

Q685-2280

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



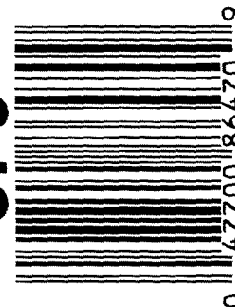
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6852280

UPC



BM FORM

GUN SERIAL #

G 6852280

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-5-09	RP
430	ASSEMBLE TO STOCK		5-5-09	SP
440	PROOF		5-5-09	RP
460	CHECK HEADSPACE	MAGNA-FLUX	5-5-09	RP
470	DIS-ASSEMBLE ACTION		5-5-09	RP
472	SERIALIZE BOLT HANDLE		5/6/09	RTZ
480	MAGNAFLUX BBL ACTION	ATOR	5/8/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/12/09	RT
510	DRILL AND TAP SIGHT HOLES		5-6-09	SP
520	GOFF BLAST BBL / REC		5/12/09	REM
540	APPLY COATINGS (BARREL ACTION)		5/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-25-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

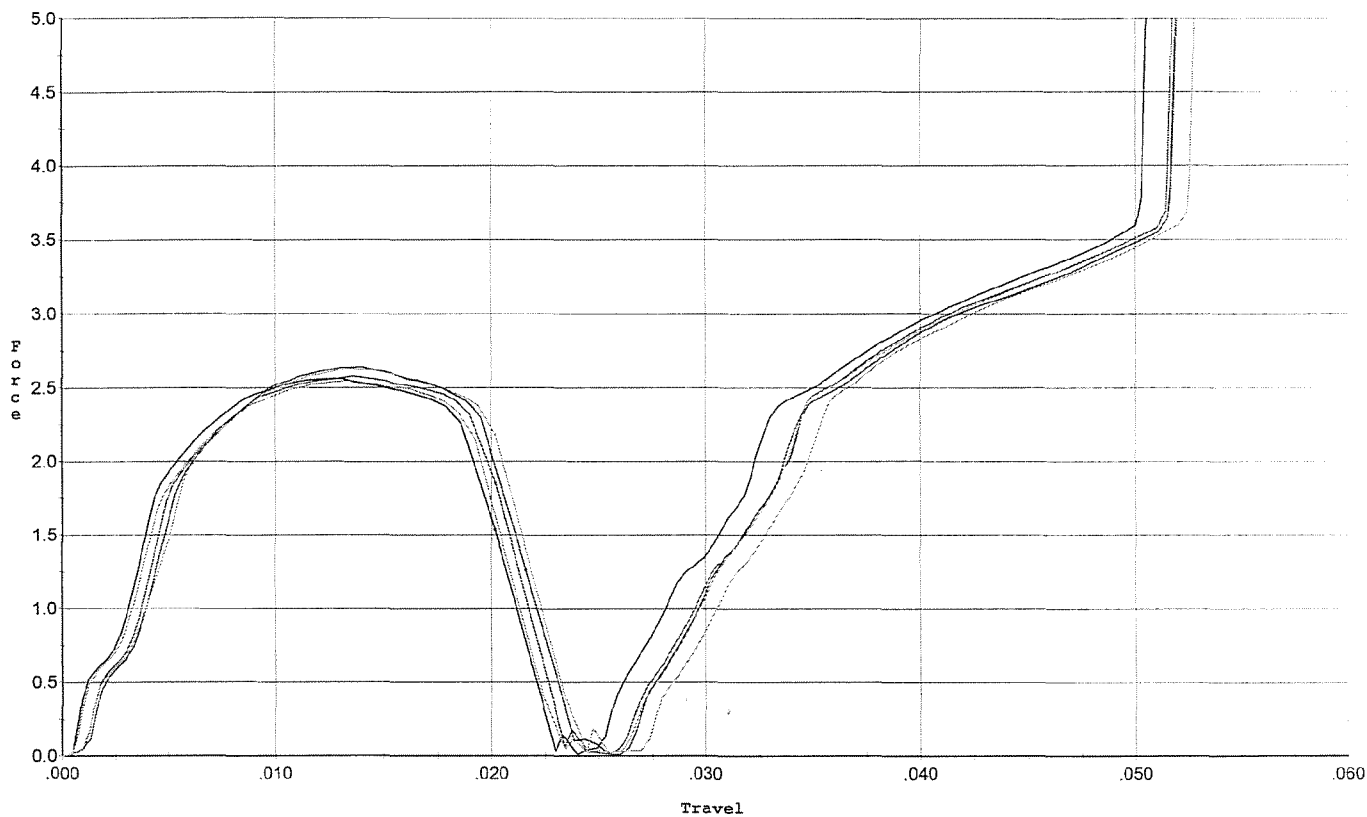
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	6-16-09	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7.0</u> <u>7.0</u> <u>7.0</u>	6-16-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	6-16-09	L.N.
	J) ASSEMBLE STOCK		5-28-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		6-16-09	L.N.
	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 <u>PASS</u> FAIL	6/14/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/11/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-16-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>274</u> <u>275</u> <u>269</u> <u>268</u> <u>265</u>	6-16-09	LT
	C) FUNCTION		6-16-09	L.N.
690	PACK		7/29/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



