

G680 7674

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



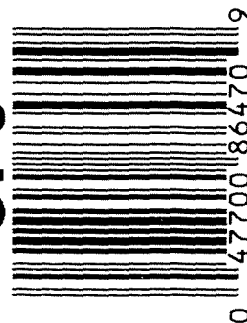
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807674

UPC



BM FORM

GUN SERIAL # G 680 76 74

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-21-09	SP
430	ASSEMBLE TO STOCK		1-21-09	SP
440	PROOF		1-21-09	SP
460	CHECK HEADSPACE		1-21-09	SP
470	DIS-ASSEMBLE ACTION		1-21-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	1-22-09	SP
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	1/23/09	SP
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	NT
520	GOFF BLAST BBL / REC		1/24/09	SP
542	APPLY COATINGS (BARREL ACTION)		730	
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		1-30-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

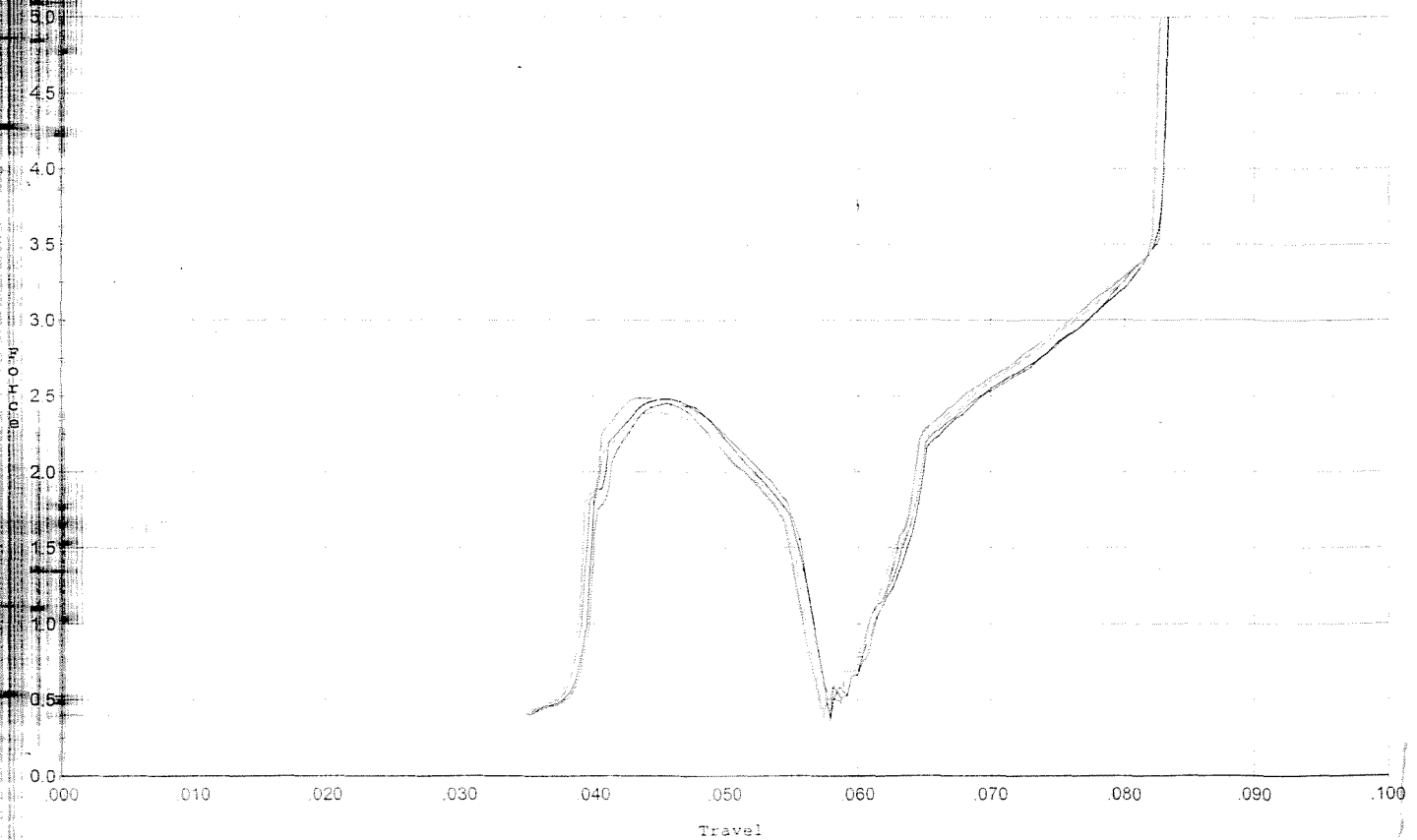
F004 REV 5/2006

BARBER - M24 0016231		2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	2-6-09	LJ		
560	F) SAFETY ON FORCE								
