

G680 7751

**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



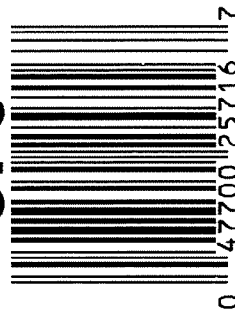
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6807751**

**UPC**



GUN SERIAL # G 6807751

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                    | DATE    | INITIAL                                                                             |
|------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                             | 3-6-09  | RR                                                                                  |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                             | 3-6-09  | RR                                                                                  |
| 440  | PROOF                                                                                                                                  |                                                                                             | 3-6-09  | TR                                                                                  |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                             | 3-6-09  | TR                                                                                  |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                             | 3-6-09  | RR                                                                                  |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX                                                                                | 3-9-09  | RR                                                                                  |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | MAR 13 2009                                                                                 | 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                                                                                                    |                                                                                             | 3-24-09 | SP                                                                                  |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                             | 3-24-09 | SP                                                                                  |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                             | 3-24-09 | SP                                                                                  |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                             | 3-25-09 | RR                                                                                  |
|      | 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

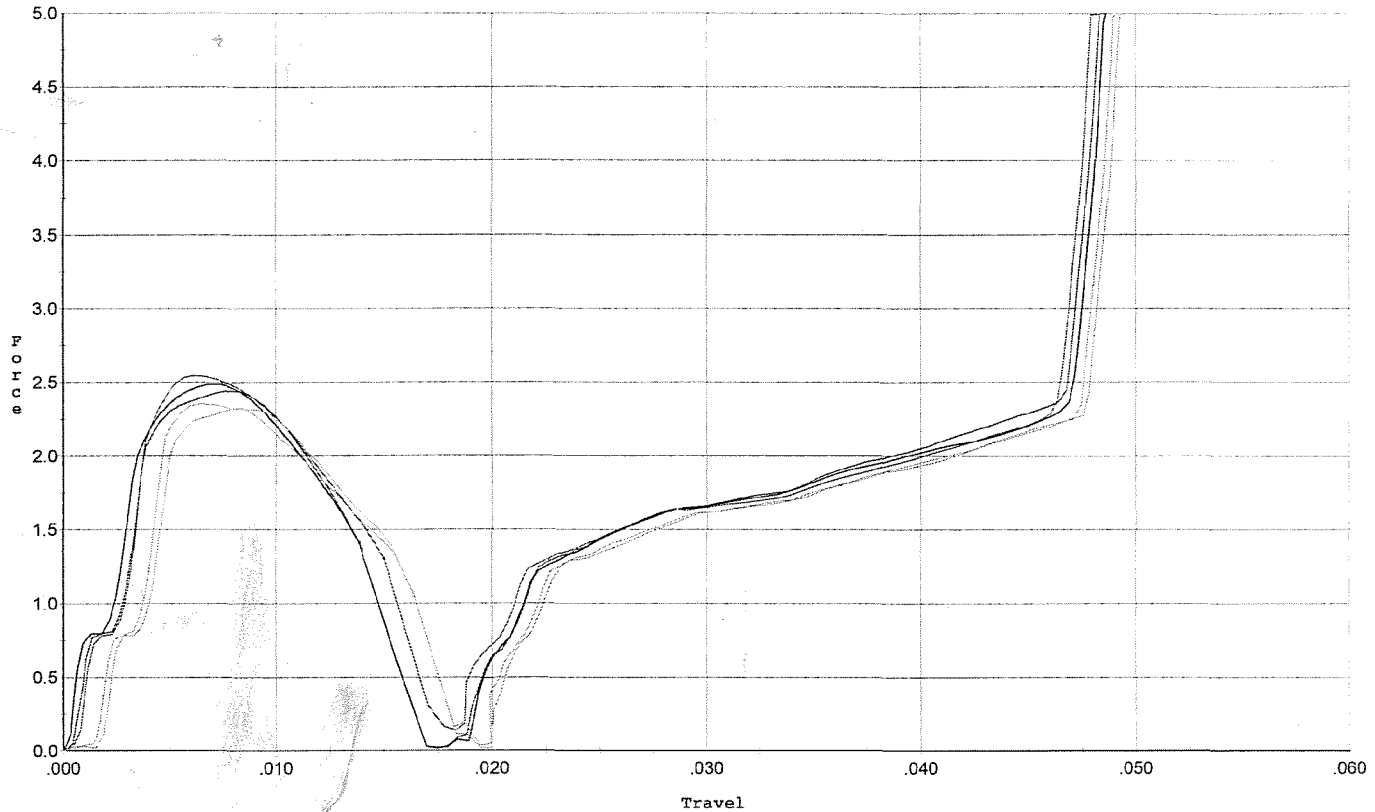
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>40</u> <u>40</u> <u>30</u>                               | 3-28-09 | RN      |
| CONT.        |                                                                          |                                                             |         |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>40</u> <u>40</u> <u>40</u>                               | 3-28-09 | RN      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.024</u>                         | 3-28-09 | RN      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 3-25-09 | RN      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-28-09 | RN      |
|              | 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                        | 3-26-09 | RN      |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION N/A                                              |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 3-26-09 | TL      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-28-09 | RN      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.63</u> <u>2.55</u> <u>2.63</u> <u>2.60</u> <u>2.52</u> | 3-27-09 | TL      |
|              | C) FUNCTION                                                              |                                                             | 3-28-09 | RN      |
| 690          | PACK                                                                     |                                                             | 3/31/09 | FM      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

