

G 6871318

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD

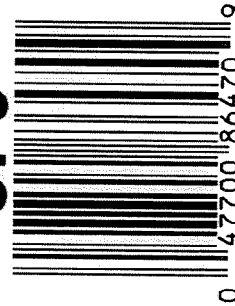
proof of purchase



owner registration sticker



BM FORM

ORDER NO. **86470**BARREL LENGTH **24"**CAPACITY **6****G6871318****UPC**

GUN SERIAL #

G 6871318

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-14-09	SP
430	ASSEMBLE TO STOCK		7-14-09	SP
440	PROOF		7-14-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	7-14-09	SP
470	DIS-ASSEMBLE ACTION		7-14-09	SP
472	SERIALIZE BOLT HANDLE	JUL 18 2009	7-15-09	RL
480	MAGNAFLUX BBL ACTION	OPERATOR (P)	7/18/09	(P)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-21-09	OWO
510	DRILL AND TAP SIGHT HOLES		7-15-09	SP
520	GOFF BLAST BBL / REC		7-21-09	RL
540	APPLY COATINGS (BARREL ACTION)		8/4	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-11-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-11-09	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

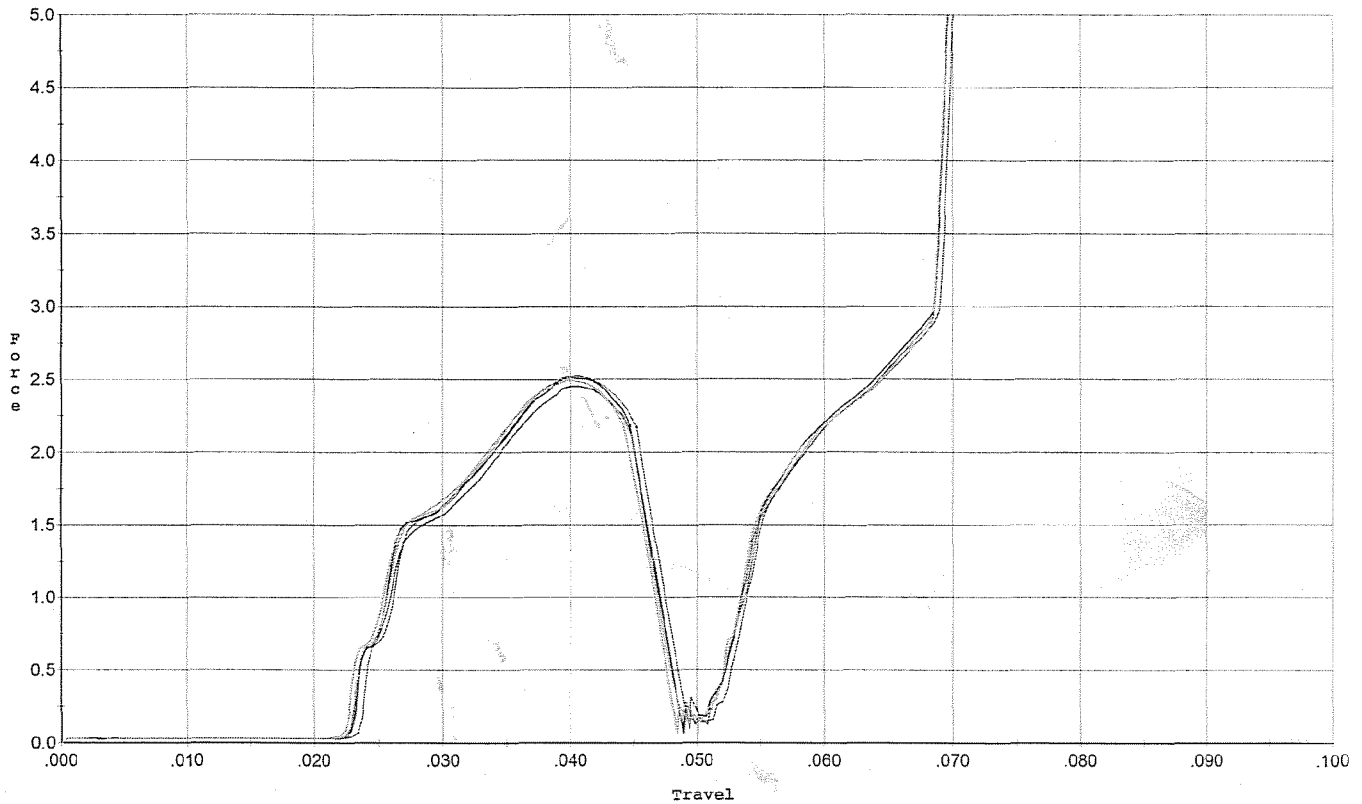
560	BARBER - M24 0080858 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3"</u>	<u>3"</u>	<u>3"</u>	8/21/09	RR		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5"</u>	<u>5"</u>	<u>5"</u>	8/21/09	RR		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>0.23</u>	<u>0.23</u>	<u>0.23</u>	8/21/09	RR		
	J) ASSEMBLE STOCK					8/17/09	LTL		
	K) ASSEMBLE SWIVEL STUDS					8/21/09	RR		
	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		8-20-09 SPD			
			<u>PASS</u>	FAIL					
	MALFUNCTION	CORRECTION	N/A						
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
660	INSPECT FOR LIVE AMMO					8-20-09	SP		
670	FINAL INSPECTION A) HEADSPACE					8/21/09	RR		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u>	<u>2.73</u>	<u>2.63</u>	<u>2.44</u>	<u>2.67</u>	8/21/09	RR
	C) FUNCTION					8/21/09	RR		
690	PACK					8/21/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



