

G6810361

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

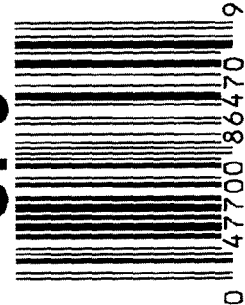
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810361

UPC



GUN SERIAL # G 6810361

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-10-09	SP
430	ASSEMBLE TO STOCK		2-10-09	SP
440	PROOF		2-10-09	SP
460	CHECK HEADSPACE		2-10-09	SP
470	DIS-ASSEMBLE ACTION		2-10-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	2-10-09	RT
475	DRILL AND TAP SIGHT HOLES		2-11-09	TE
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/13/09	
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/14/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DC
542	APPLY COATINGS (BARREL ACTION)		2/21	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-24-09	R.N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

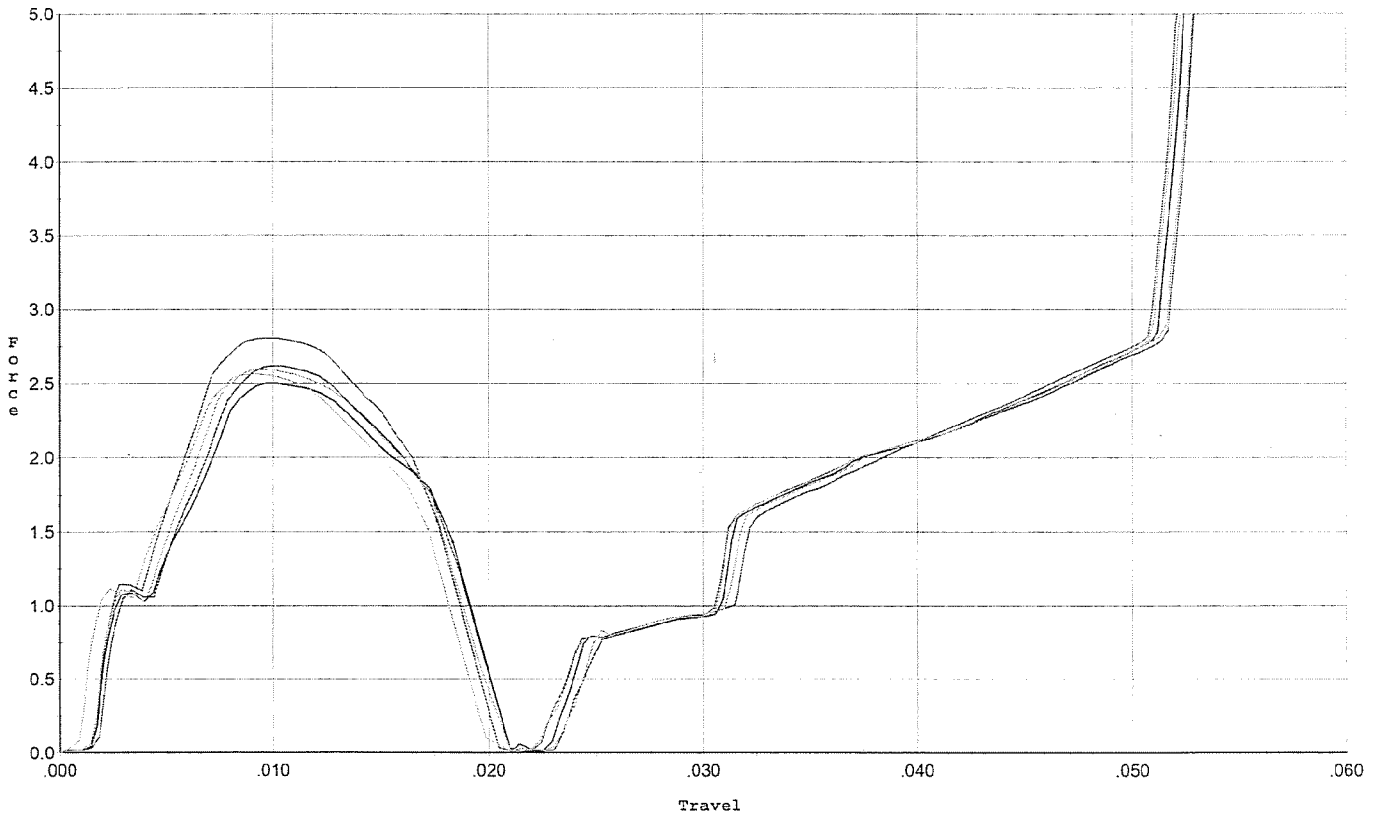
560	BARBER - M24 0130687 F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	2-27-09	NW
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3.5</u>	2-27-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	2-27-09	NW
	J) ASSEMBLE STOCK			2-24-09	RP
	K) ASSEMBLE SWIVEL STUDS			2-27-09	NW
	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	2-26-09	RP
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			2-26-09	RP
670	FINAL INSPECTION A) HEADSPACE			2-27-09	NW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.21</u> <u>2.24</u> <u>2.34</u> <u>2.13</u>	2-27-09	NW
	C) FUNCTION			2-27-09	NW
690	PACK			3/3/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/23/2009

