

G6868463

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

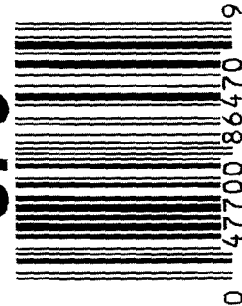


BM FORM

|               |       |
|---------------|-------|
| ORDER NO.     | 86470 |
| BARREL LENGTH | 24"   |
| CAPACITY      | 6     |

G6868463

UPC



GUN SERIAL # G 686 8463

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                     | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                              | 7-20-09 | SP                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                              | 7-20-09 | SP                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                              | 7-20-09 | SP                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX                                                                                 | 7-20-09 | SP                                                                                  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                              | 7-20-09 | SP                                                                                  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                              |         |                                                                                     |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 7/28/09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                              |         |                                                                                     |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                              | 7-28-09 | DWD                                                                                 |
| 510  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                              | 7-21-09 | SP                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                              | 7-31-09 | SP                                                                                  |
| 540  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                              | 8/12    |                                                                                     |
| 545  | (BOLT)                                                                                                                                 |                                                                                              |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                              |         |                                                                                     |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                              | 7-13-09 | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                              | 8-13-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 | INSPECT FOR LIVE AMMO                                                                        | 8-13-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                              | 8-31-09 | SP                                                                                  |
|      | 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

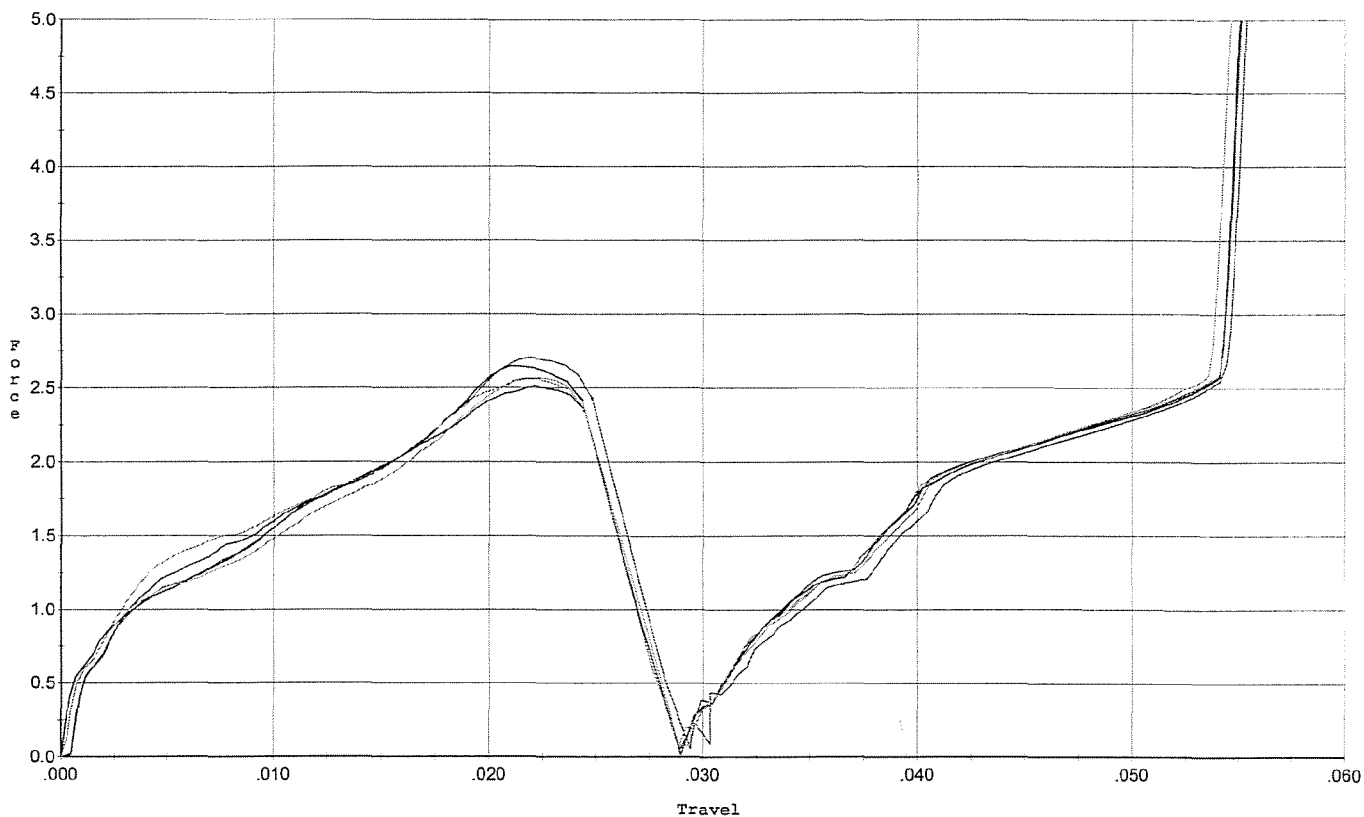
|              |                                                                       |                                           |            |      |                |         |      |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|------------|------|----------------|---------|------|
| 560          | BARBER - M24 0094882<br>F) SAFETY ON FORCE                            | 2 LBS MIN<br>10 LBS MAX                   | 2.0        | 2.0  | 2.2            | 9-1-09  | RP   |
| CONT.        | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | 3.8        | 3.6  | 3.6            | 9-1-09  | RP   |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |            |      |                |         |      |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | .022       | .022 | .023           | 9-1-09  | RP   |
|              | J) ASSEMBLE STOCK                                                     |                                           |            |      |                | 8-31-09 | RP   |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |            |      |                | 9-1-09  | RP   |
|              | 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       | FAIL |                | 9/1/09  | RP   |
|              |                                                                       |                                           | PASS       | FAIL |                |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION |      |                |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION | N/A  |                |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION |      |                |         |      |
|              | MALFUNCTION                                                           |                                           | CORRECTION |      |                |         |      |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |            |      |                | 9/1/09  | TAIR |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |            |      |                | 9-1-09  | RP   |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | 2.81       | 2.83 | 2.70 2.67 2.60 | 9-1-09  | RP   |
|              | C) FUNCTION                                                           |                                           |            |      |                | 9-1-09  | RP   |
| 690          | PACK                                                                  |                                           |            |      |                | 9-2-09  | TC   |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/28/2009