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	2-6-09	LJ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.025</u>	2-6-09	LJ		
	J) ASSEMBLE STOCK					1-30-09	LJ		
	K) ASSEMBLE SWIVEL STUDS					2-6-09	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		2-3-09	LJ		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					2-3-09	LJ		
670	FINAL INSPECTION A) HEADSPACE					2-6-09	LJ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u>	<u>2.49</u>	<u>2.53</u>	<u>2.52</u>	<u>2.61</u>	2-4-09	LJ
	C) FUNCTION					2-6-09	LJ		
690	PACK					2/16/09	Fm		

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



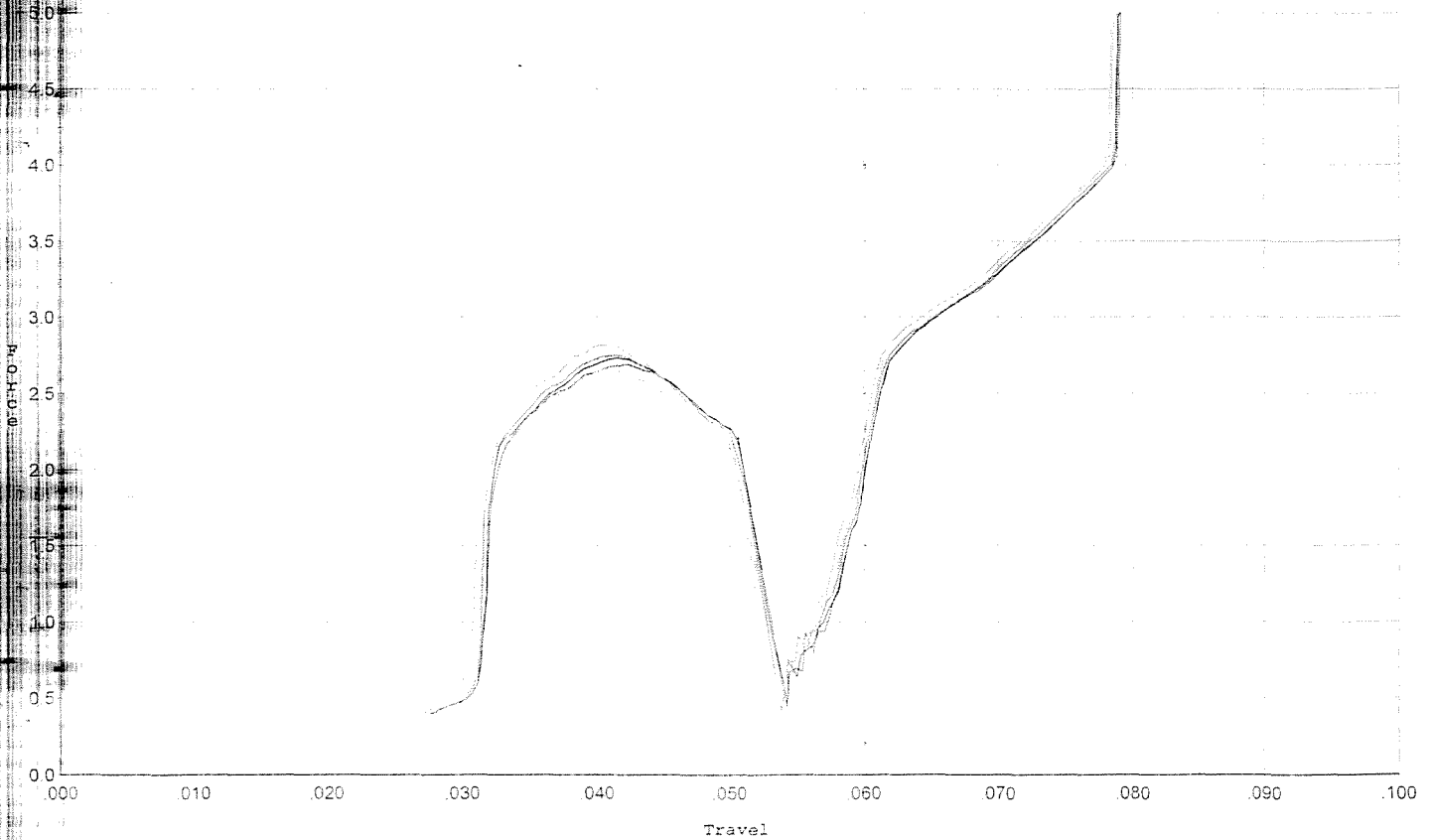
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.056	0.039	0.034	0.051		Set Trigger
2	2.480	0.056	0.039	0.034	0.052		Set Trigger
3	2.485	0.054	0.038	0.035	0.050		Set Trigger
4	2.480	0.054	0.038	0.035	0.051		Set Trigger
5	2.391	0.055	0.038	0.034	0.051		Set Trigger

