

G680 7674

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



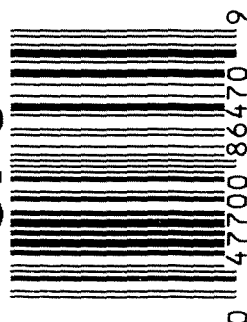
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807674

UPC



BM FORM

GUN SERIAL # G 680 76 74

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-21-09	SP
430	ASSEMBLE TO STOCK		1-21-09	SP
440	PROOF		1-21-09	SP
460	CHECK HEADSPACE		1-21-09	SP
470	DIS-ASSEMBLE ACTION		1-21-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	1-22-09	SP
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	1/23/09	SP
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	NT
520	GOFF BLAST BBL / REC		1/24/09	SP
542	APPLY COATINGS (BARREL ACTION)		730	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		1-30-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

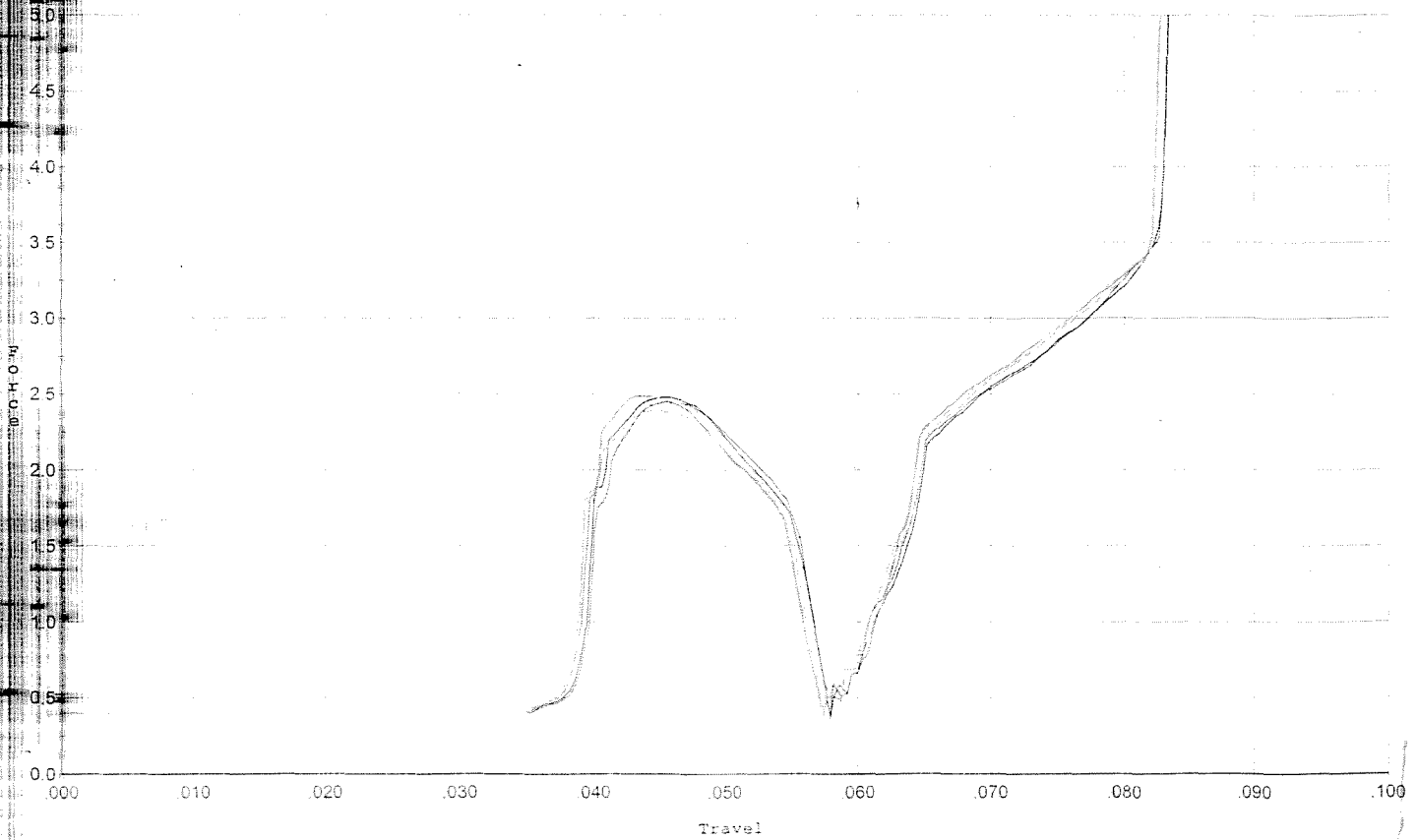
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	2-6-09	LJ		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	2-6-09	LJ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.025</u>	2-6-09	LJ		
	J) ASSEMBLE STOCK					1-30-09	LJ		
	K) ASSEMBLE SWIVEL STUDS					2-6-09	LJ		
	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		2-3-09	LJ		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					2-3-09	LJ		
670	FINAL INSPECTION A) HEADSPACE					2-6-09	LJ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u>	<u>2.49</u>	<u>2.53</u>	<u>2.52</u>	<u>2.61</u>	2-4-09	LJ
	C) FUNCTION							2-6-09	LJ
690	PACK							2/16/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/21/2009

