

6678 9974

**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**

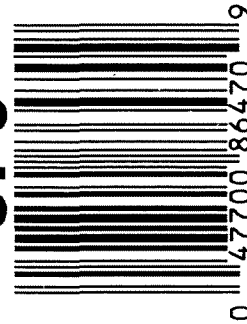
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6789974**

**UPC**



GUN SERIAL # G 6789974

| OP # | OPERATION NAME                                                 | READINGS            | DATE     | INITIAL |
|------|----------------------------------------------------------------|---------------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 12-1-08  | SP      |
| 430  | ASSEMBLE TO STOCK                                              |                     | 12-1-08  | SP      |
| 440  | PROOF                                                          |                     | 12-1-08  | SP      |
| 460  | CHECK HEADSPACE                                                |                     | 12-1-08  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 12-1-08  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                          | MAGNA-FLUX          | 12-2-08  | PSW     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   | 2008                | 12-2-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR            | 12-9-08  | SP      |
| 490  | MAGNAFLUX BOLT                                                 |                     |          |         |
| 500  | ROLLMARK CALIBER                                               |                     | 12/9/08  | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 12/9/08  | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 12/5     |         |
| 545  | (BOLT)                                                         |                     |          |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 12-17-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 12-17-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 12-17-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 1-5-09   | PSW     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |          |         |

F004 REV 5/2006

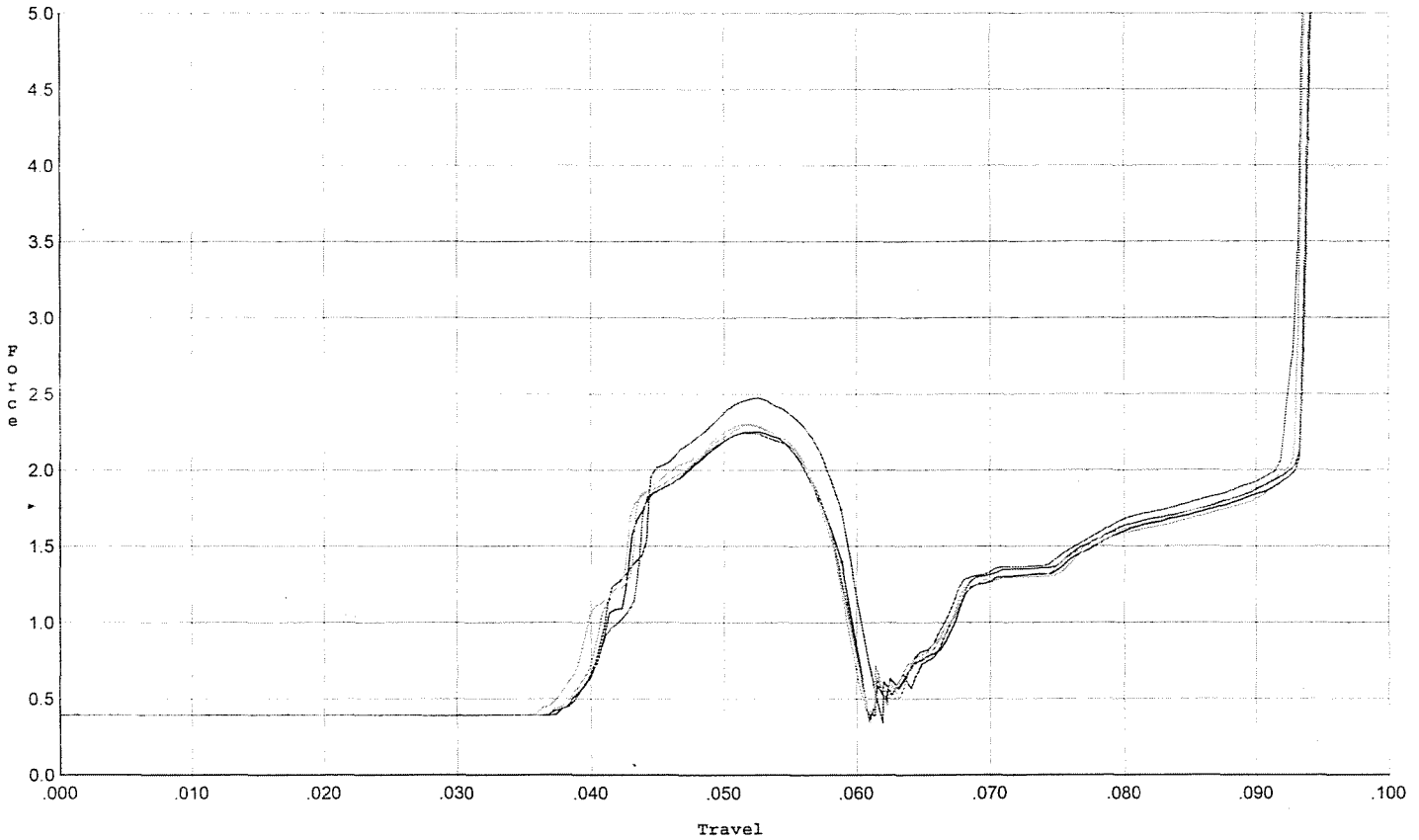
| OP #         | OP                                                                    | BARBER - M24 6071711                      | READINGS                                                    | DATE    | INITIAL |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>4.0</u> <u>5.0</u> <u>4.0</u>                            | 1-6-09  | L N     |
| CONT.        |                                                                       |                                           |                                                             |         |         |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>5.0</u> <u>5.0</u> <u>6.0</u>                            | 1-6-09  | L N     |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |         |         |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.024</u> <u>.024</u> <u>.023</u>                         | 1-6-09  | L N     |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 1-5-09  | RSN     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 1-6-09  | R N     |
|              | 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                        | 1-5-09  | L.P.D.  |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 1-5-09  | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 1-6-09  | L N     |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.66</u> <u>2.66</u> <u>2.58</u> <u>2.64</u> <u>2.56</u> | 1-6-09  | TC      |
|              | C) FUNCTION                                                           |                                           |                                                             | 1-6-09  | L N     |
| 690          | PACK                                                                  |                                           |                                                             | 1/15/09 | FM      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 11/18/2008