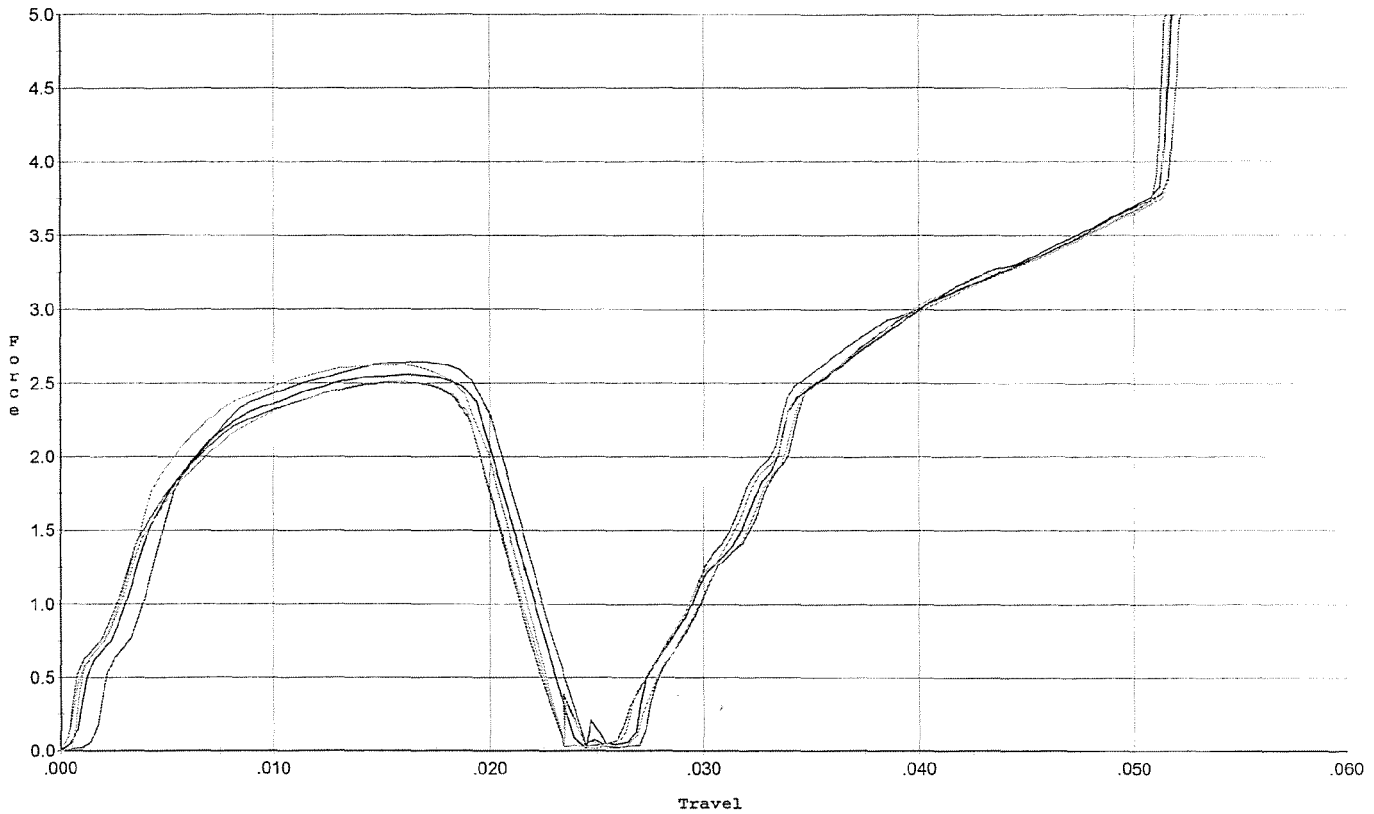
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.639	0.022	0.00	0.034	0.040		Set Trigger
2	2.561	0.020	0.00	0.034	0.038		Set Trigger
3	2.577	0.020	0.00	0.035	0.037		Set Trigger
4	2.626	0.020	0.00	0.035	0.038		Set Trigger
5	2.545	0.019	0.00	0.035	0.036		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



