

66810354

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



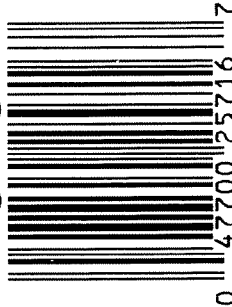
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

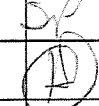
G6810354

UPC



GUN SERIAL #

66810354

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 3-6-09  | RZ                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 3-6-09  | RT                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                             | 3-6-09  | TC                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 3-6-09  | TC                                                                                  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 3-6-09  | SP                                                                                  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX                                                                                | 3-9-09  | RT                                                                                  |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                             | 3-9-09  | SP                                                                                  |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 3/13/09 |  |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                             | 3/13/09 | MR                                                                                  |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                             | 3/13/09 | RT                                                                                  |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                             | 3-16    | BT                                                                                  |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                             | 3/24    | —                                                                                   |
| 545  | (BOLT)                                                                                                                                 |                                                                                             |         |                                                                                     |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                             |         |                                                                                     |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                             | 3-25-09 | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-25-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-25-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-26-09 | 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

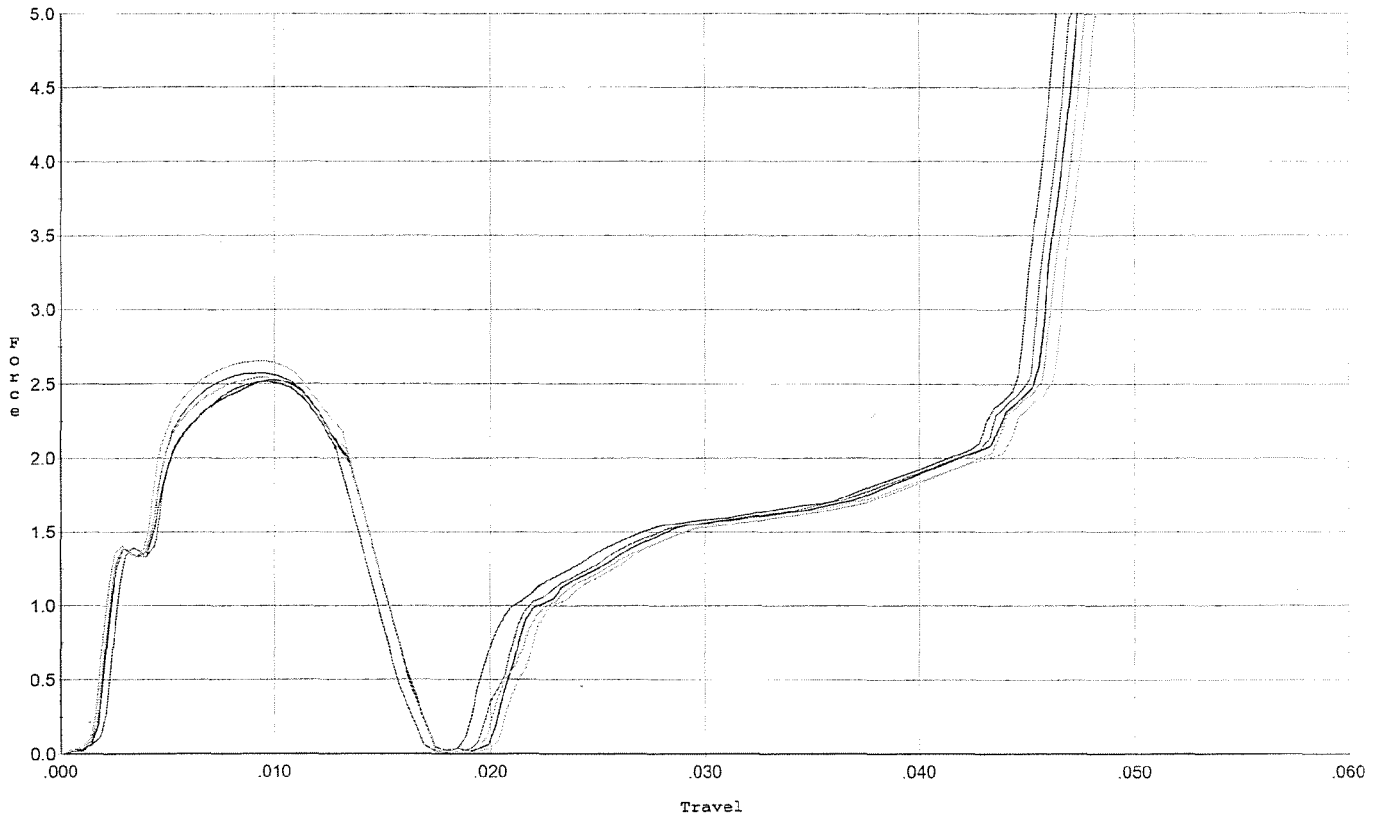
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>40</u> <u>40</u> <u>30</u>                               | 3-30-09 | R.N.    |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>50</u> <u>50</u> <u>60</u>                               | 3-30-09 | R.N.    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 3-30-09 | R.N.    |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-26-09 | R.N.    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-30-09 | R.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                        | 3-27-09 | TL      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-27-09 | W.W.    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-30-09 | R.N.    |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.41</u> <u>2.42</u> <u>2.41</u> <u>2.37</u> <u>2.37</u> | 3-28-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3-30-09 | R.N.    |
| 690          | PACK                                                                     |                                                             | 4/13/09 | Fm      |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