A. 2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



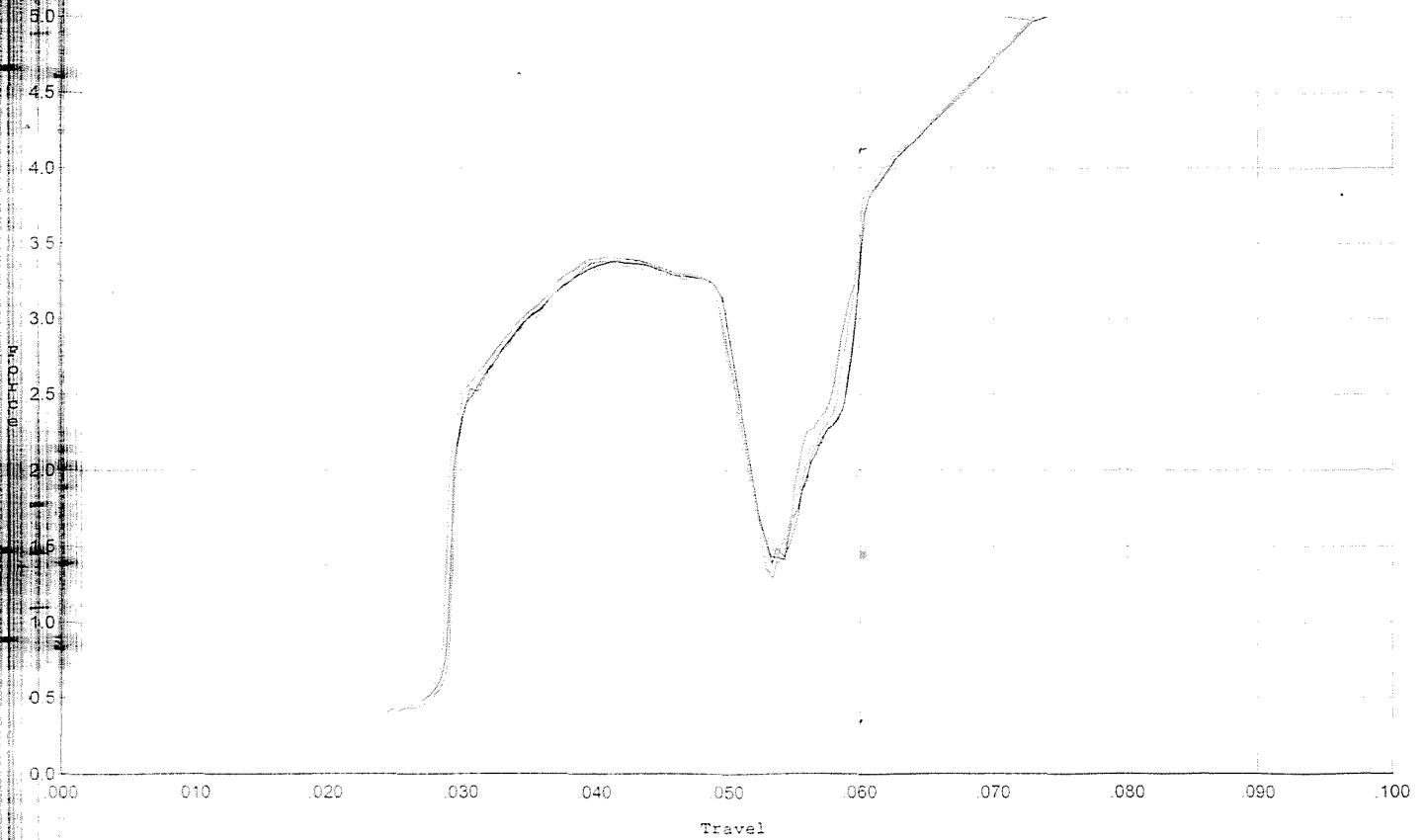
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.051	0.031	0.032	0.060		Set Trigger
2	2.730	0.051	0.031	0.032	0.060		Set Trigger
3	2.748	0.051	0.031	0.032	0.061		Set Trigger
4	2.658	0.052	0.031	0.032	0.061		Set Trigger
5	2.816	0.050	0.030	0.031	0.062		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



