

G 6868451

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

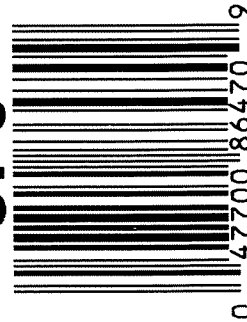
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6868451

UPC



GUN SERIAL # G 6868451

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-09	SPD
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	7-28-09	SPD
470	DIS-ASSEMBLE ACTION		7-28-09	SPD
472	SERIALIZE BOLT HANDLE		7-29-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	7/31/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	DWD
510	DRILL AND TAP SIGHT HOLES		7-29-09	SP
520	GOFF BLAST BBL / REC		7/31/09	SP
540	APPLY COATINGS (BARREL ACTION)		8/11	SP
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-21-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

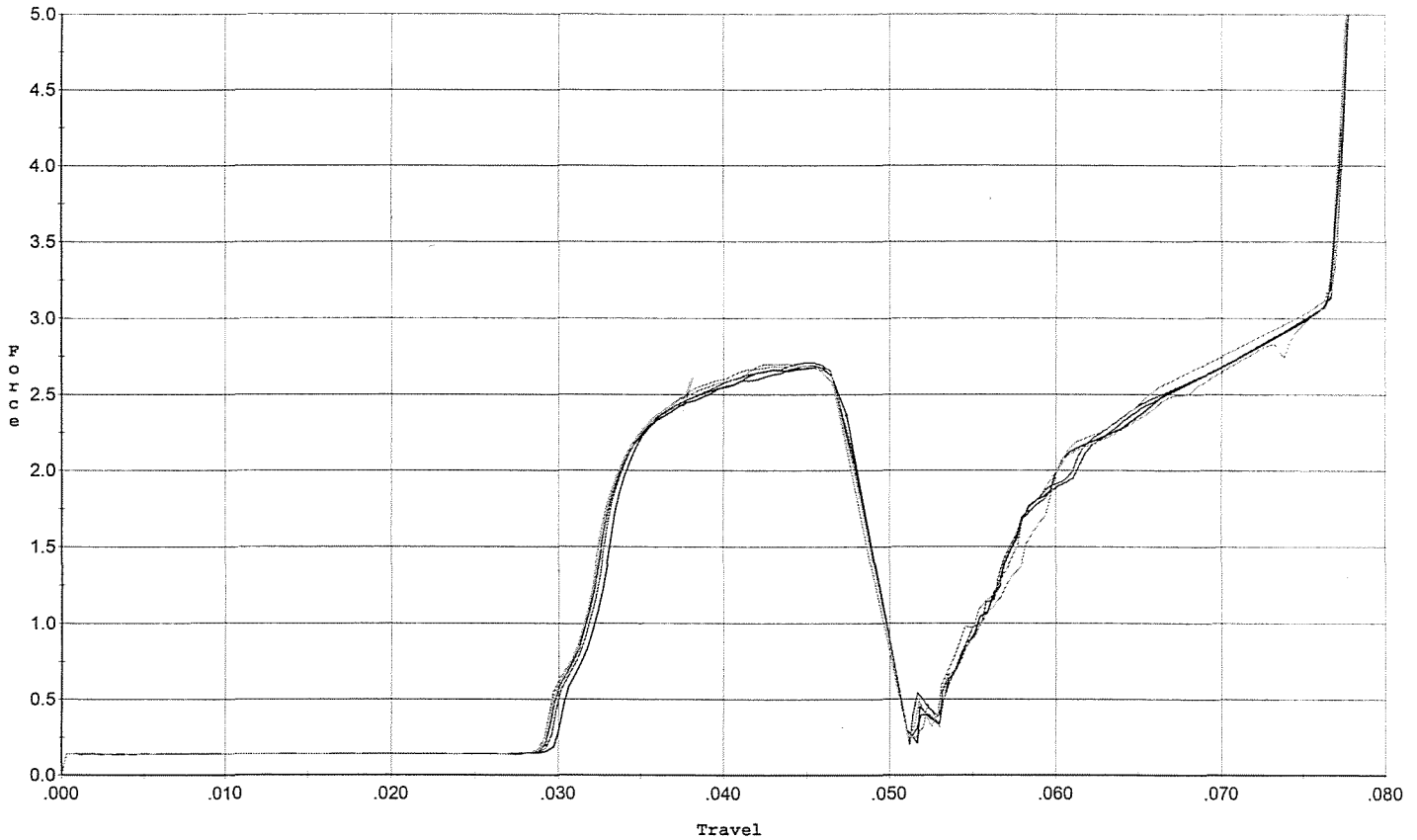
560	F) SAFETY ON FORCE	10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	8-22-09	RN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6.0</u>	<u>6.0</u>	<u>6.0</u>	8-22-09	RN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.023</u>	8-22-09	RN		
	J) ASSEMBLE STOCK					8-21-09	RN		
	K) ASSEMBLE SWIVEL STUDS					8-22-09	RN		
	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		8-21-09	RN		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					8-21-09	RP		
670	FINAL INSPECTION A) HEADSPACE					8-22-09	RN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u>	<u>2.15</u>	<u>2.09</u>	<u>2.19</u>	<u>2.11</u>	8-22-09	RTZ
	C) FUNCTION					8-22-09	RN		
690	PACK					8/24/09	FM		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