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



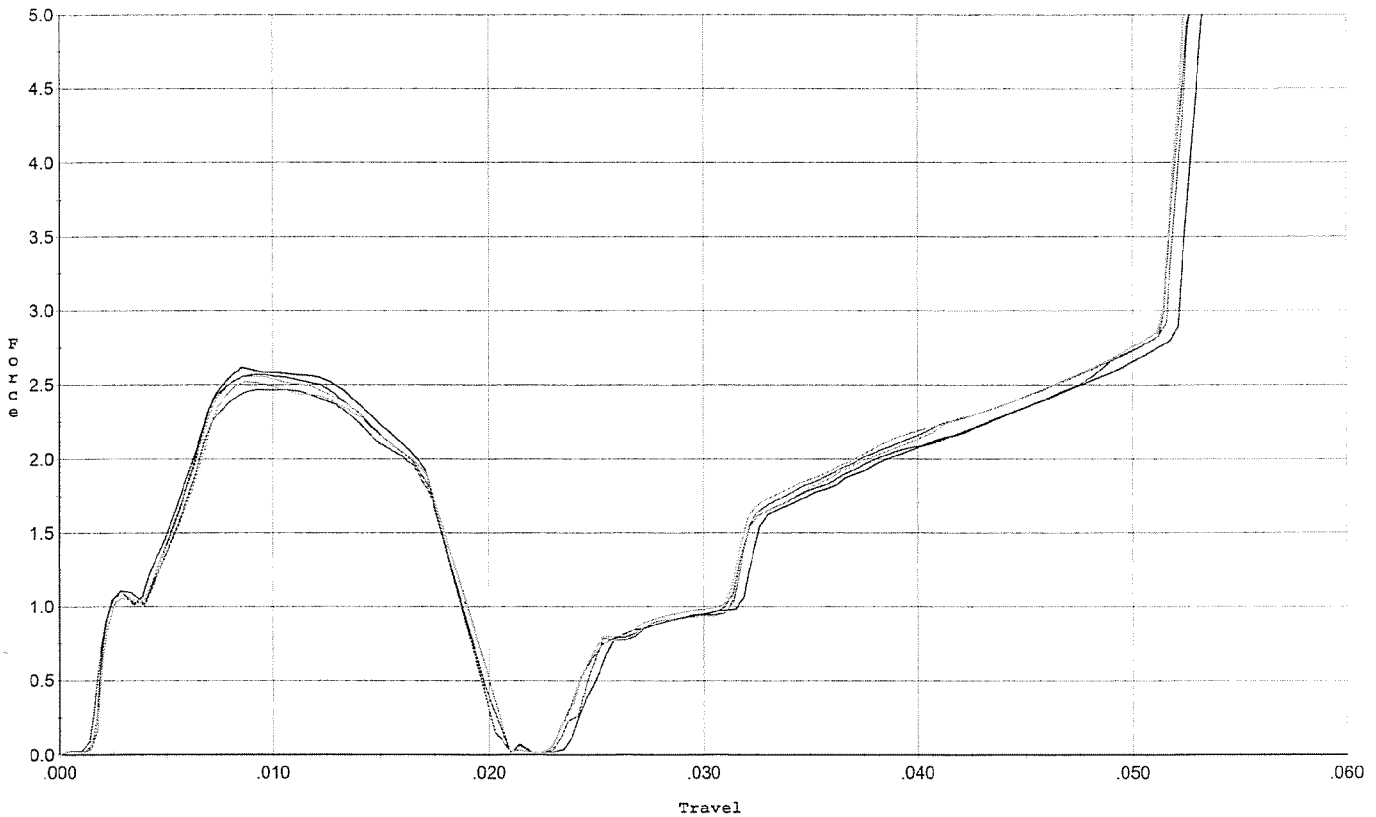
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.019	0.005	0.039	0.031		Set Trigger
2	2.503	0.018	0.00	0.038	0.030		Set Trigger
3	2.806	0.018	0.004	0.039	0.032		Set Trigger
4	2.562	0.017	0.004	0.039	0.030		Set Trigger
5	2.596	0.017	0.004	0.039	0.030		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/23/2009

