

G6863529

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

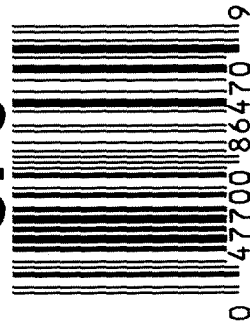
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6863529

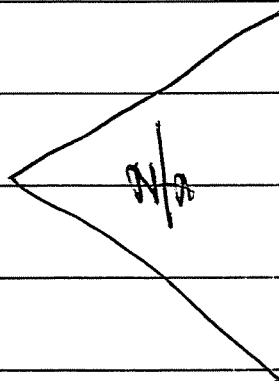
UPC



GUN SERIAL # G 6863529

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SPD
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	6-10-09	SPD
470	DIS-ASSEMBLE ACTION		6-10-09	SPD
472	SERIALIZE BOLT HANDLE		6-10-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	6/13/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/19/09	KTW
540	APPLY COATINGS (BARREL ACTION)		6/24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-11-09	XN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

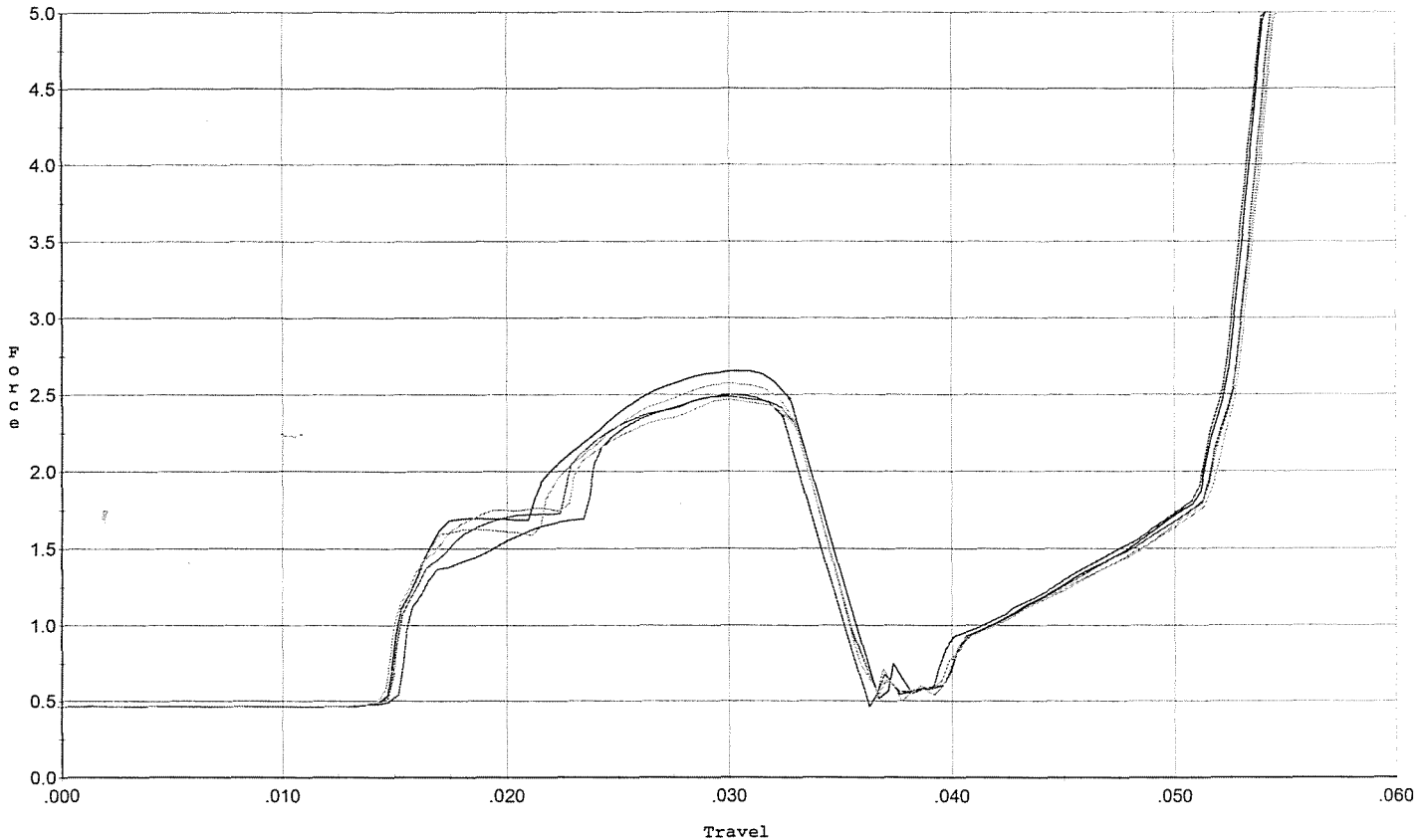
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3°</u>	<u>3°</u>	<u>3°</u>	8/20/09	RR		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>7°</u>	<u>7°</u>	<u>6°</u>	8/20/09	RR		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>0.22</u>	<u>0.23</u>	<u>0.24</u>	8/20/09	RR		
	J) ASSEMBLE STOCK					8-11-09	L.N.		
	K) ASSEMBLE SWIVEL STUDS					8/20/09	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		8-18-09	L.N.		
			<u>PASS</u>	FAIL					
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
660	INSPECT FOR LIVE AMMO					8-18-09	RR		
670	FINAL INSPECTION A) HEADSPACE					8/20/09	RR		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u>	<u>2.38</u>	<u>2.45</u>	<u>2.37</u>	<u>2.40</u>	8-20-09	L.N.
	C) FUNCTION					8/20/09	RR		
690	PACK					8/21/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