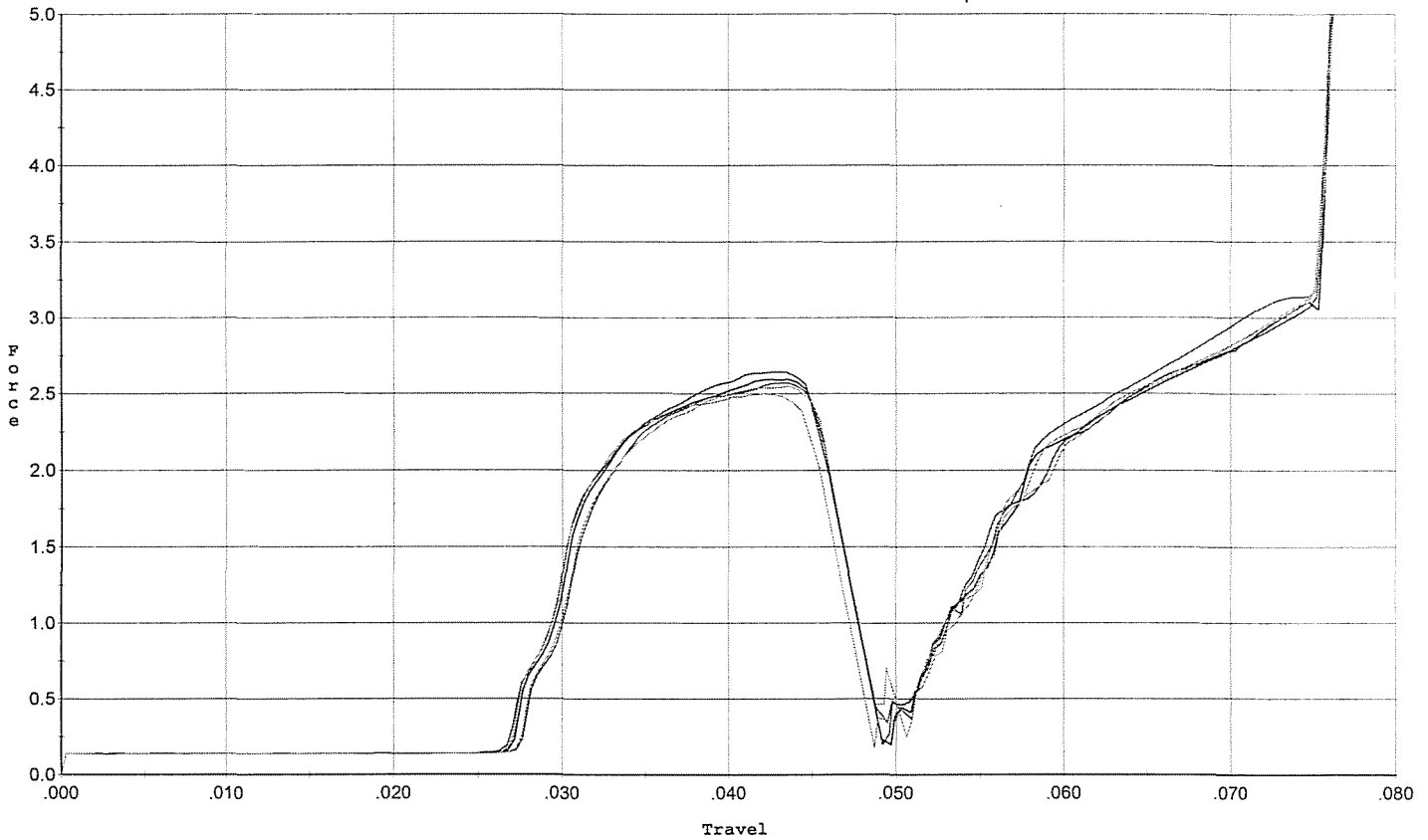
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.691	0.048	0.030	0.034	0.045		Set Trigger
2	2.678	0.047	0.030	0.034	0.043		Set Trigger
3	2.710	0.048	0.030	0.034	0.045		Set Trigger
4	2.685	0.048	0.029	0.034	0.046		Set Trigger
5	2.702	0.047	0.029	0.034	0.044		Set Trigger

