

G684 8367

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

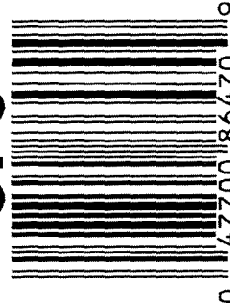
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6848367

UPC



GUN SERIAL #

G 6848367

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-3-09	SPD
430	ASSEMBLE TO STOCK		4-3-09	SP
440	PROOF		4-3-09	SPD
460	CHECK HEADSPACE		4-3-09	SPD
470	DIS-ASSEMBLE ACTION	MAGNA - FLUX	4-3-09	SPD
472	SERIALIZE BOLT HANDLE		4-6-09	RTZ
475	DRILL AND TAP SIGHT HOLES	OPERATOR 	4-6-09	SP
480	MAGNAFLUX BBL ACTION		4/8/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/8/09	RT
520	GOFF BLAST BBL / REC		4-8	BT
542	APPLY COATINGS (BARREL ACTION)		4-16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-20-09	cms
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-20-09	cms
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-20-09	cms
	D) OIL FIRING PIN ASSEMBLY		4-23-09	LN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

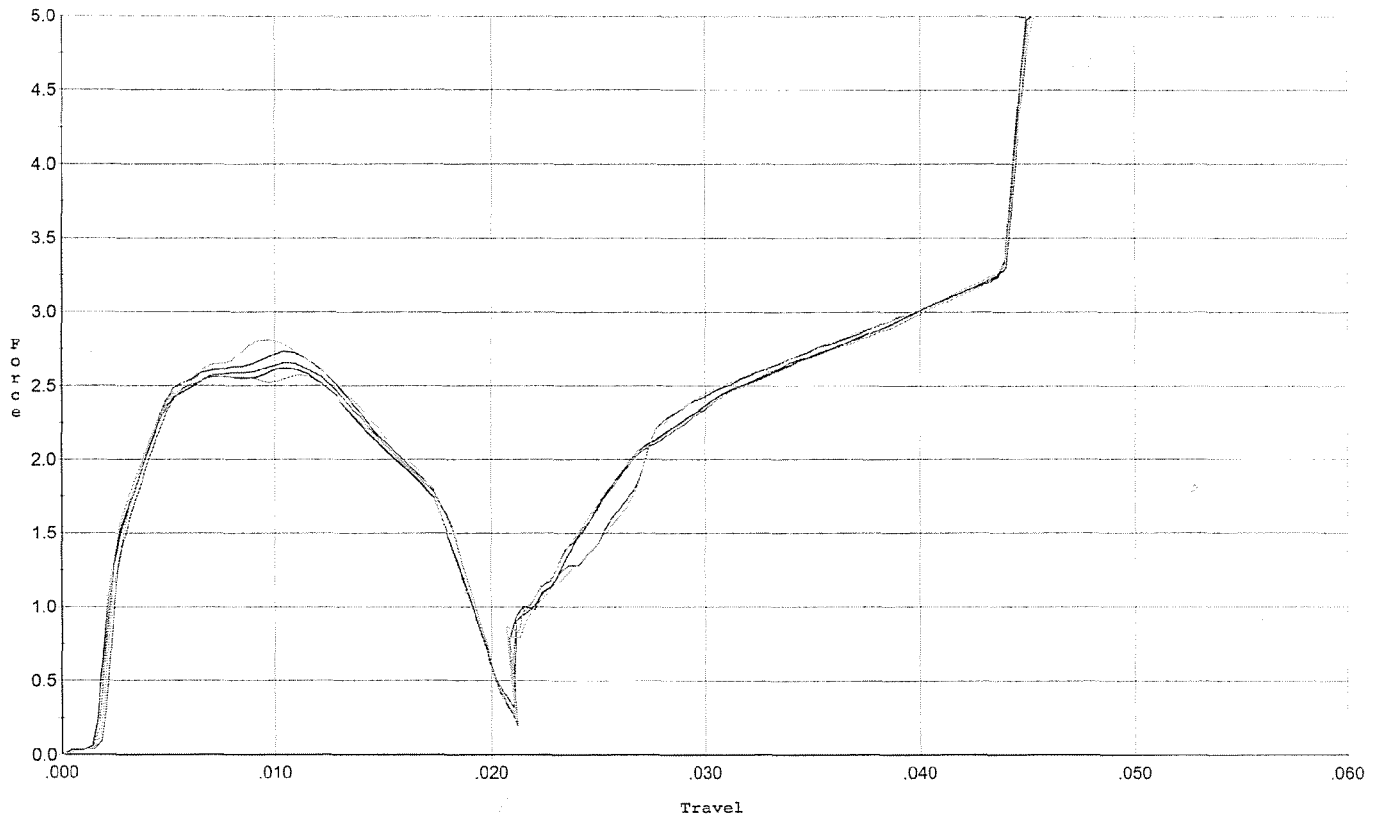
560	F) BARBER M24 0054494 SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	5-7-09	RP		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>60</u>	<u>60</u>	<u>60</u>	5-7-09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.023</u>	<u>.023</u>	5-7-09	RP		
	J) ASSEMBLE STOCK					4-23-09	RP		
	K) ASSEMBLE SWIVEL STUDS					5-7-09	RP		
	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		PASS	FAIL		4-27-09	RP		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION			4-27-09	TAR		
660	INSPECT FOR LIVE AMMO								
670	FINAL INSPECTION A) HEADSPACE					5-7-09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u>	<u>2.64</u>	<u>2.83</u>	<u>2.76</u>	<u>2.62</u>	5/11/09	RP
	C) FUNCTION					5-7-09	RP		
690	PACK					5-26-09	RP		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 02/11/2009

