

66810394

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

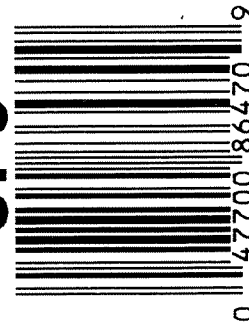
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6810394**

**UPC**



GUN SERIAL # G 681 03 94

| OP #            | OPERATION NAME                                                                                                                         | READINGS                                                                                     | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|---------|---------|
| 420             | ASSEMBLE ACTION                                                                                                                        |                                                                                              | 2-10-09 | SP      |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |                                                                                              | 2-10-09 | SP      |
| 440             | PROOF                                                                                                                                  |                                                                                              | 2-10-09 | SP      |
| 460             | CHECK HEADSPACE                                                                                                                        |                                                                                              | 2-10-09 | SP      |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                              | 2-10-09 | SP      |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX                                                                                 | 2-11-09 | RT      |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                                                                                              | 2-11-09 | TL      |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR  | 2/13/09 | MR      |
| 490             | MAGNAFLUX BOLT                                                                                                                         |                                                                                              | 2/13/09 | MR      |
| 500             | ROLLMARK CALIBER                                                                                                                       |                                                                                              | 2/14/09 | RT      |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |                                                                                              | 2/16/09 | DC      |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                              | 2/21/09 |         |
| 545             | (BOLT)                                                                                                                                 |                                                                                              |         |         |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                              |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                              | 2-23-09 | SP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                              | 2-23-09 | SP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                              | 2-23-09 | SP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                              | 2-24-09 | 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 |                                                                                                                                        |                                                                                              |         |         |

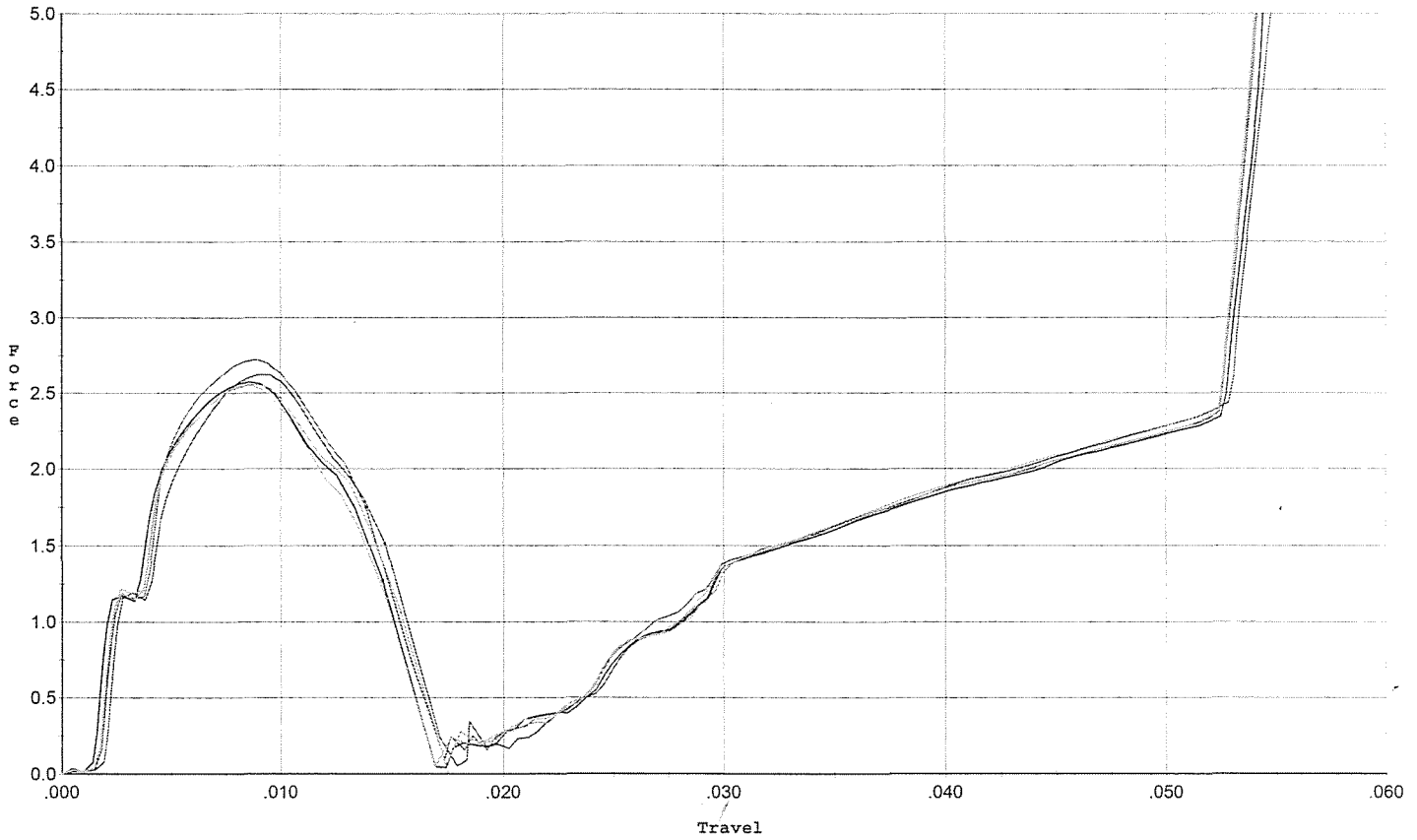
|              |                                                                       |                                           |            |             |             |             |             |             |         |    |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|------------|-------------|-------------|-------------|-------------|-------------|---------|----|
| 560          | PARSER-1124 ON 30920                                                  |                                           | 10 LBS MAX | <u>4</u>    | <u>4</u>    | <u>4</u>    | 3-2-09      | WV          |         |    |
| CONT.        |                                                                       |                                           |            |             |             |             |             |             |         |    |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 |            | <u>3.5</u>  | <u>3.5</u>  | <u>3.5</u>  | 3-2-09      | WV          |         |    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |            |             |             |             |             |             |         |    |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  |            | <u>.022</u> | <u>.024</u> | <u>.023</u> | 3-2-09      | WV          |         |    |
|              | J) ASSEMBLE STOCK                                                     |                                           |            |             |             |             | 2-24-09     | R.H.        |         |    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |            |             |             |             | 3-3-09      | WV          |         |    |
|              | 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        |             | 2-25-09     | J.P.D.      |         |    |
|              |                                                                       |                                           |            | PASS        | FAIL        |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION |             |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION |             |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION |             |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | CORRECTION |             |             |             |             |             |         |    |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |            |             |             |             | 2-25-09     | RP          |         |    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |            |             |             |             | 3-2-09      | WV          |         |    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS |            | <u>2.66</u> | <u>2.72</u> | <u>2.65</u> | <u>2.61</u> | <u>2.41</u> | 2-26-09 | WV |
|              | C) FUNCTION                                                           |                                           |            |             |             |             | 3-2-09      | WV          |         |    |
| 690          | PACK                                                                  |                                           |            |             |             |             | 3/5/09      | Fm          |         |    |