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



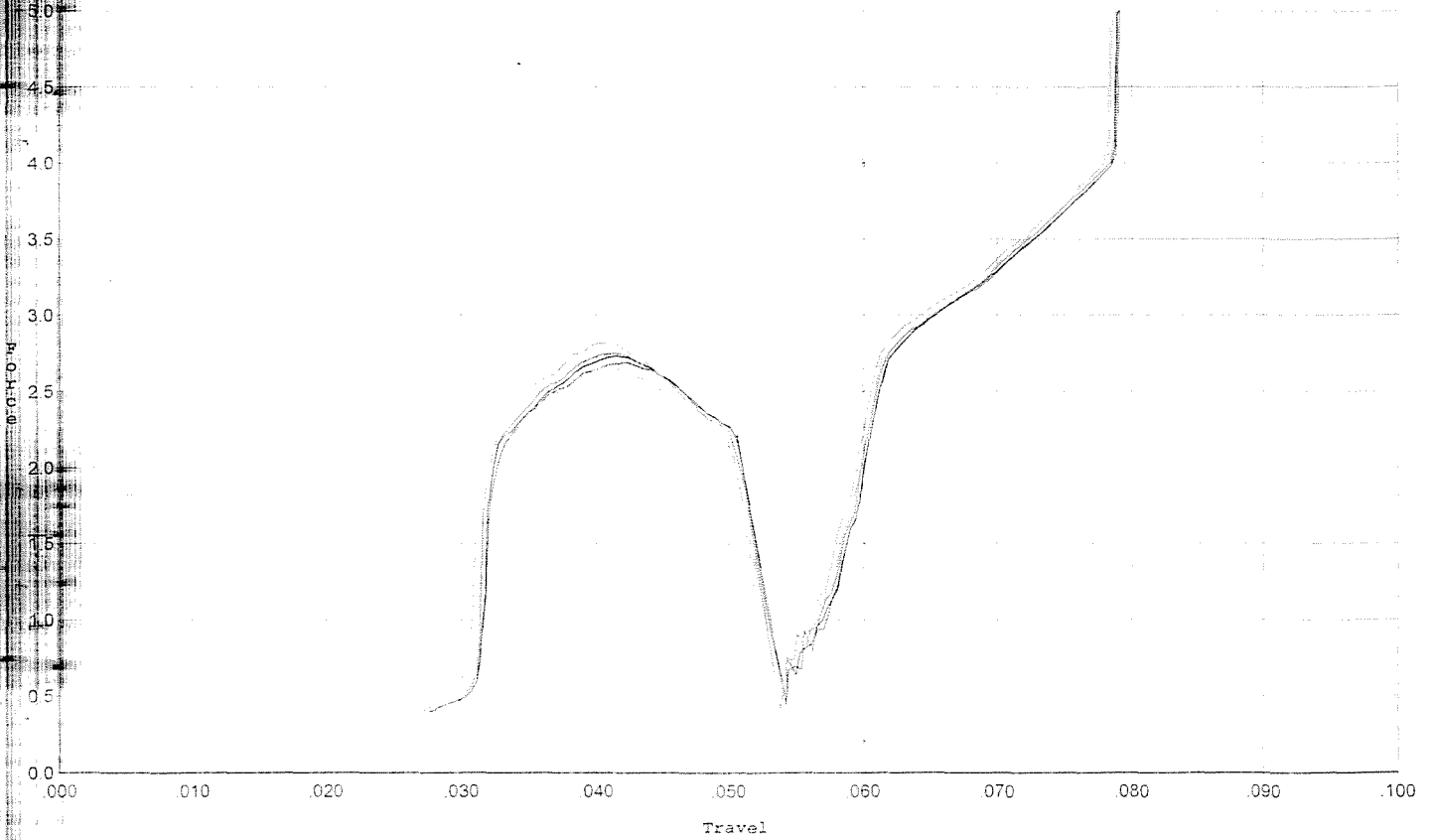
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.056	0.039	0.034	0.051		Set Trigger
2	2.480	0.056	0.039	0.034	0.052		Set Trigger
3	2.485	0.054	0.038	0.035	0.050		Set Trigger
4	2.480	0.054	0.038	0.035	0.051		Set Trigger
5	2.391	0.055	0.038	0.034	0.051		Set Trigger