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



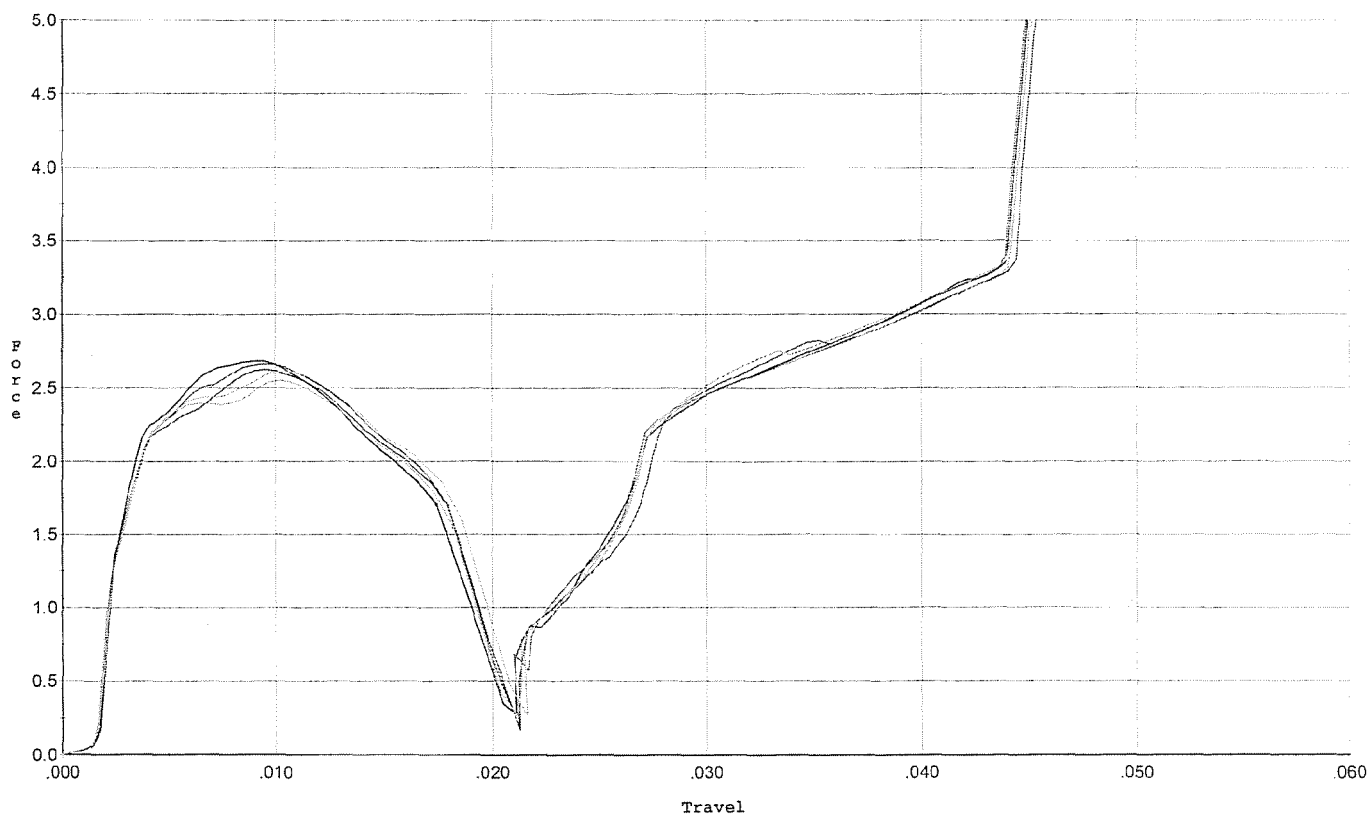
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.734	0.018	0.00	0.031	0.035		Set Trigger
2	2.621	0.019	0.00	0.031	0.035		Set Trigger
3	2.658	0.018	0.00	0.031	0.034		Set Trigger
4	2.813	0.018	0.00	0.031	0.035		Set Trigger
5	2.576	0.019	0.00	0.031	0.035		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 02/11/2009

