

8596 0894

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



BM FORM

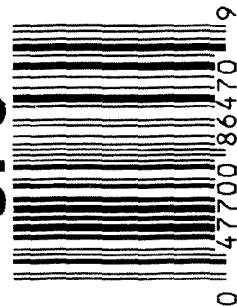
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807658

UPC



GUN SERIAL #

G 680 7658

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-21-09	SPJ
430	ASSEMBLE TO STOCK		1-21-09	SP
440	PROOF		1-21-09	SPJ
460	CHECK HEADSPACE		1-21-09	SPJ
470	DIS-ASSEMBLE ACTION		1-21-09	SPJ
472	SERIALIZE BOLT HANDLE		1-22-09	RJN
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION	(RB)	1/23/09	(RB)
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		26 Jan 09	SPJ
542	APPLY COATINGS (BARREL ACTION)		1-27	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION		1/27/09	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1/27/09	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1/27/09	RP
	D) OIL FIRING PIN ASSEMBLY		1-30-09	SPJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

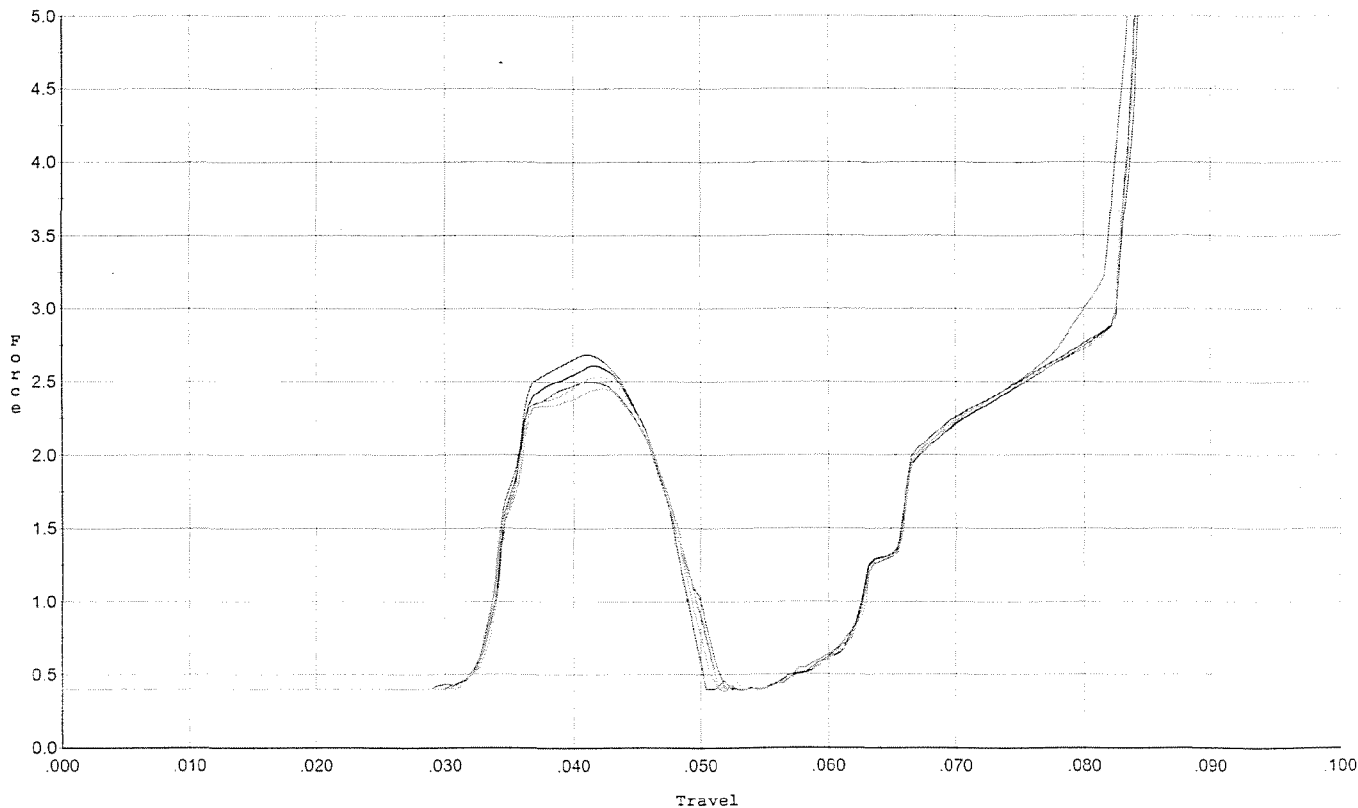
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>4.0</u>	2-16-09	L.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-16-09	L.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.035</u> <u>.025</u> <u>.034</u>	2-16-09	L.D.
	J) ASSEMBLE STOCK		1-30-09	L.D.
	K) ASSEMBLE SWIVEL STUDS		2-16-09	L.D.
	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	2-12-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-12-09	W.W.
670	FINAL INSPECTION A) HEADSPACE		2-16-09	L.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.24</u> <u>2.15</u> <u>2.29</u> <u>2.19</u> <u>2.25</u>	2-13-09	W.W.
	C) FUNCTION		2-16-09	L.D.
690	PACK		2/18/09	F.M.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/23/2009