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



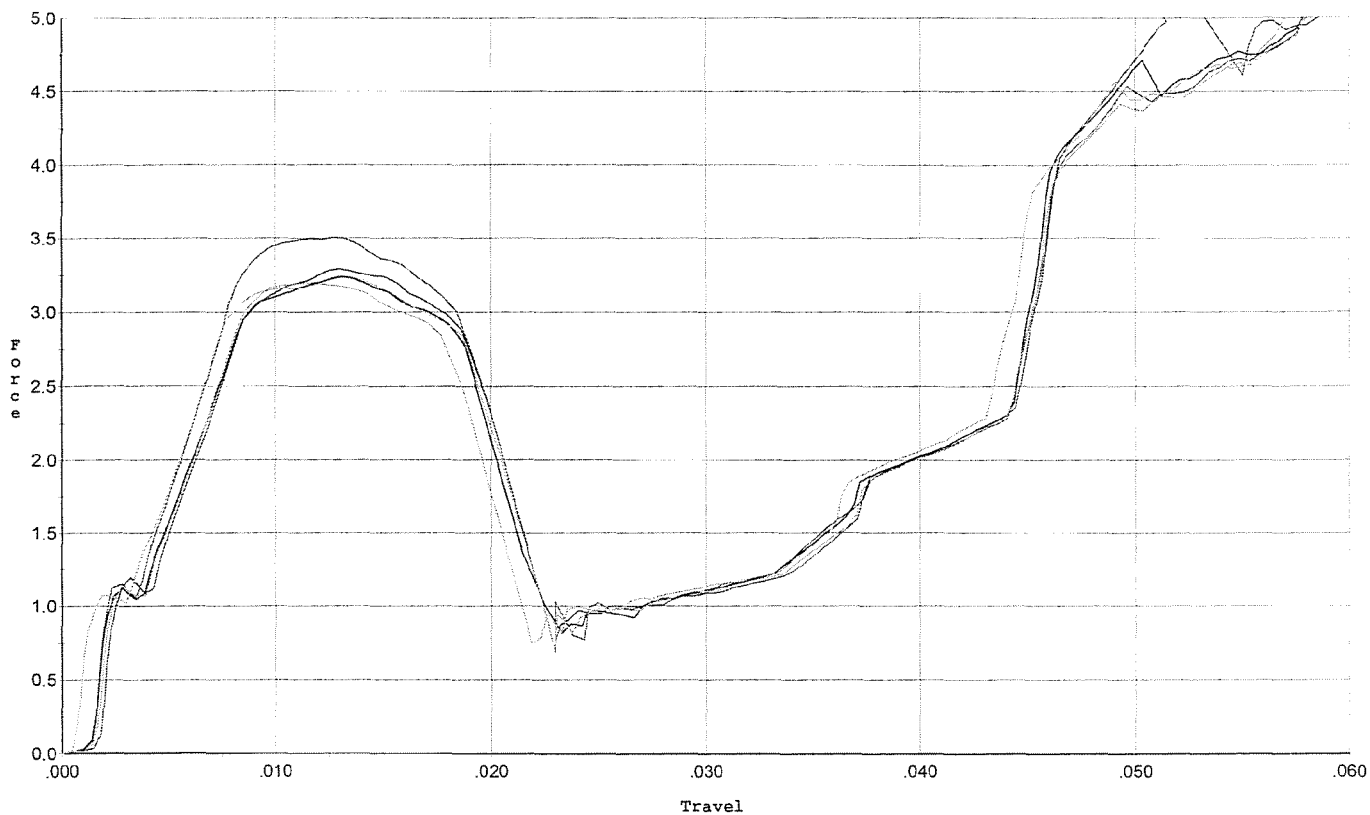
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.017	0.004	0.039	0.030		Set Trigger
2	2.616	0.019	0.00	0.039	0.033		Set Trigger
3	2.467	0.017	0.004	0.039	0.029		Set Trigger
4	2.558	0.019	0.004	0.038	0.032		Set Trigger
5	2.522	0.019	0.004	0.038	0.031		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/23/2009

