

6684 8420

**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



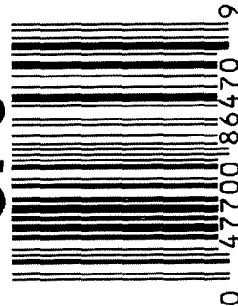
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6848420**

**UPC**



BM FORM

GUN SERIAL #

6684 8420

| OP #            | OPERATION NAME                                                 | READINGS              | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------|-----------------------|---------|---------|
| 420             | ASSEMBLE ACTION                                                |                       | 4-20-09 | S.P.D.  |
| 430             | ASSEMBLE TO STOCK                                              |                       | 4-20-09 | RP      |
| 440             | PROOF                                                          |                       | 4-20-09 | S.P.D.  |
| 460             | CHECK HEADSPACE                                                | MAGNA - FLUX          | 4-20-09 | S.P.D.  |
| 470             | DIS-ASSEMBLE ACTION                                            | APP                   | 4-20-09 | S.P.D.  |
| 472             | SERIALIZE BOLT HANDLE                                          |                       | 4-21-09 | R/C     |
| 480             | MAGNAFLUX BBL ACTION                                           | OPERATOR              | 4/24/09 | (D)     |
| 490             | MAGNAFLUX BOLT                                                 |                       |         |         |
| 500             | ROLLMARK CALIBER                                               |                       | 4/27/09 | RT      |
| 510             | DRILL AND TAP<br>SIGHT HOLES                                   |                       | 4-21-09 | JP      |
| 520             | GOFF BLAST BBL / REC                                           |                       | 4/28    | mm      |
| 540             | APPLY COATINGS<br>(BARREL ACTION)                              |                       | 4-50    |         |
| 545             | (BOLT)                                                         |                       |         |         |
| 560             | RE-ASSEMBLE ACTION                                             |                       |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                       | 5-1-09  | JP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                       | 5-1-09  | JP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         | INSPECT FOR LIVE AMMO | 5-1-09  | JP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                     |                       | 5-4-09  | 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>2.5</u> <u>2.5</u> <u>2.5</u>                            | 5-13-09 | LRD     |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3.0</u> <u>3.0</u> <u>3.0</u>                            | 5-13-09 | LRD     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 5-13-09 | LRD     |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 5-4-09  | LRD     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 5-13-09 | LRD     |
|              | 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                        | 5-7-09  | WV      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 5-7-09  | TQR     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 5-13-09 | LRD     |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.44</u> <u>2.45</u> <u>2.47</u> <u>2.47</u> <u>2.45</u> | 5-7-09  | RP      |
|              | C) FUNCTION                                                              |                                                             | 5-13-09 | LRD     |
| 690          | PACK                                                                     |                                                             | 7/23/09 | Fm      |

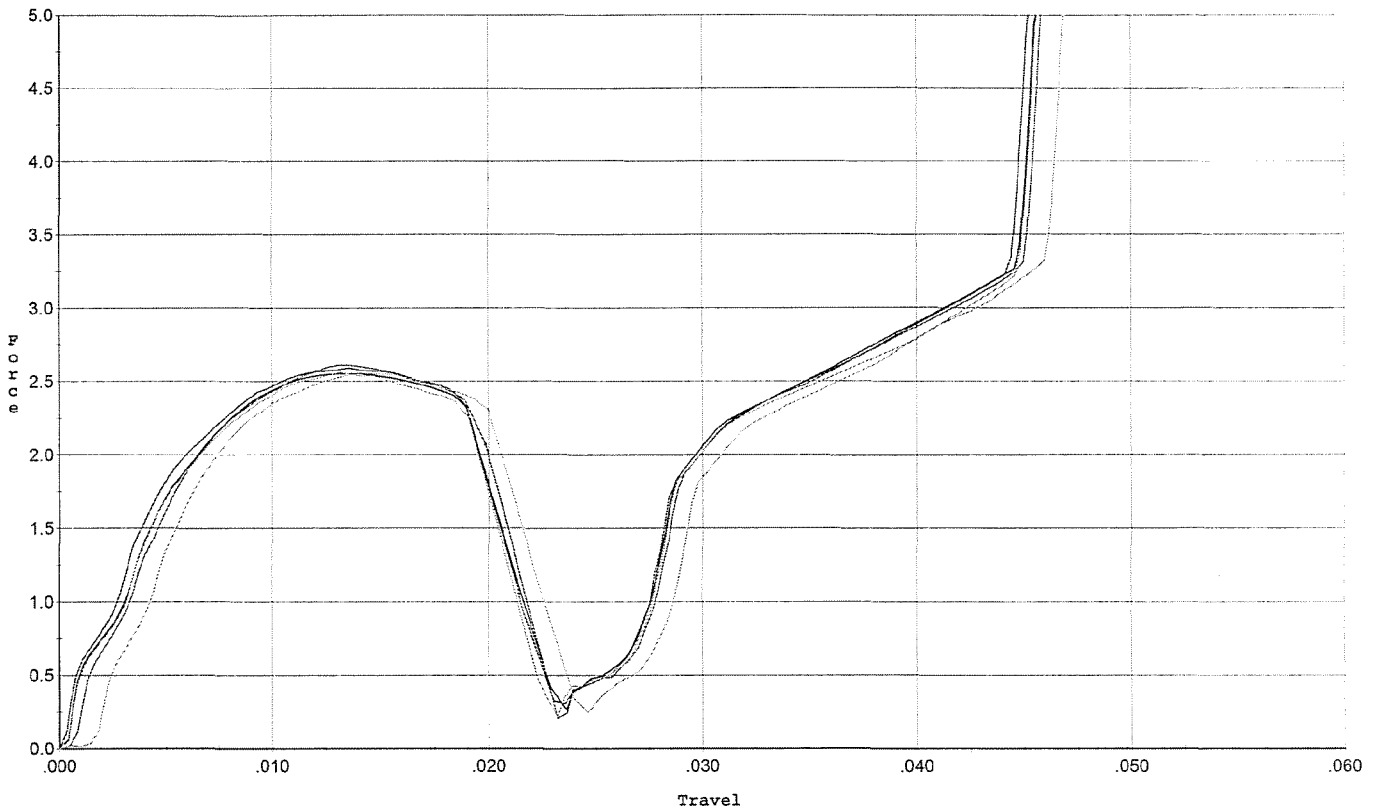
F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