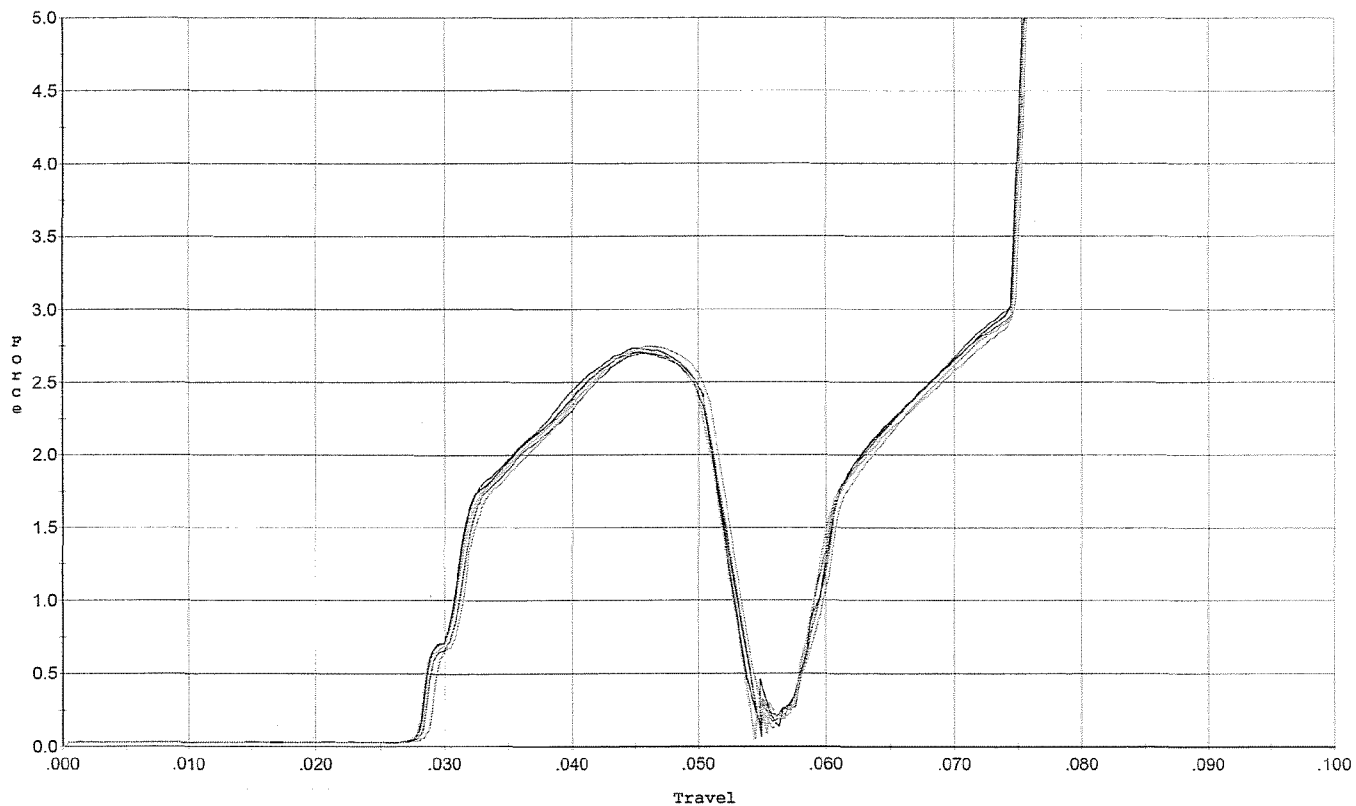
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.453	0.047	0.023	0.029	0.043		Set Trigger
2	2.519	0.045	0.023	0.029	0.042		Set Trigger
3	2.526	0.045	0.024	0.029	0.043		Set Trigger
4	2.492	0.045	0.023	0.029	0.042		Set Trigger
5	2.503	0.046	0.023	0.029	0.044		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



