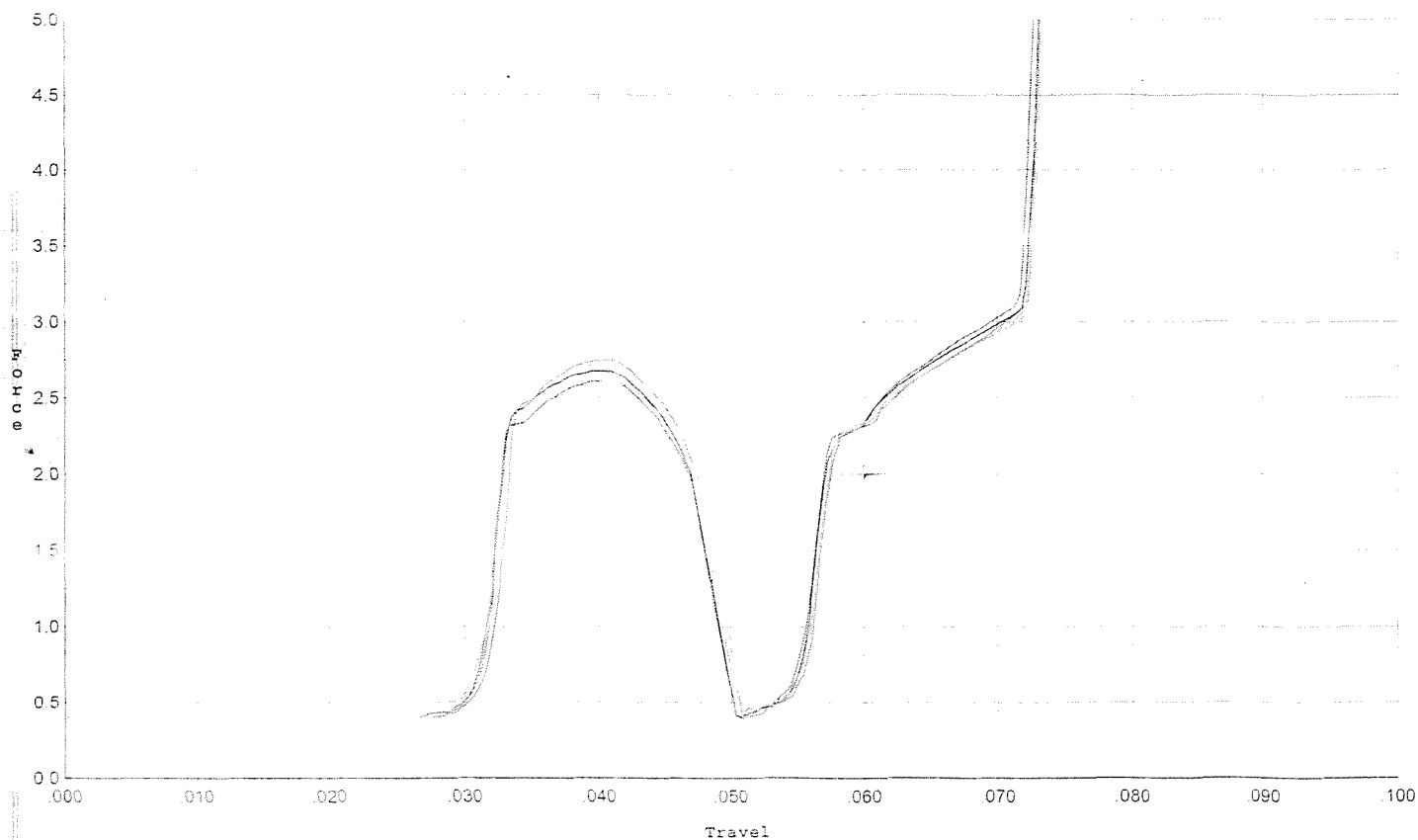
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.131      | 0.048             | 0.030           | 0.029      | 0.077             |           | Set Trigger |
| 2 | 4.109      | 0.048             | 0.031           | 0.028      | 0.078             |           | Set Trigger |
| 3 | 4.128      | 0.048             | 0.030           | 0.028      | 0.078             |           | Set Trigger |
| 4 | 4.150      | 0.049             | 0.030           | 0.028      | 0.079             |           |             |
| 5 | 4.195      | 0.049             | 0.031           | 0.028      | 0.080             |           |             |

A-4.14

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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



