

G684 5285

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

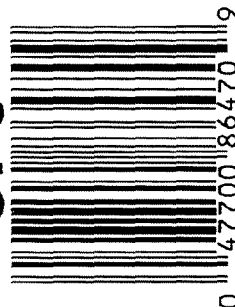
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6845285

UPC



GUN SERIAL #

G 6845285

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-4-09	RP
430	ASSEMBLE TO STOCK		5-4-09	SP
440	PROOF		5-4-09	RP
460	CHECK HEADSPACE		5-4-09	RP
470	DIS-ASSEMBLE ACTION		5-4-09	RP
472	SERIALIZE BOLT HANDLE		5-5-09	RT
480	MAGNAFLUX BBL ACTION		5/6/09	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/7/09	RT
510	DRILL AND TAP SIGHT HOLES		5-5-09	SP
520	GOFF BLAST BBL / REC		5/7/09	RS M
540	APPLY COATINGS (BARREL ACTION)		5/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-14-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-14-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-14-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-20-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

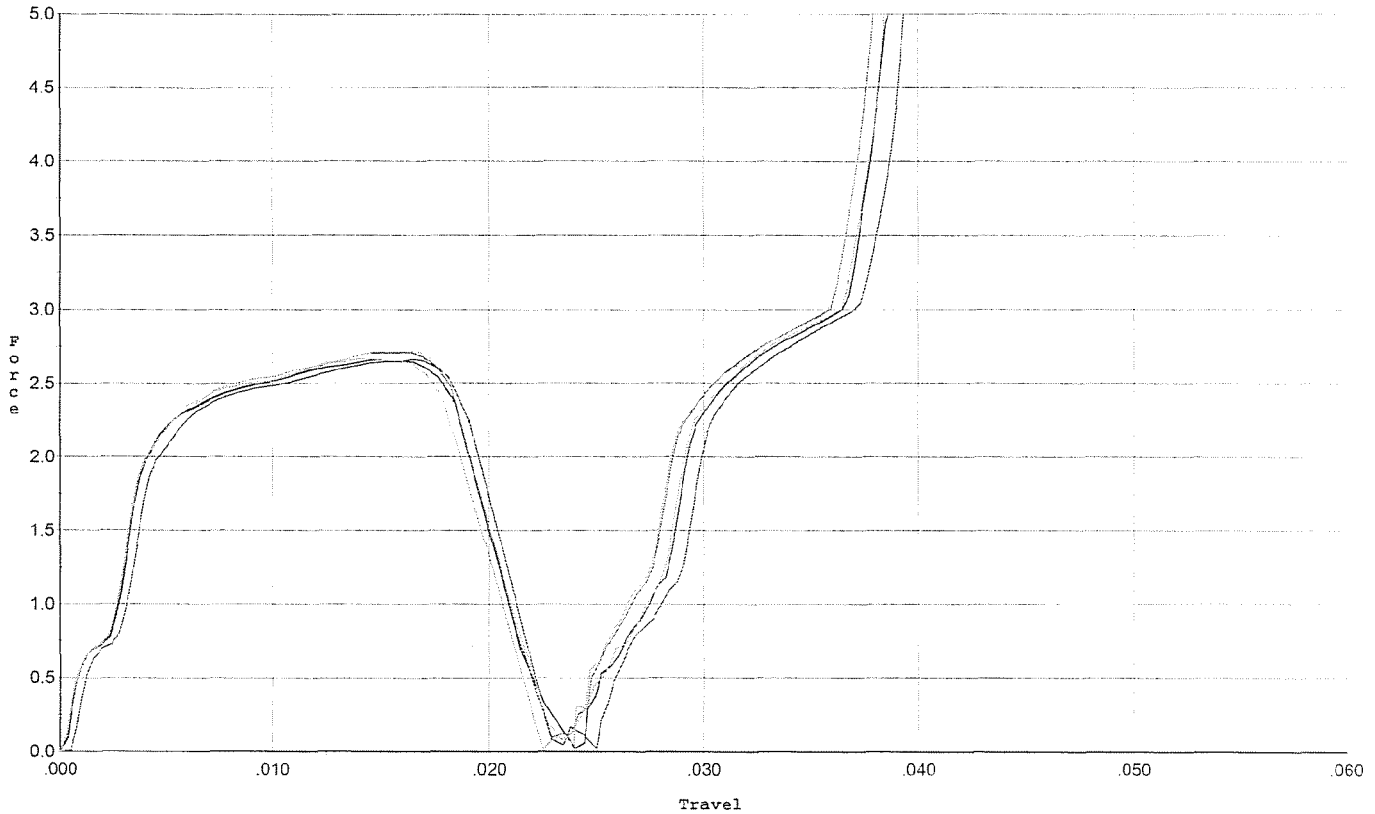
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>48</u> <u>40</u>	6-15-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-15-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.032</u> <u>.032</u> <u>.032</u>	6-15-09	LN
	J) ASSEMBLE STOCK		5-20-09	LN
	K) ASSEMBLE SWIVEL STUDS		6-15-09	LN
	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	6/10/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/10/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-15-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.49</u> <u>2.46</u> <u>2.40</u> <u>2.44</u>	6-15-09	RTZ
	C) FUNCTION		6-15-09	LN
690	PACK		6/17/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



