

66801389

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

**BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD**

proof of purchase



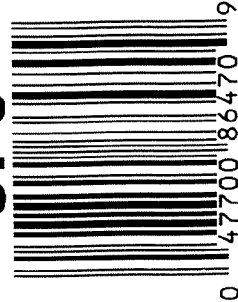
owner registration sticker



ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6801389

UPC



BM FORM

GUN SERIAL # G 680 1389

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	SPD
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	SPD
460	CHECK HEADSPACE		10-14-08	SPD
470	DIS-ASSEMBLE ACTION		10-14-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	10-15-08	RTZ
475	DRILL AND TAP SIGHT HOLES	1 JOB	10-15-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/17/08	
490	MAGNAFLUX BOLT		10/17/08	RTZ
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DG
542	APPLY COATINGS (BARREL ACTION)		10/22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-23-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-23-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-23-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-15-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

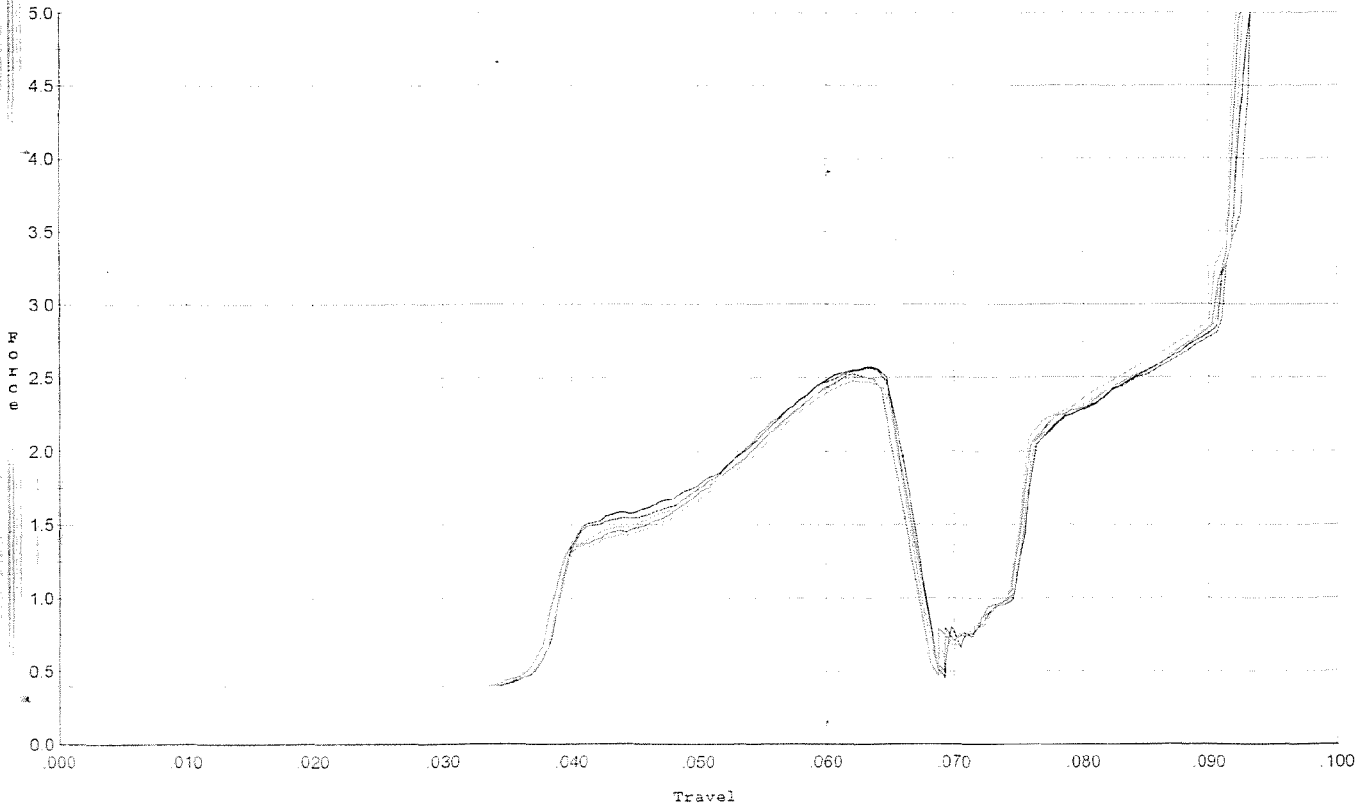
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>49</u> <u>40</u>	1-28-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	1-28-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	1-28-09	LN
	J) ASSEMBLE STOCK		1-15-09	LN
	K) ASSEMBLE SWIVEL STUDS		1-28-09	LN
	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	1-26-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-26-09	WV
670	FINAL INSPECTION A) HEADSPACE		1-28-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>264</u> <u>238</u> <u>247</u> <u>238</u> <u>264</u>	1-28-09	LN
	C) FUNCTION		1-28-09	LN
690	PACK		1/30/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/15/2009