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



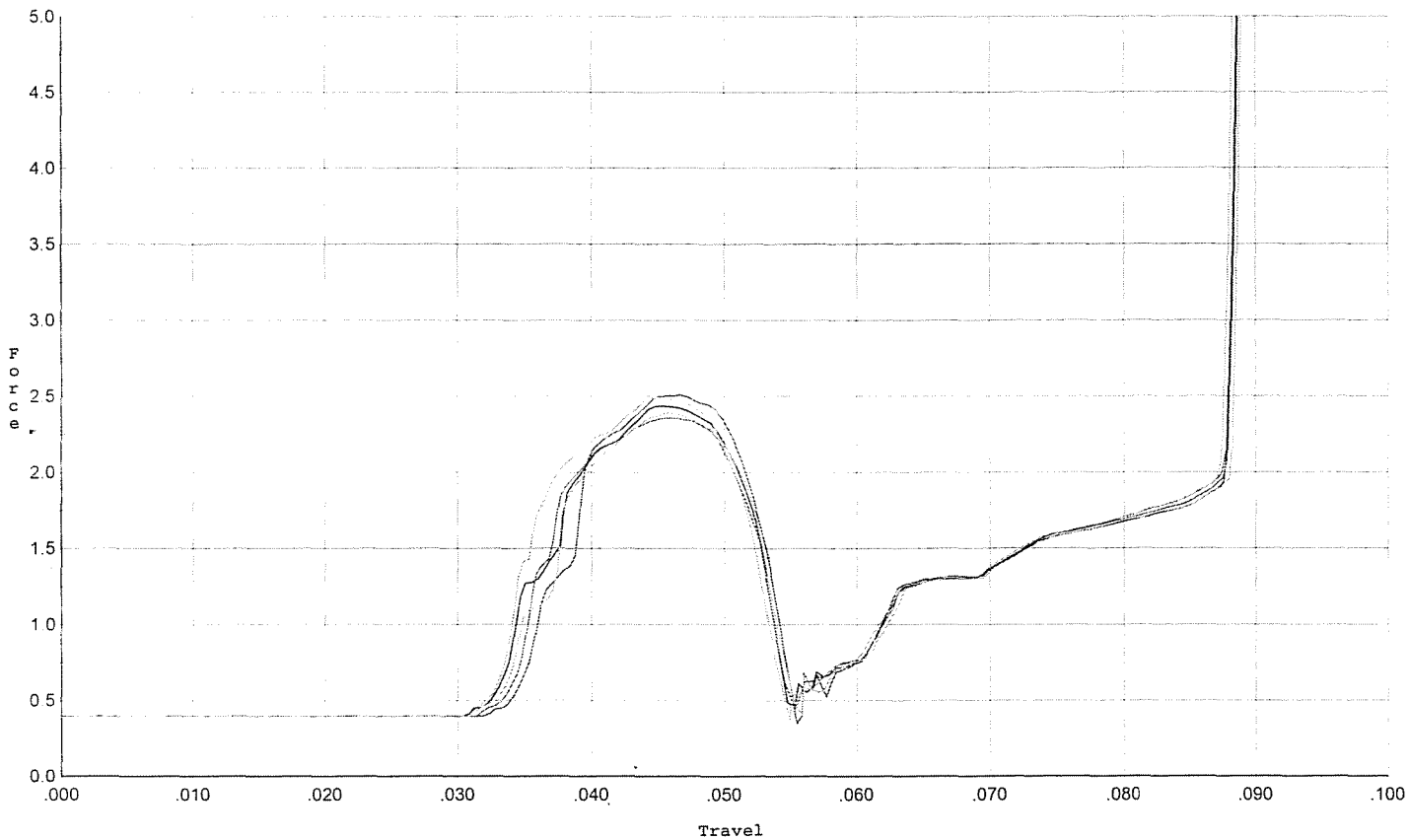
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.474      | 0.059             | 0.039           | 0.041      | 0.054             |           | Set Trigger |
| 2 | 2.255      | 0.059             | 0.039           | 0.041      | 0.051             |           | Set Trigger |
| 3 | 2.246      | 0.059             | 0.039           | 0.041      | 0.051             |           | Set Trigger |
| 4 | 2.305      | 0.058             | 0.040           | 0.042      | 0.051             |           | Set Trigger |
| 5 | 2.298      | 0.058             | 0.039           | 0.041      | 0.052             |           | Set Trigger |

