

6680 7666

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

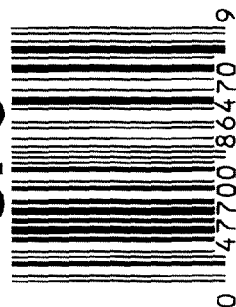
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807666

UPC



GUN SERIAL #

G 680 7666

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-20-09	SP
430	ASSEMBLE TO STOCK		1-20-09	SP
440	PROOF		1-20-09	SP
460	CHECK HEADSPACE		1-20-09	SP
470	DIS-ASSEMBLE ACTION		1-20-09	SP
472	SERIALIZE BOLT HANDLE		1-21-09	RTR
475	DRILL AND TAP SIGHT HOLES		1-21-09	SP
480	MAGNAFLUX BBL ACTION	(K)	1/24/09	(K)
490	MAGNAFLUX BOLT		1/24/09	mt
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1/25/09	dg
542	APPLY COATINGS (BARREL ACTION)		2 3	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-4-09	RTR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

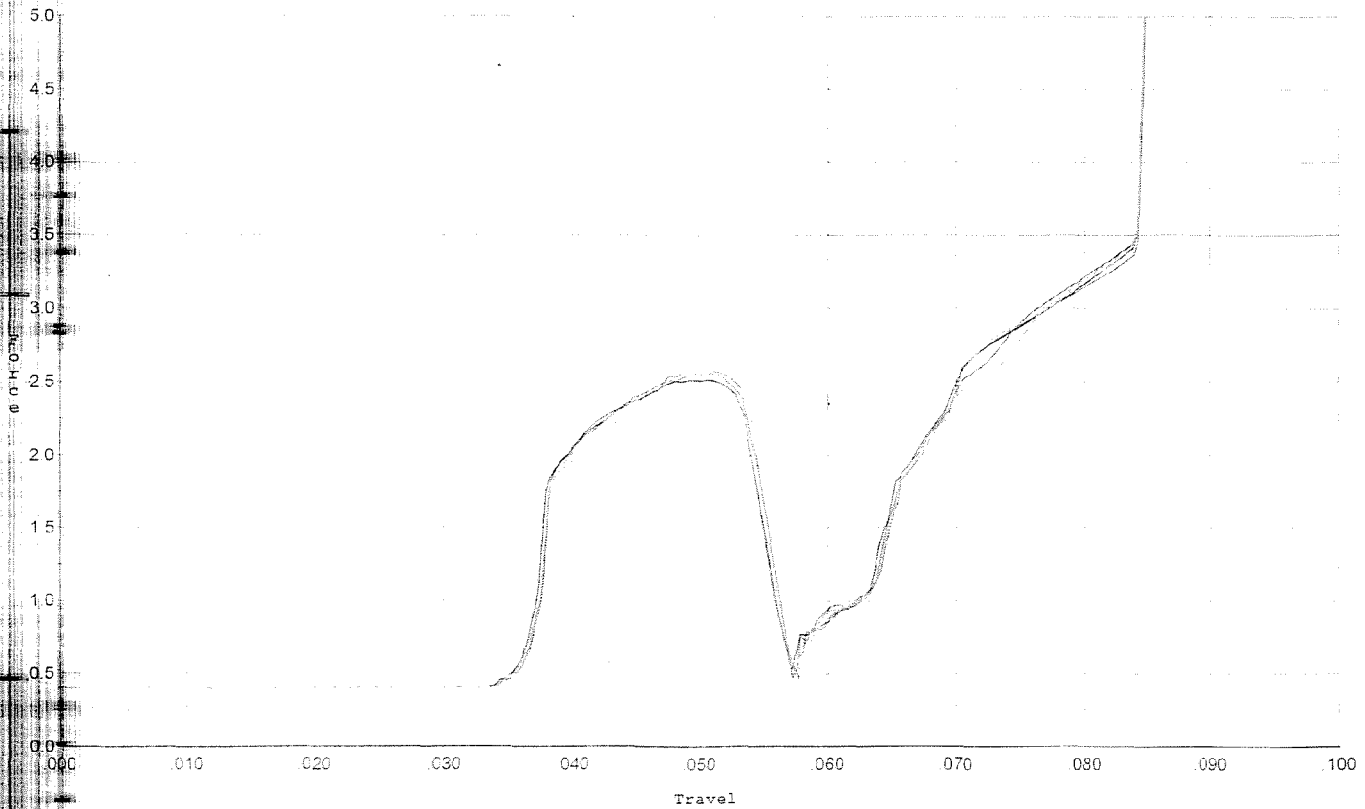
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	2-9-09	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	2-9-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	2-9-09	LJN
	J) ASSEMBLE STOCK		2-4-09	TK
	K) ASSEMBLE SWIVEL STUDS		2-9-09	LJN
	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	2-5-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-5-09	TK
670	FINAL INSPECTION A) HEADSPACE		2-9-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.41</u> <u>2.47</u> <u>2.39</u> <u>2.41</u>	2-6-09	TK
	C) FUNCTION		2-9-09	LJN
690	PACK		2-13-09	TK

