

66858455

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE

24" BARREL 7.62 NATO

WITH BIPOD

proof of purchase



9

0 47700 86470

G6858455

owner registration sticker



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0 47700 86470

G6858455

BM FORM

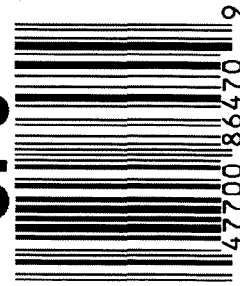
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6858455

UPC



9

0 47700 86470

GUN SERIAL # G 6858455

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5/27/09	SP
430	ASSEMBLE TO STOCK		5-27-09	SP
440	PROOF		5/27/09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5/27/09	RP
470	DIS-ASSEMBLE ACTION		5/27/09	RP
472	SERIALIZE BOLT HANDLE		5-28-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>RD</u>	5/30/09	RD
490	MAGNAFLUX BOLT.			
500	ROLLMARK CALIBER		6/1/09	RT
510	DRILL AND TAP SIGHT HOLES		5-28-09	SP
520	GOFF BLAST BBL / REC		6-1-09	DLN
540	APPLY COATINGS (BARREL ACTION)		6/1/8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		7-15-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

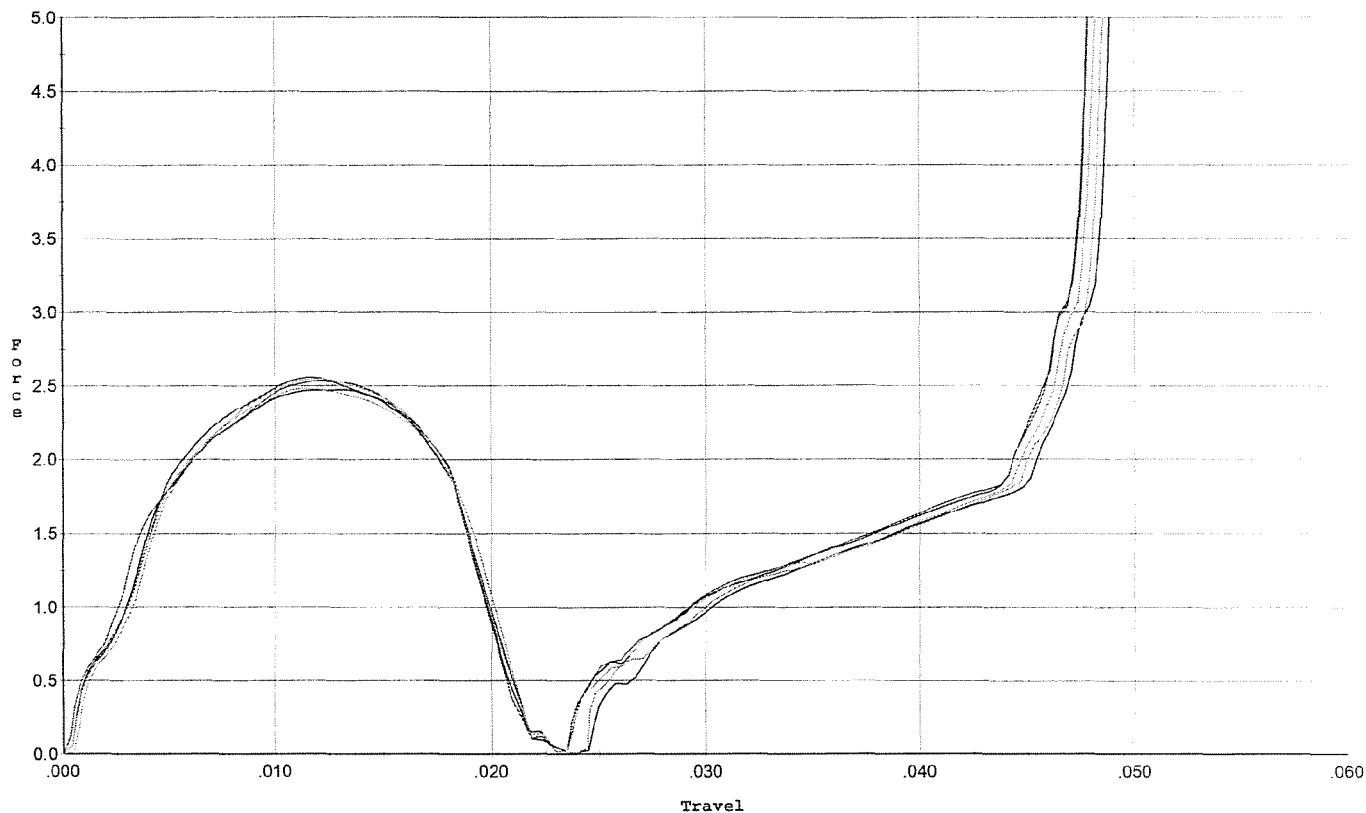
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.0</u> <u>8.0</u>	8-3-09	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	8-3-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.004</u> <u>.004</u> <u>.004</u>	8-3-09	R.N.
	J) ASSEMBLE STOCK		7-15-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		8-3-09	R.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	7/27/09	R.P.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-27	R.N.
670	FINAL INSPECTION A) HEADSPACE		8-3-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.79</u> <u>2.77</u> <u>2.82</u> <u>2.80</u>	7-3-09	R.N.
	C) FUNCTION		8-3-09	R.N.
690	PACK		8/7/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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



