

G680 1405

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

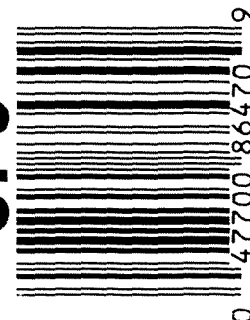


BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801405**UPC**

GUN SERIAL # G 6801405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-22-08	SP
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (B)	10/24/08	(B)
490	MAGNAFLUX BOLT		10-24-08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10-25-08	TL
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/30/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-12-09	PSA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

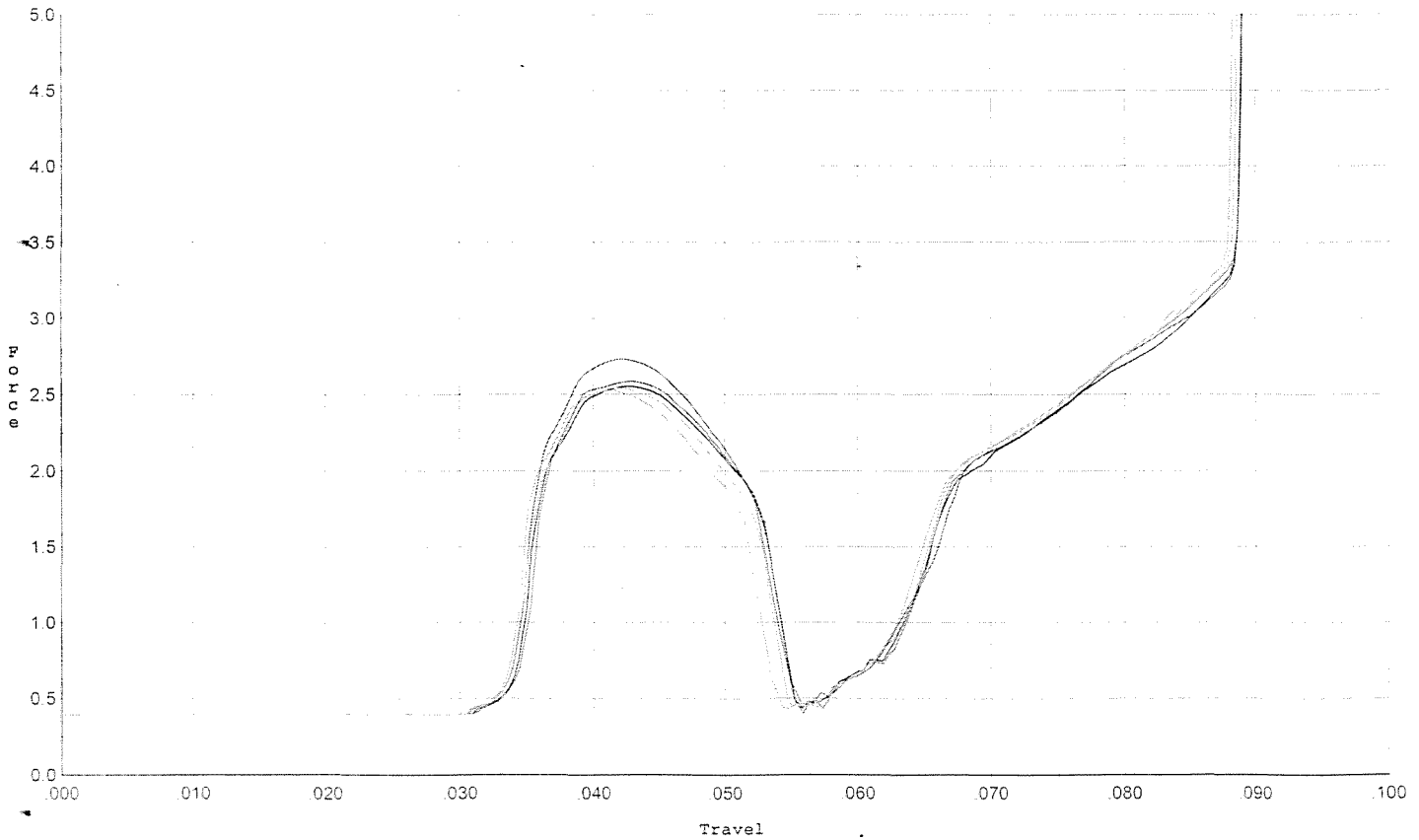
F004 REV 5/2006

BARBER - M24 0014889		2 LBS MIN 10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	1-20-09	L.N.		
560	F) SAFETY ON FORCE								
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6.0</u>	<u>6.0</u>	<u>5.0</u>	1-20-09	L.N.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.024</u>	1-20-09	L.N.		