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



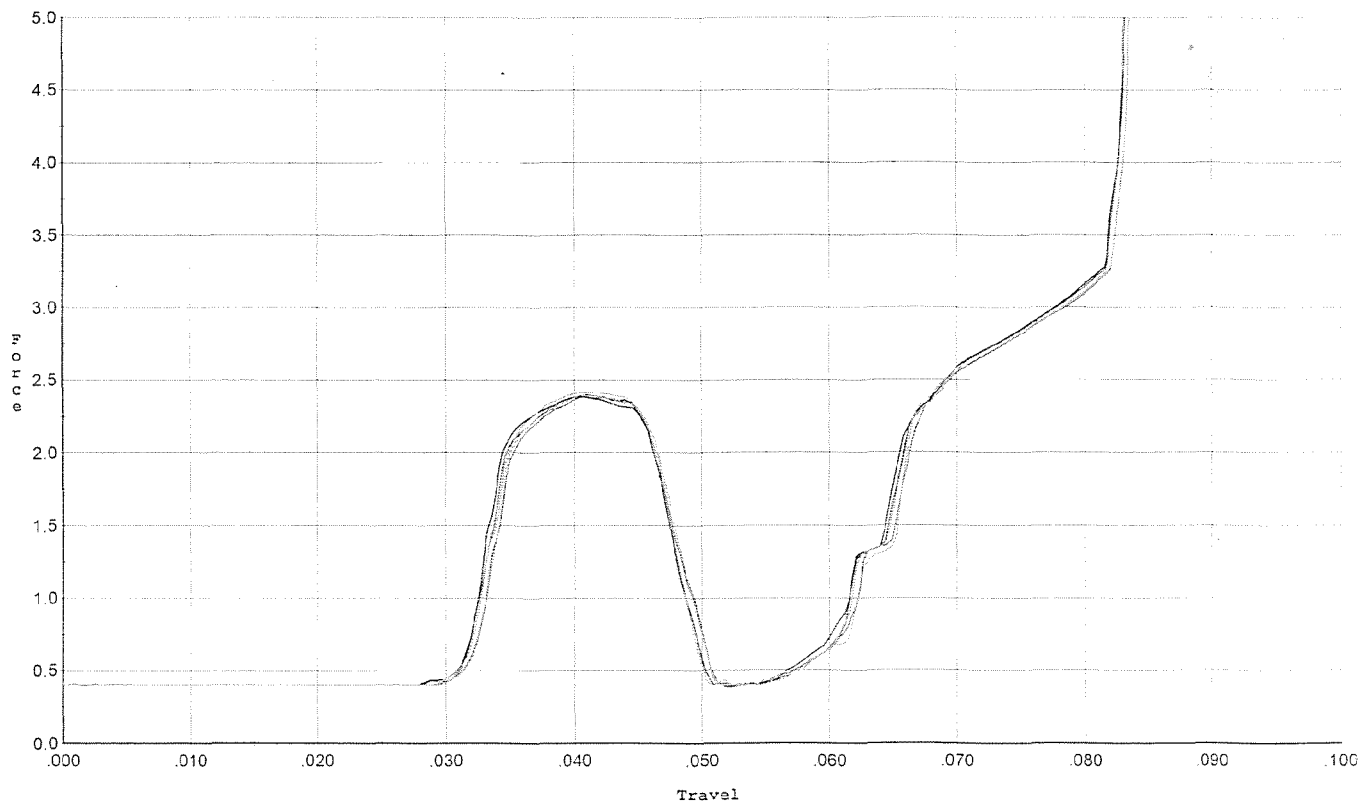
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.686	0.049	0.033	0.040	0.047		Set Trigger
2	2.611	0.050	0.033	0.038	0.048		Set Trigger
3	2.496	0.050	0.033	0.038	0.047		Set Trigger
4	2.532	0.048	0.033	0.040	0.045		Set Trigger
5	2.455	0.050	0.033	0.039	0.047		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



