

6684-5246

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



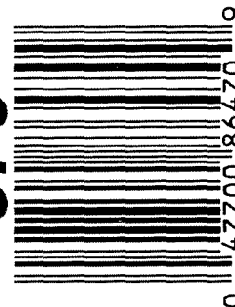
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6845246

UPC



BM FORM

GUN SERIAL #

6845246

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SP
460	CHECK HEADSPACE		3-20-09	SP
470	DIS-ASSEMBLE ACTION		3-20-09	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX - FLUX	3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/25/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	Bt
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-3-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

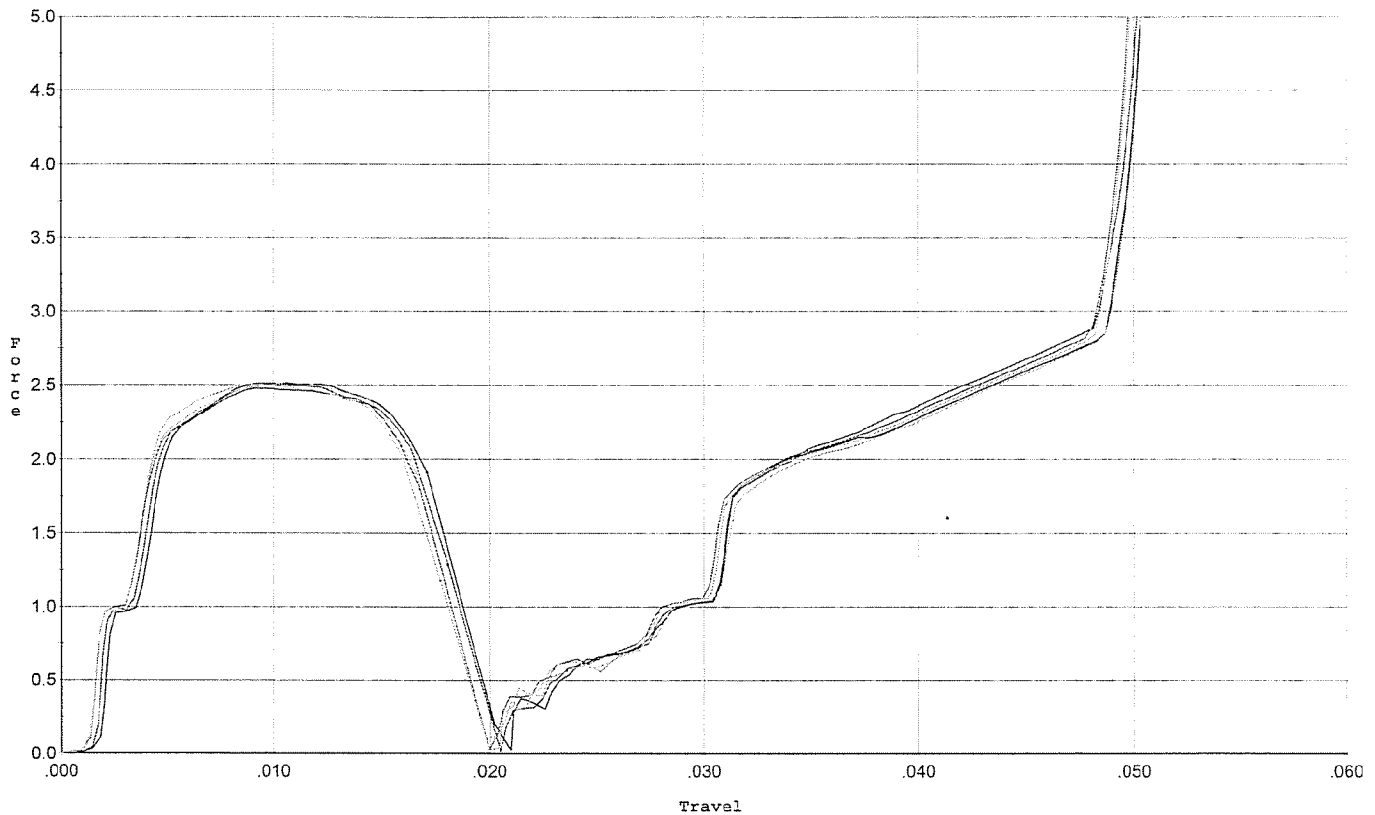
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6.5</u> <u>6.5</u>	4-15-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-15-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-15-09	WW
	J) ASSEMBLE STOCK		4-13-09	WW
	K) ASSEMBLE SWIVEL STUDS		4-15-09	WW
	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	4-7-09	WW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-7-09	TGR
670	FINAL INSPECTION A) HEADSPACE		4-15-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.90</u> <u>2.95</u> <u>2.91</u> <u>2.90</u>	4-14-09	WW
	C) FUNCTION		4-15-09	WW
690	PACK		4/15/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



