

G 684 5253

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



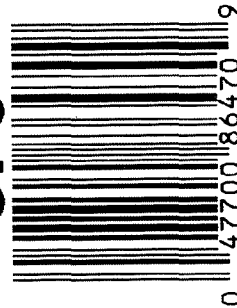
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6845253

UPC



BM FORM

GUN SERIAL # G 6845253

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-4-09	RP
430	ASSEMBLE TO STOCK		5-4-09	SP
440	PROOF		5-4-09	RP
460	CHECK HEADSPACE		5-4-09	RP
470	DIS-ASSEMBLE ACTION		5-4-09	RP
472	SERIALIZE BOLT HANDLE		5-5-09	RIZ
480	MAGNAFLUX BBL ACTION		5/6/09	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/7/09	RT
510	DRILL AND TAP SIGHT HOLES		5-5-09	SP
520	GOFF BLAST BBL / REC		5/7/09	REM
540	APPLY COATINGS (BARREL ACTION)		5/14	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-14-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5/14/09	SP
	D) OIL FIRING PIN ASSEMBLY		5-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

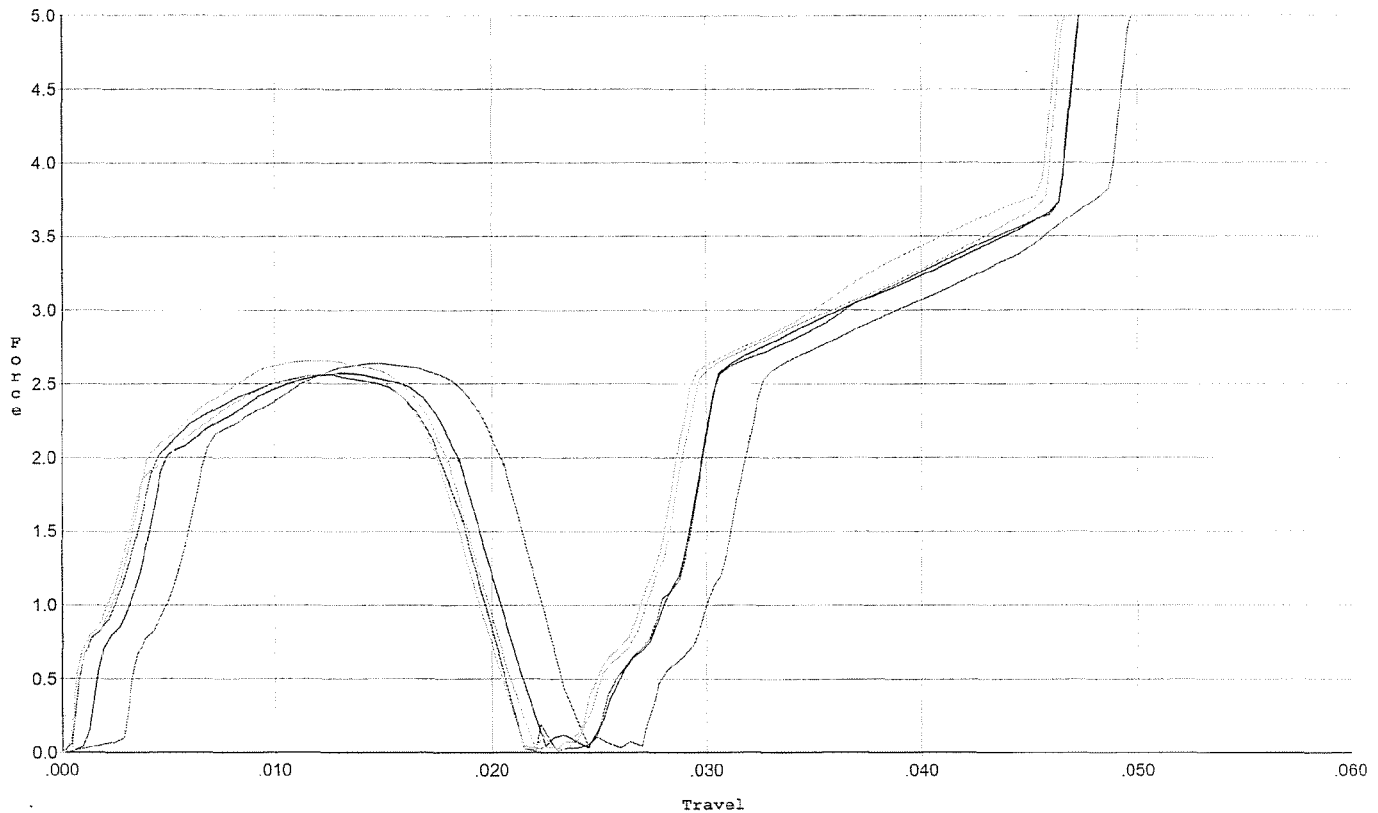
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-16-09	LJH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-16-09	LJH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	6-16-09	LJH
	J) ASSEMBLE STOCK		5-20-09	LJH
	K) ASSEMBLE SWIVEL STUDS		6-16-09	LJH
	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	6/10/09	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/10/09	TGR
670	FINAL INSPECTION A) HEADSPACE		6-16-09	LJH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>262</u> <u>264</u> <u>259</u> <u>258</u> <u>256</u>	10-15-09	RTZ
	C) FUNCTION		6-16-09	LJH
690	PACK		7/29/09	Fen