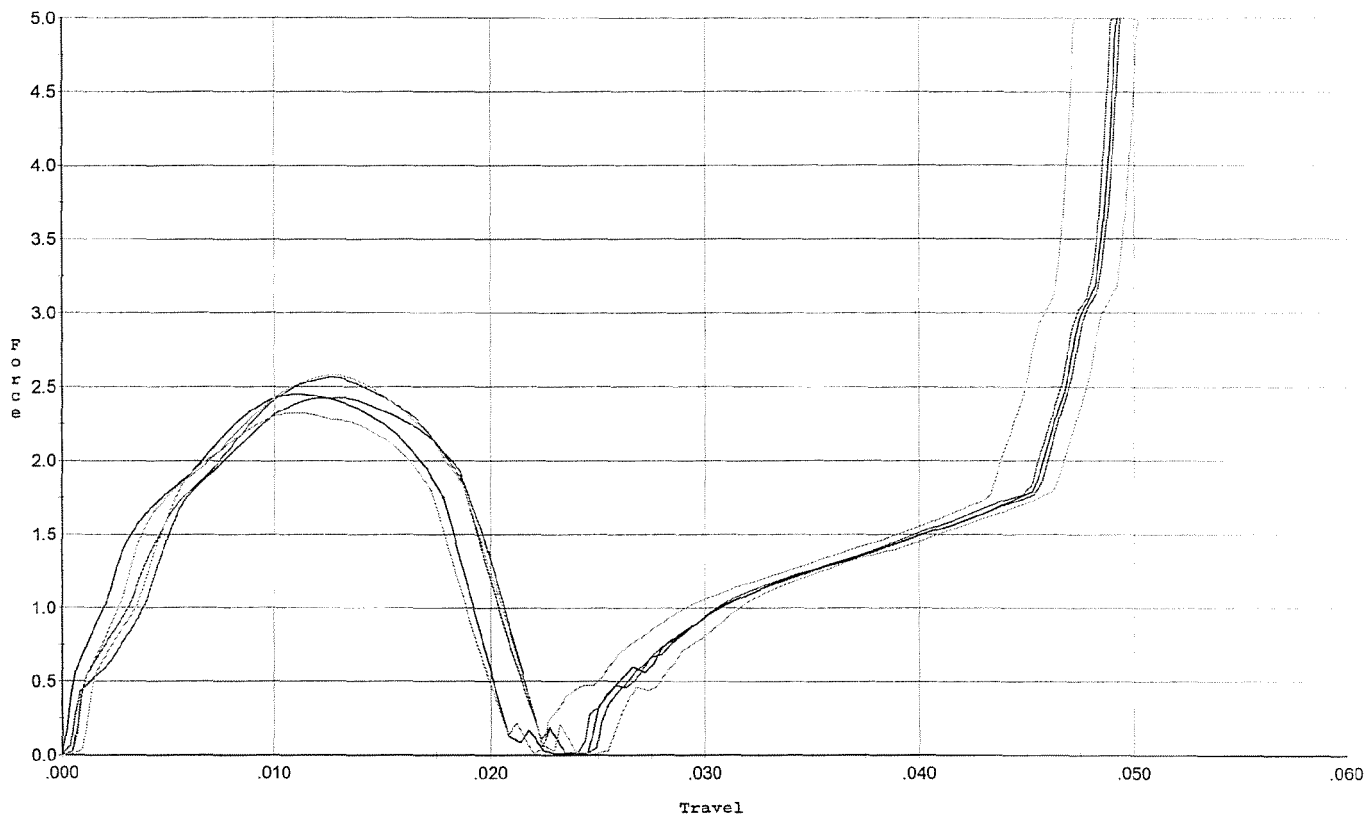
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.558	0.018	0.00	0.034	0.033		Set Trigger
2	2.475	0.018	0.00	0.035	0.033		Set Trigger
3	2.536	0.018	0.00	0.034	0.033		Set Trigger
4	2.484	0.018	0.00	0.035	0.032		Set Trigger
5	2.549	0.019	0.00	0.035	0.035		Set Trigger

