

G680 7665

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.

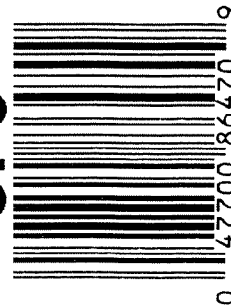
86470

BARREL LENGTH

24"

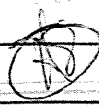
CAPACITY

6

G6807665**UPC**

BM FORM

GUN SERIAL # G 680 7665

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-21-09	SPD
430	ASSEMBLE TO STOCK		1-21-09	SP
440	PROOF		1-21-09	SPD
460	CHECK HEADSPACE		1-21-09	SPD
470	DIS-ASSEMBLE ACTION		1-21-09	SPD
472	SERIALIZE BOLT HANDLE		1-22-09	RT
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	1/23/09	
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1/24/09	DG
542	APPLY COATINGS (BARREL ACTION)		1-30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		1-31-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

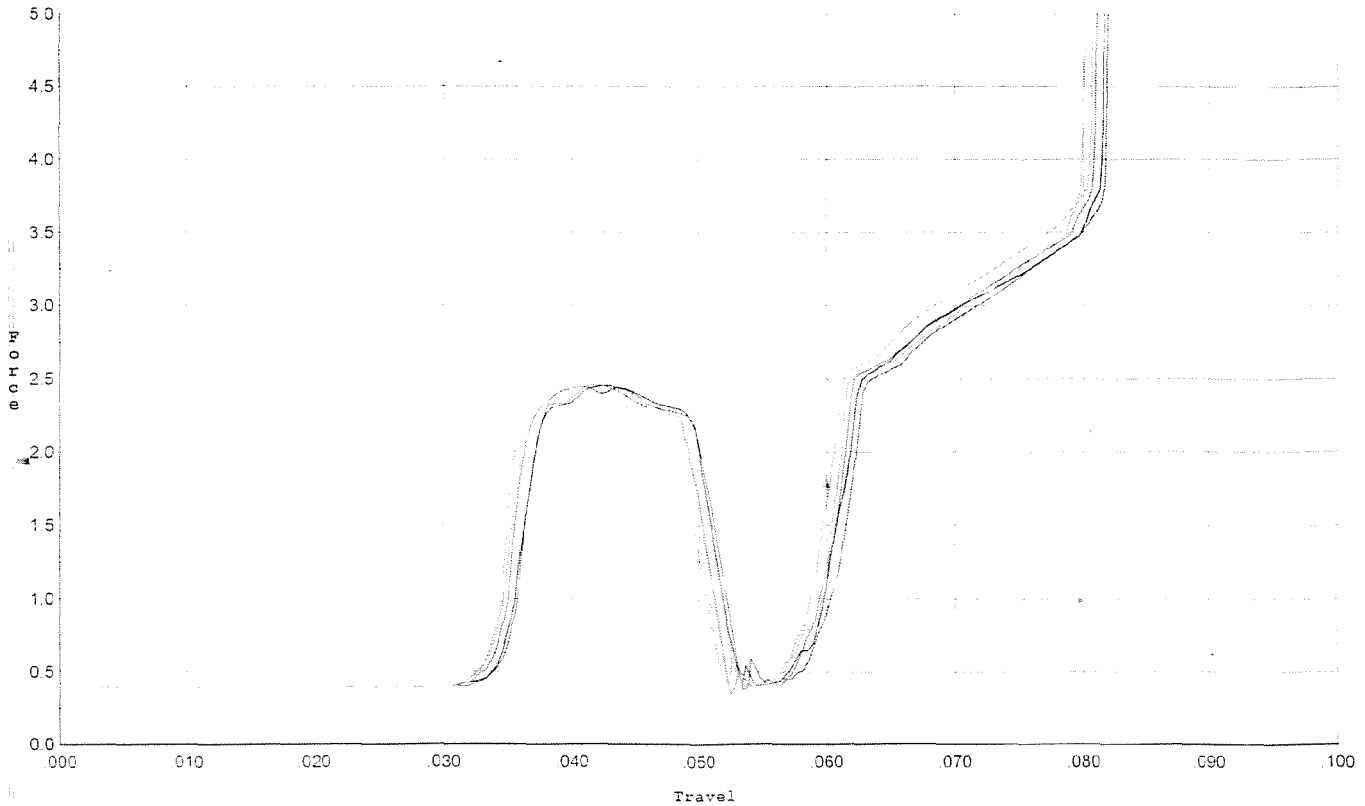
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	2-16-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	2-16-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	2-16-09	LJ
	J) ASSEMBLE STOCK		1-31-09	PHD
	K) ASSEMBLE SWIVEL STUDS		2-16-09	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 <u>PASS</u> FAIL	2-12-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-12-09	W W
670	FINAL INSPECTION A) HEADSPACE		2-16-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.51</u> <u>2.50</u> <u>2.70</u> <u>2.15</u>	2-13-09	W W
	C) FUNCTION		2-16-09	LJ
690	PACK		2/18/09	FJ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



