

G684 8399

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

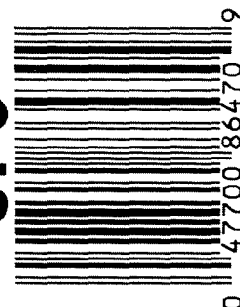
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

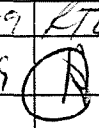
G6848399

UPC



GUN SERIAL #

G 6848399

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-15-09	RTZ
430	ASSEMBLE TO STOCK		5-19-09	W W
440	PROOF		5-19-09	W W
460	CHECK HEADSPACE	MAGNA - FLUX	5-19-09	W W
470	DIS-ASSEMBLE ACTION		5-19-09	RTZ
472	SERIALIZE BOLT HANDLE		5-19-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/29/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-19-09	SP
520	GOFF BLAST BBL / REC		5/29/09	W W
540	APPLY COATINGS (BARREL ACTION)		6/2	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-2-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-2-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-2-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-2-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

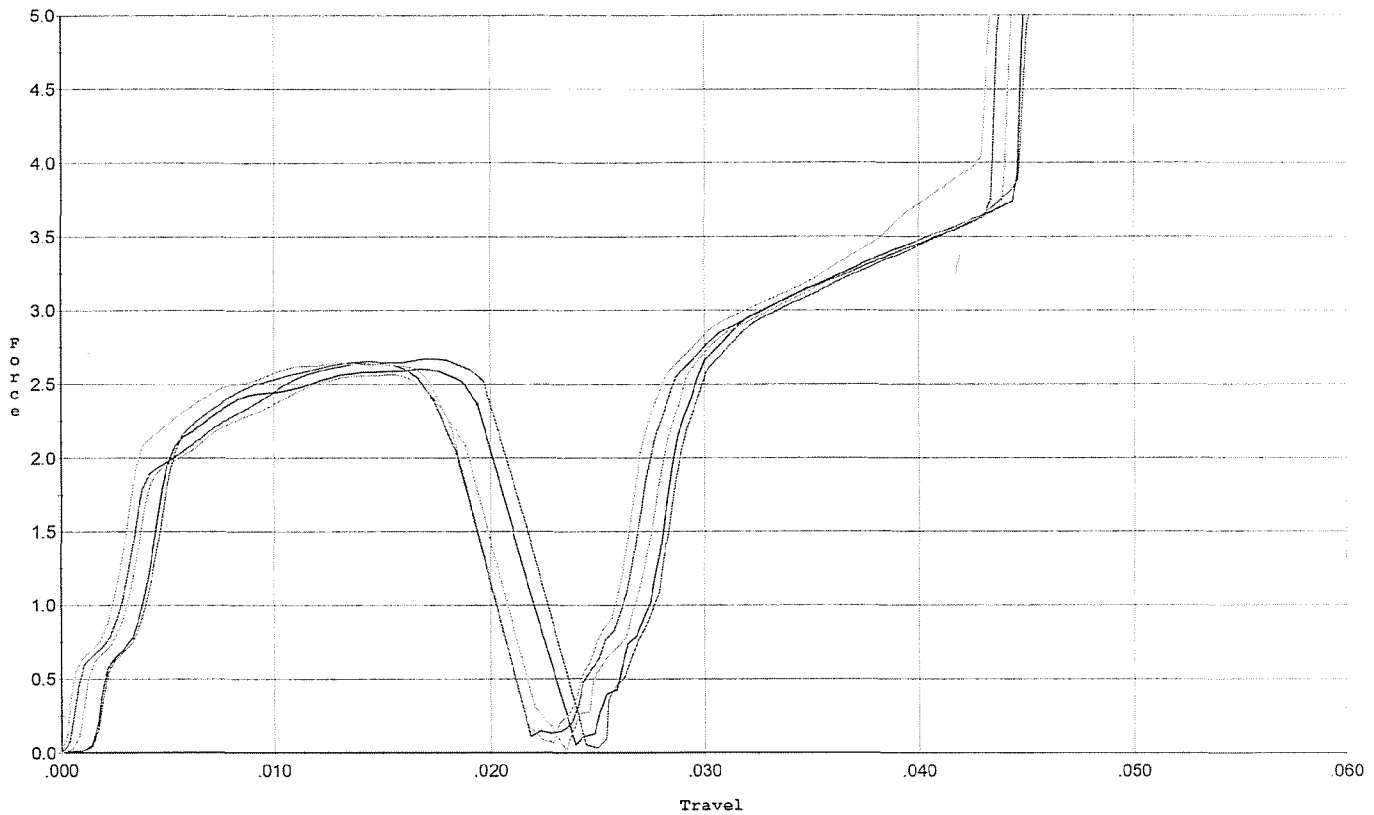
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	6-18-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	6-18-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	6-18-09	LJ
	J) ASSEMBLE STOCK		6-2-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		6-18-09	R.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	PASS FAIL PASS FAIL	6/16/09	R.B.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-18-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.77</u> <u>2.88</u> <u>2.87</u> <u>2.90</u>	6-18-09	LJ
	C) FUNCTION		6-18-09	R.N.
690	PACK		7/24/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



