

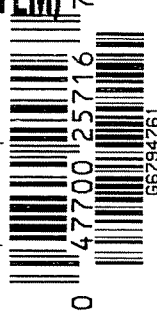
66794761

**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



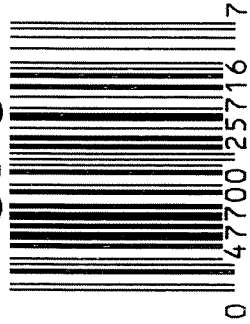
ORDER NO. **25716**

BARREL LENGTH **24"**

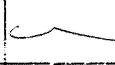
CAPACITY **6**

**G6794761**

**UPC**



GUN SERIAL # G 6794761

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                     | DATE     | INITIAL                                                                               |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|----------|---------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                              | 10-7-08  | SP                                                                                    |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                              | 10-7-08  | SP                                                                                    |
| 440  | PROOF                                                                                                                                  |                                                                                              | 10-7-08  | SP                                                                                    |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                              | 10-7-08  | SP                                                                                    |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                              | 10-7-08  | SP                                                                                    |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNAFLUX                                                                                    | 10-8-08  | PSW                                                                                   |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                              | 10-8-08  | SP                                                                                    |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 10/11/08 |    |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                              |          |                                                                                       |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                              | 10/13/08 | RT                                                                                    |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                              |          |                                                                                       |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                              | 10-21    |  |
| 545  | (BOLT)                                                                                                                                 |                                                                                              |          |                                                                                       |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                              |          |                                                                                       |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                              | 10-21-08 | SP                                                                                    |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                              | 10-21-08 | SP                                                                                    |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                              | 10-21-08 | SP                                                                                    |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                              | 10-21-08 | RT                                                                                    |
|      | 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> |                                                                                              |          |                                                                                       |

