



No. 153L

UPC 10330

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66765004

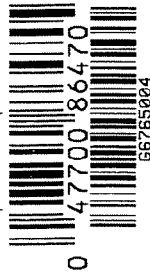
**M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)**

**BOLT ACTION CENTERFIRE RIFLE**

**24" BARREL 7.62 NATO**

**WITH BIPOD**

proof of purchase



owner registration sticker



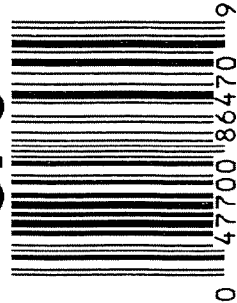
**ORDER NO. 86470**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6765004**

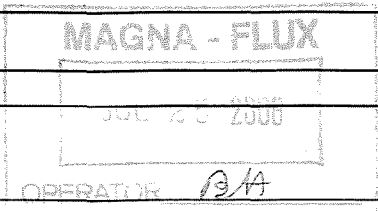
**UPC**



**BM FORM**

GUN SERIAL #

G 676 5004

| OP # | OPERATION NAME                                                 | READINGS                                                                           | DATE    | INITIAL |
|------|----------------------------------------------------------------|------------------------------------------------------------------------------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                |                                                                                    | 7-15-08 | BSN     |
| 430  | ASSEMBLE TO STOCK                                              |                                                                                    | 7-15-08 | SP      |
| 440  | PROOF                                                          |                                                                                    | 7-15-08 | SP      |
| 460  | CHECK HEADSPACE                                                |                                                                                    | 7-15-08 | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                                                                                    | 7-16-08 | RR      |
| 472  | SERIALIZE BOLT HANDLE                                          |                                                                                    | 7-16-08 | RR      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |  | 7-17-08 | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           |                                                                                    | 7-25-08 | B/A     |
| 490  | MAGNAFLUX BOLT                                                 |                                                                                    |         |         |
| 500  | ROLLMARK CALIBER                                               |                                                                                    | 7-25-08 | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                                                                                    | 7-25-08 | DS      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                                                                                    | P2      |         |
| 545  | (BOLT)                                                         |                                                                                    |         |         |
| 560  | RE-ASSEMBLE ACTION                                             |                                                                                    |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                                                                                    | 8-4-08  | BSN     |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                                                                                    | 8-4-08  | BSN     |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                                                                                    | 8-4-08  | BSN     |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                                                                                    | 8-5-08  | BSN     |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS                                                                |         |         |