A 2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



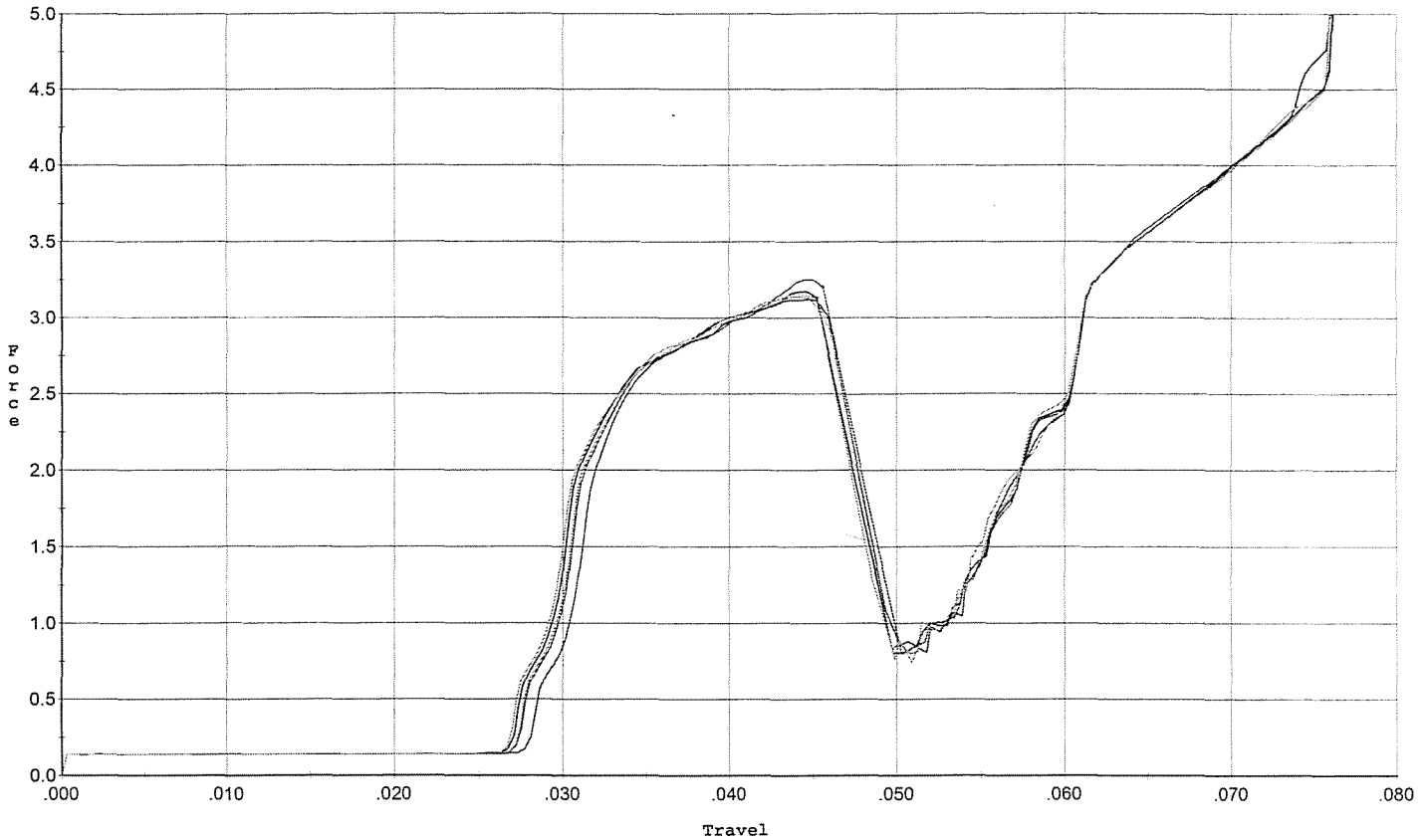
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.643	0.046	0.027	0.034	0.044		Set Trigger
2	2.593	0.046	0.027	0.034	0.043		Set Trigger
3	2.569	0.045	0.028	0.034	0.042		Set Trigger
4	2.550	0.045	0.028	0.034	0.042		Set Trigger
5	2.501	0.045	0.027	0.034	0.042		Set Trigger

