

G6794527

**M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)**  
**BOLT ACTION CENTERFIRE RIFLE**  
**24" BARREL 7.62 NATO**

- INSTRUCTION BOOK 3518

**BM FORM**

proof of purchase

owner registration sticker



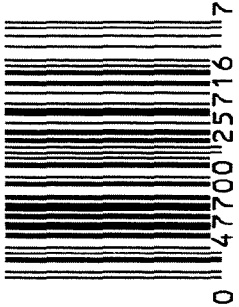
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6794527**

**UPC**



GUN SERIAL #

G 6794527

| OP # | OPERATION NAME                                                 | READINGS            | DATE     | INITIAL |
|------|----------------------------------------------------------------|---------------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 9-30-08  | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                     | 9-30-08  | SP      |
| 440  | PROOF                                                          |                     | 9-30-08  | SPD     |
| 460  | CHECK HEADSPACE                                                |                     | 9-30-08  | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 9-30-08  | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 10-1-08  | PSH     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 10-1-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           |                     | 10/2/08  | SP      |
| 490  | MAGNAFLUX BOLT                                                 |                     |          |         |
| 500  | ROLLMARK CALIBER                                               |                     | 10/2/08  | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     | 10/3/08  | DB      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 10-8     |         |
| 545  | (BOLT)                                                         |                     |          |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 10-9-08  | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 10-9-08  | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 10-9-08  | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 10-28-08 | SPD     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |          |         |

F004 REV 5/2006

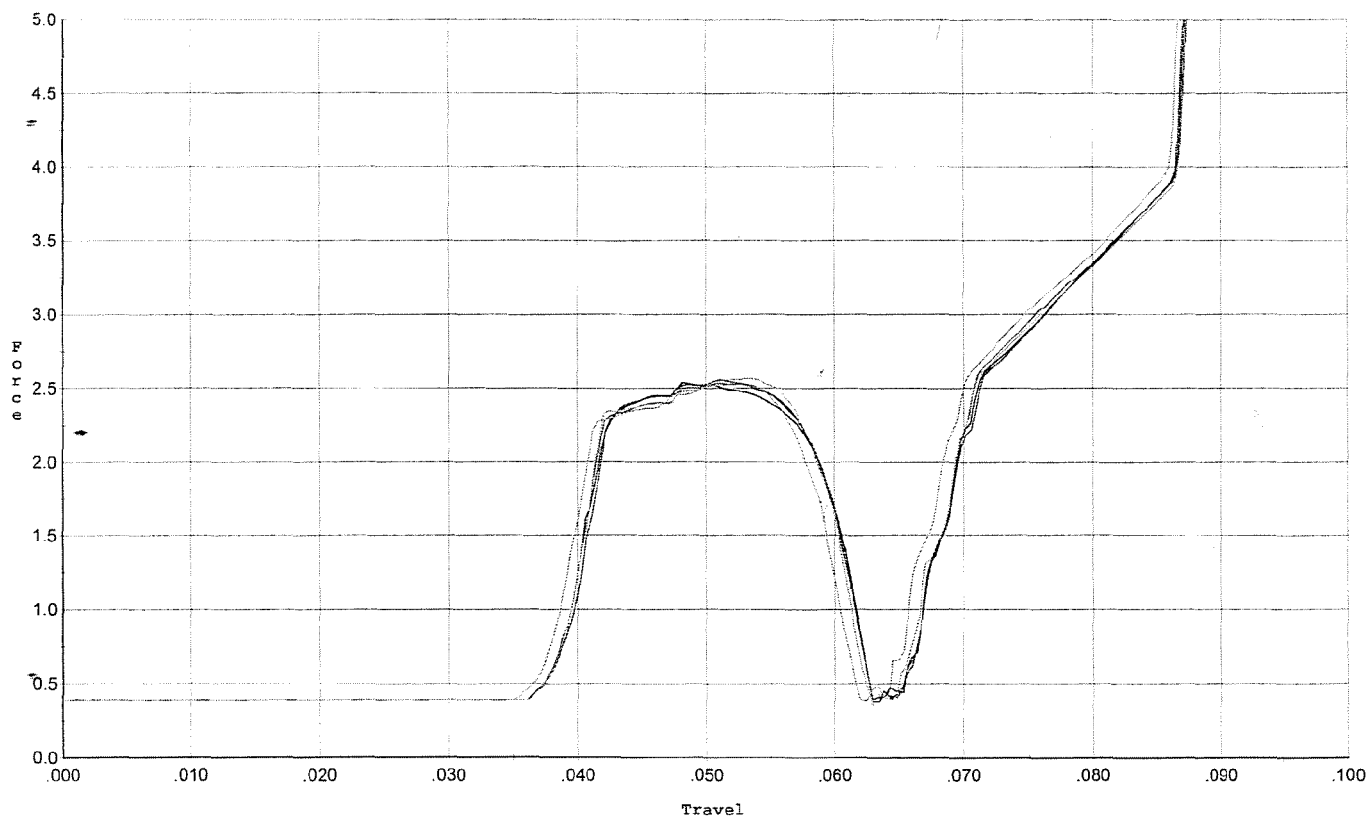
| OP #         | OPERATION NAME                                                           | READINGS                             | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|--------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | 4.0 4.0 3.0                          | 10-30-08 | L. J.   |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | 6.0 6.0 5.0                          | 10-30-08 | L. J.   |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                      |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | .023 .023 .023                       | 10-30-08 | L. J.   |
|              | J) ASSEMBLE STOCK                                                        |                                      | 10-28-08 | L. J.   |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                      | 10-30-08 | L. J.   |
|              | 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 | 10-29-08 | L. J.   |
|              | MALFUNCTION                                                              | CORRECTION                           |          |         |
|              | MALFUNCTION                                                              | CORRECTION                           |          |         |
|              | MALFUNCTION                                                              | CORRECTION NA                        |          |         |
|              | MALFUNCTION                                                              | CORRECTION                           |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                      | 10-30-08 | L. J.   |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                      | 10-30-08 | L. J.   |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | 2.60 2.63 2.61 2.61 2.60             | 10-30-08 | L. J.   |
|              | C) FUNCTION                                                              |                                      | 10-30-08 | L. J.   |
| 690          | PACK                                                                     |                                      | 10/31/08 | Em      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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



