

G6814691

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

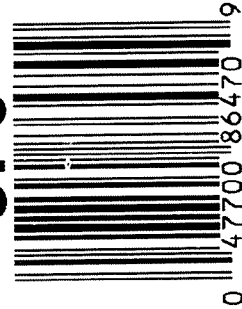
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6814691

UPC



GUN SERIAL #

G 681 4691

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-10-09	SPD
430	ASSEMBLE TO STOCK		2-10-09	SP
440	PROOF		2-10-09	SPD
460	CHECK HEADSPACE		2-10-09	SPD
470	DIS-ASSEMBLE ACTION		2-10-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	2-11-09	RT
475	DRILL AND TAP SIGHT HOLES	OPERATOR	2-11-09	TL
480	MAGNAFLUX BBL ACTION		2/13/09	SP
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		2-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-24-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

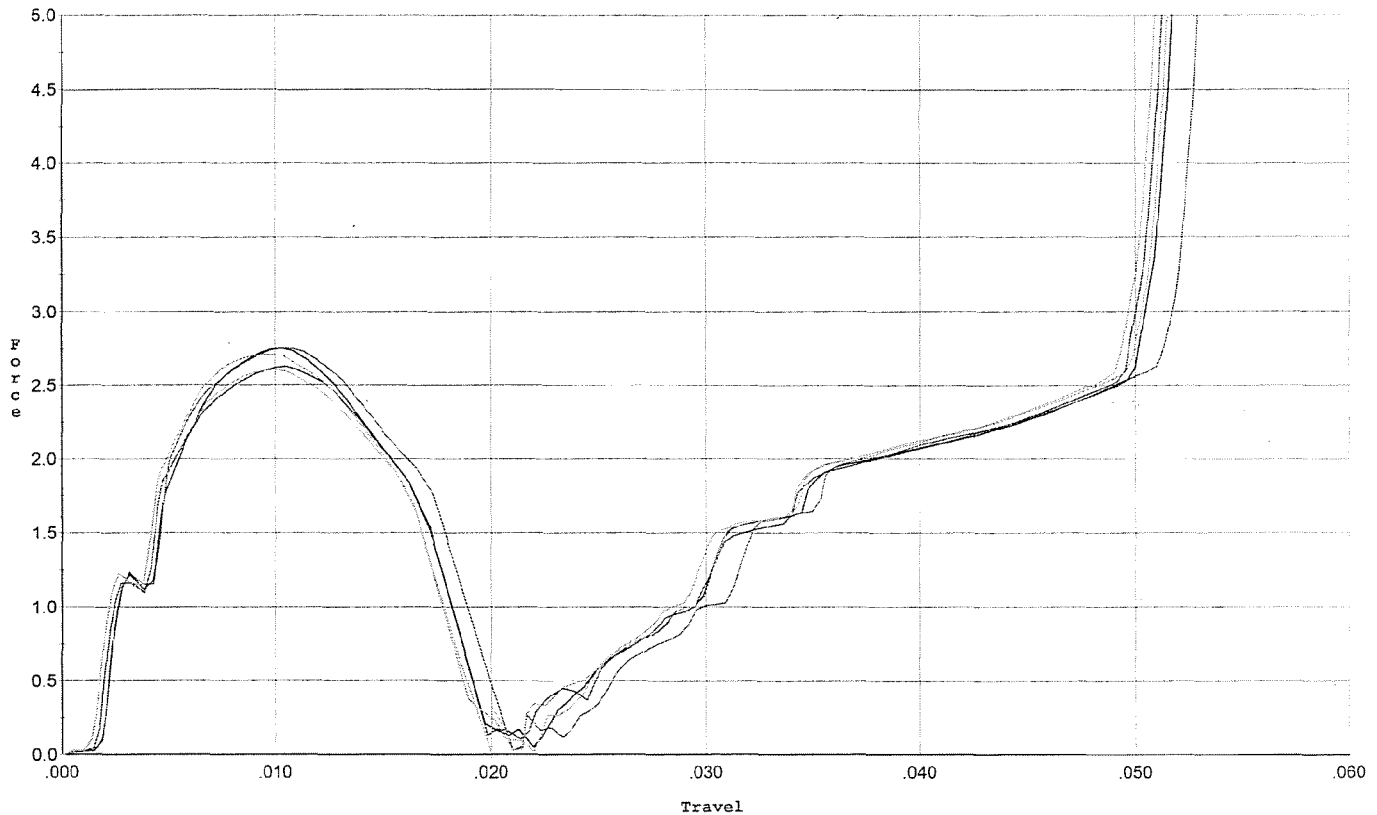
560	BARBER - M24 0131948		2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	2-26-09	RP		
CONT.										
	G) SAFETY OFF FORCE	2 LBS MIN		<u>60</u>	<u>60</u>	<u>60</u>	2-26-09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY									
	I) FIRING PIN INDENT	.020 MIN		<u>.022</u>	<u>.022</u>	<u>.022</u>	2-26-09	RP		
	J) ASSEMBLE STOCK						2-24-09	RP		
	K) ASSEMBLE SWIVEL STUDS						2-26-09	RP		
	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		2-25-09	RP		
	MALFUNCTION		CORRECTION	<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION	N/A						
	MALFUNCTION		CORRECTION							
	MALFUNCTION		CORRECTION							
660	INSPECT FOR LIVE AMMO						2-25-09	RP		
670	FINAL INSPECTION A) HEADSPACE						2-26-09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS		<u>2.72</u>	<u>2.67</u>	<u>2.61</u>	<u>2.71</u>	<u>2.65</u>	2-26-09	RP
	C) FUNCTION						2-26-09	RP		
690	PACK						3/2/09	Fry		