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



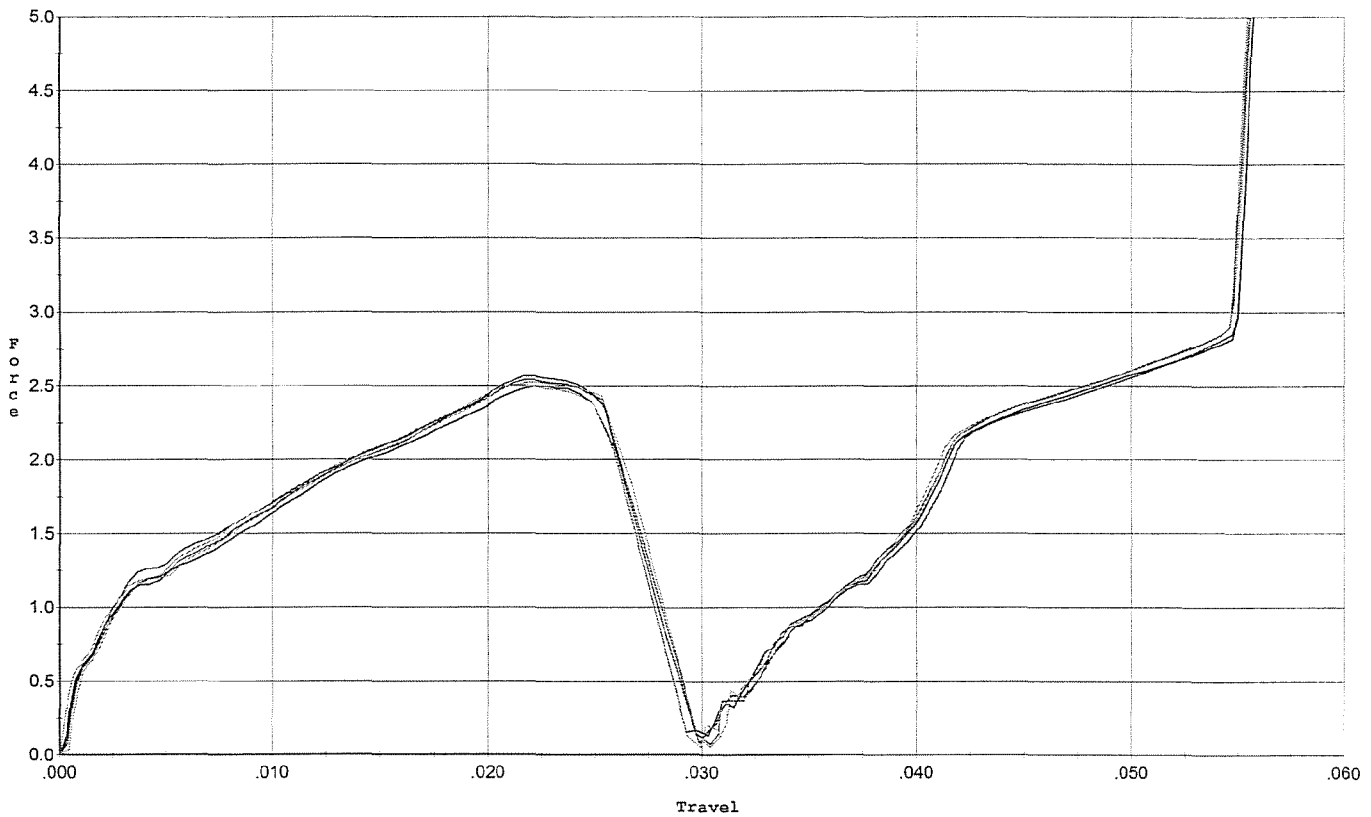
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.514      | 0.024             | 0.00            | 0.035      | 0.040             |           | Set Trigger |
| 2 | 2.647      | 0.024             | 0.00            | 0.035      | 0.041             |           | Set Trigger |
| 3 | 2.705      | 0.025             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 4 | 2.562      | 0.027             | 0.00            | 0.035      | 0.043             |           | Set Trigger |
| 5 | 2.561      | 0.024             | 0.00            | 0.035      | 0.042             |           | Set Trigger |