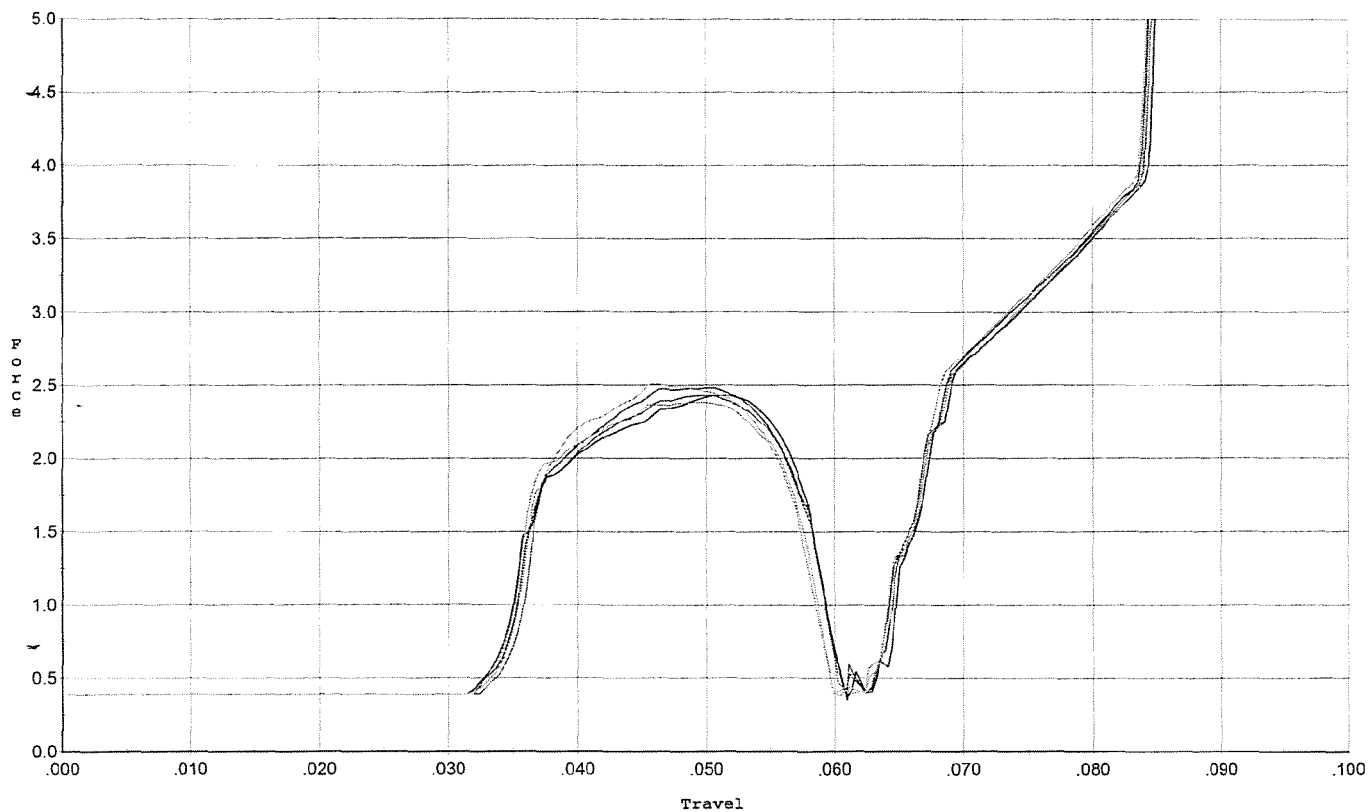
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.559      | 0.061             | 0.038           | 0.033      | 0.064             |           | Set Trigger |
| 2 | 2.537      | 0.061             | 0.038           | 0.033      | 0.064             |           | Set Trigger |
| 3 | 2.534      | 0.061             | 0.038           | 0.033      | 0.064             |           | Set Trigger |
| 4 | 2.565      | 0.060             | 0.038           | 0.034      | 0.063             |           | Set Trigger |
| 5 | 2.534      | 0.059             | 0.037           | 0.034      | 0.062             |           | Set Trigger |

