

66814693

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

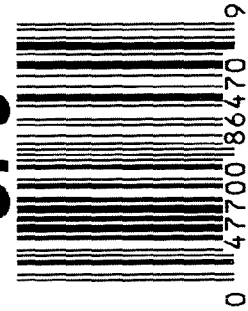
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6814693

UPC



GUN SERIAL #

G 6814693

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	2-11-09	RIZ
475	DRILL AND TAP SIGHT HOLES		2-11-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/13/09	
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DG
542	APPLY COATINGS (BARREL ACTION)		2/20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

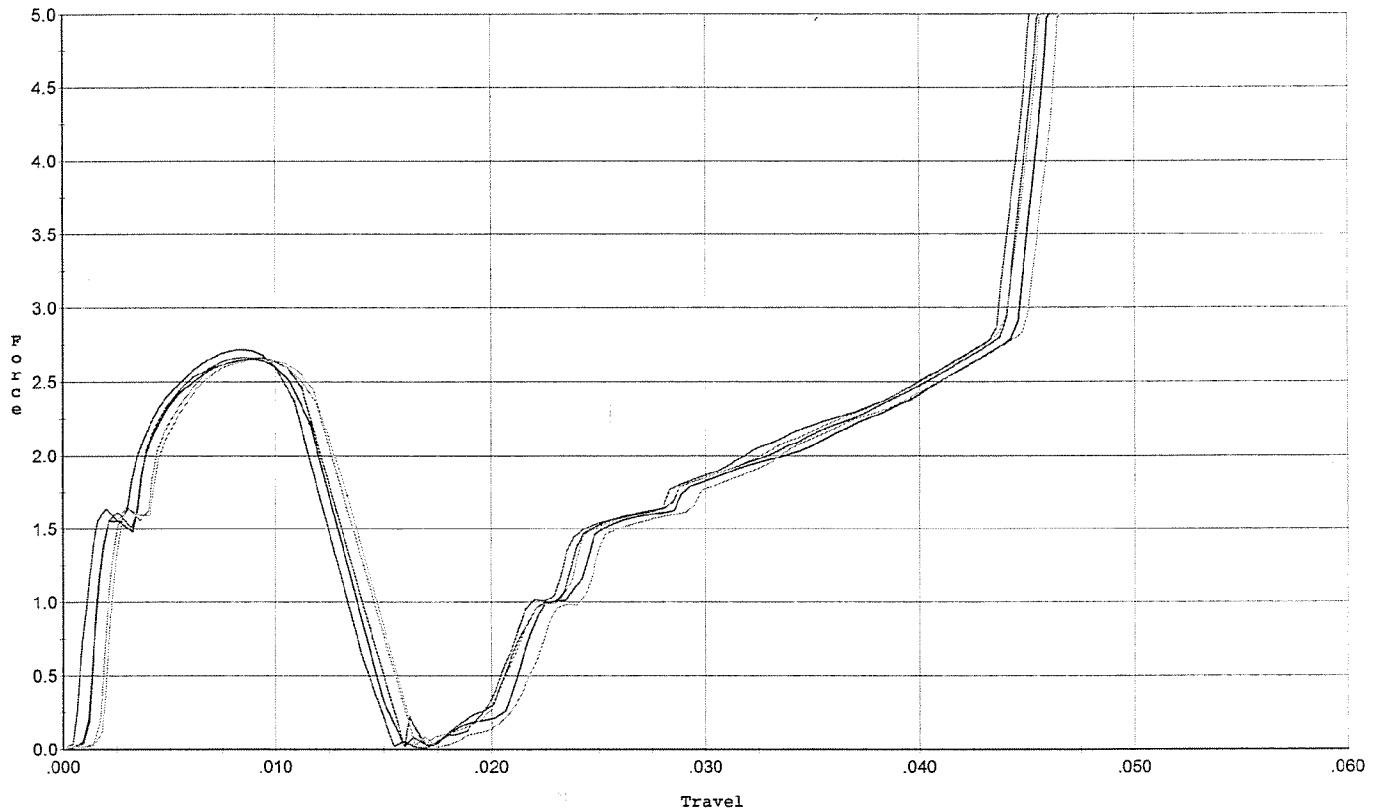
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0131972 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	2-26-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>4°</u>	2-26-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	2-26-09	LN
	J) ASSEMBLE STOCK		2-23-09	LN
	K) ASSEMBLE SWIVEL STUDS		2-26-09	LN
	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	2-24-09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-24-09	RP
670	FINAL INSPECTION A) HEADSPACE		2-26-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.54</u> <u>2.62</u> <u>2.65</u> <u>2.70</u>	2-26-09	N2
	C) FUNCTION		2-26-09	LN
690	PACK		3/3/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