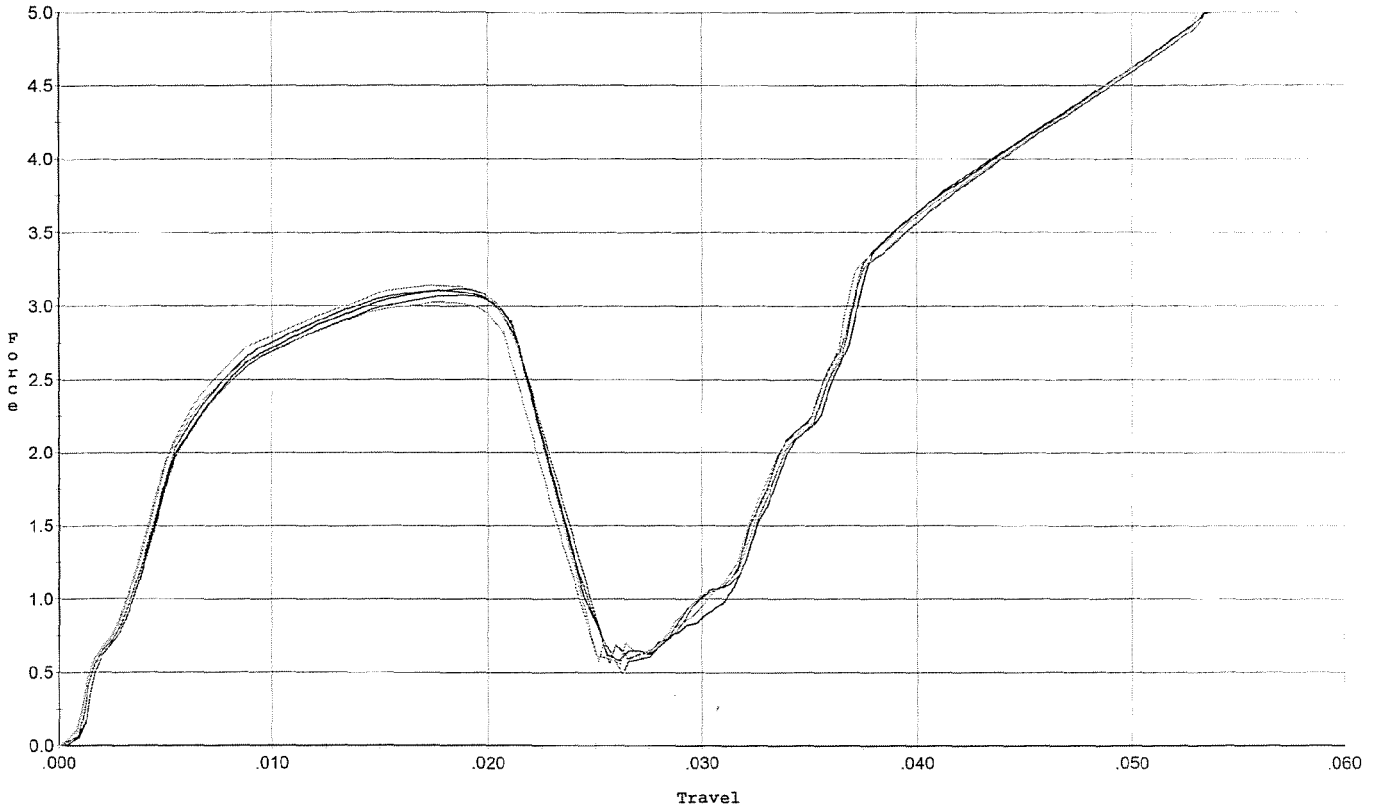
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.020	0.00	0.035	0.037		Set Trigger
2	2.559	0.022	0.00	0.034	0.040		Set Trigger
3	2.510	0.019	0.00	0.035	0.036		Set Trigger
4	2.512	0.019	0.00	0.036	0.035		Set Trigger
5	2.628	0.020	0.00	0.035	0.039		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/18/09