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



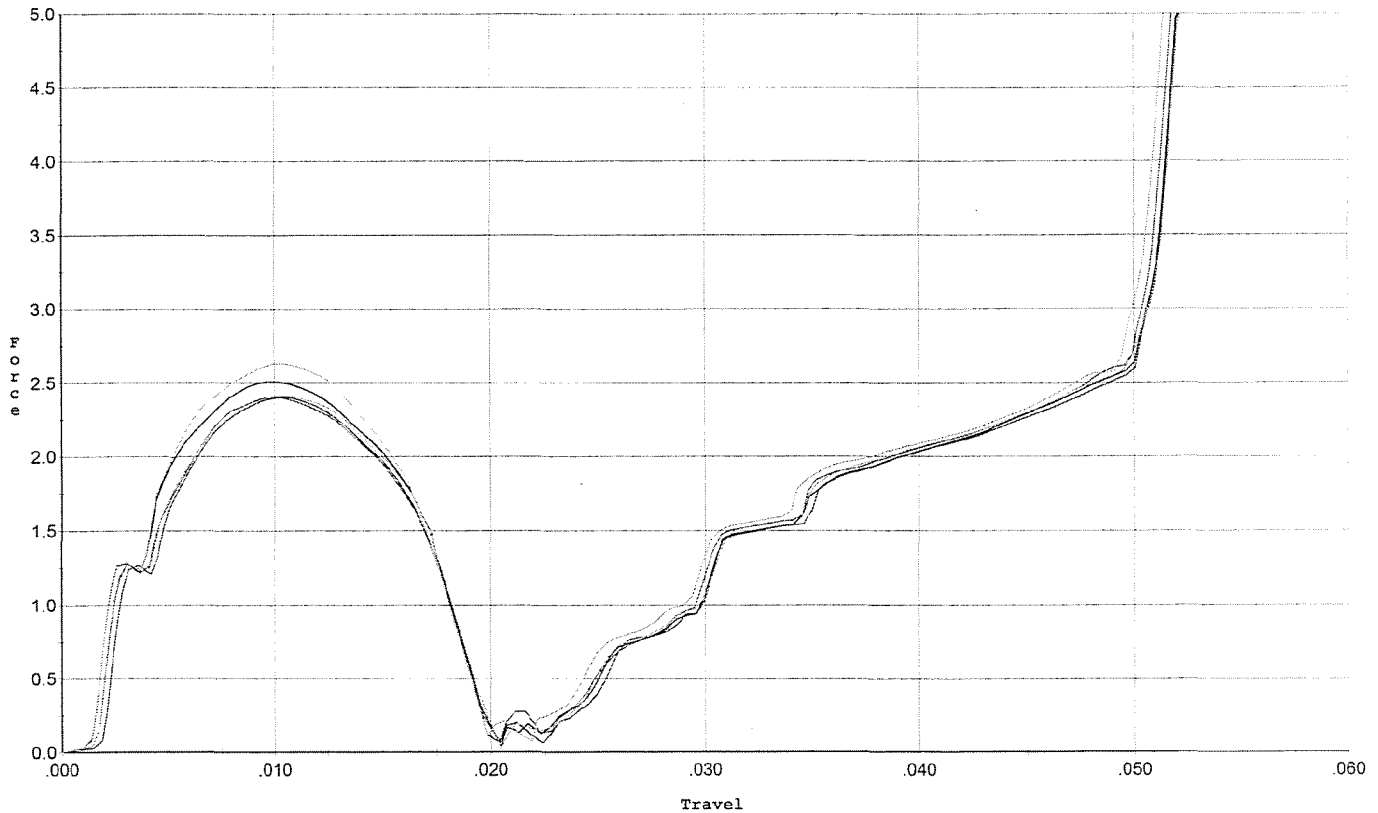
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.629	0.017	0.004	0.038	0.030		Set Trigger
2	2.755	0.017	0.00	0.039	0.030		Set Trigger
3	2.755	0.017	0.004	0.039	0.031		Set Trigger
4	2.606	0.016	0.004	0.039	0.029		Set Trigger
5	2.711	0.016	0.00	0.038	0.030		Set Trigger