F004 REV 5/2006

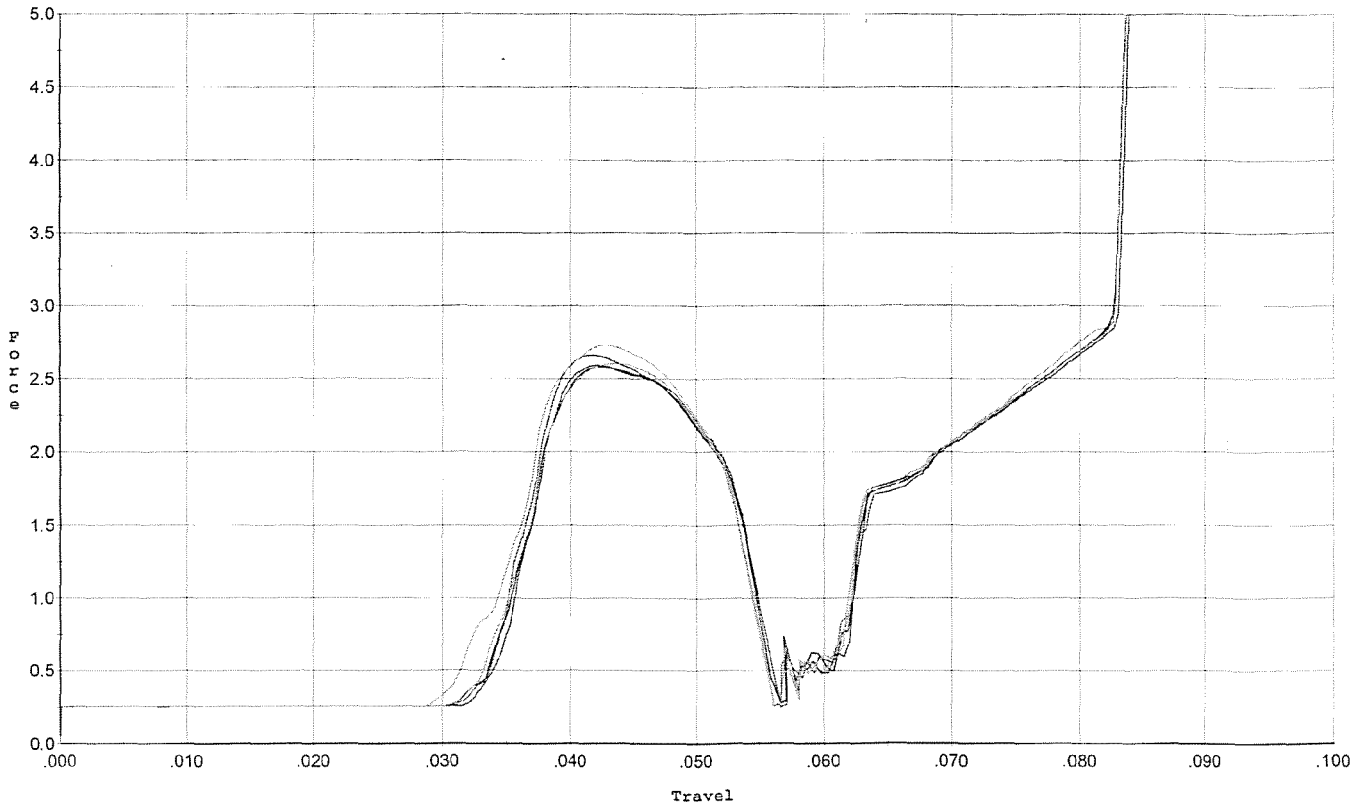
| OP #         | OPERATION NAME                                                                   | READINGS                                                    | DATE    | INITIAL |
|--------------|----------------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | BARBER - M24 0129690<br>F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span> | <u>3 LBS</u> <u>3 LBS</u> <u>3 LBS</u>                      | 8-13-08 | L.P.D.  |
| CONT.        |                                                                                  |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                                       | <u>5 LBS</u> <u>4 1/2 LBS</u> <u>4 1/2 LBS</u>              | 8-13-08 | L.P.D.  |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                        |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                                       | <u>.023</u> <u>.020</u> <u>.026</u>                         | 8-13-08 | L.P.D.  |
|              | J) ASSEMBLE STOCK                                                                |                                                             | 8-5-08  | ESW     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                                      |                                                             | 8-13-08 | L.P.D.  |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                         |                                                             | 8-13-08 | L.P.D.  |
|              | M) IRON SIGHT<br>ALIGNMENT                                                       |                                                             | 8-13-08 | L.P.D.  |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER            |                                                             | 8-13-08 | L.P.D.  |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                                      | <u>PASS</u> FAIL<br><u>PASS</u> FAIL                        | 8-6-08  | TRW     |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                                      | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                            |                                                             | 8-6-08  | TL      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                                 |                                                             | 8-13-08 | L.P.D.  |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span>         | <u>2.81</u> <u>2.36</u> <u>2.27</u> <u>2.29</u> <u>2.28</u> | 8-7-08  | TRW     |
|              | C) FUNCTION                                                                      |                                                             | 8-13-08 | L.P.D.  |
| 690          | PACK                                                                             |                                                             | 8/24/08 | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 7/22/08