A-257

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



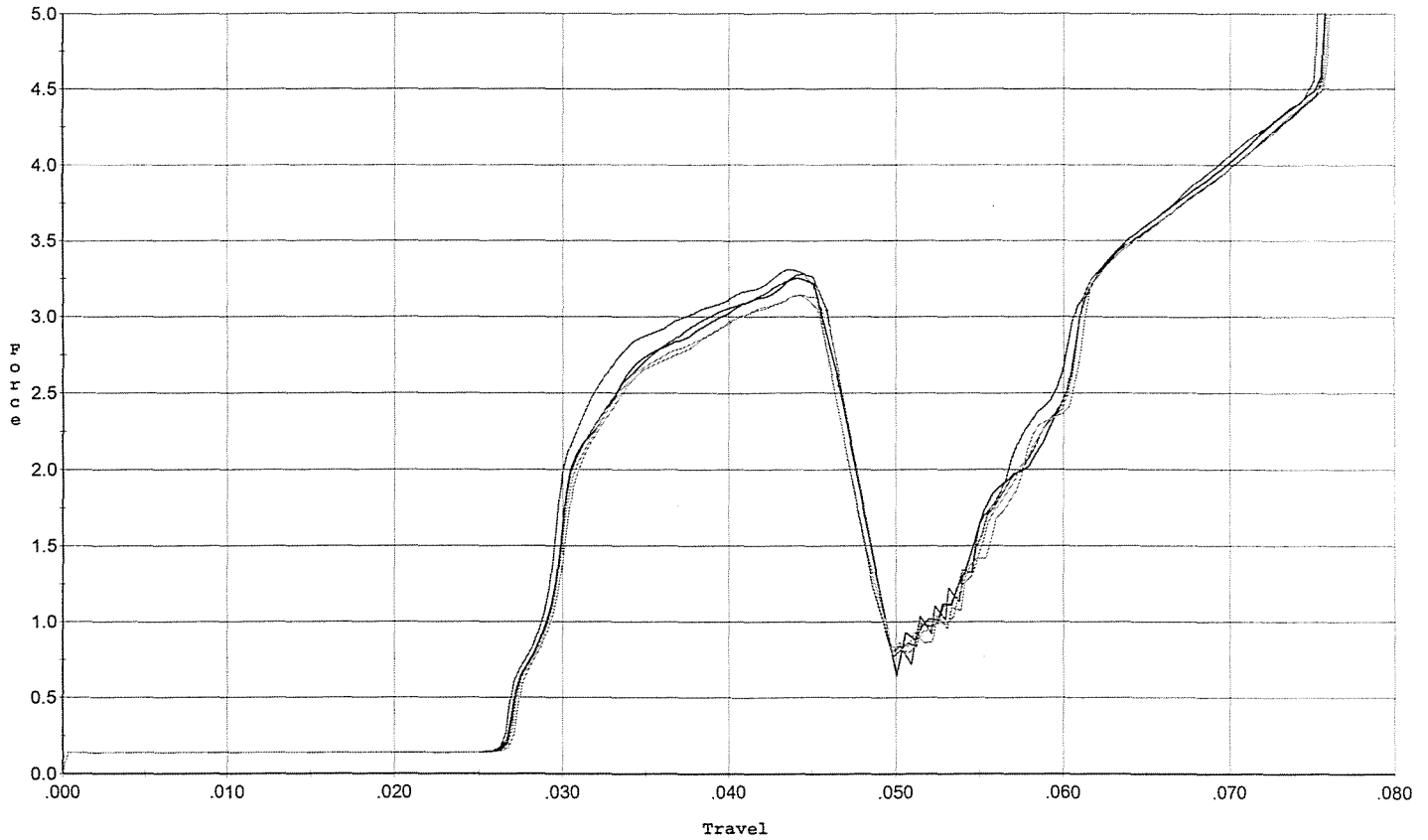
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.046	0.028	0.032	0.050		Set Trigger
2	3.173	0.045	0.027	0.032	0.051		Set Trigger
3	3.253	0.046	0.028	0.032	0.051		Set Trigger
4	3.156	0.046	0.027	0.032	0.052		Set Trigger
5	3.139	0.045	0.027	0.032	0.051		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



