

66784969

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



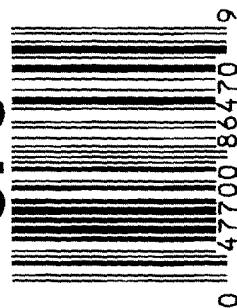
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6784969**

**UPC**



BM FORM

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6784968

| OP # | OPERATION NAME                                                                                                                         | READINGS                                                                                                                                                                                                       | DATE     | INITIAL |
|------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                                                                                        |                                                                                                                                                                                                                | 9-18-08  | JP      |
| 430  | ASSEMBLE TO STOCK                                                                                                                      |                                                                                                                                                                                                                | 9-18-08  | JP      |
| 440  | PROOF                                                                                                                                  |                                                                                                                                                                                                                | 9-18-08  | JP      |
| 460  | CHECK HEADSPACE                                                                                                                        |                                                                                                                                                                                                                | 9-18-08  | JP      |
| 470  | DIS-ASSEMBLE ACTION                                                                                                                    |                                                                                                                                                                                                                | 9-18-08  | JP      |
| 472  | SERIALIZE BOLT HANDLE                                                                                                                  |                                                                                                                                                                                                                | 10-7-08  | RT      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                                                                                           | <div style="border: 1px solid black; padding: 5px; display: inline-block;"> MAGNA-FLUX<br/> ULI US 2008<br/> OPERATOR <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">Y</span> </div> | 10-7-08  | JP      |
| 480  | MAGNAFLUX BBL ACTION                                                                                                                   |                                                                                                                                                                                                                | 10/8/08  | JP      |
| 490  | MAGNAFLUX BOLT                                                                                                                         |                                                                                                                                                                                                                | 9/18/08  | JP      |
| 500  | ROLLMARK CALIBER                                                                                                                       |                                                                                                                                                                                                                | 10/10/08 | RT      |
| 520  | GOFF BLAST BBL / REC                                                                                                                   |                                                                                                                                                                                                                | 10/9/08  | DG      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                                                                                                                                                                                                                | 10/3     | C       |
| 545  | (BOLT)                                                                                                                                 |                                                                                                                                                                                                                |          |         |
| 560  | RE-ASSEMBLE ACTION                                                                                                                     |                                                                                                                                                                                                                |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                                                                                                                                                                                                                | 10-13-08 | JP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                                                                                                                                                                                                                | 10-13-08 | JP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                                                                                                                                                                                                                | 10-13-08 | JP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                                                                                                                                                                                                                | 11-19-08 | JP      |
|      | 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>5.0</u> <u>4.0</u> <u>5.0</u>                            | 12-17-08 | L.N.    |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>6.0</u> <u>6.0</u> <u>6.0</u>                            | 12-17-08 | L.N.    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.025</u> <u>.025</u> <u>.024</u>                         | 12-17-08 | L.N.    |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 11-19-08 | RP      |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 12-17-08 | L.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                        | 12-12-08 | L.R.D.  |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 12-12-08 | RP      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 12-17-08 | L.N.    |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.35</u> <u>2.39</u> <u>2.30</u> <u>2.31</u> <u>2.31</u> | 12-16-08 | TC      |
|              | C) FUNCTION                                                              |                                                             | 12-17-08 | L.N.    |
| 690          | PACK                                                                     |                                                             | 1-10-09  | TC      |

F004 REV 5/2006

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)  
3.00 LBS (plus or minus 0.75 LBS)  
4.00 LBS (plus or minus 1.00 LBS)

DATE 11-13-08  
TESTER TAE

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER 50<br>CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |      | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|------|----------|
| PULL #1 | 252                 | 271                         |                                   | 273  |          |
| PULL #2 | 262                 | 272                         |                                   | 273  |          |
| PULL #3 | 262                 | 271                         |                                   | 273  |          |
| PULL #4 | 264                 | 266                         |                                   | 266  |          |
| PULL #5 | 264                 | 269                         |                                   | 260  |          |
| TOTAL   | 1304                | 1349                        |                                   | 1345 |          |
| AVERAGE | 260                 | 269                         |                                   | 269  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER 20<br>CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 328                 | 353                         |  |          |
| PULL #2 | <del>328</del> 328  | 349                         |  |          |
| PULL #3 | 348                 | 345                         |  |          |
| PULL #4 | 360                 | 353                         |  |          |
| PULL #5 | 349                 | 347                         |  |          |
| TOTAL   | 1738                | <del>1749</del> 1747        |  |          |
| AVERAGE | 347                 | 349                         |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER 20<br>CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 462                 | 461                         |                                   | 422                                     |
| PULL #2 | 457                 | 454                         |                                   | 423                                     |
| PULL #3 | 465                 | 470                         |                                   | 413                                     |
| PULL #4 | 451                 | 474                         |                                   | 441                                     |
| PULL #5 | 472                 | 463                         |                                   | 422                                     |
| TOTAL   | 2307                | 2322                        |                                   | 2121                                    |
| AVERAGE | 461                 | 464                         |                                   | 424                                     |