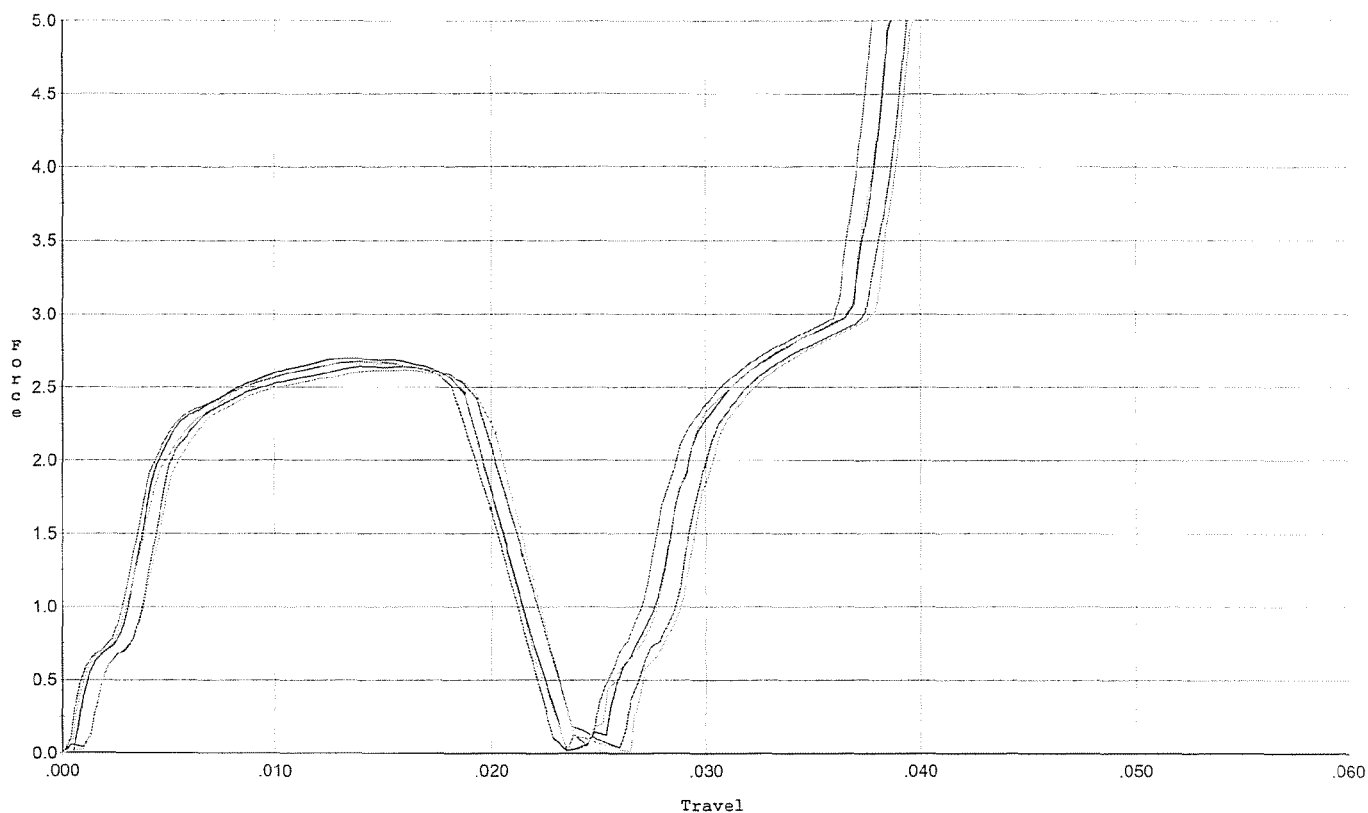
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.019	0.00	0.026	0.038		Set Trigger
2	2.663	0.018	0.00	0.026	0.037		Set Trigger
3	2.712	0.018	0.00	0.025	0.037		Set Trigger
4	2.725	0.018	0.00	0.025	0.037		Set Trigger
5	2.668	0.020	0.00	0.026	0.040		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



