

G6845319

**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**

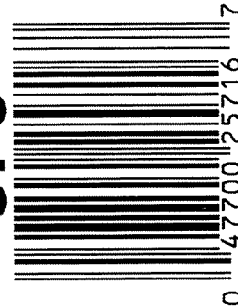
ORDER NO. **25716**

BARREL LENGTH **24"**

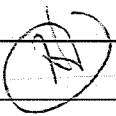
CAPACITY **6**

**G6845319**

**UPC**



GUN SERIAL # G 6845319

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 3-17-09 | SPD                                                                                 |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 3-17-09 | RP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                             | 3-17-09 | SPD                                                                                 |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 3-17-09 | SPD                                                                                 |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 3-17-09 | SPD                                                                                 |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNAFLUX                                                                                   | 3-18-09 | RZ                                                                                  |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 3-18-09 | SP                                                                                  |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/20/09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             |         |                                                                                     |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 3/24/09 | RT                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 3-24    | BT                                                                                  |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 3-27    | —                                                                                   |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION<br>A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                              |                                                                                             | 3-28-09 | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-28-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-28-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 4-1-09  | SPD                                                                                 |
|      | 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

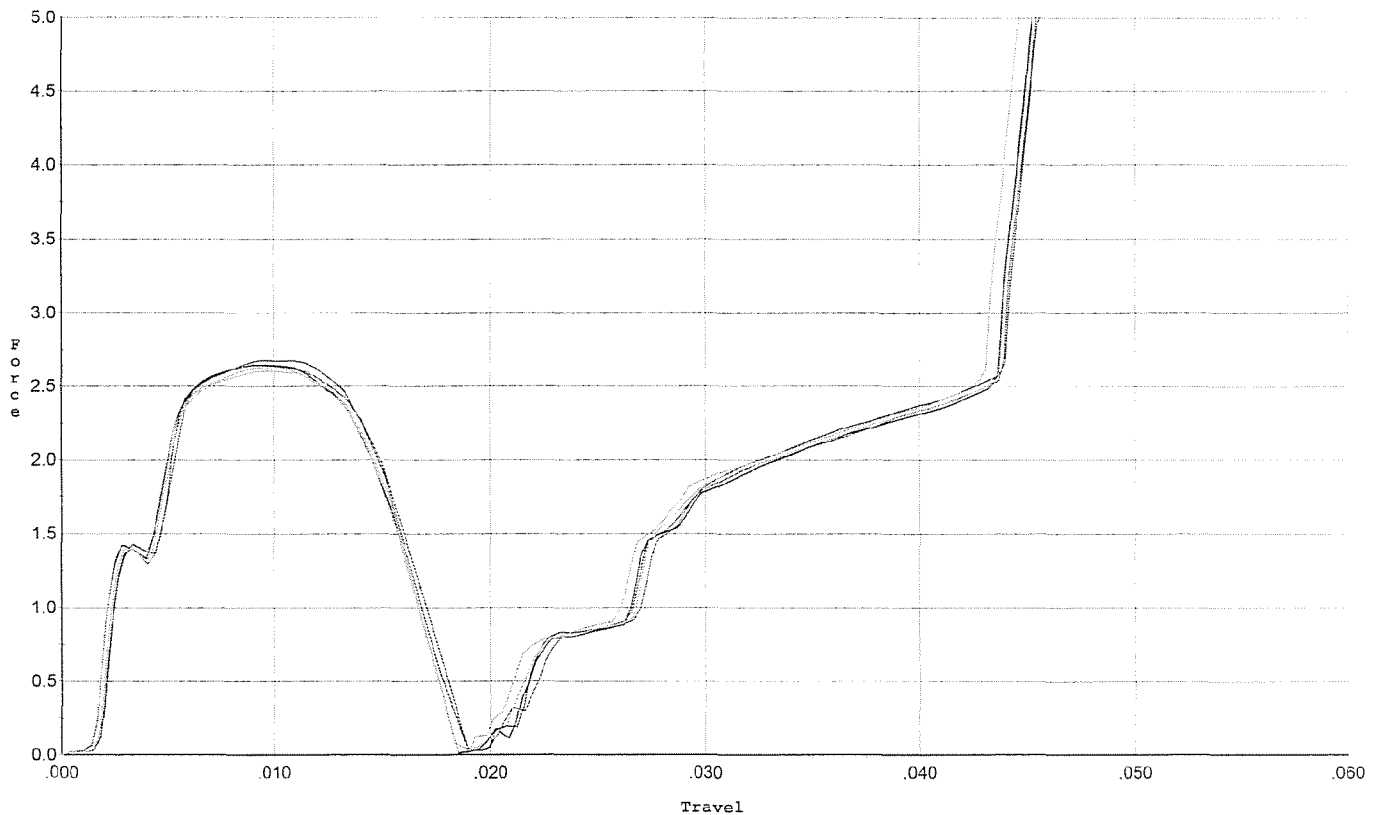
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>25</u> <u>25</u> <u>26</u>                               | 4-17-09 | RP      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.6</u> <u>4.6</u> <u>4.5</u>                            | 4-17-09 | RP      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.024</u> <u>.024</u>                         | 4-17-09 | RP      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 4-1-09  | S.P.D.  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 4-17-09 | RP      |
|              | 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> <u>PASS</u> FAIL FAIL                           | 4-9-09  | WW      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  | 4-9-09  | TQR     |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             |         |         |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             |         |         |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.72</u> <u>2.61</u> <u>2.65</u> <u>2.69</u> <u>2.69</u> | 4-14-09 | WW      |
|              | C) FUNCTION                                                              |                                                             | 4-17-09 | RP      |
| 690          | PACK                                                                     |                                                             | 5/29/09 | FM      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



