

G677 8930

**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**

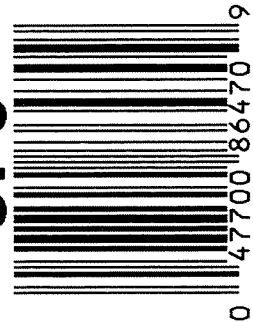
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6778930**

**UPC**



GUN SERIAL # G6778930

| OP # | OPERATION NAME                                                 | READINGS            | DATE    | INITIAL |
|------|----------------------------------------------------------------|---------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 8-19-08 | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 8-19-08 | SP      |
| 440  | PROOF                                                          |                     | 8-19-08 | SPD     |
| 460  | CHECK HEADSPACE                                                |                     | 8-19-08 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 8-19-08 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          | MAGNA - FLUX        | 8-20-08 | ESN     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   | AUG 21 2008         | 8-20-08 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR BH         | 8-21-08 | BH      |
| 490  | MAGNAFLUX BOLT                                                 |                     |         |         |
| 500  | ROLLMARK CALIBER                                               |                     | 8/22/08 | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 8/22/08 | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 8/23    | u       |
| 545  | (BOLT)                                                         |                     |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 8-25-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 8-25-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 8-25-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 9-10-08 | SPD     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |         |         |

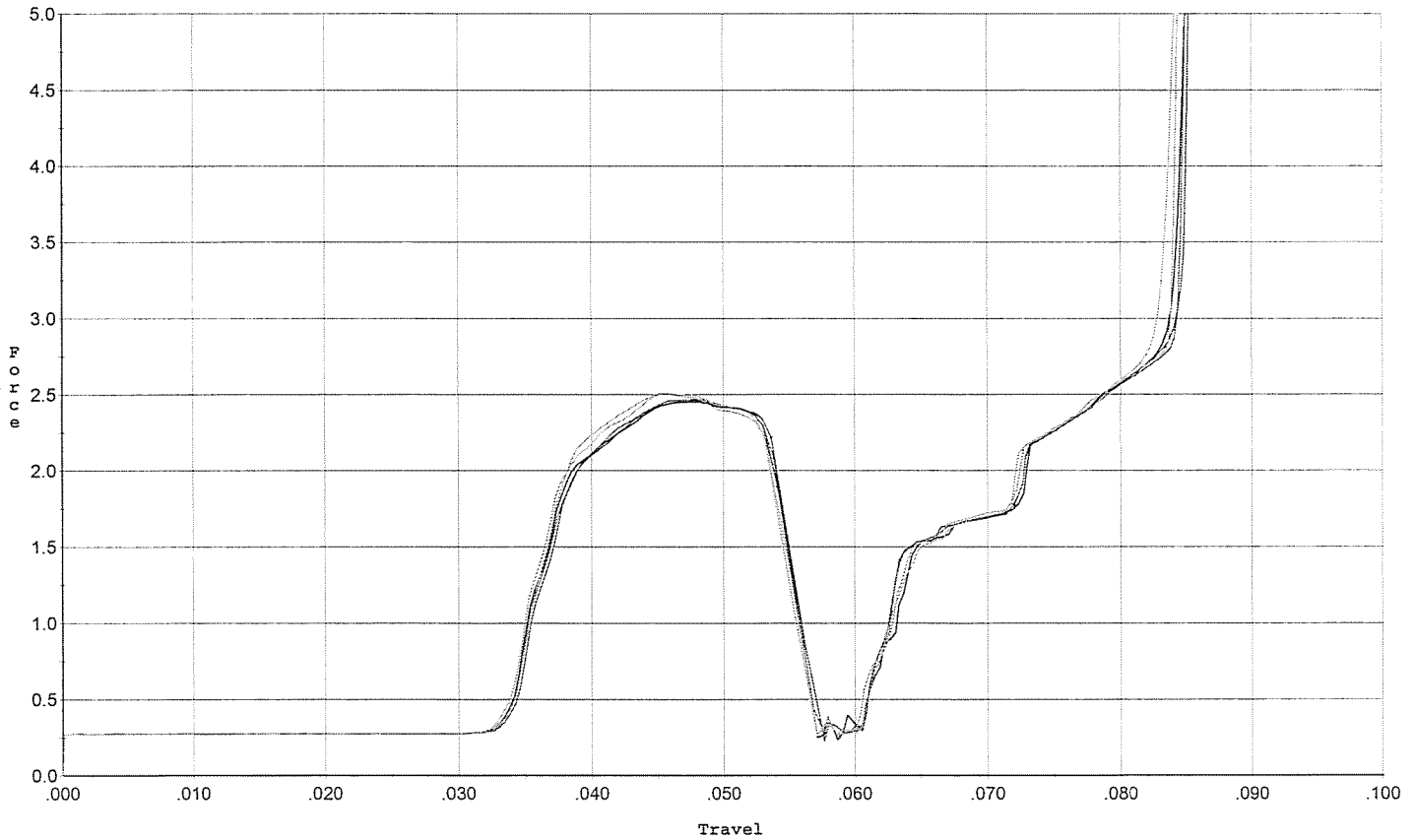
F004 REV 5/2006

|              |                                                                       |                                           |                                                             |         |     |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|-----|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>2.5</u> <u>2.5</u> <u>2.5</u>                            | 9-12-08 | TC  |