Aug 2.52

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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



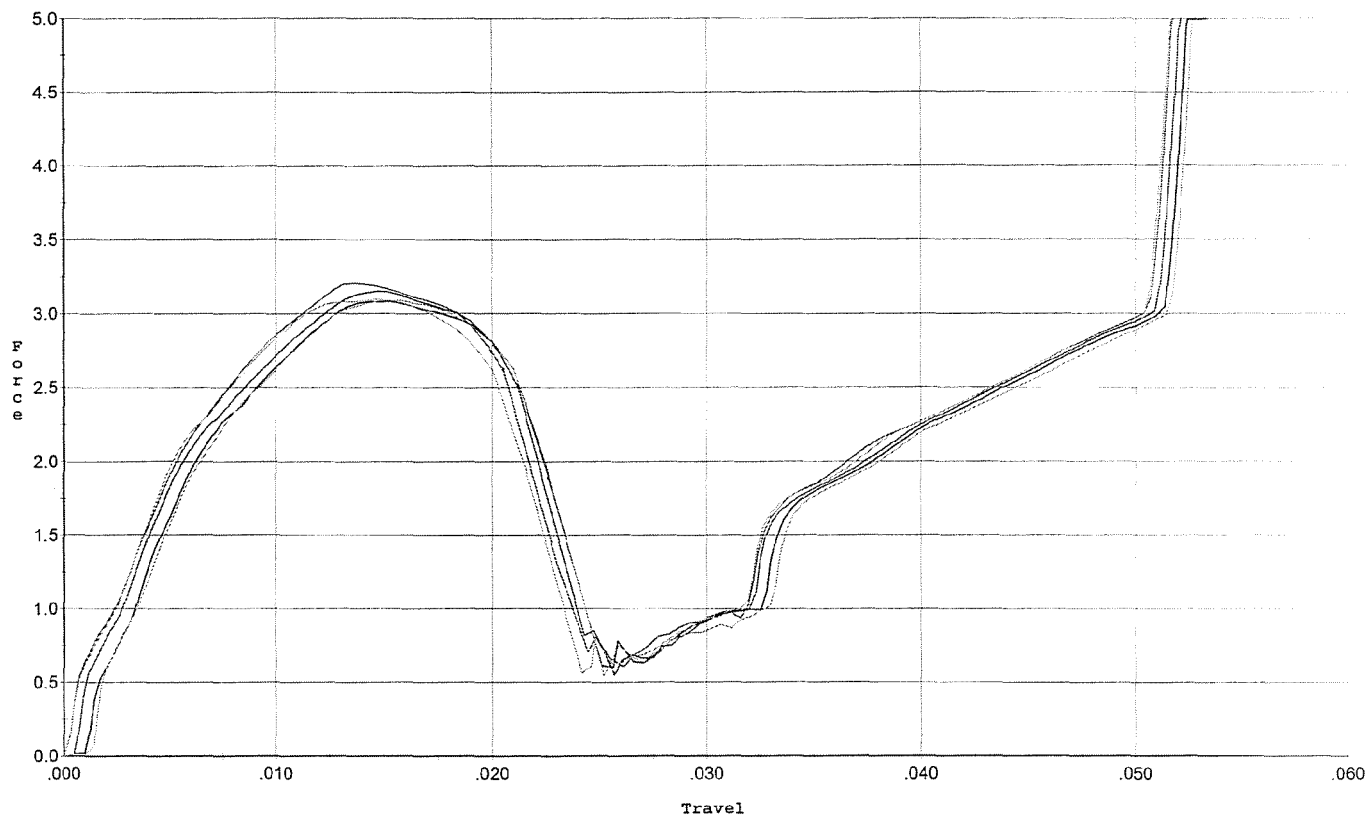
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.424	0.020	0.00	0.035	0.034		Set Trigger
2	2.450	0.018	0.00	0.036	0.032		Set Trigger
3	2.566	0.019	0.00	0.035	0.033		Set Trigger
4	2.579	0.020	0.00	0.036	0.036		Set Trigger
5	2.323	0.017	0.00	0.035	0.029		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/16/09

