

6680 1387

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



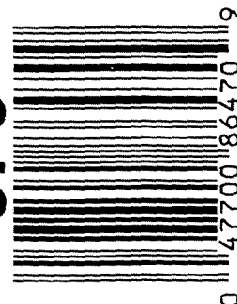
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801387

UPC



BM FORM

GUN SERIAL #

G 680 1387

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	RN
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION		10-24-08	SP
490	MAGNAFLUX BOLT		10-24-08	MR
500	ROLLMARK CALIBER		10-24-08	RT
520	GOFF BLAST BBL / REC		10-25-08	TL
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		1-12-09	RN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

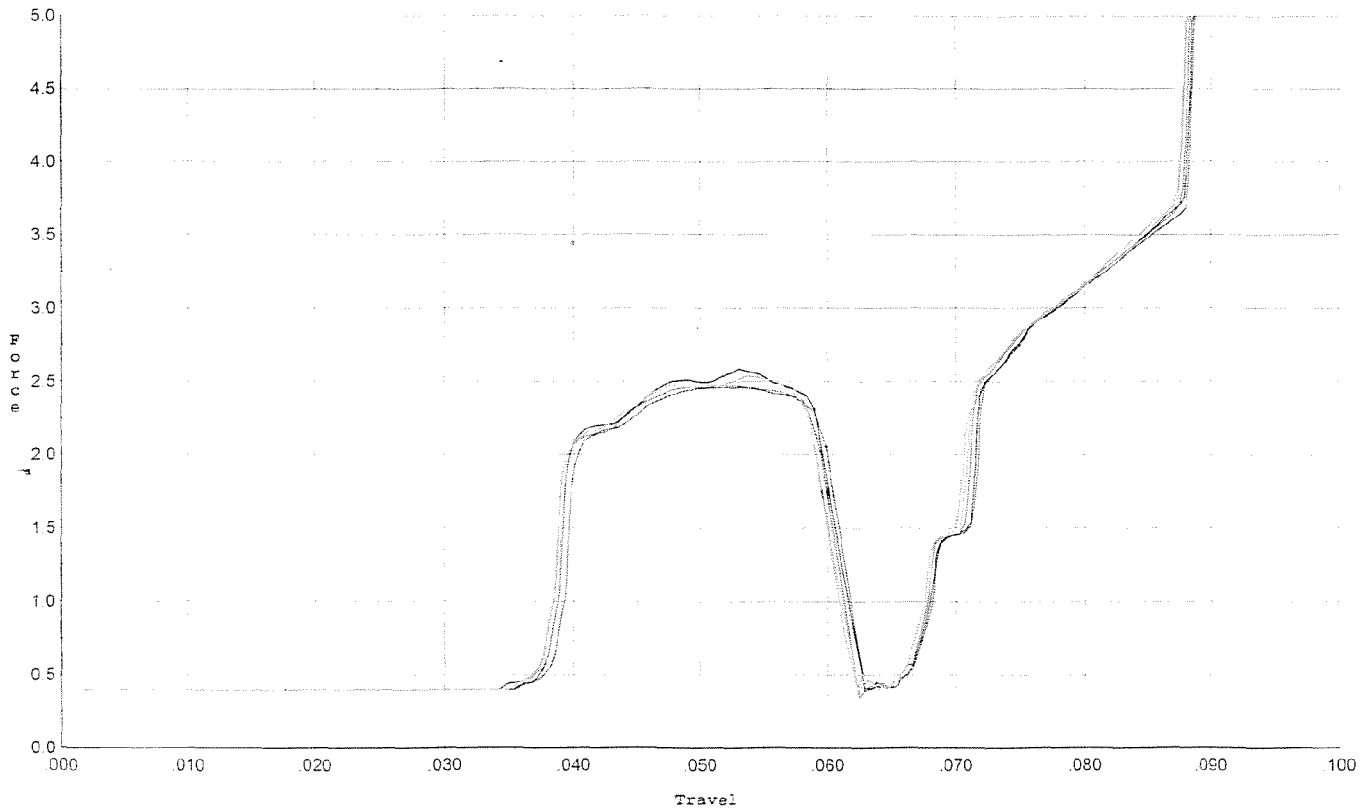
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-20-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>70</u> <u>70</u> <u>70</u>	1-20-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-20-09	L.N.
	J) ASSEMBLE STOCK		1-12-09	RBN
	K) ASSEMBLE SWIVEL STUDS		1-20-09	L.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	1-19-09	TC
	MALFUNCTION	CORRECTION	/	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-19-09	W.N.
670	FINAL INSPECTION A) HEADSPACE		1-20-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.35</u> <u>2.42</u> <u>2.45</u> <u>2.39</u>	1-20-09	L.N.
	C) FUNCTION		1-20-09	R.N.
690	PACK		1-22-09	RBN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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