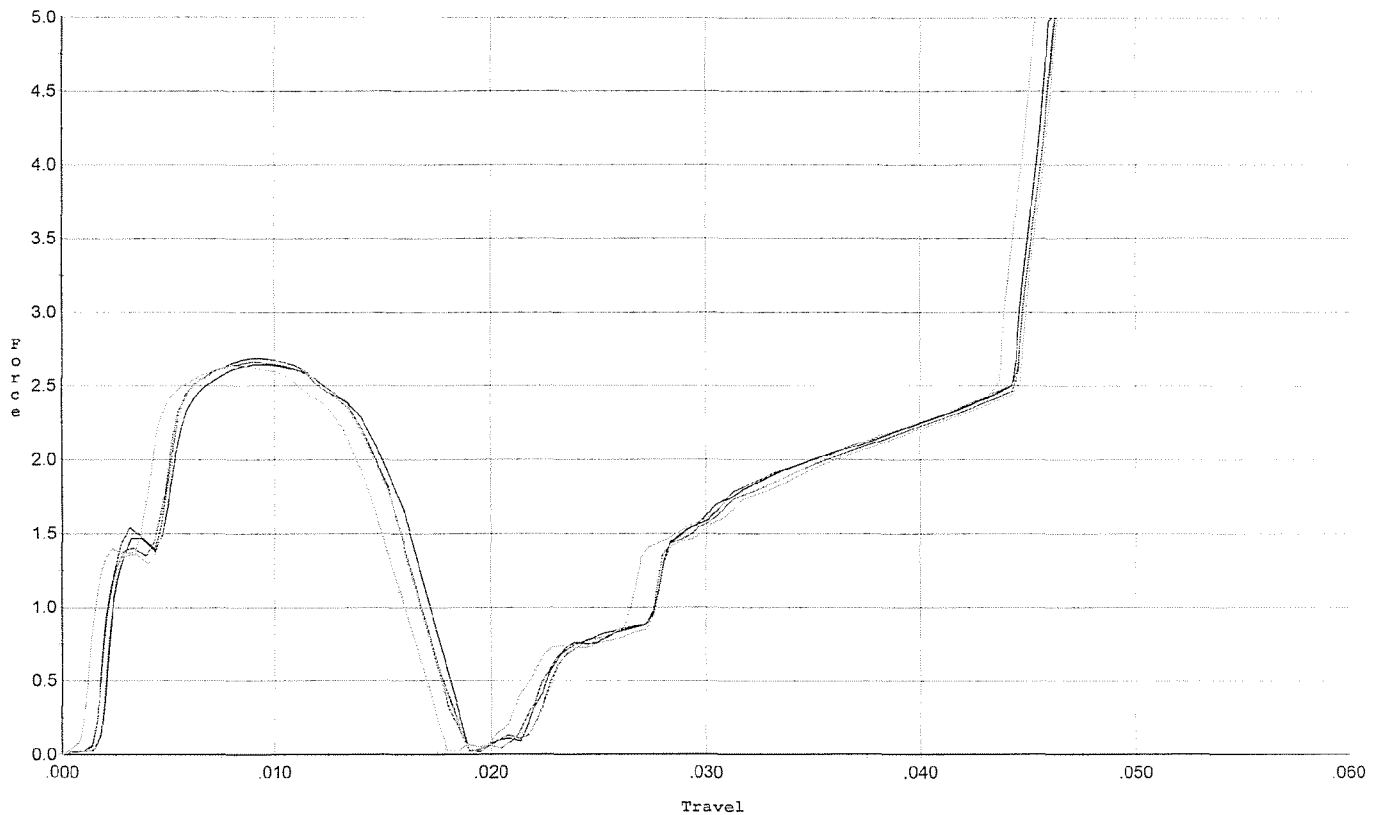
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.676      | 0.015             | 0.005           | 0.034      | 0.027             |           | Set Trigger |
| 2 | 2.647      | 0.016             | 0.004           | 0.034      | 0.028             |           | Set Trigger |
| 3 | 2.640      | 0.017             | 0.00            | 0.034      | 0.030             |           | Set Trigger |
| 4 | 2.604      | 0.015             | 0.004           | 0.034      | 0.027             |           | Set Trigger |
| 5 | 2.626      | 0.016             | 0.004           | 0.033      | 0.028             |           | Set Trigger |