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



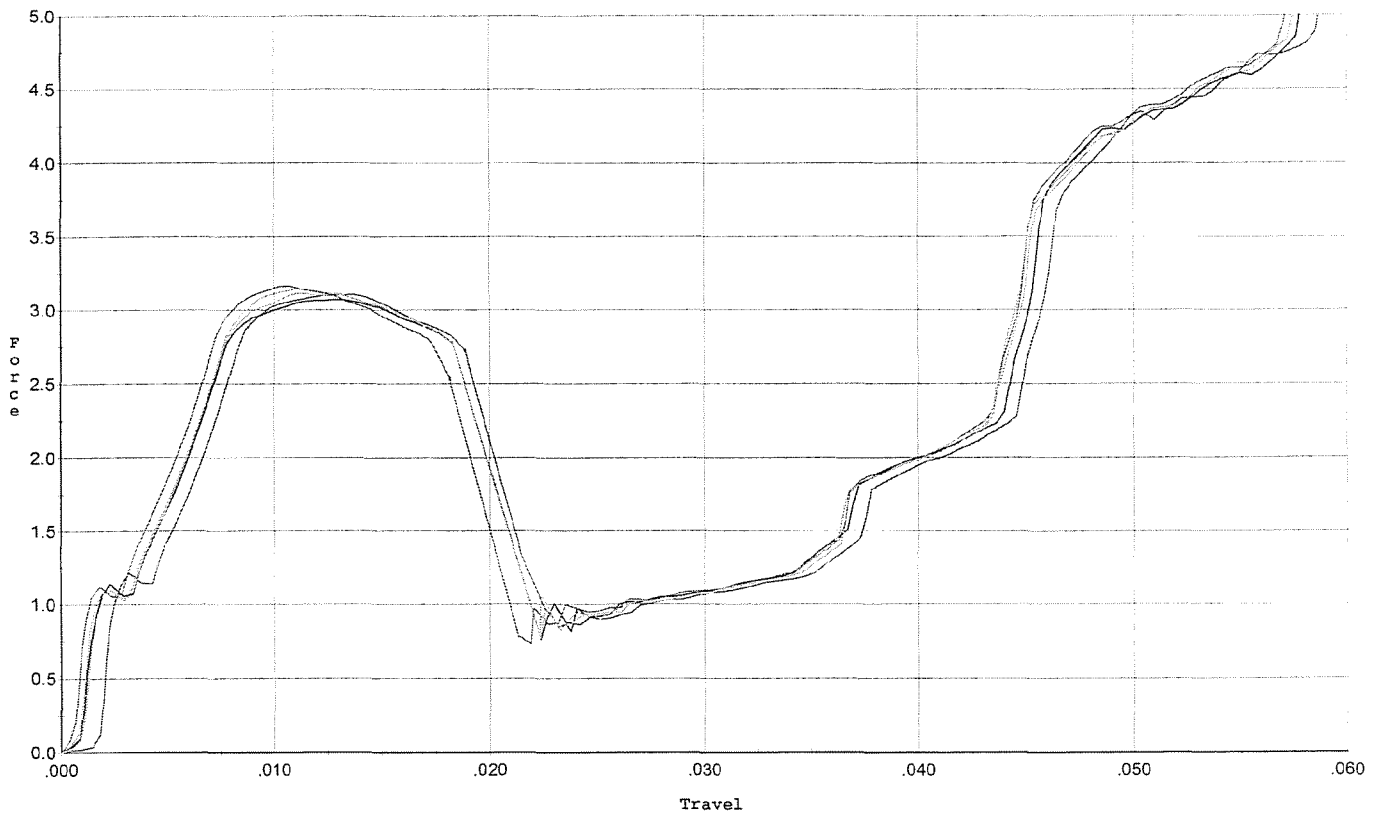
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.291	0.020	0.00	0.041	0.043		Set Trigger
2	3.237	0.019	0.00	0.041	0.041		Set Trigger
3	3.504	0.020	0.00	0.041	0.047		Set Trigger
4	3.188	0.019	0.003	0.041	0.042		Set Trigger
5	3.248	0.020	0.004	0.041	0.045		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/23/2009