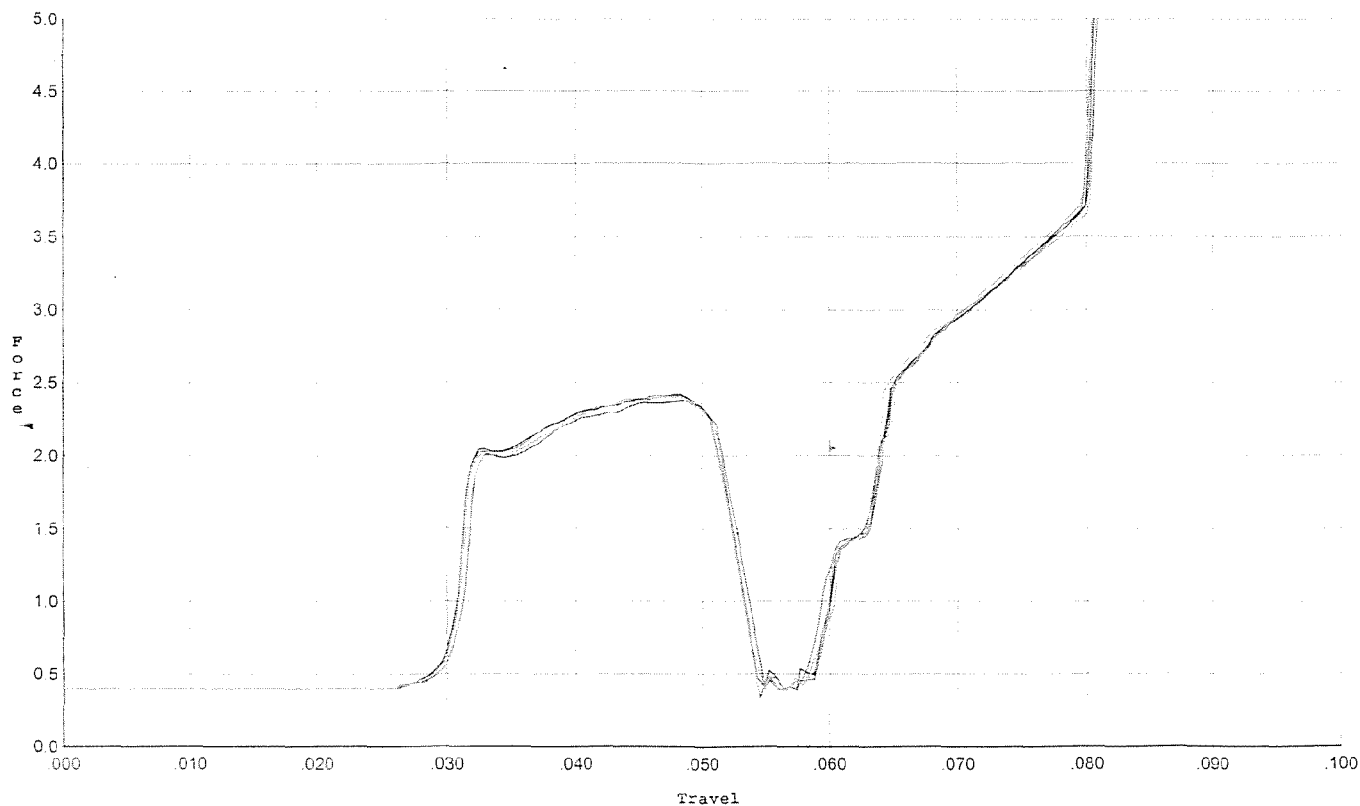
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.060	0.039	0.035	0.064		Set Trigger
2	2.587	0.059	0.038	0.035	0.065		Set Trigger
3	2.477	0.059	0.038	0.035	0.064		Set Trigger
4	2.545	0.058	0.038	0.035	0.064		Set Trigger
5	2.534	0.059	0.038	0.035	0.064		Set Trigger