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



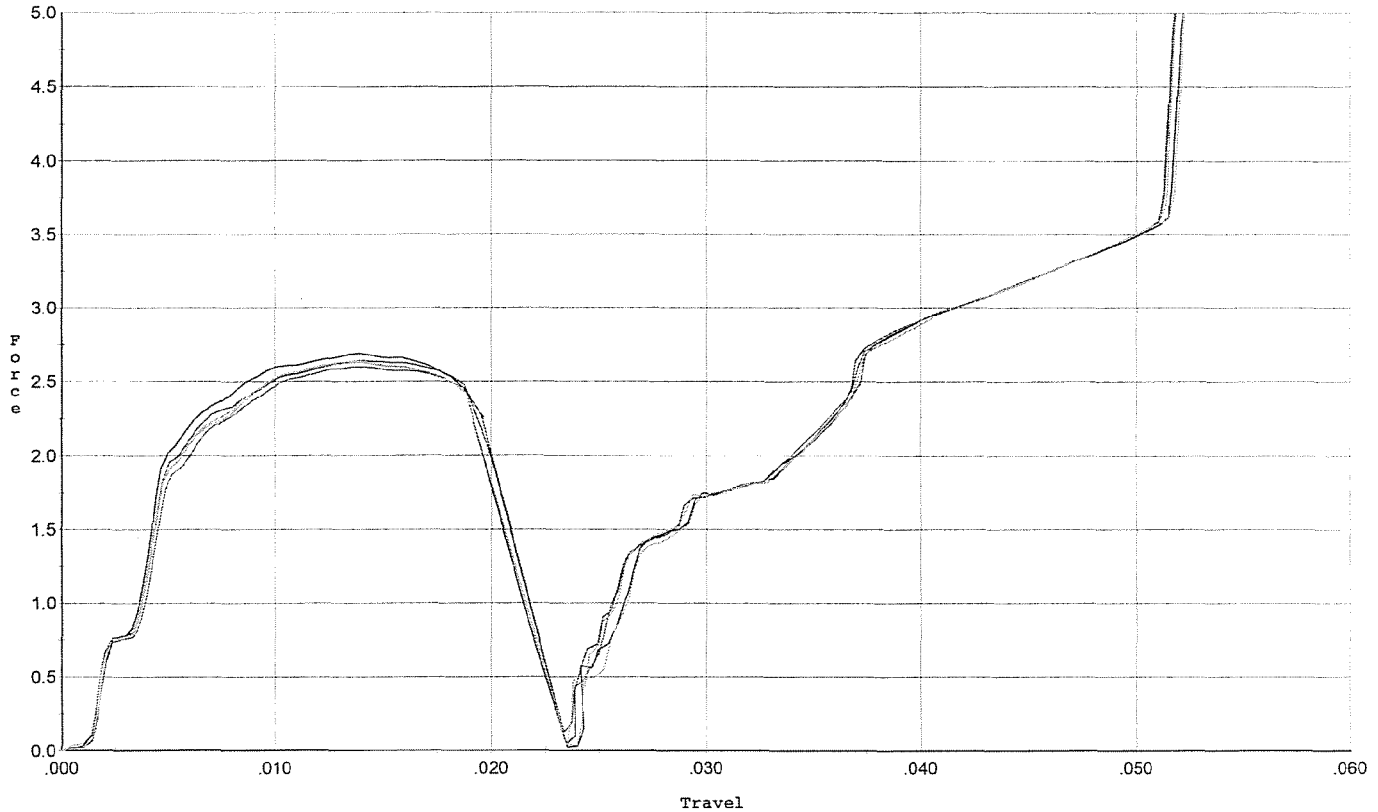
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.442      | 0.014             | 0.00            | 0.039      | 0.023             |           | Set Trigger |
| 2 | 2.488      | 0.014             | 0.00            | 0.039      | 0.024             |           | Set Trigger |
| 3 | 2.547      | 0.015             | 0.00            | 0.038      | 0.025             |           | Set Trigger |
| 4 | 2.353      | 0.016             | 0.00            | 0.038      | 0.025             |           | Set Trigger |
| 5 | 2.328      | 0.016             | 0.00            | 0.038      | 0.024             |           | Set Trigger |

