

G 681 0334

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

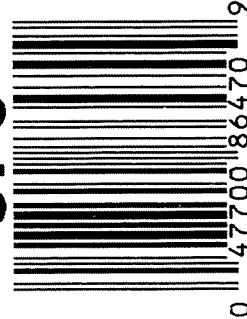


BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6810334

UPC



GUN SERIAL #

G681 0334

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-5-09	SP
430	ASSEMBLE TO STOCK		2-5-09	SP
440	PROOF		2-5-09	SP
460	CHECK HEADSPACE		2-5-09	SP
470	DIS-ASSEMBLE ACTION		2-5-09	SP
472	SERIALIZE BOLT HANDLE		2-6-09	RIC
475	DRILL AND TAP SIGHT HOLES		2-6-09	TC
480	MAGNAFLUX BBL ACTION		2/7/09	MR
490	MAGNAFLUX BOLT		2/7/09	MR
500	ROLLMARK CALIBER		2/9/09	RT
520	GOFF BLAST BBL / REC		9-Feb-09	
542	APPLY COATINGS (BARREL ACTION)		2-12	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

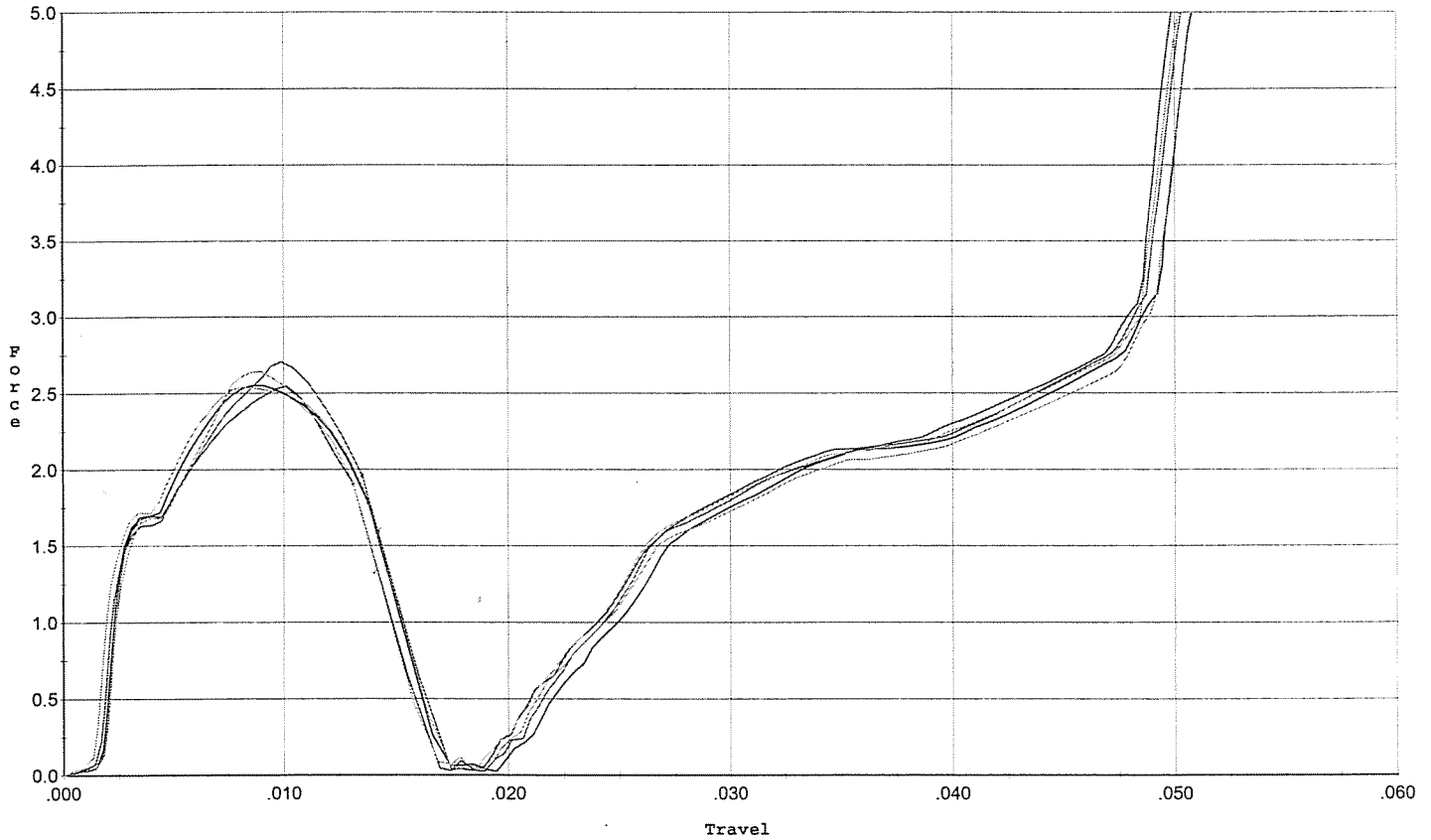
OP #	OP	BARBER - M24 0130399	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-18-09	LJ
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-18-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u> <u>.025</u> <u>.024</u>	2-18-09	LJ
	J) ASSEMBLE STOCK			2-13-09	LJ
	K) ASSEMBLE SWIVEL STUDS			2-18-09	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	2-16-09	TL
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			2-16-09	WN
670	FINAL INSPECTION A) HEADSPACE			2-18-09	LJ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.30</u> <u>2.49</u> <u>2.47</u> <u>2.25</u>	2-17-09	WN
	C) FUNCTION			2-18-09	LJ
690	PACK			2/19/09	Fey