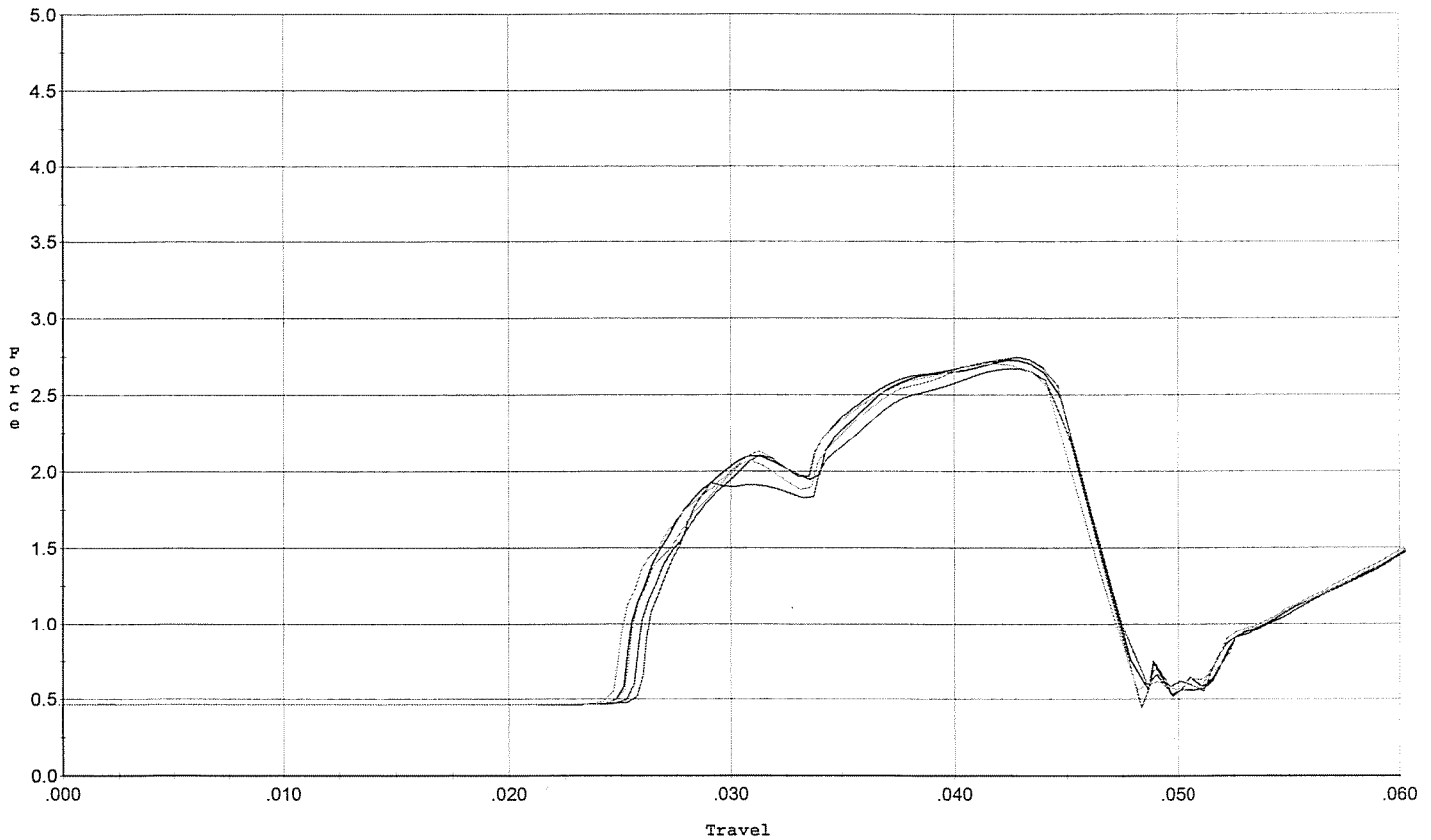
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.497	0.032	0.015	0.025	0.041		Set Trigger
2	2.654	0.033	0.015	0.024	0.045		Set Trigger
3	2.485	0.033	0.015	0.025	0.043		Set Trigger
4	2.465	0.033	0.015	0.025	0.043		Set Trigger
5	2.572	0.033	0.015	0.025	0.044		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