A-2-69

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



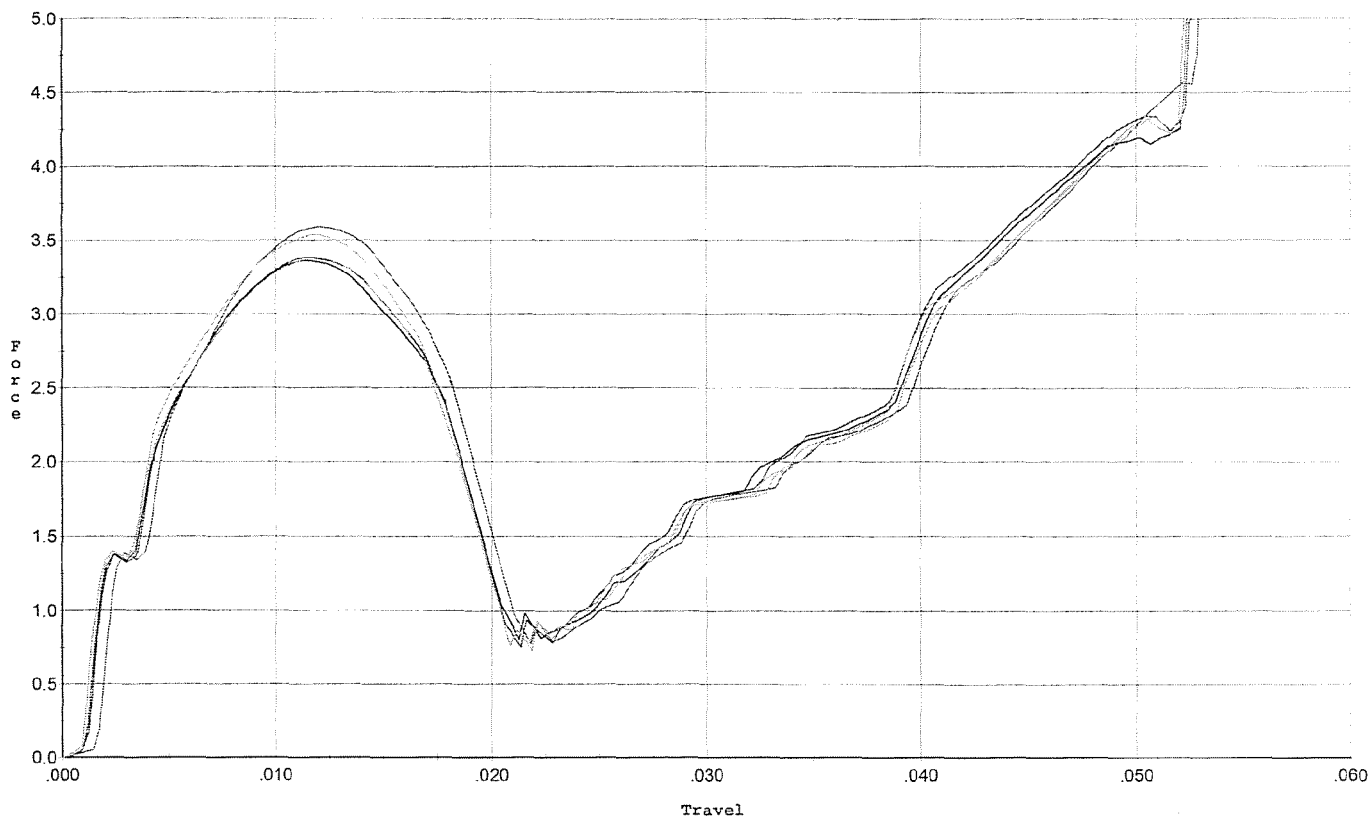
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.407	0.018	0.00	0.039	0.028		Set Trigger
2	2.511	0.017	0.00	0.039	0.030		Set Trigger
3	2.404	0.017	0.00	0.039	0.029		Set Trigger
4	2.631	0.018	0.00	0.038	0.031		Set Trigger
5	2.414	0.017	0.004	0.039	0.028		Set Trigger

