

G685-2302

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

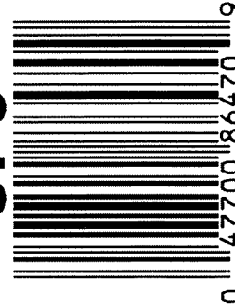


BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6852302**UPC**

GUN SERIAL #

G6852302

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		5-5-09	RP
470	DIS-ASSEMBLE ACTION		5-5-09	RP
472	SERIALIZE BOLT HANDLE		5-6-09	RIZ
480	MAGNAFLUX BBL ACTION	MAGNA-FLUX OPERATOR (15)	5/8/09	(15)
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	Rgm
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		5-27-09	RJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

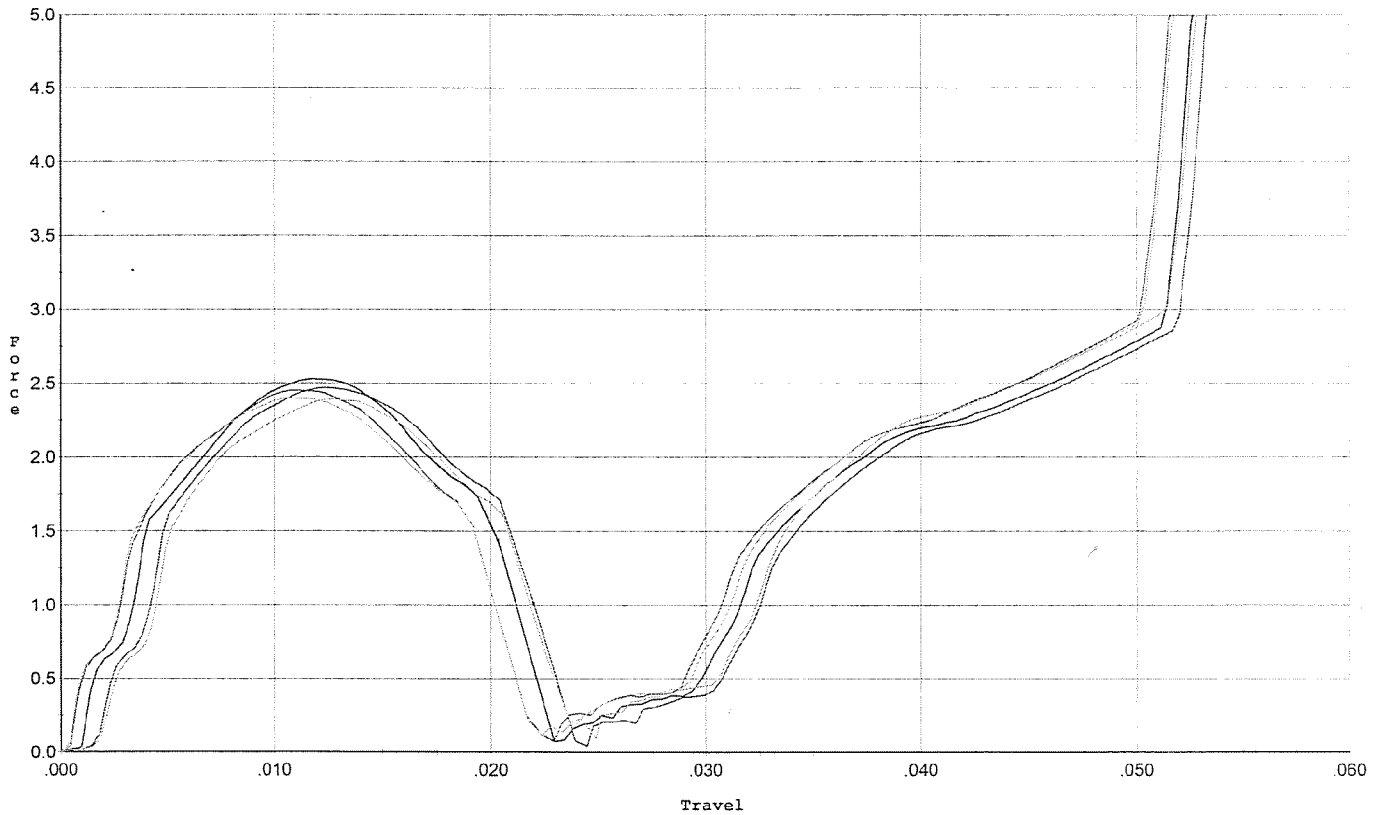
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	6-24-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	6-24-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	6-24-09	LN
	J) ASSEMBLE STOCK		5-27-09	LN
	K) ASSEMBLE SWIVEL STUDS		6-24-09	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	6/11/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/11/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-24-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.54</u> <u>2.57</u> <u>2.59</u> <u>2.57</u>	6-24-09	LN
	C) FUNCTION		6-24-09	LN
690	PACK		7/22/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