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



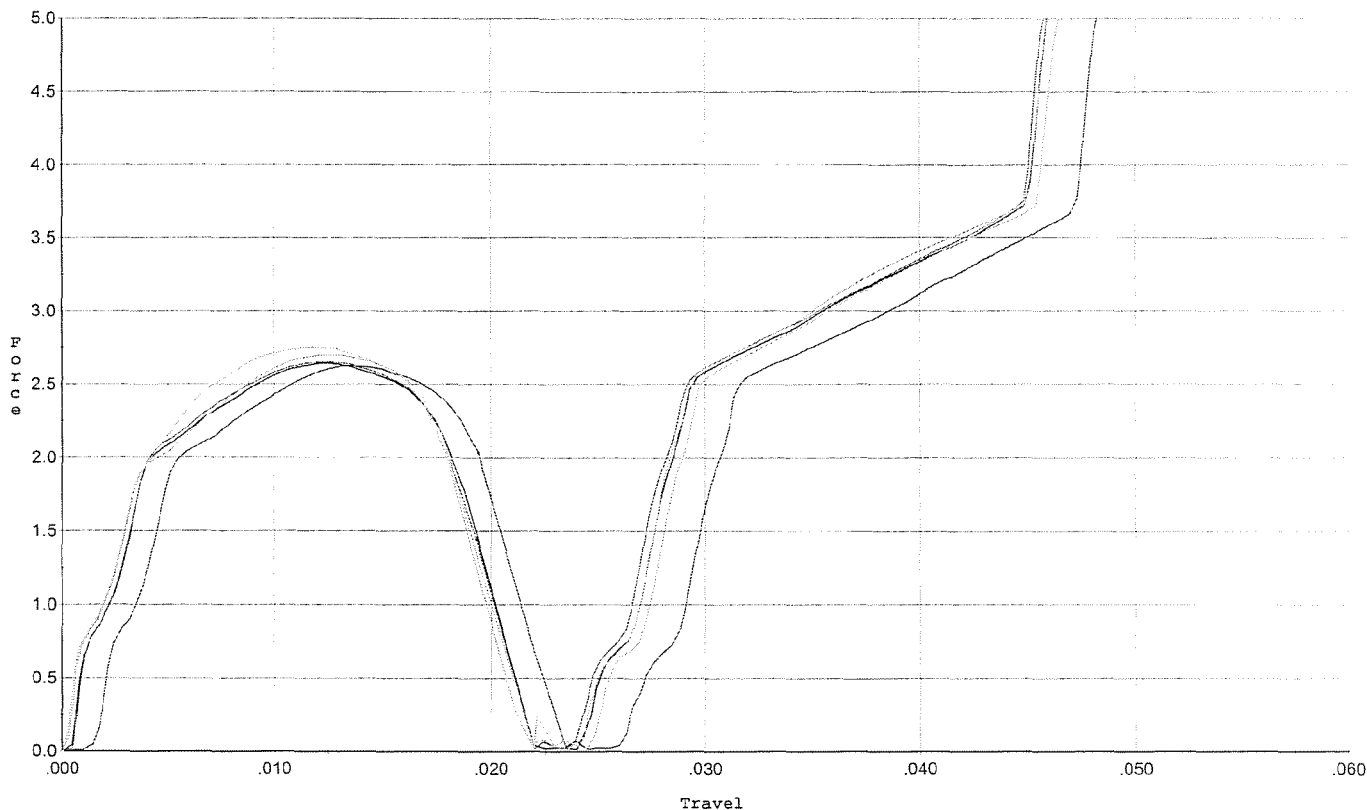
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.019	0.00	0.032	0.035		Set Trigger
2	2.572	0.018	0.00	0.032	0.034		Set Trigger
3	2.639	0.021	0.00	0.033	0.036		Set Trigger
4	2.571	0.017	0.00	0.032	0.033		Set Trigger
5	2.658	0.018	0.00	0.031	0.036		Set Trigger