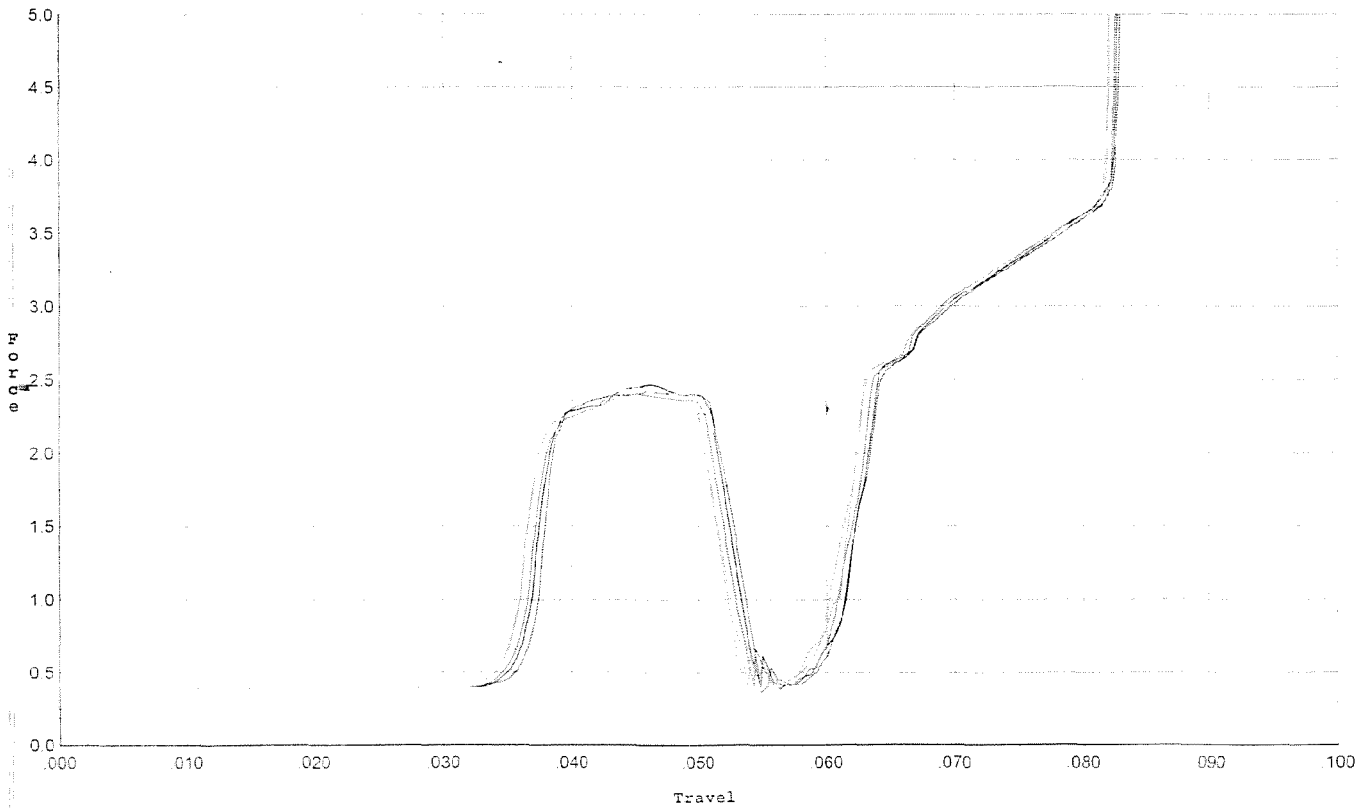
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.446	0.051	0.035	0.036	0.049		Set Trigger
2	2.450	0.050	0.034	0.036	0.048		Set Trigger
3	2.456	0.050	0.034	0.036	0.048		Set Trigger
4	2.386	0.049	0.034	0.036	0.047		Set Trigger
5	2.469	0.048	0.034	0.036	0.047		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