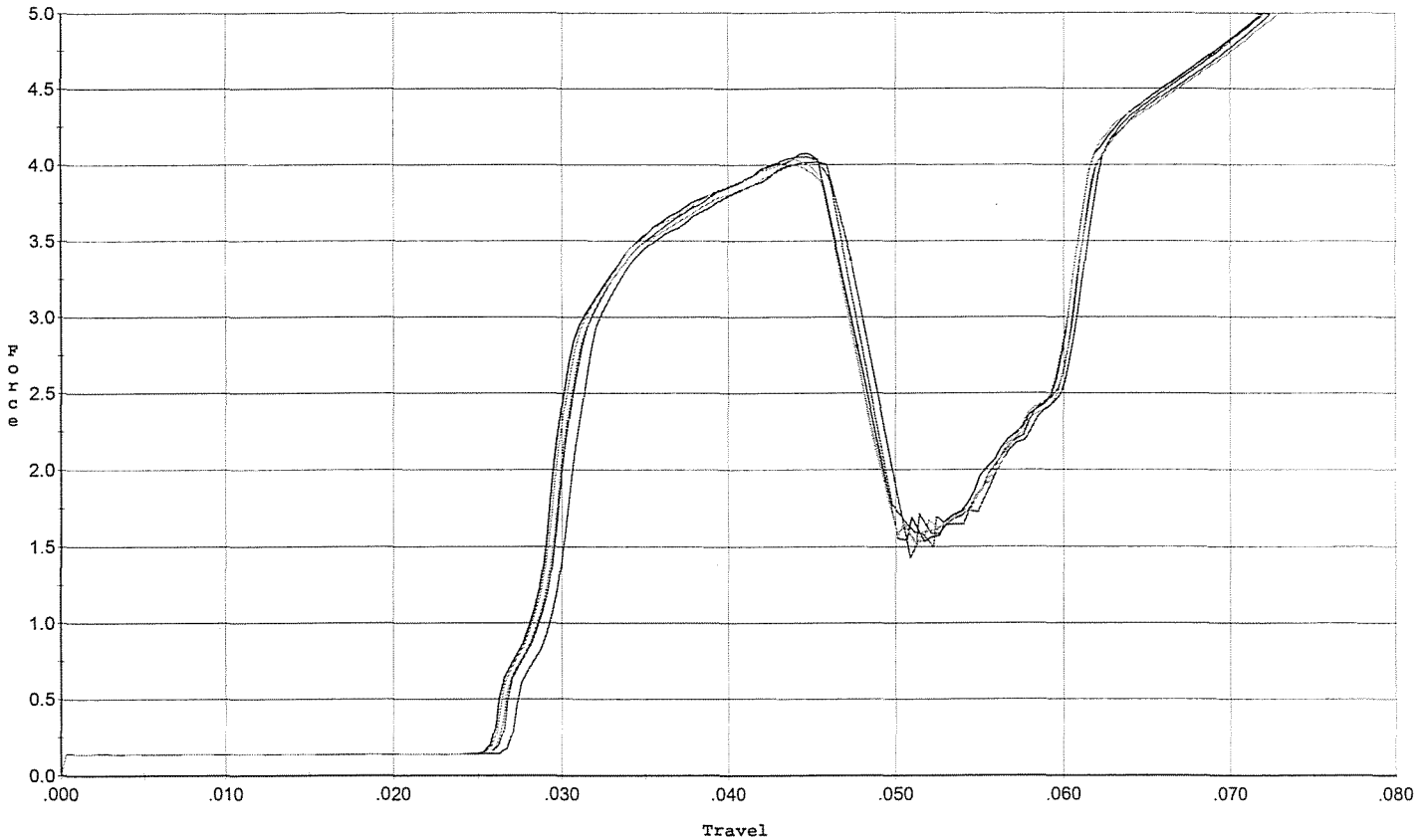
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.279	0.046	0.027	0.032	0.054		Set Trigger
2	3.253	0.047	0.027	0.032	0.054		Set Trigger
3	3.310	0.045	0.027	0.032	0.054		Set Trigger
4	3.139	0.045	0.027	0.032	0.051		Set Trigger
5	3.145	0.046	0.027	0.032	0.052		Set Trigger