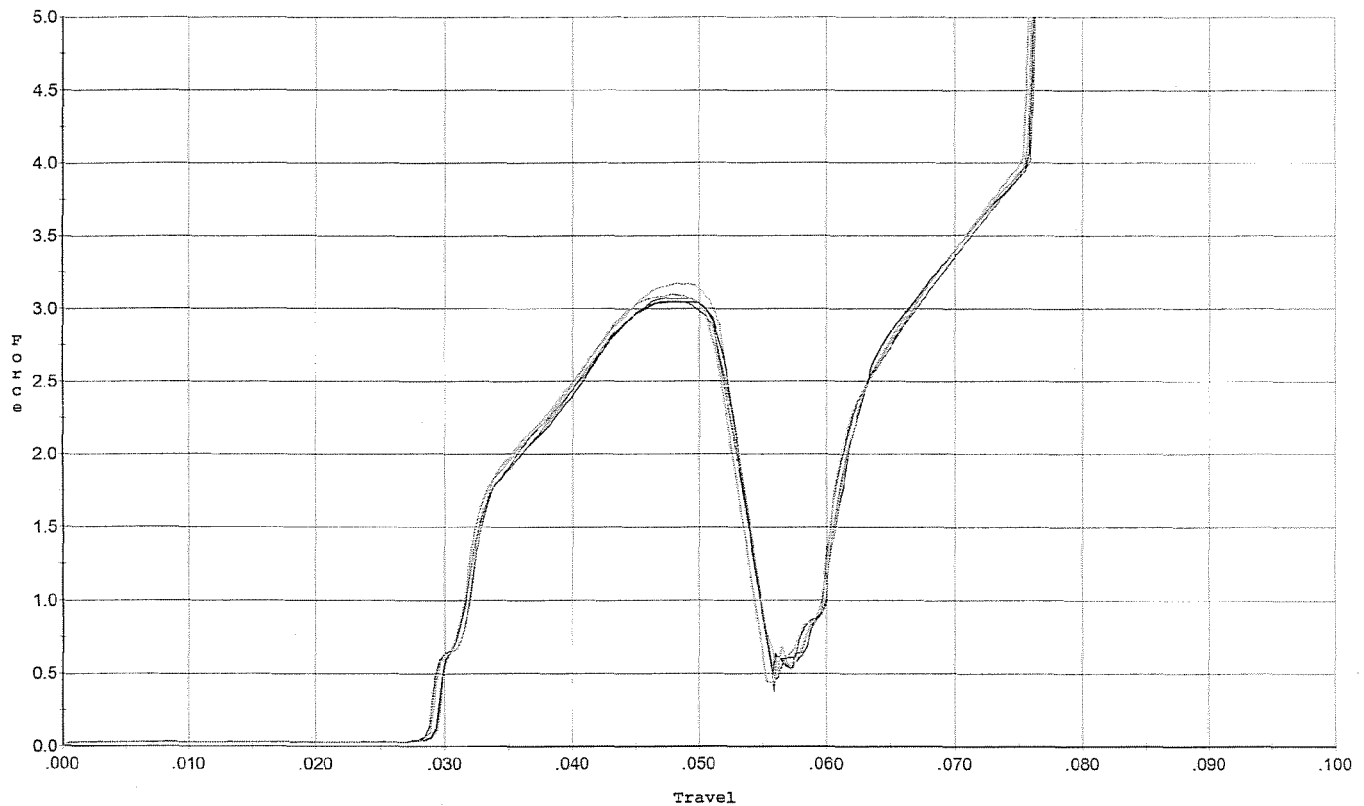
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.736	0.050	0.028	0.030	0.049		Set Trigger
2	2.709	0.051	0.028	0.030	0.049		Set Trigger
3	2.703	0.053	0.028	0.030	0.050		Set Trigger
4	2.728	0.051	0.028	0.030	0.049		Set Trigger
5	2.747	0.051	0.029	0.030	0.049		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