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



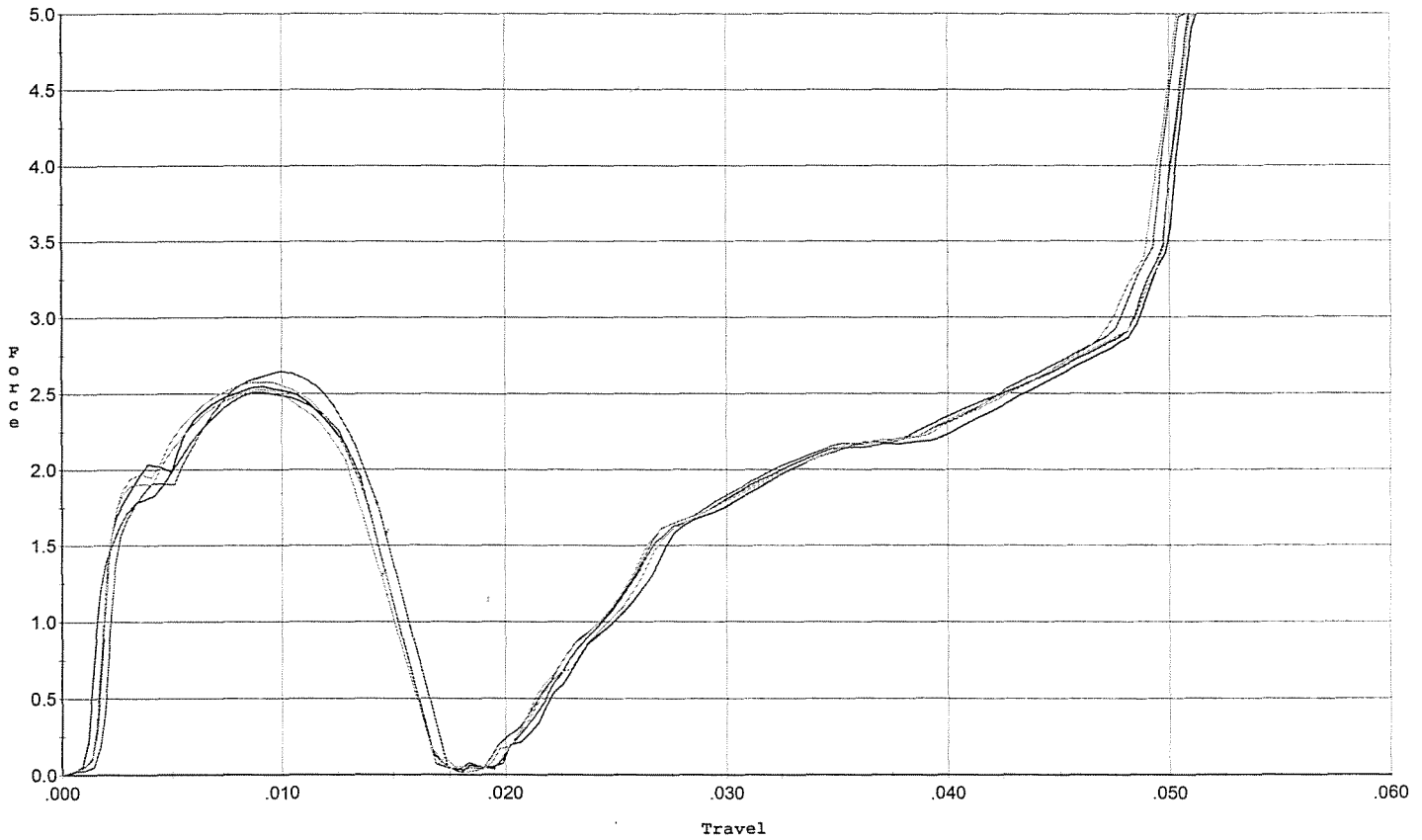
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.013	0.00	0.040	0.022		Set Trigger
2	2.553	0.014	0.00	0.041	0.023		Set Trigger
3	2.706	0.014	0.00	0.041	0.023		Set Trigger
4	2.539	0.013	0.00	0.041	0.023		Set Trigger
5	2.643	0.014	0.00	0.041	0.023		Set Trigger

