

66868453

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

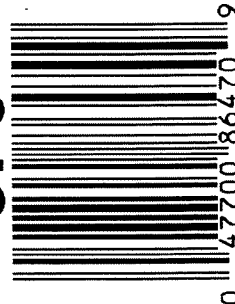


BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6868453

UPC



GUN SERIAL # G 6868453

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		7-28-09	SPD
470	DIS-ASSEMBLE ACTION		7-28-09	SPD
472	SERIALIZE BOLT HANDLE		7-29-09	RTZ
480	MAGNAFLUX BBL ACTION		7/31/09	(SP)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	AWO
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	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-24-09	FR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

MAGNA - FLUX

- 4009

OPERATOR SP

F004 REV 5/2006

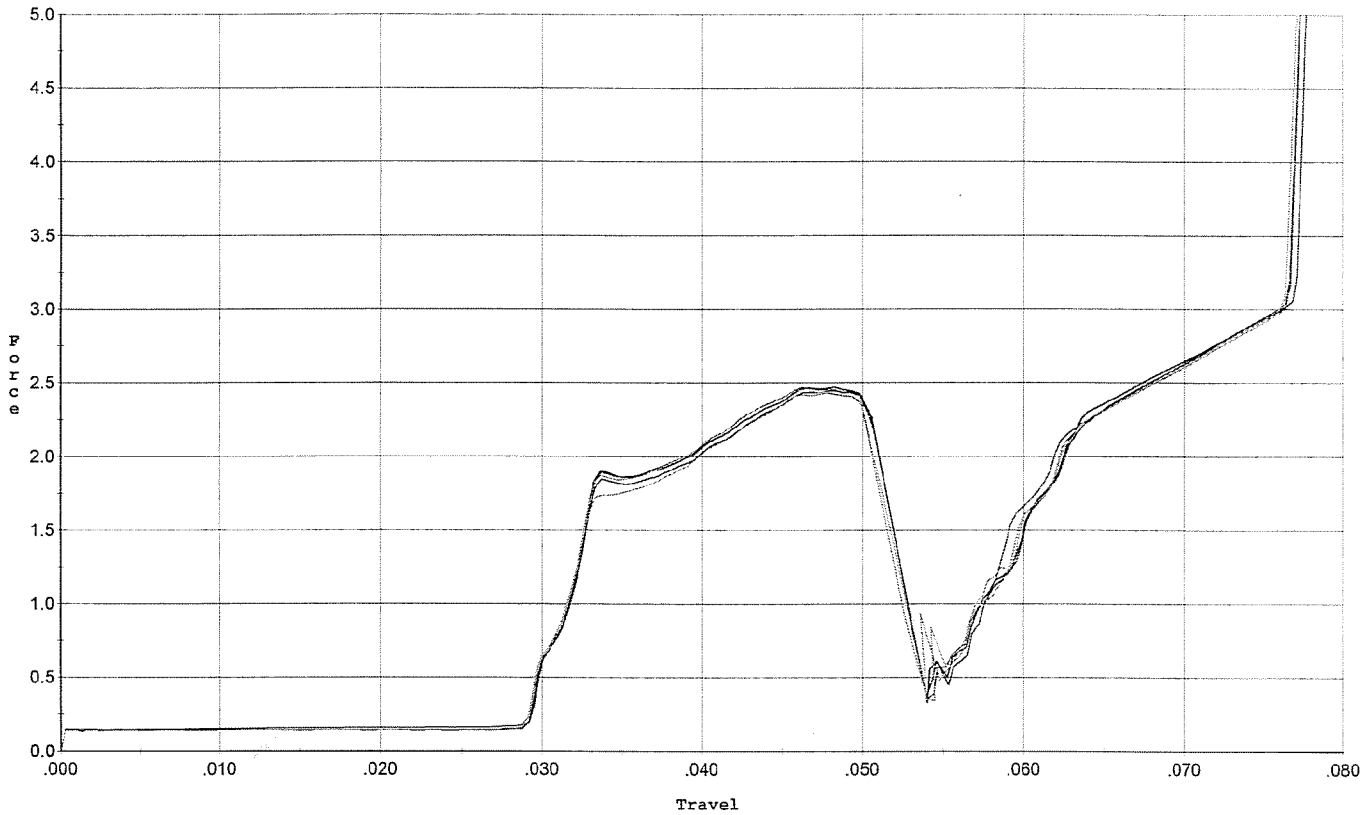
560	BARBER - M24 0094737 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3°</u>	<u>3°</u>	<u>3°</u>	8/26/09	RB	
CONT.								
	G) SAFETY OFF FORCE	2 LBS MIN	<u>7°</u>	<u>7°</u>	<u>7°</u>	8/26/09	RB	
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	8/26/09	RB	
	J) ASSEMBLE STOCK					8/24/09	RTZ	
	K) ASSEMBLE SWIVEL STUDS					8/26/09	RB	
	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		8/25/09	RB	
			<u>PASS</u>	FAIL				
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
660	INSPECT FOR LIVE AMMO					8/25/09	TAR	
670	FINAL INSPECTION A) HEADSPACE					8/26/09	RB	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u>	<u>2.83</u>	<u>2.82</u>	<u>2.72</u>	<u>2.71</u>	8/26/09 RB
	C) FUNCTION					8/26/09	RB	
690	PACK					8/24/09	Em	