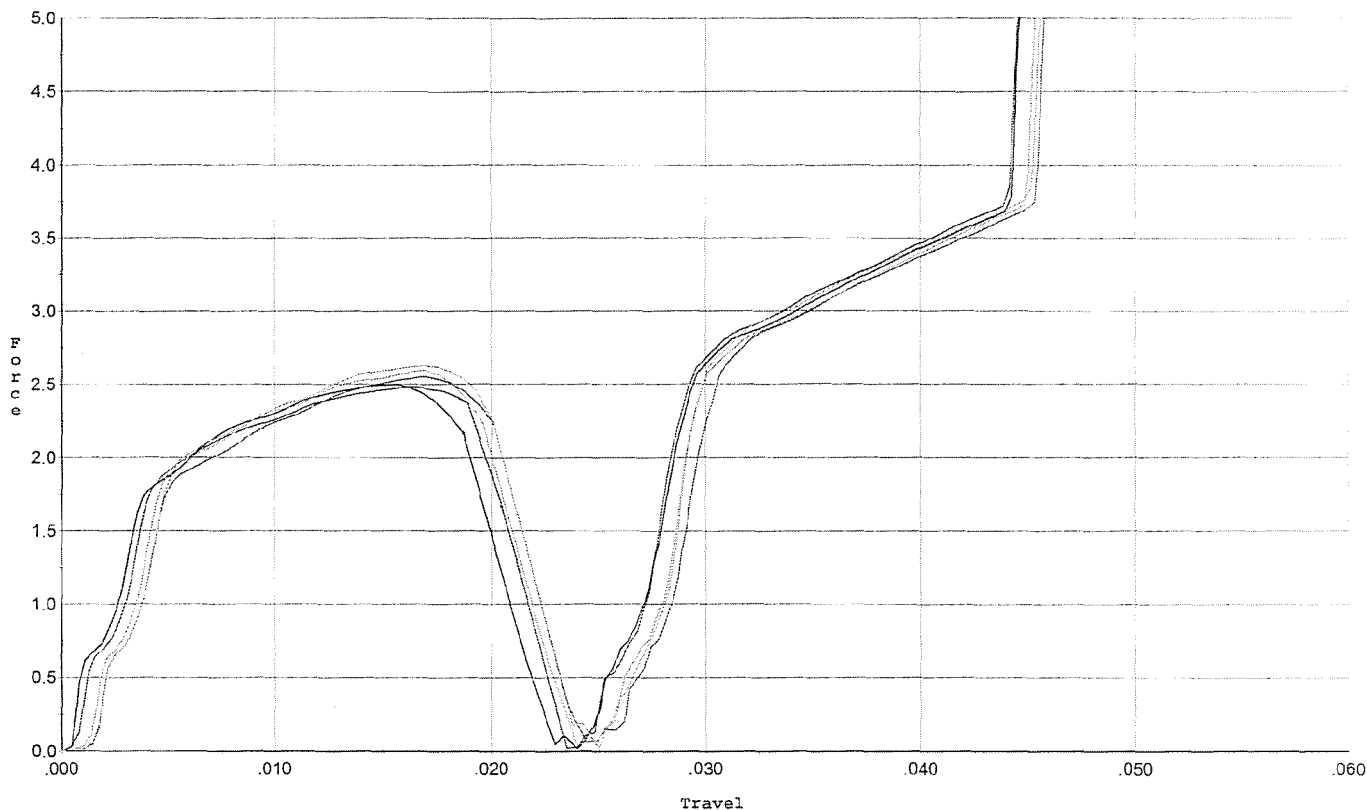
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.640	0.018	0.00	0.028	0.035		Set Trigger
2	2.601	0.019	0.00	0.029	0.037		Set Trigger
3	2.671	0.022	0.00	0.028	0.042		Set Trigger
4	2.645	0.018	0.00	0.028	0.037		Set Trigger
5	2.561	0.019	0.00	0.029	0.035		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