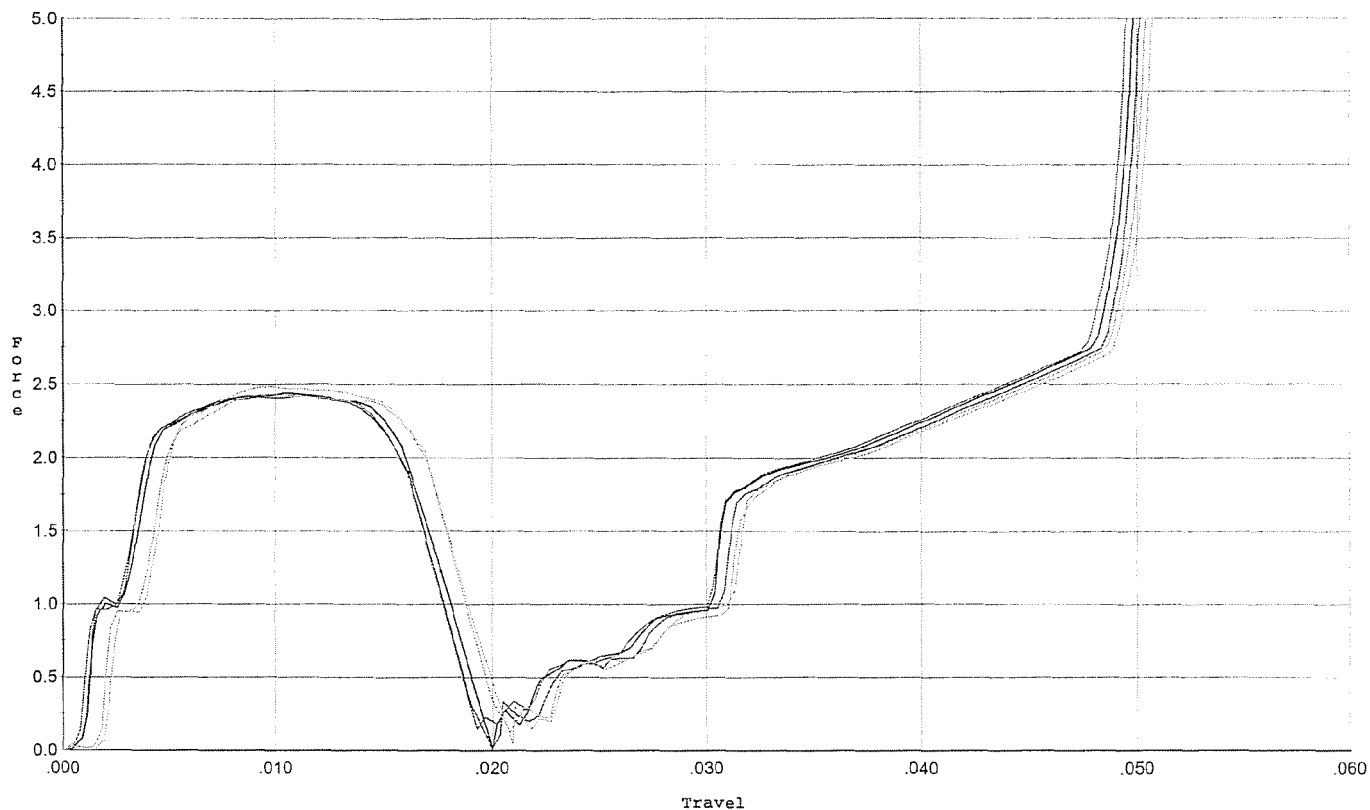
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.018	0.00	0.037	0.032		Set Trigger
2	2.509	0.017	0.00	0.037	0.031		Set Trigger
3	2.501	0.017	0.00	0.037	0.030		Set Trigger
4	2.518	0.017	0.00	0.037	0.030		Set Trigger
5	2.504	0.018	0.00	0.037	0.032		Set Trigger

