

G 680 7687

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



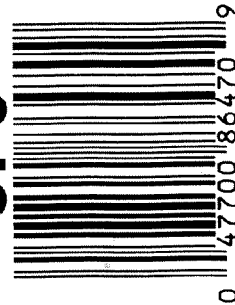
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807687

UPC



BM FORM

GUN SERIAL #

G 680 7687

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RP
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION		3/25/09	RP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

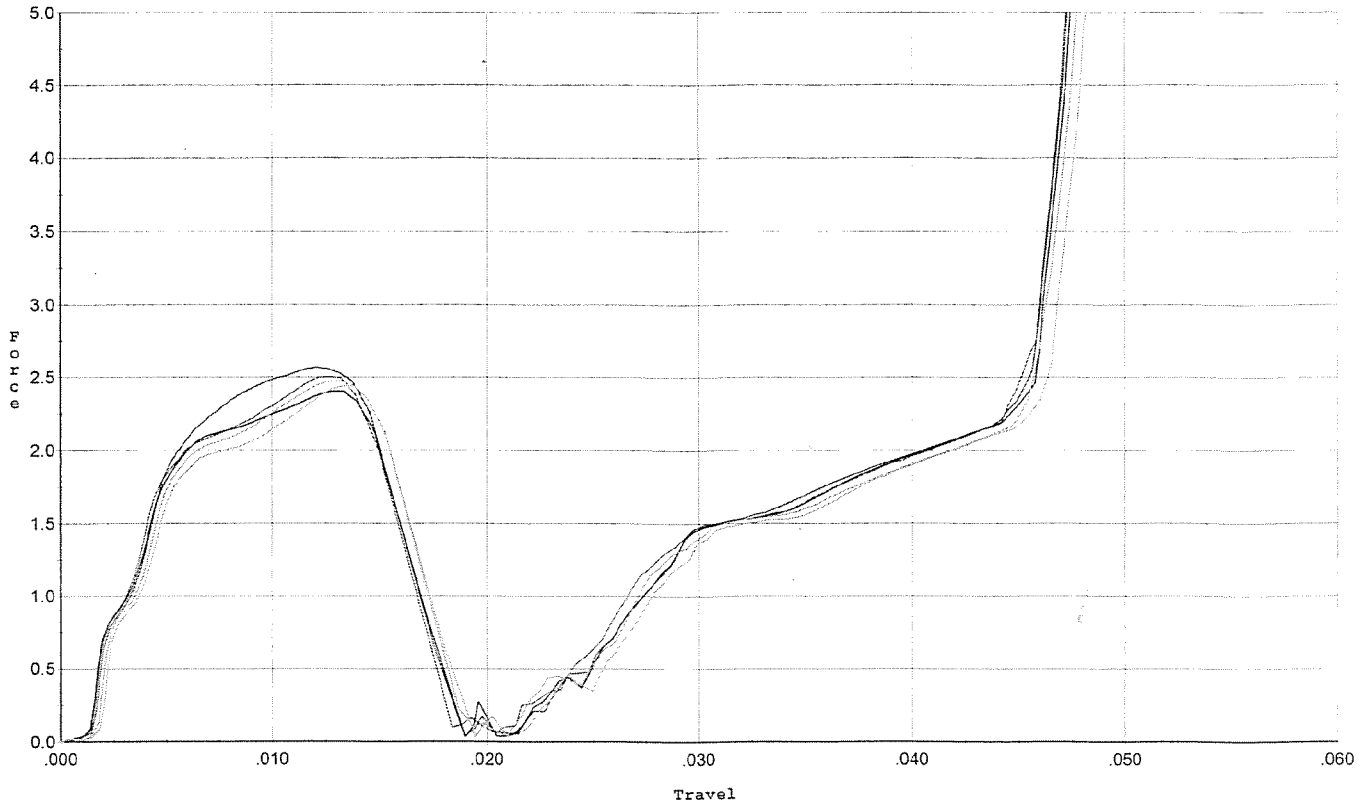
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4</u> <u>6</u>	4-13-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	4-13-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-13-09	WN
	J) ASSEMBLE STOCK		4-2-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-13-09	WN
	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	4-14-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-4-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-13-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>233</u> <u>243</u> <u>243</u> <u>226</u> <u>236</u>	4-7-09	RP
	C) FUNCTION		4-13-09	WN
690	PACK		8/13/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



