

G680 1410

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



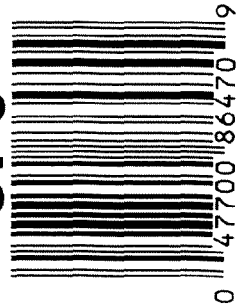
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6801410

UPC



BM FORM

GUN SERIAL #

G 680 1410

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	MAGNA - FLUX	10-21-08	SP
472	SERIALIZE BOLT HANDLE		10-22-08	SP
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION		10/24/08	SP
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/24/08	DG
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		11-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

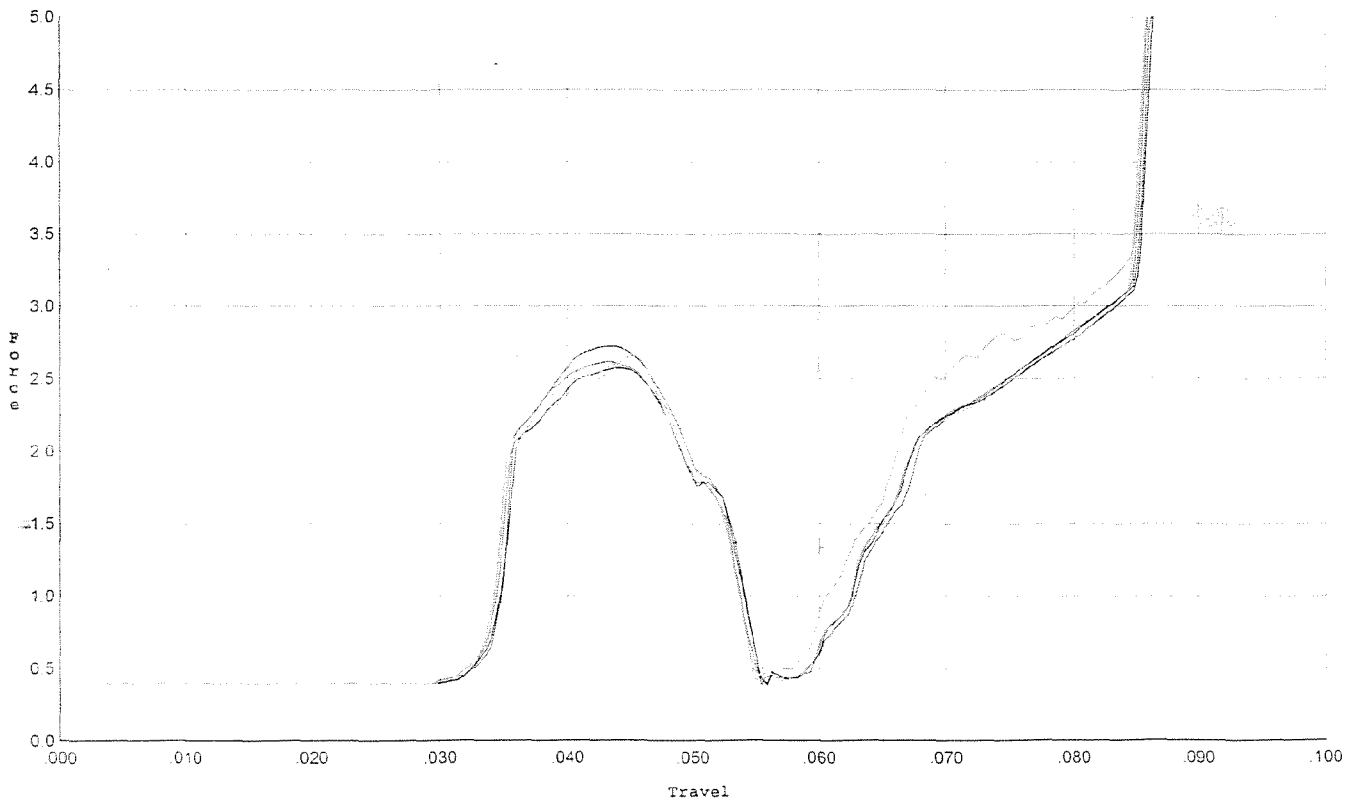
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-13-09	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>70</u> <u>70</u> <u>70</u>	1-13-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.034</u>	1-13-09	L.N.
	J) ASSEMBLE STOCK		1-8-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-13-09	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 <u>PASS</u> FAIL	1-8-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-8-09	RP
670	FINAL INSPECTION A) HEADSPACE		1-13-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.45</u> <u>2.55</u> <u>2.44</u> <u>2.55</u>	1-12-09	TL
	C) FUNCTION		1-13-09	L.N.
690	PACK		1/20/09	F.M.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