A-252

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



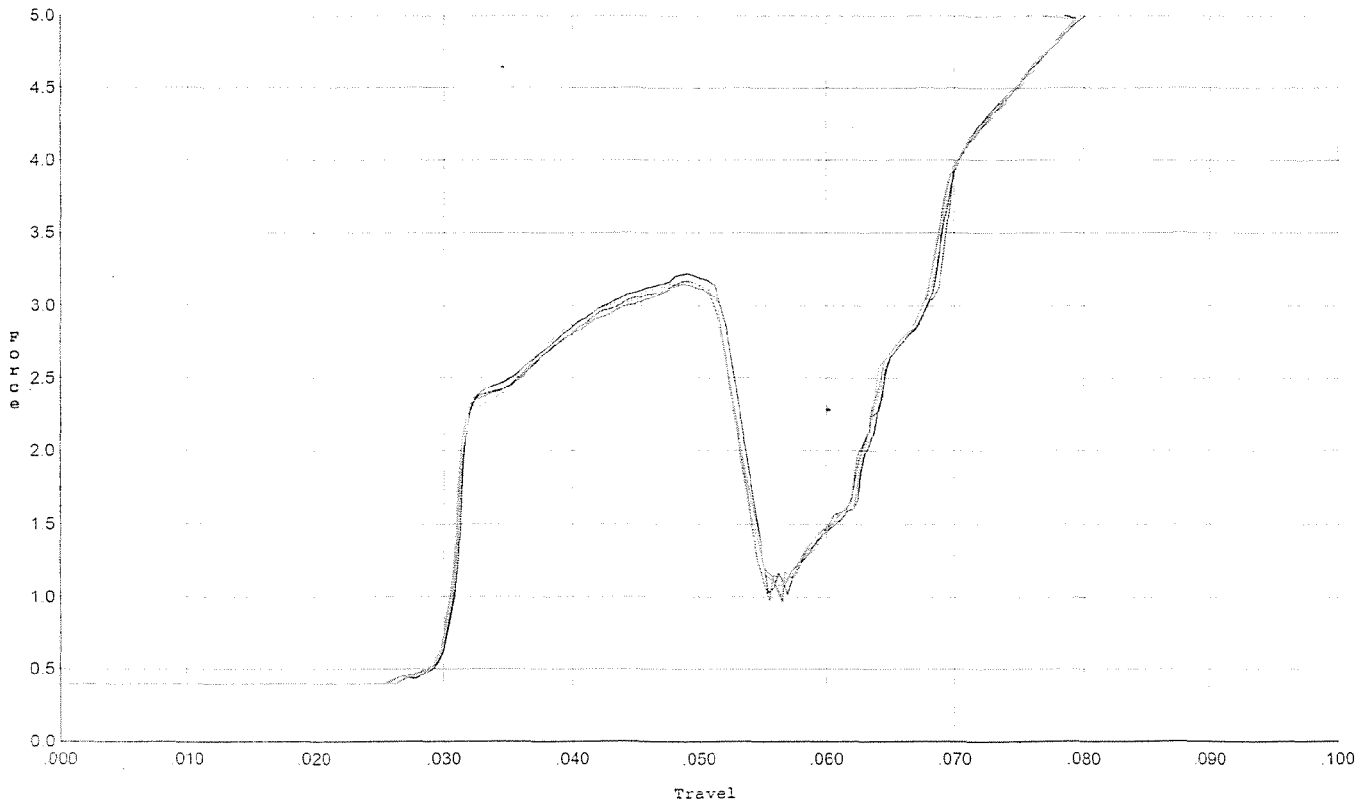
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.380	0.053	0.030	0.033	0.059		Set Trigger
2	2.418	0.051	0.030	0.032	0.059		Set Trigger
3	2.411	0.052	0.030	0.032	0.059		Set Trigger
4	2.398	0.052	0.030	0.033	0.059		Set Trigger
5	2.405	0.051	0.030	0.033	0.058		Set Trigger