A-2-63

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



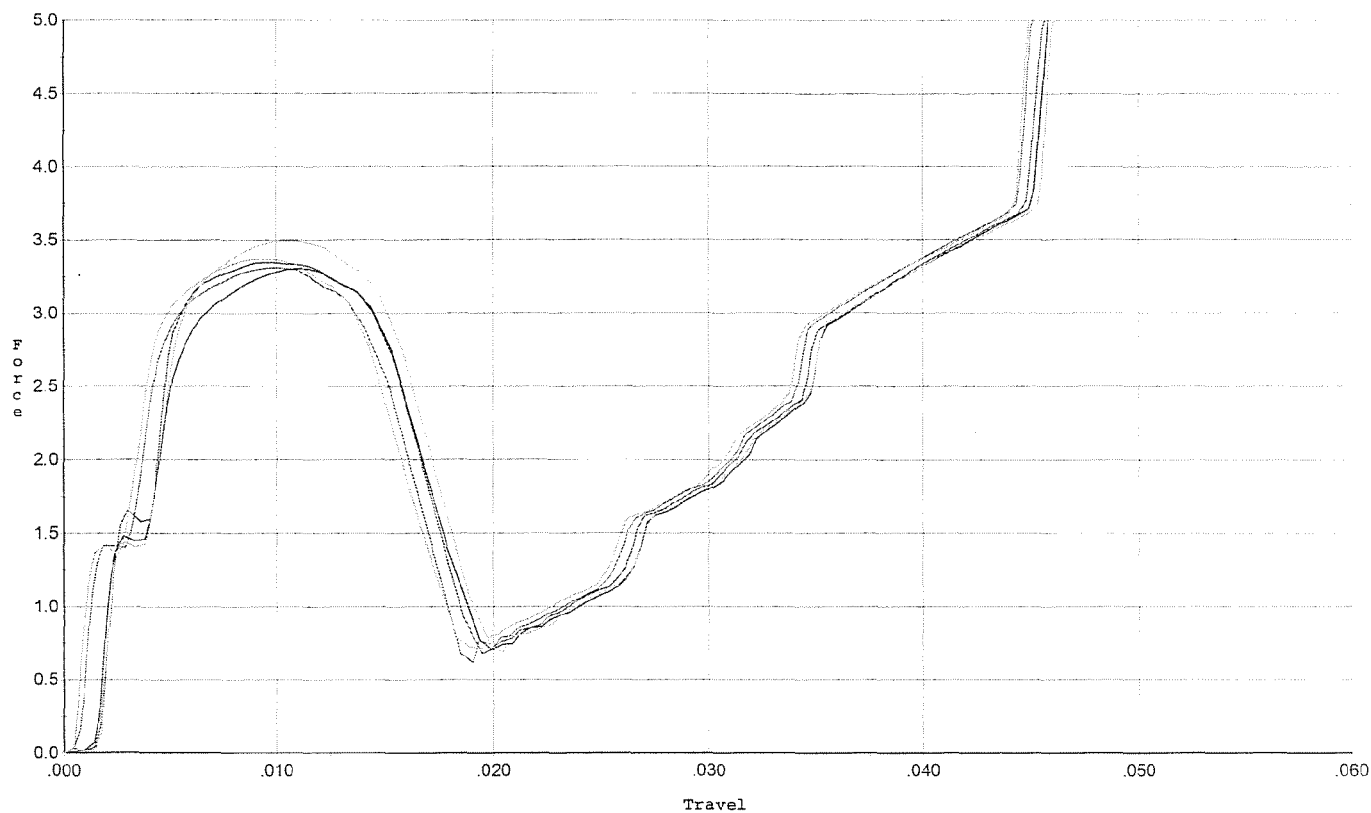
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.687      | 0.015             | 0.005           | 0.035      | 0.028             |           | Set Trigger |
| 2 | 2.646      | 0.016             | 0.005           | 0.034      | 0.028             |           | Set Trigger |
| 3 | 2.664      | 0.015             | 0.00            | 0.035      | 0.028             |           | Set Trigger |
| 4 | 2.682      | 0.015             | 0.004           | 0.035      | 0.027             |           | Set Trigger |
| 5 | 2.634      | 0.016             | 0.00            | 0.035      | 0.029             |           | Set Trigger |