	J) ASSEMBLE STOCK					1-12-09	LSN		
	K) ASSEMBLE SWIVEL STUDS					1-20-09	L.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		<u>PASS</u>	FAIL		1-19-09	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					1-19-09	W.N.		
670	FINAL INSPECTION A) HEADSPACE					1-20-09	L.N.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u>	<u>2.39</u>	<u>2.48</u>	<u>2.49</u>	<u>2.45</u>	1-20-09	L.N.
	C) FUNCTION					1-20-09	L.N.		
690	PACK					1-22-09	LSN		

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



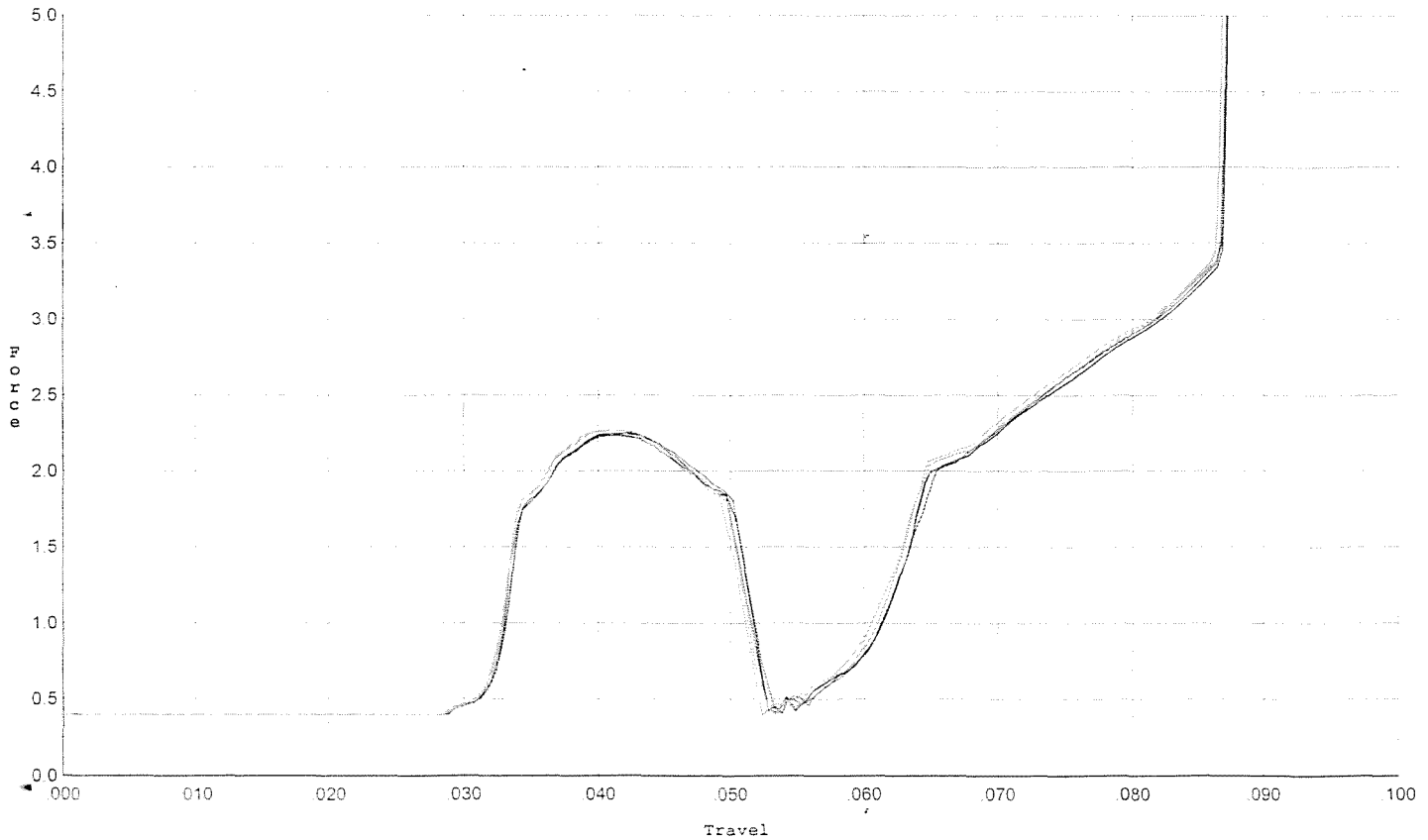
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.729	0.052	0.034	0.039	0.056		Set Trigger
2	2.552	0.053	0.034	0.039	0.055		Set Trigger
3	2.583	0.053	0.034	0.039	0.055		Set Trigger
4	2.542	0.053	0.034	0.039	0.054		Set Trigger
5	2.526	0.051	0.034	0.040	0.052		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



