

6685-2345

**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



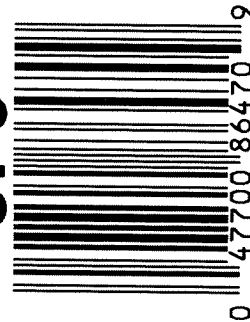
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

**G6852345**

**UPC**



**BM FORM**

GUN SERIAL # G6852345

| OP #            | OPERATION NAME                                                                                                                         | READINGS            | DATE    | INITIAL |
|-----------------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------|---------|---------|
| 420             | ASSEMBLE ACTION                                                                                                                        |                     | 4-15-09 | RPD     |
| 430             | ASSEMBLE TO STOCK                                                                                                                      |                     | 4-15-09 | RP      |
| 440             | PROOF                                                                                                                                  |                     | 4-15-09 | RPD     |
| 460             | CHECK HEADSPACE                                                                                                                        |                     | 4-15-09 | RP      |
| 470             | DIS-ASSEMBLE ACTION                                                                                                                    |                     | 4-15-09 | RP      |
| 472             | SERIALIZE BOLT HANDLE                                                                                                                  | MAGNA - FLUX        | 4-16-09 | RT      |
| 475             | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                     | 4-15-09 | JP      |
| 480             | MAGNAFLUX BBL ACTION                                                                                                                   | OPERATOR <u>(B)</u> | 4/18/09 | (A)     |
| 490             | MAGNAFLUX BOLT                                                                                                                         |                     |         |         |
| 500             | ROLLMARK CALIBER                                                                                                                       |                     | 4/20/09 | RT      |
| 520             | GOFF BLAST BBL / REC                                                                                                                   |                     | 4/21/09 | CS      |
| 542             | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                     | 4-28    |         |
| 545             | (BOLT)                                                                                                                                 |                     |         |         |
| 560             | RE-ASSEMBLE ACTION                                                                                                                     |                     |         |         |
|                 | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                     | 4-30-09 | JP      |
|                 | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                     | 4-30-09 | JP      |
|                 | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                     | 4-30-09 | JP      |
|                 | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                     | 5-1-09  | RT      |
|                 | 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 |                                                                                                                                        |                     |         |         |