1A 2.43

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

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



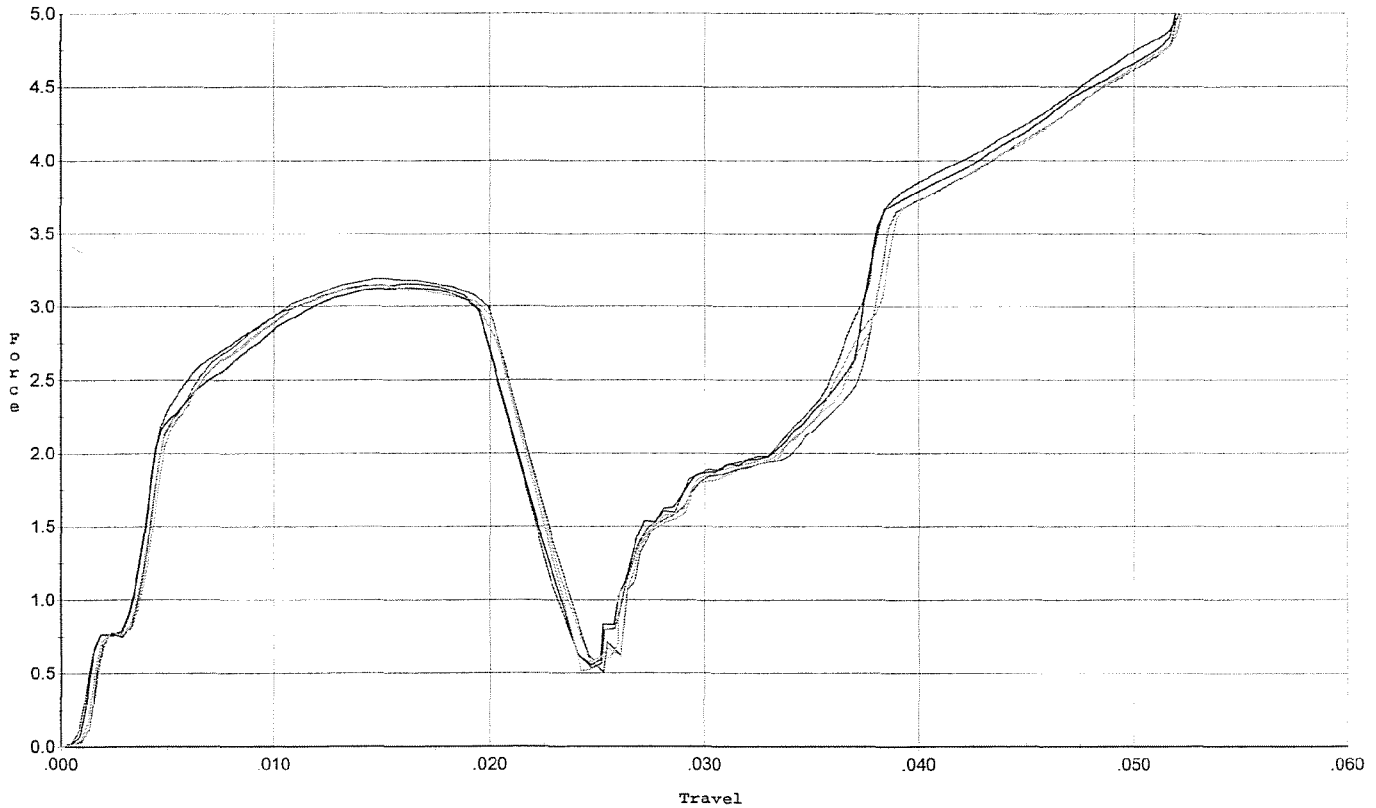
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.642      | 0.020             | 0.00            | 0.035      | 0.038             |           | Set Trigger |
| 2 | 2.690      | 0.019             | 0.00            | 0.036      | 0.037             |           | Set Trigger |
| 3 | 2.598      | 0.020             | 0.00            | 0.035      | 0.037             |           | Set Trigger |
| 4 | 2.630      | 0.021             | 0.00            | 0.036      | 0.040             |           | Set Trigger |
| 5 | 2.641      | 0.021             | 0.00            | 0.035      | 0.040             |           | Set Trigger |

