

6863639

**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

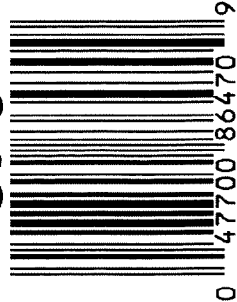
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6863639**

**UPC**



GUN SERIAL #

G 6863639

| OP # | OPERATION NAME                                                 | READINGS              | DATE    | INITIAL |
|------|----------------------------------------------------------------|-----------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                       | 6-11-09 | SPD     |
| 430  | ASSEMBLE TO STOCK                                              |                       | 6-11-09 | SP      |
| 440  | PROOF                                                          |                       | 6-11-09 | SPD     |
| 460  | CHECK HEADSPACE                                                | MAGNA - FLUX          | 6-11-09 | SPD     |
| 470  | DIS-ASSEMBLE ACTION                                            | 2009                  | 6-11-09 | SPD     |
| 472  | SERIALIZE BOLT HANDLE                                          | OPERATOR              | 6-12-09 | RT      |
| 480  | MAGNAFLUX BBL ACTION                                           |                       | 6/13/09 | RT      |
| 490  | MAGNAFLUX BOLT                                                 |                       |         |         |
| 500  | ROLLMARK CALIBER                                               |                       | 6/16/09 | RT      |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                   |                       | 6-12-09 | SP      |
| 520  | GOFF BLAST BBL / REC                                           |                       | 6/14/09 | XTW     |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                              |                       | 7/1/09  | ✓       |
| 545  | (BOLT)                                                         |                       |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                       |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                       | 7-16-09 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                       | 7-16-09 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         | INSPECT FOR LIVE AMMO | 7-16-09 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                       | 7-22-09 | RT      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS   |         |         |

F004 REV 5/2006

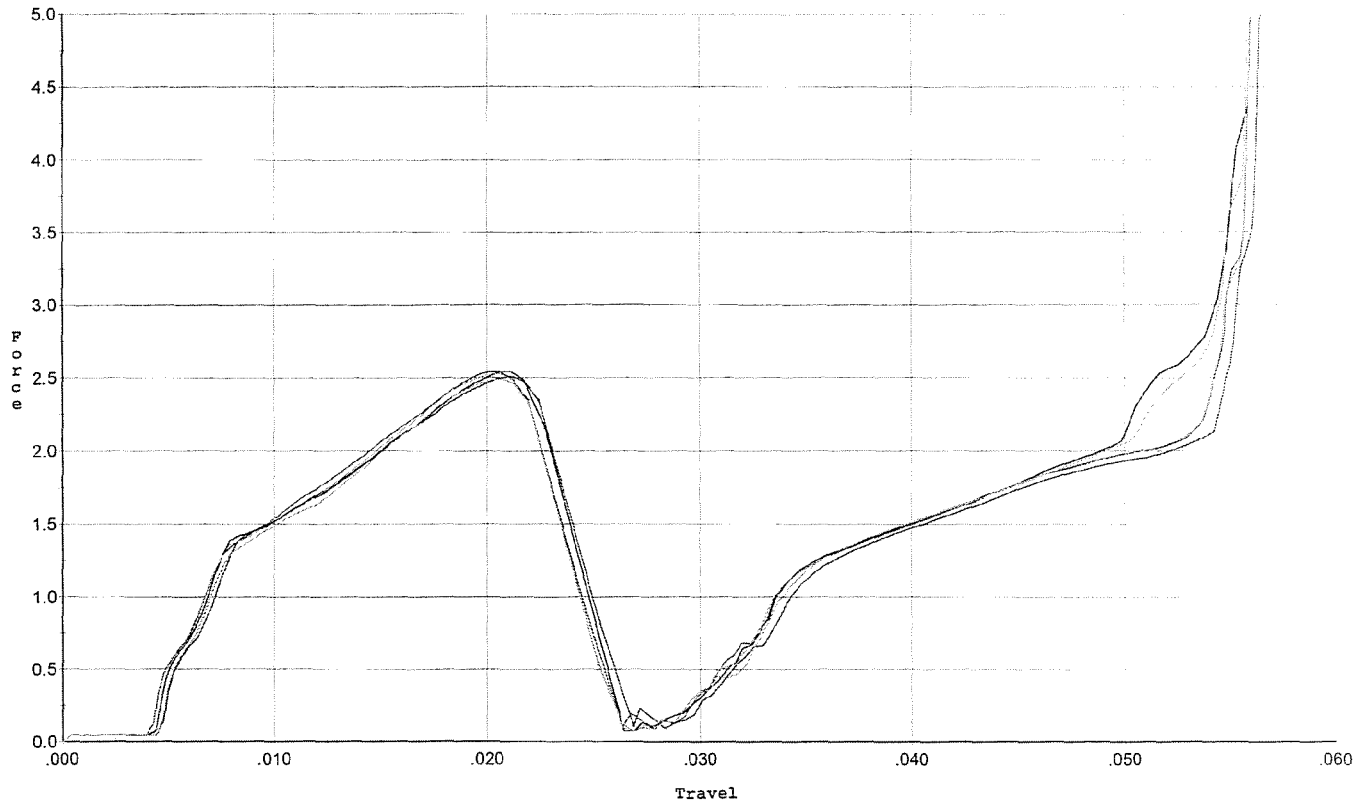
|              |                                                                       |                                           |                                                                |         |     |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|----------------------------------------------------------------|---------|-----|
| 560          | BARBER - M24 0094062<br>F) SAFETY ON FORCE                            | 2 LBS MIN<br>10 LBS MAX                   | <u>4<sup>0</sup></u> <u>4<sup>0</sup></u> <u>4<sup>0</sup></u> | 8-5-09  | LN  |
| CONT.        | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>6<sup>0</sup></u> <u>6<sup>0</sup></u> <u>6<sup>0</sup></u> | 8-5-09  | LN  |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |                                                                |         |     |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.025</u> <u>.024</u> <u>.024</u>                            | 8-5-09  | LN  |
|              | J) ASSEMBLE STOCK                                                     |                                           |                                                                | 7-22-09 | LN  |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |                                                                | 8-5-09  | LN  |
|              | 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                           | 7/28    | RL  |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                     |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                     |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                     |         |     |
|              | MALFUNCTION                                                           |                                           | CORRECTION                                                     |         |     |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |                                                                | 7/28    | TAR |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |                                                                | 8-5-09  | LN  |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>248</u> <u>244</u> <u>245</u> <u>248</u> <u>259</u>         | 8-4-09  | LN  |
|              | C) FUNCTION                                                           |                                           |                                                                | 8-5-09  | LN  |
| 690          | PACK                                                                  |                                           |                                                                | 8/10/09 | Fm  |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