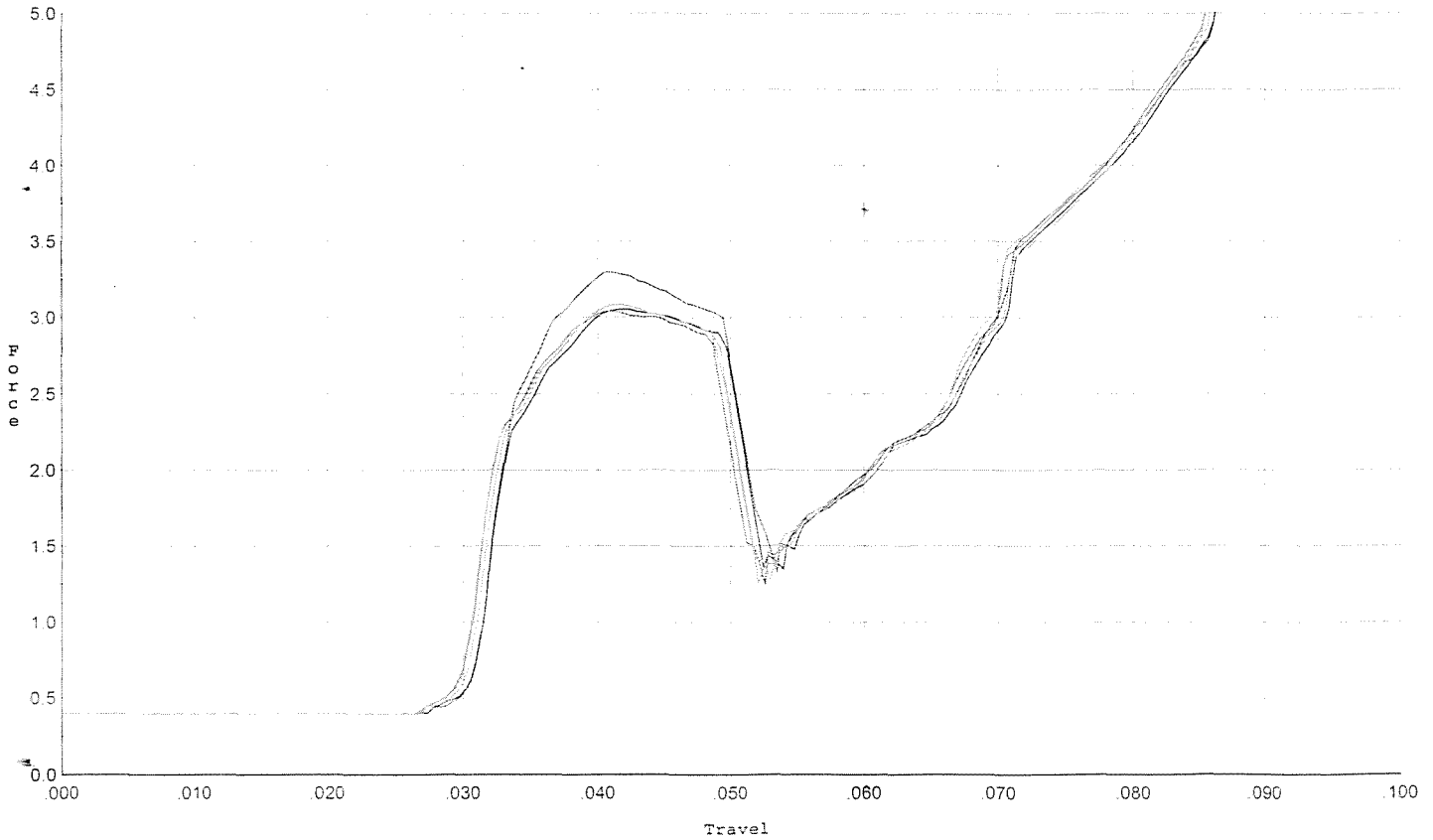
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.230	0.050	0.032	0.041	0.048		Set Trigger
2	2.242	0.050	0.032	0.041	0.049		Set Trigger
3	2.251	0.050	0.032	0.040	0.049		Set Trigger
4	2.267	0.050	0.032	0.041	0.049		Set Trigger
5	2.255	0.050	0.032	0.041	0.049		Set Trigger