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



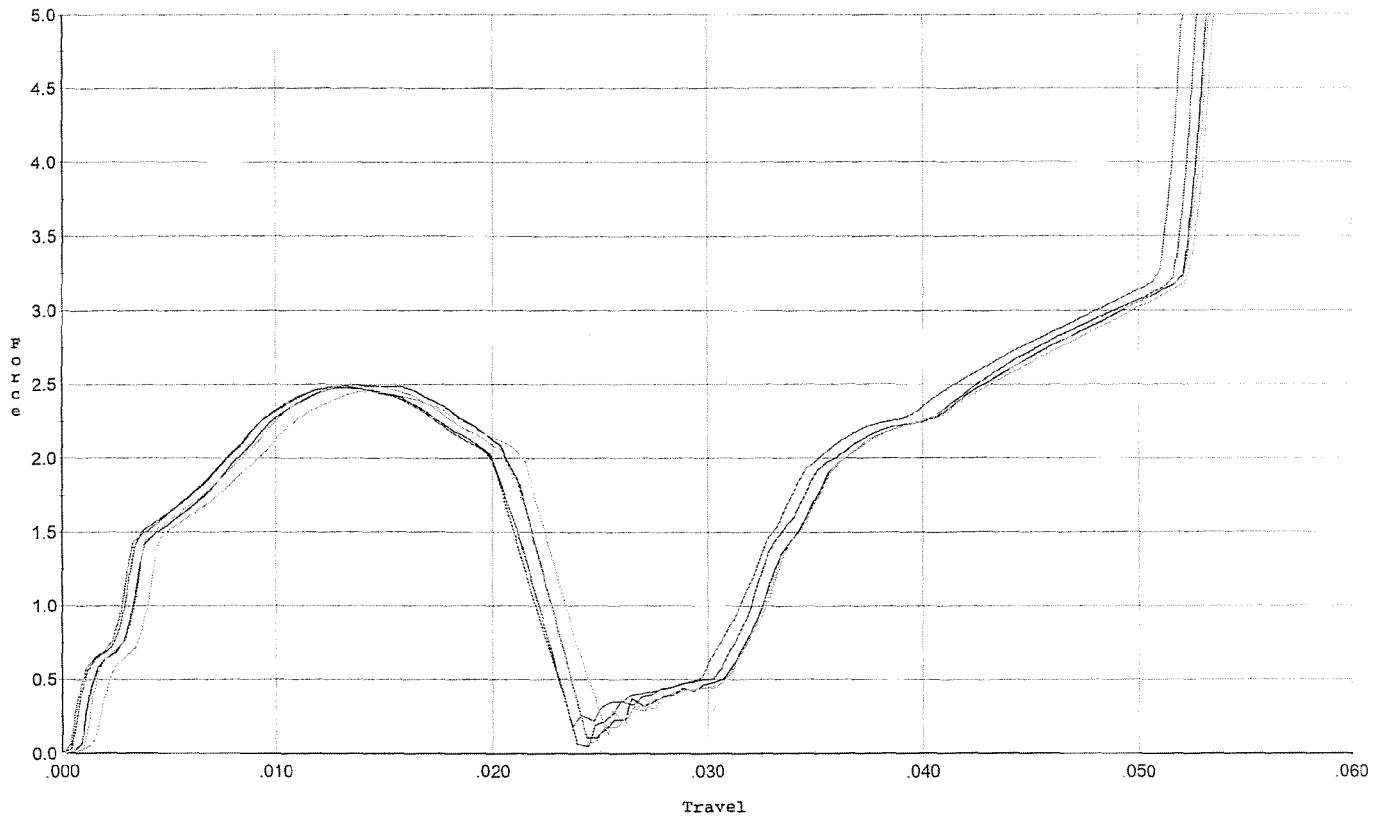
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.470	0.022	0.00	0.037	0.037		Set Trigger
2	2.528	0.020	0.00	0.037	0.035		Set Trigger
3	2.453	0.019	0.00	0.037	0.034		Set Trigger
4	2.399	0.019	0.00	0.037	0.033		Set Trigger
5	2.390	0.021	0.00	0.037	0.033		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



