

66863579

**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

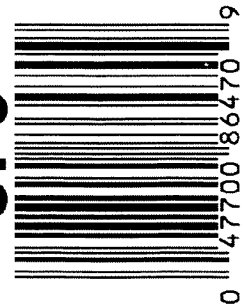
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6863579**

**UPC**



GUN SERIAL # G 6863579

| OP # | OPERATION NAME                                                                                                                         | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                       | 6-23-09 | SP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                       | 6-23-09 | SP      |
| 440  | PROOF                                                                                                                                  |                       | 6-23-09 | SP      |
| 460  | CHECK HEADSPACE                                                                                                                        | WAC 10-FLWA           | 6-23-09 | SP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    | 209                   | 6-23-09 | SP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                       | 6-24-09 | RT      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR'S (P)        | 6/26/09 | (P)     |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                       |         |         |
| 500  | ROLLMARK CALIBER                                                                                                                       |                       | 6/26/09 | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                       | 6-24-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                       | 6-26-09 | RT      |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                       | 7/14    | ✓       |
| 545  | (BOLT)                                                                                                                                 |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                       | 7-14-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                       | 7-14-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO | 7-14-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                       | 7-16-09 | L.W.    |
|      | 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

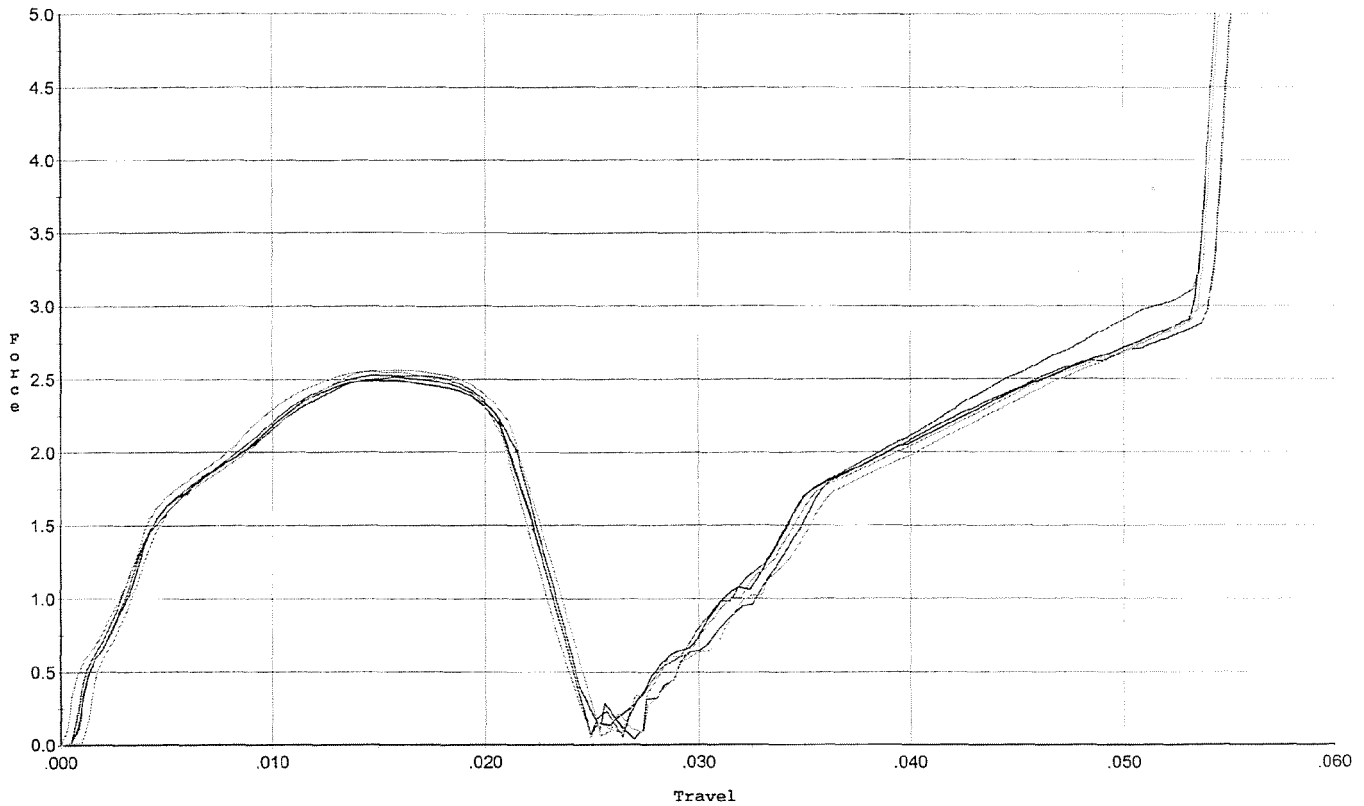
|              |                                                                       |                                           |                                                        |         |      |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|--------------------------------------------------------|---------|------|
| 560          | BARBER - M24 0093119<br>F) SAFETY ON FORCE                            | 2 LBS MIN<br>10 LBS MAX                   | <u>50</u> <u>50</u> <u>50</u>                          | 8-3-09  | L.N. |
| CONT.        | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>70</u> <u>70</u> <u>60</u>                          | 8-3-09  | L.N. |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                        |         |      |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.023</u> <u>.024</u> <u>.024</u>                    | 8-3-09  | L.N. |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                        | 7-16-09 | L.N. |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                        | 8-3-09  | L.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                   | 7-27-09 | L.N. |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                             |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION N/A                                         |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                             |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                             |         |      |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                        | 7/27/09 | RF   |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                        | 8-3-09  | L.N. |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>234</u> <u>233</u> <u>235</u> <u>241</u> <u>234</u> | 7-31-09 | L.N. |
|              | C) FUNCTION                                                           |                                           |                                                        | 8-3-09  | L.N. |
| 690          | PACK                                                                  |                                           |                                                        | 8/13/08 | Fm   |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