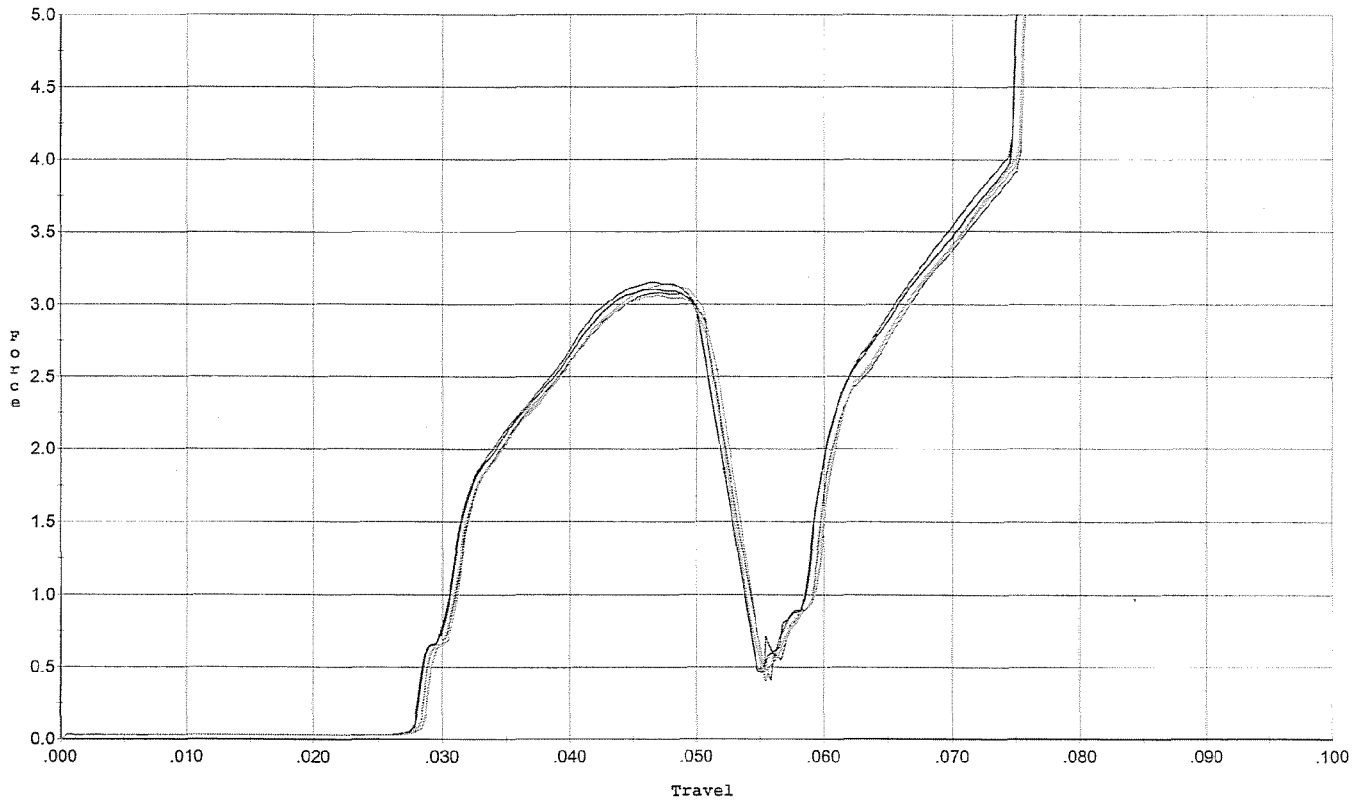
Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs ini +/- .75 lb