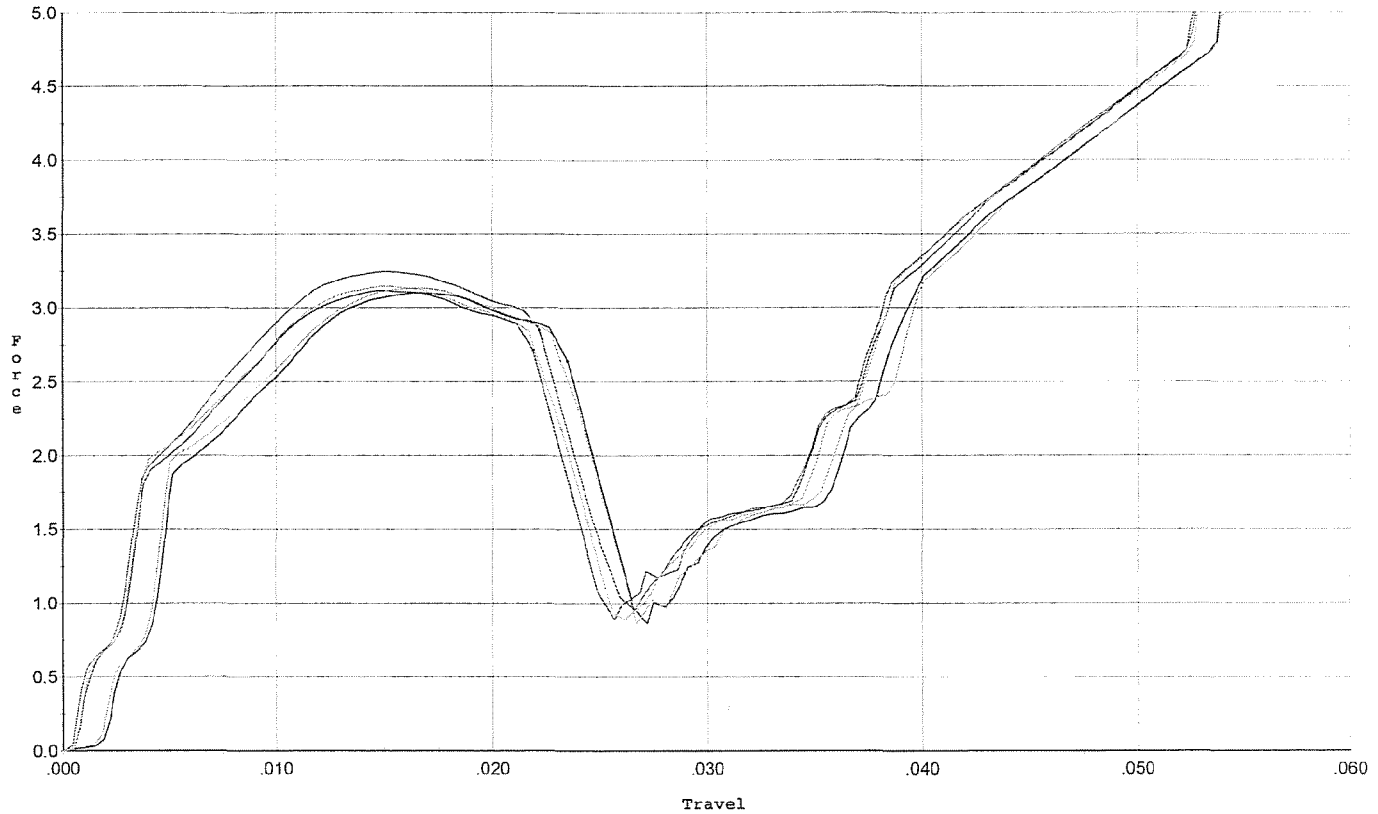
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.021	0.00	0.036	0.038		Set Trigger
2	2.501	0.021	0.00	0.036	0.038		Set Trigger
3	2.477	0.020	0.00	0.036	0.036		Set Trigger
4	2.504	0.021	0.00	0.036	0.038		Set Trigger
5	2.453	0.021	0.00	0.036	0.037		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