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



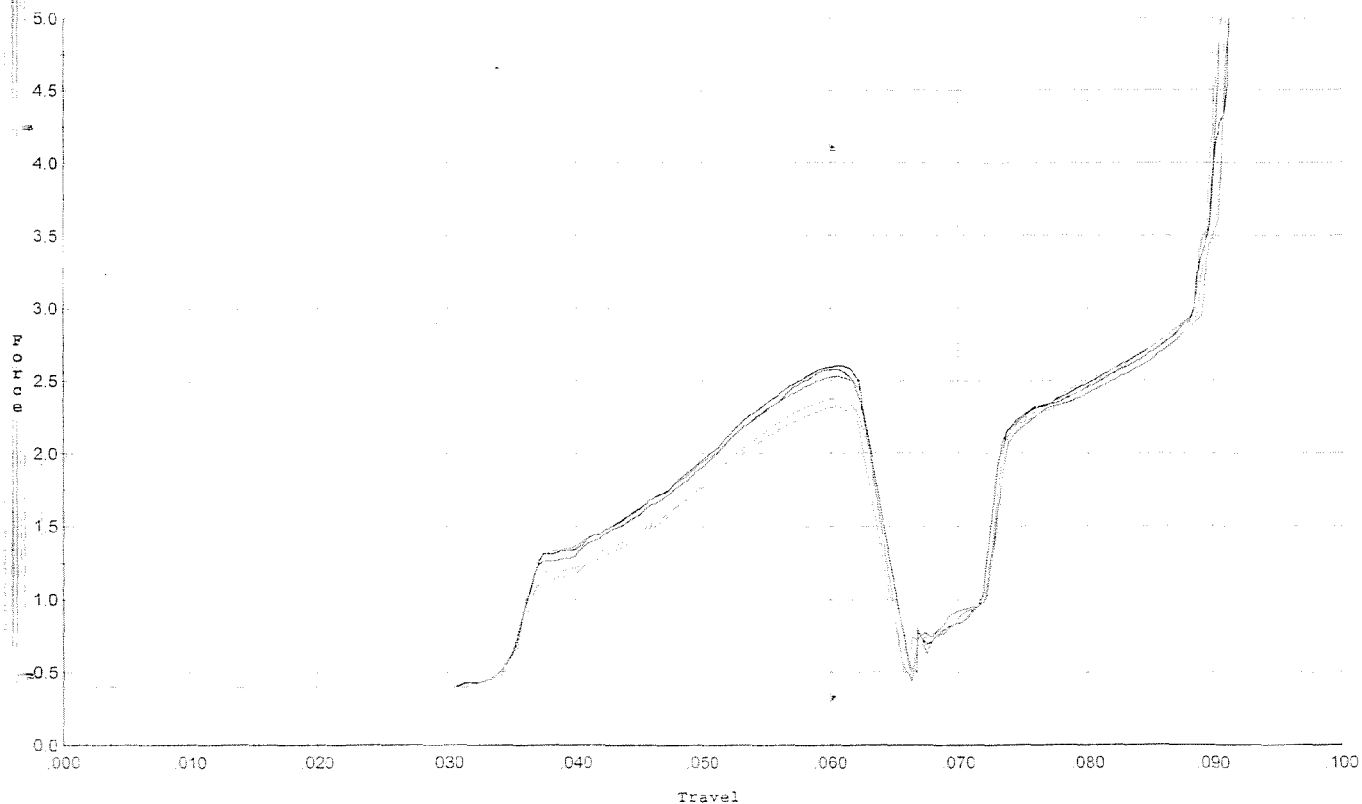
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.562	0.065	0.038	0.034	0.067		Set Trigger
2	2.572	0.066	0.038	0.034	0.070		Set Trigger
3	2.525	0.066	0.038	0.033	0.068		Set Trigger
4	2.478	0.065	0.038	0.034	0.066		Set Trigger
5	2.507	0.065	0.038	0.033	0.067		Set Trigger