Model: M/24  
Serial No: Form #F005  
Trigger: 2.5 lbs ini

+/- .50 lb.  
cms



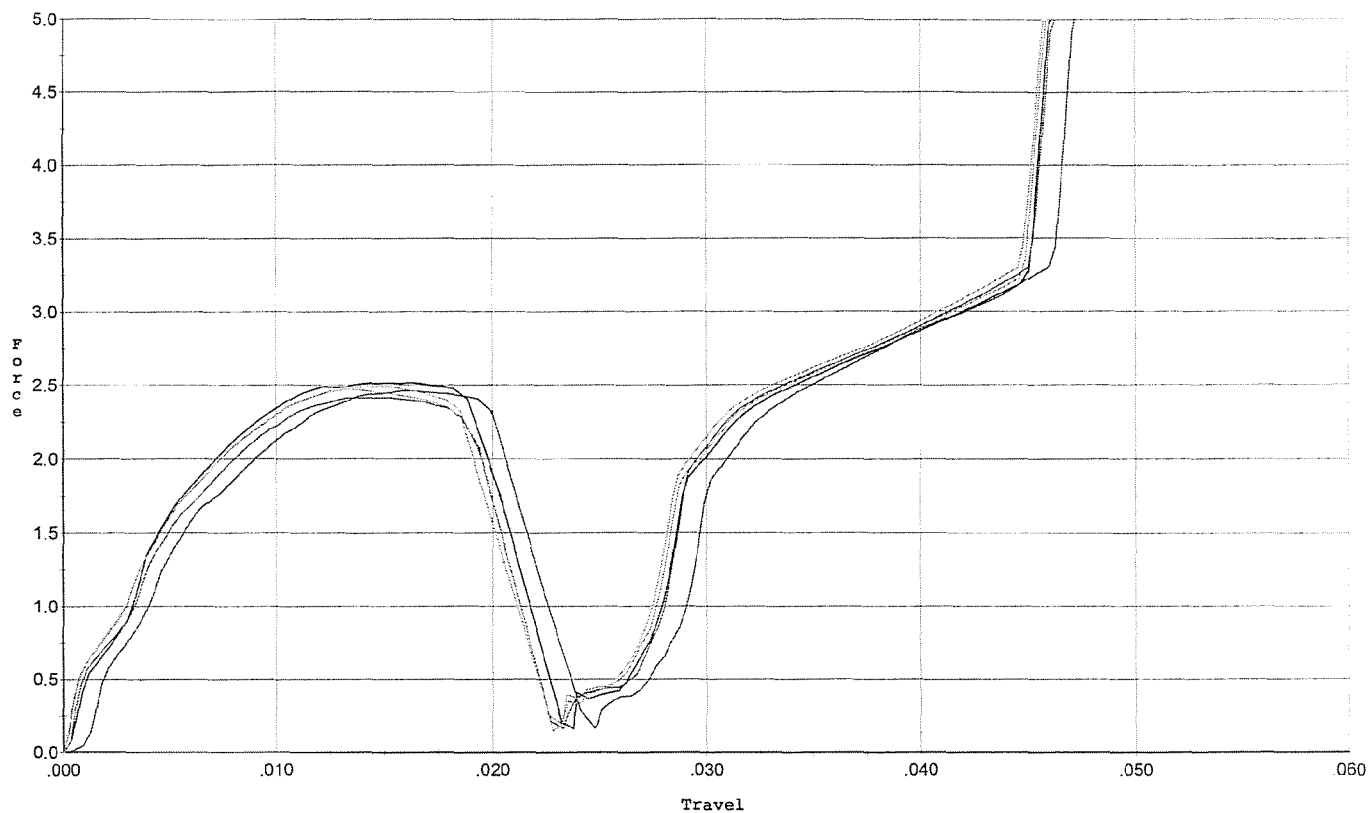
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.592      | 0.019             | 0.00            | 0.030      | 0.037             |           | Set Trigger |
| 2 | 2.555      | 0.019             | 0.00            | 0.030      | 0.036             |           | Set Trigger |
| 3 | 2.612      | 0.020             | 0.00            | 0.030      | 0.037             |           | Set Trigger |
| 4 | 2.553      | 0.020             | 0.00            | 0.031      | 0.035             |           | Set Trigger |
| 5 | 2.560      | 0.019             | 0.00            | 0.030      | 0.035             |           | Set Trigger |