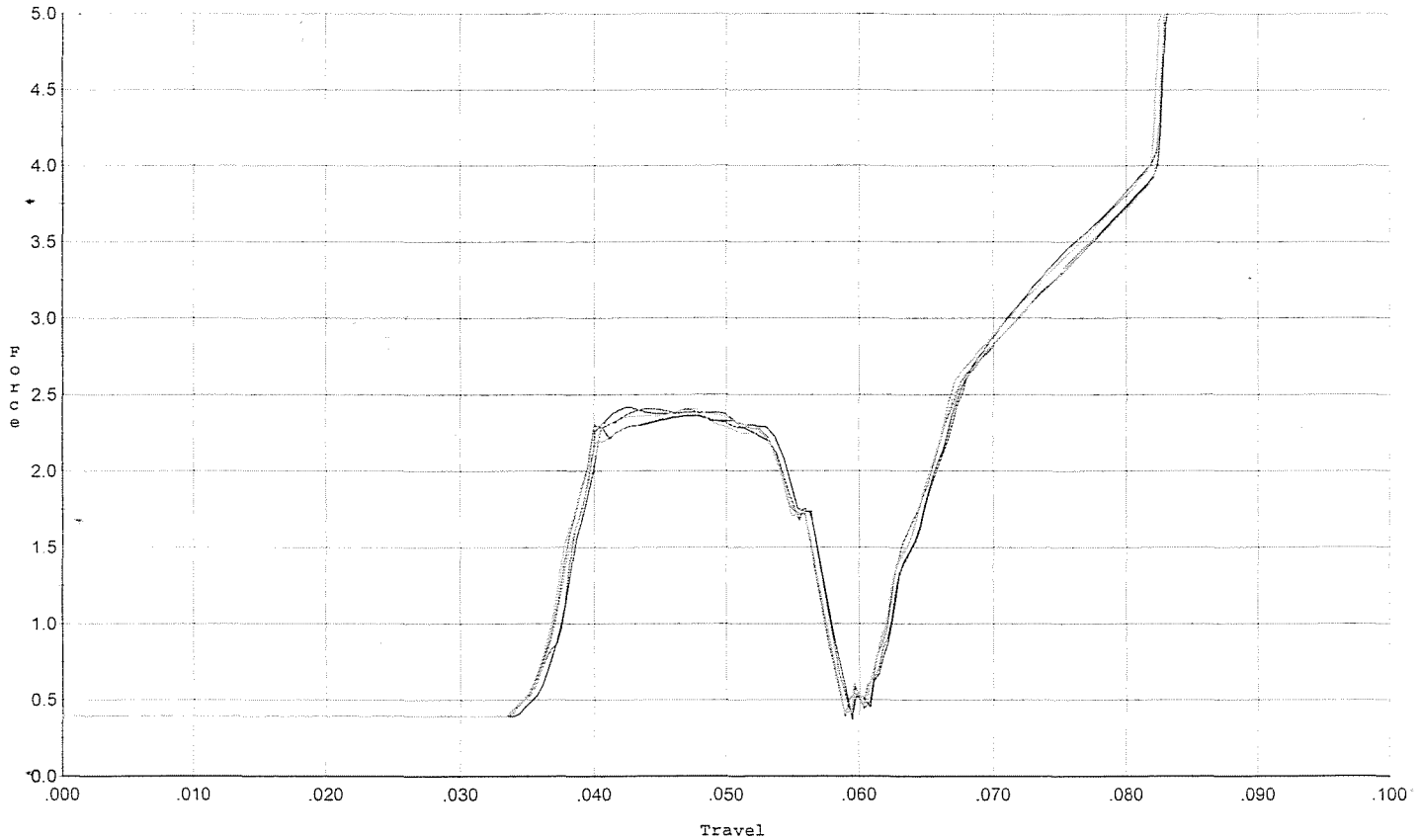
F004 REV 5/2006

|              |                                                                       |                                           |                                                             |          |      |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------------------------------------------------------|----------|------|
| 560          | F) SAFETY ON FORCE                                                    | 2 LBS MIN<br>10 LBS MAX                   | <u>3.0</u> <u>3.0</u> <u>4.0</u>                            | 11-11-08 | L.D. |
| CONT.        |                                                                       |                                           |                                                             |          |      |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>4.0</u> <u>4.0</u> <u>4.5</u>                            | 11-11-08 | L.D. |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                             |          |      |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.093</u> <u>.093</u> <u>.093</u>                         | 11-11-08 | L.D. |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                             | 10-21-08 | RTL  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                             | 11-11-08 | L.D. |
|              | 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                                           |                                           | PASS PASS FAIL FAIL                                         | 10-30-08 | RSA  |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |          |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |          |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |          |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                  |          |      |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                             | 10-30-08 | TL   |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                             | 11-11-08 | L.D. |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.14</u> <u>2.06</u> <u>2.13</u> <u>2.08</u> <u>2.10</u> | 11/5/08  | F.M. |
|              | C) FUNCTION                                                           |                                           |                                                             | 11-11-08 | L.D. |
| 690          | PACK                                                                  |                                           |                                                             |          |      |

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/23/2008

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



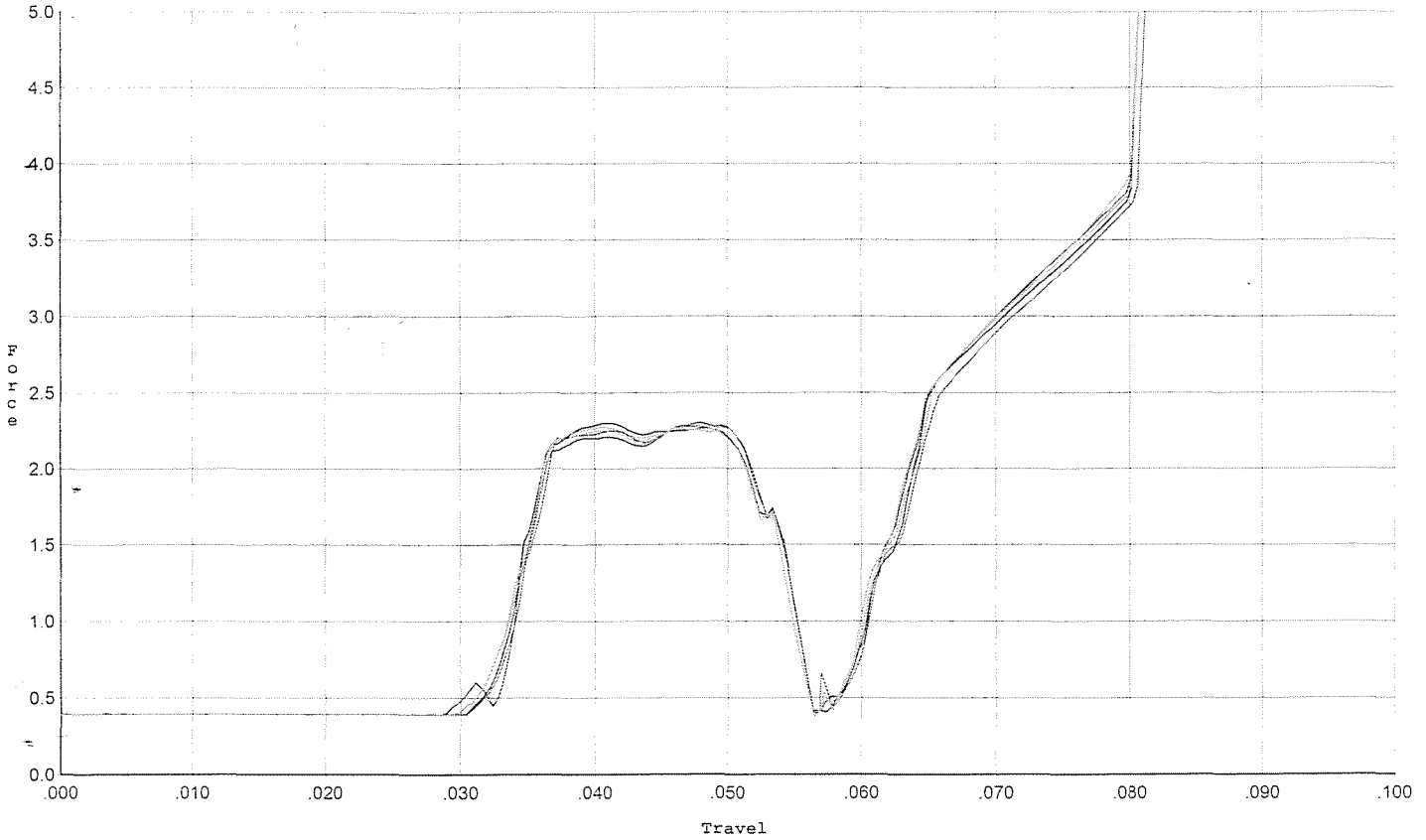
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.414      | 0.056             | 0.036           | 0.033      | 0.057             |           | Set Trigger |
| 2 | 2.363      | 0.056             | 0.036           | 0.033      | 0.056             |           | Set Trigger |
| 3 | 2.407      | 0.056             | 0.036           | 0.034      | 0.056             |           | Set Trigger |
| 4 | 2.413      | 0.056             | 0.036           | 0.034      | 0.056             |           | Set Trigger |
| 5 | 2.375      | 0.057             | 0.036           | 0.033      | 0.057             |           | Set Trigger |