| CONT.        |                                                                       |                                           |                                                             |         |     |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>4</u> <u>4</u> <u>4</u>                                  | 9-12-08 | TC  |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |     |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.025</u> <u>.024</u> <u>.025</u>                         | 9-12-08 | TC  |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 9-10-08 | PPS |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 9-12-08 | TC  |
|              | 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                        | 9-11-08 | FR  |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |     |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 9-11-08 | TRU |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 9-12-08 | TC  |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.18</u> <u>2.22</u> <u>2.18</u> <u>2.07</u> <u>2.07</u> | 9-11-08 | ESW |
|              | C) FUNCTION                                                           |                                           |                                                             | 9-12-08 | TC  |
| 690          | PACK                                                                  |                                           |                                                             | 9-19-08 | TC  |

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/26/08

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



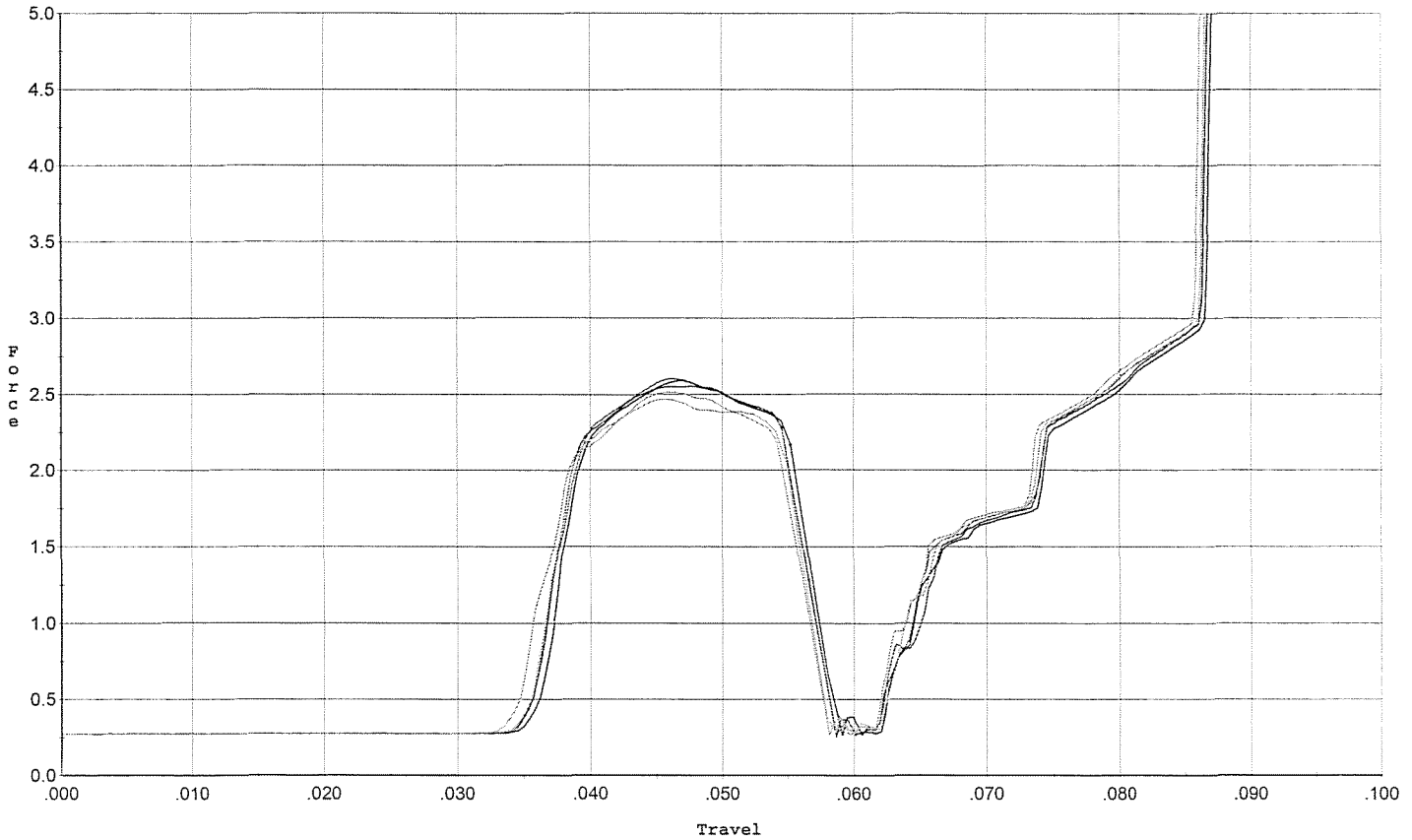
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.454      | 0.054             | 0.034           | 0.036      | 0.051             |           | Set Trigger |
| 2 | 2.463      | 0.054             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 3 | 2.470      | 0.054             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 4 | 2.509      | 0.053             | 0.033           | 0.036      | 0.052             |           | Set Trigger |
| 5 | 2.507      | 0.055             | 0.034           | 0.035      | 0.053             |           | Set Trigger |

