

0014826

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



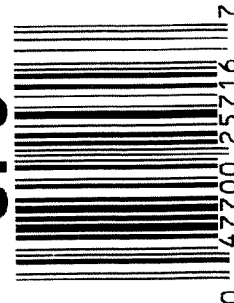
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6801400**

**UPC**



**BM FORM**

GUN SERIAL #

G 680 1400

| OP #            | OPERATION NAME                                                 | READINGS            | DATE     | INITIAL |
|-----------------|----------------------------------------------------------------|---------------------|----------|---------|
| 420             | ASSEMBLE ACTION                                                |                     | 10-14-08 | S.P.D.  |
| 430             | ASSEMBLE TO STOCK                                              |                     | 10-14-08 | JP      |
| 440             | PROOF                                                          |                     | 10-14-08 | S.P.D.  |
| 460             | CHECK HEADSPACE                                                |                     | 10-14-08 | S.P.D.  |
| 470             | DIS-ASSEMBLE ACTION                                            |                     | 10-14-08 | S.P.D.  |
| 472             | SERIALIZE BOLT HANDLE                                          | MAGNA-FLUX          | 10-15-08 | RIC     |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 10-15-08 | JP      |
| 480             | MAGNAFLUX BBL ACTION                                           | OPERATOR            | 10/17/08 | (R)     |
| 490             | MAGNAFLUX BOLT                                                 |                     |          |         |
| 500             | ROLLMARK CALIBER                                               |                     | 10/17/08 | RJ      |
| 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 | JP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 10-22-08 | JP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 10-22-08 | JP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                     |                     | 10-23-08 | S.P.D.  |
|                 | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |          |         |
| F004 REV 5/2006 |                                                                |                     |          |         |

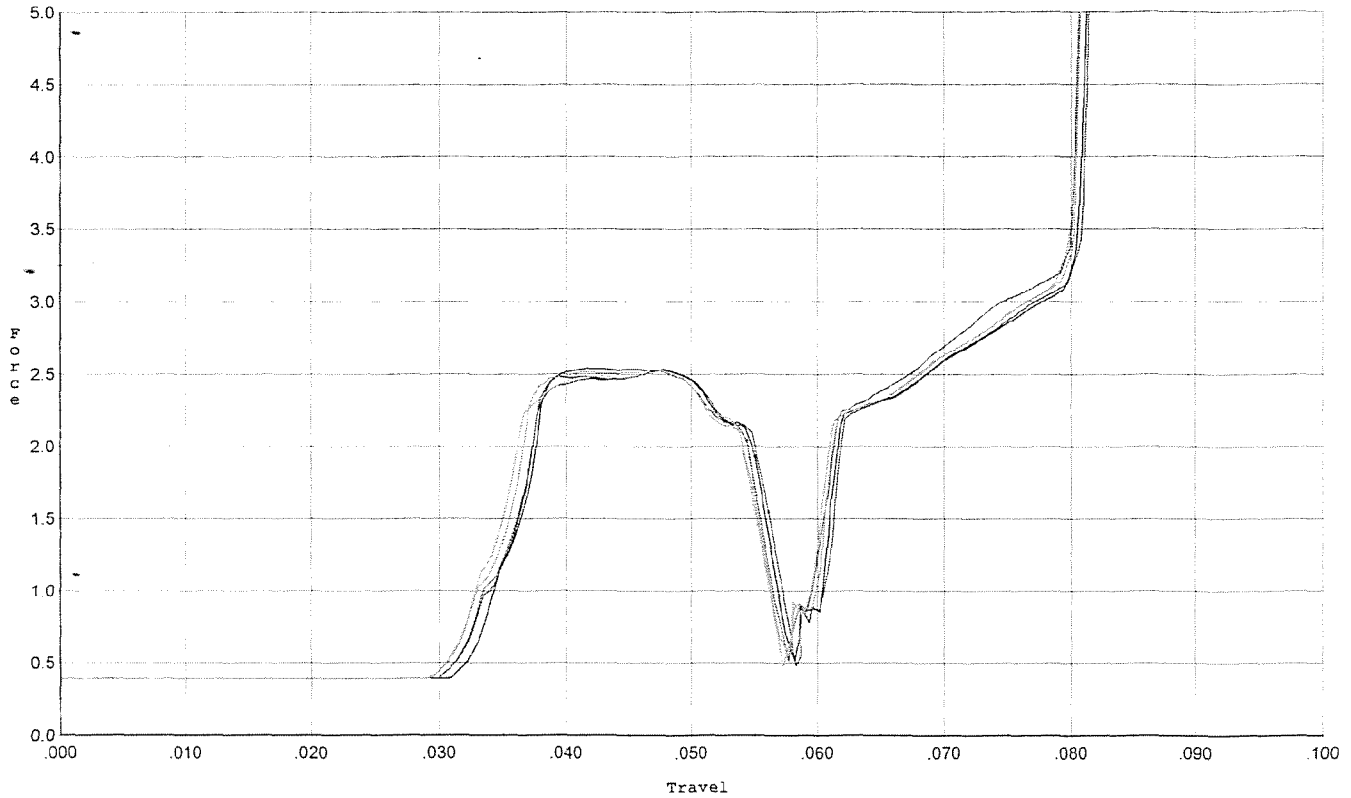
| OP #         | OPERATION NAME                                                           | READINGS                                                   | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>3.5</u> <u>3.5</u> <u>4.0</u>                           | 10-30-08 | L. D.   |
| CONT.        |                                                                          |                                                            |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.0</u> <u>4.0</u> <u>5.0</u>                           | 10-30-08 | L. D.   |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                            |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.024</u> <u>.024</u>                        | 10-30-08 | L. D.   |
|              | J) ASSEMBLE STOCK                                                        |                                                            | 10-23-08 | L. D.   |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                            | 10-30-08 | L. D.   |
|              | 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                       | 10-24-08 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                 |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                 |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                 |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                 |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                            | 10-24-08 | ESN     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                            | 10-30-08 | L. D.   |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.74</u> <u>2.77</u> <u>2.8</u> <u>2.77</u> <u>2.83</u> | 10-28-08 | TL      |
|              | C) FUNCTION                                                              |                                                            | 10-30-08 | L. D.   |
| 690          | PACK                                                                     |                                                            | 11/3/08  | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