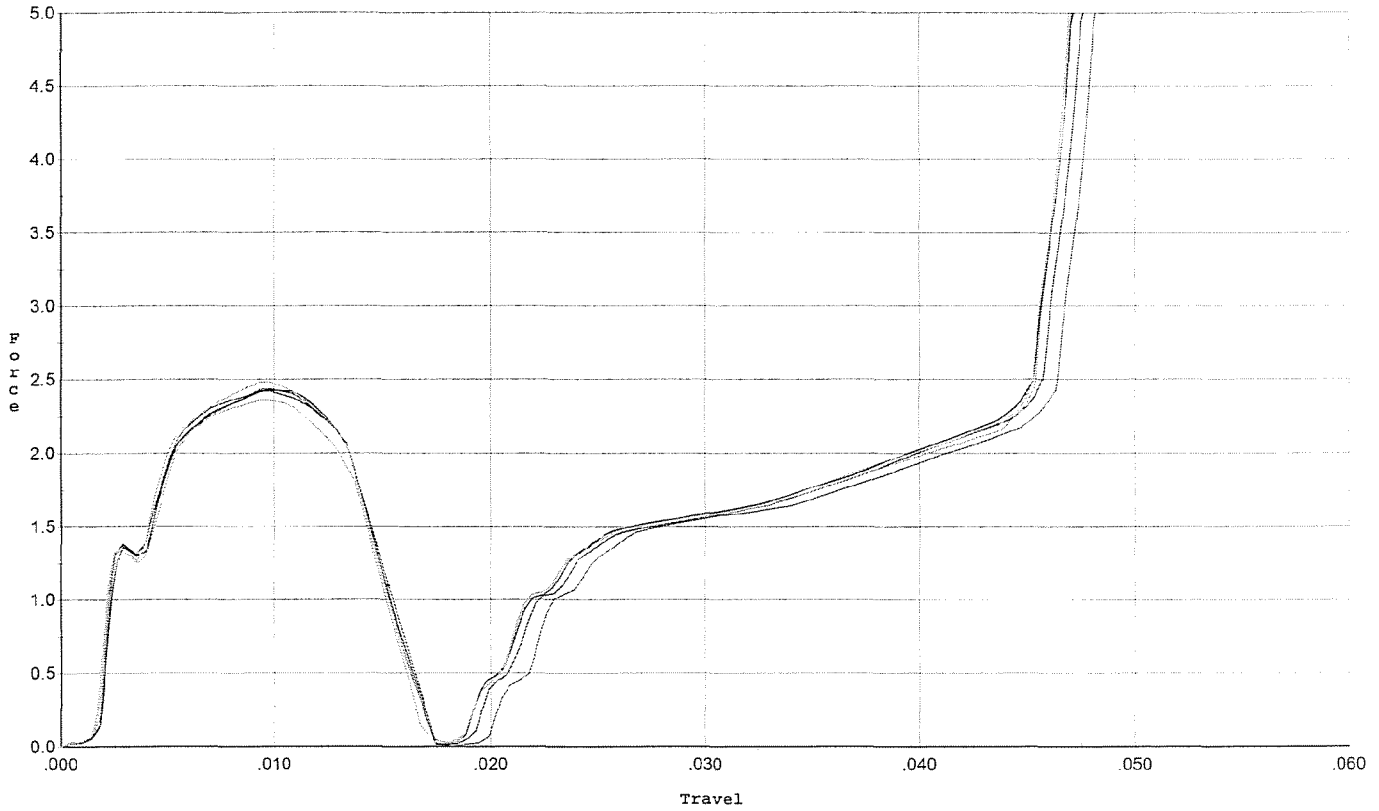
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.514      | 0.013             | 0.00            | 0.037      | 0.021             |           | Set Trigger |
| 2 | 2.526      | 0.013             | 0.004           | 0.038      | 0.023             |           | Set Trigger |
| 3 | 2.571      | 0.014             | 0.00            | 0.038      | 0.023             |           | Set Trigger |
| 4 | 2.544      | 0.013             | 0.00            | 0.039      | 0.023             |           | Set Trigger |
| 5 | 2.655      | 0.013             | 0.00            | 0.038      | 0.024             |           | Set Trigger |