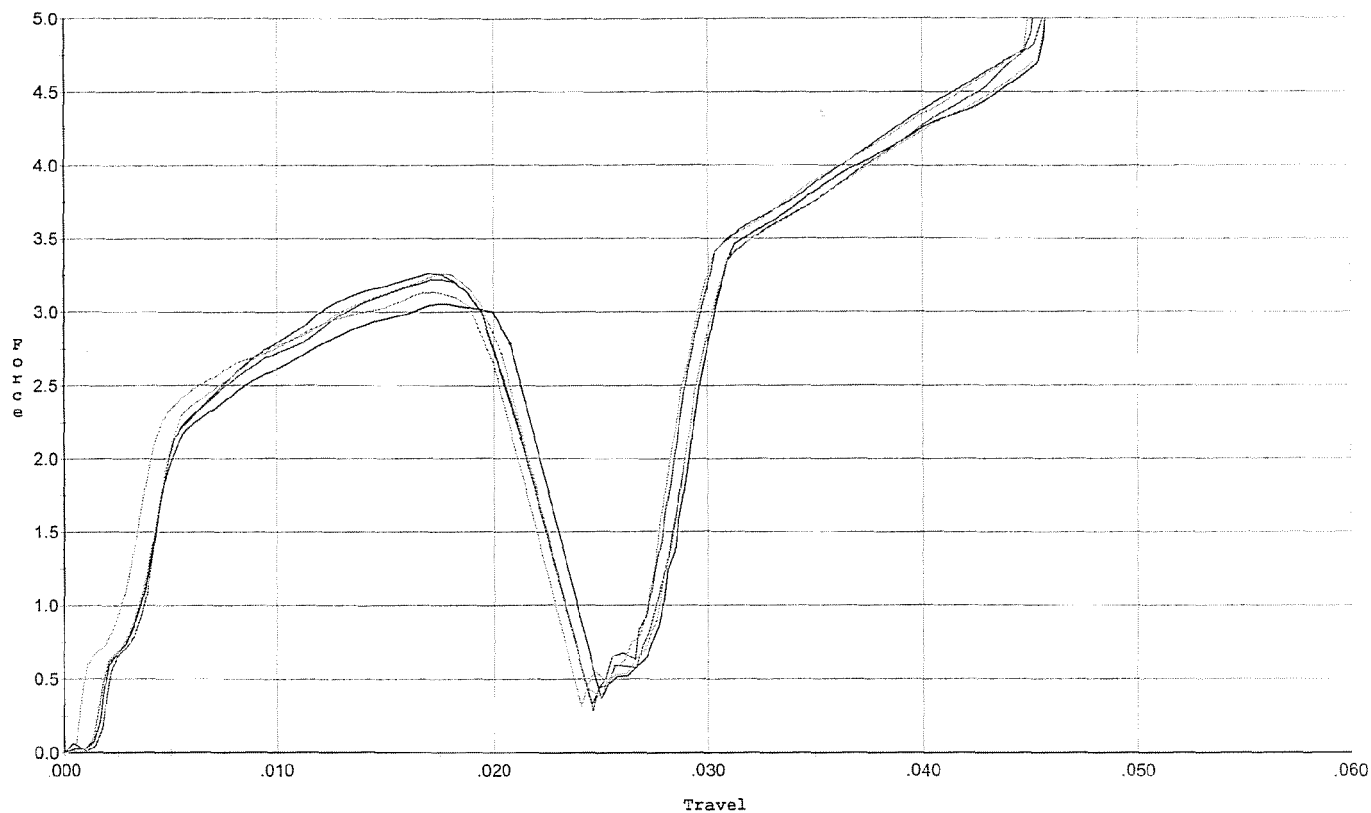
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.484	0.020	0.00	0.028	0.038		Set Trigger
2	2.496	0.019	0.00	0.029	0.035		Set Trigger
3	2.549	0.020	0.00	0.029	0.036		Set Trigger
4	2.592	0.020	0.00	0.029	0.036		Set Trigger
5	2.628	0.020	0.00	0.029	0.037		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