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



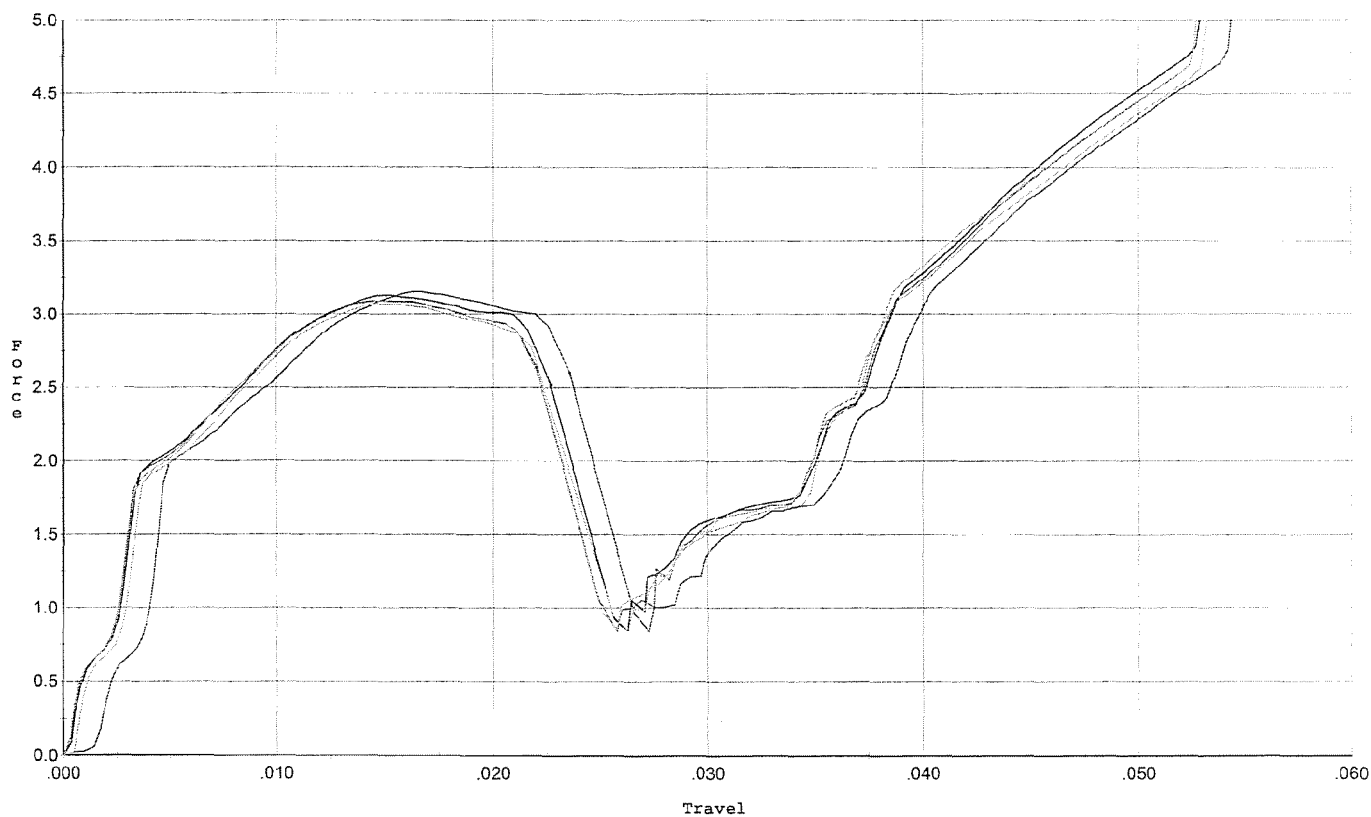
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.022	0.00	0.034	0.049		Set Trigger
2	3.099	0.023	0.00	0.034	0.050		Set Trigger
3	3.246	0.022	0.00	0.033	0.052		Set Trigger
4	3.146	0.023	0.00	0.033	0.053		Set Trigger
5	3.134	0.024	0.00	0.034	0.052		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

