

G680 1384

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



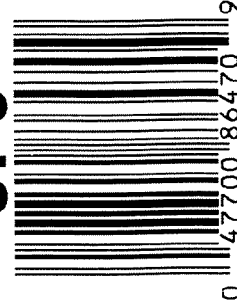
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6801384

UPC



BM FORM

GUN SERIAL #

G 680 1384

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SPD.
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SPD.
460	CHECK HEADSPACE		10-21-08	SPD.
470	DIS-ASSEMBLE ACTION		10-21-08	SPD.
472	SERIALIZE BOLT HANDLE		10-22-08	LSN
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/24/08	
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/24/08	DS
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-30-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-8-09	SPD.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

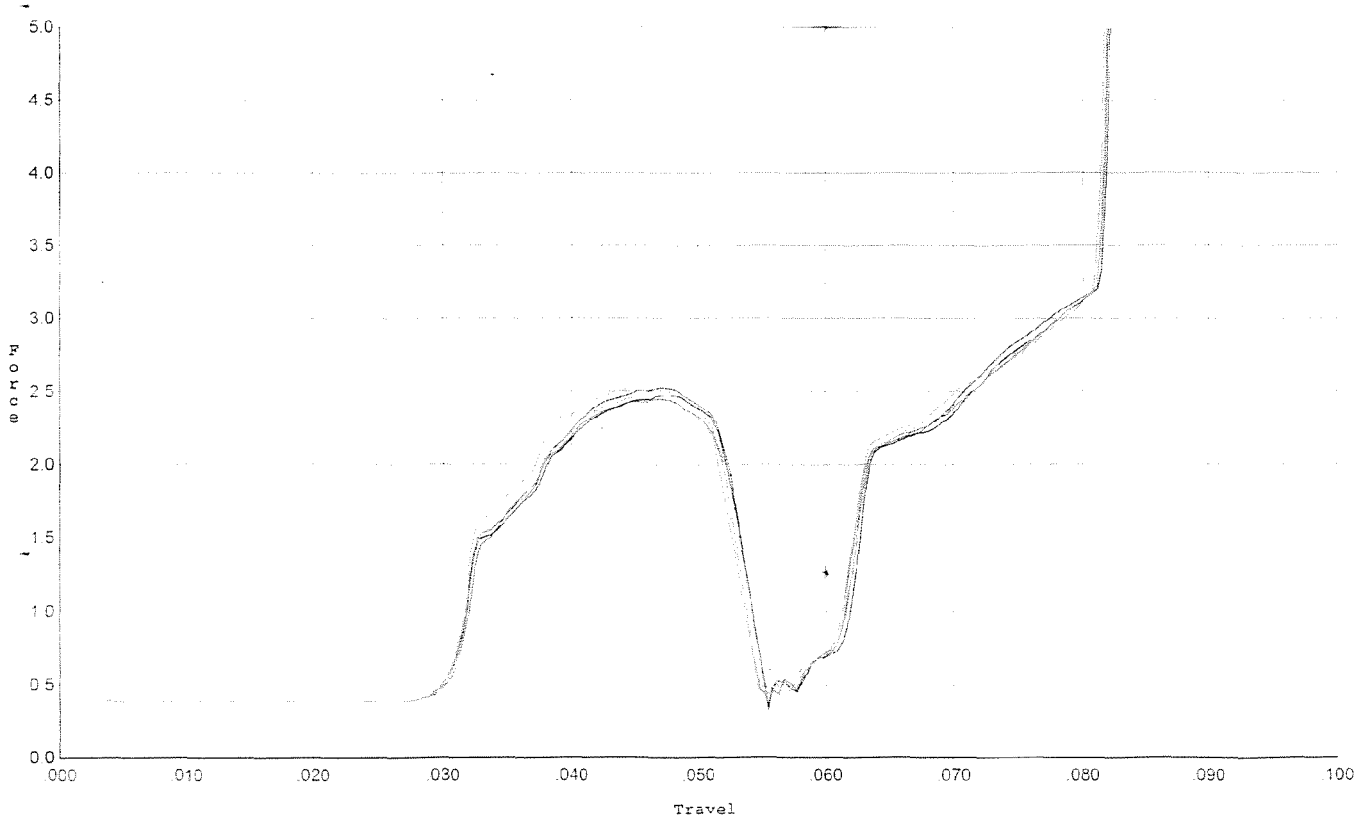
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-16-09	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	1-16-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	1-16-09	R.N.
	J) ASSEMBLE STOCK		1-8-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-16-09	R.N.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-15-09 1-15-09	R.N. R.N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-15-09	TC
670	FINAL INSPECTION A) HEADSPACE		1-16-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.47</u> <u>2.47</u> <u>2.39</u> <u>2.39</u>	1-16-09	TC
	C) FUNCTION		1-16-09	R.N.
690	PACK		1/20/09	Em