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.053	0.029	0.029	0.056		Set Trigger
2	3.047	0.052	0.029	0.030	0.054		Set Trigger
3	3.047	0.052	0.030	0.030	0.055		Set Trigger
4	3.173	0.052	0.030	0.030	0.056		Set Trigger
5	3.097	0.051	0.029	0.029	0.055		Set Trigger

A. 3-08

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



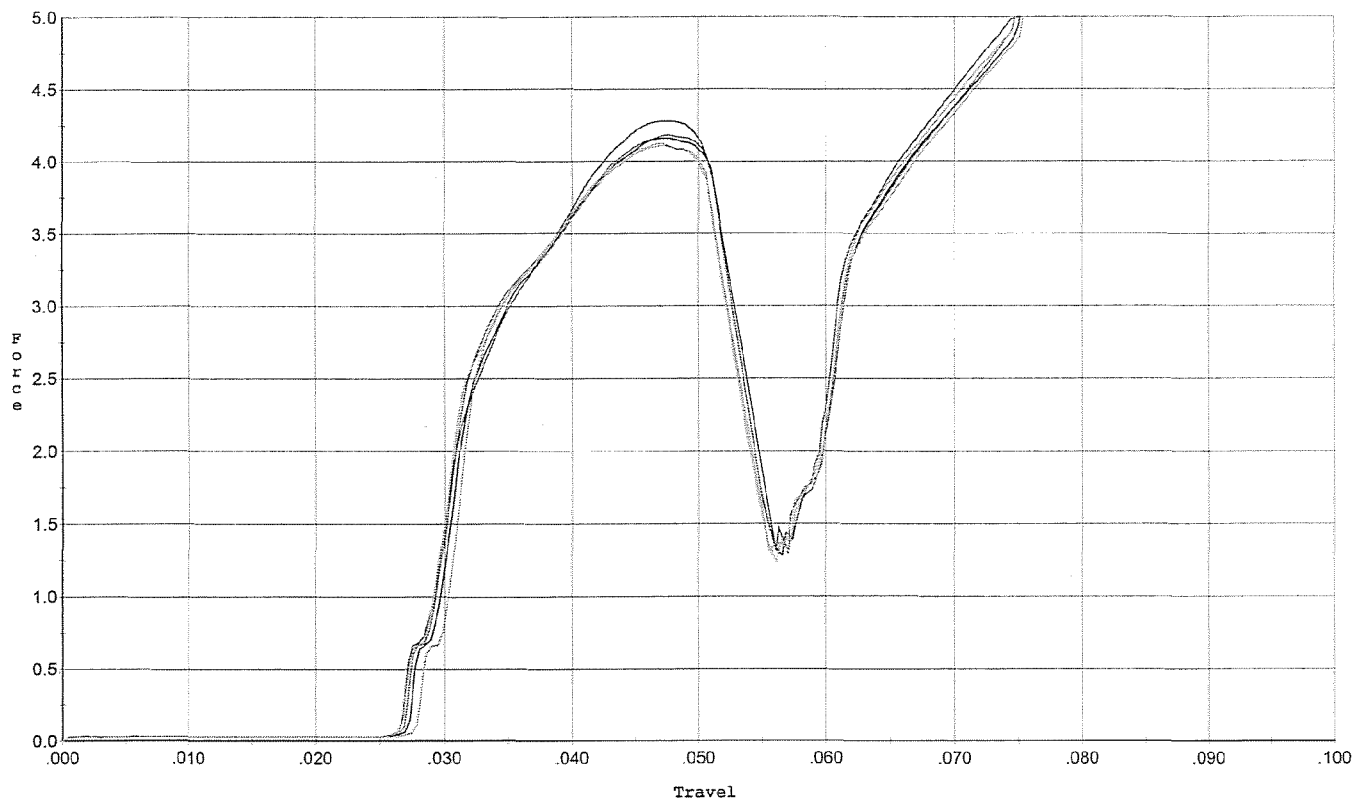
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.052	0.028	0.029	0.058		Set Trigger
2	3.104	0.052	0.028	0.029	0.057		Set Trigger
3	3.080	0.051	0.028	0.030	0.055		Set Trigger
4	3.062	0.051	0.028	0.030	0.055		Set Trigger
5	3.140	0.052	0.029	0.029	0.056		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