Avg 2.48

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/26/08

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



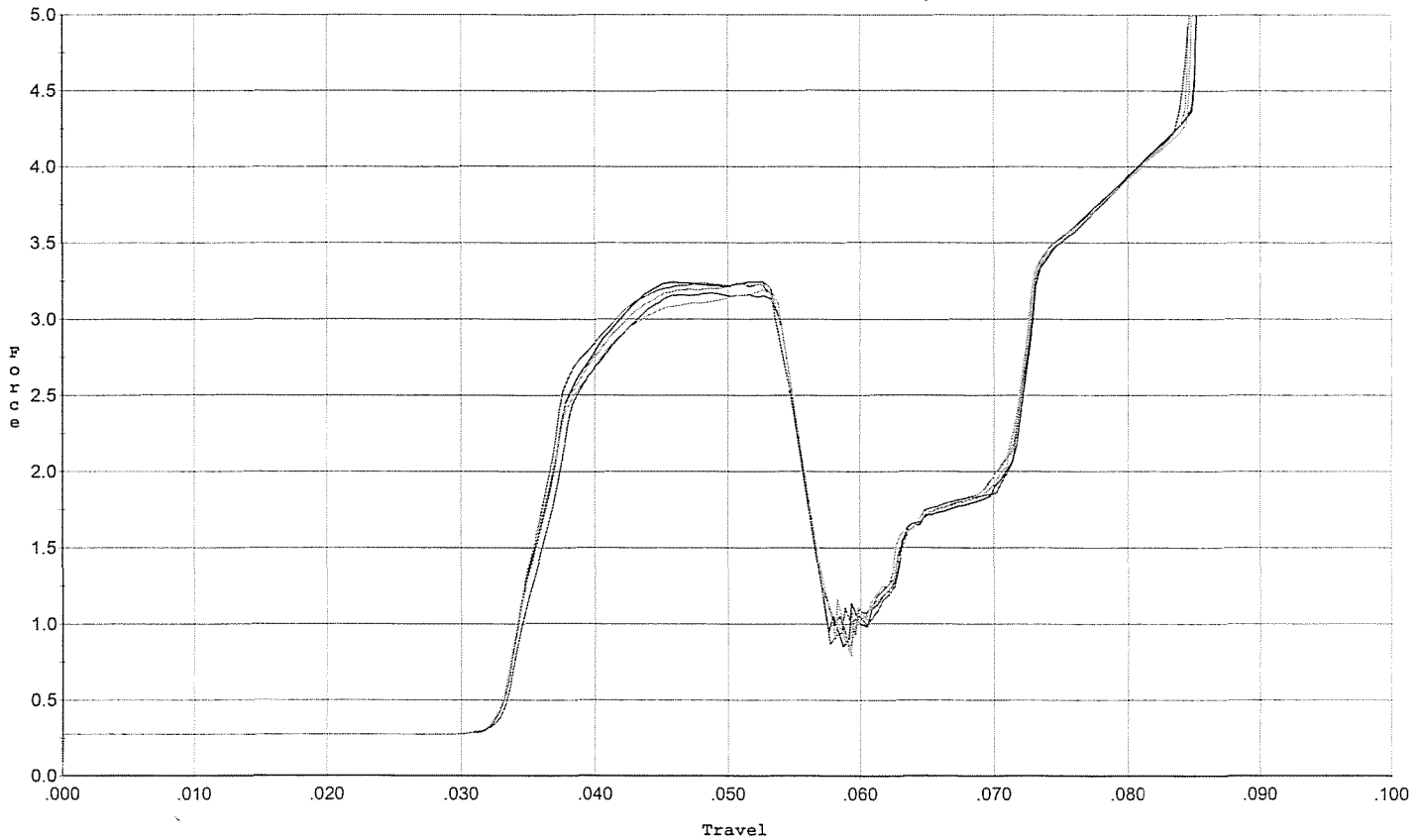
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.555      | 0.055             | 0.035           | 0.037      | 0.053             |           | Set Trigger |
| 2 | 2.589      | 0.055             | 0.036           | 0.037      | 0.054             |           | Set Trigger |
| 3 | 2.604      | 0.057             | 0.035           | 0.037      | 0.056             |           | Set Trigger |
| 4 | 2.468      | 0.055             | 0.035           | 0.037      | 0.053             |           | Set Trigger |
| 5 | 2.514      | 0.056             | 0.034           | 0.036      | 0.055             |           | Set Trigger |