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



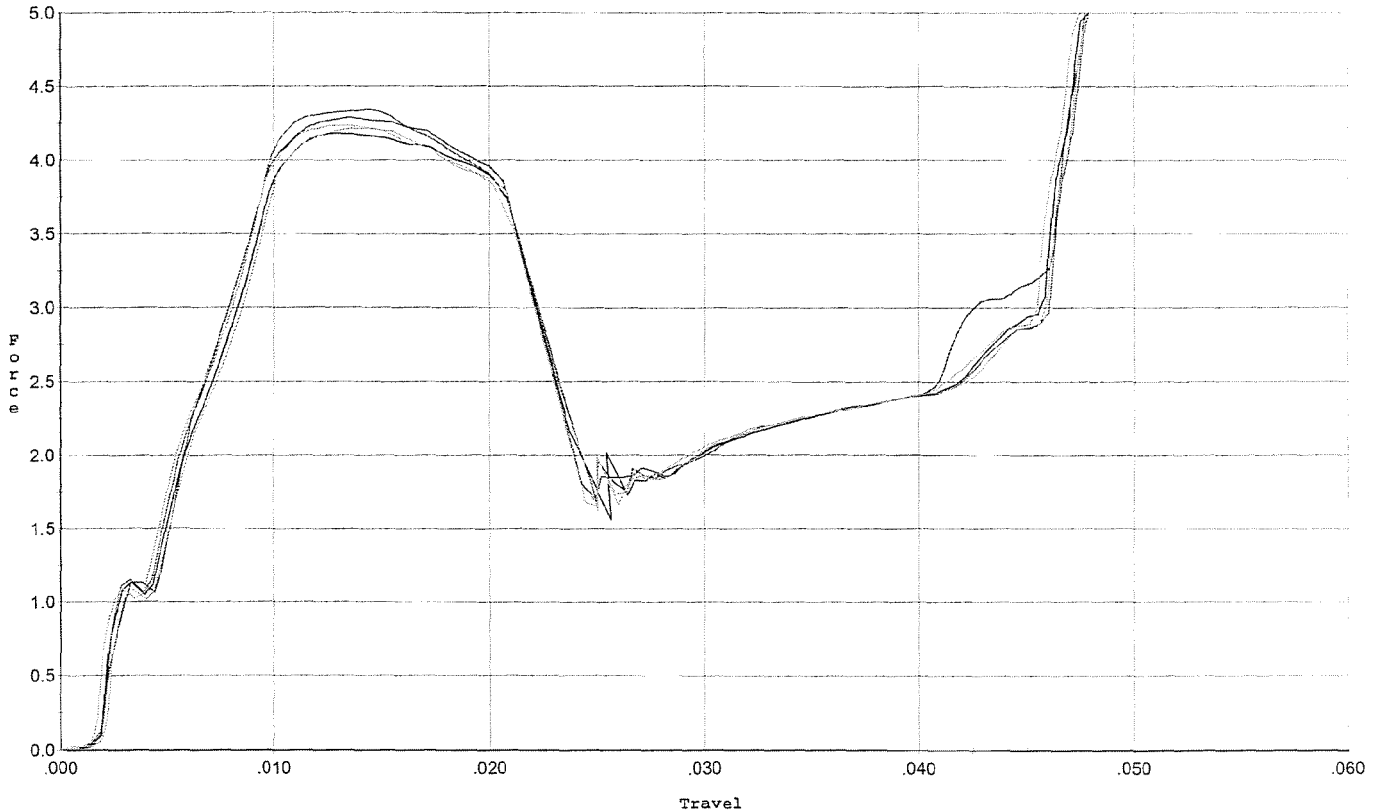
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.108	0.019	0.005	0.042	0.039		Set Trigger
2	3.071	0.020	0.00	0.041	0.043		Set Trigger
3	3.164	0.018	0.00	0.041	0.040		Set Trigger
4	3.116	0.020	0.00	0.041	0.044		Set Trigger
5	3.145	0.018	0.00	0.041	0.040		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/23/2009