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



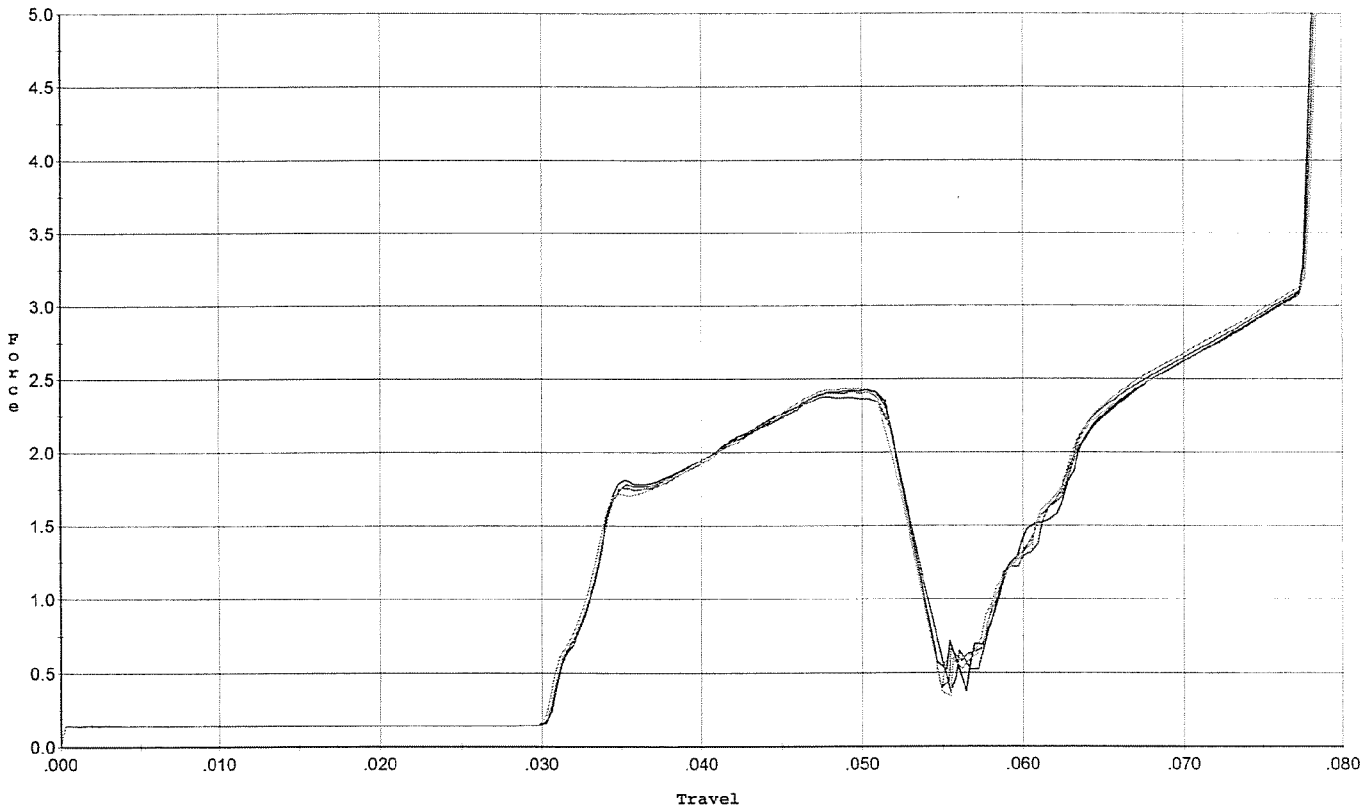
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.446	0.051	0.030	0.032	0.046		Set Trigger
2	2.469	0.051	0.029	0.032	0.047		Set Trigger
3	2.467	0.051	0.029	0.032	0.047		Set Trigger
4	2.453	0.052	0.029	0.032	0.048		Set Trigger
5	2.429	0.050	0.029	0.032	0.045		Set Trigger