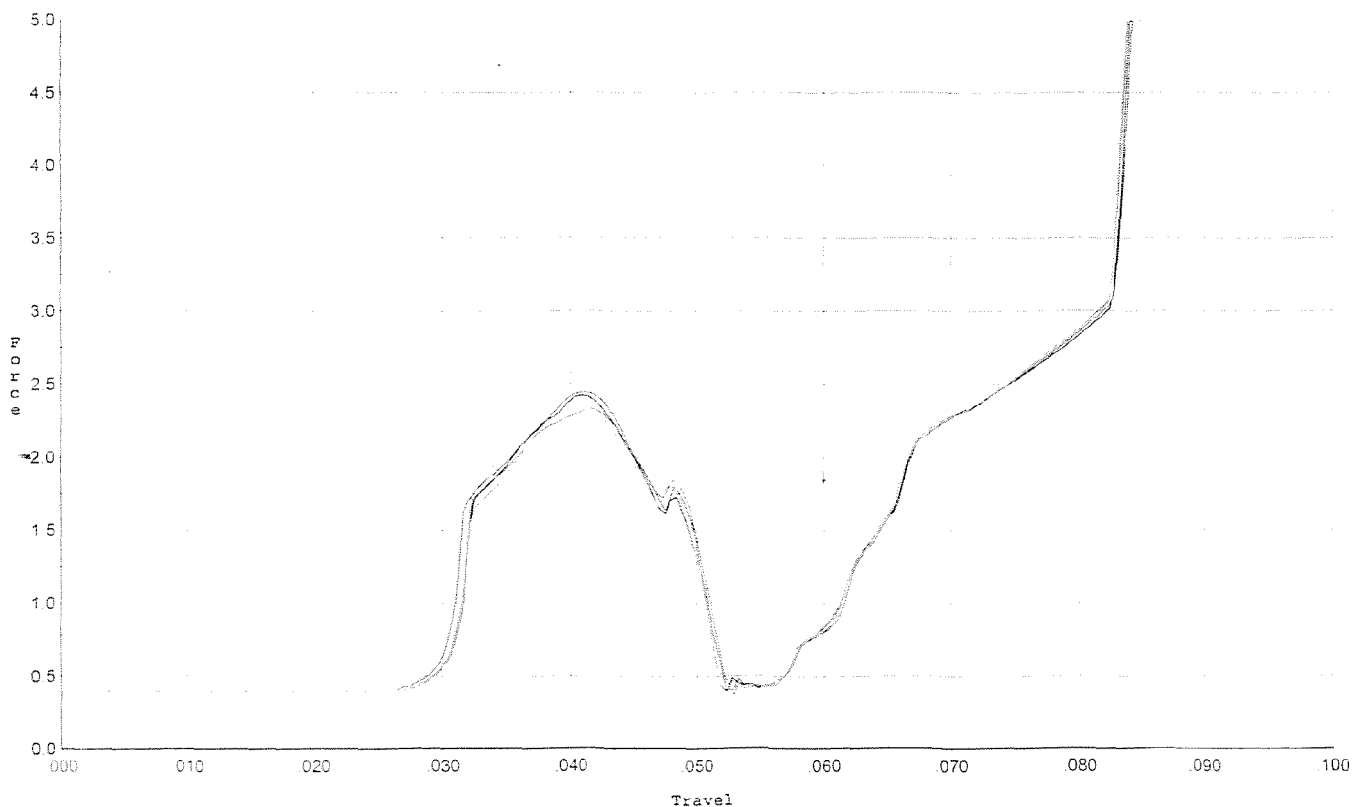
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.721	0.053	0.034	0.037	0.057		Set Trigger
2	2.571	0.054	0.034	0.037	0.055		Set Trigger
3	2.612	0.053	0.033	0.038	0.055		Set Trigger
4	2.652	0.053	0.033	0.037	0.055		Set Trigger
5	2.605	0.053	0.033	0.037	0.055		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