A. 2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



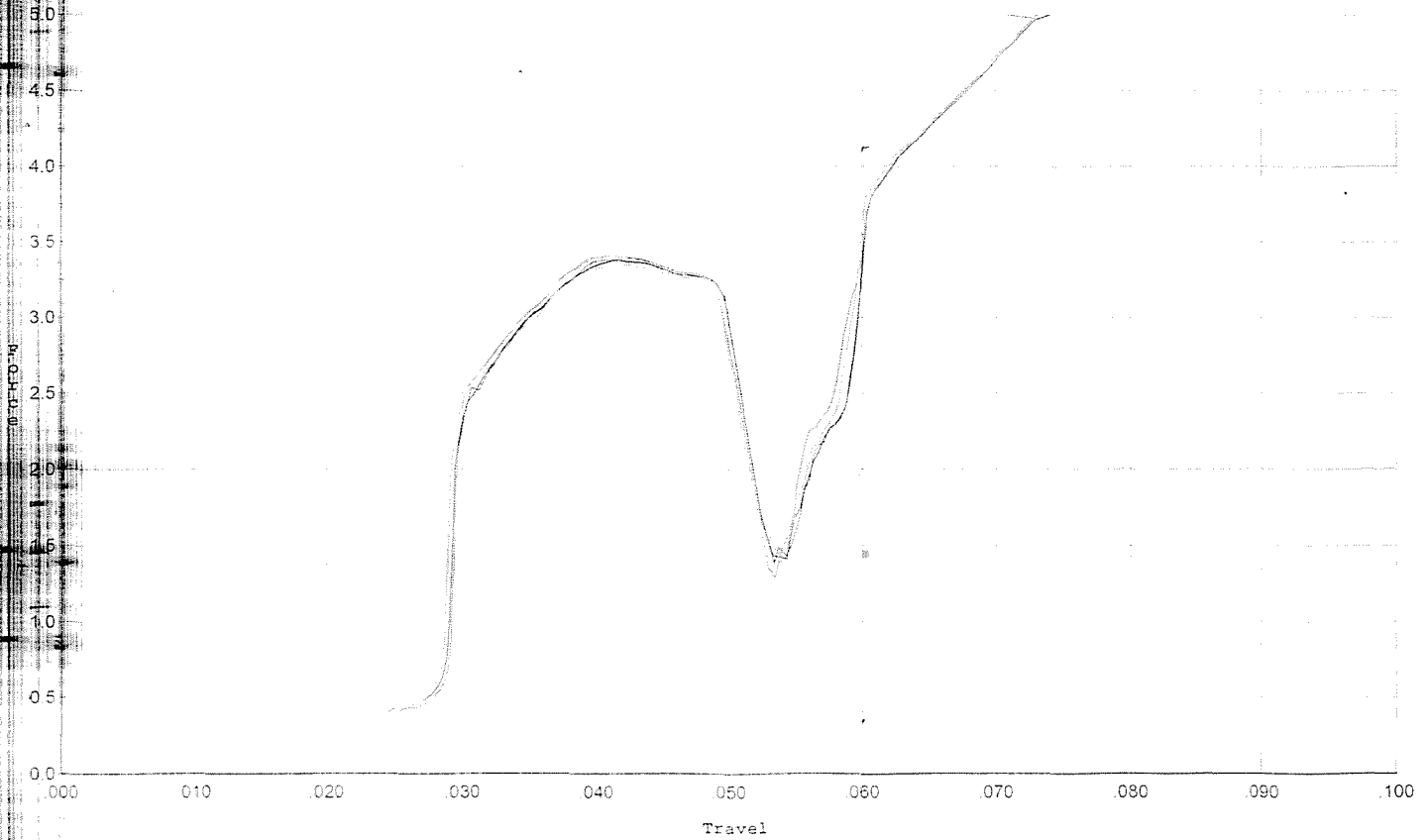
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.051	0.031	0.032	0.060		Set Trigger
2	2.730	0.051	0.031	0.032	0.060		Set Trigger
3	2.748	0.051	0.031	0.032	0.061		Set Trigger
4	2.658	0.052	0.031	0.032	0.061		Set Trigger
5	2.816	0.050	0.030	0.031	0.062		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