FORM REV 5/2005

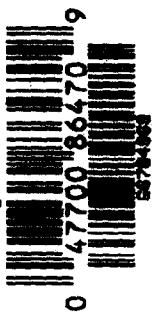
G6784969

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BOLT ACTION CENTERFIRE RIFLE  
24" BARREL 7.62 NATO  
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owner registration sticker



ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

**G6784969**

**UPC**



BM FORM

## INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6784969

| OP # | OPERATION NAME                                                             | READINGS     | DATE    | INITIAL |
|------|----------------------------------------------------------------------------|--------------|---------|---------|
| 420  | ASSEMBLE ACTION                                                            |              | 9-8-08  | SP      |
| 430  | ASSEMBLE TO STOCK                                                          |              | 9-8-08  | SP      |
| 440  | PROOF                                                                      |              | 9-8-08  | SP      |
| 460  | CHECK HEADSPACE                                                            |              | 9-8-08  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                                        |              | 9-8-08  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                                      | MAGNA - FLUX | 9-9-08  | SP      |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                               | SEP 10 2008  | 9-9-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                                       | OPERATOR Bm  | 9-10-08 | Bm      |
| 490  | MAGNAFLUX BOLT                                                             |              | 9/18/08 | MB      |
| 500  | ROLLMARK CALIBER                                                           |              | 9/10/08 | RT      |
| 520  | GOFF BLAST BBL / REC                                                       |              | 9/16/08 | DS      |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                                          |              | 9/14    | c       |
| 545  | (BOLT)                                                                     |              |         |         |
| 560  | RE-ASSEMBLE ACTION                                                         |              |         |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                        |              | 9-16-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD             |              | 9-16-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                     |              | 9-16-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                                 |              | 9-22-08 | Bm      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE 2.60 LBS +/- .5 LBS |              |         |         |

F004 REV 5/2006

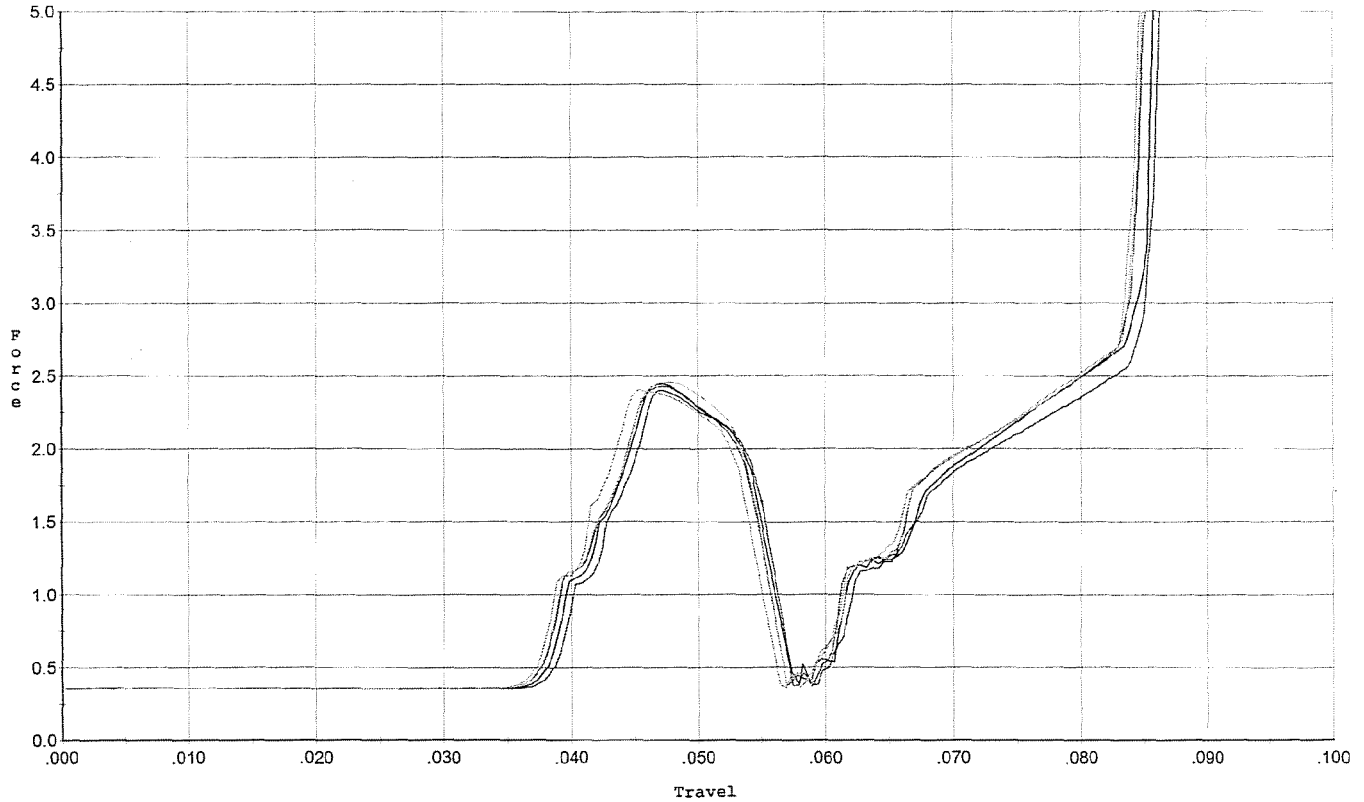
| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>2.5</u> <u>2</u> <u>2.5</u>                              | 9-24-08 | TL      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.5</u> <u>4.5</u> <u>4.5</u>                            | 9-24-08 | TL      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.024</u> <u>.025</u> <u>.024</u>                         | 9-24-08 | R       |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 9-22-08 | BRW     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 9-24-08 | TL      |
|              | 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                        | 9-23-08 | TRW     |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 9-23-08 | L.2.    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 9-24-08 | TL      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.69</u> <u>2.56</u> <u>2.45</u> <u>2.41</u> <u>2.44</u> | 9-24-08 | TL      |
|              | C) FUNCTION                                                              |                                                             | 9-24-08 | TL      |
| 690          | PACK                                                                     |                                                             | 12/4/08 | FM      |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putch 9/15/08