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



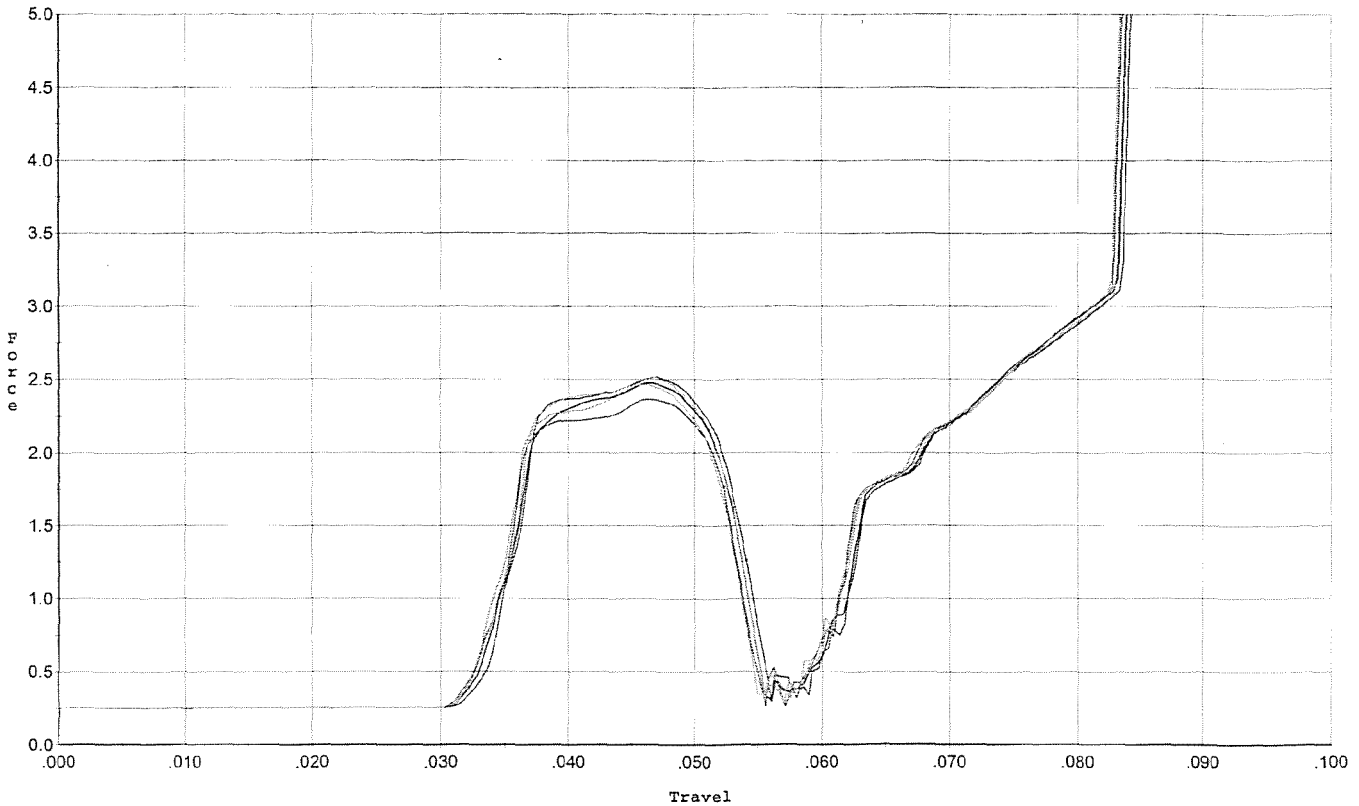
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.591      | 0.054             | 0.034           | 0.036      | 0.050             |           | Set Trigger |
| 2 | 2.581      | 0.054             | 0.034           | 0.036      | 0.051             |           | Set Trigger |
| 3 | 2.661      | 0.053             | 0.034           | 0.036      | 0.050             |           | Set Trigger |
| 4 | 2.601      | 0.054             | 0.033           | 0.036      | 0.051             |           | Set Trigger |
| 5 | 2.727      | 0.053             | 0.031           | 0.036      | 0.053             |           | Set Trigger |

Avg 2.63

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 7/22/08

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



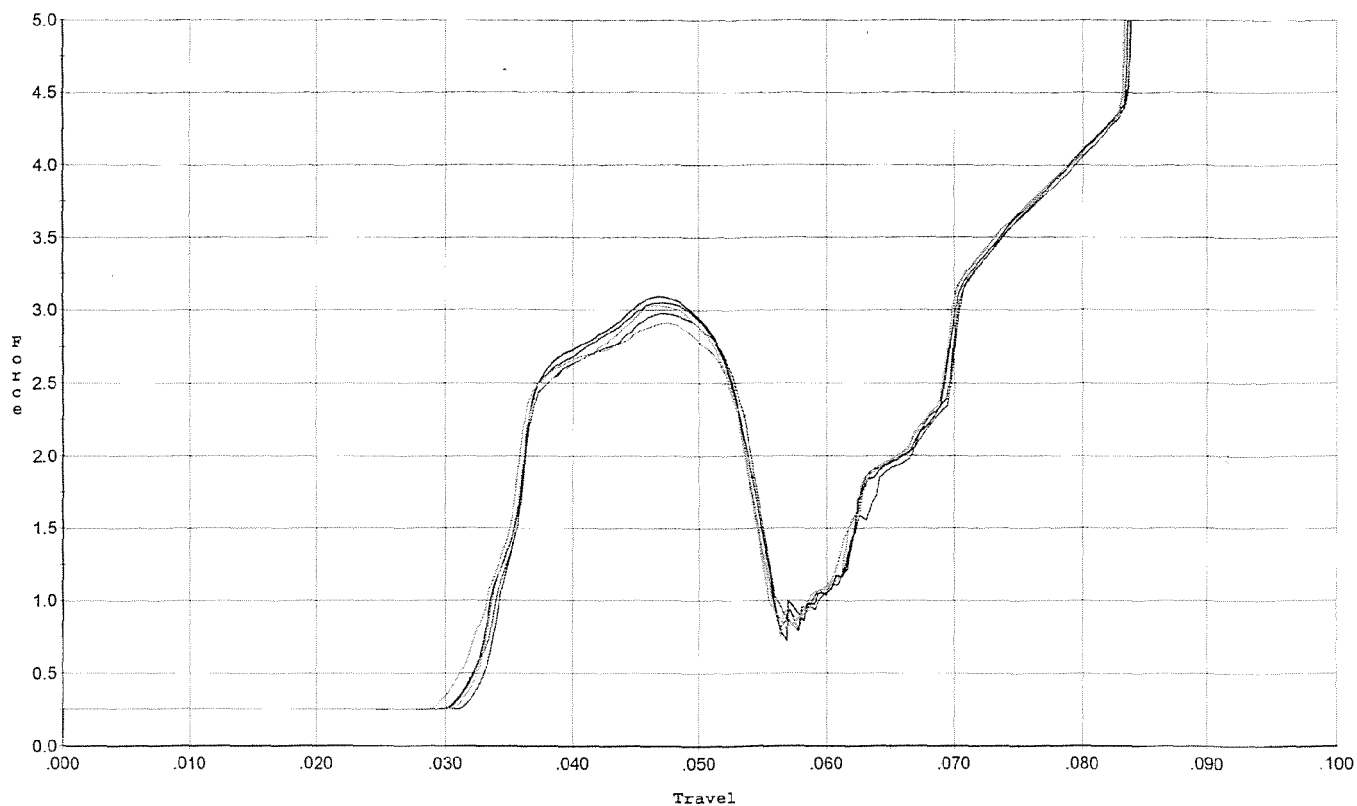
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.513      | 0.054             | 0.034           | 0.036      | 0.052             |           | Set Trigger |
| 2 | 2.474      | 0.053             | 0.033           | 0.036      | 0.050             |           | Set Trigger |
| 3 | 2.364      | 0.052             | 0.032           | 0.036      | 0.048             |           | Set Trigger |
| 4 | 2.518      | 0.053             | 0.032           | 0.036      | 0.051             |           | Set Trigger |
| 5 | 2.465      | 0.053             | 0.032           | 0.036      | 0.050             |           | Set Trigger |