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



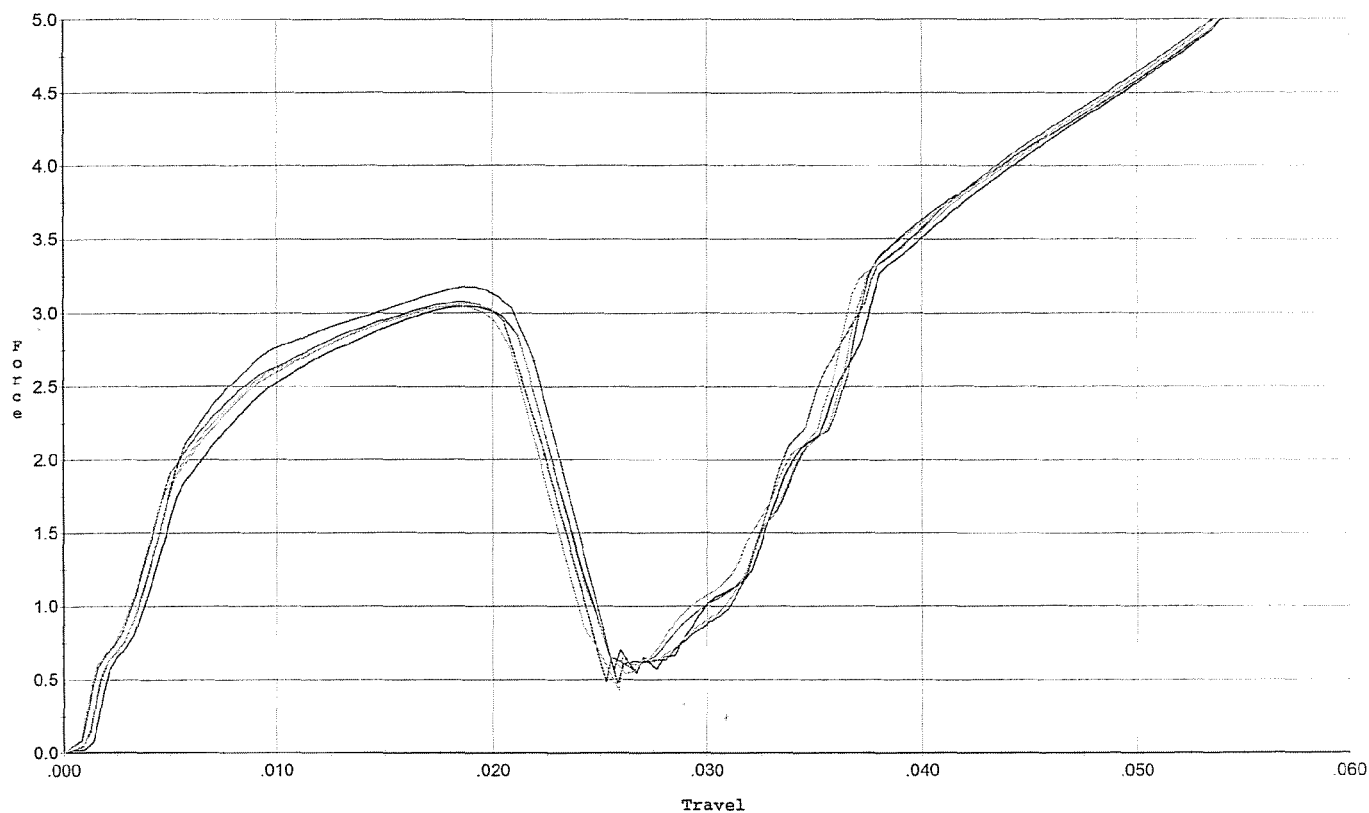
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.021	0.00	0.034	0.047		Set Trigger
2	3.108	0.021	0.00	0.034	0.046		Set Trigger
3	3.074	0.021	0.00	0.034	0.046		Set Trigger
4	3.141	0.021	0.00	0.034	0.048		Set Trigger
5	3.026	0.021	0.00	0.034	0.045		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



