

6681 0343

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

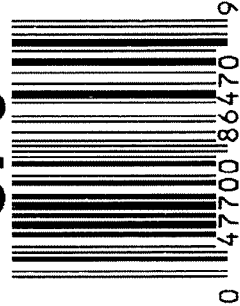
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6810343

UPC



GUN SERIAL #

G 6810343

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-5-09	SP
430	ASSEMBLE TO STOCK		2-5-09	SP
440	PROOF		2-5-09	SP
460	CHECK HEADSPACE		2-5-09	SP
470	DIS-ASSEMBLE ACTION		2-5-09	SP
472	SERIALIZE BOLT HANDLE		2-6-09	RT
475	DRILL AND TAP SIGHT HOLES		2-6-09	TC
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/7/09	AD
490	MAGNAFLUX BOLT		2/7/09	MR
500	ROLLMARK CALIBER		2/9/09	RT
520	GOFF BLAST BBL / REC		9-Feb-09	SP
542	APPLY COATINGS (BARREL ACTION)		2-12	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

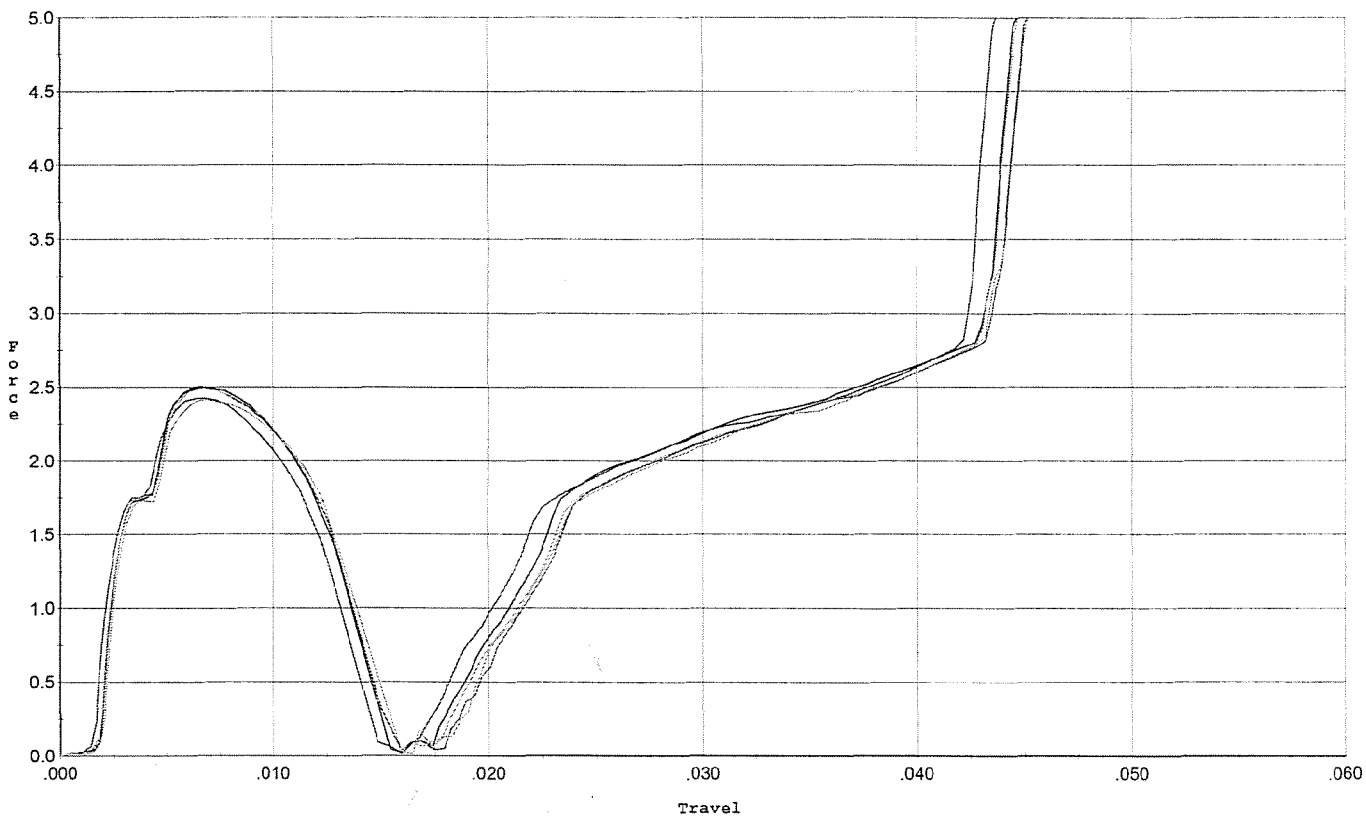
OP # OPERATION NAME		READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	2-18-09	LJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u>	<u>6.0</u>	<u>6.0</u>	2-18-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>.034</u>	<u>.034</u>	<u>.034</u>	2-18-09	LJ
	J) ASSEMBLE STOCK				2-13-09	LJ
	K) ASSEMBLE SWIVEL STUDS				2-18-09	LJ
	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		2-14-09	TL
		<u>PASS</u>	FAIL			
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
660	INSPECT FOR LIVE AMMO				2-14-09	LJ
670	FINAL INSPECTION A) HEADSPACE				2-18-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u>	<u>2.52</u>	<u>2.48</u> <u>2.62</u> <u>2.64</u>	2-16-09	WW
	C) FUNCTION				2-18-09	LJ
690	PACK				2/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