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



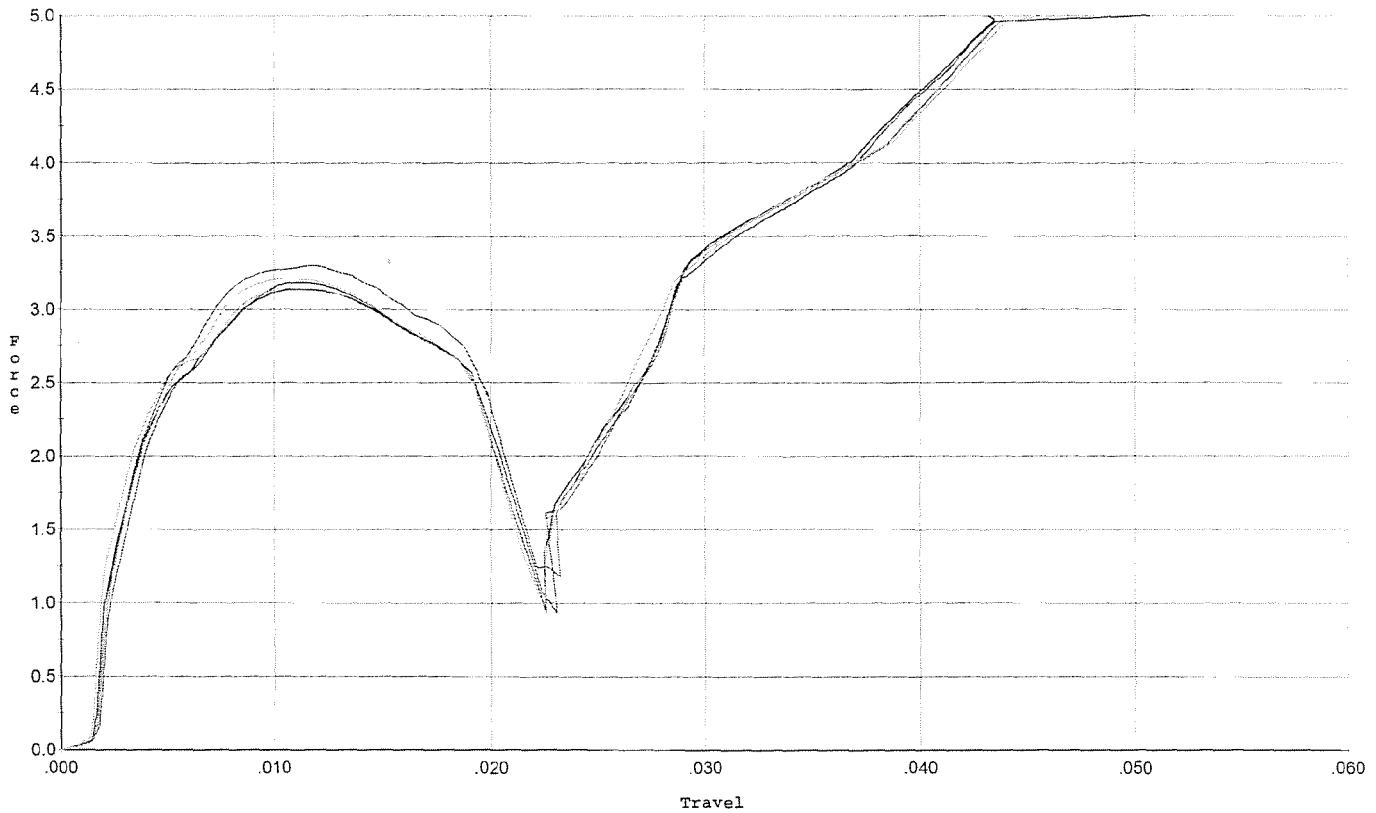
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.624	0.018	0.00	0.031	0.033		Set Trigger
2	2.683	0.017	0.00	0.031	0.033		Set Trigger
3	2.663	0.018	0.00	0.031	0.034		Set Trigger
4	2.615	0.019	0.00	0.030	0.035		Set Trigger
5	2.552	0.018	0.00	0.031	0.033		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 02/11/2009