A-2.64

# Trigger Profile [ lbs,inch ]

Profile: SWS  
 GunType: Rifle  
 Make: Remington  
 Note: C Schults 3/17/2009

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



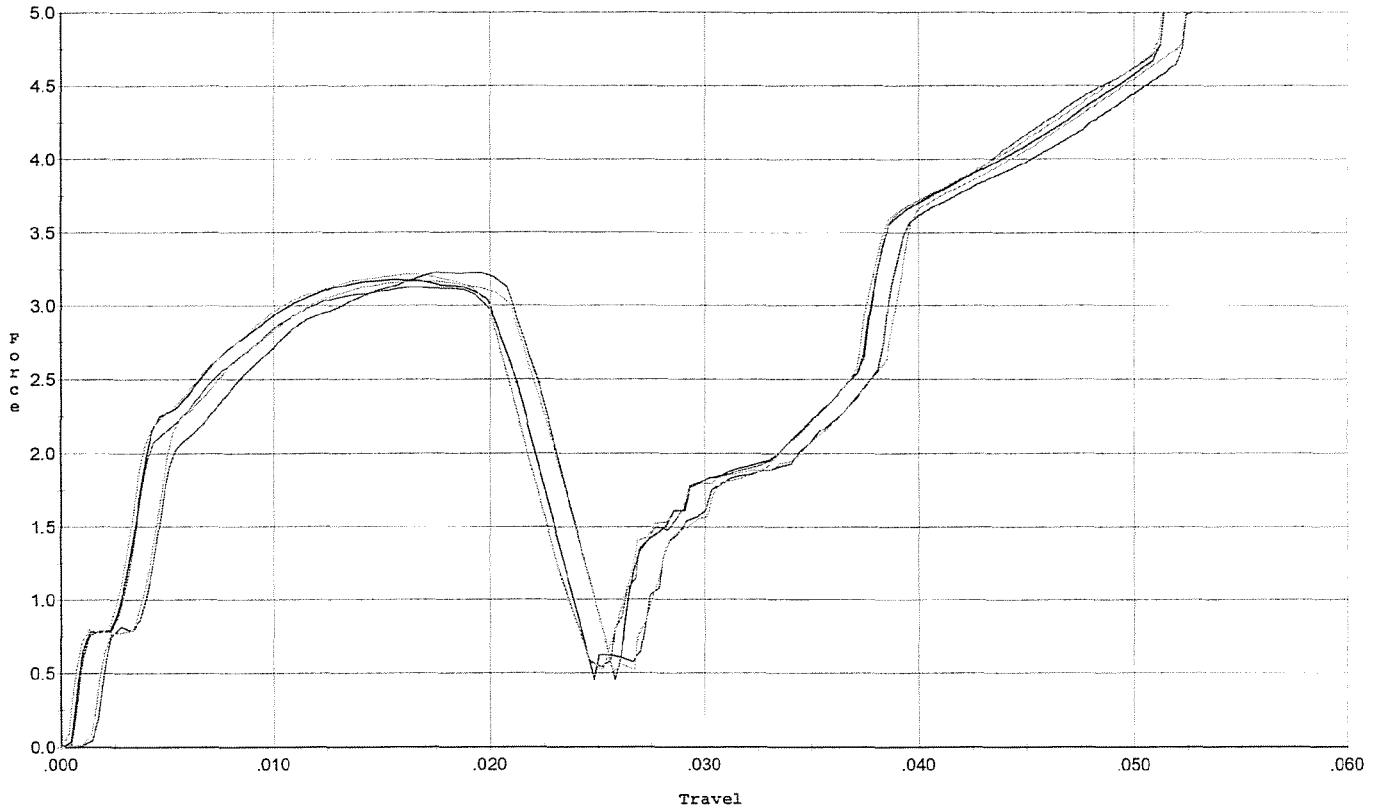
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.154      | 0.019             | 0.00            | 0.035      | 0.044             |           | Set Trigger |
| 2 | 3.126      | 0.019             | 0.00            | 0.034      | 0.044             |           | Set Trigger |
| 3 | 3.186      | 0.020             | 0.00            | 0.034      | 0.045             |           | Set Trigger |
| 4 | 3.145      | 0.020             | 0.00            | 0.034      | 0.046             |           | Set Trigger |
| 5 | 3.143      | 0.020             | 0.00            | 0.034      | 0.045             |           | Set Trigger |