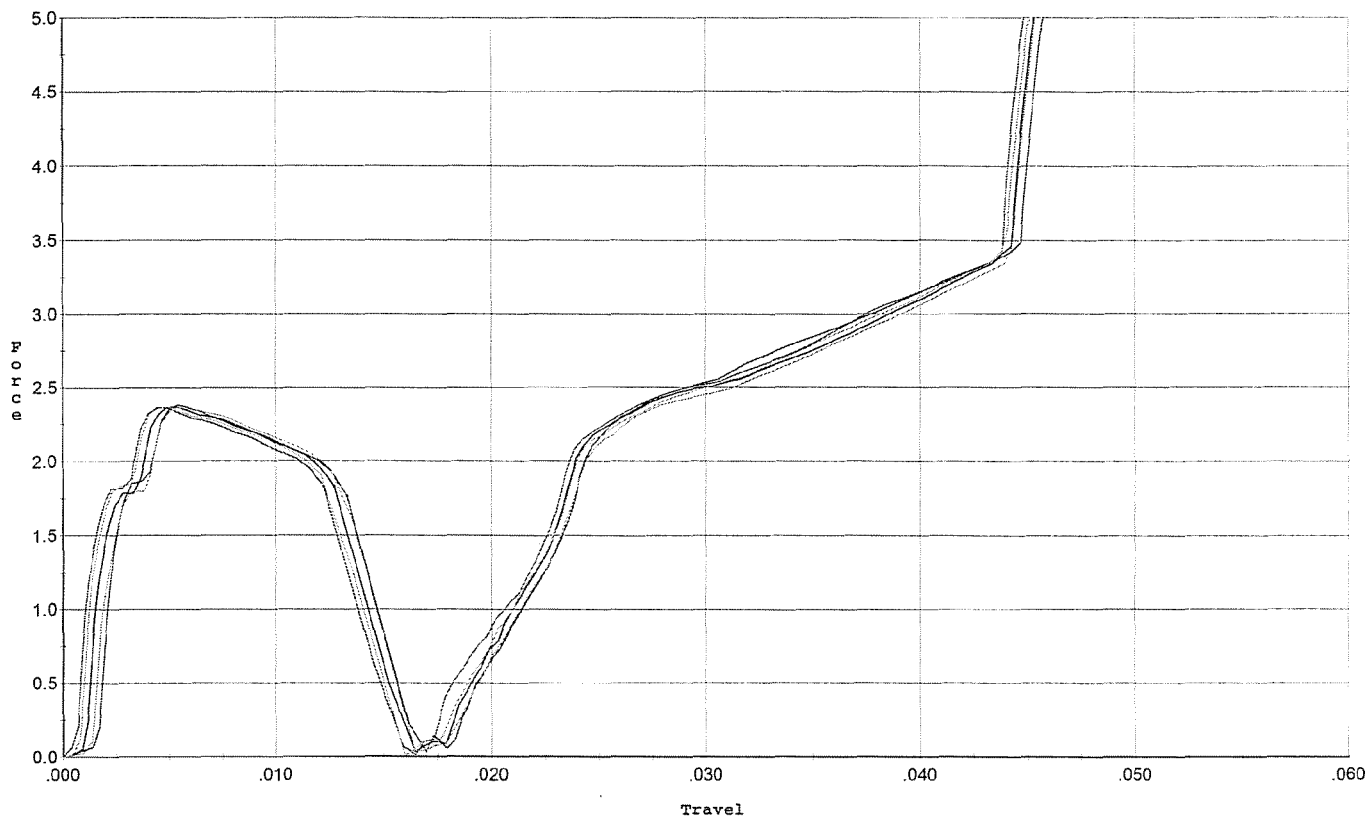
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.429	0.012	0.00	0.035	0.020		Set Trigger
2	2.496	0.013	0.00	0.036	0.021		Set Trigger
3	2.499	0.013	0.002	0.036	0.020		Set Trigger
4	2.493	0.012	0.00	0.036	0.020		Set Trigger
5	2.418	0.012	0.00	0.036	0.019		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