A3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



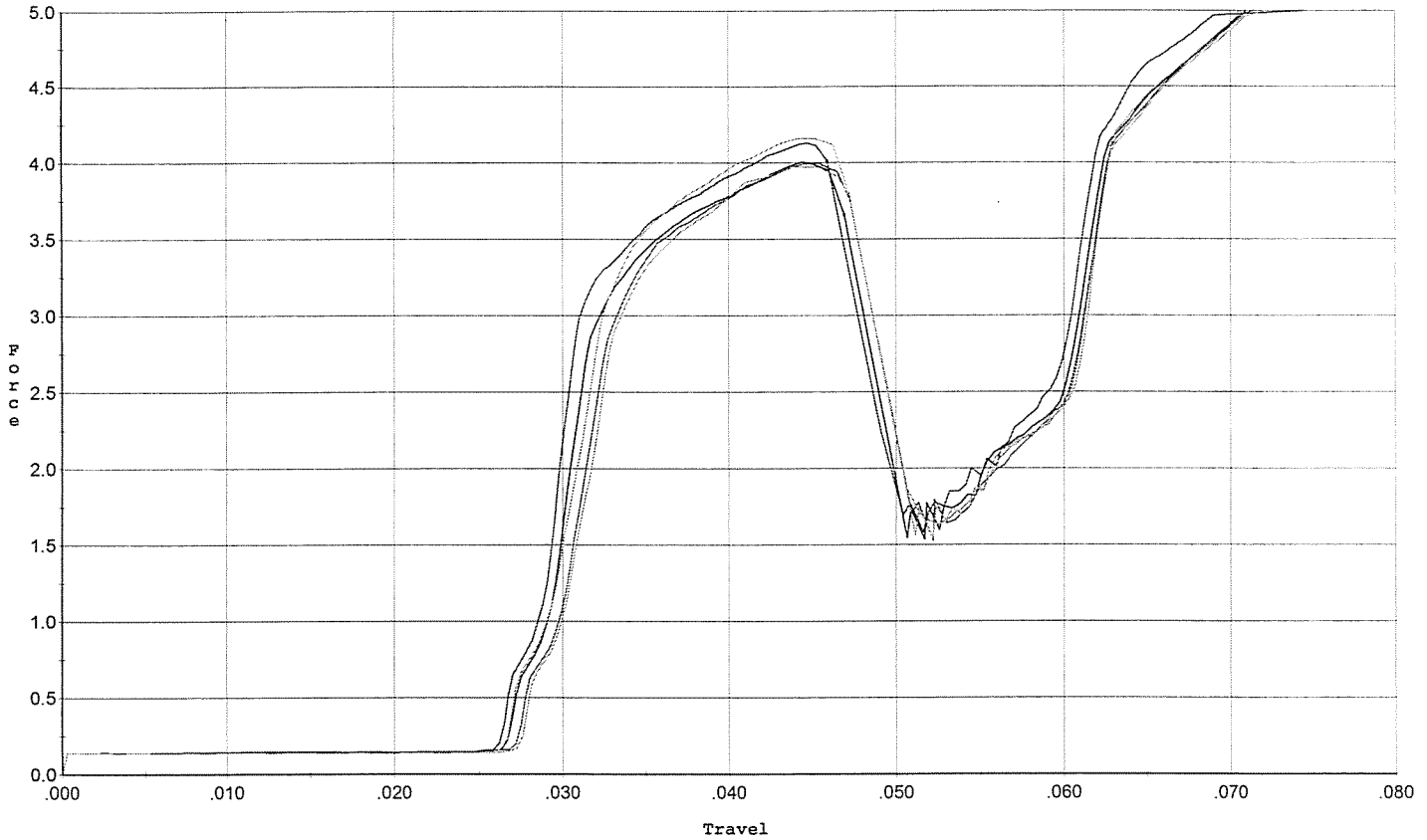
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.019	0.047	0.027	0.031	0.069		Set Trigger
2	4.076	0.048	0.026	0.030	0.072		Set Trigger
3	4.053	0.046	0.027	0.030	0.069		Set Trigger
4	4.038	0.046	0.026	0.030	0.068		Set Trigger
5	3.999	0.046	0.026	0.031	0.067		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