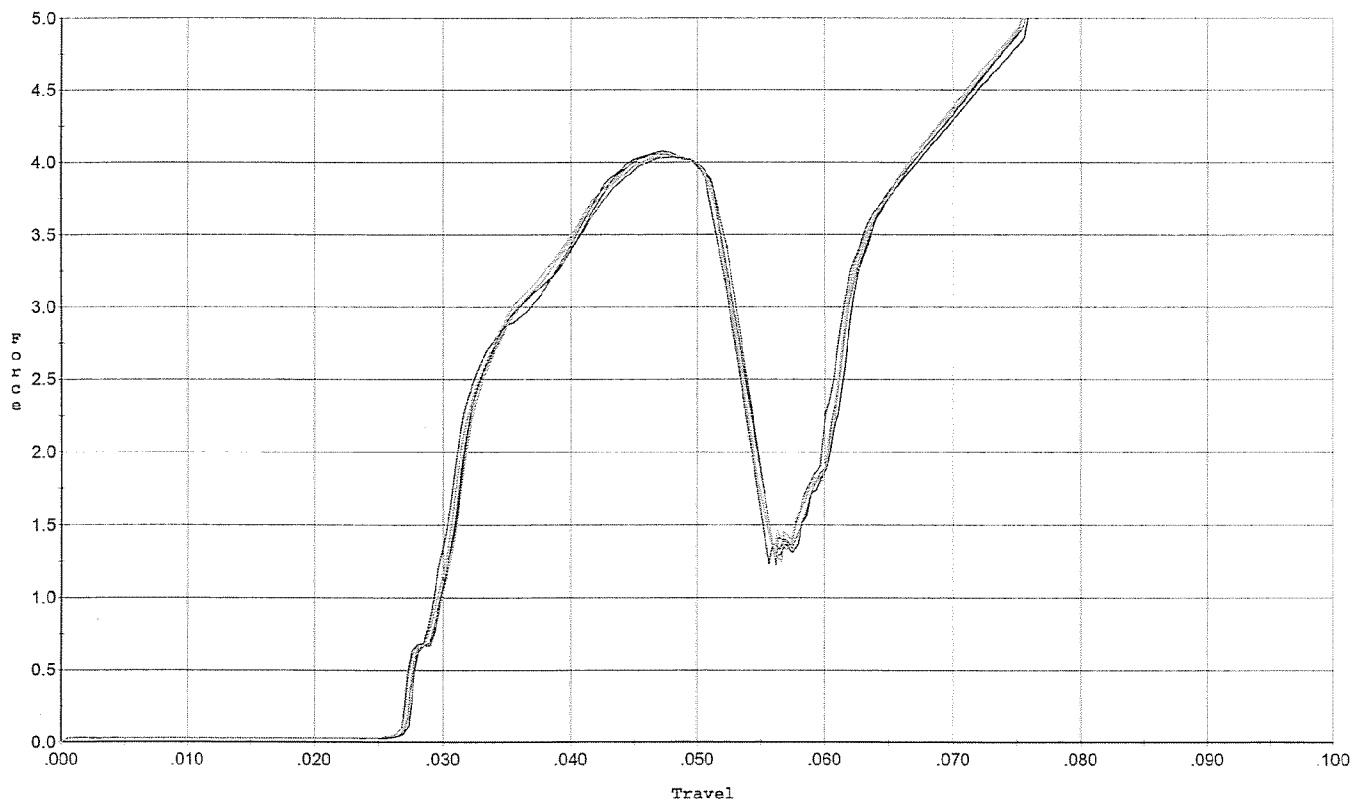
Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.278	0.051	0.027	0.027	0.081		Set Trigger
2	4.161	0.053	0.027	0.027	0.083		Set Trigger
3	4.183	0.051	0.027	0.027	0.080		Set Trigger
4	4.122	0.051	0.027	0.027	0.078		Set Trigger
5	4.107	0.051	0.028	0.028	0.076		Set Trigger

