

6863631

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

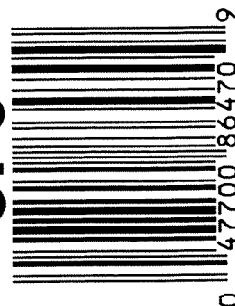
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863631

UPC



GUN SERIAL # G 686 3631

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-11-09	SPD
430	ASSEMBLE TO STOCK		6-11-09	SP
440	PROOF		6-11-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	6-11-09	SPD
470	DIS-ASSEMBLE ACTION		6-11-09	SPD
472	SERIALIZE BOLT HANDLE		6-12-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	6/13/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-12-09	SP
520	GOFF BLAST BBL / REC		6/16/09	RTW
540	APPLY COATINGS (BARREL ACTION)		7/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-16-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-16-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-16-09	SP
	D) OIL FIRING PIN ASSEMBLY		7-22-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

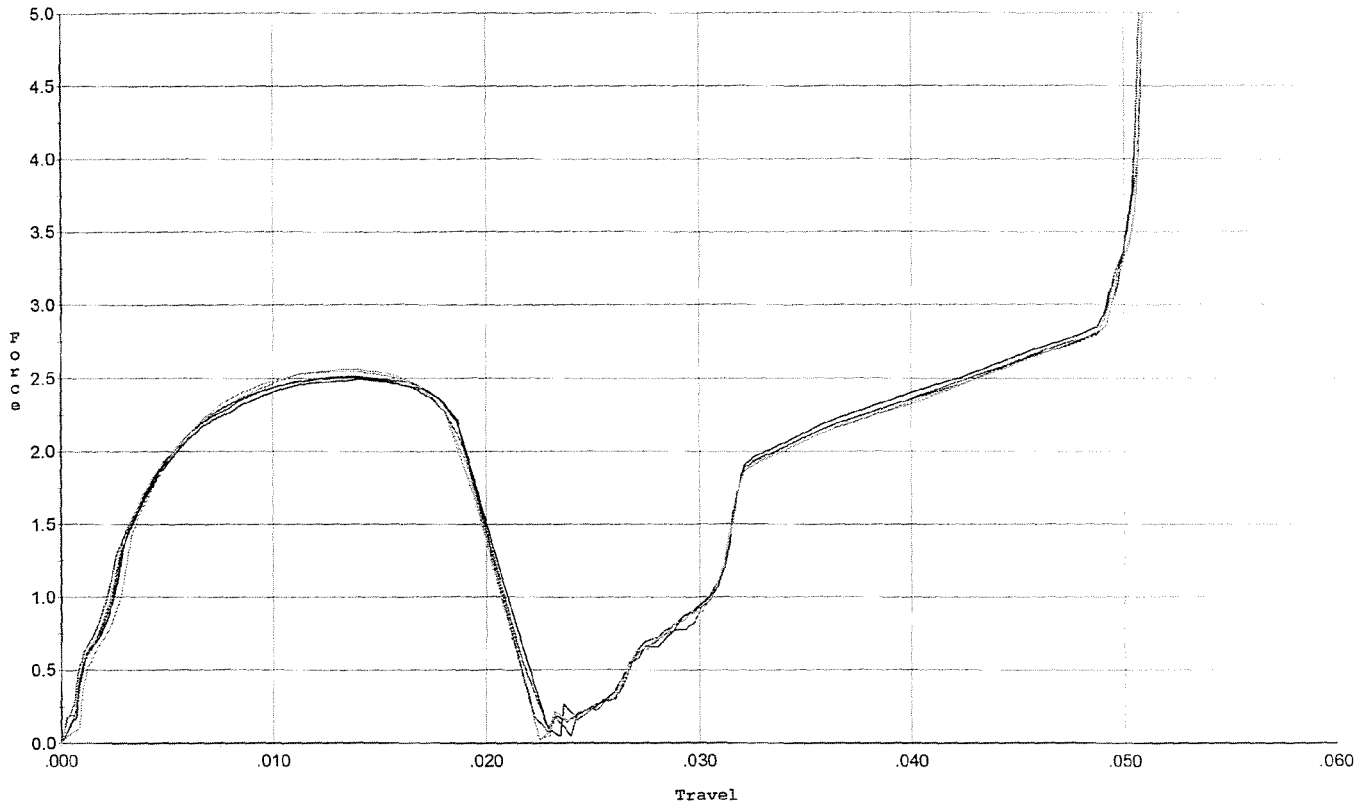
560	BARBER - M24 0093966 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	8-5-09	LN
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	8-5-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.002</u> <u>.003</u> <u>.003</u>	8-5-09	LN
	J) ASSEMBLE STOCK			7-22-09	LN
	K) ASSEMBLE SWIVEL STUDS			8-5-09	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		PASS FAIL PASS FAIL	7/28	RB
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			7/28	TAR
670	FINAL INSPECTION A) HEADSPACE			8-5-09	LN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.57</u> <u>2.49</u> <u>2.55</u> <u>2.66</u>	8-4-09	LN
	C) FUNCTION			8-5-09	LN
690	PACK			8/10/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/24/09