A-259

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



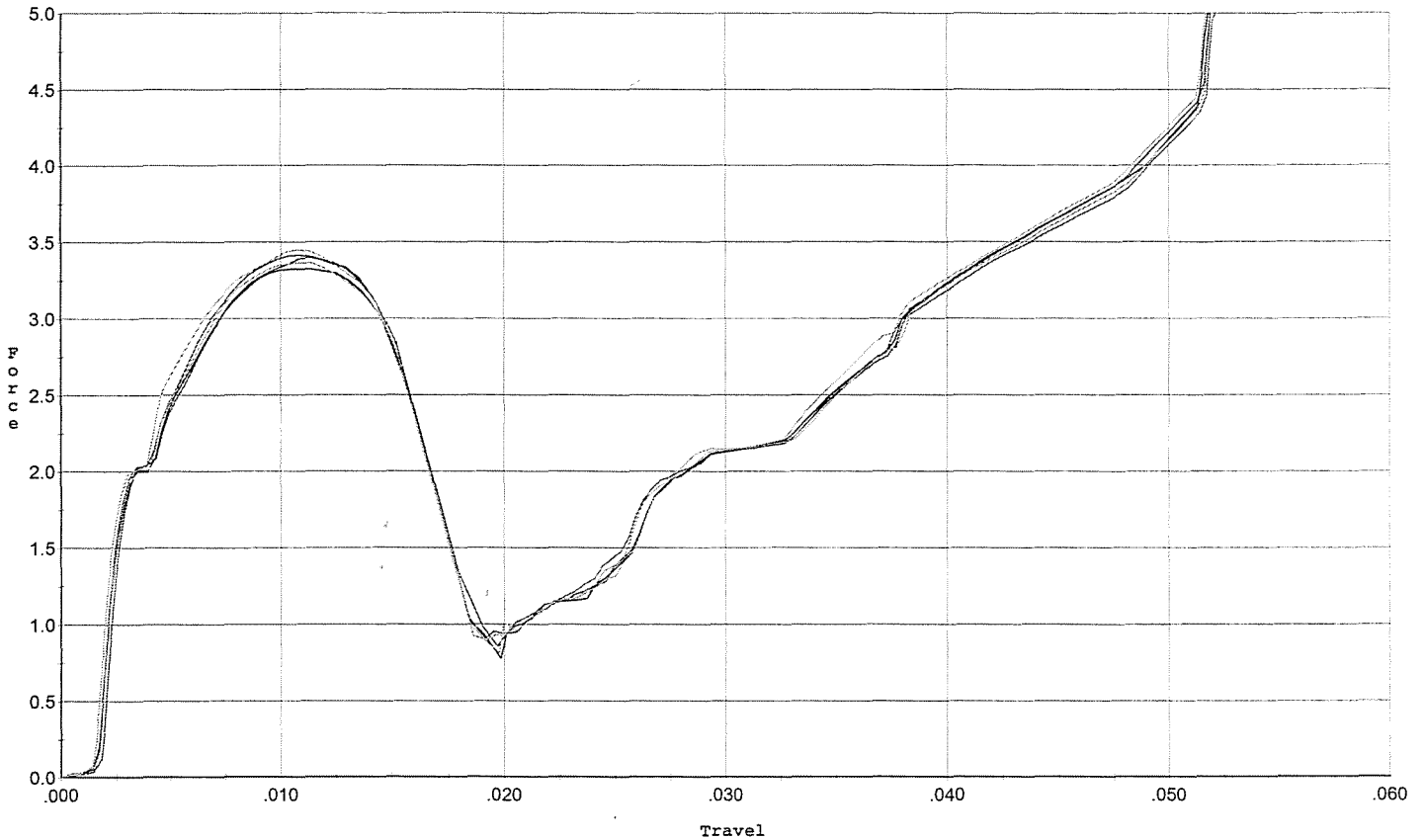
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.508	0.014	0.00	0.041	0.024		Set Trigger
2	2.548	0.014	0.00	0.041	0.025		Set Trigger
3	2.647	0.014	0.00	0.040	0.025		Set Trigger
4	2.576	0.014	0.00	0.041	0.025		Set Trigger
5	2.527	0.015	0.00	0.040	0.026		Set Trigger

