

G680 7805

**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



BM FORM

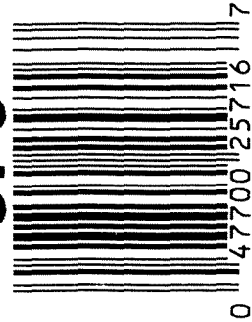
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

**G6807805**

**UPC**



GUN SERIAL # G6807805

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 2-27-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 2-27-09 | RP      |
| 440  | PROOF                                                          |                     | 2-27-09 | SPD     |
| 460  | CHECK HEADSPACE                                                |                     | 2-27-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 2-27-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 3-2-09  | RL      |
| 480  | MAGNAFLUX BBL ACTION                                           | (H)                 | 3/5/09  | (H)     |
| 490  | MAGNAFLUX BOLT                                                 |                     | 3/5/09  | mk      |
| 500  | ROLLMARK CALIBER                                               |                     | 3/5/09  | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 3-2-09  | SP      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 3/6     | mm      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 3/9     | —       |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 3-10-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 3-10-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 3-10-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 3-12-09 | SPD     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

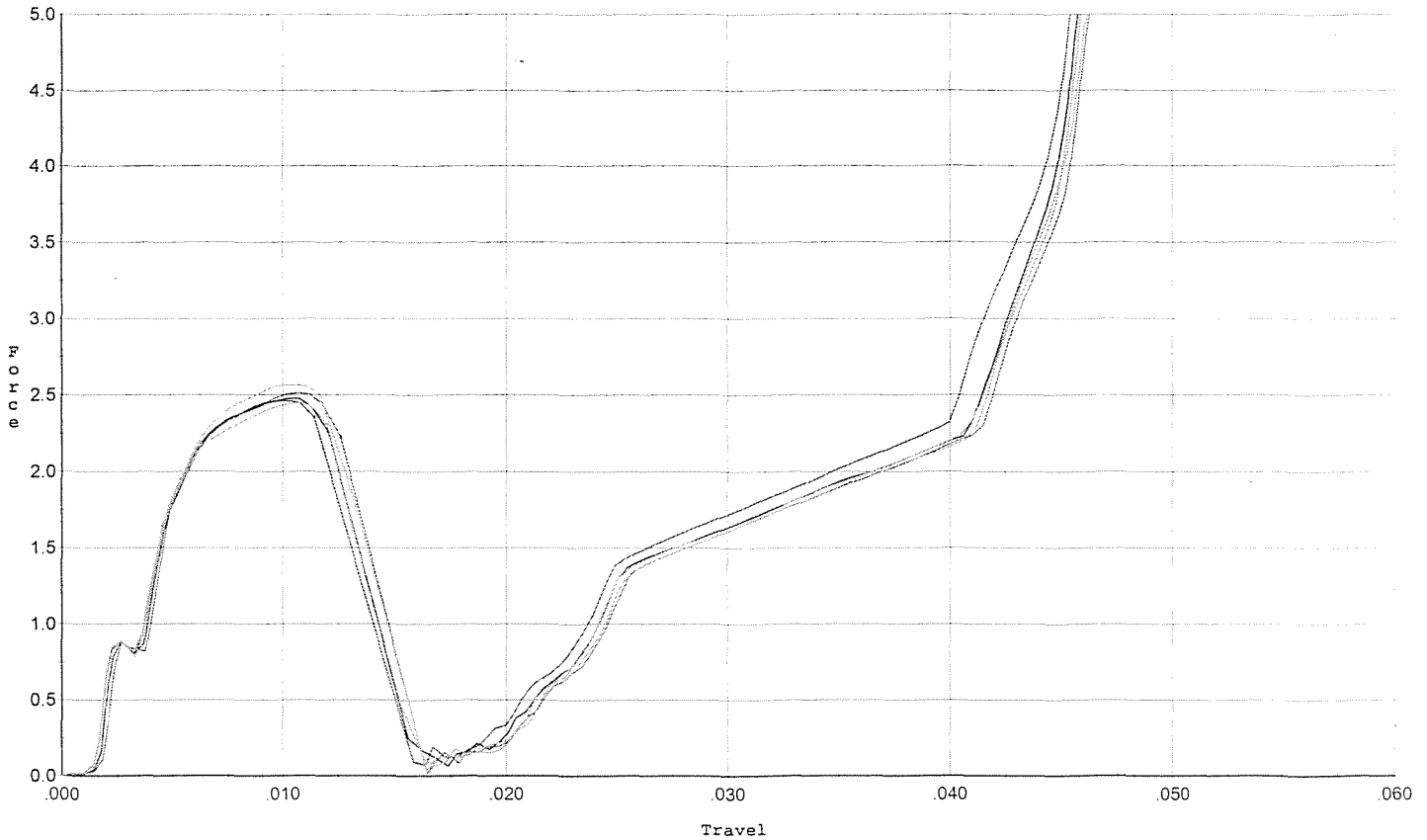
F004 REV 5/2006

|                      |                                                                       |                                           |             |             |             |             |             |         |    |
|----------------------|-----------------------------------------------------------------------|-------------------------------------------|-------------|-------------|-------------|-------------|-------------|---------|----|
| BARBER - M24 0017808 |                                                                       | 2 LBS MIN<br>10 LBS MAX                   | <u>4</u>    | <u>5.5</u>  | <u>4</u>    | 3-20-09     | WW          |         |    |
| 560                  | F) SAFETY ON FORCE                                                    |                                           |             |             |             |             |             |         |    |
| CONT.                |                                                                       |                                           |             |             |             |             |             |         |    |
|                      | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>3</u>    | <u>3</u>    | <u>3</u>    | 3-20-09     | WW          |         |    |
|                      | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |             |             |             |             |             |         |    |
|                      | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> | <u>.023</u> | <u>.023</u> | 3-20-09     | WW          |         |    |