A - 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



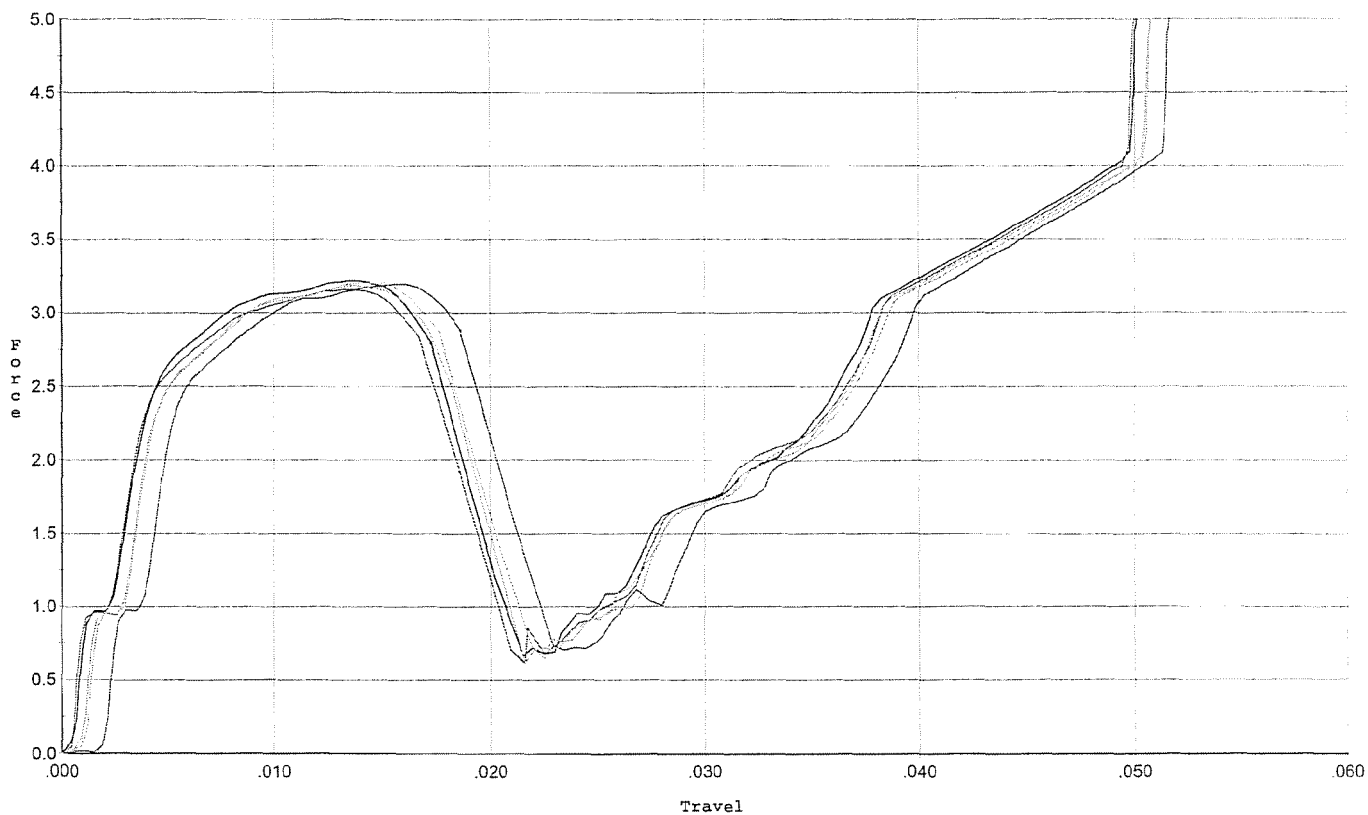
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.016	0.00	0.038	0.030		Set Trigger
2	2.438	0.018	0.00	0.037	0.032		Set Trigger
3	2.429	0.016	0.00	0.037	0.030		Set Trigger
4	2.482	0.017	0.002	0.037	0.030		Set Trigger
5	2.434	0.017	0.00	0.037	0.030		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