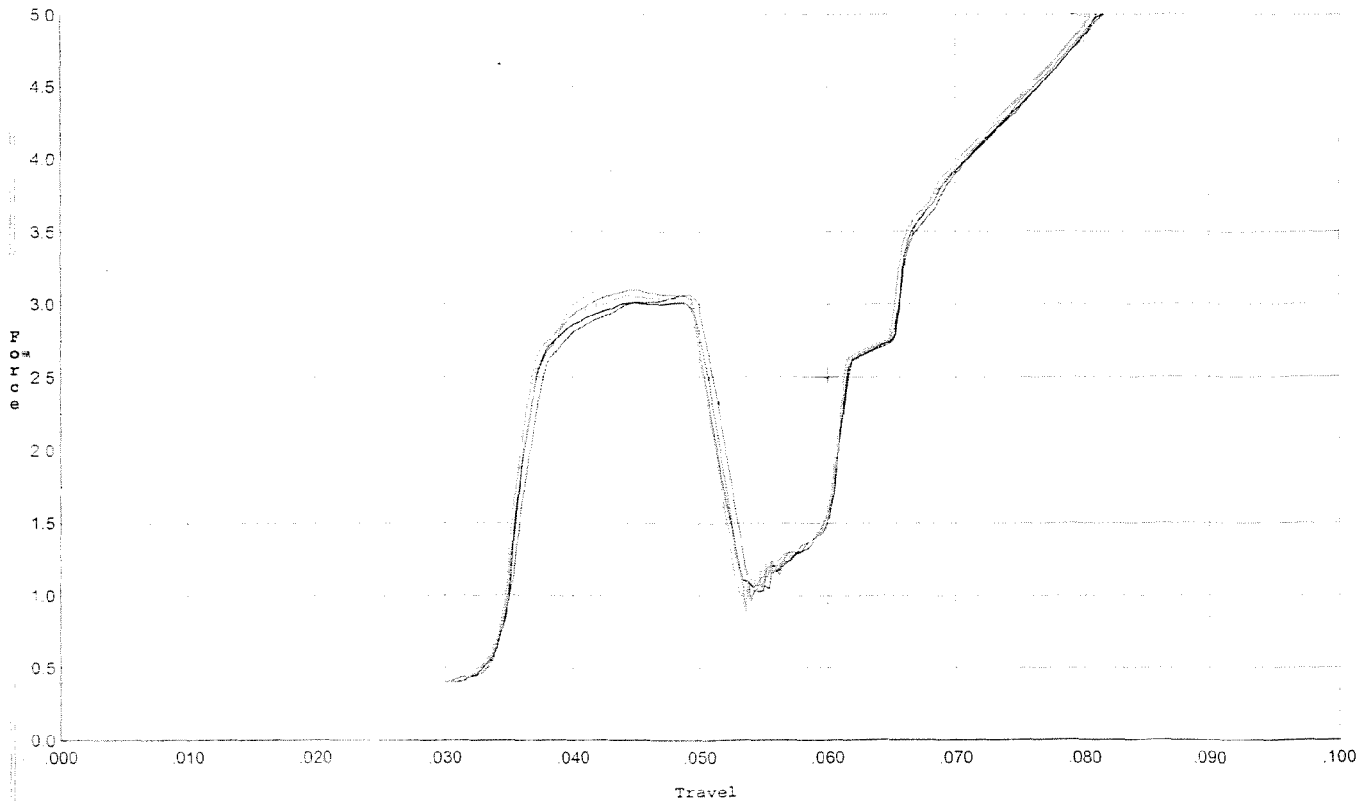
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.421	0.052	0.036	0.037	0.050		Set Trigger
2	2.467	0.051	0.036	0.037	0.049		Set Trigger
3	2.401	0.051	0.036	0.037	0.048		Set Trigger
4	2.447	0.050	0.035	0.036	0.048		Set Trigger
5	2.450	0.050	0.035	0.036	0.048		Set Trigger