A-2-24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



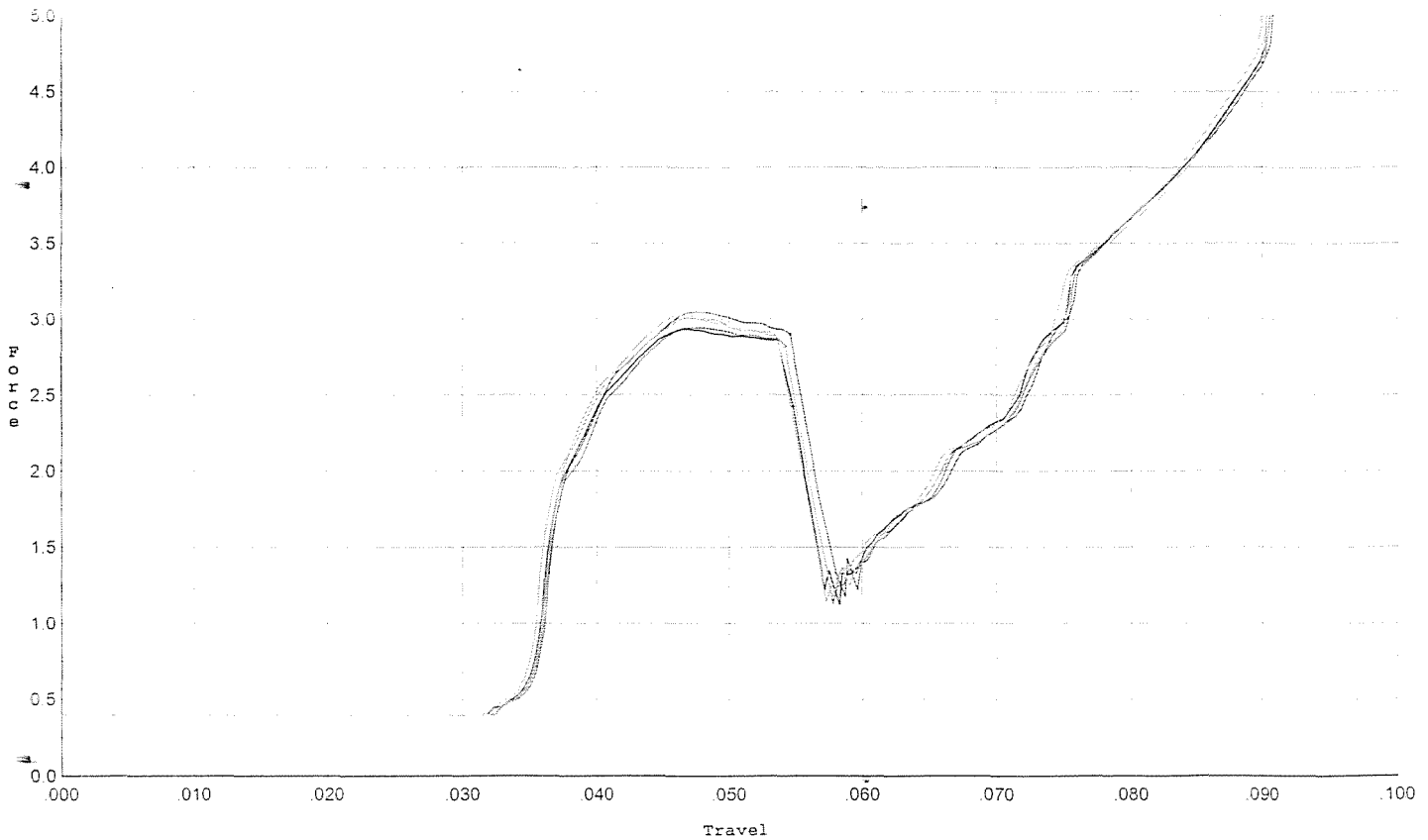
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.295	0.049	0.031	0.037	0.067		Set Trigger
2	3.050	0.050	0.031	0.038	0.064		Set Trigger
3	3.040	0.049	0.030	0.038	0.063		Set Trigger
4	3.088	0.049	0.030	0.038	0.064		Set Trigger
5	3.078	0.050	0.030	0.037	0.065		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



