

66810423

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



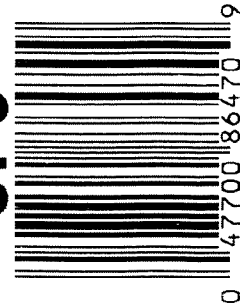
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810423

UPC



BM FORM

GUN SERIAL #

6810423

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	RT
475	DRILL AND TAP SIGHT HOLES		2-6-09	RT
480	MAGNAFLUX BBL ACTION	(K)	2/7/09	(K)
490	MAGNAFLUX BOLT		2/7/09	MR
500	ROLLMARK CALIBER		2/9/09	RT
520	GOFF BLAST BBL / REC		9-Feb-09	SP
542	APPLY COATINGS (BARREL ACTION)		2-11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-11-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-12-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

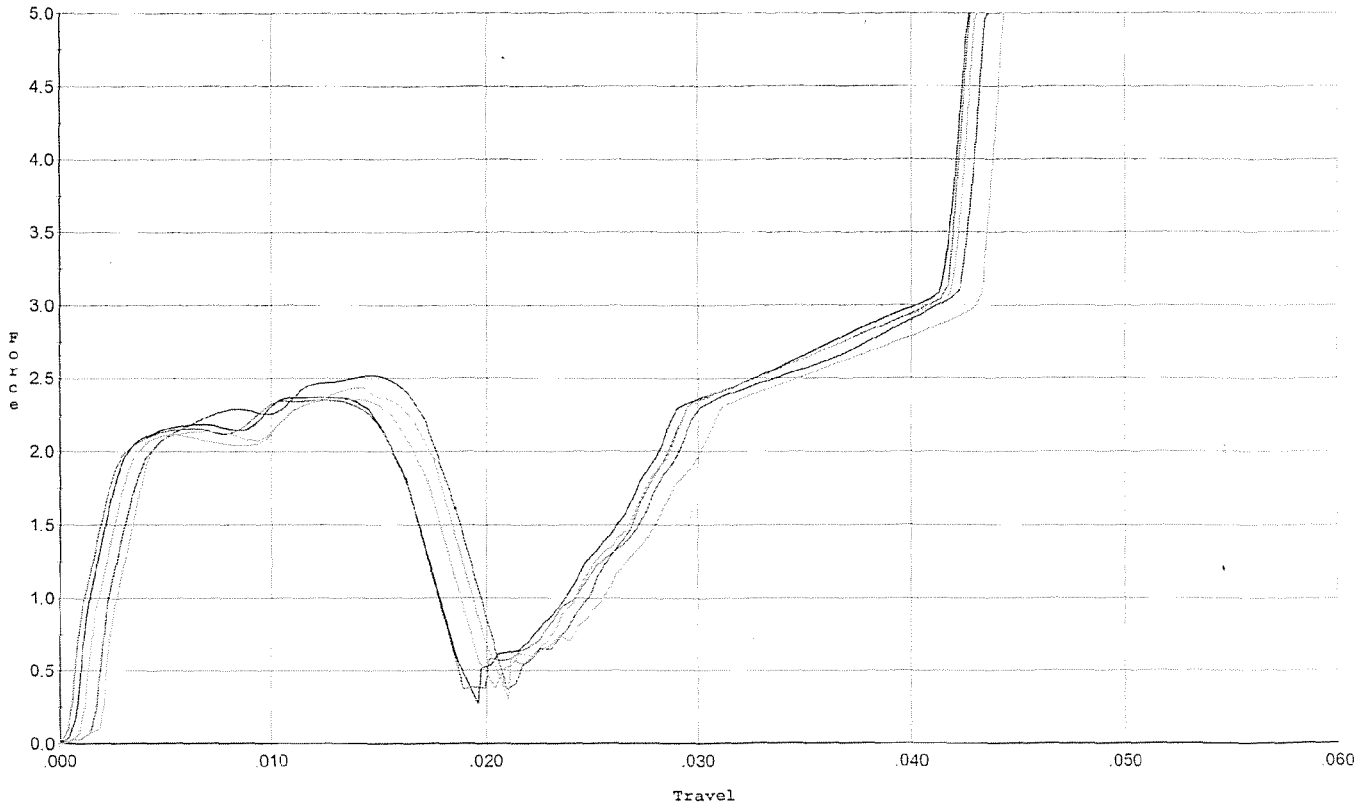
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	2-18-09	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	2-18-09	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.035</u> <u>.035</u> <u>.035</u>	2-18-09	RJ
	J) ASSEMBLE STOCK		2-18-09	RJ
	K) ASSEMBLE SWIVEL STUDS		2-18-09	RJ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	2-18-09	TL
650	TARGET	<u>PASS</u> FAIL	2-14-09	RJ
	MALFUNCTION <u>BAC</u>	CORRECTION	2-18-09	TL
	MALFUNCTION <u>OH</u>	CORRECTION	2-18-09	TL
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-14-09	TL
670	FINAL INSPECTION A) HEADSPACE		2-18-09	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.30</u> <u>2.35</u> <u>2.35</u> <u>2.35</u>	2-16-09	WV
	C) FUNCTION		2-18-09	RJ
690	PACK		3/4/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .75 lb