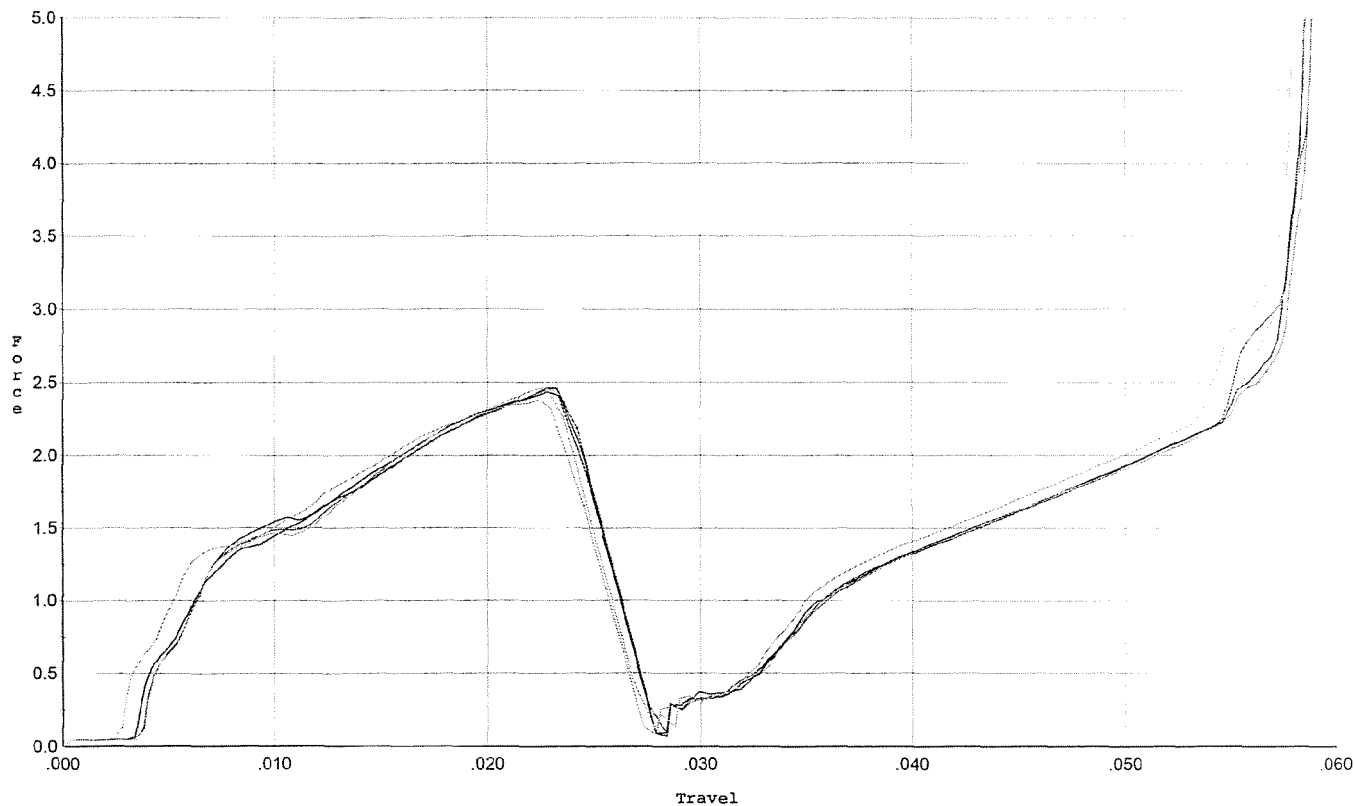
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.508      | 0.022             | 0.005           | 0.038      | 0.031             |           | Set Trigger |
| 2 | 2.543      | 0.023             | 0.005           | 0.037      | 0.032             |           | Set Trigger |
| 3 | 2.539      | 0.022             | 0.004           | 0.038      | 0.031             |           | Set Trigger |
| 4 | 2.527      | 0.022             | 0.005           | 0.038      | 0.031             |           | Set Trigger |
| 5 | 2.492      | 0.022             | 0.005           | 0.038      | 0.030             |           | Set Trigger |