A-2-S2

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/15/2009

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



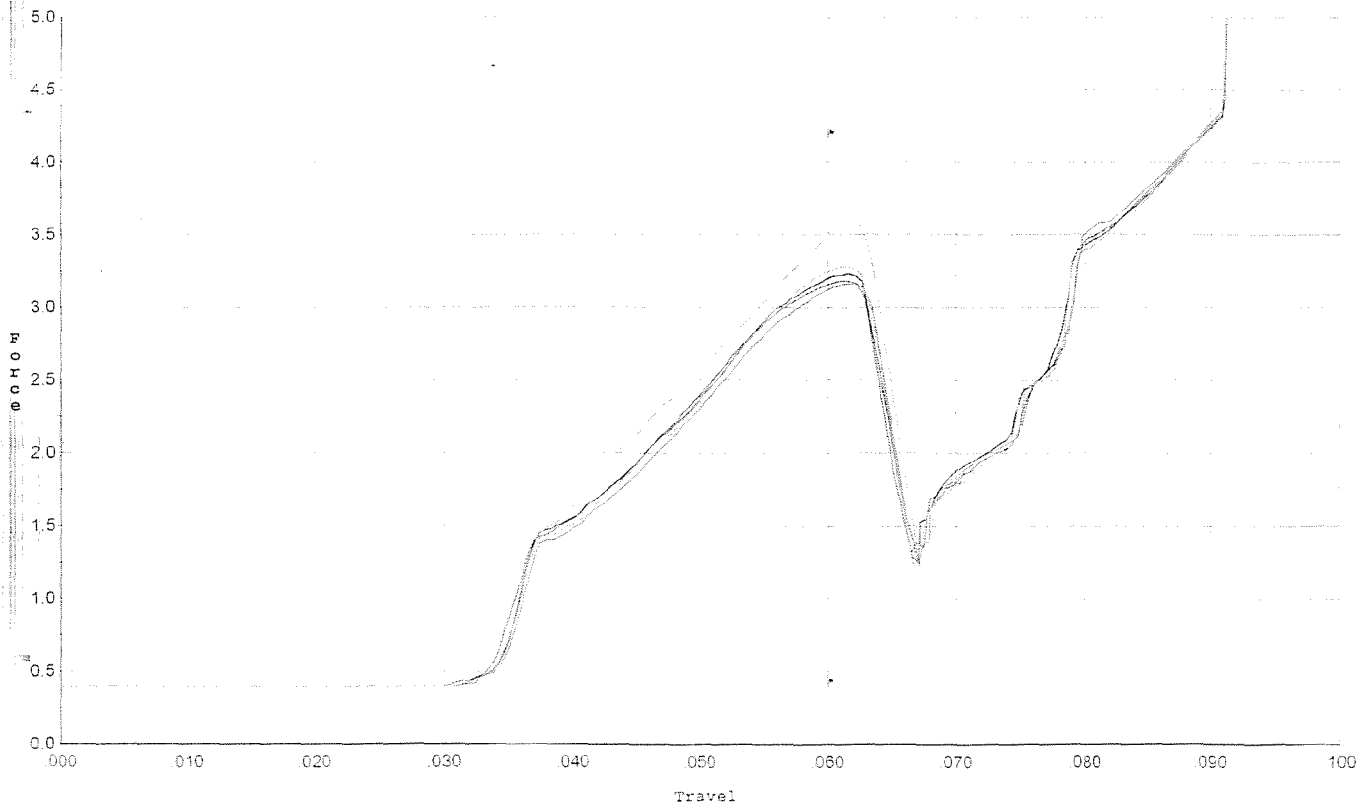
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.062	0.035	0.034	0.066		Set Trigger
2	2.602	0.062	0.035	0.034	0.066		Set Trigger
3	2.530	0.062	0.035	0.034	0.066		Set Trigger
4	2.322	0.064	0.035	0.034	0.062		Set Trigger
5	2.377	0.063	0.035	0.035	0.063		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