A-2-59

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: cms 8/28/2009

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



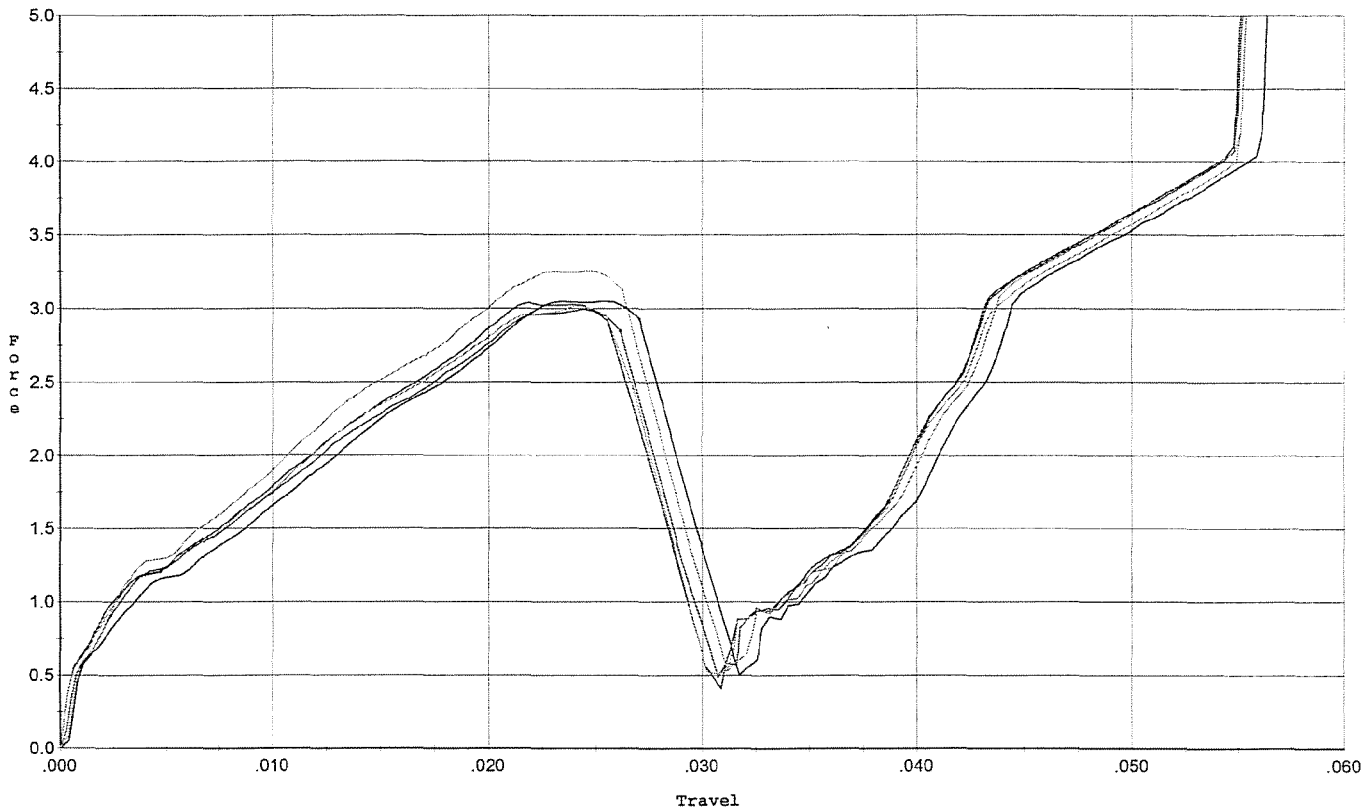
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.567      | 0.025             | 0.00            | 0.035      | 0.045             |           | Set Trigger |
| 2 | 2.497      | 0.026             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 3 | 2.539      | 0.028             | 0.00            | 0.034      | 0.048             |           | Set Trigger |
| 4 | 2.526      | 0.027             | 0.00            | 0.035      | 0.046             |           | Set Trigger |
| 5 | 2.506      | 0.026             | 0.00            | 0.035      | 0.045             |           | Set Trigger |