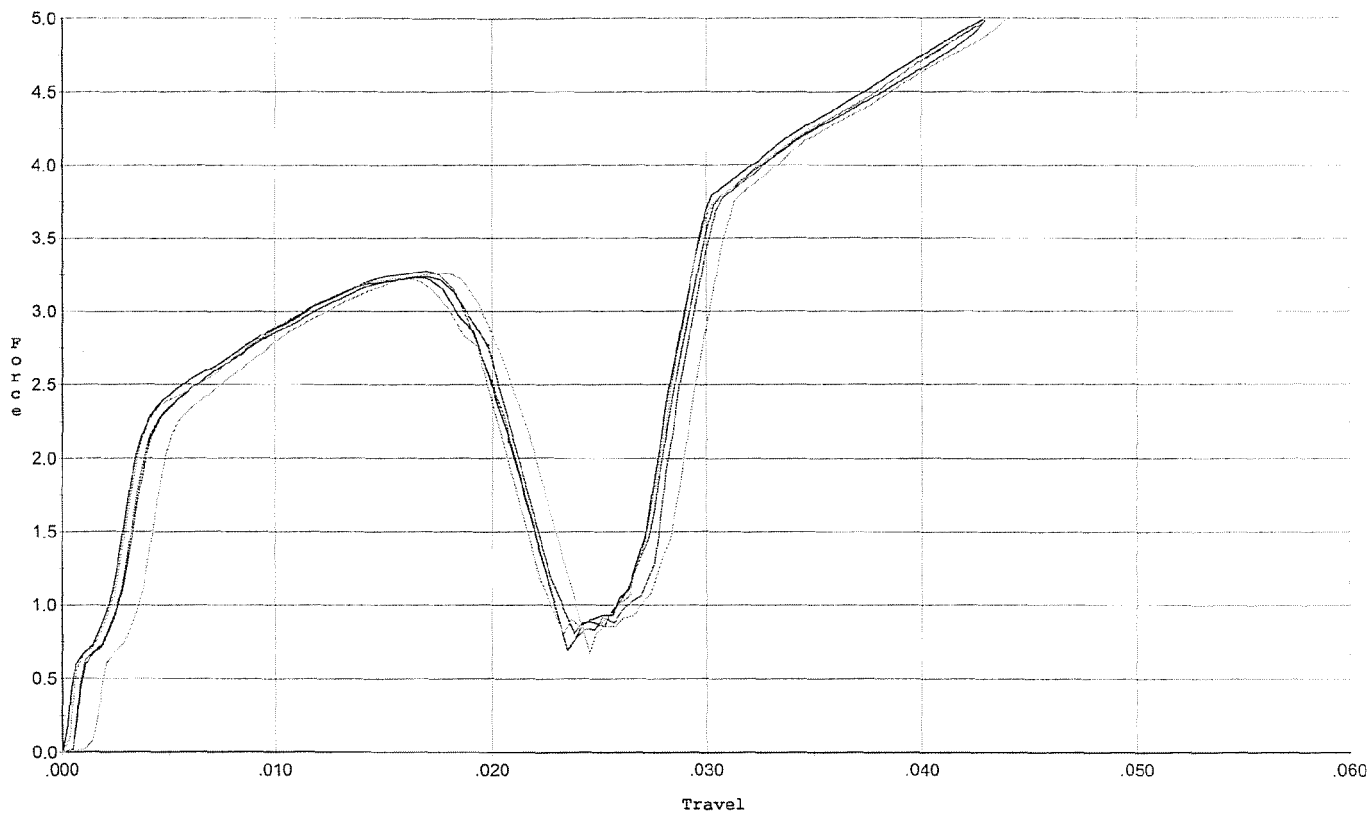
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.261	0.021	0.00	0.028	0.047		Set Trigger
2	3.053	0.021	0.00	0.028	0.044		Set Trigger
3	3.219	0.021	0.00	0.029	0.046		Set Trigger
4	3.258	0.020	0.00	0.029	0.045		Set Trigger
5	3.134	0.020	0.00	0.028	0.045		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