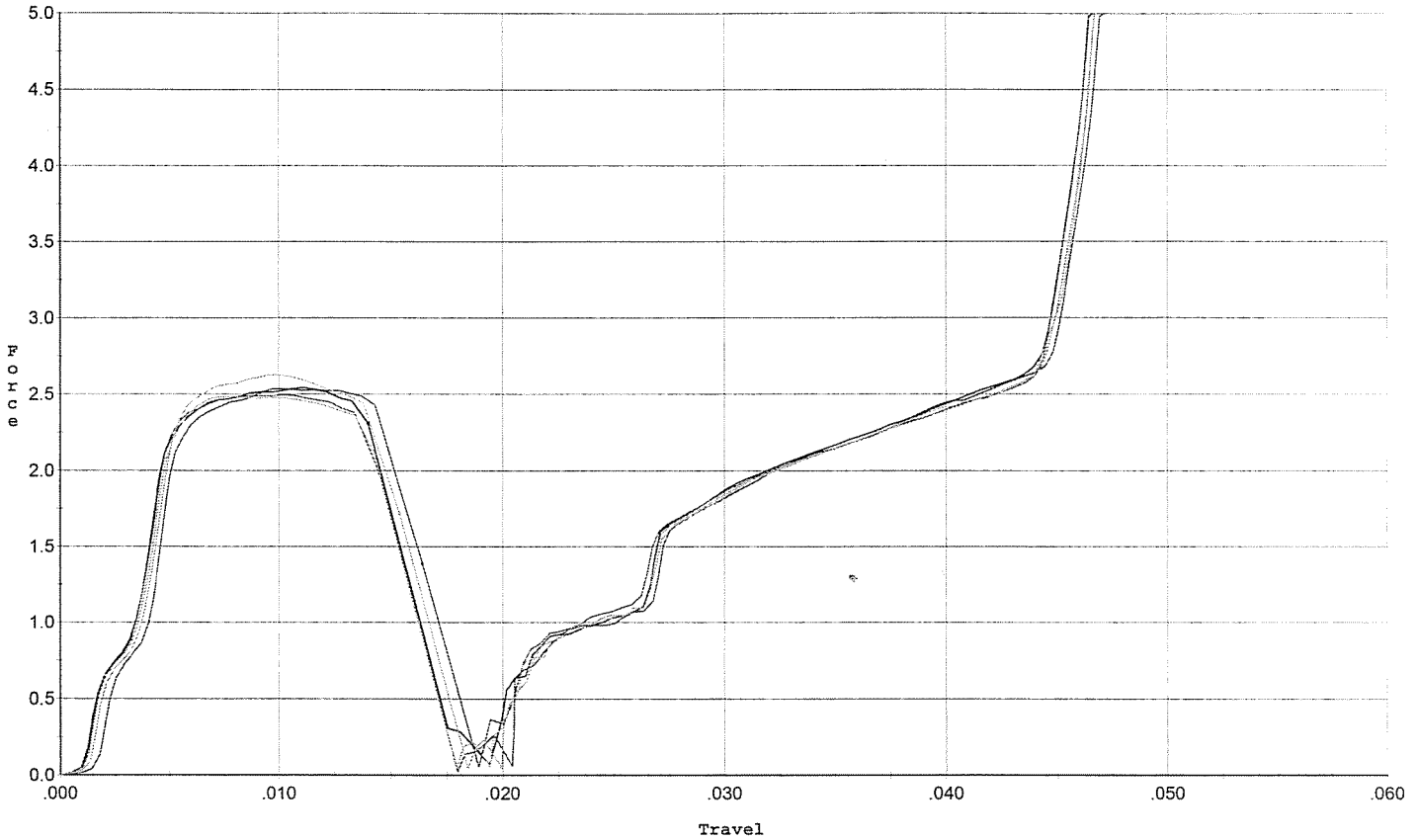
|              |                                                                       |                                           |             |             |             |             |             |         |    |
|--------------|-----------------------------------------------------------------------|-------------------------------------------|-------------|-------------|-------------|-------------|-------------|---------|----|
| 560          | F) SAFETY ON FORCE                                                    | 10 LBS MAX                                | <u>2.0</u>  | <u>2.3</u>  | <u>2.0</u>  | 5/22/09     | RP          |         |    |
| CONT.        |                                                                       |                                           |             |             |             |             |             |         |    |
|              | G) SAFETY OFF FORCE                                                   | 2 LBS MIN                                 | <u>3.3</u>  | <u>3.6</u>  | <u>3.6</u>  | 5/22/09     | RP          |         |    |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                             |                                           |             |             |             |             |             |         |    |
|              | I) FIRING PIN INDENT                                                  | .020 MIN                                  | <u>.022</u> | <u>.024</u> | <u>.023</u> | 5/22/09     | RP          |         |    |
|              | J) ASSEMBLE STOCK                                                     |                                           |             |             |             | 5-1-09      | NW          |         |    |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                           |                                           |             |             |             | 5/22/09     | RP          |         |    |
|              | 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        |             | 5/14/09     | RP          |         |    |
|              |                                                                       |                                           | <u>PASS</u> | FAIL        |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           | N/A         |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |         |    |
|              | MALFUNCTION                                                           |                                           |             |             |             |             |             |         |    |
| 660          | INSPECT FOR LIVE AMMO                                                 |                                           |             |             |             | 5-14-09     | NW          |         |    |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                      |                                           |             |             |             | 5/22/09     | RP          |         |    |
|              | B) TRIGGER PULL                                                       | +/- .5 LBS<br>MIN 2.50 LBS<br>MAX 4.0 LBS | <u>2.84</u> | <u>2.94</u> | <u>2.87</u> | <u>2.90</u> | <u>2.86</u> | 5-21-09 | NW |
|              | C) FUNCTION                                                           |                                           |             |             |             | 5/22/09     | RP          |         |    |
| 690          | PACK                                                                  |                                           |             |             |             | 7/30/09     | FM          |         |    |