A-2-52

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: cms 8/28/2009

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



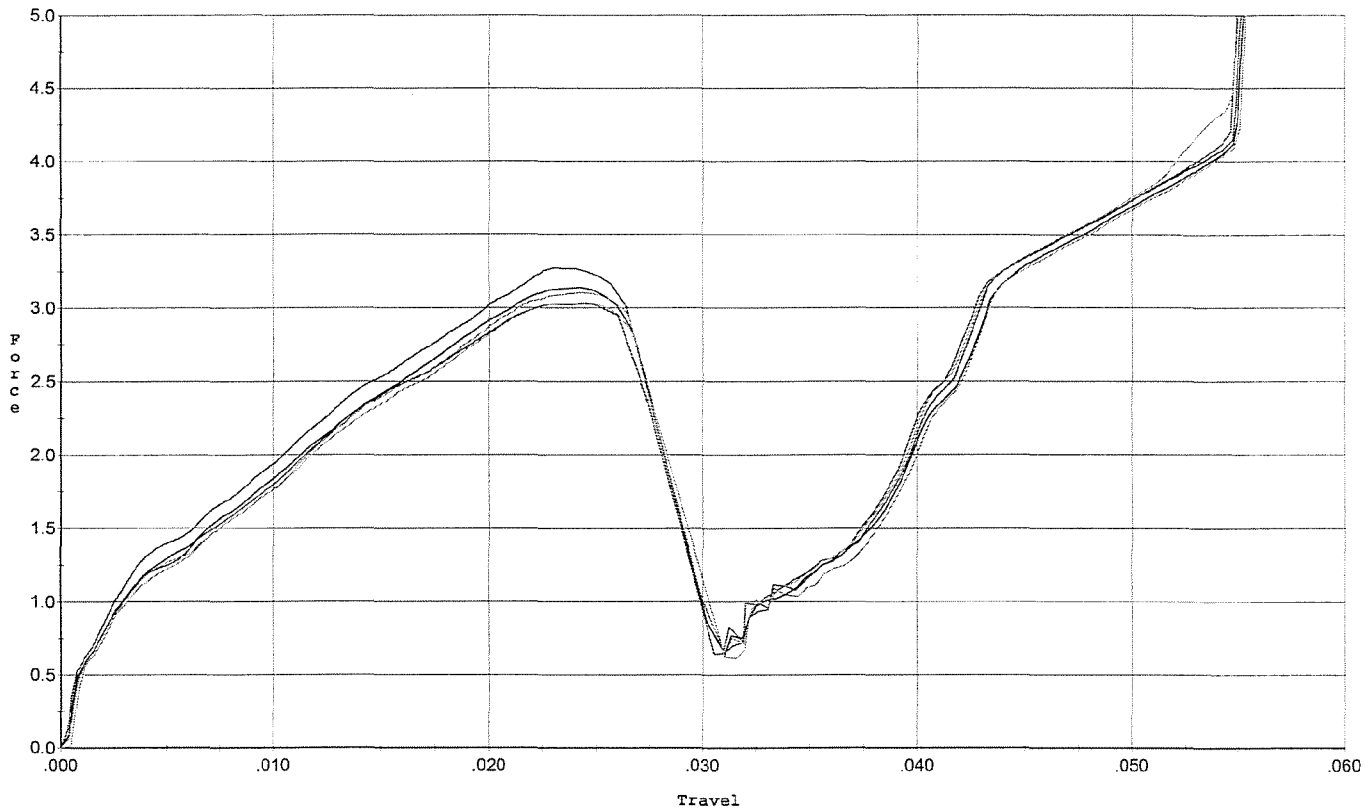
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.040      | 0.028             | 0.00            | 0.033      | 0.054             |           | Set Trigger |
| 2 | 3.050      | 0.027             | 0.00            | 0.033      | 0.052             |           | Set Trigger |
| 3 | 2.996      | 0.026             | 0.00            | 0.033      | 0.051             |           | Set Trigger |
| 4 | 3.016      | 0.027             | 0.00            | 0.033      | 0.053             |           | Set Trigger |
| 5 | 3.257      | 0.026             | 0.00            | 0.033      | 0.055             |           | Set Trigger |