A-2.57

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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



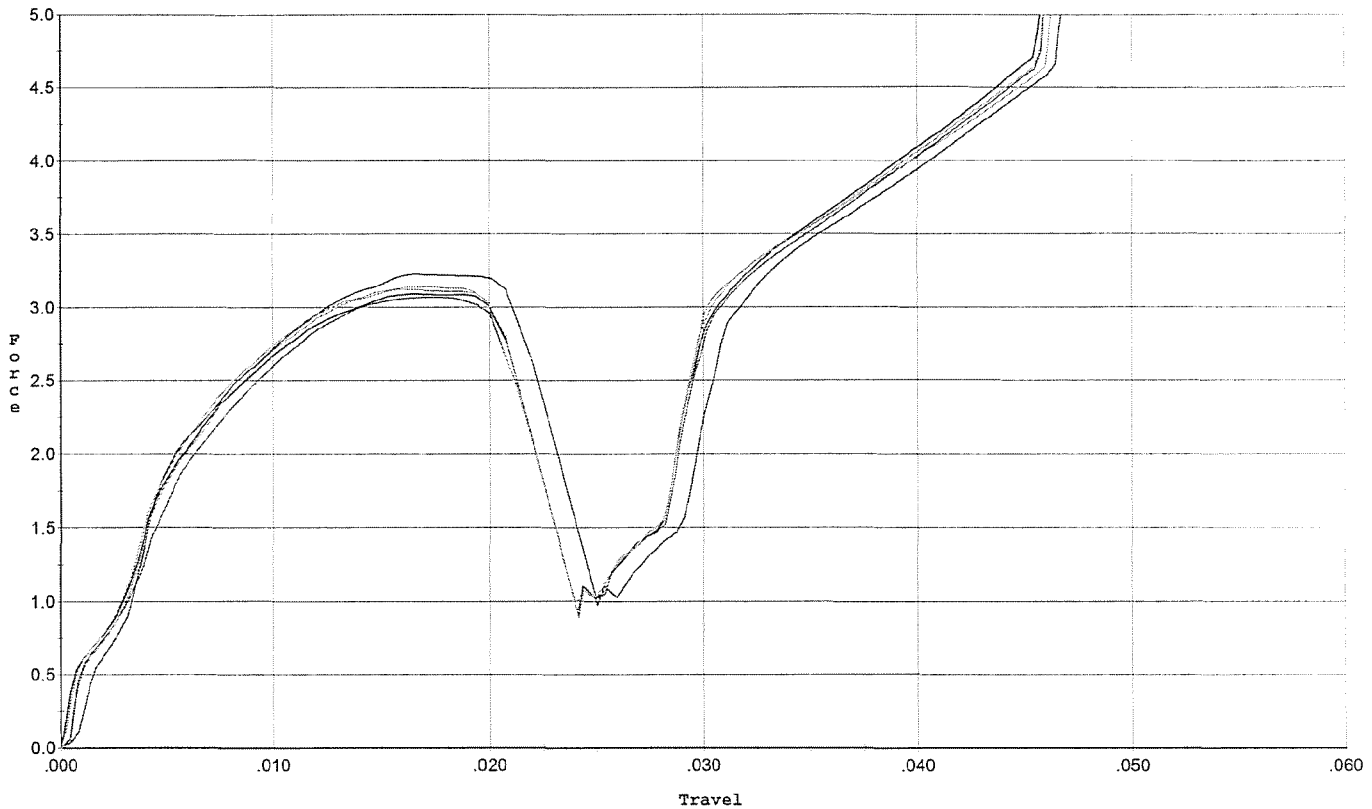
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.464      | 0.020             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 2 | 2.515      | 0.020             | 0.00            | 0.030      | 0.037             |           | Set Trigger |
| 3 | 2.414      | 0.019             | 0.00            | 0.031      | 0.034             |           | Set Trigger |
| 4 | 2.492      | 0.019             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 5 | 2.472      | 0.021             | 0.00            | 0.030      | 0.037             |           | Set Trigger |