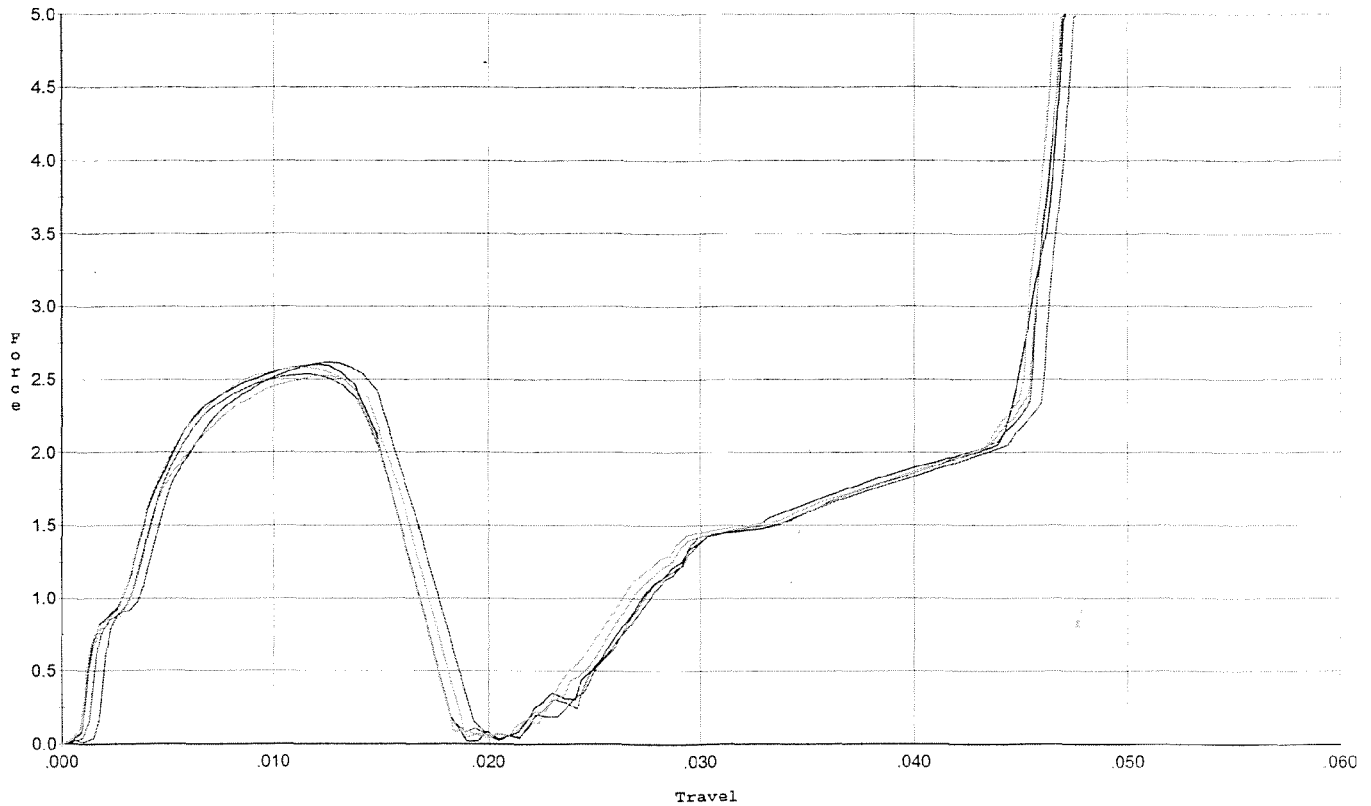
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.566	0.015	0.00	0.036	0.025		Set Trigger
2	2.404	0.015	0.00	0.036	0.024		Set Trigger
3	2.502	0.015	0.00	0.036	0.025		Set Trigger
4	2.439	0.015	0.00	0.037	0.024		Set Trigger
5	2.472	0.015	0.00	0.036	0.025		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