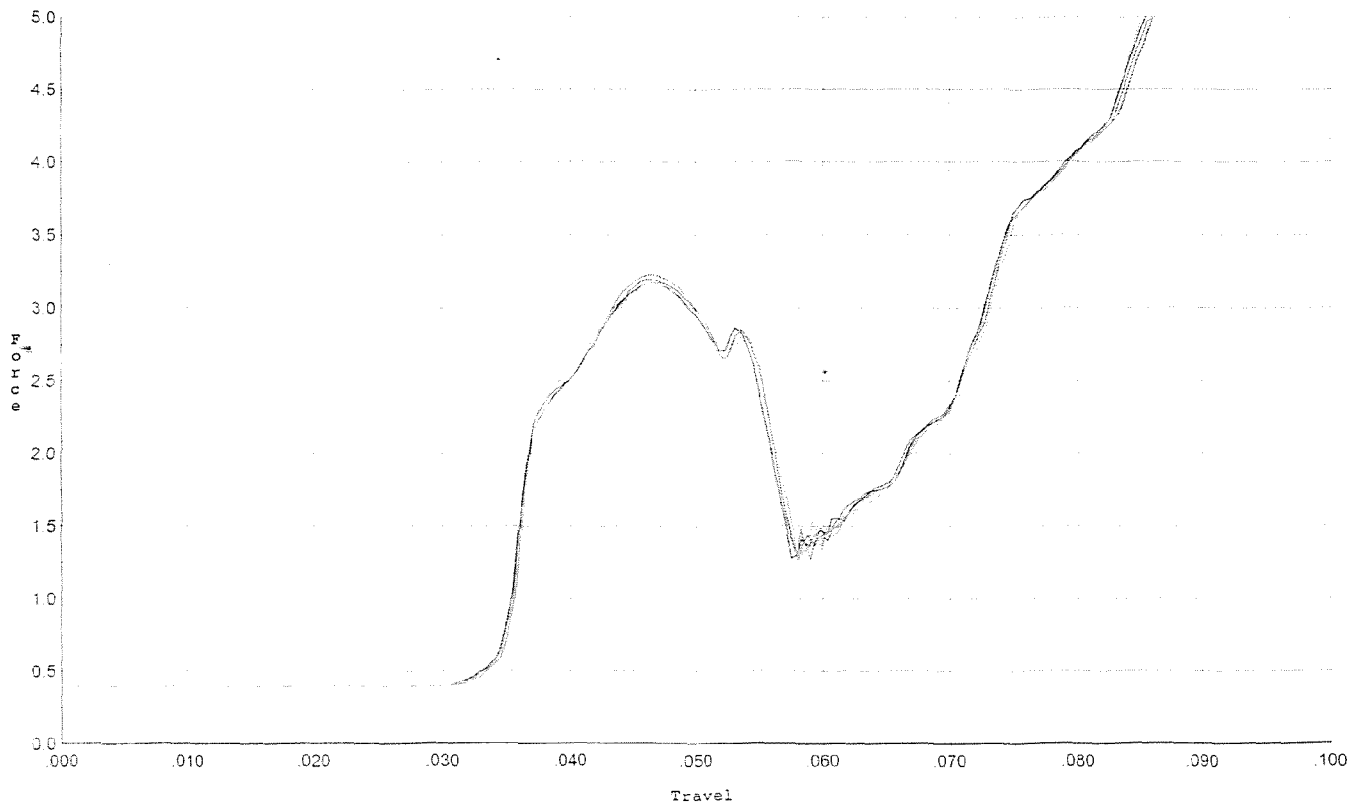
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.442	0.050	0.030	0.039	0.051		Set Trigger
2	2.420	0.050	0.031	0.039	0.050		Set Trigger
3	2.331	0.051	0.031	0.038	0.051		Set Trigger
4	2.345	0.050	0.031	0.038	0.049		Set Trigger
5	2.587	0.050	0.031	0.038	0.052		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