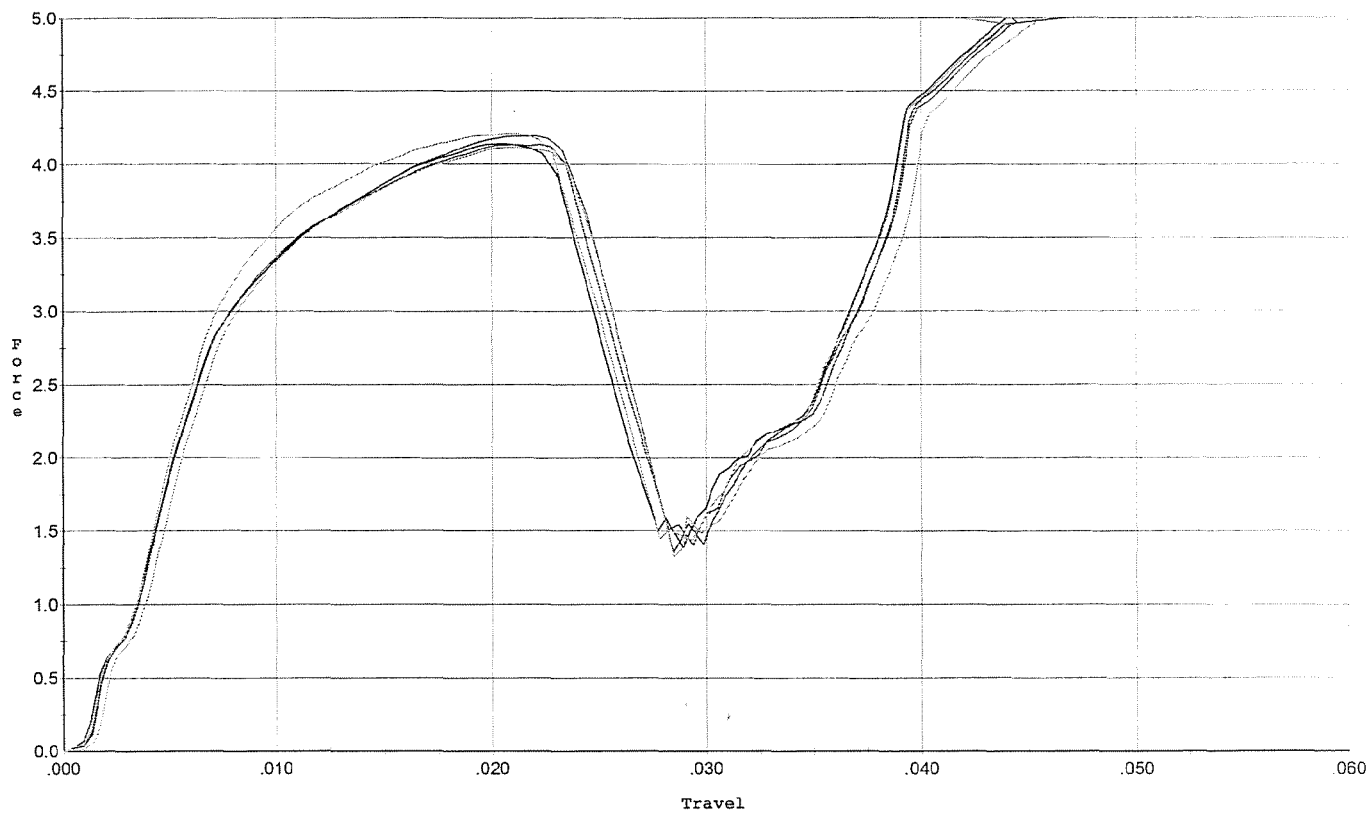
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.180	0.022	0.00	0.034	0.049		Set Trigger
2	3.047	0.021	0.00	0.035	0.044		Set Trigger
3	3.080	0.022	0.00	0.034	0.048		Set Trigger
4	3.066	0.021	0.00	0.035	0.045		Set Trigger
5	3.052	0.021	0.00	0.035	0.044		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