A.2.45

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



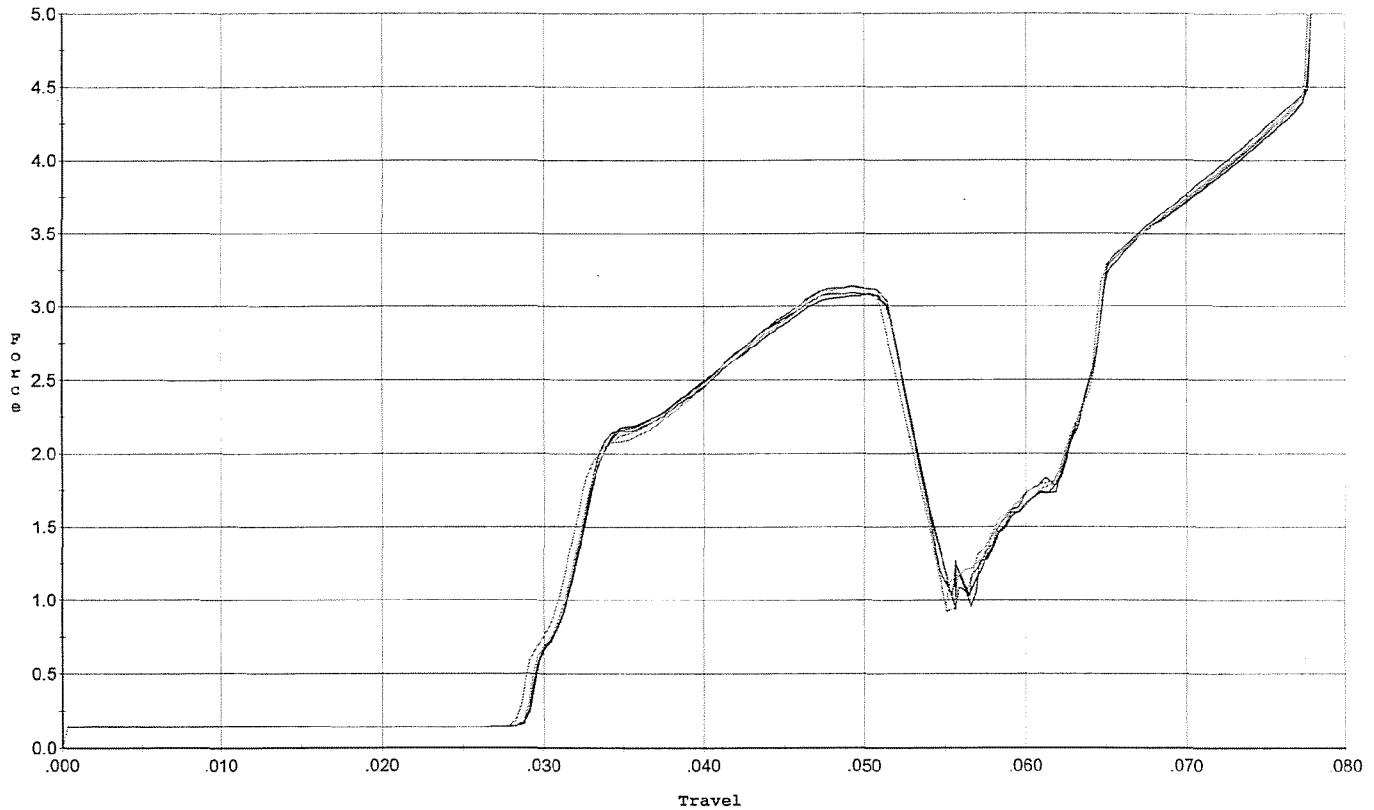
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.413	0.051	0.031	0.032	0.045		Set Trigger
2	2.426	0.051	0.031	0.032	0.046		Set Trigger
3	2.378	0.052	0.031	0.032	0.045		Set Trigger
4	2.411	0.052	0.031	0.032	0.046		Set Trigger
5	2.434	0.052	0.031	0.032	0.046		Set Trigger

