

G685-2322

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

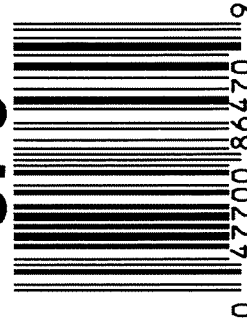


BM FORM

ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6852322**UPC**

GUN SERIAL # G 685 2322

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-5-09	RP
430	ASSEMBLE TO STOCK		5-5-09	JP
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	RP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(D)</u>	5/8/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/12/09	RT
510	DRILL AND TAP SIGHT HOLES		5-6-09	JP
520	GOFF BLAST BBL / REC		5/12/09	RSM
540	APPLY COATINGS (BARREL ACTION)		5/1/8	c
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-19-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-19-09	JP
	D) OIL FIRING PIN ASSEMBLY		5-27-09	JD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

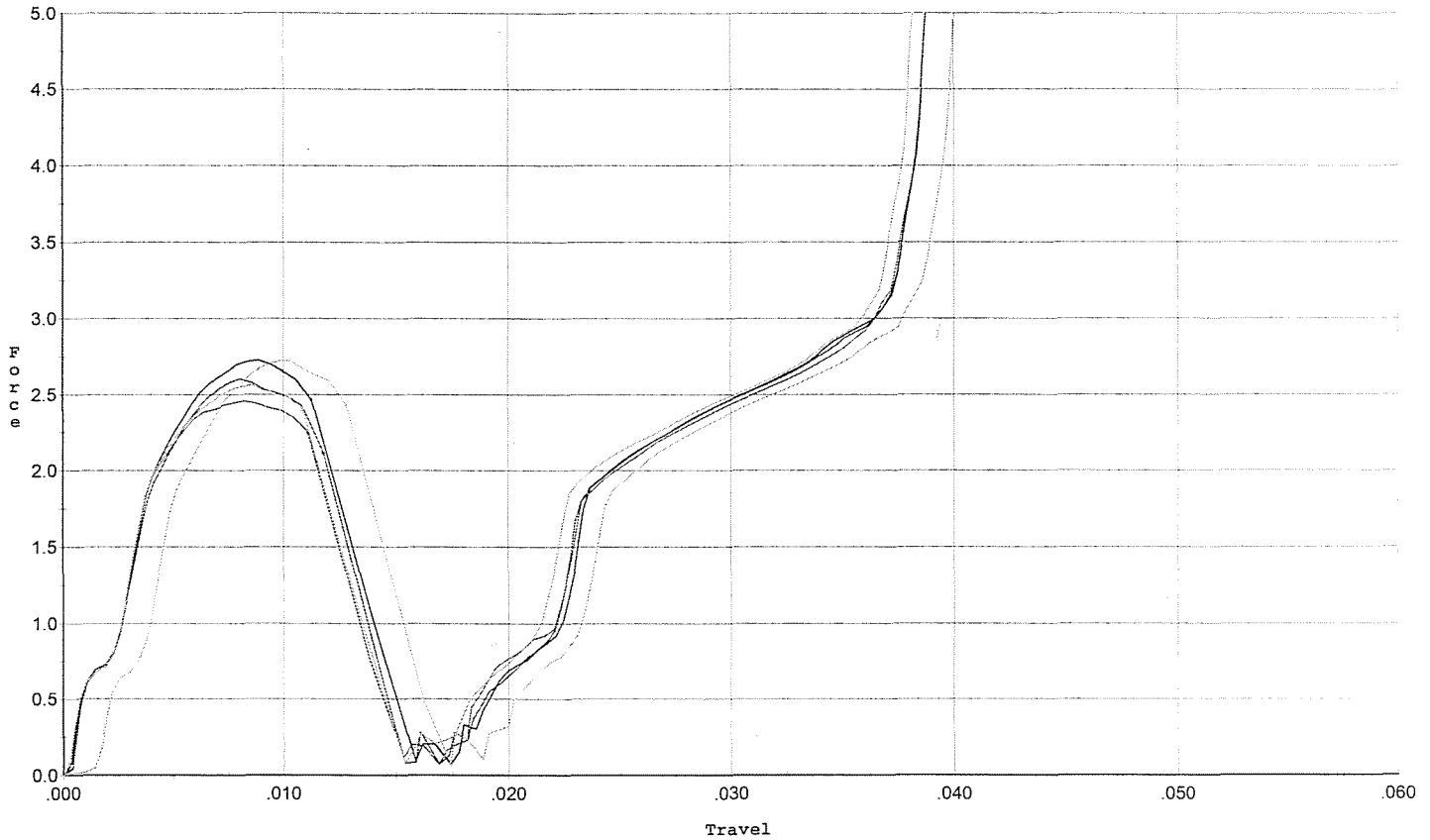
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>30</u>	6-16-09	RN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>60</u>	<u>60</u>	<u>60</u>	6-16-09	RN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	6-16-09	RN		
	J) ASSEMBLE STOCK					5-27-09	RN		
	K) ASSEMBLE SWIVEL STUDS					6-16-09	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		6/11/09	RB		
			<u>PASS</u>	FAIL					
	MALFUNCTION		N/A						
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
660	INSPECT FOR LIVE AMMO					6/11/09	TAR		
670	FINAL INSPECTION A) HEADSPACE					6-16-09	RN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>295</u>	<u>295</u>	<u>298</u>	<u>280</u>	<u>263</u>	6-15-09	RT
	C) FUNCTION							6-16-09	RN
690	PACK							7/29/09	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