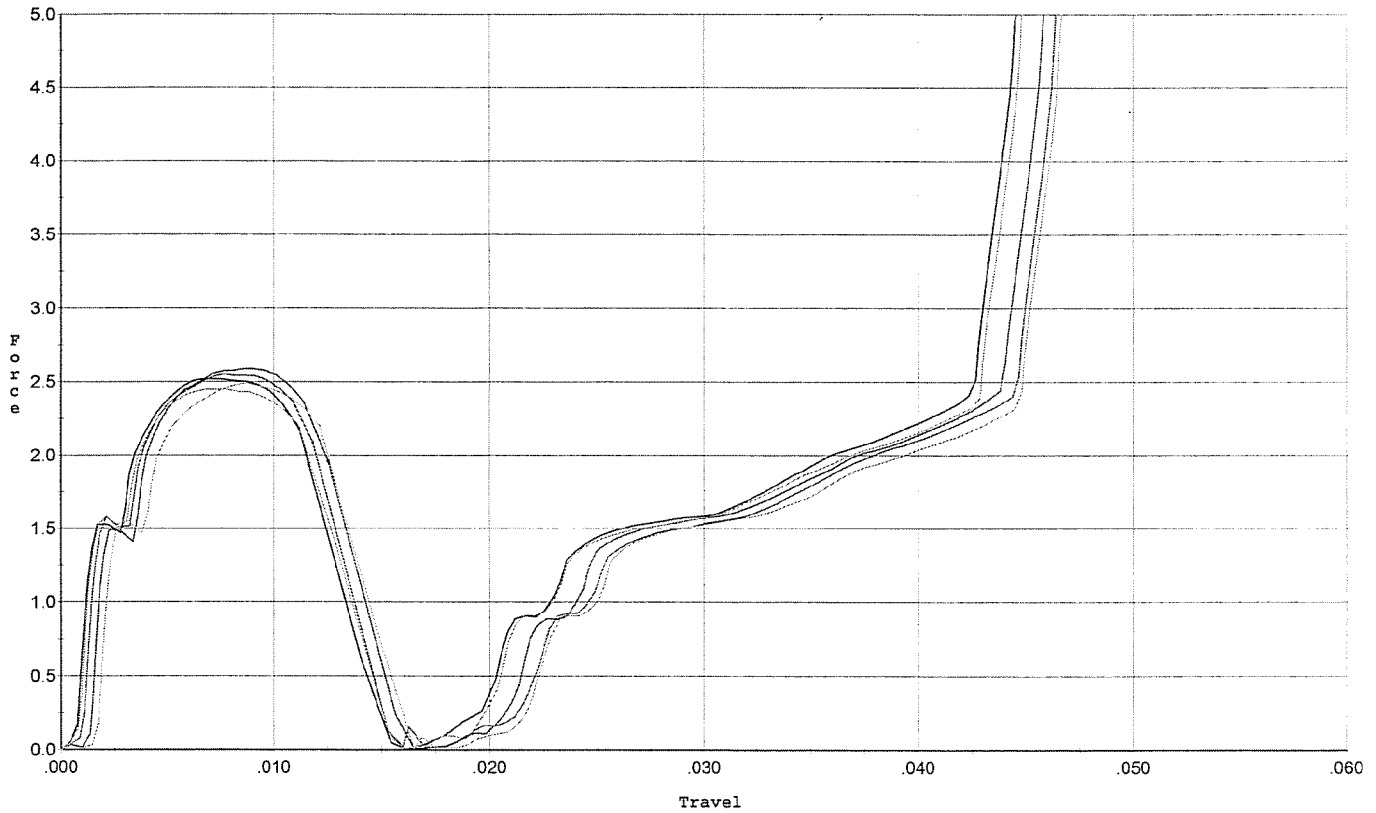
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.719	0.011	0.00	0.038	0.021		Set Trigger
2	2.656	0.012	0.003	0.037	0.021		Set Trigger
3	2.665	0.011	0.00	0.037	0.021		Set Trigger
4	2.646	0.013	0.00	0.036	0.023		Set Trigger
5	2.648	0.014	0.00	0.037	0.025		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/19/2009