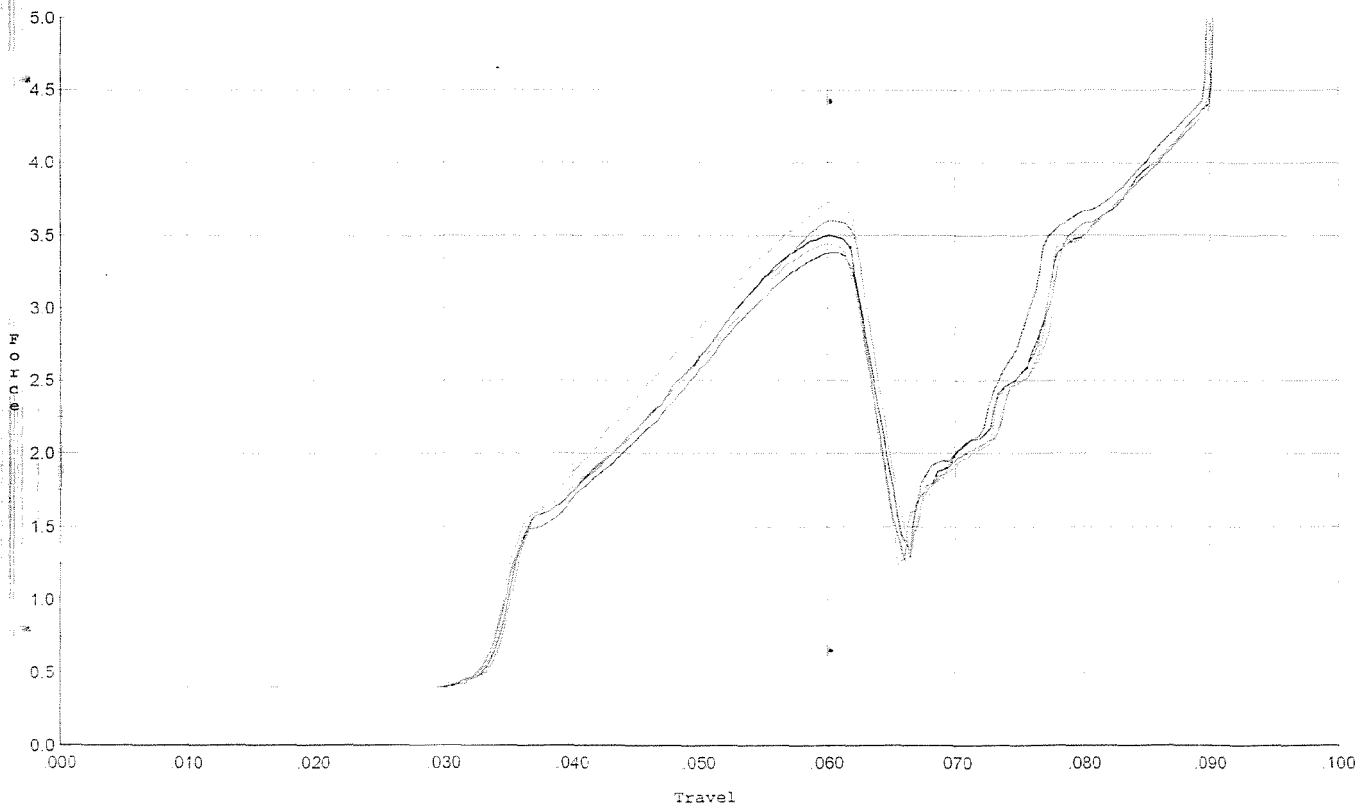
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.181	0.063	0.034	0.033	0.080		Set Trigger
2	3.233	0.064	0.035	0.032	0.083		Set Trigger
3	3.160	0.063	0.035	0.032	0.079		Set Trigger
4	3.278	0.064	0.035	0.032	0.081		Set Trigger
5	3.565	0.063	0.035	0.032	0.087		Set Trigger