A-2.56

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/2/2009

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



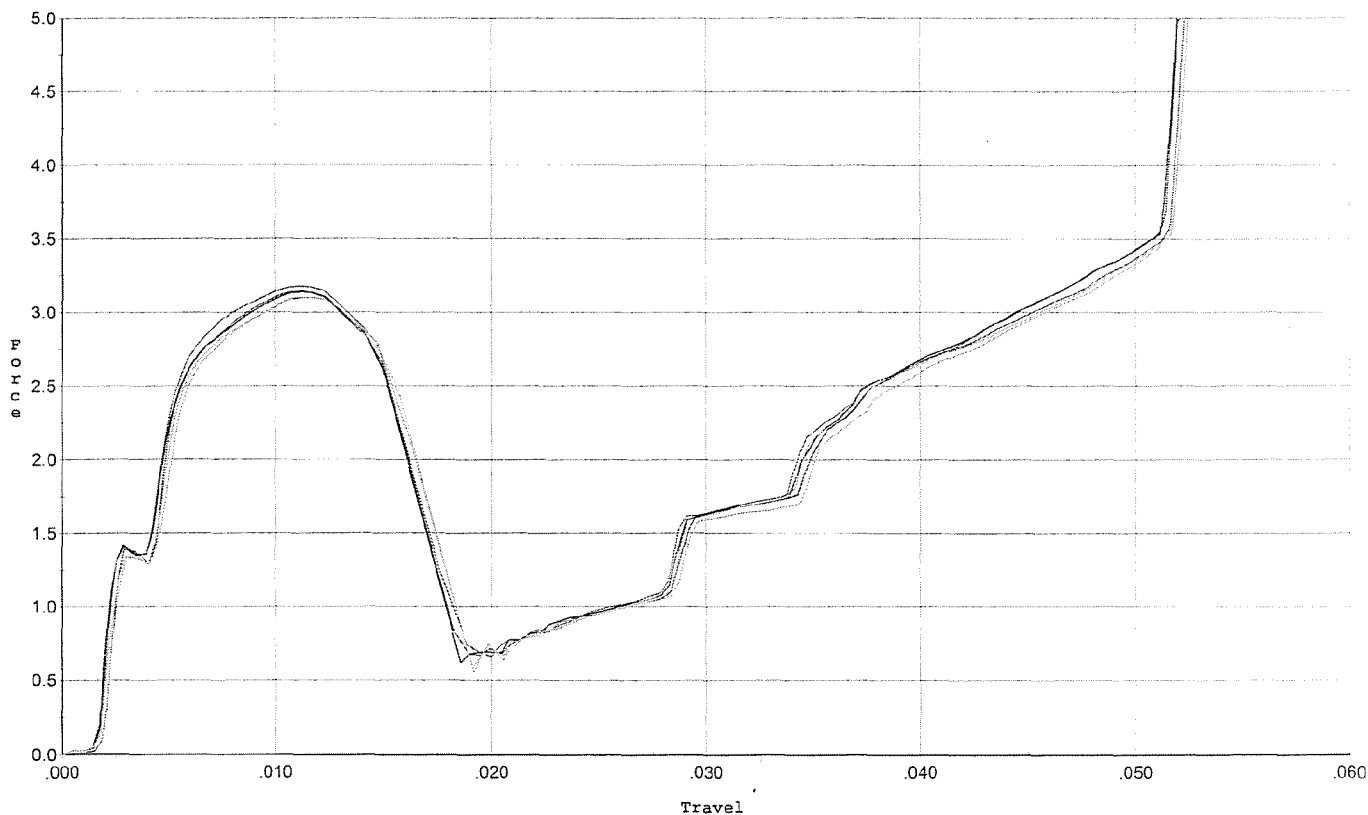
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.420      | 0.013             | 0.00            | 0.038      | 0.022             |           | Set Trigger |
| 2 | 2.428      | 0.013             | 0.00            | 0.038      | 0.022             |           | Set Trigger |
| 3 | 2.438      | 0.015             | 0.00            | 0.038      | 0.025             |           | Set Trigger |
| 4 | 2.484      | 0.013             | 0.00            | 0.037      | 0.023             |           | Set Trigger |
| 5 | 2.361      | 0.014             | 0.00            | 0.038      | 0.022             |           | Set Trigger |

