

G6810450

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

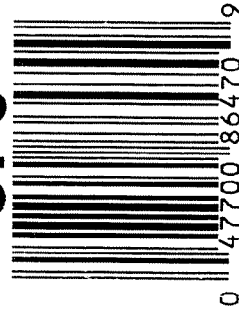
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810450

UPC



GUN SERIAL #

G-6810450

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-9-09	SP
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		2-9-09	SP
460	CHECK HEADSPACE		2-9-09	SP
470	DIS-ASSEMBLE ACTION		2-9-09	SP
472	SERIALIZE BOLT HANDLE		2-10-09	RT
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (AS)	2/13/09	AS
490	MAGNAFLUX BOLT		2/13/09	
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DE
542	APPLY COATINGS (BARREL ACTION)		2/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-18-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

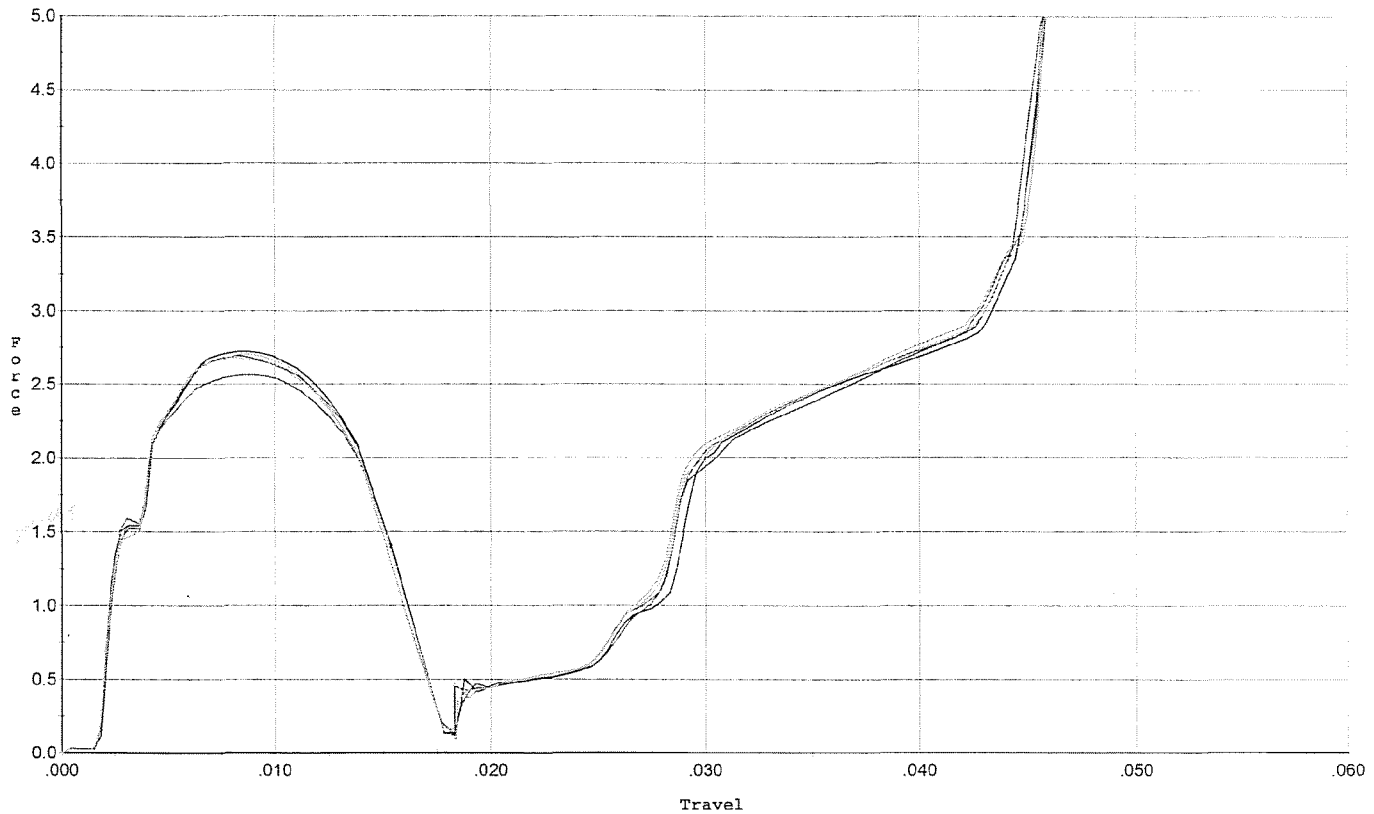
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>4.5</u>	2-27-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>3.5</u> <u>4</u>	2-27-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.032</u> <u>.032</u> <u>.032</u>	2-27-09	WW
	J) ASSEMBLE STOCK		2-18-09	LPD
	K) ASSEMBLE SWIVEL STUDS		2-27-09	WW
	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	2-23-09	LPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-23-09	RP
670	FINAL INSPECTION A) HEADSPACE		2-27-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.24</u> <u>2.31</u> <u>2.39</u> <u>2.41</u>	2-24-09	WW
	C) FUNCTION		2-27-09	WW
690	PACK		3-6-09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