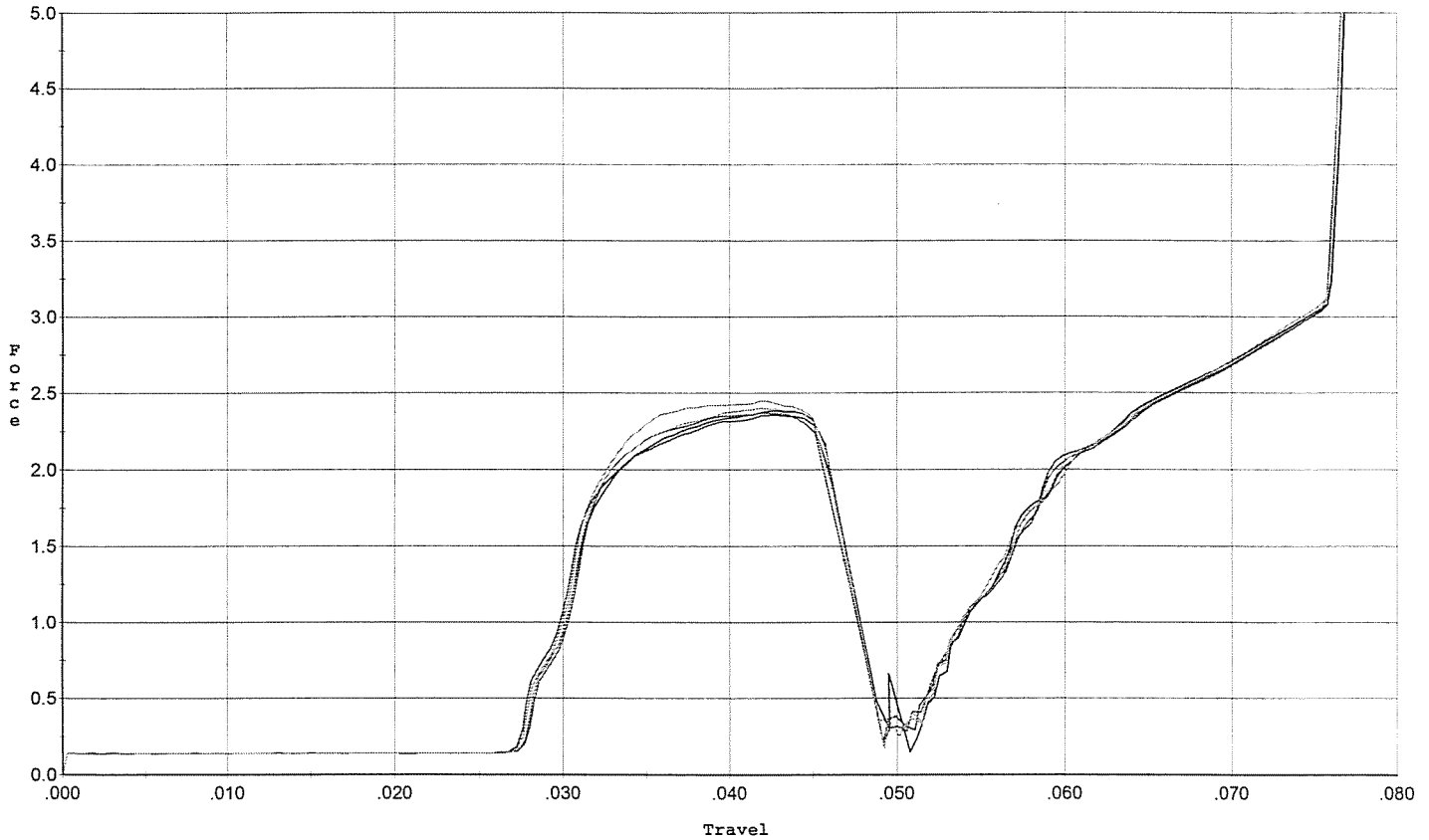
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.046	0.026	0.030	0.070		Set Trigger
2	4.004	0.047	0.027	0.030	0.069		Set Trigger
3	3.996	0.047	0.028	0.031	0.068		Set Trigger
4	4.158	0.047	0.027	0.031	0.072		Set Trigger
5	3.974	0.047	0.028	0.031	0.067		Set Trigger