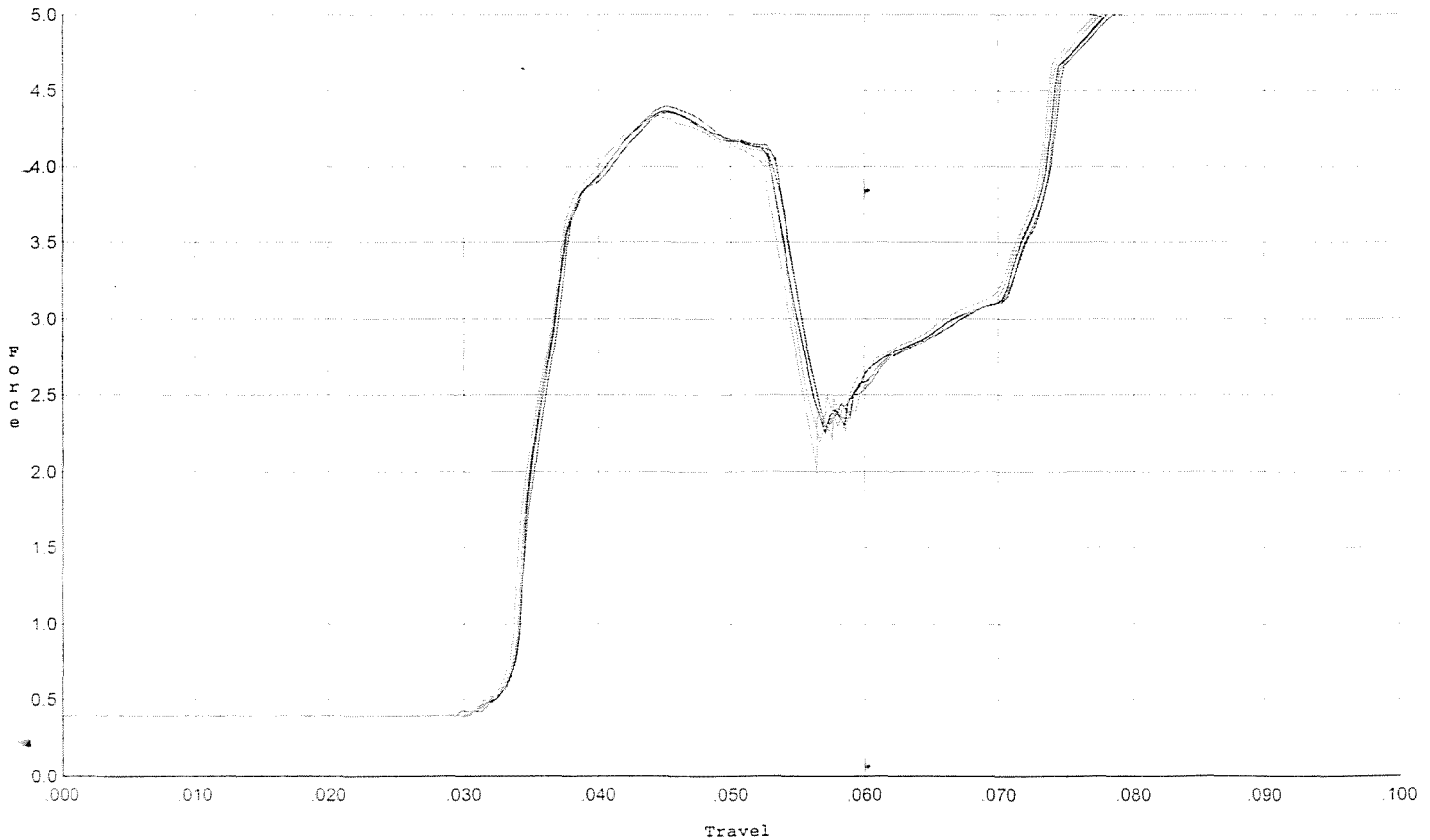
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.055	0.035	0.038	0.067		Set Trigger
2	2.933	0.055	0.035	0.038	0.065		Set Trigger
3	2.944	0.054	0.035	0.038	0.064		Set Trigger
4	3.009	0.054	0.035	0.038	0.065		Set Trigger
5	3.023	0.055	0.035	0.038	0.068		Set Trigger