A-2.40

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



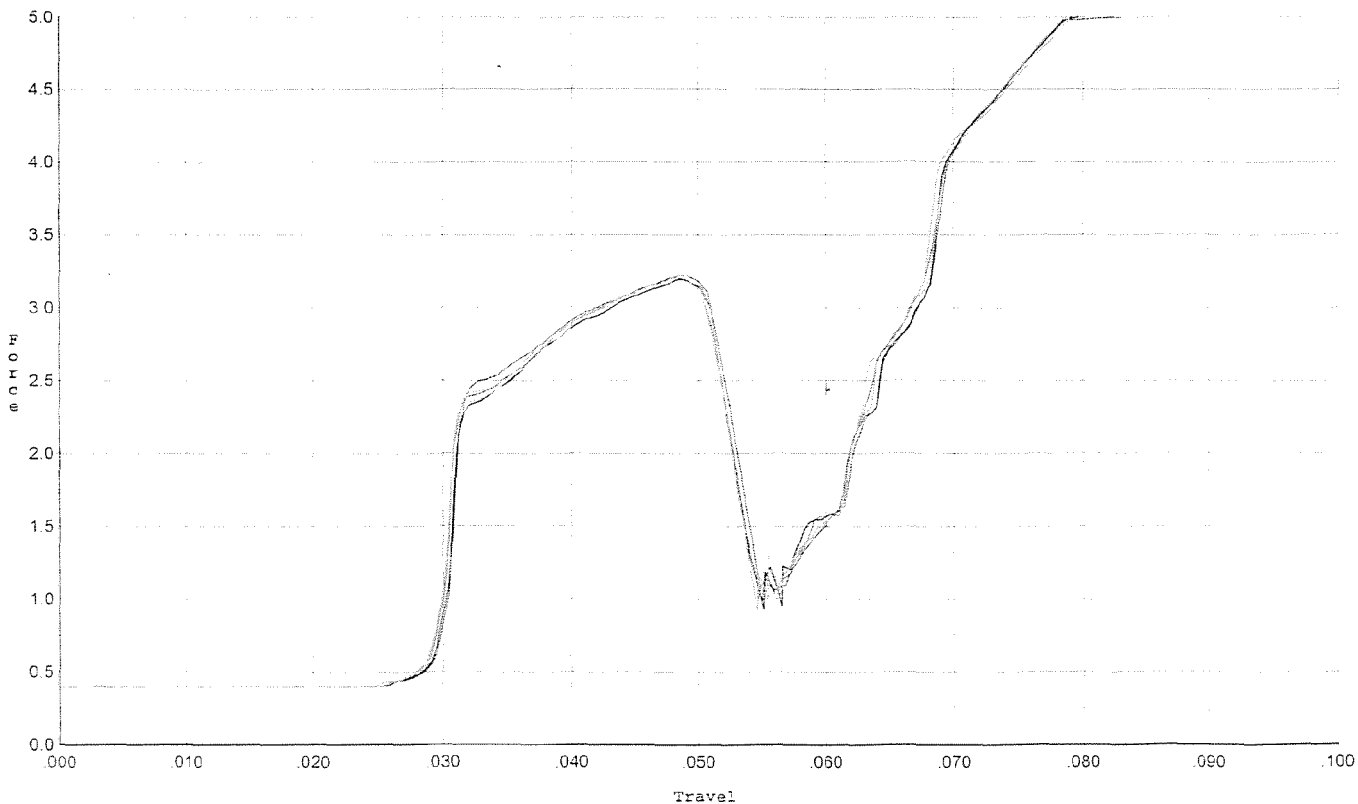
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.168	0.051	0.030	0.031	0.071		Set Trigger
2	3.216	0.052	0.030	0.031	0.074		Set Trigger
3	3.143	0.052	0.030	0.031	0.072		Set Trigger
4	3.151	0.051	0.030	0.031	0.071		Set Trigger
5	3.177	0.051	0.030	0.031	0.072		Set Trigger