A-0.54

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/22/2008

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



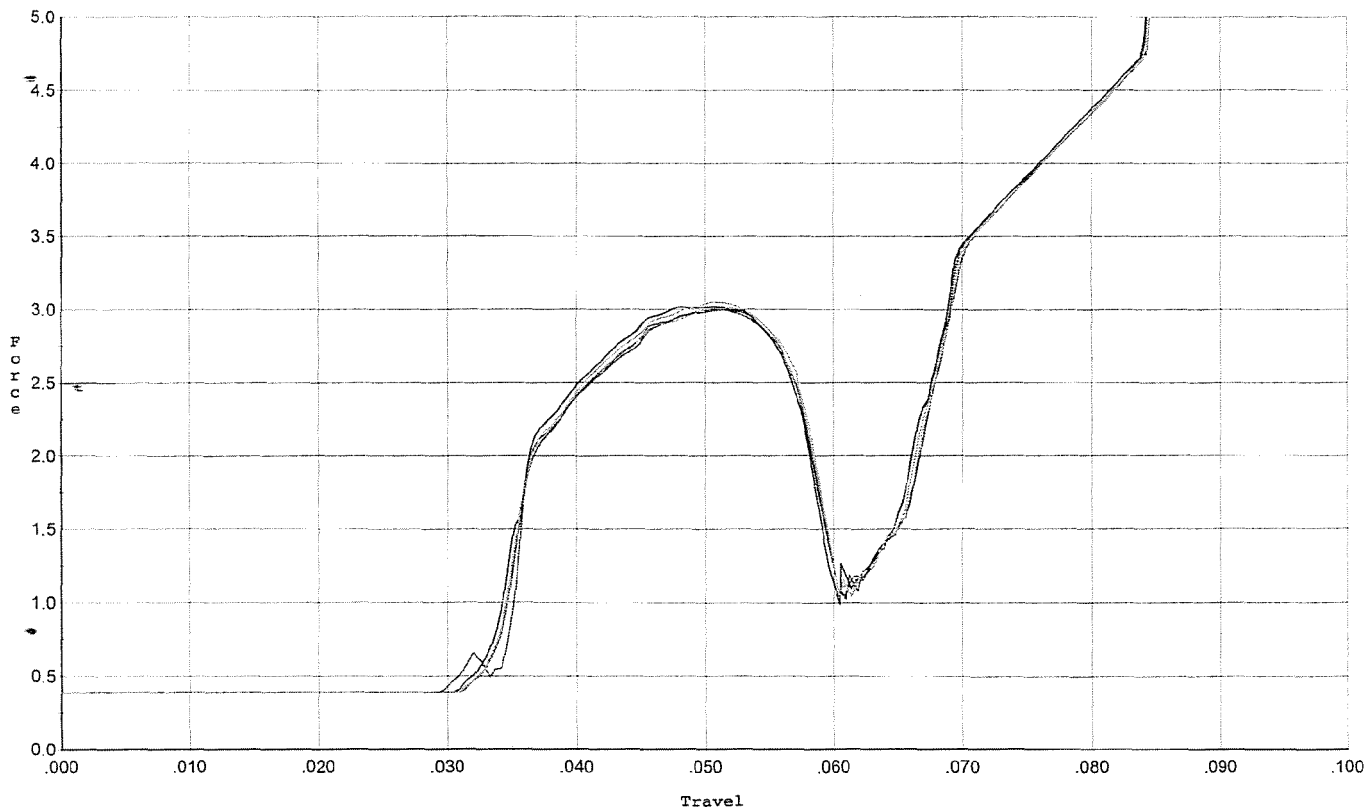
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.480      | 0.058             | 0.034           | 0.033      | 0.064             |           | Set Trigger |
| 2 | 2.431      | 0.058             | 0.034           | 0.033      | 0.063             |           | Set Trigger |
| 3 | 2.430      | 0.058             | 0.034           | 0.033      | 0.062             |           | Set Trigger |
| 4 | 2.509      | 0.058             | 0.034           | 0.033      | 0.063             |           | Set Trigger |
| 5 | 2.380      | 0.057             | 0.034           | 0.034      | 0.061             |           | Set Trigger |