A-2-31

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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



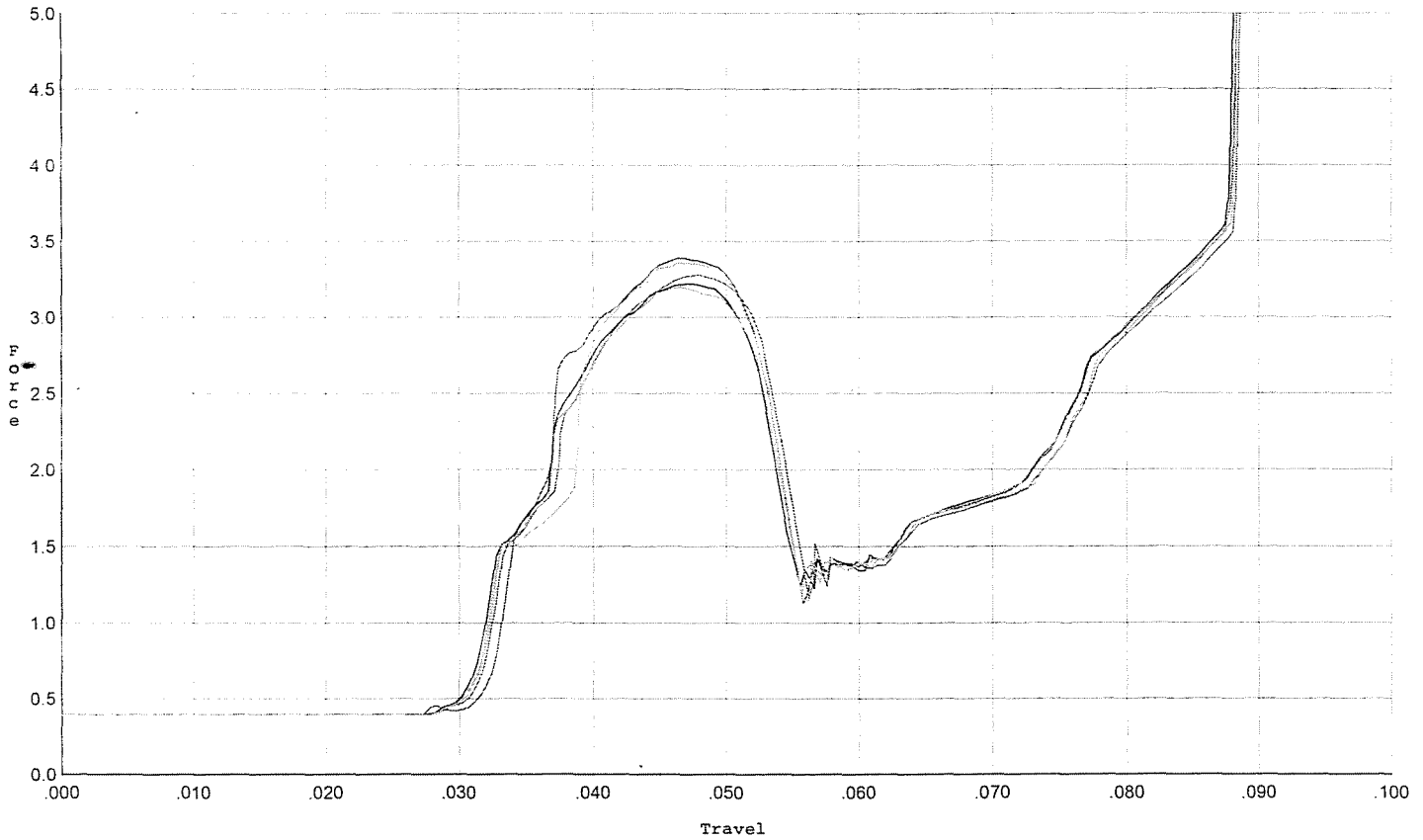
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.509      | 0.053             | 0.034           | 0.040      | 0.051             |           | Set Trigger |
| 2 | 2.437      | 0.052             | 0.033           | 0.040      | 0.051             |           | Set Trigger |
| 3 | 2.358      | 0.053             | 0.034           | 0.040      | 0.050             |           | Set Trigger |
| 4 | 2.397      | 0.052             | 0.034           | 0.040      | 0.050             |           | Set Trigger |
| 5 | 2.494      | 0.052             | 0.033           | 0.040      | 0.052             |           | Set Trigger |