A-3.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/15/2009

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



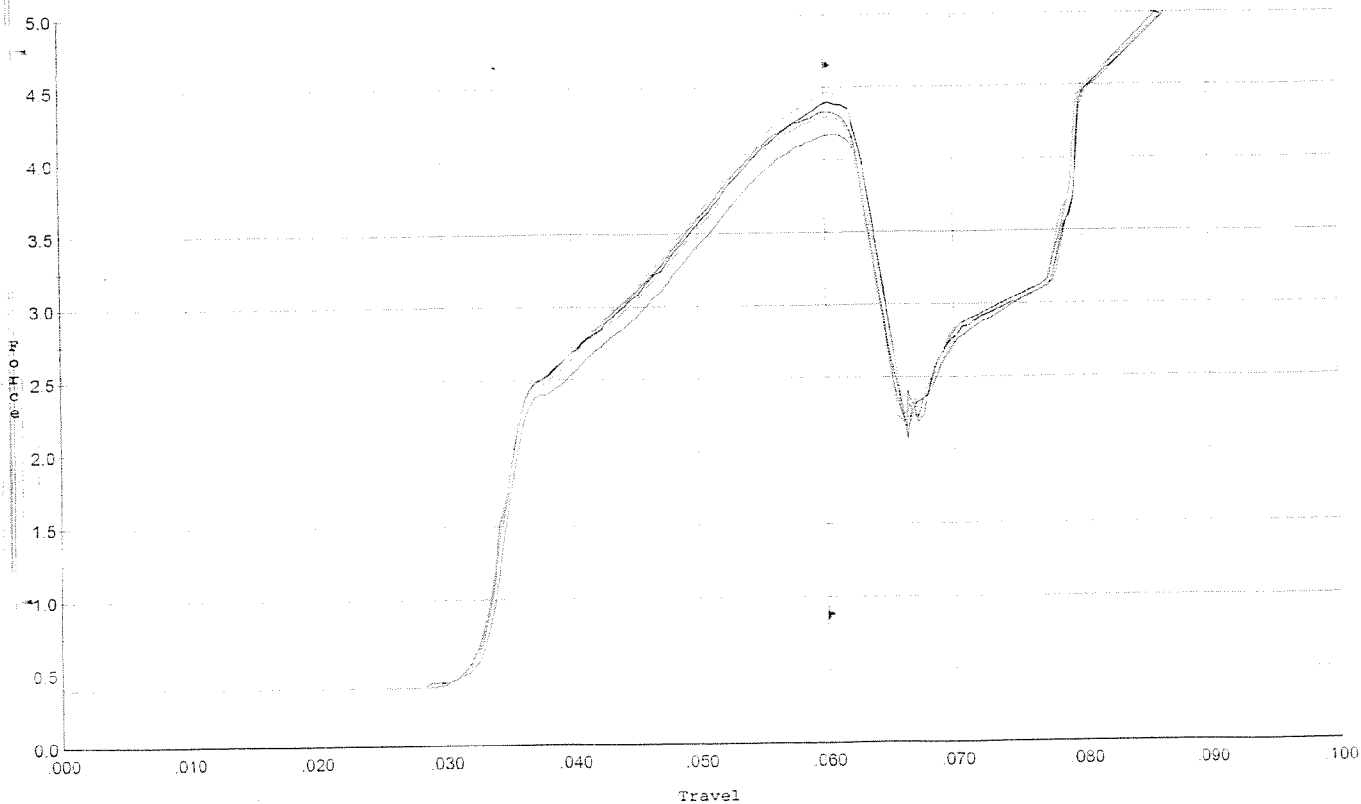
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.382	0.062	0.034	0.032	0.083		Set Trigger
2	3.502	0.062	0.034	0.032	0.084		Set Trigger
3	3.598	0.062	0.034	0.032	0.086		Set Trigger
4	3.442	0.062	0.034	0.032	0.085		Set Trigger
5	3.731	0.062	0.034	0.032	0.090		Set Trigger