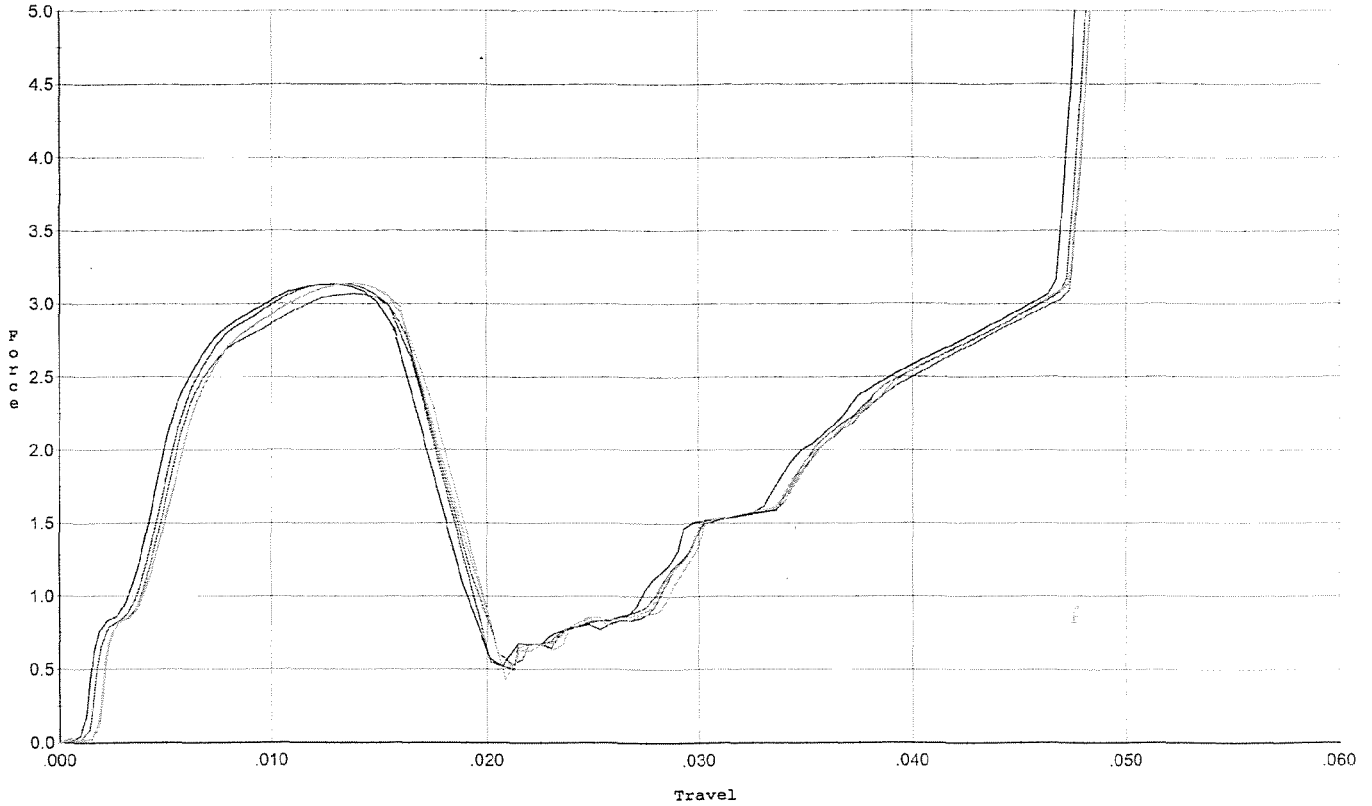
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.615	0.017	0.00	0.035	0.029		Set Trigger
2	2.601	0.015	0.00	0.036	0.027		Set Trigger
3	2.535	0.015	0.00	0.036	0.026		Set Trigger
4	2.582	0.015	0.00	0.036	0.027		Set Trigger
5	2.524	0.016	0.00	0.036	0.027		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