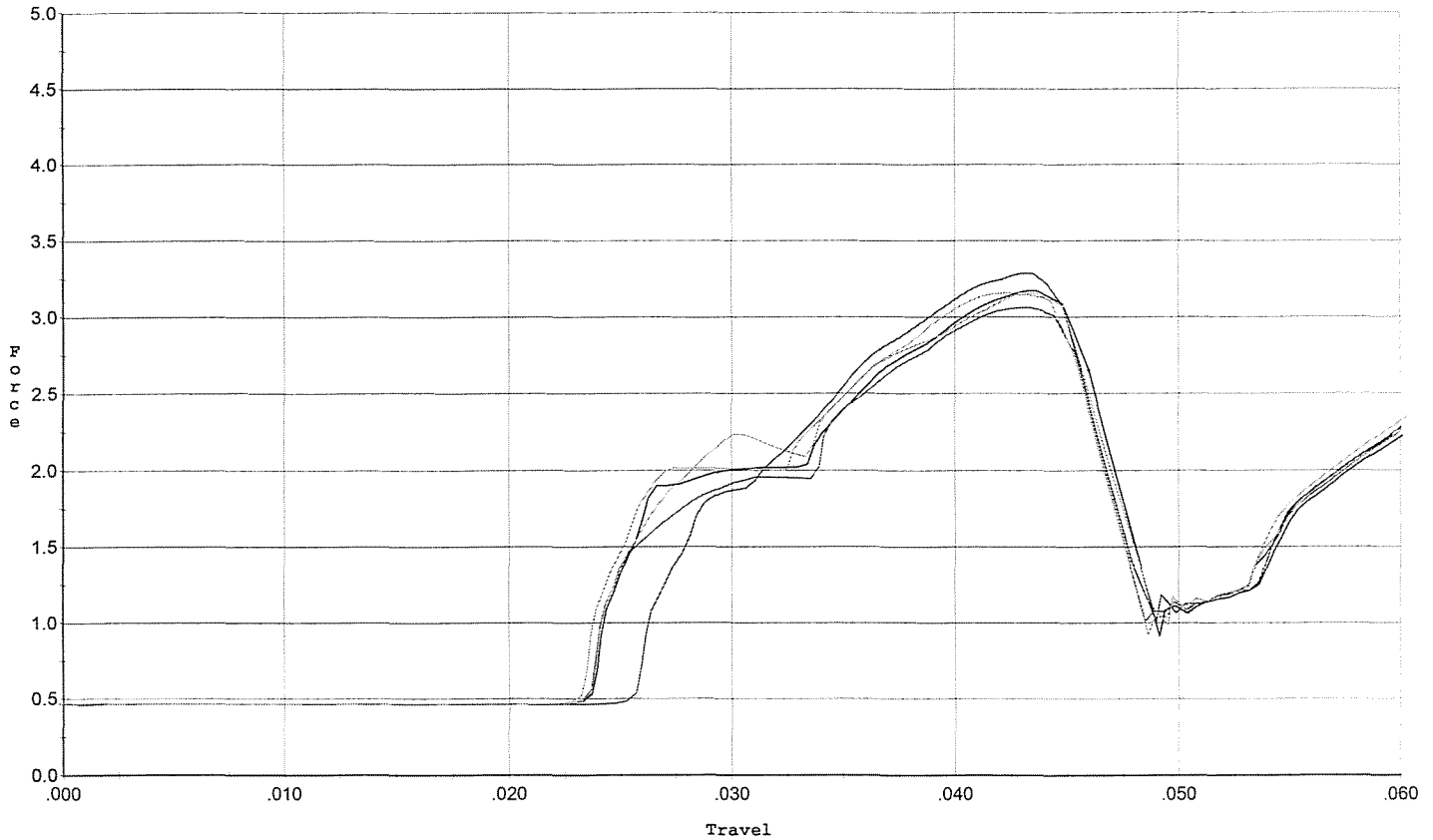
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.743	0.045	0.026	0.026	0.055		Set Trigger
2	2.726	0.045	0.025	0.026	0.056		Set Trigger
3	2.672	0.045	0.026	0.026	0.054		Set Trigger
4	2.701	0.044	0.025	0.026	0.054		Set Trigger
5	2.747	0.045	0.025	0.026	0.056		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