F004 REV 5/2006

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: T Rogowski 4/6/2009

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



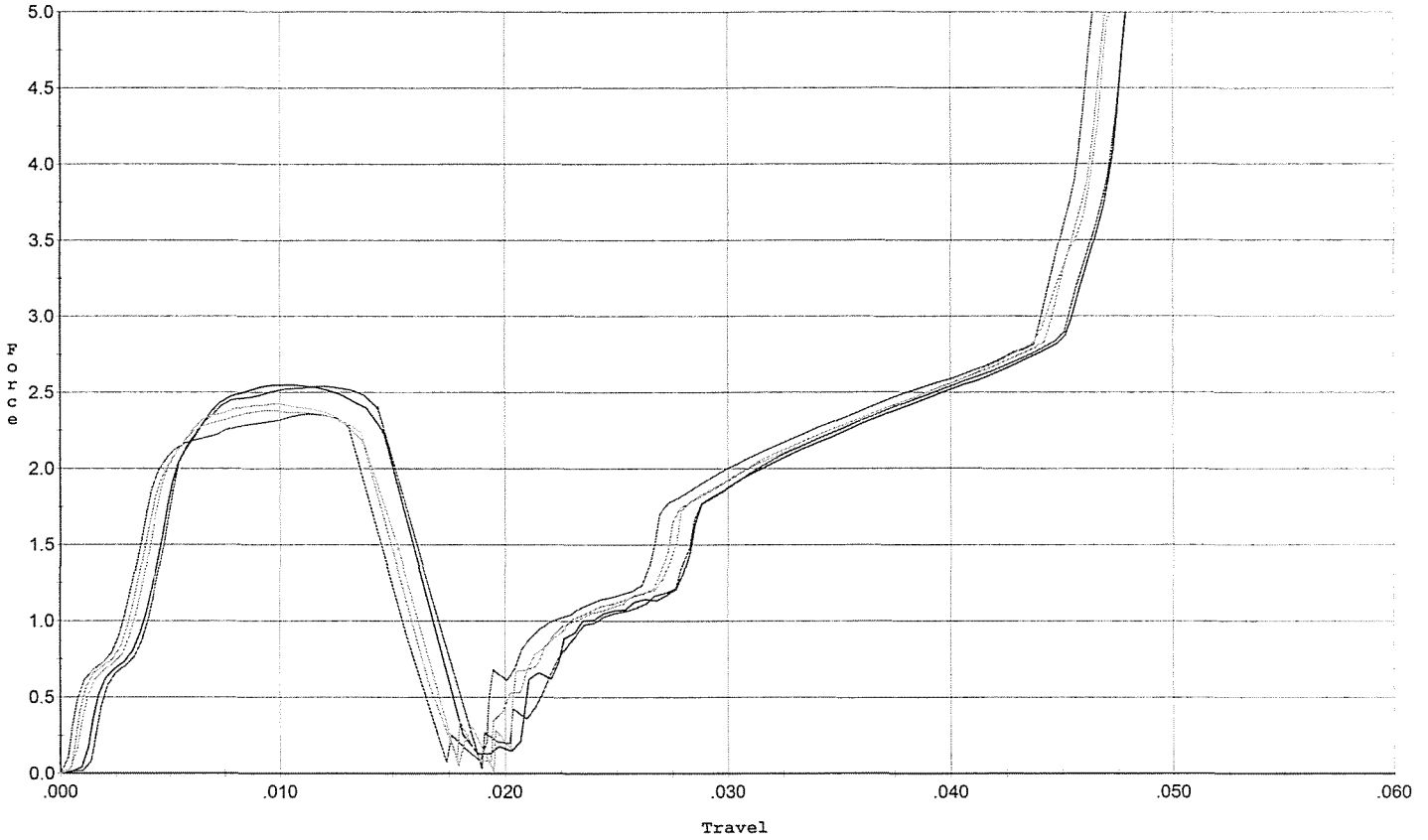
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.535      | 0.016             | 0.00            | 0.035      | 0.028             |           | Set Trigger |
| 2 | 2.542      | 0.014             | 0.00            | 0.036      | 0.025             |           | Set Trigger |
| 3 | 2.495      | 0.014             | 0.00            | 0.036      | 0.025             |           | Set Trigger |
| 4 | 2.626      | 0.015             | 0.00            | 0.035      | 0.027             |           | Set Trigger |
| 5 | 2.484      | 0.014             | 0.00            | 0.036      | 0.025             |           | Set Trigger |

A-2.53

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

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



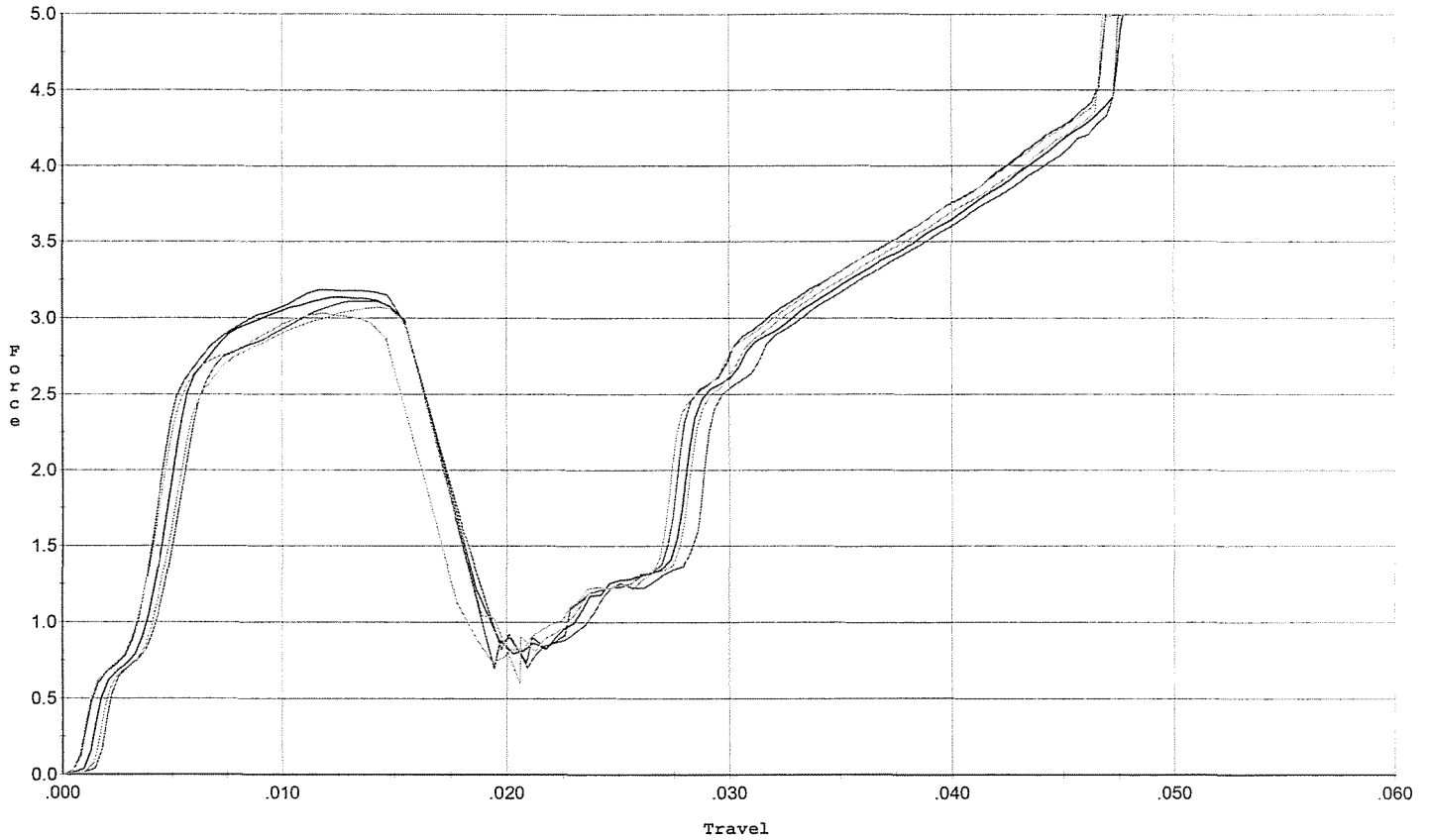
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.539      | 0.014             | 0.00            | 0.036      | 0.024             |           | Set Trigger |
| 2 | 2.549      | 0.015             | 0.00            | 0.036      | 0.025             |           | Set Trigger |
| 3 | 2.357      | 0.013             | 0.00            | 0.036      | 0.022             |           | Set Trigger |
| 4 | 2.428      | 0.015             | 0.00            | 0.036      | 0.026             |           | Set Trigger |
| 5 | 2.381      | 0.014             | 0.00            | 0.036      | 0.023             |           | Set Trigger |