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



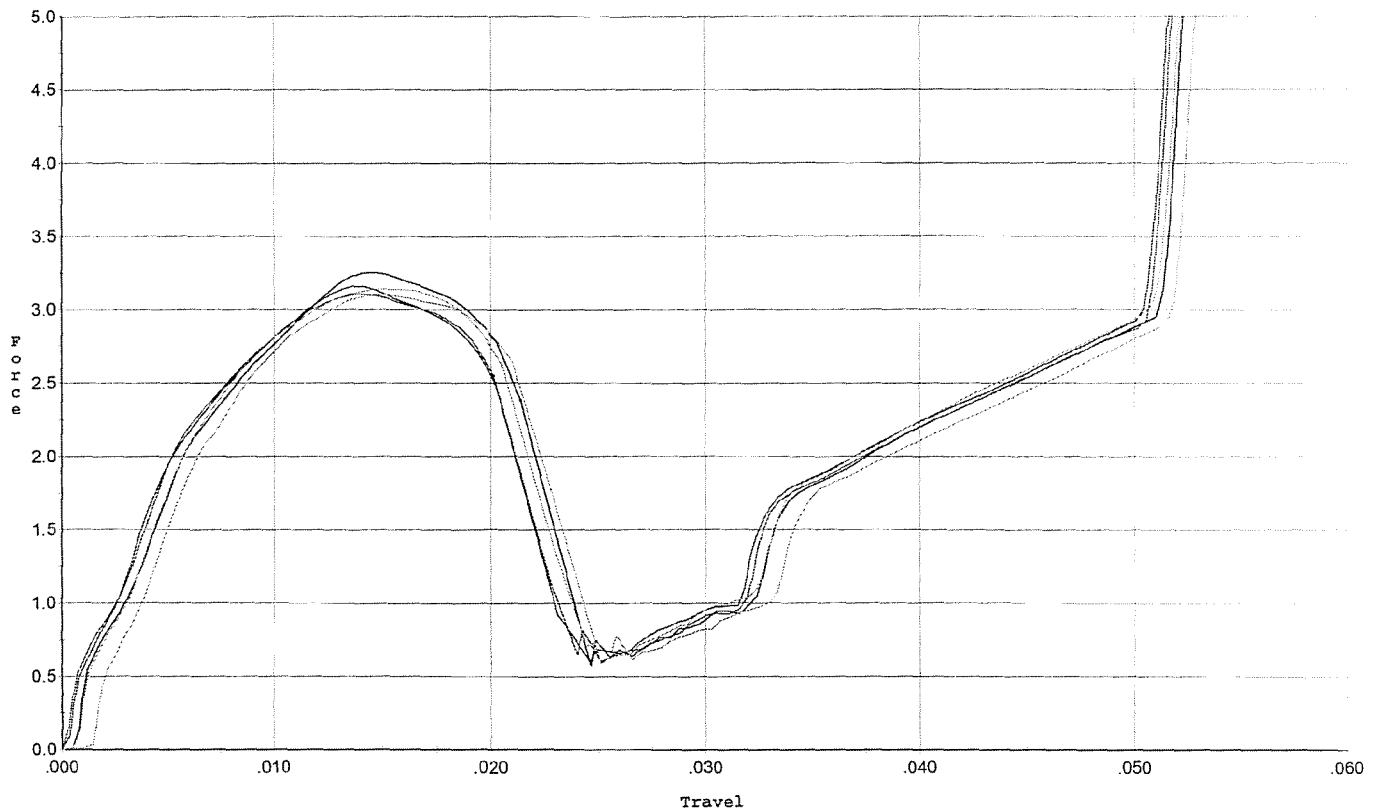
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.149	0.021	0.00	0.034	0.047		Set Trigger
2	3.084	0.023	0.00	0.034	0.048		Set Trigger
3	3.204	0.021	0.00	0.034	0.046		Set Trigger
4	3.097	0.022	0.00	0.034	0.048		Set Trigger
5	3.087	0.022	0.00	0.034	0.047		Set Trigger

