

G 680 7669

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

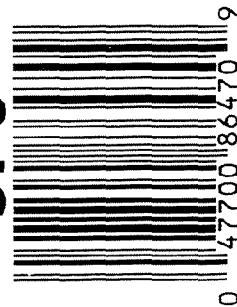
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6807669**

**UPC**



GUN SERIAL # G 6807669

| OP #            | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------|---------------------|---------|---------|
| 420             | ASSEMBLE ACTION                                                |                     | 1-20-09 | SP      |
| 430             | ASSEMBLE TO STOCK                                              |                     | 1-20-09 | SP      |
| 440             | PROOF                                                          |                     | 1-20-09 | SP      |
| 460             | CHECK HEADSPACE                                                |                     | 1-20-09 | SP      |
| 470             | DIS-ASSEMBLE ACTION                                            |                     | 1-20-09 | SP      |
| 472             | SERIALIZE BOLT HANDLE                                          |                     | 1-21-09 | SP      |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 1-21-09 | SP      |
| 480             | MAGNAFLUX BBL ACTION                                           | (R)                 | 1/24/09 | (R)     |
| 490             | MAGNAFLUX BOLT                                                 |                     | 1/24/09 | RT      |
| 500             | ROLLMARK CALIBER                                               |                     | 1/24/09 | RT      |
| 520             | GOFF BLAST BBL / REC                                           |                     | 1/24/09 | DS      |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 2-3     | —       |
| 545             | (BOLT)                                                         |                     |         |         |
| 560             | RE-ASSEMBLE ACTION                                             |                     |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 2-3-09  | SP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 2-3-09  | SP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 2-3-09  | SP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                     |                     | 2-4-09  | SP      |
|                 | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |
| F004 REV 5/2006 |                                                                |                     |         |         |

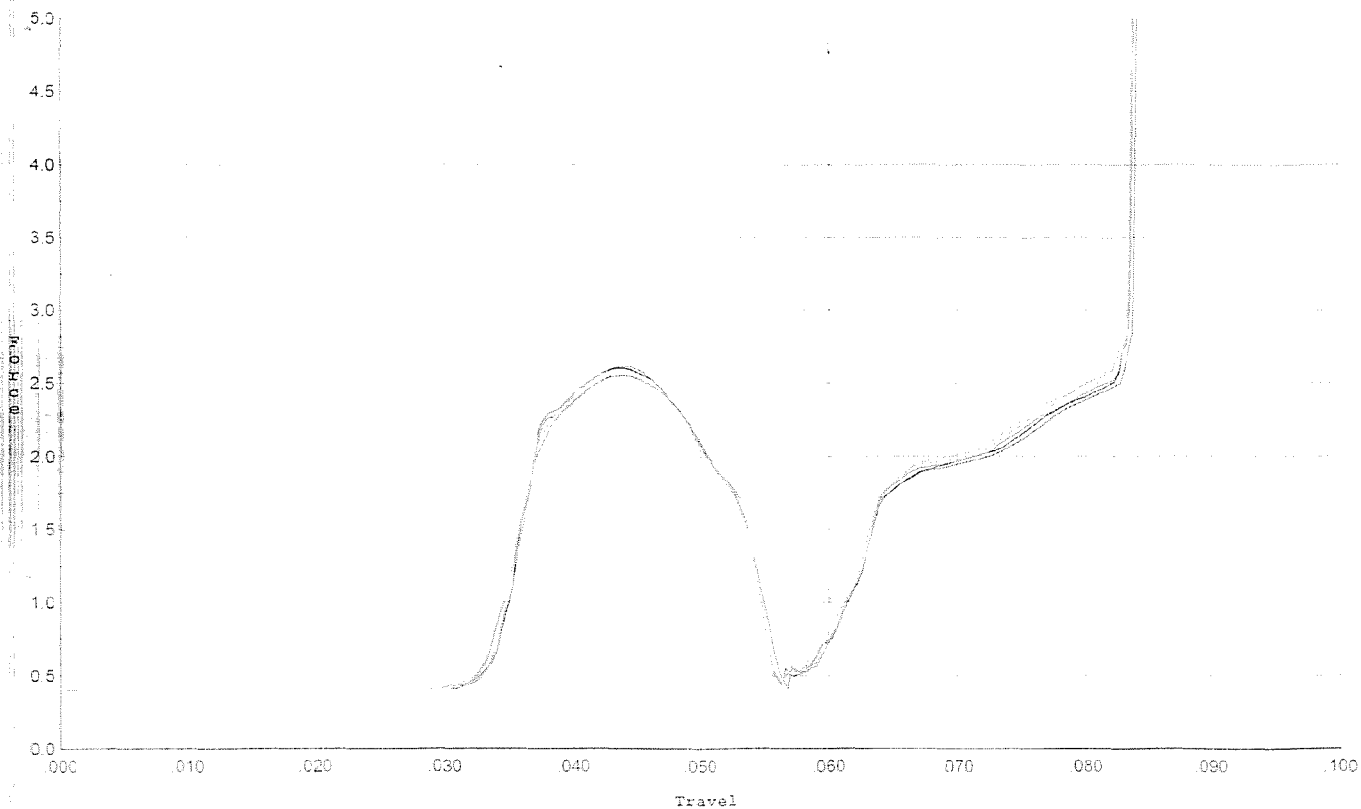
| OP #         | OPERATION NAME                                                                   | READINGS                                                    | DATE    | INITIAL |
|--------------|----------------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | BARBER - M24 0016135<br>F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span> | <u>40</u> <u>40</u> <u>40</u>                               | 2-10-09 | RN      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                                       | <u>50</u> <u>50</u> <u>50</u>                               | 2-10-09 | RN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                        |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                                       | <u>.023</u> <u>.024</u> <u>.025</u>                         | 2-10-09 | RN      |
|              | J) ASSEMBLE STOCK                                                                |                                                             | 2-4-09  | RN      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                                      |                                                             | 2-10-09 | 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<br><u>PASS</u> FAIL                        | 2-5-09  | TC      |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                            |                                                             | 2-5-09  | WN      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                                 |                                                             | 2-10-09 | RN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span>         | <u>2.14</u> <u>2.15</u> <u>2.19</u> <u>2.15</u> <u>2.15</u> | 2-6-09  | WN      |
|              | C) FUNCTION                                                                      |                                                             | 2-10-09 | RN      |
| 690          | PACK                                                                             |                                                             | 3/12/09 | FM      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