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



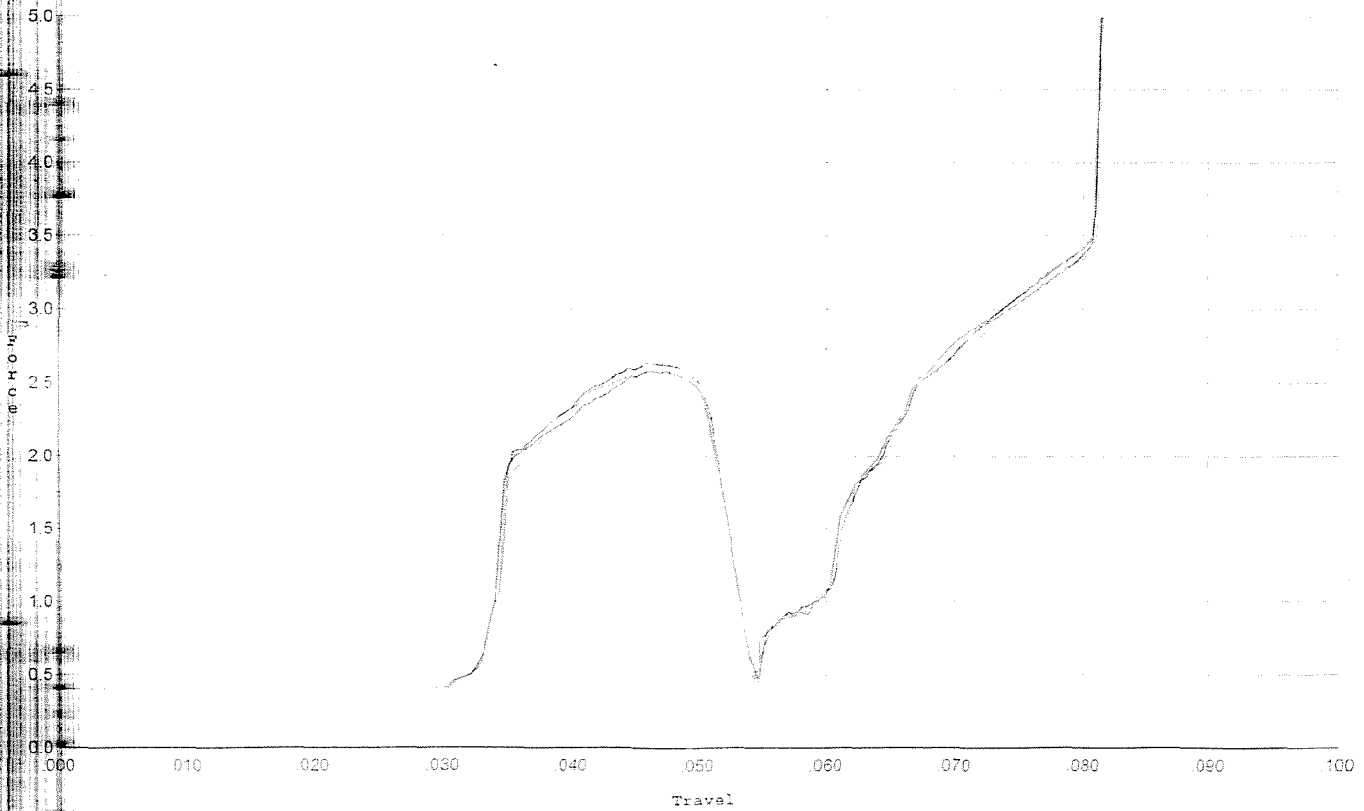
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.054	0.037	0.036	0.055		Set Trigger
2	2.514	0.054	0.036	0.036	0.054		Set Trigger
3	2.557	0.055	0.036	0.036	0.055		Set Trigger
4	2.567	0.054	0.037	0.036	0.055		Set Trigger
5	2.479	0.054	0.036	0.036	0.053		Set Trigger