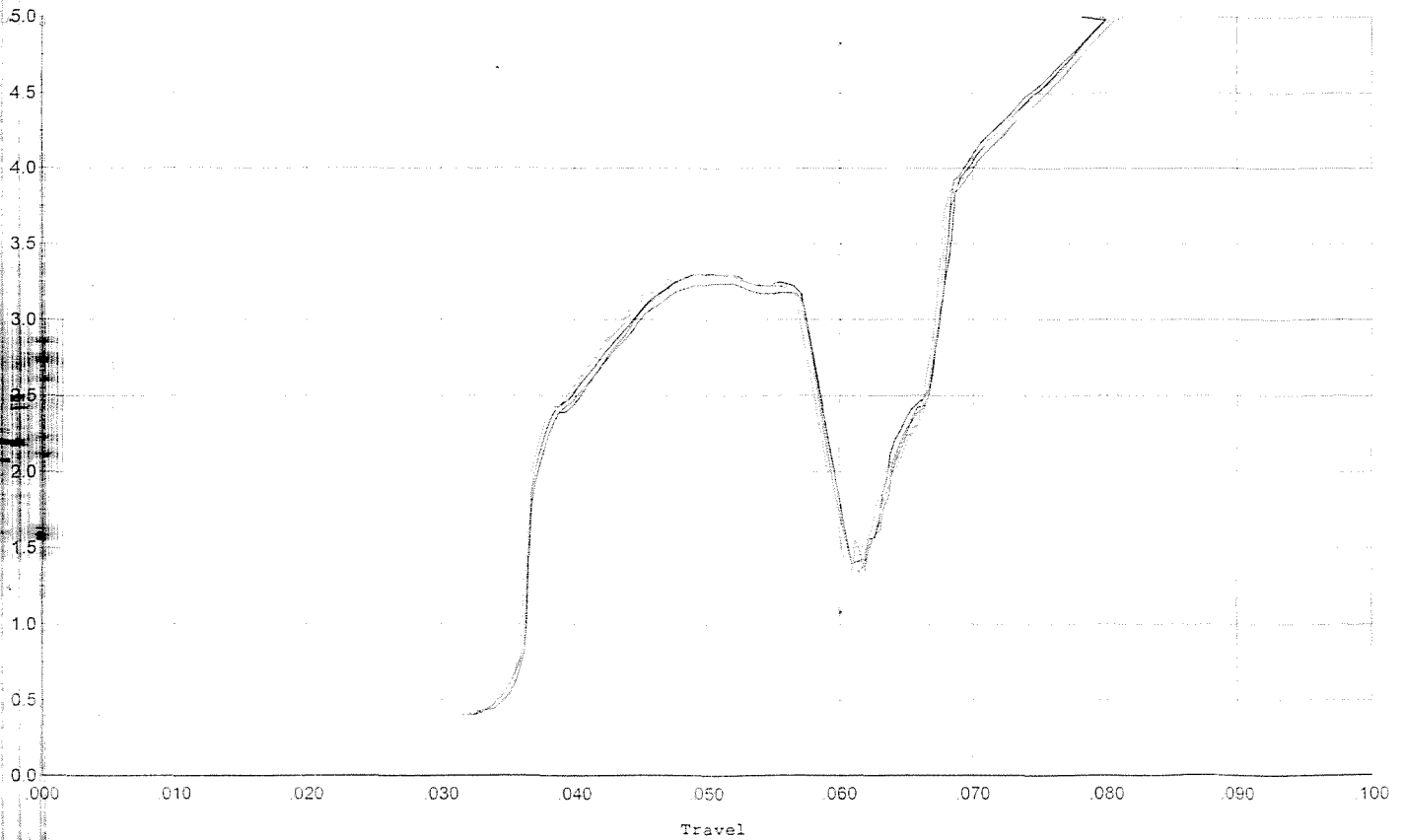
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.388	0.050	0.029	0.030	0.076		Set Trigger
2	3.380	0.050	0.029	0.029	0.077		Set Trigger
3	3.408	0.051	0.028	0.029	0.079		Set Trigger
4	3.388	0.051	0.028	0.029	0.079		Set Trigger
5	3.347	0.049	0.028	0.029	0.075		Set Trigger