A-239

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schultz 10/23/2008

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



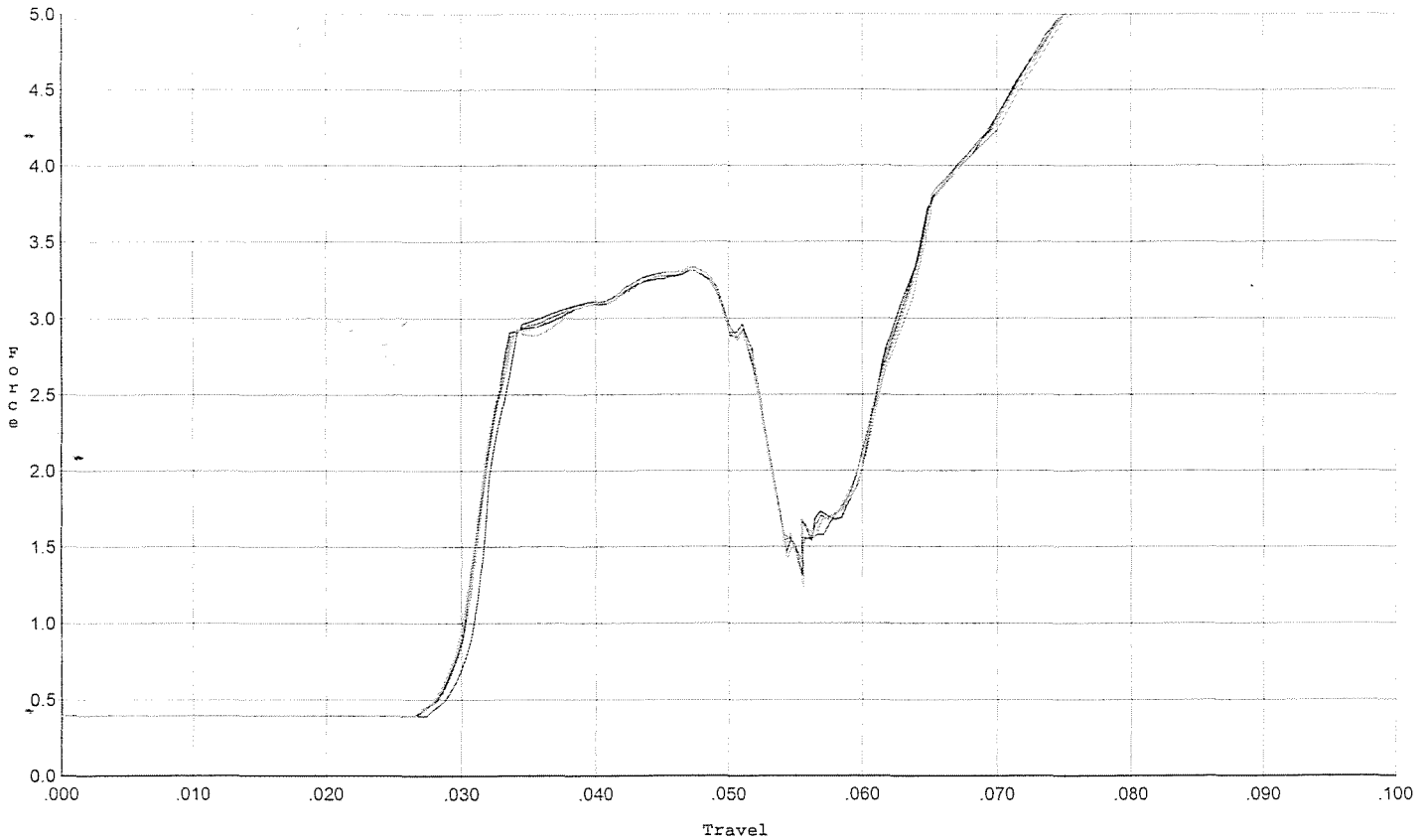
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.304      | 0.054             | 0.033           | 0.033      | 0.056             |           | Set Trigger |
| 2 | 2.300      | 0.054             | 0.033           | 0.033      | 0.056             |           | Set Trigger |
| 3 | 2.278      | 0.054             | 0.033           | 0.033      | 0.056             |           | Set Trigger |
| 4 | 2.260      | 0.053             | 0.032           | 0.033      | 0.055             |           | Set Trigger |
| 5 | 2.275      | 0.053             | 0.032           | 0.033      | 0.055             |           | Set Trigger |