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



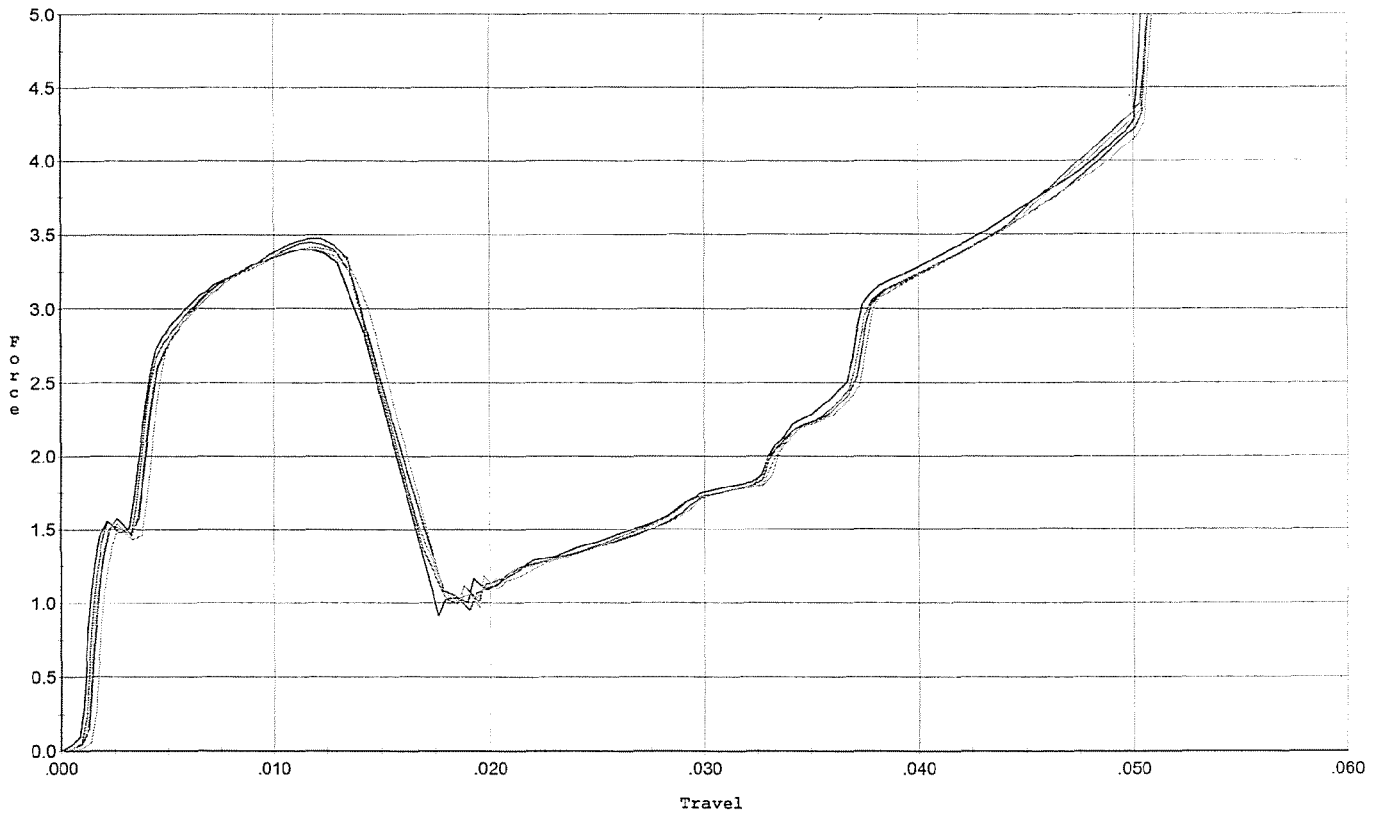
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.013	0.004	0.037	0.022		Set Trigger
2	2.521	0.011	0.00	0.036	0.021		Set Trigger
3	2.553	0.012	0.00	0.038	0.021		Set Trigger
4	2.492	0.012	0.00	0.038	0.021		Set Trigger
5	2.449	0.013	0.00	0.036	0.023		Set Trigger