A-2-66

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



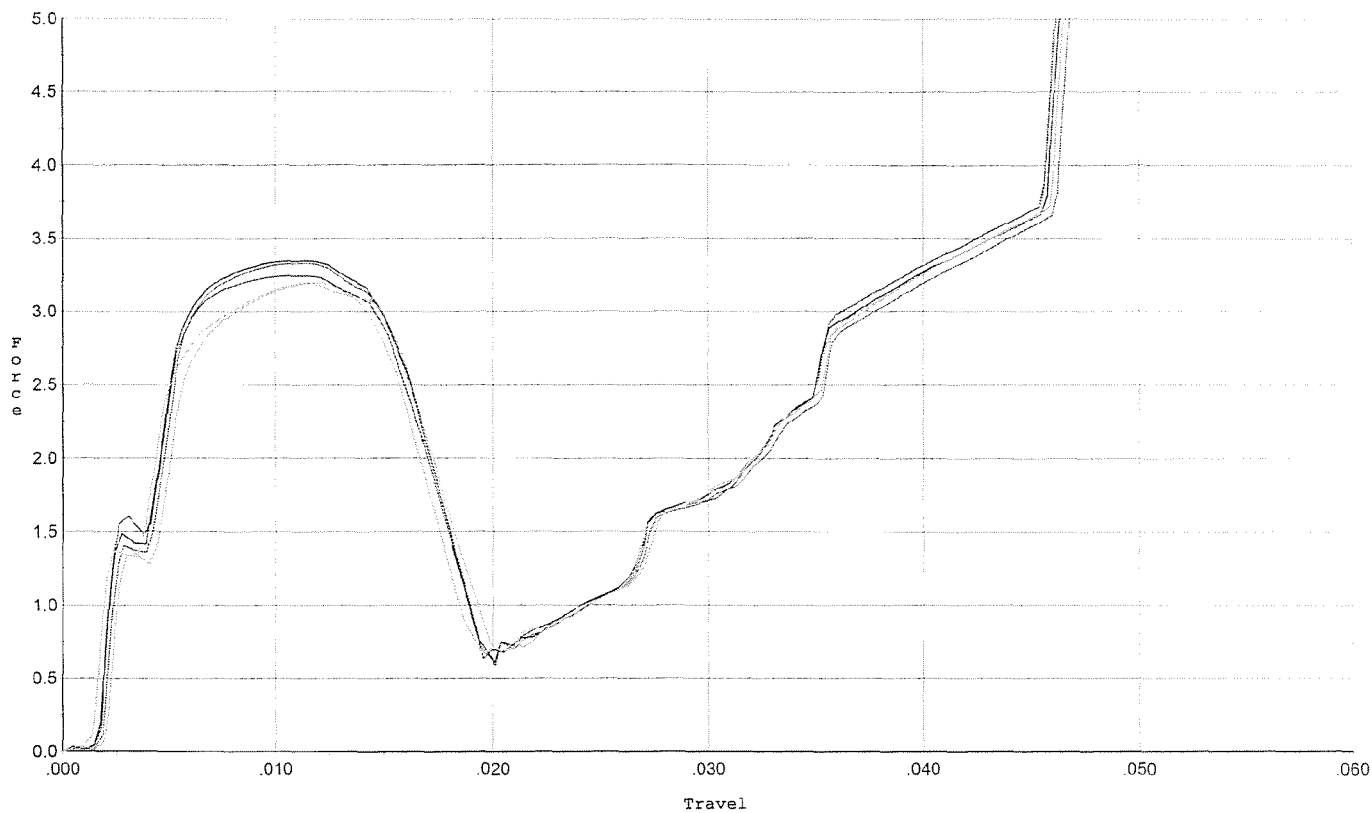
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.346      | 0.015             | 0.00            | 0.033      | 0.035             |           | Set Trigger |
| 2 | 3.305      | 0.015             | 0.00            | 0.033      | 0.034             |           | Set Trigger |
| 3 | 3.311      | 0.015             | 0.003           | 0.033      | 0.036             |           | Set Trigger |
| 4 | 3.496      | 0.016             | 0.00            | 0.033      | 0.037             |           | Set Trigger |
| 5 | 3.369      | 0.014             | 0.00            | 0.033      | 0.034             |           | Set Trigger |