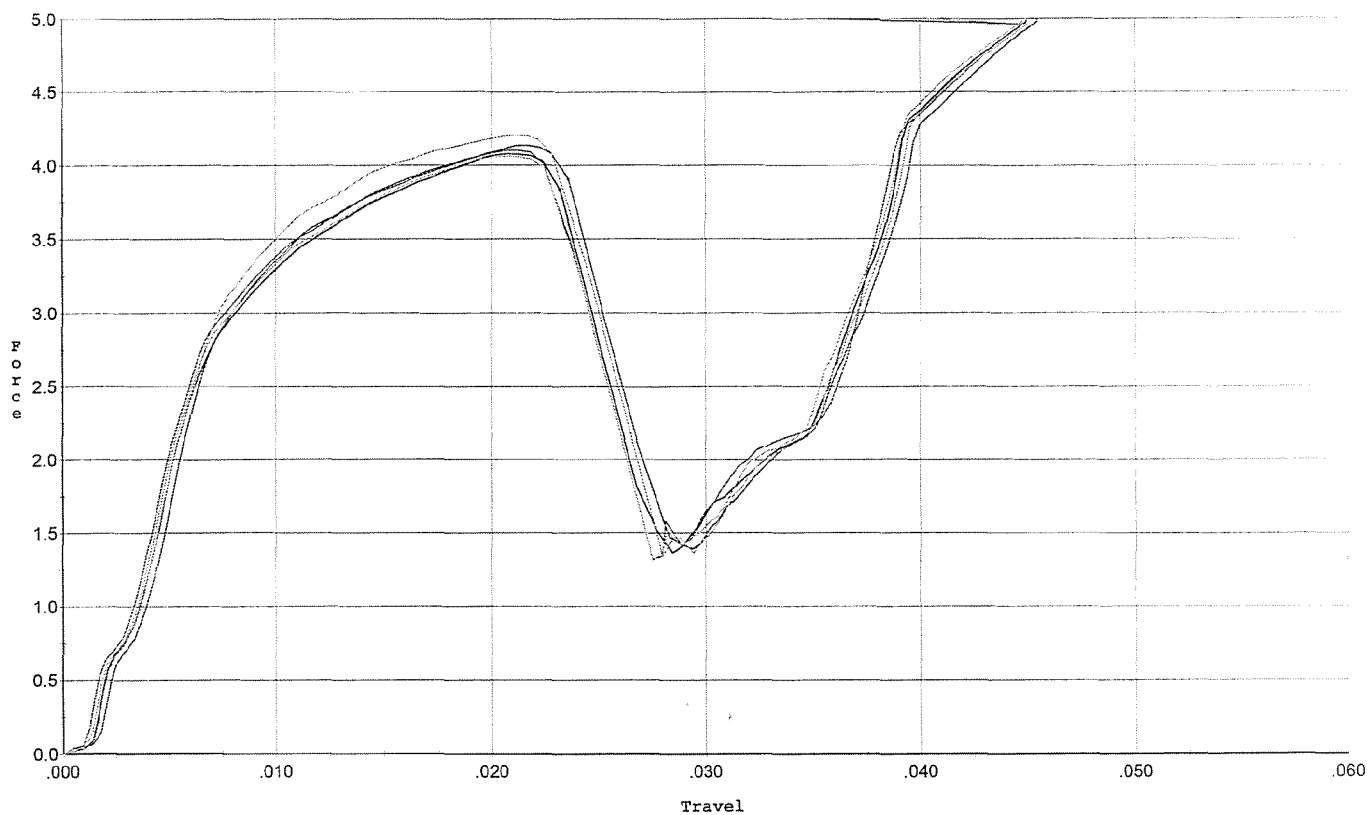
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.191	0.025	0.00	0.032	0.070		Set Trigger
2	4.136	0.023	0.00	0.032	0.065		Set Trigger
3	4.131	0.023	0.00	0.032	0.066		Set Trigger
4	4.112	0.025	0.00	0.032	0.069		Set Trigger
5	4.209	0.025	0.00	0.031	0.072		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