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



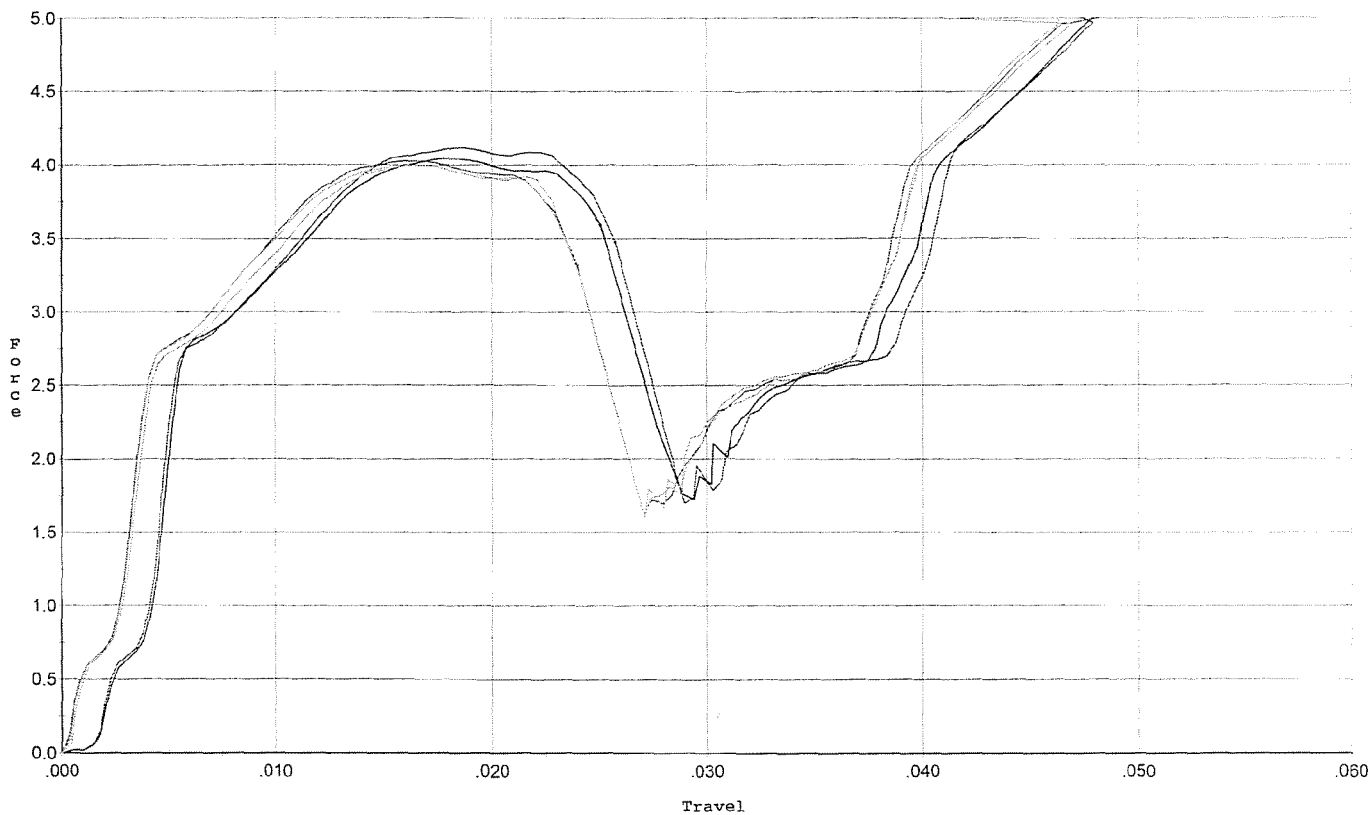
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.024	0.00	0.034	0.052		Set Trigger
2	3.128	0.023	0.00	0.033	0.052		Set Trigger
3	3.088	0.022	0.00	0.034	0.050		Set Trigger
4	3.069	0.022	0.00	0.034	0.049		Set Trigger
5	3.085	0.022	0.00	0.034	0.050		Set Trigger