A-3-15

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

**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 | 3.228      | 0.022             | 0.00            | 0.034      | 0.049             |           | Set Trigger |
| 2 | 3.176      | 0.021             | 0.00            | 0.033      | 0.050             |           | Set Trigger |
| 3 | 3.124      | 0.020             | 0.00            | 0.033      | 0.046             |           | Set Trigger |
| 4 | 3.215      | 0.020             | 0.00            | 0.033      | 0.047             |           | Set Trigger |
| 5 | 3.167      | 0.023             | 0.00            | 0.033      | 0.051             |           | Set Trigger |

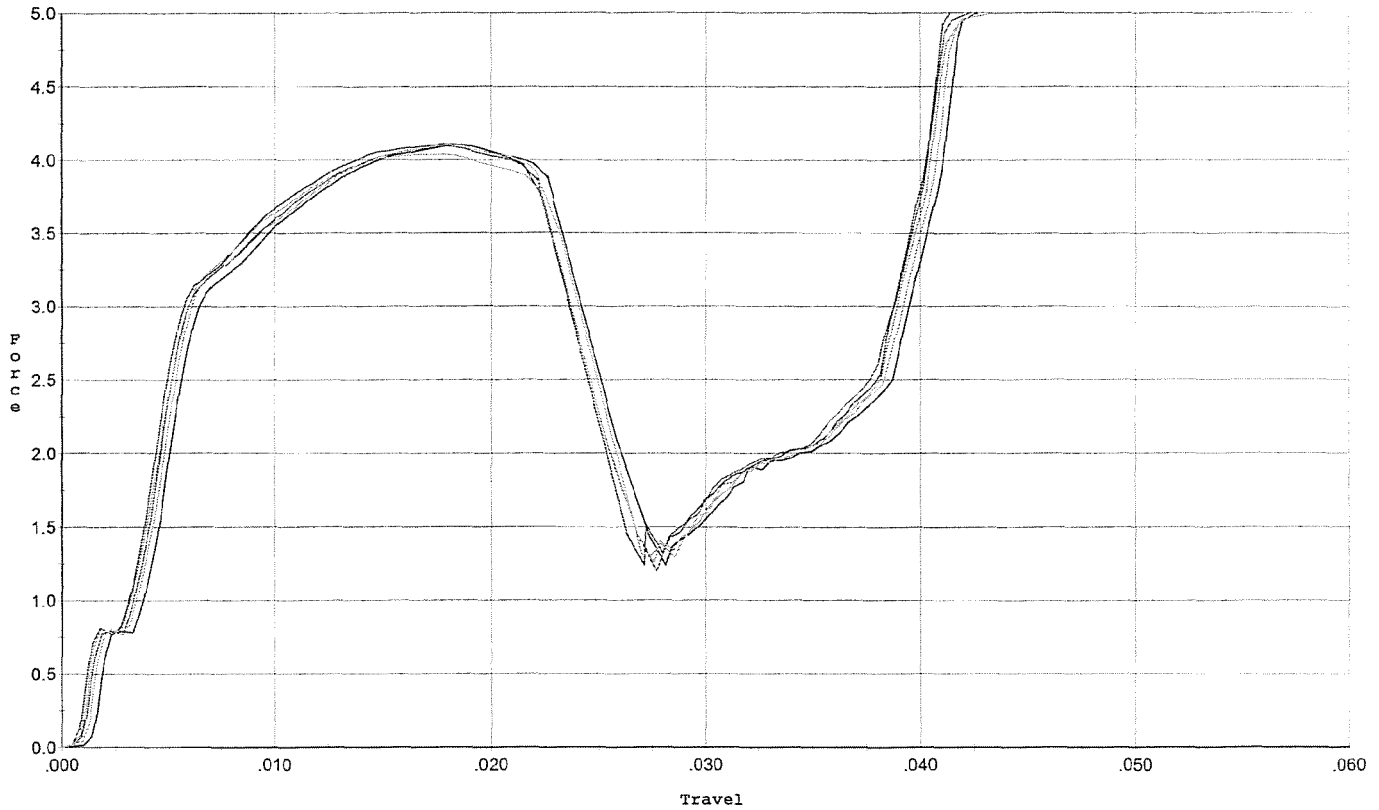
A-3-18



# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

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



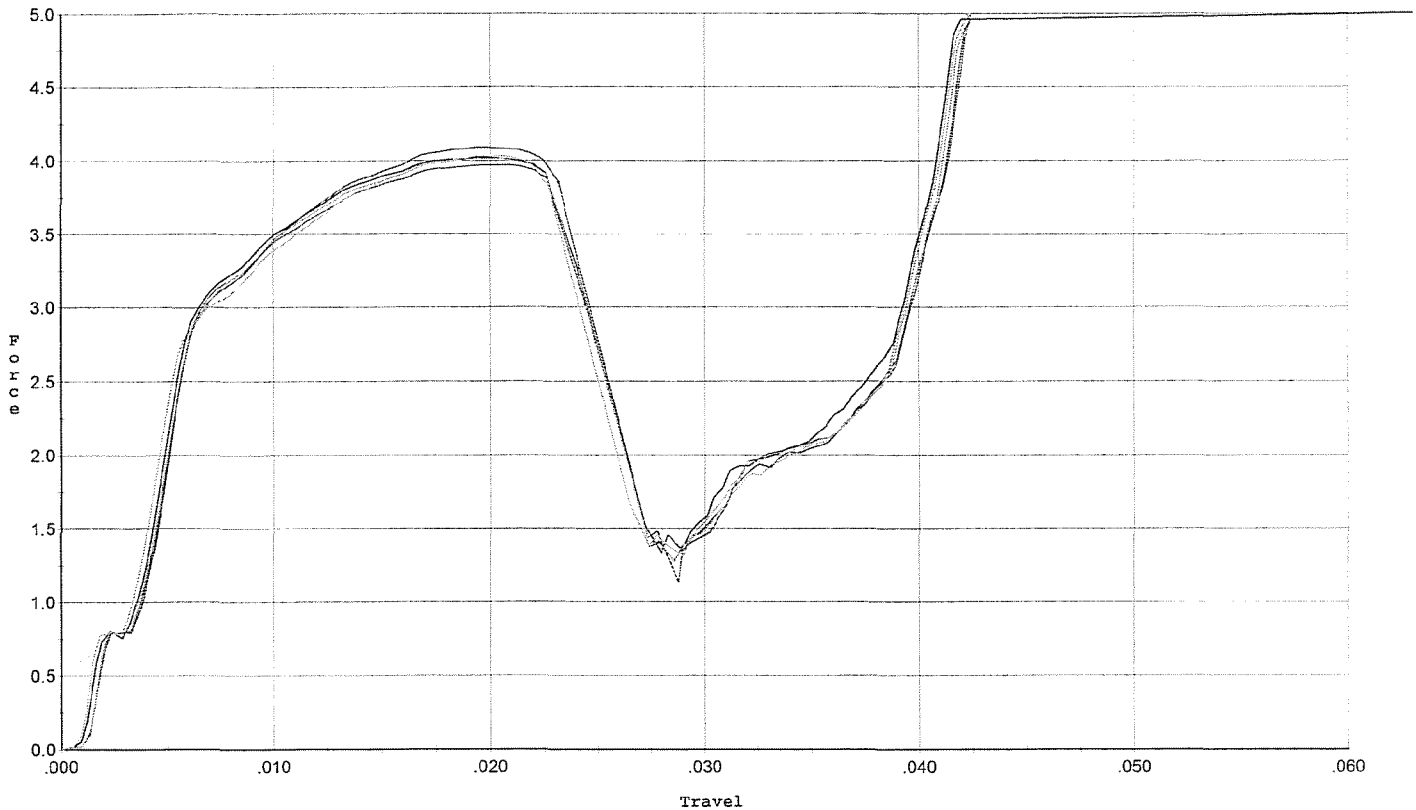
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.109      | 0.022             | 0.00            | 0.032      | 0.065             |           | Set Trigger |
| 2 | 4.104      | 0.023             | 0.00            | 0.032      | 0.064             |           | Set Trigger |
| 3 | 4.094      | 0.022             | 0.00            | 0.032      | 0.064             |           | Set Trigger |
| 4 | 4.106      | 0.023             | 0.00            | 0.032      | 0.067             |           | Set Trigger |
| 5 | 4.039      | 0.022             | 0.00            | 0.032      | 0.064             |           | Set Trigger |