Aug 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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



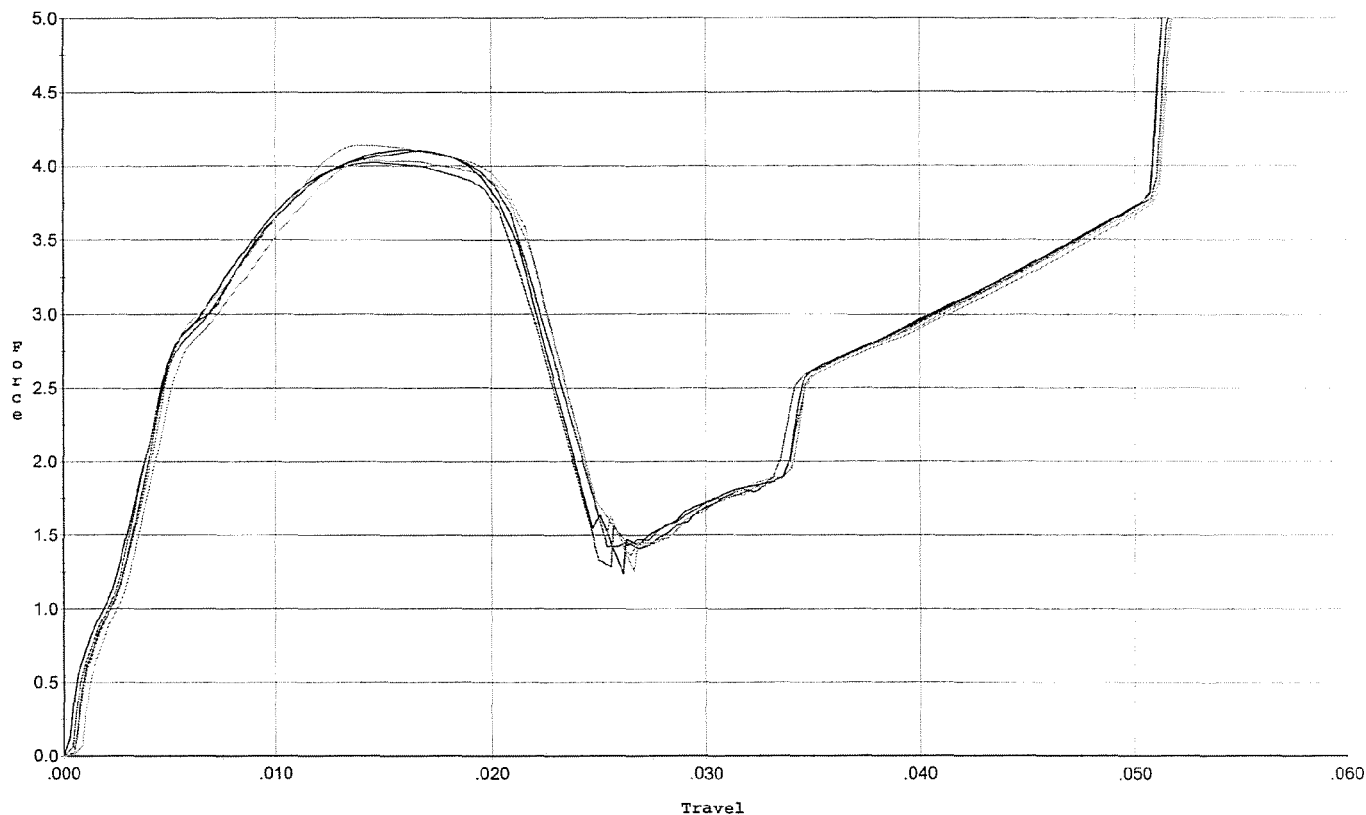
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.020	0.00	0.035	0.045		Set Trigger
2	3.254	0.021	0.00	0.034	0.047		Set Trigger
3	3.104	0.020	0.00	0.035	0.044		Set Trigger
4	3.140	0.021	0.00	0.035	0.045		Set Trigger
5	3.102	0.023	0.00	0.035	0.048		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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