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



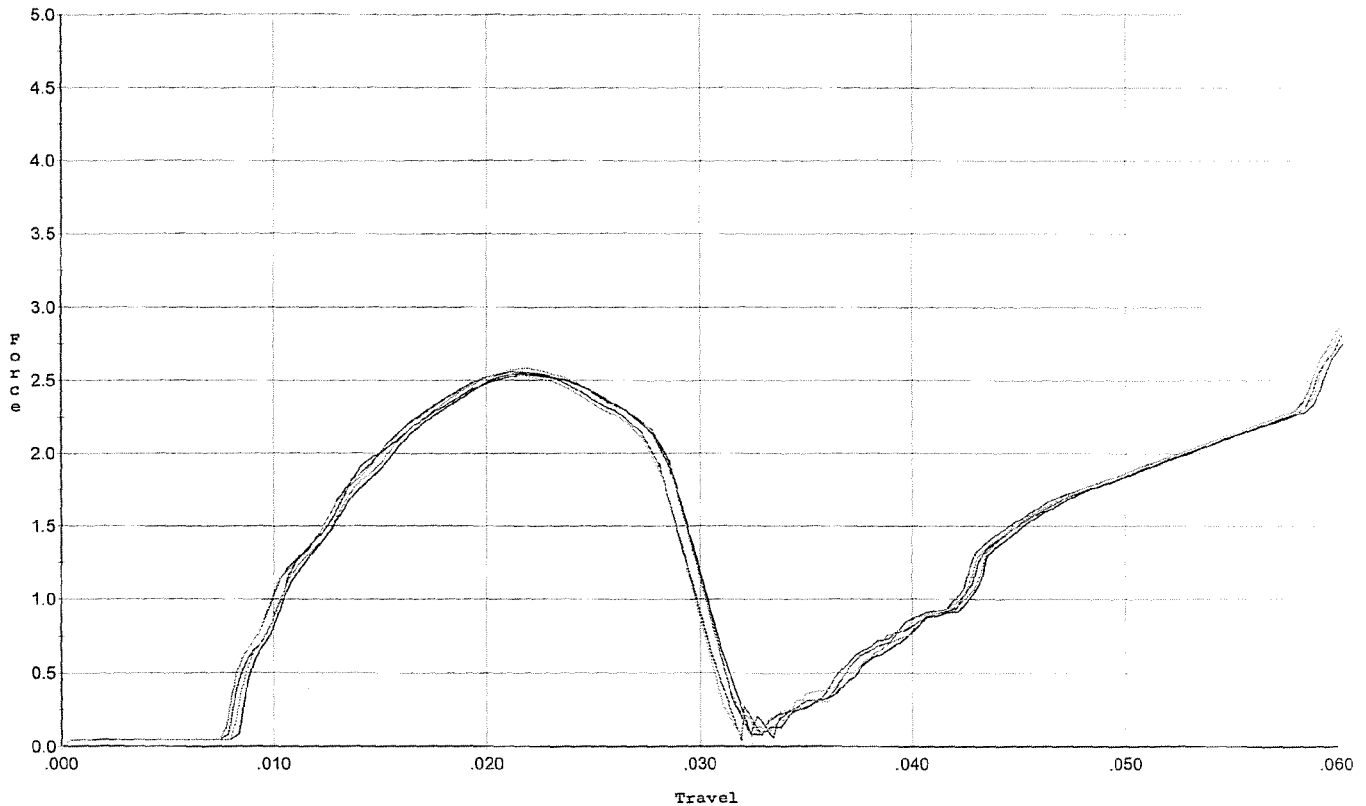
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.516	0.019	0.00	0.035	0.036		Set Trigger
2	2.496	0.019	0.00	0.035	0.035		Set Trigger
3	2.507	0.019	0.00	0.035	0.036		Set Trigger
4	2.550	0.019	0.00	0.035	0.037		Set Trigger
5	2.562	0.019	0.00	0.035	0.037		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/24/09