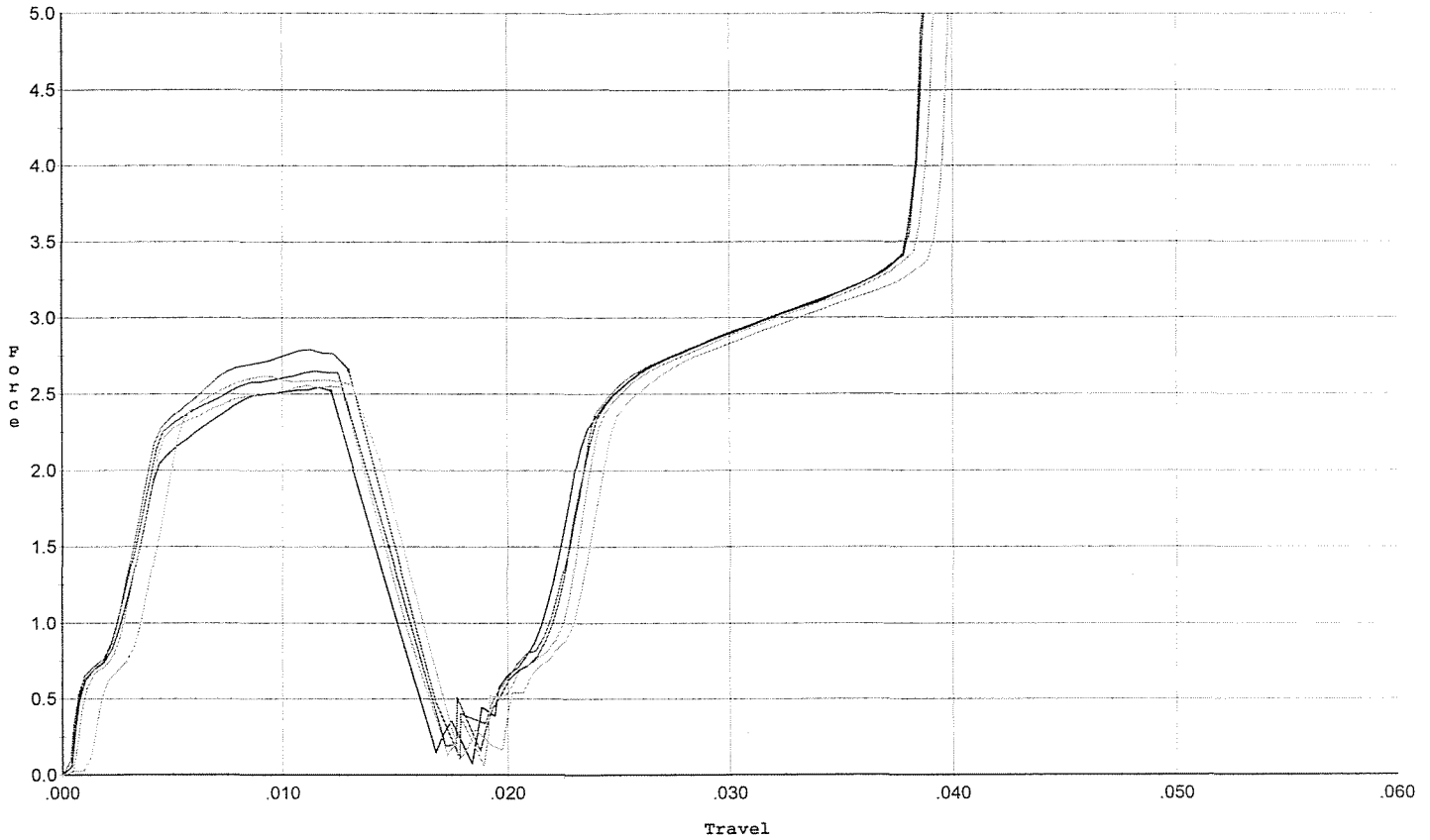
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.012	0.00	0.030	0.020		Set Trigger
2	2.731	0.011	0.00	0.030	0.020		Set Trigger
3	2.457	0.011	0.00	0.030	0.019		Set Trigger
4	2.723	0.013	0.00	0.030	0.021		Set Trigger
5	2.563	0.011	0.00	0.030	0.019		Set Trigger