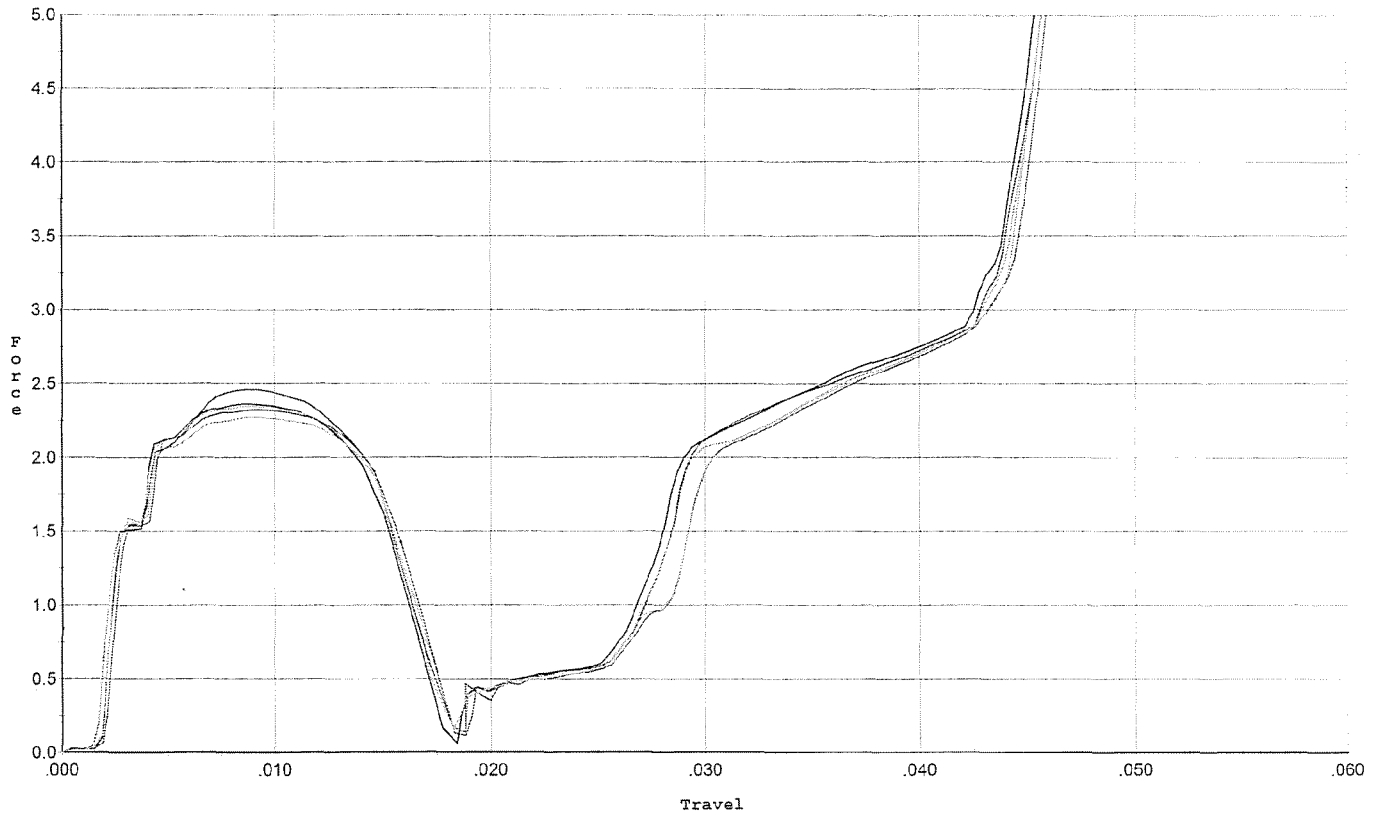
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.693	0.015	0.002	0.035	0.028		Set Trigger
2	2.724	0.015	0.002	0.035	0.028		Set Trigger
3	2.564	0.014	0.002	0.035	0.025		Set Trigger
4	2.702	0.016	0.002	0.035	0.028		Set Trigger
5	2.679	0.014	0.002	0.035	0.026		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