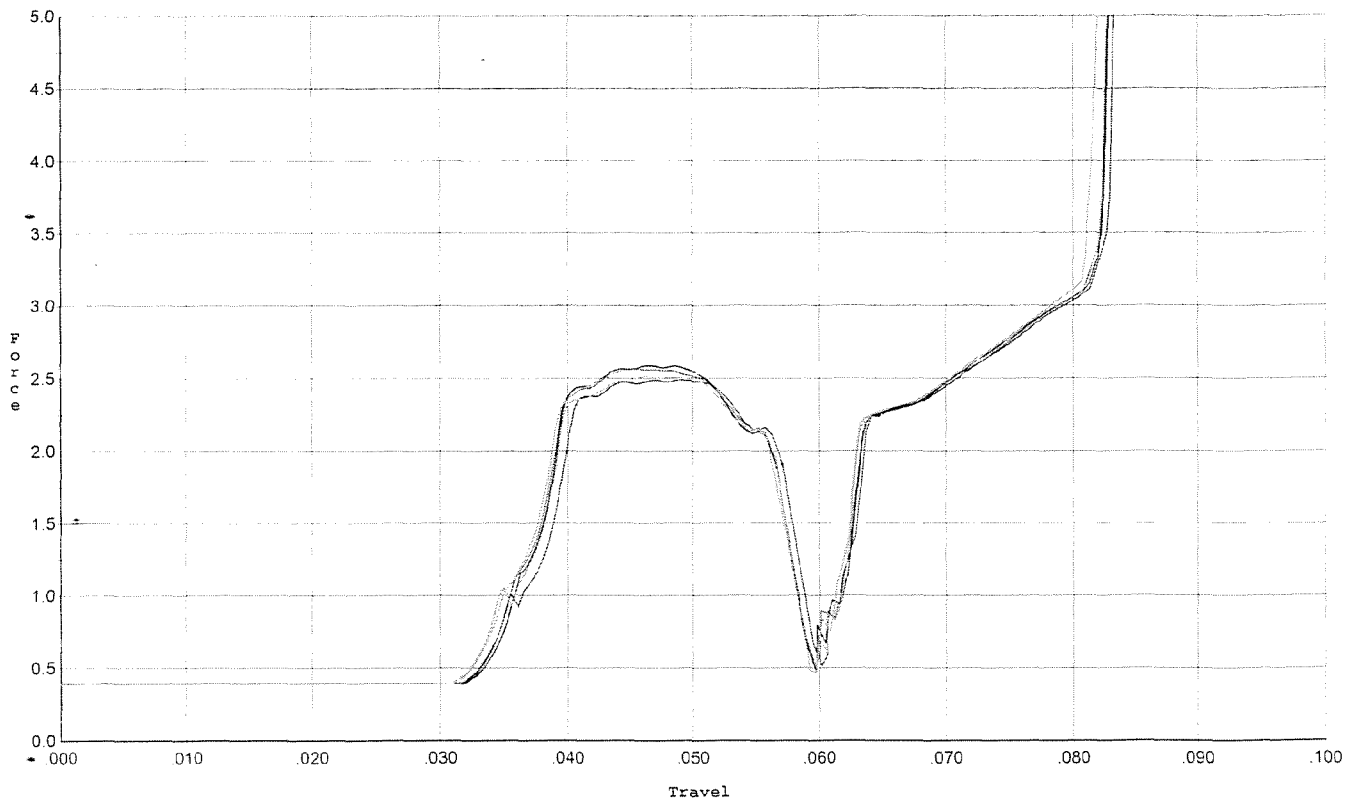
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.540      | 0.056             | 0.032           | 0.032      | 0.063             |           | Set Trigger |
| 2 | 2.534      | 0.055             | 0.033           | 0.032      | 0.061             |           | Set Trigger |
| 3 | 2.524      | 0.054             | 0.032           | 0.032      | 0.060             |           | Set Trigger |
| 4 | 2.524      | 0.055             | 0.031           | 0.032      | 0.063             |           | Set Trigger |
| 5 | 2.534      | 0.055             | 0.031           | 0.032      | 0.062             |           | Set Trigger |