4-2-61

Trigger Profile [lbs,inch]

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

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



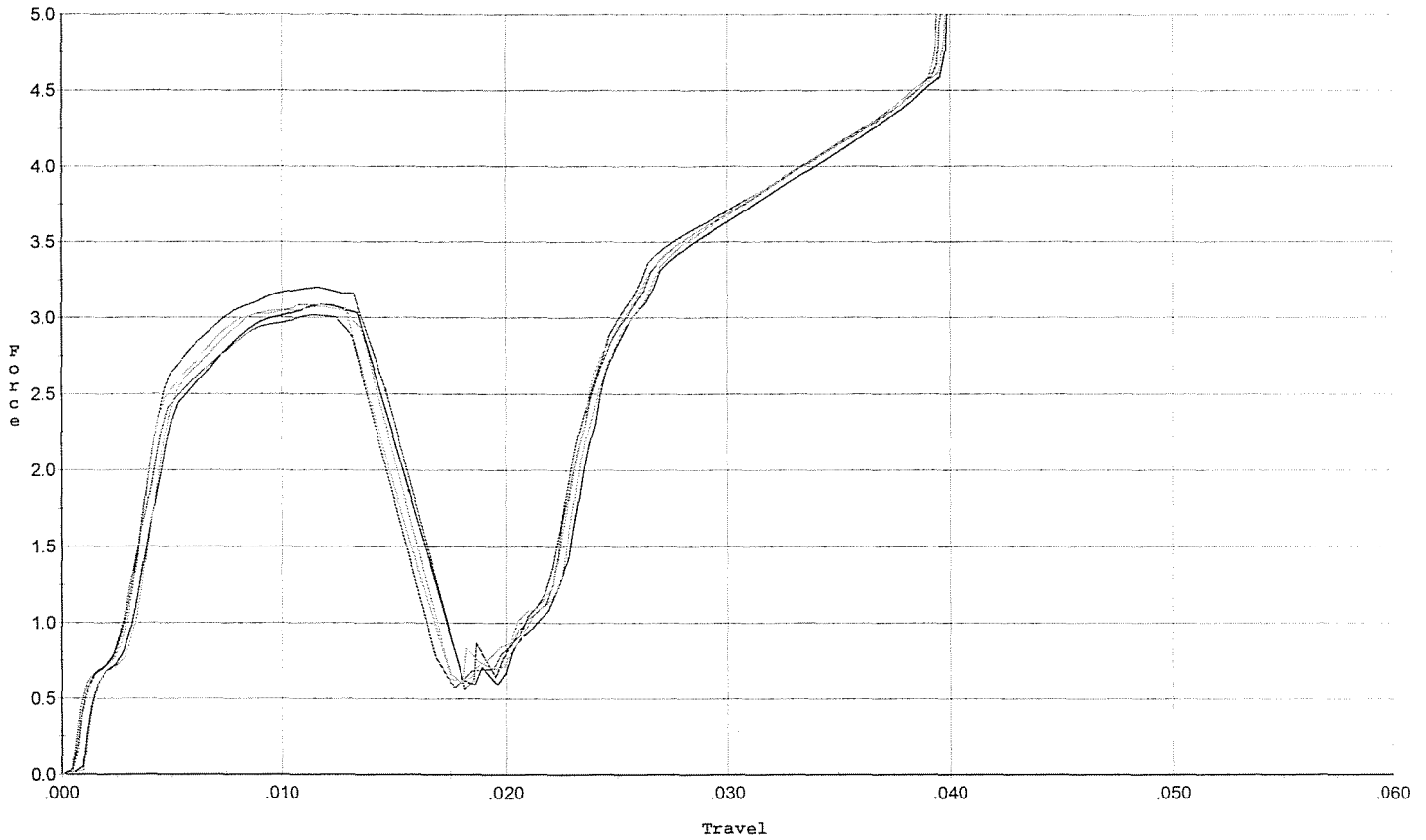
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.650	0.015	0.00	0.027	0.027		Set Trigger
2	2.544	0.012	0.00	0.028	0.021		Set Trigger
3	2.792	0.013	0.00	0.027	0.025		Set Trigger
4	2.615	0.014	0.00	0.028	0.025		Set Trigger
5	2.555	0.013	0.00	0.028	0.023		Set Trigger