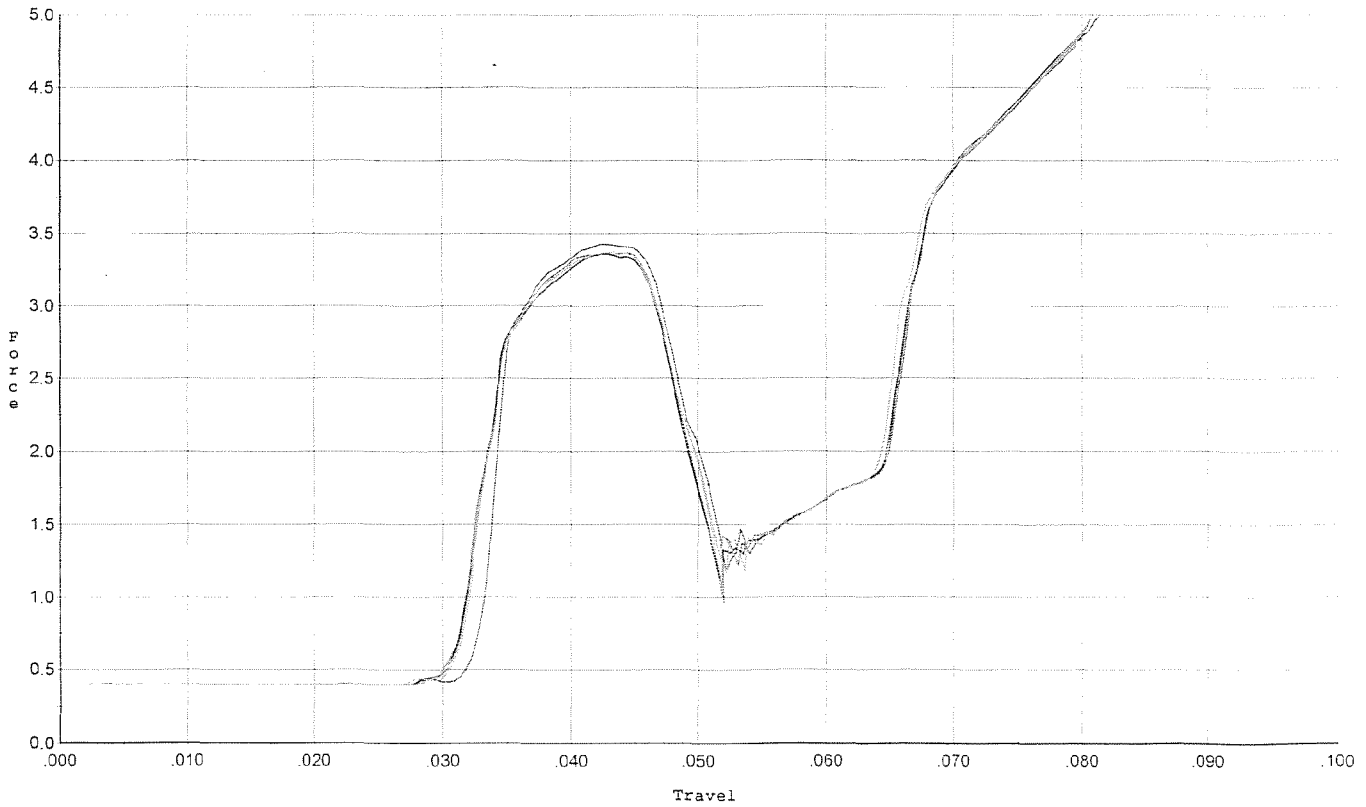
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.382	0.046	0.032	0.040	0.044		Set Trigger
2	2.398	0.047	0.032	0.040	0.045		Set Trigger
3	2.385	0.047	0.032	0.040	0.045		Set Trigger
4	2.395	0.047	0.032	0.040	0.045		Set Trigger
5	2.419	0.046	0.032	0.040	0.044		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