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



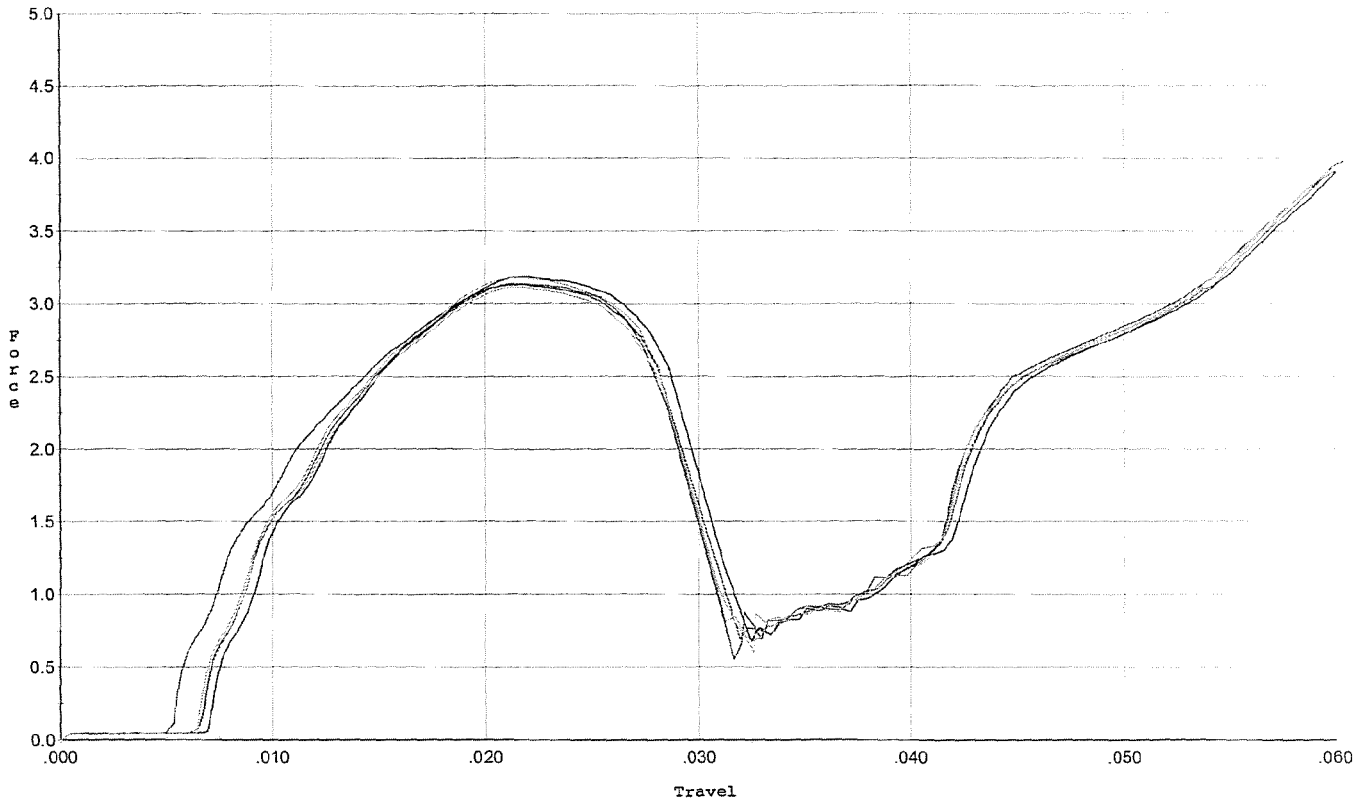
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.538	0.029	0.008	0.039	0.040		Set Trigger
2	2.551	0.029	0.009	0.039	0.039		Set Trigger
3	2.558	0.028	0.008	0.039	0.040		Set Trigger
4	2.539	0.028	0.008	0.039	0.039		Set Trigger
5	2.580	0.029	0.008	0.039	0.040		Set Trigger