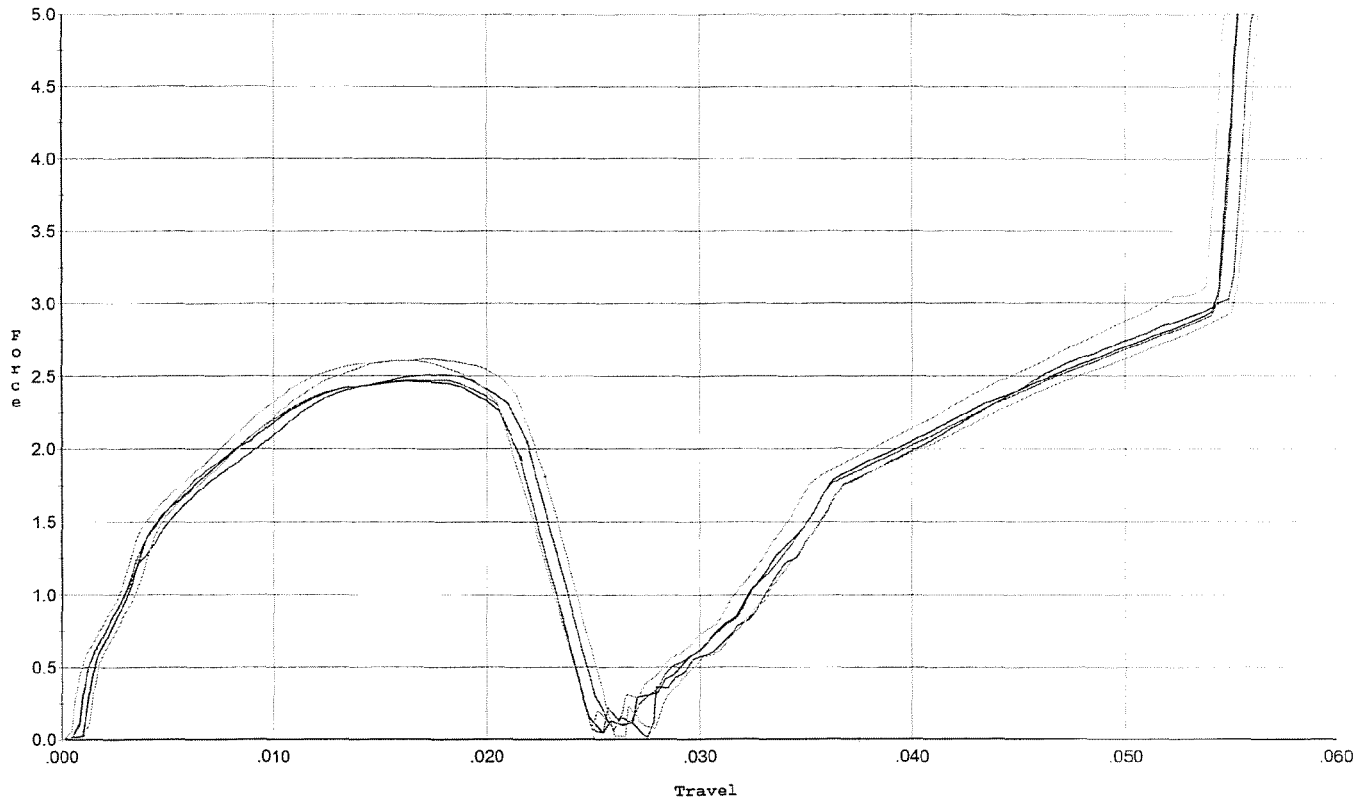
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.515      | 0.021             | 0.00            | 0.038      | 0.039             |           | Set Trigger |
| 2 | 2.492      | 0.022             | 0.00            | 0.037      | 0.040             |           | Set Trigger |
| 3 | 2.526      | 0.022             | 0.00            | 0.037      | 0.040             |           | Set Trigger |
| 4 | 2.564      | 0.023             | 0.00            | 0.037      | 0.042             |           | Set Trigger |
| 5 | 2.551      | 0.021             | 0.00            | 0.038      | 0.039             |           | Set Trigger |

