

G685 2325

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

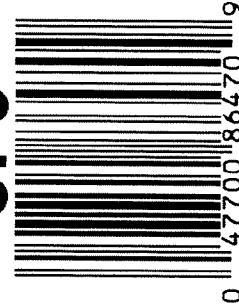


BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6852325

UPC



GUN SERIAL # G6852325

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	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/8/09	
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)		5/22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-26-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-26-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-26-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-29-09	LJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

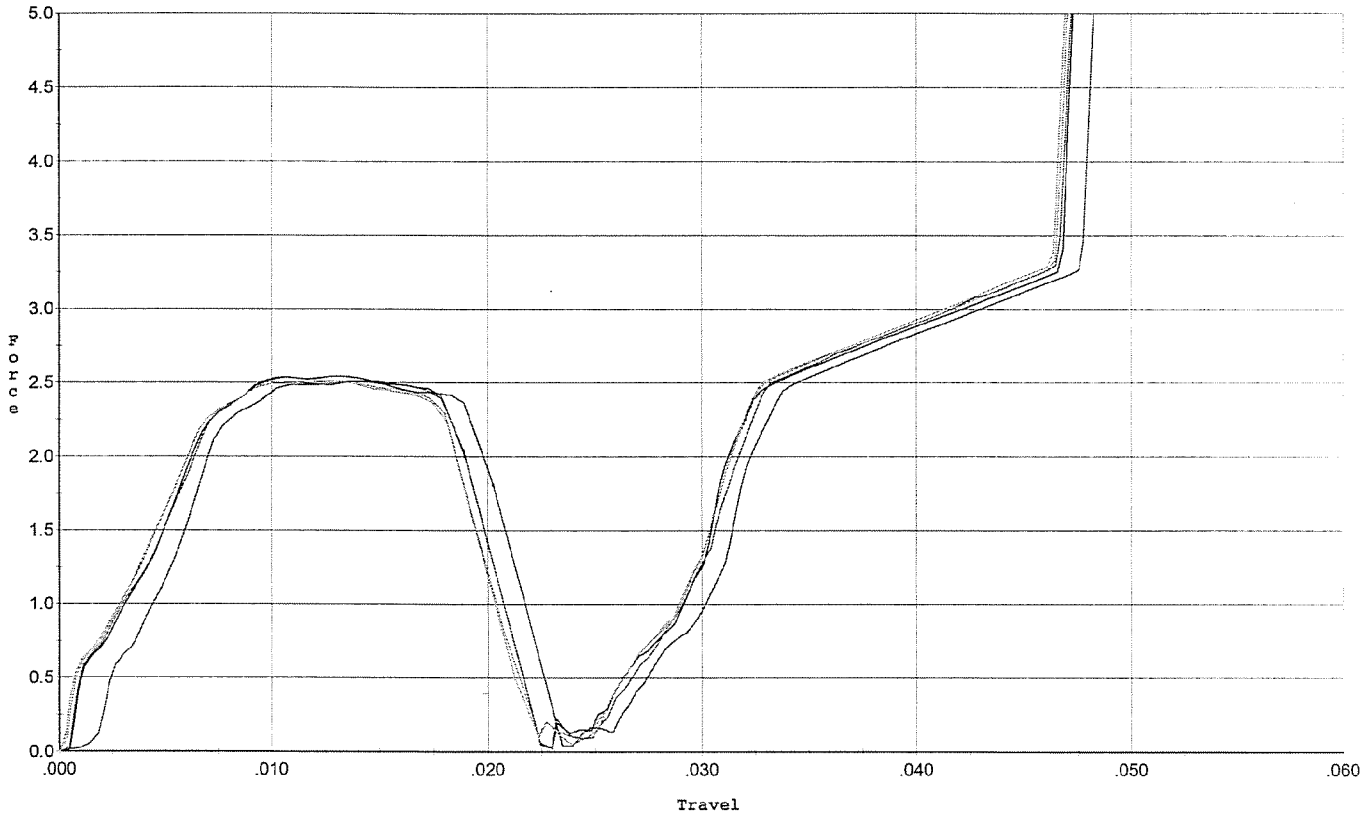
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	6-19-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	6-19-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	6-19-09	LJ
	J) ASSEMBLE STOCK		5-29-09	LJ
	K) ASSEMBLE SWIVEL STUDS		6-19-09	LJ
	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	6-9-09	L.P.A.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-9-09	RP
670	FINAL INSPECTION A) HEADSPACE		6-19-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>242</u> <u>246</u> <u>242</u> <u>241</u> <u>246</u>	6-19-09	LJ
	C) FUNCTION		6-19-09	LJ
690	PACK		7/20/09	Em