A-3-10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

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



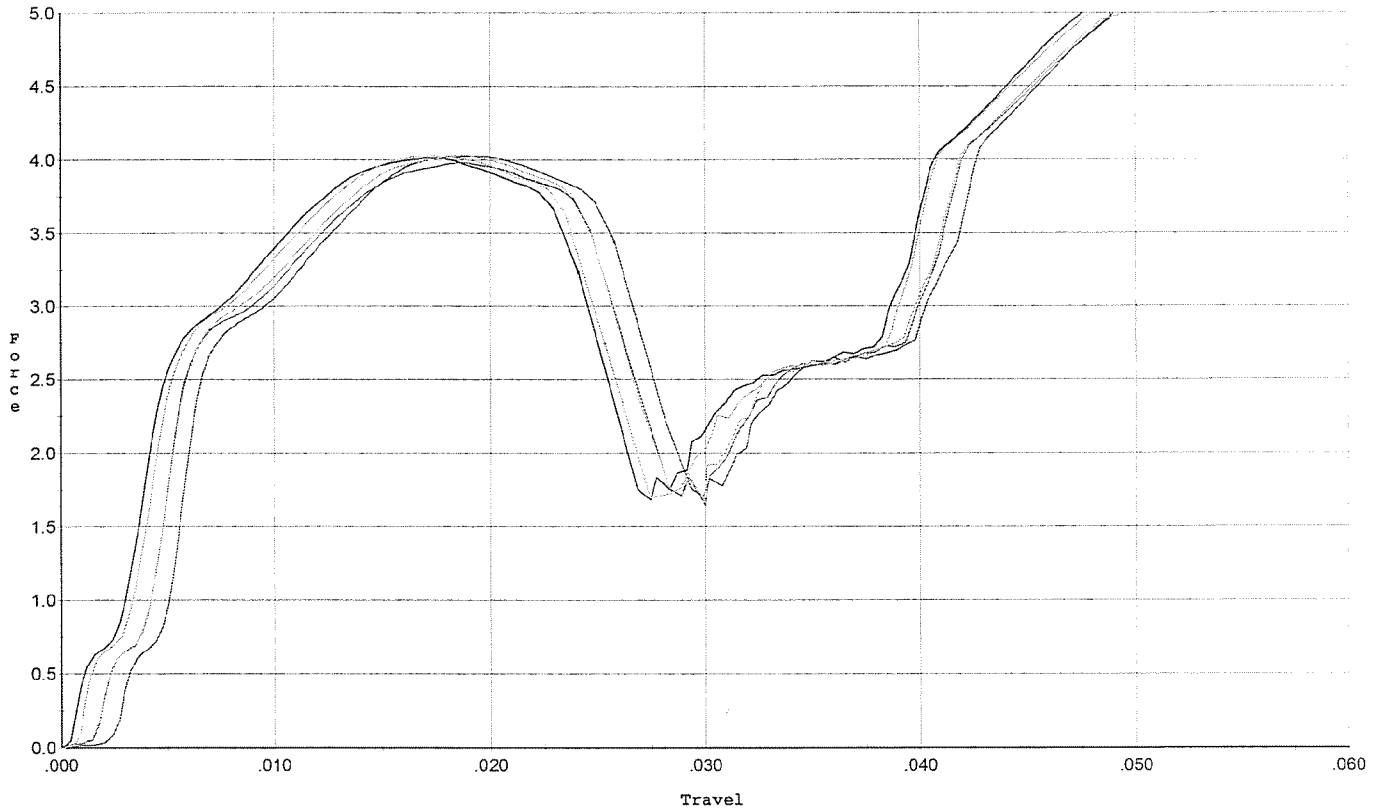
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.026	0.00	0.030	0.074		Set Trigger
2	4.046	0.025	0.00	0.030	0.070		Set Trigger
3	4.029	0.024	0.00	0.030	0.070		Set Trigger
4	4.002	0.024	0.00	0.030	0.070		Set Trigger
5	3.998	0.024	0.00	0.031	0.070		Set Trigger