A-2-41

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



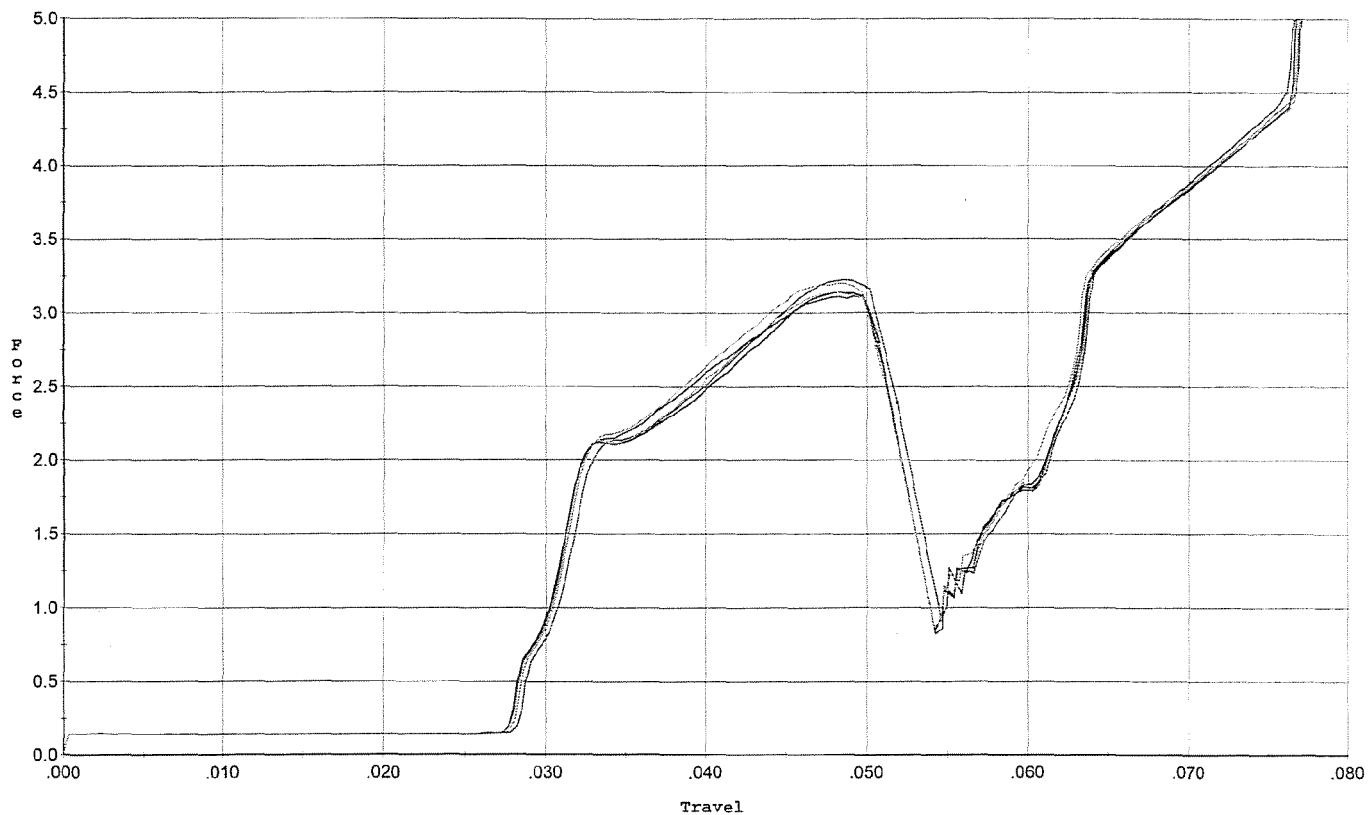
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.051	0.029	0.030	0.059		Set Trigger
2	3.089	0.051	0.029	0.030	0.059		Set Trigger
3	3.139	0.051	0.029	0.030	0.059		Set Trigger
4	3.134	0.052	0.029	0.030	0.059		Set Trigger
5	3.087	0.053	0.029	0.030	0.061		Set Trigger