A-2-52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



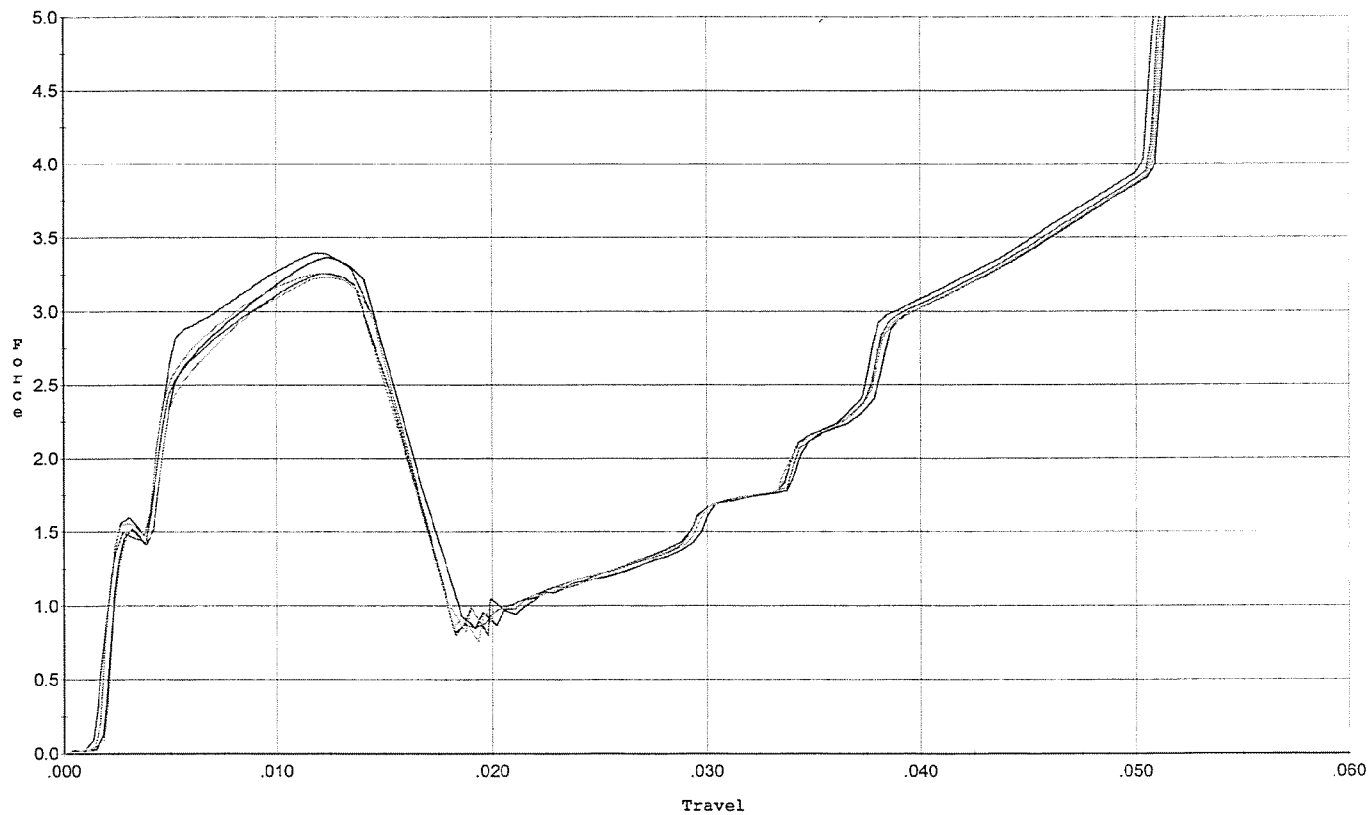
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.473	0.013	0.00	0.038	0.031		Set Trigger
2	3.399	0.014	0.00	0.037	0.033		Set Trigger
3	3.450	0.014	0.003	0.038	0.032		Set Trigger
4	3.414	0.014	0.00	0.037	0.033		Set Trigger
5	3.400	0.014	0.00	0.038	0.031		Set Trigger