Avg 2.54

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/26/08

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



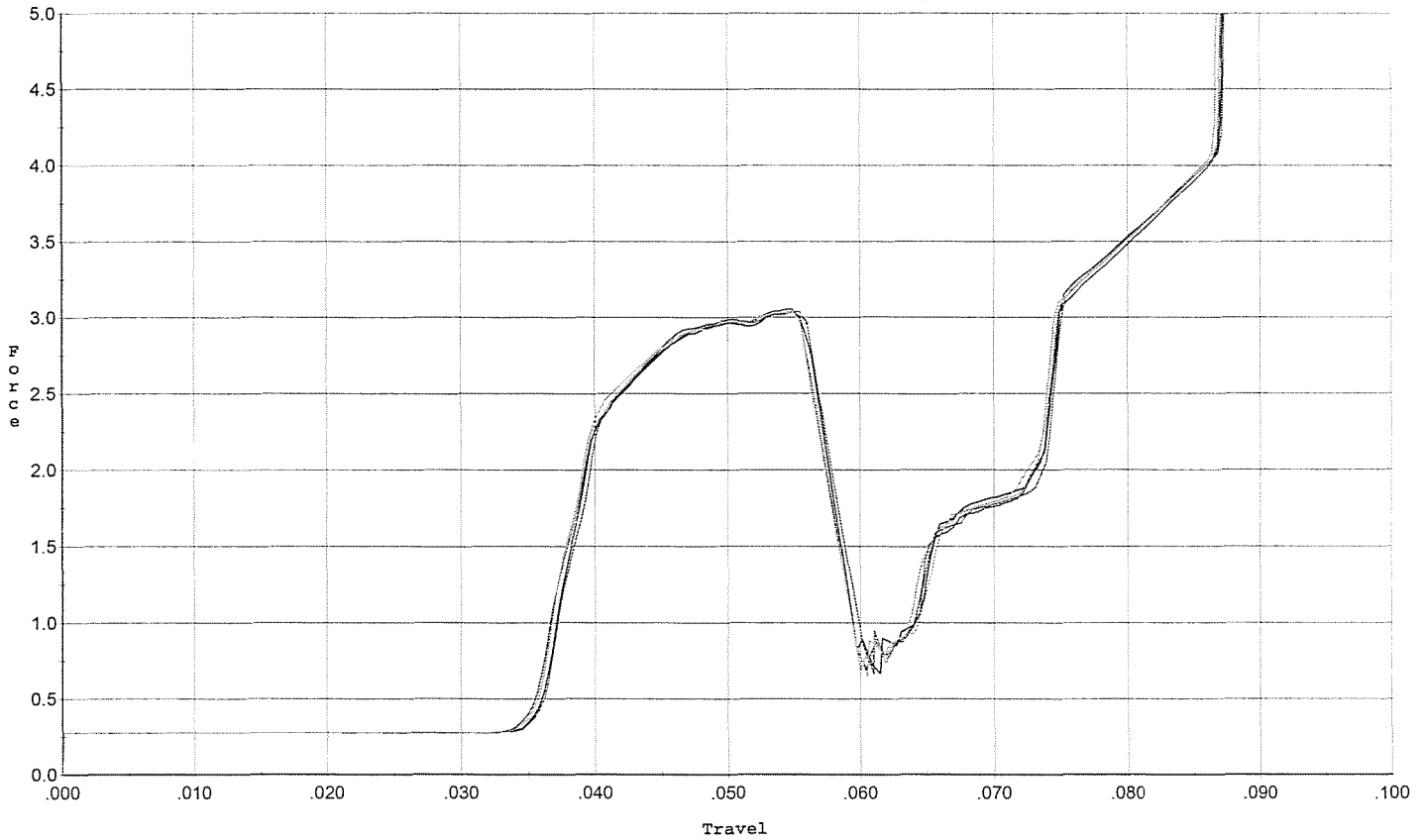
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.171      | 0.054             | 0.033           | 0.035      | 0.066             |           | Set Trigger |
| 2 | 3.246      | 0.054             | 0.033           | 0.035      | 0.068             |           | Set Trigger |
| 3 | 3.239      | 0.055             | 0.033           | 0.034      | 0.069             |           | Set Trigger |
| 4 | 3.191      | 0.054             | 0.033           | 0.034      | 0.066             |           | Set Trigger |
| 5 | 3.230      | 0.054             | 0.033           | 0.034      | 0.067             |           | Set Trigger |