A-2.45

# Trigger Profile [ lbs,inch ]

Profile SWS  
GunType: Rifle  
Make: Remington  
Note: T Rogowski 4/6/2009

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



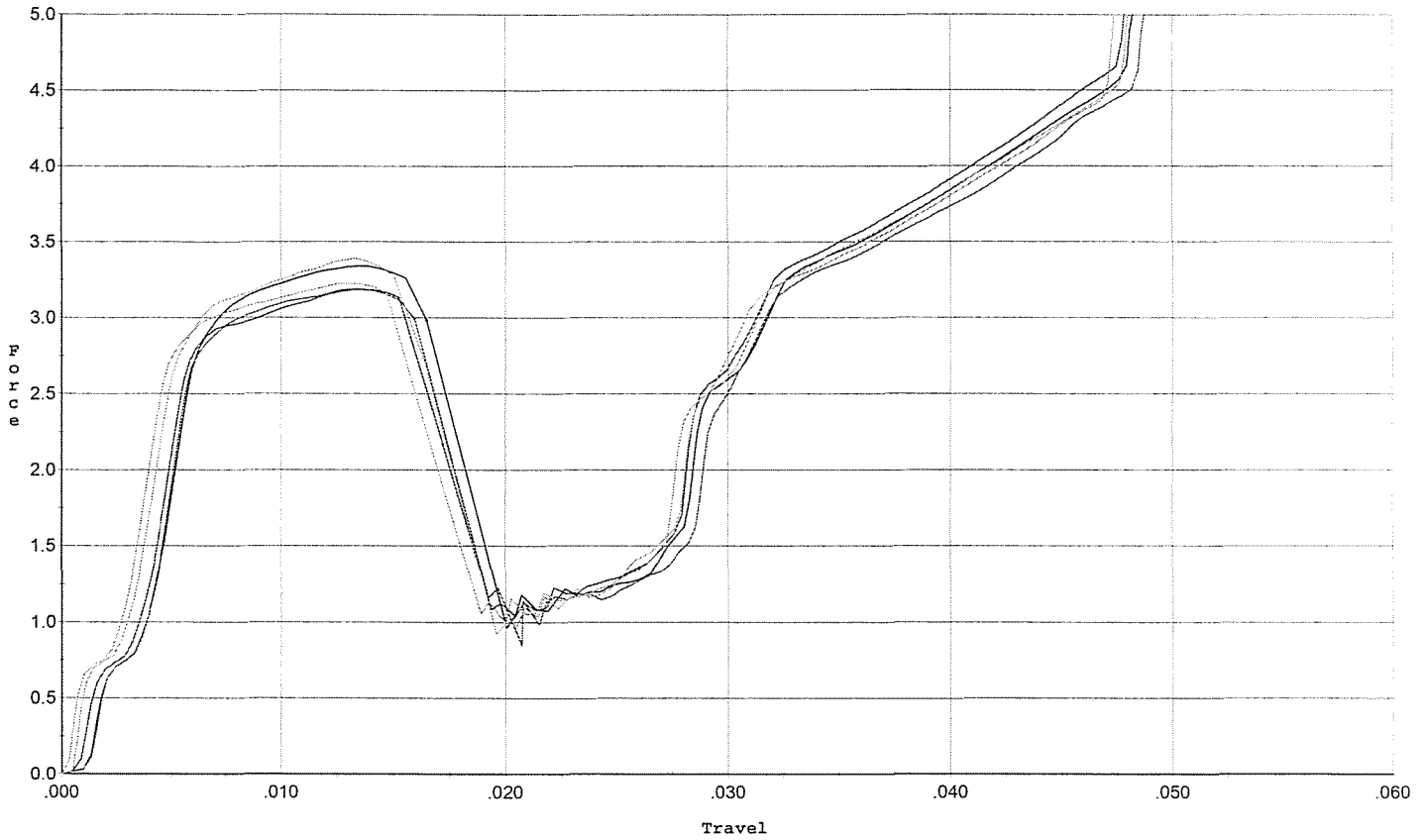
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.184      | 0.015             | 0.00            | 0.032      | 0.034             |           | Set Trigger |
| 2 | 3.136      | 0.015             | 0.00            | 0.033      | 0.032             |           | Set Trigger |
| 3 | 3.110      | 0.015             | 0.00            | 0.033      | 0.031             |           | Set Trigger |
| 4 | 3.072      | 0.016             | 0.00            | 0.032      | 0.031             |           | Set Trigger |
| 5 | 3.031      | 0.015             | 0.00            | 0.033      | 0.030             |           | Set Trigger |