A.3.07

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/28/2009

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



| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.274      | 0.026             | 0.00            | 0.033      | 0.056             |           | Set Trigger |
| 2 | 3.139      | 0.027             | 0.00            | 0.033      | 0.054             |           | Set Trigger |
| 3 | 3.034      | 0.027             | 0.00            | 0.032      | 0.055             |           | Set Trigger |
| 4 | 3.034      | 0.027             | 0.00            | 0.032      | 0.053             |           | Set Trigger |
| 5 | 3.105      | 0.027             | 0.00            | 0.032      | 0.053             |           | Set Trigger |

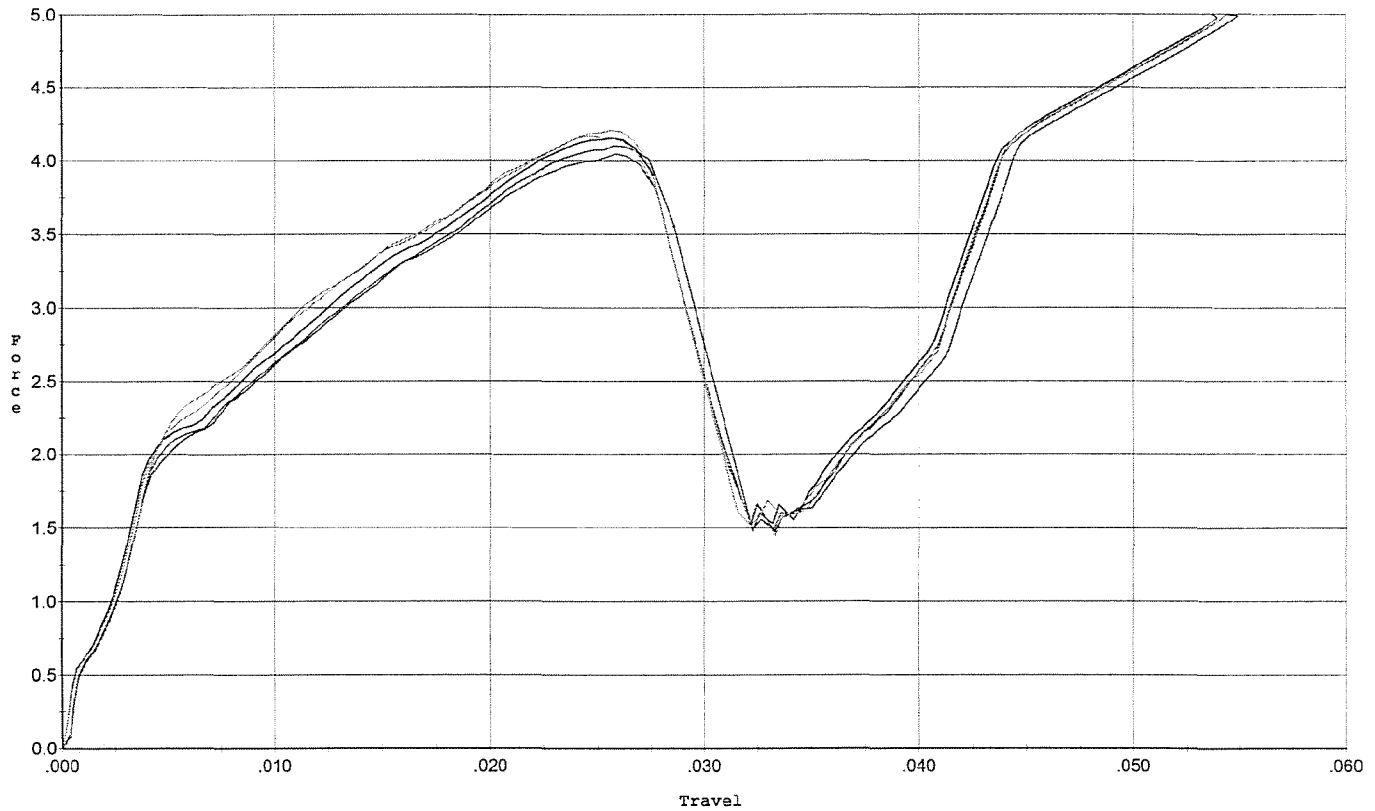