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



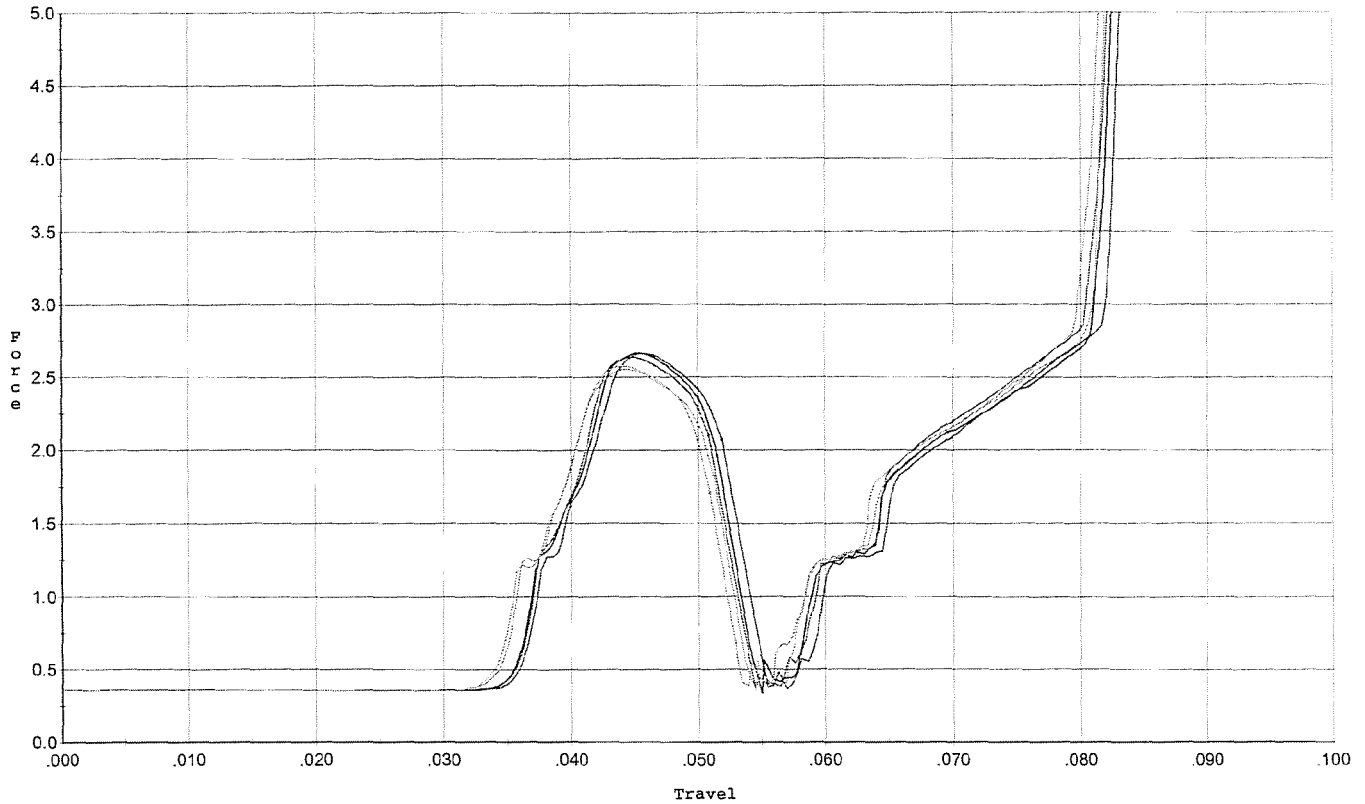
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.400      | 0.055             | 0.039           | 0.038      | 0.044             |           | Set Trigger |
| 2 | 2.446      | 0.054             | 0.038           | 0.038      | 0.044             |           | Set Trigger |
| 3 | 2.430      | 0.055             | 0.038           | 0.037      | 0.045             |           | Set Trigger |
| 4 | 2.458      | 0.055             | 0.038           | 0.037      | 0.046             |           | Set Trigger |
| 5 | 2.404      | 0.055             | 0.038           | 0.037      | 0.045             |           | Set Trigger |