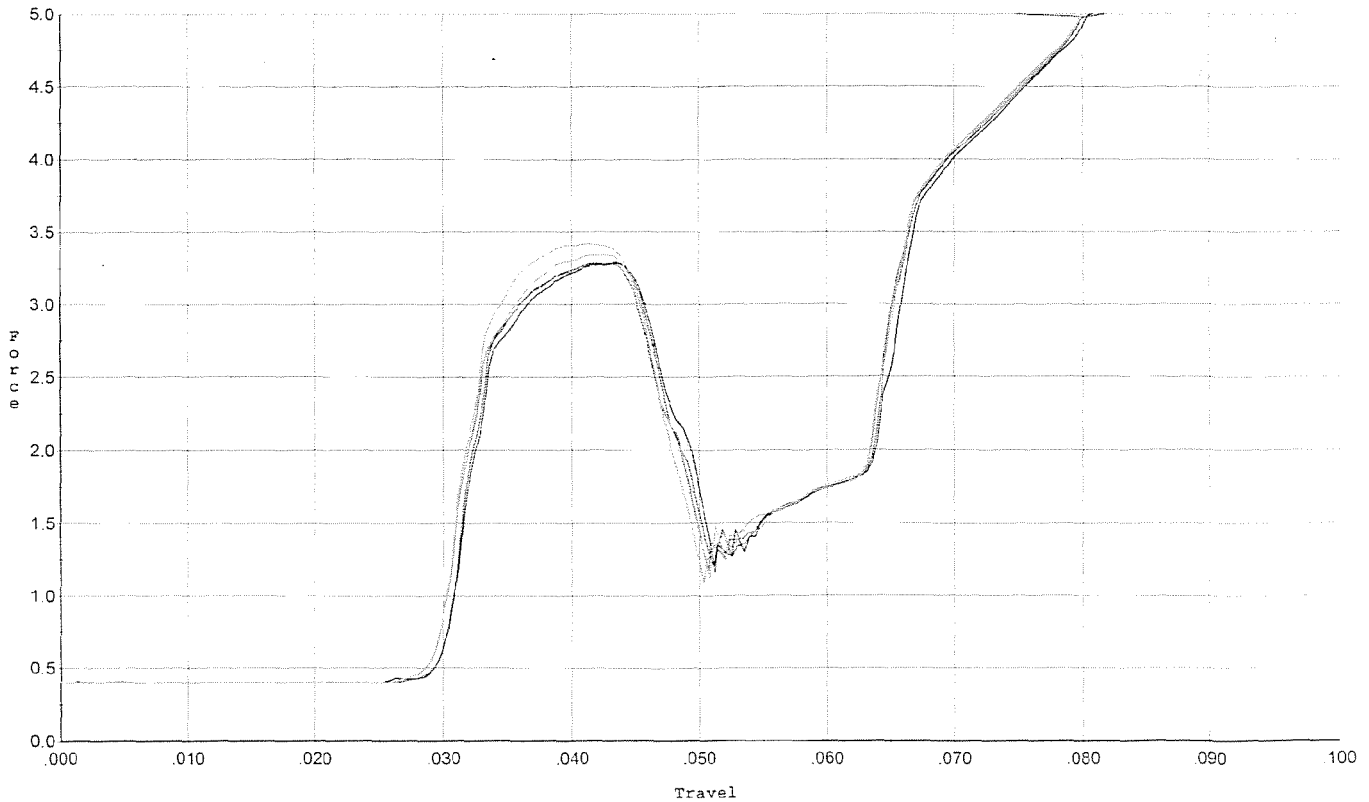
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.426	0.051	0.032	0.035	0.065		Set Trigger
2	3.361	0.047	0.031	0.036	0.060		Set Trigger
3	3.369	0.047	0.030	0.036	0.060		Set Trigger
4	3.375	0.050	0.031	0.035	0.065		Set Trigger
5	3.369	0.050	0.031	0.035	0.064		Set Trigger