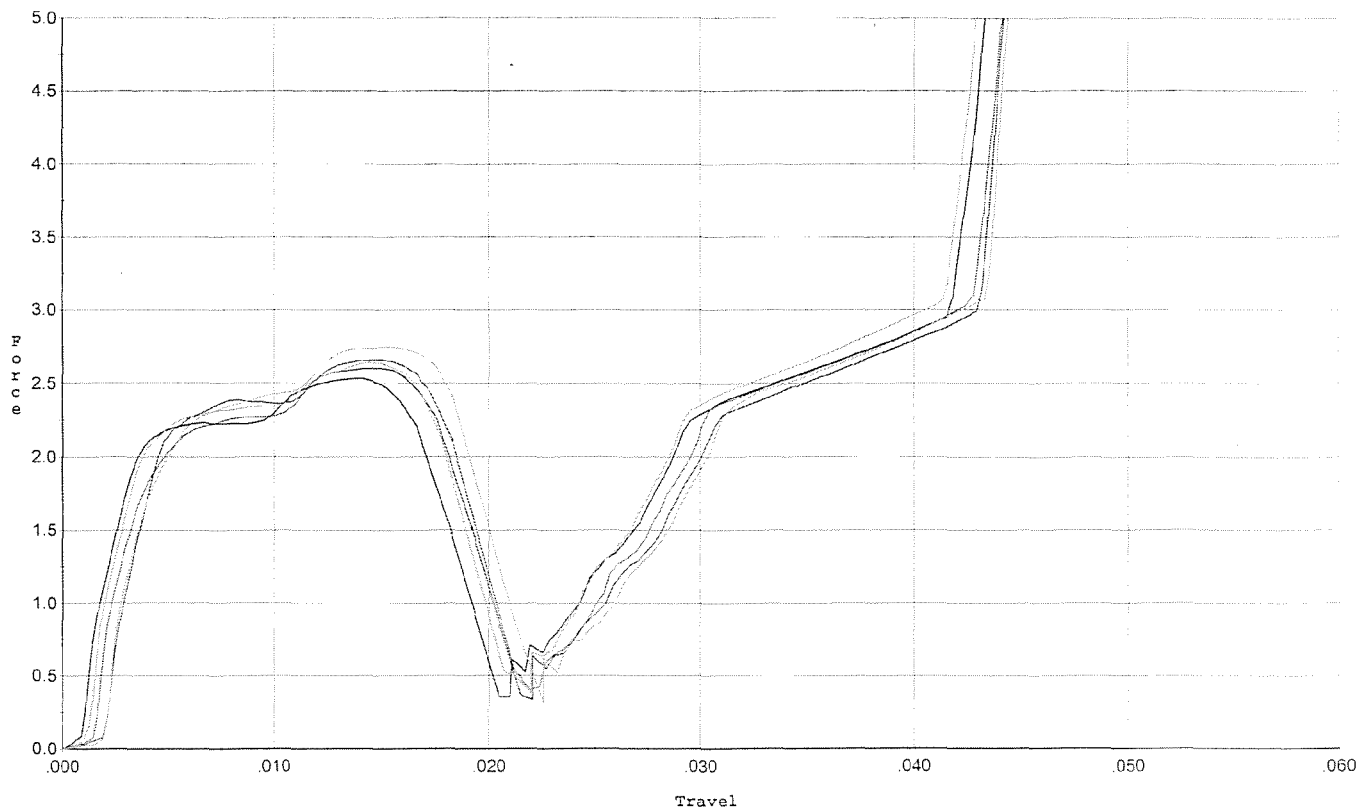
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.019	0.00	0.029	0.034		Set Trigger
2	2.371	0.016	0.00	0.030	0.030		Set Trigger
3	2.351	0.016	0.00	0.030	0.030		Set Trigger
4	2.354	0.017	0.00	0.030	0.031		Set Trigger
5	2.436	0.018	0.00	0.031	0.031		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs after 50 cycles +/- .75 lb