A-2.42

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



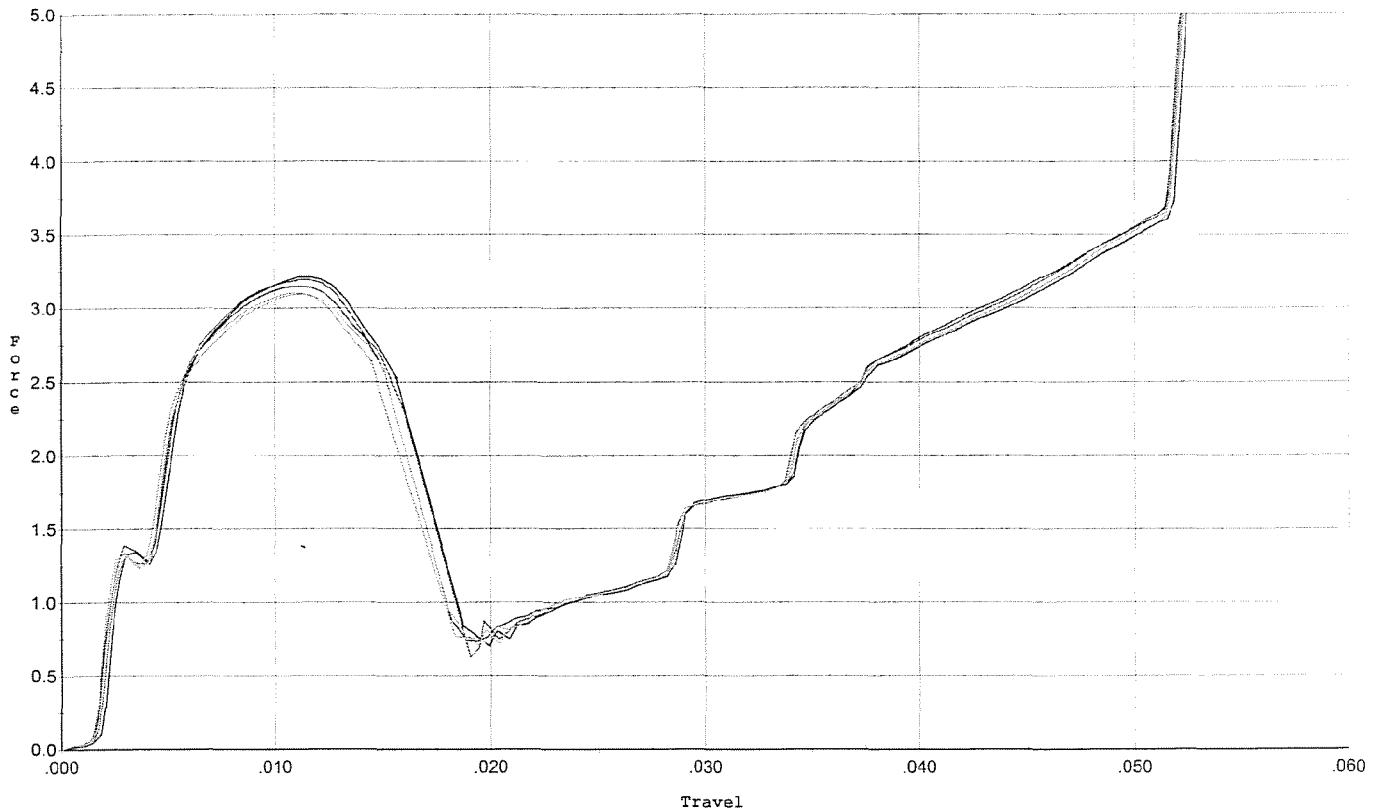
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.146      | 0.015             | 0.004           | 0.039      | 0.031             |           | Set Trigger |
| 2 | 3.139      | 0.015             | 0.004           | 0.039      | 0.031             |           | Set Trigger |
| 3 | 3.176      | 0.015             | 0.00            | 0.039      | 0.031             |           | Set Trigger |
| 4 | 3.099      | 0.016             | 0.00            | 0.039      | 0.032             |           | Set Trigger |
| 5 | 3.101      | 0.016             | 0.004           | 0.039      | 0.033             |           | Set Trigger |