A.3-38

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/23/2009

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



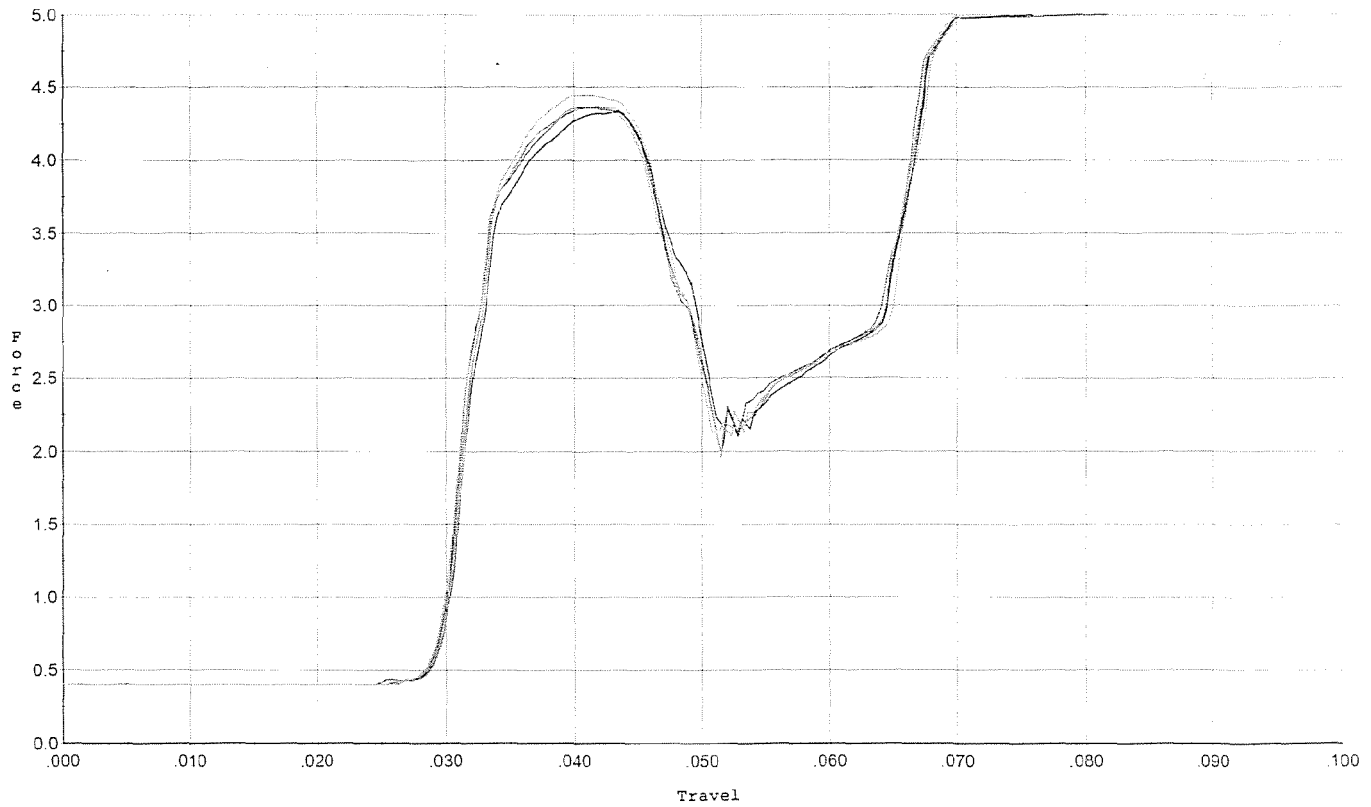
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.296	0.046	0.030	0.036	0.059		Set Trigger
2	3.288	0.050	0.030	0.035	0.064		Set Trigger
3	3.288	0.046	0.029	0.036	0.058		Set Trigger
4	3.342	0.046	0.030	0.036	0.059		Set Trigger
5	3.420	0.045	0.029	0.036	0.060		Set Trigger