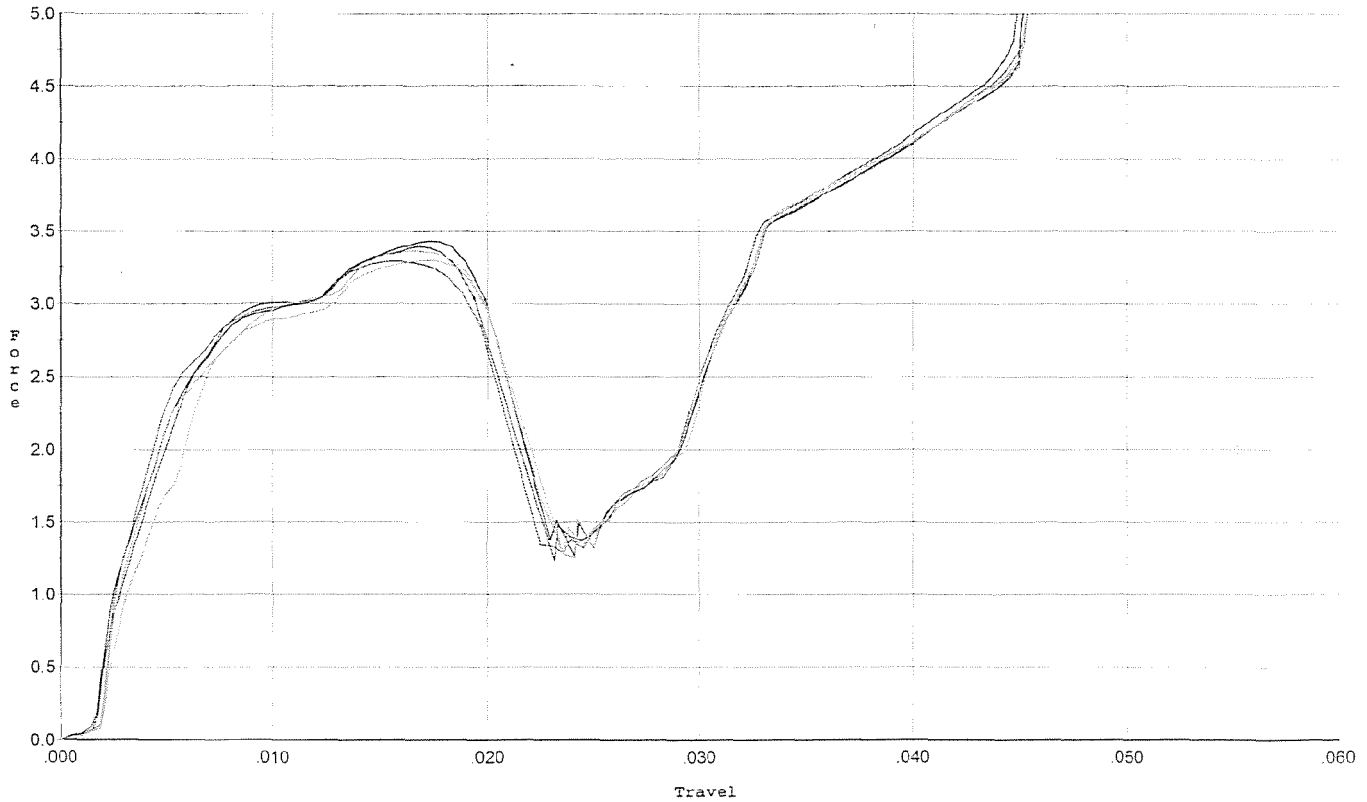
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.601	0.019	0.00	0.030	0.036		Set Trigger
2	2.536	0.018	0.00	0.030	0.035		Set Trigger
3	2.662	0.018	0.00	0.029	0.035		Set Trigger
4	2.747	0.018	0.00	0.030	0.035		Set Trigger
5	2.643	0.018	0.00	0.029	0.034		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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