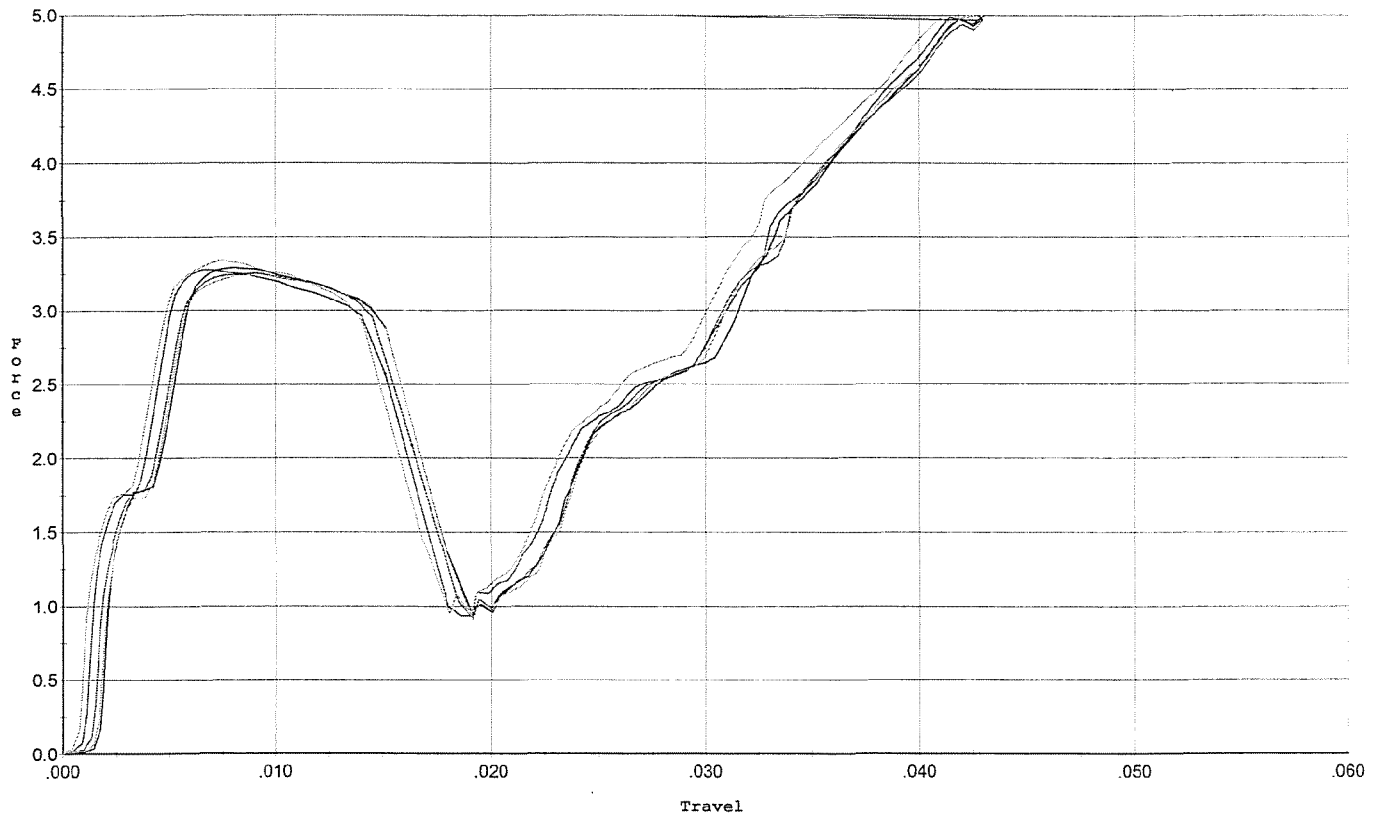
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.381	0.013	0.00	0.035	0.022		Set Trigger
2	2.366	0.013	0.00	0.036	0.022		Set Trigger
3	2.366	0.012	0.00	0.036	0.022		Set Trigger
4	2.368	0.014	0.00	0.035	0.024		Set Trigger
5	2.364	0.014	0.00	0.035	0.023		Set Trigger