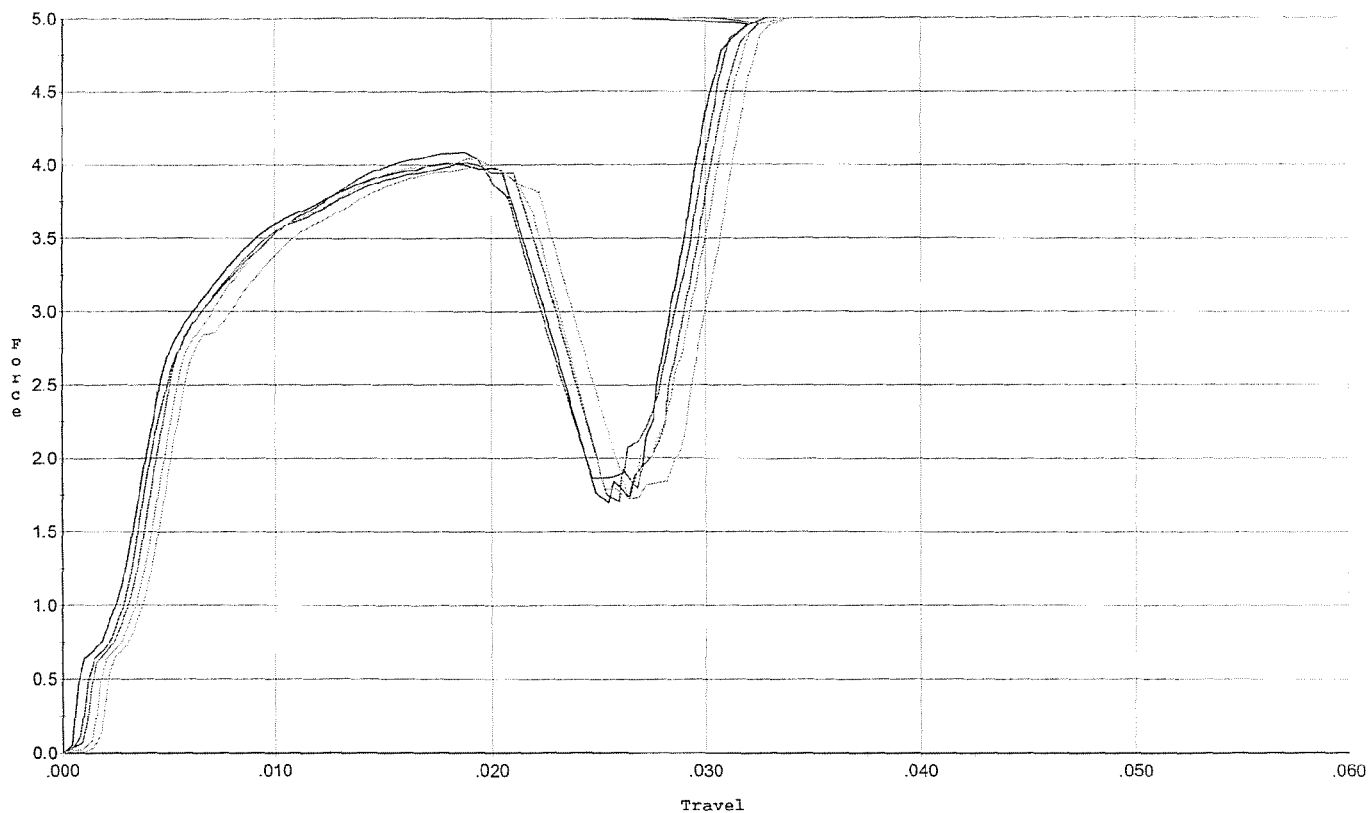
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.238	0.020	0.00	0.028	0.046		Set Trigger
2	3.232	0.021	0.00	0.027	0.049		Set Trigger
3	3.272	0.021	0.00	0.028	0.048		Set Trigger
4	3.261	0.022	0.00	0.028	0.048		Set Trigger
5	3.225	0.019	0.00	0.028	0.045		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