A-3.10

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

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



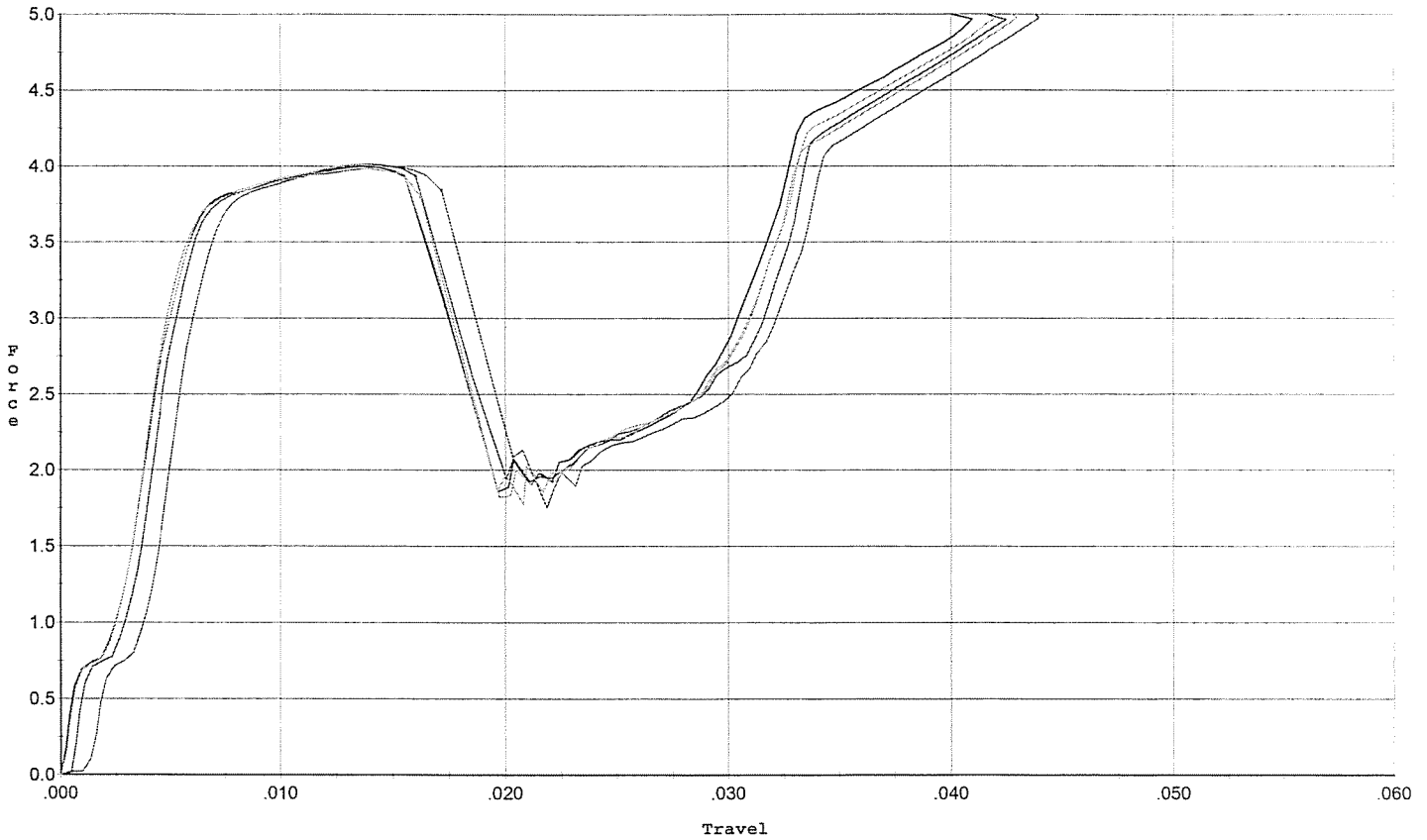
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 3.182      | 0.017             | 0.00            | 0.032      | 0.037             |           | Set Trigger |
| 2 | 3.339      | 0.016             | 0.00            | 0.032      | 0.036             |           | Set Trigger |
| 3 | 3.185      | 0.016             | 0.00            | 0.033      | 0.034             |           | Set Trigger |
| 4 | 3.389      | 0.016             | 0.00            | 0.033      | 0.038             |           | Set Trigger |
| 5 | 3.226      | 0.015             | 0.00            | 0.033      | 0.033             |           | Set Trigger |