|                      | J) ASSEMBLE STOCK                                                     |                                           |             |             |             | 3-12-09     | RPD         |         |    |
|                      | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |             |             |             | 3-20-09     | WW          |         |    |
|                      | 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        |             | 3-19-09     | RPD         |         |    |
|                      |                                                                       |                                           | <u>PASS</u> | FAIL        |             |             |             |         |    |
|                      | MALFUNCTION                                                           | CORRECTION                                |             |             |             |             |             |         |    |
|                      | MALFUNCTION                                                           | CORRECTION                                |             |             | N/A         |             |             |         |    |
|                      | MALFUNCTION                                                           | CORRECTION                                |             |             |             |             |             |         |    |
|                      | MALFUNCTION                                                           | CORRECTION                                |             |             |             |             |             |         |    |
| 660                  | INSPECT FOR LIVE AMMO                                                 |                                           |             |             |             | 3-19-09     | RP          |         |    |
| 670                  | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |             |             |             | 3-20-09     | WW          |         |    |
|                      | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.37</u> | <u>2.35</u> | <u>2.29</u> | <u>2.33</u> | <u>2.26</u> | 3-20-09 | TK |
|                      | C) FUNCTION                                                           |                                           |             |             |             | 3-20-09     | WW          |         |    |
| 690                  | PACK                                                                  |                                           |             |             |             | 3-20-09     | TK          |         |    |

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/11/2009

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



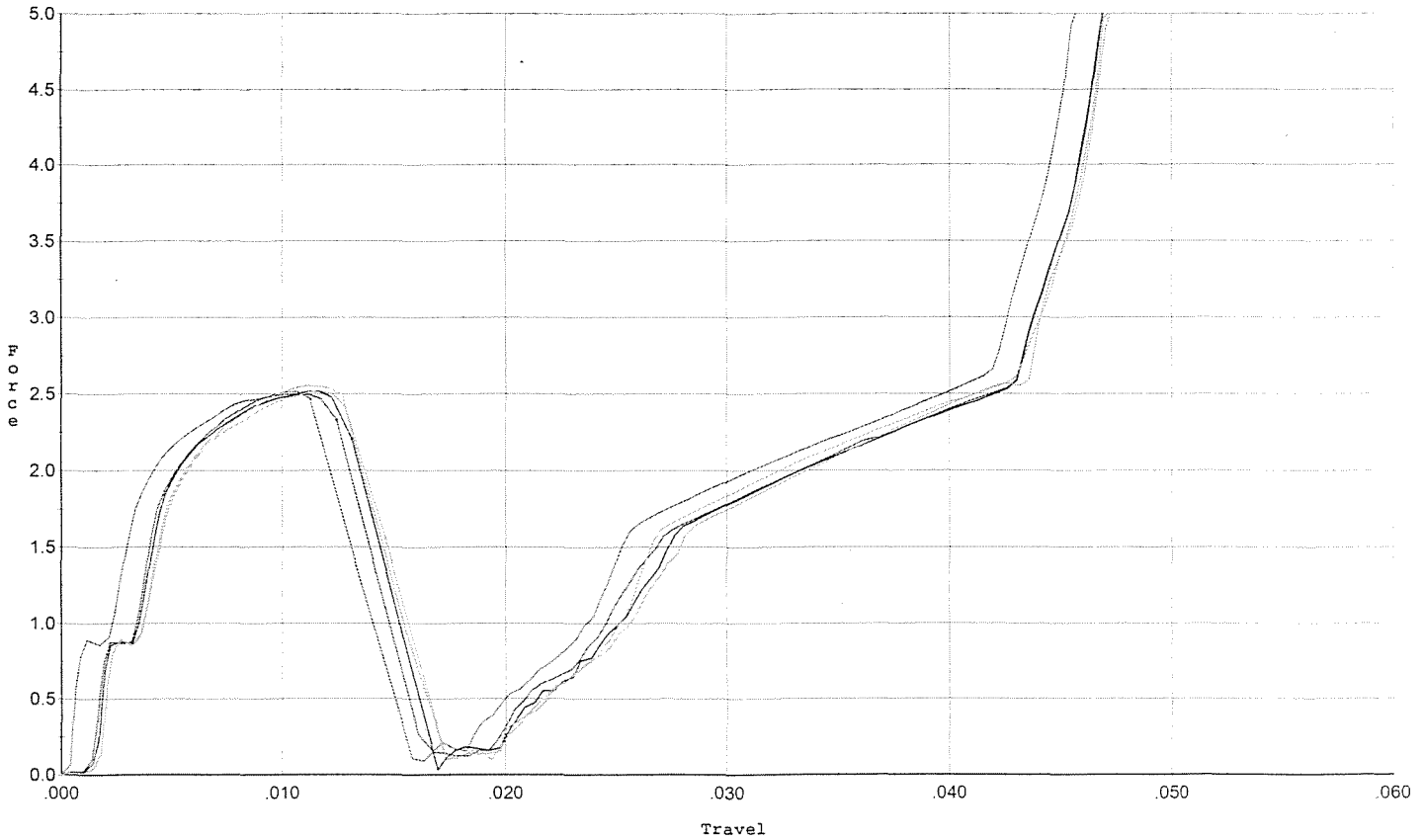
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.462      | 0.011             | 0.00            | 0.037      | 0.018             |           | Set Trigger |
| 2 | 2.477      | 0.012             | 0.00            | 0.037      | 0.019             |           | Set Trigger |
| 3 | 2.512      | 0.013             | 0.004           | 0.037      | 0.020             |           | Set Trigger |
| 4 | 2.453      | 0.012             | 0.00            | 0.037      | 0.019             |           | Set Trigger |
| 5 | 2.565      | 0.013             | 0.00            | 0.037      | 0.022             |           | Set Trigger |