Model: M24  
Serial No: Form #F005  
Trigger: 2.5 lbs. ini. +/- .50 lbs.



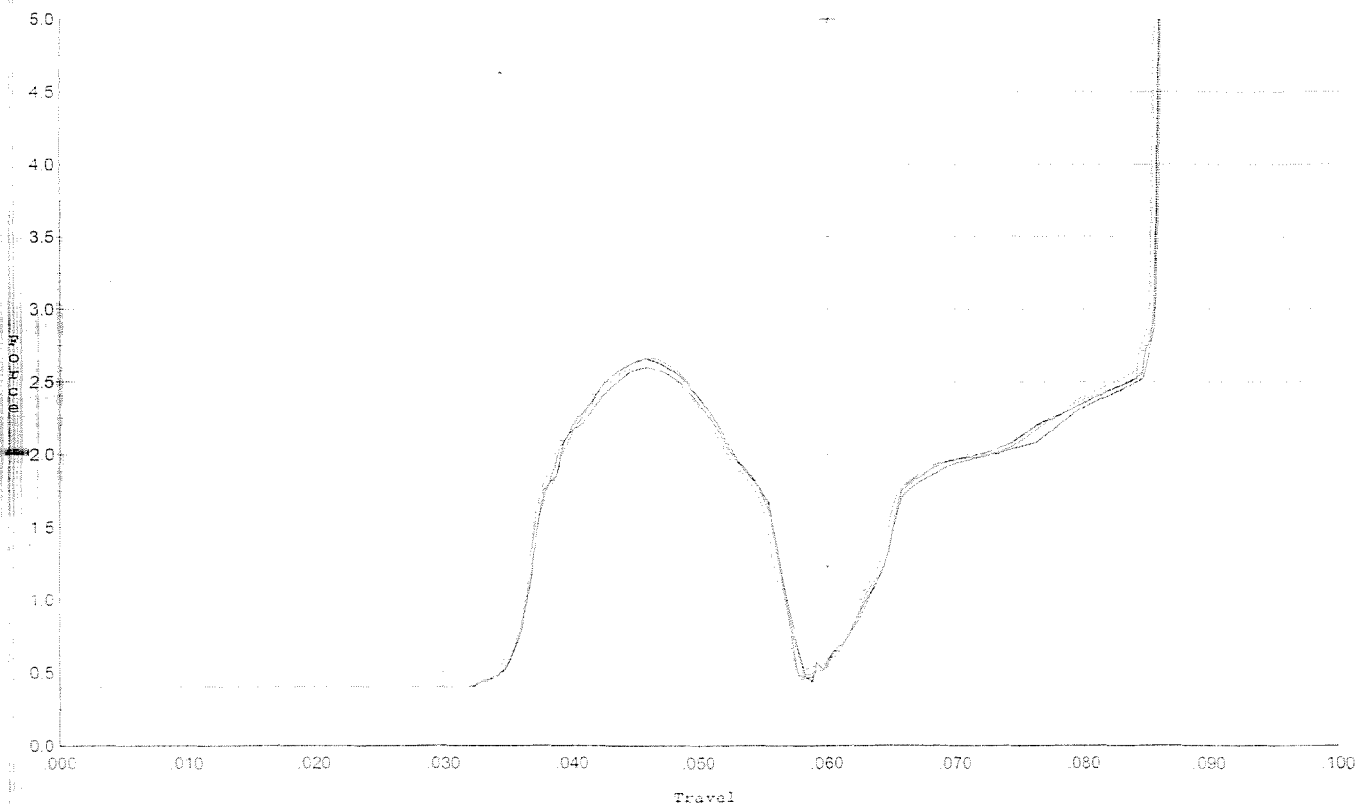
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.556      | 0.053             | 0.033           | 0.036      | 0.055             |           | Set Trigger |
| 2 | 2.605      | 0.054             | 0.034           | 0.035      | 0.056             |           | Set Trigger |
| 3 | 2.617      | 0.054             | 0.033           | 0.035      | 0.056             |           | Set Trigger |
| 4 | 2.636      | 0.053             | 0.034           | 0.035      | 0.056             |           | Set Trigger |
| 5 | 2.542      | 0.054             | 0.033           | 0.035      | 0.056             |           | Set Trigger |