A-3-42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/19/2009

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



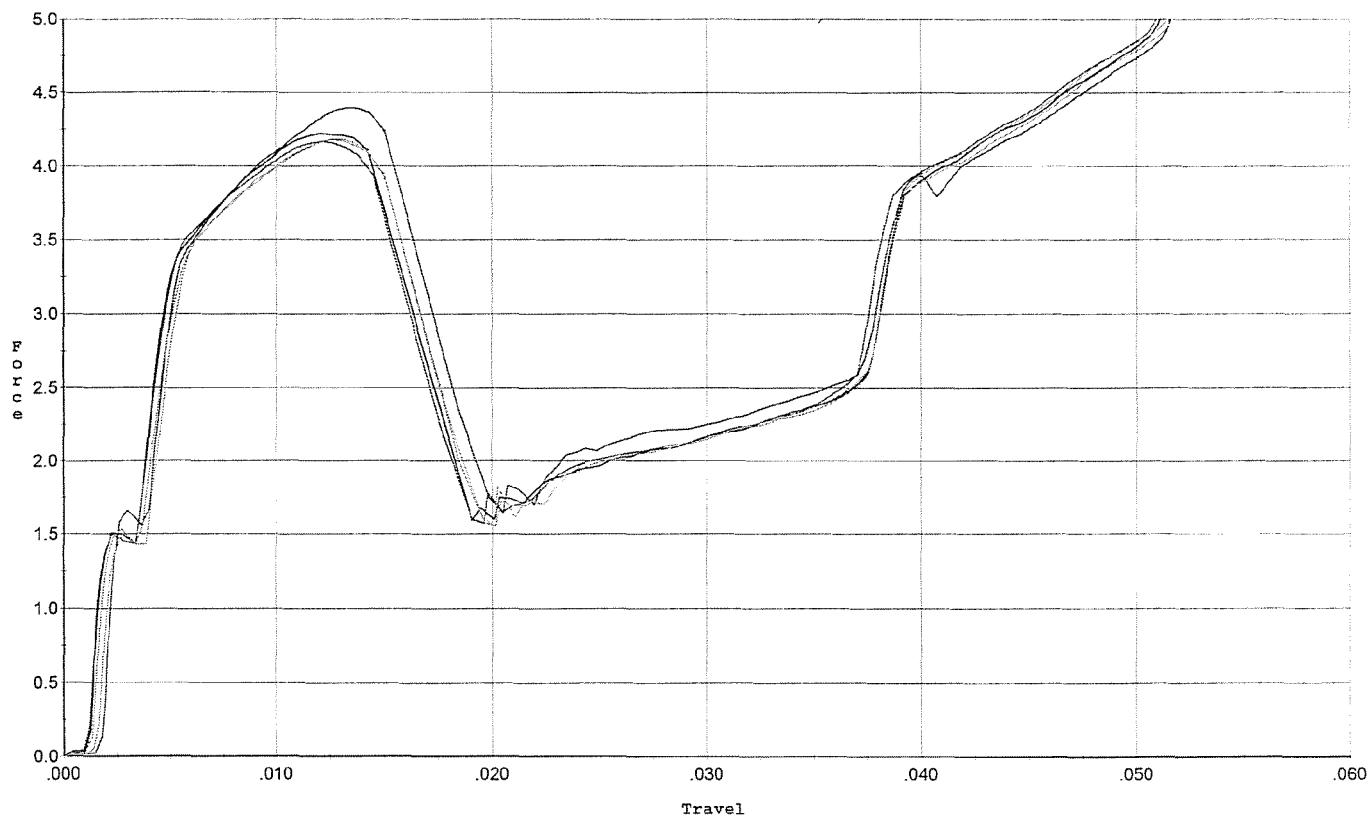
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.396	0.014	0.00	0.038	0.033		Set Trigger
2	3.366	0.014	0.00	0.038	0.031		Set Trigger
3	3.255	0.015	0.004	0.038	0.033		Set Trigger
4	3.231	0.014	0.00	0.038	0.031		Set Trigger
5	3.258	0.016	0.004	0.038	0.034		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/19/2009