AVG 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/24/09

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



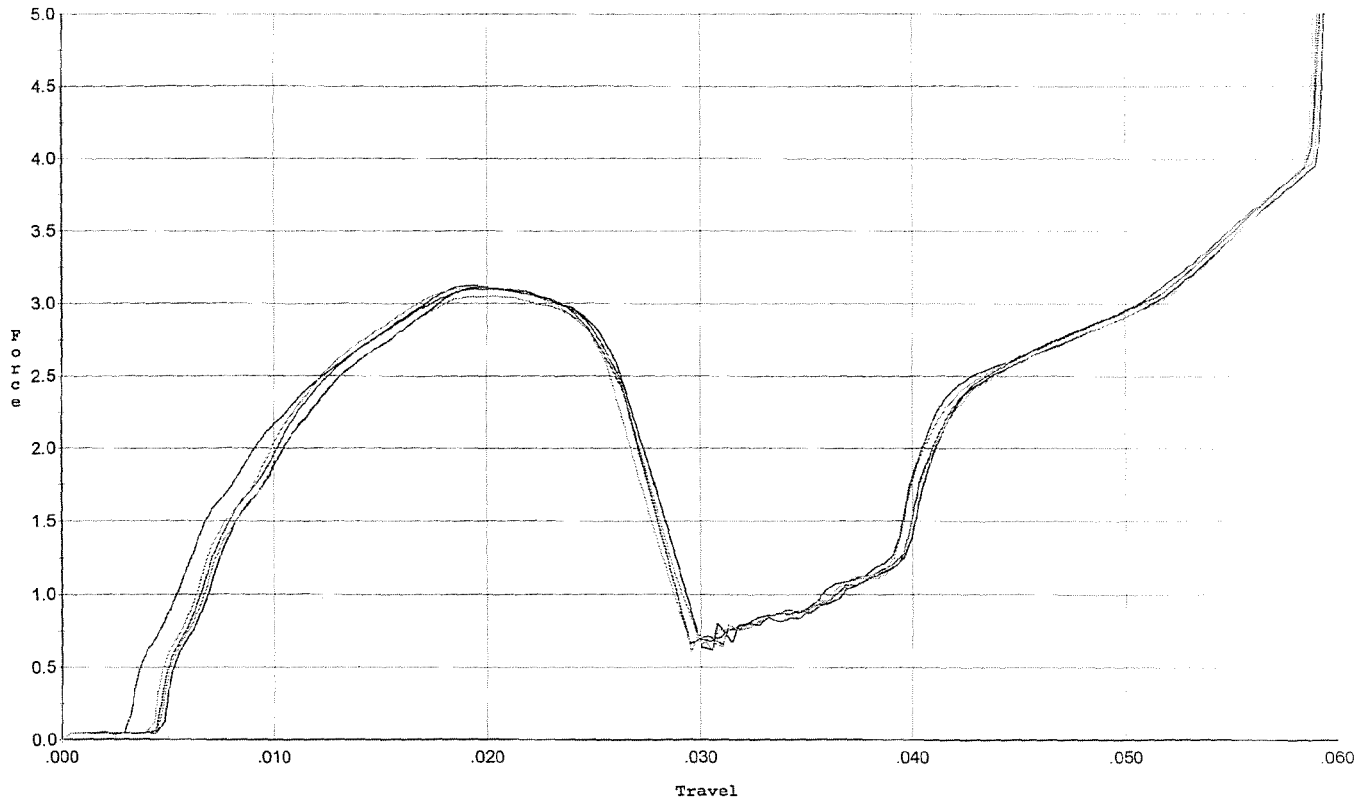
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.131	0.029	0.005	0.037	0.054		Set Trigger
2	3.188	0.029	0.007	0.037	0.052		Set Trigger
3	3.137	0.028	0.007	0.038	0.051		Set Trigger
4	3.114	0.028	0.007	0.037	0.051		Set Trigger
5	3.177	0.028	0.007	0.037	0.051		Set Trigger