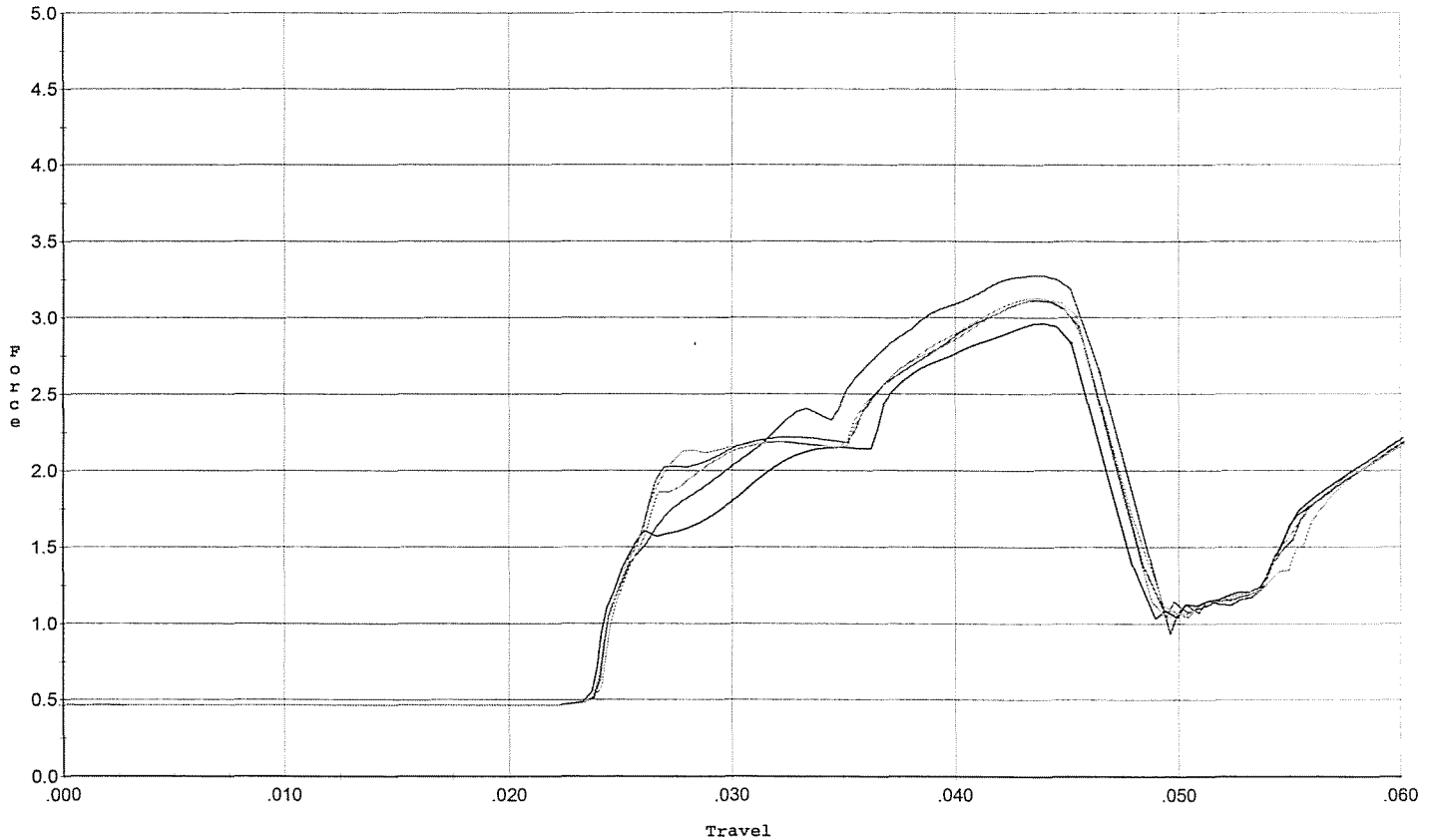
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.288	0.045	0.026	0.025	0.061		Set Trigger
2	3.172	0.046	0.024	0.024	0.064		Set Trigger
3	3.061	0.045	0.024	0.024	0.061		Set Trigger
4	3.161	0.045	0.023	0.024	0.064		Set Trigger
5	3.148	0.045	0.024	0.024	0.063		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