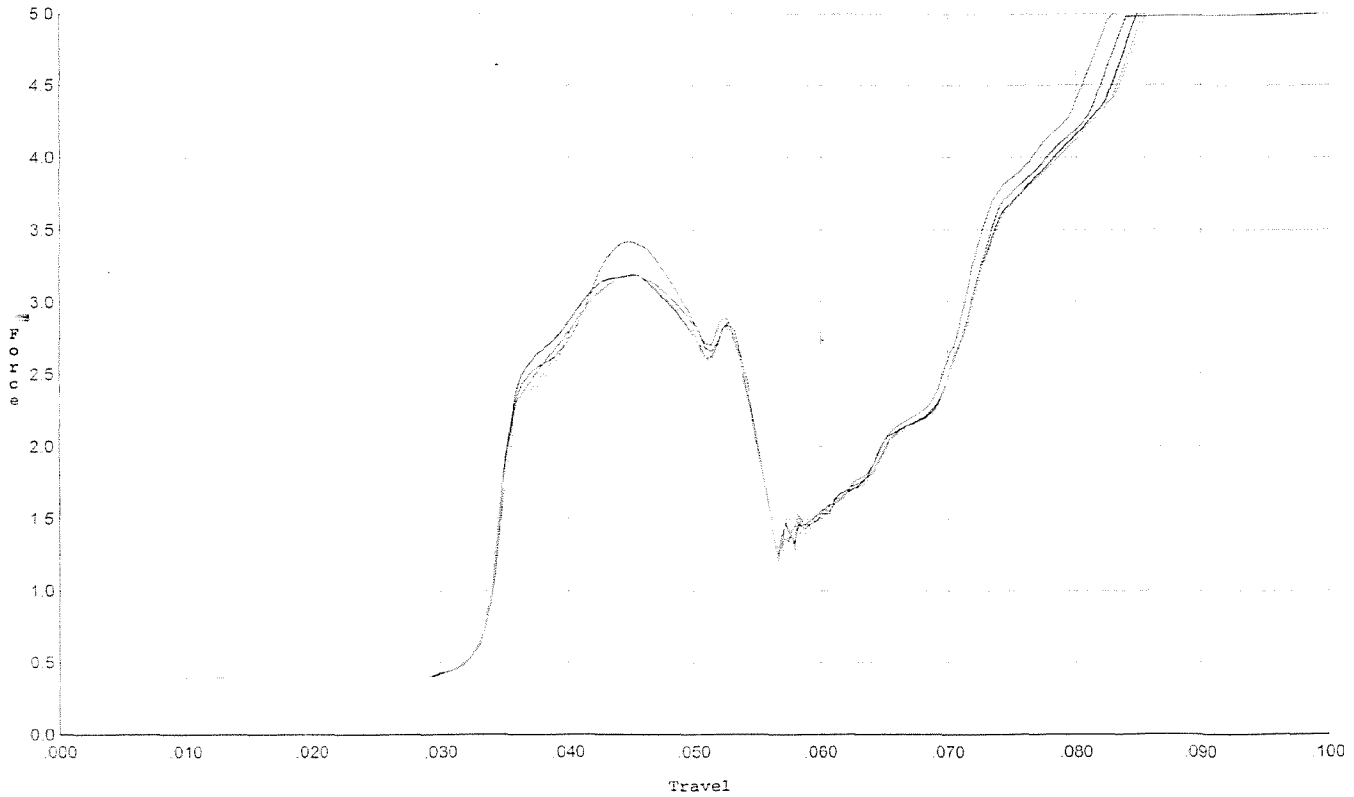
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.194	0.055	0.034	0.037	0.069		Set Trigger
2	3.172	0.056	0.035	0.037	0.070		Set Trigger
3	3.223	0.055	0.035	0.037	0.069		Set Trigger
4	3.148	0.055	0.035	0.037	0.069		Set Trigger
5	3.167	0.056	0.035	0.036	0.071		Set Trigger