A-2-49

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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 | 2.496      | 0.012             | 0.00            | 0.038      | 0.021             |           | Set Trigger |
| 2 | 2.518      | 0.013             | 0.00            | 0.037      | 0.022             |           | Set Trigger |
| 3 | 2.514      | 0.011             | 0.00            | 0.037      | 0.020             |           | Set Trigger |
| 4 | 2.522      | 0.013             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 5 | 2.554      | 0.015             | 0.00            | 0.037      | 0.024             |           | Set Trigger |

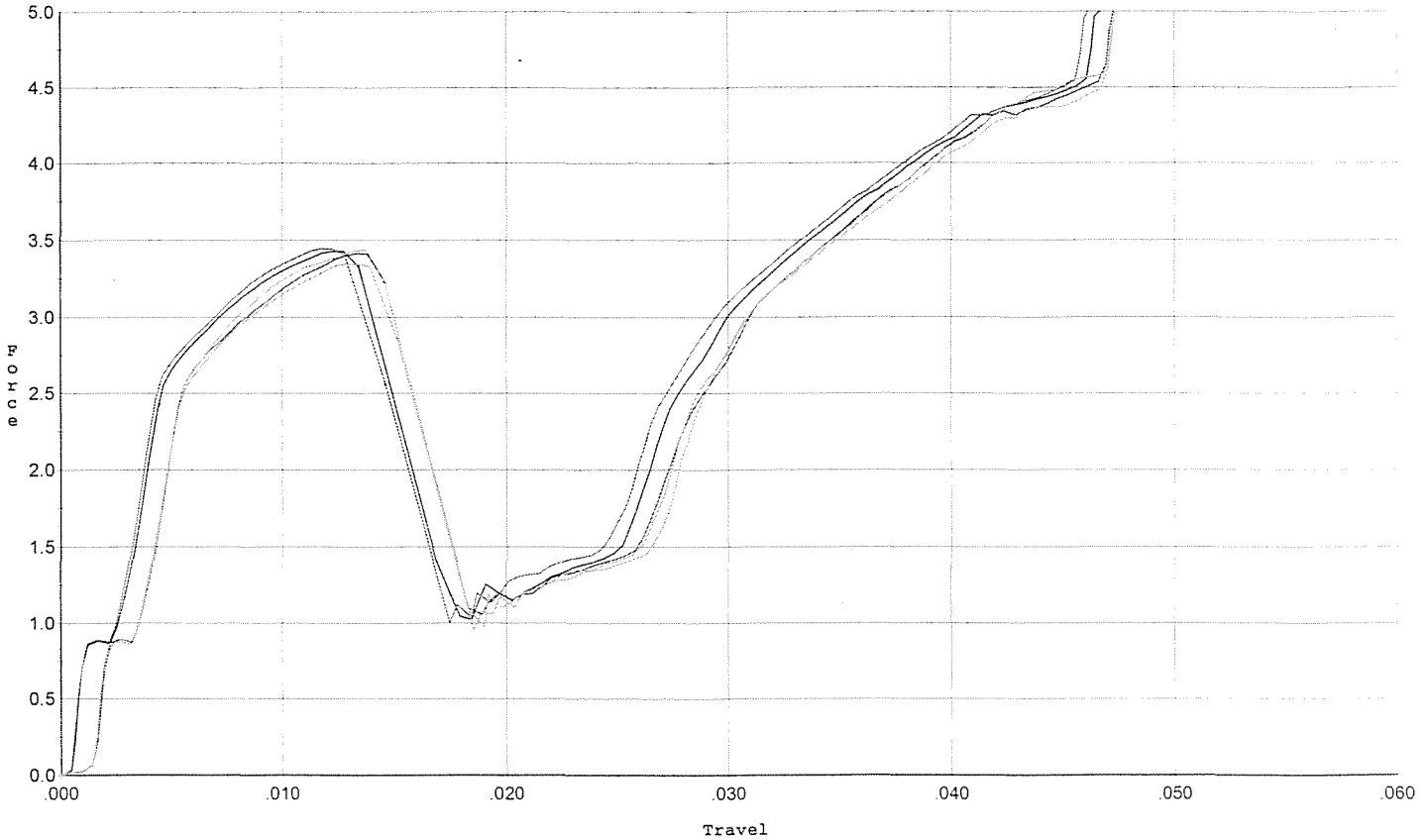
A-2.52

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