A-2.47

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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



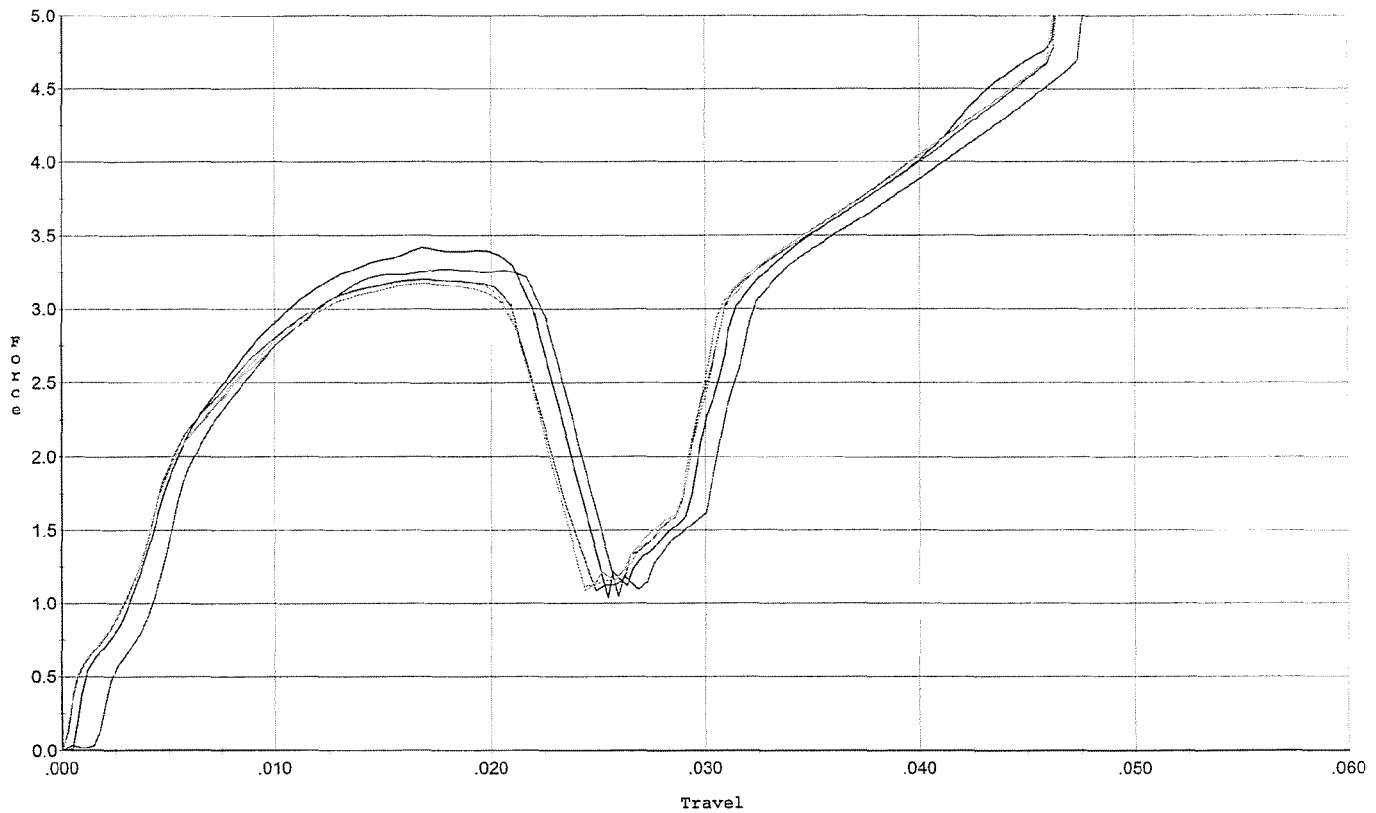
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.227      | 0.022             | 0.00            | 0.028      | 0.050             |           | Set Trigger |
| 2 | 3.091      | 0.021             | 0.00            | 0.028      | 0.046             |           | Set Trigger |
| 3 | 3.067      | 0.021             | 0.00            | 0.028      | 0.045             |           | Set Trigger |
| 4 | 3.145      | 0.021             | 0.00            | 0.028      | 0.048             |           | Set Trigger |
| 5 | 3.123      | 0.021             | 0.00            | 0.028      | 0.046             |           | Set Trigger |