AJ-99

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



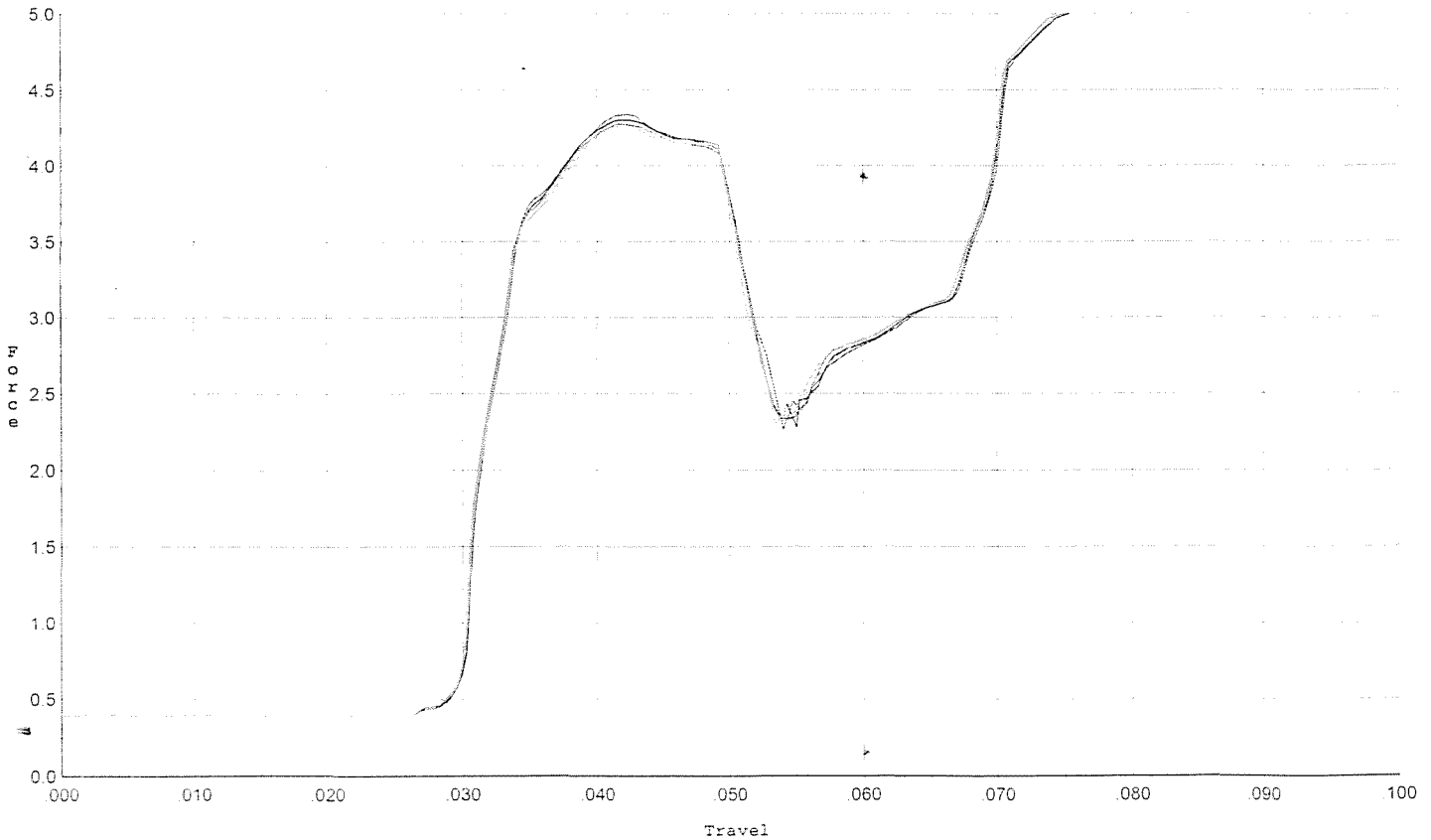
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.358	0.053	0.034	0.036	0.090		Set Trigger
2	4.370	0.053	0.033	0.036	0.089		Set Trigger
3	4.398	0.054	0.033	0.036	0.091		Set Trigger
4	4.349	0.053	0.033	0.035	0.090		Set Trigger
5	4.322	0.054	0.033	0.035	0.091		Set Trigger