Aug 2.52

## Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



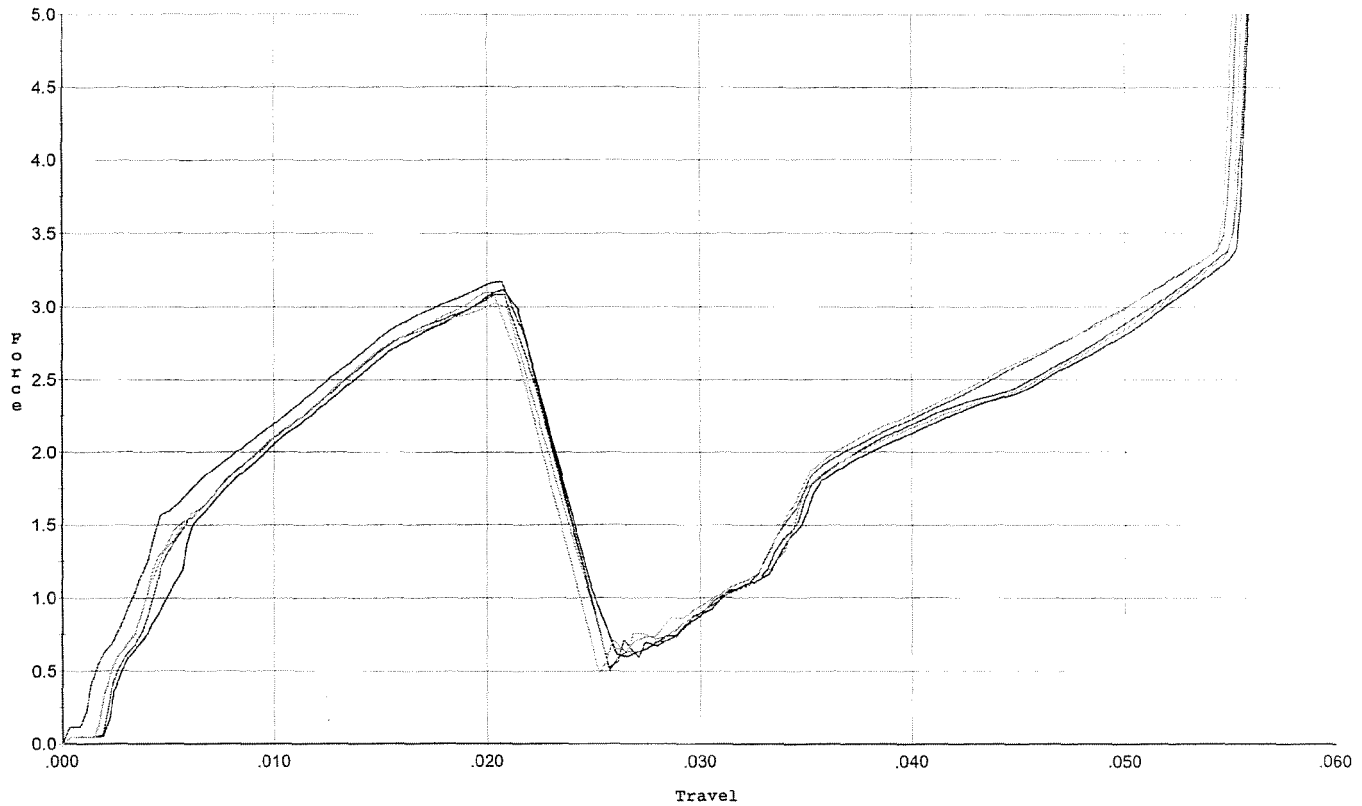
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.436      | 0.025             | 0.004           | 0.039      | 0.036             |           | Set Trigger |
| 2 | 2.466      | 0.024             | 0.004           | 0.039      | 0.035             |           | Set Trigger |
| 3 | 2.452      | 0.024             | 0.004           | 0.039      | 0.035             |           | Set Trigger |
| 4 | 2.467      | 0.024             | 0.004           | 0.040      | 0.034             |           | Set Trigger |
| 5 | 2.379      | 0.024             | 0.003           | 0.039      | 0.036             |           | Set Trigger |