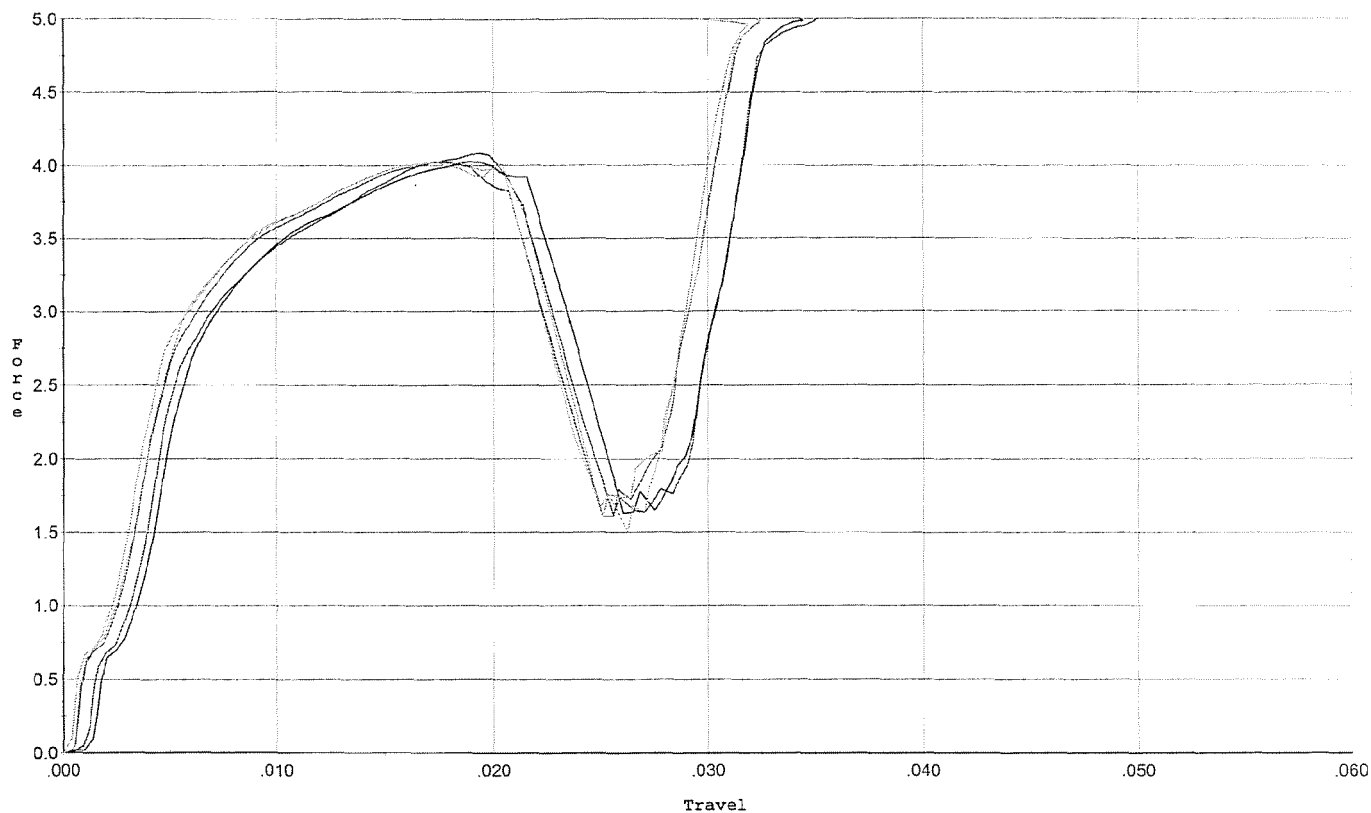
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.021	0.00	0.025	0.058		Set Trigger
2	4.013	0.022	0.00	0.022	0.064		Set Trigger
3	4.012	0.023	0.00	0.021	0.064		Set Trigger
4	4.039	0.022	0.00	0.020	0.061		Set Trigger
5	3.999	0.022	0.00	0.021	0.060		Set Trigger