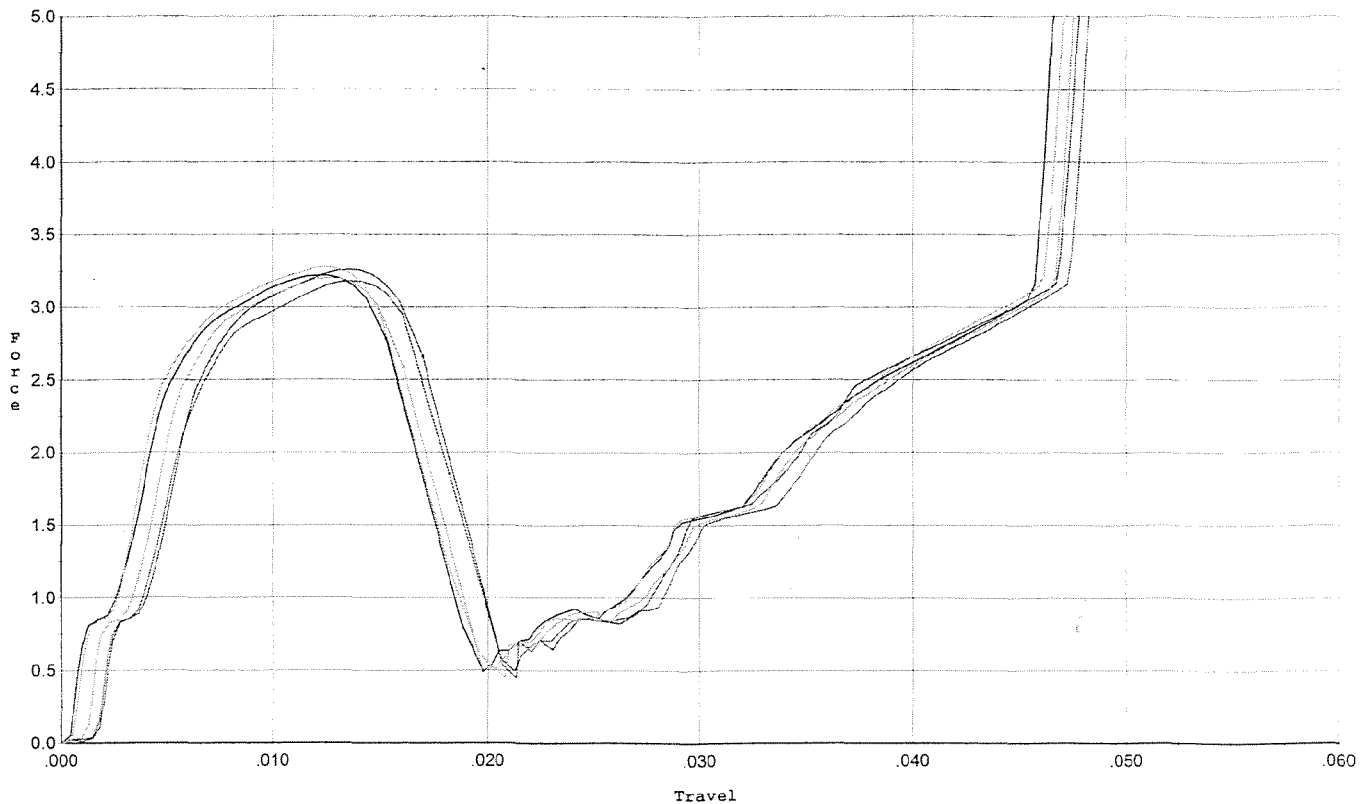
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.137	0.017	0.00	0.035	0.034		Set Trigger
2	3.131	0.016	0.00	0.035	0.033		Set Trigger
3	3.069	0.016	0.002	0.035	0.032		Set Trigger
4	3.145	0.016	0.002	0.035	0.032		Set Trigger
5	3.144	0.018	0.00	0.034	0.035		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