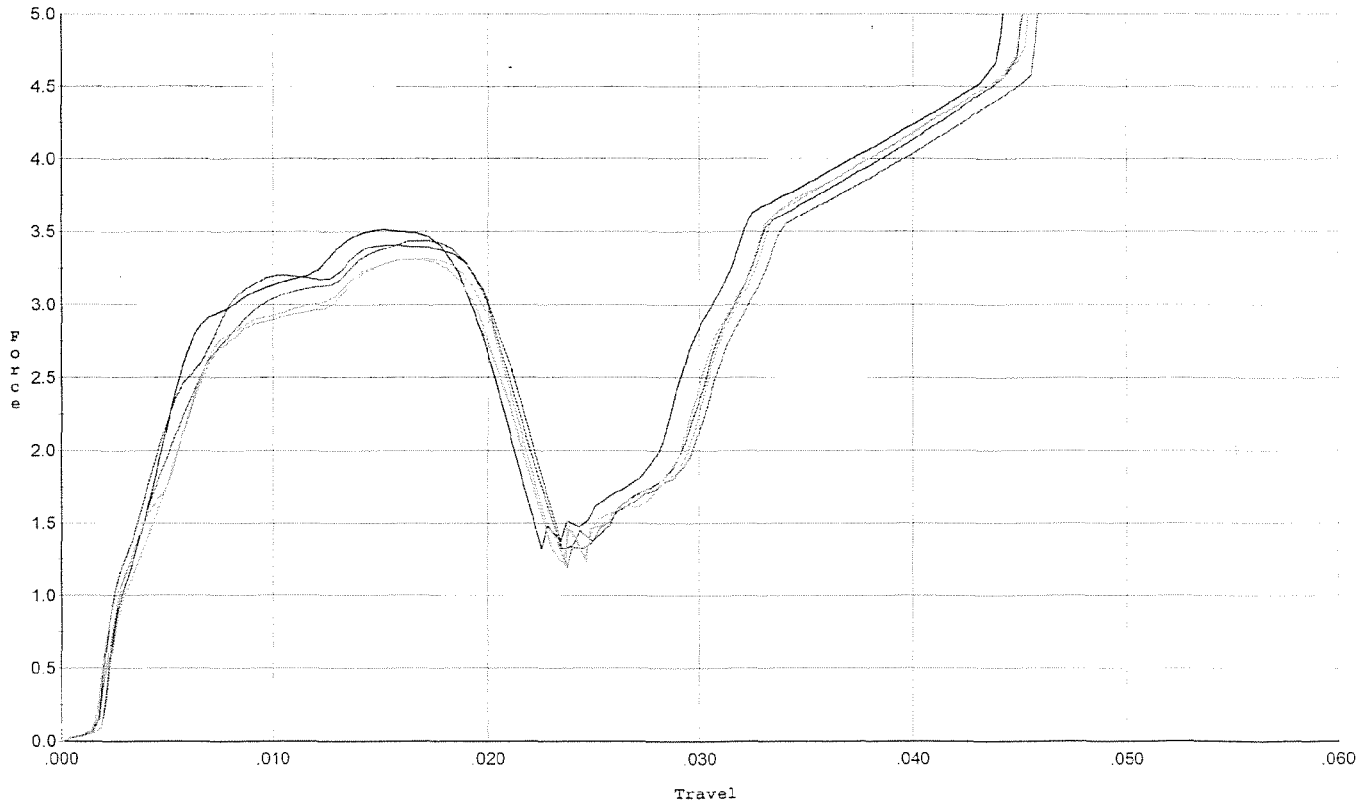
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.396	0.019	0.00	0.028	0.045		Set Trigger
2	3.431	0.020	0.00	0.028	0.047		Set Trigger
3	3.293	0.020	0.00	0.029	0.046		Set Trigger
4	3.300	0.020	0.00	0.028	0.046		Set Trigger
5	3.366	0.022	0.00	0.028	0.049		Set Trigger