F004 REV 5/2006

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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



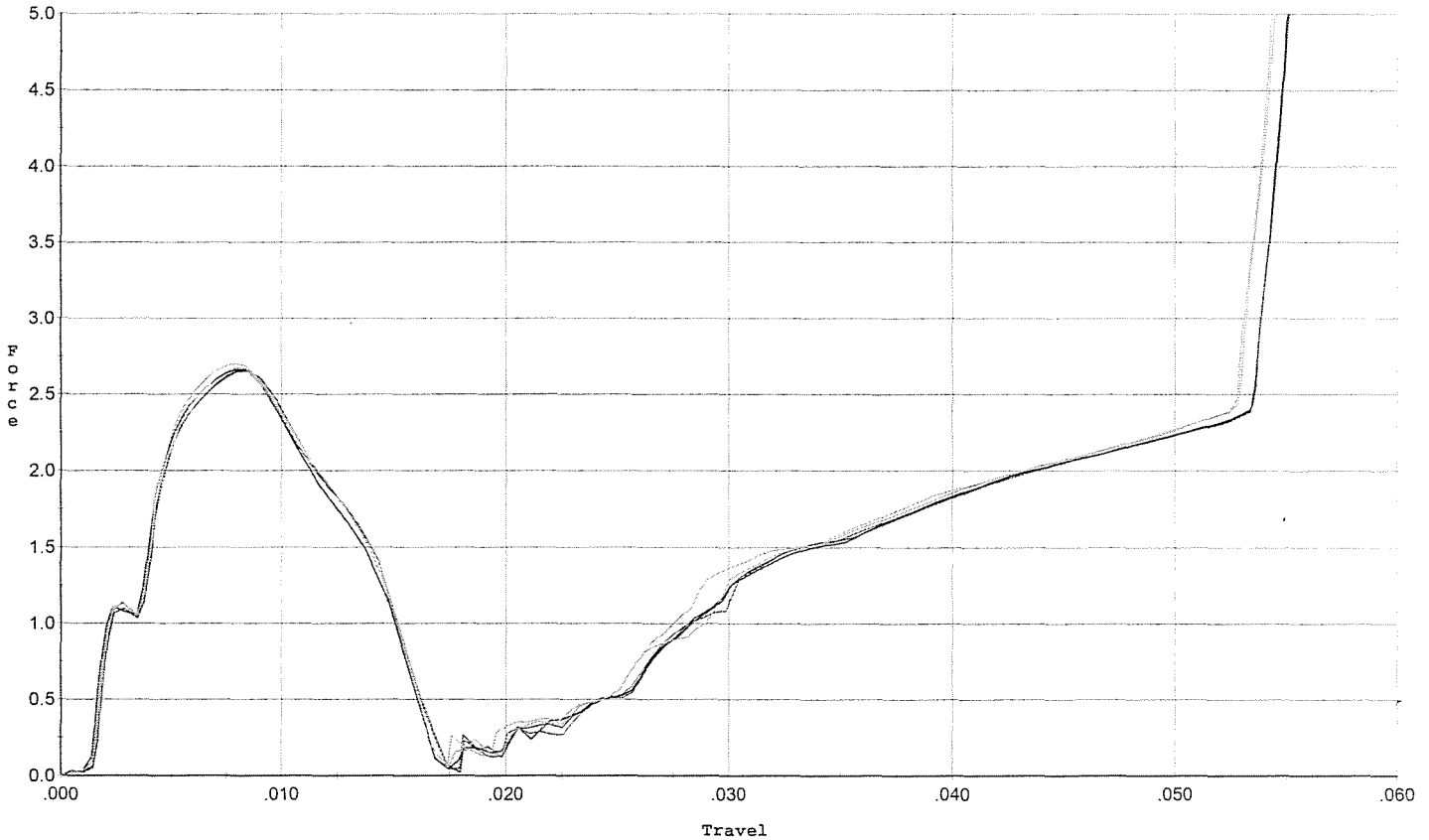
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.627      | 0.015             | 0.002           | 0.044      | 0.024             |           | Set Trigger |
| 2 | 2.577      | 0.015             | 0.00            | 0.044      | 0.024             |           | Set Trigger |
| 3 | 2.727      | 0.014             | 0.00            | 0.044      | 0.024             |           | Set Trigger |
| 4 | 2.551      | 0.015             | 0.00            | 0.044      | 0.024             |           | Set Trigger |
| 5 | 2.558      | 0.015             | 0.00            | 0.044      | 0.025             |           | Set Trigger |