AVG 2.53

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



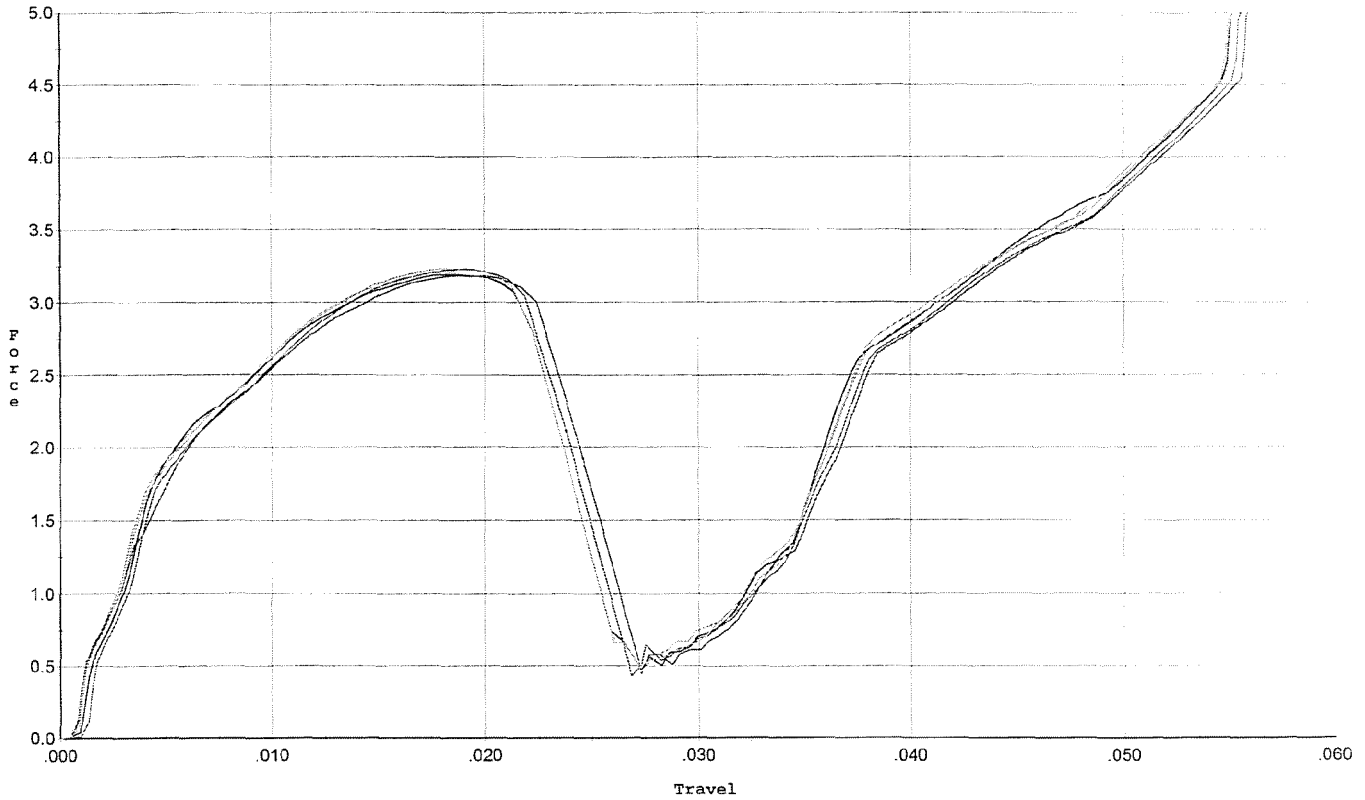
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.509      | 0.022             | 0.00            | 0.038      | 0.040             |           | Set Trigger |
| 2 | 2.466      | 0.022             | 0.00            | 0.038      | 0.039             |           | Set Trigger |
| 3 | 2.474      | 0.022             | 0.00            | 0.038      | 0.039             |           | Set Trigger |
| 4 | 2.606      | 0.022             | 0.00            | 0.037      | 0.042             |           | Set Trigger |
| 5 | 2.621      | 0.023             | 0.00            | 0.038      | 0.042             |           | Set Trigger |