Aug 243

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/13/09

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



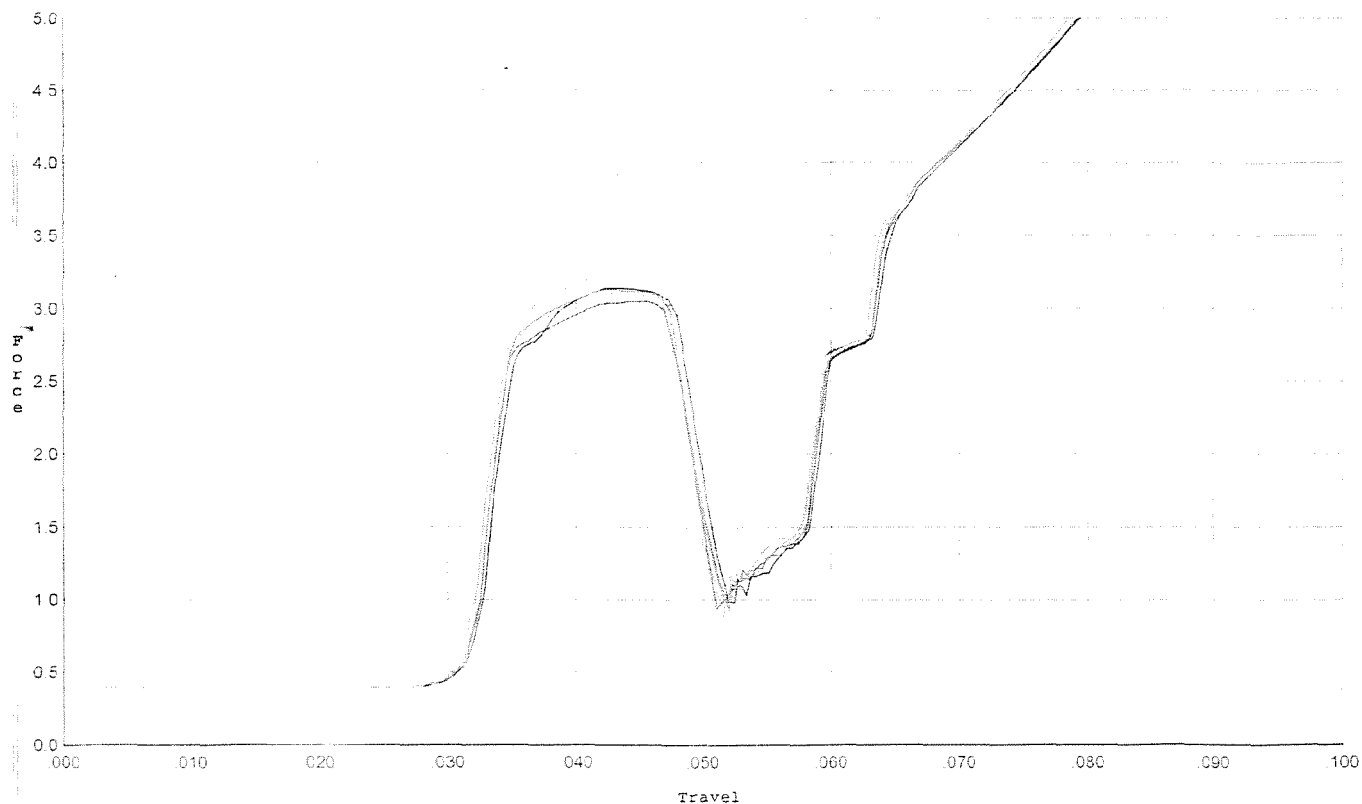
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.064	0.051	0.034	0.035	0.060		Set Trigger
2	3.013	0.050	0.034	0.035	0.057		Set Trigger
3	3.098	0.051	0.034	0.035	0.060		Set Trigger
4	3.057	0.050	0.034	0.035	0.058		Set Trigger
5	3.158	0.049	0.034	0.035	0.059		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