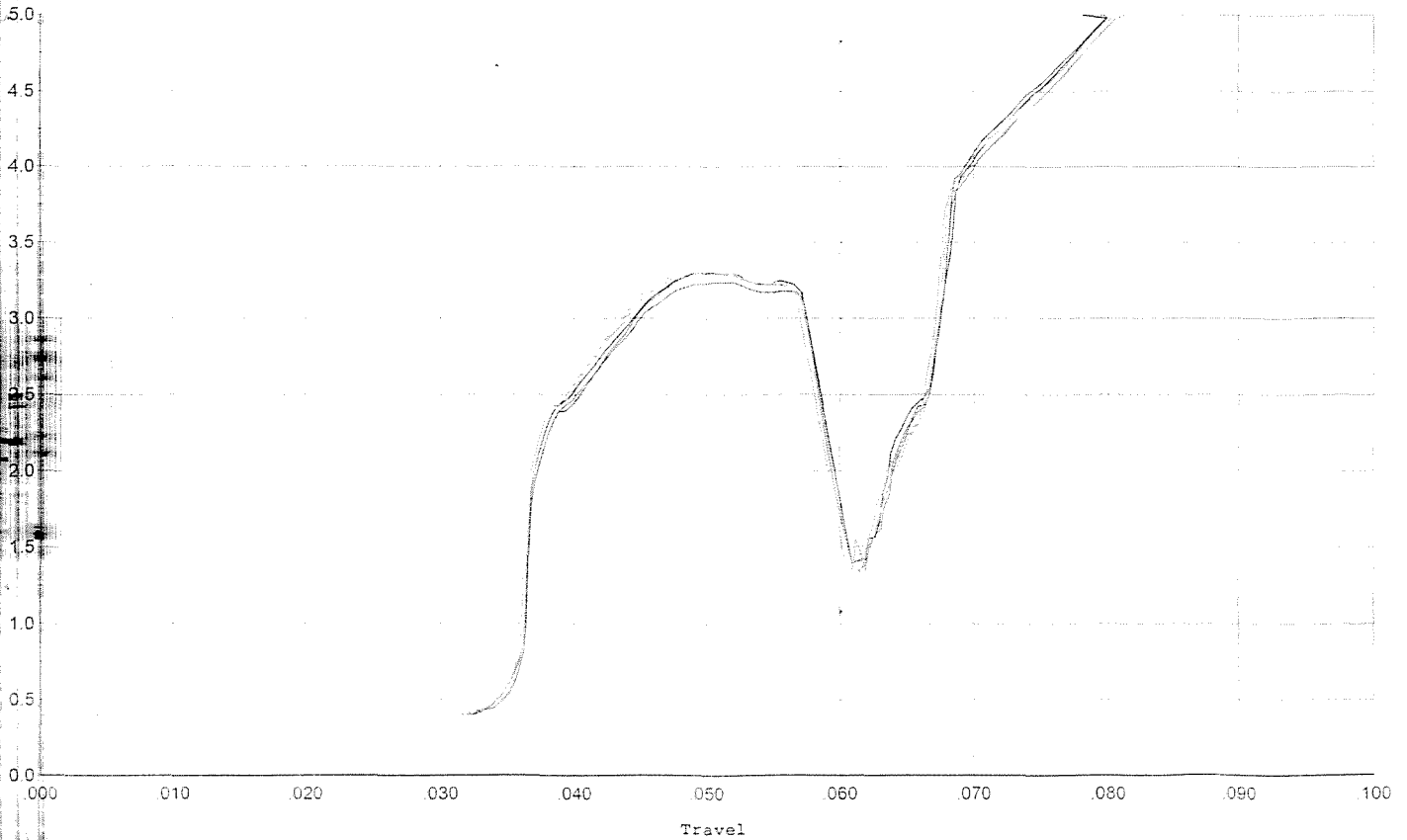
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.388	0.050	0.029	0.030	0.076		Set Trigger
2	3.380	0.050	0.029	0.029	0.077		Set Trigger
3	3.408	0.051	0.028	0.029	0.079		Set Trigger
4	3.388	0.051	0.028	0.029	0.079		Set Trigger
5	3.347	0.049	0.028	0.029	0.075		Set Trigger