A 4.09

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

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



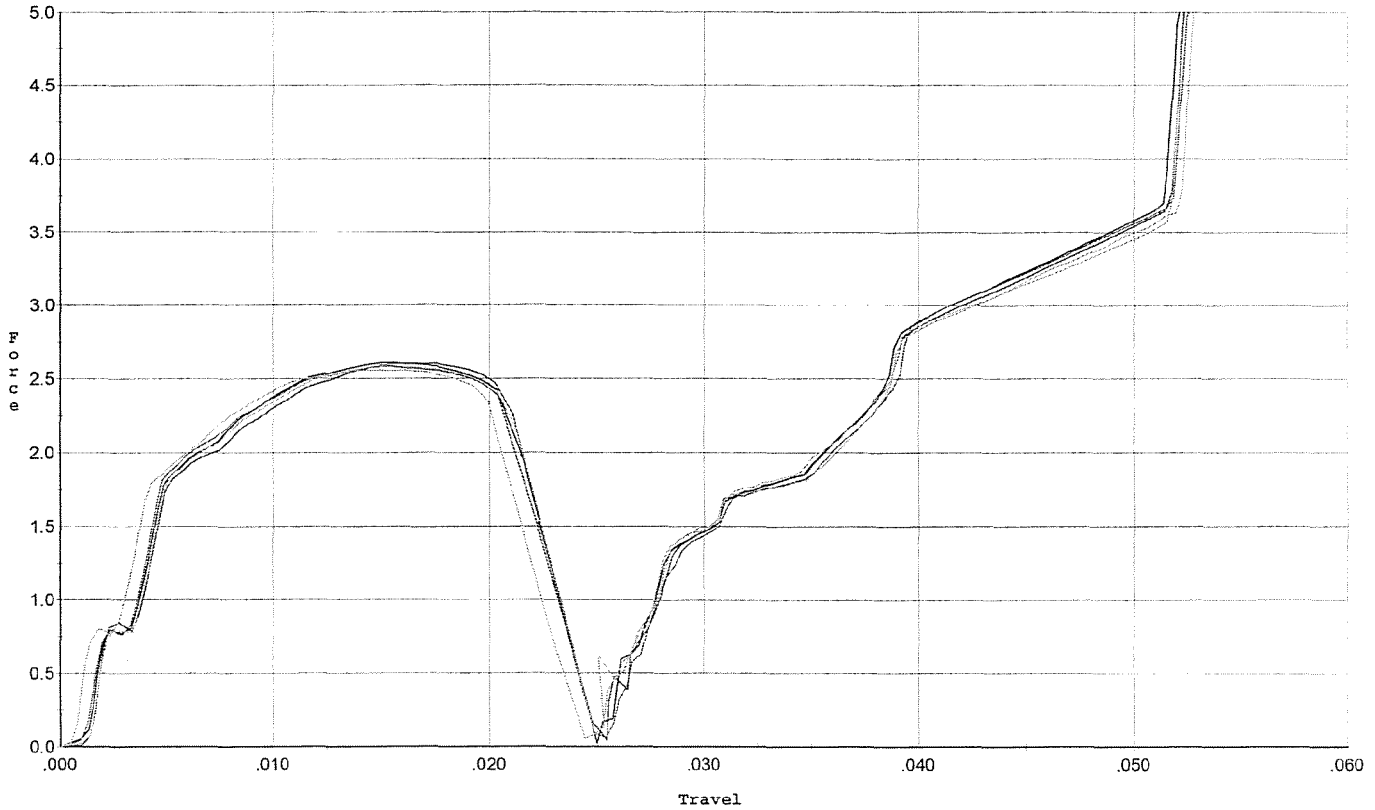
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.089      | 0.023             | 0.004           | 0.031      | 0.066             |           | Set Trigger |
| 2 | 4.024      | 0.024             | 0.00            | 0.031      | 0.068             |           | Set Trigger |
| 3 | 3.969      | 0.024             | 0.00            | 0.031      | 0.068             |           | Set Trigger |
| 4 | 4.031      | 0.023             | 0.00            | 0.032      | 0.064             |           | Set Trigger |
| 5 | 4.014      | 0.024             | 0.00            | 0.031      | 0.068             |           | Set Trigger |