A 4-17

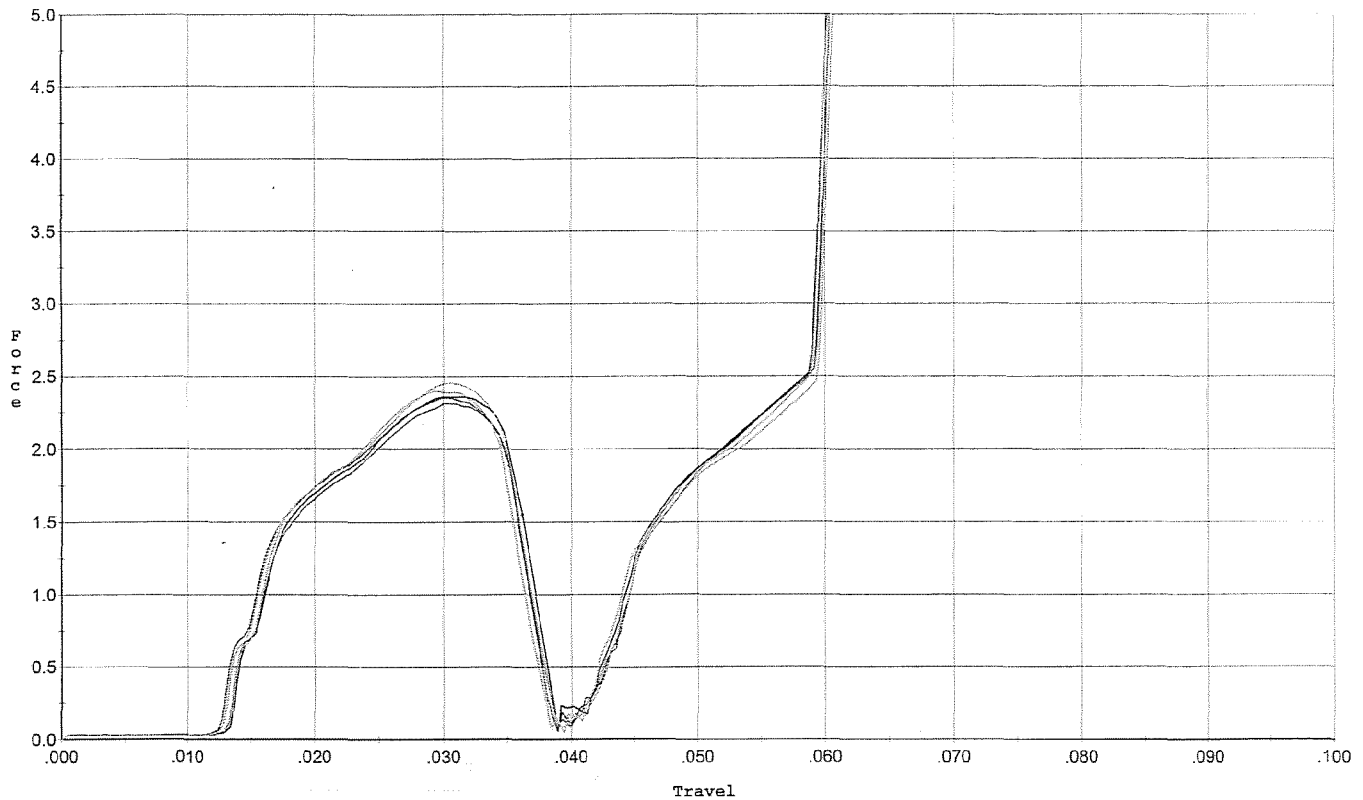
Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.052	0.027	0.027	0.079		Set Trigger
2	4.077	0.053	0.027	0.028	0.080		Set Trigger
3	4.034	0.052	0.027	0.027	0.079		Set Trigger
4	4.060	0.051	0.027	0.027	0.078		Set Trigger
5	4.055	0.051	0.027	0.028	0.076		Set Trigger