Avg 2.46

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 7/22/08

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



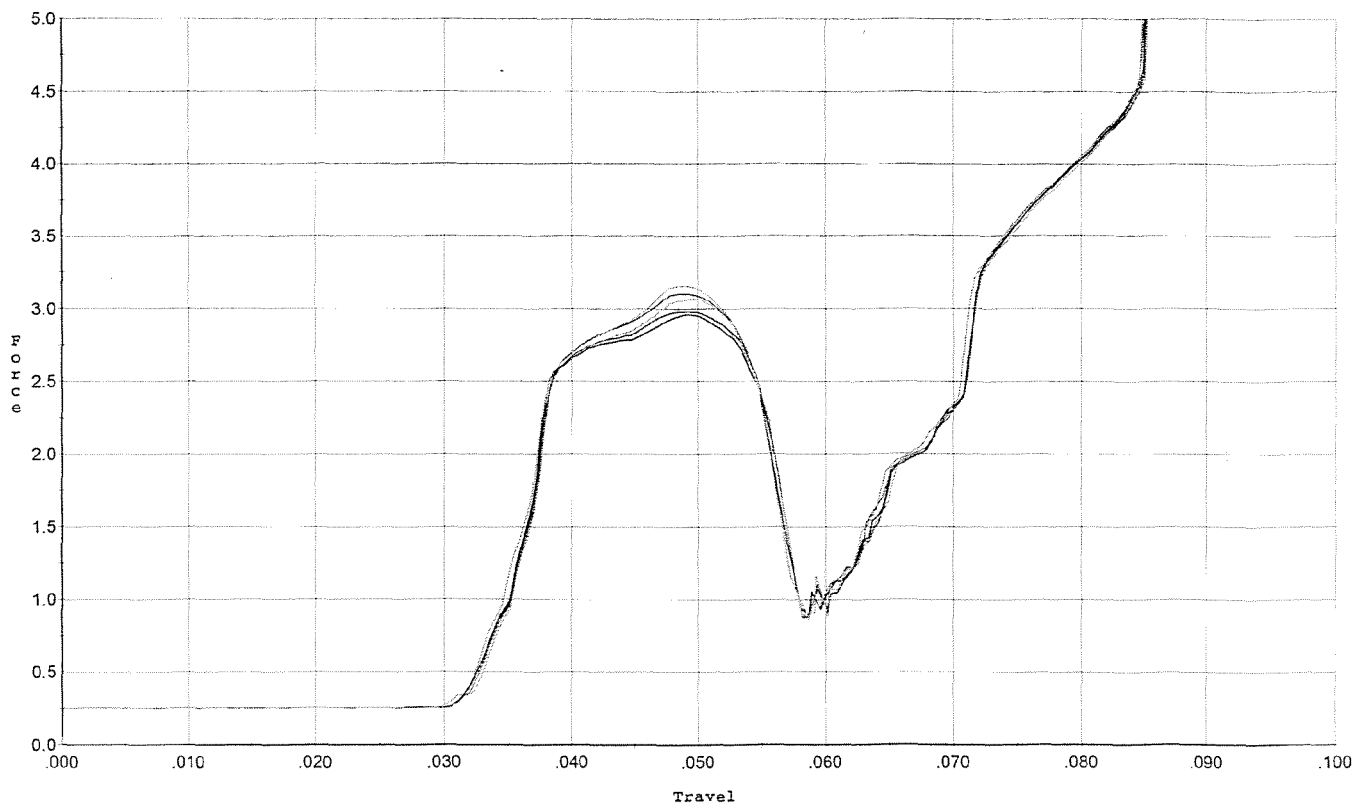
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.047      | 0.053             | 0.033           | 0.035      | 0.060             |           | Set Trigger |
| 2 | 3.091      | 0.054             | 0.032           | 0.035      | 0.063             |           | Set Trigger |
| 3 | 2.974      | 0.054             | 0.032           | 0.035      | 0.061             |           | Set Trigger |
| 4 | 3.030      | 0.053             | 0.032           | 0.035      | 0.060             |           | Set Trigger |
| 5 | 2.912      | 0.053             | 0.031           | 0.034      | 0.060             |           | Set Trigger |