Aug 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



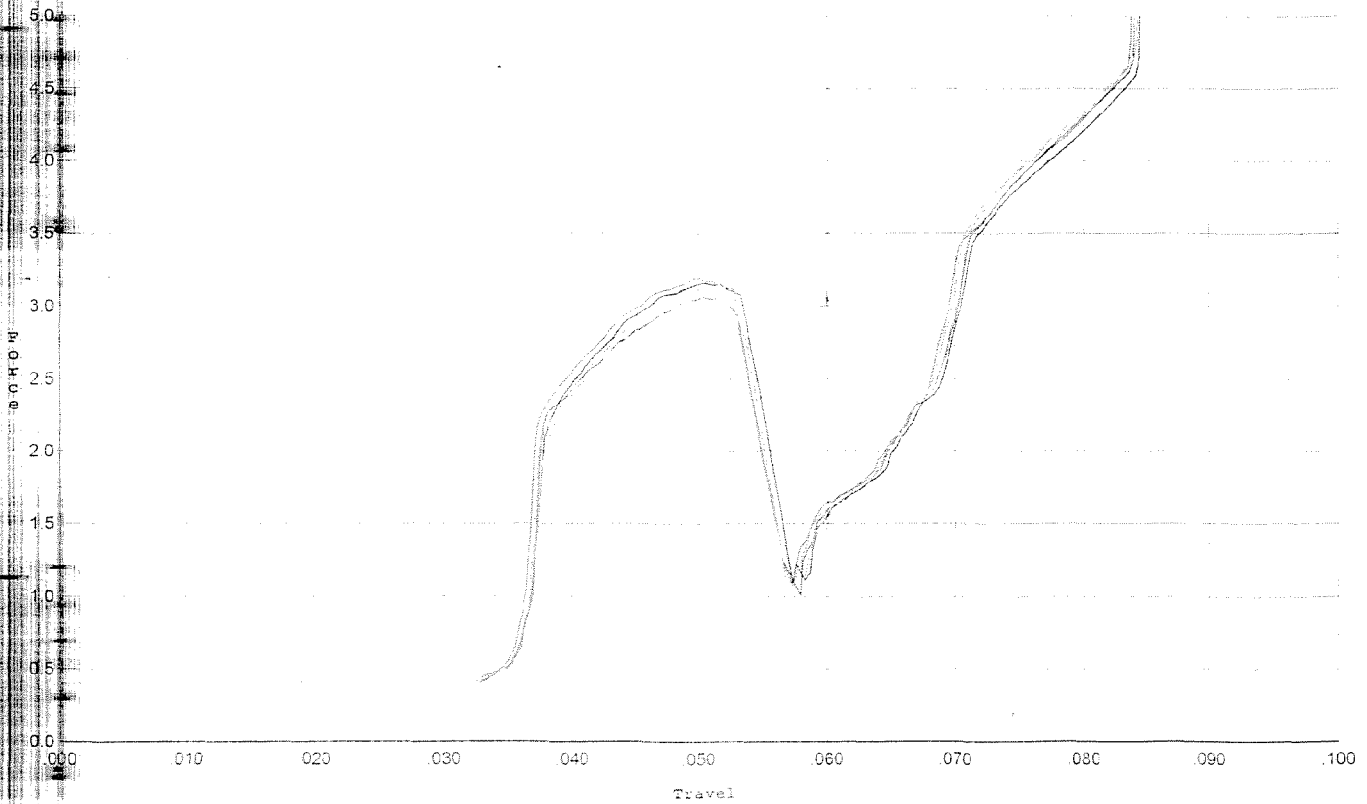
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.583	0.051	0.033	0.035	0.055		Set Trigger
2	2.634	0.051	0.033	0.034	0.055		Set Trigger
3	2.584	0.051	0.033	0.035	0.055		Set Trigger
4	2.663	0.051	0.033	0.035	0.056		Set Trigger
5	2.537	0.052	0.033	0.035	0.054		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