A-3-35

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



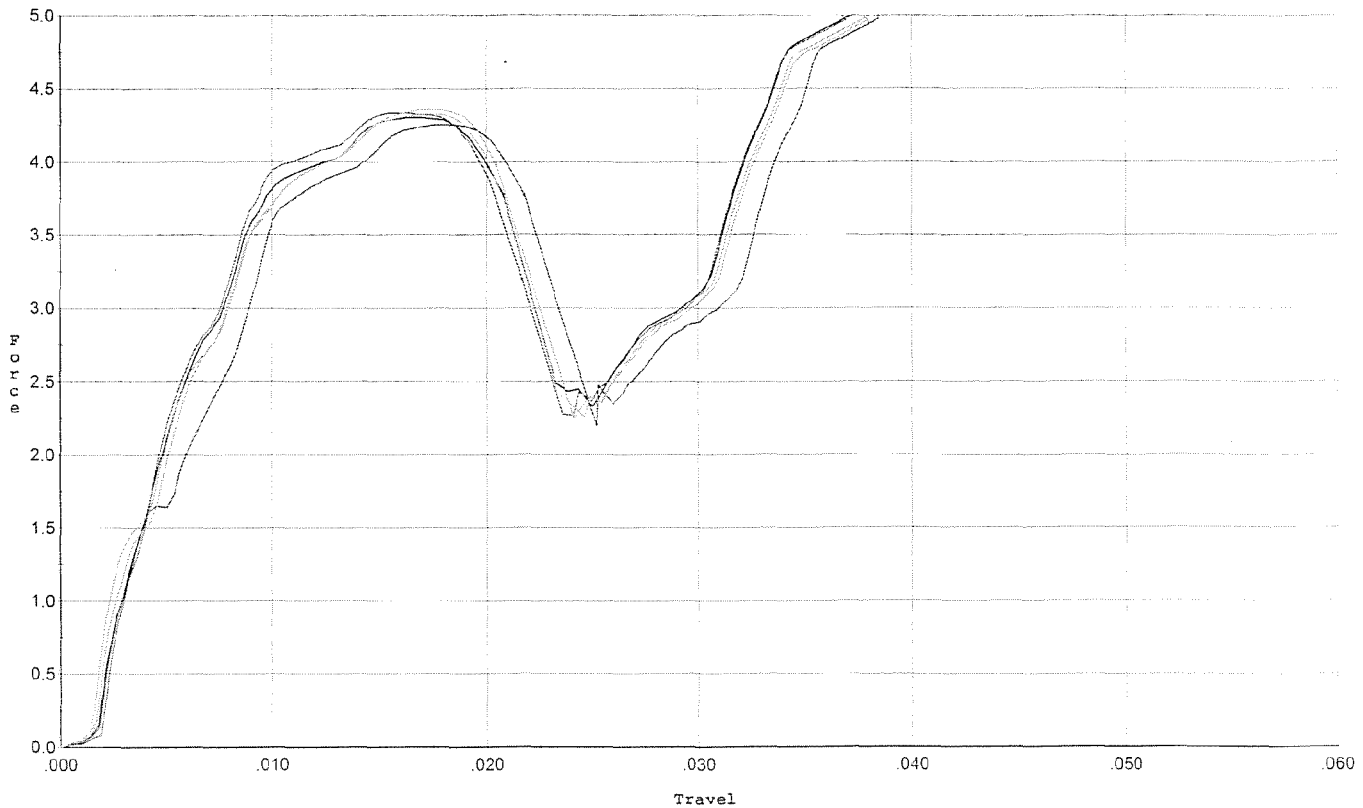
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.408	0.021	0.00	0.027	0.051		Set Trigger
2	3.514	0.020	0.00	0.027	0.047		Set Trigger
3	3.434	0.020	0.00	0.029	0.046		Set Trigger
4	3.316	0.020	0.00	0.028	0.045		Set Trigger
5	3.306	0.021	0.00	0.028	0.047		Set Trigger