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



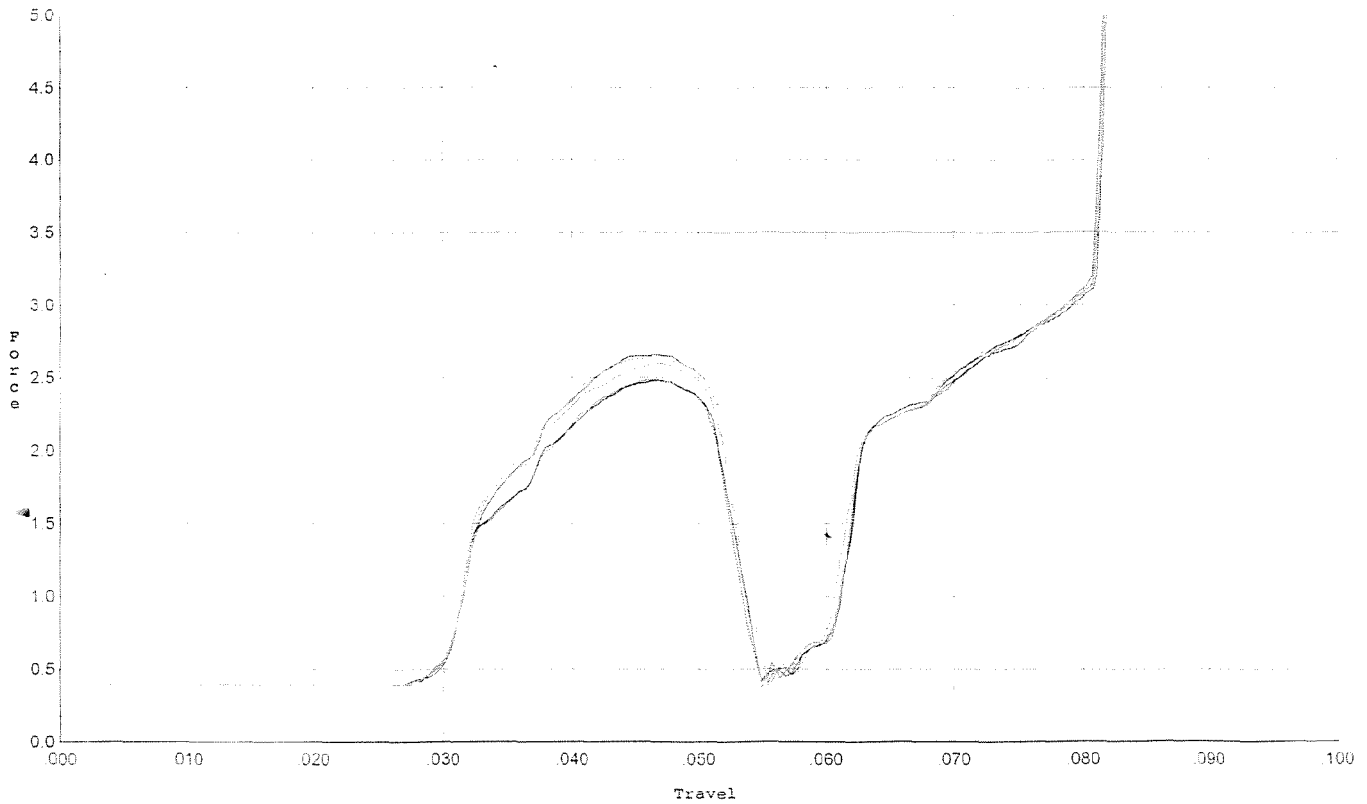
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.053	0.031	0.034	0.058		Set Trigger
2	2.473	0.053	0.031	0.034	0.057		Set Trigger
3	2.448	0.052	0.031	0.034	0.056		Set Trigger
4	2.480	0.052	0.031	0.034	0.056		Set Trigger
5	2.517	0.053	0.031	0.034	0.058		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