Model: M/24  
 Serial No: Form #F005  
 Trigger: 3.0 lbs ini

+/- .175 lb.  
 cm5



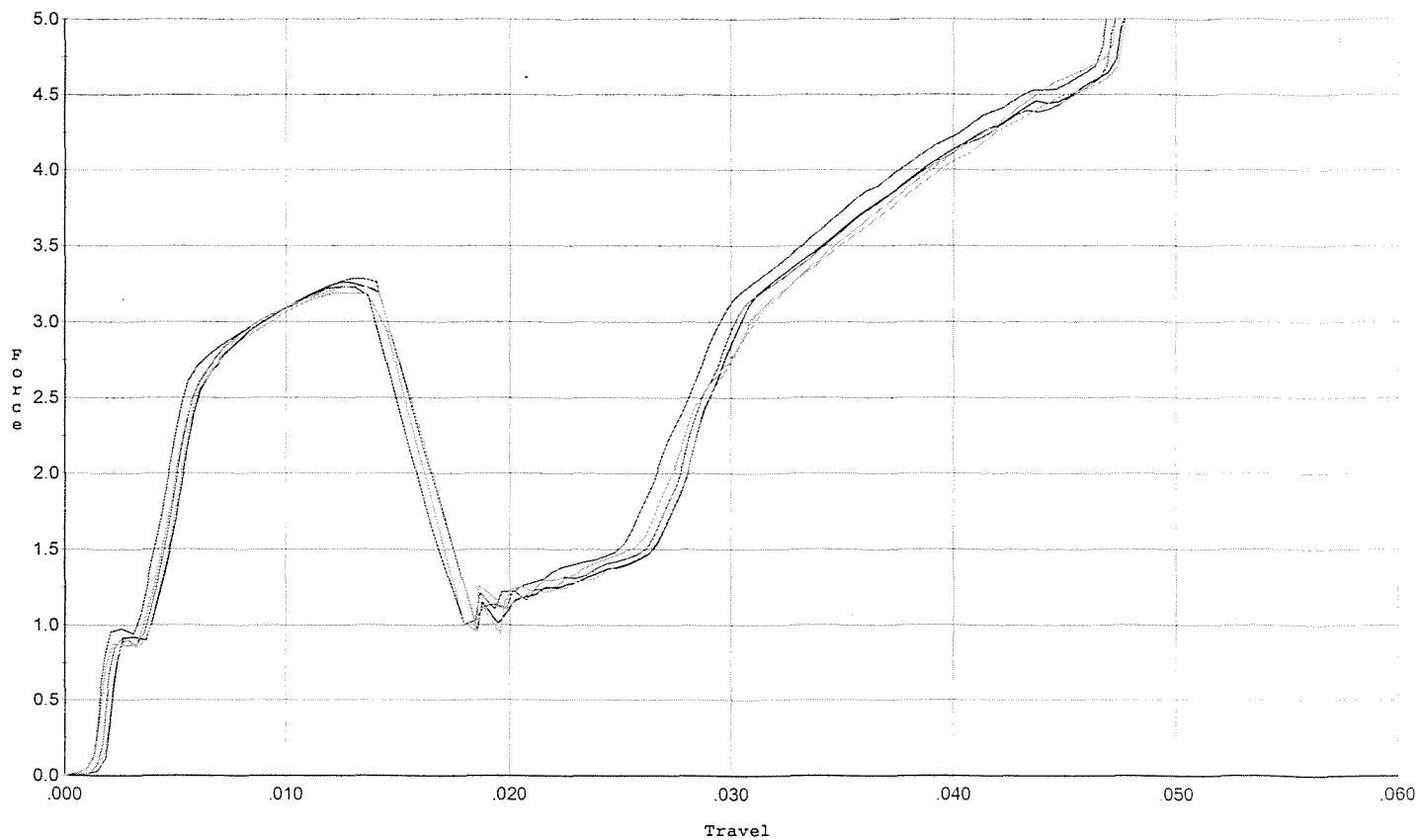
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.414      | 0.015             | 0.00            | 0.033      | 0.032             |           | Set Trigger |
| 2 | 3.430      | 0.013             | 0.00            | 0.033      | 0.031             |           | Set Trigger |
| 3 | 3.446      | 0.015             | 0.00            | 0.033      | 0.033             |           | Set Trigger |
| 4 | 3.436      | 0.015             | 0.00            | 0.033      | 0.032             |           | Set Trigger |
| 5 | 3.346      | 0.015             | 0.003           | 0.033      | 0.032             |           | Set Trigger |