A-3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles



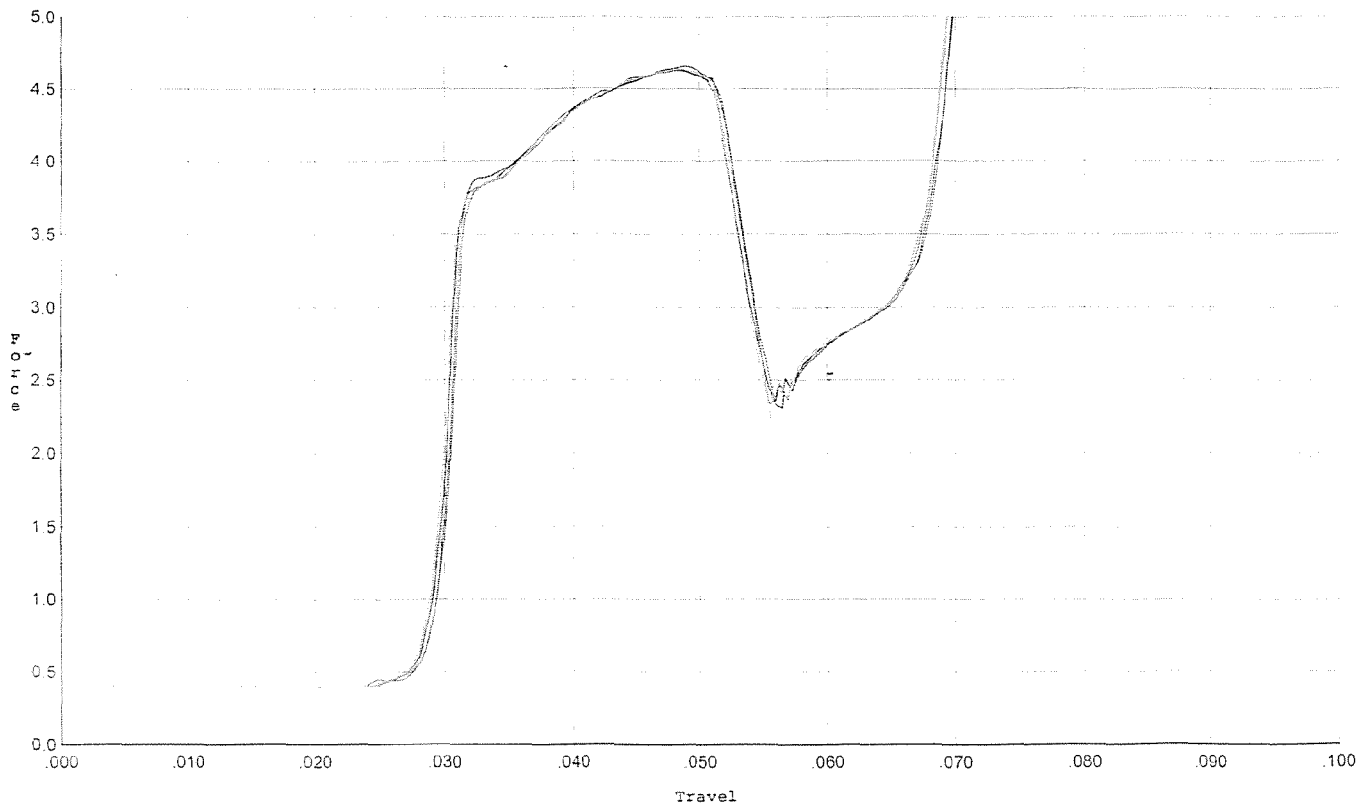
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.052	0.030	0.031	0.075		Set Trigger
2	3.195	0.051	0.029	0.031	0.071		Set Trigger
3	3.206	0.051	0.029	0.031	0.073		Set Trigger
4	3.223	0.052	0.029	0.031	0.073		Set Trigger
5	3.226	0.051	0.029	0.031	0.072		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/16/2008