A-3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schultz 1/7/2009

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



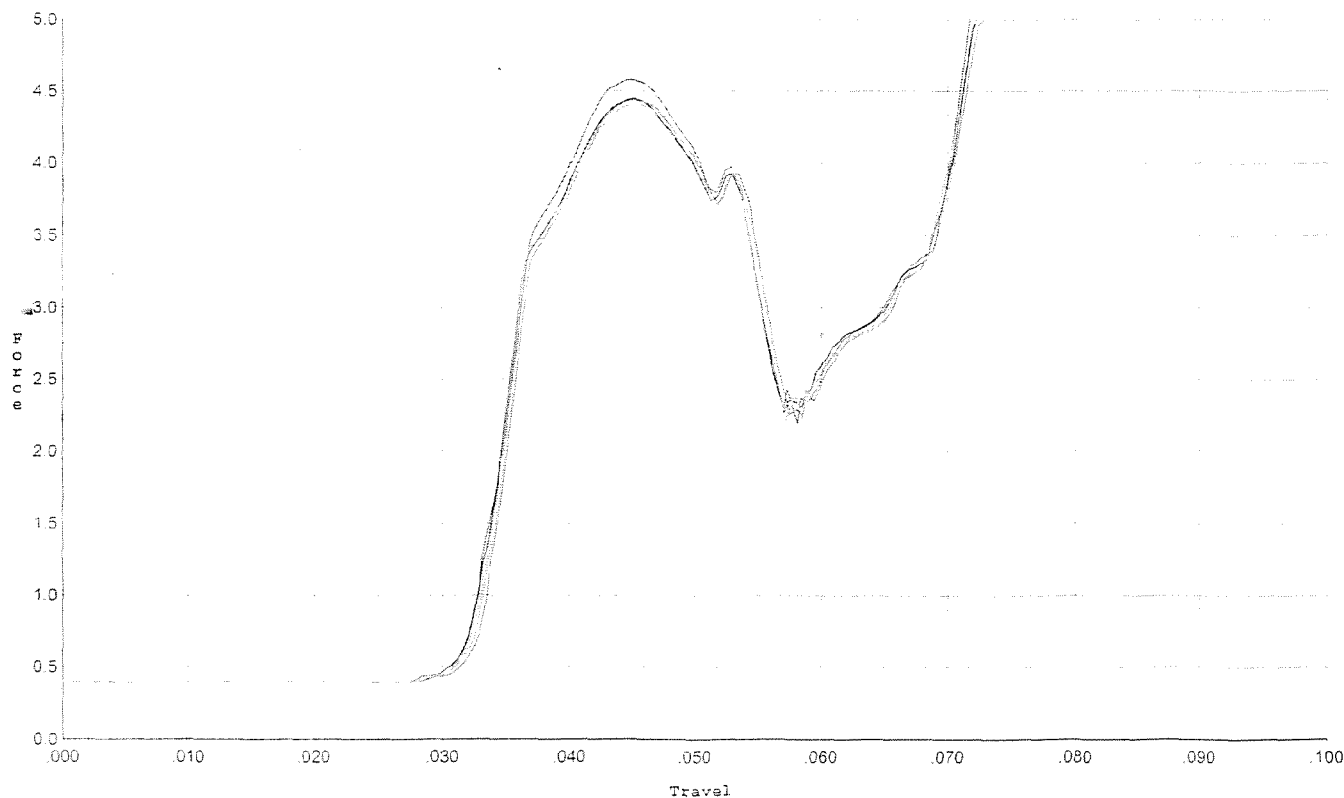
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.418	0.054	0.033	0.036	0.072		Set Trigger
2	3.188	0.055	0.033	0.036	0.071		Set Trigger
3	3.181	0.054	0.033	0.035	0.070		Set Trigger
4	3.222	0.053	0.033	0.036	0.068		Set Trigger
5	3.182	0.054	0.033	0.036	0.070		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schultz 1/7/2009

