

G 680 7705

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



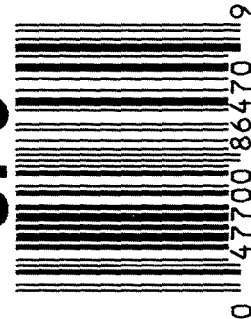
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807705

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 7705

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		1-22-09	RIC
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION		1/23/09	SP
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1/24/09	DS
542	APPLY COATINGS (BARREL ACTION)		1/30	
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		1-31-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

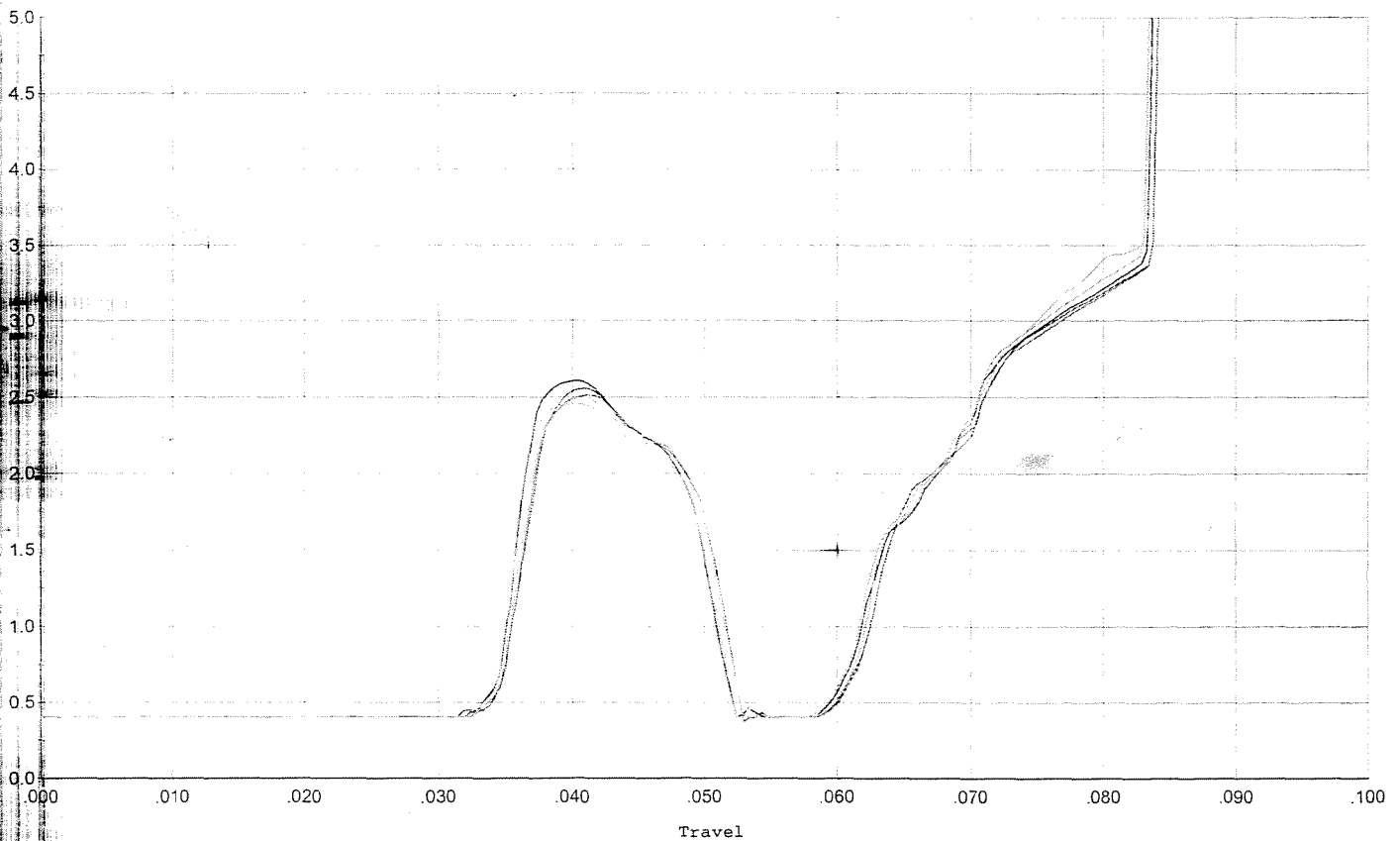
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	2-6-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	2-6-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	2-6-09	LJ
	J) ASSEMBLE STOCK		1-31-09	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 <u>PASS</u> FAIL	2-3-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-3-09	WV
670	FINAL INSPECTION A) HEADSPACE		2-6-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>241</u> <u>231</u> <u>255</u> <u>251</u> <u>259</u>	2-4-09	WV
	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: R.P. 1/20/09