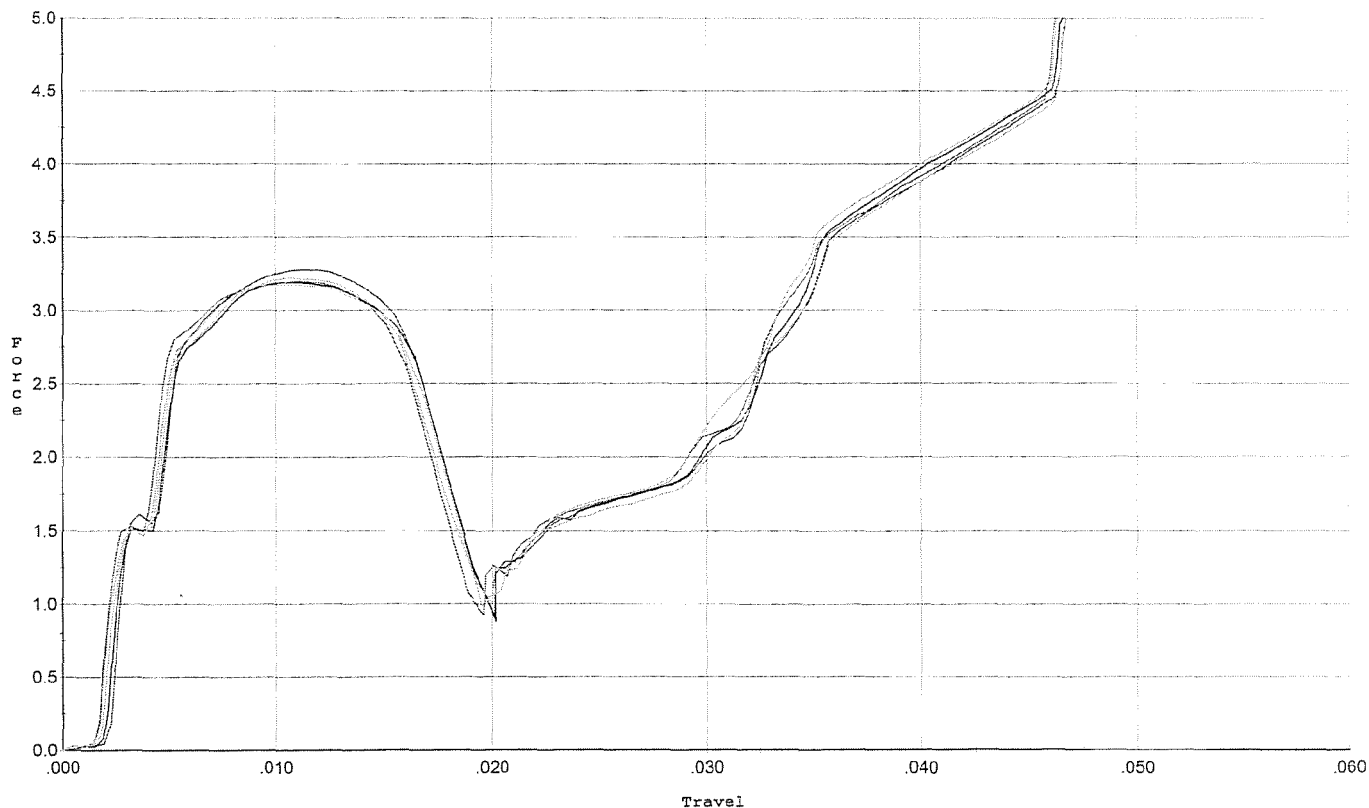
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.015	0.002	0.034	0.025		Set Trigger
2	2.361	0.015	0.00	0.034	0.026		Set Trigger
3	2.323	0.016	0.002	0.034	0.026		Set Trigger
4	2.347	0.015	0.00	0.034	0.025		Set Trigger
5	2.275	0.016	0.002	0.034	0.027		Set Trigger