A-3-13

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



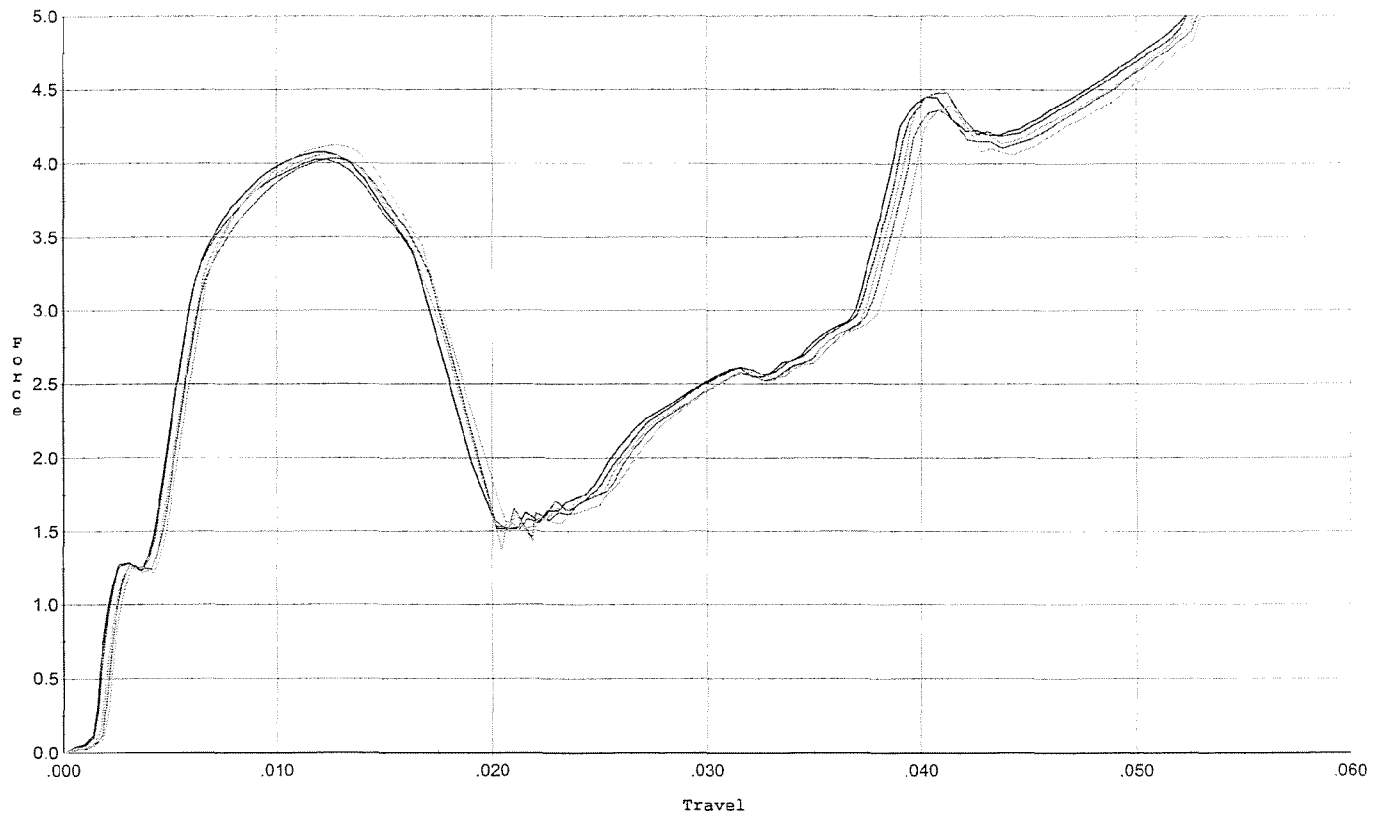
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.147      | 0.015             | 0.004           | 0.039      | 0.031             |           | Set Trigger |
| 2 | 3.214      | 0.016             | 0.00            | 0.038      | 0.032             |           | Set Trigger |
| 3 | 3.192      | 0.016             | 0.004           | 0.038      | 0.033             |           | Set Trigger |
| 4 | 3.095      | 0.015             | 0.00            | 0.039      | 0.031             |           | Set Trigger |
| 5 | 3.101      | 0.014             | 0.00            | 0.039      | 0.030             |           | Set Trigger |