A-3.36

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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 | 3.245      | 0.017             | 0.00            | 0.033      | 0.037             |           | Set Trigger |
| 2 | 3.347      | 0.016             | 0.004           | 0.033      | 0.037             |           | Set Trigger |
| 3 | 3.332      | 0.016             | 0.004           | 0.033      | 0.036             |           | Set Trigger |
| 4 | 3.198      | 0.016             | 0.004           | 0.033      | 0.034             |           | Set Trigger |
| 5 | 3.199      | 0.016             | 0.00            | 0.033      | 0.034             |           | Set Trigger |

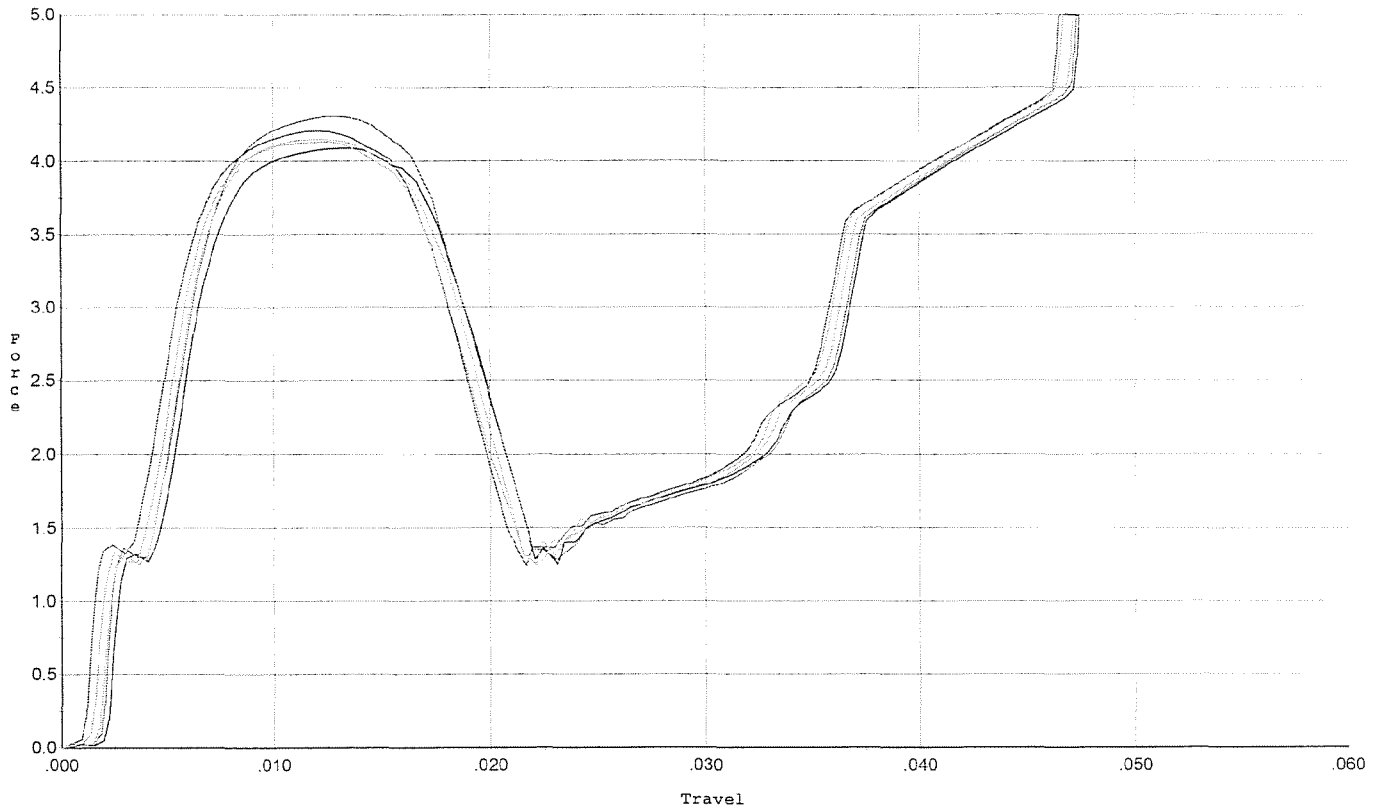