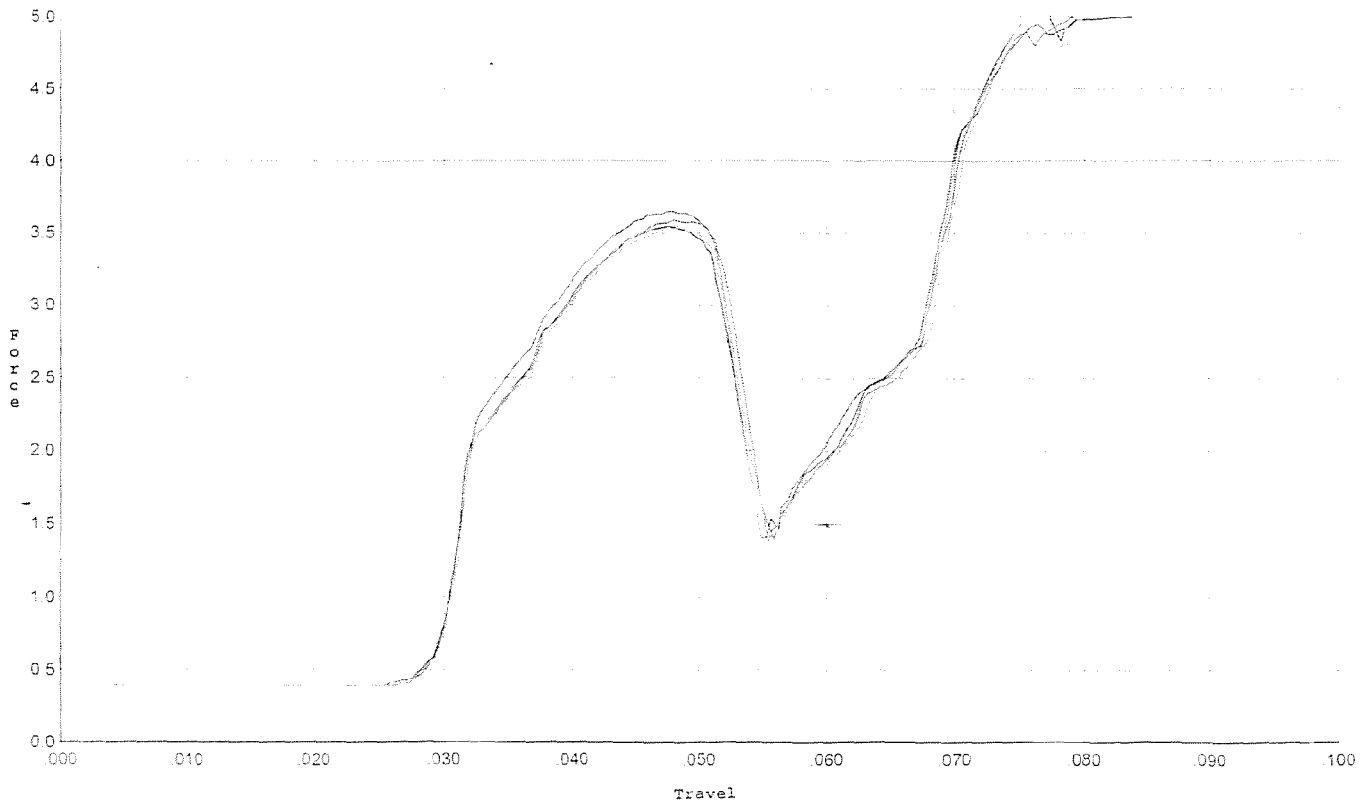
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.656	0.051	0.031	0.034	0.059		Set Trigger
2	2.480	0.053	0.031	0.034	0.057		Set Trigger
3	2.483	0.051	0.031	0.034	0.055		Set Trigger
4	2.645	0.051	0.030	0.034	0.059		Set Trigger
5	2.600	0.052	0.030	0.034	0.059		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