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



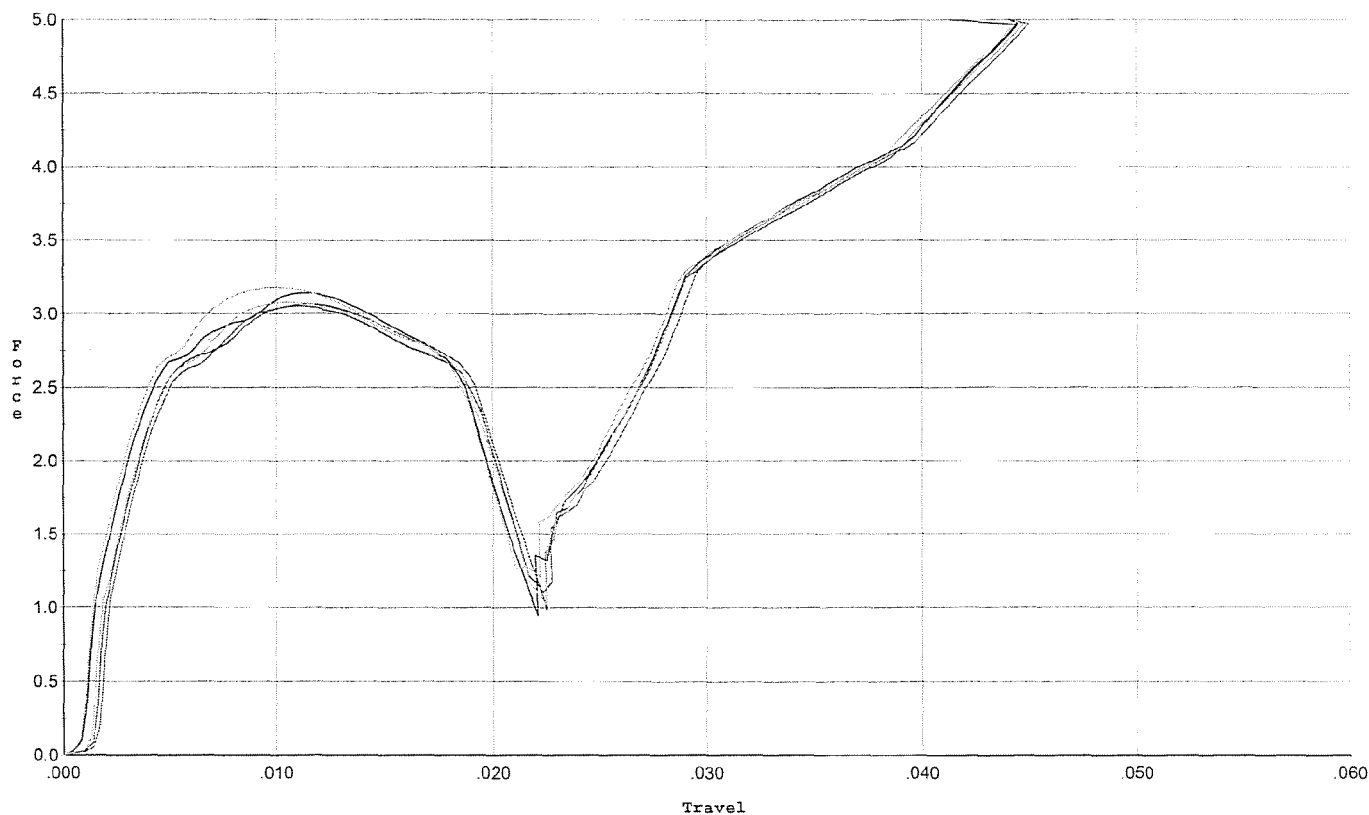
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.184	0.021	0.00	0.028	0.046		Set Trigger
2	3.140	0.019	0.00	0.028	0.044		Set Trigger
3	3.296	0.020	0.00	0.028	0.047		Set Trigger
4	3.212	0.019	0.00	0.028	0.045		Set Trigger
5	3.145	0.019	0.00	0.028	0.044		Set Trigger