AVG 2.42

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putch 9/15/08

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



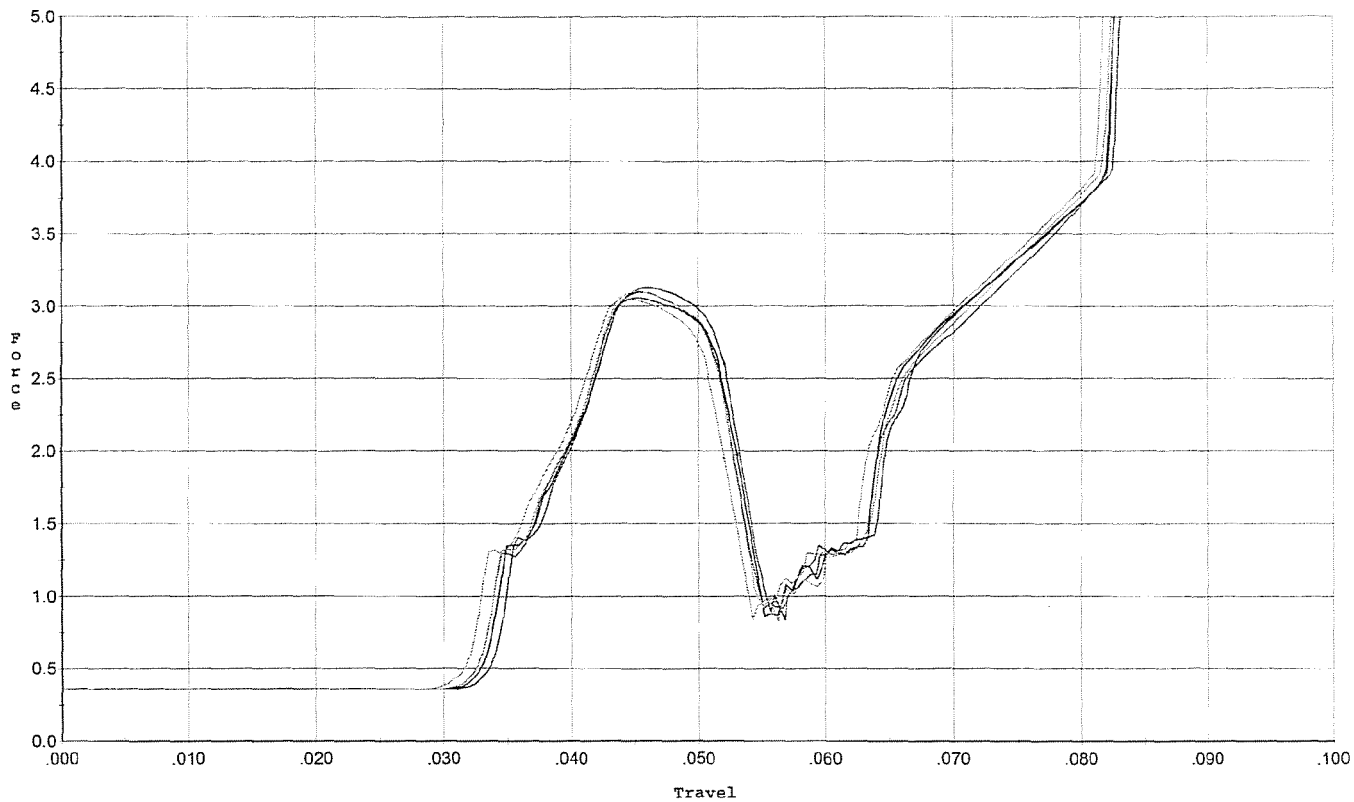
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.663      | 0.052             | 0.036           | 0.037      | 0.047             |           | Set Trigger |
| 2 | 2.664      | 0.052             | 0.036           | 0.037      | 0.046             |           | Set Trigger |
| 3 | 2.638      | 0.051             | 0.036           | 0.037      | 0.045             |           | Set Trigger |
| 4 | 2.554      | 0.051             | 0.034           | 0.036      | 0.047             |           | Set Trigger |
| 5 | 2.575      | 0.051             | 0.035           | 0.036      | 0.046             |           | Set Trigger |