17-3-38

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



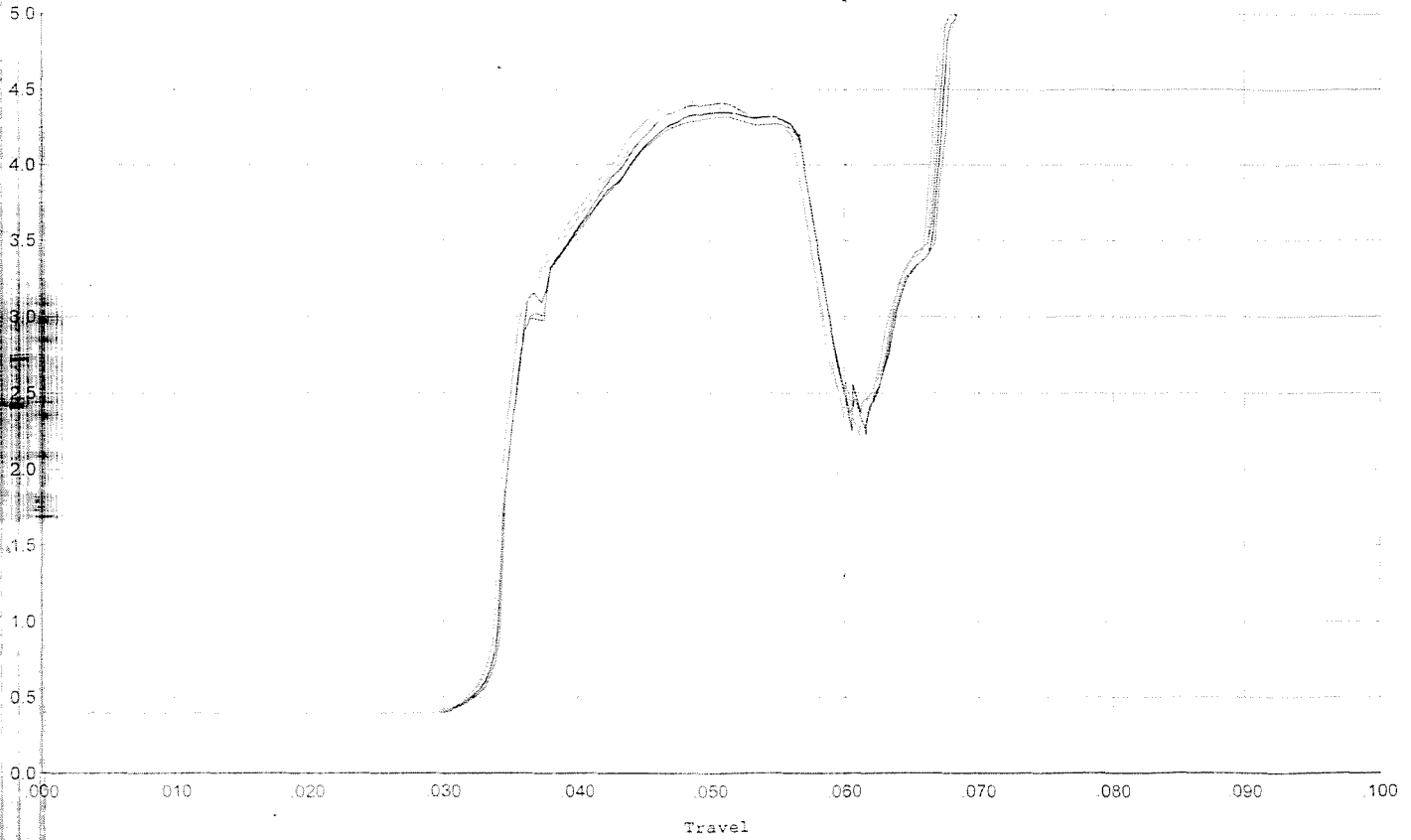
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.237	0.059	0.036	0.032	0.080		Set Trigger
2	3.307	0.057	0.035	0.032	0.079		Set Trigger
3	3.299	0.057	0.036	0.032	0.078		Set Trigger
4	3.312	0.057	0.036	0.032	0.079		Set Trigger
5	3.318	0.058	0.035	0.032	0.081		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