A-3-15

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

Model: M/24  
Serial No: Form #F005  
Trigger: 04.0 lbs ini +/- 1.0 lb



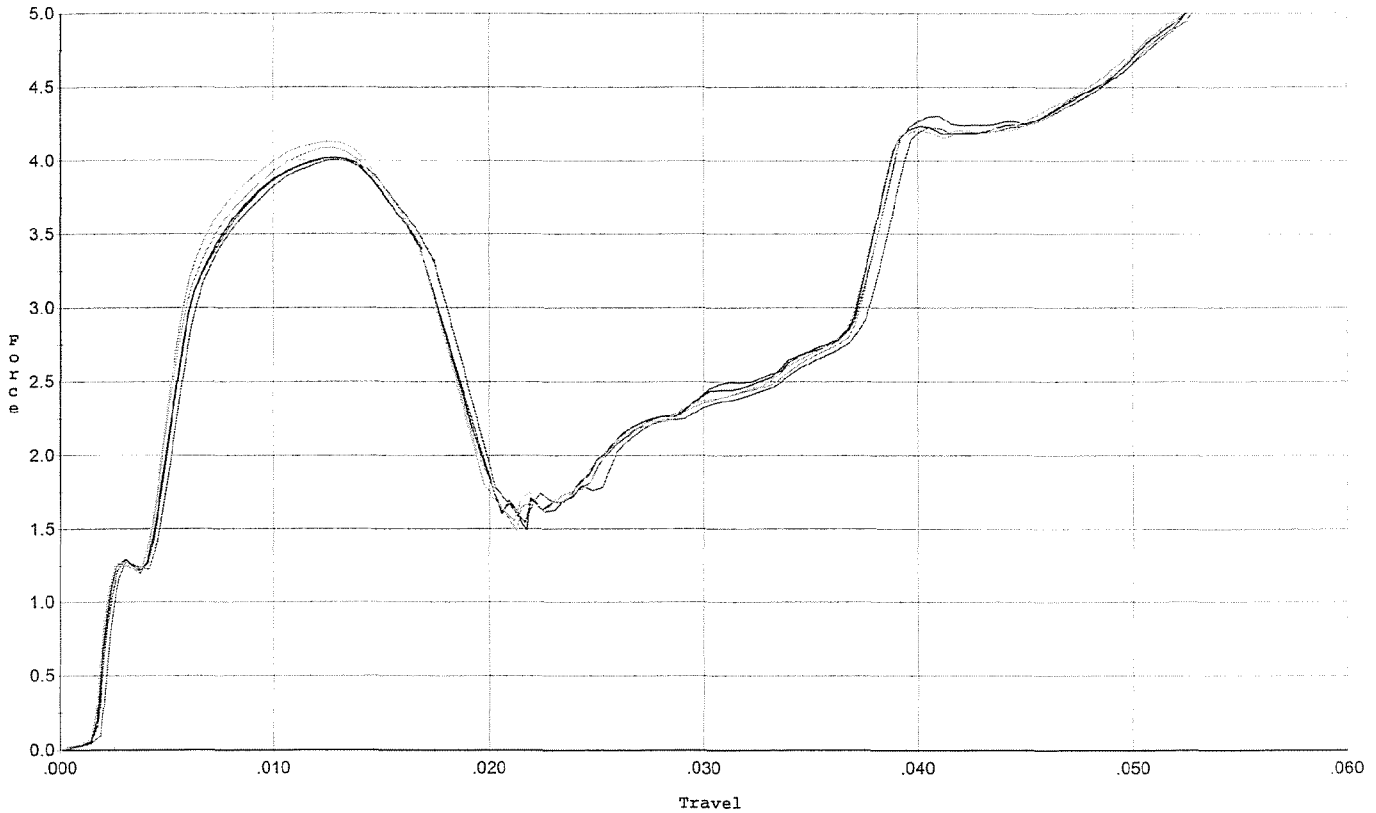
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.027      | 0.016             | 0.00            | 0.036      | 0.042             |           | Set Trigger |
| 2 | 4.072      | 0.016             | 0.00            | 0.036      | 0.043             |           | Set Trigger |
| 3 | 4.032      | 0.017             | 0.004           | 0.036      | 0.043             |           | Set Trigger |
| 4 | 4.125      | 0.017             | 0.00            | 0.037      | 0.043             |           | Set Trigger |
| 5 | 4.061      | 0.018             | 0.00            | 0.036      | 0.045             |           | Set Trigger |

A-4.06

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

Model: M/24  
Serial No: Form #F005  
Trigger: 04.0 lbs after 20 cycles+/- 1.0 lb