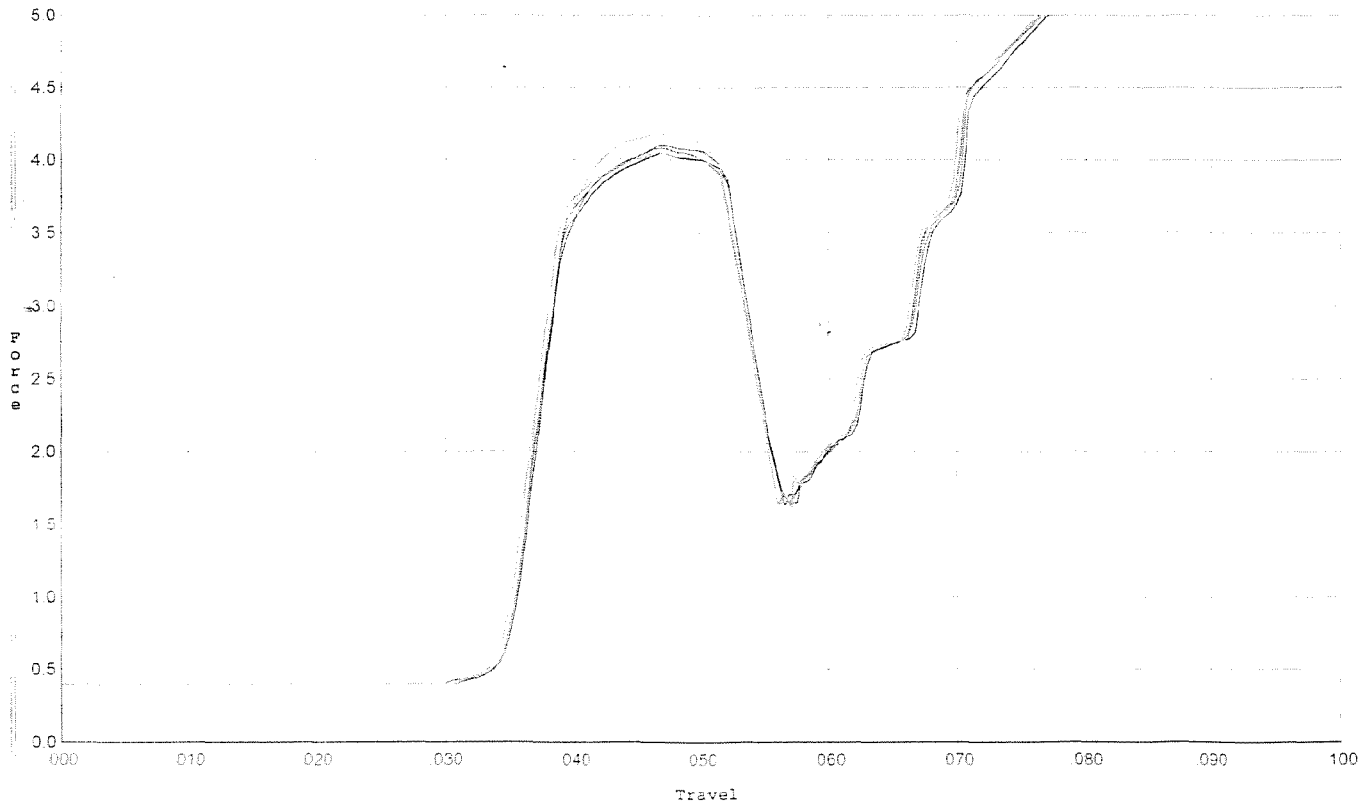
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.050	0.048	0.032	0.034	0.058		Set Trigger
2	3.138	0.048	0.032	0.034	0.059		Set Trigger
3	3.126	0.047	0.031	0.034	0.058		Set Trigger
4	3.112	0.048	0.032	0.034	0.058		Set Trigger
5	3.249	0.047	0.031	0.033	0.060		Set Trigger