A-2-35

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



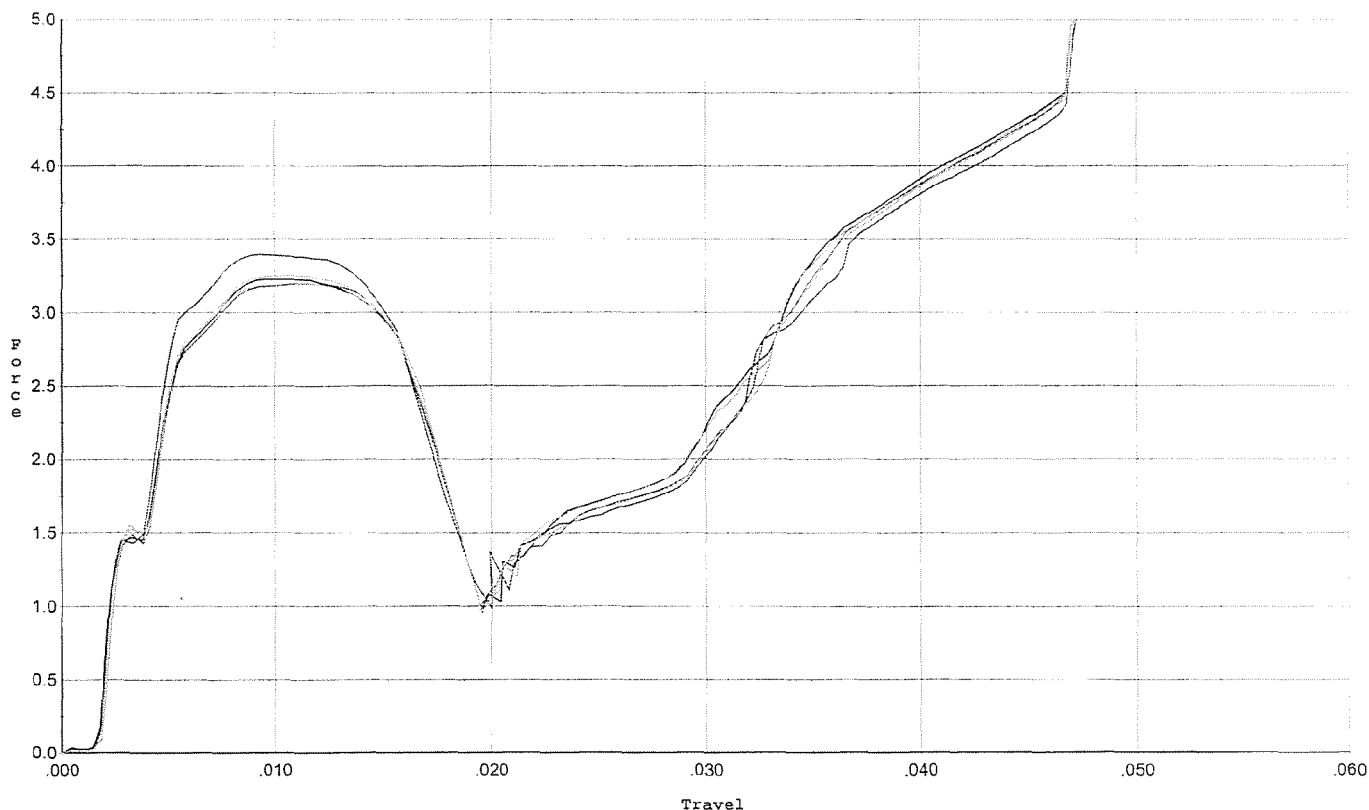
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.016	0.00	0.032	0.036		Set Trigger
2	3.190	0.016	0.002	0.032	0.036		Set Trigger
3	3.199	0.016	0.00	0.032	0.036		Set Trigger
4	3.223	0.017	0.00	0.032	0.037		Set Trigger
5	3.174	0.016	0.00	0.032	0.035		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