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



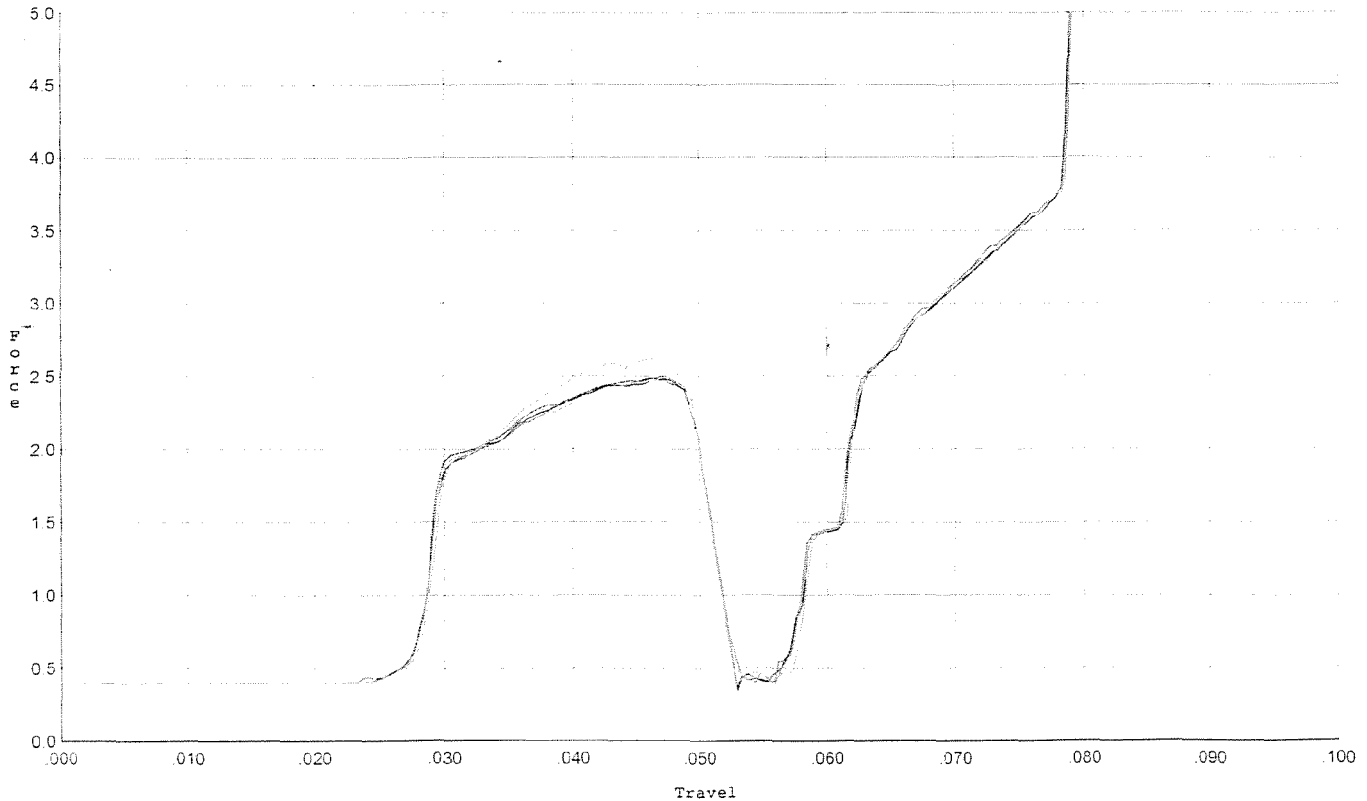
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.657	0.052	0.029	0.025	0.108		Set Trigger
2	4.627	0.051	0.028	0.025	0.105		Set Trigger
3	4.632	0.052	0.029	0.025	0.107		Set Trigger
4	4.639	0.051	0.028	0.025	0.106		Set Trigger
5	4.638	0.053	0.028	0.024	0.109		Set Trigger