A-2-47

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 lbs



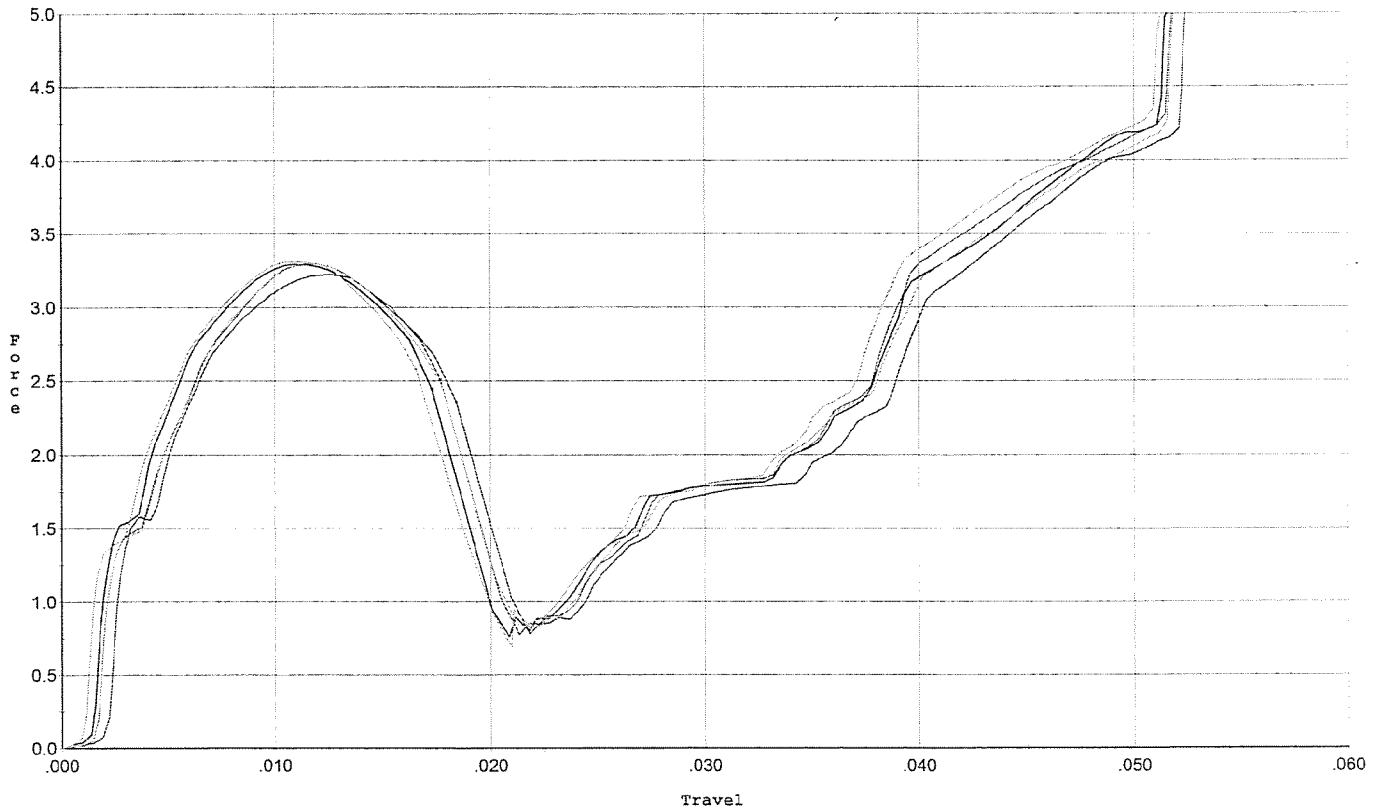
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.382	0.018	0.00	0.037	0.041		Set Trigger
2	3.365	0.018	0.00	0.037	0.041		Set Trigger
3	3.591	0.018	0.00	0.037	0.043		Set Trigger
4	3.535	0.018	0.00	0.037	0.043		Set Trigger
5	3.372	0.018	0.00	0.037	0.043		Set Trigger