Aug 2.59

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

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



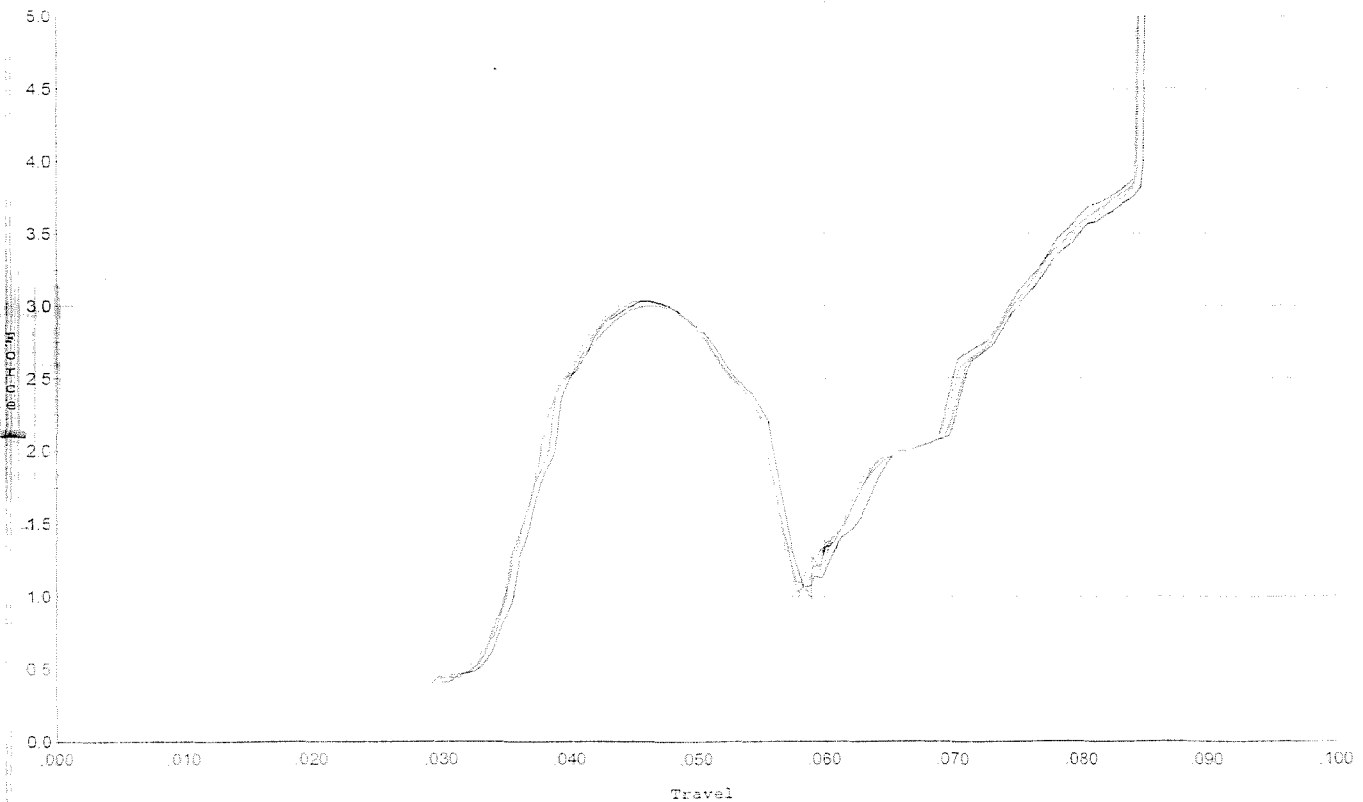
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.597      | 0.056             | 0.035           | 0.036      | 0.057             |           | Set Trigger |
| 2 | 2.653      | 0.055             | 0.035           | 0.036      | 0.058             |           | Set Trigger |
| 3 | 2.669      | 0.056             | 0.035           | 0.036      | 0.058             |           | Set Trigger |
| 4 | 2.609      | 0.055             | 0.035           | 0.036      | 0.057             |           |             |
| 5 | 2.653      | 0.055             | 0.035           | 0.036      | 0.057             |           |             |