A-3-10

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



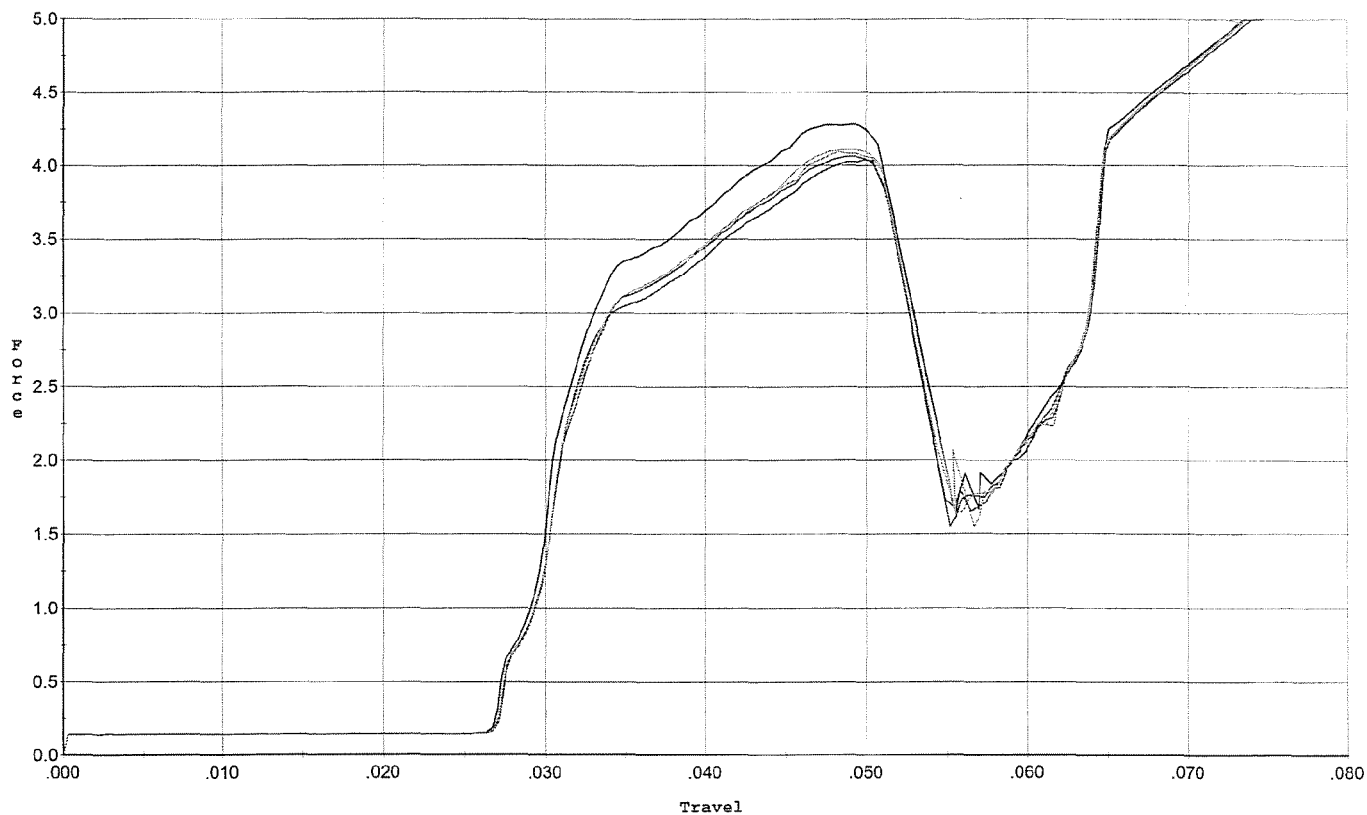
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.117	0.051	0.028	0.030	0.060		Set Trigger
2	3.140	0.051	0.028	0.030	0.059		Set Trigger
3	3.225	0.052	0.029	0.030	0.061		Set Trigger
4	3.198	0.051	0.028	0.030	0.060		Set Trigger
5	3.140	0.051	0.028	0.030	0.059		Set Trigger