A-3.44

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 lbs



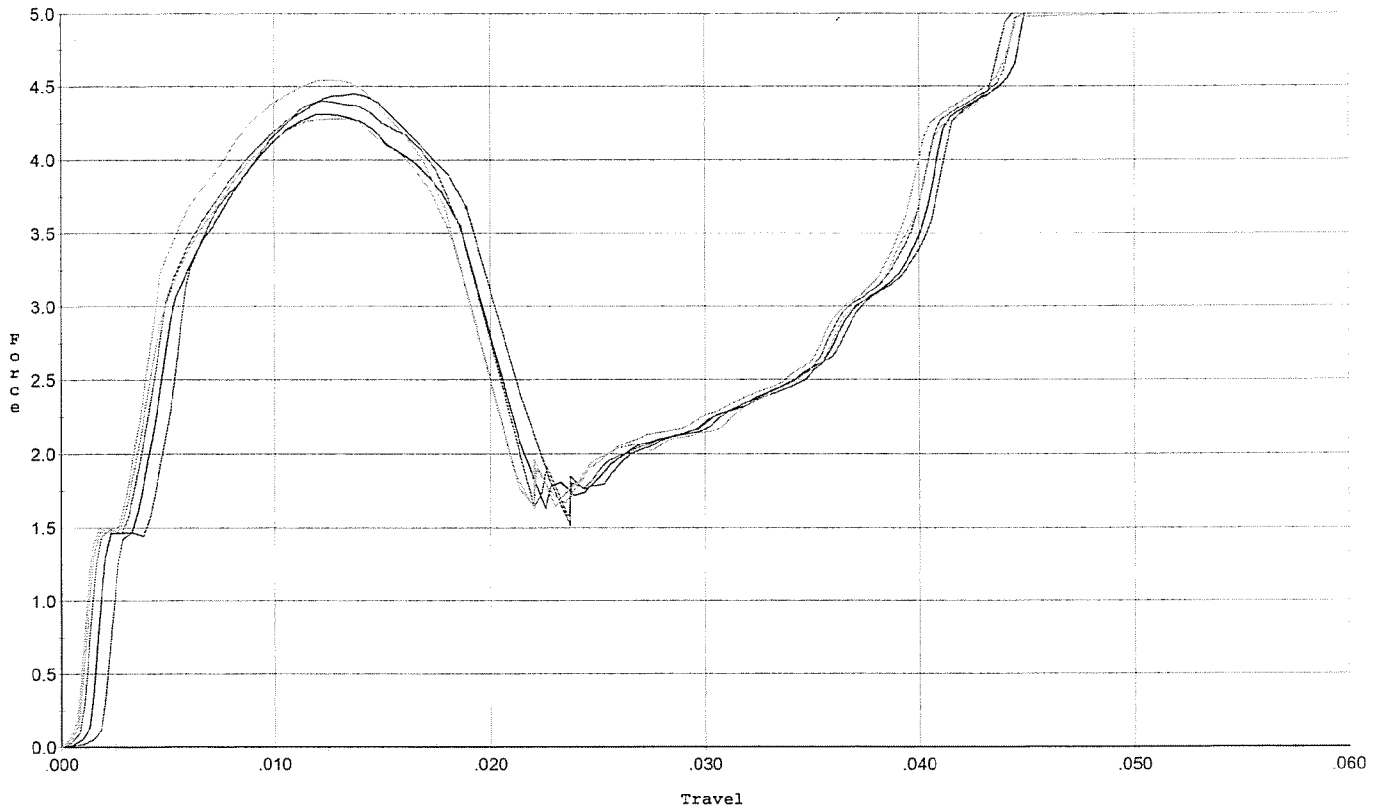
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.223	0.018	0.00	0.037	0.040		Set Trigger
2	3.294	0.017	0.00	0.037	0.039		Set Trigger
3	3.296	0.018	0.00	0.036	0.039		Set Trigger
4	3.299	0.018	0.00	0.036	0.039		Set Trigger
5	3.310	0.017	0.00	0.037	0.038		Set Trigger