A3.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 02/11/2009

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



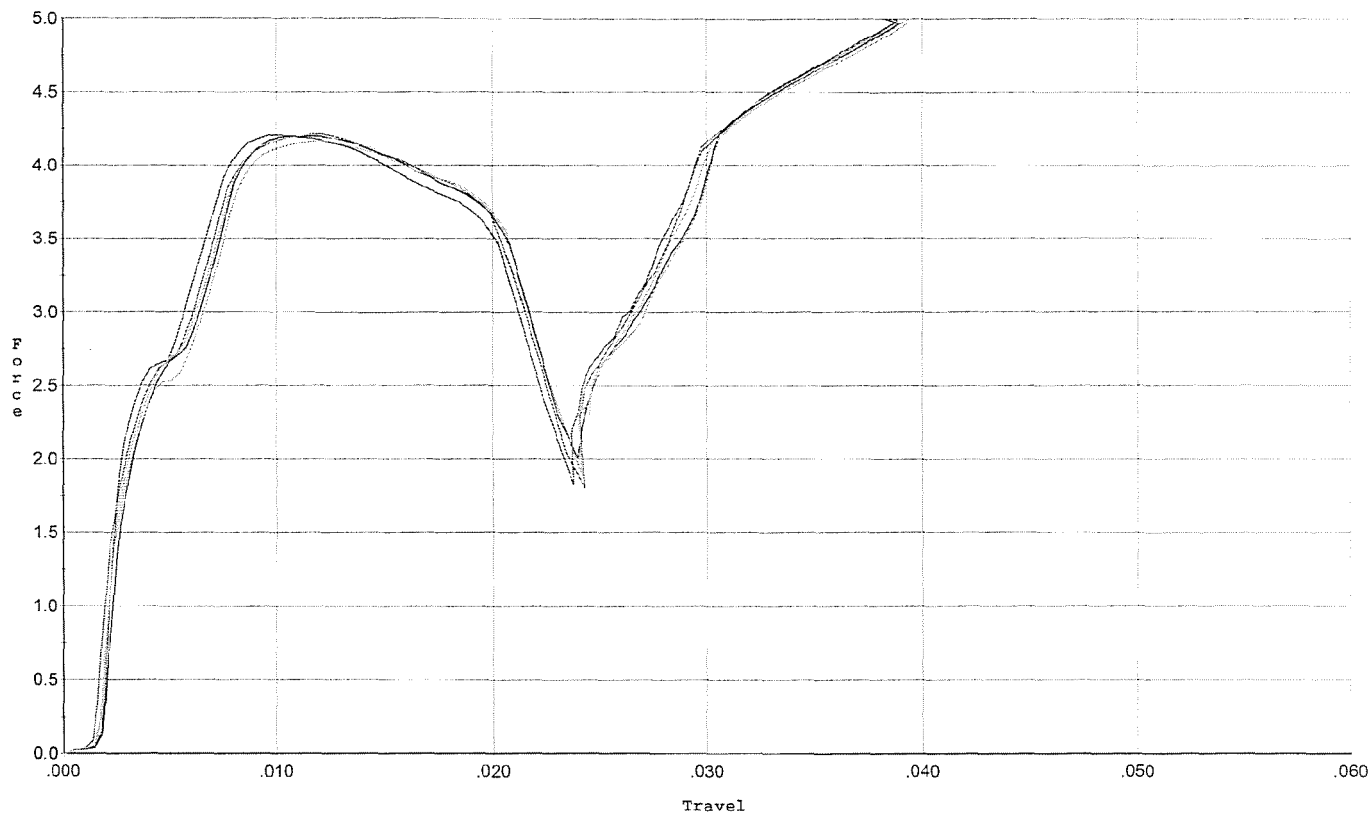
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.052	0.019	0.00	0.028	0.044		Set Trigger
2	3.142	0.019	0.00	0.028	0.044		Set Trigger
3	3.068	0.019	0.00	0.029	0.043		Set Trigger
4	3.078	0.020	0.00	0.028	0.045		Set Trigger
5	3.177	0.019	0.00	0.028	0.045		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 02/11/2009