A-2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



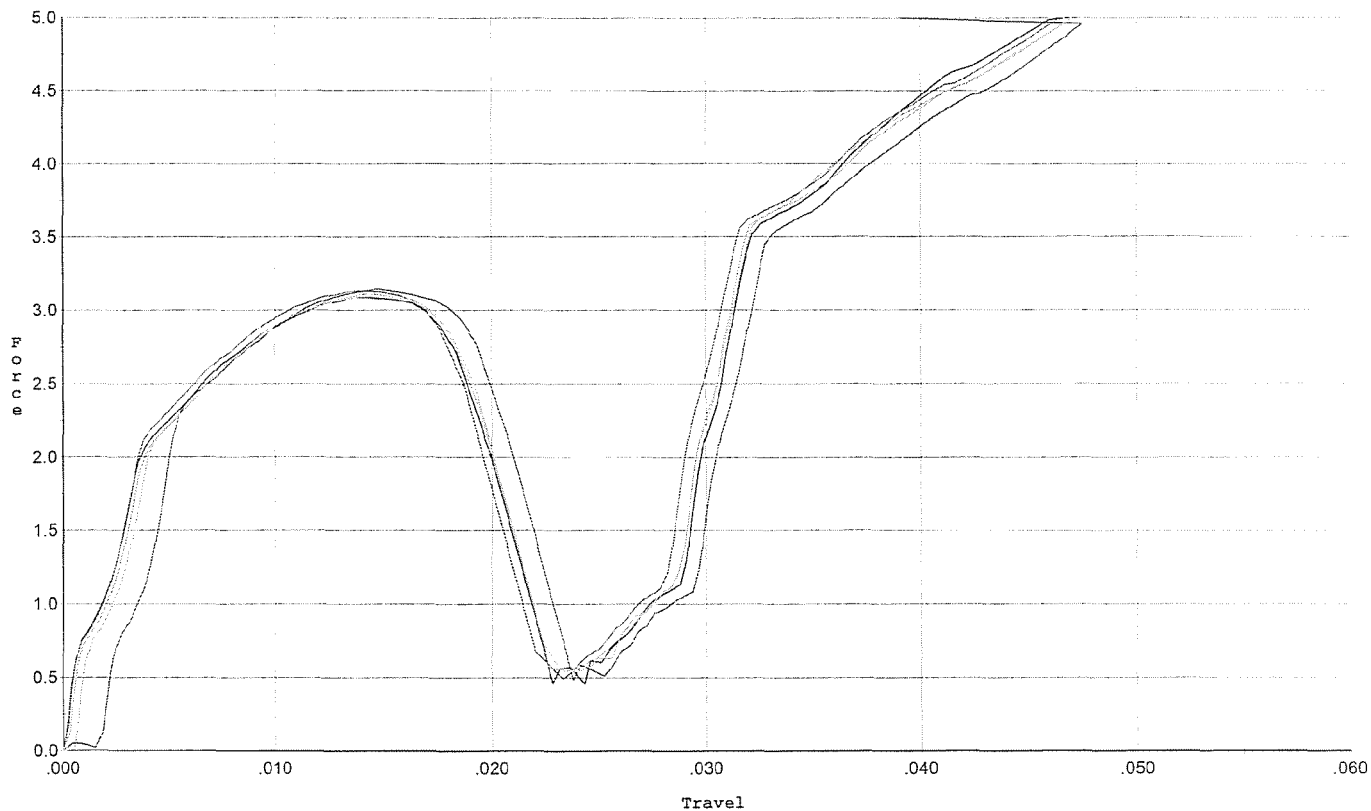
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.627	0.019	0.00	0.032	0.036		Set Trigger
2	2.644	0.019	0.00	0.031	0.037		Set Trigger
3	2.653	0.019	0.00	0.030	0.038		Set Trigger
4	2.753	0.018	0.00	0.031	0.037		Set Trigger
5	2.702	0.018	0.00	0.031	0.035		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