A 2.28

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/23/2008

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



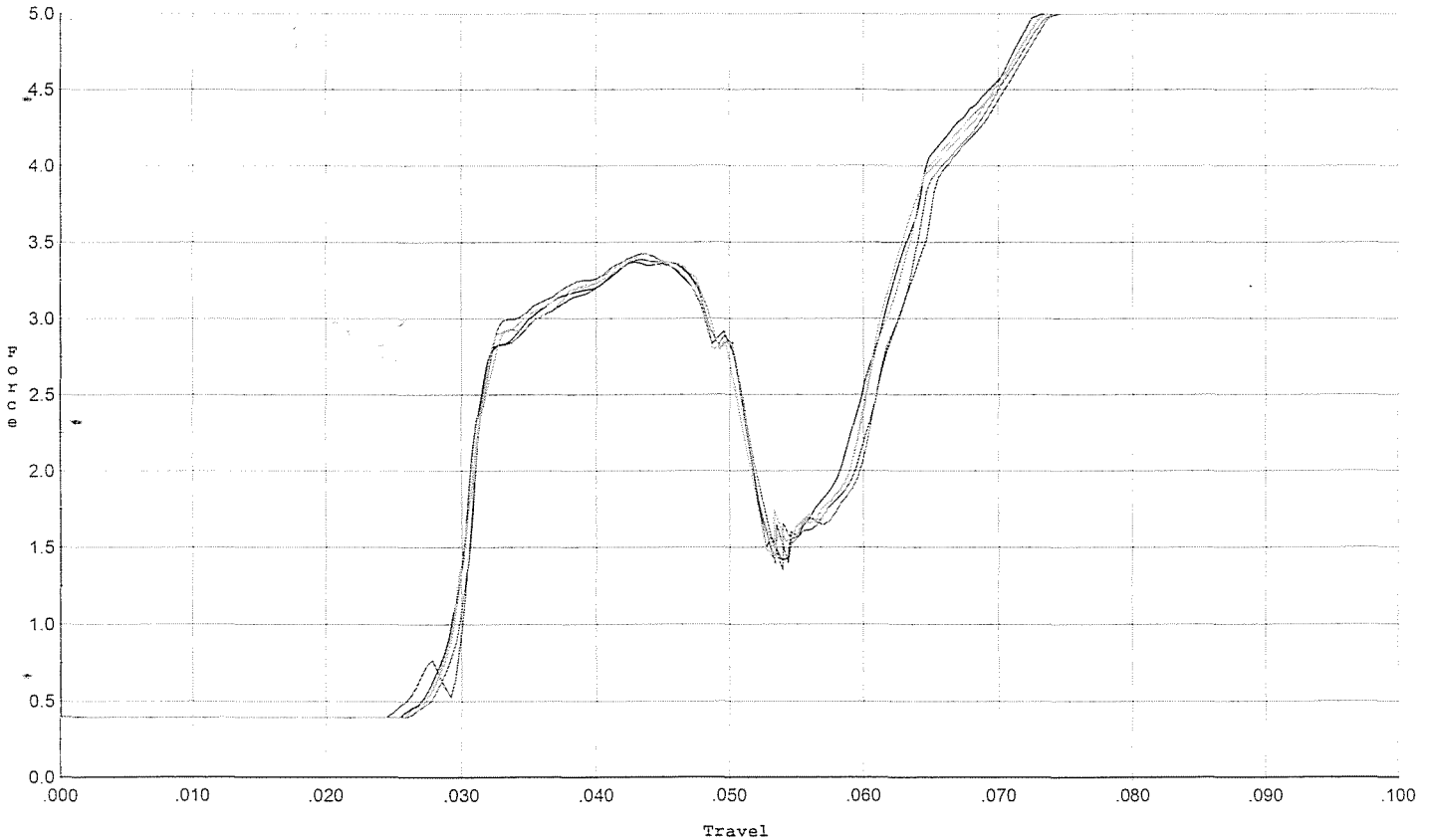
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.315      | 0.052             | 0.029           | 0.031      | 0.075             |           | Set Trigger |
| 2 | 3.307      | 0.052             | 0.029           | 0.031      | 0.076             |           | Set Trigger |
| 3 | 3.331      | 0.052             | 0.029           | 0.031      | 0.076             |           | Set Trigger |
| 4 | 3.312      | 0.052             | 0.029           | 0.031      | 0.076             |           | Set Trigger |
| 5 | 3.330      | 0.052             | 0.028           | 0.031      | 0.077             |           | Set Trigger |