A-256

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



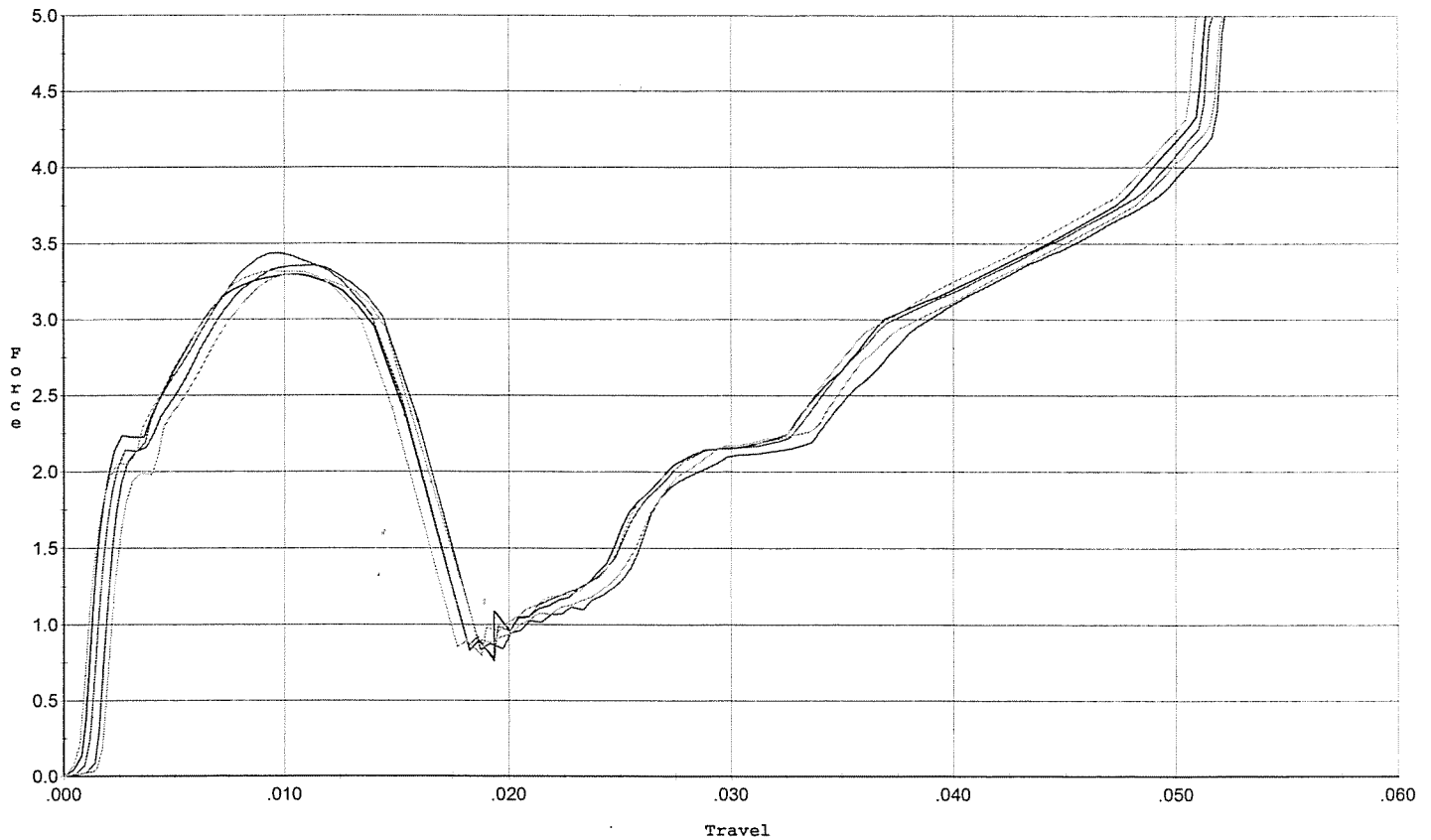
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.400	0.015	0.00	0.038	0.034		Set Trigger
2	3.326	0.015	0.00	0.038	0.035		Set Trigger
3	3.415	0.015	0.00	0.038	0.036		Set Trigger
4	3.447	0.015	0.00	0.038	0.036		Set Trigger
5	3.366	0.016	0.00	0.038	0.035		Set Trigger