A-3.41

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



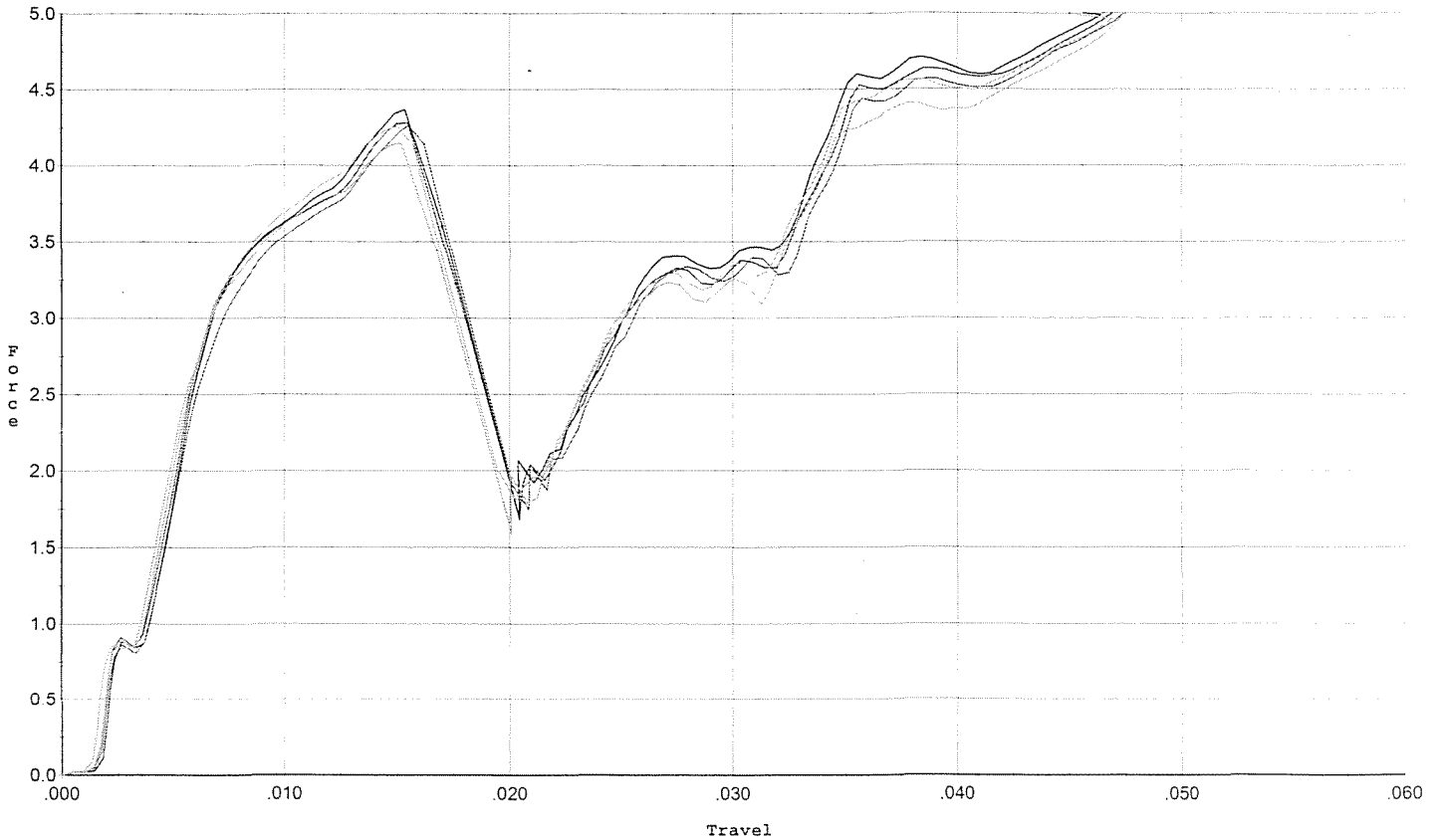
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.231      | 0.014             | 0.00            | 0.033      | 0.029             |           | Set Trigger |
| 2 | 3.263      | 0.016             | 0.004           | 0.033      | 0.033             |           | Set Trigger |
| 3 | 3.286      | 0.014             | 0.00            | 0.033      | 0.029             |           | Set Trigger |
| 4 | 3.236      | 0.016             | 0.00            | 0.033      | 0.033             |           | Set Trigger |
| 5 | 3.191      | 0.015             | 0.003           | 0.033      | 0.030             |           | Set Trigger |