A-5-28

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



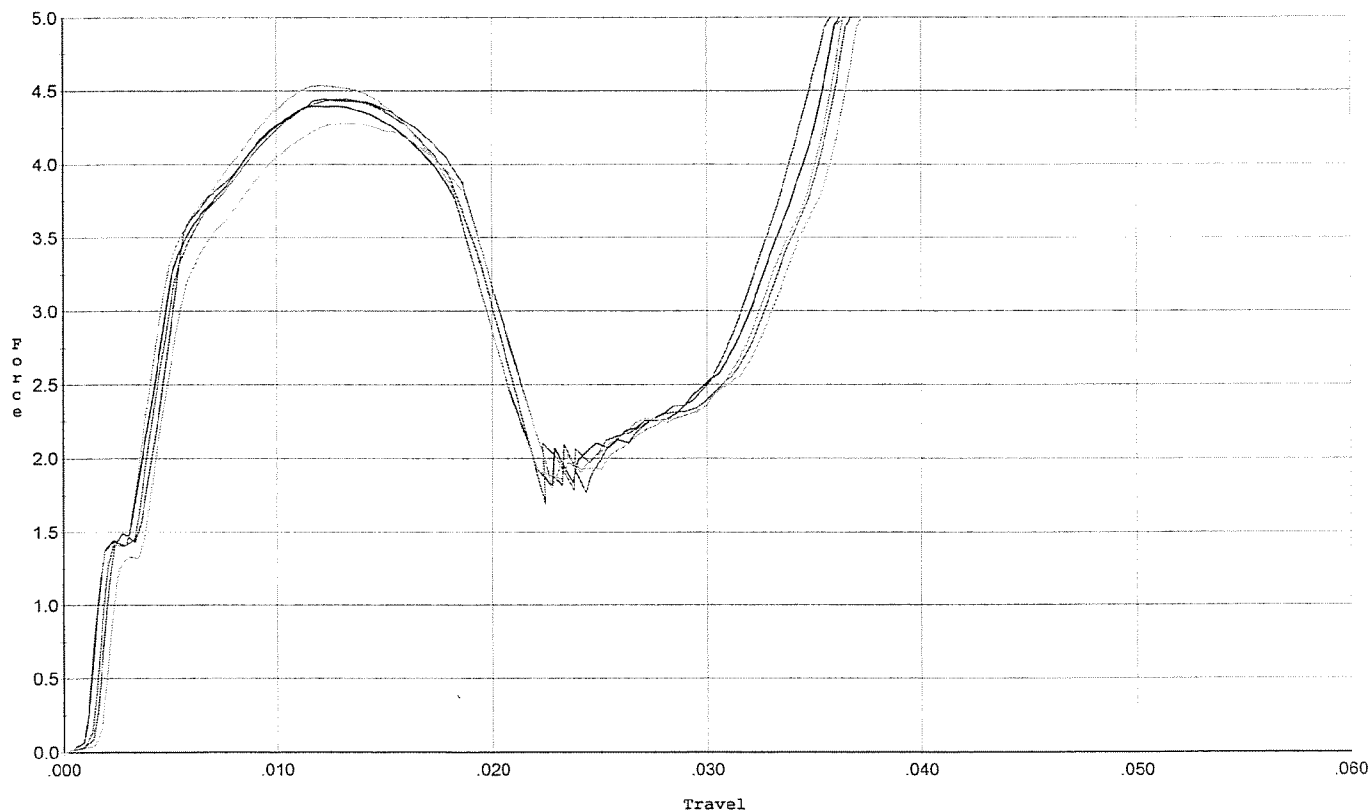
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.448	0.019	0.00	0.028	0.055		Set Trigger
2	4.310	0.019	0.004	0.028	0.054		Set Trigger
3	4.400	0.019	0.00	0.028	0.056		Set Trigger
4	4.543	0.018	0.00	0.028	0.056		Set Trigger
5	4.280	0.018	0.00	0.028	0.054		Set Trigger