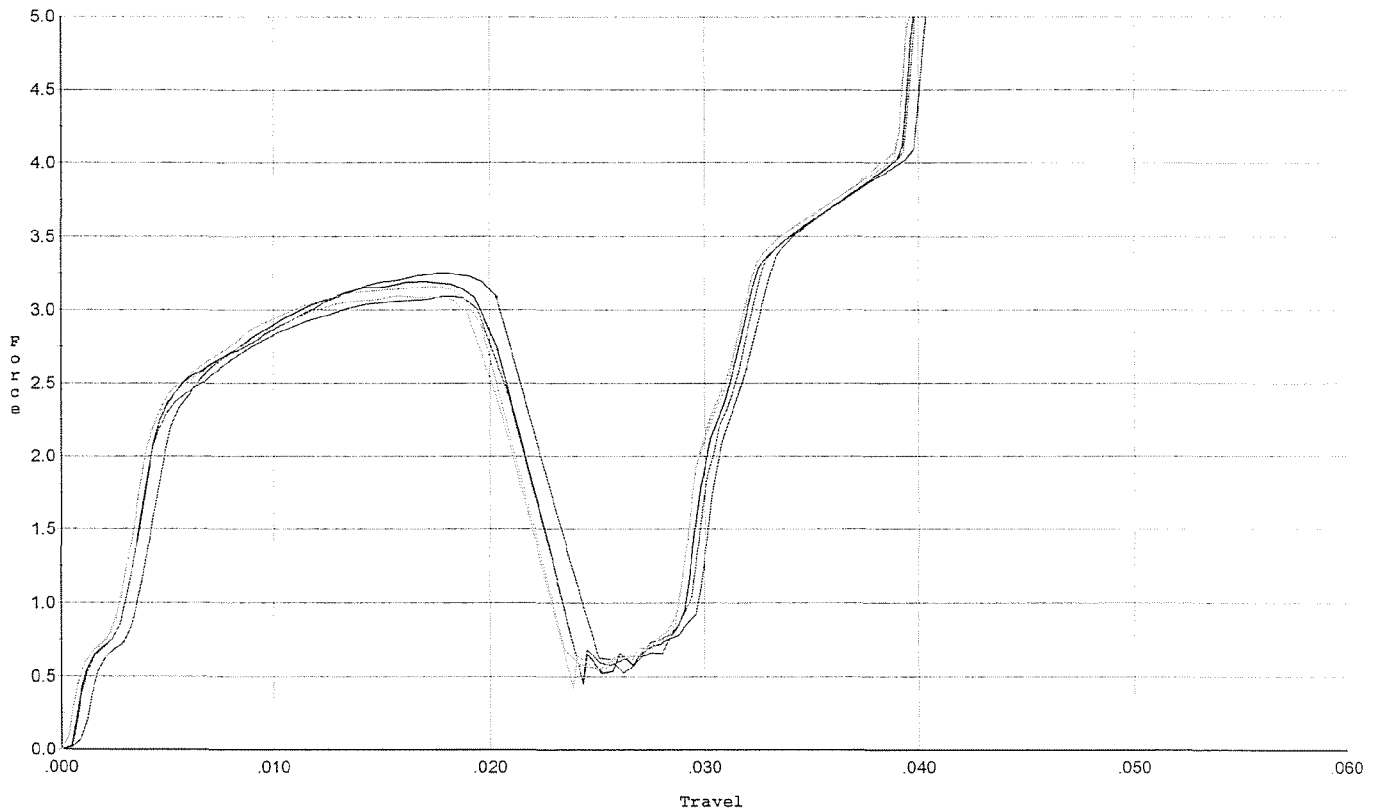
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.642	0.021	0.00	0.026	0.041		Set Trigger
2	2.698	0.019	0.00	0.026	0.038		Set Trigger
3	2.674	0.020	0.00	0.025	0.040		Set Trigger
4	2.664	0.019	0.00	0.025	0.038		Set Trigger
5	2.620	0.020	0.00	0.026	0.039		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