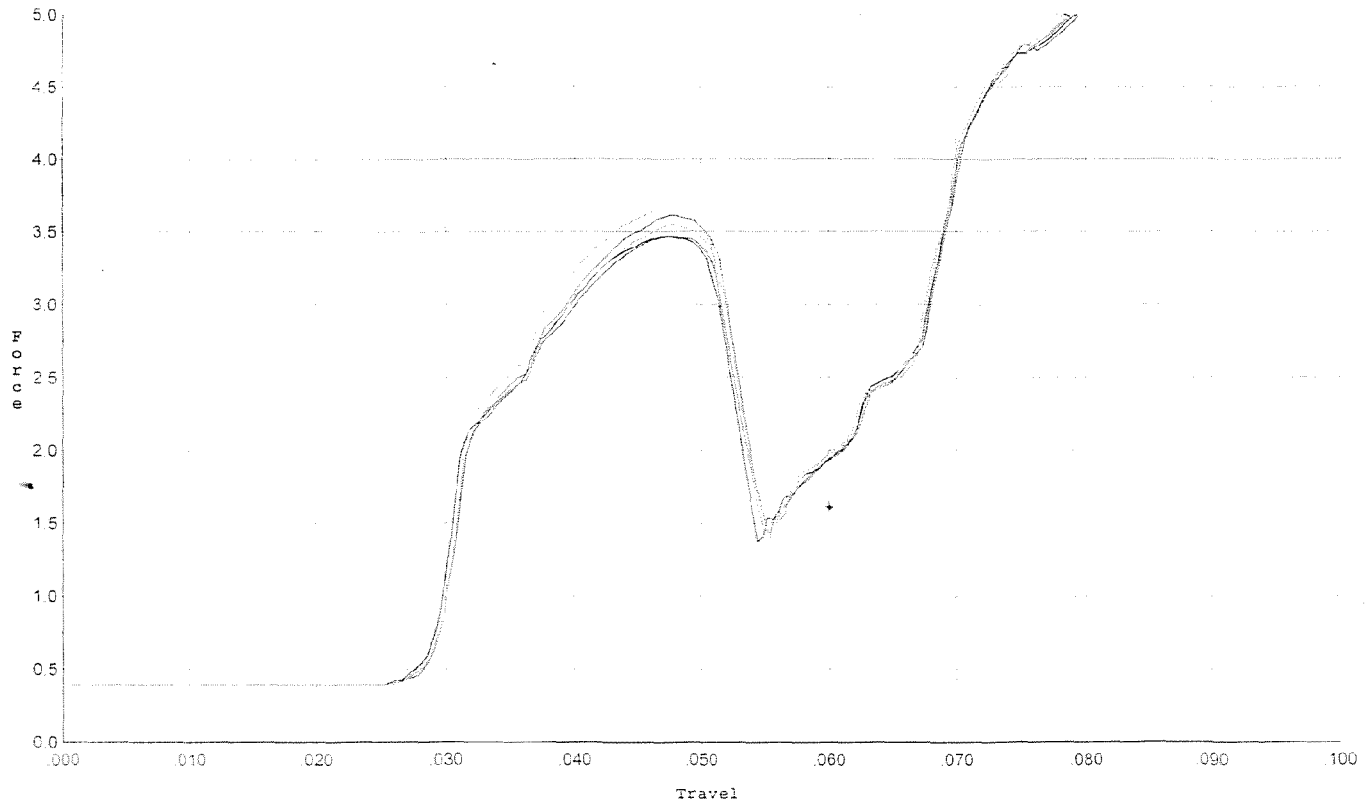
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.648	0.051	0.029	0.032	0.078		Set Trigger
2	3.544	0.052	0.029	0.032	0.077		Set Trigger
3	3.592	0.052	0.030	0.032	0.078		Set Trigger
4	3.559	0.052	0.029	0.032	0.077		Set Trigger
5	3.530	0.051	0.030	0.032	0.075		Set Trigger