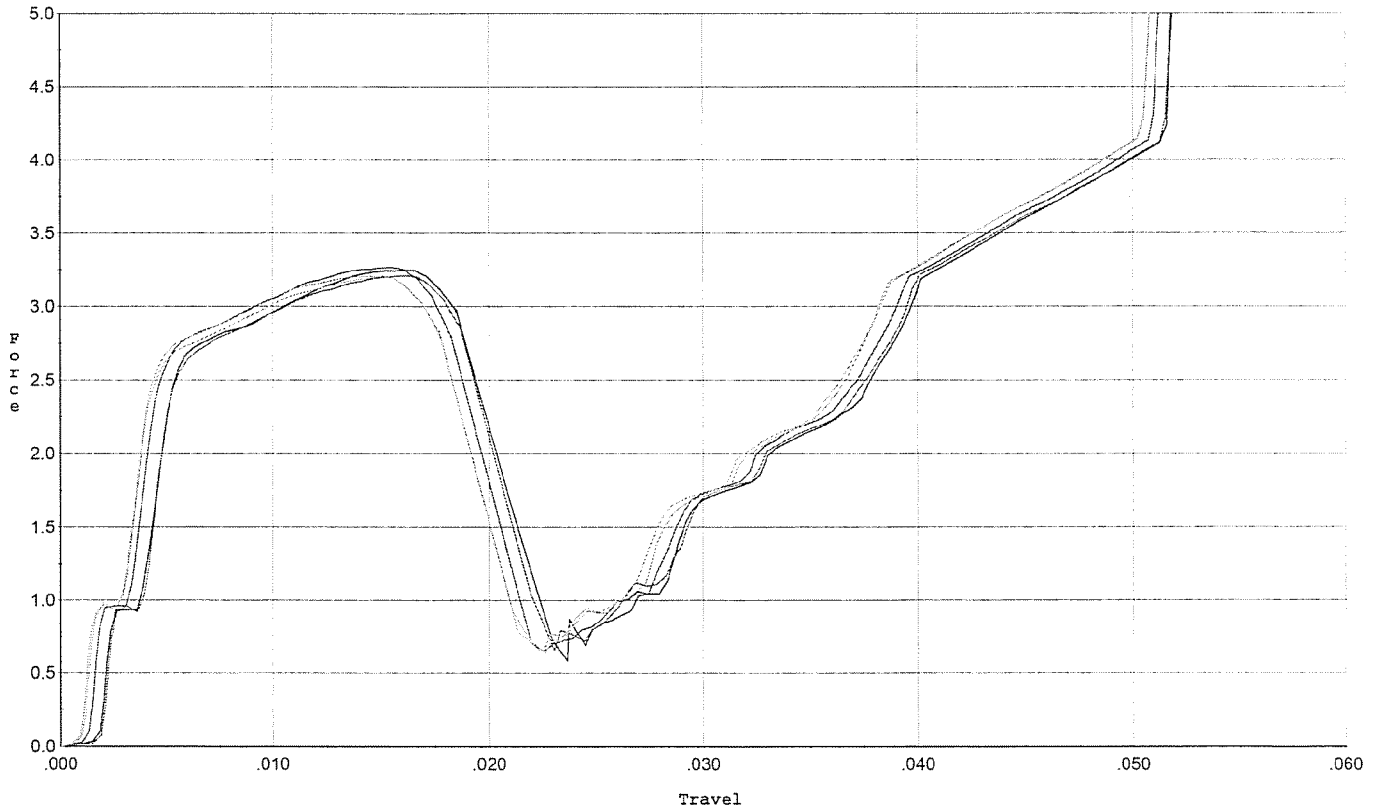
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.197	0.019	0.002	0.035	0.041		Set Trigger
2	3.220	0.017	0.00	0.035	0.041		Set Trigger
3	3.158	0.019	0.00	0.035	0.043		Set Trigger
4	3.188	0.018	0.00	0.035	0.041		Set Trigger
5	3.204	0.018	0.00	0.035	0.041		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