Aug 2.53

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



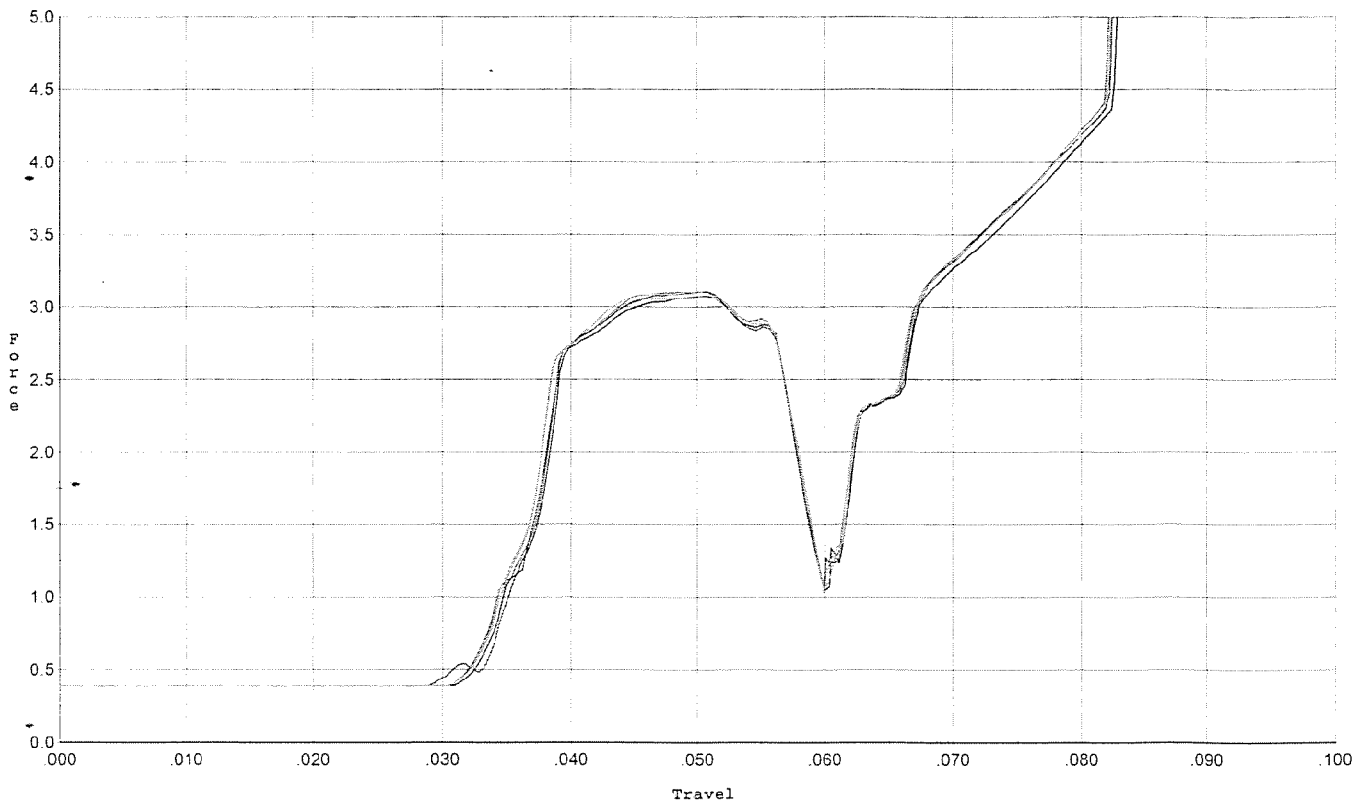
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.488      | 0.057             | 0.034           | 0.032      | 0.061             |           | Set Trigger |
| 2 | 2.591      | 0.057             | 0.034           | 0.032      | 0.062             |           | Set Trigger |
| 3 | 2.561      | 0.057             | 0.034           | 0.032      | 0.062             |           | Set Trigger |
| 4 | 2.579      | 0.057             | 0.033           | 0.032      | 0.063             |           | Set Trigger |
| 5 | 2.515      | 0.057             | 0.033           | 0.031      | 0.062             |           | Set Trigger |