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



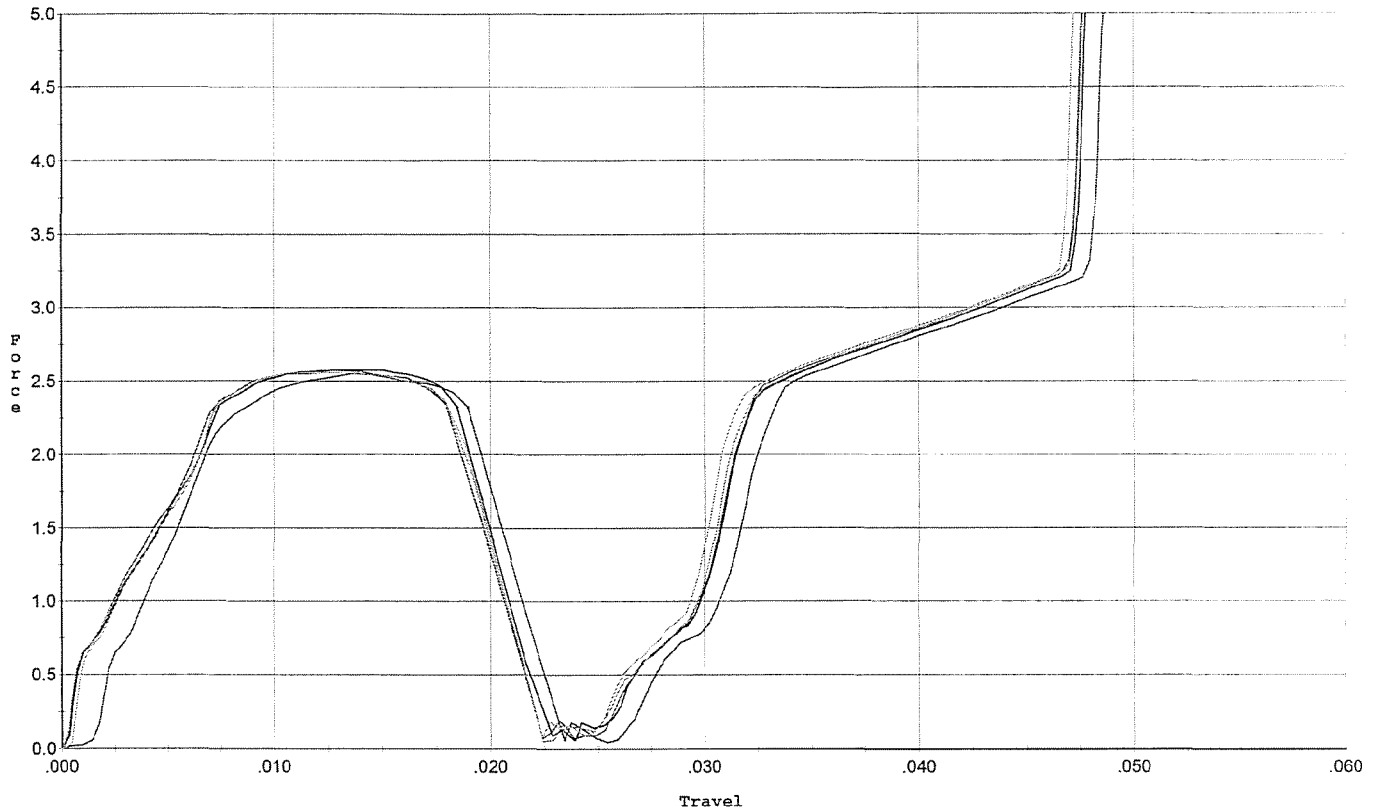
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.508	0.020	0.00	0.032	0.035		Set Trigger
2	2.545	0.019	0.00	0.032	0.035		Set Trigger
3	2.543	0.019	0.00	0.032	0.035		Set Trigger
4	2.513	0.018	0.00	0.032	0.034		Set Trigger
5	2.502	0.018	0.00	0.032	0.034		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