Avg 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/24/09

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



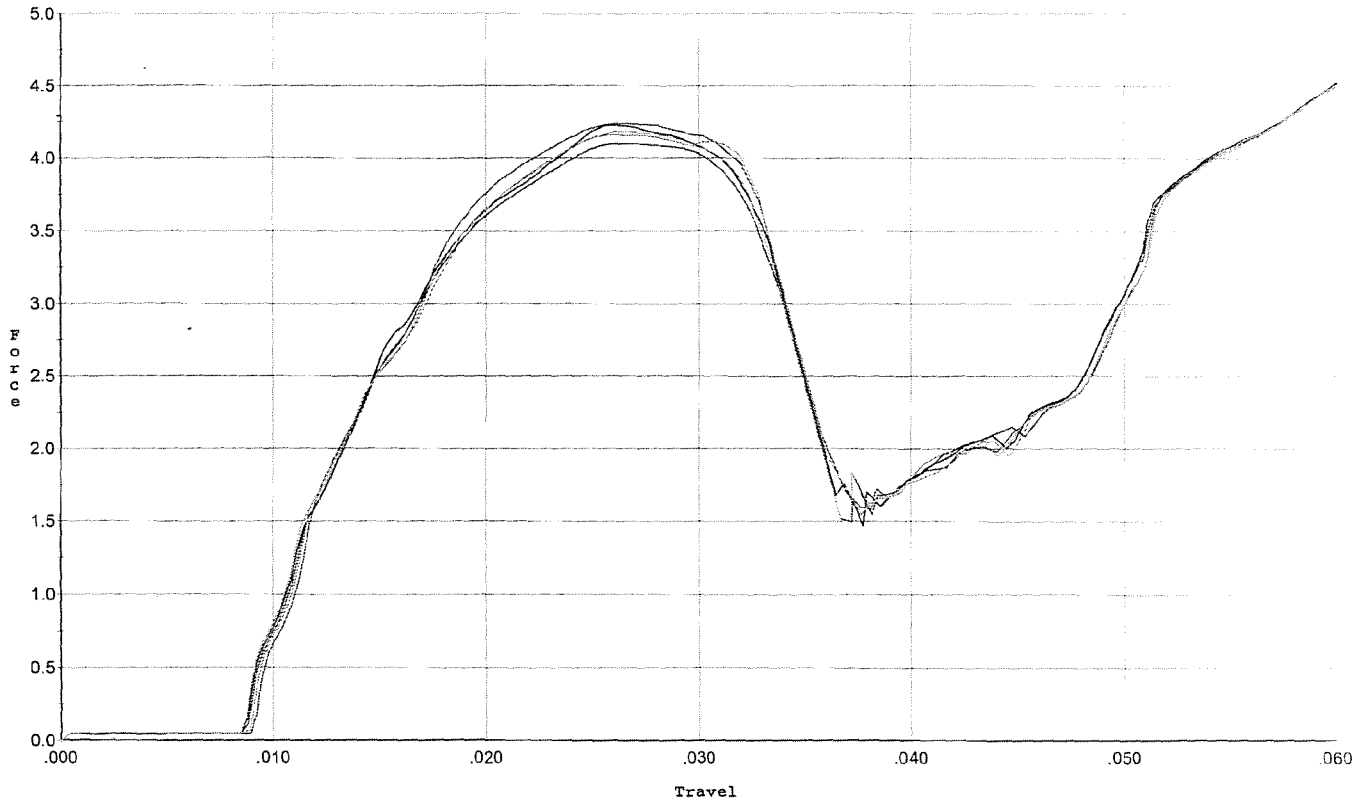
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.126	0.026	0.003	0.037	0.053		Set Trigger
2	3.111	0.028	0.005	0.037	0.052		Set Trigger
3	3.098	0.026	0.005	0.037	0.051		Set Trigger
4	3.113	0.026	0.004	0.037	0.050		Set Trigger
5	3.051	0.026	0.005	0.037	0.049		Set Trigger