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



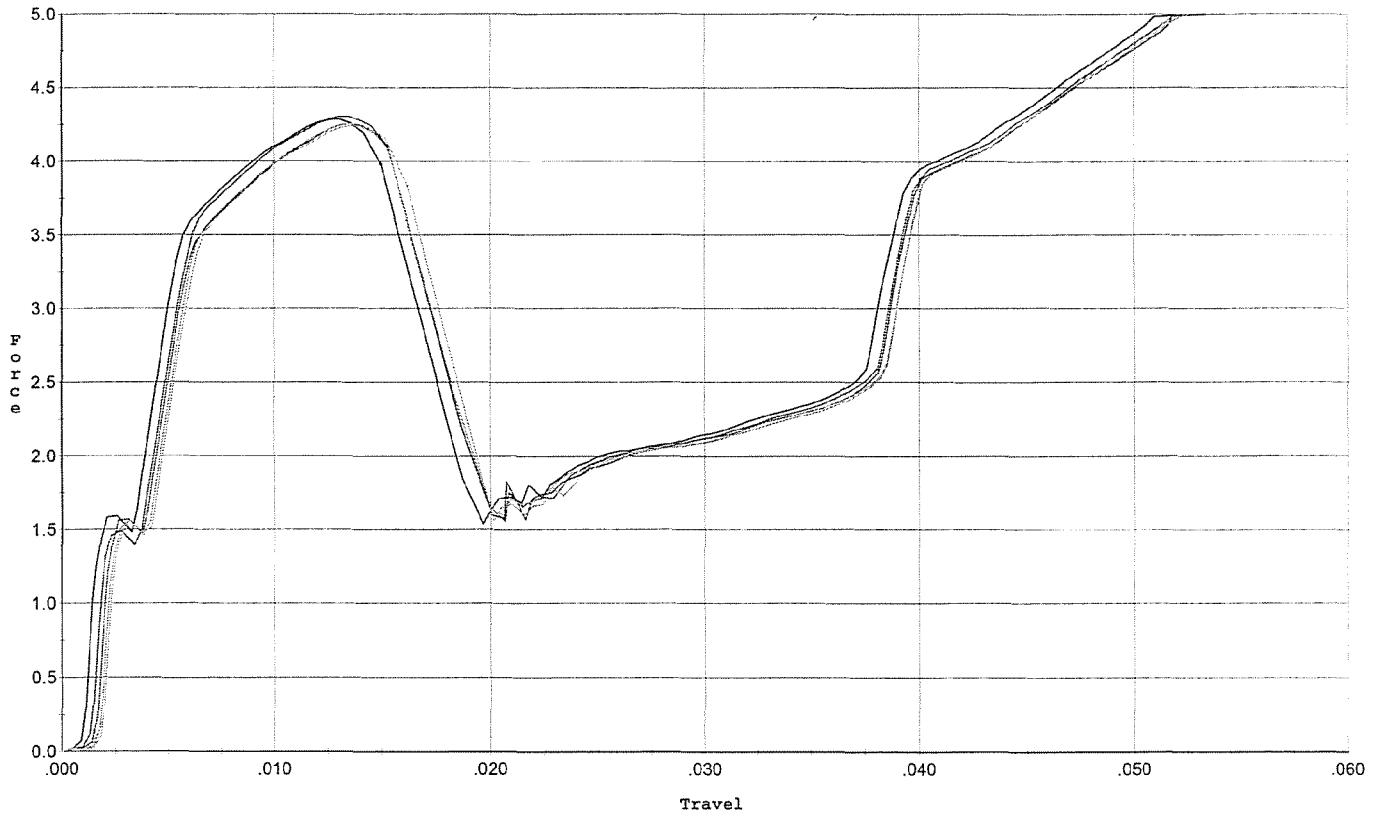
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.393	0.015	0.002	0.036	0.042		Set Trigger
2	4.220	0.014	0.004	0.036	0.040		Set Trigger
3	4.167	0.015	0.004	0.036	0.040		Set Trigger
4	4.180	0.015	0.004	0.037	0.041		Set Trigger
5	4.183	0.015	0.00	0.036	0.041		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/19/2009