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



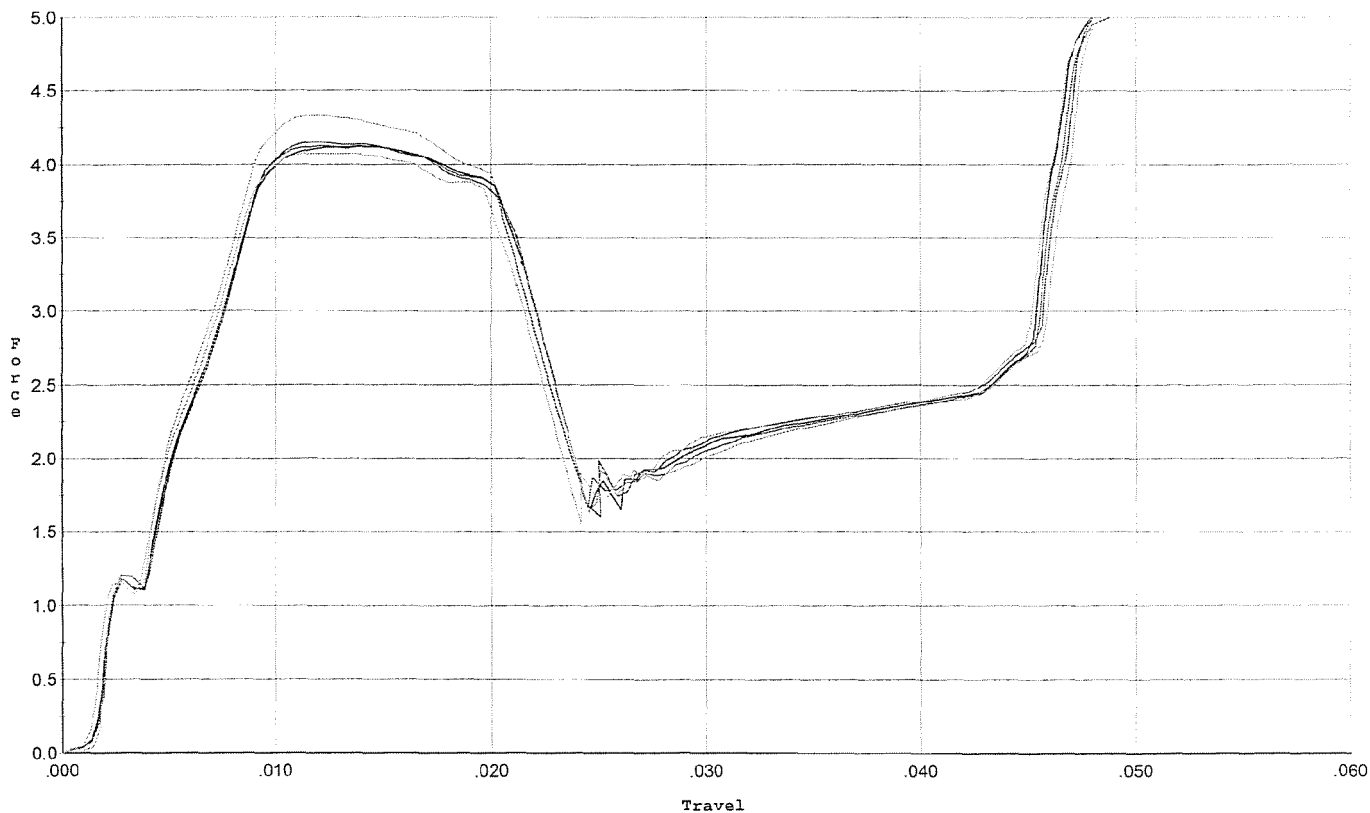
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.290	0.021	0.005	0.038	0.057		Set Trigger
2	4.180	0.021	0.00	0.037	0.057		Set Trigger
3	4.342	0.021	0.00	0.037	0.058		Set Trigger
4	4.234	0.021	0.00	0.038	0.059		Set Trigger
5	4.215	0.021	0.00	0.037	0.056		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/23/2009