A-2-43

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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



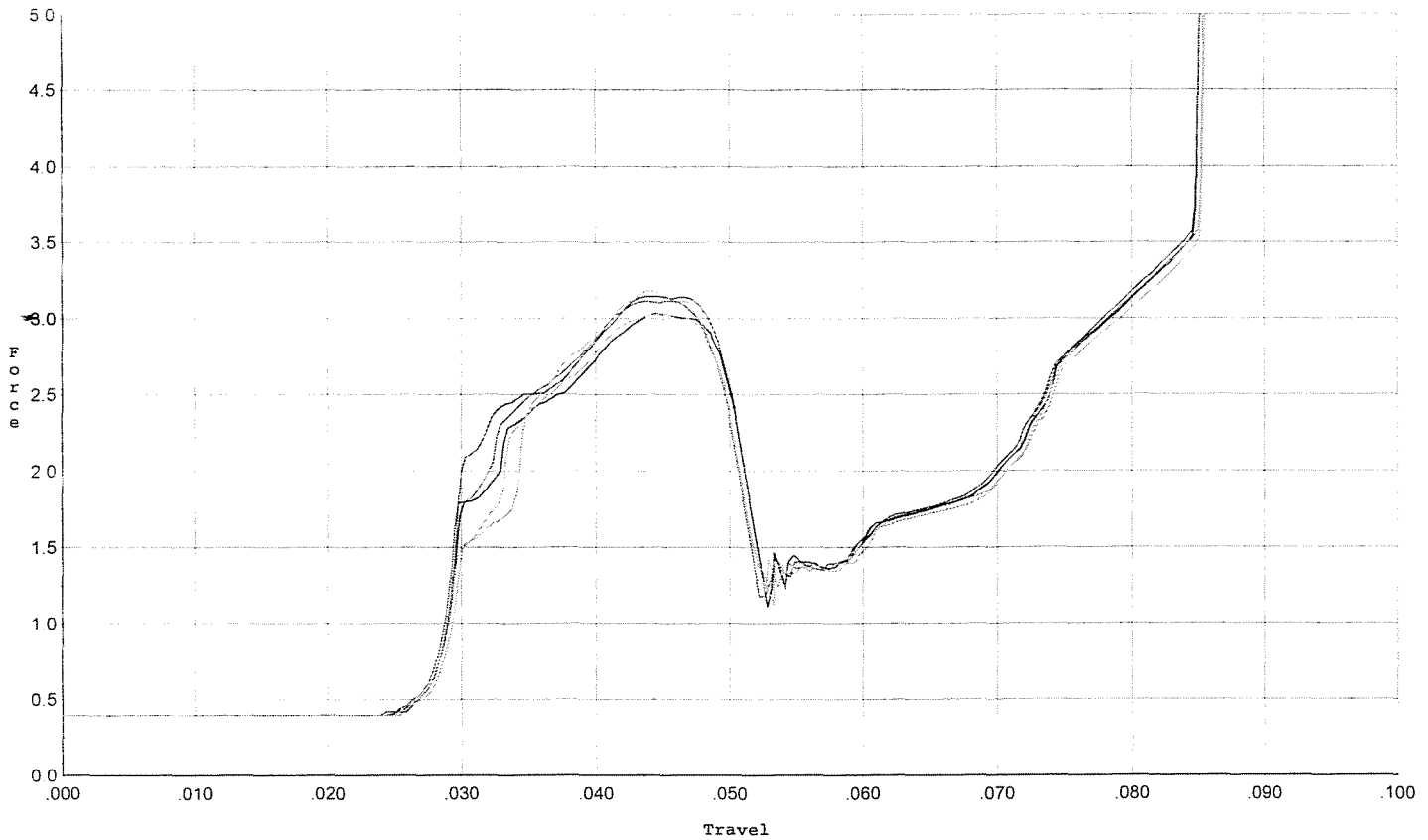
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.394      | 0.053             | 0.032           | 0.037      | 0.071             |           | Set Trigger |
| 2 | 3.222      | 0.052             | 0.031           | 0.038      | 0.068             |           | Set Trigger |
| 3 | 3.281      | 0.054             | 0.031           | 0.038      | 0.071             |           | Set Trigger |
| 4 | 3.357      | 0.053             | 0.031           | 0.038      | 0.069             |           | Set Trigger |
| 5 | 3.196      | 0.054             | 0.031           | 0.037      | 0.069             |           | Set Trigger |