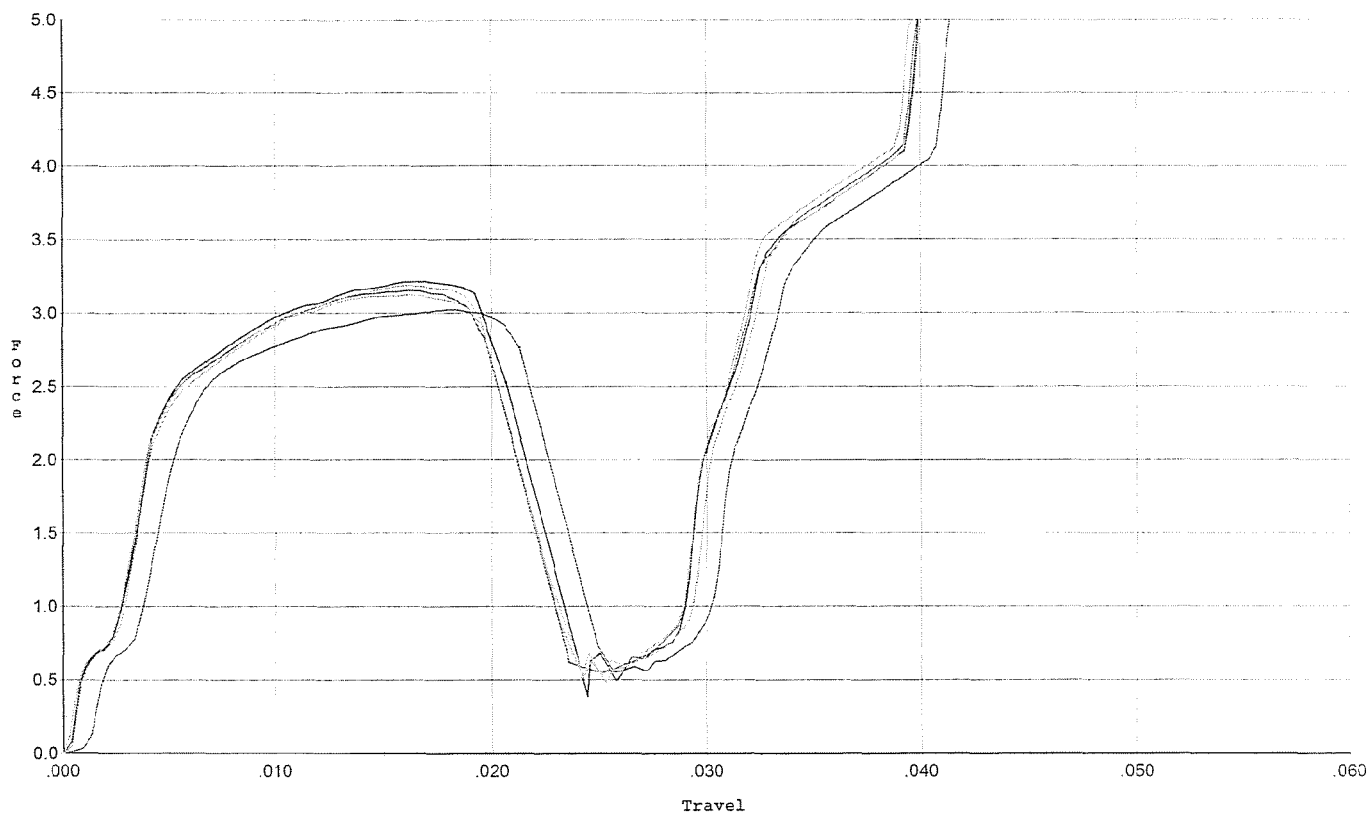
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.249	0.020	0.00	0.023	0.046		Set Trigger
2	3.191	0.020	0.00	0.025	0.047		Set Trigger
3	3.093	0.021	0.00	0.024	0.047		Set Trigger
4	3.096	0.020	0.00	0.025	0.047		Set Trigger
5	3.158	0.020	0.00	0.025	0.046		Set Trigger