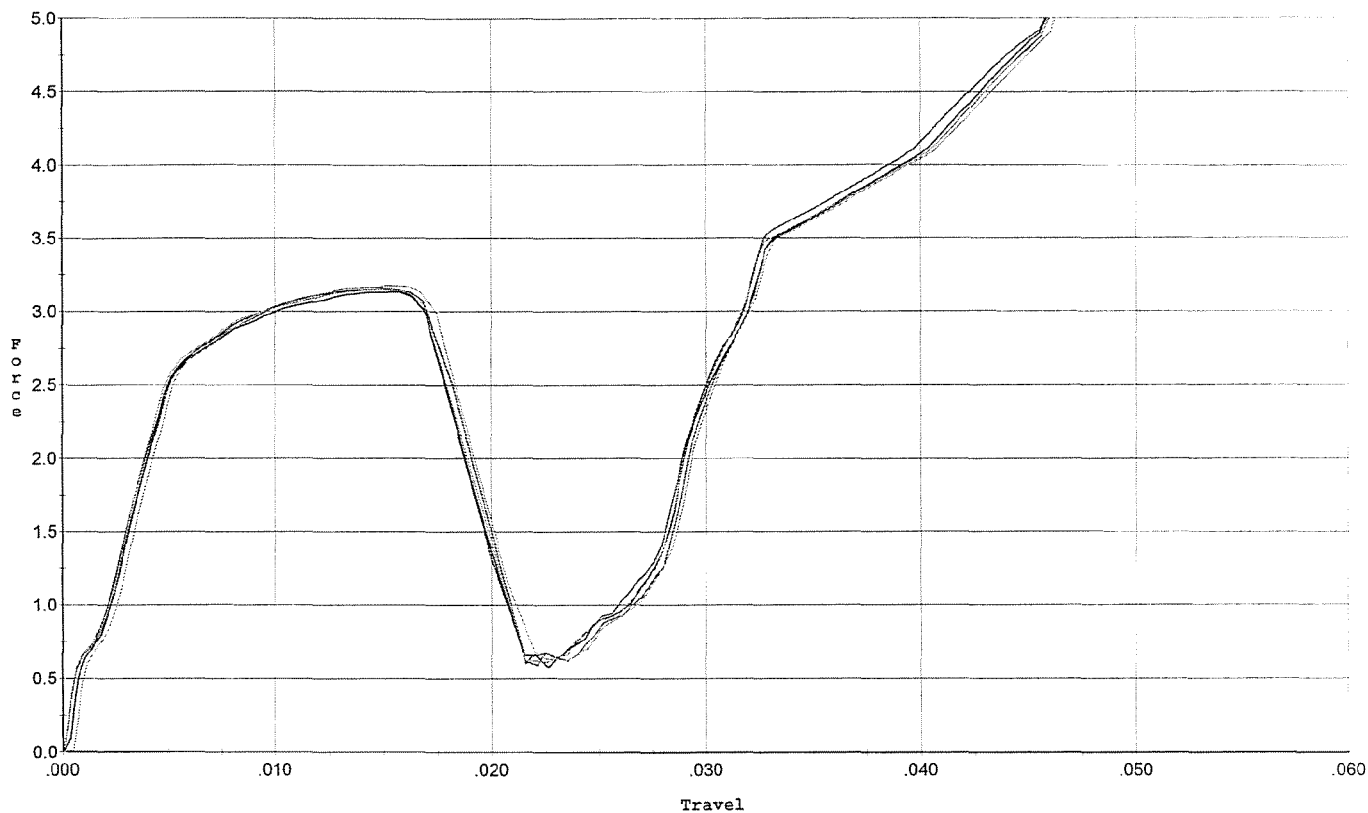
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.019	0.00	0.033	0.034		Set Trigger
2	2.576	0.018	0.00	0.032	0.035		Set Trigger
3	2.572	0.020	0.00	0.032	0.038		Set Trigger
4	2.561	0.019	0.00	0.032	0.036		Set Trigger
5	2.558	0.019	0.00	0.032	0.036		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