A-3-26

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

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



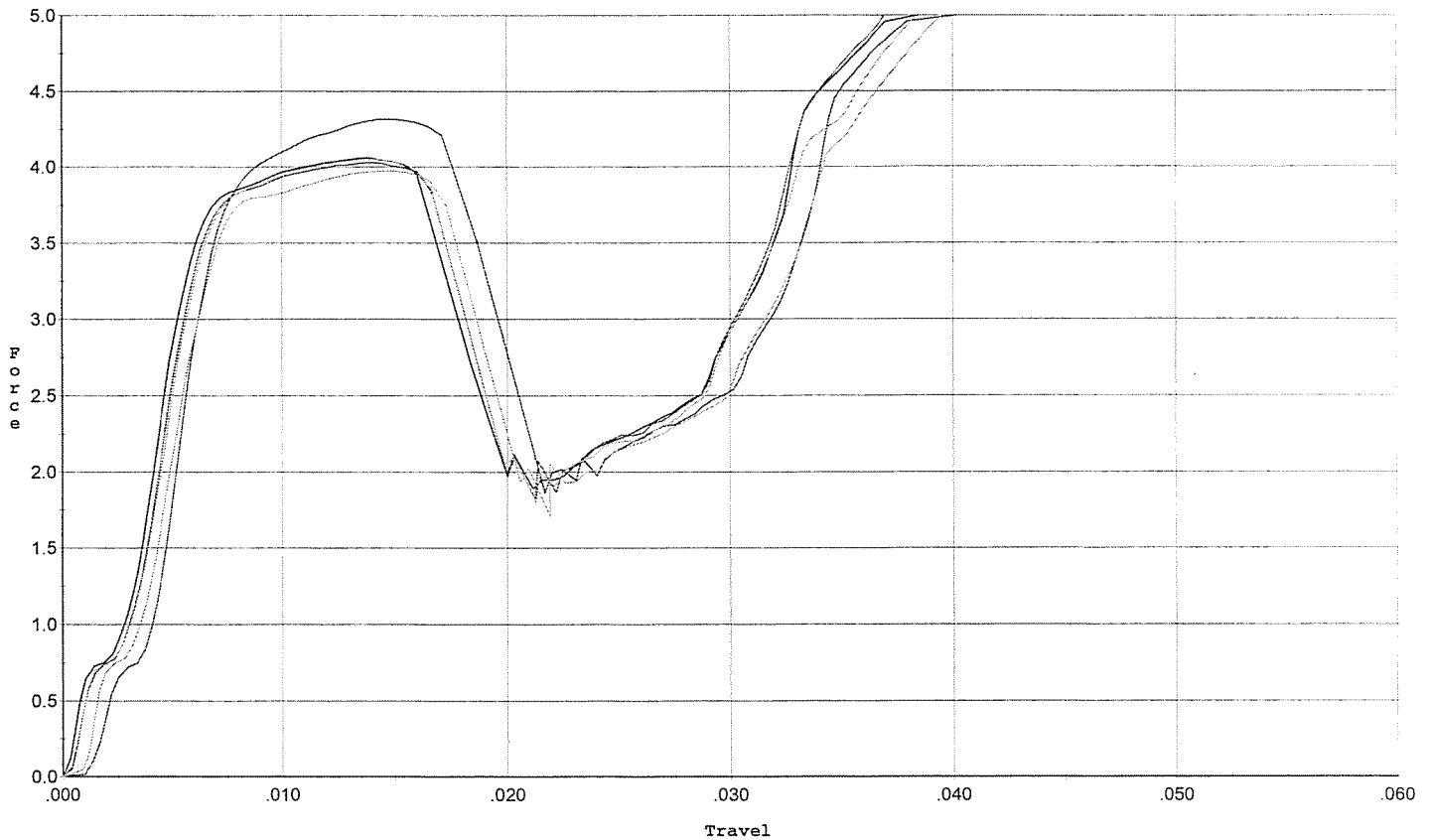
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.014      | 0.016             | 0.00            | 0.031      | 0.044             |           | Set Trigger |
| 2 | 3.998      | 0.017             | 0.00            | 0.031      | 0.048             |           | Set Trigger |
| 3 | 3.999      | 0.017             | 0.00            | 0.032      | 0.046             |           | Set Trigger |
| 4 | 4.015      | 0.017             | 0.00            | 0.031      | 0.048             |           | Set Trigger |
| 5 | 3.985      | 0.016             | 0.00            | 0.031      | 0.046             |           | Set Trigger |