Aug 3.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



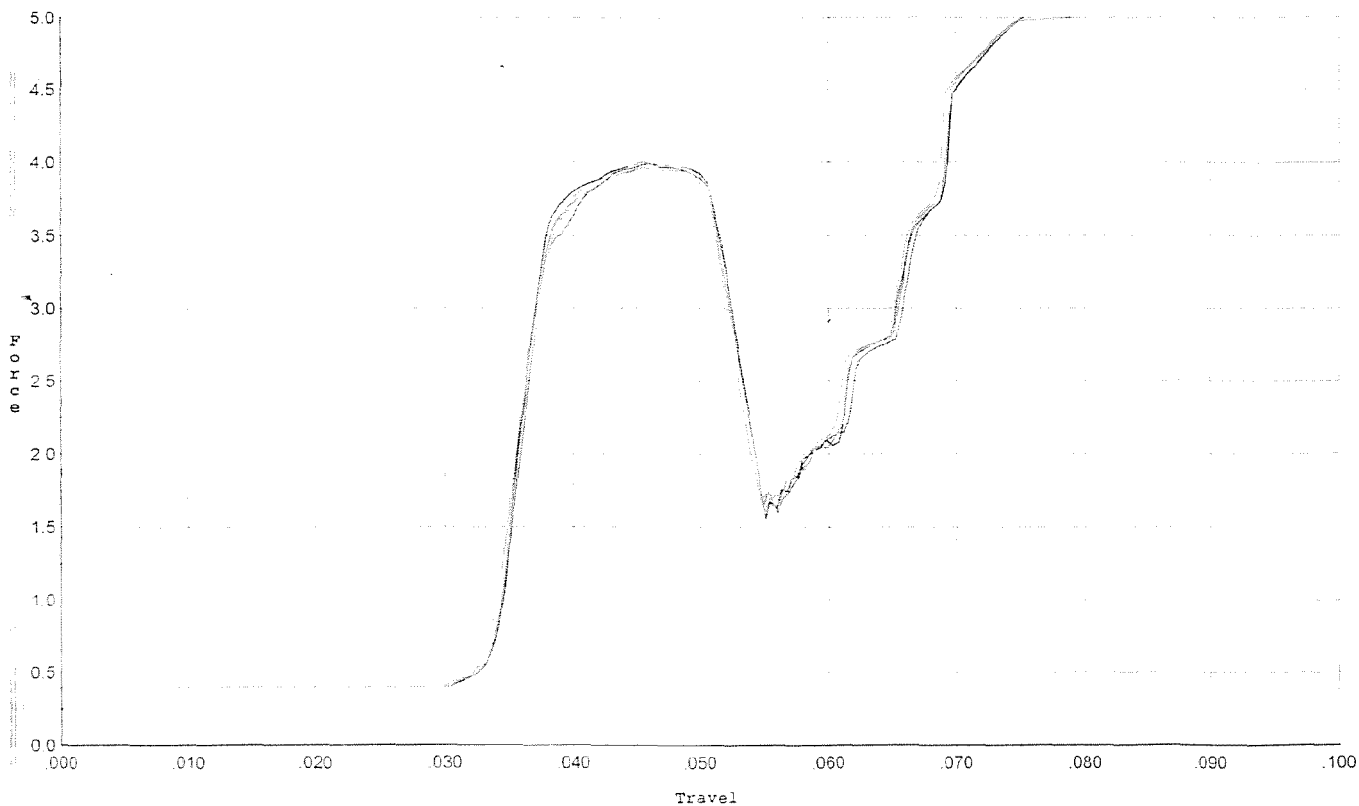
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.052	0.035	0.034	0.078		Set Trigger
2	4.044	0.052	0.035	0.034	0.077		Set Trigger
3	4.082	0.053	0.034	0.034	0.079		Set Trigger
4	4.046	0.053	0.035	0.034	0.079		Set Trigger
5	4.183	0.053	0.034	0.033	0.081		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