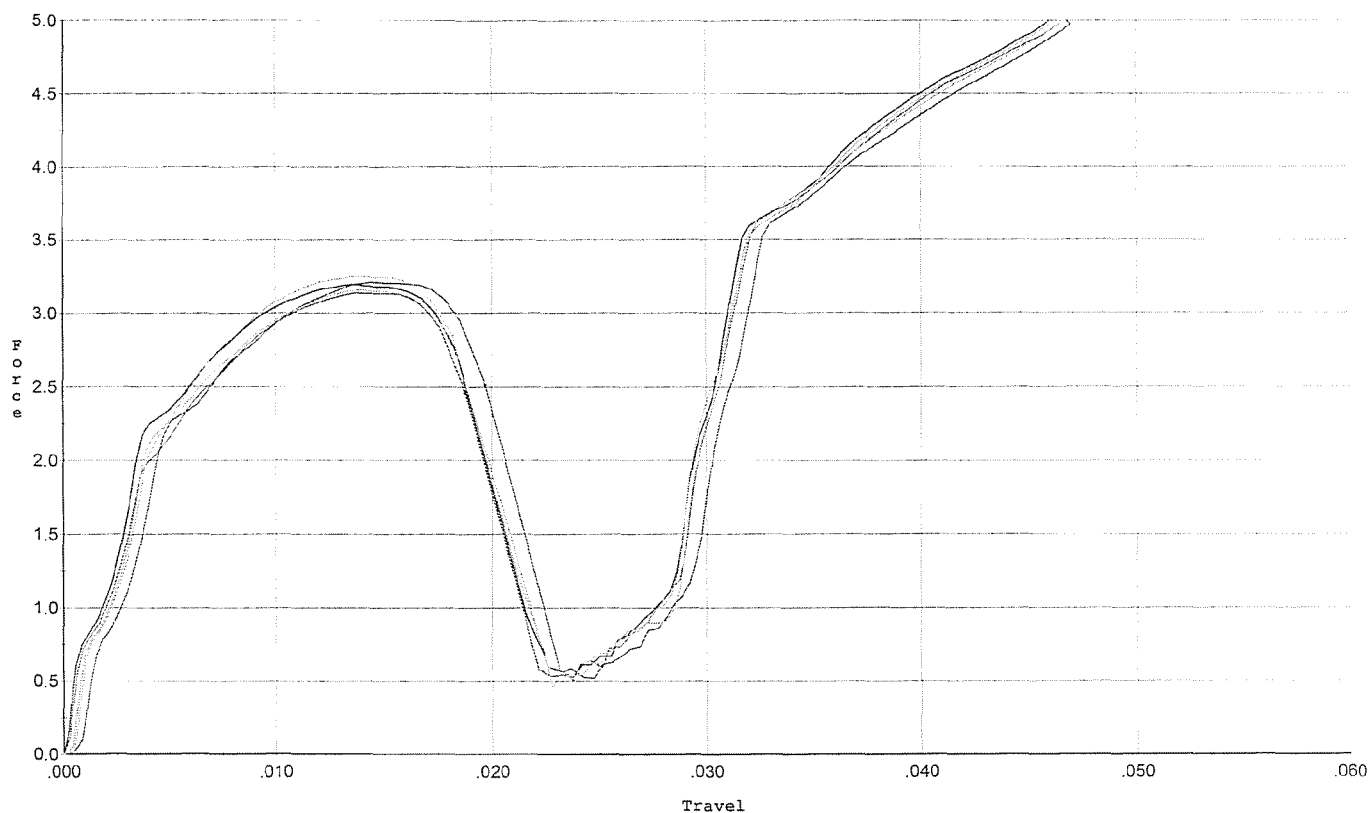
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.142	0.021	0.002	0.031	0.045		Set Trigger
2	3.087	0.020	0.00	0.031	0.045		Set Trigger
3	3.131	0.019	0.00	0.030	0.043		Set Trigger
4	3.089	0.020	0.00	0.031	0.044		Set Trigger
5	3.112	0.019	0.00	0.031	0.044		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