A-2-63

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



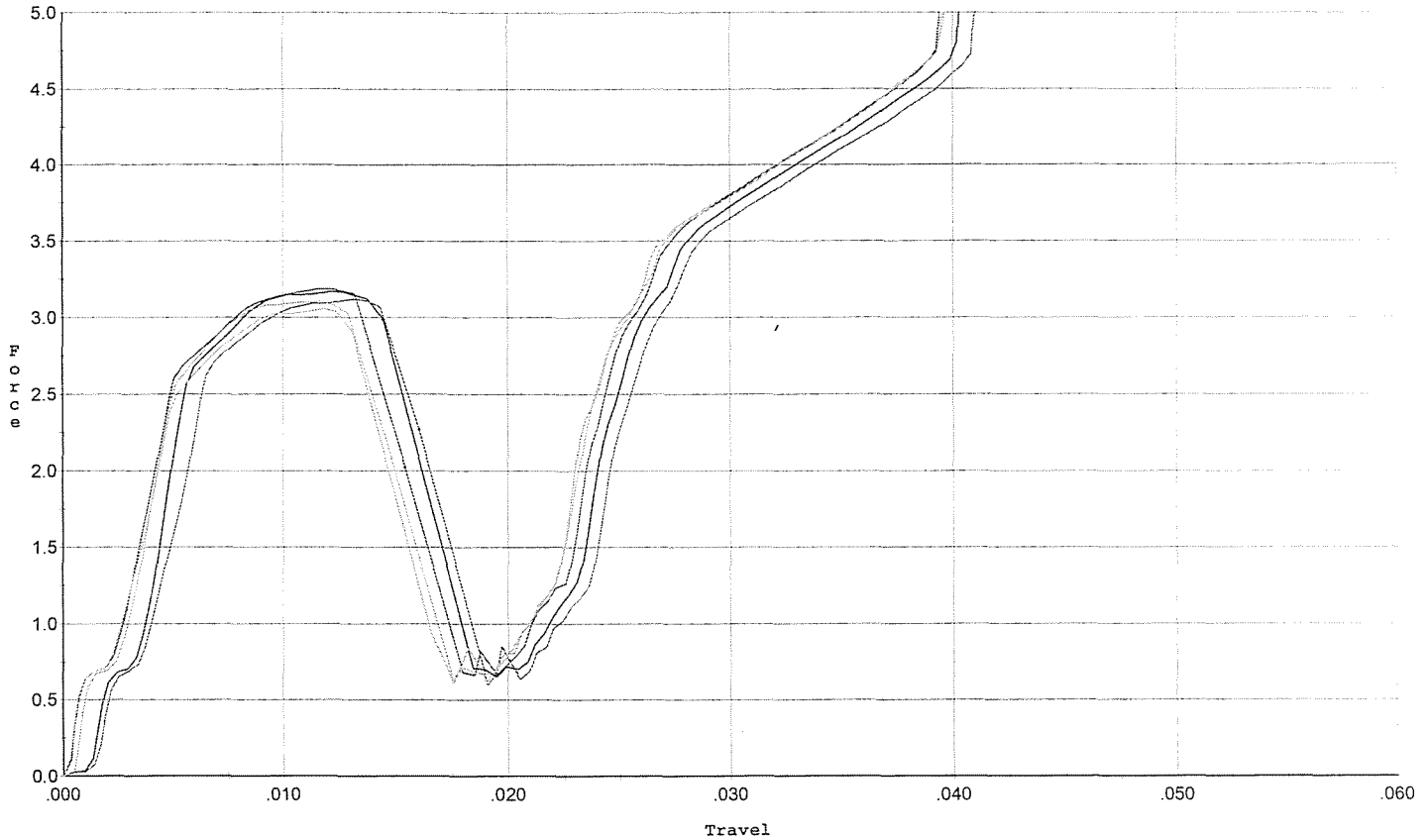
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.200	0.015	0.00	0.026	0.032		Set Trigger
2	3.088	0.016	0.00	0.026	0.032		Set Trigger
3	3.018	0.013	0.00	0.027	0.027		Set Trigger
4	3.086	0.013	0.00	0.026	0.027		Set Trigger
5	3.074	0.014	0.00	0.027	0.028		Set Trigger