A 4.05

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



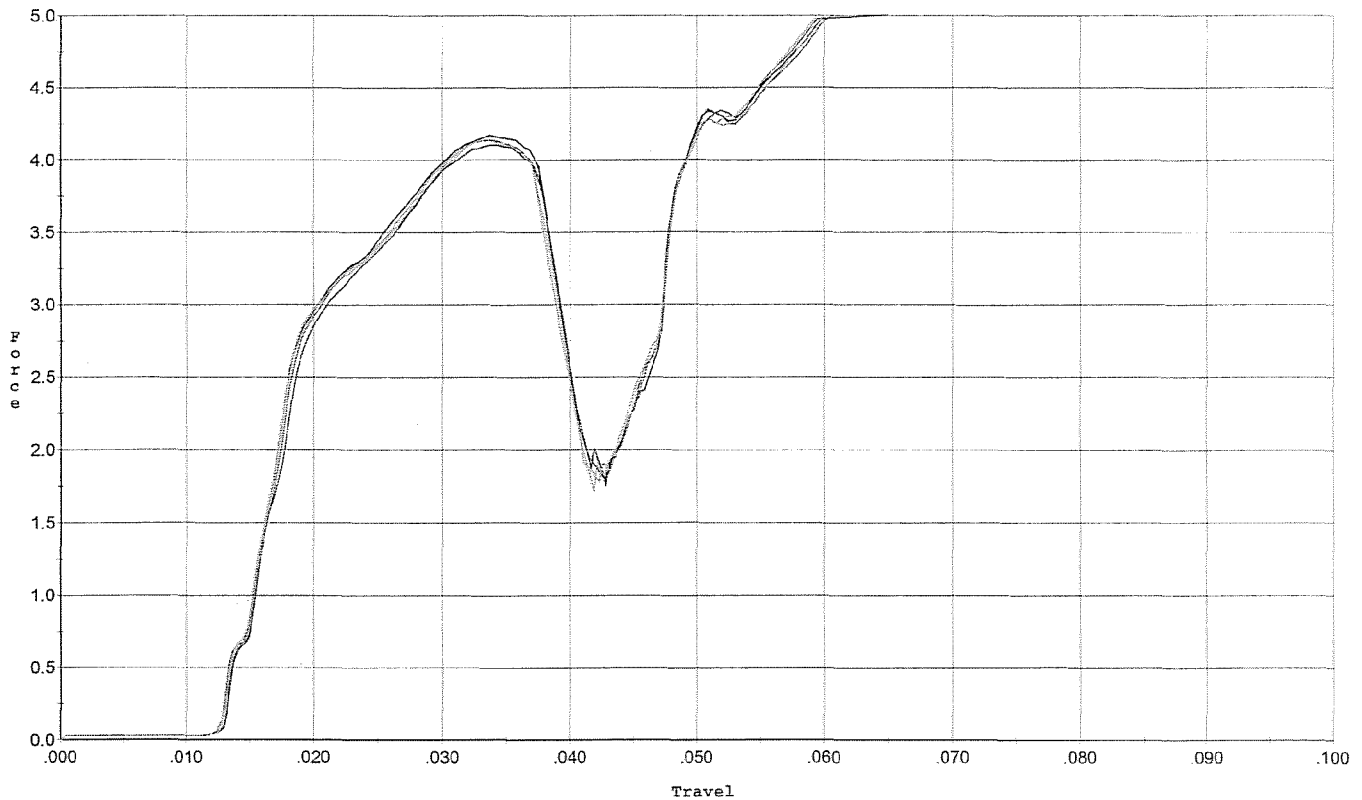
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.354	0.035	0.013	0.029	0.041		Set Trigger
2	2.361	0.036	0.014	0.028	0.041		Set Trigger
3	2.312	0.035	0.013	0.029	0.039		Set Trigger
4	2.399	0.034	0.013	0.029	0.040		Set Trigger
5	2.454	0.035	0.014	0.029	0.041		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.038	0.013	0.023	0.077		Set Trigger
2	4.170	0.037	0.013	0.022	0.078		Set Trigger
3	4.136	0.038	0.013	0.023	0.077		Set Trigger
4	4.141	0.037	0.013	0.023	0.076		Set Trigger
5	4.137	0.038	0.013	0.022	0.079		Set Trigger

A. 4.13