AVG 2.63

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

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



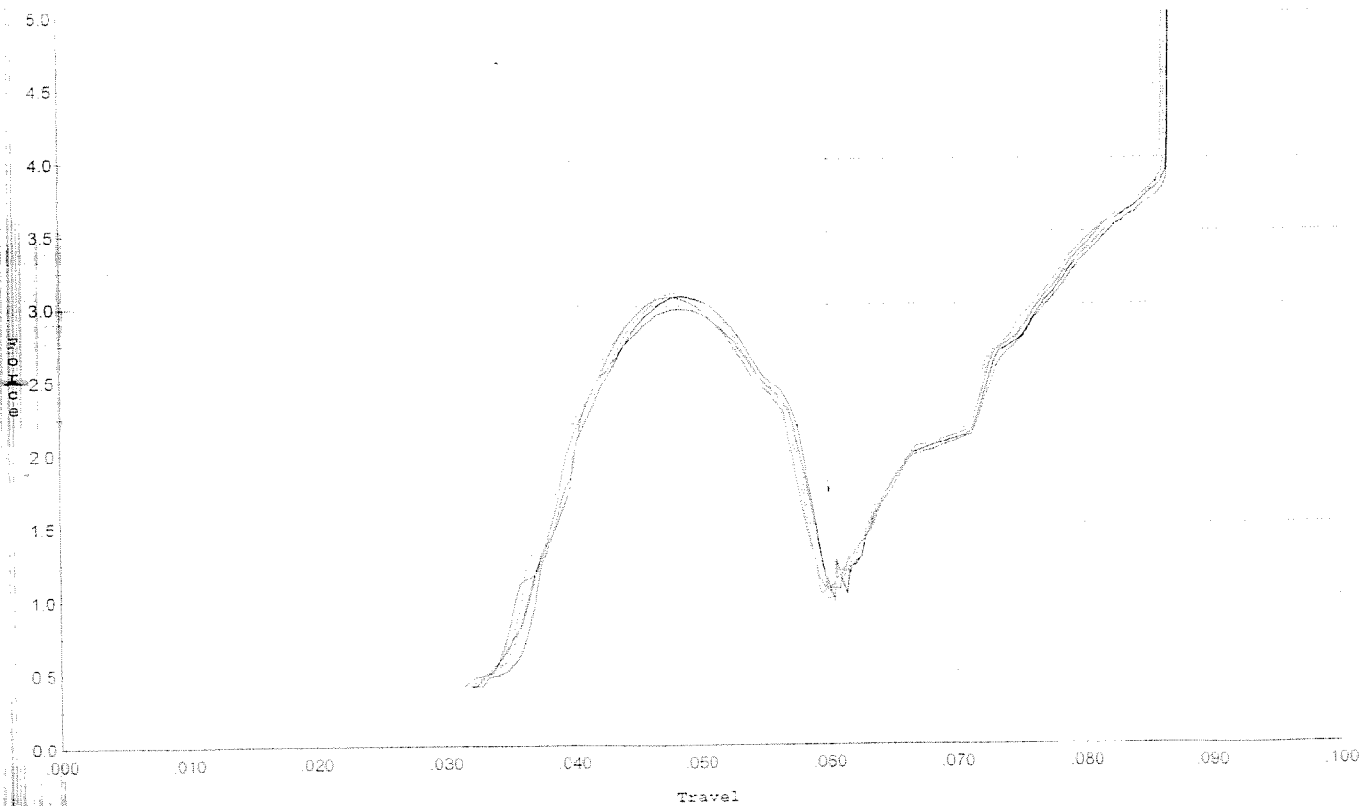
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.040      | 0.055             | 0.034           | 0.034      | 0.067             |           | Set Trigger |
| 2 | 3.033      | 0.056             | 0.034           | 0.034      | 0.067             |           | Set Trigger |
| 3 | 3.004      | 0.055             | 0.033           | 0.034      | 0.066             |           | Set Trigger |
| 4 | 3.049      | 0.055             | 0.033           | 0.034      | 0.067             |           |             |
| 5 | 3.059      | 0.055             | 0.033           | 0.034      | 0.067             |           |             |