A-3-14

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 +/-n 1.0 lb



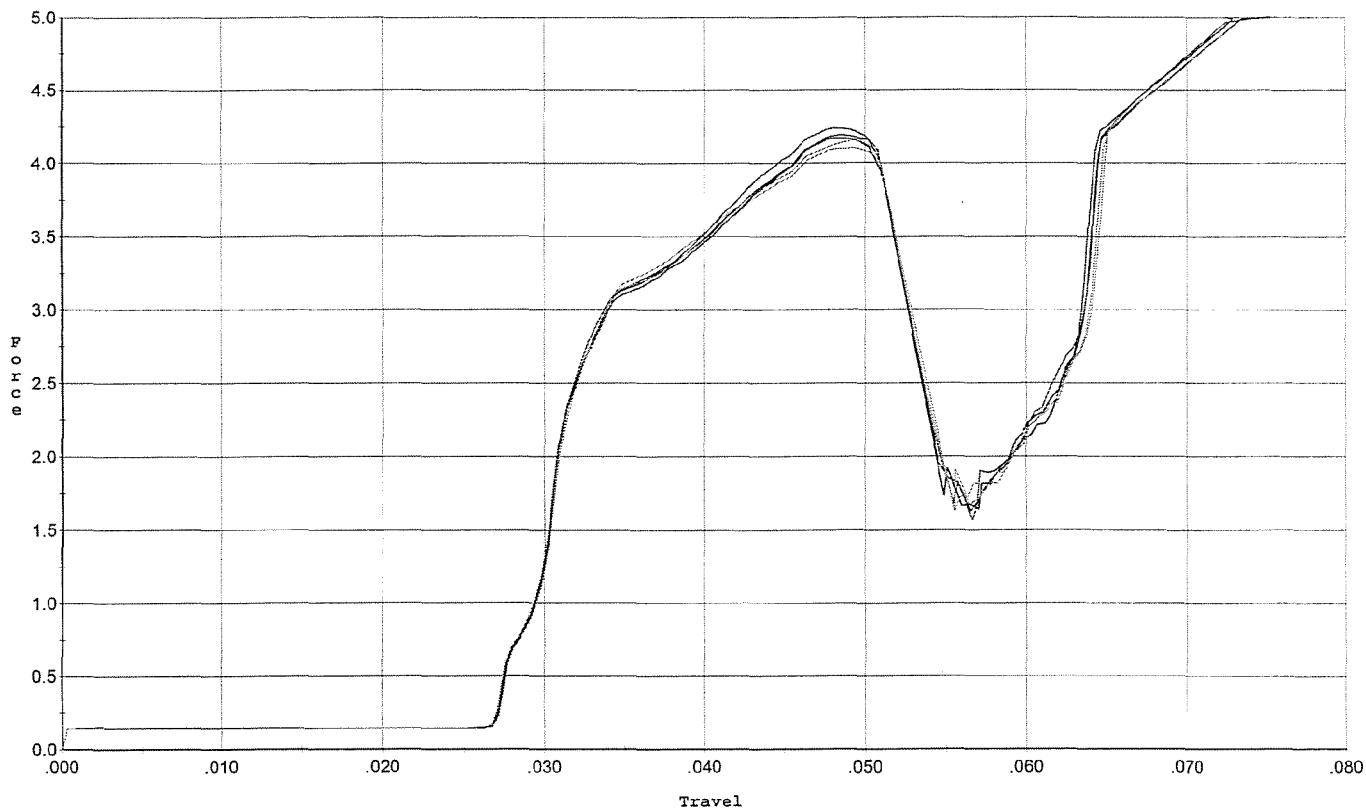
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.040	0.051	0.027	0.029	0.080		Set Trigger
2	4.280	0.053	0.027	0.028	0.089		Set Trigger
3	4.061	0.051	0.027	0.029	0.081		Set Trigger
4	4.109	0.051	0.027	0.029	0.081		Set Trigger
5	4.091	0.051	0.027	0.029	0.081		Set Trigger