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



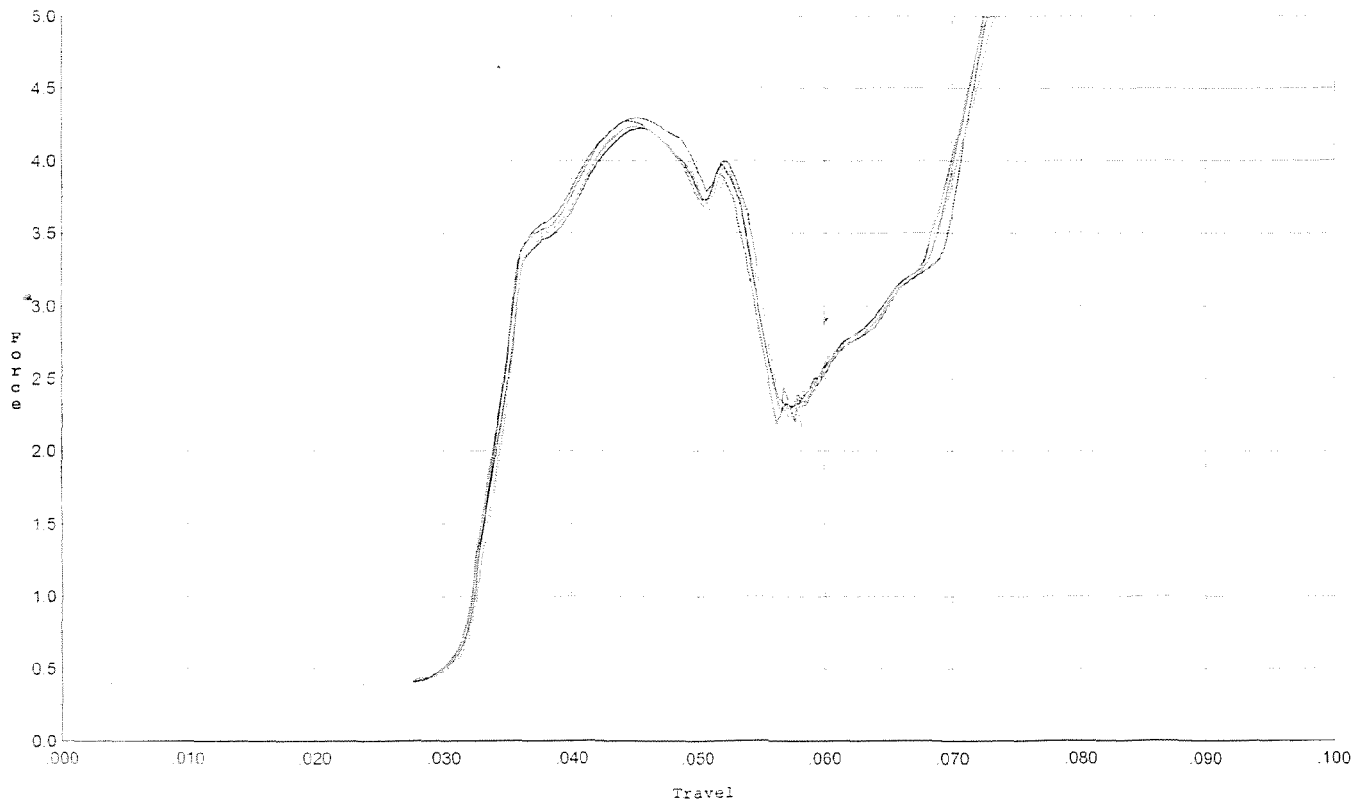
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.575	0.054	0.032	0.023	0.094		Set Trigger
2	4.441	0.054	0.032	0.023	0.093		Set Trigger
3	4.431	0.054	0.032	0.023	0.093		Set Trigger
4	4.423	0.054	0.032	0.023	0.093		Set Trigger
5	4.405	0.055	0.032	0.023	0.094		Set Trigger