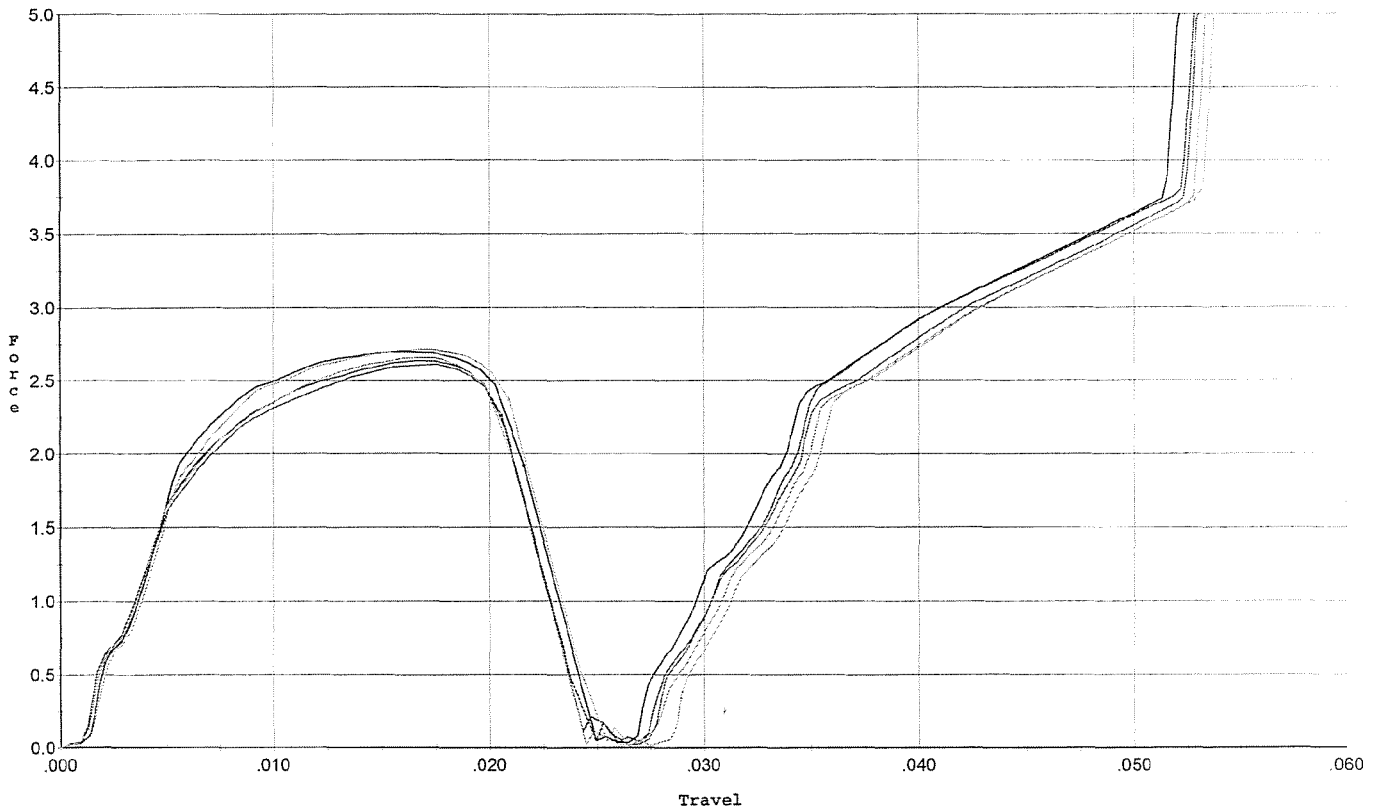
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.024	0.00	0.033	0.065		Set Trigger
2	4.077	0.023	0.00	0.033	0.064		Set Trigger
3	4.102	0.024	0.00	0.032	0.067		Set Trigger
4	4.061	0.024	0.00	0.032	0.066		Set Trigger
5	4.204	0.025	0.00	0.032	0.070		Set Trigger

Avg 4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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