A-3-29

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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



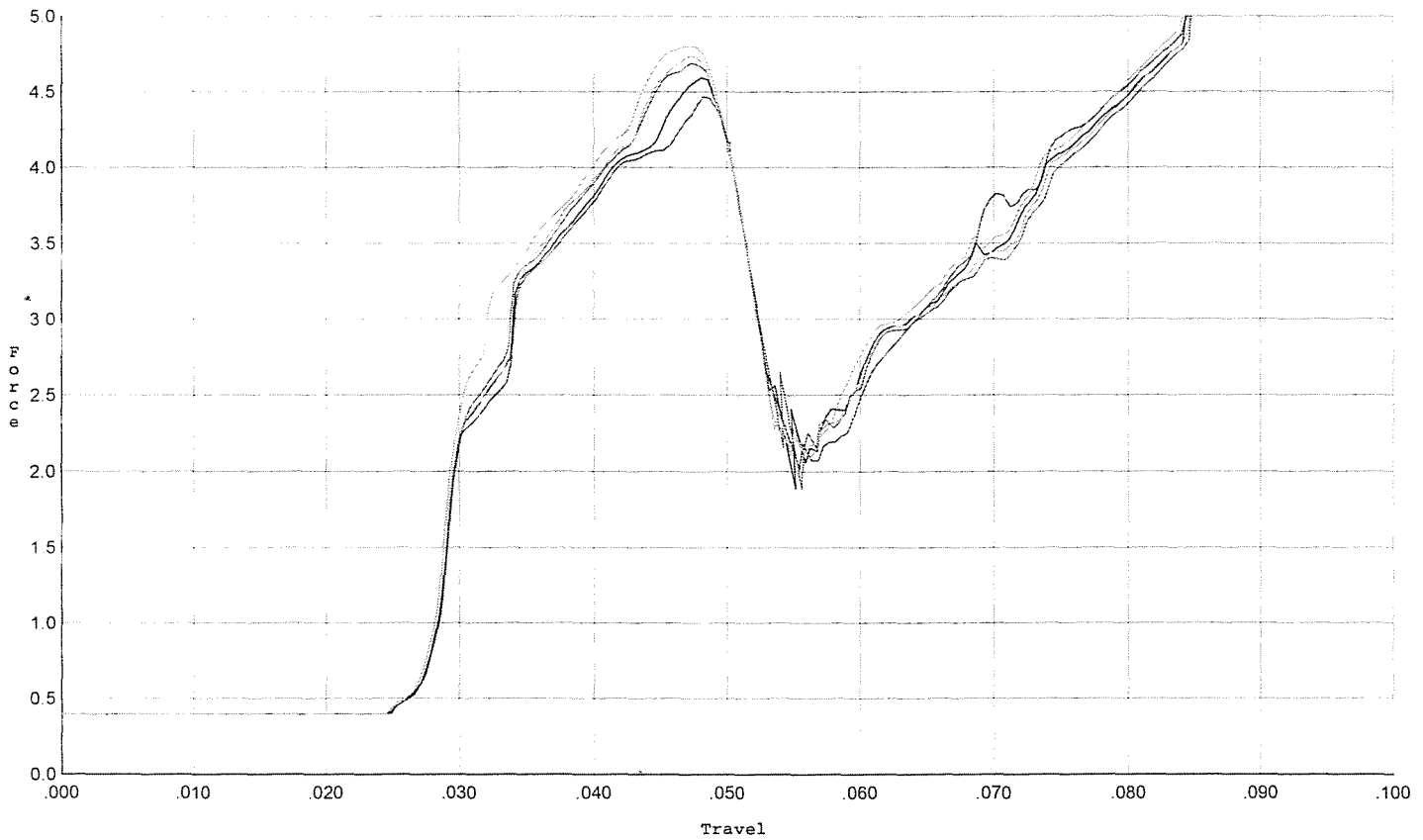
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.145      | 0.050             | 0.028           | 0.037      | 0.069             |           | Set Trigger |
| 2 | 3.031      | 0.050             | 0.028           | 0.037      | 0.067             |           | Set Trigger |
| 3 | 3.116      | 0.050             | 0.028           | 0.037      | 0.067             |           | Set Trigger |
| 4 | 3.034      | 0.050             | 0.028           | 0.038      | 0.064             |           | Set Trigger |
| 5 | 3.181      | 0.050             | 0.028           | 0.037      | 0.065             |           | Set Trigger |