A. 4.03

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



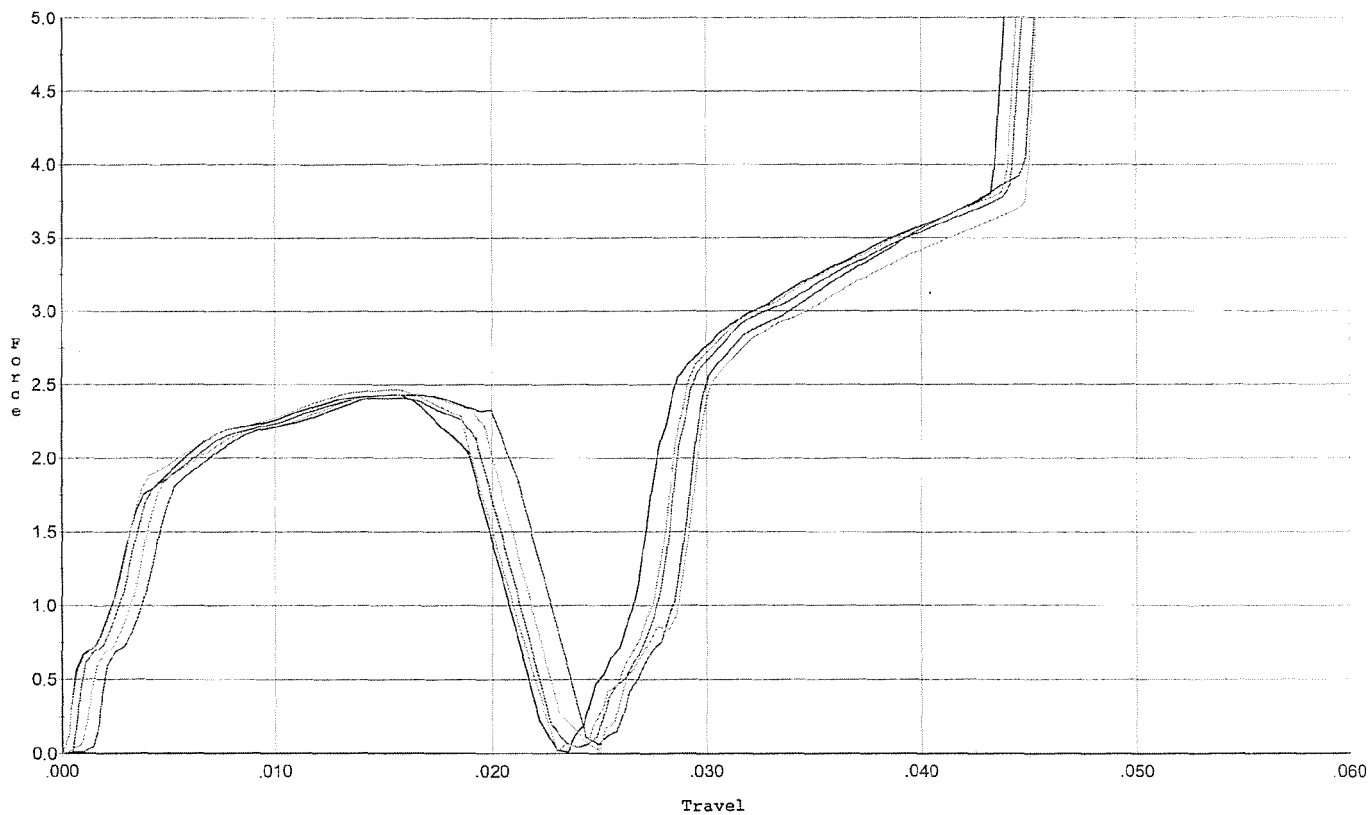
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.021	0.00	0.026	0.059		Set Trigger
2	4.024	0.024	0.00	0.022	0.065		Set Trigger
3	4.019	0.021	0.00	0.021	0.059		Set Trigger
4	4.018	0.021	0.00	0.020	0.059		Set Trigger
5	4.028	0.021	0.00	0.020	0.062		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