A-3-31

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/23/2008

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



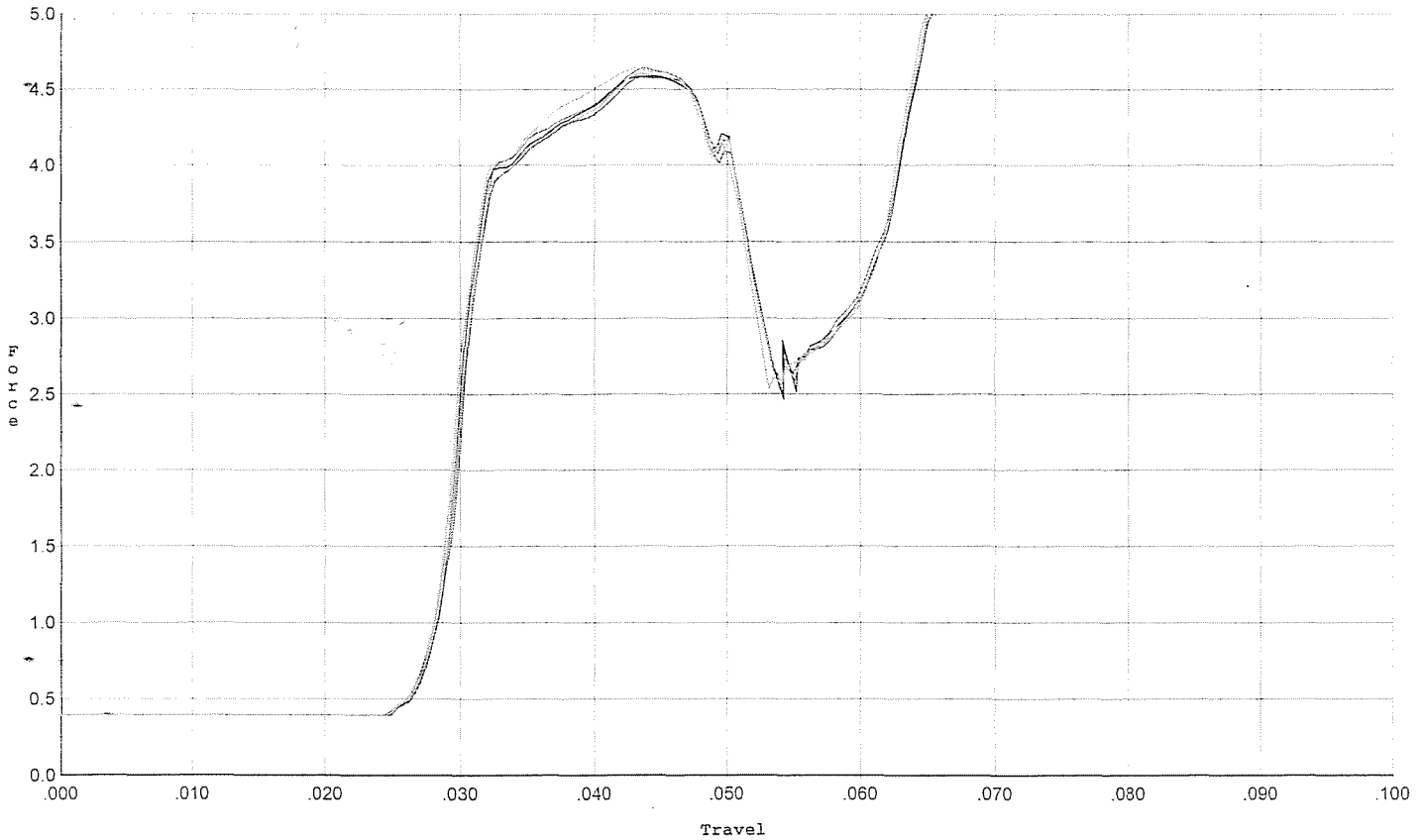
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.388      | 0.050             | 0.027           | 0.031      | 0.074             |           | Set Trigger |
| 2 | 3.371      | 0.050             | 0.028           | 0.030      | 0.075             |           | Set Trigger |
| 3 | 3.425      | 0.050             | 0.028           | 0.031      | 0.075             |           | Set Trigger |
| 4 | 3.400      | 0.051             | 0.028           | 0.030      | 0.076             |           | Set Trigger |
| 5 | 3.423      | 0.050             | 0.028           | 0.031      | 0.075             |           | Set Trigger |