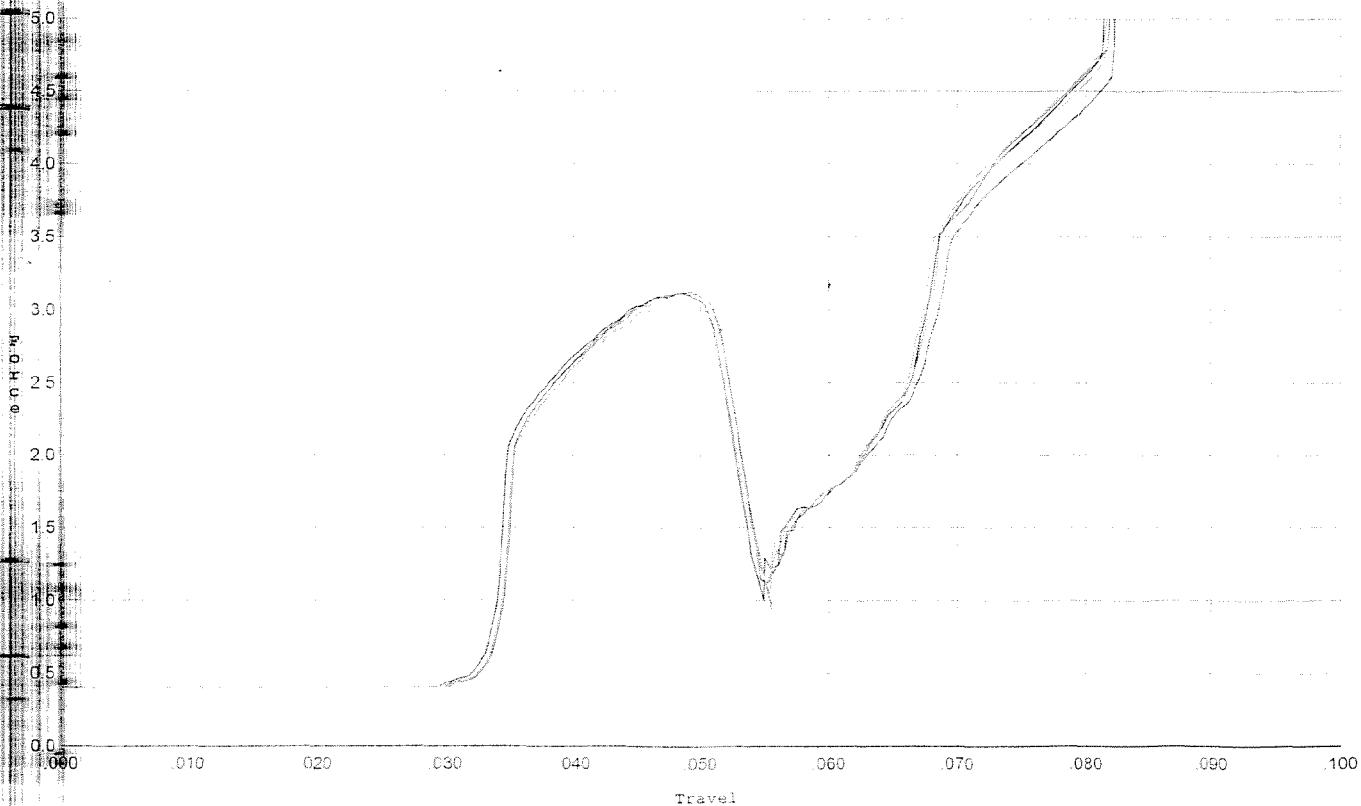
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.064	0.053	0.036	0.035	0.062		Set Trigger
2	3.158	0.055	0.036	0.035	0.066		Set Trigger
3	3.193	0.053	0.035	0.035	0.064		Set Trigger
4	3.118	0.053	0.036	0.035	0.062		Set Trigger
5	3.047	0.054	0.036	0.035	0.063		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