Avg 2.53

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



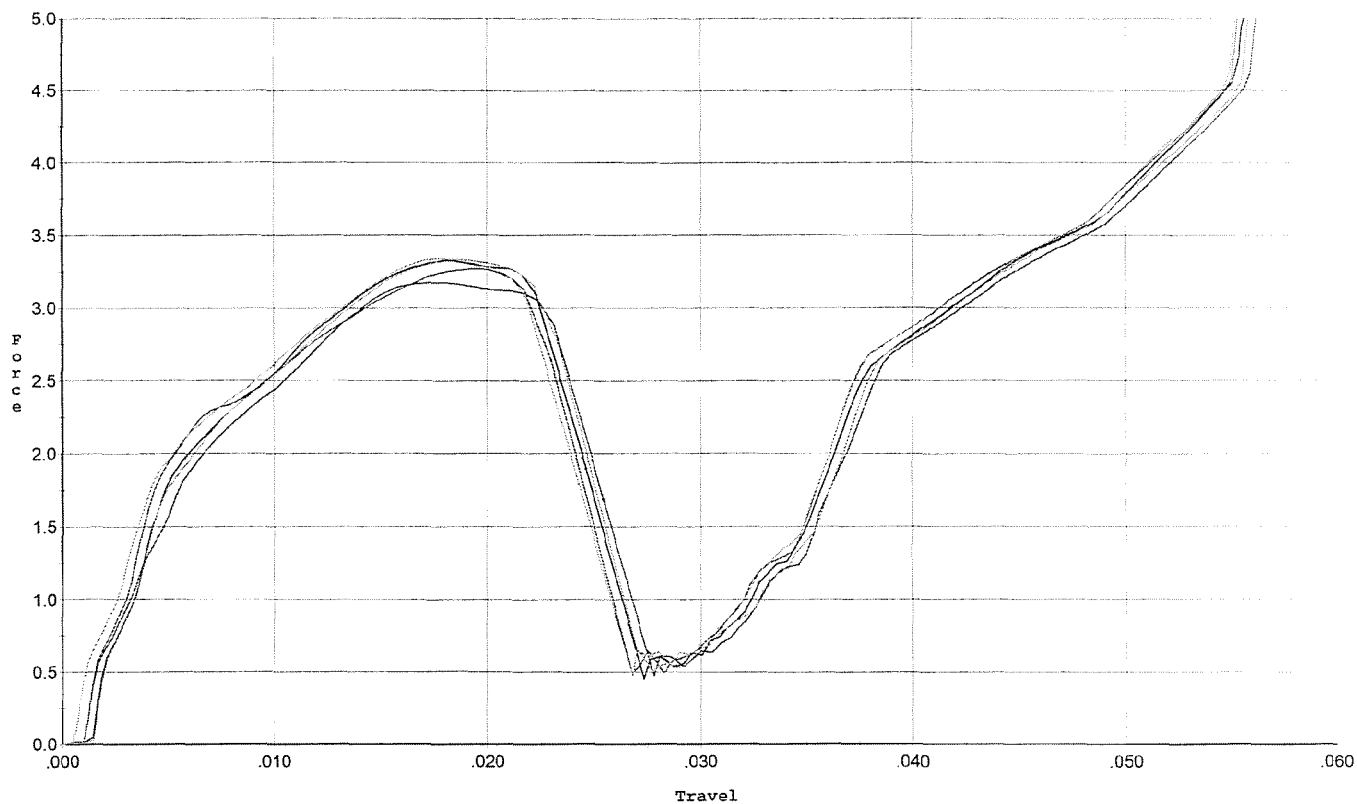
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.182      | 0.025             | 0.00            | 0.036      | 0.055             |           | Set Trigger |
| 2 | 3.190      | 0.022             | 0.00            | 0.036      | 0.050             |           | Set Trigger |
| 3 | 3.230      | 0.024             | 0.00            | 0.036      | 0.053             |           | Set Trigger |
| 4 | 3.202      | 0.022             | 0.00            | 0.036      | 0.050             |           | Set Trigger |
| 5 | 3.229      | 0.022             | 0.00            | 0.036      | 0.051             |           | Set Trigger |