A-3.24

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/11/2009

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



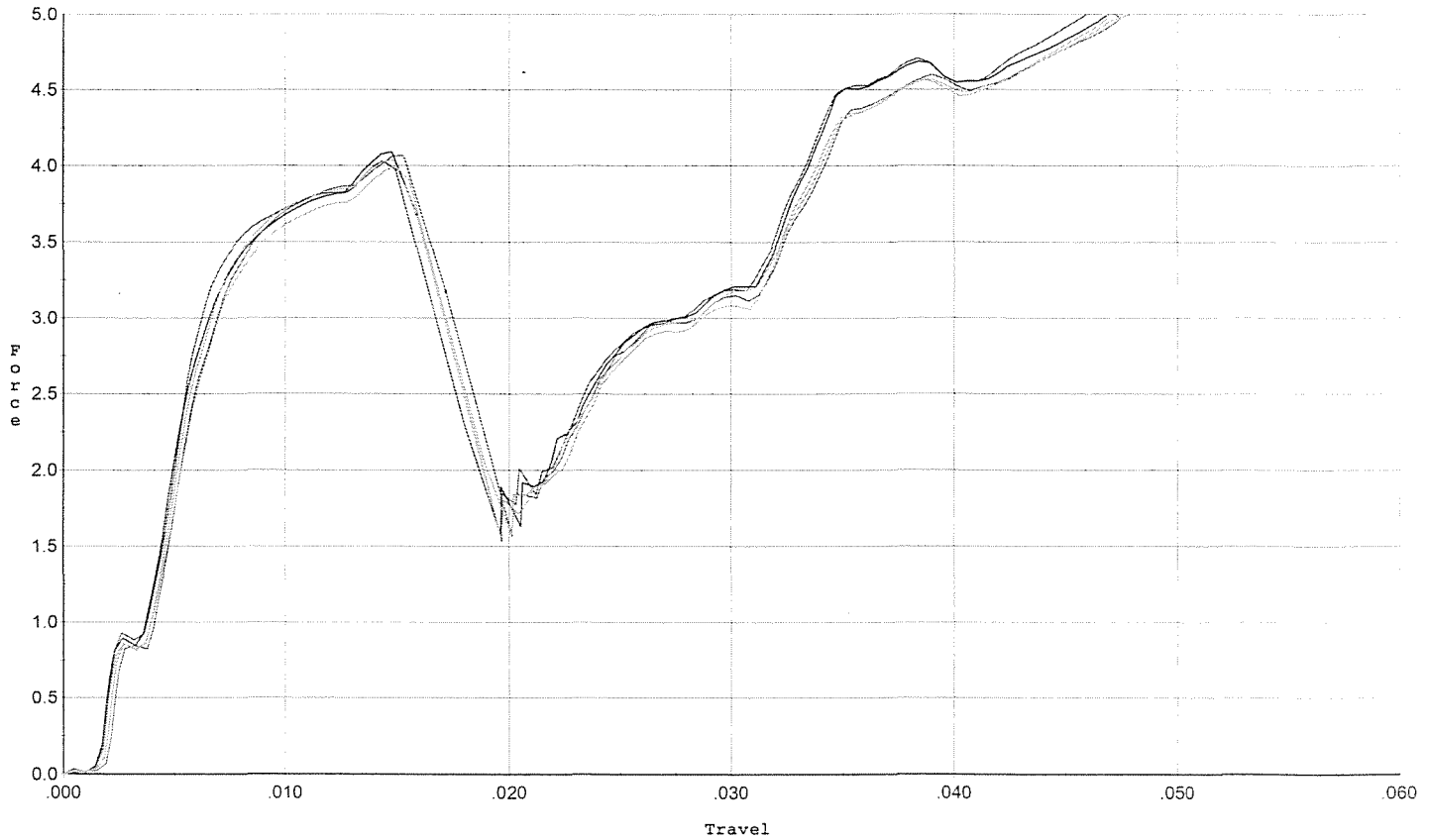
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.281      | 0.018             | 0.00            | 0.030      | 0.045             |           | Set Trigger |
| 2 | 4.368      | 0.017             | 0.00            | 0.031      | 0.043             |           | Set Trigger |
| 3 | 4.268      | 0.016             | 0.00            | 0.031      | 0.040             |           | Set Trigger |
| 4 | 4.258      | 0.016             | 0.00            | 0.031      | 0.040             |           | Set Trigger |
| 5 | 4.144      | 0.017             | 0.00            | 0.031      | 0.042             |           | Set Trigger |