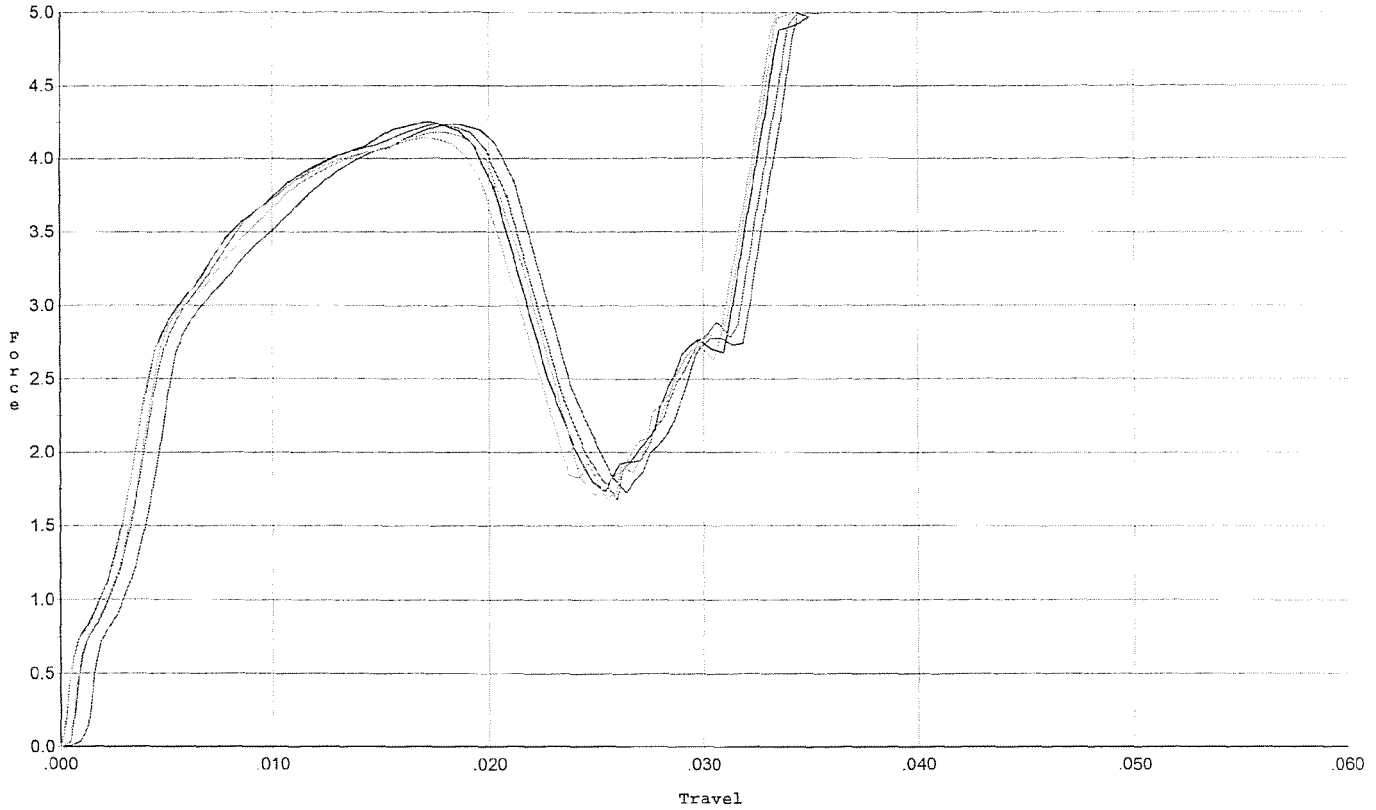
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.210	0.020	0.00	0.031	0.045		Set Trigger
2	3.196	0.018	0.00	0.031	0.043		Set Trigger
3	3.137	0.019	0.00	0.031	0.042		Set Trigger
4	3.250	0.018	0.00	0.031	0.042		Set Trigger
5	3.158	0.020	0.00	0.031	0.046		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