A. 4.00

# Trigger Profile [ lbs,inch ]

**Profile:** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

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



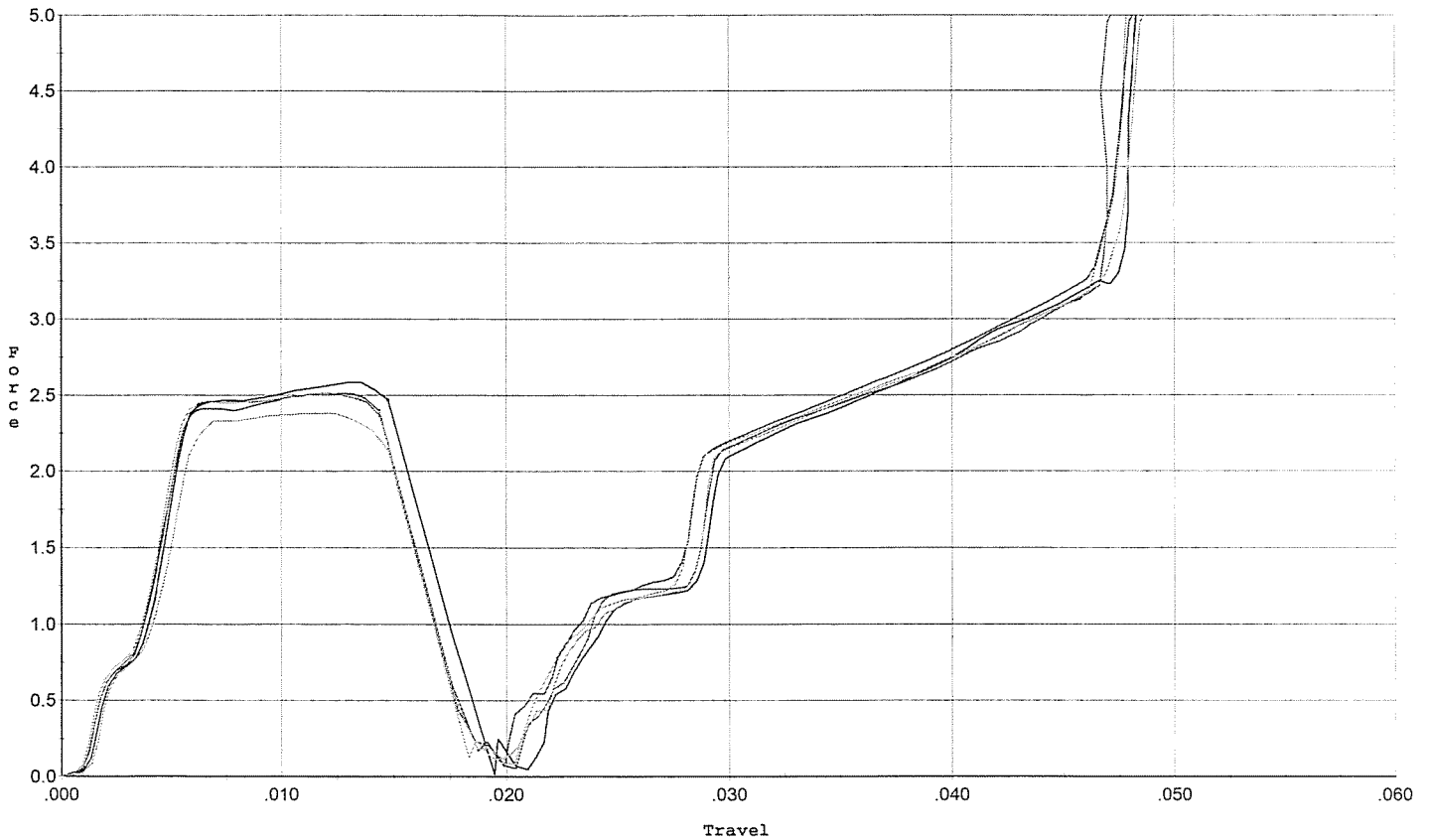
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 4.320      | 0.019             | 0.00            | 0.031      | 0.052             |           | Set Trigger |
| 2 | 4.062      | 0.016             | 0.00            | 0.031      | 0.044             |           | Set Trigger |
| 3 | 4.030      | 0.017             | 0.00            | 0.030      | 0.046             |           | Set Trigger |
| 4 | 4.053      | 0.017             | 0.00            | 0.030      | 0.046             |           | Set Trigger |
| 5 | 3.976      | 0.017             | 0.00            | 0.031      | 0.046             |           | Set Trigger |