A-2-60

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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



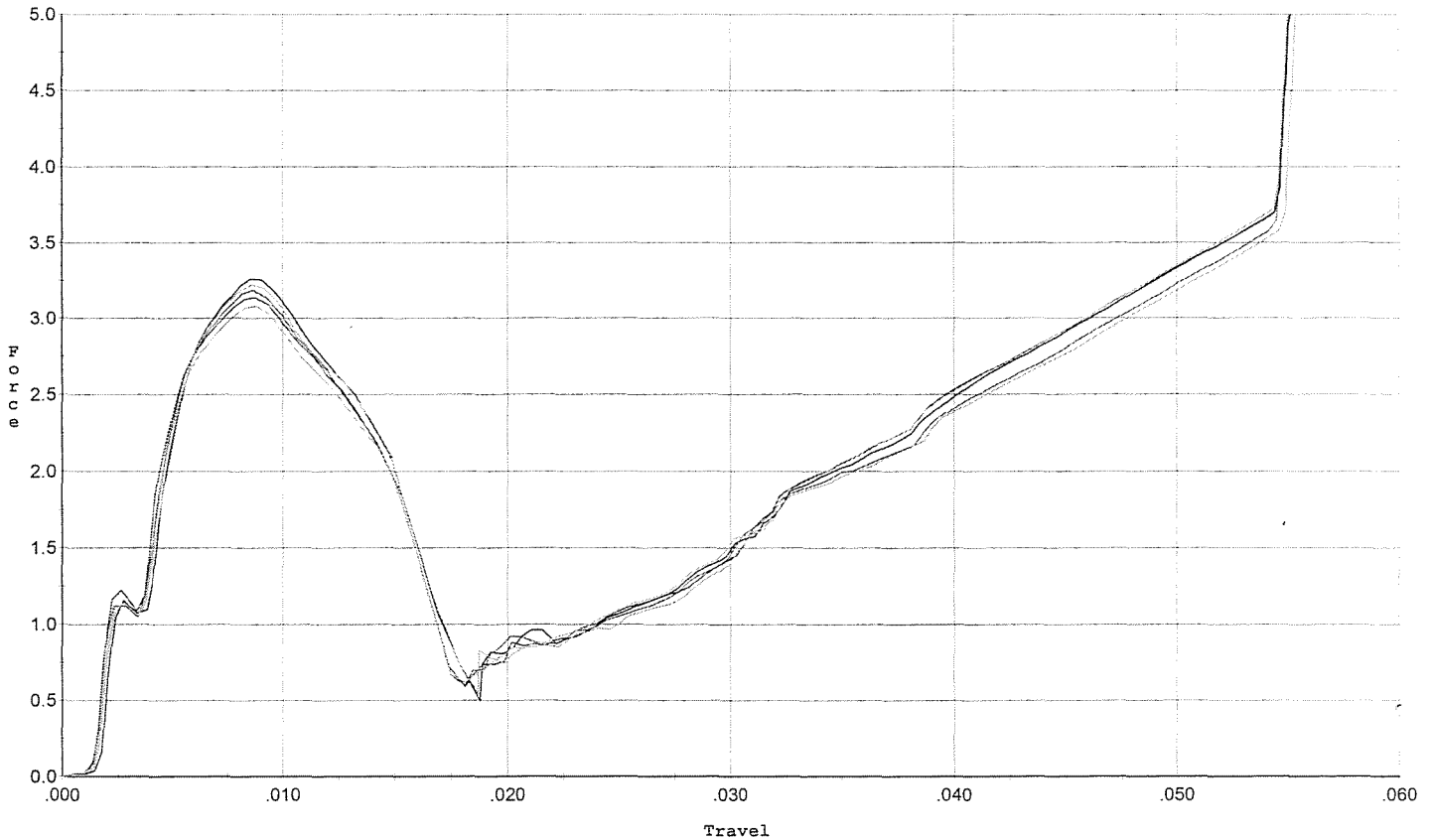
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.660      | 0.014             | 0.00            | 0.045      | 0.023             |           | Set Trigger |
| 2 | 2.660      | 0.015             | 0.004           | 0.045      | 0.024             |           | Set Trigger |
| 3 | 2.646      | 0.014             | 0.00            | 0.045      | 0.023             |           | Set Trigger |
| 4 | 2.674      | 0.014             | 0.00            | 0.044      | 0.024             |           | Set Trigger |
| 5 | 2.702      | 0.015             | 0.00            | 0.044      | 0.024             |           | Set Trigger |