Avg 2.54

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



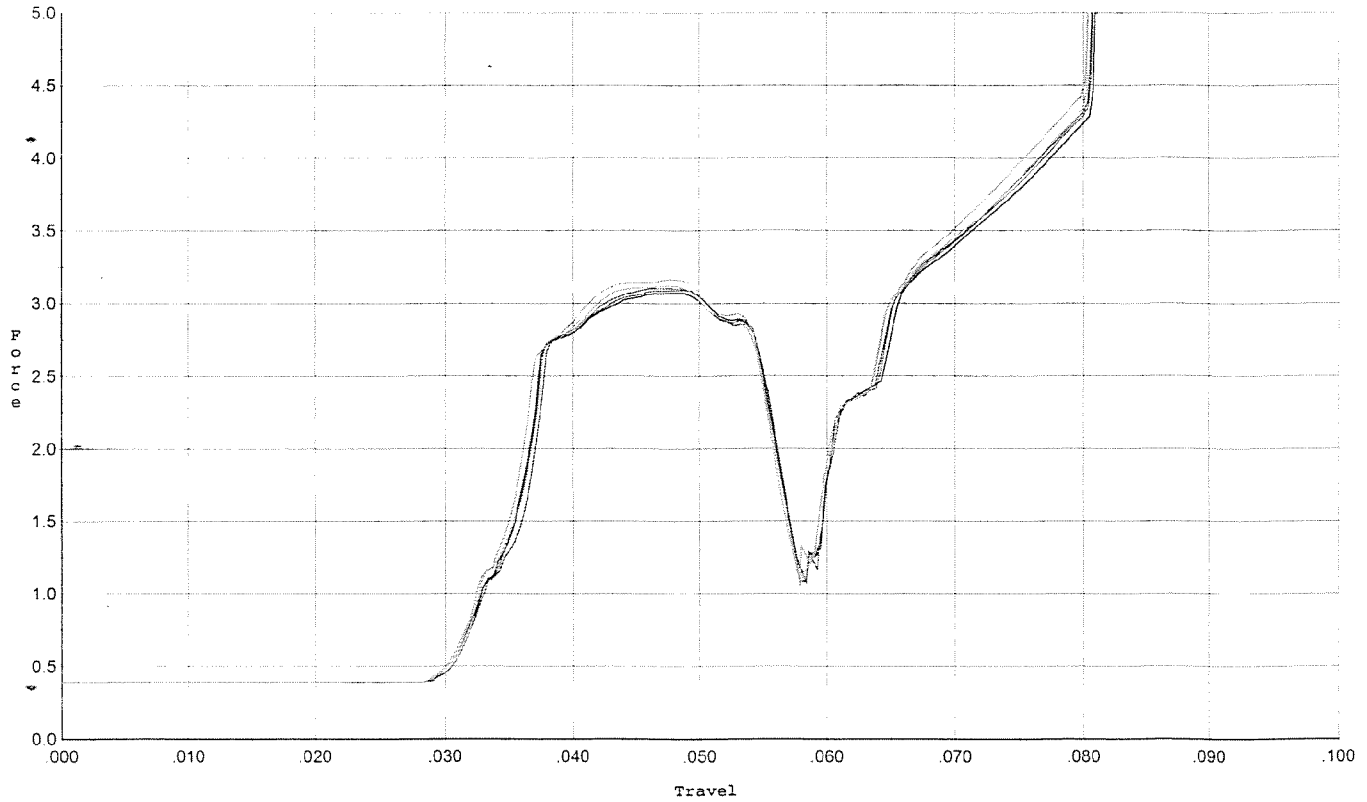
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.099      | 0.056             | 0.034           | 0.031      | 0.073             |           | Set Trigger |
| 2 | 3.071      | 0.058             | 0.033           | 0.031      | 0.075             |           | Set Trigger |
| 3 | 3.103      | 0.056             | 0.033           | 0.031      | 0.074             |           | Set Trigger |
| 4 | 3.109      | 0.056             | 0.033           | 0.031      | 0.074             |           | Set Trigger |
| 5 | 3.077      | 0.058             | 0.033           | 0.030      | 0.076             |           | Set Trigger |