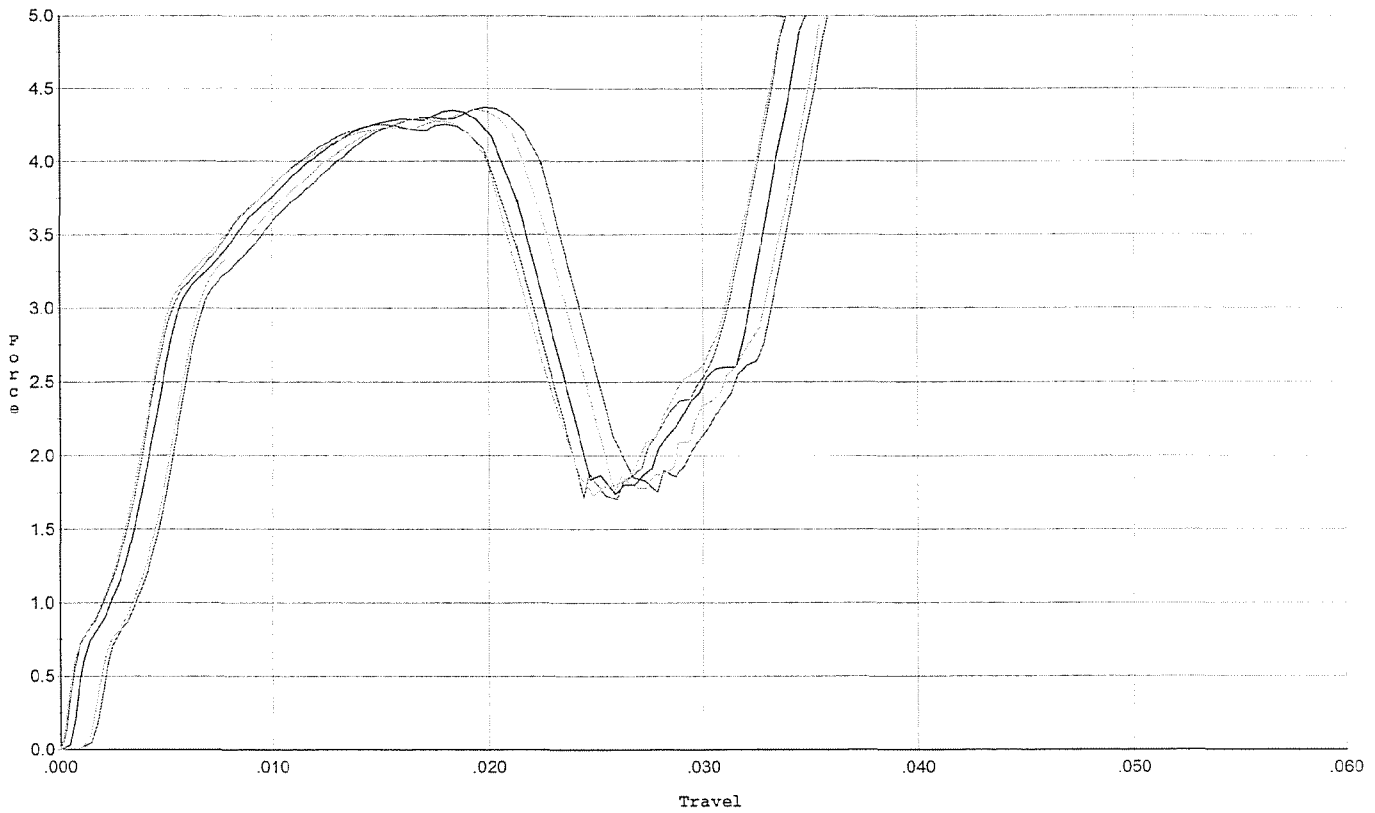
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.237	0.021	0.00	0.028	0.060		Set Trigger
2	4.253	0.020	0.00	0.027	0.060		Set Trigger
3	4.239	0.021	0.00	0.028	0.061		Set Trigger
4	4.144	0.022	0.00	0.028	0.063		Set Trigger
5	4.185	0.022	0.00	0.027	0.063		Set Trigger