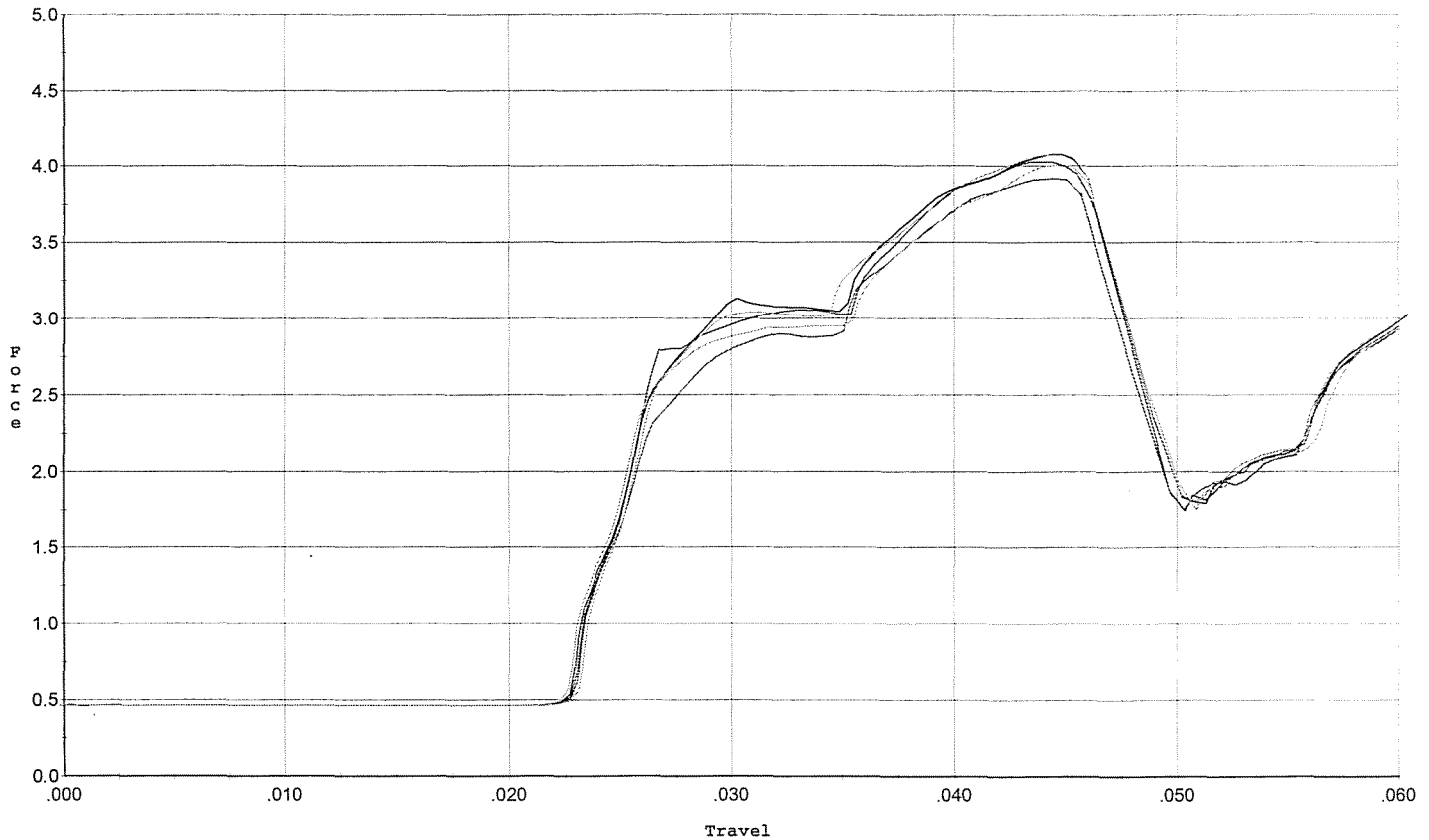
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.046	0.024	0.024	0.067		Set Trigger
2	2.964	0.045	0.024	0.025	0.059		Set Trigger
3	3.112	0.046	0.024	0.024	0.064		Set Trigger
4	3.128	0.045	0.024	0.025	0.064		Set Trigger
5	3.126	0.046	0.024	0.025	0.063		Set Trigger