A-3-11



## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/28/2009

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



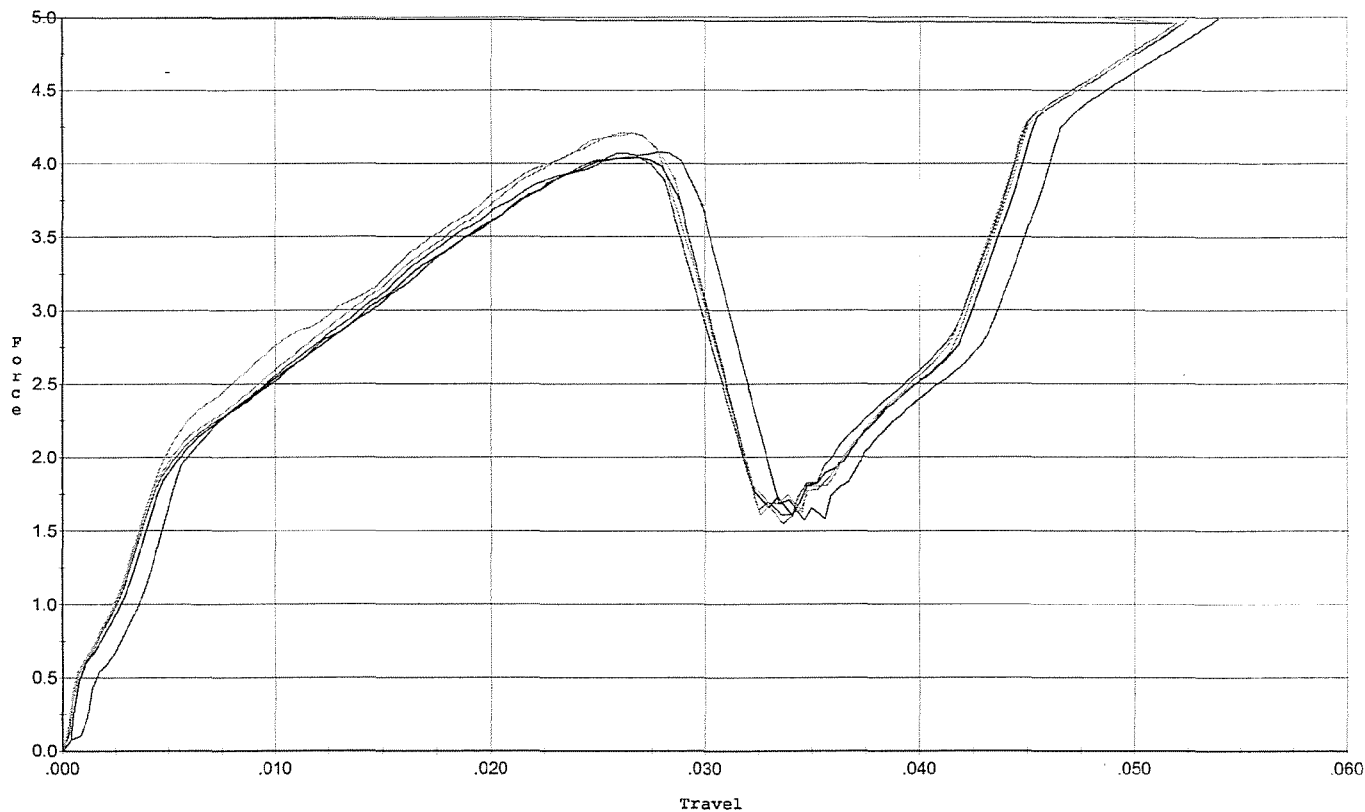
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.101      | 0.029             | 0.00            | 0.025      | 0.078             |           | Set Trigger |
| 2 | 4.153      | 0.028             | 0.00            | 0.025      | 0.077             |           | Set Trigger |
| 3 | 4.045      | 0.028             | 0.00            | 0.025      | 0.075             |           | Set Trigger |
| 4 | 4.167      | 0.028             | 0.00            | 0.025      | 0.078             |           | Set Trigger |
| 5 | 4.206      | 0.028             | 0.00            | 0.025      | 0.078             |           | Set Trigger |