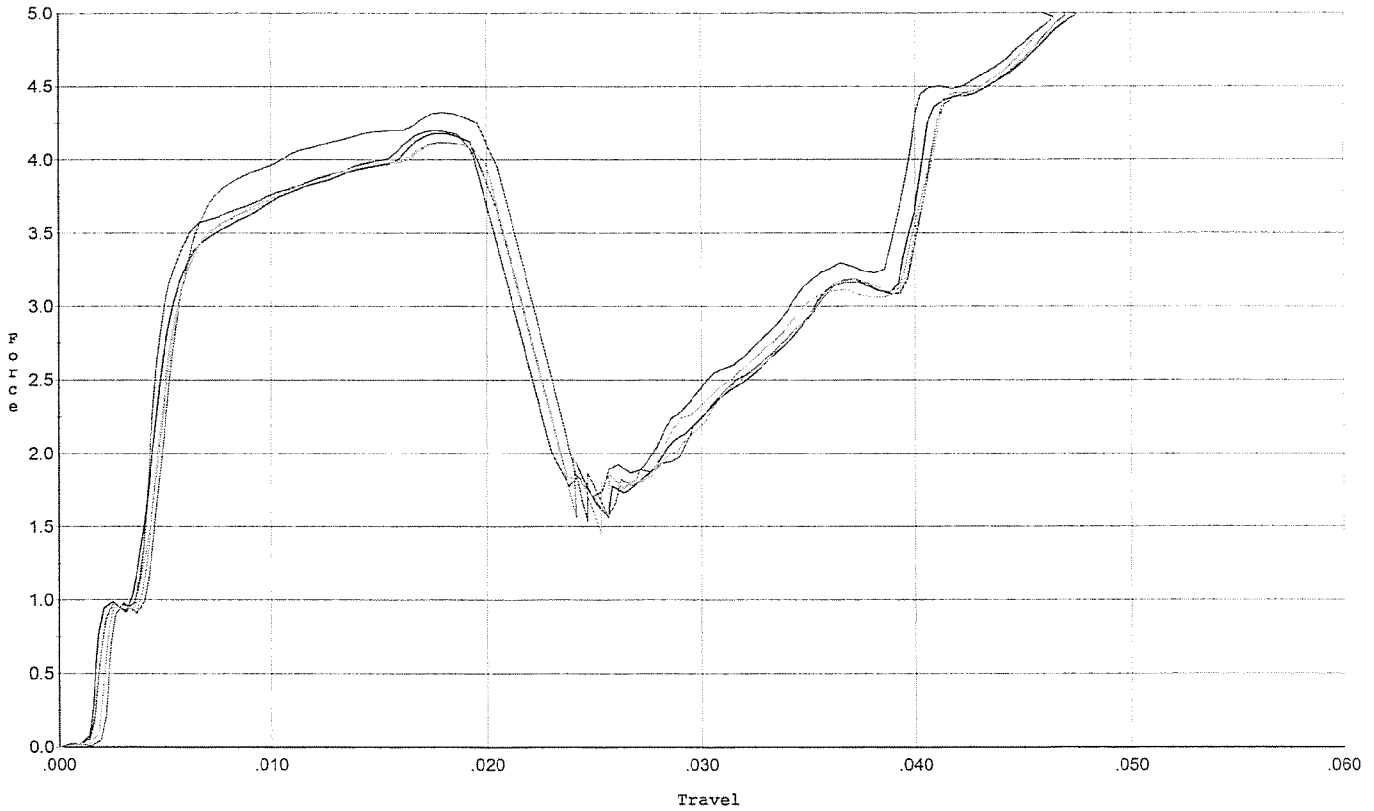
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.264	0.018	0.00	0.035	0.042		Set Trigger
2	3.247	0.018	0.004	0.035	0.041		Set Trigger
3	3.209	0.019	0.002	0.035	0.041		Set Trigger
4	3.206	0.018	0.00	0.035	0.041		Set Trigger
5	3.206	0.018	0.00	0.035	0.041		Set Trigger