A-3-26



## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



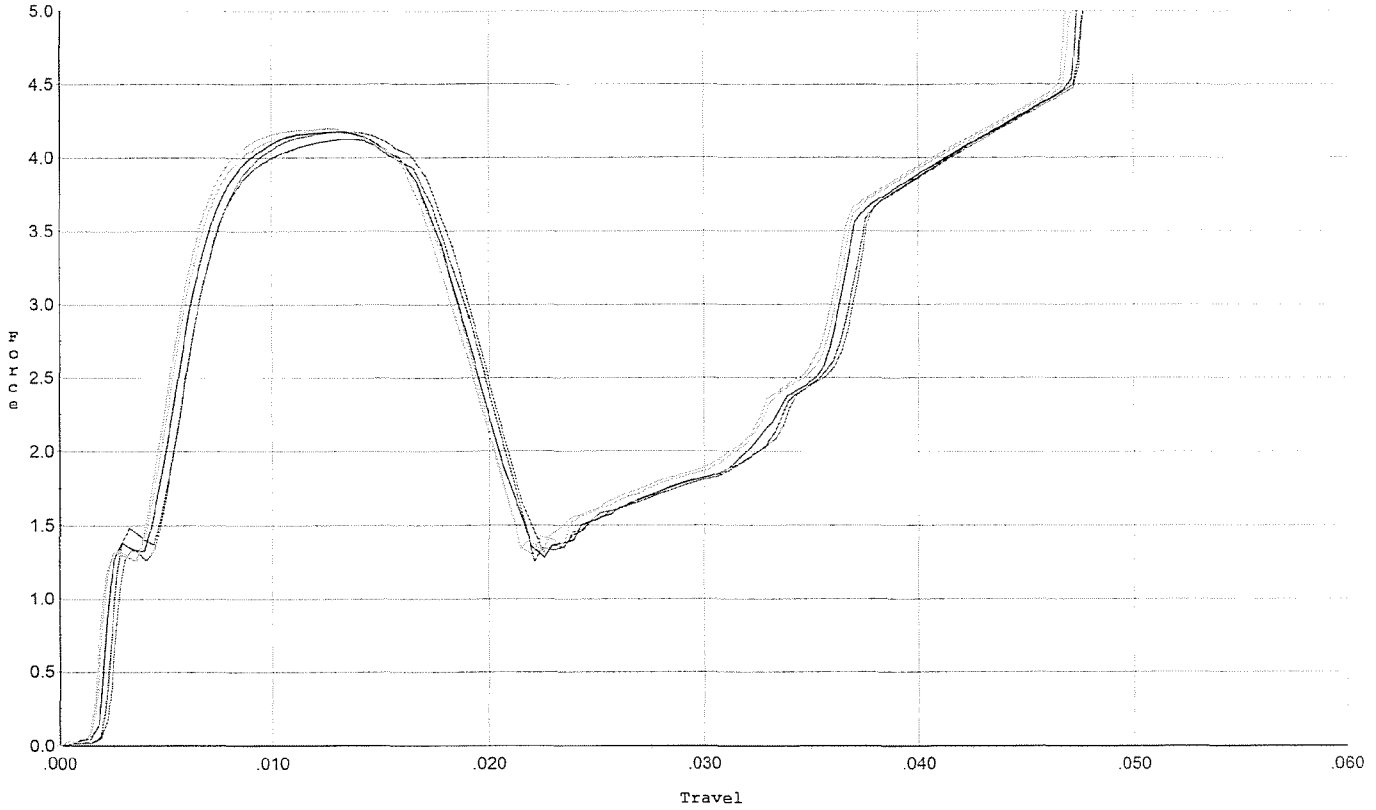
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.204      | 0.017             | 0.00            | 0.031      | 0.049             |           | Set Trigger |
| 2 | 4.088      | 0.019             | 0.00            | 0.031      | 0.051             |           | Set Trigger |
| 3 | 4.305      | 0.020             | 0.002           | 0.031      | 0.054             |           | Set Trigger |
| 4 | 4.146      | 0.018             | 0.00            | 0.031      | 0.049             |           | Set Trigger |
| 5 | 4.128      | 0.017             | 0.004           | 0.031      | 0.047             |           | Set Trigger |