Avg 3.01

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 7/22/08

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



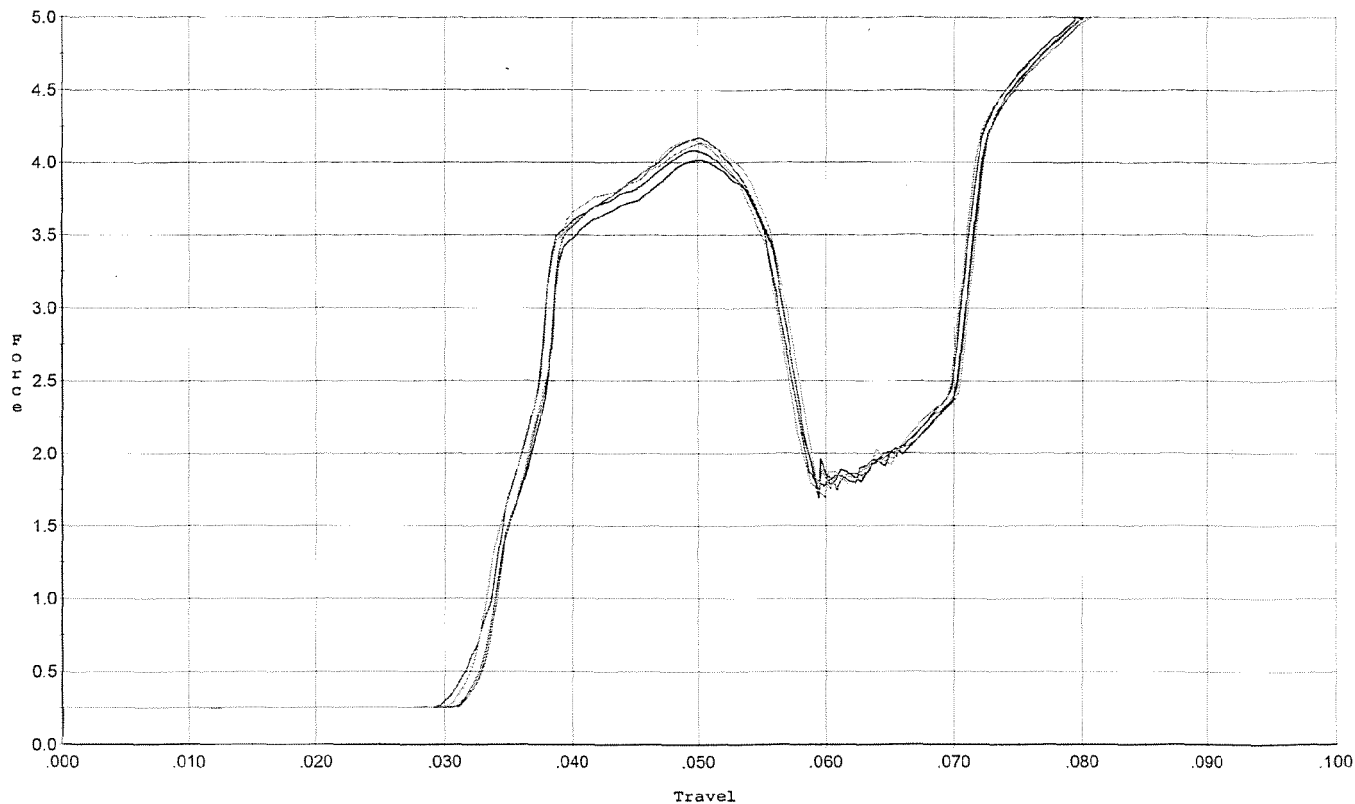
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.980      | 0.056             | 0.032           | 0.035      | 0.065             |           | Set Trigger |
| 2 | 2.960      | 0.055             | 0.032           | 0.035      | 0.063             |           | Set Trigger |
| 3 | 3.101      | 0.056             | 0.032           | 0.035      | 0.065             |           | Set Trigger |
| 4 | 3.068      | 0.056             | 0.033           | 0.035      | 0.065             |           | Set Trigger |
| 5 | 3.158      | 0.055             | 0.032           | 0.035      | 0.065             |           | Set Trigger |