A - 4.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 1/7/2009

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



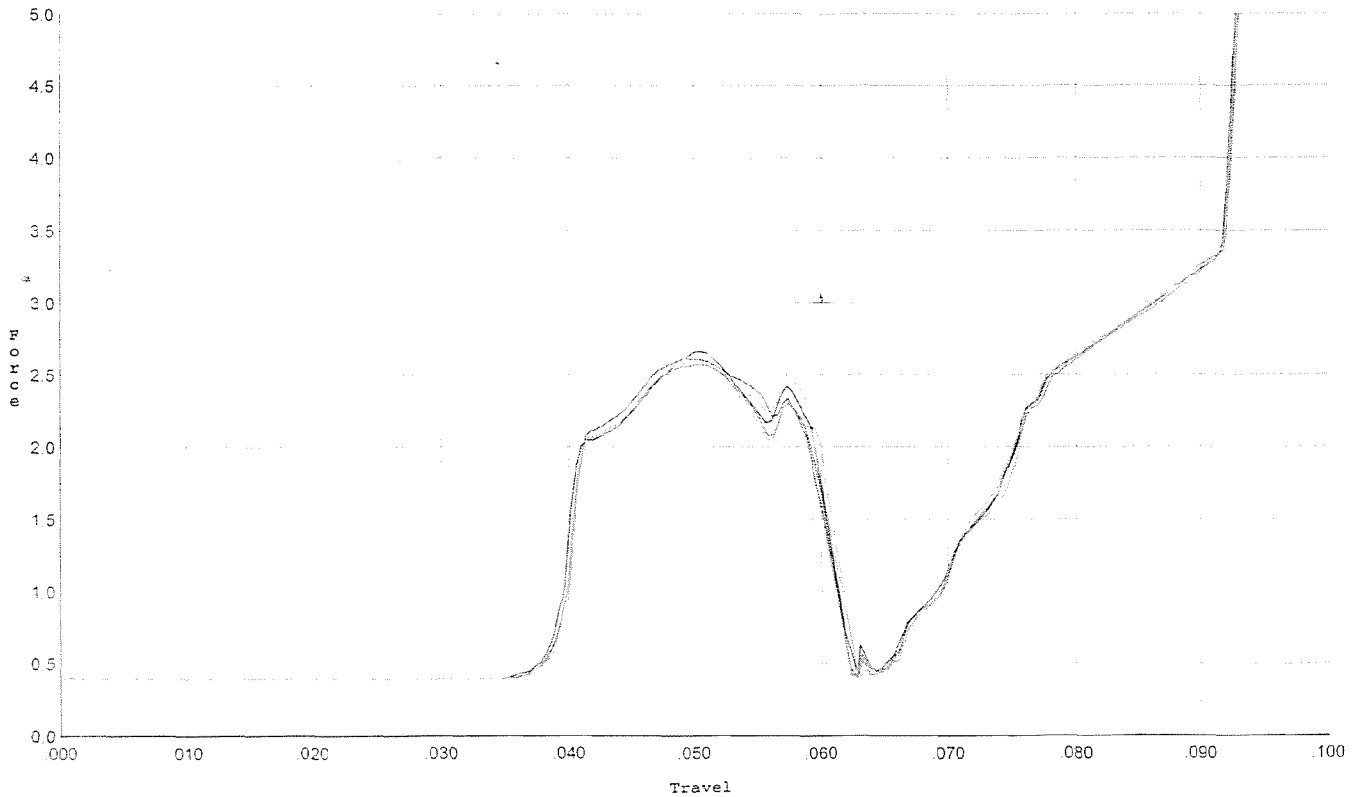
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.054	0.031	0.025	0.094		Set Trigger
2	4.226	0.053	0.031	0.025	0.090		Set Trigger
3	4.271	0.054	0.031	0.025	0.093		Set Trigger
4	4.233	0.055	0.032	0.024	0.093		Set Trigger
5	4.237	0.054	0.032	0.025	0.092		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