Avg 3.20

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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 | 3.172      | 0.025             | 0.00            | 0.036      | 0.056             |           | Set Trigger |
| 2 | 3.326      | 0.025             | 0.00            | 0.035      | 0.055             |           | Set Trigger |
| 3 | 3.268      | 0.023             | 0.00            | 0.035      | 0.052             |           | Set Trigger |
| 4 | 3.343      | 0.024             | 0.00            | 0.035      | 0.056             |           | Set Trigger |
| 5 | 3.338      | 0.023             | 0.00            | 0.036      | 0.053             |           | Set Trigger |

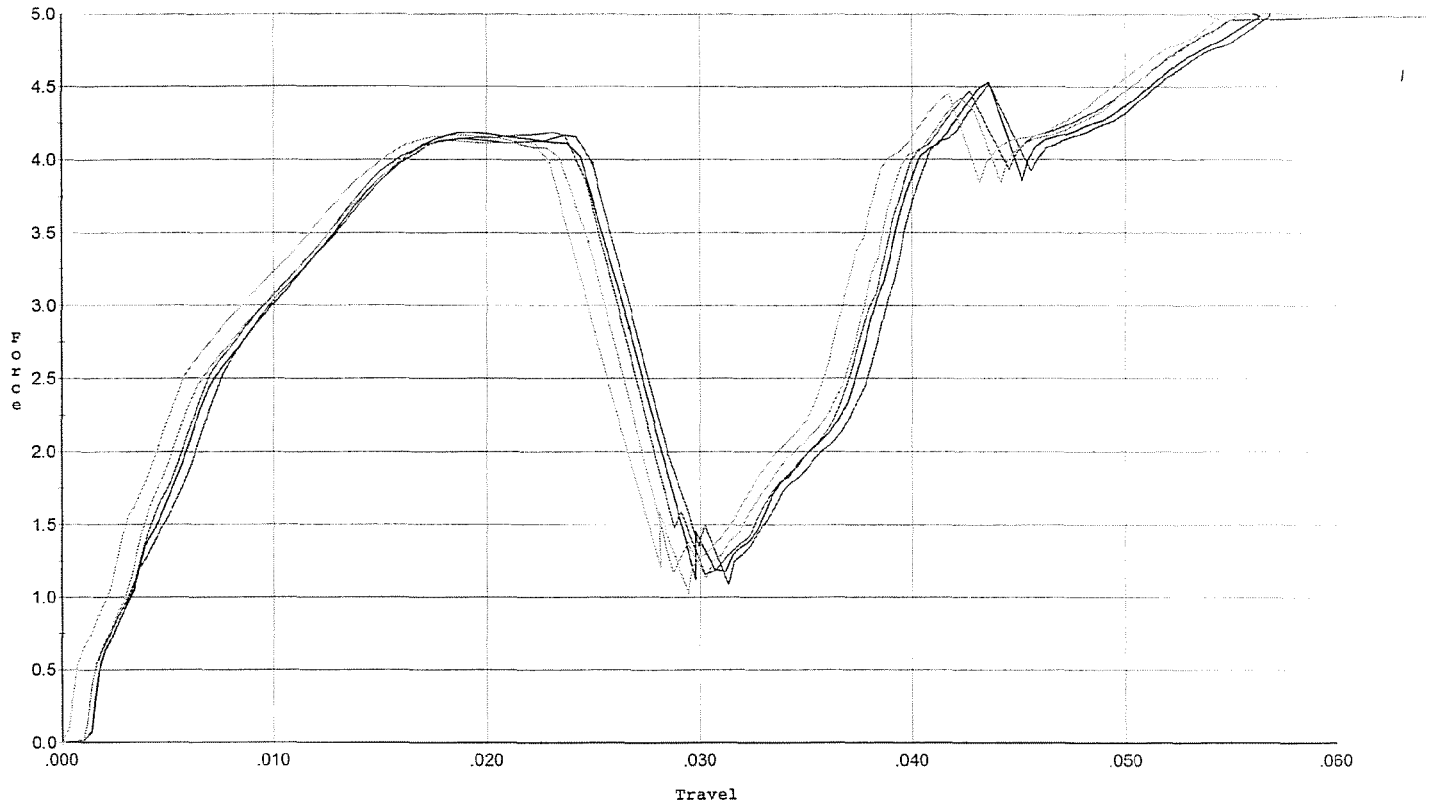