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



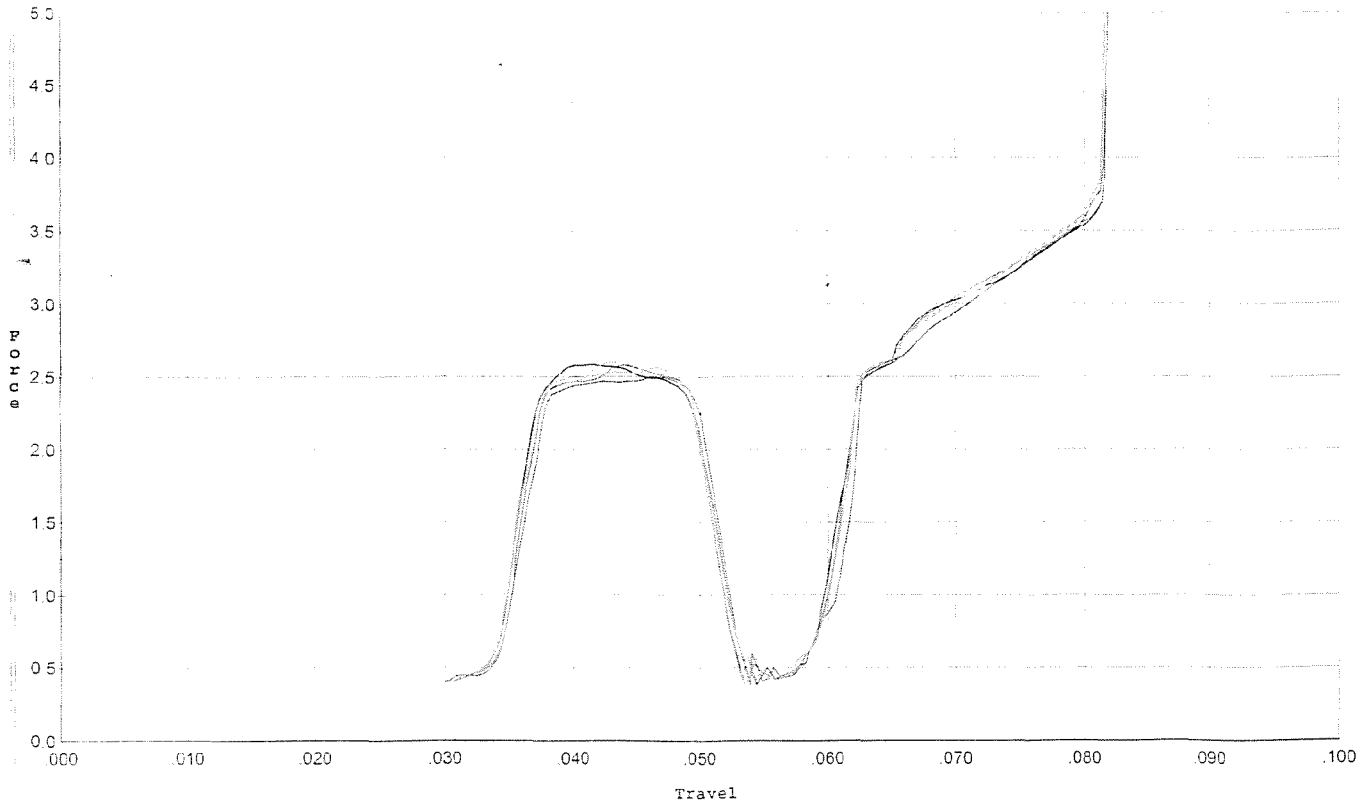
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.987	0.053	0.034	0.034	0.078		Set Trigger
2	3.996	0.052	0.034	0.034	0.079		Set Trigger
3	3.964	0.052	0.034	0.034	0.078		Set Trigger
4	3.996	0.051	0.033	0.034	0.075		Set Trigger
5	3.965	0.051	0.033	0.033	0.076		Set Trigger