A. 4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/15/2009

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



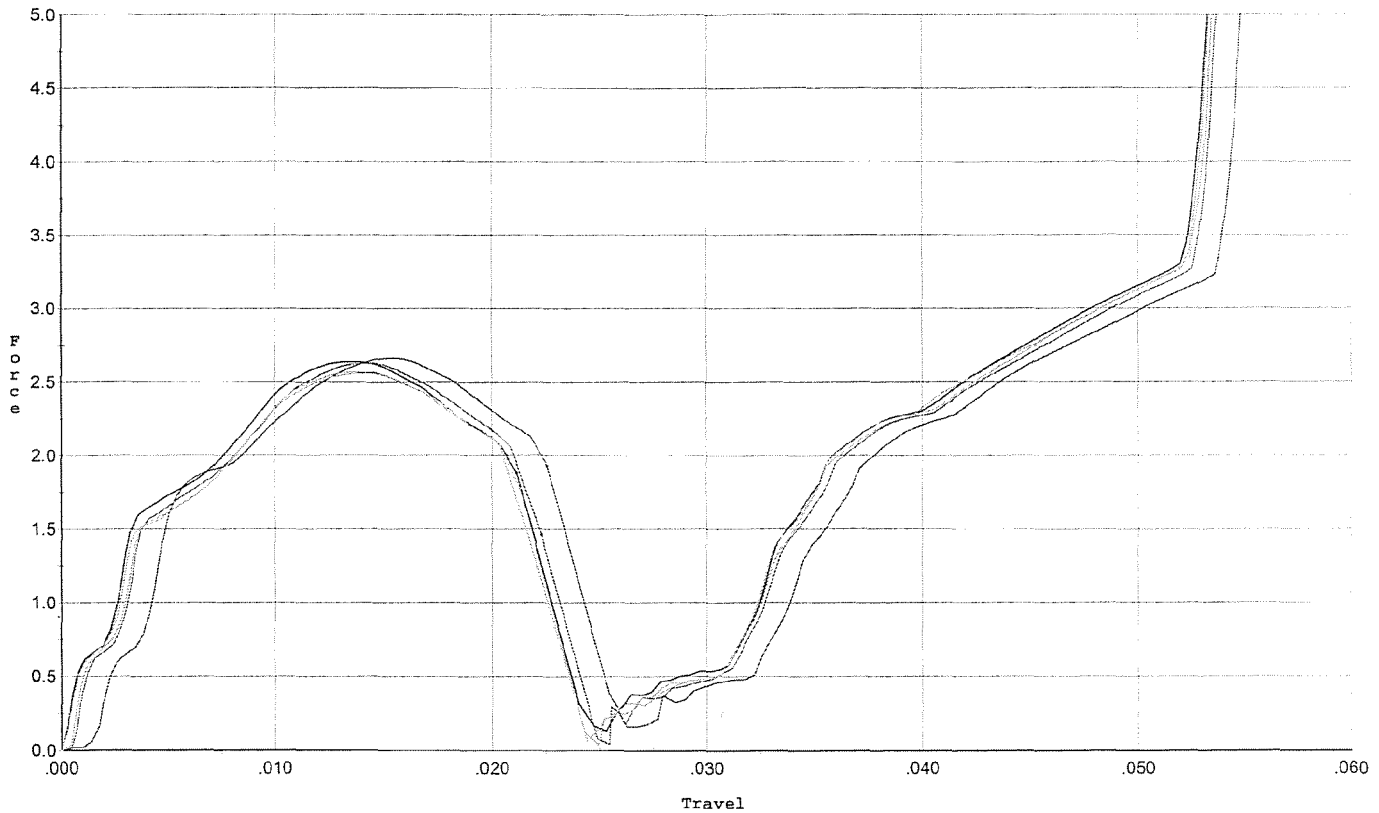
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.026	0.026	0.003	0.031	0.069		Set Trigger
2	4.015	0.024	0.00	0.031	0.069		Set Trigger
3	3.980	0.025	0.00	0.032	0.067		Set Trigger
4	4.036	0.025	0.00	0.031	0.068		Set Trigger
5	4.030	0.025	0.00	0.031	0.072		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