A.3.57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



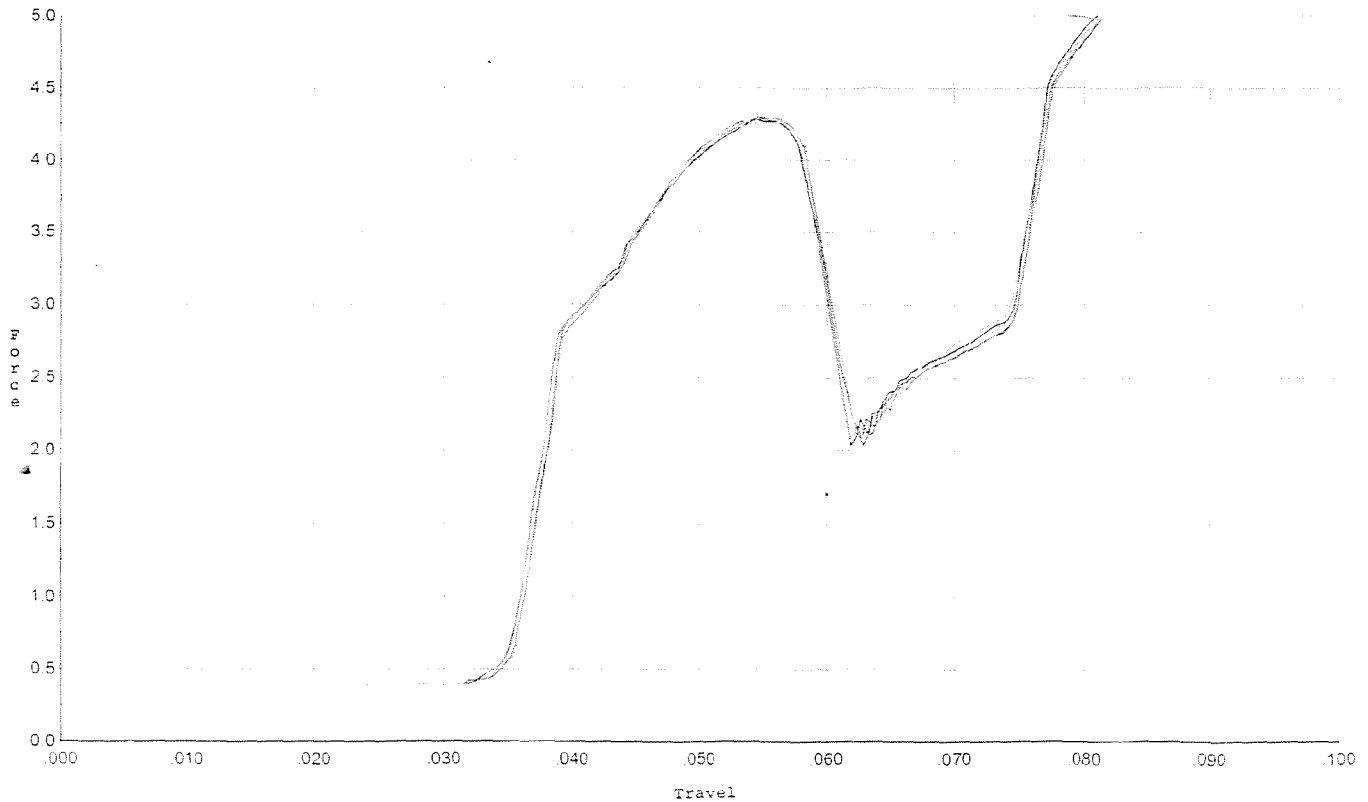
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.469	0.051	0.029	0.032	0.074		Set Trigger
2	3.466	0.051	0.029	0.031	0.076		Set Trigger
3	3.611	0.051	0.029	0.031	0.077		Set Trigger
4	3.664	0.051	0.029	0.031	0.077		Set Trigger
5	3.547	0.052	0.029	0.031	0.077		Set Trigger