Aug 303

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 1/16/09

Model: M24  
 Serial No: Form #F005  
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



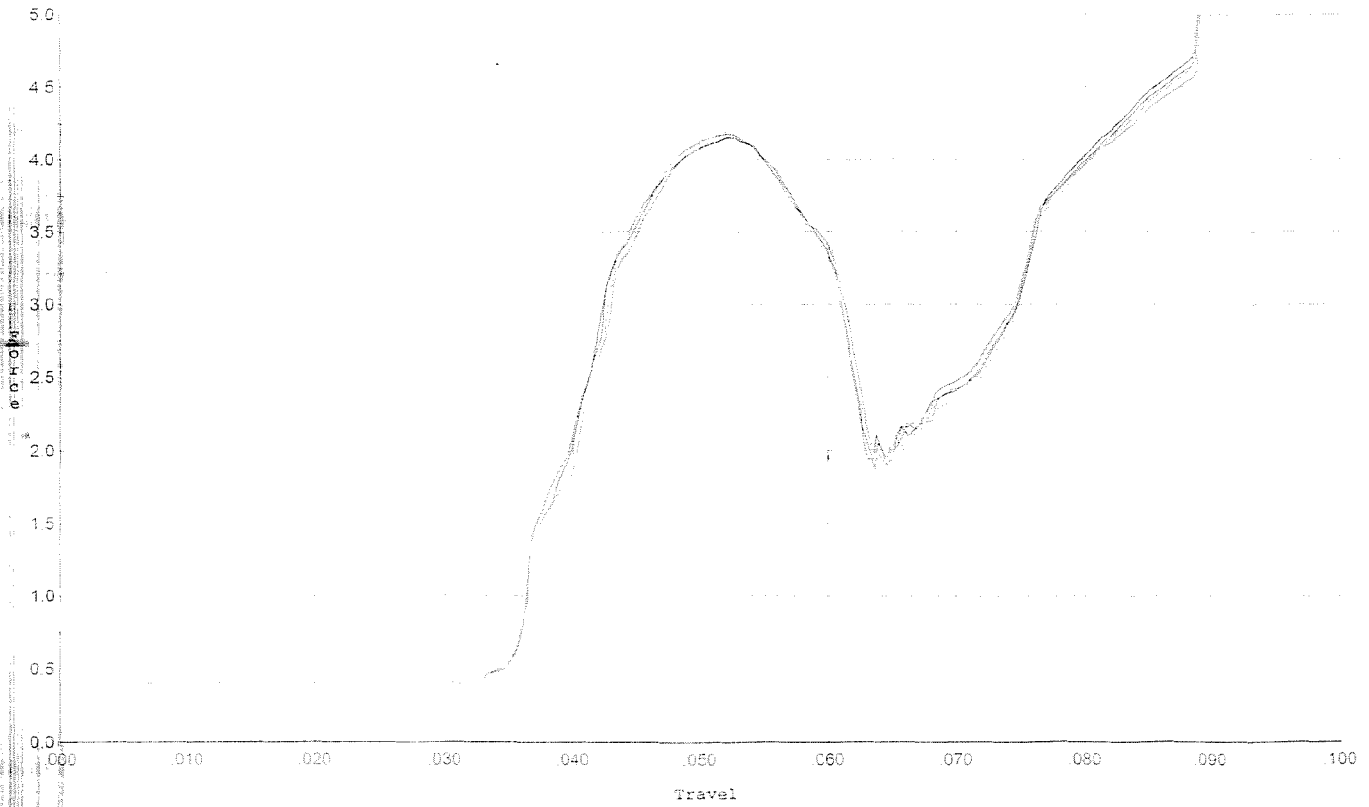
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.979      | 0.058             | 0.033           | 0.035      | 0.068             |           | Set Trigger |
| 2 | 3.064      | 0.058             | 0.034           | 0.035      | 0.069             |           | Set Trigger |
| 3 | 3.061      | 0.057             | 0.034           | 0.035      | 0.067             |           | Set Trigger |
| 4 | 3.082      | 0.057             | 0.035           | 0.035      | 0.068             |           |             |
| 5 | 3.092      | 0.057             | 0.035           | 0.035      | 0.070             |           | Set Trigger |