Aug 3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/24/09

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



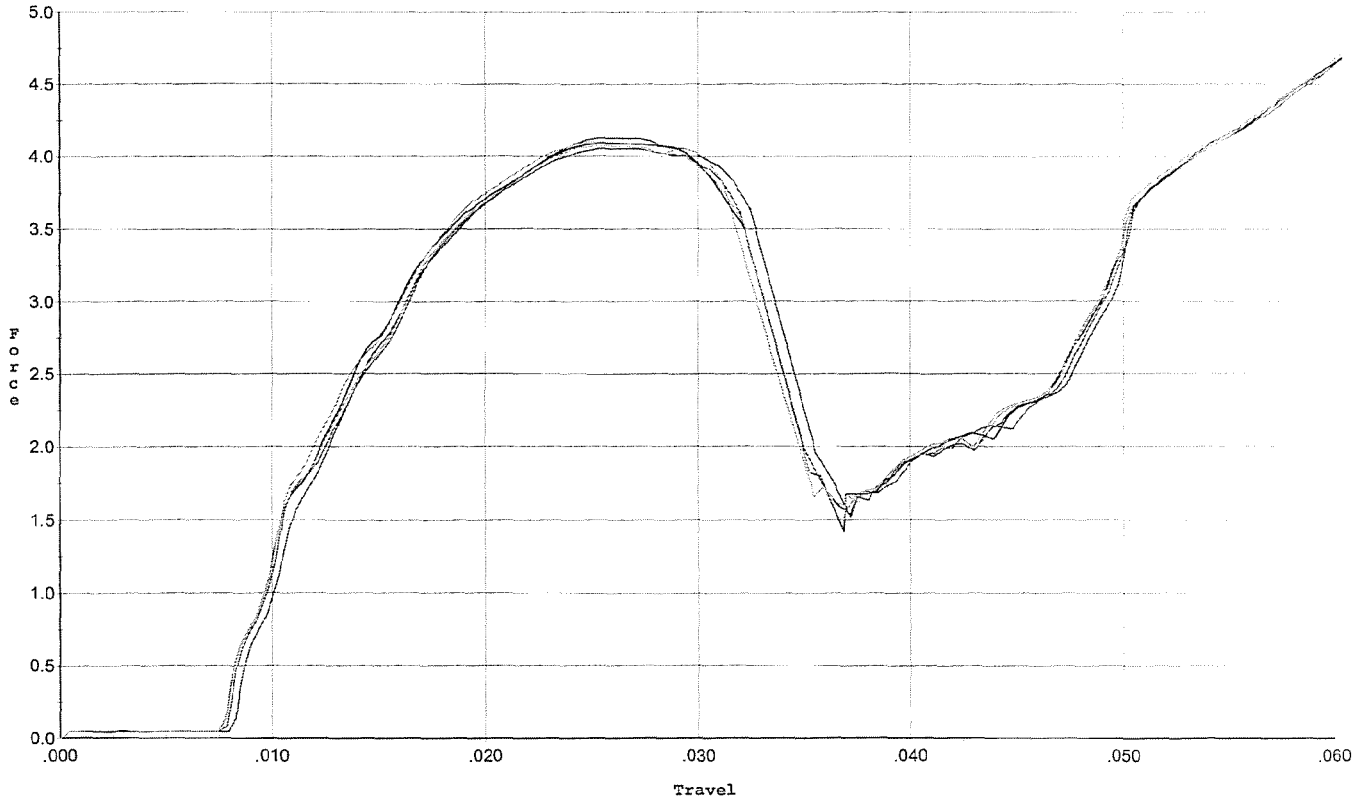
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.034	0.009	0.030	0.076		Set Trigger
2	4.225	0.033	0.009	0.030	0.076		Set Trigger
3	4.237	0.033	0.009	0.030	0.076		Set Trigger
4	4.160	0.034	0.009	0.030	0.077		Set Trigger
5	4.180	0.033	0.009	0.030	0.075		Set Trigger