Aug 3.28



## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



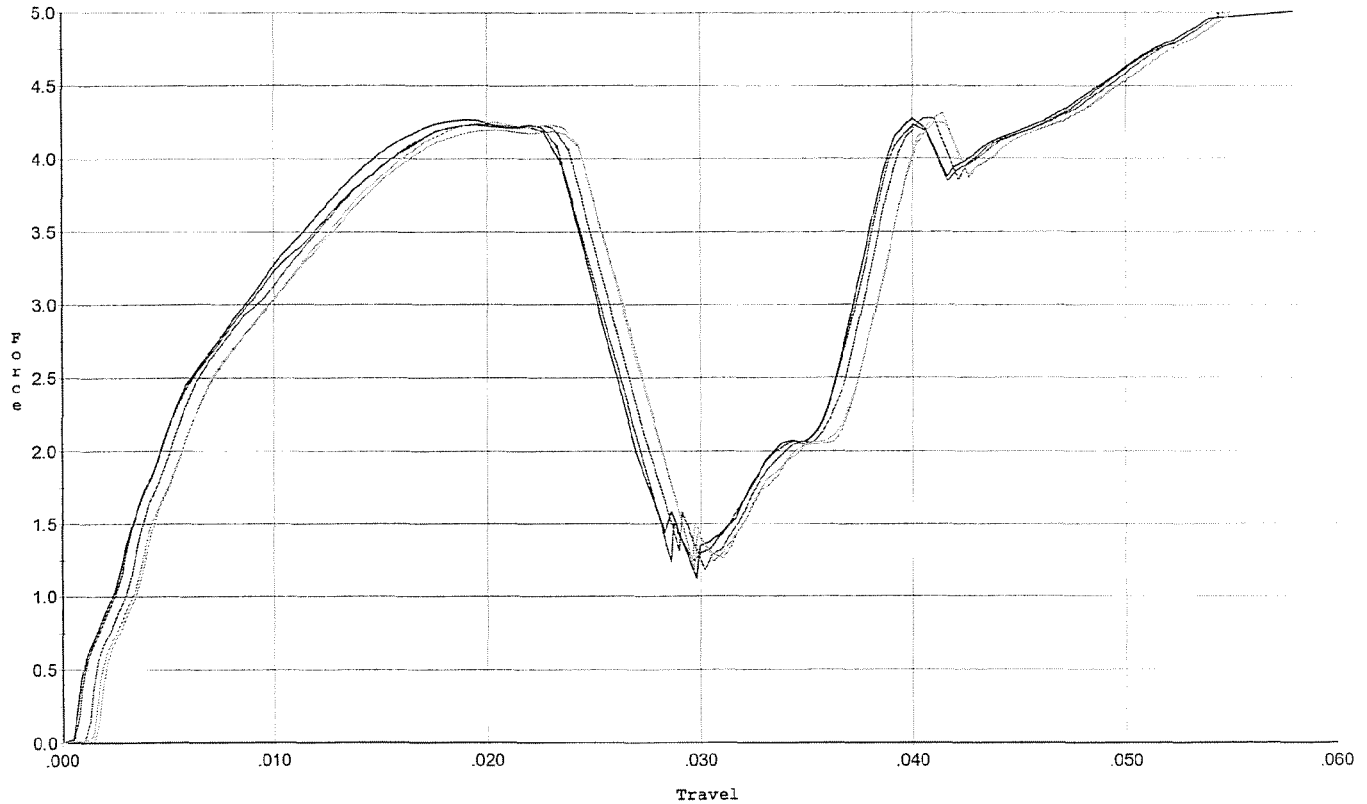
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.168      | 0.025             | 0.00            | 0.034      | 0.070             |           | Set Trigger |
| 2 | 4.185      | 0.027             | 0.00            | 0.033      | 0.074             |           | Set Trigger |
| 3 | 4.187      | 0.025             | 0.00            | 0.033      | 0.069             |           | Set Trigger |
| 4 | 4.166      | 0.023             | 0.00            | 0.033      | 0.066             |           | Set Trigger |
| 5 | 4.130      | 0.025             | 0.00            | 0.033      | 0.069             |           | Set Trigger |