A-3-13

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 5/1/2009

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 | 3.271      | 0.023             | 0.00            | 0.028      | 0.051             |           | Set Trigger |
| 2 | 3.416      | 0.022             | 0.00            | 0.027      | 0.052             |           | Set Trigger |
| 3 | 3.199      | 0.021             | 0.00            | 0.028      | 0.048             |           | Set Trigger |
| 4 | 3.193      | 0.021             | 0.00            | 0.028      | 0.048             |           | Set Trigger |
| 5 | 3.173      | 0.021             | 0.00            | 0.028      | 0.048             |           | Set Trigger |

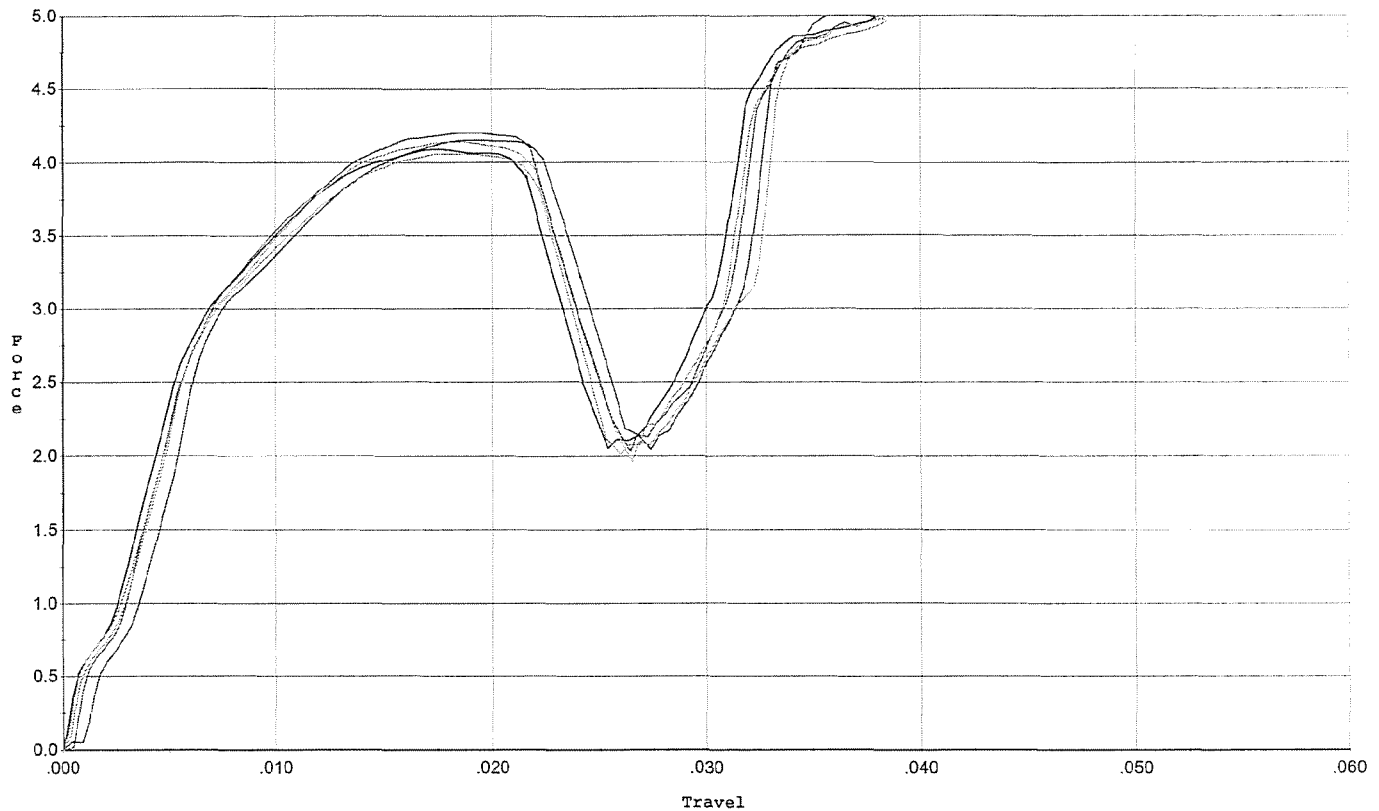
A-3.25



## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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