Aug 4.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/24/09

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



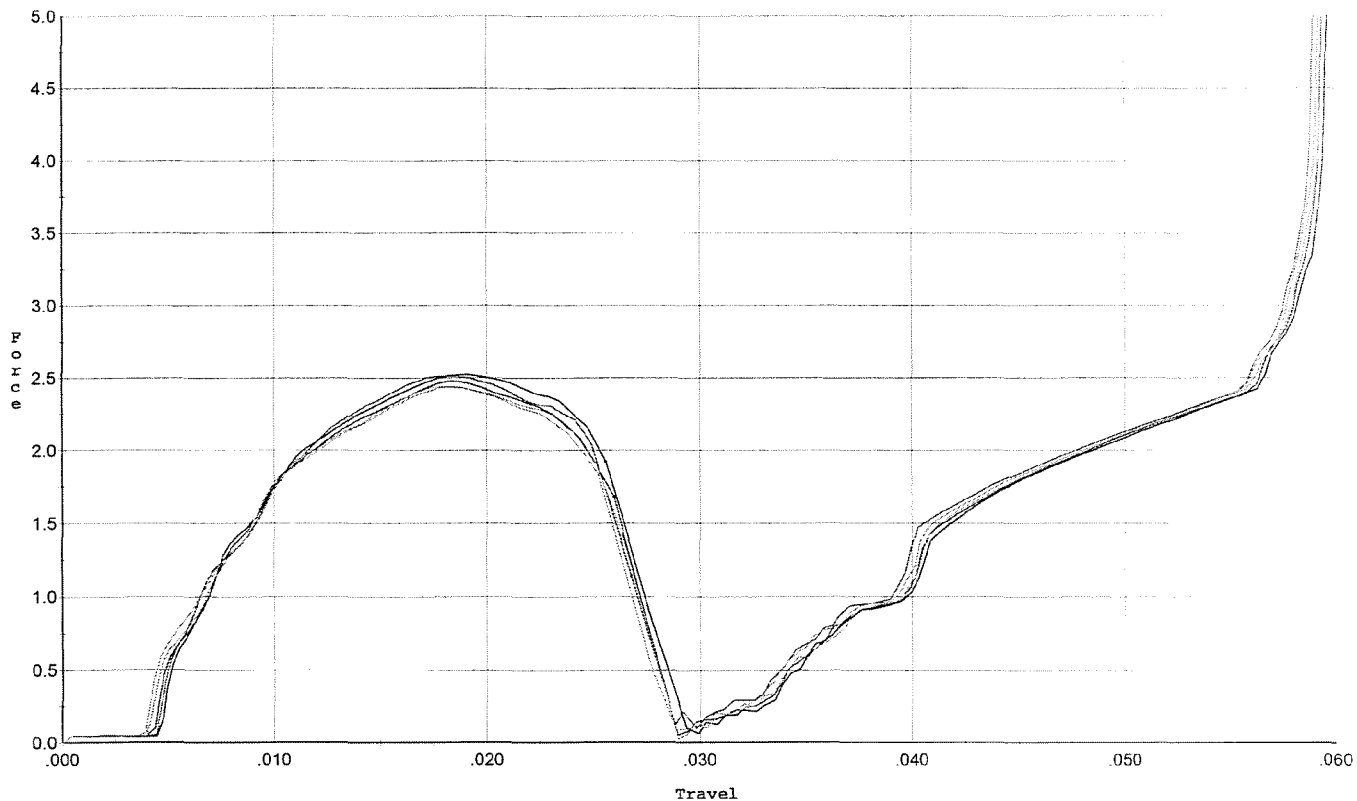
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.127	0.032	0.008	0.030	0.075		Set Trigger
2	4.091	0.032	0.008	0.030	0.075		Set Trigger
3	4.053	0.032	0.008	0.031	0.074		Set Trigger
4	4.074	0.032	0.008	0.030	0.074		Set Trigger
5	4.098	0.031	0.008	0.030	0.073		Set Trigger