A-3.40

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/23/2008

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



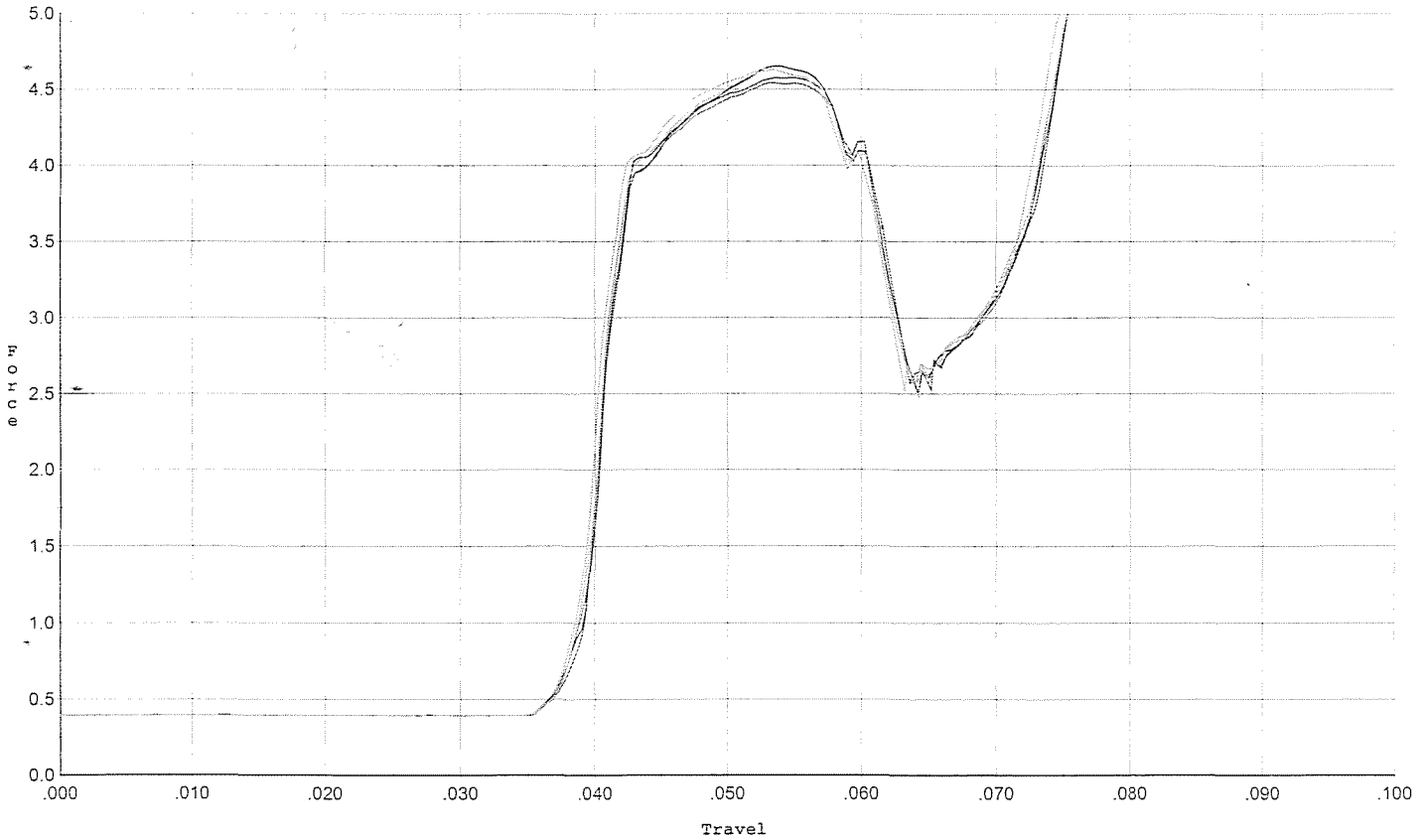
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.582      | 0.050             | 0.027           | 0.023      | 0.100             |           | Set Trigger |
| 2 | 4.585      | 0.050             | 0.027           | 0.023      | 0.101             |           | Set Trigger |
| 3 | 4.640      | 0.050             | 0.027           | 0.024      | 0.101             |           | Set Trigger |
| 4 | 4.604      | 0.050             | 0.027           | 0.024      | 0.101             |           | Set Trigger |
| 5 | 4.641      | 0.051             | 0.027           | 0.023      | 0.104             |           | Set Trigger |