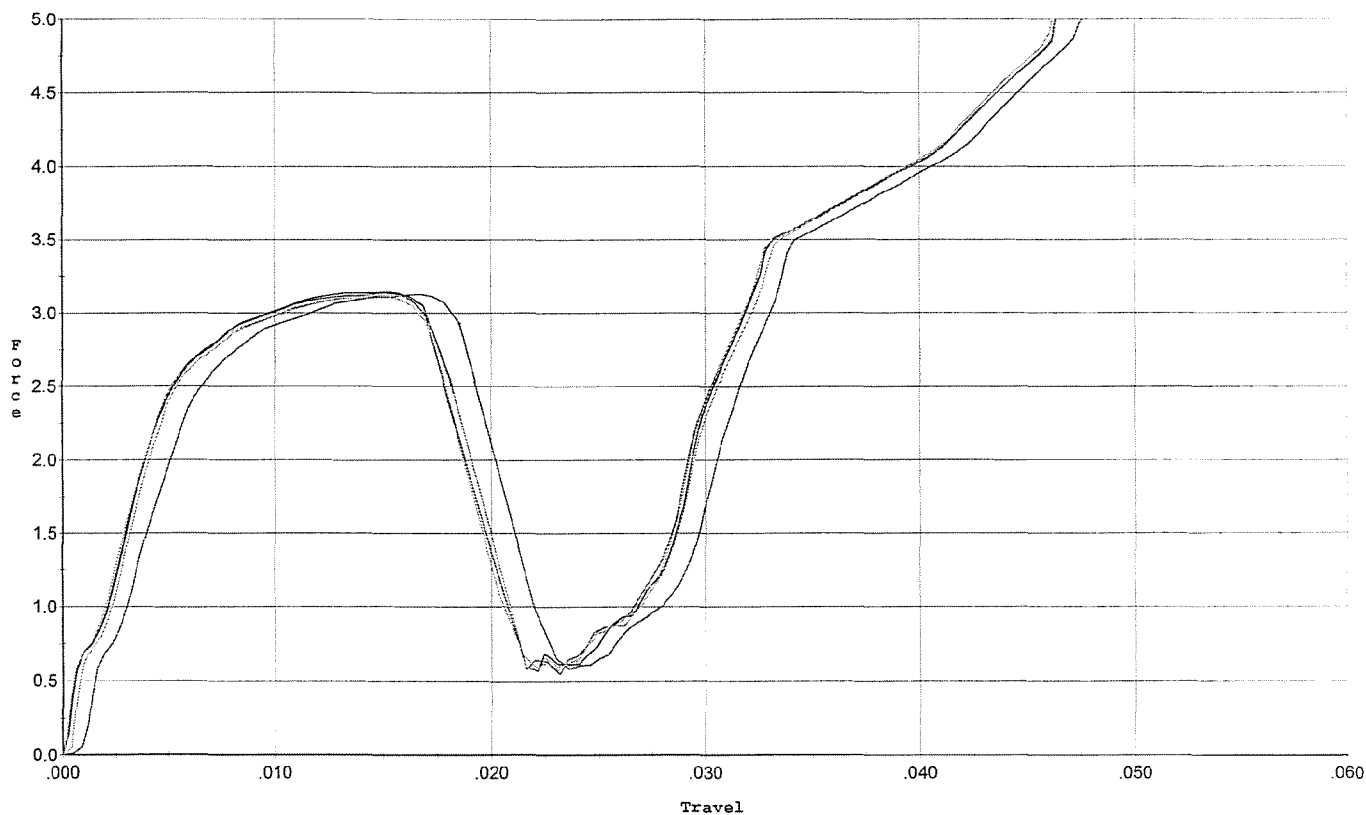
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.159	0.017	0.00	0.030	0.039		Set Trigger
2	3.134	0.017	0.00	0.030	0.039		Set Trigger
3	3.147	0.018	0.00	0.030	0.042		Set Trigger
4	3.177	0.017	0.00	0.030	0.040		Set Trigger
5	3.155	0.019	0.00	0.030	0.044		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