A-2.66

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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



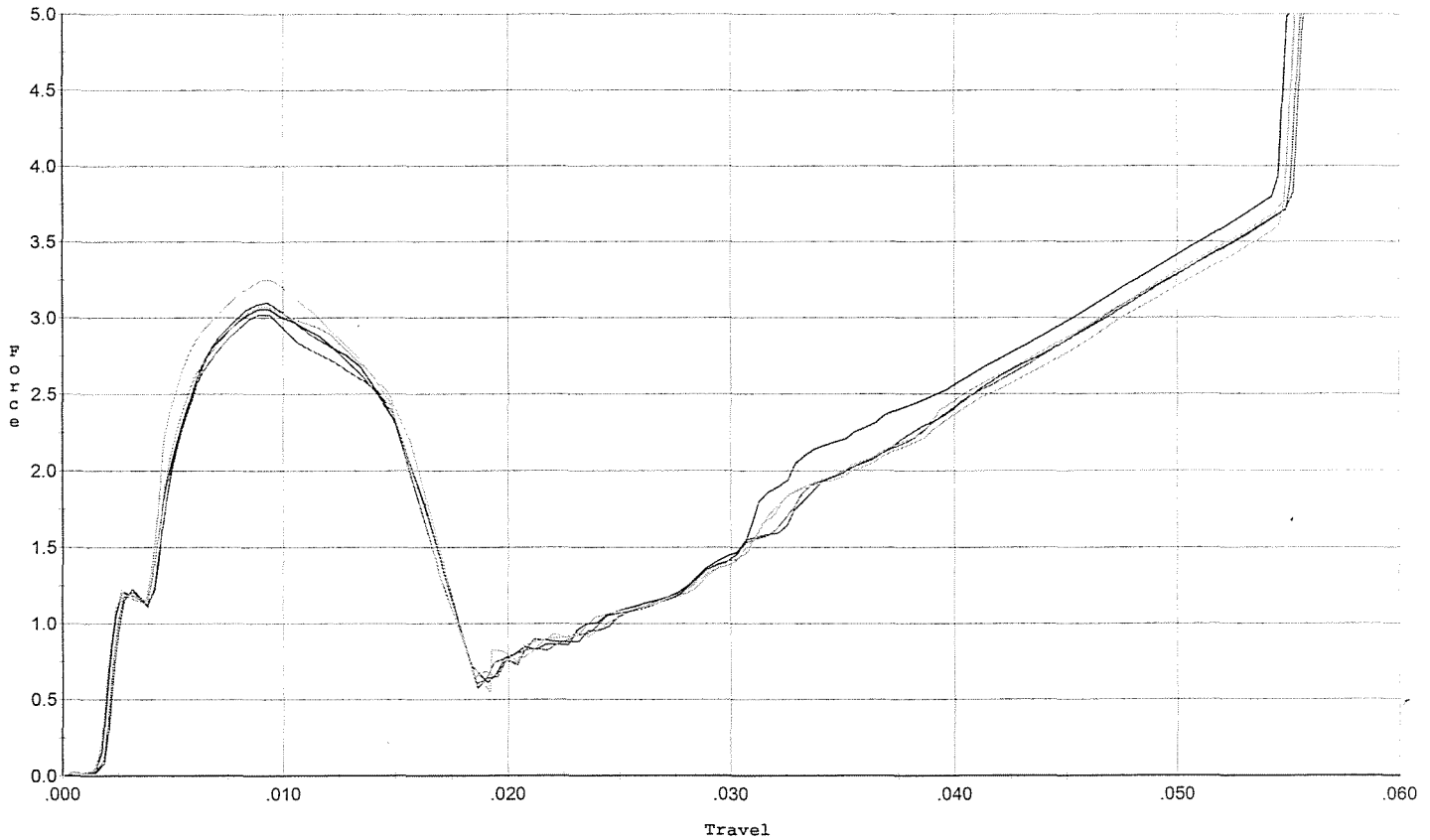
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.138      | 0.015             | 0.00            | 0.043      | 0.030             |           | Set Trigger |
| 2 | 3.261      | 0.015             | 0.00            | 0.043      | 0.029             |           | Set Trigger |
| 3 | 3.185      | 0.015             | 0.004           | 0.043      | 0.030             |           | Set Trigger |
| 4 | 3.079      | 0.015             | 0.00            | 0.042      | 0.029             |           | Set Trigger |
| 5 | 3.220      | 0.015             | 0.00            | 0.043      | 0.029             |           | Set Trigger |