A-3.09

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



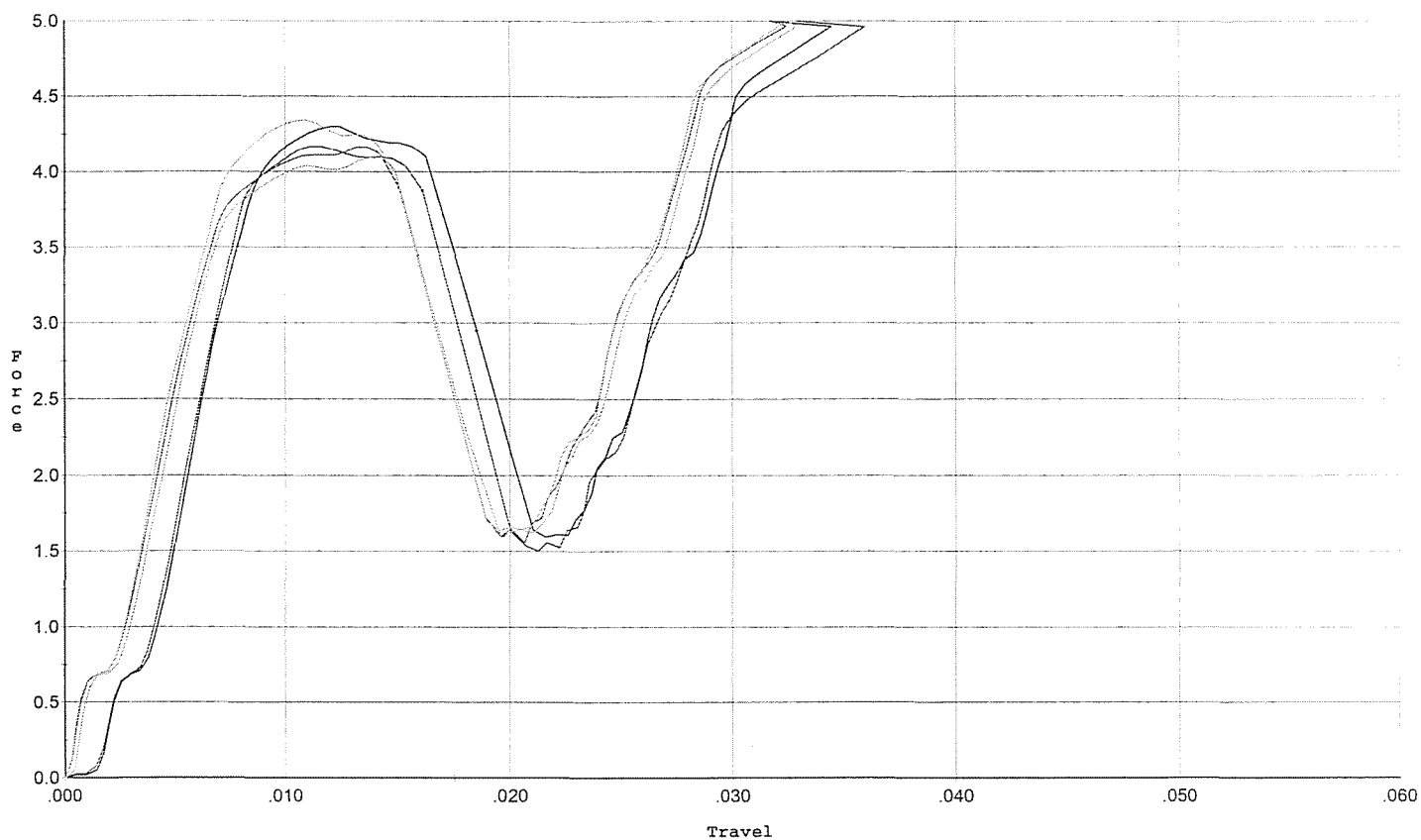
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.188	0.015	0.00	0.026	0.033		Set Trigger
2	3.169	0.014	0.00	0.026	0.030		Set Trigger
3	3.120	0.016	0.00	0.027	0.032		Set Trigger
4	3.056	0.013	0.00	0.026	0.027		Set Trigger
5	3.104	0.015	0.00	0.026	0.031		Set Trigger