A-3-SS

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



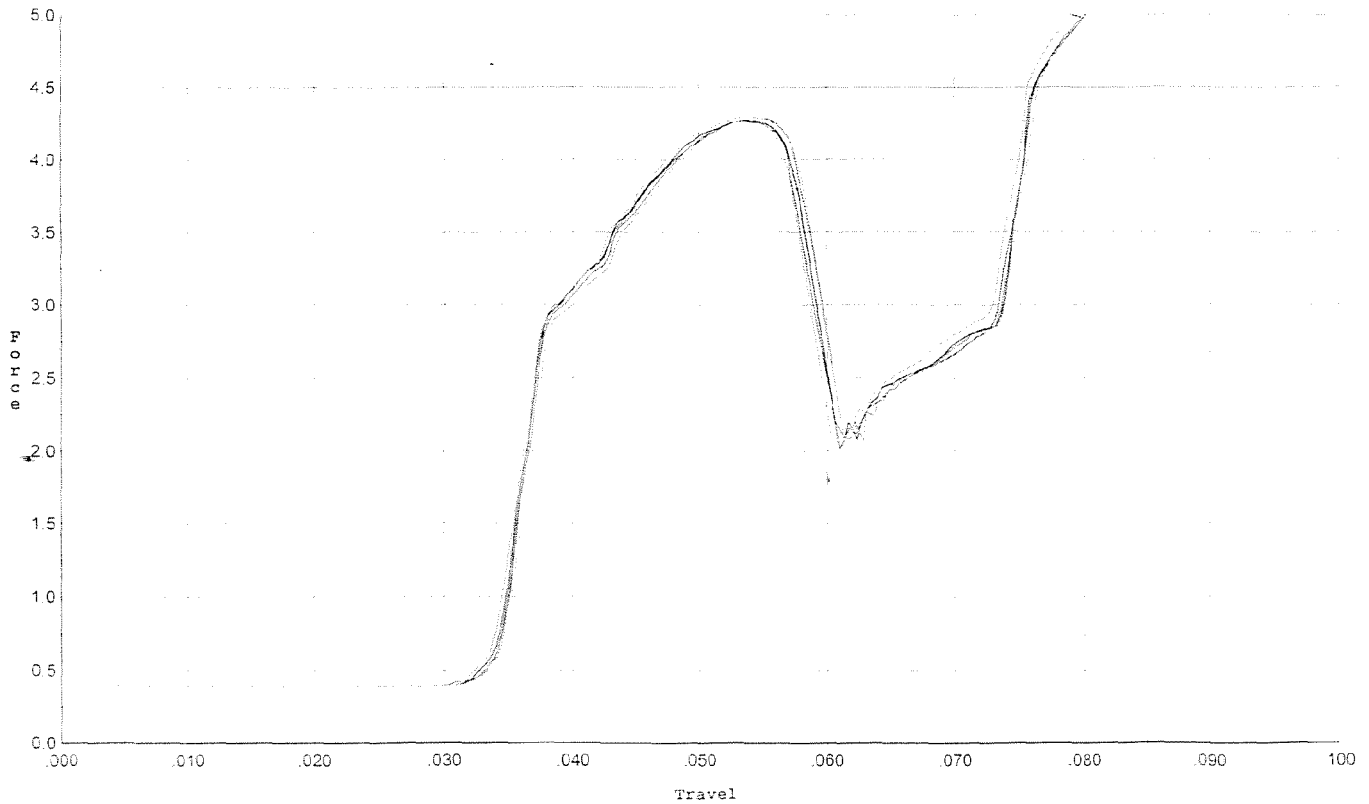
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.296	0.058	0.035	0.032	0.096		Set Trigger
2	4.282	0.059	0.035	0.032	0.098		Set Trigger
3	4.288	0.058	0.035	0.033	0.095		Set Trigger
4	4.307	0.060	0.036	0.032	0.100		
5	4.267	0.059	0.035	0.032	0.097		