A-3.22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



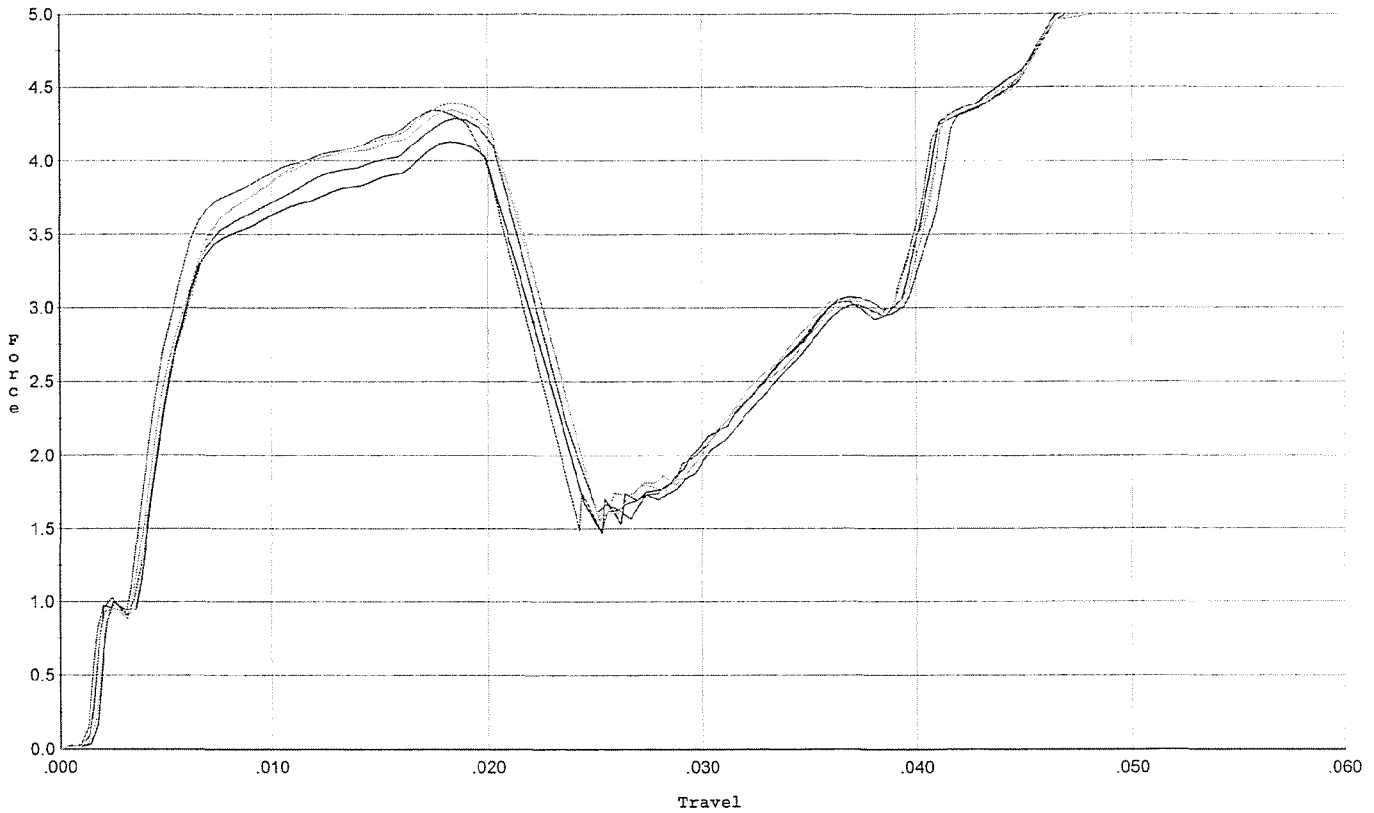
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.200	0.019	0.00	0.031	0.056		Set Trigger
2	4.182	0.020	0.00	0.032	0.058		Set Trigger
3	4.323	0.021	0.002	0.032	0.060		Set Trigger
4	4.120	0.020	0.00	0.032	0.057		Set Trigger
5	4.117	0.020	0.00	0.032	0.056		Set Trigger