A-3-12

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



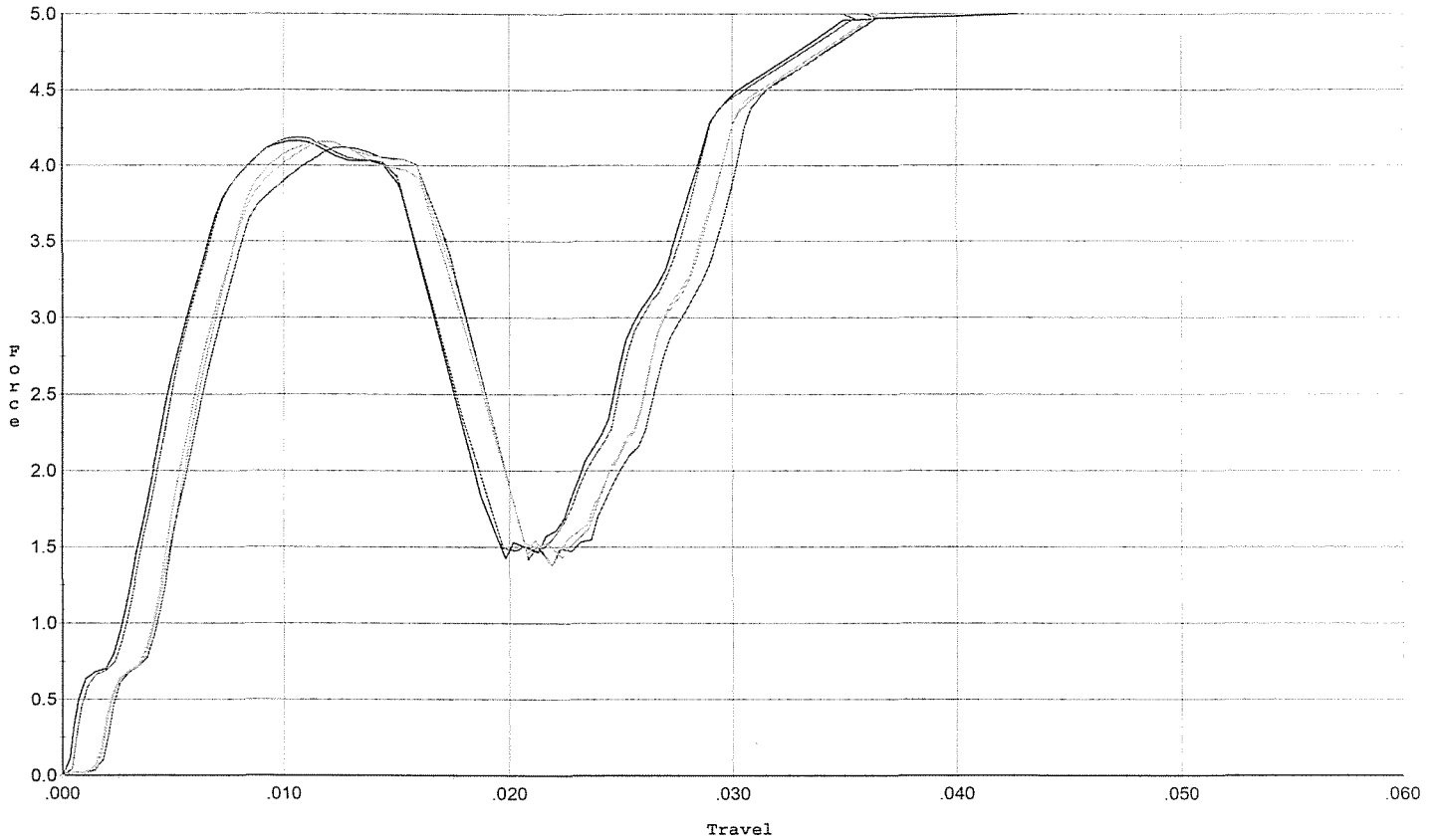
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.016	0.00	0.026	0.041		Set Trigger
2	4.299	0.019	0.00	0.025	0.049		Set Trigger
3	4.165	0.015	0.00	0.025	0.041		Set Trigger
4	4.344	0.015	0.00	0.024	0.042		Set Trigger
5	4.104	0.015	0.00	0.025	0.040		Set Trigger