Aug 2.44

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



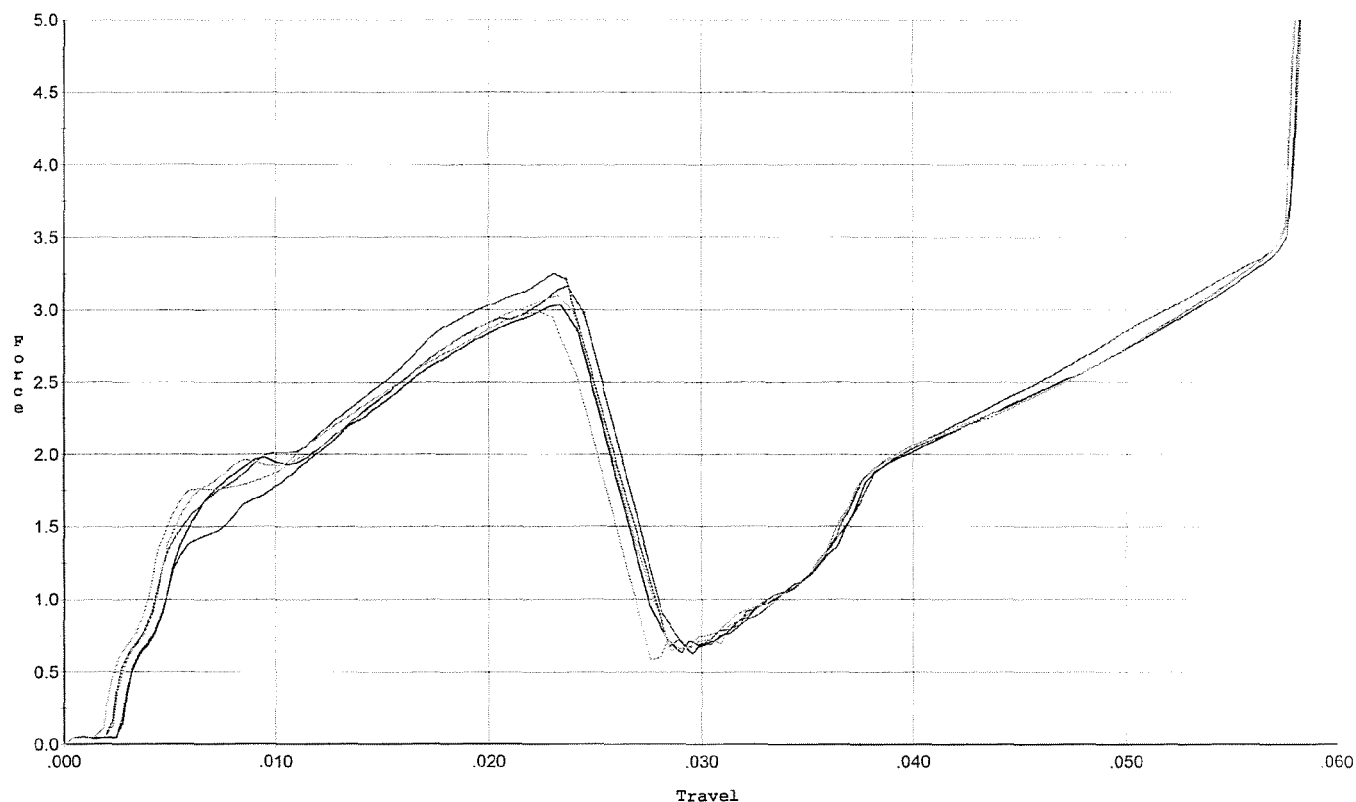
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.171      | 0.022             | 0.00            | 0.037      | 0.044             |           | Set Trigger |
| 2 | 3.120      | 0.021             | 0.002           | 0.037      | 0.040             |           | Set Trigger |
| 3 | 3.084      | 0.022             | 0.002           | 0.036      | 0.042             |           | Set Trigger |
| 4 | 3.027      | 0.021             | 0.00            | 0.037      | 0.040             |           | Set Trigger |
| 5 | 3.101      | 0.022             | 0.00            | 0.036      | 0.041             |           | Set Trigger |