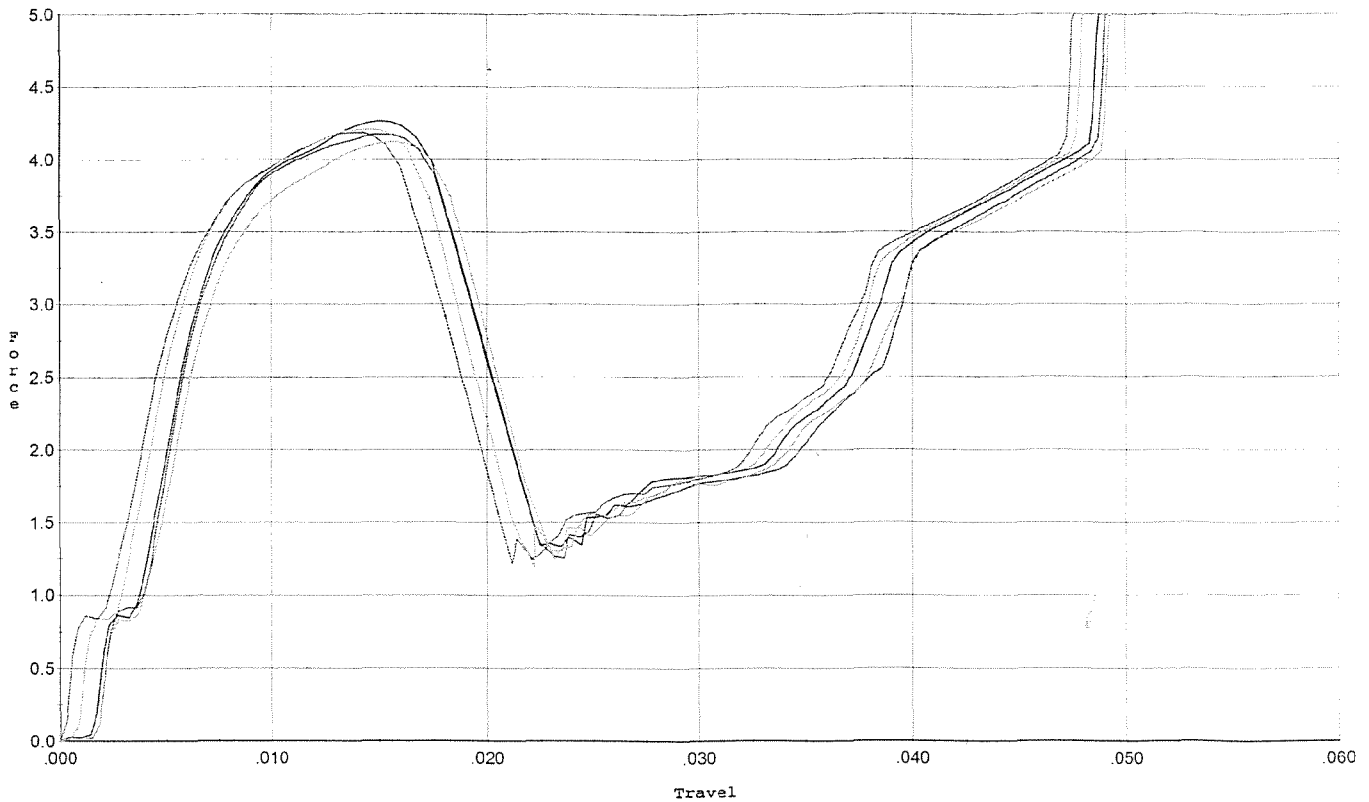
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.261	0.017	0.00	0.034	0.035		Set Trigger
2	3.214	0.015	0.00	0.034	0.034		Set Trigger
3	3.174	0.018	0.00	0.034	0.037		Set Trigger
4	3.275	0.015	0.00	0.034	0.034		Set Trigger
5	3.195	0.016	0.00	0.034	0.034		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