A-3-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



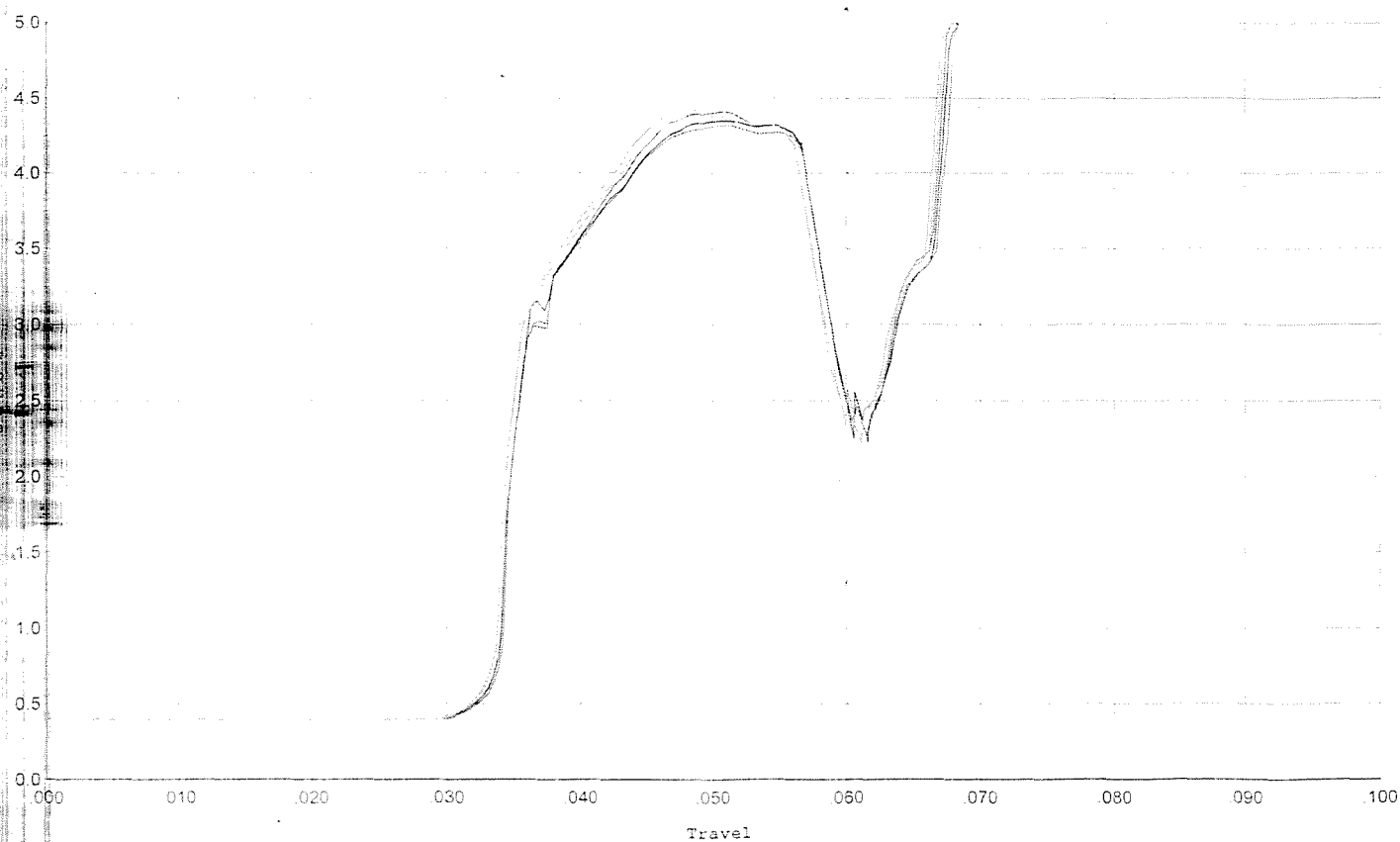
Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
3.237	0.059	0.036	0.032	0.080		Set Trigger
3.307	0.057	0.035	0.032	0.079		Set Trigger
3.299	0.057	0.036	0.032	0.078		Set Trigger
3.312	0.057	0.036	0.032	0.079		Set Trigger
3.318	0.058	0.035	0.032	0.081		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