A-4.35

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



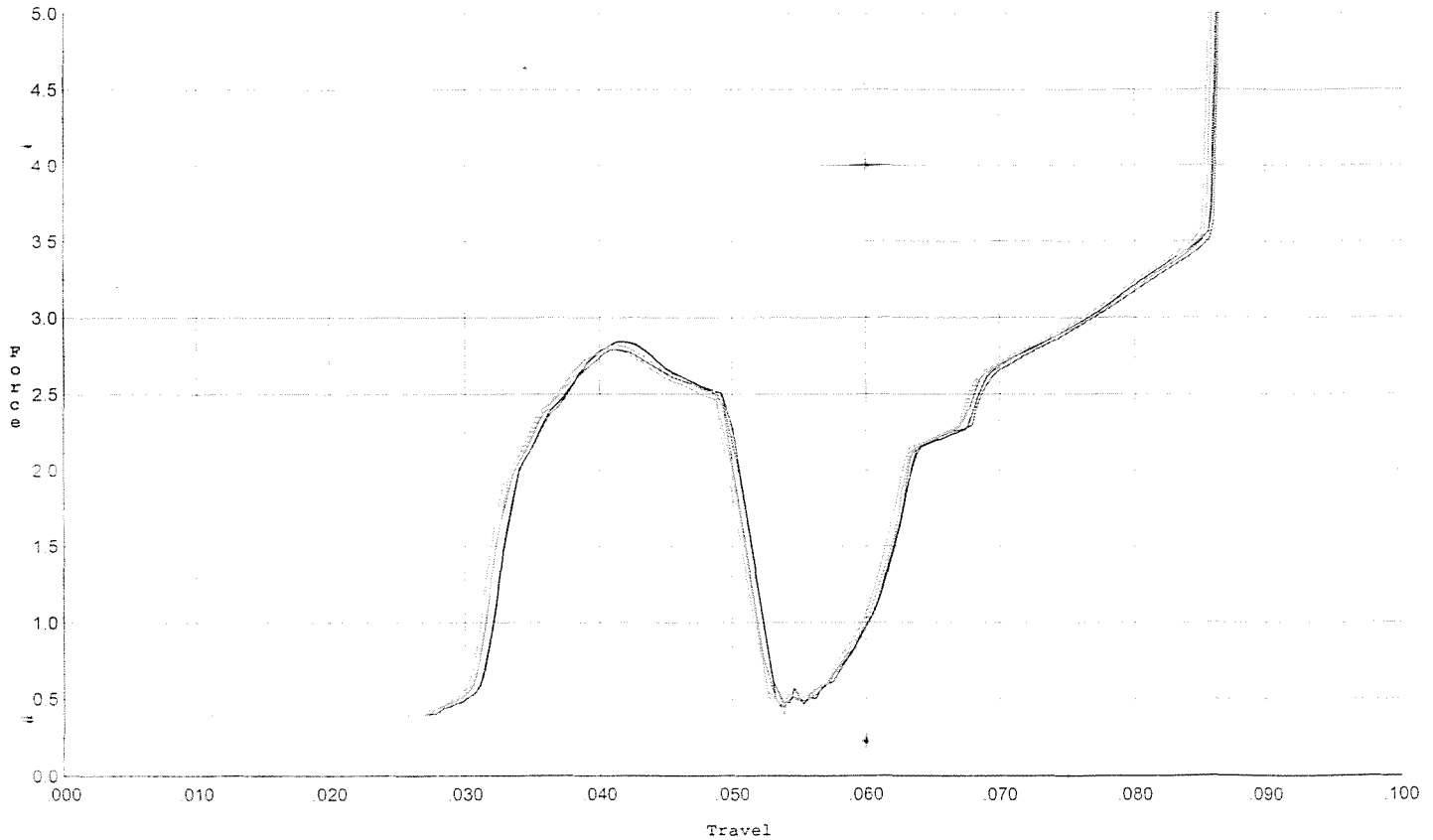
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.340	0.050	0.030	0.034	0.090		Set Trigger
2	4.304	0.049	0.030	0.034	0.087		Set Trigger
3	4.277	0.051	0.030	0.034	0.090		Set Trigger
4	4.264	0.049	0.030	0.034	0.087		Set Trigger
5	4.291	0.049	0.030	0.034	0.087		Set Trigger