Aug 3.05

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

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



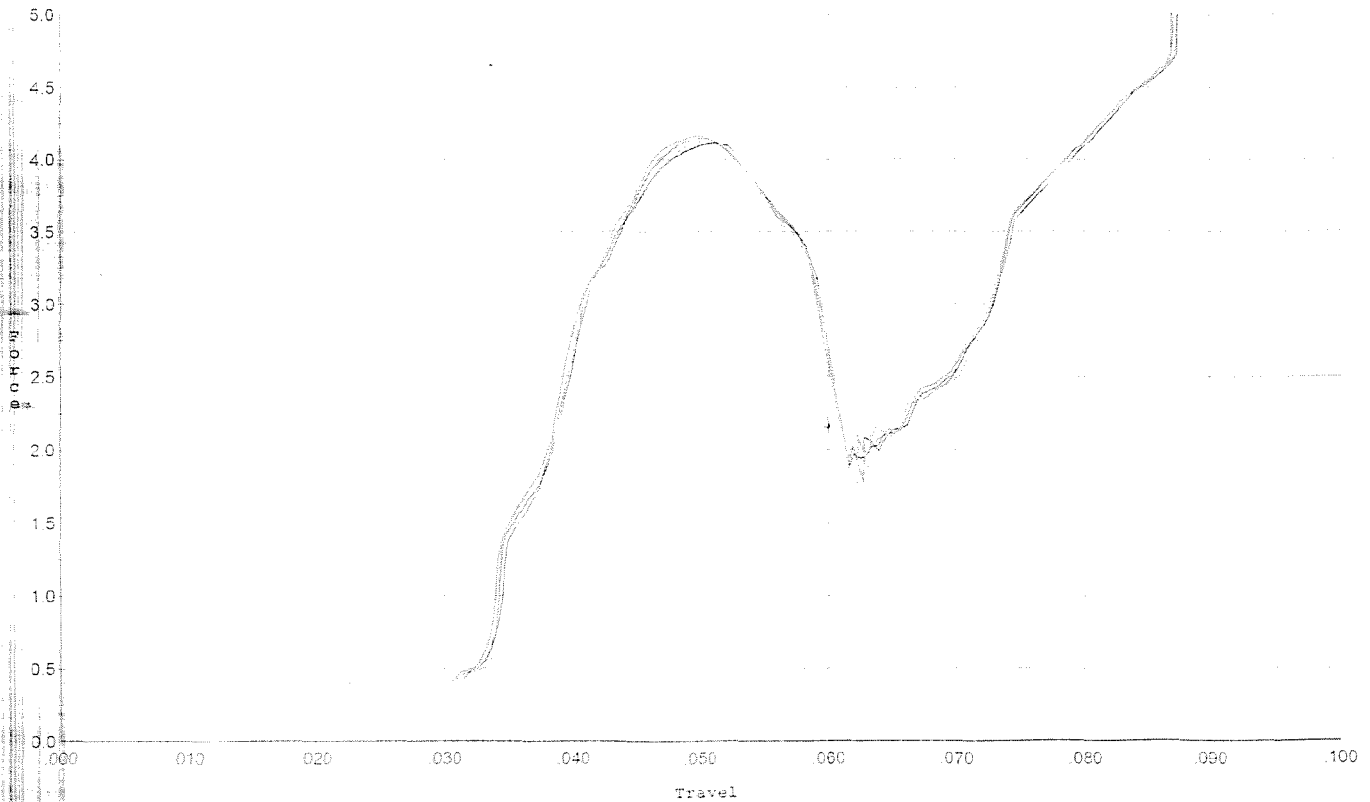
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.176      | 0.060             | 0.033           | 0.032      | 0.097             |           | Set Trigger |
| 2 | 4.156      | 0.061             | 0.036           | 0.032      | 0.097             |           | Set Trigger |
| 3 | 4.150      | 0.062             | 0.036           | 0.032      | 0.098             |           | Set Trigger |
| 4 | 4.201      | 0.060             | 0.036           | 0.032      | 0.096             |           |             |
| 5 | 4.193      | 0.061             | 0.036           | 0.032      | 0.097             |           |             |