Avg 2.61

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putsch 9/15/08

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



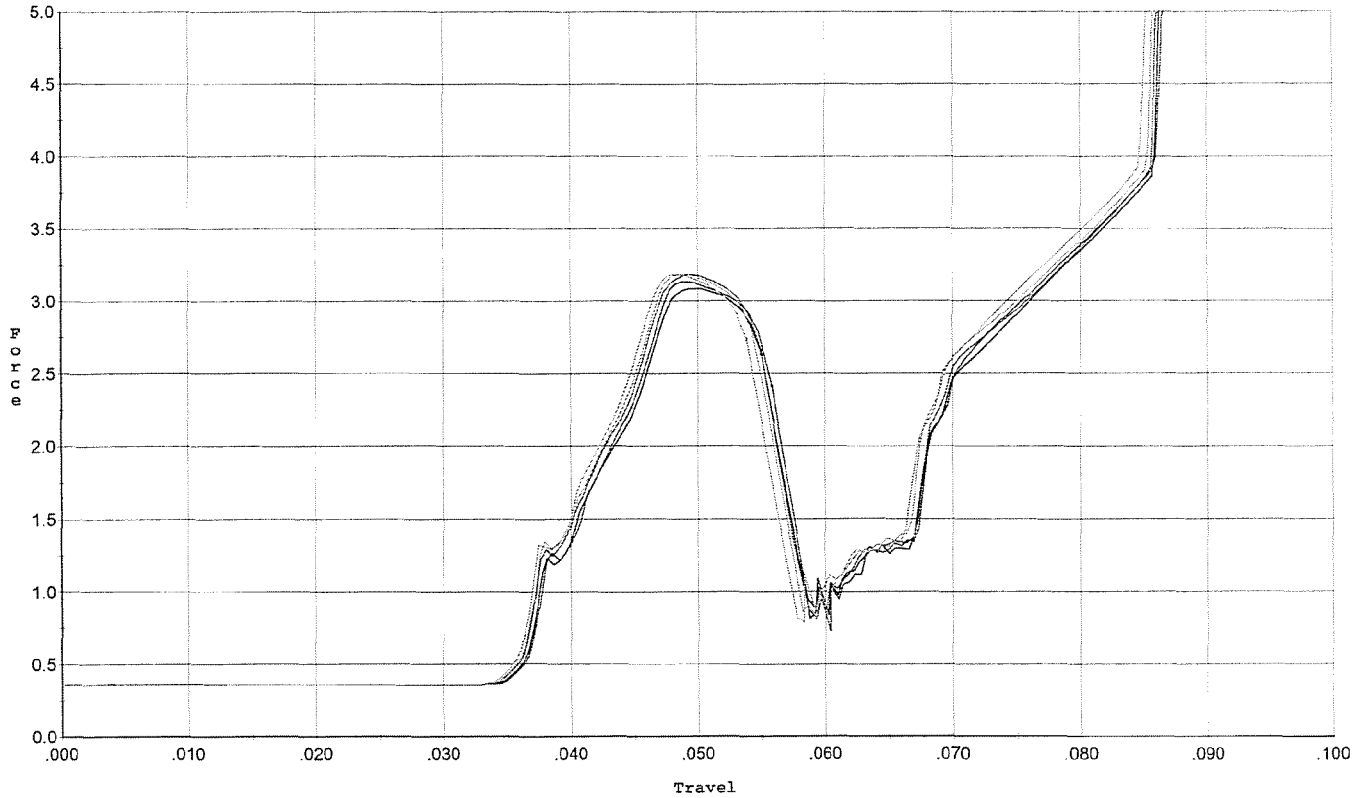
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.128      | 0.052             | 0.034           | 0.035      | 0.057             |           | Set Trigger |
| 2 | 3.097      | 0.053             | 0.033           | 0.035      | 0.058             |           | Set Trigger |
| 3 | 3.058      | 0.052             | 0.033           | 0.035      | 0.056             |           | Set Trigger |
| 4 | 3.103      | 0.052             | 0.033           | 0.035      | 0.057             |           | Set Trigger |
| 5 | 3.053      | 0.052             | 0.032           | 0.035      | 0.057             |           | Set Trigger |