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



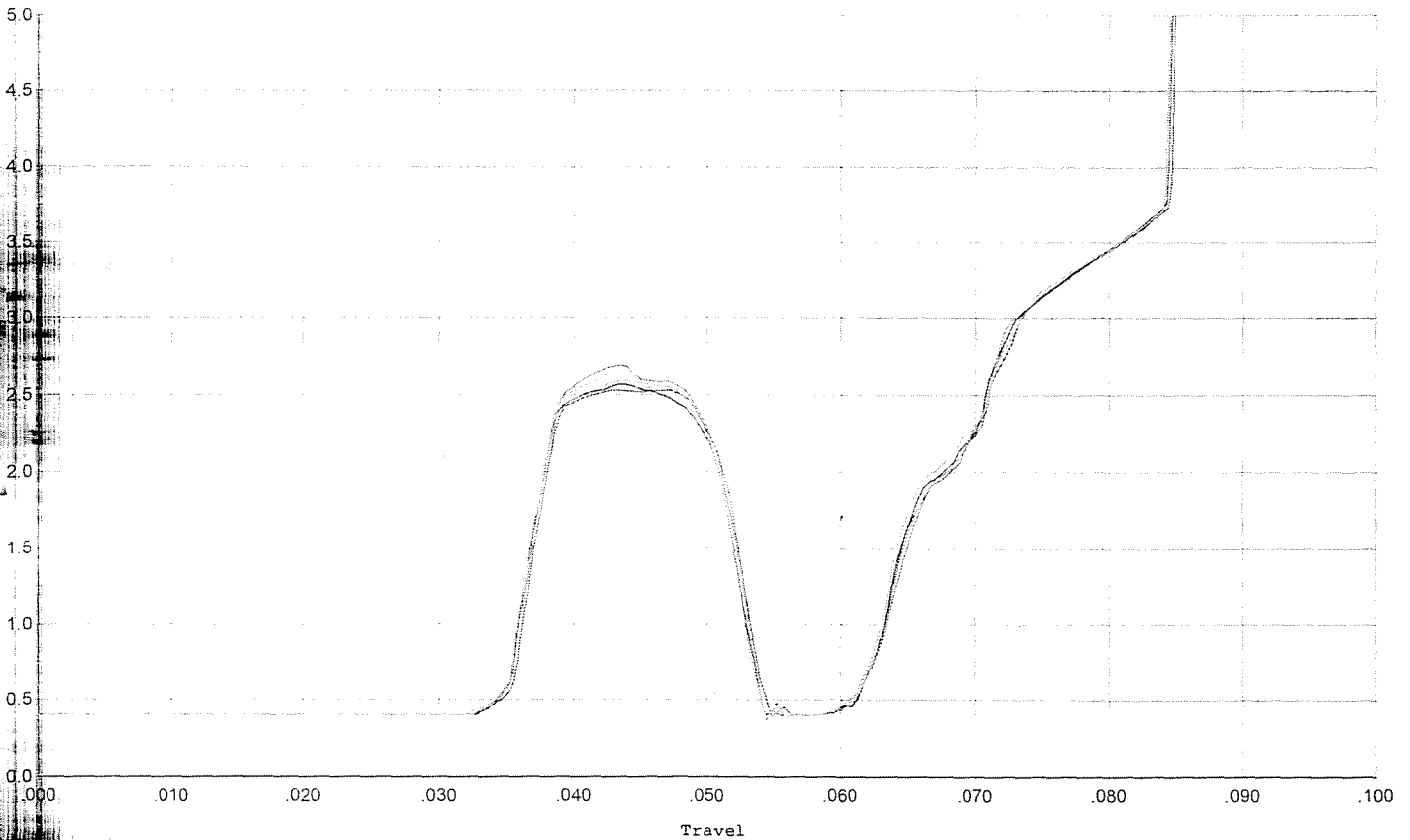
Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
2.553	0.051	0.034	0.038	0.048		Set Trigger
2.604	0.049	0.033	0.038	0.047		Set Trigger
2.513	0.051	0.035	0.038	0.048		Set Trigger
2.498	0.050	0.035	0.038	0.047		Set Trigger
2.453	0.051	0.034	0.037	0.048		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 1/20/09