A-4-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



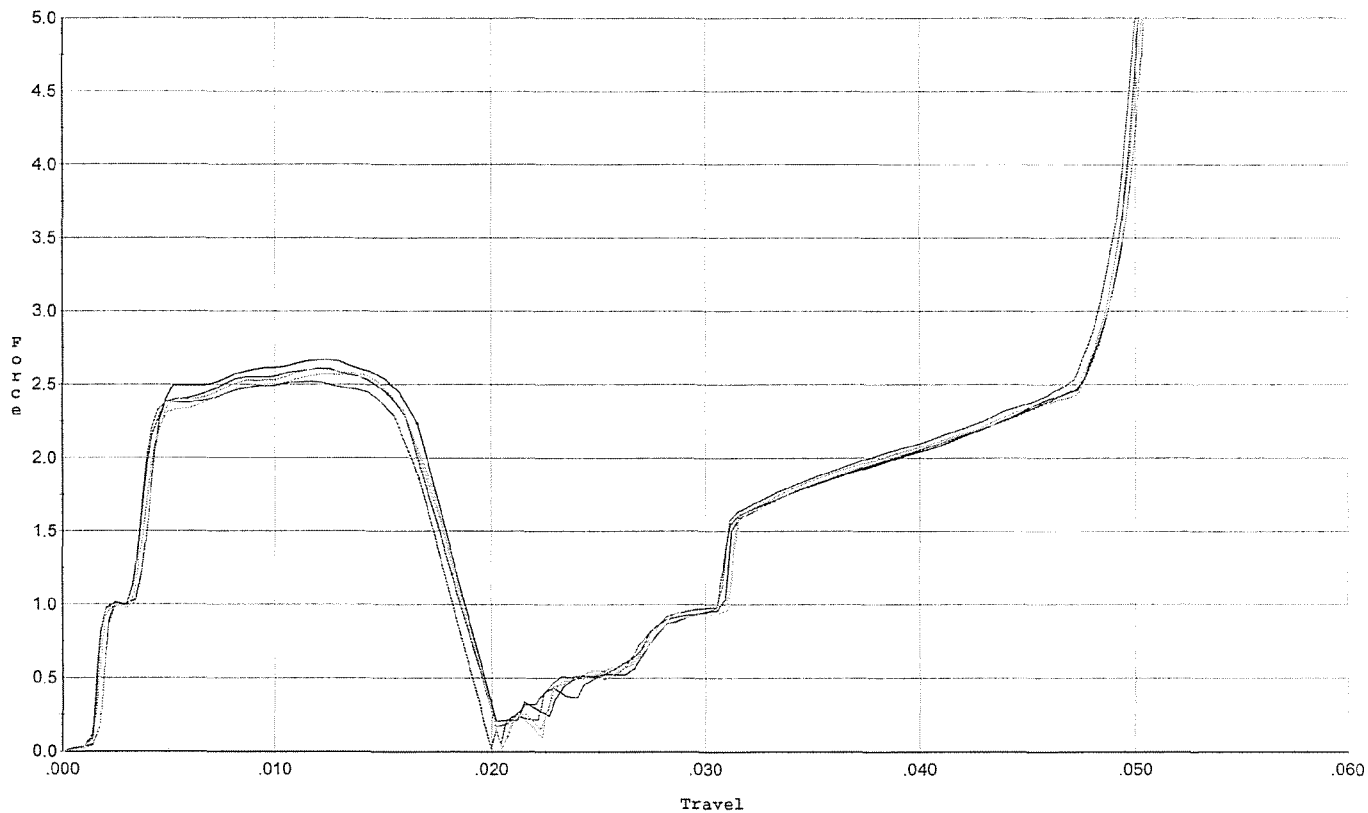
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.288	0.020	0.00	0.032	0.058		Set Trigger
2	4.129	0.022	0.004	0.032	0.061		Set Trigger
3	4.345	0.020	0.003	0.032	0.059		Set Trigger
4	4.347	0.022	0.00	0.031	0.064		Set Trigger
5	4.393	0.022	0.00	0.031	0.064		Set Trigger