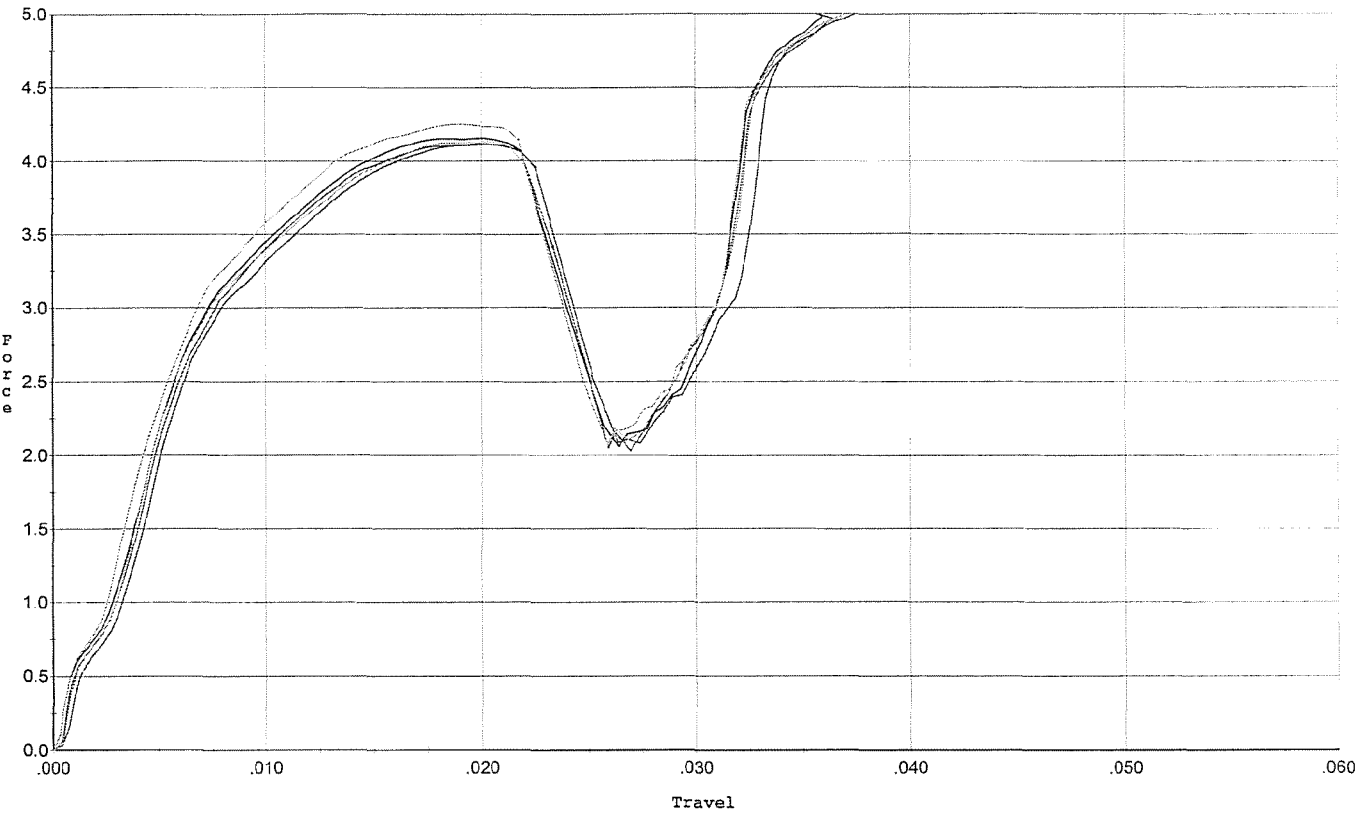
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.150      | 0.024             | 0.00            | 0.022      | 0.068             |           | Set Trigger |
| 2 | 4.091      | 0.022             | 0.00            | 0.025      | 0.062             |           | Set Trigger |
| 3 | 4.199      | 0.022             | 0.00            | 0.024      | 0.063             |           | Set Trigger |
| 4 | 4.139      | 0.022             | 0.00            | 0.027      | 0.063             |           | Set Trigger |
| 5 | 4.058      | 0.022             | 0.00            | 0.025      | 0.063             |           | Set Trigger |