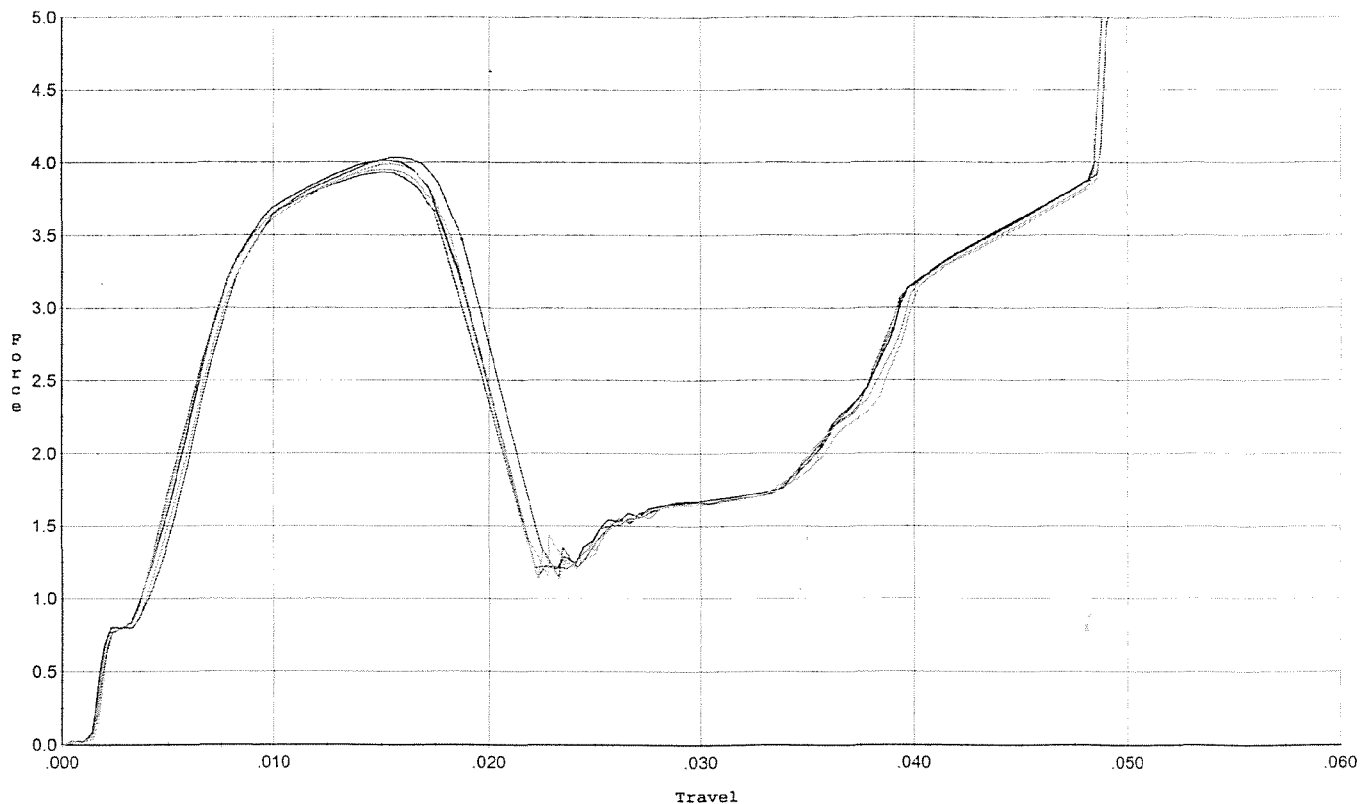
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.018	0.00	0.033	0.047		Set Trigger
2	4.264	0.020	0.00	0.032	0.054		Set Trigger
3	4.185	0.018	0.00	0.032	0.051		Set Trigger
4	4.207	0.017	0.00	0.032	0.048		Set Trigger
5	4.123	0.018	0.00	0.032	0.048		Set Trigger