A-4.28

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



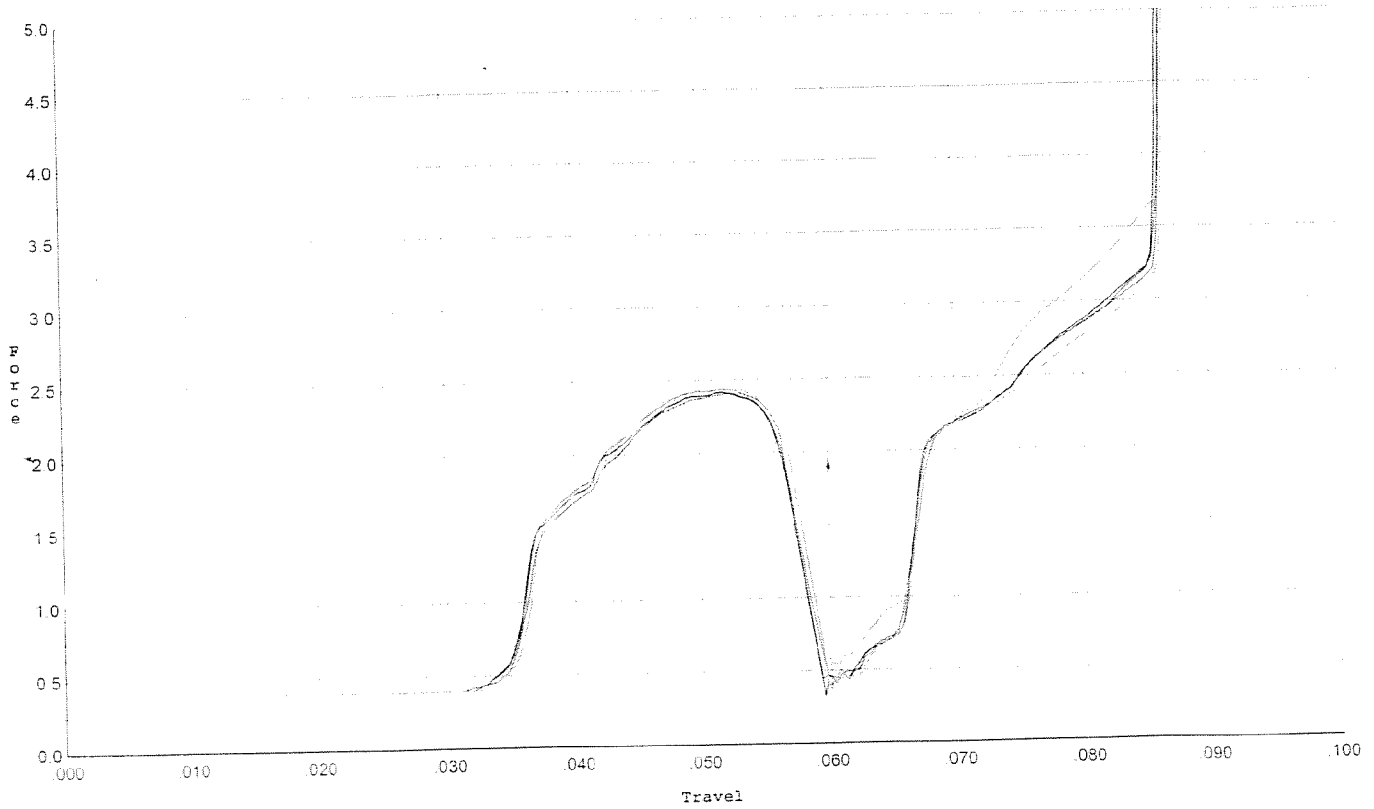
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.269	0.057	0.034	0.033	0.095		Set Trigger
2	4.272	0.058	0.034	0.032	0.098		Set Trigger
3	4.287	0.059	0.034	0.032	0.100		Set Trigger
4	4.286	0.058	0.034	0.032	0.098		Set Trigger
5	4.285	0.057	0.034	0.032	0.097		Set Trigger