A-2.44

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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



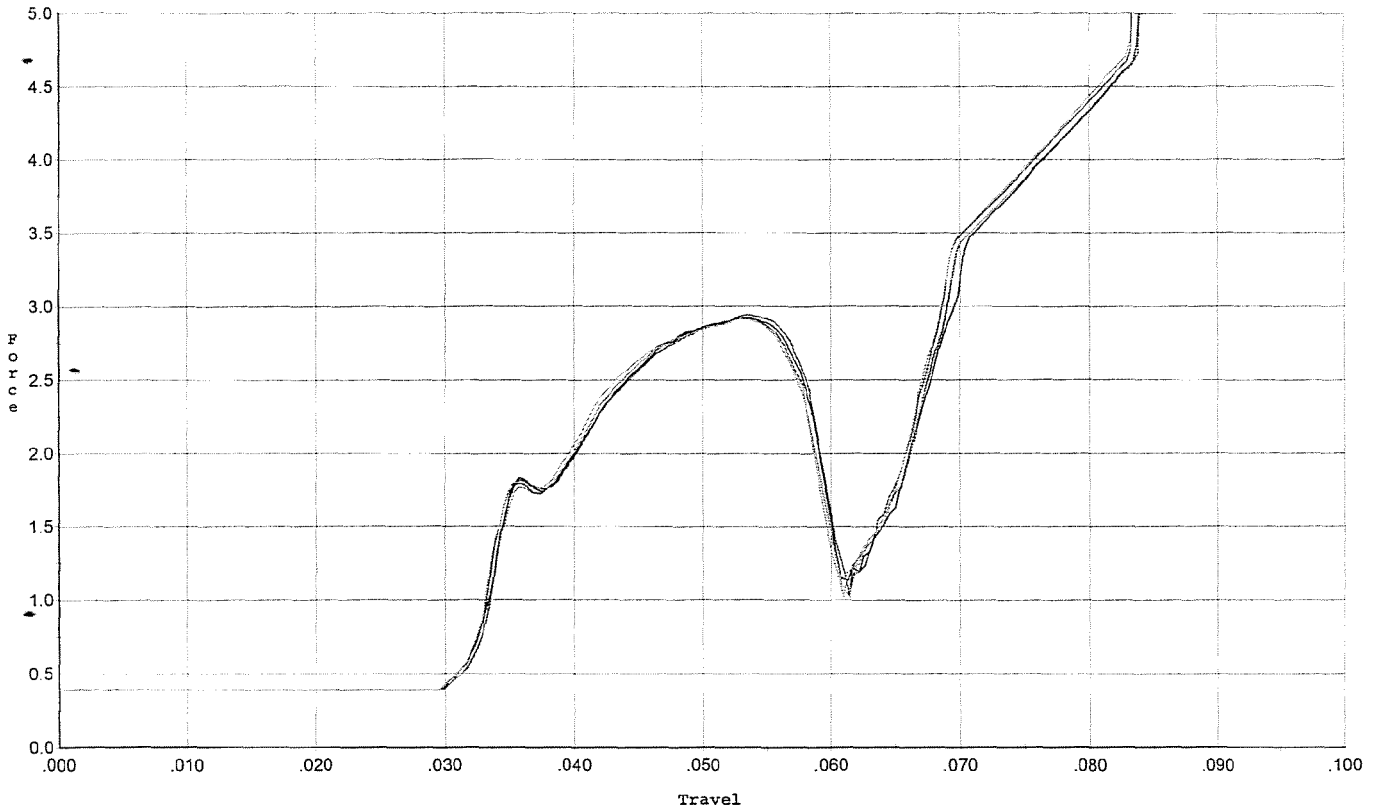
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.000      | 0.057             | 0.032           | 0.032      | 0.074             |           | Set Trigger |
| 2 | 3.019      | 0.058             | 0.033           | 0.032      | 0.076             |           | Set Trigger |
| 3 | 2.999      | 0.059             | 0.033           | 0.032      | 0.076             |           | Set Trigger |
| 4 | 3.050      | 0.058             | 0.033           | 0.032      | 0.077             |           | Set Trigger |
| 5 | 3.015      | 0.058             | 0.033           | 0.032      | 0.076             |           | Set Trigger |