A. 4.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



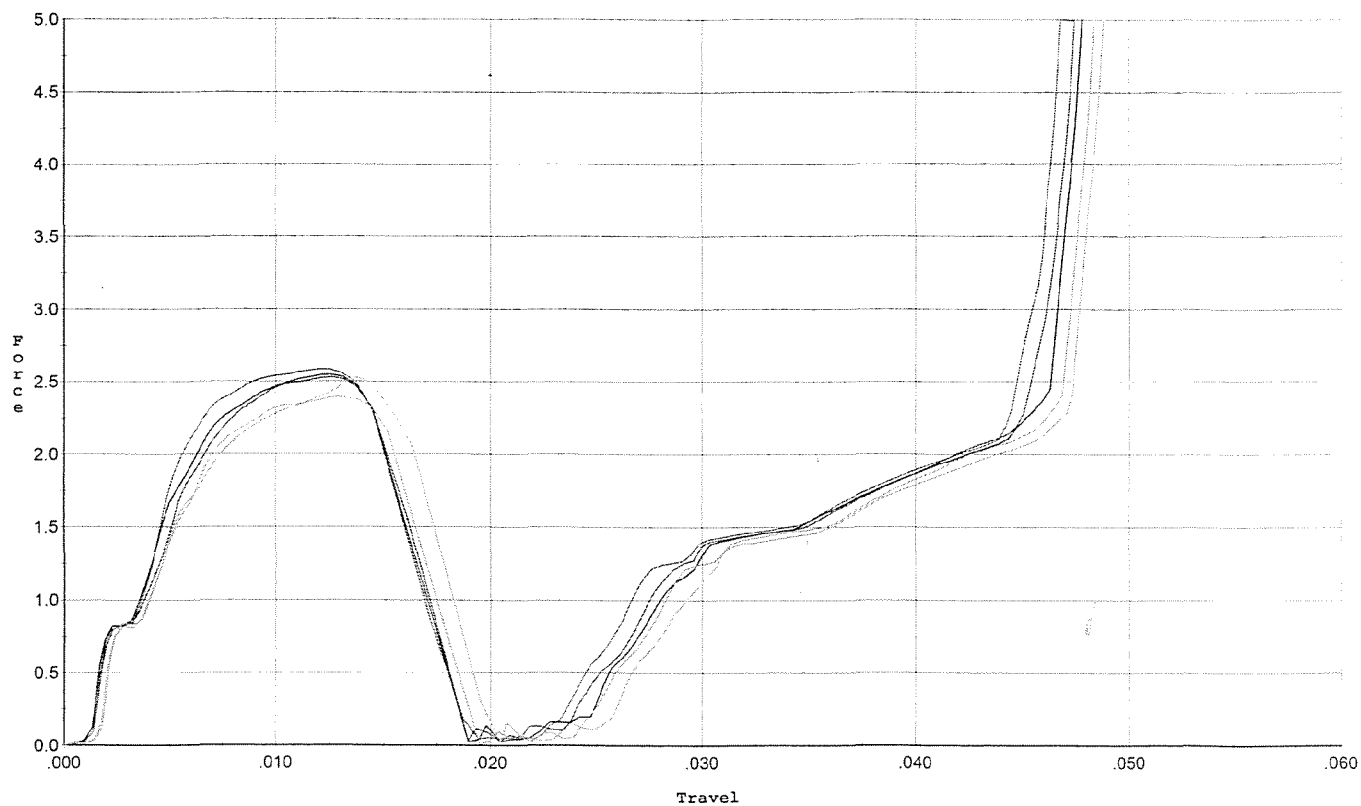
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.034	0.019	0.00	0.032	0.047		Set Trigger
2	4.014	0.019	0.00	0.032	0.047		Set Trigger
3	3.934	0.020	0.00	0.032	0.049		Set Trigger
4	3.990	0.018	0.00	0.032	0.045		Set Trigger
5	3.951	0.019	0.00	0.032	0.047		Set Trigger