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	4.155	0.021	0.004	0.038	0.059		Set Trigger
2	4.123	0.021	0.004	0.037	0.060		Set Trigger
3	4.128	0.020	0.004	0.038	0.056		Set Trigger
4	4.075	0.021	0.00	0.037	0.059		Set Trigger
5	4.333	0.021	0.00	0.038	0.062		Set Trigger

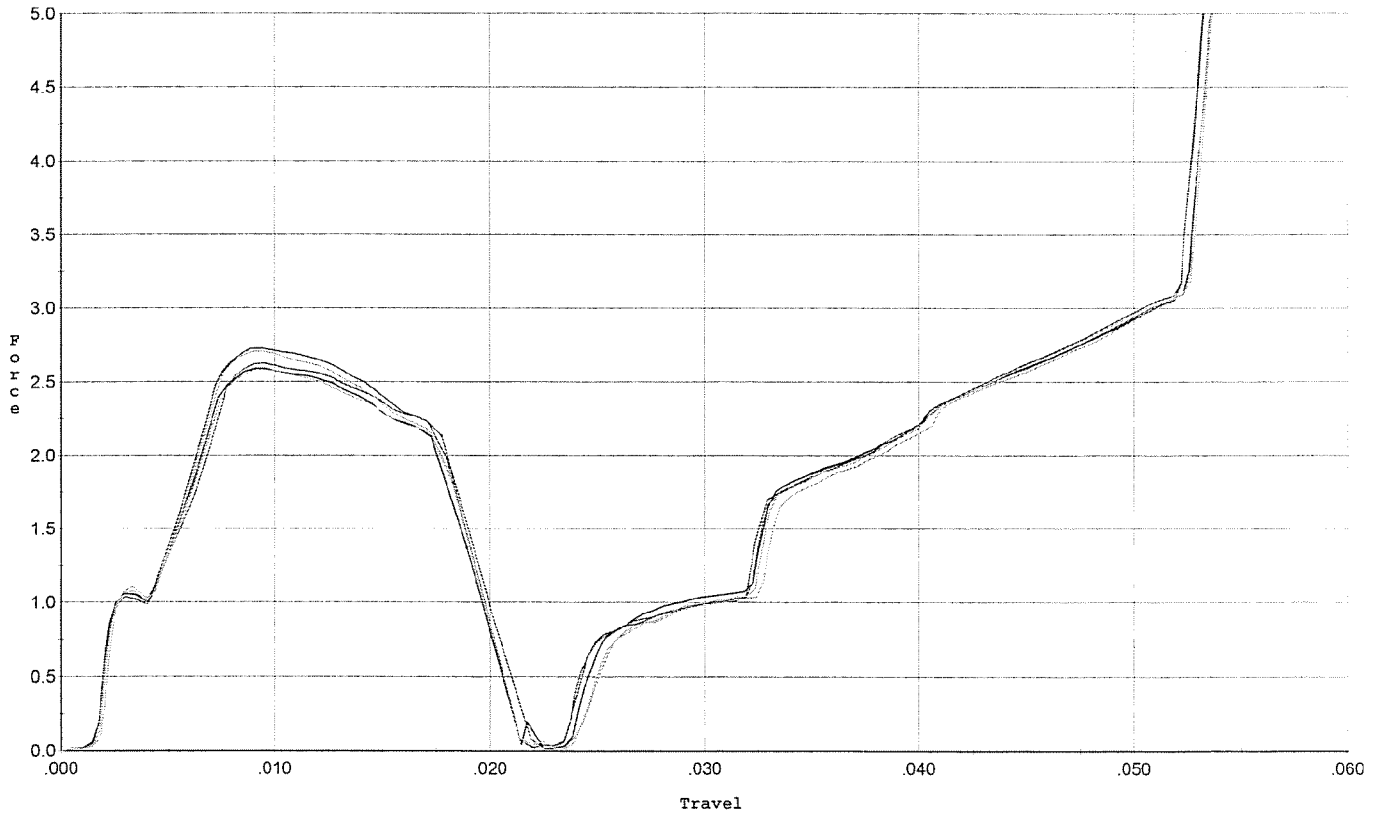
A-406

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/23/2009

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

for final test
 cm5



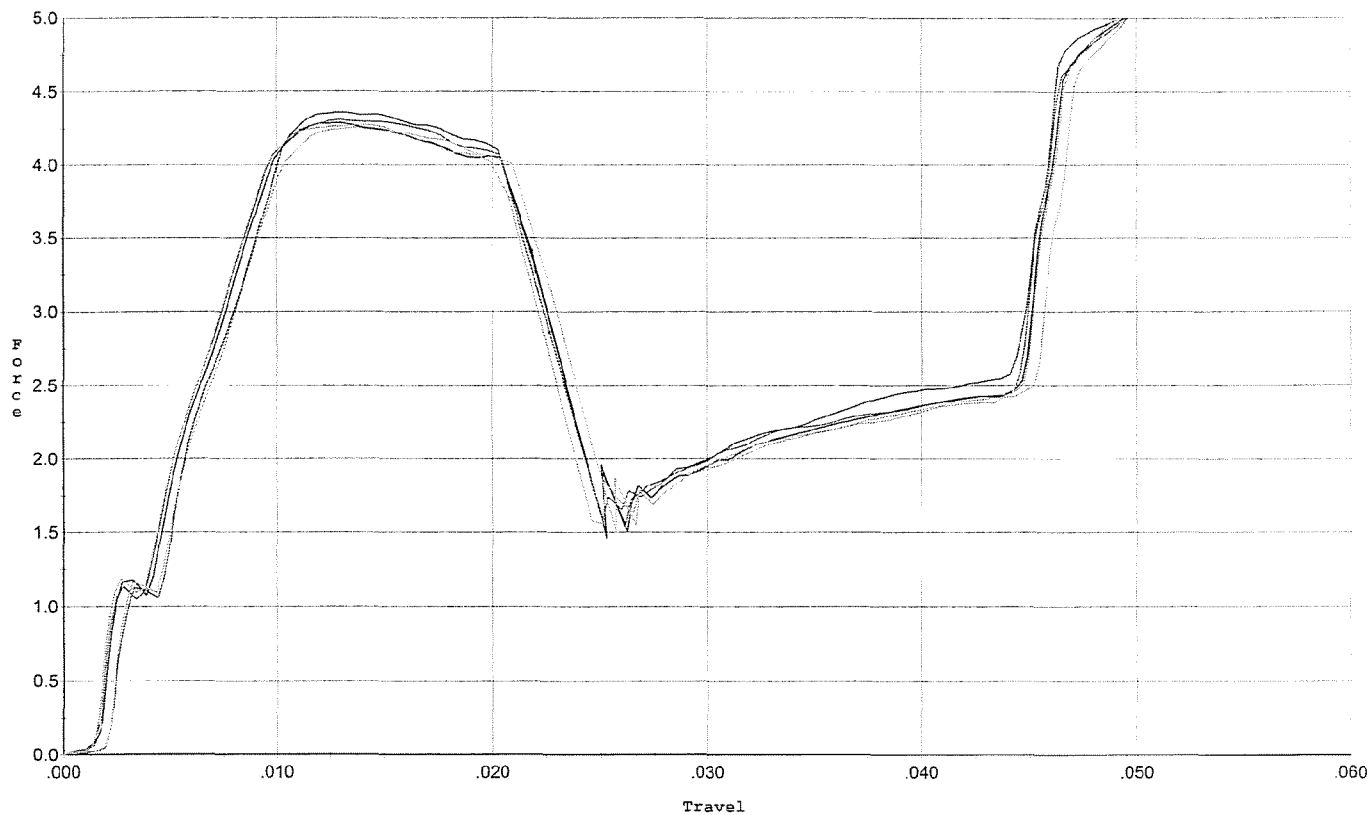
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.726	0.018	0.004	0.039	0.033		Set Trigger
2	2.588	0.019	0.004	0.039	0.033		Set Trigger
3	2.625	0.018	0.004	0.039	0.031		Set Trigger
4	2.707	0.018	0.004	0.039	0.032		Set Trigger
5	2.581	0.018	0.00	0.039	0.031		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/23/2009

Model: M/24
 Serial No: Form #F005
 Trigger: reset 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	4.358	0.022	0.005	0.037	0.062		Set Trigger
2	4.288	0.022	0.00	0.038	0.062		Set Trigger
3	4.309	0.023	0.00	0.037	0.065		Set Trigger
4	4.255	0.023	0.005	0.038	0.064		Set Trigger
5	4.274	0.021	0.00	0.038	0.060		Set Trigger

A-4.29