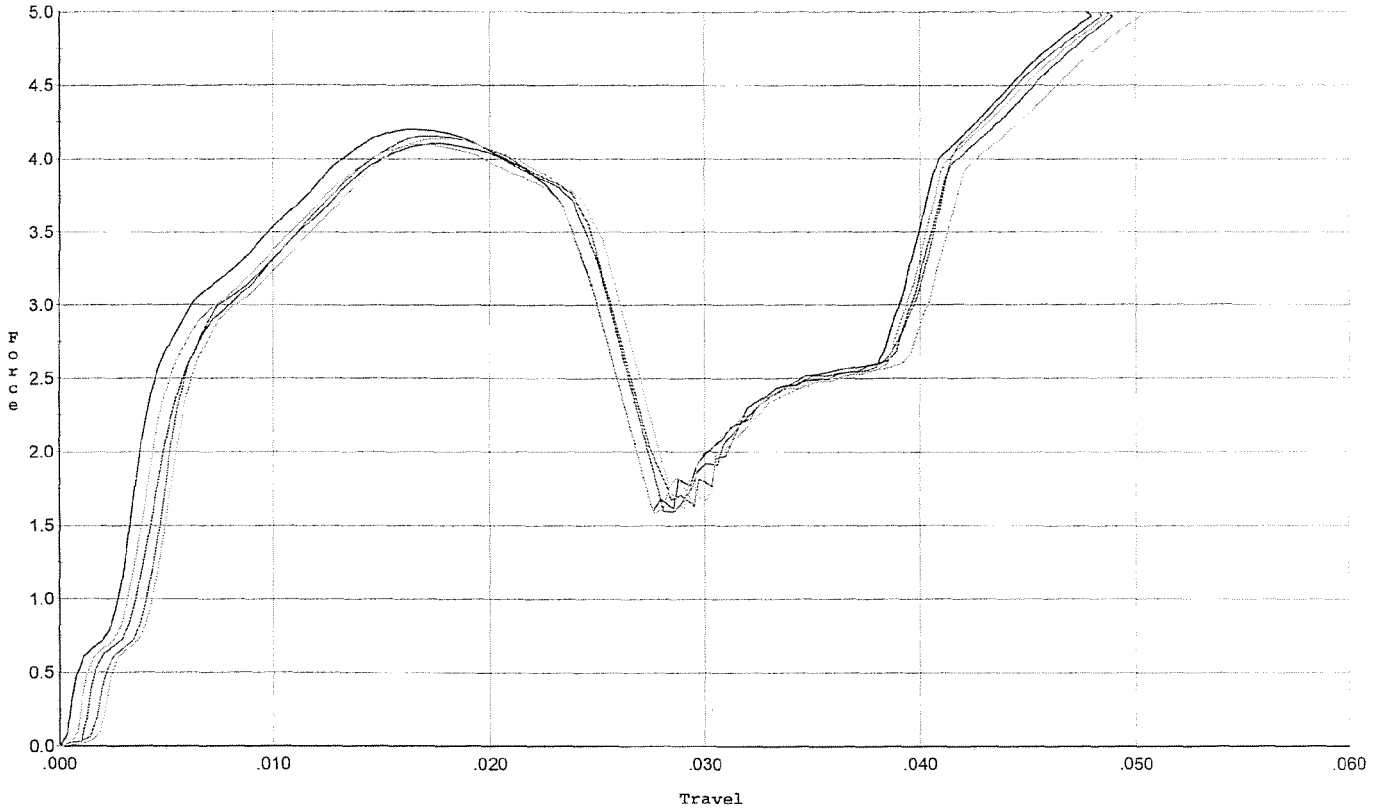
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.662	0.023	0.00	0.036	0.041		Set Trigger
2	2.638	0.021	0.00	0.036	0.040		Set Trigger
3	2.627	0.022	0.00	0.036	0.041		Set Trigger
4	2.559	0.021	0.00	0.036	0.039		Set Trigger
5	2.569	0.022	0.00	0.036	0.040		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/15/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.108	0.025	0.00	0.031	0.071		Set Trigger
2	4.201	0.025	0.00	0.031	0.074		Set Trigger
3	4.154	0.025	0.00	0.031	0.069		Set Trigger
4	4.139	0.025	0.00	0.032	0.070		Set Trigger
5	4.101	0.025	0.00	0.031	0.071		Set Trigger

A-414