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



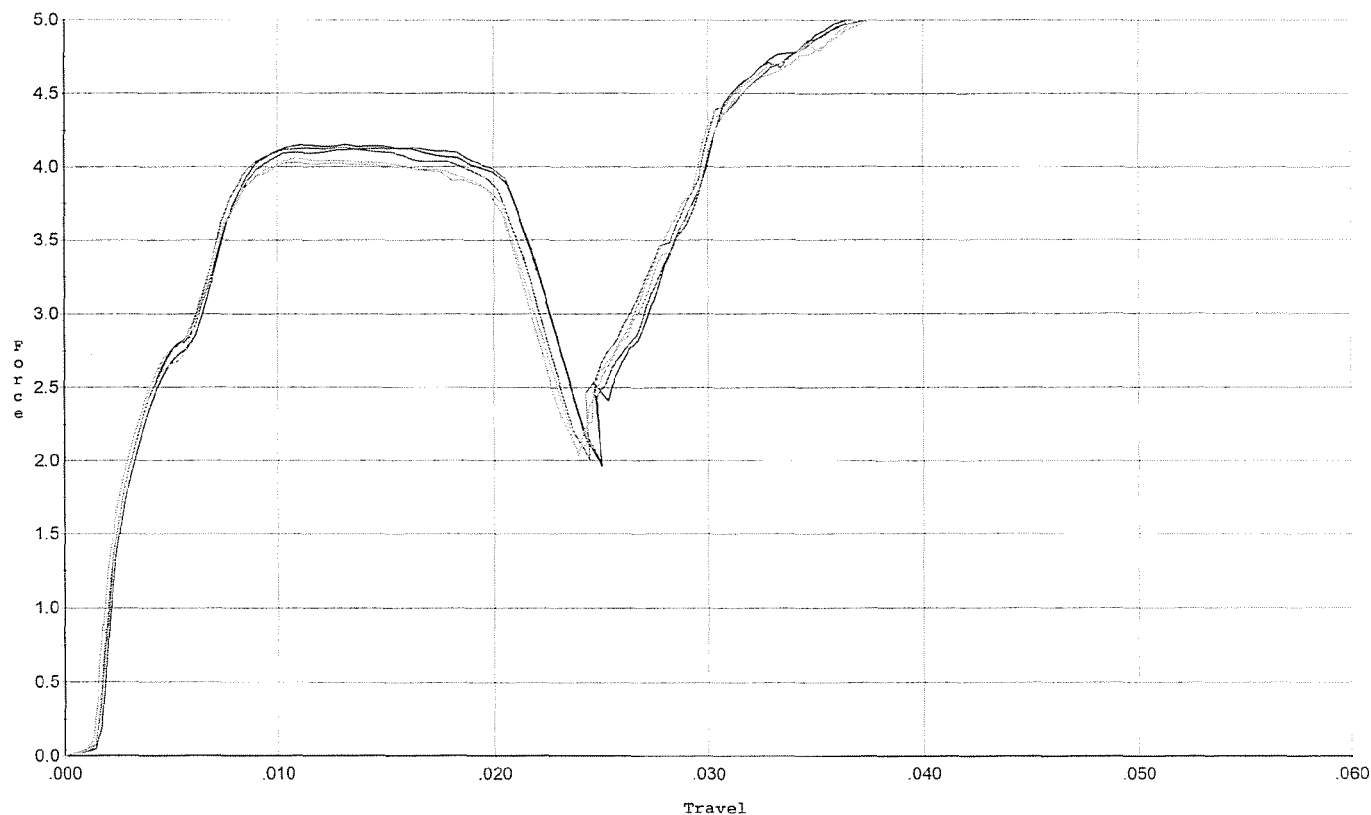
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.020	0.00	0.026	0.060		Set Trigger
2	4.199	0.021	0.00	0.026	0.061		Set Trigger
3	4.218	0.021	0.00	0.026	0.064		Set Trigger
4	4.209	0.021	0.00	0.026	0.061		Set Trigger
5	4.166	0.021	0.00	0.026	0.060		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 02/11/2009