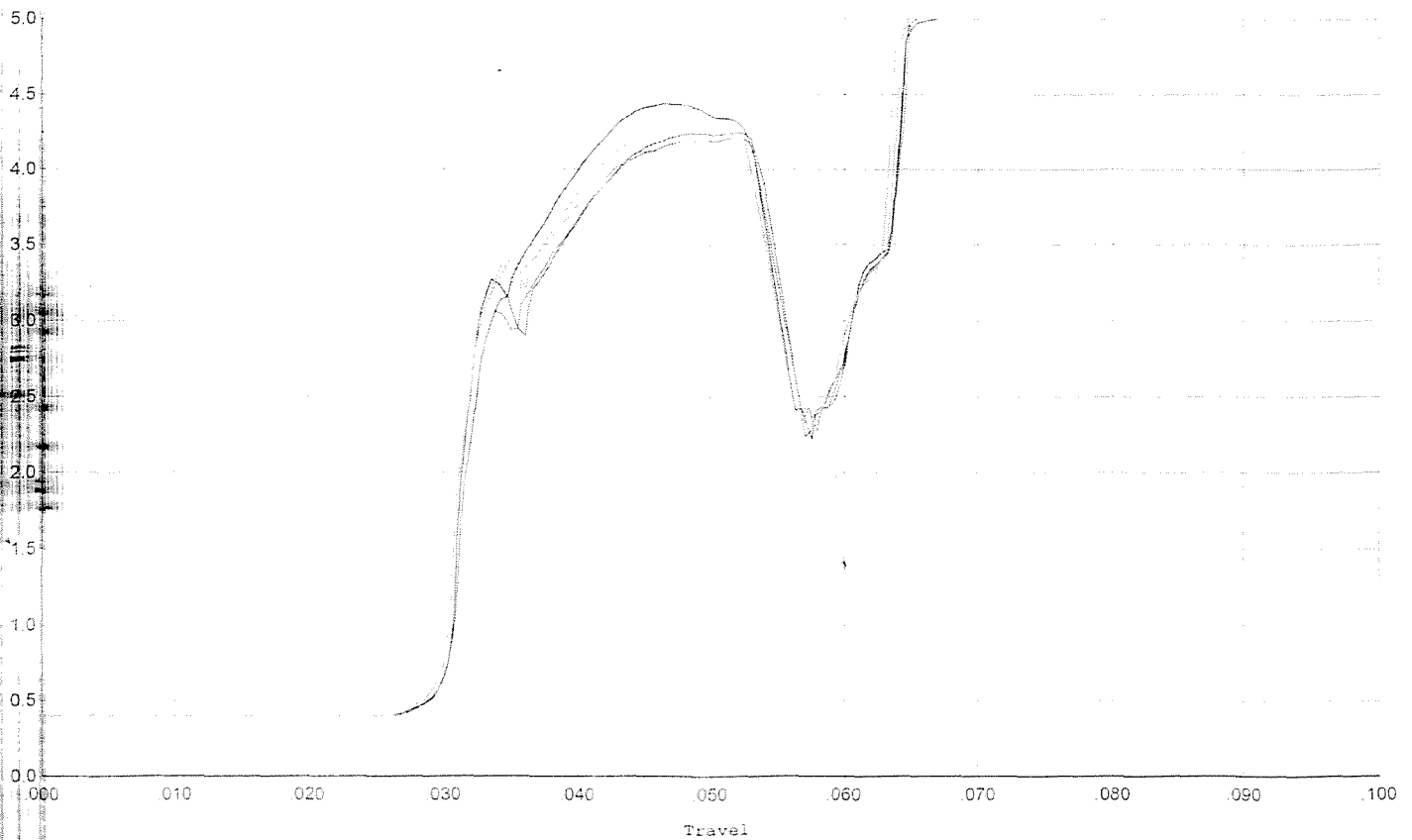
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.410	0.057	0.034	0.023	0.104		Set Trigger
2	4.350	0.057	0.033	0.024	0.104		Set Trigger
3	4.319	0.057	0.033	0.024	0.103		Set Trigger
4	4.382	0.056	0.033	0.024	0.103		Set Trigger
5	4.430	0.056	0.033	0.024	0.104		Set Trigger