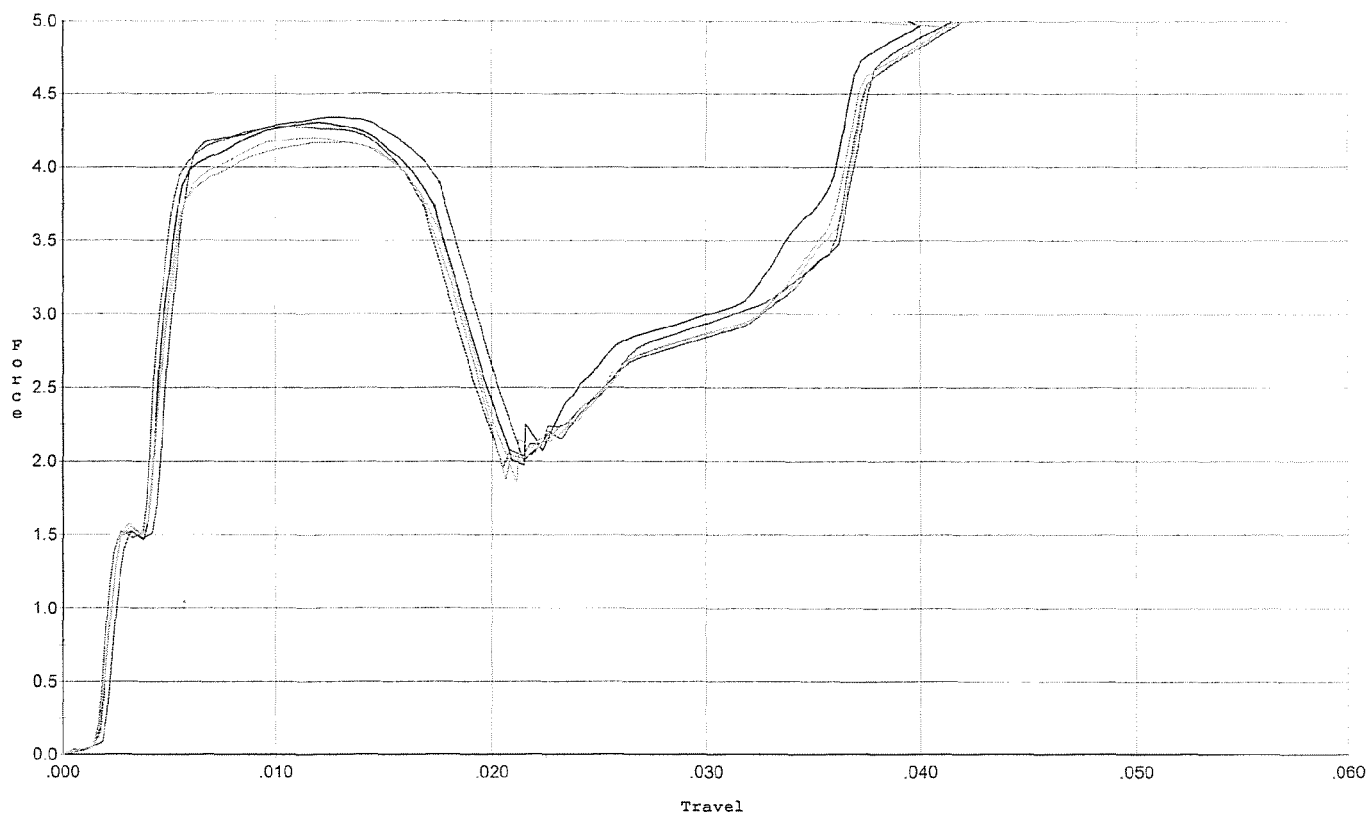
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.396	0.016	0.002	0.033	0.036		Set Trigger
2	3.226	0.017	0.00	0.032	0.038		Set Trigger
3	3.193	0.017	0.00	0.032	0.038		Set Trigger
4	3.252	0.017	0.00	0.033	0.037		Set Trigger
5	3.196	0.017	0.00	0.033	0.037		Set Trigger