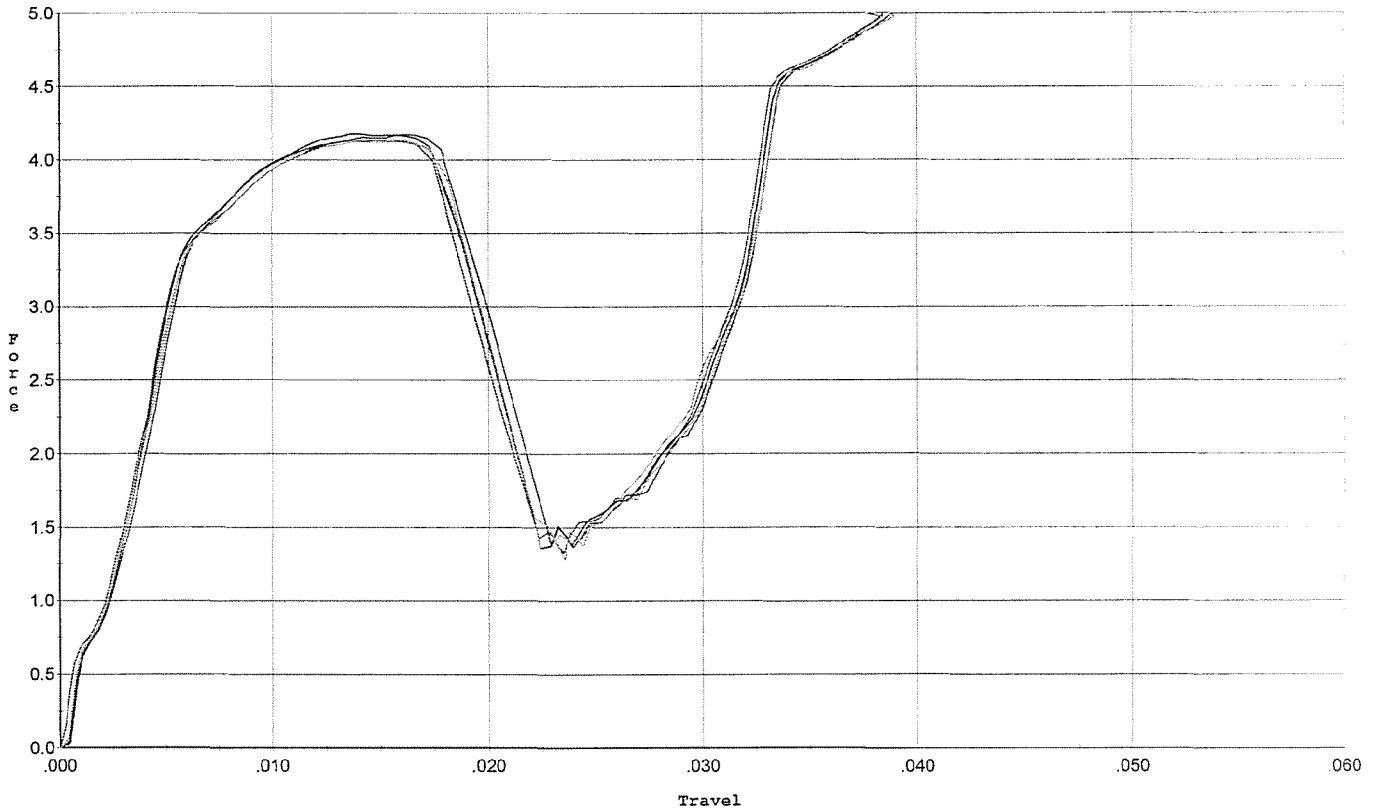
#	Peak Force	Travel To Actuate	Initial Take-up	Overtavel	Energy To Actuate	Lock Time	Action Type
1	3.128	0.019	0.00	0.031	0.041		Set Trigger
2	3.145	0.018	0.00	0.030	0.042		Set Trigger
3	3.136	0.017	0.00	0.031	0.039		Set Trigger
4	3.110	0.017	0.00	0.031	0.039		Set Trigger
5	3.123	0.018	0.00	0.030	0.041		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