A 4.13

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: cms 8/28/2009

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



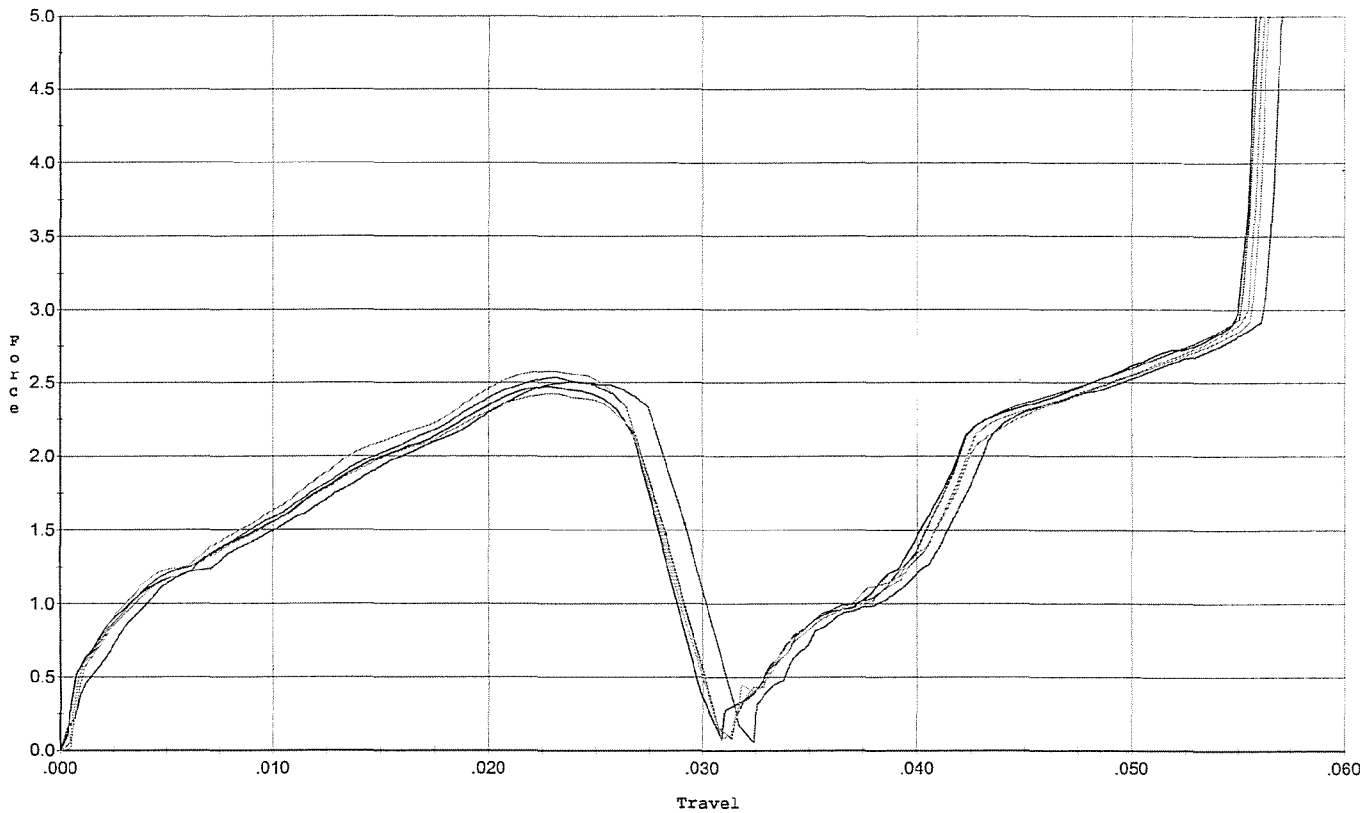
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.075      | 0.030             | 0.00            | 0.025      | 0.080             |           | Set Trigger |
| 2 | 4.039      | 0.029             | 0.00            | 0.025      | 0.078             |           | Set Trigger |
| 3 | 4.042      | 0.028             | 0.00            | 0.025      | 0.076             |           | Set Trigger |
| 4 | 4.211      | 0.029             | 0.00            | 0.024      | 0.079             |           | Set Trigger |
| 5 | 4.209      | 0.029             | 0.00            | 0.025      | 0.083             |           | Set Trigger |