Aug 4.16

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



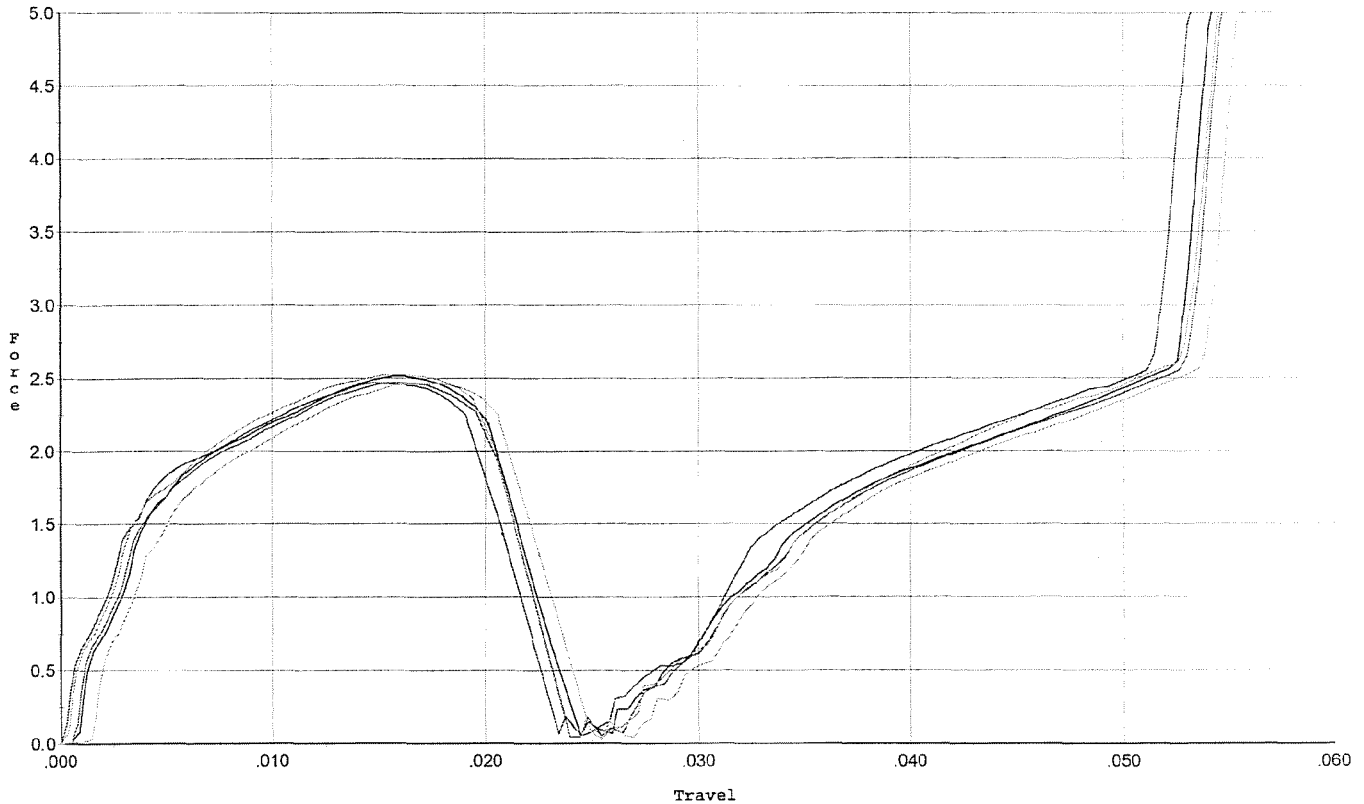
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.231      | 0.023             | 0.00            | 0.033      | 0.067             |           | Set Trigger |
| 2 | 4.264      | 0.023             | 0.00            | 0.033      | 0.069             |           | Set Trigger |
| 3 | 4.236      | 0.024             | 0.00            | 0.033      | 0.068             |           | Set Trigger |
| 4 | 4.247      | 0.024             | 0.00            | 0.033      | 0.068             |           | Set Trigger |
| 5 | 4.193      | 0.027             | 0.002           | 0.033      | 0.075             |           | Set Trigger |

Aug 4.23

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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