Avg 3.08

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: R. Putch 9/15/08

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



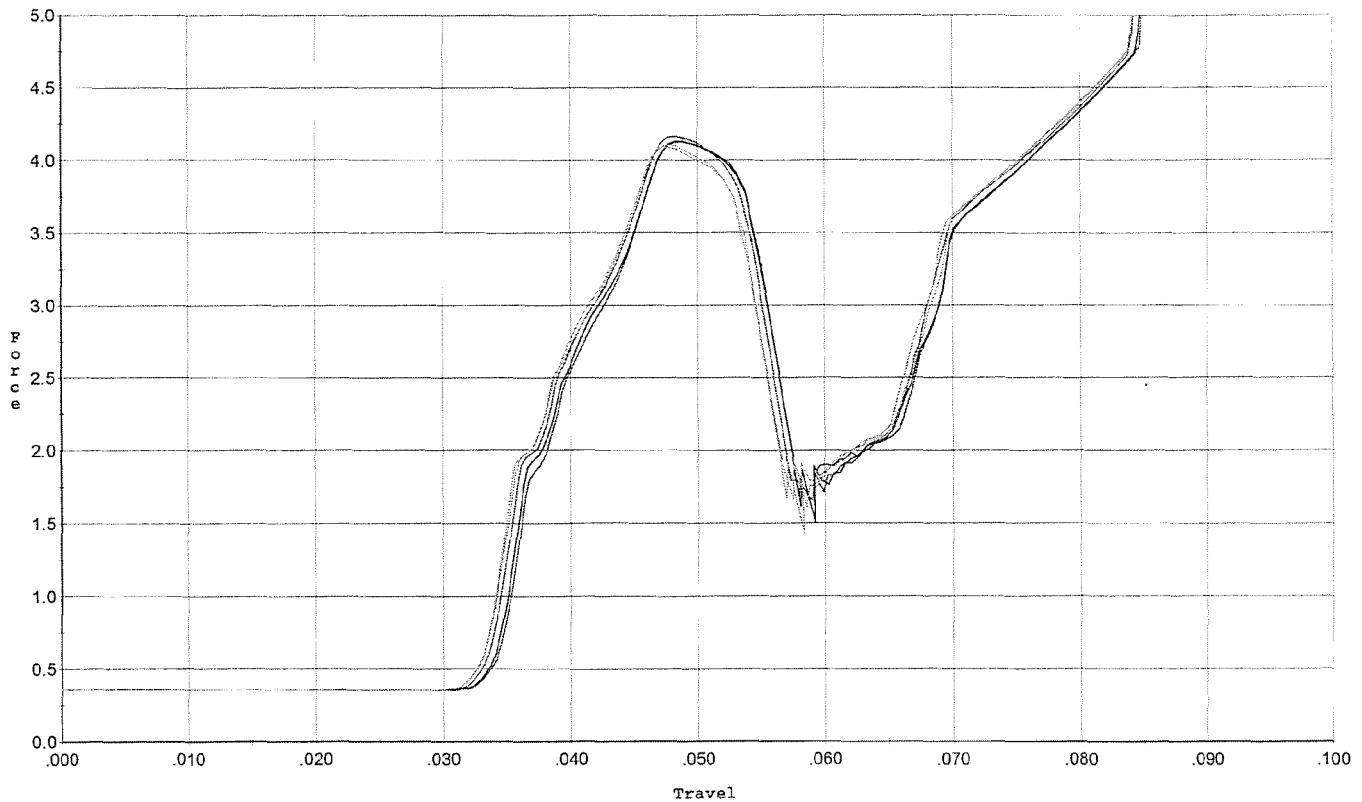
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.132      | 0.056             | 0.037           | 0.036      | 0.059             |           | Set Trigger |
| 2 | 3.085      | 0.055             | 0.037           | 0.036      | 0.057             |           | Set Trigger |
| 3 | 3.180      | 0.055             | 0.037           | 0.036      | 0.059             |           | Set Trigger |
| 4 | 3.180      | 0.056             | 0.036           | 0.036      | 0.060             |           | Set Trigger |
| 5 | 3.180      | 0.054             | 0.036           | 0.036      | 0.057             |           | Set Trigger |

Avg 3.15

# Trigger Profile [ lbs,inch ]

Profile SWS  
 GunType: Rifle  
 Make: Remington  
 Note: R. Putch 9/15/08

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



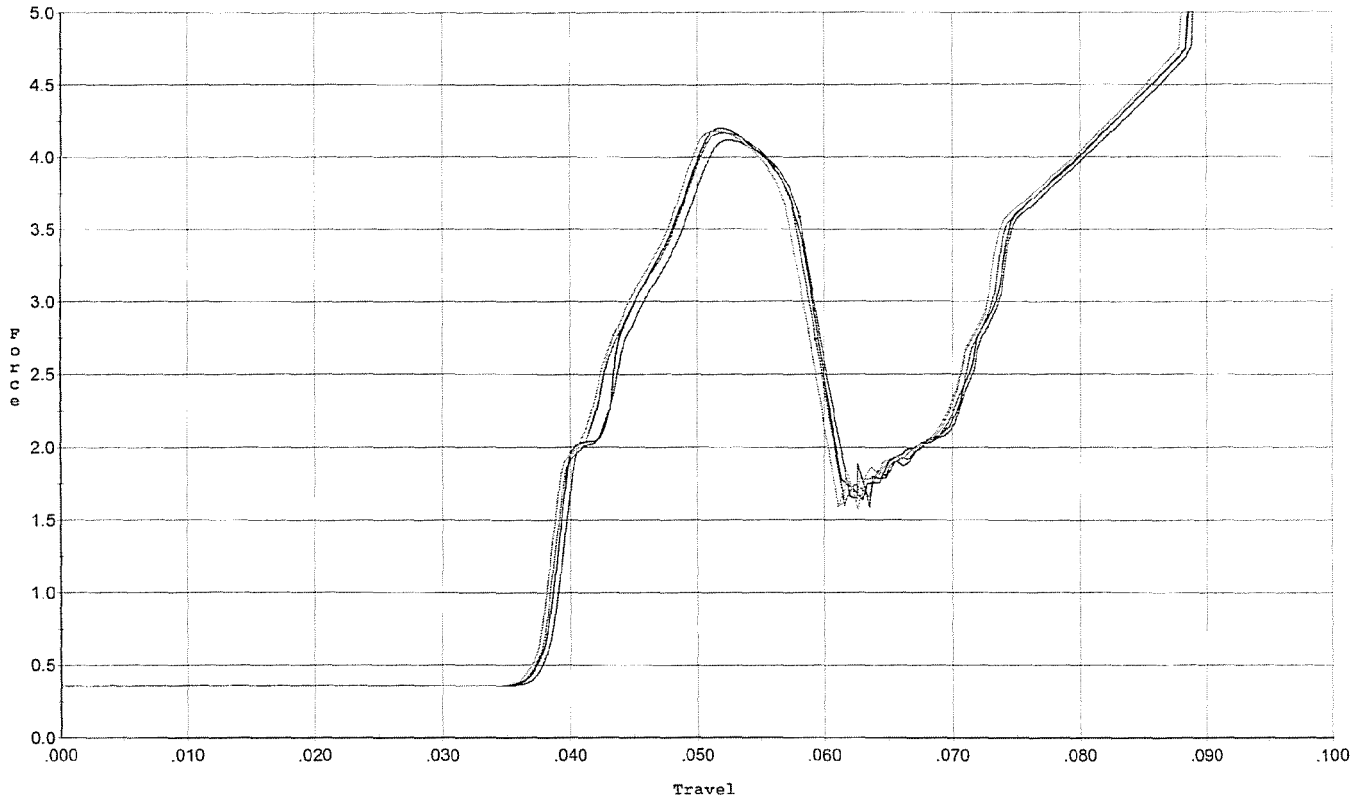
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.125      | 0.055             | 0.034           | 0.034      | 0.078             |           | Set Trigger |
| 2 | 4.131      | 0.055             | 0.034           | 0.034      | 0.079             |           | Set Trigger |
| 3 | 4.162      | 0.054             | 0.033           | 0.034      | 0.079             |           | Set Trigger |
| 4 | 4.085      | 0.054             | 0.033           | 0.034      | 0.077             |           | Set Trigger |
| 5 | 4.104      | 0.054             | 0.033           | 0.034      | 0.078             |           | Set Trigger |