A-4.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 12/16/2008

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



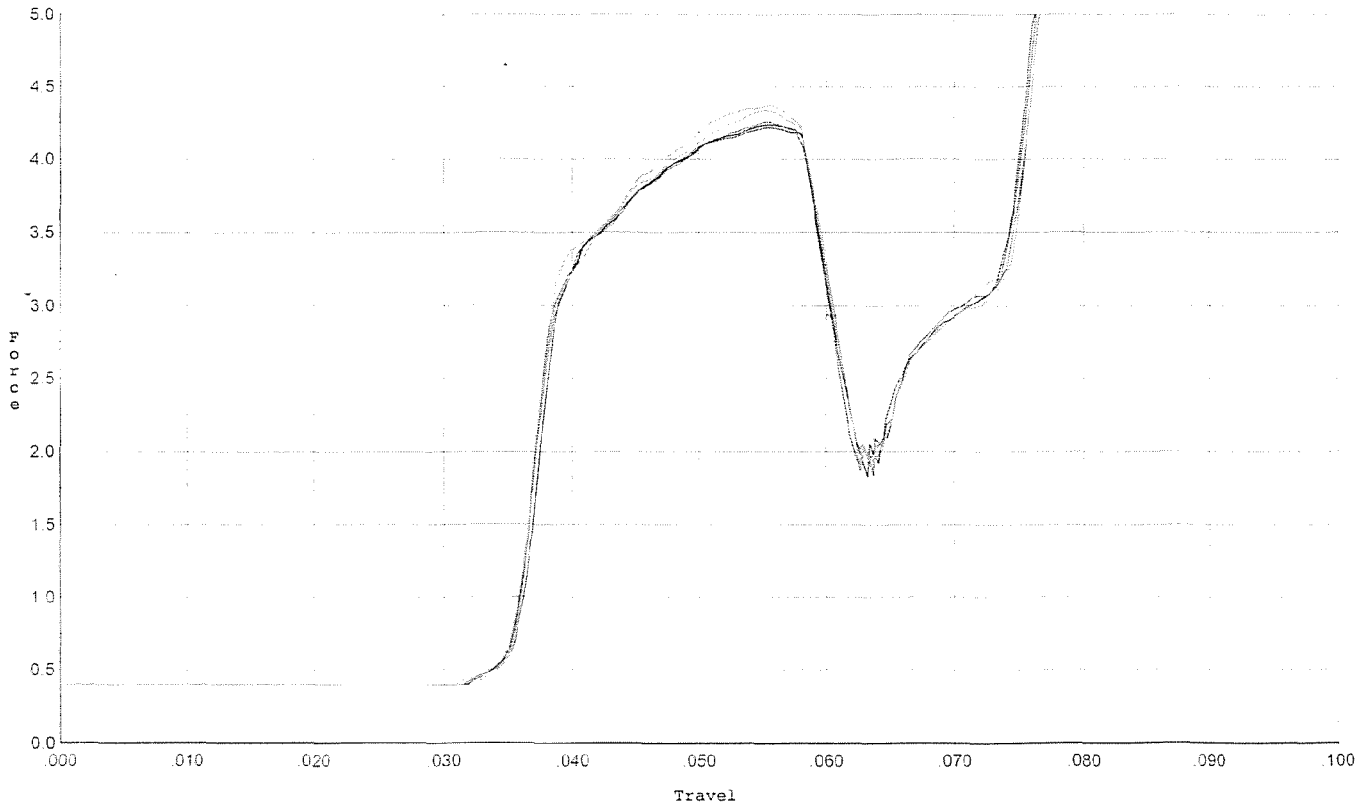
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.050	0.028	0.032	0.059		Set Trigger
2	2.484	0.050	0.028	0.032	0.059		Set Trigger
3	2.496	0.049	0.028	0.032	0.059		Set Trigger
4	2.626	0.049	0.028	0.032	0.060		Set Trigger
5	2.475	0.050	0.028	0.032	0.059		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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	4.218	0.058	0.035	0.028	0.100		Set Trigger
2	4.235	0.058	0.035	0.028	0.099		Set Trigger
3	4.255	0.060	0.035	0.028	0.104		Set Trigger
4	4.336	0.060	0.035	0.028	0.104		Set Trigger
5	4.369	0.060	0.035	0.028	0.105		Set Trigger

A. 4.28