A.3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs after 2 cycles+/- .75 lb



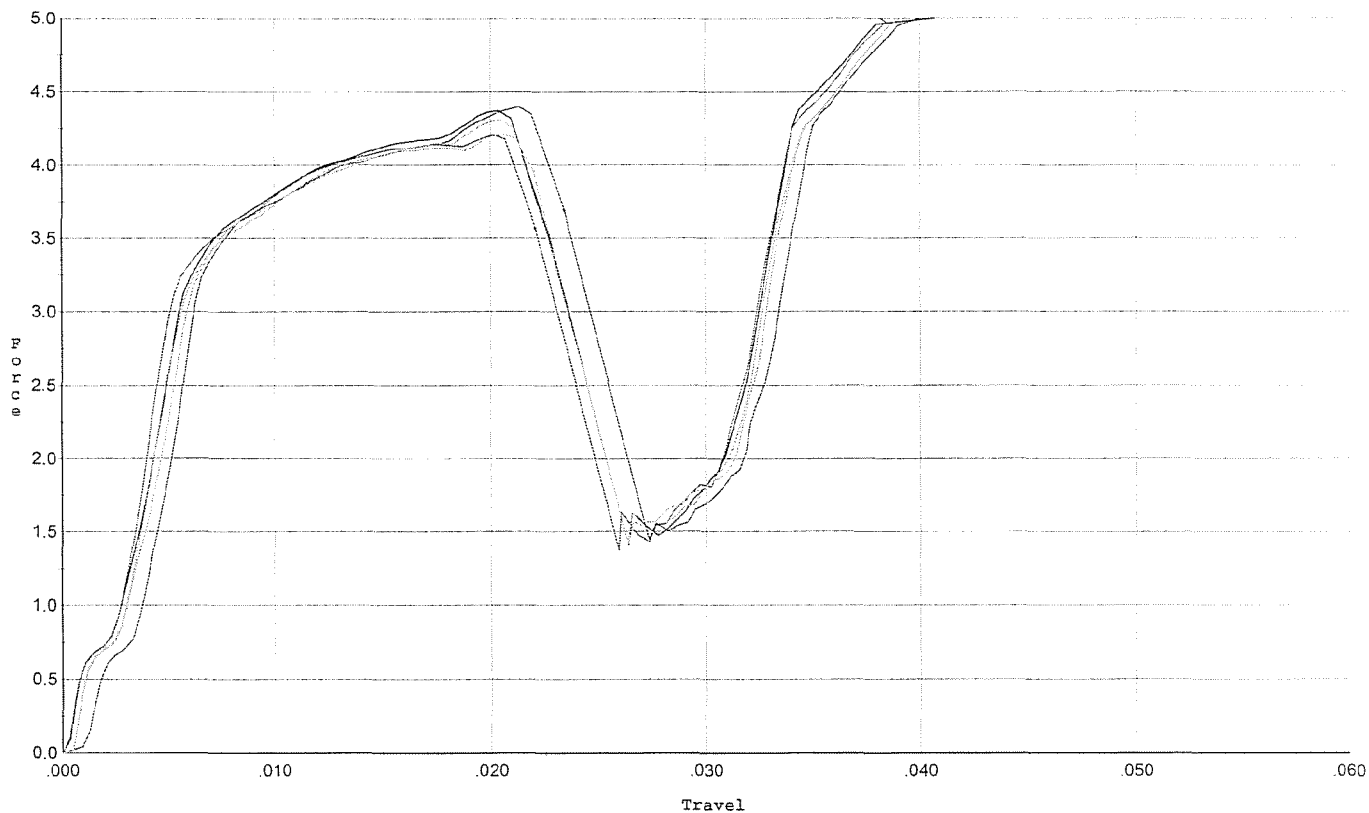
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.020	0.021	0.00	0.025	0.046		Set Trigger
2	3.212	0.021	0.00	0.025	0.049		Set Trigger
3	3.154	0.020	0.00	0.025	0.046		Set Trigger
4	3.124	0.020	0.00	0.025	0.045		Set Trigger
5	3.188	0.019	0.00	0.025	0.046		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