A-421

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



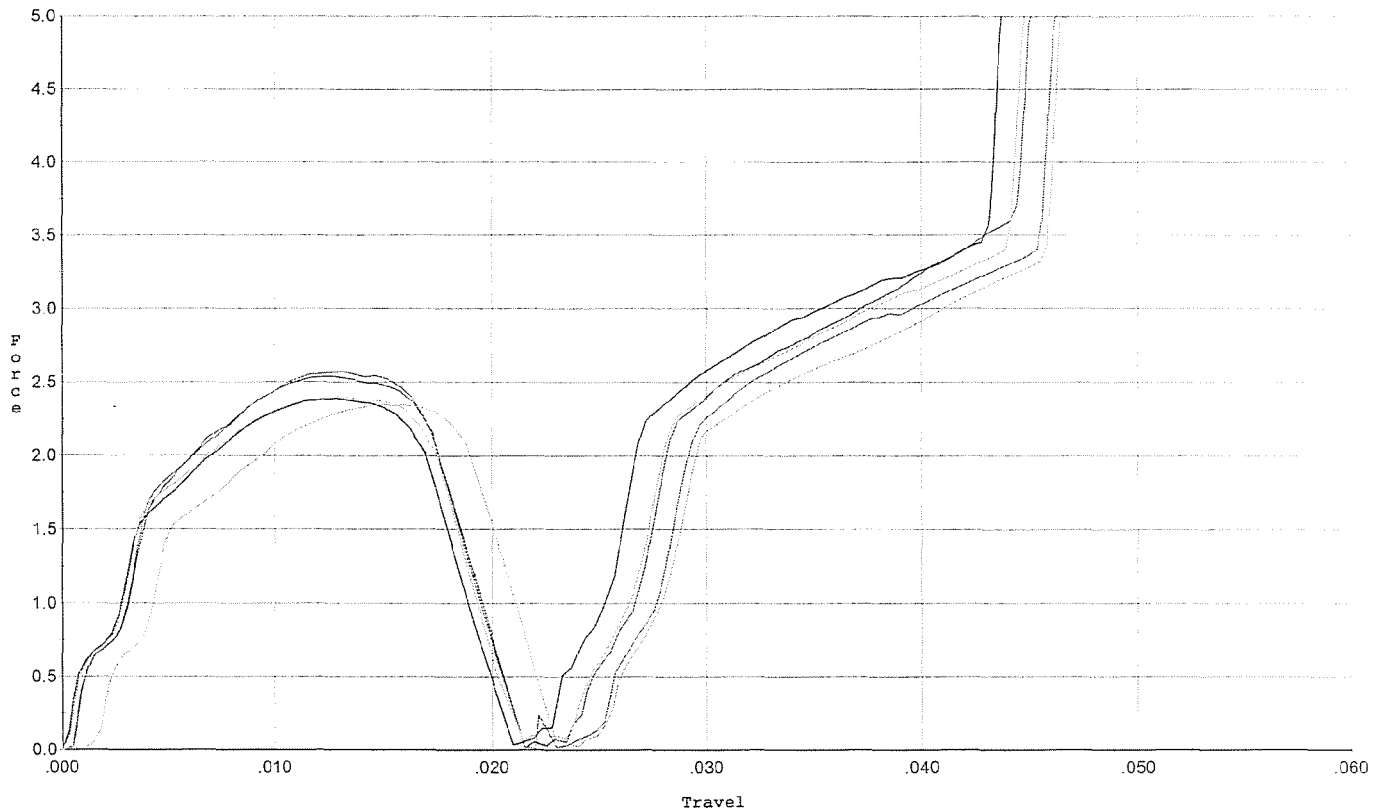
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.373	0.022	0.00	0.027	0.065		Set Trigger
2	4.353	0.021	0.00	0.027	0.064		Set Trigger
3	4.256	0.021	0.00	0.027	0.064		Set Trigger
4	4.356	0.023	0.00	0.027	0.066		Set Trigger
5	4.274	0.020	0.00	0.027	0.060		Set Trigger