A-4.37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



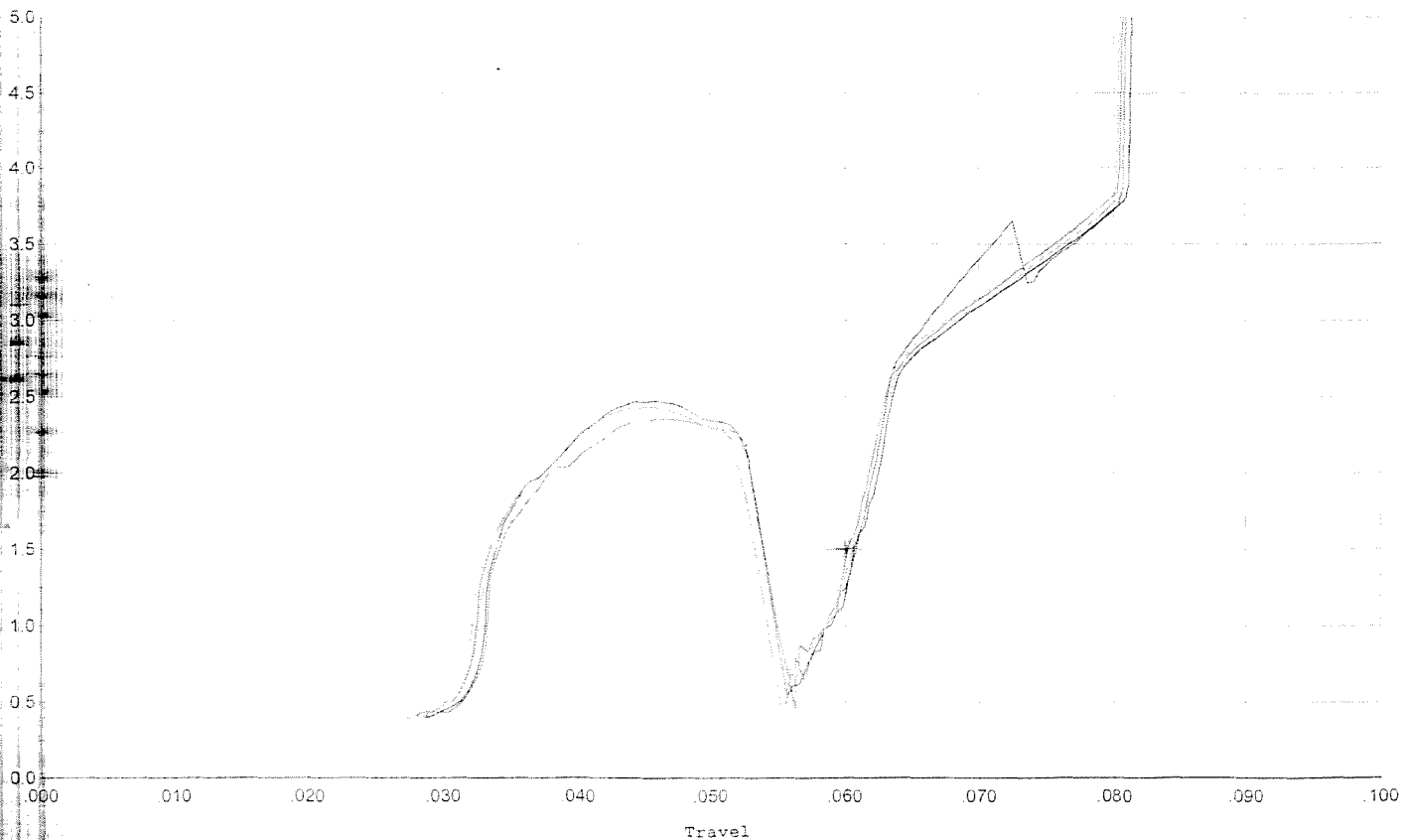
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.249	0.054	0.030	0.024	0.099		Set Trigger
2	4.440	0.053	0.030	0.024	0.102		Set Trigger
3	4.218	0.053	0.030	0.024	0.097		Set Trigger
4	4.265	0.054	0.030	0.024	0.102		Set Trigger
5	4.221	0.054	0.030	0.024	0.100		Set Trigger

A-4-27

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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