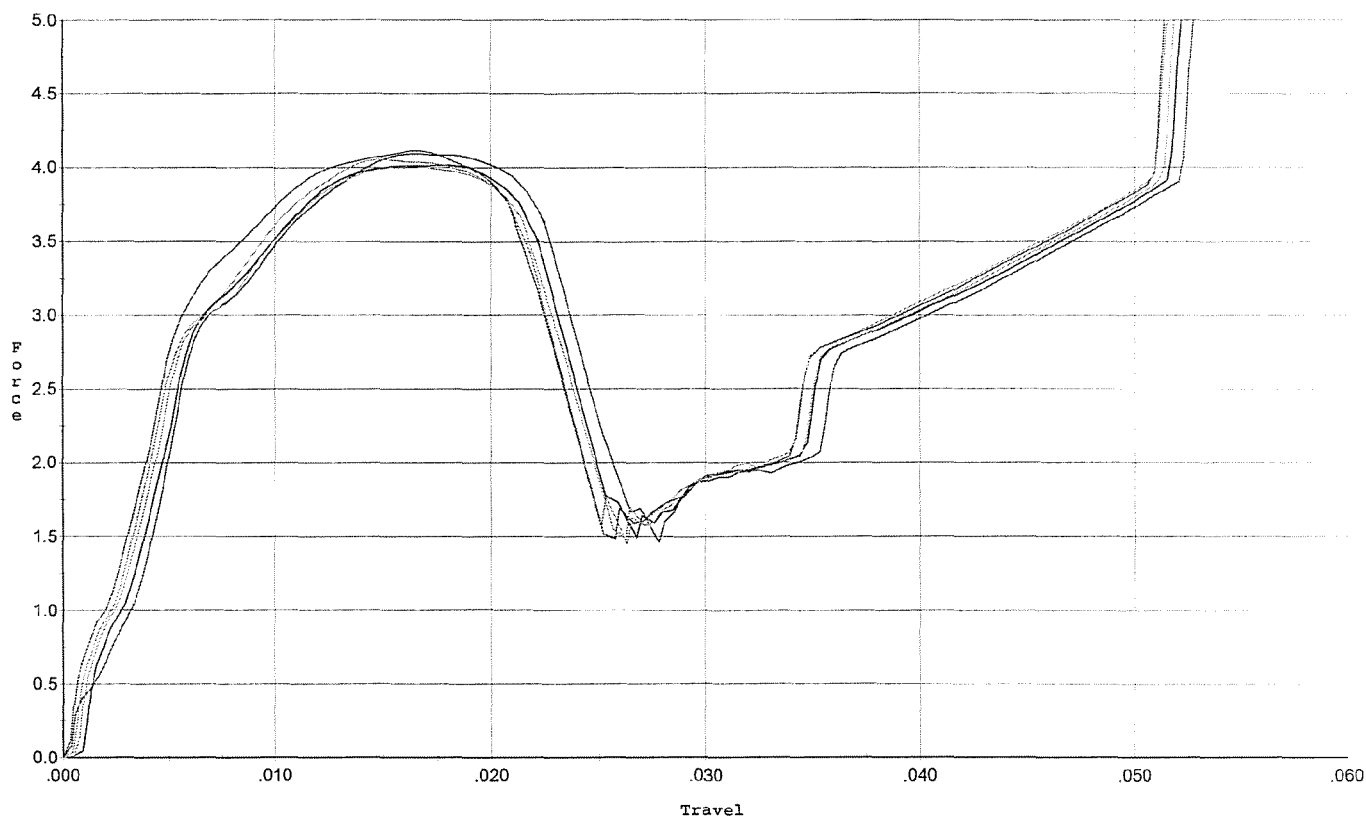
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.023	0.00	0.032	0.066		Set Trigger
2	4.109	0.021	0.00	0.032	0.062		Set Trigger
3	4.023	0.022	0.00	0.032	0.063		Set Trigger
4	4.041	0.022	0.00	0.032	0.061		Set Trigger
5	4.140	0.022	0.00	0.032	0.063		Set Trigger