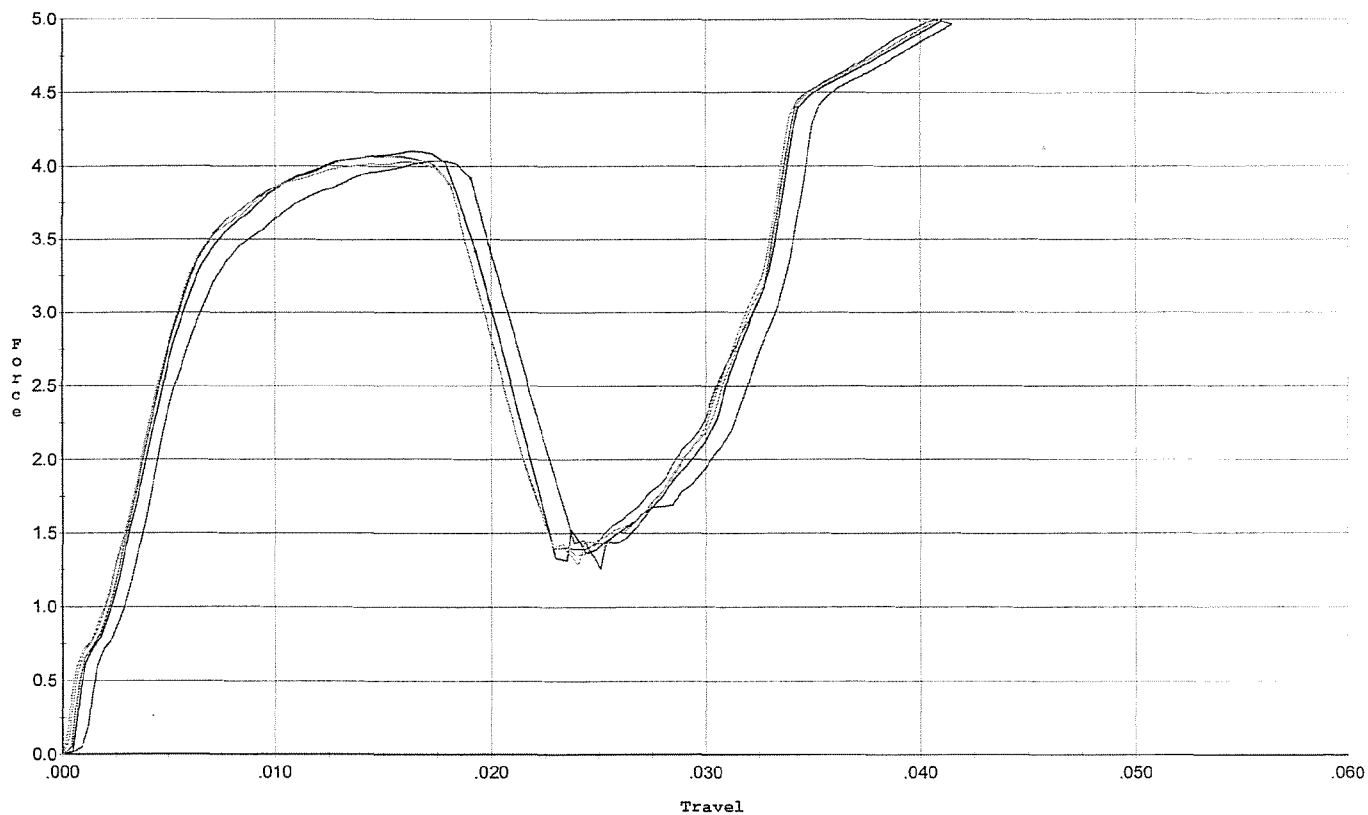
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.175	0.020	0.00	0.028	0.058		Set Trigger
2	4.180	0.019	0.00	0.028	0.055		Set Trigger
3	4.138	0.017	0.00	0.029	0.051		Set Trigger
4	4.137	0.018	0.00	0.029	0.053		Set Trigger
5	4.128	0.018	0.00	0.029	0.054		Set Trigger