Aug 3.10

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



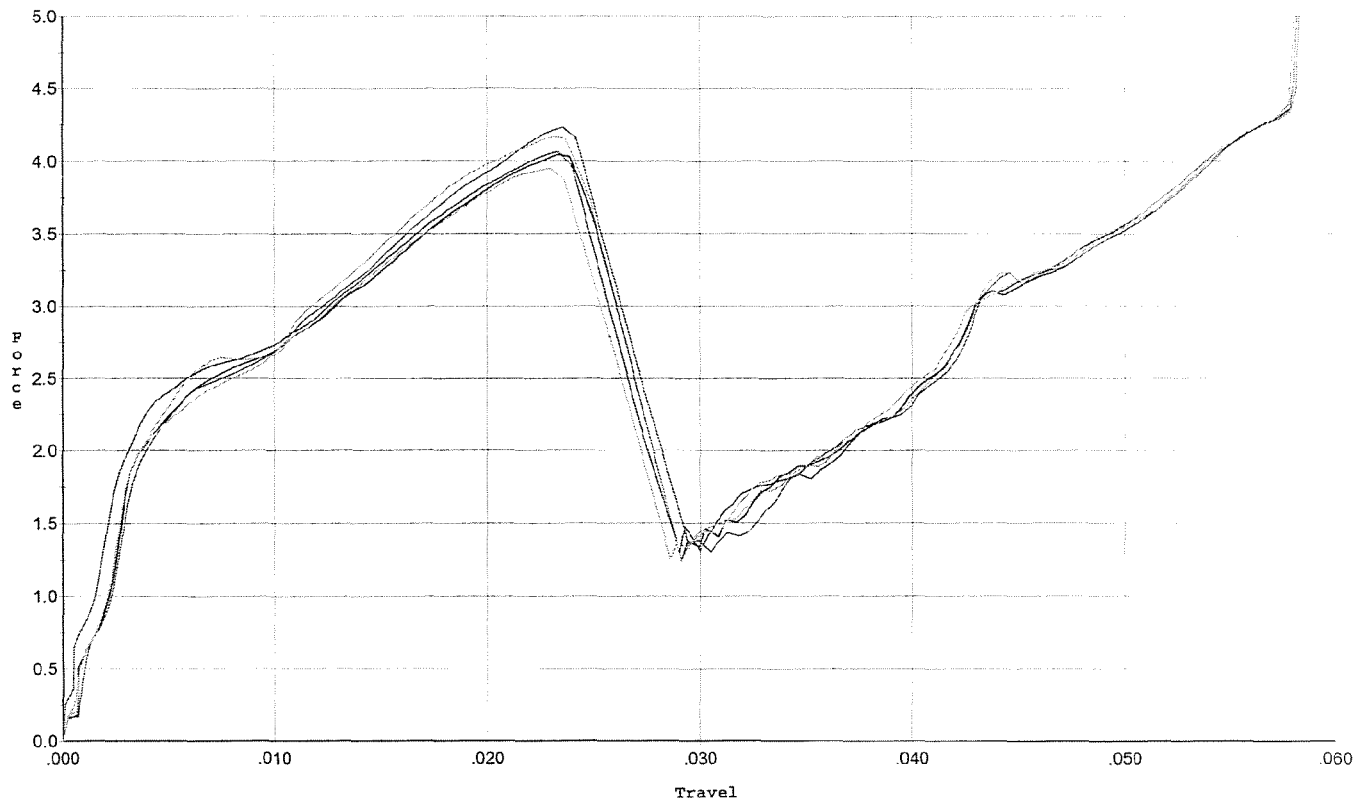
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.163      | 0.024             | 0.003           | 0.037      | 0.046             |           | Set Trigger |
| 2 | 3.035      | 0.024             | 0.003           | 0.037      | 0.045             |           | Set Trigger |
| 3 | 3.249      | 0.024             | 0.00            | 0.037      | 0.047             |           | Set Trigger |
| 4 | 3.099      | 0.024             | 0.002           | 0.037      | 0.046             |           | Set Trigger |
| 5 | 2.982      | 0.024             | 0.002           | 0.037      | 0.046             |           | Set Trigger |