A-2-36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



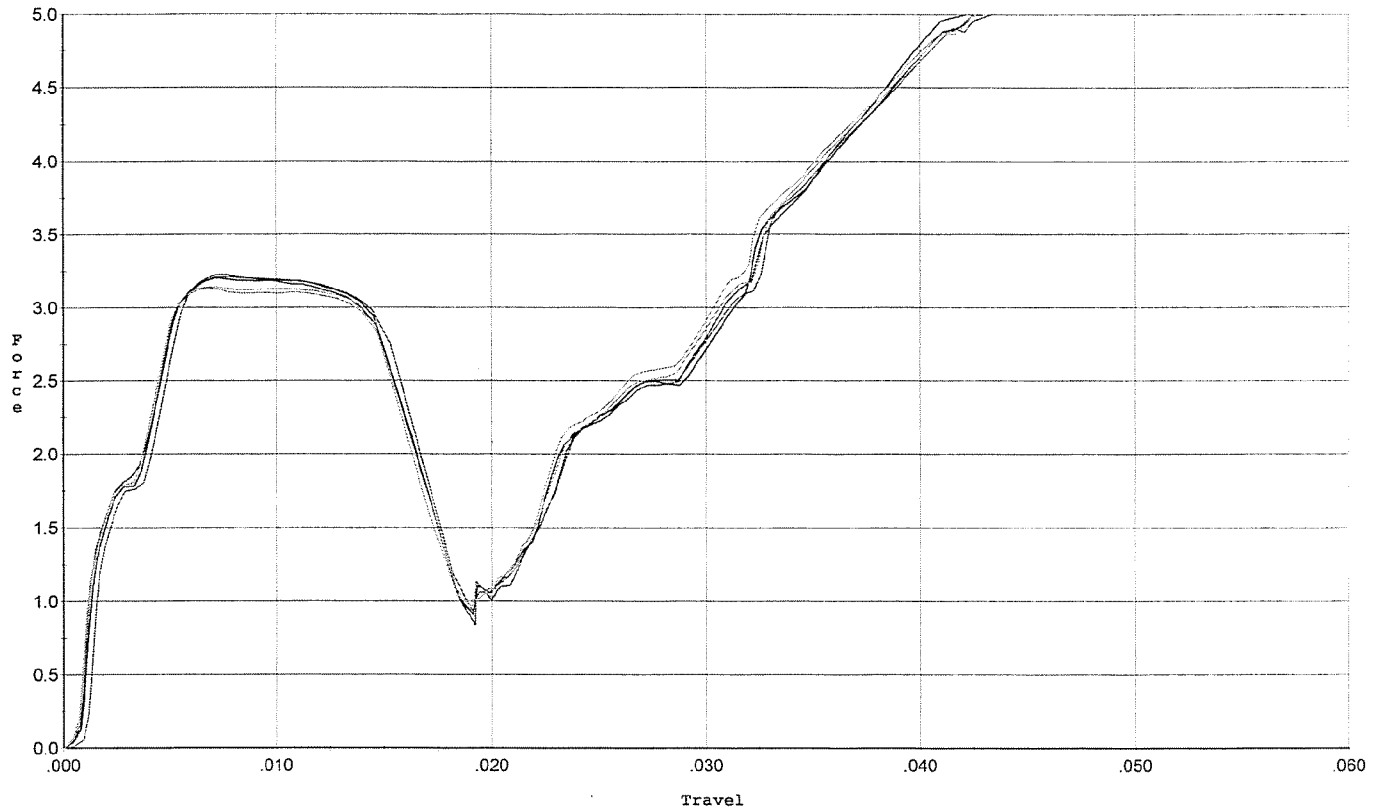
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.015	0.00	0.032	0.035		Set Trigger
2	3.291	0.015	0.00	0.032	0.034		Set Trigger
3	3.256	0.016	0.00	0.032	0.037		Set Trigger
4	3.251	0.015	0.00	0.032	0.034		Set Trigger
5	3.341	0.014	0.00	0.032	0.034		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/12/2009