Avg 3.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

Model: M24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



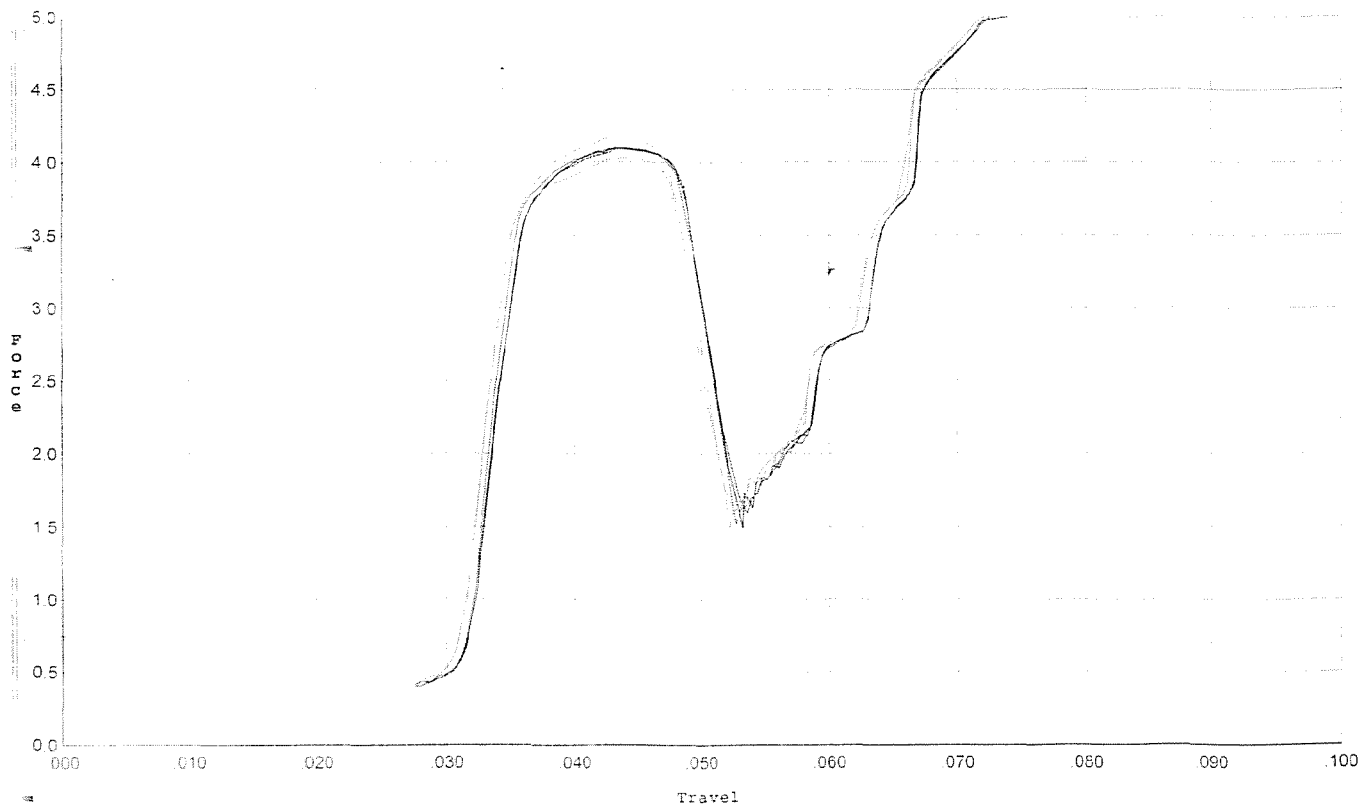
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.503	0.050	0.034	0.036	0.050		Set Trigger
2	2.582	0.050	0.034	0.036	0.050		Set Trigger
3	2.577	0.051	0.034	0.036	0.052		Set Trigger
4	2.564	0.049	0.034	0.036	0.050		Set Trigger
5	2.600	0.050	0.034	0.036	0.050		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/13/09

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.049	0.031	0.033	0.076		Set Trigger
2	4.094	0.049	0.031	0.033	0.076		Set Trigger
3	4.105	0.049	0.031	0.032	0.078		Set Trigger
4	4.029	0.048	0.031	0.032	0.074		Set Trigger
5	4.169	0.049	0.031	0.032	0.078		Set Trigger

Aug 4.09