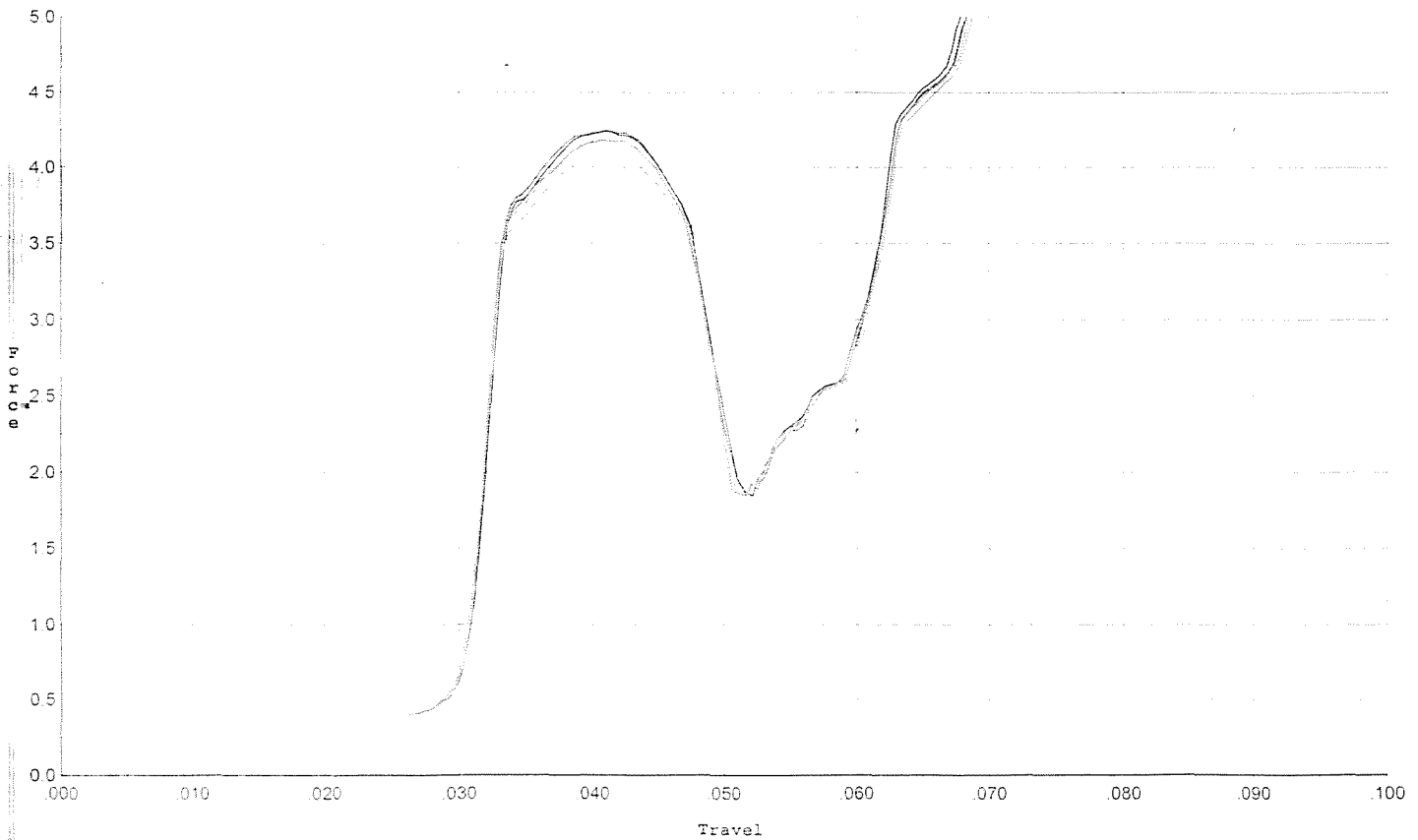
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.612      | 0.047             | 0.031           | 0.031      | 0.050             |           | Set Trigger |
| 2 | 2.674      | 0.049             | 0.031           | 0.031      | 0.052             |           | Set Trigger |
| 3 | 2.751      | 0.047             | 0.031           | 0.031      | 0.052             |           | Set Trigger |
| 4 | 2.769      | 0.048             | 0.031           | 0.031      | 0.054             |           | Set Trigger |
| 5 | 2.608      | 0.047             | 0.030           | 0.031      | 0.051             |           | Set Trigger |

A2-63

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 1/14/2009

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 | 4.247      | 0.048             | 0.030           | 0.028      | 0.078             |           | Set Trigger |
| 2 | 4.243      | 0.048             | 0.030           | 0.027      | 0.077             |           | Set Trigger |
| 3 | 4.176      | 0.048             | 0.030           | 0.028      | 0.078             |           | Set Trigger |
| 4 | 4.074      | 0.048             | 0.030           | 0.028      | 0.076             |           | Set Trigger |
| 5 | 4.189      | 0.048             | 0.030           | 0.028      | 0.078             |           | Set Trigger |

A-4.18