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



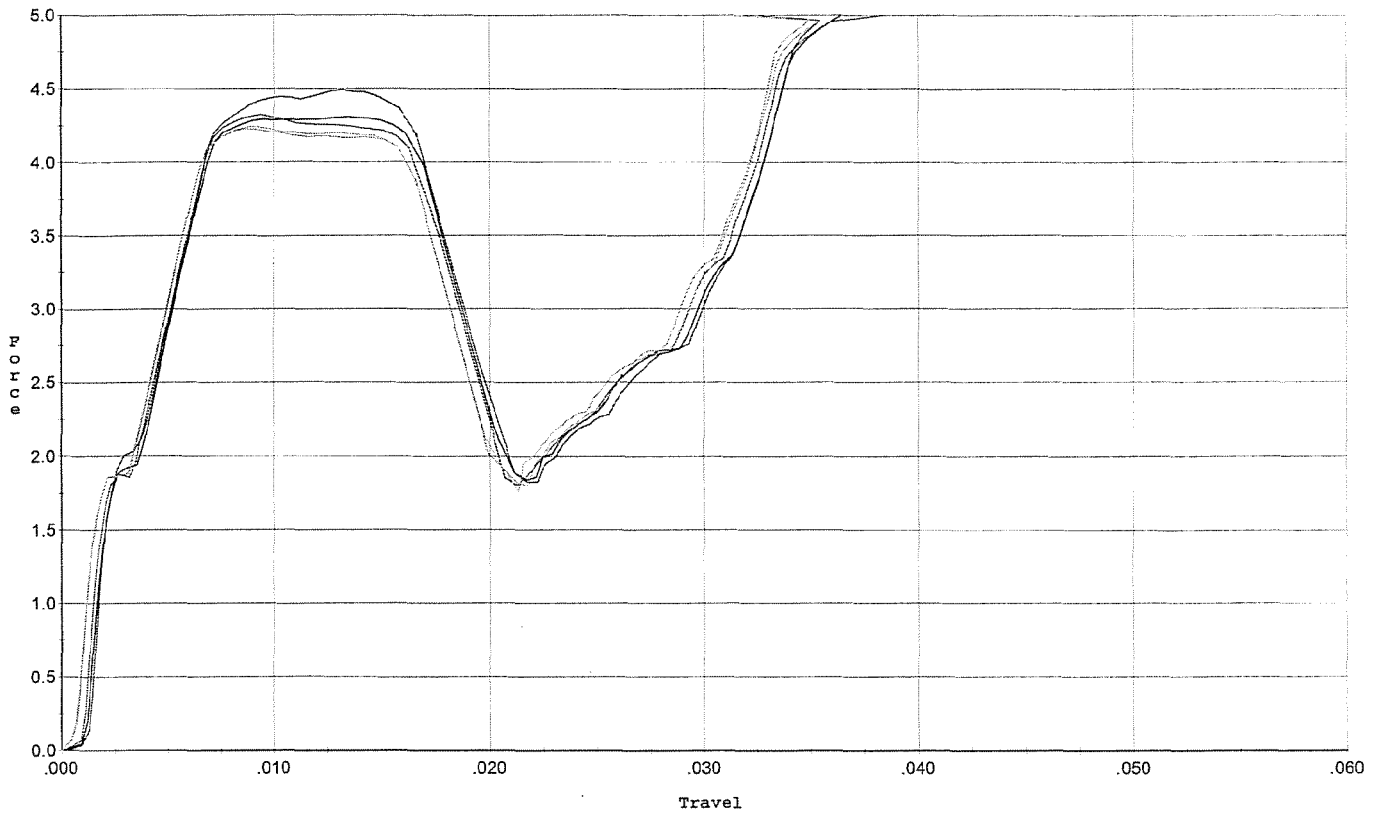
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.016	0.00	0.032	0.039		Set Trigger
2	3.202	0.016	0.00	0.031	0.038		Set Trigger
3	3.209	0.015	0.00	0.032	0.035		Set Trigger
4	3.138	0.015	0.00	0.032	0.034		Set Trigger
5	3.132	0.015	0.00	0.032	0.034		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/12/2009