Avg 3.10

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



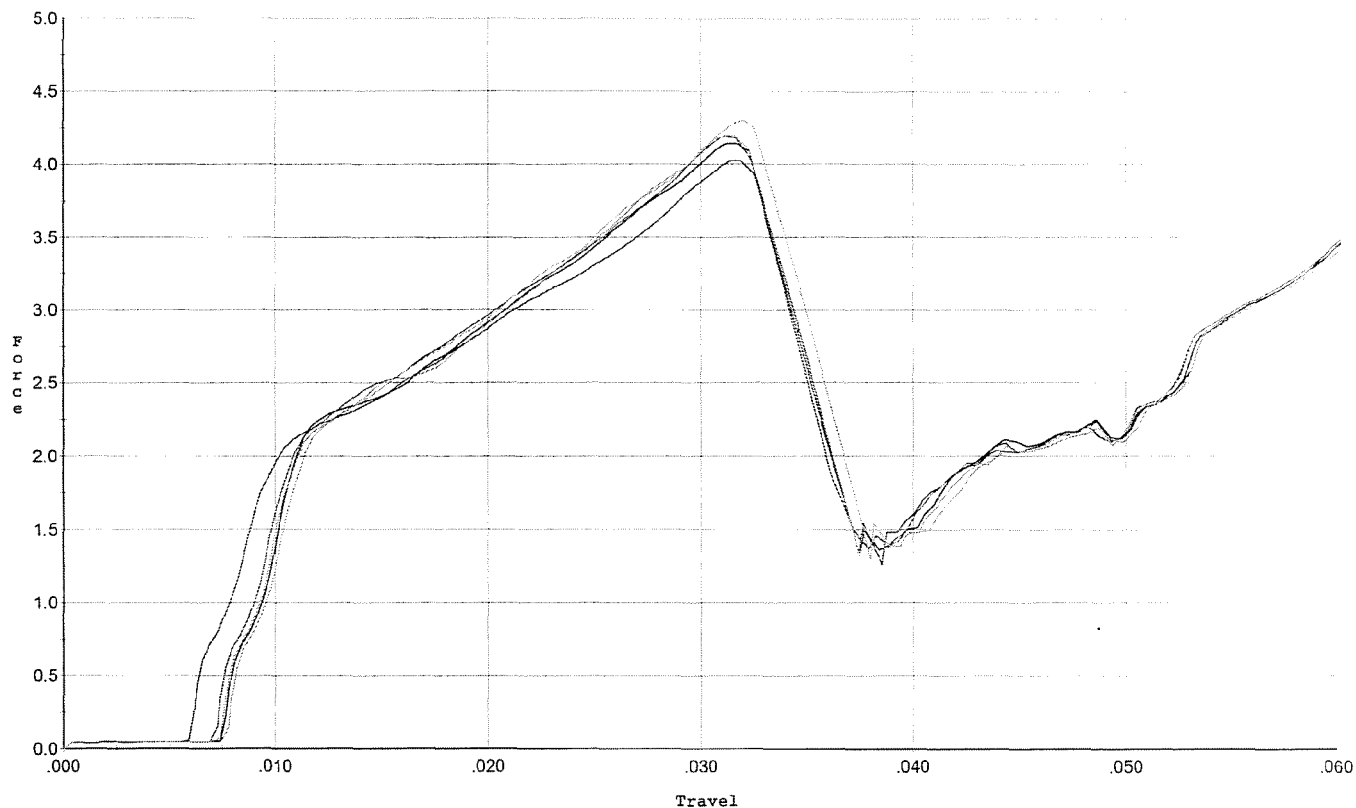
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.065      | 0.024             | 0.00            | 0.035      | 0.066             |           | Set Trigger |
| 2 | 4.047      | 0.025             | 0.00            | 0.035      | 0.067             |           | Set Trigger |
| 3 | 4.231      | 0.024             | 0.00            | 0.035      | 0.066             |           | Set Trigger |
| 4 | 3.951      | 0.026             | 0.00            | 0.035      | 0.068             |           | Set Trigger |
| 5 | 4.171      | 0.025             | 0.011           | 0.035      | 0.069             |           | Set Trigger |