Avg 309

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



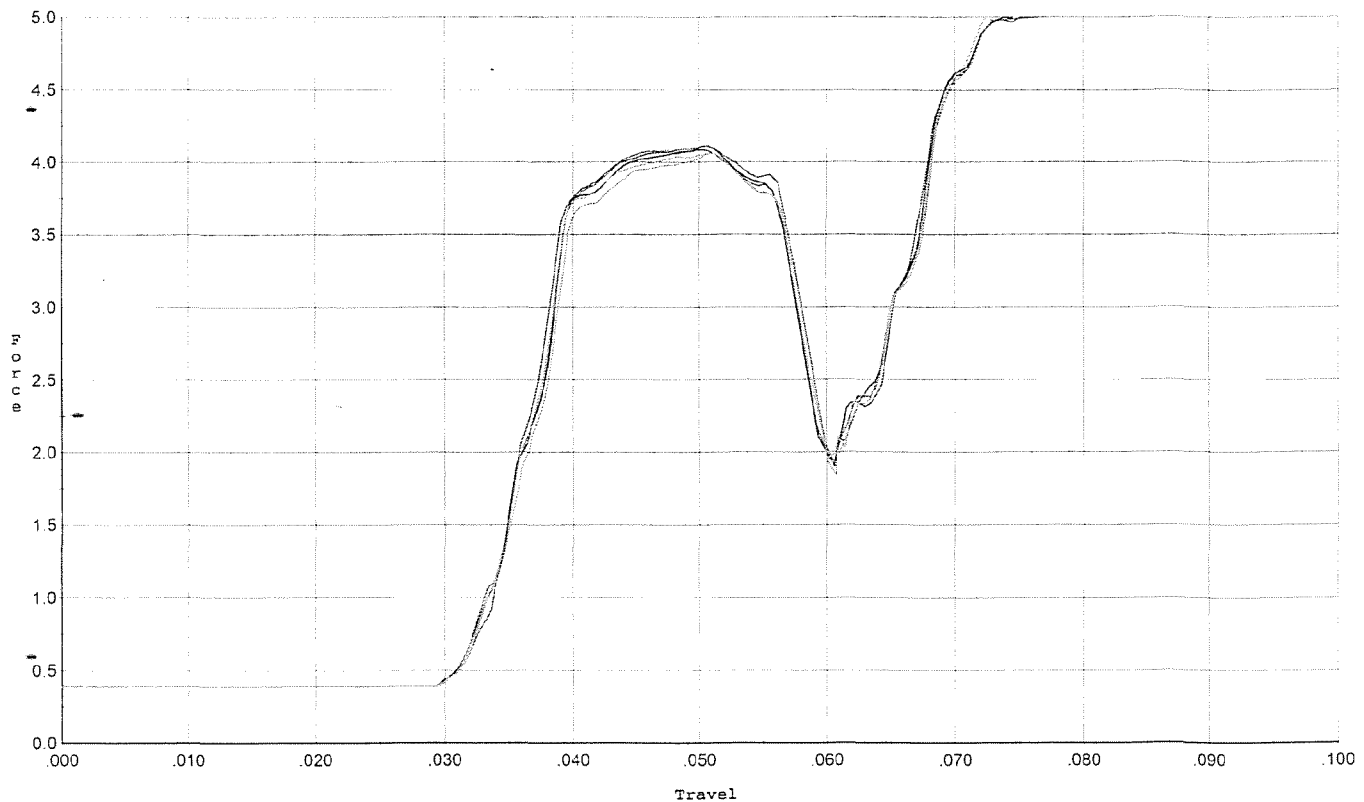
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.089      | 0.055             | 0.031           | 0.031      | 0.073             |           | Set Trigger |
| 2 | 3.072      | 0.056             | 0.031           | 0.031      | 0.074             |           | Set Trigger |
| 3 | 3.102      | 0.056             | 0.031           | 0.031      | 0.074             |           | Set Trigger |
| 4 | 3.164      | 0.054             | 0.031           | 0.031      | 0.073             |           | Set Trigger |
| 5 | 3.118      | 0.054             | 0.031           | 0.031      | 0.073             |           | Set Trigger |