A 4.61

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 10/23/2008

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



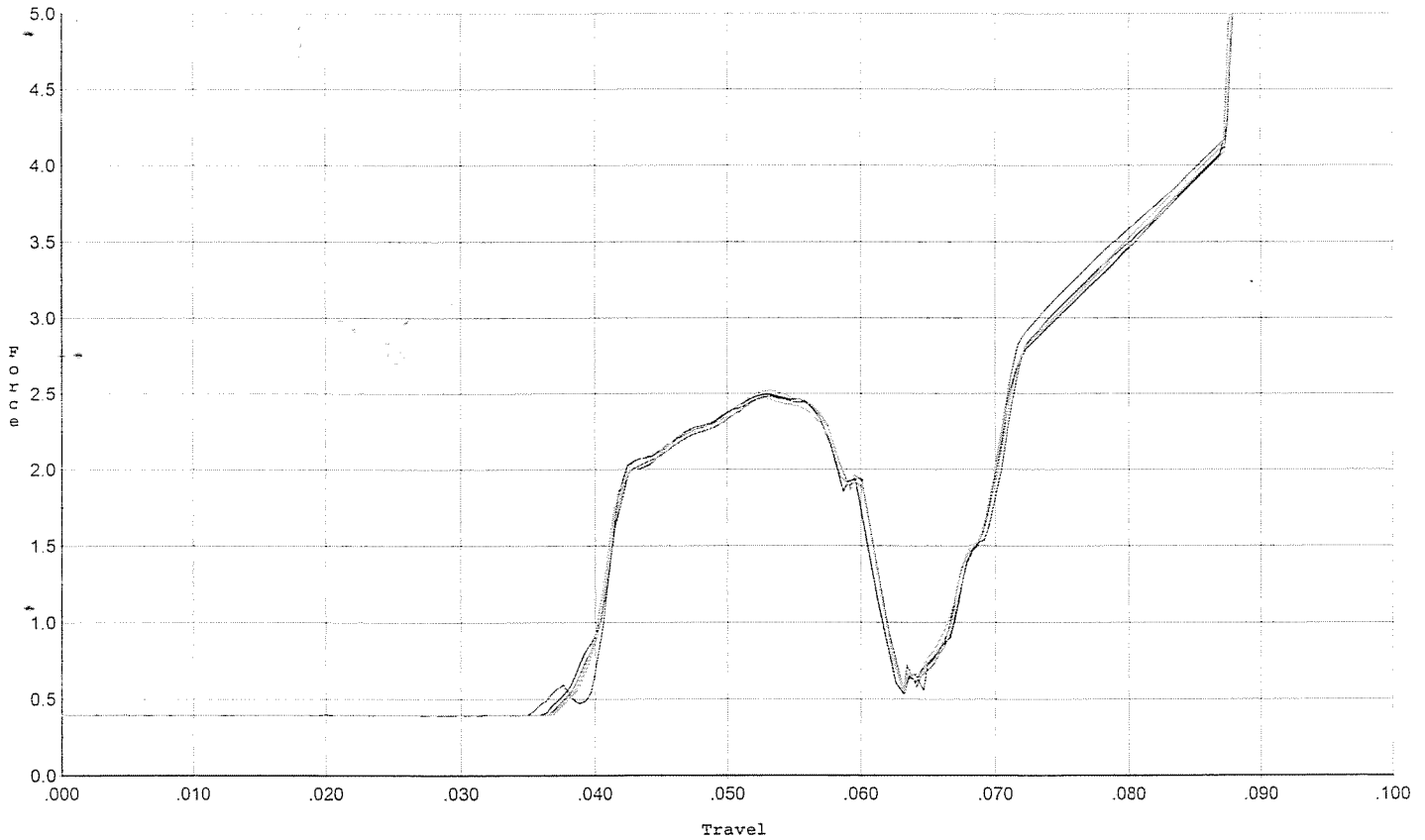
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.575      | 0.062             | 0.038           | 0.024      | 0.108             |           | Set Trigger |
| 2 | 4.652      | 0.060             | 0.038           | 0.025      | 0.106             |           | Set Trigger |
| 3 | 4.541      | 0.062             | 0.038           | 0.024      | 0.108             |           | Set Trigger |
| 4 | 4.634      | 0.061             | 0.037           | 0.024      | 0.108             |           | Set Trigger |
| 5 | 4.628      | 0.060             | 0.038           | 0.024      | 0.106             |           | Set Trigger |