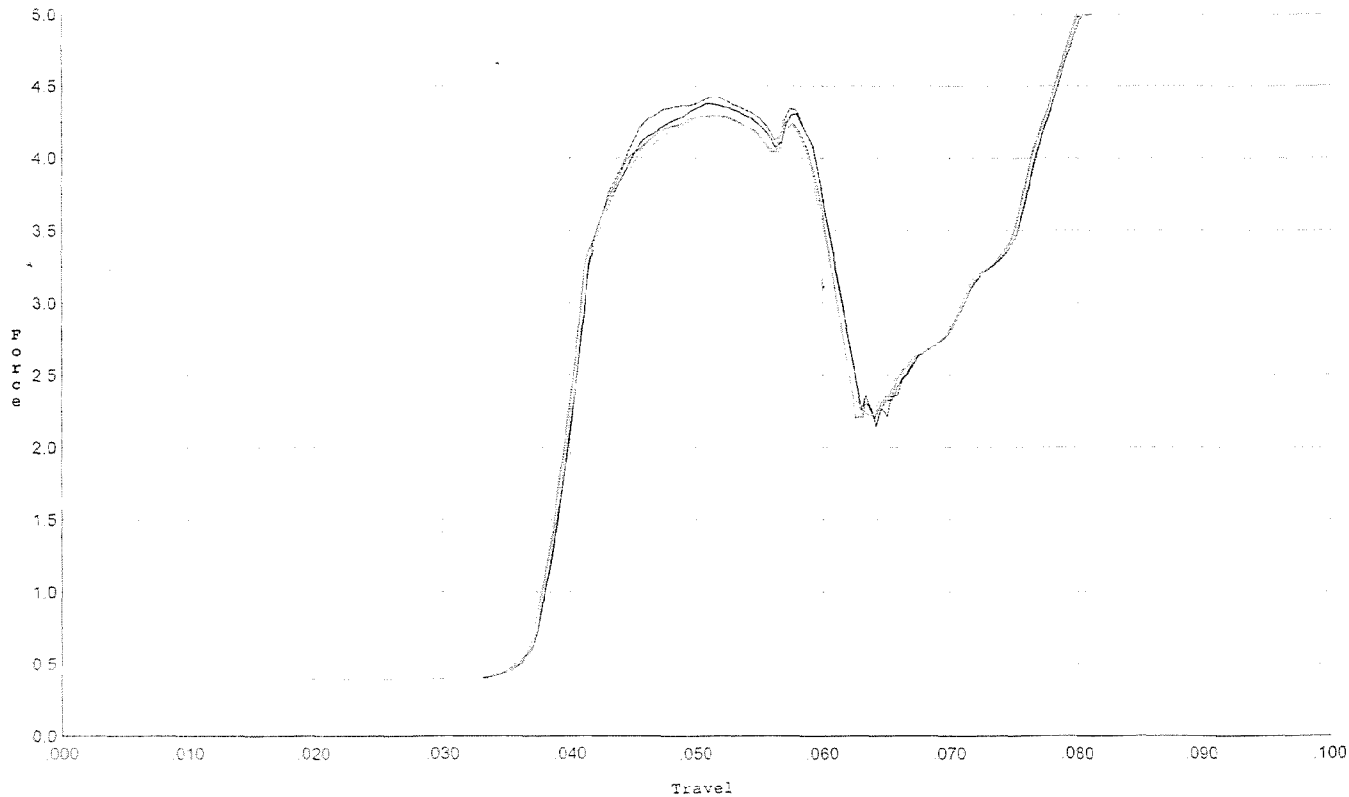
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.060	0.039	0.039	0.063		Set Trigger
2	2.664	0.059	0.038	0.039	0.062		Set Trigger
3	2.568	0.060	0.039	0.039	0.062		Set Trigger
4	2.647	0.060	0.039	0.039	0.063		Set Trigger
5	2.617	0.059	0.039	0.039	0.061		Set Trigger

A. 2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schultz 1/7/2009

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	4.423	0.061	0.037	0.026	0.104		Set Trigger
2	4.378	0.059	0.037	0.027	0.100		Set Trigger
3	4.294	0.060	0.037	0.027	0.101		Set Trigger
4	4.291	0.060	0.037	0.027	0.100		Set Trigger
5	4.296	0.060	0.037	0.027	0.101		Set Trigger

A-4.33