A-3-39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



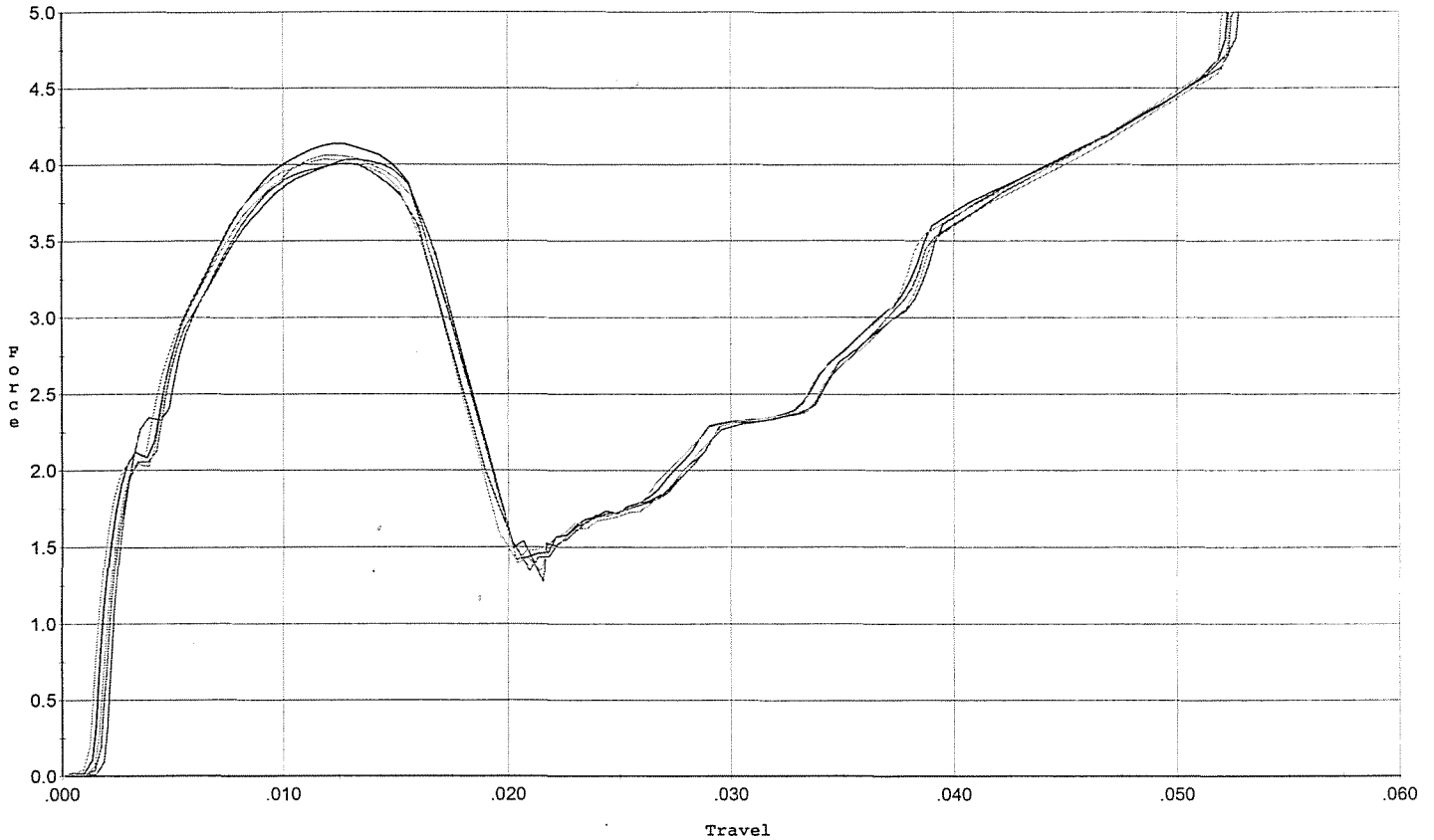
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.356	0.016	0.00	0.038	0.037		Set Trigger
2	3.299	0.015	0.00	0.038	0.037		Set Trigger
3	3.438	0.015	0.00	0.038	0.036		Set Trigger
4	3.321	0.015	0.00	0.038	0.035		Set Trigger
5	3.300	0.017	0.00	0.038	0.037		Set Trigger