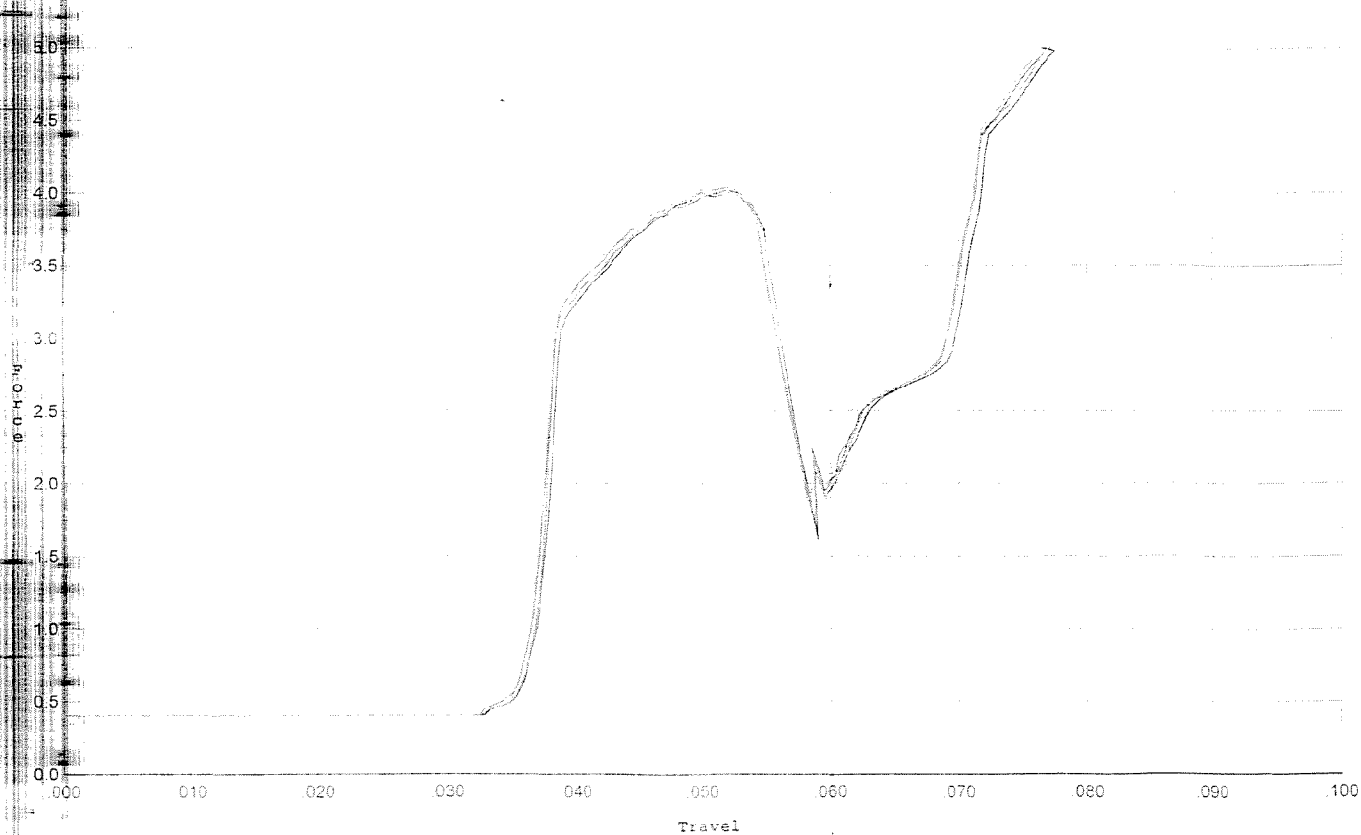
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.052	0.033	0.034	0.063		Set Trigger
2	3.107	0.051	0.033	0.034	0.063		Set Trigger
3	3.111	0.052	0.034	0.034	0.063		Set Trigger
4	3.060	0.051	0.034	0.034	0.061		Set Trigger
5	3.042	0.051	0.034	0.034	0.061		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