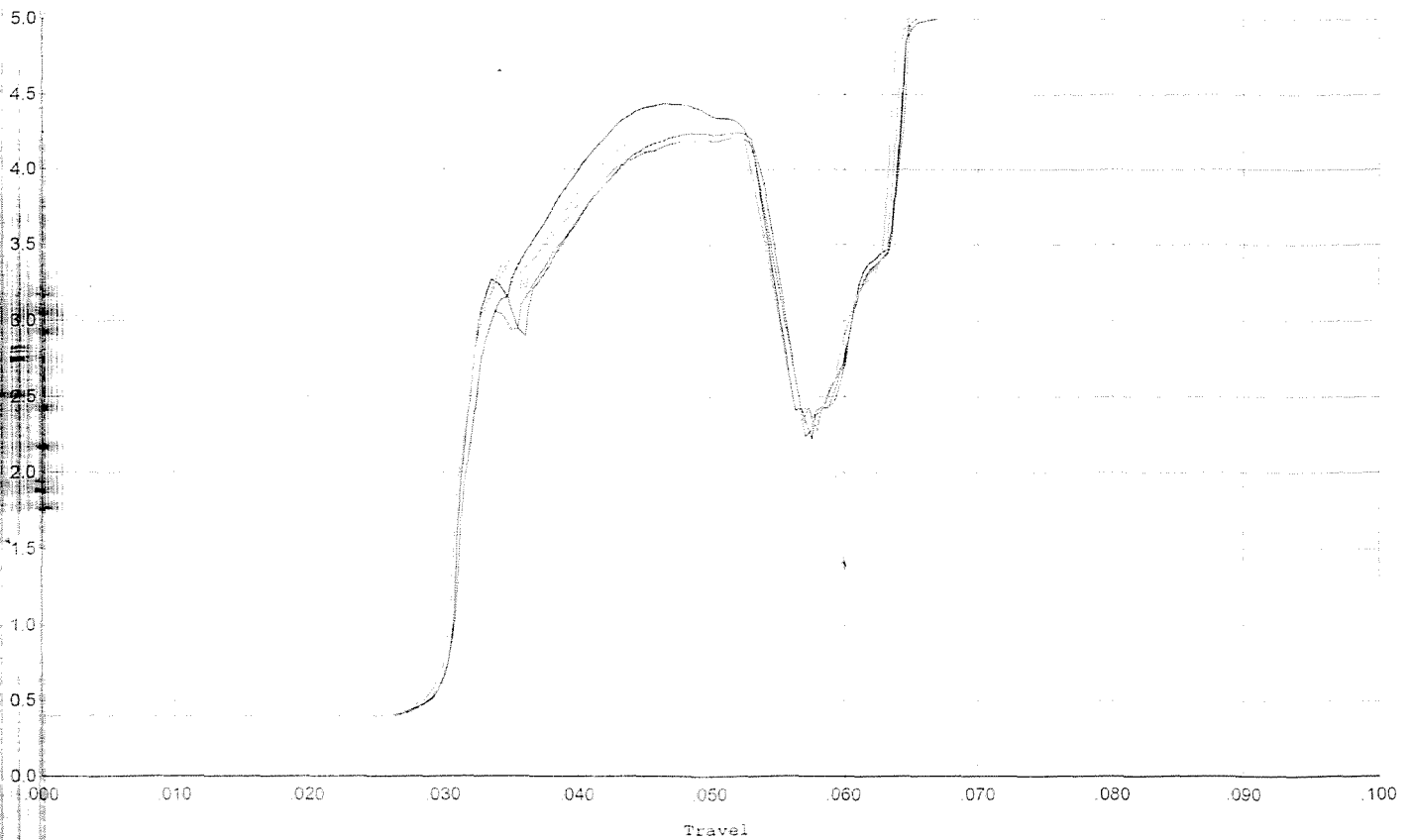
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.410	0.057	0.034	0.023	0.104		Set Trigger
2	4.350	0.057	0.033	0.024	0.104		Set Trigger
3	4.319	0.057	0.033	0.024	0.103		Set Trigger
4	4.382	0.056	0.033	0.024	0.103		Set Trigger
5	4.430	0.056	0.033	0.024	0.104		Set Trigger