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



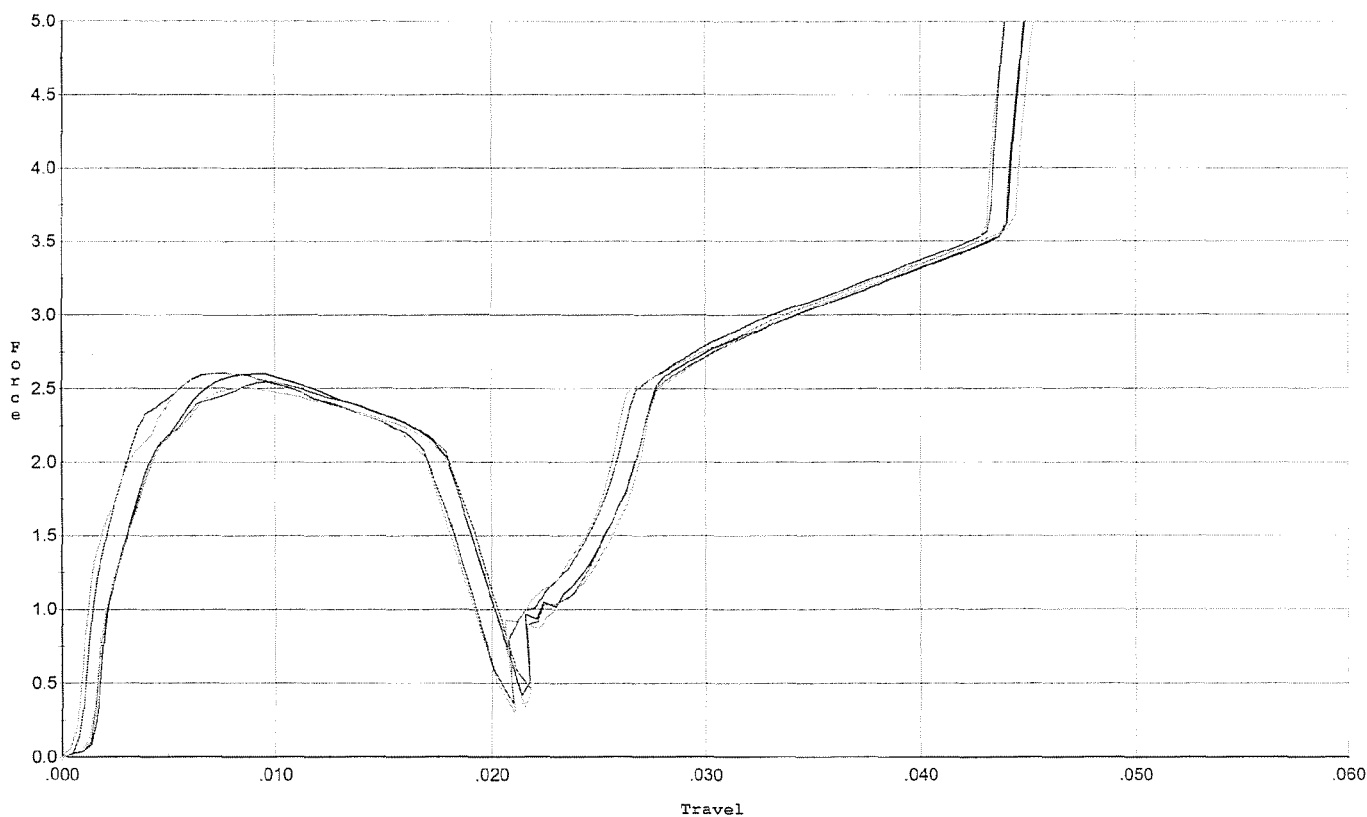
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.022	0.00	0.025	0.066		Set Trigger
2	4.153	0.022	0.00	0.025	0.066		Set Trigger
3	4.130	0.021	0.00	0.025	0.064		Set Trigger
4	4.063	0.022	0.00	0.025	0.065		Set Trigger
5	4.029	0.020	0.00	0.026	0.061		Set Trigger