A-3-25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



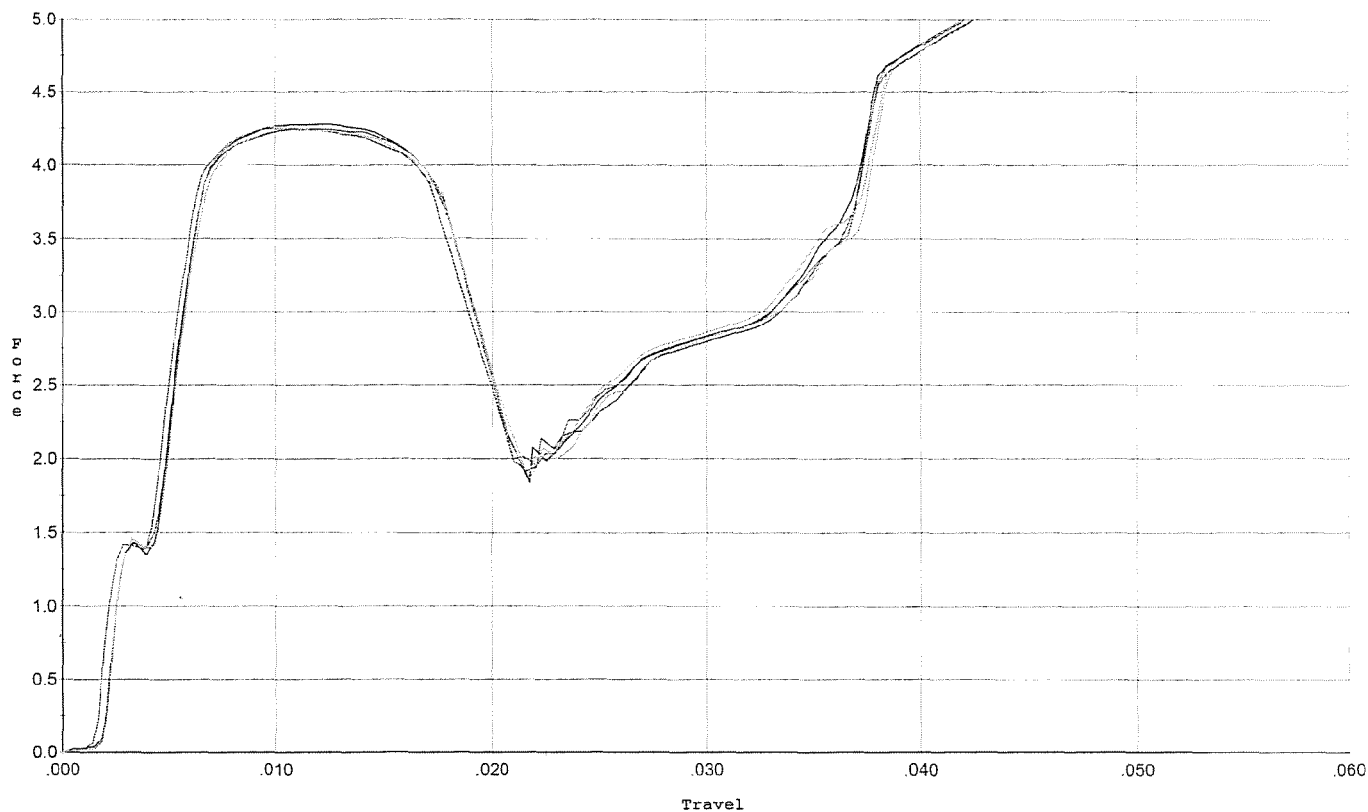
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.338	0.018	0.00	0.030	0.052		Set Trigger
2	4.302	0.017	0.00	0.029	0.051		Set Trigger
3	4.274	0.017	0.00	0.030	0.050		Set Trigger
4	4.196	0.018	0.00	0.030	0.051		Set Trigger
5	4.166	0.018	0.00	0.030	0.052		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