A - 4.30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



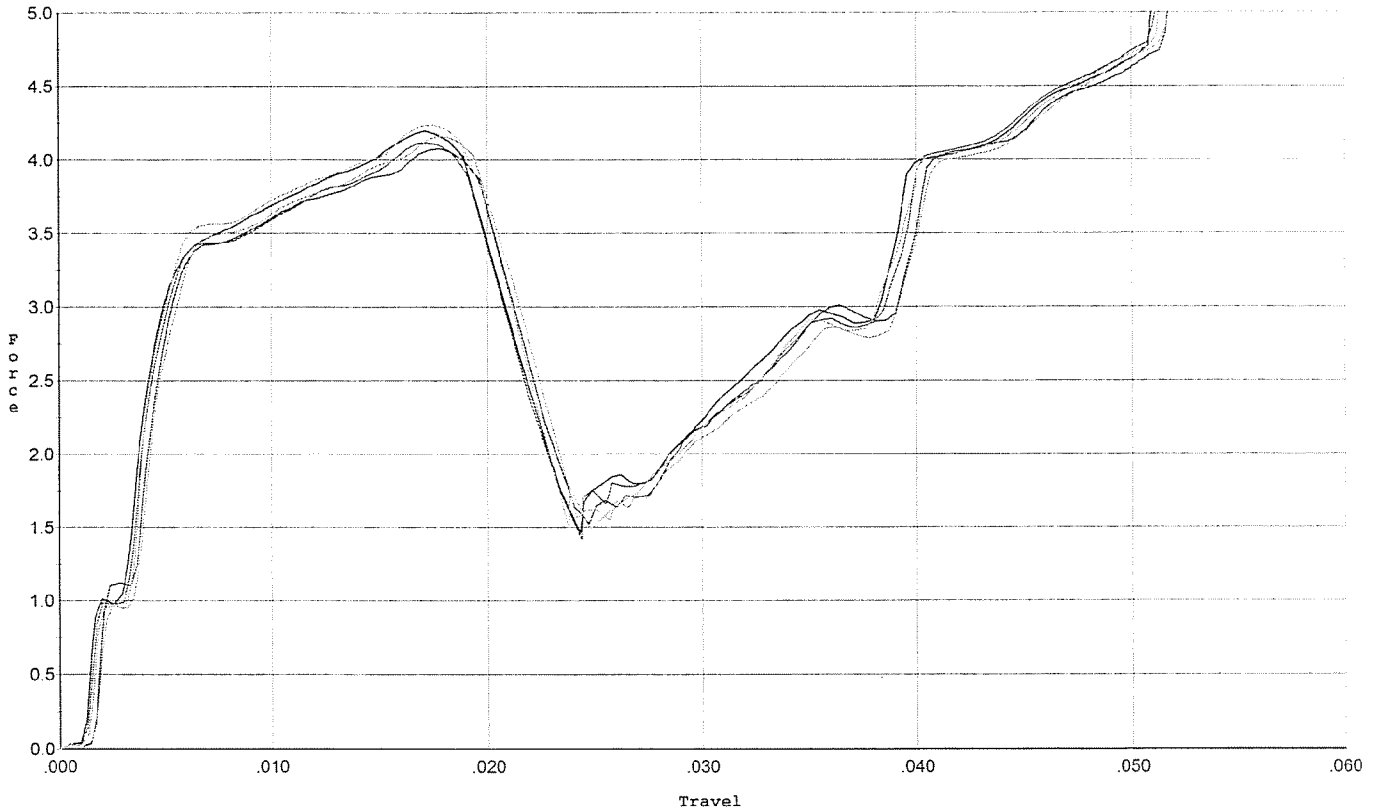
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.018	0.00	0.037	0.034		Set Trigger
2	2.669	0.017	0.00	0.037	0.032		Set Trigger
3	2.518	0.017	0.00	0.037	0.031		Set Trigger
4	2.566	0.017	0.00	0.037	0.032		Set Trigger
5	2.604	0.018	0.00	0.037	0.033		Set Trigger

A-2.59

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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	4.079	0.020	0.00	0.032	0.055		Set Trigger
2	4.197	0.019	0.00	0.032	0.054		Set Trigger
3	4.118	0.019	0.00	0.032	0.054		Set Trigger
4	4.237	0.020	0.00	0.032	0.057		Set Trigger
5	4.160	0.021	0.00	0.032	0.060		Set Trigger

A-4.15