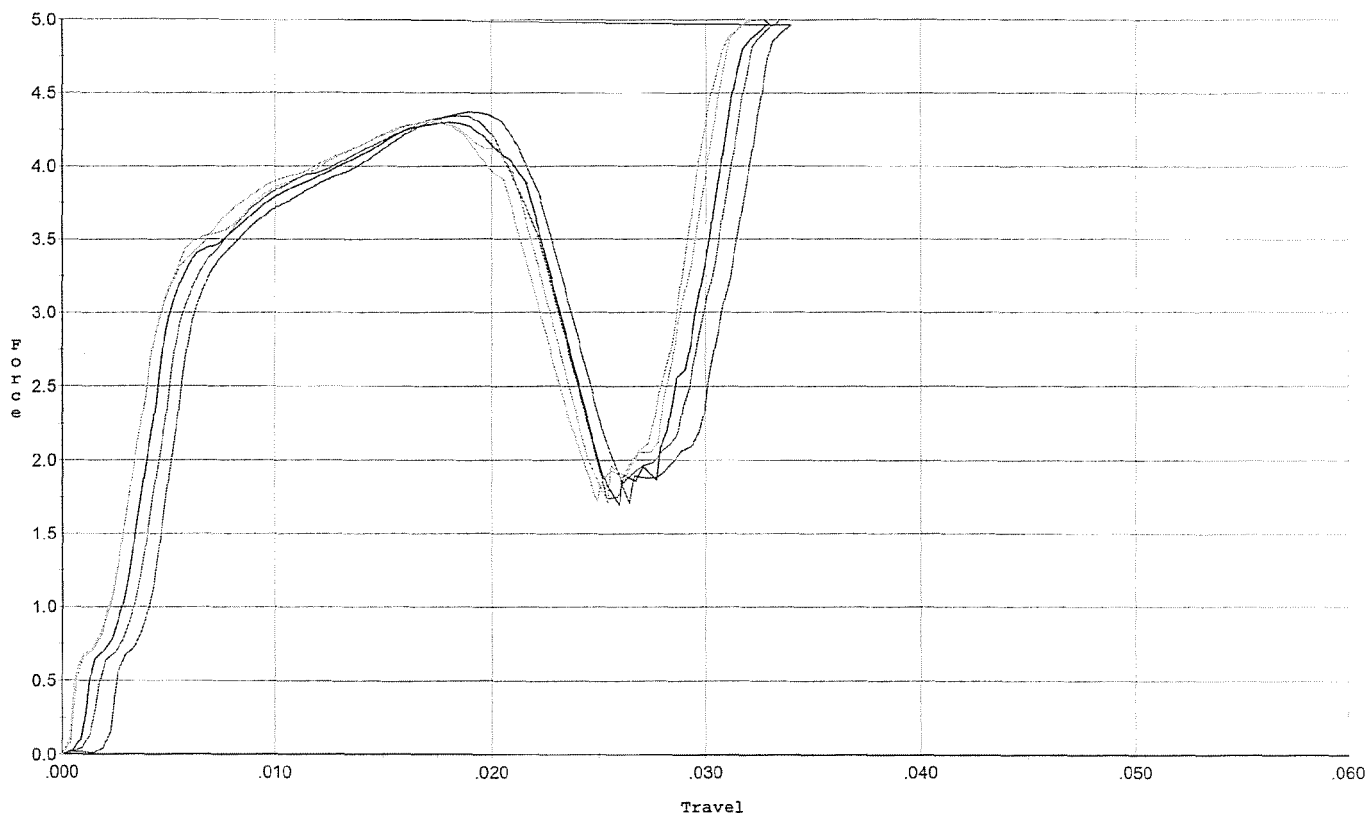
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.430	0.021	0.00	0.029	0.038		Set Trigger
2	2.429	0.019	0.00	0.028	0.035		Set Trigger
3	2.409	0.019	0.00	0.029	0.035		Set Trigger
4	2.439	0.020	0.00	0.029	0.035		Set Trigger
5	2.463	0.019	0.00	0.029	0.035		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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	4.372	0.022	0.002	0.015	0.064		Set Trigger
2	4.301	0.022	0.00	0.015	0.065		Set Trigger
3	4.347	0.022	0.00	0.015	0.065		Set Trigger
4	4.300	0.021	0.00	0.015	0.063		Set Trigger
5	4.308	0.021	0.00	0.014	0.065		Set Trigger

A-4.32