A.3.39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



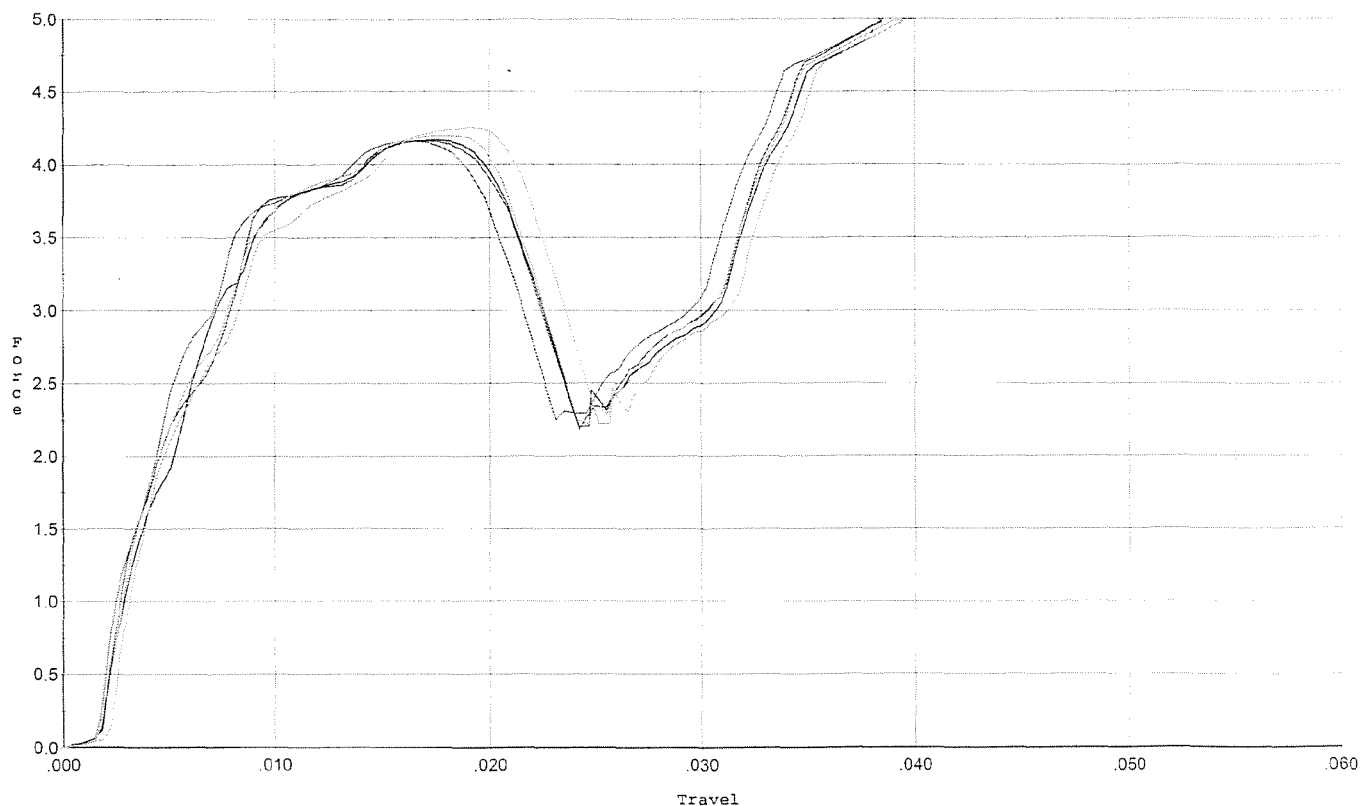
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.251	0.022	0.00	0.025	0.060		Set Trigger
2	4.302	0.021	0.00	0.025	0.059		Set Trigger
3	4.335	0.022	0.00	0.025	0.062		Set Trigger
4	4.328	0.021	0.00	0.025	0.059		Set Trigger
5	4.358	0.020	0.00	0.026	0.058		Set Trigger