A-4.24

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/11/2009

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



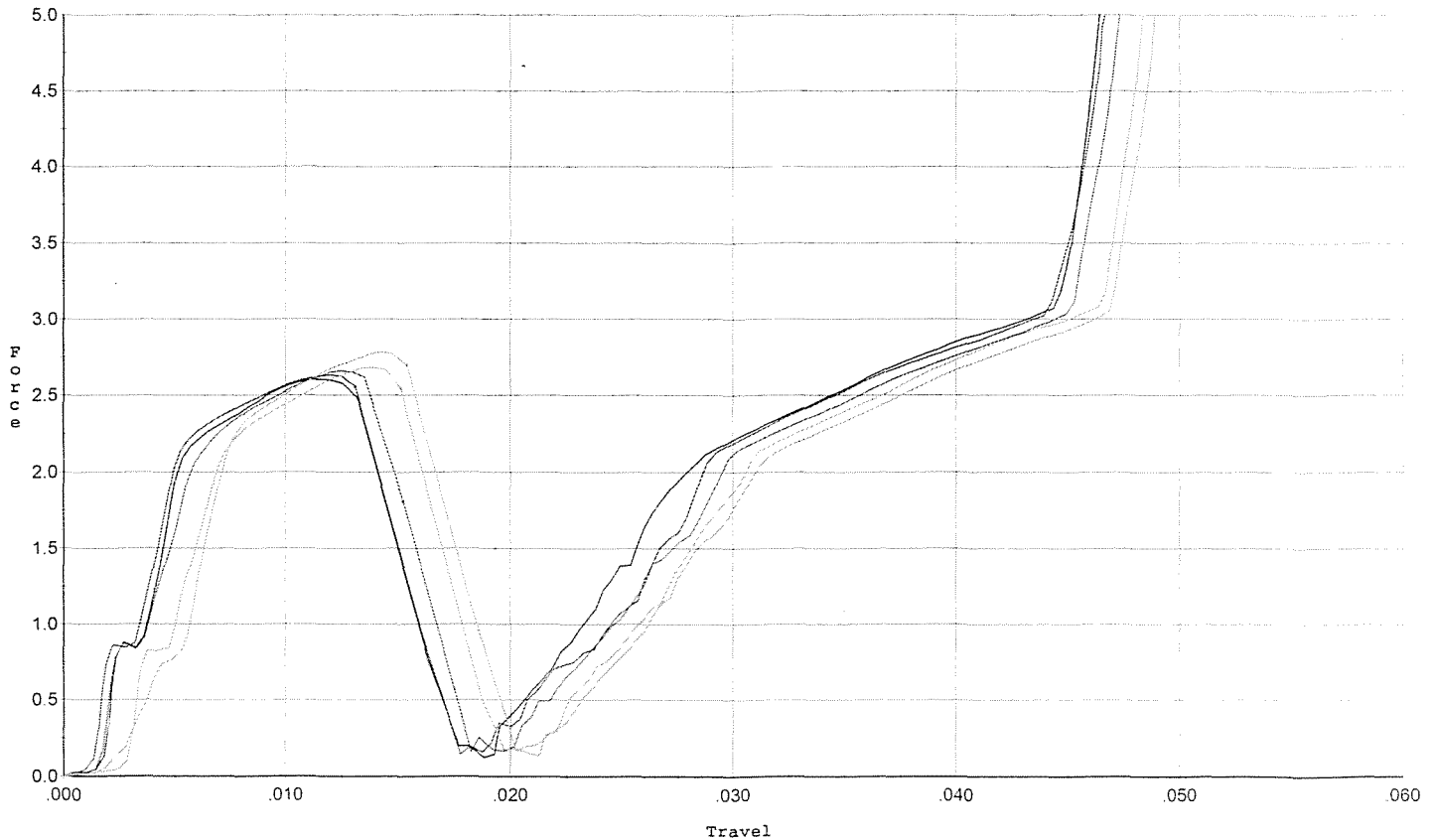
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.032      | 0.015             | 0.00            | 0.031      | 0.037             |           | Set Trigger |
| 2 | 4.089      | 0.016             | 0.00            | 0.031      | 0.040             |           | Set Trigger |
| 3 | 4.066      | 0.017             | 0.00            | 0.032      | 0.042             |           | Set Trigger |
| 4 | 4.034      | 0.016             | 0.00            | 0.031      | 0.039             |           | Set Trigger |
| 5 | 3.997      | 0.016             | 0.00            | 0.032      | 0.038             |           | Set Trigger |