A-3-34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



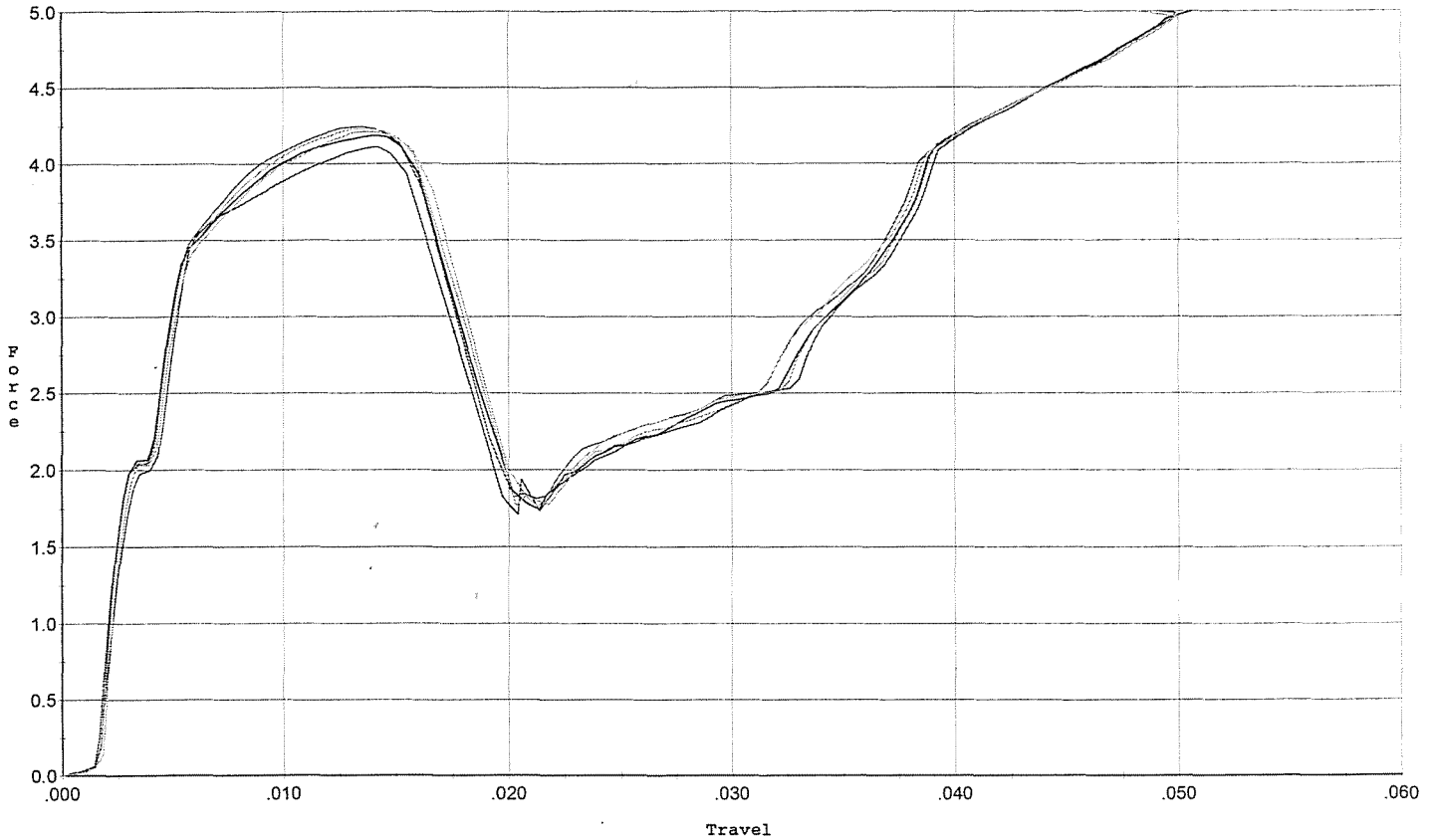
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.032	0.017	0.002	0.036	0.045		Set Trigger
2	4.138	0.017	0.00	0.036	0.048		Set Trigger
3	4.007	0.016	0.00	0.037	0.043		Set Trigger
4	4.036	0.016	0.00	0.036	0.045		Set Trigger
5	4.060	0.017	0.00	0.036	0.047		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