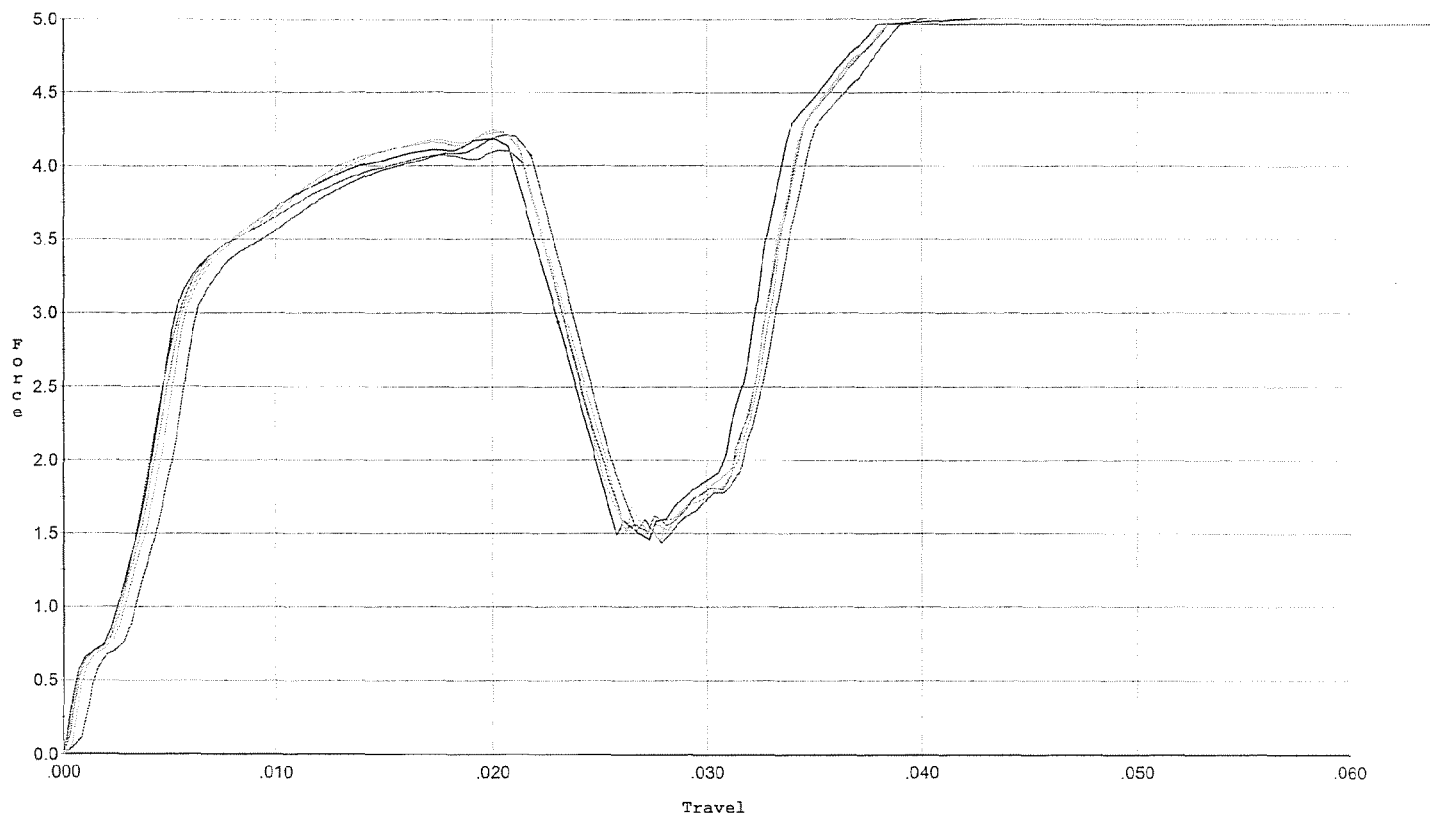
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.396	0.023	0.00	0.016	0.069		Set Trigger
2	4.369	0.023	0.00	0.017	0.069		Set Trigger
3	4.205	0.022	0.00	0.017	0.066		Set Trigger
4	4.307	0.023	0.00	0.017	0.068		Set Trigger
5	4.207	0.022	0.00	0.017	0.065		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/22/2009