A-3-19

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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 | 3.101      | 0.016             | 0.002           | 0.042      | 0.032             |           | Set Trigger |
| 2 | 3.054      | 0.015             | 0.004           | 0.042      | 0.029             |           | Set Trigger |
| 3 | 3.022      | 0.016             | 0.002           | 0.042      | 0.031             |           | Set Trigger |
| 4 | 3.249      | 0.015             | 0.004           | 0.043      | 0.031             |           | Set Trigger |
| 5 | 3.072      | 0.016             | 0.004           | 0.042      | 0.031             |           | Set Trigger |

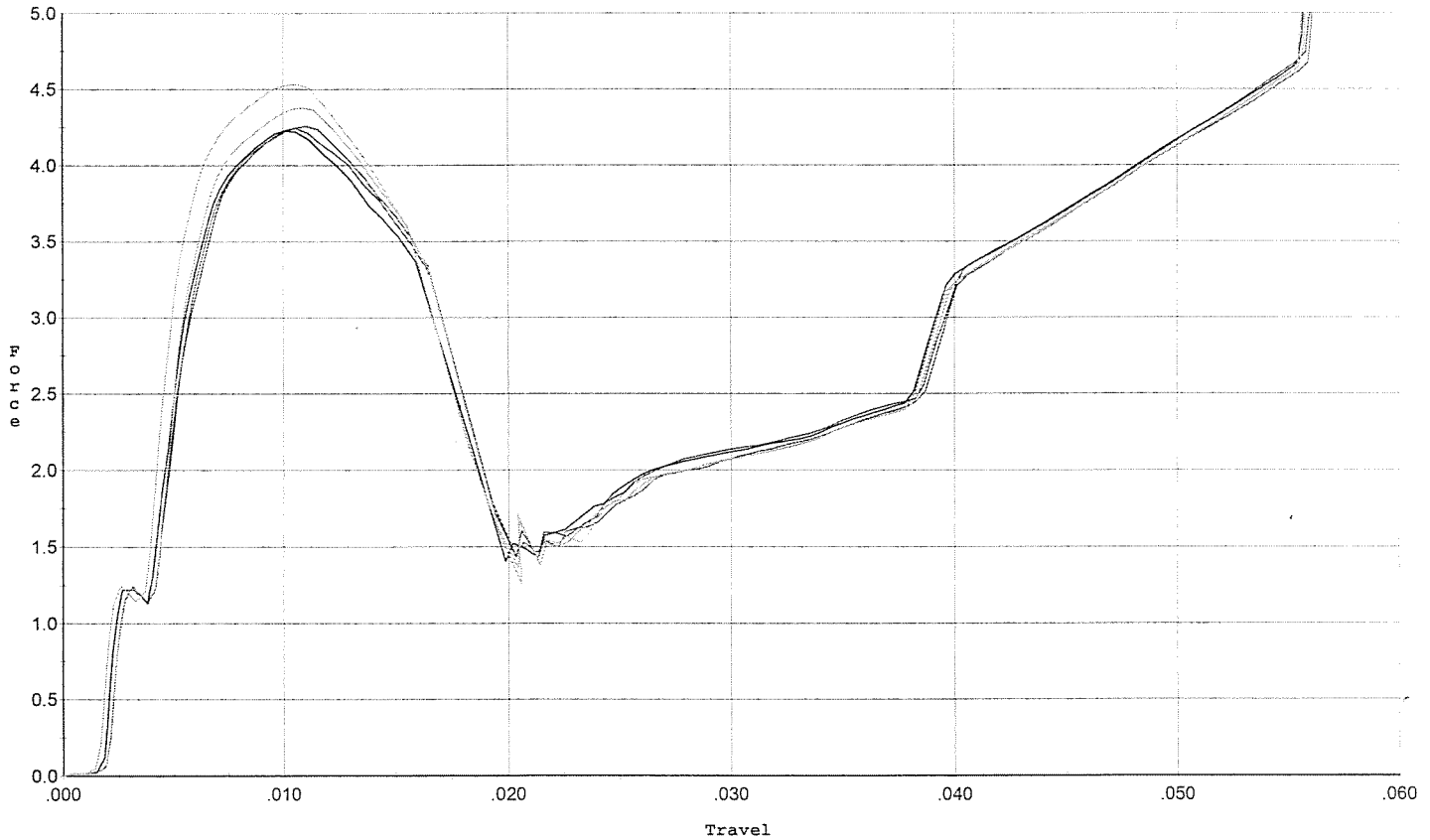
A-3.10



## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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



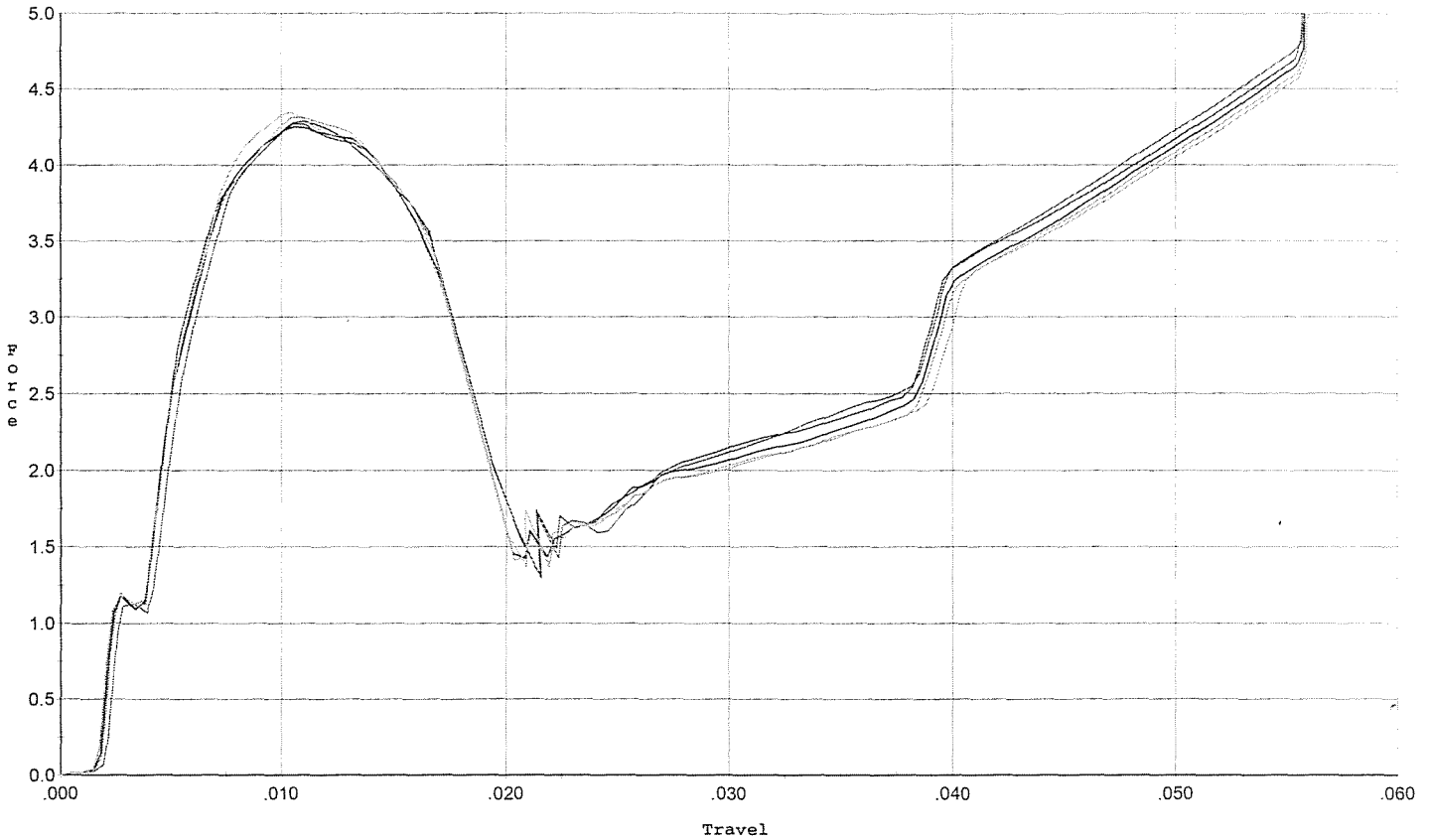
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.245      | 0.016             | 0.002           | 0.039      | 0.043             |           | Set Trigger |
| 2 | 4.227      | 0.018             | 0.004           | 0.039      | 0.047             |           | Set Trigger |
| 3 | 4.258      | 0.016             | 0.002           | 0.040      | 0.043             |           | Set Trigger |
| 4 | 4.380      | 0.016             | 0.002           | 0.039      | 0.044             |           | Set Trigger |
| 5 | 4.534      | 0.016             | 0.00            | 0.039      | 0.044             |           | Set Trigger |