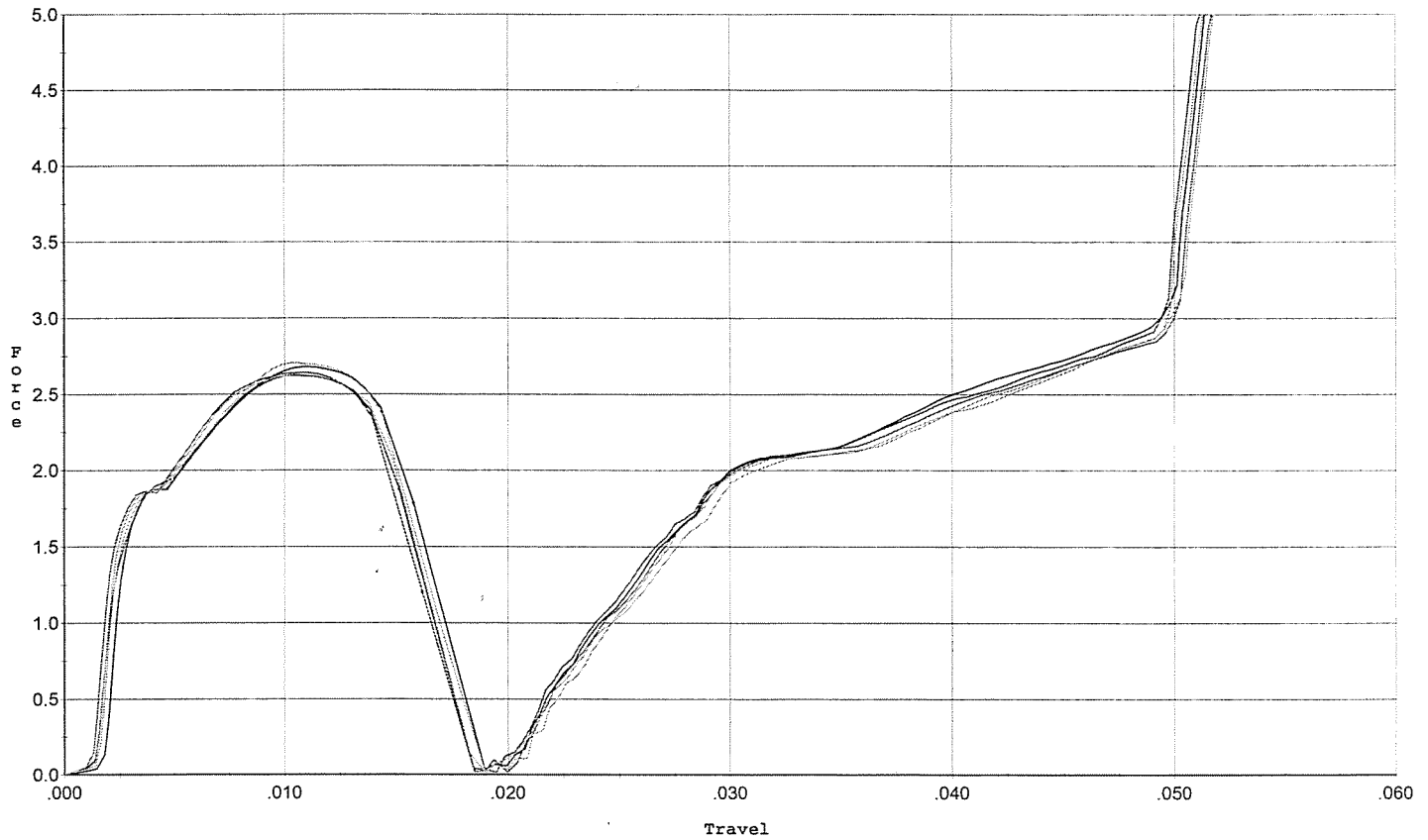
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.110	0.018	0.00	0.036	0.048		Set Trigger
2	4.185	0.016	0.00	0.035	0.045		Set Trigger
3	4.244	0.016	0.00	0.035	0.046		Set Trigger
4	4.228	0.018	0.00	0.035	0.051		Set Trigger
5	4.210	0.017	0.00	0.035	0.047		Set Trigger

A-4.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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