A-3.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



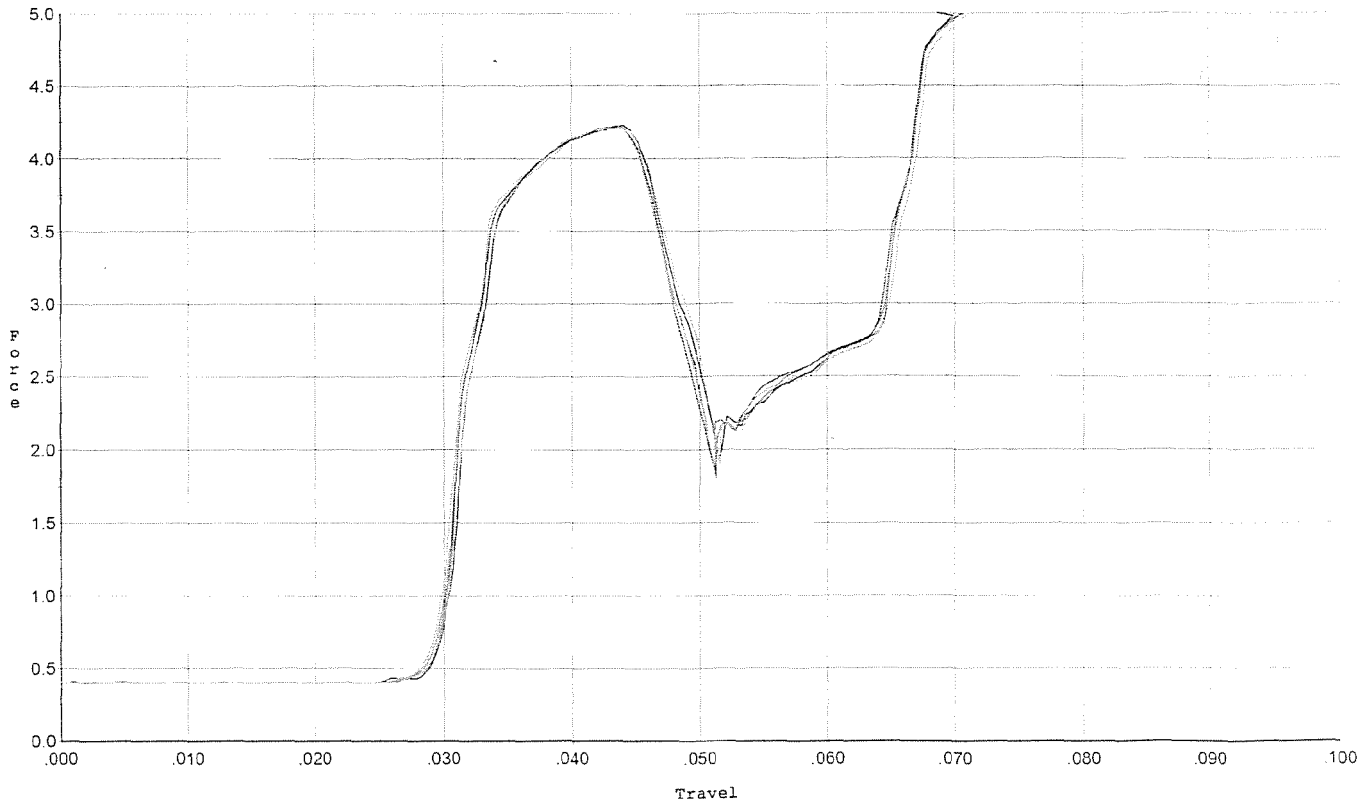
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.364	0.046	0.029	0.033	0.076		Set Trigger
2	4.336	0.049	0.029	0.033	0.083		Set Trigger
3	4.369	0.050	0.029	0.033	0.085		Set Trigger
4	4.361	0.049	0.029	0.033	0.083		Set Trigger
5	4.450	0.050	0.029	0.033	0.085		Set Trigger