A-3-01

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/22/2008

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



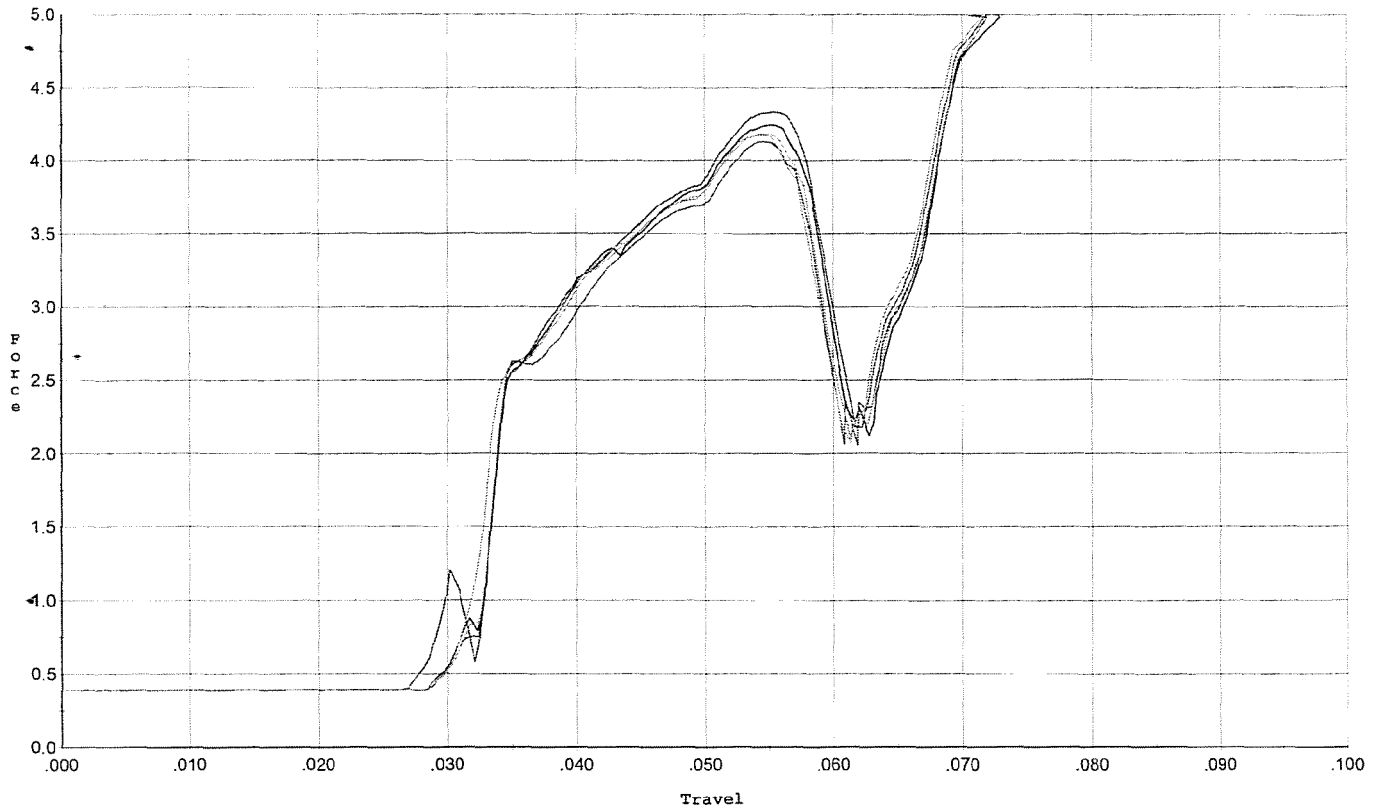
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.944      | 0.058             | 0.032           | 0.031      | 0.074             |           | Set Trigger |
| 2 | 2.922      | 0.059             | 0.032           | 0.031      | 0.074             |           | Set Trigger |
| 3 | 2.917      | 0.058             | 0.032           | 0.031      | 0.073             |           | Set Trigger |
| 4 | 2.915      | 0.059             | 0.032           | 0.031      | 0.075             |           | Set Trigger |
| 5 | 2.915      | 0.058             | 0.032           | 0.031      | 0.074             |           | Set Trigger |