A-4.37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



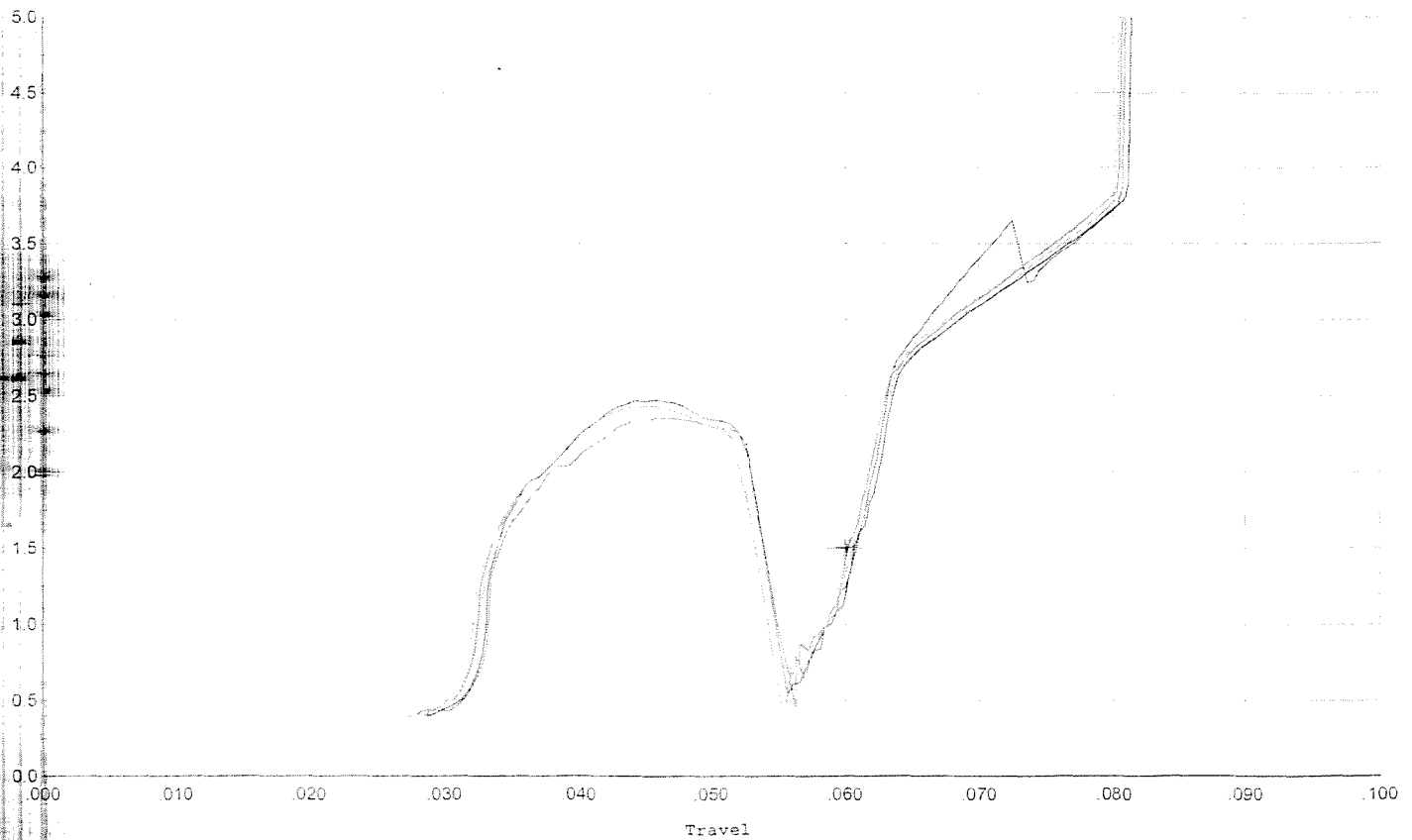
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.249	0.054	0.030	0.024	0.099		Set Trigger
2	4.440	0.053	0.030	0.024	0.102		Set Trigger
3	4.218	0.053	0.030	0.024	0.097		Set Trigger
4	4.265	0.054	0.030	0.024	0.102		Set Trigger
5	4.221	0.054	0.030	0.024	0.100		Set Trigger