A. 4.37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/23/2009

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



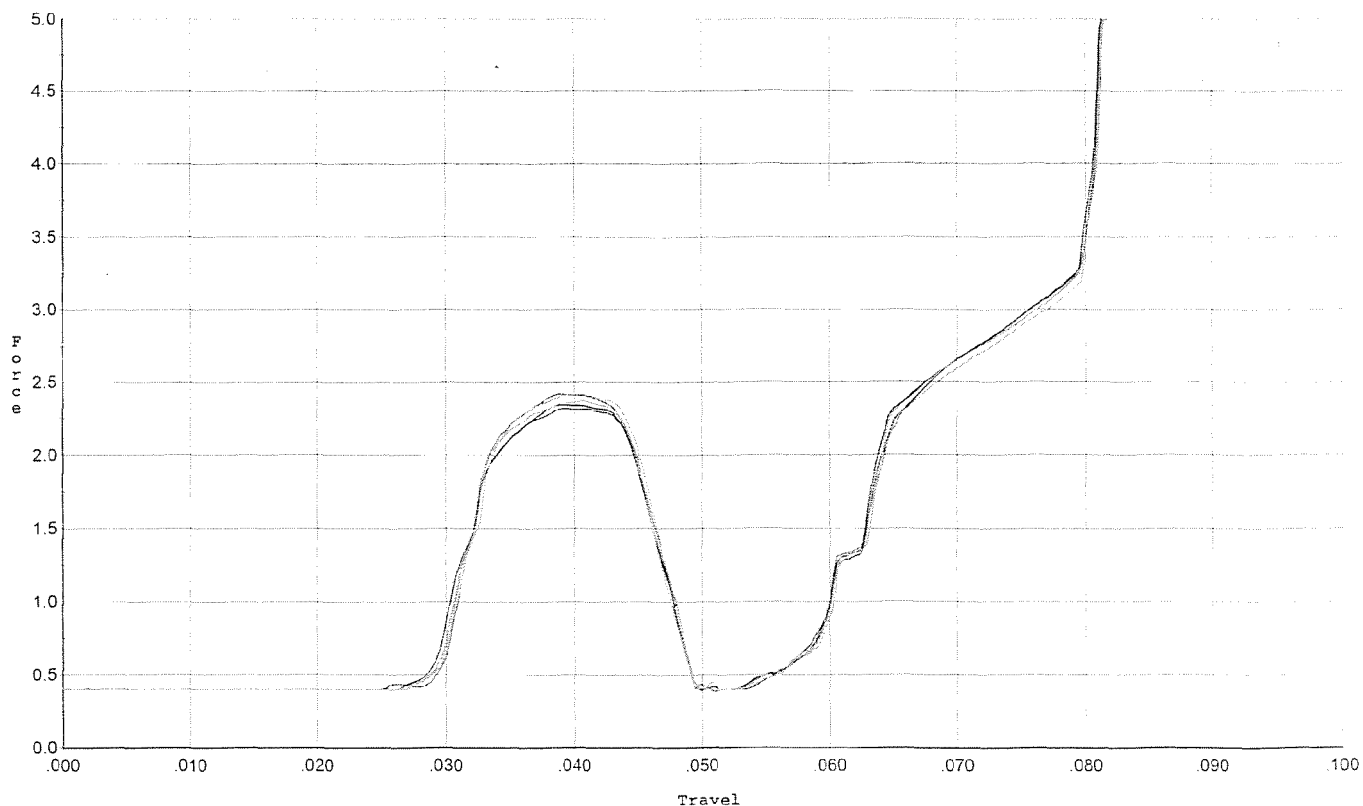
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.220	0.046	0.029	0.034	0.074		Set Trigger
2	4.228	0.046	0.029	0.034	0.073		Set Trigger
3	4.226	0.050	0.029	0.033	0.082		Set Trigger
4	4.216	0.050	0.029	0.033	0.082		Set Trigger
5	4.228	0.050	0.029	0.033	0.082		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