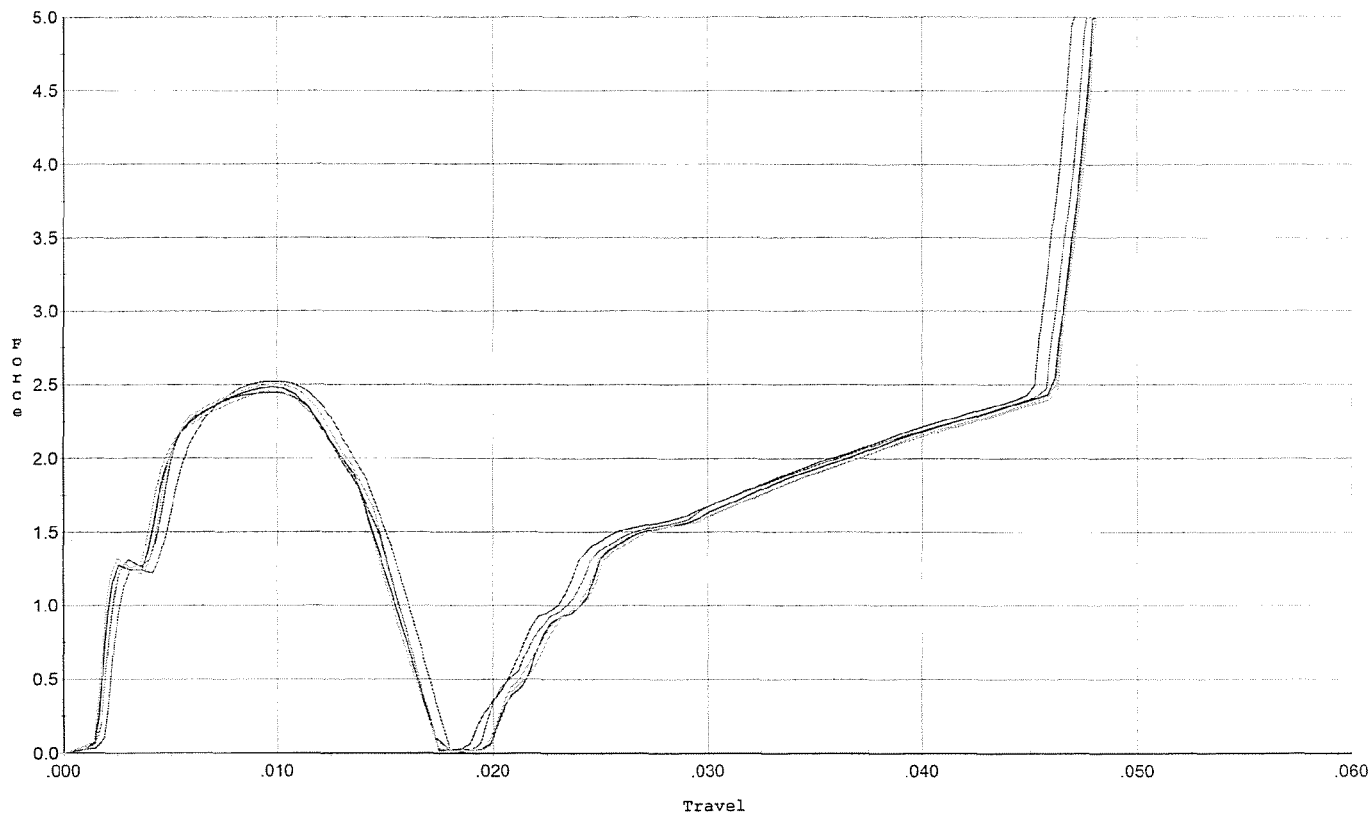
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.008      | 0.017             | 0.00            | 0.036      | 0.043             |           | Set Trigger |
| 2 | 4.020      | 0.017             | 0.00            | 0.036      | 0.044             |           | Set Trigger |
| 3 | 4.004      | 0.017             | 0.004           | 0.036      | 0.045             |           | Set Trigger |
| 4 | 4.085      | 0.017             | 0.00            | 0.036      | 0.044             |           | Set Trigger |
| 5 | 4.128      | 0.017             | 0.004           | 0.036      | 0.045             |           | Set Trigger |

A-4.04

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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