Aug 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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



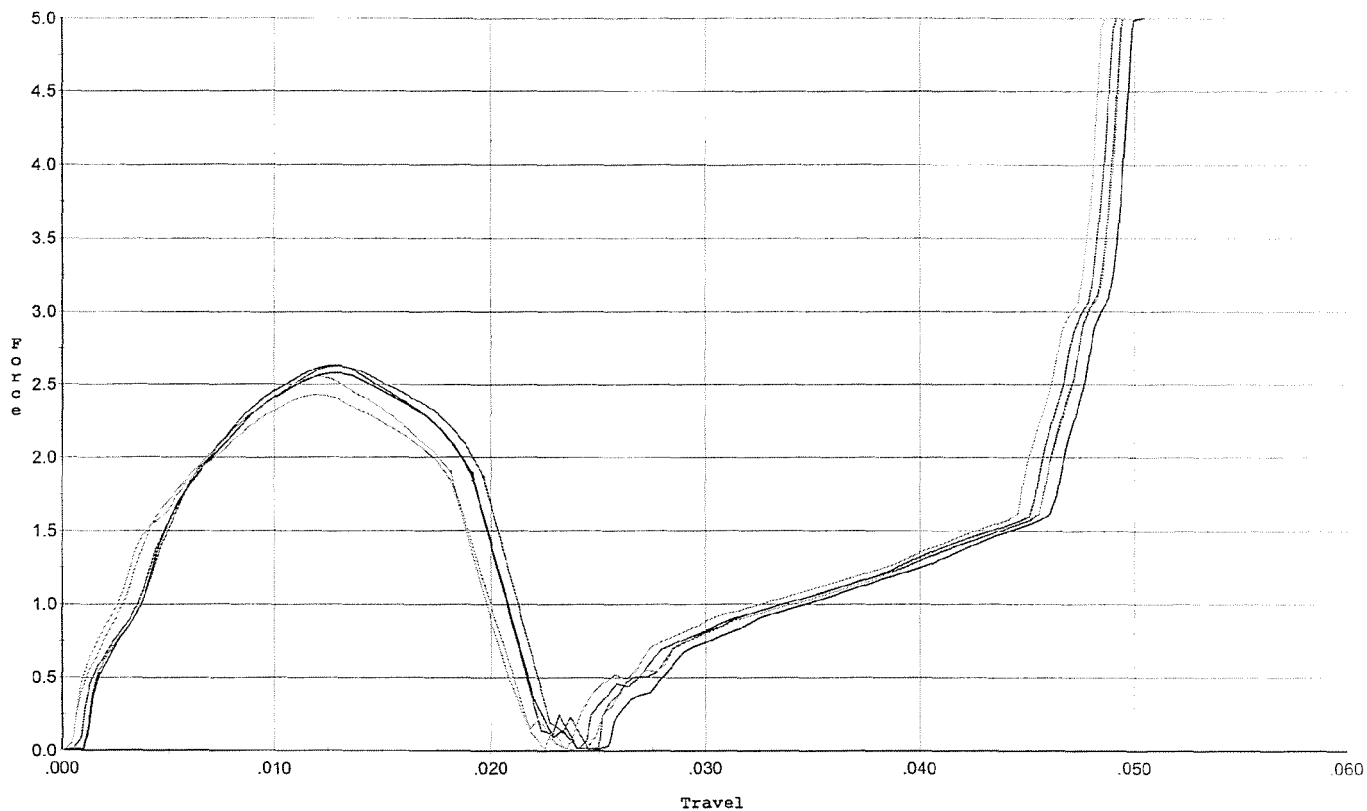
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.092	0.022	0.00	0.032	0.064		Set Trigger
2	4.018	0.022	0.00	0.032	0.063		Set Trigger
3	4.112	0.022	0.00	0.031	0.066		Set Trigger
4	4.009	0.023	0.00	0.031	0.066		Set Trigger
5	4.055	0.022	0.00	0.031	0.063		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/16/09