AVG 3.21

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/26/08

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 | 3.055      | 0.055             | 0.035           | 0.036      | 0.062             |           | Set Trigger |
| 2 | 3.036      | 0.056             | 0.036           | 0.036      | 0.063             |           | Set Trigger |
| 3 | 3.039      | 0.056             | 0.036           | 0.036      | 0.063             |           | Set Trigger |
| 4 | 3.039      | 0.057             | 0.035           | 0.035      | 0.065             |           | Set Trigger |
| 5 | 3.046      | 0.055             | 0.035           | 0.036      | 0.062             |           | Set Trigger |

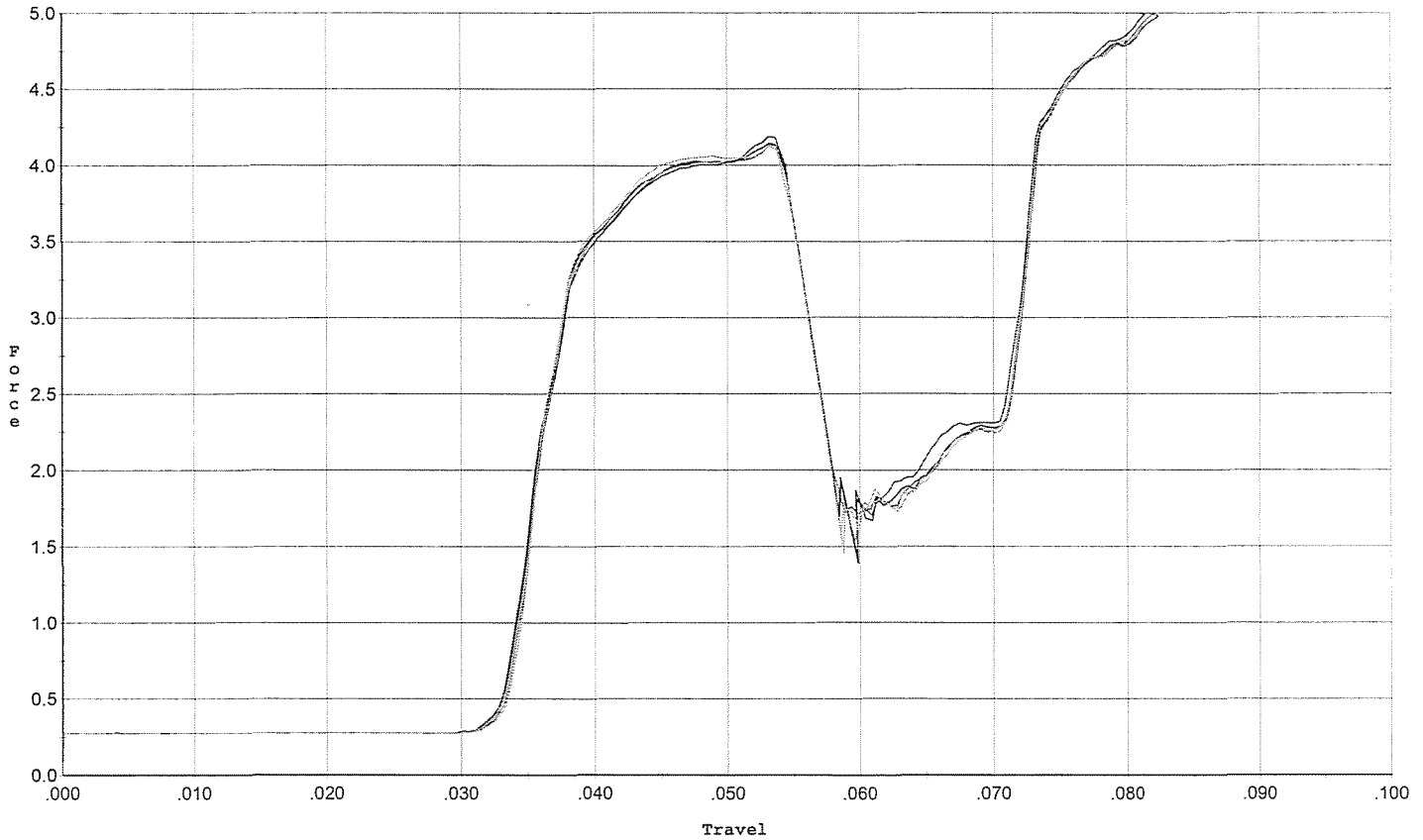
Avg 3.04



## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/26/08

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



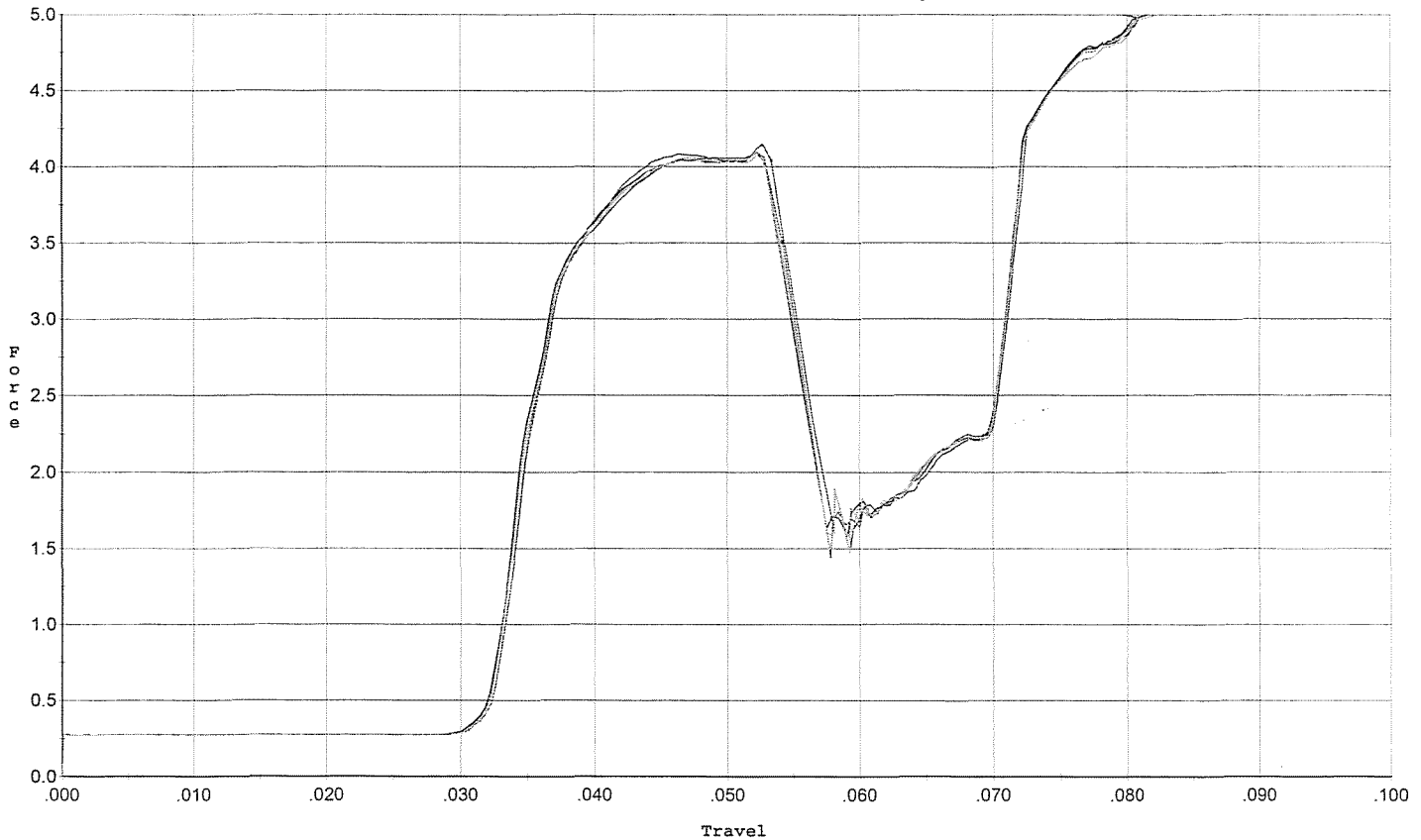
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.188      | 0.054             | 0.033           | 0.033      | 0.086             |           | Set Trigger |
| 2 | 4.144      | 0.054             | 0.033           | 0.033      | 0.086             |           | Set Trigger |
| 3 | 4.131      | 0.054             | 0.033           | 0.033      | 0.085             |           | Set Trigger |
| 4 | 4.125      | 0.055             | 0.033           | 0.033      | 0.086             |           | Set Trigger |
| 5 | 4.129      | 0.055             | 0.033           | 0.033      | 0.086             |           | Set Trigger |