ALF. 02

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: C Schults 3/17/2009

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



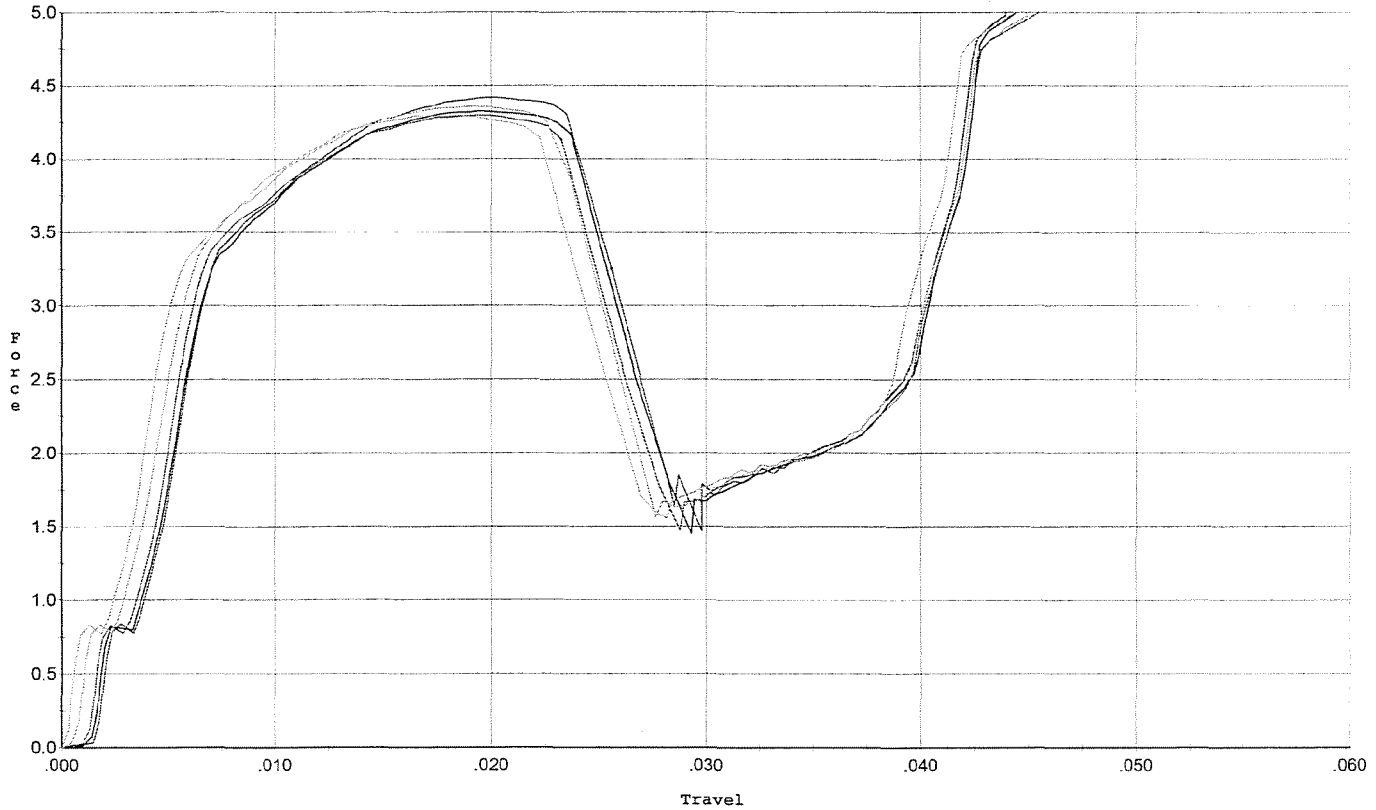
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.604      | 0.021             | 0.00            | 0.035      | 0.039             |           | Set Trigger |
| 2 | 2.608      | 0.021             | 0.00            | 0.035      | 0.041             |           | Set Trigger |
| 3 | 2.581      | 0.022             | 0.00            | 0.035      | 0.042             |           | Set Trigger |
| 4 | 2.592      | 0.021             | 0.00            | 0.035      | 0.040             |           | Set Trigger |
| 5 | 2.558      | 0.020             | 0.00            | 0.036      | 0.039             |           | Set Trigger |

A.2.58

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** C Schults 3/17/2009

**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 | 4.419      | 0.026             | 0.00            | 0.031      | 0.078             |           | Set Trigger |
| 2 | 4.326      | 0.024             | 0.004           | 0.031      | 0.071             |           | Set Trigger |
| 3 | 4.297      | 0.023             | 0.00            | 0.032      | 0.070             |           | Set Trigger |
| 4 | 4.299      | 0.022             | 0.00            | 0.031      | 0.070             |           | Set Trigger |
| 5 | 4.359      | 0.024             | 0.00            | 0.031      | 0.074             |           | Set Trigger |

A-4.34