Avg 3.05

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 7/22/08

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



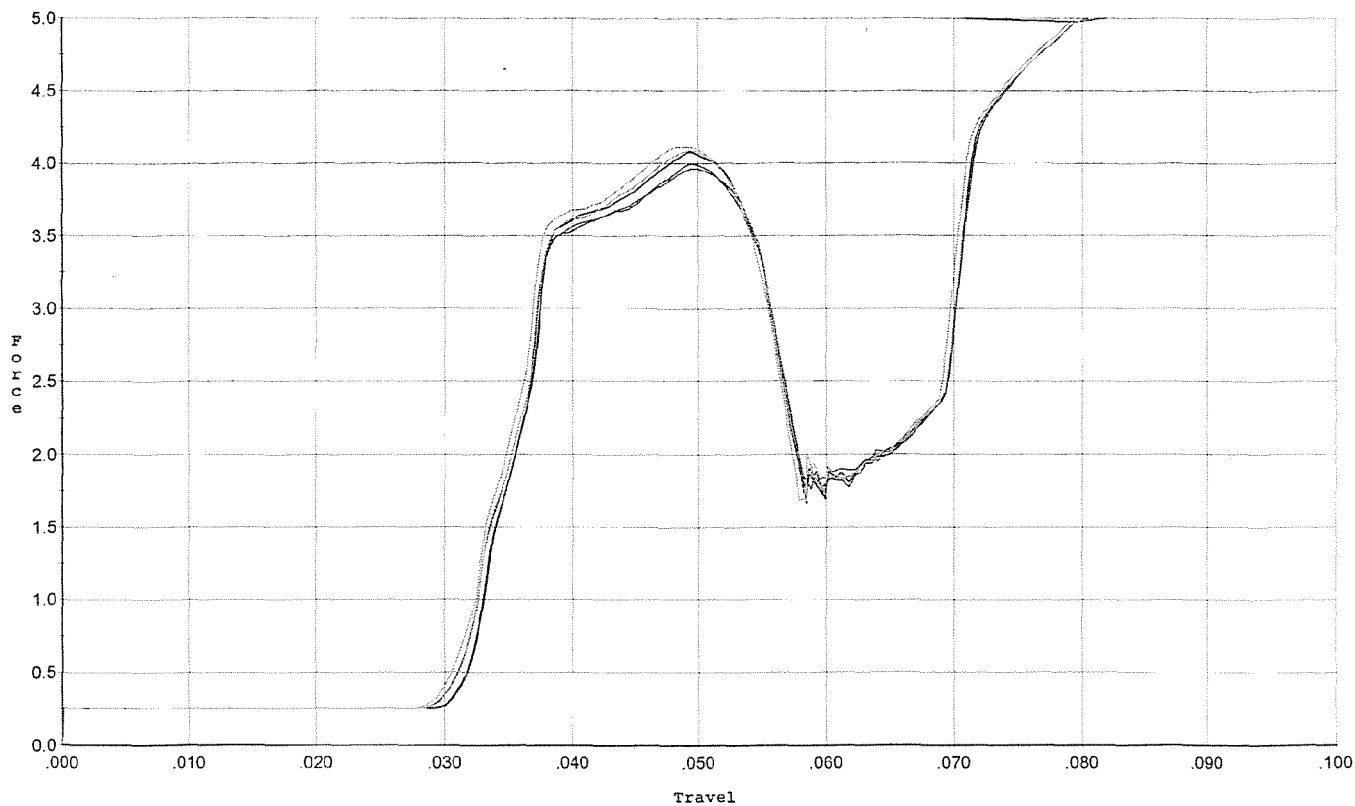
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.081      | 0.055             | 0.031           | 0.033      | 0.086             |           | Set Trigger |
| 2 | 4.015      | 0.056             | 0.032           | 0.033      | 0.084             |           | Set Trigger |
| 3 | 4.171      | 0.056             | 0.032           | 0.033      | 0.086             |           | Set Trigger |
| 4 | 4.137      | 0.057             | 0.032           | 0.033      | 0.089             |           | Set Trigger |
| 5 | 4.155      | 0.055             | 0.031           | 0.033      | 0.086             |           | Set Trigger |