Aug 4.09

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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



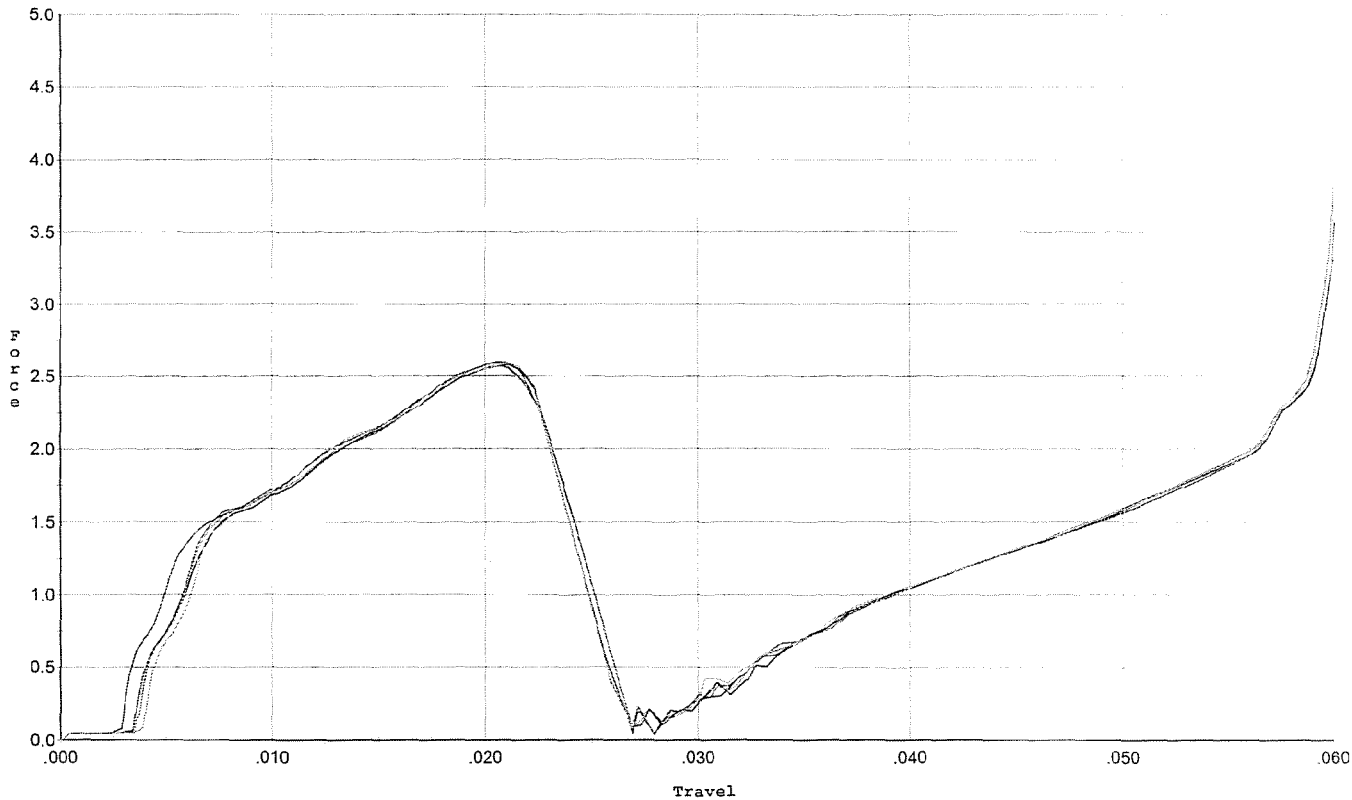
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.025      | 0.033             | 0.006           | 0.037      | 0.072             |           | Set Trigger |
| 2 | 4.142      | 0.035             | 0.008           | 0.035      | 0.076             |           | Set Trigger |
| 3 | 4.196      | 0.032             | 0.007           | 0.037      | 0.072             |           | Set Trigger |
| 4 | 4.199      | 0.035             | 0.008           | 0.035      | 0.077             |           | Set Trigger |
| 5 | 4.301      | 0.035             | 0.008           | 0.032      | 0.077             |           | Set Trigger |