Aug 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



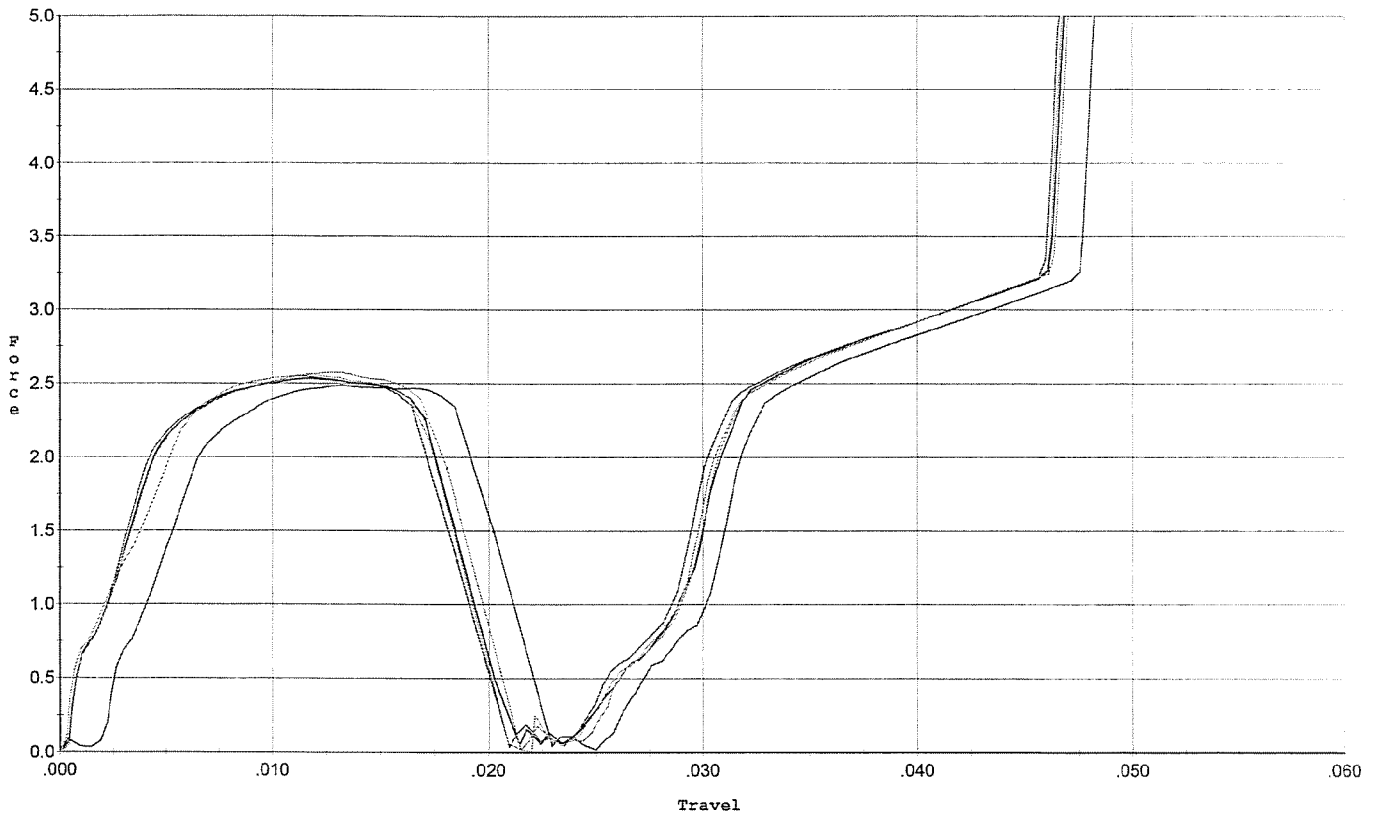
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.019	0.00	0.030	0.052		Set Trigger
2	4.104	0.019	0.00	0.029	0.055		Set Trigger
3	4.069	0.018	0.00	0.029	0.052		Set Trigger
4	4.066	0.018	0.00	0.029	0.052		Set Trigger
5	4.028	0.018	0.00	0.029	0.052		Set Trigger

Aug 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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