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



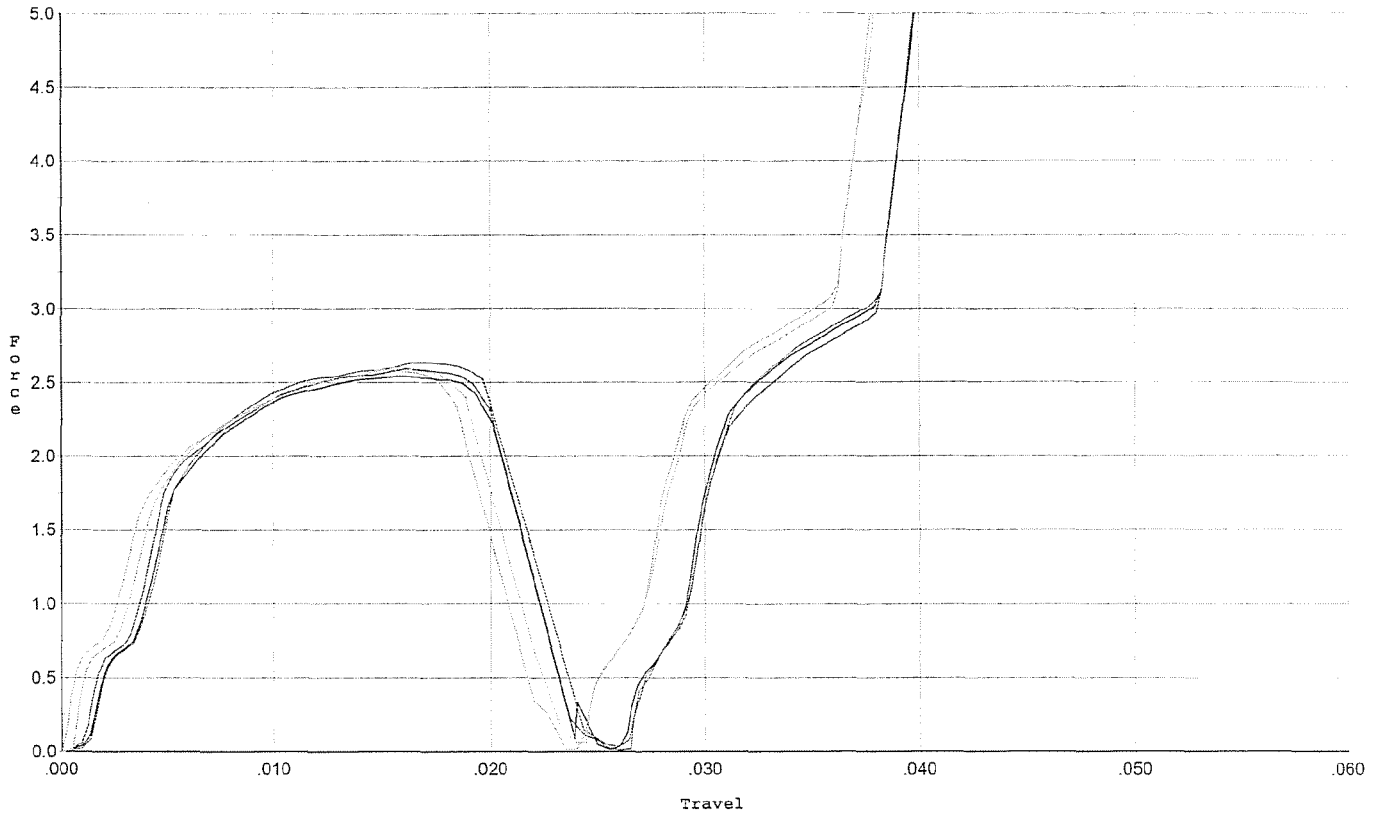
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.207	0.022	0.00	0.017	0.062		Set Trigger
2	4.182	0.023	0.00	0.017	0.068		Set Trigger
3	4.105	0.021	0.00	0.017	0.063		Set Trigger
4	4.230	0.021	0.00	0.017	0.063		Set Trigger
5	4.246	0.021	0.00	0.017	0.063		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