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



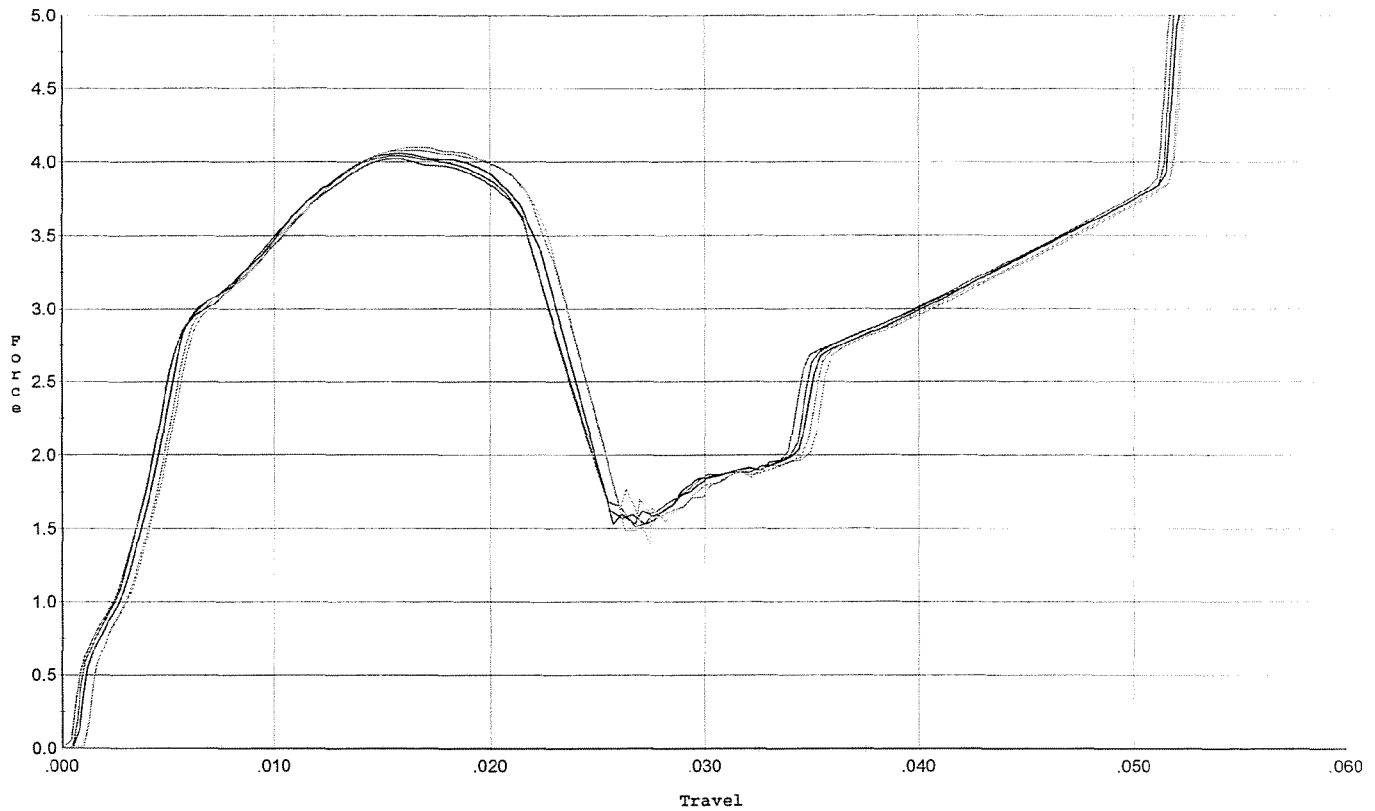
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.019	0.00	0.035	0.034		Set Trigger
2	2.578	0.019	0.00	0.036	0.034		Set Trigger
3	2.624	0.020	0.00	0.035	0.035		Set Trigger
4	2.428	0.018	0.00	0.036	0.032		Set Trigger
5	2.555	0.018	0.00	0.036	0.032		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 6/16/09

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	4.044	0.021	0.00	0.032	0.061		Set Trigger
2	4.058	0.022	0.00	0.032	0.063		Set Trigger
3	4.021	0.022	0.00	0.032	0.061		Set Trigger
4	4.099	0.023	0.00	0.032	0.064		Set Trigger
5	4.080	0.023	0.00	0.031	0.065		Set Trigger

Avg 4.06