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



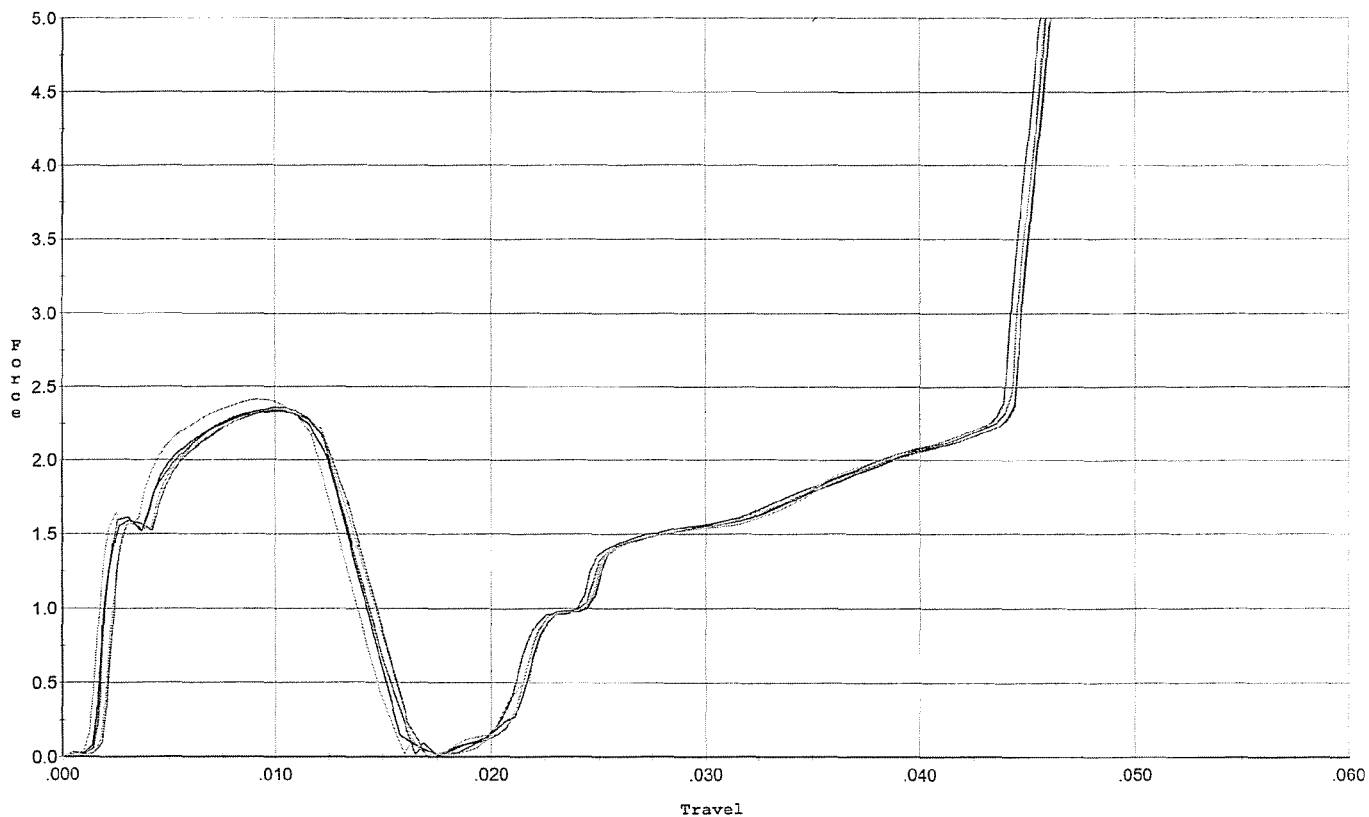
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.301	0.015	0.00	0.036	0.043		Set Trigger
2	4.285	0.015	0.00	0.036	0.042		Set Trigger
3	4.253	0.015	0.00	0.036	0.042		Set Trigger
4	4.240	0.016	0.00	0.036	0.044		Set Trigger
5	4.255	0.015	0.00	0.036	0.041		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/19/2009