Avg 4.14

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 8/26/08

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



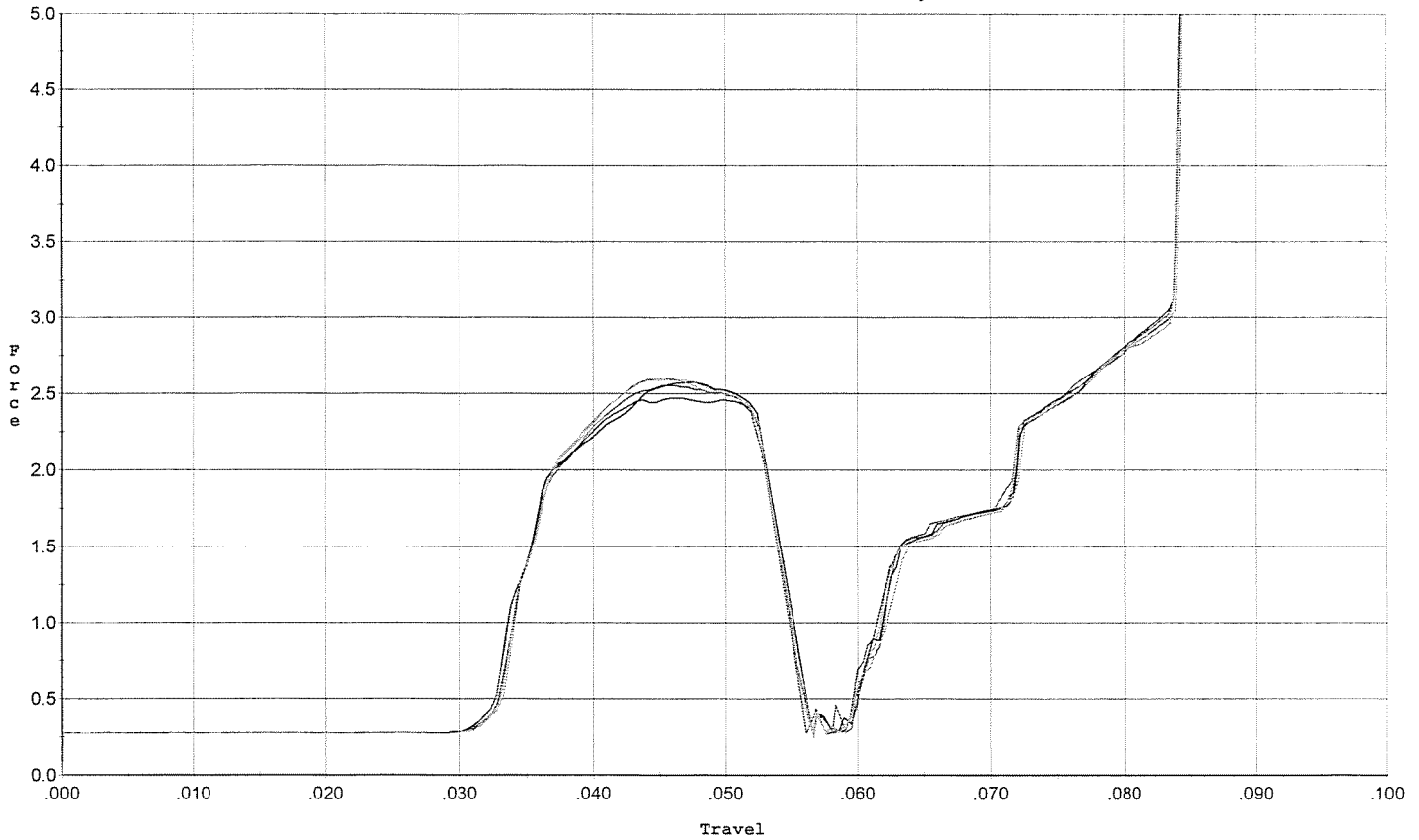
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.150      | 0.053             | 0.032           | 0.033      | 0.085             |           | Set Trigger |
| 2 | 4.101      | 0.053             | 0.032           | 0.033      | 0.084             |           | Set Trigger |
| 3 | 4.099      | 0.054             | 0.032           | 0.033      | 0.086             |           | Set Trigger |
| 4 | 4.101      | 0.055             | 0.032           | 0.033      | 0.088             |           | Set Trigger |
| 5 | 4.077      | 0.055             | 0.032           | 0.033      | 0.086             |           | Set Trigger |