A-292

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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



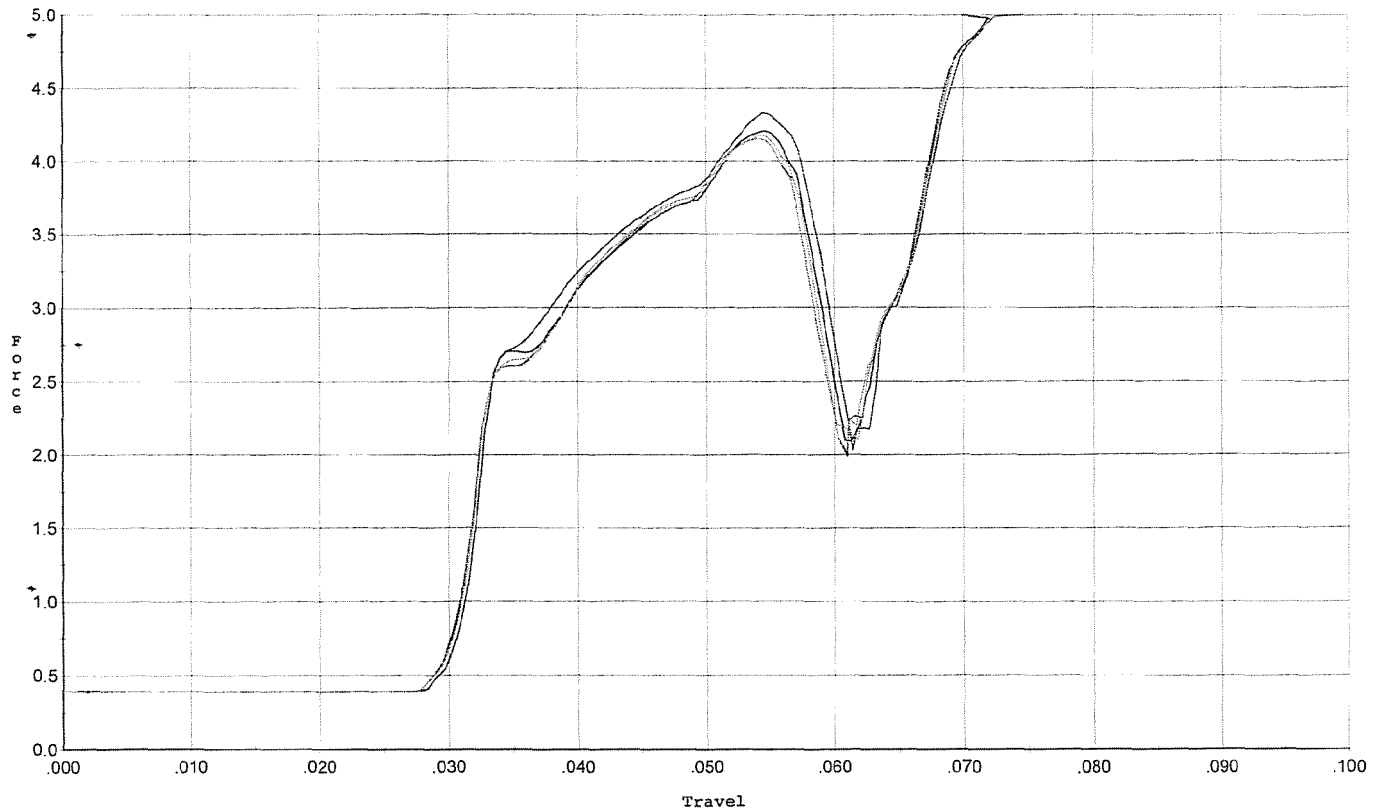
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.333      | 0.058             | 0.027           | 0.025      | 0.105             |           | Set Trigger |
| 2 | 4.242      | 0.058             | 0.031           | 0.026      | 0.103             |           | Set Trigger |
| 3 | 4.128      | 0.058             | 0.031           | 0.026      | 0.099             |           | Set Trigger |
| 4 | 4.184      | 0.058             | 0.031           | 0.026      | 0.101             |           | Set Trigger |
| 5 | 4.176      | 0.059             | 0.031           | 0.025      | 0.103             |           | Set Trigger |