Arg 4.12

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putch 9/15/08

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



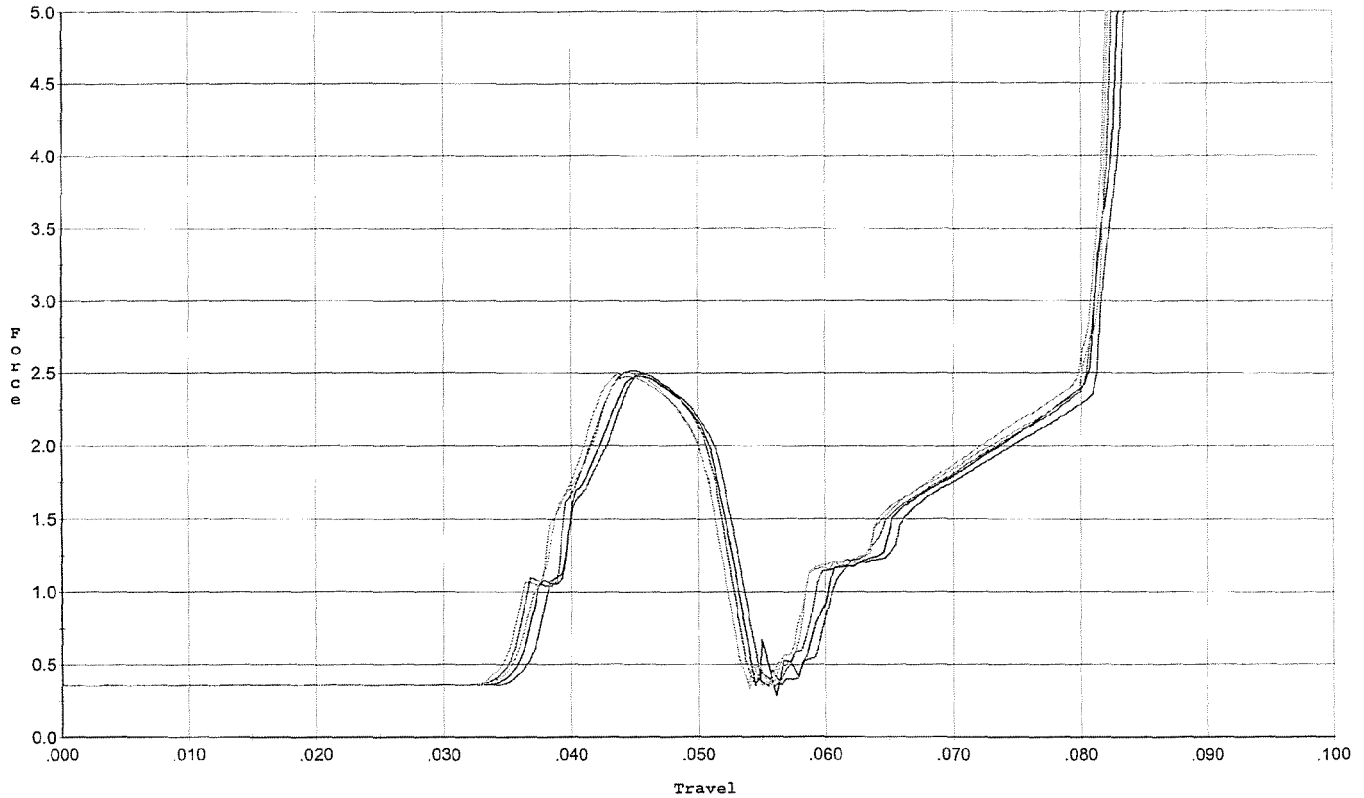
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.117      | 0.058             | 0.038           | 0.034      | 0.079             |           | Set Trigger |
| 2 | 4.199      | 0.058             | 0.037           | 0.034      | 0.081             |           | Set Trigger |
| 3 | 4.166      | 0.059             | 0.037           | 0.034      | 0.083             |           | Set Trigger |
| 4 | 4.177      | 0.059             | 0.037           | 0.034      | 0.082             |           | Set Trigger |
| 5 | 4.182      | 0.059             | 0.037           | 0.034      | 0.082             |           | Set Trigger |