Aug 3.10

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/21/08

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



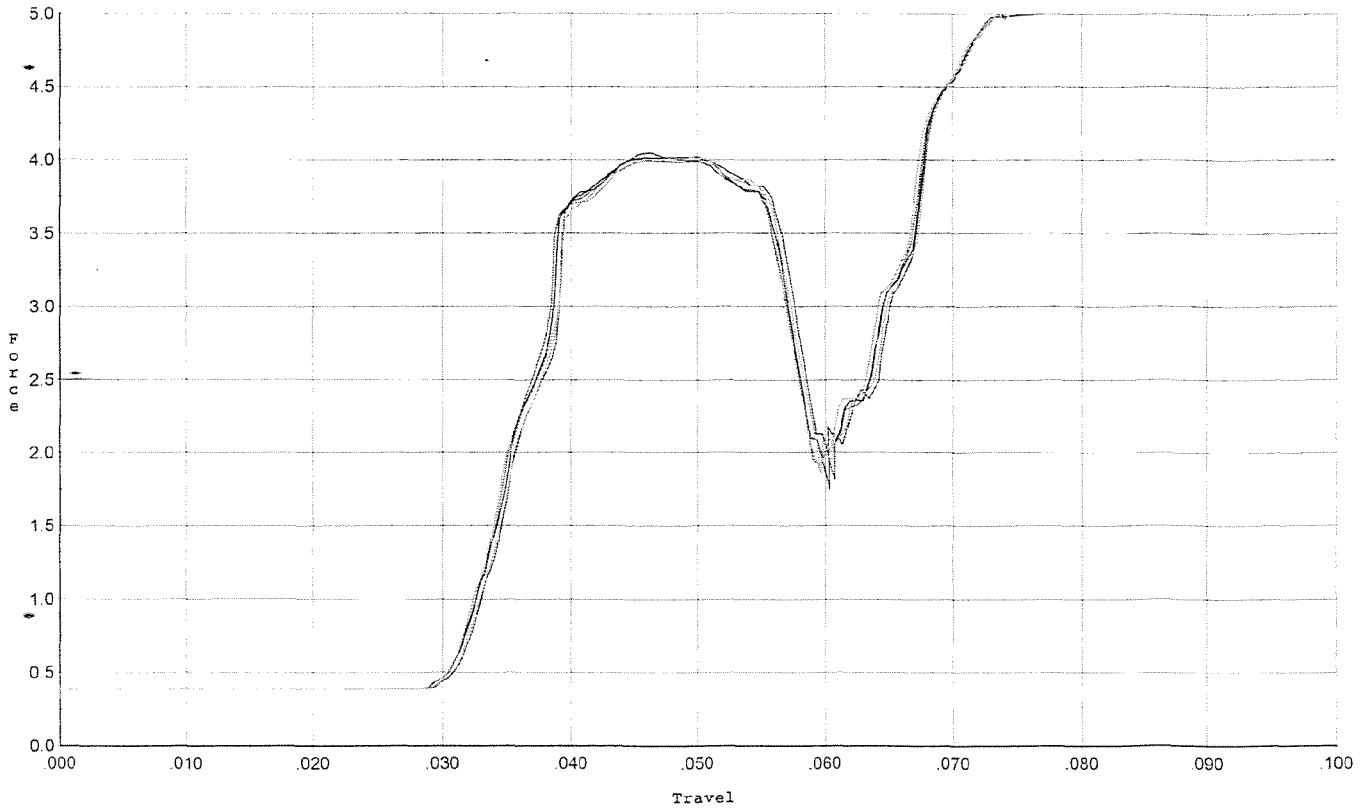
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.085      | 0.057             | 0.032           | 0.029      | 0.096             |           | Set Trigger |
| 2 | 4.113      | 0.057             | 0.032           | 0.029      | 0.096             |           | Set Trigger |
| 3 | 4.115      | 0.057             | 0.032           | 0.029      | 0.099             |           | Set Trigger |
| 4 | 4.061      | 0.056             | 0.032           | 0.029      | 0.095             |           | Set Trigger |
| 5 | 4.060      | 0.058             | 0.032           | 0.029      | 0.097             |           | Set Trigger |