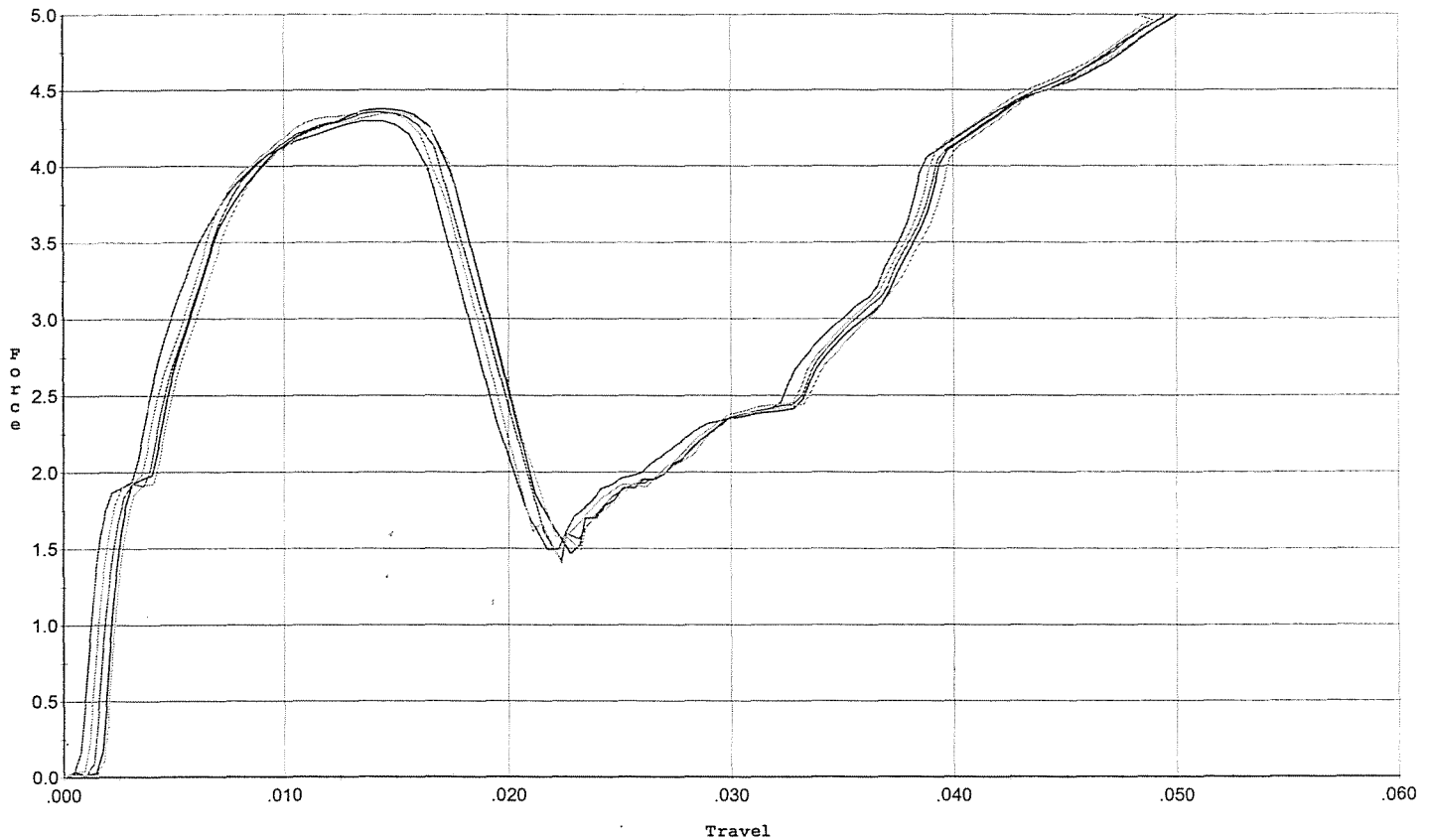
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.623	0.015	0.00	0.039	0.028		Set Trigger
2	2.680	0.016	0.00	0.039	0.029		Set Trigger
3	2.642	0.016	0.00	0.040	0.030		Set Trigger
4	2.707	0.014	0.00	0.039	0.027		Set Trigger
5	2.631	0.015	0.00	0.040	0.028		Set Trigger

A-2-65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/12/2009

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	4.297	0.016	0.00	0.035	0.049		Set Trigger
2	4.375	0.018	0.00	0.035	0.051		Set Trigger
3	4.353	0.019	0.00	0.034	0.056		Set Trigger
4	4.347	0.017	0.002	0.035	0.050		Set Trigger
5	4.361	0.017	0.00	0.034	0.052		Set Trigger

A-4.34