A 4-60

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/23/2008

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



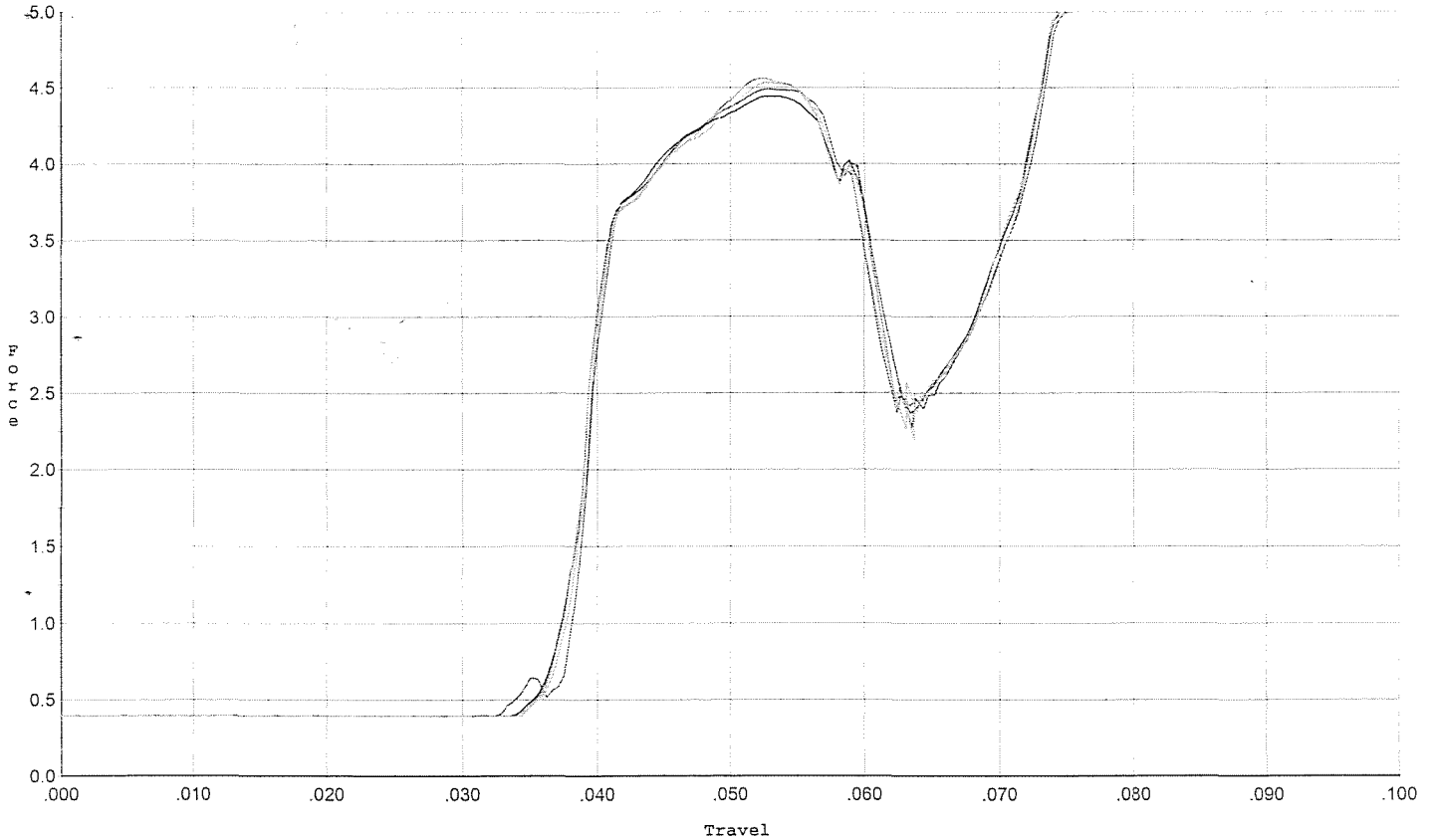
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.481      | 0.060             | 0.040           | 0.034      | 0.060             |           | Set Trigger |
| 2 | 2.494      | 0.060             | 0.039           | 0.034      | 0.060             |           | Set Trigger |
| 3 | 2.482      | 0.060             | 0.039           | 0.034      | 0.060             |           | Set Trigger |
| 4 | 2.521      | 0.060             | 0.039           | 0.034      | 0.061             |           | Set Trigger |
| 5 | 2.469      | 0.060             | 0.039           | 0.034      | 0.060             |           | Set Trigger |

A 2.48

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 10/23/2008

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 | 4.491      | 0.059             | 0.035           | 0.030      | 0.103             |           | Set Trigger |
| 2 | 4.443      | 0.060             | 0.036           | 0.029      | 0.103             |           | Set Trigger |
| 3 | 4.562      | 0.059             | 0.036           | 0.030      | 0.102             |           | Set Trigger |
| 4 | 4.560      | 0.059             | 0.036           | 0.029      | 0.102             |           | Set Trigger |
| 5 | 4.533      | 0.060             | 0.037           | 0.029      | 0.103             |           | Set Trigger |

A 4.51