A-4-11

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 +/-n 1.0 lb



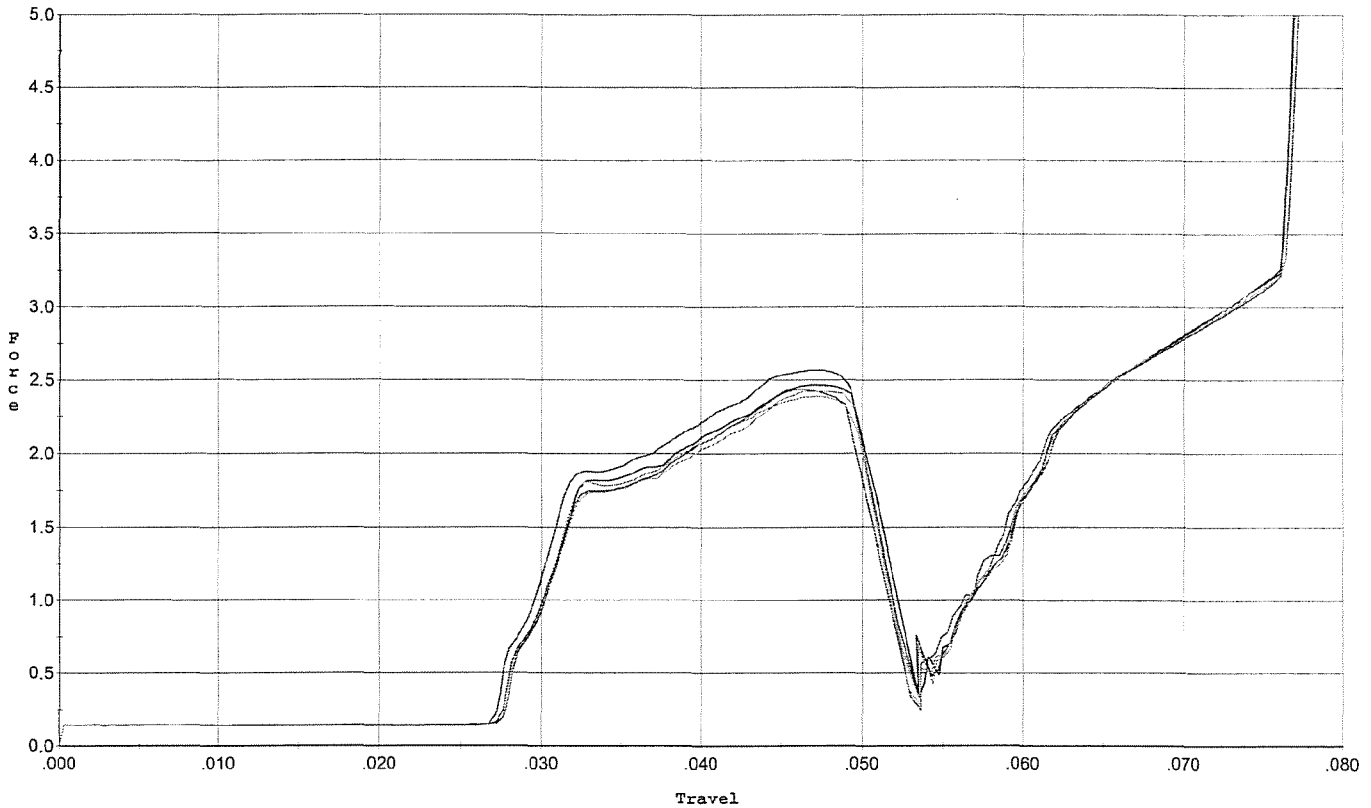
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.192	0.051	0.027	0.028	0.082		Set Trigger
2	4.172	0.051	0.027	0.029	0.082		Set Trigger
3	4.239	0.051	0.027	0.029	0.082		Set Trigger
4	4.104	0.051	0.027	0.029	0.081		Set Trigger
5	4.153	0.053	0.027	0.028	0.086		Set Trigger