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



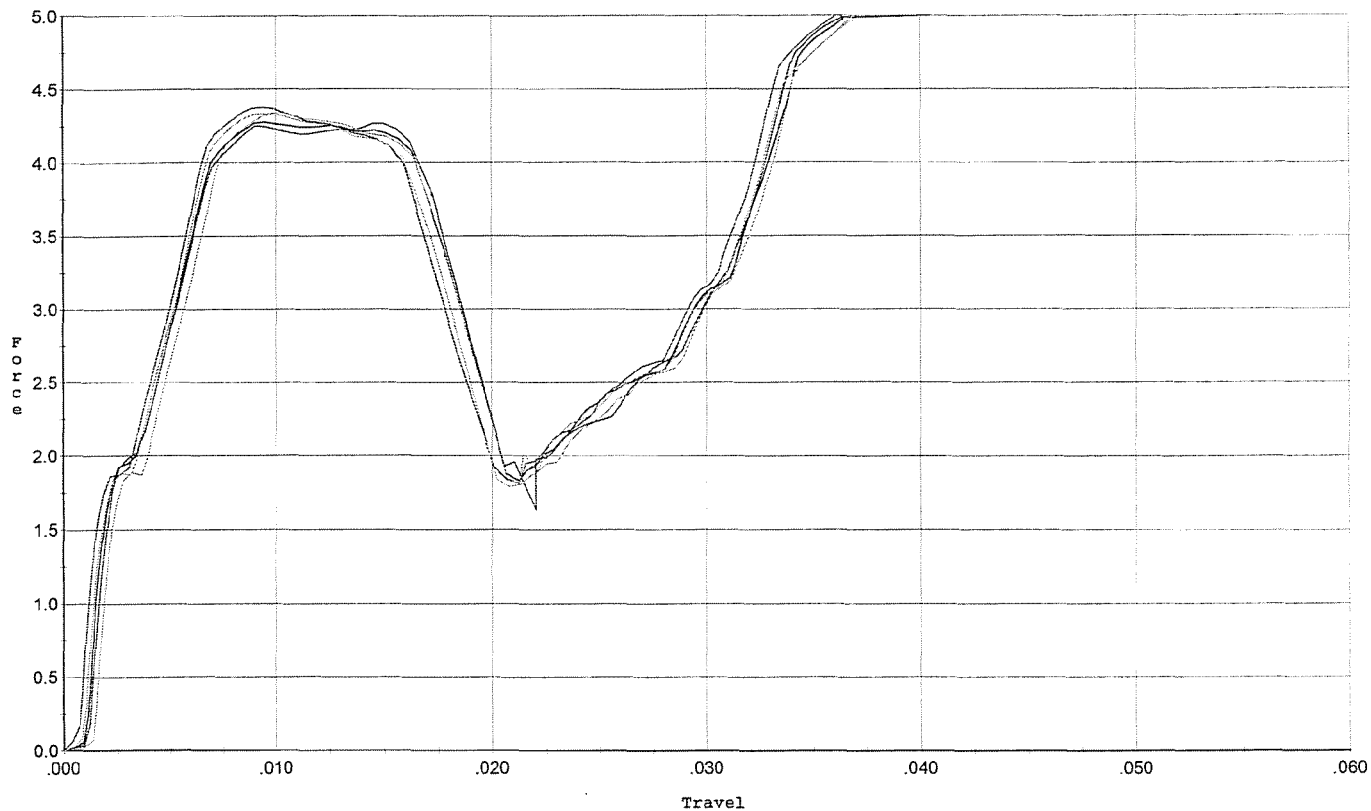
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.491	0.017	0.00	0.028	0.051		Set Trigger
2	4.306	0.017	0.00	0.028	0.051		Set Trigger
3	4.323	0.018	0.00	0.028	0.053		Set Trigger
4	4.242	0.017	0.00	0.028	0.050		Set Trigger
5	4.224	0.017	0.00	0.028	0.050		Set Trigger