A-4-27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



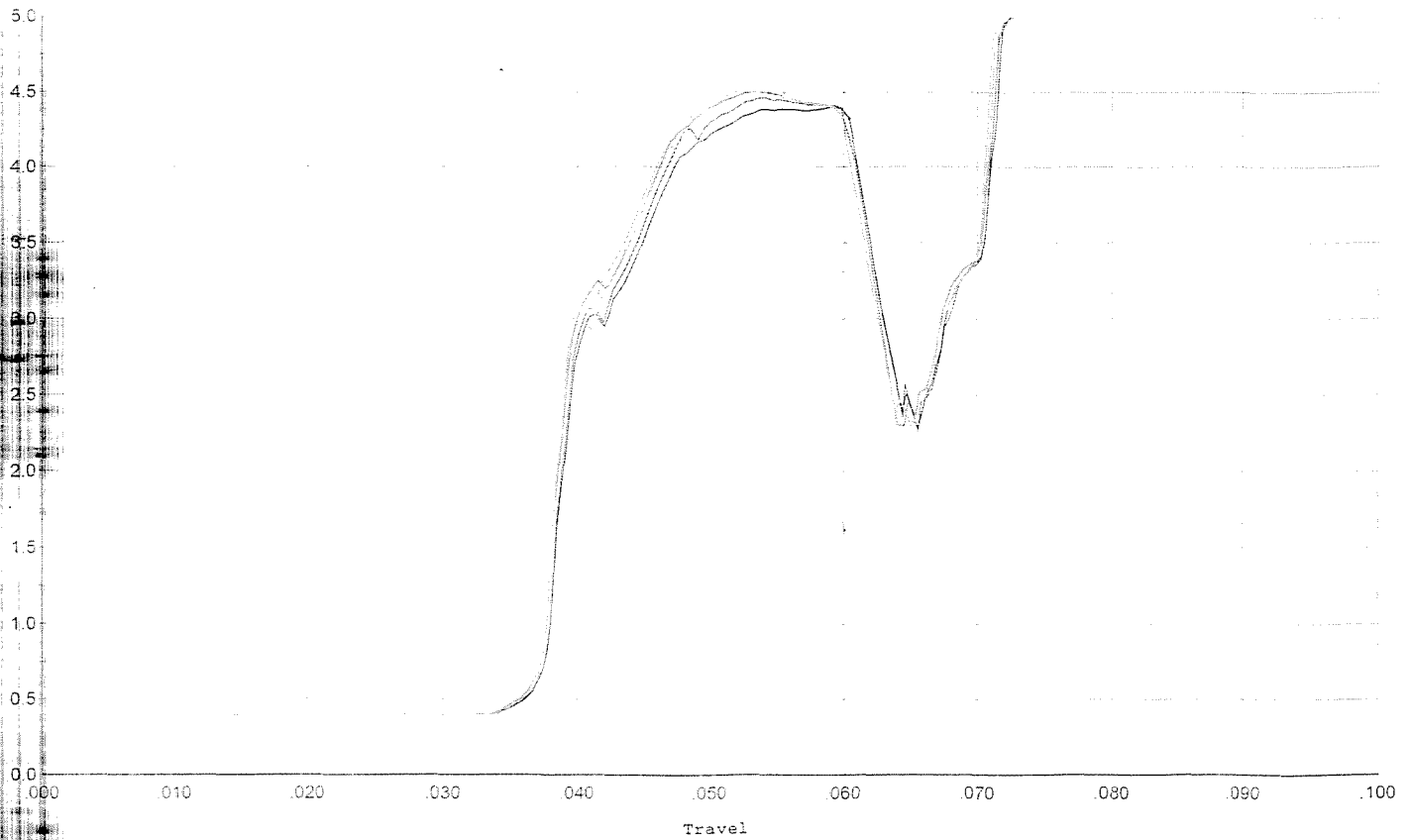
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.358	0.053	0.032	0.033	0.056		Set Trigger
2	2.475	0.053	0.032	0.033	0.058		Set Trigger
3	2.439	0.053	0.032	0.033	0.057		Set Trigger
4	2.338	0.053	0.032	0.033	0.057		Set Trigger
5	2.349	0.053	0.031	0.033	0.057		Set Trigger

A.239

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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	4.464	0.060	0.037	0.024	0.106		Set Trigger
2	4.404	0.060	0.037	0.024	0.105		Set Trigger
3	4.501	0.061	0.037	0.024	0.109		Set Trigger
4	4.499	0.060	0.037	0.024	0.106		
5	4.528	0.060	0.037	0.024	0.106		

A. 4.47