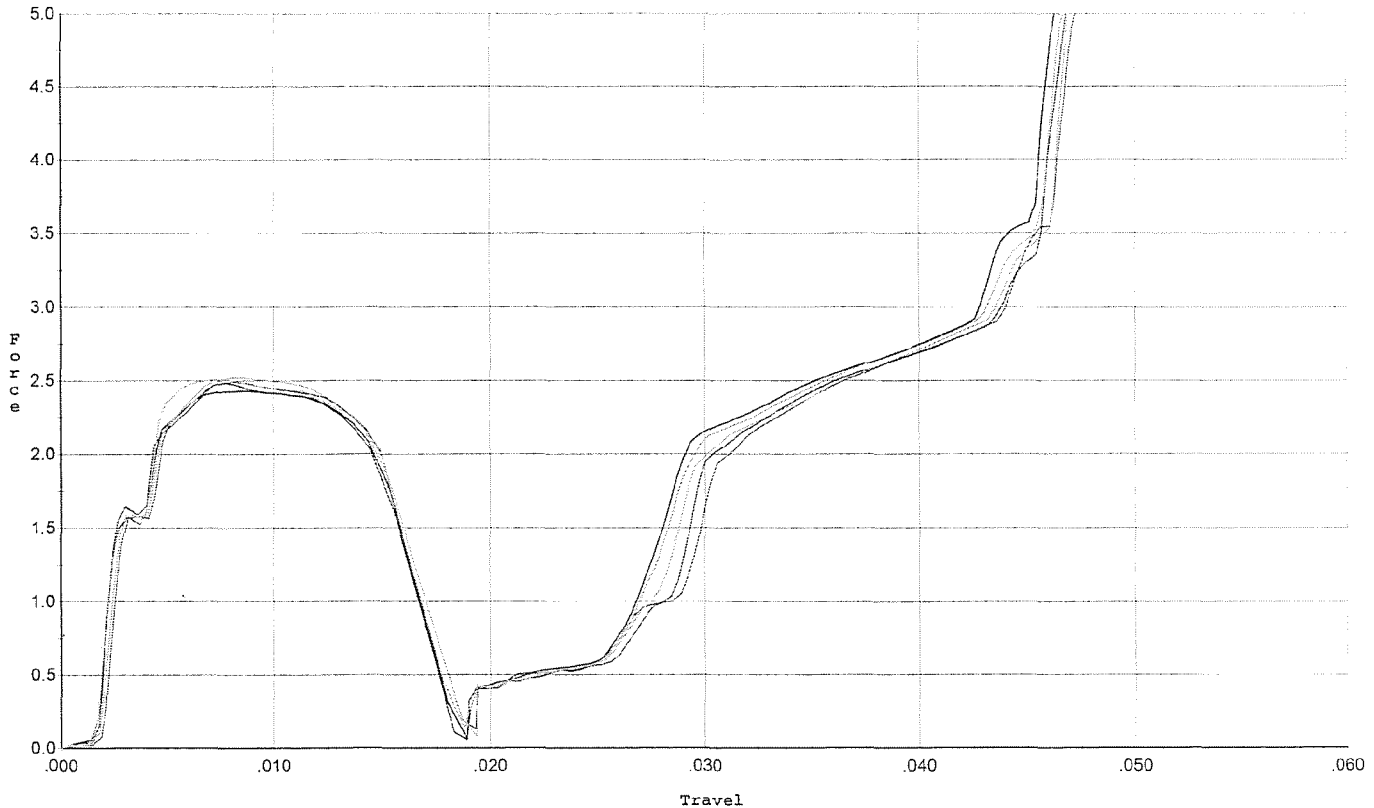
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.246	0.018	0.002	0.030	0.051		Set Trigger
2	4.275	0.018	0.00	0.030	0.051		Set Trigger
3	4.249	0.017	0.004	0.030	0.049		Set Trigger
4	4.262	0.018	0.00	0.030	0.051		Set Trigger
5	4.249	0.018	0.00	0.030	0.050		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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