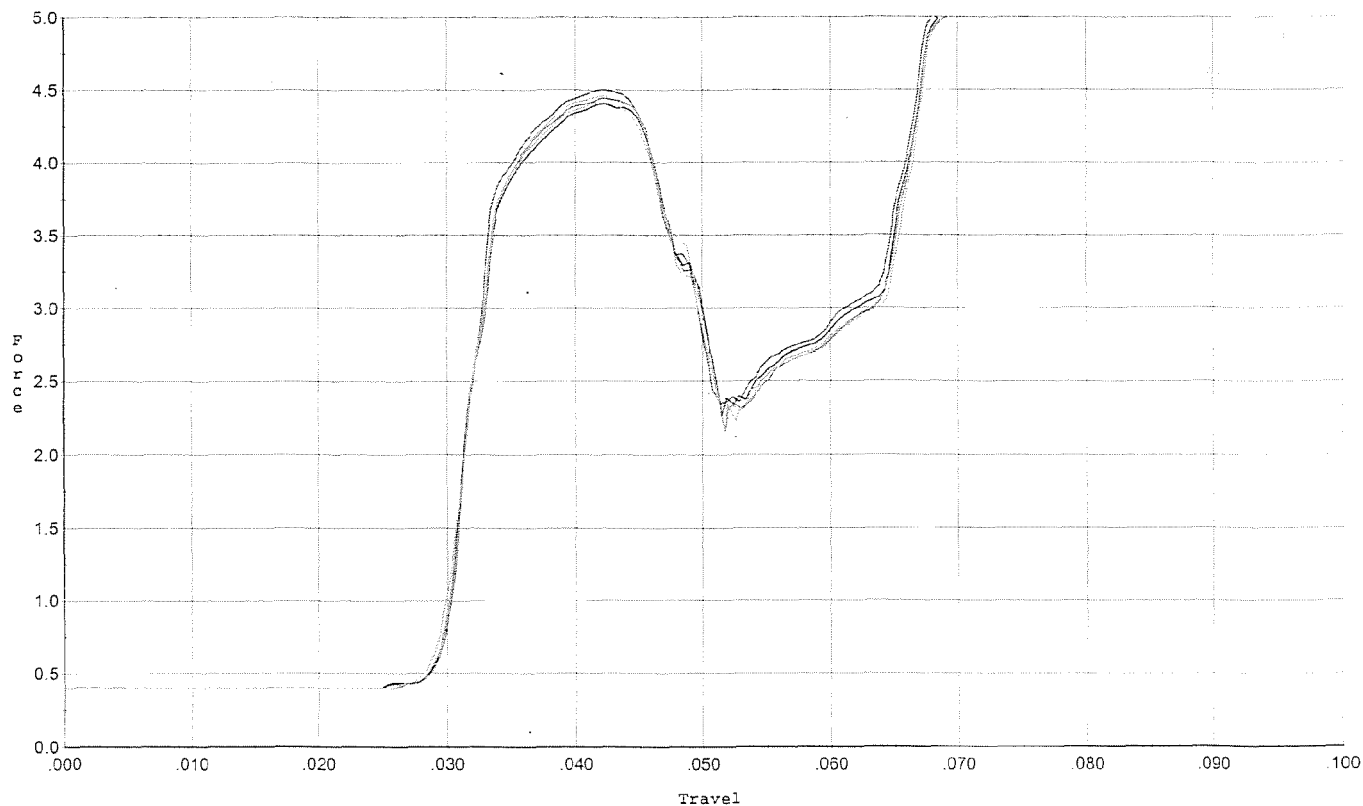
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.319	0.048	0.030	0.038	0.046		Set Trigger
2	2.345	0.047	0.029	0.038	0.046		Set Trigger
3	2.420	0.047	0.029	0.038	0.047		Set Trigger
4	2.368	0.045	0.030	0.039	0.044		Set Trigger
5	2.415	0.048	0.030	0.038	0.047		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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	4.499	0.049	0.029	0.030	0.085		Set Trigger
2	4.407	0.050	0.029	0.030	0.086		Set Trigger
3	4.442	0.050	0.029	0.030	0.086		Set Trigger
4	4.461	0.050	0.029	0.030	0.087		Set Trigger
5	4.413	0.050	0.029	0.030	0.087		Set Trigger

A - 2.44