Aug 4.17

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R.P. 6/26/09

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



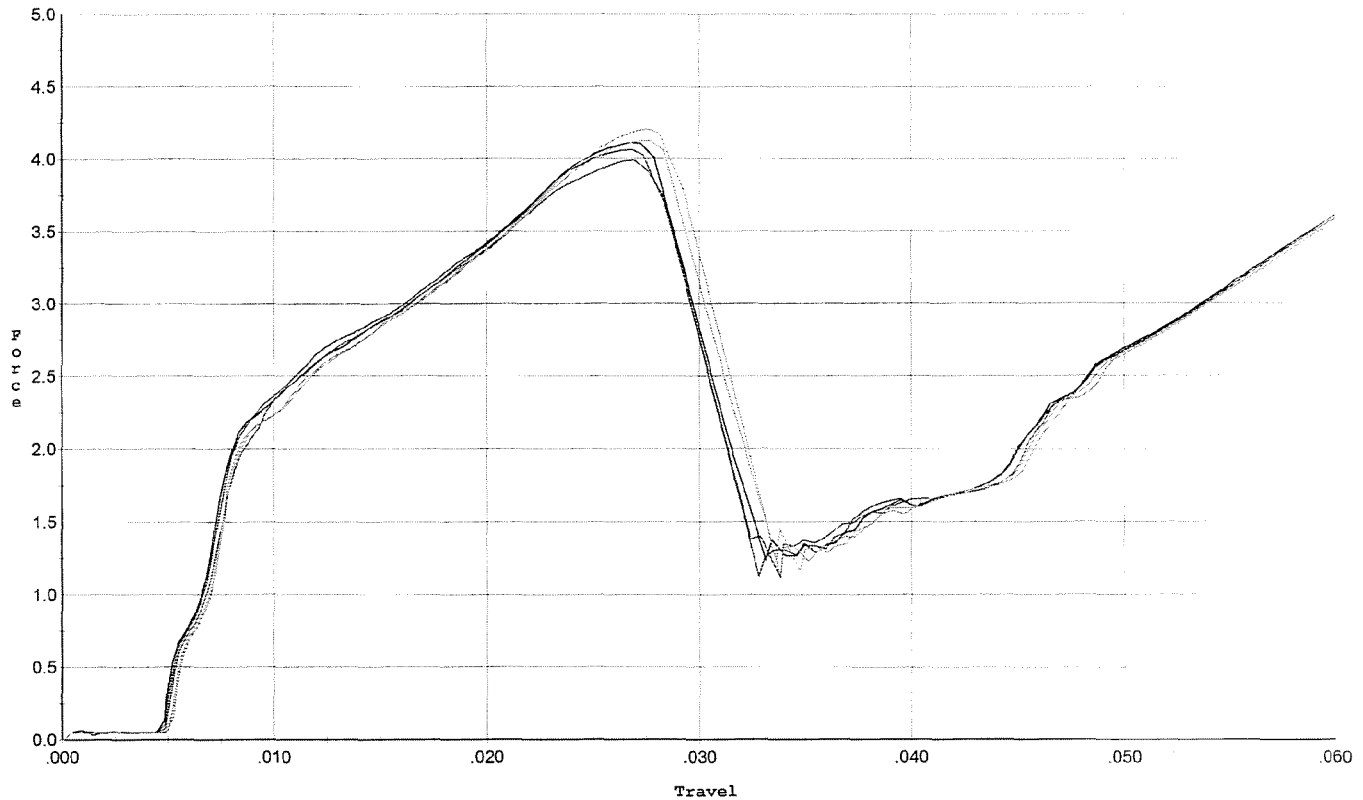
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.599      | 0.023             | 0.003           | 0.043      | 0.036             |           | Set Trigger |
| 2 | 2.580      | 0.024             | 0.004           | 0.042      | 0.037             |           | Set Trigger |
| 3 | 2.570      | 0.023             | 0.004           | 0.042      | 0.035             |           | Set Trigger |
| 4 | 2.569      | 0.023             | 0.004           | 0.042      | 0.035             |           | Set Trigger |
| 5 | 2.591      | 0.024             | 0.004           | 0.042      | 0.037             |           | Set Trigger |

Aug 2, 58

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R.P. 6/26/09

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 | 4.063      | 0.028             | 0.005           | 0.038      | 0.067             |           | Set Trigger |
| 2 | 4.111      | 0.028             | 0.005           | 0.038      | 0.066             |           | Set Trigger |
| 3 | 3.988      | 0.028             | 0.005           | 0.038      | 0.066             |           | Set Trigger |
| 4 | 4.123      | 0.028             | 0.005           | 0.037      | 0.067             |           | Set Trigger |
| 5 | 4.204      | 0.029             | 0.005           | 0.037      | 0.070             |           | Set Trigger |

Avg 4.09