A. 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



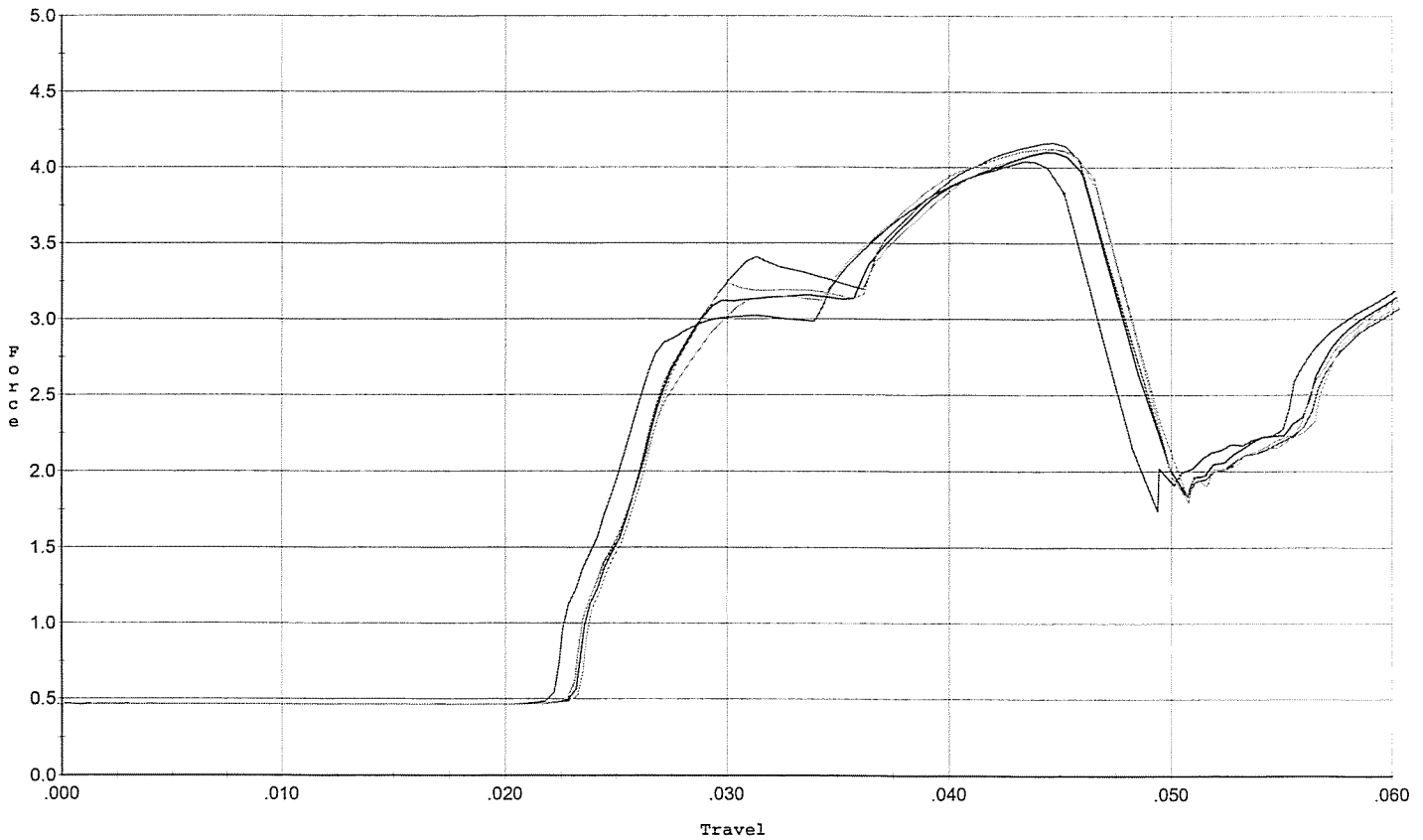
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.046	0.023	0.023	0.085		Set Trigger
2	4.074	0.046	0.023	0.023	0.086		Set Trigger
3	3.916	0.046	0.023	0.023	0.081		Set Trigger
4	4.007	0.046	0.023	0.023	0.083		Set Trigger
5	4.073	0.046	0.023	0.023	0.086		Set Trigger