A-4-39

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



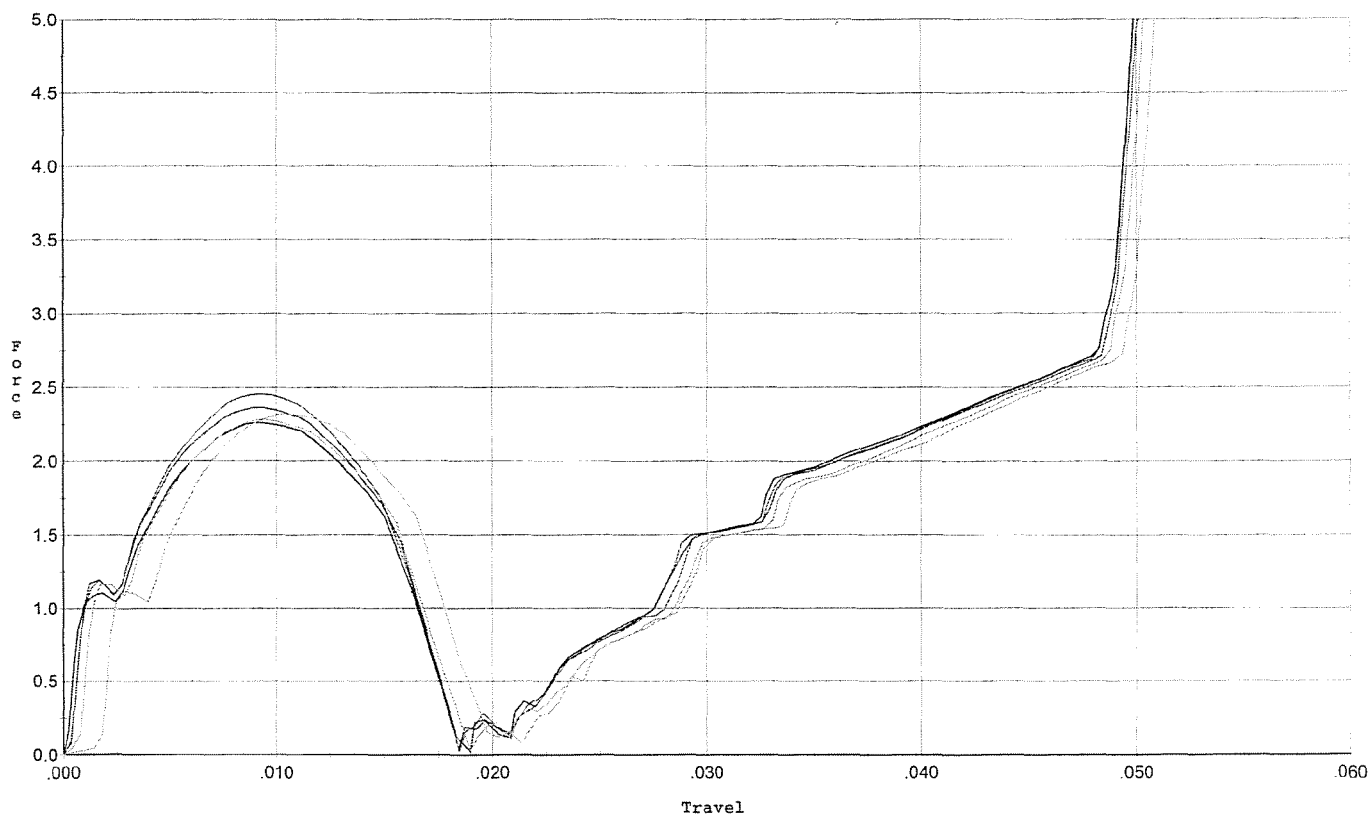
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.442	0.019	0.00	0.015	0.056		Set Trigger
2	4.396	0.018	0.00	0.016	0.055		Set Trigger
3	4.441	0.019	0.00	0.016	0.059		Set Trigger
4	4.277	0.021	0.00	0.016	0.060		Set Trigger
5	4.535	0.018	0.00	0.017	0.056		Set Trigger

A-4.41

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 2.5 lbs +/- .50 lb for final test