A-4.08

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

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



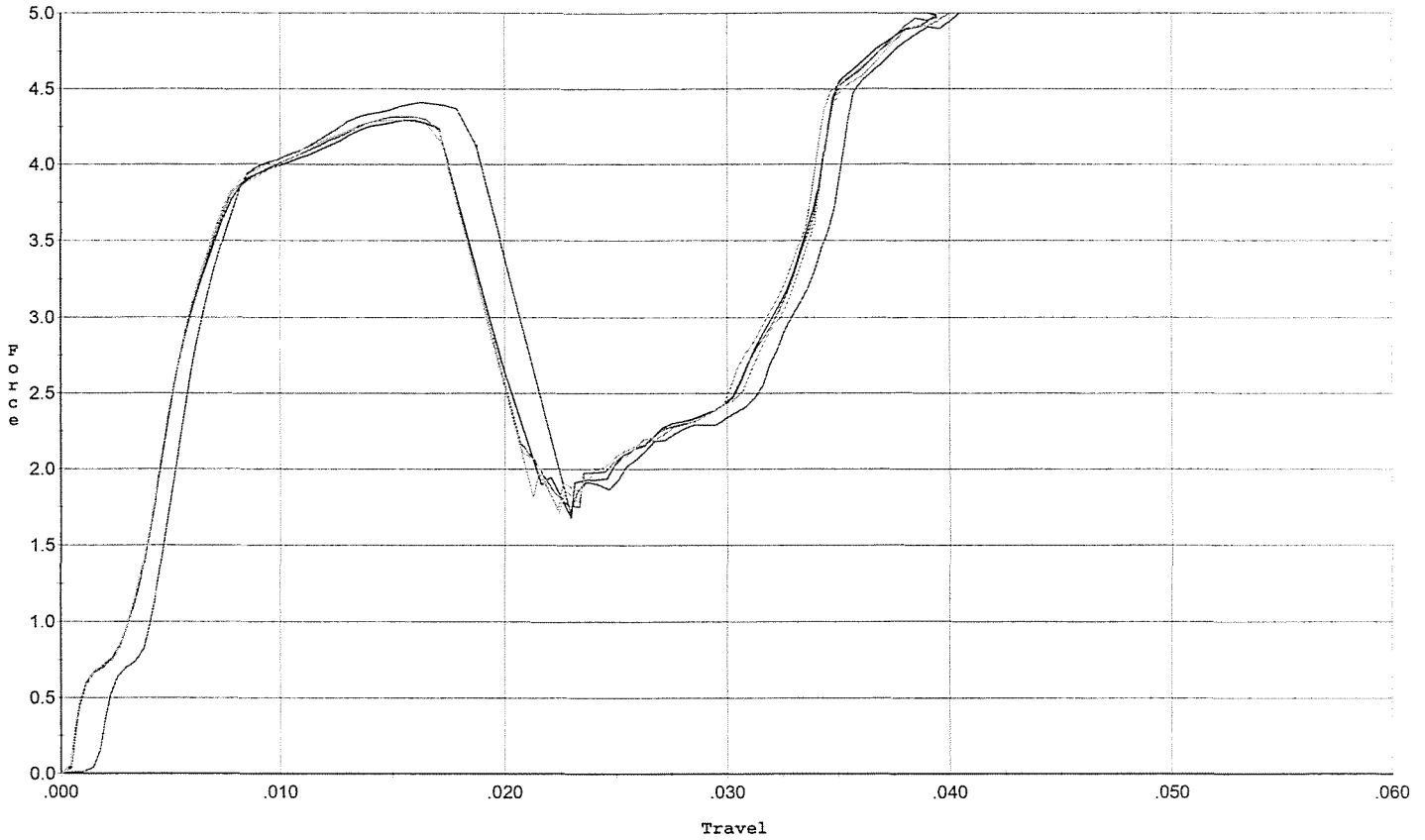
| # | Peak Force | Travel To Actuate | Initial Take-up | Overtravel | Energy To Actuate | Lock Time | Action Type |
|---|------------|-------------------|-----------------|------------|-------------------|-----------|-------------|
| 1 | 2.513      | 0.014             | 0.00            | 0.036      | 0.025             |           | Set Trigger |
| 2 | 2.585      | 0.015             | 0.00            | 0.036      | 0.026             |           | Set Trigger |
| 3 | 2.510      | 0.014             | 0.00            | 0.035      | 0.025             |           | Set Trigger |
| 4 | 2.509      | 0.014             | 0.00            | 0.036      | 0.025             |           | Set Trigger |
| 5 | 2.382      | 0.015             | 0.00            | 0.037      | 0.024             |           | Set Trigger |

A-2.50

# Trigger Profile [ lbs,inch ]

**Profile** SWS  
**GunType:** Rifle  
**Make:** Remington  
**Note:** T Rogowski 4/6/2009

**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 | 4.409      | 0.019             | 0.00            | 0.030      | 0.053             |           | Set Trigger |
| 2 | 4.293      | 0.017             | 0.00            | 0.031      | 0.048             |           | Set Trigger |
| 3 | 4.315      | 0.017             | 0.00            | 0.031      | 0.049             |           | Set Trigger |
| 4 | 4.324      | 0.017             | 0.00            | 0.031      | 0.049             |           | Set Trigger |
| 5 | 4.293      | 0.017             | 0.00            | 0.030      | 0.049             |           | Set Trigger |

A-4.32