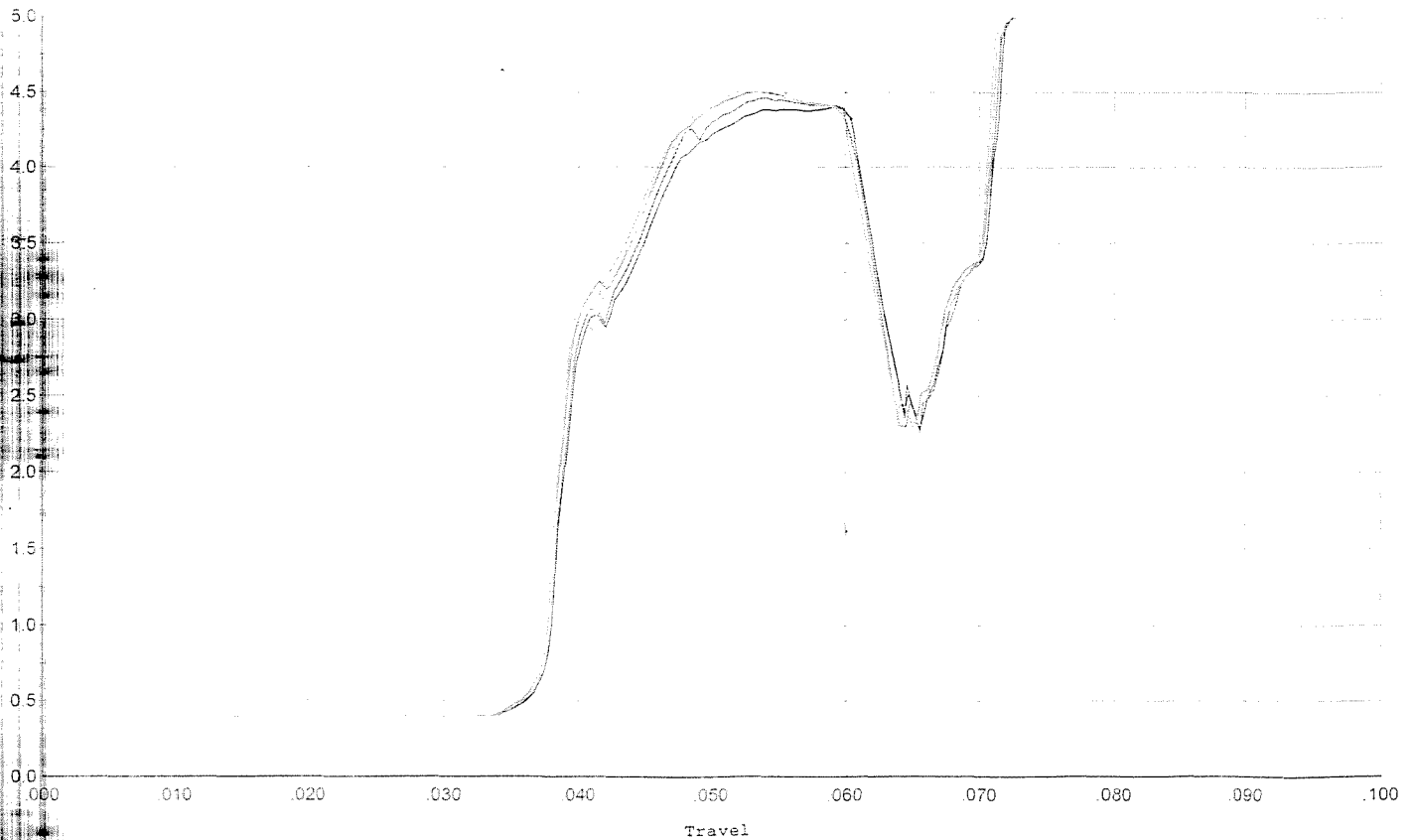
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.358	0.053	0.032	0.033	0.056		Set Trigger
2	2.475	0.053	0.032	0.033	0.058		Set Trigger
3	2.439	0.053	0.032	0.033	0.057		Set Trigger
4	2.338	0.053	0.032	0.033	0.057		Set Trigger
5	2.349	0.053	0.031	0.033	0.057		Set Trigger

A.2.39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/21/2009

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	4.464	0.060	0.037	0.024	0.106		Set Trigger
2	4.404	0.060	0.037	0.024	0.105		Set Trigger
3	4.501	0.061	0.037	0.024	0.109		Set Trigger
4	4.499	0.060	0.037	0.024	0.106		
5	4.528	0.060	0.037	0.024	0.106		

A. 4.47