A. 4.17

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



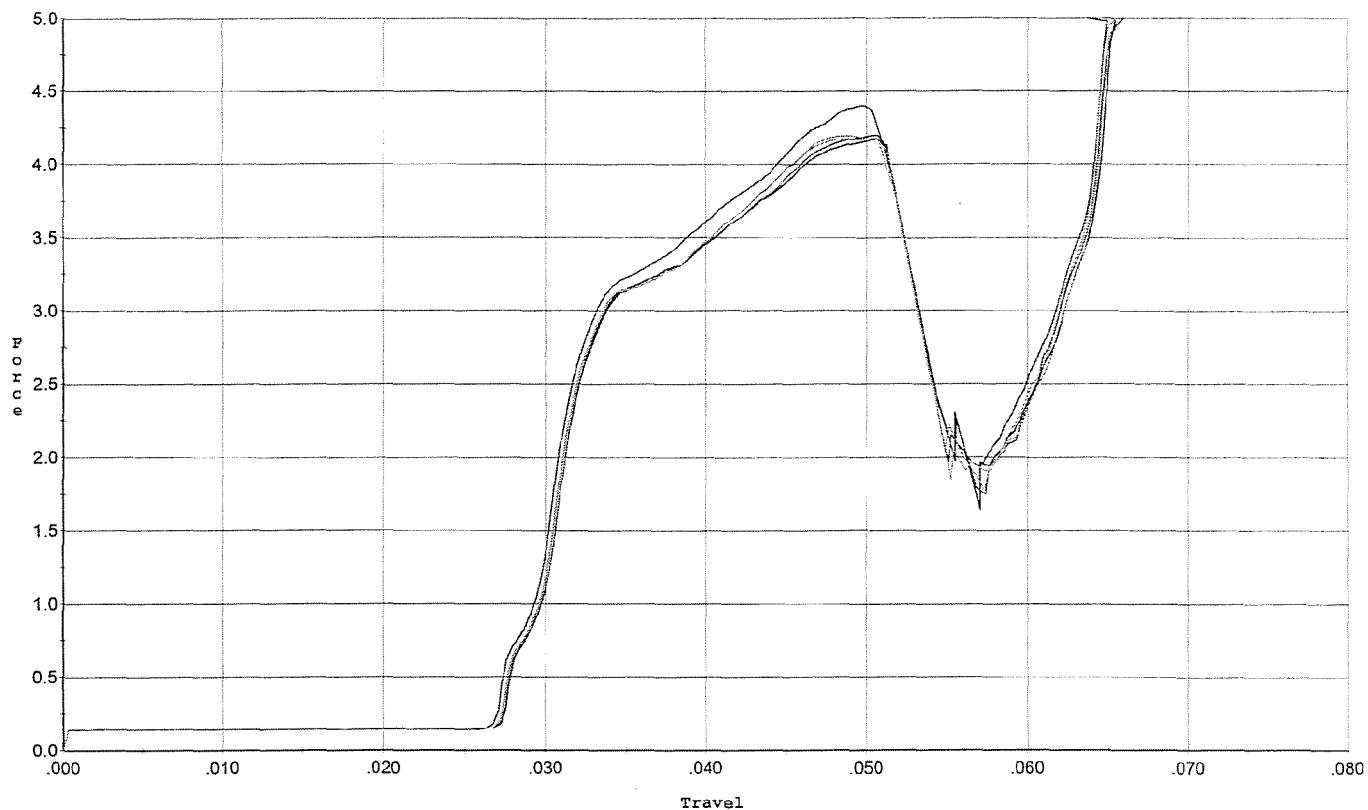
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.566	0.049	0.027	0.031	0.049		Set Trigger
2	2.466	0.051	0.028	0.031	0.048		Set Trigger
3	2.437	0.051	0.028	0.032	0.047		Set Trigger
4	2.389	0.050	0.028	0.032	0.046		Set Trigger
5	2.422	0.049	0.028	0.032	0.046		Set Trigger

A2-45

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	4.400	0.052	0.027	0.028	0.086		Set Trigger
2	4.174	0.051	0.028	0.028	0.082		Set Trigger
3	4.196	0.051	0.028	0.028	0.082		Set Trigger
4	4.176	0.052	0.027	0.028	0.084		Set Trigger
5	4.192	0.051	0.027	0.028	0.083		Set Trigger

A-4-22