Avg 4.10

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 8/26/08

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



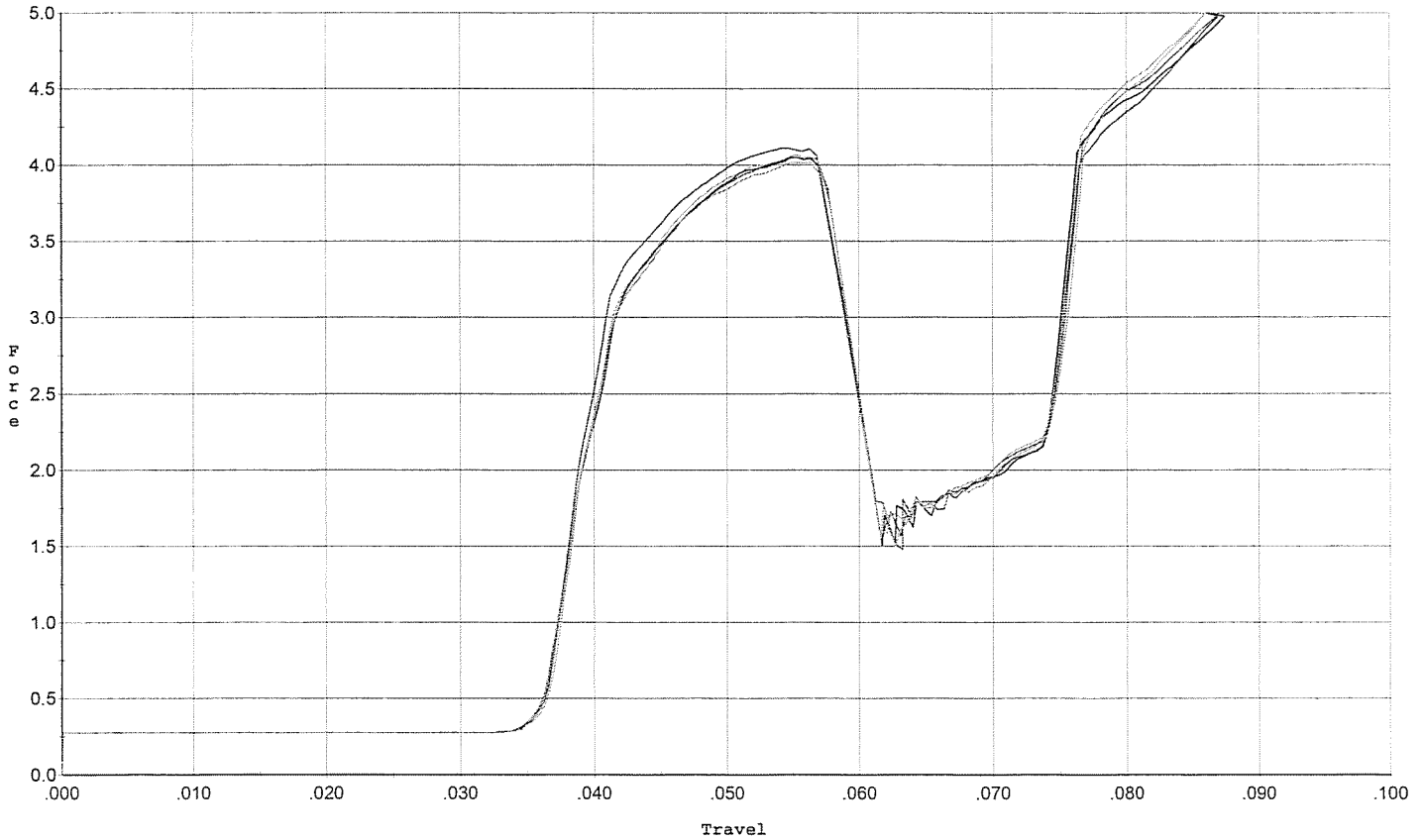
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.470      | 0.053             | 0.033           | 0.036      | 0.053             |           | Set Trigger |
| 2 | 2.576      | 0.054             | 0.033           | 0.035      | 0.055             |           | Set Trigger |
| 3 | 2.553      | 0.053             | 0.033           | 0.036      | 0.054             |           | Set Trigger |
| 4 | 2.594      | 0.052             | 0.033           | 0.036      | 0.053             |           | Set Trigger |
| 5 | 2.601      | 0.053             | 0.033           | 0.036      | 0.054             |           | Set Trigger |

Avg 2.55

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putsch 8/26/08

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 | 4.113      | 0.059             | 0.036           | 0.034      | 0.087             |           | Set Trigger |
| 2 | 4.050      | 0.059             | 0.036           | 0.034      | 0.085             |           | Set Trigger |
| 3 | 4.050      | 0.058             | 0.036           | 0.034      | 0.083             |           | Set Trigger |
| 4 | 4.016      | 0.059             | 0.036           | 0.034      | 0.085             |           | Set Trigger |
| 5 | 4.066      | 0.058             | 0.036           | 0.034      | 0.084             |           | Set Trigger |

Avg 4.05