4.21

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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



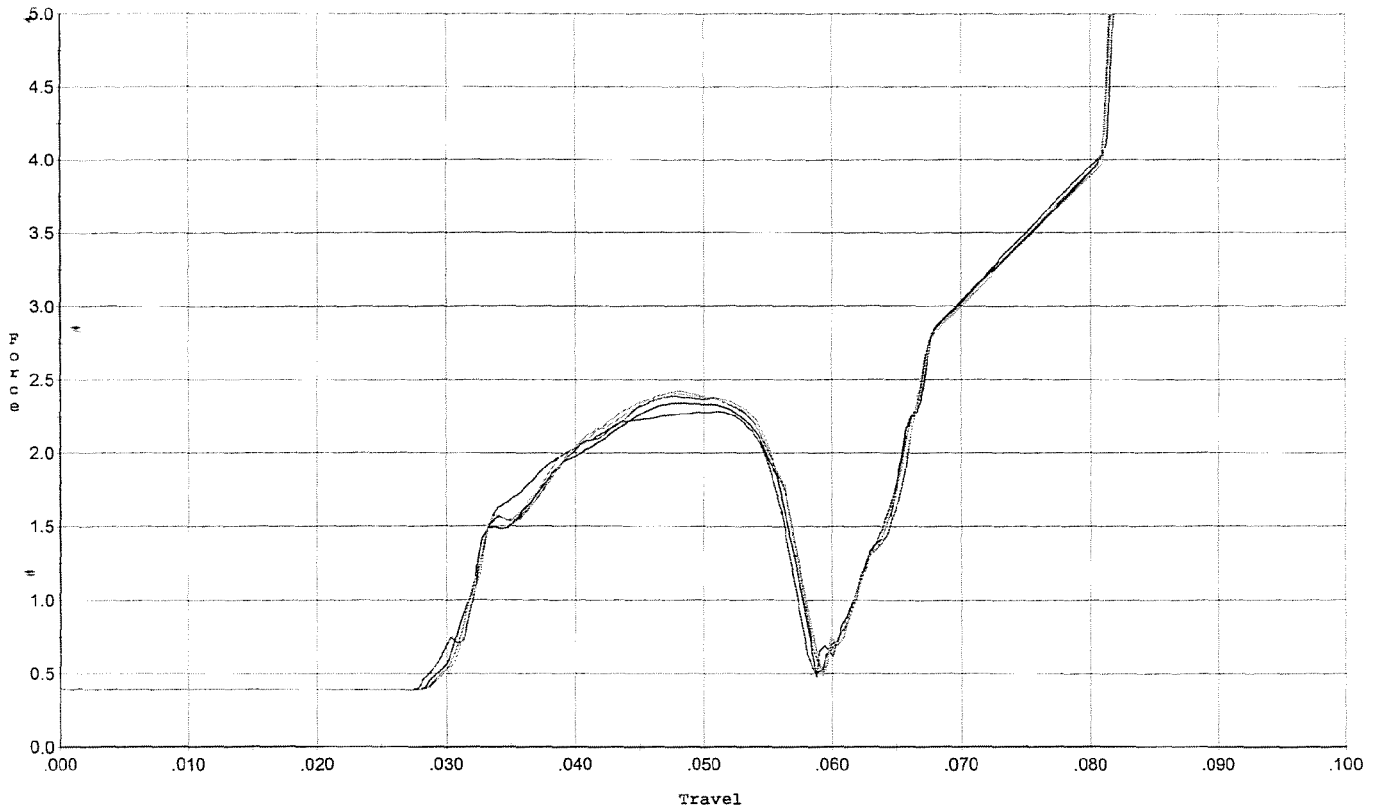
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.333      | 0.059             | 0.028           | 0.027      | 0.109             |           | Set Trigger |
| 2 | 4.209      | 0.059             | 0.030           | 0.027      | 0.105             |           | Set Trigger |
| 3 | 4.154      | 0.057             | 0.030           | 0.028      | 0.100             |           | Set Trigger |
| 4 | 4.178      | 0.057             | 0.030           | 0.026      | 0.102             |           | Set Trigger |
| 5 | 4.155      | 0.057             | 0.030           | 0.027      | 0.100             |           | Set Trigger |

A-4-20

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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