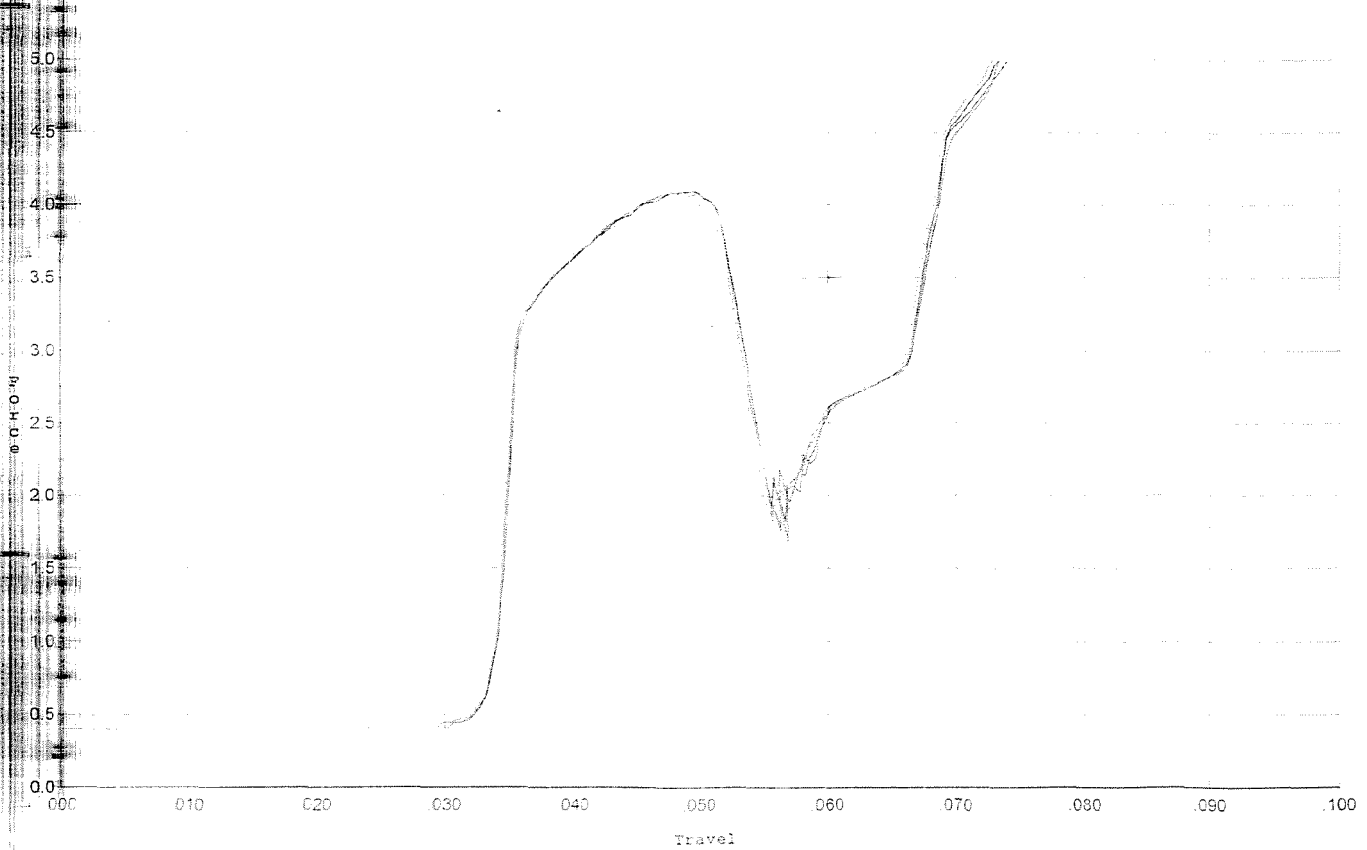
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.017	0.054	0.036	0.033	0.081		Set Trigger
2	4.007	0.055	0.036	0.033	0.082		Set Trigger
3	4.038	0.054	0.036	0.033	0.081		Set Trigger
4	4.000	0.055	0.036	0.033	0.083		Set Trigger
5	4.064	0.054	0.035	0.033	0.082		Set Trigger

Aug 4.02

Trigger Profile [lbs,inch]