A-4-31

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/5/2009

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



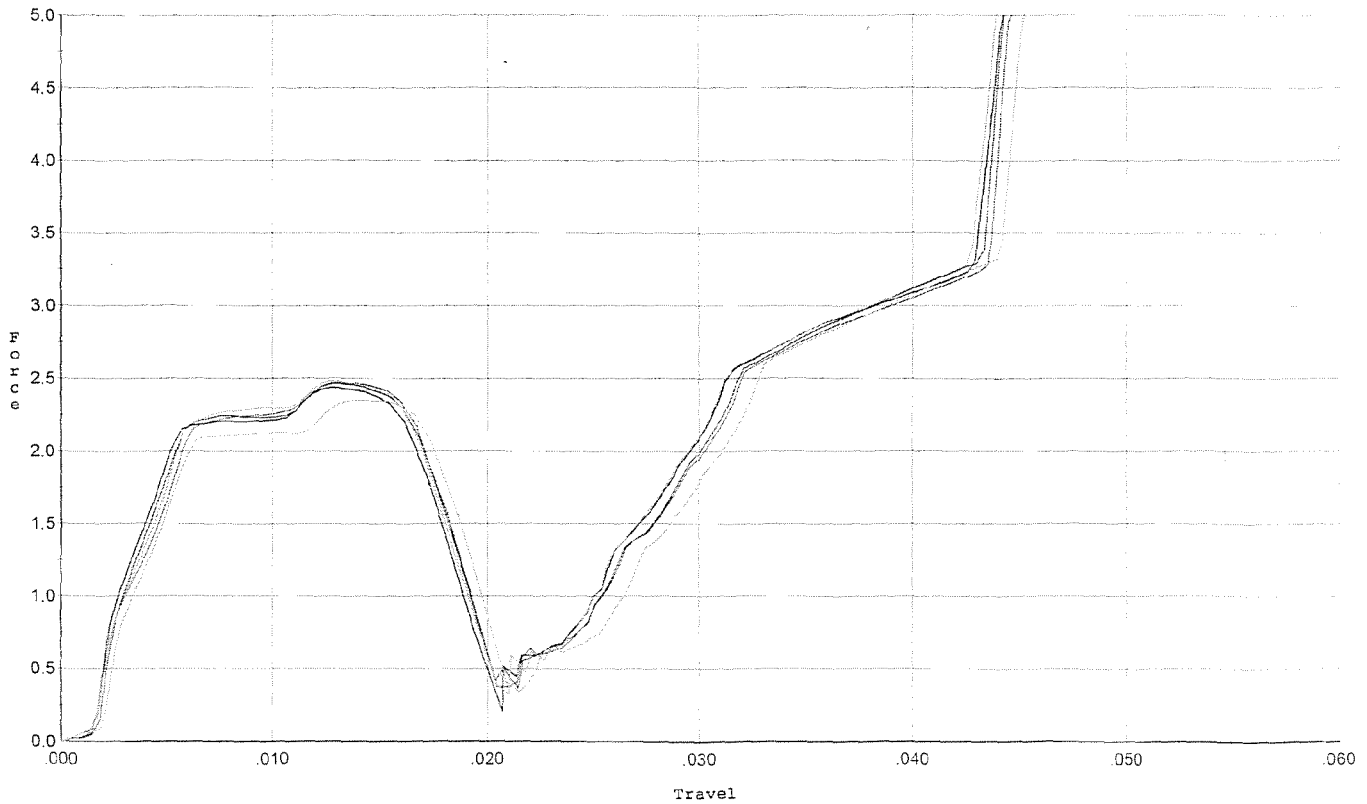
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.021	0.00	0.026	0.058		Set Trigger
2	4.168	0.022	0.00	0.026	0.062		Set Trigger
3	4.159	0.021	0.00	0.026	0.059		Set Trigger
4	4.254	0.023	0.00	0.026	0.065		Set Trigger
5	4.199	0.022	0.00	0.026	0.062		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 2/5/2009