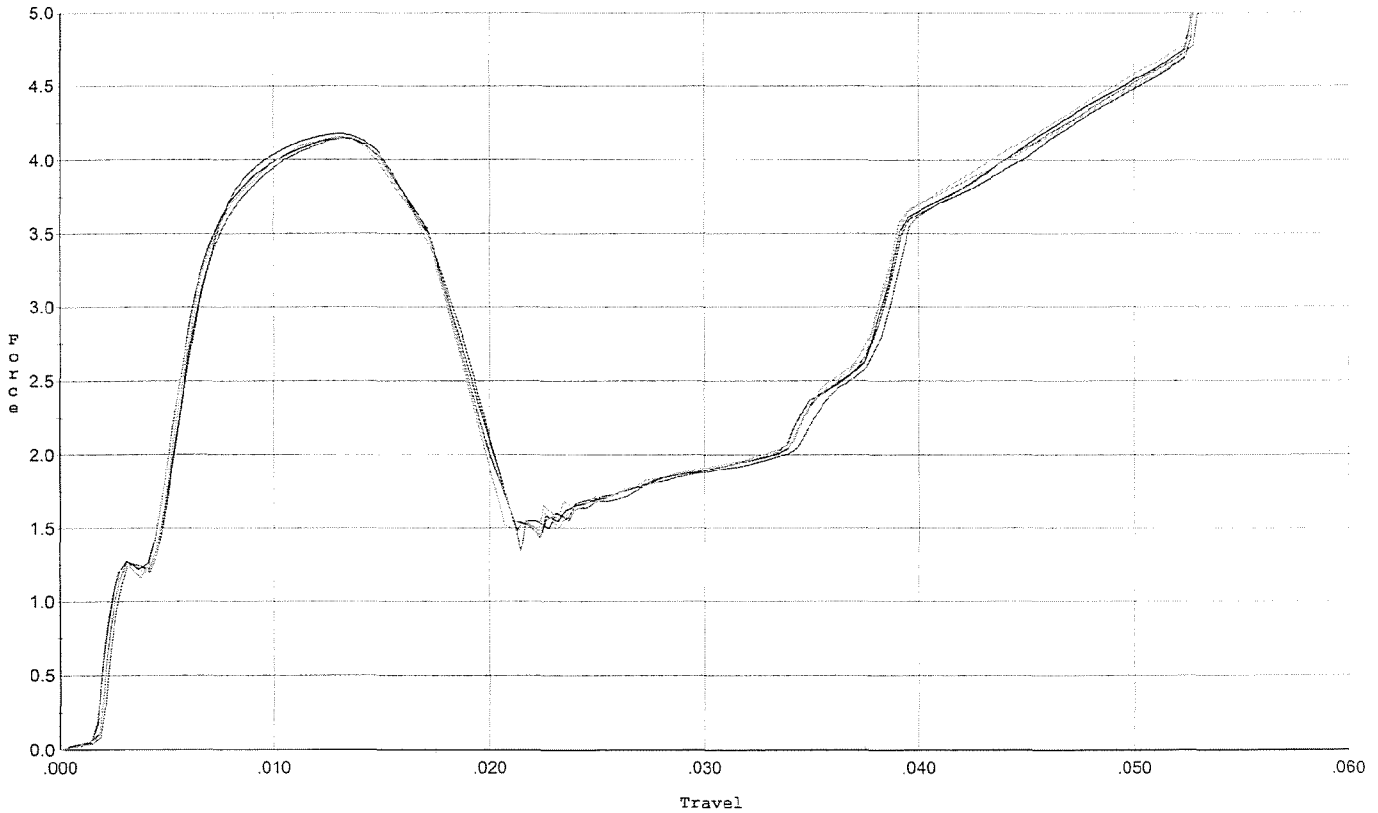
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.446      | 0.015             | 0.00            | 0.037      | 0.024             |           | Set Trigger |
| 2 | 2.483      | 0.015             | 0.004           | 0.037      | 0.026             |           | Set Trigger |
| 3 | 2.520      | 0.015             | 0.004           | 0.037      | 0.025             |           | Set Trigger |
| 4 | 2.504      | 0.014             | 0.00            | 0.038      | 0.024             |           | Set Trigger |
| 5 | 2.459      | 0.014             | 0.00            | 0.038      | 0.023             |           | Set Trigger |

A-2-48

## Trigger Profile [ lbs,inch ]

Profile: SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/2/2009

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 | 4.177      | 0.017             | 0.004           | 0.036      | 0.045             |           | Set Trigger |
| 2 | 4.148      | 0.017             | 0.00            | 0.036      | 0.045             |           | Set Trigger |
| 3 | 4.142      | 0.019             | 0.005           | 0.036      | 0.049             |           | Set Trigger |
| 4 | 4.154      | 0.017             | 0.004           | 0.036      | 0.045             |           | Set Trigger |
| 5 | 4.147      | 0.017             | 0.00            | 0.036      | 0.046             |           | Set Trigger |

A - 4.15