A-4.17

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



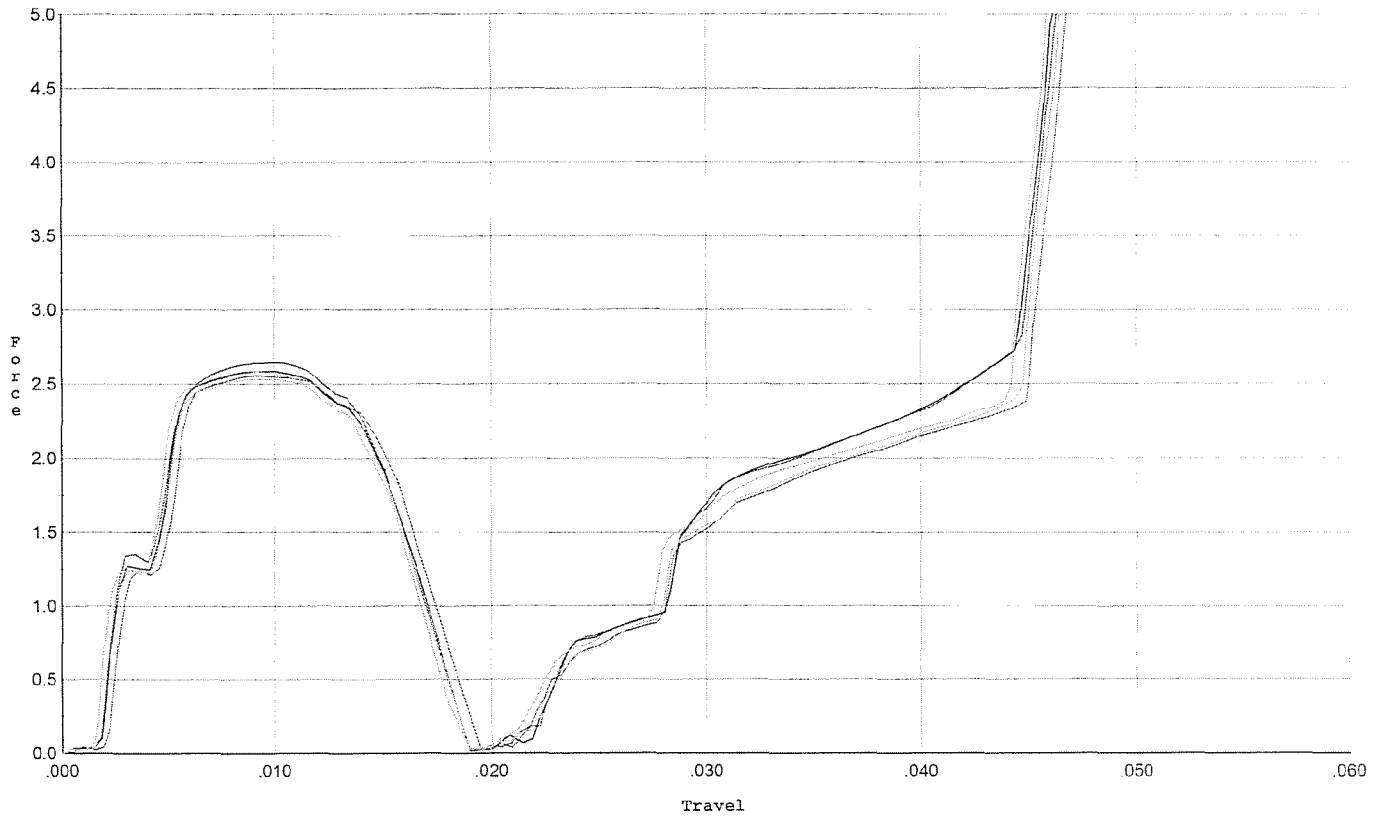
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.126      | 0.019             | 0.005           | 0.031      | 0.051             |           | Set Trigger |
| 2 | 4.174      | 0.018             | 0.004           | 0.031      | 0.049             |           | Set Trigger |
| 3 | 4.178      | 0.018             | 0.00            | 0.031      | 0.049             |           | Set Trigger |
| 4 | 4.196      | 0.018             | 0.004           | 0.031      | 0.050             |           | Set Trigger |
| 5 | 4.199      | 0.019             | 0.004           | 0.031      | 0.053             |           | Set Trigger |