A. 4.12

Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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



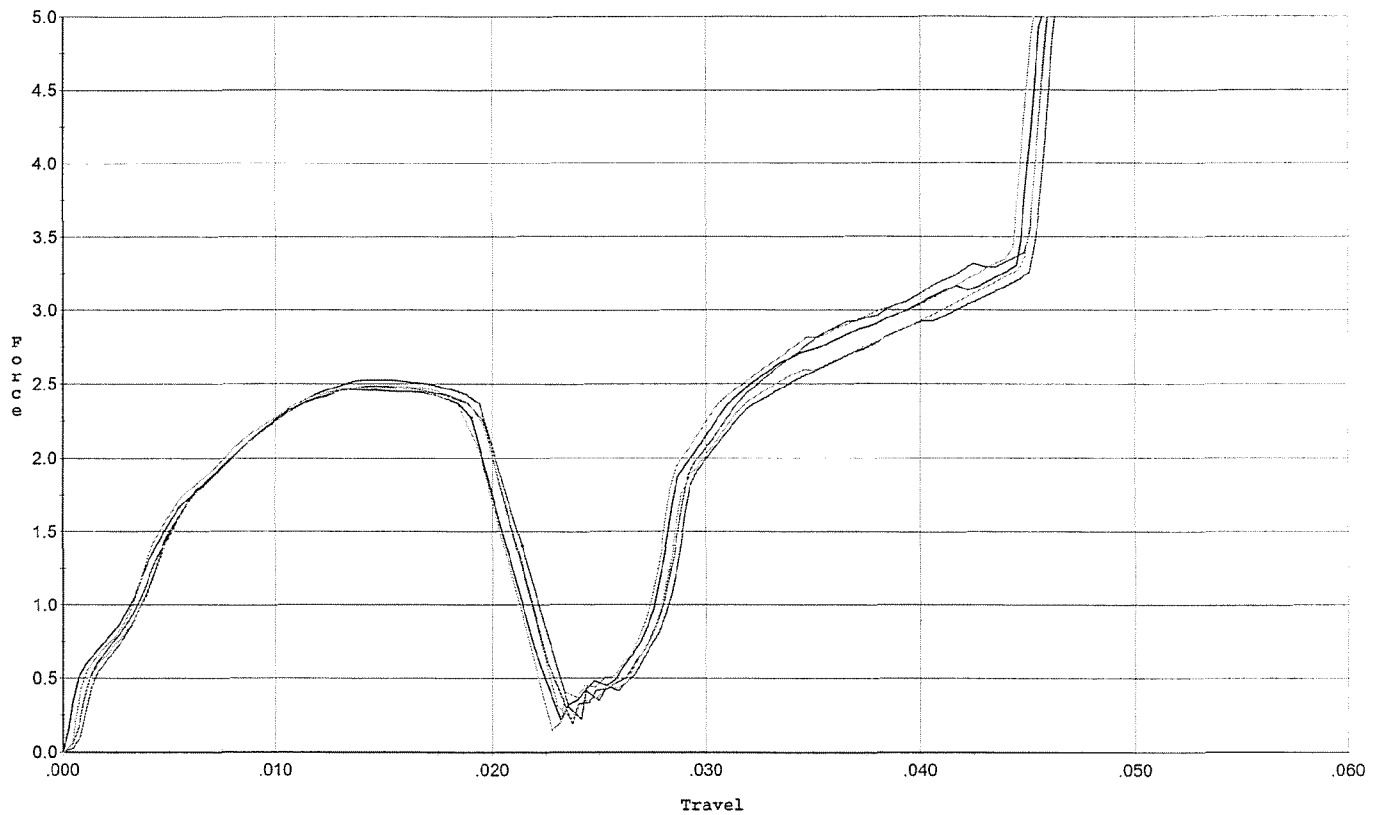
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.115      | 0.022             | 0.00            | 0.022      | 0.063             |           | Set Trigger |
| 2 | 4.153      | 0.022             | 0.00            | 0.024      | 0.063             |           | Set Trigger |
| 3 | 4.112      | 0.023             | 0.00            | 0.022      | 0.066             |           | Set Trigger |
| 4 | 4.128      | 0.022             | 0.00            | 0.026      | 0.062             |           | Set Trigger |
| 5 | 4.253      | 0.022             | 0.00            | 0.022      | 0.064             |           | Set Trigger |

A-4.15

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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