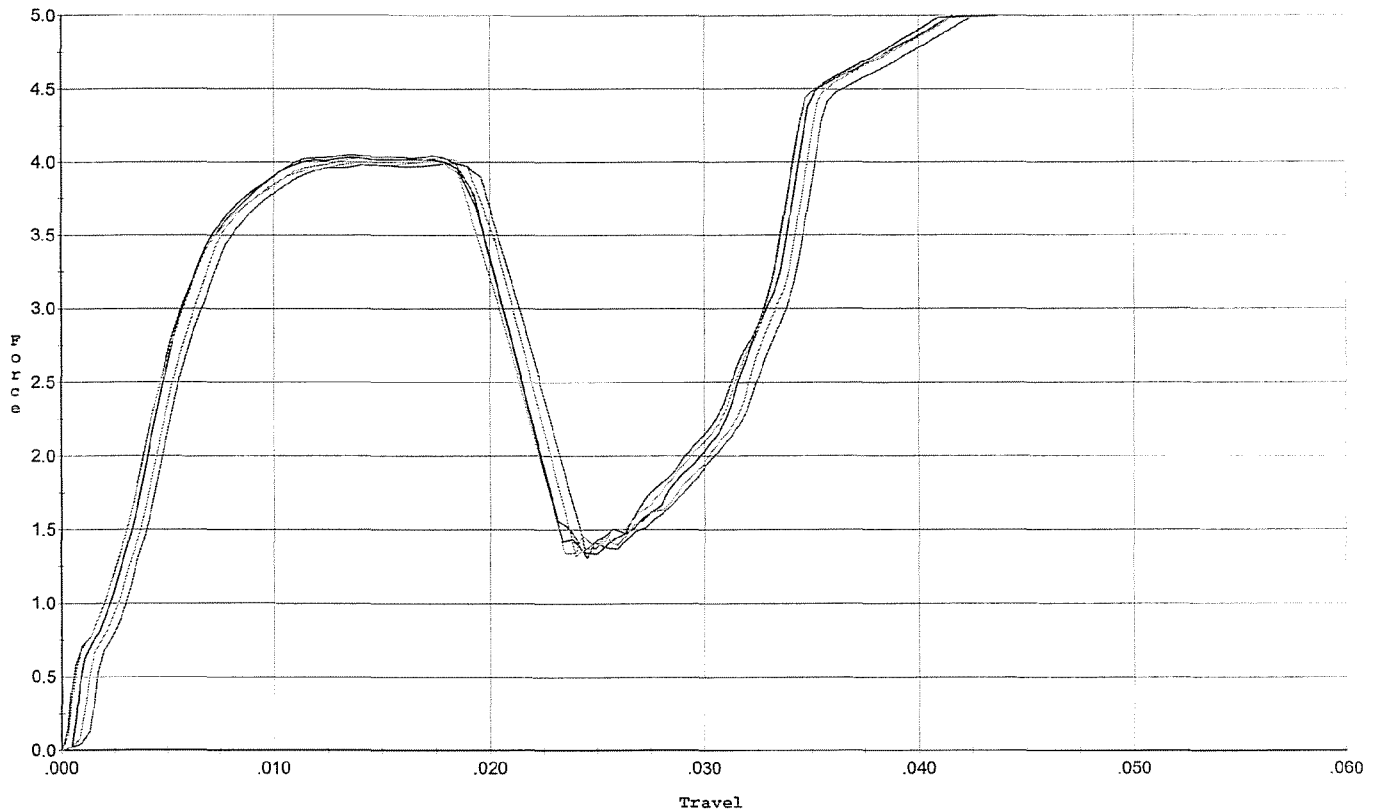
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.020	0.002	0.032	0.035		Set Trigger
2	2.533	0.017	0.00	0.032	0.033		Set Trigger
3	2.550	0.019	0.00	0.032	0.036		Set Trigger
4	2.556	0.017	0.00	0.032	0.033		Set Trigger
5	2.574	0.018	0.00	0.032	0.035		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/15/09

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	4.049	0.019	0.00	0.029	0.056		Set Trigger
2	4.031	0.019	0.00	0.030	0.056		Set Trigger
3	3.991	0.022	0.00	0.030	0.060		Set Trigger
4	4.003	0.020	0.00	0.029	0.059		Set Trigger
5	4.026	0.020	0.00	0.030	0.057		Set Trigger

Avg 4.02