A-3-S3

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



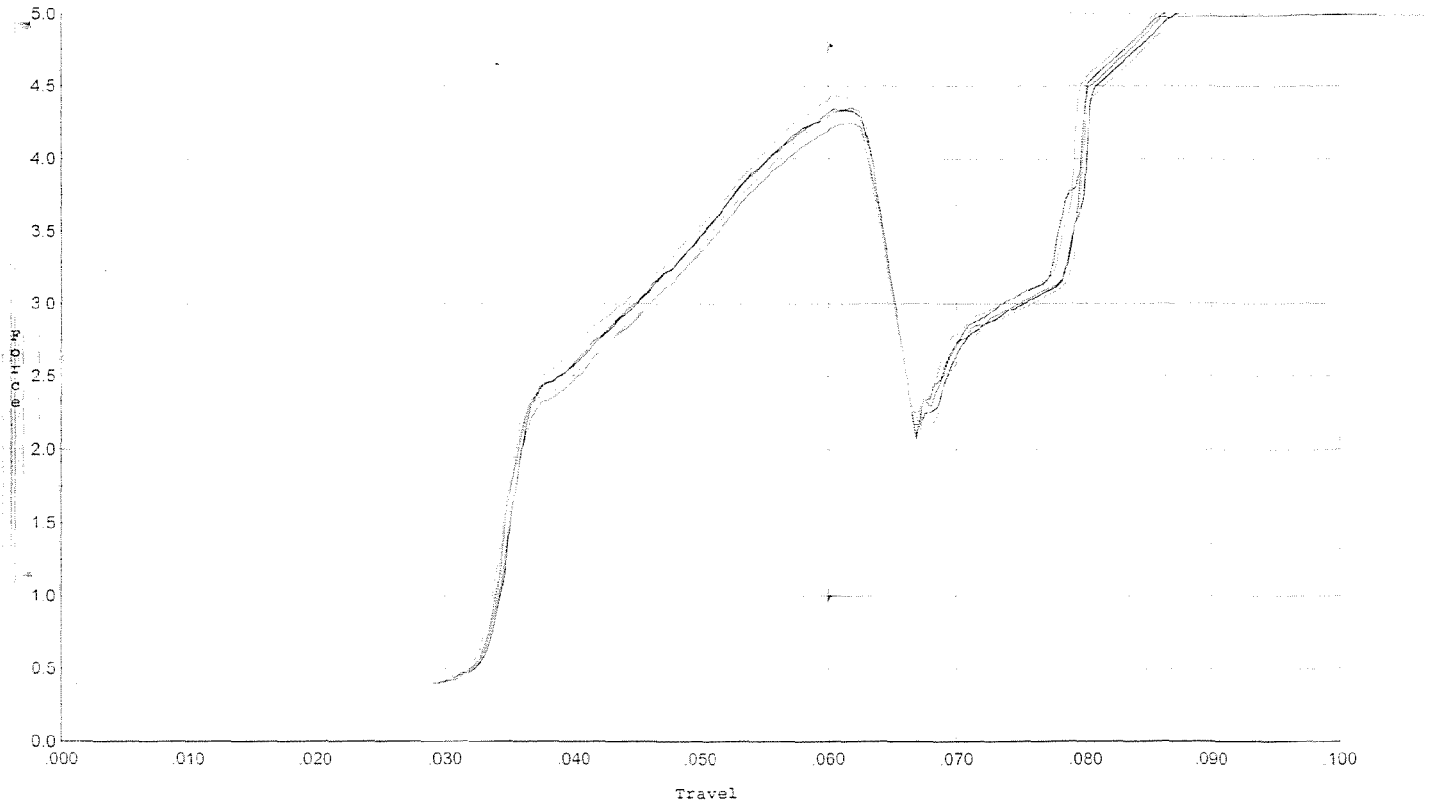
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.328	0.062	0.032	0.030	0.112		Set Trigger
2	4.396	0.063	0.033	0.030	0.114		Set Trigger
3	4.174	0.062	0.033	0.031	0.108		Set Trigger
4	4.465	0.064	0.033	0.030	0.117		Set Trigger
5	4.296	0.062	0.033	0.030	0.111		Set Trigger