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



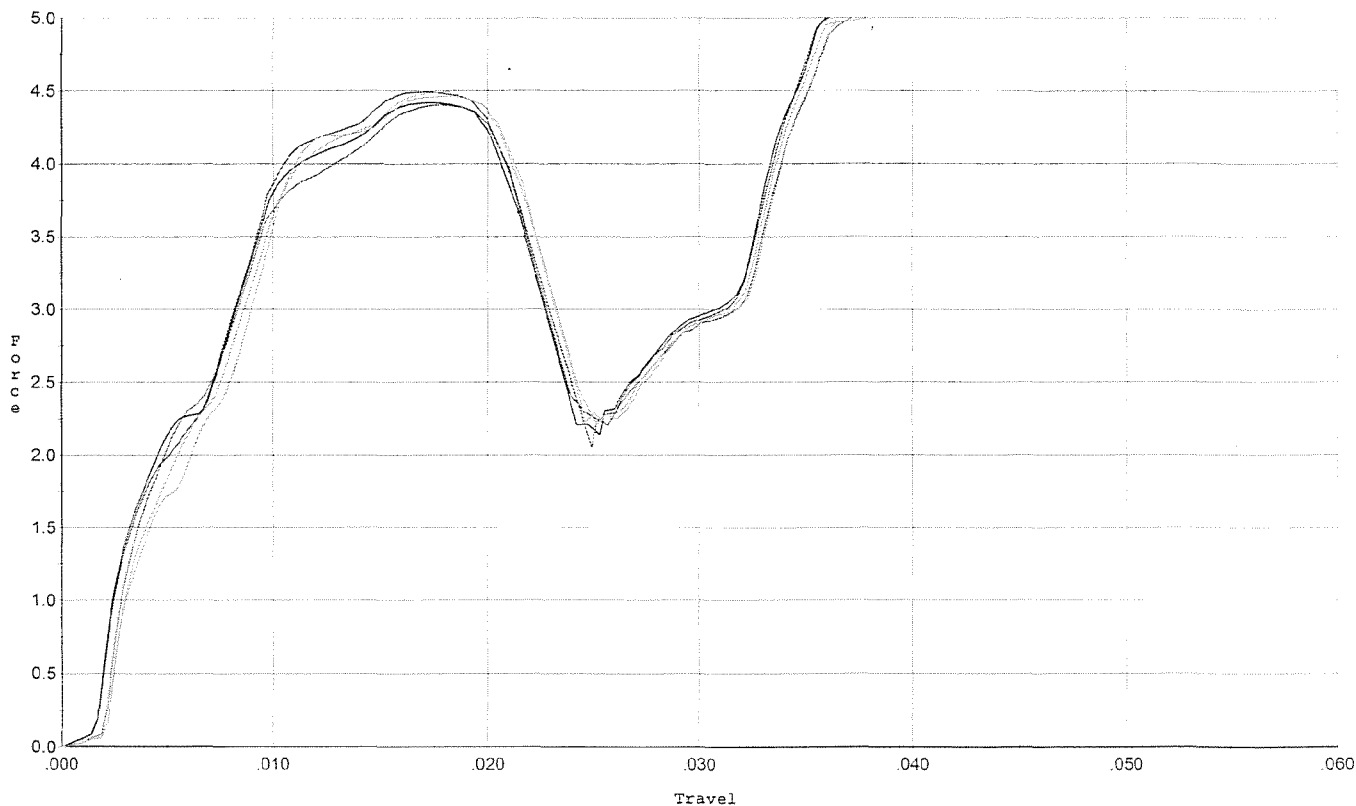
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.463	0.018	0.00	0.030	0.031		Set Trigger
2	2.440	0.017	0.00	0.031	0.030		Set Trigger
3	2.472	0.018	0.00	0.031	0.031		Set Trigger
4	2.350	0.019	0.00	0.031	0.030		Set Trigger
5	2.483	0.017	0.00	0.031	0.029		Set Trigger

A.2.44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/5/2009

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	4.492	0.021	0.00	0.026	0.061		Set Trigger
2	4.421	0.021	0.00	0.026	0.062		Set Trigger
3	4.405	0.021	0.00	0.026	0.059		Set Trigger
4	4.494	0.022	0.00	0.026	0.062		Set Trigger
5	4.463	0.022	0.00	0.026	0.061		Set Trigger

A-4.45