A-3.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/27/2009

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



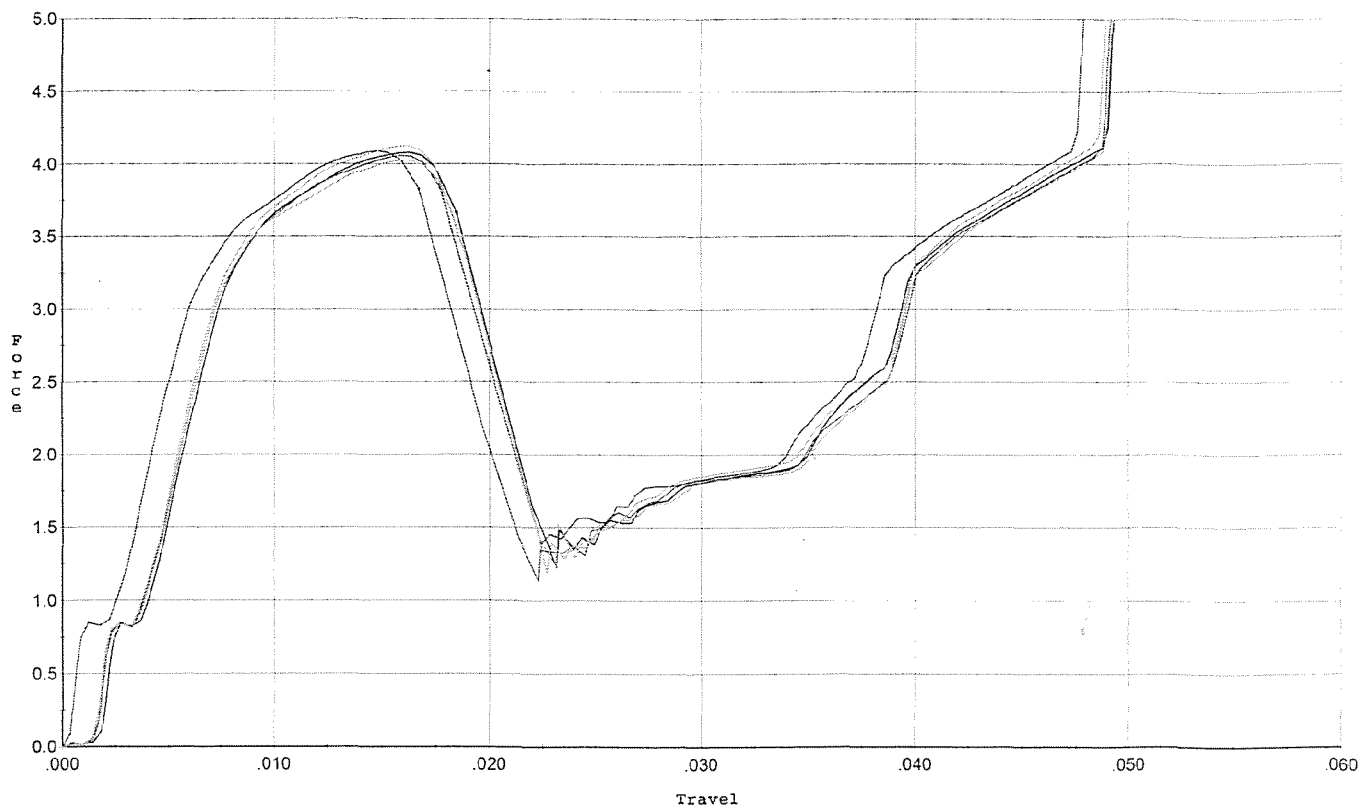
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.016	0.00	0.036	0.027		Set Trigger
2	2.547	0.014	0.00	0.037	0.024		Set Trigger
3	2.585	0.014	0.00	0.036	0.025		Set Trigger
4	2.533	0.016	0.00	0.037	0.027		Set Trigger
5	2.396	0.015	0.00	0.037	0.024		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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	4.090	0.017	0.00	0.032	0.045		Set Trigger
2	4.080	0.018	0.00	0.032	0.047		Set Trigger
3	4.059	0.018	0.00	0.033	0.045		Set Trigger
4	4.126	0.019	0.00	0.032	0.049		Set Trigger
5	4.024	0.019	0.00	0.032	0.048		Set Trigger

A 4.07