A-3-10

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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



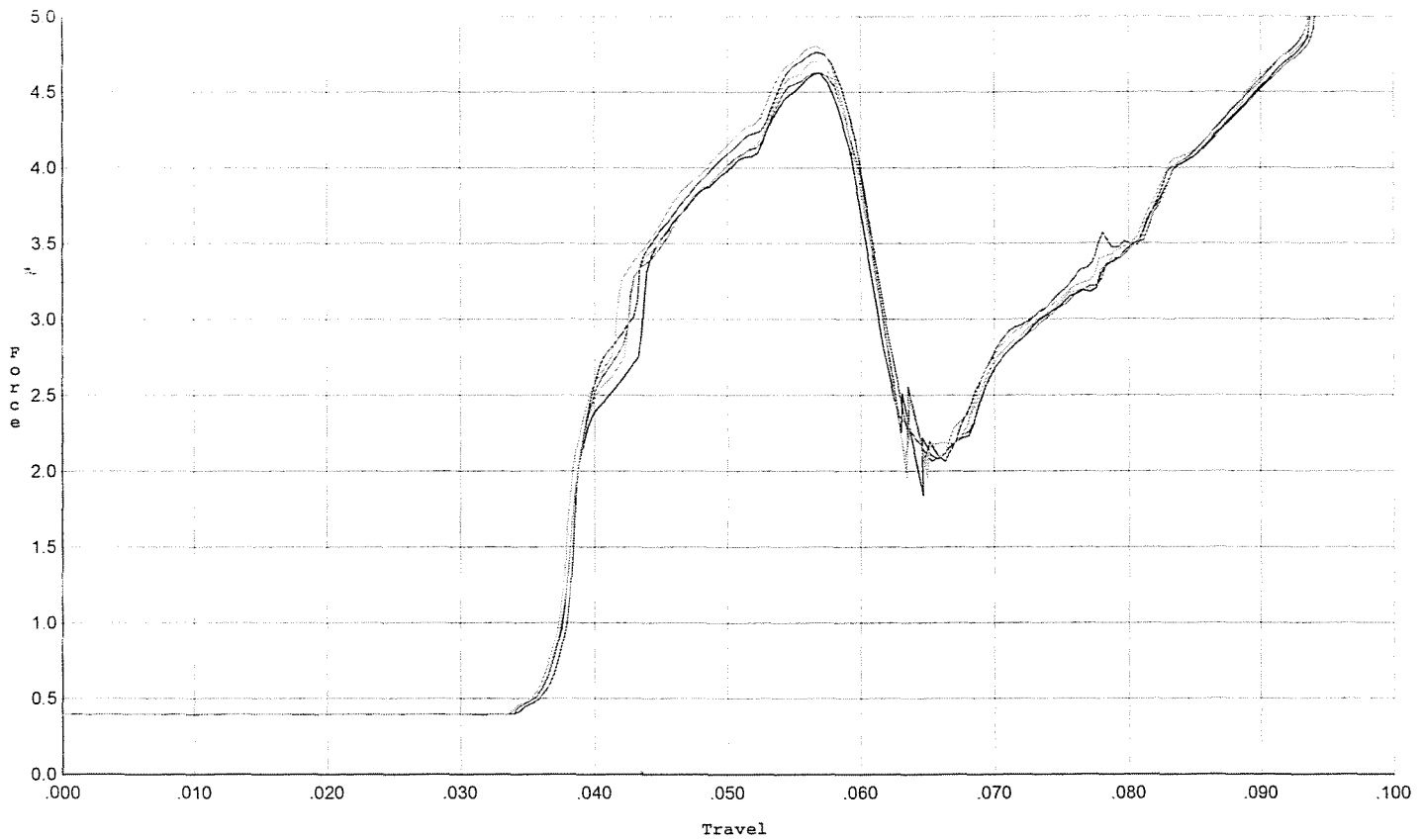
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.468      | 0.050             | 0.027           | 0.034      | 0.090             |           | Set Trigger |
| 2 | 4.595      | 0.050             | 0.027           | 0.033      | 0.092             |           | Set Trigger |
| 3 | 4.691      | 0.050             | 0.027           | 0.034      | 0.093             |           | Set Trigger |
| 4 | 4.802      | 0.050             | 0.027           | 0.033      | 0.097             |           | Set Trigger |
| 5 | 4.737      | 0.050             | 0.027           | 0.034      | 0.094             |           | Set Trigger |