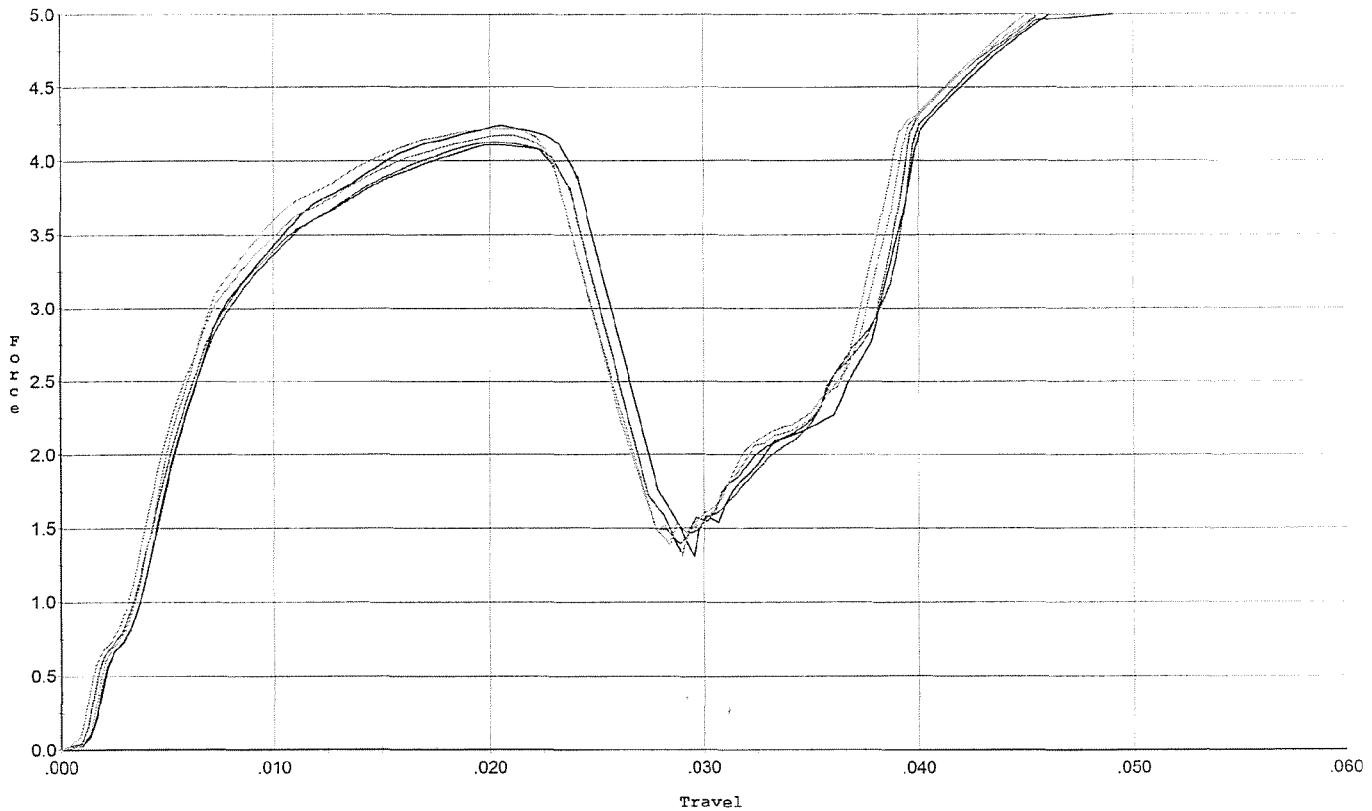
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.631	0.021	0.00	0.035	0.039		Set Trigger
2	2.697	0.022	0.00	0.034	0.042		Set Trigger
3	2.609	0.021	0.00	0.035	0.038		Set Trigger
4	2.712	0.021	0.00	0.036	0.040		Set Trigger
5	2.655	0.021	0.00	0.035	0.039		Set Trigger

Aug 266

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/18/09

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	4.109	0.024	0.00	0.032	0.066		Set Trigger
2	4.239	0.024	0.00	0.032	0.069		Set Trigger
3	4.126	0.023	0.00	0.033	0.065		Set Trigger
4	4.212	0.023	0.00	0.032	0.066		Set Trigger
5	4.172	0.023	0.00	0.032	0.066		Set Trigger

Avg 4.17