A-4.33

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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



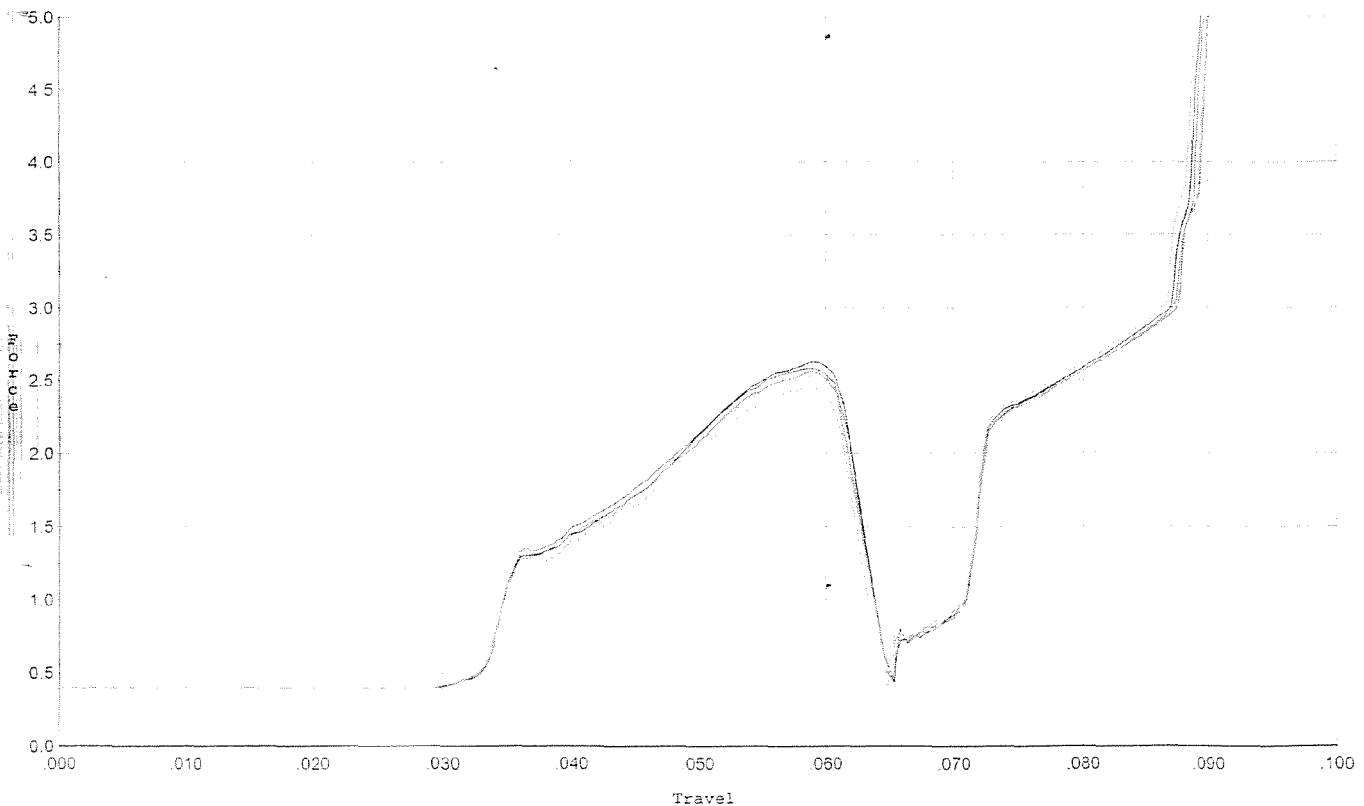
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.063	0.033	0.030	0.114		Set Trigger
2	4.336	0.063	0.033	0.030	0.113		Set Trigger
3	4.245	0.064	0.033	0.030	0.111		Set Trigger
4	4.358	0.063	0.033	0.030	0.111		Set Trigger
5	4.432	0.064	0.033	0.029	0.118		Set Trigger