Profile
GunType: Rifle
Make: Remington
Note: 1/20/09

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



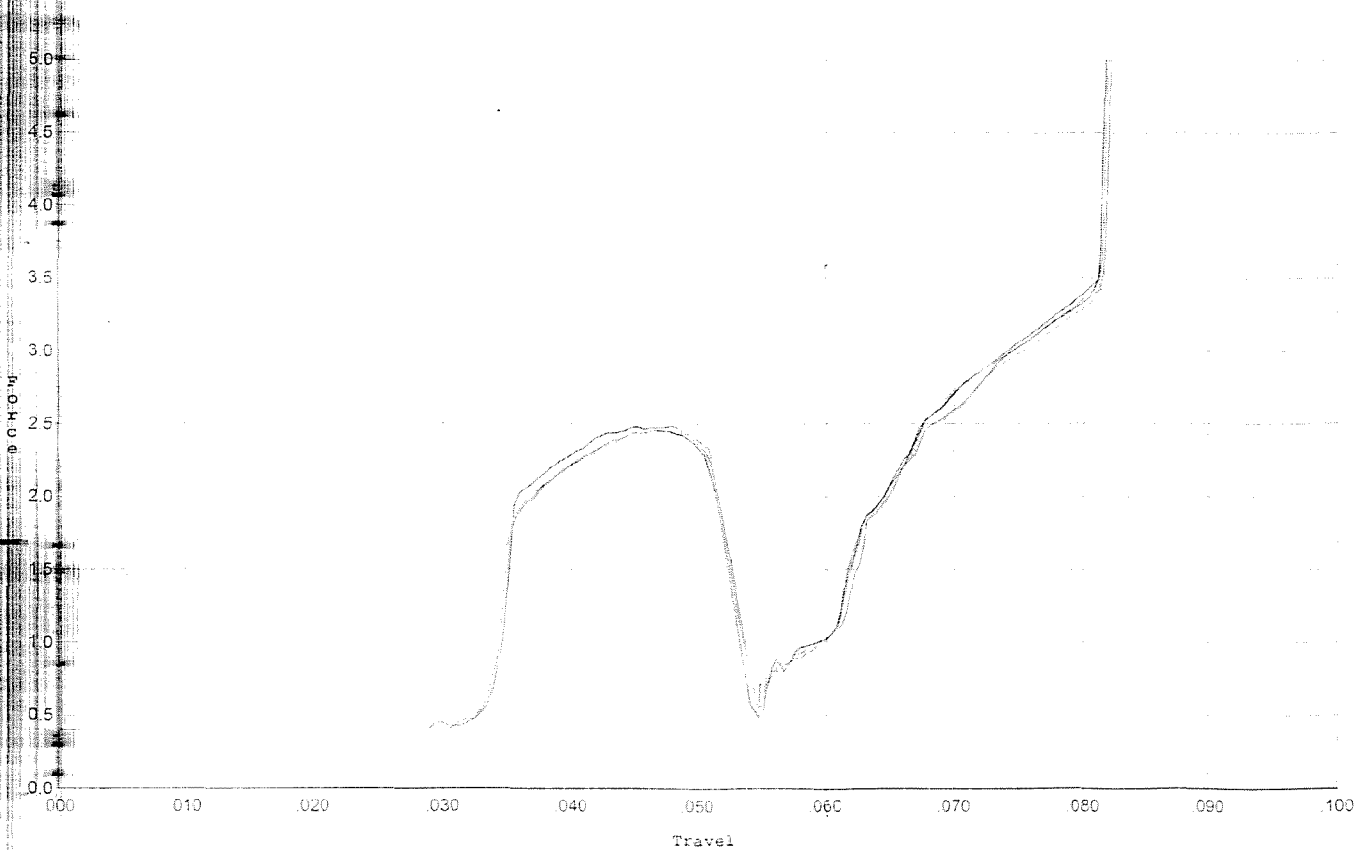
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.093	0.052	0.033	0.033	0.081		Set Trigger
2	4.091	0.053	0.033	0.033	0.084		Set Trigger
3	4.076	0.053	0.033	0.033	0.084		Set Trigger
4	4.030	0.052	0.033	0.033	0.082		Set Trigger
5	4.082	0.052	0.033	0.033	0.082		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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