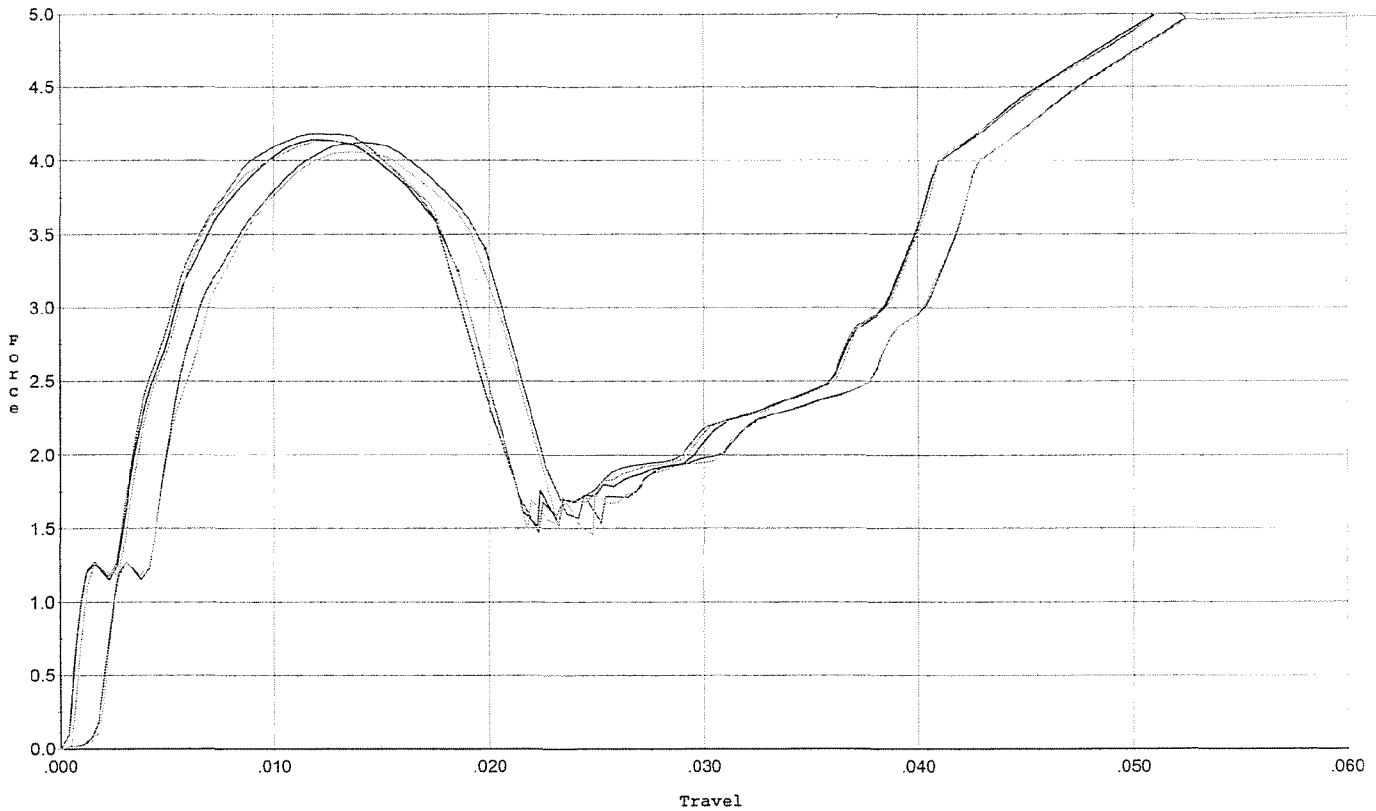
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.361	0.016	0.00	0.038	0.027		Set Trigger
2	2.260	0.016	0.00	0.038	0.027		Set Trigger
3	2.455	0.016	0.00	0.039	0.028		Set Trigger
4	2.320	0.017	0.004	0.038	0.026		Set Trigger
5	2.280	0.016	0.003	0.039	0.026		Set Trigger

A-2-33

Trigger Profile [lbs,inch]

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

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	4.120	0.020	0.00	0.034	0.054		Set Trigger
2	4.139	0.019	0.00	0.034	0.054		Set Trigger
3	4.179	0.018	0.00	0.035	0.051		Set Trigger
4	4.055	0.021	0.00	0.035	0.055		Set Trigger
5	4.130	0.019	0.003	0.034	0.053		Set Trigger

A-4.12