A-4.65

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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



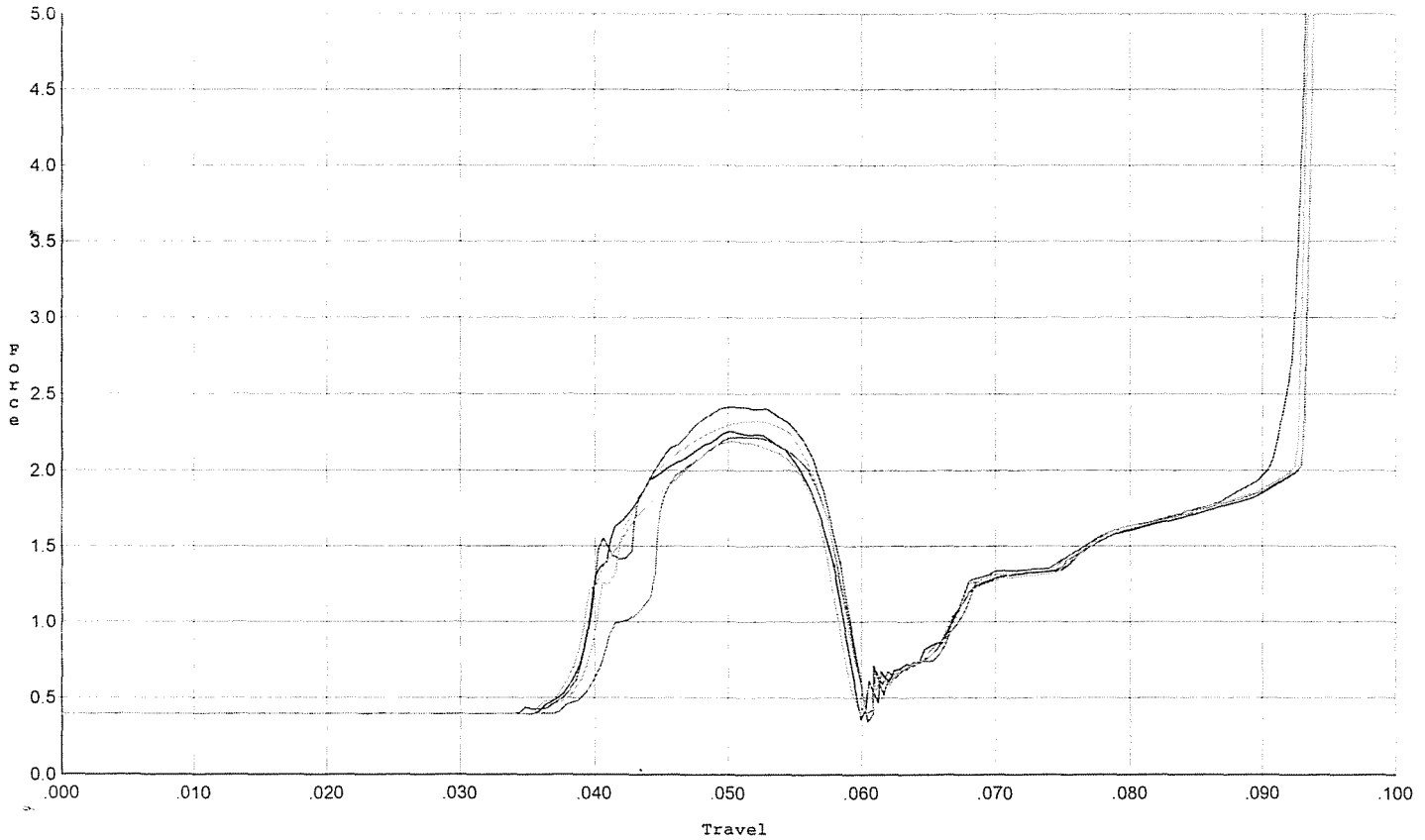
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.764      | 0.060             | 0.037           | 0.037      | 0.101             |           | Set Trigger |
| 2 | 4.628      | 0.059             | 0.037           | 0.037      | 0.097             |           | Set Trigger |
| 3 | 4.630      | 0.060             | 0.037           | 0.037      | 0.100             |           | Set Trigger |
| 4 | 4.704      | 0.060             | 0.036           | 0.037      | 0.101             |           | Set Trigger |
| 5 | 4.805      | 0.061             | 0.036           | 0.036      | 0.104             |           | Set Trigger |

A-4-70

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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