Aug 4.08

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

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



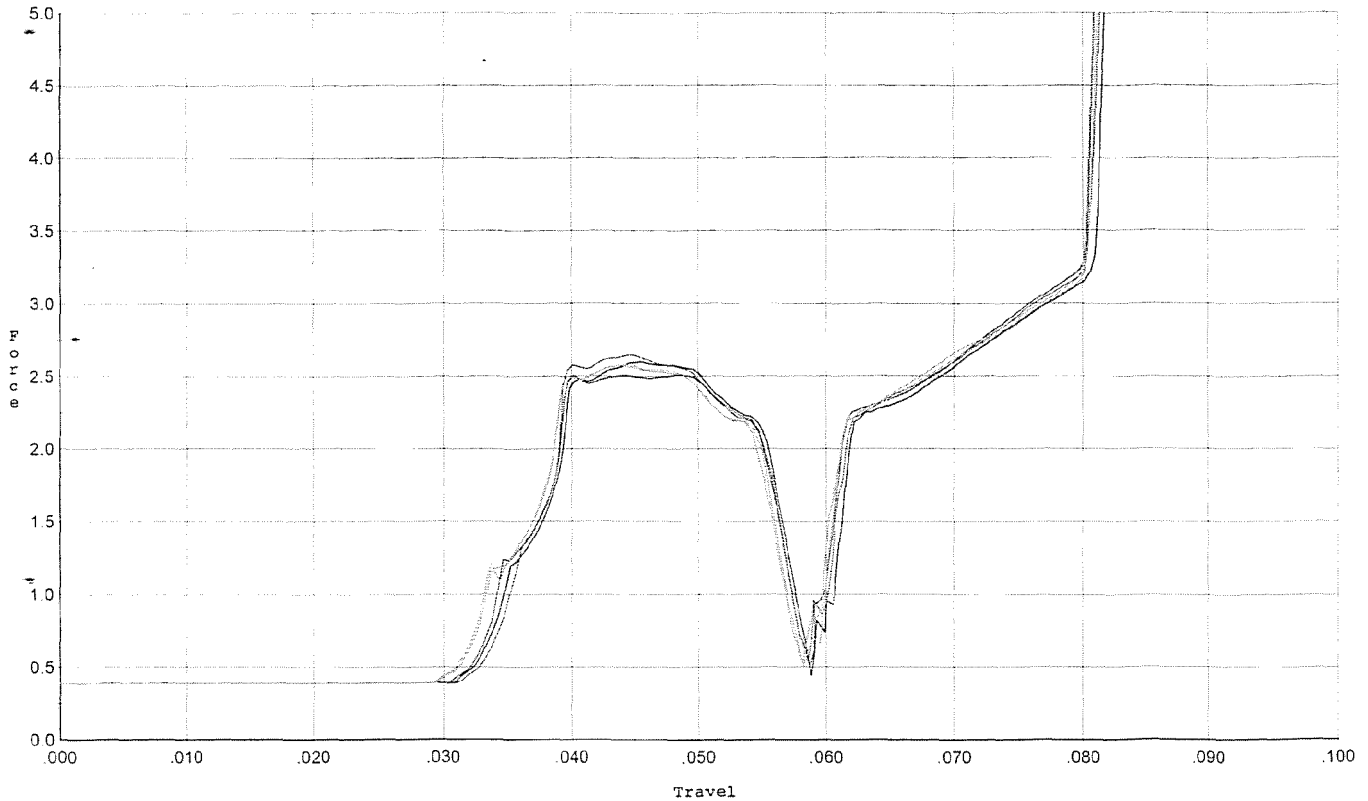
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.048      | 0.057             | 0.031           | 0.029      | 0.096             |           | Set Trigger |
| 2 | 4.017      | 0.056             | 0.031           | 0.029      | 0.095             |           | Set Trigger |
| 3 | 3.994      | 0.057             | 0.031           | 0.029      | 0.096             |           | Set Trigger |
| 4 | 4.013      | 0.056             | 0.031           | 0.029      | 0.093             |           | Set Trigger |
| 5 | 4.025      | 0.057             | 0.031           | 0.029      | 0.095             |           | Set Trigger |