A. 4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



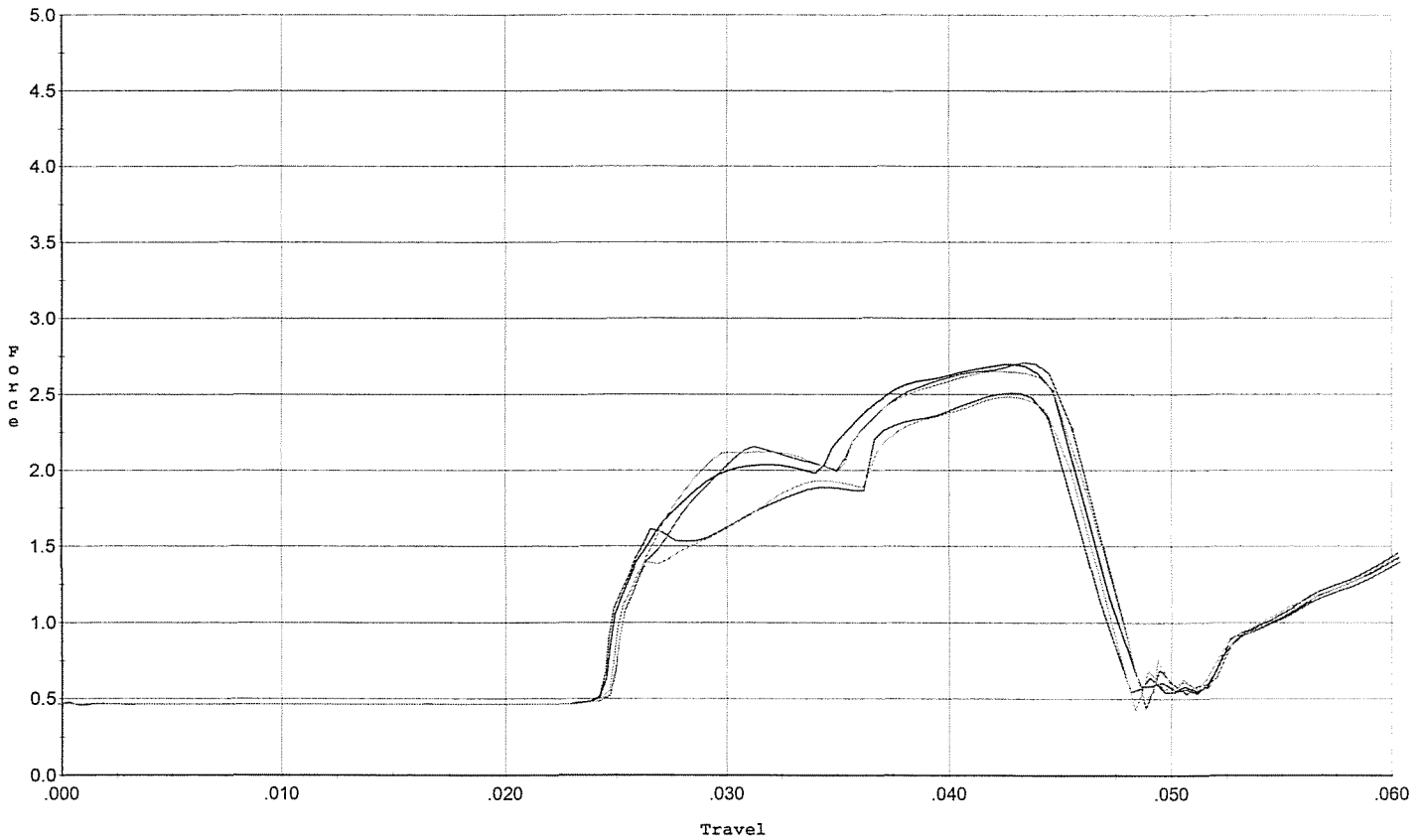
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.039	0.045	0.022	0.023	0.083		Set Trigger
2	4.098	0.046	0.023	0.023	0.085		Set Trigger
3	4.163	0.046	0.023	0.023	0.086		Set Trigger
4	4.122	0.047	0.023	0.023	0.087		Set Trigger
5	4.122	0.047	0.023	0.023	0.087		Set Trigger