A 4.32

## Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 2/23/2009

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



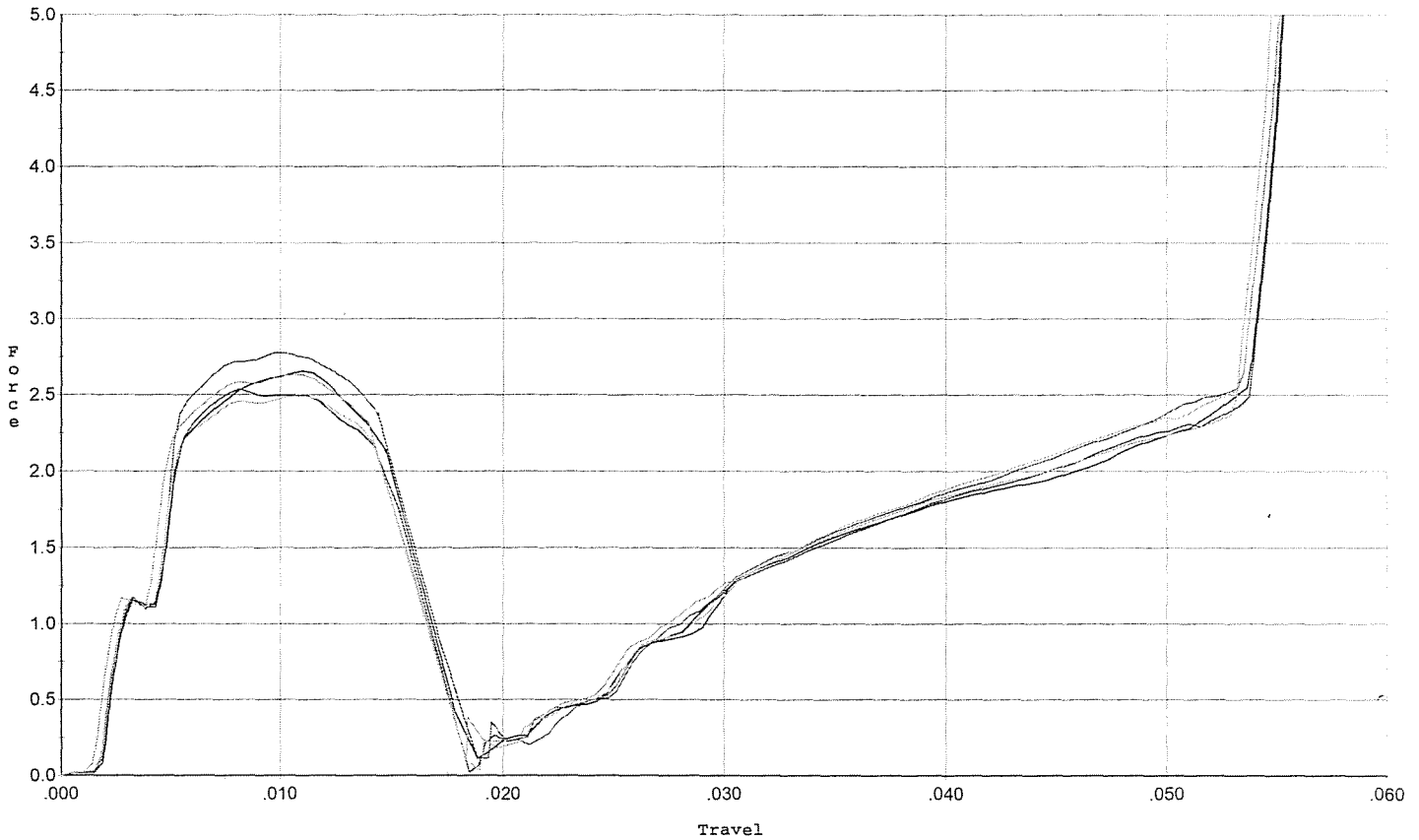
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.288      | 0.017             | 0.00            | 0.039      | 0.045             |           | Set Trigger |
| 2 | 4.251      | 0.017             | 0.00            | 0.039      | 0.046             |           | Set Trigger |
| 3 | 4.272      | 0.017             | 0.00            | 0.039      | 0.044             |           | Set Trigger |
| 4 | 4.348      | 0.017             | 0.004           | 0.039      | 0.046             |           | Set Trigger |
| 5 | 4.312      | 0.017             | 0.00            | 0.039      | 0.046             |           | Set Trigger |

A-4.29

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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