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



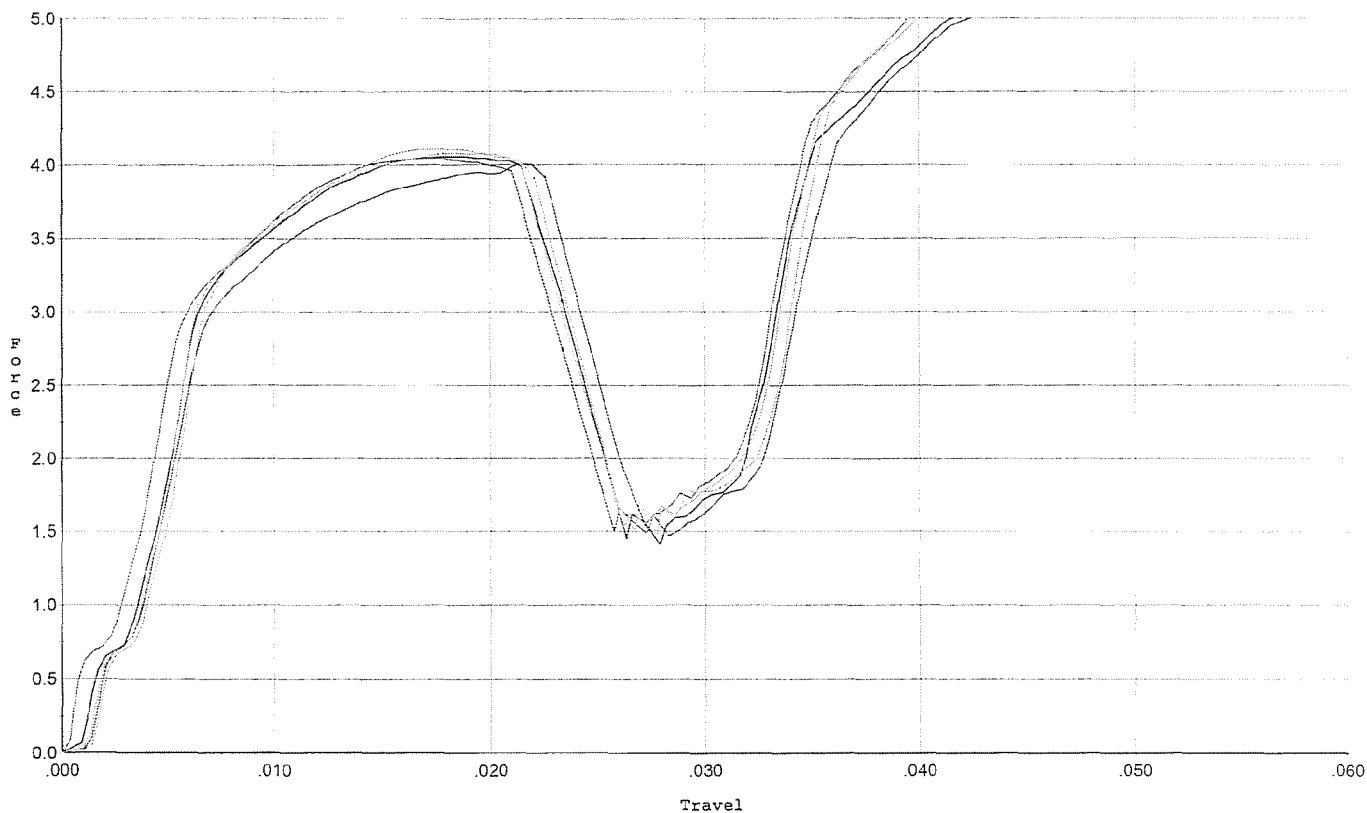
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.020	0.00	0.026	0.037		Set Trigger
2	2.540	0.020	0.00	0.026	0.037		Set Trigger
3	2.637	0.022	0.00	0.026	0.041		Set Trigger
4	2.604	0.019	0.00	0.025	0.036		Set Trigger
5	2.586	0.018	0.00	0.025	0.035		Set Trigger

7.259

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/22/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- .50 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.009	0.023	0.00	0.018	0.062		Set Trigger
2	4.058	0.023	0.00	0.017	0.066		Set Trigger
3	4.046	0.023	0.00	0.017	0.067		Set Trigger
4	4.080	0.021	0.00	0.018	0.060		Set Trigger
5	4.109	0.022	0.00	0.017	0.062		Set Trigger

A.4.06