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



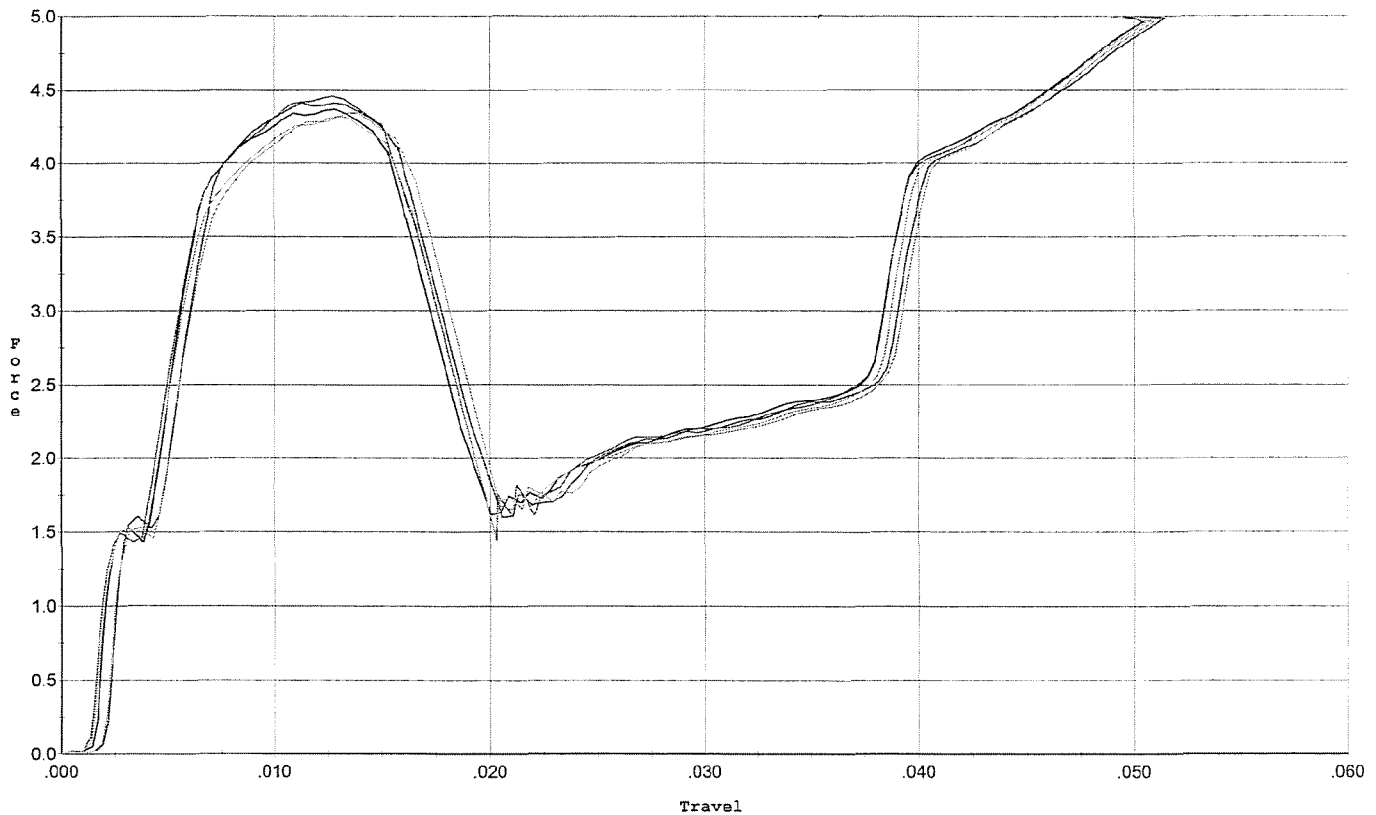
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.361	0.012	0.00	0.037	0.020		Set Trigger
2	2.342	0.012	0.00	0.038	0.020		Set Trigger
3	2.334	0.013	0.00	0.037	0.021		Set Trigger
4	2.356	0.014	0.00	0.037	0.022		Set Trigger
5	2.414	0.012	0.00	0.038	0.020		Set Trigger

A-2-36

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/19/2009

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	4.411	0.016	0.00	0.036	0.044		Set Trigger
2	4.369	0.015	0.00	0.036	0.043		Set Trigger
3	4.458	0.017	0.00	0.036	0.048		Set Trigger
4	4.319	0.016	0.00	0.036	0.046		Set Trigger
5	4.344	0.017	0.002	0.036	0.046		Set Trigger

A - 4.38