A-4.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/15/2009

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



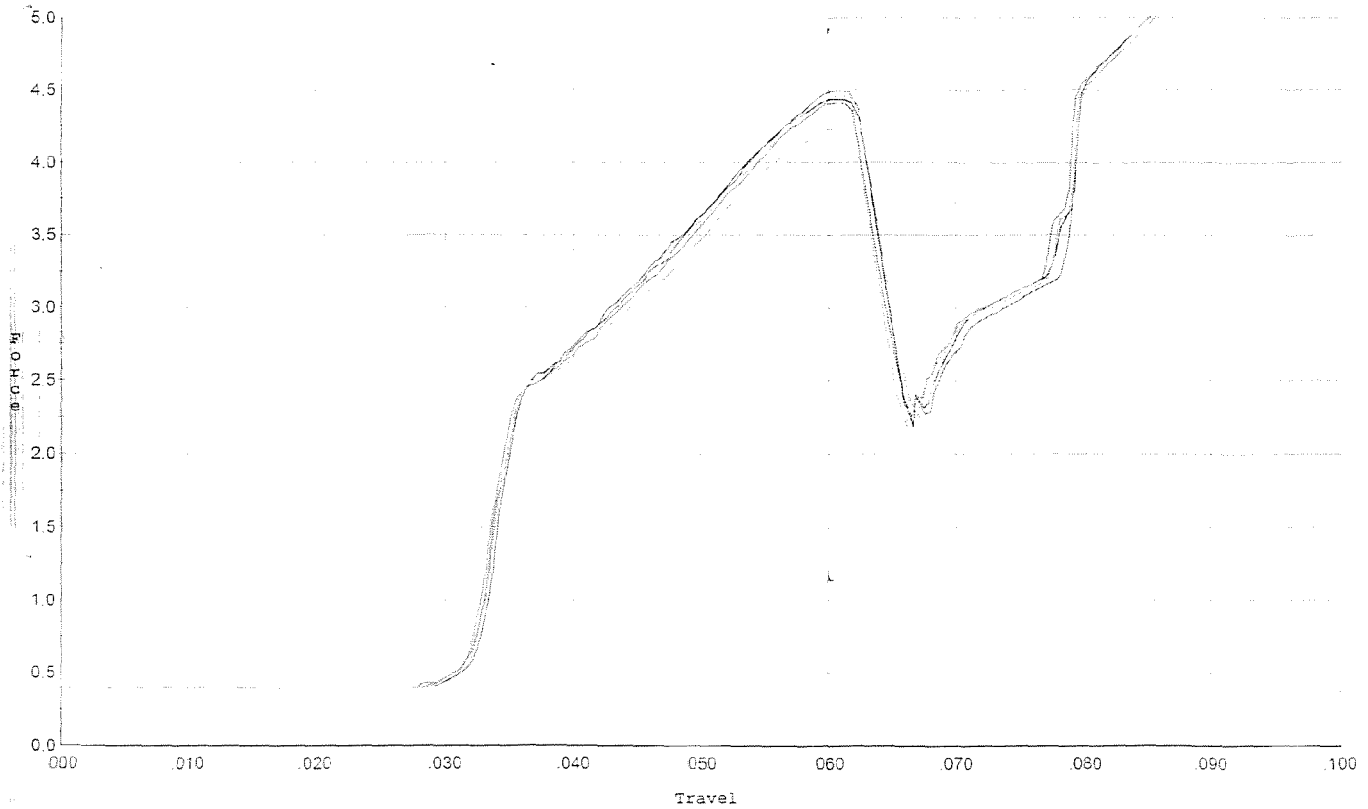
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.579	0.062	0.034	0.034	0.068		Set Trigger
2	2.628	0.061	0.034	0.034	0.068		Set Trigger
3	2.559	0.062	0.034	0.034	0.068		Set Trigger
4	2.453	0.061	0.034	0.034	0.064		Set Trigger
5	2.528	0.063	0.034	0.034	0.067		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/15/2009

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	4.493	0.062	0.032	0.030	0.116		Set Trigger
2	4.440	0.062	0.032	0.030	0.115		Set Trigger
3	4.415	0.062	0.032	0.030	0.113		Set Trigger
4	4.461	0.062	0.032	0.030	0.115		Set Trigger
5	4.229	0.062	0.032	0.030	0.111		Set Trigger

A - 4.40