Avg 4.16

## Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putch 9/15/08

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



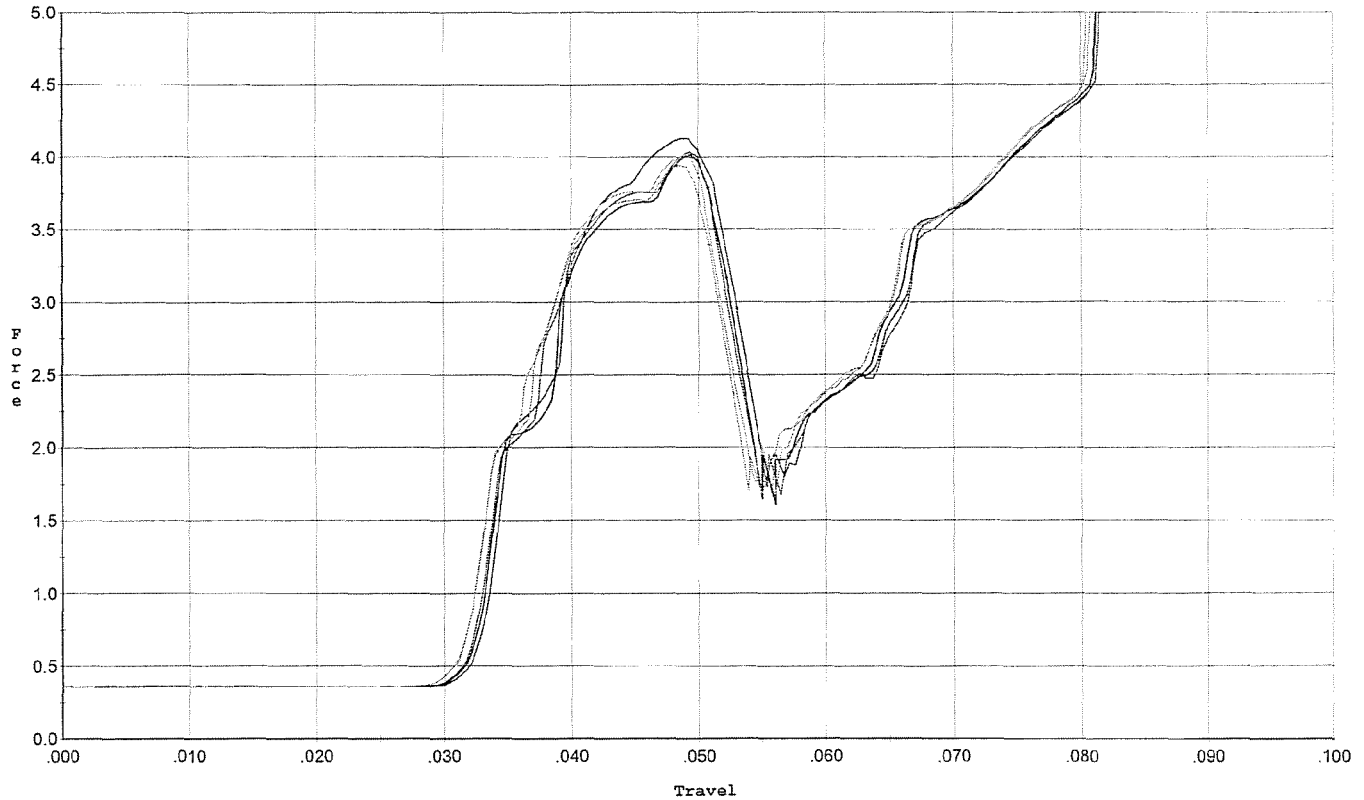
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.493      | 0.053             | 0.037           | 0.037      | 0.044             |           | Set Trigger |
| 2 | 2.478      | 0.052             | 0.036           | 0.037      | 0.044             |           | Set Trigger |
| 3 | 2.515      | 0.051             | 0.035           | 0.037      | 0.044             |           | Set Trigger |
| 4 | 2.476      | 0.051             | 0.036           | 0.037      | 0.043             |           | Set Trigger |
| 5 | 2.505      | 0.051             | 0.035           | 0.037      | 0.044             |           | Set Trigger |

Avg 2.49

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** R. Putch 9/15/08

**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 | 4.130      | 0.053             | 0.032           | 0.033      | 0.077             |           | Set Trigger |
| 2 | 4.019      | 0.052             | 0.032           | 0.033      | 0.074             |           | Set Trigger |
| 3 | 4.038      | 0.051             | 0.032           | 0.033      | 0.072             |           | Set Trigger |
| 4 | 4.018      | 0.050             | 0.031           | 0.033      | 0.072             |           | Set Trigger |
| 5 | 3.945      | 0.051             | 0.032           | 0.032      | 0.072             |           | Set Trigger |

Avg 4.03