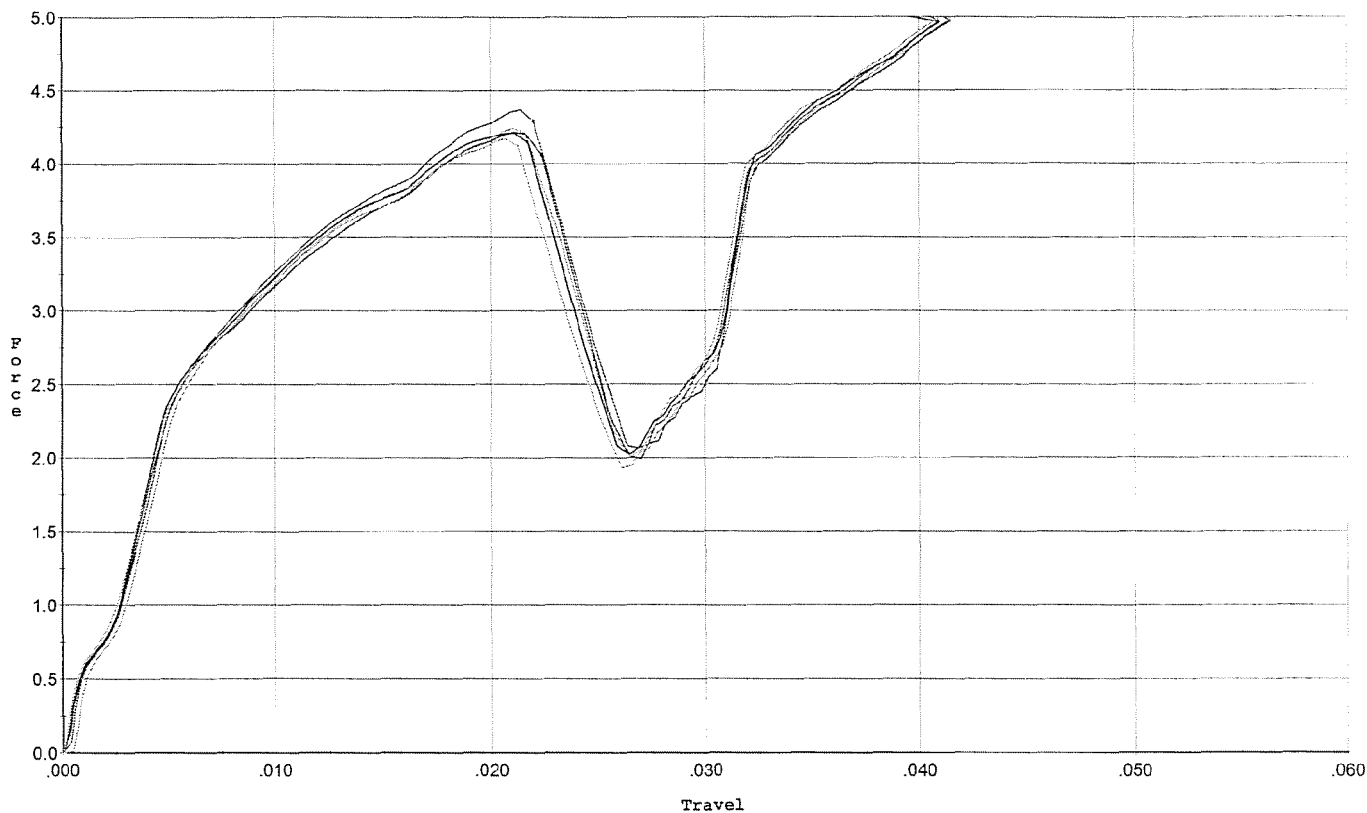
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.527      | 0.021             | 0.00            | 0.030      | 0.038             |           | Set Trigger |
| 2 | 2.464      | 0.019             | 0.00            | 0.030      | 0.034             |           | Set Trigger |
| 3 | 2.484      | 0.020             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 4 | 2.478      | 0.020             | 0.00            | 0.030      | 0.035             |           | Set Trigger |
| 5 | 2.474      | 0.019             | 0.00            | 0.030      | 0.035             |           | Set Trigger |

A.2.48

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 5/1/2009

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 | 4.215      | 0.022             | 0.00            | 0.022      | 0.062             |           | Set Trigger |
| 2 | 4.209      | 0.022             | 0.00            | 0.022      | 0.061             |           | Set Trigger |
| 3 | 4.368      | 0.022             | 0.00            | 0.021      | 0.063             |           | Set Trigger |
| 4 | 4.170      | 0.021             | 0.00            | 0.025      | 0.059             |           | Set Trigger |
| 5 | 4.242      | 0.023             | 0.00            | 0.022      | 0.064             |           | Set Trigger |

A. 4.24