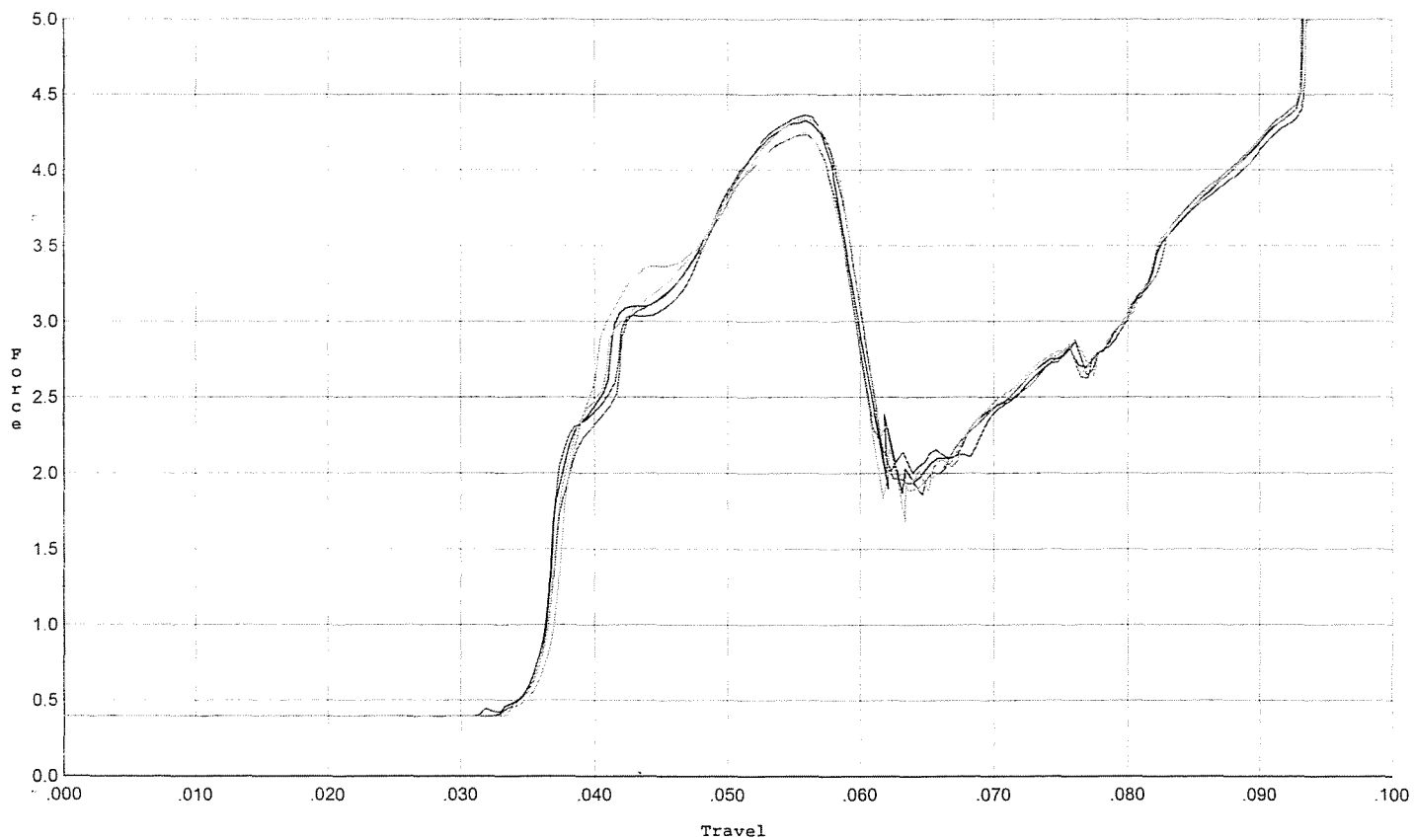


| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.417      | 0.058             | 0.039           | 0.040      | 0.055             |           | Set Trigger |
| 2 | 2.256      | 0.058             | 0.039           | 0.041      | 0.052             |           | Set Trigger |
| 3 | 2.220      | 0.059             | 0.040           | 0.041      | 0.049             |           | Set Trigger |
| 4 | 2.322      | 0.057             | 0.039           | 0.042      | 0.052             |           | Set Trigger |
| 5 | 2.191      | 0.057             | 0.038           | 0.041      | 0.050             |           | Set Trigger |

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 11/18/2008

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 | 4.364      | 0.059             | 0.036           | 0.037      | 0.093             |           | Set Trigger |
| 2 | 4.329      | 0.058             | 0.035           | 0.037      | 0.091             |           | Set Trigger |
| 3 | 4.232      | 0.058             | 0.036           | 0.037      | 0.090             |           | Set Trigger |
| 4 | 4.251      | 0.059             | 0.035           | 0.037      | 0.091             |           | Set Trigger |
| 5 | 4.339      | 0.059             | 0.036           | 0.037      | 0.094             |           | Set Trigger |

A-4.30