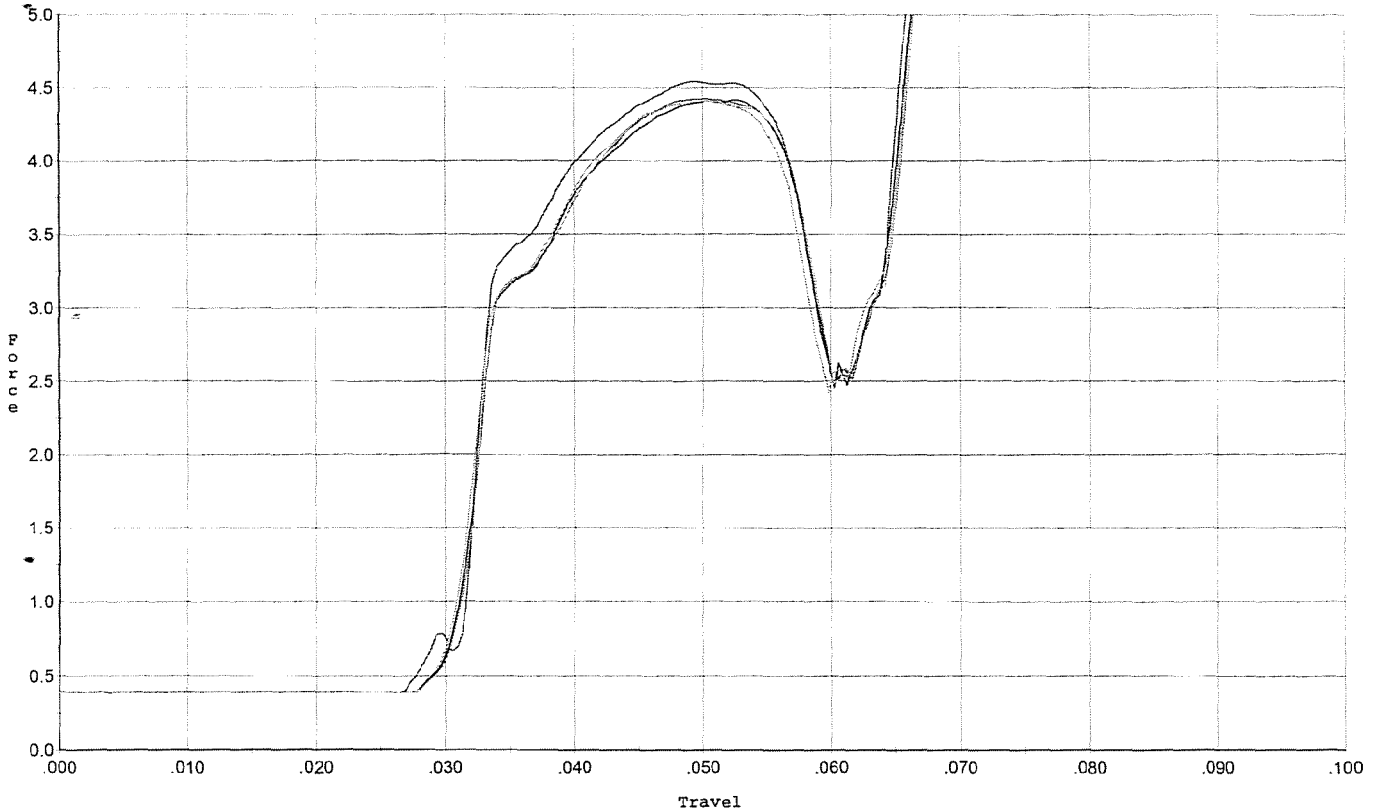
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.281      | 0.056             | 0.028           | 0.032      | 0.062             |           | Set Trigger |
| 2 | 2.339      | 0.057             | 0.030           | 0.031      | 0.063             |           | Set Trigger |
| 3 | 2.391      | 0.056             | 0.031           | 0.031      | 0.063             |           | Set Trigger |
| 4 | 2.405      | 0.056             | 0.031           | 0.031      | 0.063             |           | Set Trigger |
| 5 | 2.420      | 0.056             | 0.031           | 0.031      | 0.064             |           | Set Trigger |

A-2-36

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/22/2008

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 | 4.542      | 0.057             | 0.027           | 0.013      | 0.116             |           | Set Trigger |
| 2 | 4.417      | 0.057             | 0.028           | 0.013      | 0.112             |           | Set Trigger |
| 3 | 4.426      | 0.057             | 0.030           | 0.013      | 0.112             |           | Set Trigger |
| 4 | 4.412      | 0.058             | 0.030           | 0.013      | 0.115             |           | Set Trigger |
| 5 | 4.408      | 0.057             | 0.030           | 0.013      | 0.111             |           | Set Trigger |

A-4.44