A. 4.28

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



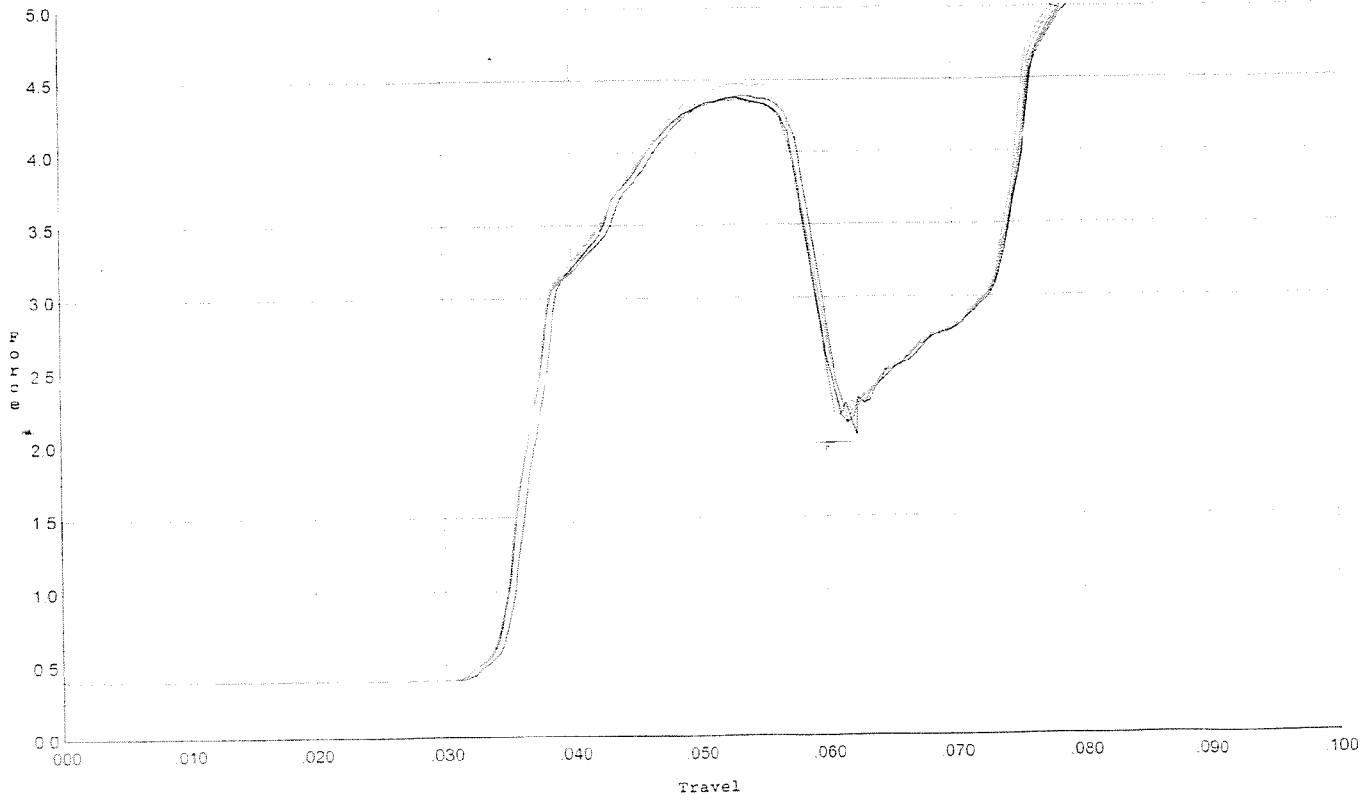
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.407	0.056	0.035	0.035	0.057		Set Trigger
2	2.414	0.057	0.035	0.035	0.058		Set Trigger
3	2.435	0.056	0.035	0.035	0.058		Set Trigger
4	2.452	0.057	0.036	0.036	0.059		Set Trigger
5	2.436	0.057	0.036	0.036	0.058		Set Trigger

A.2.42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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	4.389	0.058	0.035	0.032	0.100		Set Trigger
2	4.377	0.057	0.034	0.032	0.099		Set Trigger
3	4.367	0.057	0.034	0.032	0.100		Set Trigger
4	4.471	0.057	0.034	0.031	0.100		Set Trigger
5	4.412	0.057	0.034	0.032	0.099		Set Trigger

A-4.40