A-432

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



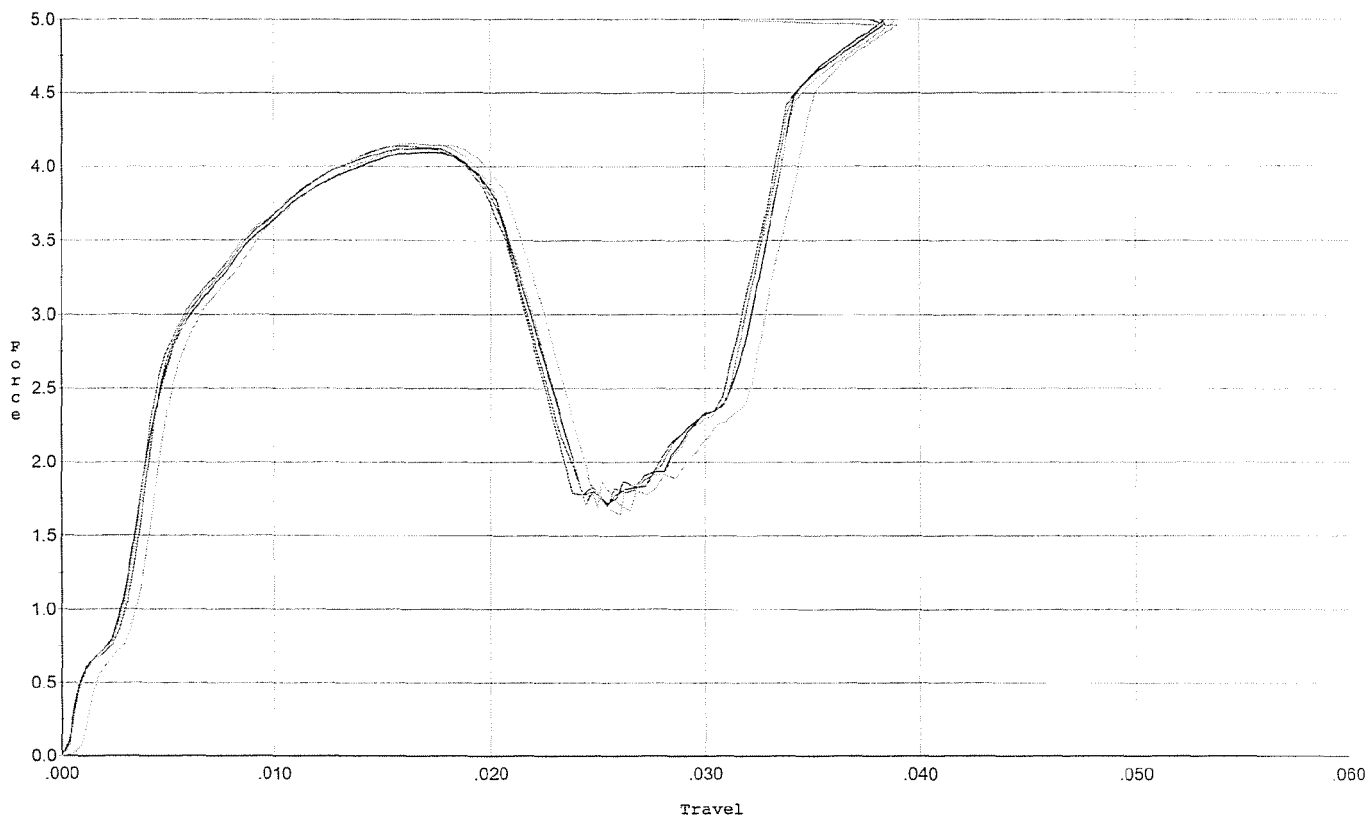
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.019	0.00	0.030	0.035		Set Trigger
2	2.391	0.017	0.00	0.030	0.030		Set Trigger
3	2.574	0.017	0.00	0.032	0.032		Set Trigger
4	2.404	0.017	0.00	0.030	0.031		Set Trigger
5	2.350	0.021	0.00	0.031	0.033		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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	4.134	0.020	0.00	0.028	0.059		Set Trigger
2	4.093	0.022	0.00	0.028	0.064		Set Trigger
3	4.117	0.021	0.00	0.028	0.060		Set Trigger
4	4.152	0.022	0.00	0.028	0.063		Set Trigger
5	4.142	0.022	0.00	0.029	0.063		Set Trigger

A. 4.12