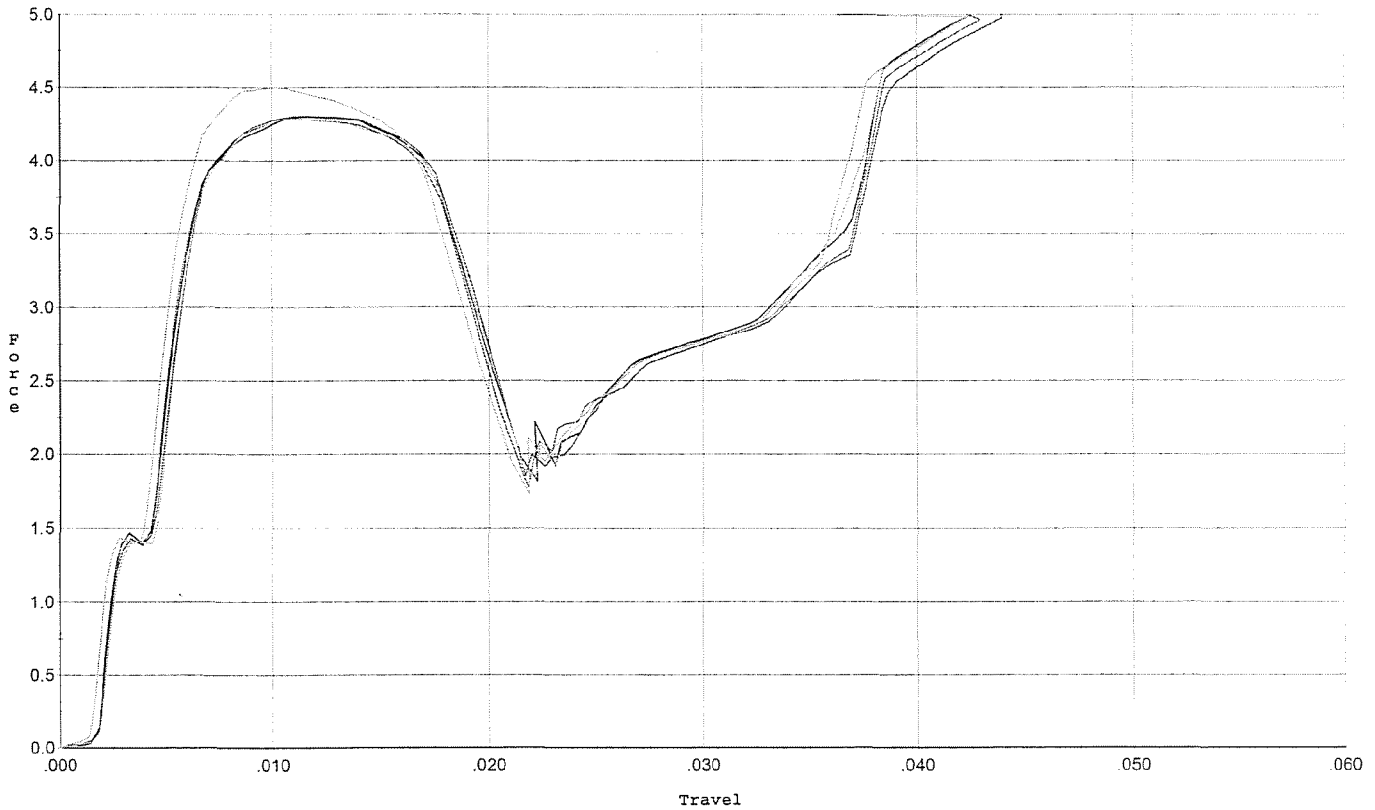
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.485	0.016	0.00	0.035	0.027		Set Trigger
2	2.430	0.015	0.00	0.035	0.027		Set Trigger
3	2.490	0.015	0.002	0.035	0.026		Se: Trigger
4	2.522	0.015	0.00	0.035	0.027		Set Trigger
5	2.508	0.015	0.00	0.035	0.027		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/16/2009

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	4.305	0.019	0.00	0.030	0.055		Set Trigger
2	4.299	0.018	0.00	0.030	0.051		Set Trigger
3	4.289	0.018	0.00	0.030	0.051		Set Trigger
4	4.288	0.019	0.005	0.029	0.056		Set Trigger
5	4.503	0.017	0.00	0.030	0.051		Set Trigger

A 4.33