A-4-21

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



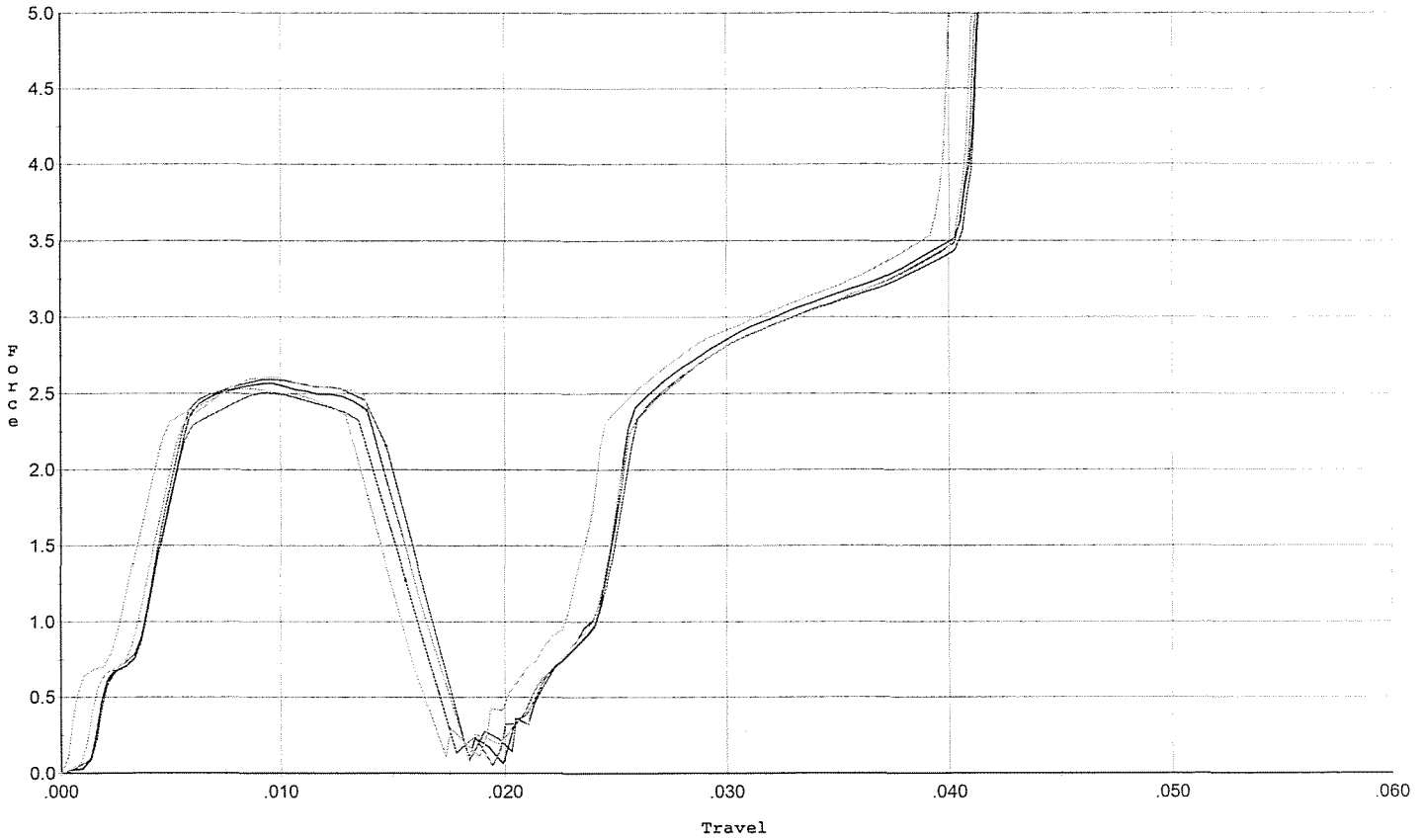
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.017	0.00	0.026	0.043		Set Trigger
2	4.166	0.015	0.00	0.025	0.041		Set Trigger
3	4.191	0.015	0.00	0.026	0.041		Set Trigger
4	4.155	0.018	0.00	0.026	0.045		Set Trigger
5	4.166	0.018	0.00	0.026	0.046		Set Trigger