A-4-10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 02/11/2009

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



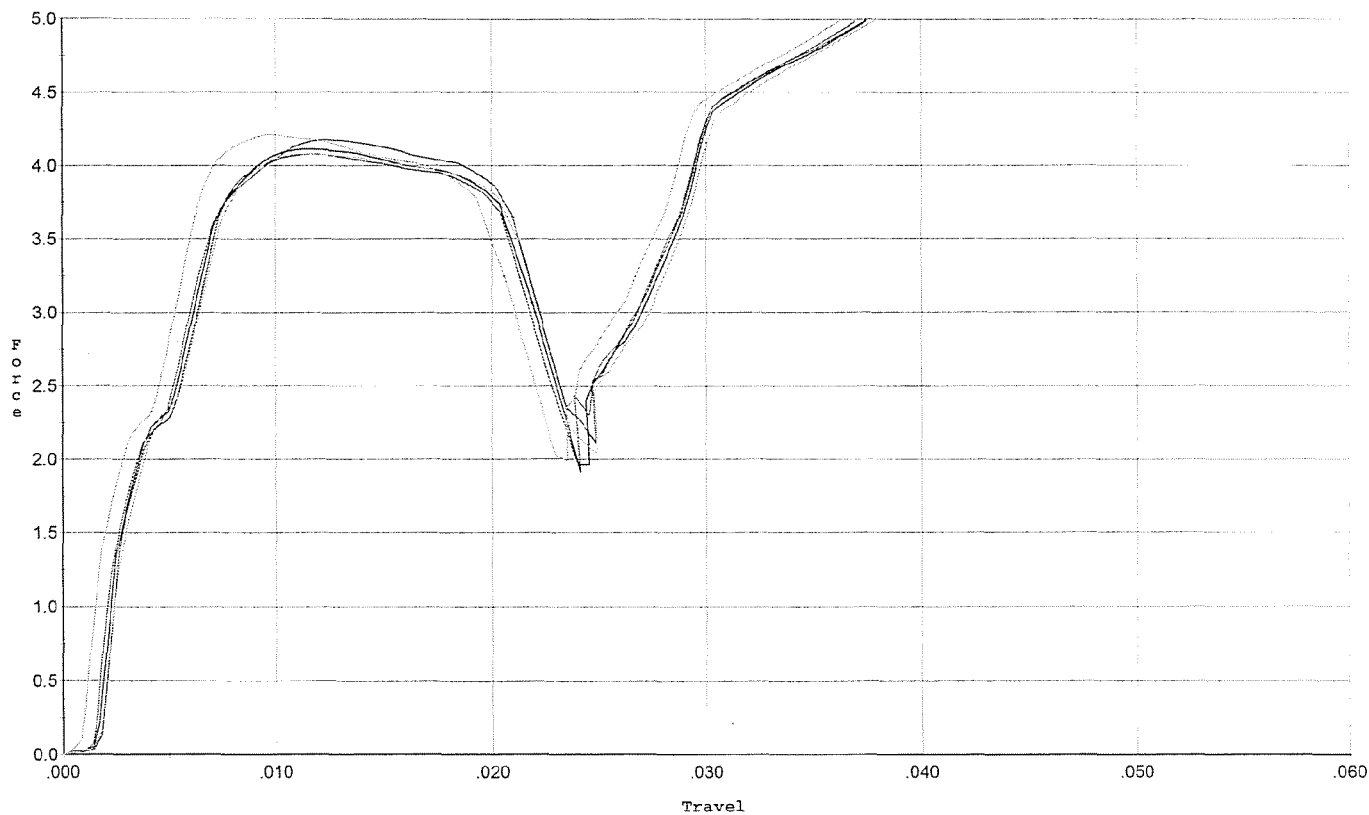
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.018	0.00	0.029	0.036		Set Trigger
2	2.597	0.020	0.00	0.029	0.037		Set Trigger
3	2.546	0.019	0.00	0.029	0.036		Set Trigger
4	2.506	0.018	0.00	0.030	0.034		Set Trigger
5	2.604	0.019	0.00	0.029	0.037		Set Trigger

A-2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 02/11/2009

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	4.175	0.021	0.00	0.023	0.062		Set Trigger
2	4.112	0.022	0.00	0.024	0.064		Set Trigger
3	4.079	0.020	0.00	0.024	0.060		Set Trigger
4	4.080	0.021	0.00	0.024	0.061		Set Trigger
5	4.212	0.021	0.00	0.024	0.063		Set Trigger

A-4013