A-4.31

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/12/2009

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



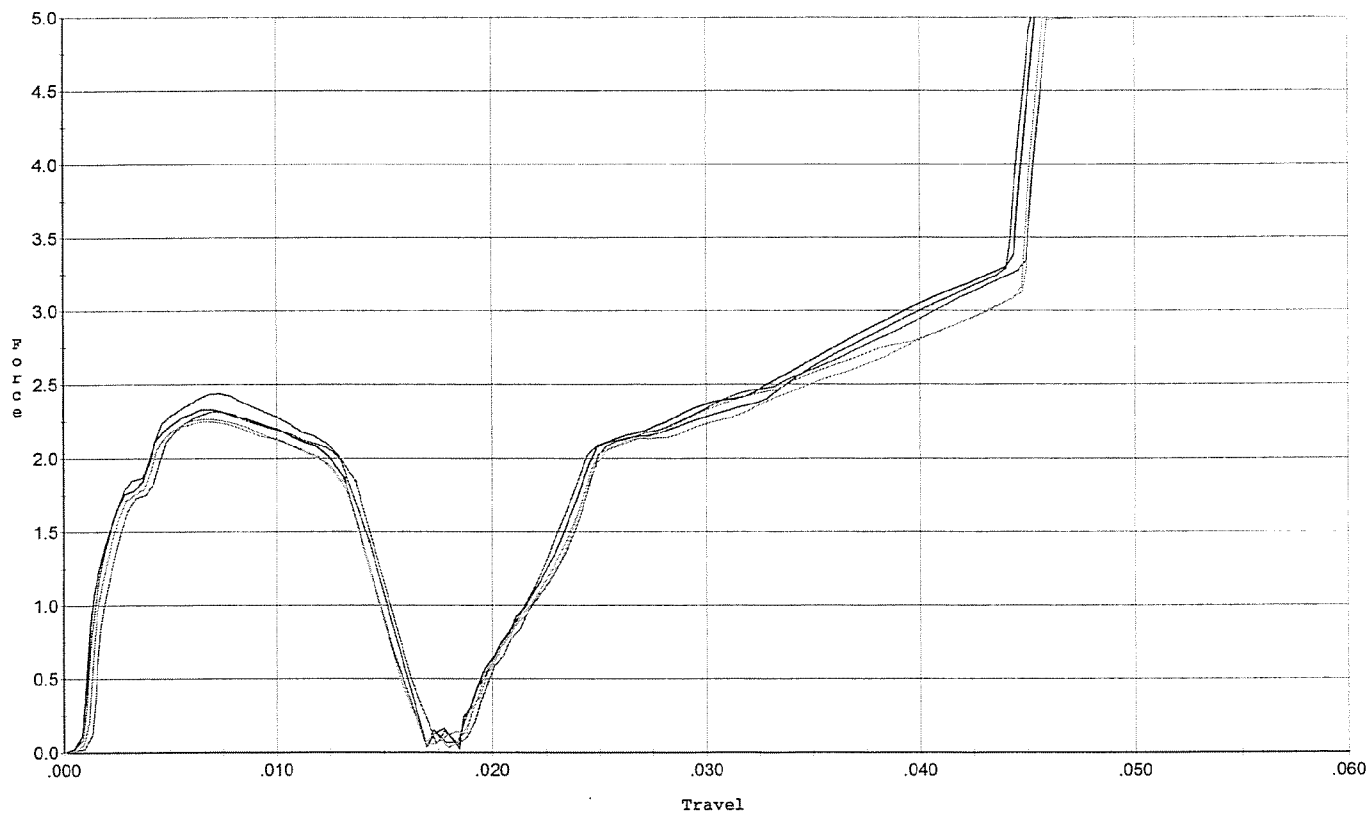
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.264	0.017	0.00	0.029	0.052		Set Trigger
2	4.276	0.018	0.00	0.029	0.054		Set Trigger
3	4.374	0.016	0.00	0.029	0.048		Set Trigger
4	4.332	0.017	0.00	0.029	0.051		Set Trigger
5	4.336	0.018	0.00	0.029	0.052		Set Trigger