A-4-16

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



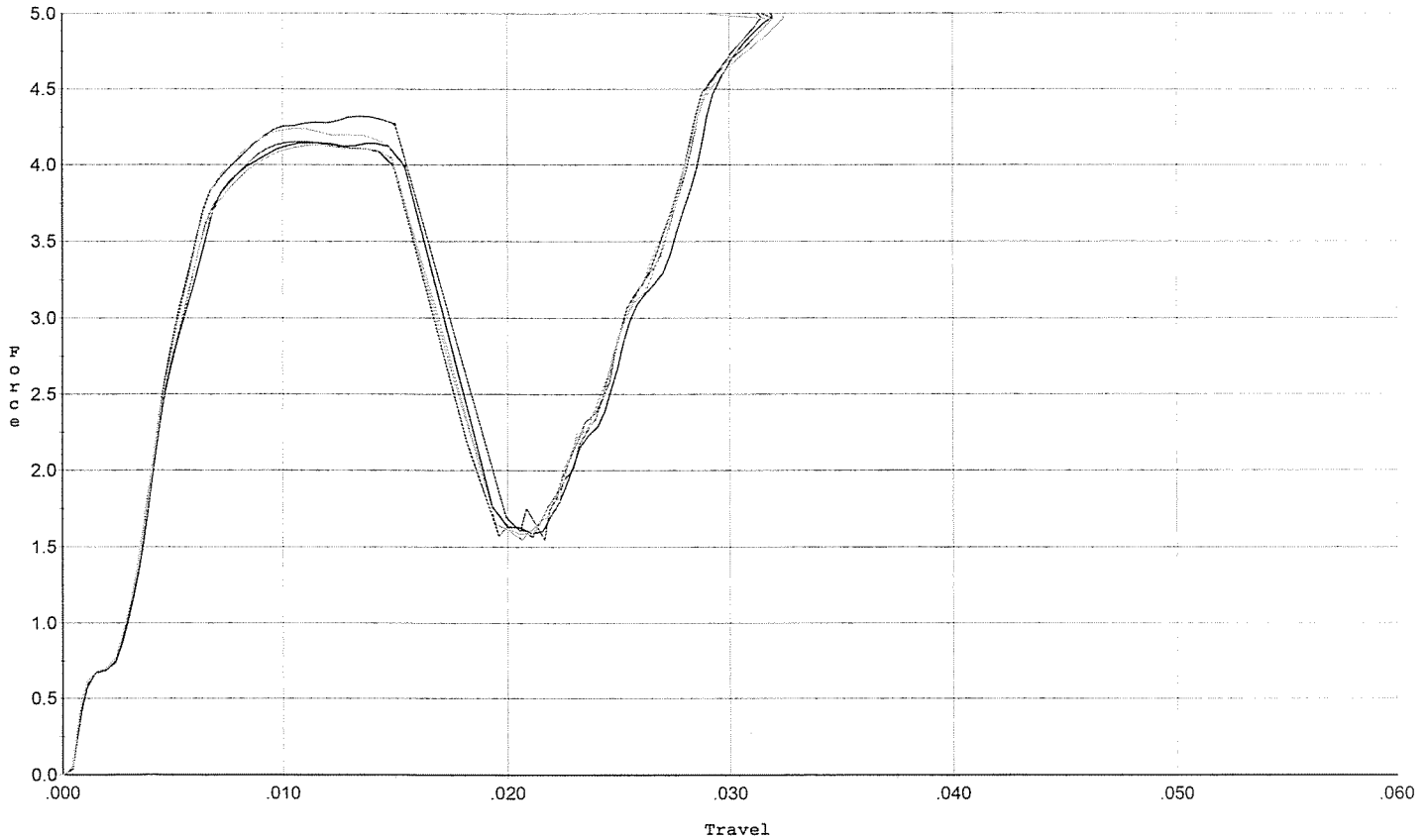
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.015	0.00	0.029	0.026		Set Trigger
2	2.567	0.014	0.00	0.029	0.024		Set Trigger
3	2.506	0.016	0.00	0.029	0.026		Set Trigger
4	2.609	0.014	0.00	0.029	0.024		Set Trigger
5	2.534	0.013	0.00	0.029	0.023		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

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

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	4.323	0.015	0.00	0.025	0.043		Set Trigger
2	4.144	0.015	0.00	0.025	0.043		Set Trigger
3	4.153	0.015	0.00	0.025	0.041		Set Trigger
4	4.245	0.017	0.00	0.025	0.047		Set Trigger
5	4.129	0.015	0.00	0.025	0.041		Set Trigger

A-4.19