Aug 417

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 1/16/09

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



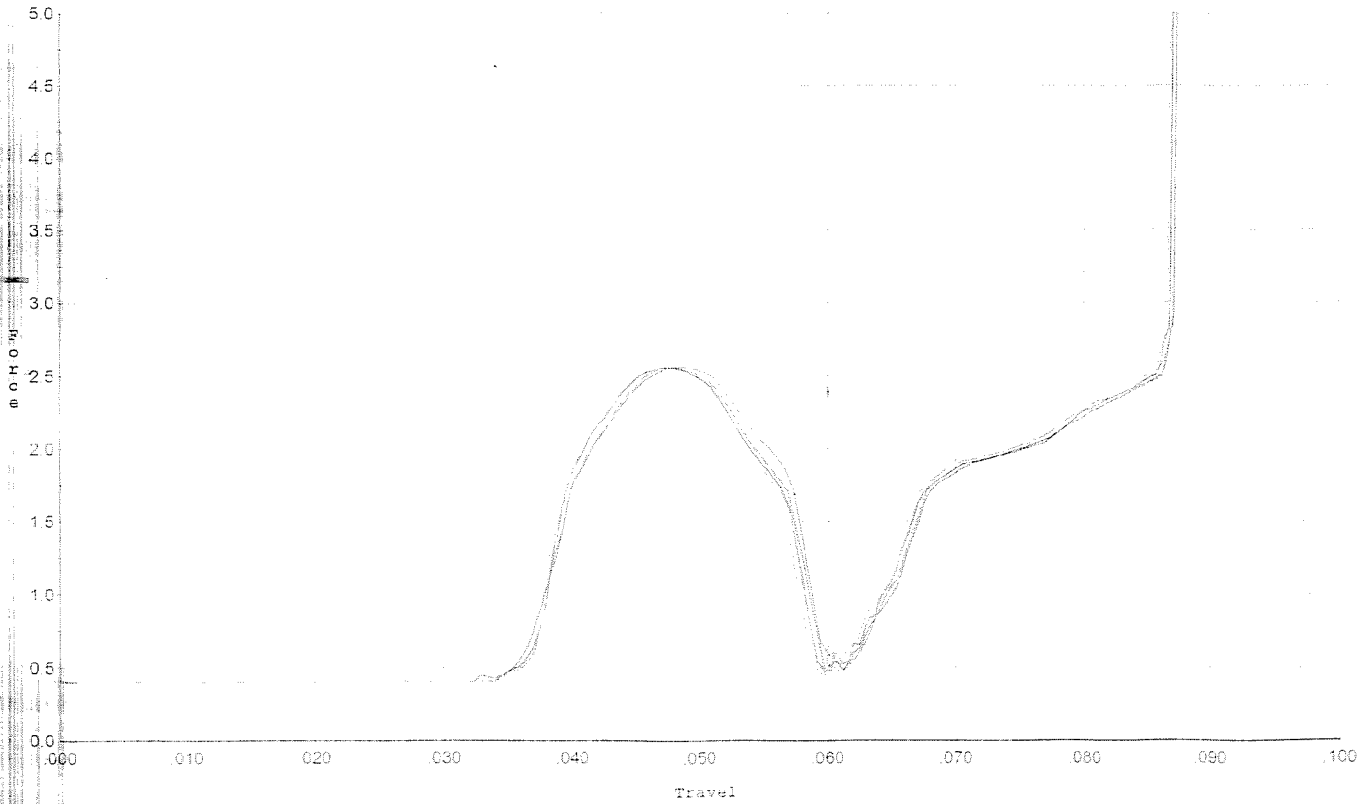
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.148      | 0.060             | 0.034           | 0.032      | 0.097             |           | Set Trigger |
| 2 | 4.114      | 0.059             | 0.032           | 0.032      | 0.096             |           | Set Trigger |
| 3 | 4.160      | 0.058             | 0.033           | 0.032      | 0.096             |           | Set Trigger |
| 4 | 4.137      | 0.059             | 0.034           | 0.032      | 0.096             |           | Set Trigger |
| 5 | 4.152      | 0.058             | 0.034           | 0.032      | 0.095             |           | Set Trigger |