Avg 4.11

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 7/22/08

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



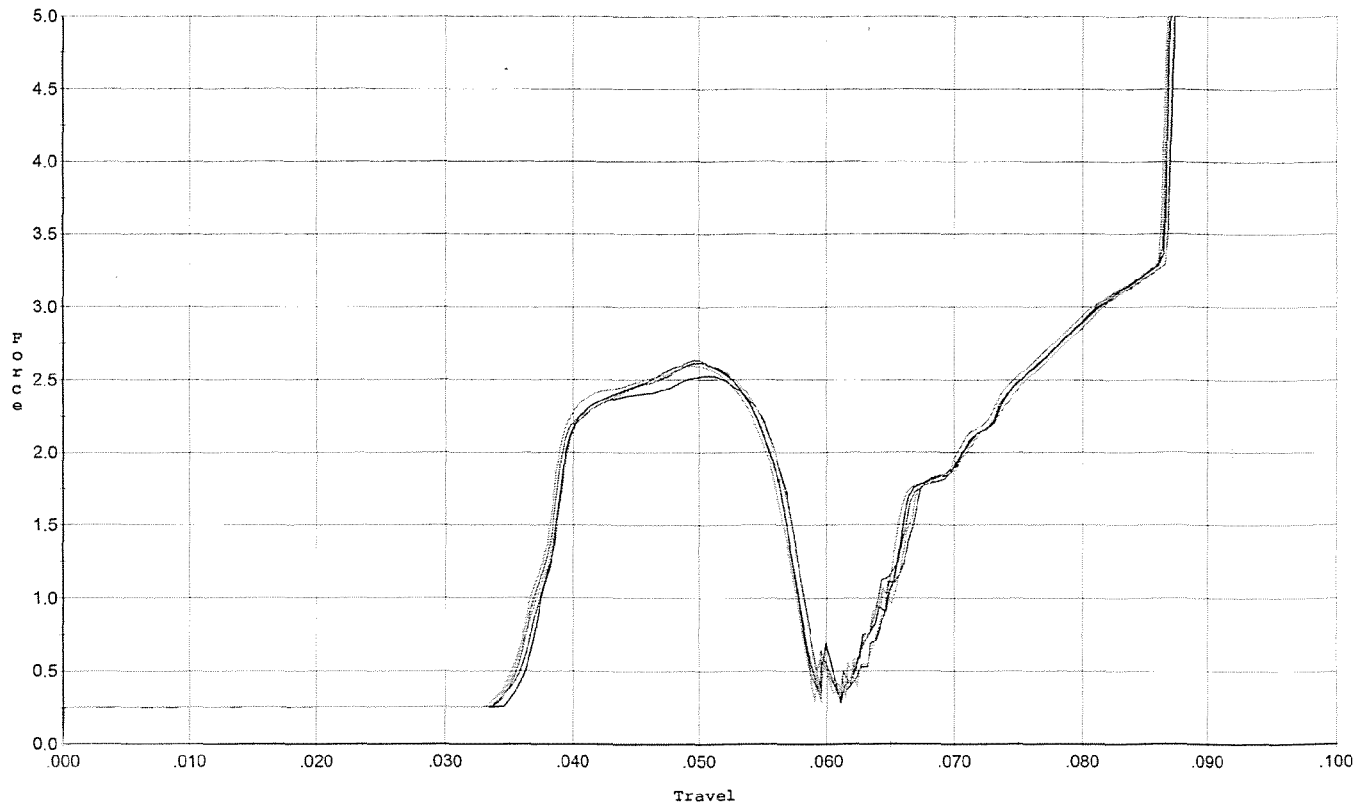
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.997      | 0.055             | 0.031           | 0.033      | 0.084             |           | Set Trigger |
| 2 | 4.080      | 0.055             | 0.031           | 0.033      | 0.085             |           | Set Trigger |
| 3 | 3.963      | 0.055             | 0.031           | 0.032      | 0.085             |           | Set Trigger |
| 4 | 4.085      | 0.055             | 0.031           | 0.033      | 0.086             |           | Set Trigger |
| 5 | 4.118      | 0.055             | 0.030           | 0.032      | 0.089             |           | Set Trigger |