Aug 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/24/09

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



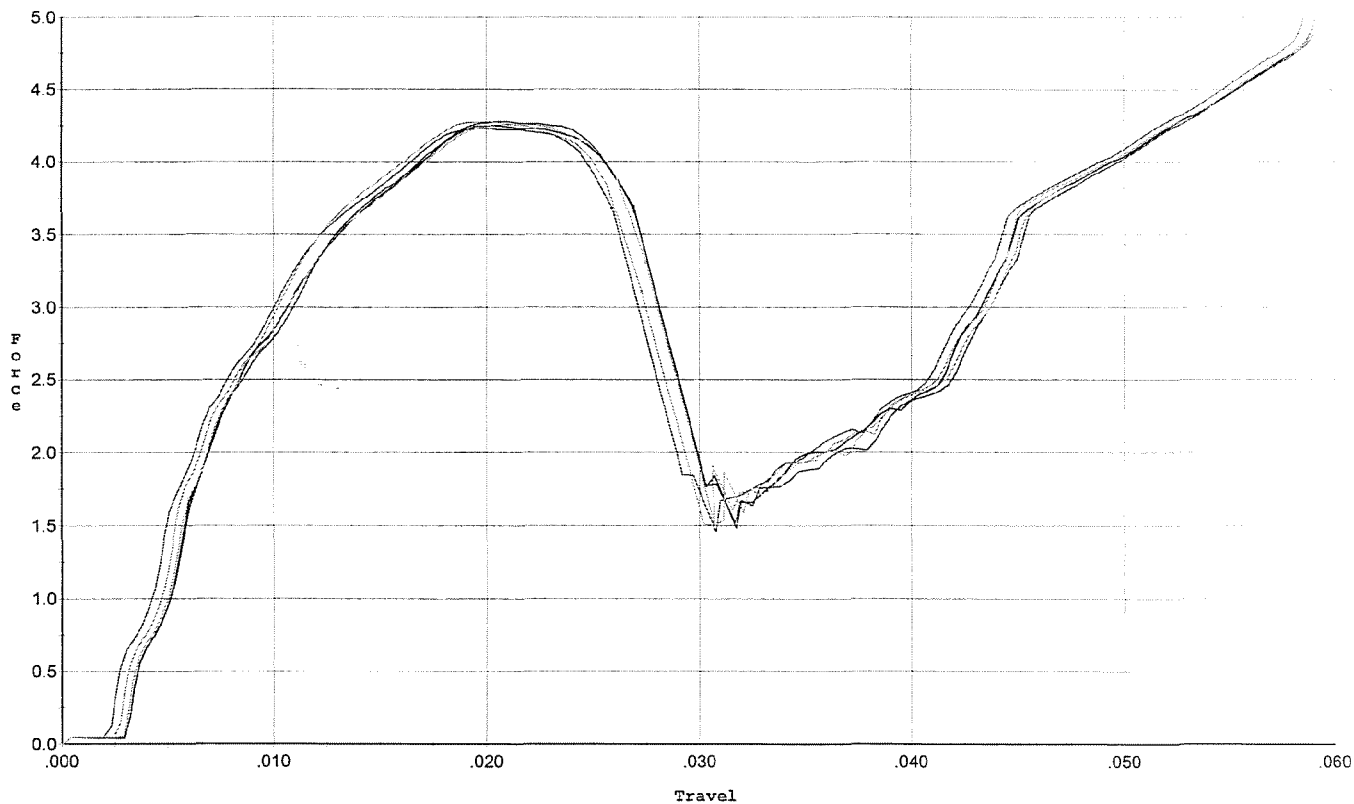
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.026	0.005	0.039	0.040		Set Trigger
2	2.520	0.026	0.005	0.039	0.041		Set Trigger
3	2.513	0.027	0.005	0.039	0.042		Set Trigger
4	2.437	0.026	0.004	0.039	0.040		Set Trigger
5	2.442	0.025	0.004	0.039	0.039		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/24/09

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.278	0.027	0.003	0.034	0.074		Set Trigger
2	4.245	0.027	0.003	0.033	0.074		Set Trigger
3	4.230	0.026	0.002	0.034	0.072		Set Trigger
4	4.259	0.027	0.003	0.033	0.075		Set Trigger
5	4.277	0.027	0.003	0.034	0.075		Set Trigger

Avg 4.25