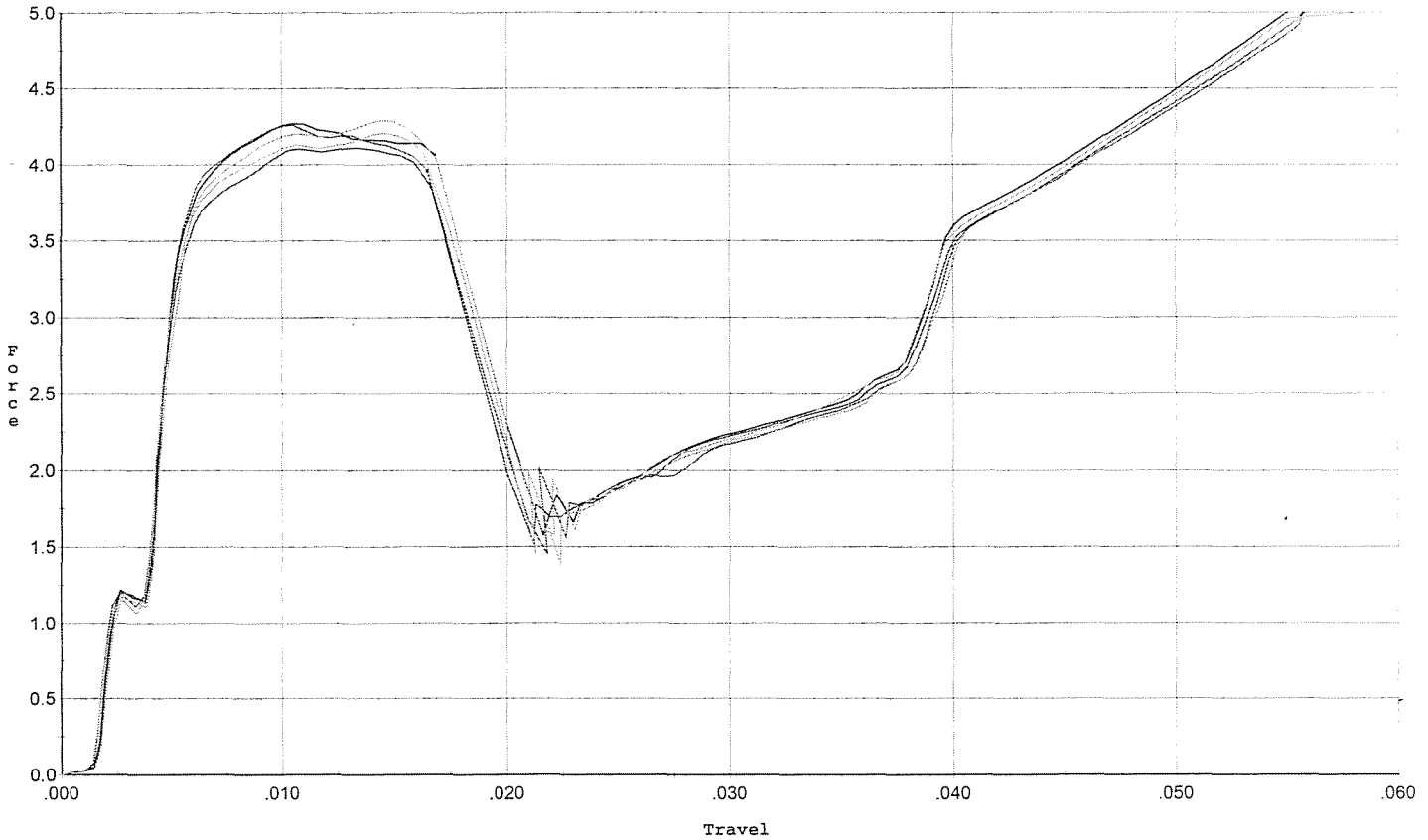
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.538      | 0.015             | 0.002           | 0.044      | 0.026             |           | Set Trigger |
| 2 | 2.655      | 0.015             | 0.002           | 0.044      | 0.026             |           | Set Trigger |
| 3 | 2.777      | 0.014             | 0.00            | 0.044      | 0.026             |           | Set Trigger |
| 4 | 2.491      | 0.016             | 0.00            | 0.044      | 0.027             |           | Set Trigger |
| 5 | 2.631      | 0.014             | 0.004           | 0.044      | 0.025             |           | Set Trigger |

A-2-61

## Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 2/23/2009

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 | 4.111      | 0.017             | 0.00            | 0.039      | 0.047             |           | Set Trigger |
| 2 | 4.271      | 0.017             | 0.004           | 0.038      | 0.049             |           | Set Trigger |
| 3 | 4.258      | 0.016             | 0.004           | 0.039      | 0.047             |           | Set Trigger |
| 4 | 4.206      | 0.018             | 0.00            | 0.038      | 0.051             |           | Set Trigger |
| 5 | 4.291      | 0.017             | 0.004           | 0.038      | 0.048             |           | Set Trigger |

A-4.22