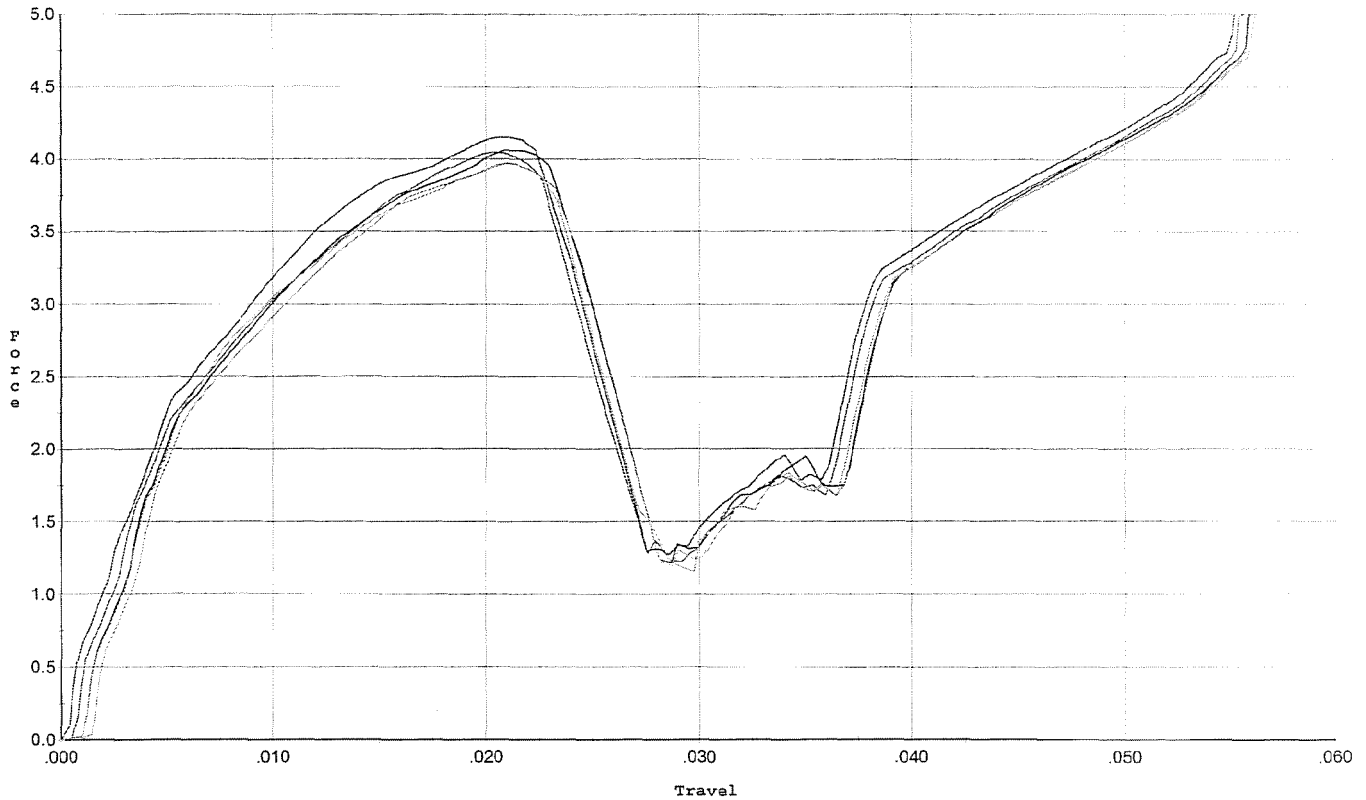
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.470      | 0.021             | 0.00            | 0.037      | 0.039             |           | Set Trigger |
| 2 | 2.515      | 0.020             | 0.00            | 0.038      | 0.037             |           | Set Trigger |
| 3 | 2.470      | 0.021             | 0.00            | 0.038      | 0.037             |           | Set Trigger |
| 4 | 2.466      | 0.023             | 0.00            | 0.038      | 0.039             |           | Set Trigger |
| 5 | 2.524      | 0.020             | 0.00            | 0.038      | 0.039             |           | Set Trigger |

Aug 248

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/12/09

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 | 4.153      | 0.024             | 0.00            | 0.033      | 0.068             |           | Set Trigger |
| 2 | 4.061      | 0.025             | 0.00            | 0.034      | 0.067             |           | Set Trigger |
| 3 | 4.049      | 0.023             | 0.00            | 0.034      | 0.061             |           | Set Trigger |
| 4 | 3.973      | 0.023             | 0.00            | 0.034      | 0.062             |           | Set Trigger |
| 5 | 3.969      | 0.025             | 0.00            | 0.034      | 0.065             |           | Set Trigger |

Avg 4.04