A. 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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



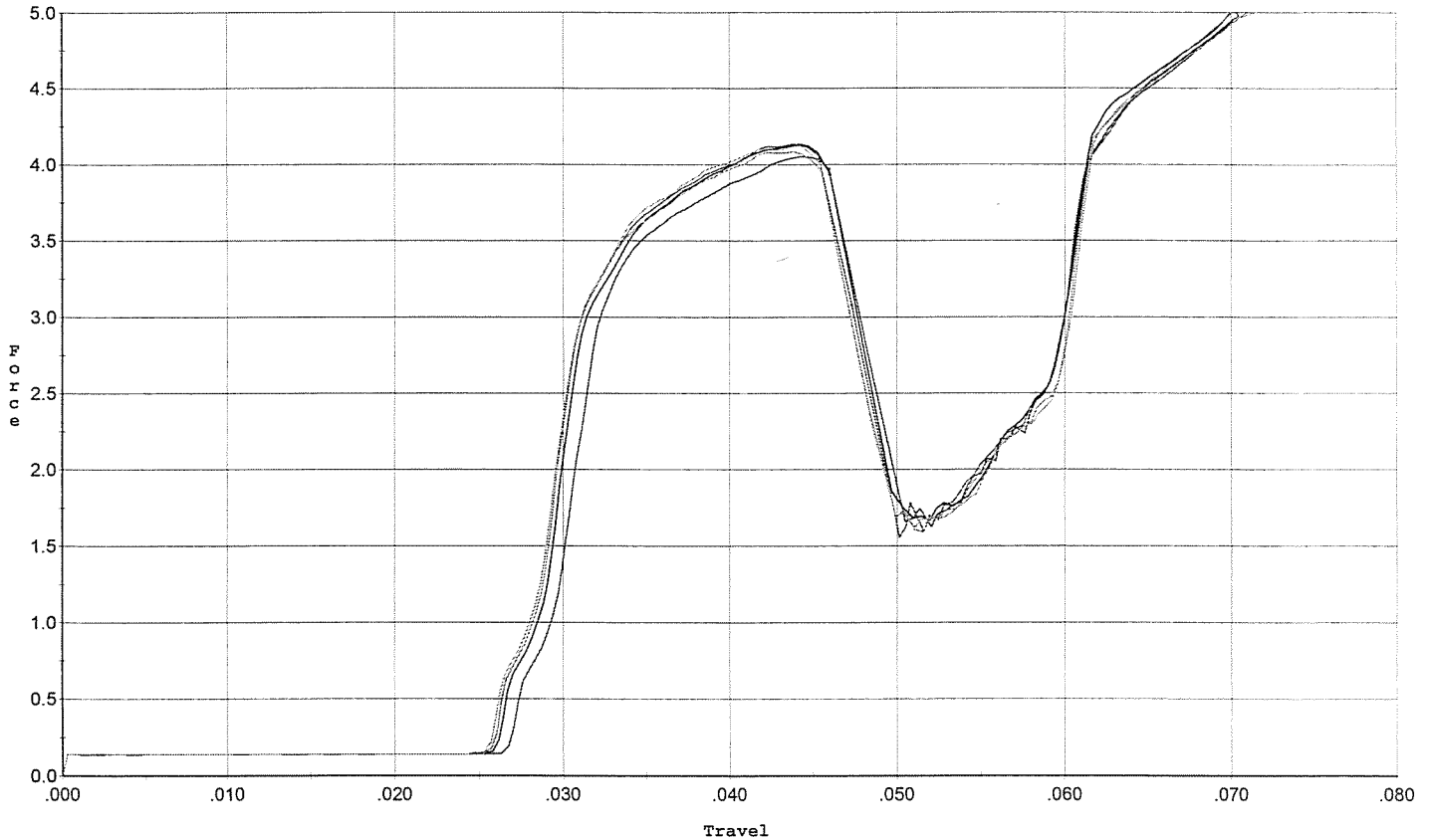
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.353	0.046	0.028	0.034	0.041		Set Trigger
2	2.383	0.046	0.028	0.034	0.040		Set Trigger
3	2.371	0.047	0.028	0.034	0.041		Set Trigger
4	2.402	0.046	0.028	0.034	0.041		Set Trigger
5	2.446	0.046	0.028	0.034	0.042		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

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	4.051	0.046	0.027	0.031	0.067		Set Trigger
2	4.133	0.046	0.026	0.030	0.070		Set Trigger
3	4.133	0.047	0.026	0.030	0.073		Set Trigger
4	4.122	0.045	0.026	0.030	0.070		Set Trigger
5	4.085	0.045	0.026	0.030	0.070		Set Trigger

A4-10