A 4.11

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: cms 8/28/2009

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



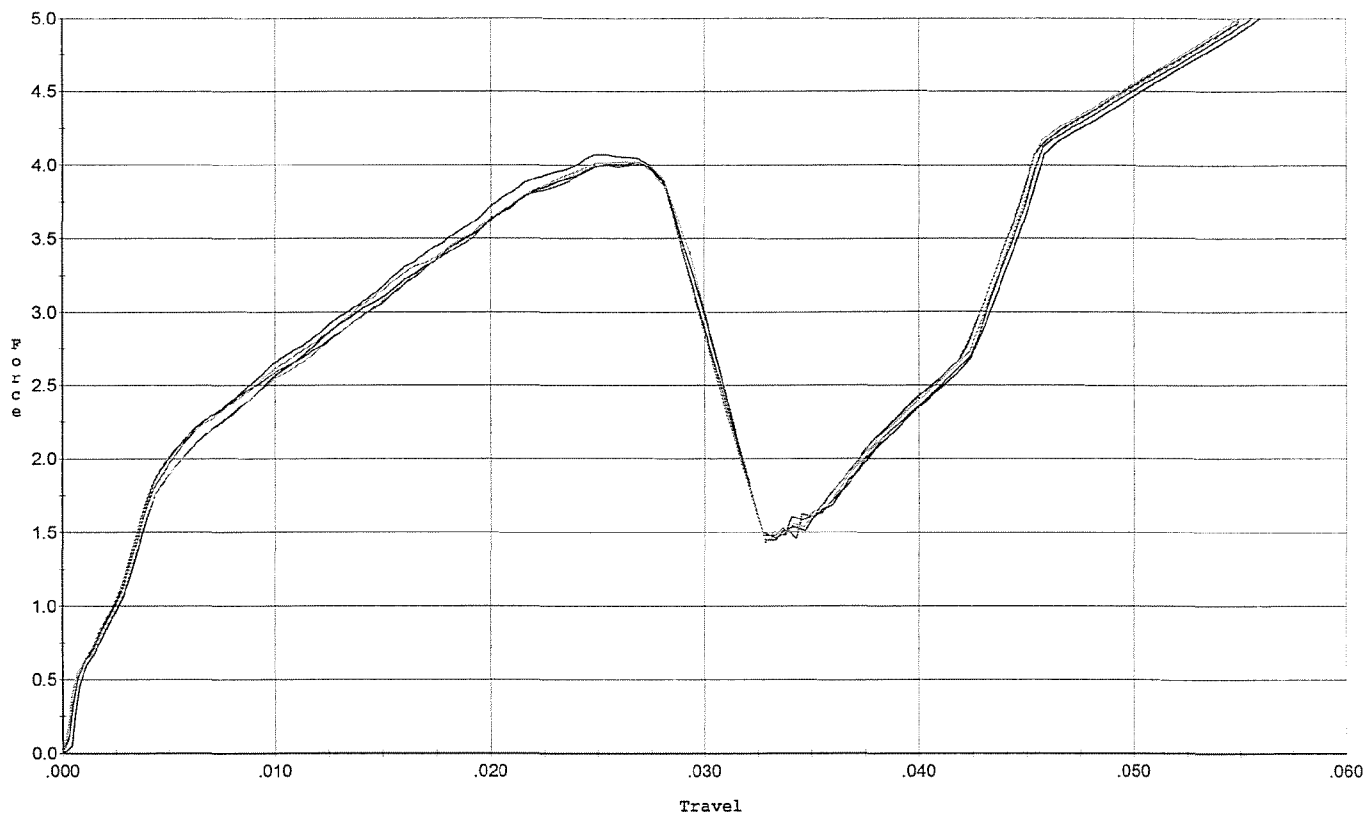
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.505      | 0.029             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 2 | 2.474      | 0.027             | 0.00            | 0.034      | 0.045             |           | Set Trigger |
| 3 | 2.534      | 0.028             | 0.00            | 0.034      | 0.048             |           | Set Trigger |
| 4 | 2.580      | 0.026             | 0.00            | 0.035      | 0.047             |           | Set Trigger |
| 5 | 2.424      | 0.027             | 0.00            | 0.035      | 0.045             |           | Set Trigger |

A-250

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: cms 8/28/2009

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 | 4.072      | 0.028             | 0.00            | 0.026      | 0.077             |           | Set Trigger |
| 2 | 4.021      | 0.030             | 0.00            | 0.026      | 0.080             |           | Set Trigger |
| 3 | 4.006      | 0.028             | 0.00            | 0.026      | 0.076             |           | Set Trigger |
| 4 | 4.026      | 0.029             | 0.00            | 0.026      | 0.079             |           | Set Trigger |
| 5 | 4.023      | 0.028             | 0.00            | 0.026      | 0.077             |           | Set Trigger |

A. 4.03