Avg 4.04

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 7/22/08

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



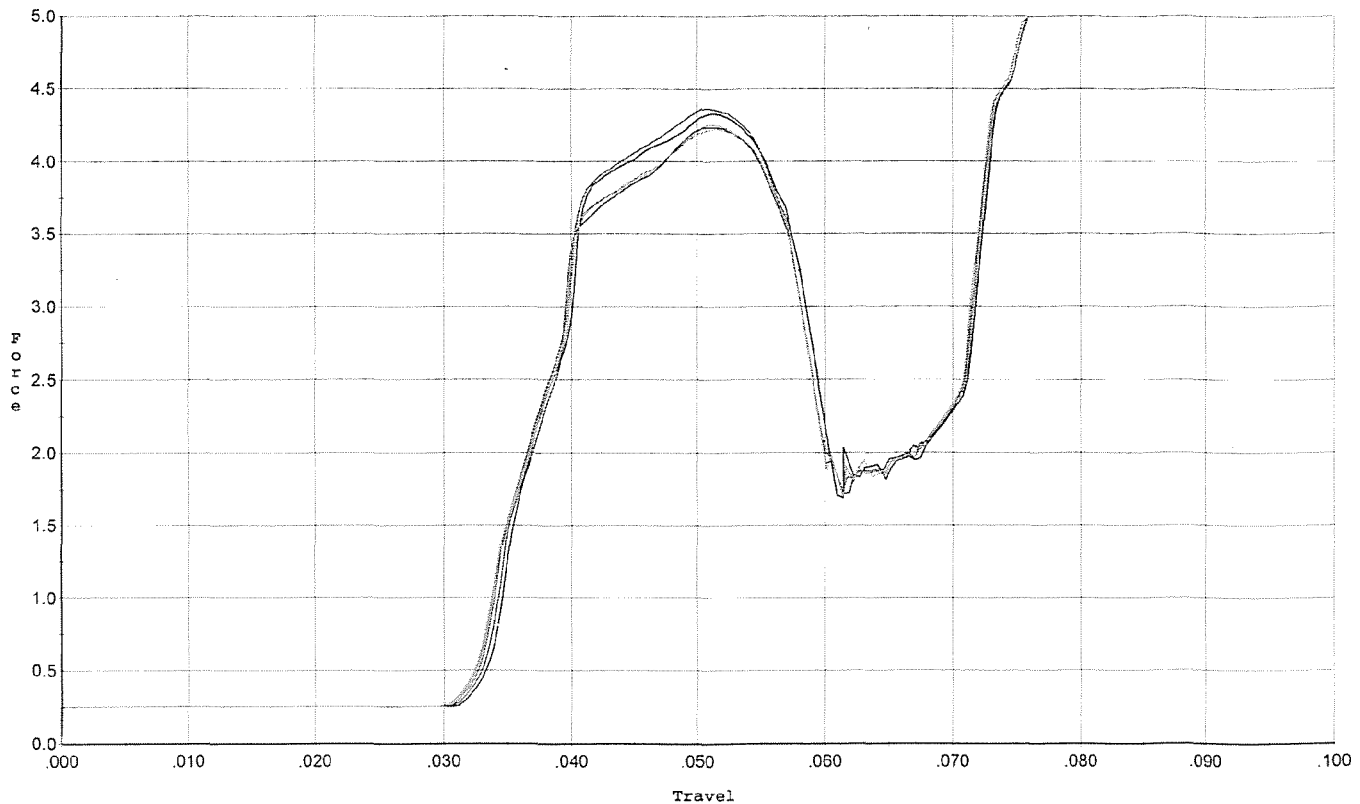
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.528      | 0.057             | 0.036           | 0.036      | 0.055             |           | Set Trigger |
| 2 | 2.620      | 0.056             | 0.036           | 0.037      | 0.054             |           | Set Trigger |
| 3 | 2.634      | 0.056             | 0.035           | 0.036      | 0.055             |           | Set Trigger |
| 4 | 2.615      | 0.057             | 0.035           | 0.036      | 0.056             |           | Set Trigger |
| 5 | 2.595      | 0.057             | 0.034           | 0.036      | 0.056             |           | Set Trigger |

Avg 2.59

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 7/22/08

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 | 4.236      | 0.057             | 0.033           | 0.028      | 0.091             |           | Set Trigger |
| 2 | 4.329      | 0.058             | 0.033           | 0.028      | 0.094             |           | Set Trigger |
| 3 | 4.364      | 0.057             | 0.032           | 0.028      | 0.094             |           | Set Trigger |
| 4 | 4.224      | 0.057             | 0.032           | 0.028      | 0.092             |           | Set Trigger |
| 5 | 4.256      | 0.057             | 0.032           | 0.028      | 0.091             |           | Set Trigger |

Avg 4.28