A-4-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



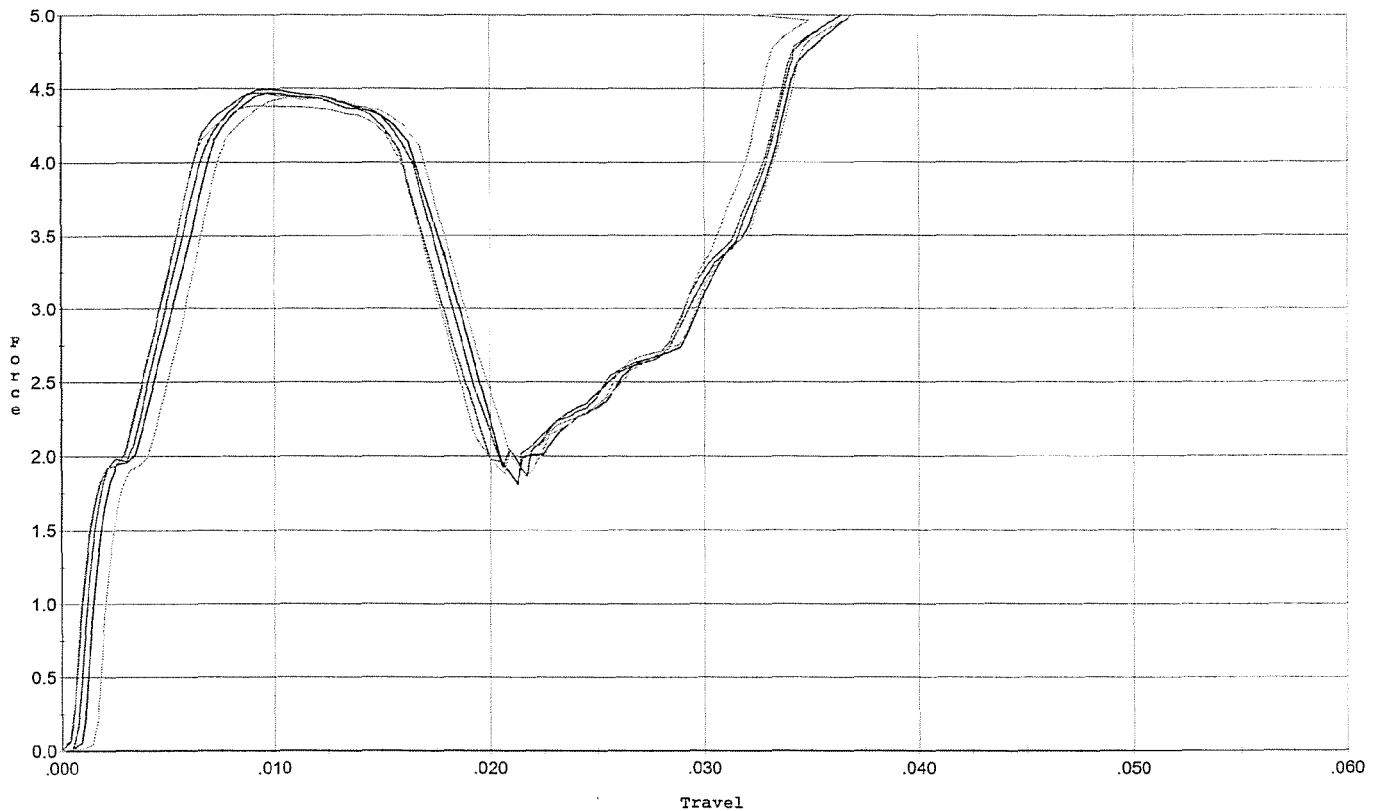
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.438	0.014	0.00	0.035	0.025		Set Trigger
2	2.330	0.013	0.00	0.035	0.023		Set Trigger
3	2.315	0.014	0.00	0.036	0.023		Set Trigger
4	2.247	0.013	0.00	0.036	0.022		Set Trigger
5	2.263	0.013	0.00	0.036	0.022		Set Trigger

17-2-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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	4.494	0.016	0.00	0.029	0.051		Set Trigger
2	4.471	0.018	0.00	0.030	0.055		Set Trigger
3	4.472	0.016	0.00	0.030	0.050		Set Trigger
4	4.436	0.017	0.00	0.029	0.050		Set Trigger
5	4.385	0.016	0.00	0.029	0.050		Set Trigger

A. 4.45