A-4-10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



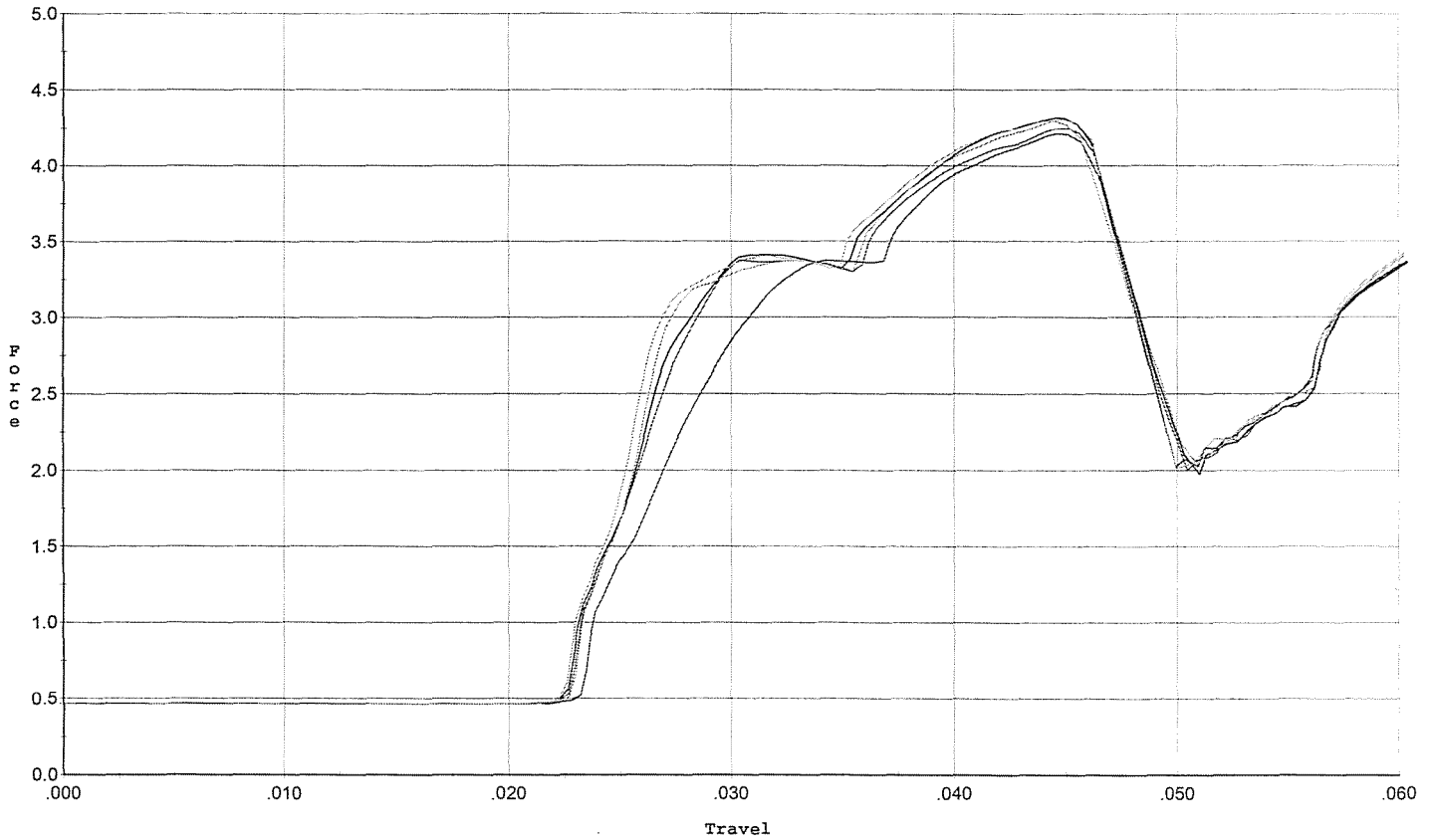
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.044	0.024	0.026	0.051		Set Trigger
2	2.696	0.045	0.025	0.026	0.056		Set Trigger
3	2.708	0.046	0.025	0.026	0.057		Set Trigger
4	2.486	0.045	0.025	0.026	0.052		Set Trigger
5	2.649	0.046	0.025	0.026	0.058		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 8/10/2009

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	4.211	0.047	0.023	0.023	0.086		Set Trigger
2	4.315	0.046	0.023	0.023	0.091		Set Trigger
3	4.247	0.046	0.023	0.023	0.090		Set Trigger
4	4.295	0.047	0.023	0.023	0.094		Set Trigger
5	4.307	0.046	0.023	0.023	0.091		Set Trigger

A-4.27