4-4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 12/16/2008

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



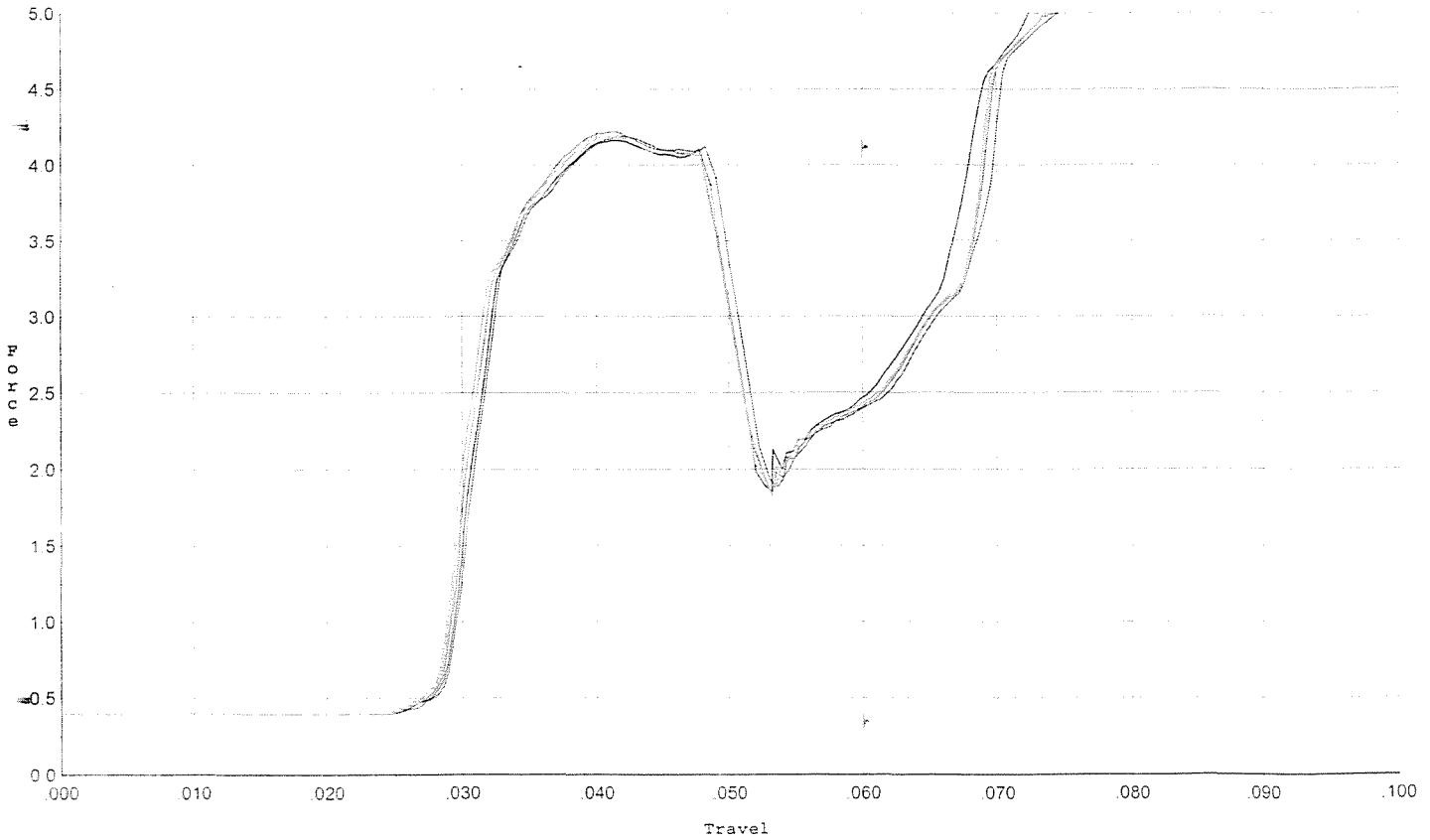
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.843	0.050	0.031	0.038	0.059		Set Trigger
2	2.842	0.050	0.031	0.038	0.058		Set Trigger
3	2.791	0.049	0.031	0.039	0.057		Set Trigger
4	2.798	0.049	0.030	0.038	0.057		Set Trigger
5	2.820	0.050	0.031	0.038	0.058		Set Trigger

A-2-81

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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	4.193	0.049	0.029	0.034	0.086		Set Trigger
2	4.159	0.049	0.029	0.033	0.085		Set Trigger
3	4.219	0.049	0.029	0.034	0.087		Set Trigger
4	4.190	0.049	0.028	0.034	0.086		Set Trigger
5	4.207	0.049	0.028	0.034	0.088		Set Trigger

A-4-19