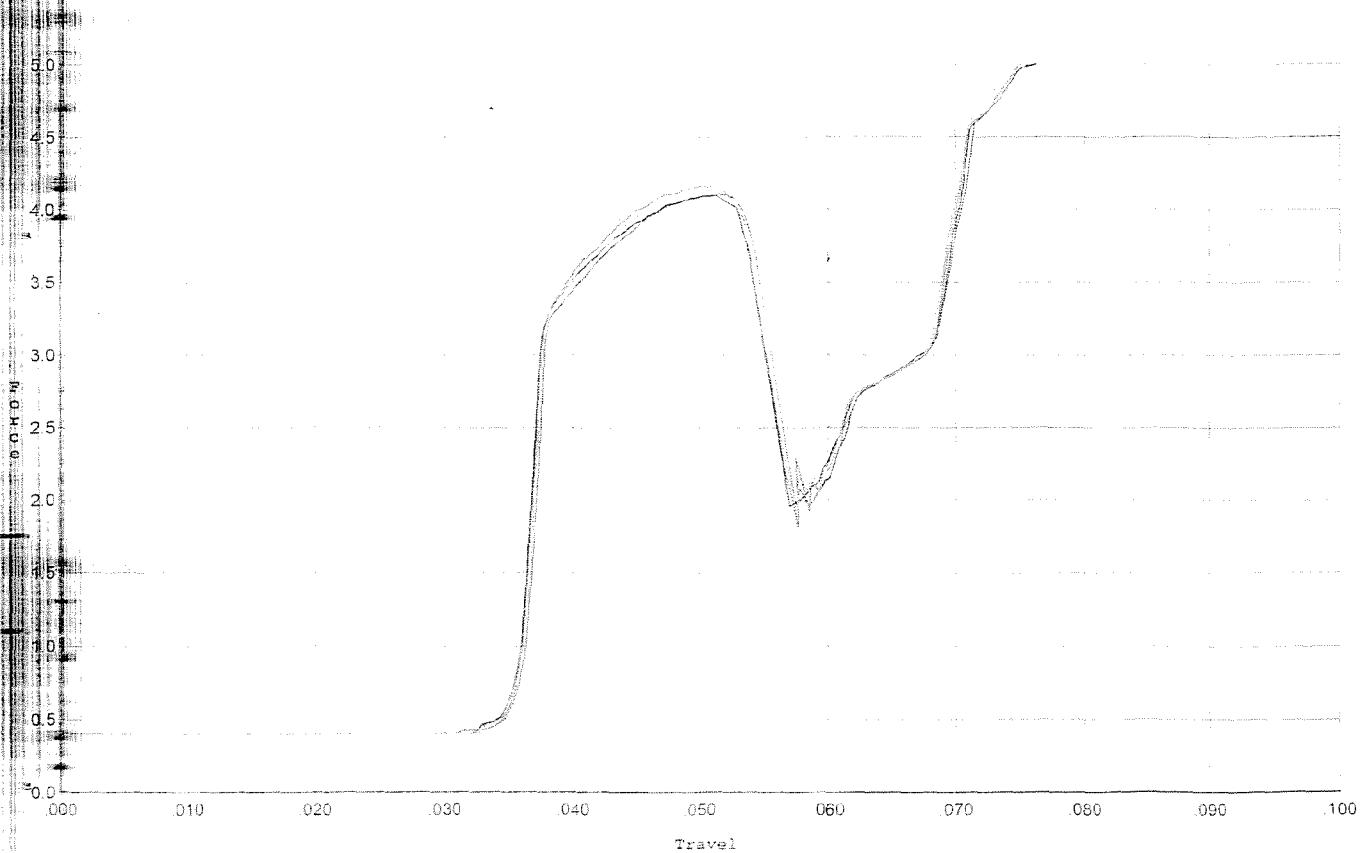
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.053	0.034	0.035	0.055		Set Trigger
2	2.456	0.051	0.034	0.035	0.053		Set Trigger
3	2.466	0.051	0.034	0.035	0.052		Set Trigger
4	2.470	0.051	0.034	0.035	0.053		Set Trigger
5	2.461	0.051	0.034	0.035	0.053		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 1/20/09

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	4.107	0.054	0.035	0.033	0.084		Set Trigger
2	4.097	0.054	0.035	0.033	0.084		Set Trigger
3	4.162	0.054	0.035	0.033	0.084		Set Trigger
4	4.139	0.054	0.035	0.033	0.083		Set Trigger
5	4.251	0.054	0.035	0.032	0.086		Set Trigger

Avg 4.15