Aug 4.01

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putsch 8/21/08

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



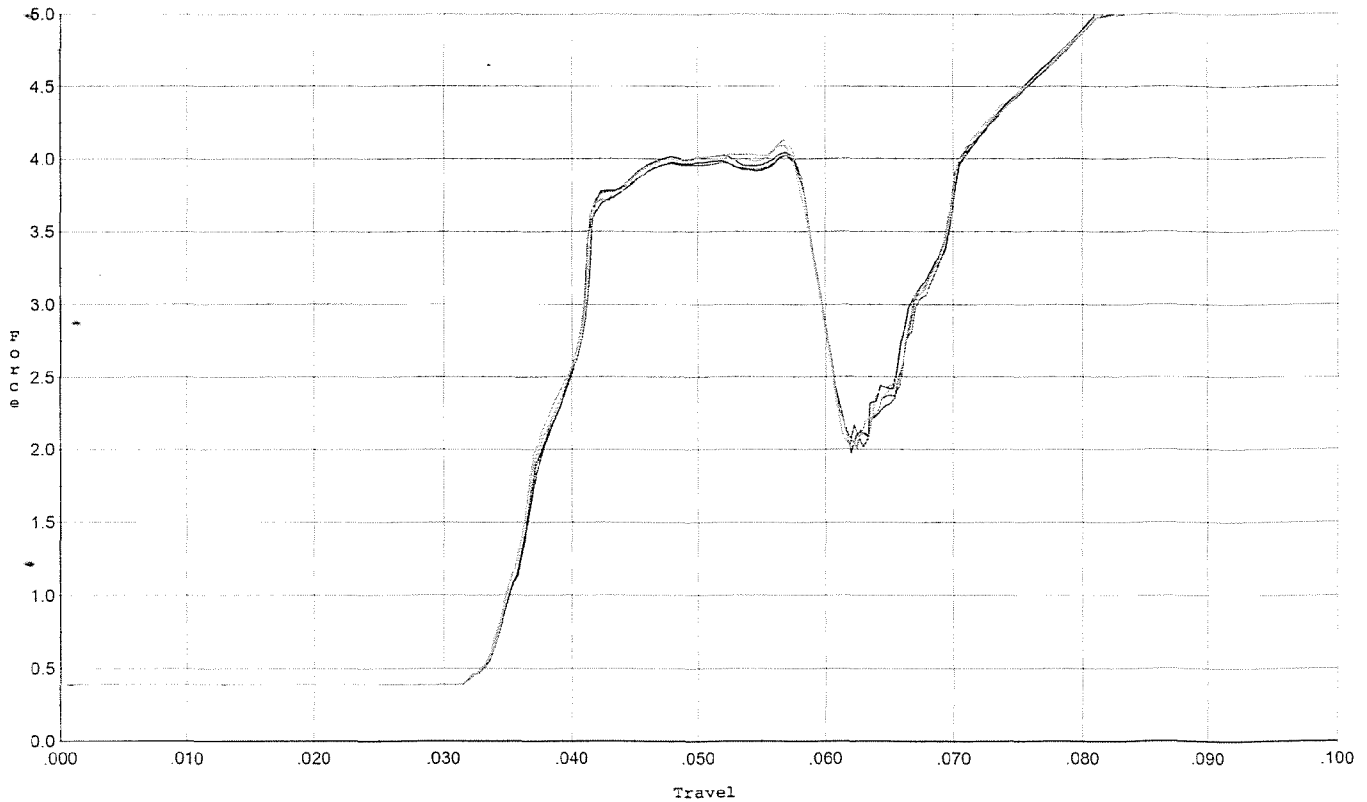
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.507      | 0.056             | 0.033           | 0.031      | 0.061             |           | Set Trigger |
| 2 | 2.600      | 0.057             | 0.033           | 0.032      | 0.063             |           | Set Trigger |
| 3 | 2.650      | 0.056             | 0.034           | 0.032      | 0.061             |           | Set Trigger |
| 4 | 2.582      | 0.055             | 0.032           | 0.032      | 0.061             |           | Set Trigger |
| 5 | 2.574      | 0.056             | 0.032           | 0.032      | 0.061             |           | Set Trigger |

AUG 2.58

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/21/08

Model: M/24  
 Serial No: Form #F005  
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.046      | 0.058             | 0.034           | 0.029      | 0.096             |           | Set Trigger |
| 2 | 4.026      | 0.058             | 0.034           | 0.029      | 0.095             |           | Set Trigger |
| 3 | 4.022      | 0.058             | 0.034           | 0.029      | 0.096             |           | Set Trigger |
| 4 | 4.091      | 0.059             | 0.034           | 0.029      | 0.097             |           | Set Trigger |
| 5 | 4.133      | 0.058             | 0.034           | 0.029      | 0.097             |           | Set Trigger |

Avg 4.06