A-4.17

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



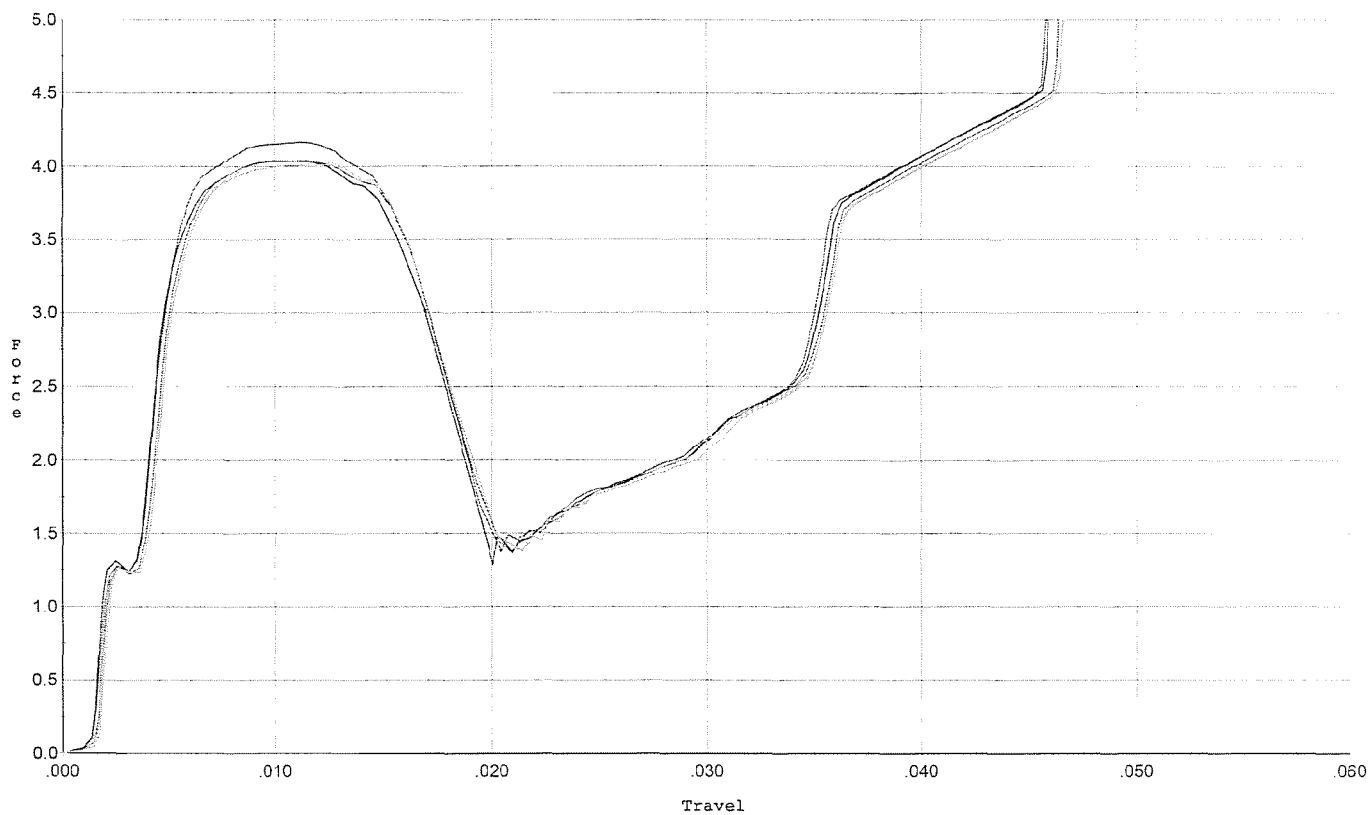
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.645      | 0.015             | 0.002           | 0.035      | 0.027             |           | Set Trigger |
| 2 | 2.583      | 0.017             | 0.004           | 0.034      | 0.029             |           | Set Trigger |
| 3 | 2.555      | 0.016             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 4 | 2.531      | 0.017             | 0.004           | 0.035      | 0.029             |           | Set Trigger |
| 5 | 2.585      | 0.015             | 0.00            | 0.035      | 0.027             |           | Set Trigger |

A-2.58

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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 | 4.164      | 0.016             | 0.00            | 0.031      | 0.046             |           | Set Trigger |
| 2 | 4.038      | 0.017             | 0.00            | 0.031      | 0.046             |           | Set Trigger |
| 3 | 4.035      | 0.016             | 0.00            | 0.031      | 0.044             |           | Set Trigger |
| 4 | 4.042      | 0.016             | 0.004           | 0.032      | 0.044             |           | Set Trigger |
| 5 | 4.013      | 0.016             | 0.004           | 0.032      | 0.044             |           | Set Trigger |

A-4.05