A-4.04

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/11/2009

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



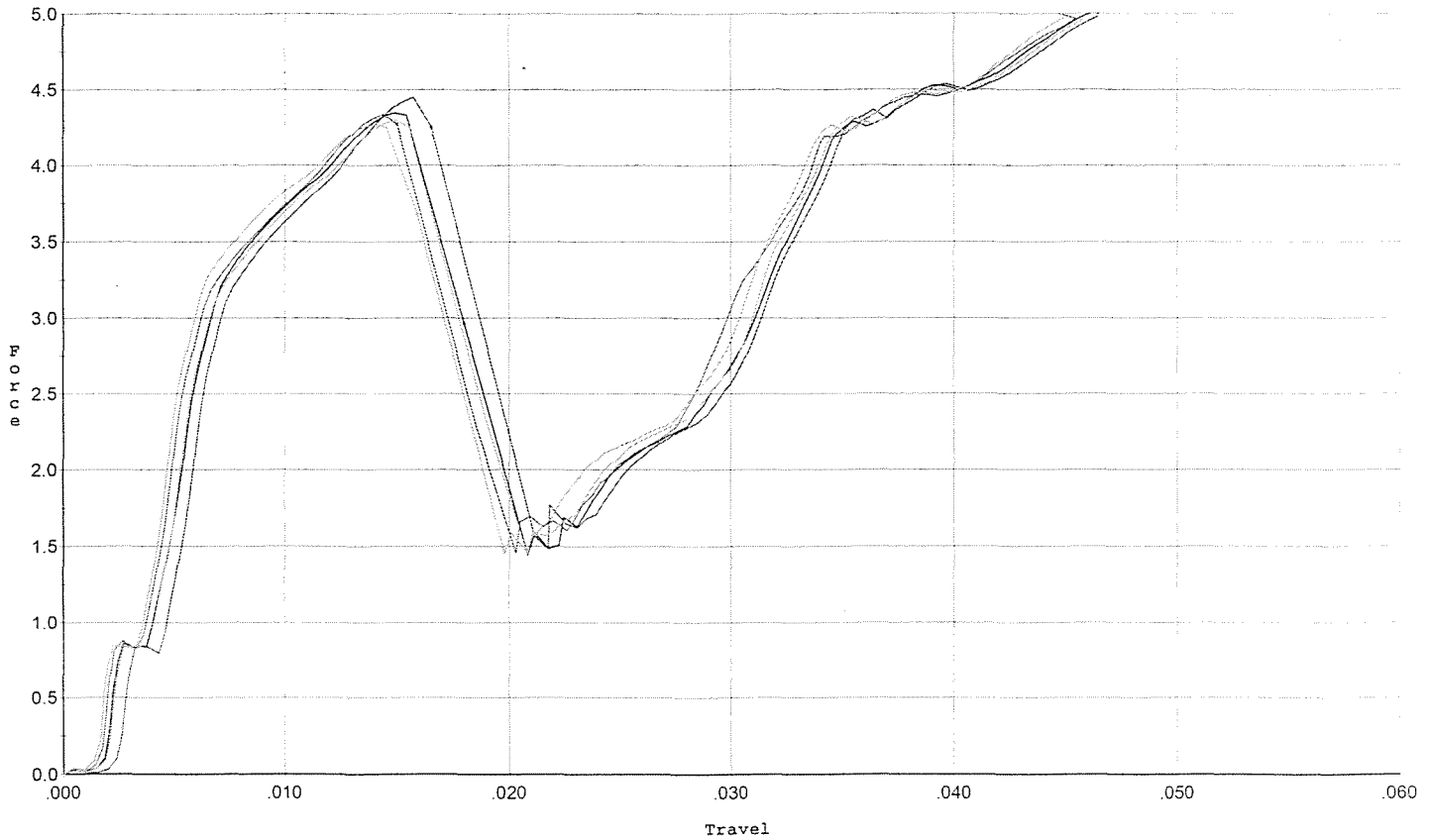
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.631      | 0.013             | 0.00            | 0.036      | 0.023             |           | Set Trigger |
| 2 | 2.604      | 0.013             | 0.00            | 0.036      | 0.022             |           | Set Trigger |
| 3 | 2.658      | 0.015             | 0.00            | 0.035      | 0.026             |           | Set Trigger |
| 4 | 2.682      | 0.015             | 0.00            | 0.036      | 0.024             |           | Set Trigger |
| 5 | 2.785      | 0.015             | 0.002           | 0.036      | 0.025             |           | Set Trigger |

A-2-67

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schultz 3/11/2009

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 | 4.450      | 0.017             | 0.002           | 0.031      | 0.042             |           | Set Trigger |
| 2 | 4.347      | 0.018             | 0.004           | 0.031      | 0.046             |           | Set Trigger |
| 3 | 4.337      | 0.015             | 0.00            | 0.031      | 0.038             |           | Set Trigger |
| 4 | 4.304      | 0.016             | 0.004           | 0.031      | 0.039             |           | Set Trigger |
| 5 | 4.272      | 0.016             | 0.004           | 0.031      | 0.041             |           | Set Trigge  |

A-4.34