Aug 4.14

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

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



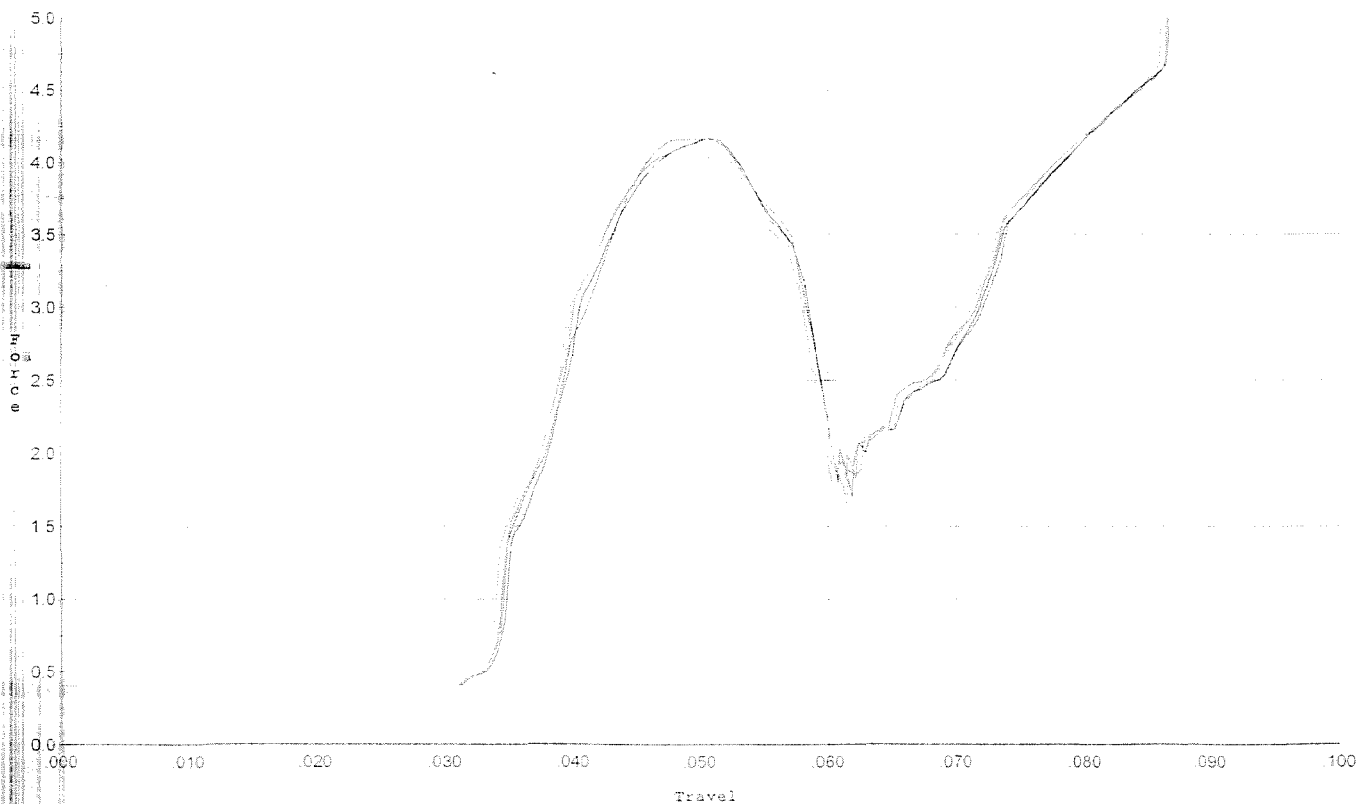
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.561      | 0.057             | 0.036           | 0.036      | 0.059             |           | Set Trigger |
| 2 | 2.558      | 0.057             | 0.037           | 0.036      | 0.057             |           | Set Trigger |
| 3 | 2.558      | 0.058             | 0.037           | 0.036      | 0.058             |           | Set Trigger |
| 4 | 2.550      | 0.057             | 0.037           | 0.037      | 0.056             |           |             |
| 5 | 2.631      | 0.057             | 0.037           | 0.037      | 0.058             |           |             |

Avg 2.57

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 1/16/09

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 | 4.164      | 0.059             | 0.034           | 0.032      | 0.095             |           | Set Trigger |
| 2 | 4.162      | 0.058             | 0.034           | 0.032      | 0.094             |           | Set Trigger |
| 3 | 4.168      | 0.059             | 0.034           | 0.032      | 0.096             |           | Set Trigger |
| 4 | 4.126      | 0.057             | 0.034           | 0.033      | 0.092             |           | Set Trigger |
| 5 | 4.041      | 0.058             | 0.033           | 0.032      | 0.093             |           | Set Trigger |

Aug 4.13