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



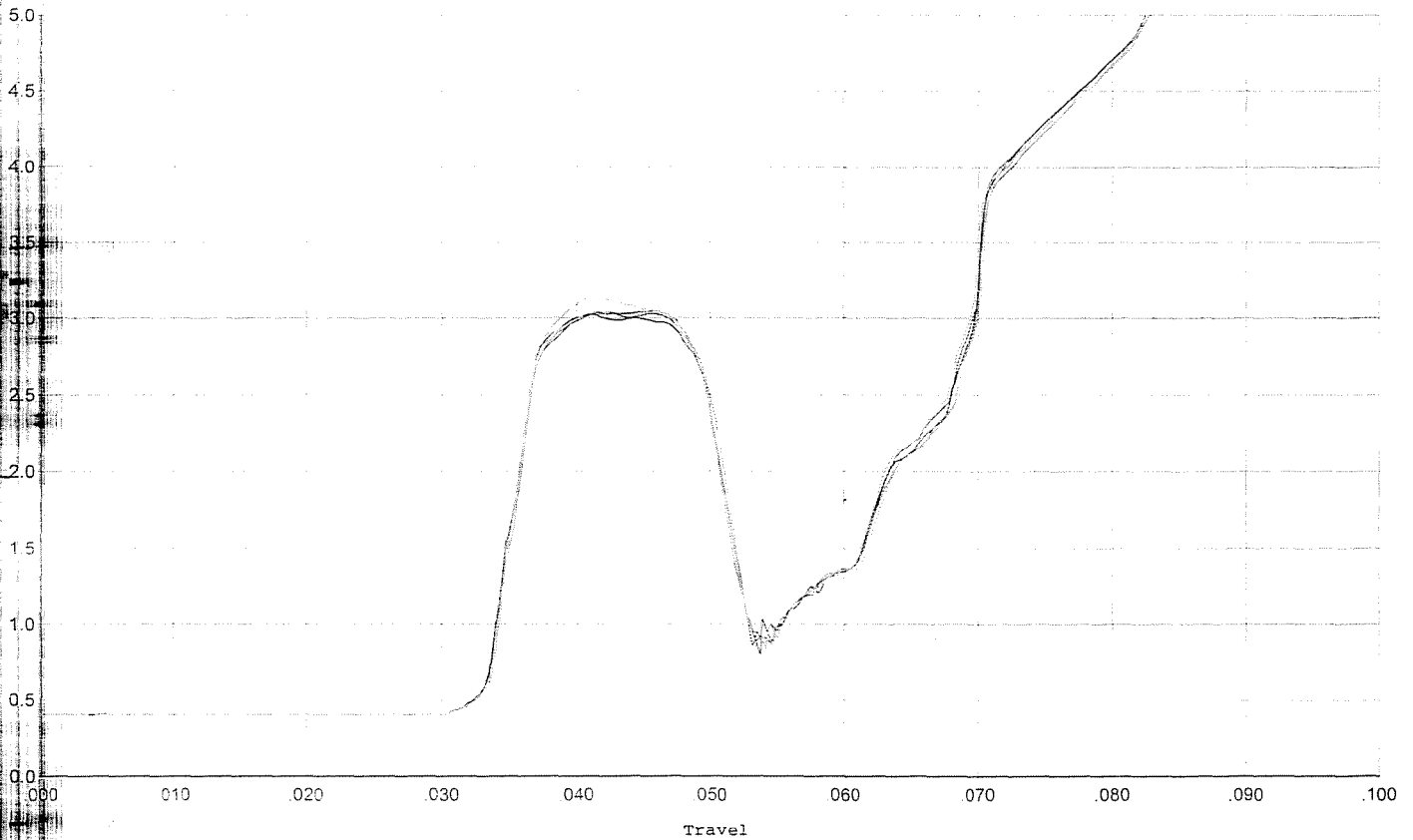
	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.052	0.036	0.037	0.051		Set Trigger
2	2.569	0.051	0.035	0.038	0.050		Set Trigger
3	2.692	0.052	0.035	0.037	0.053		Set Trigger
4	2.646	0.052	0.035	0.037	0.053		Set Trigger
5	2.593	0.051	0.035	0.037	0.051		Set Trigger

AVG 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

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



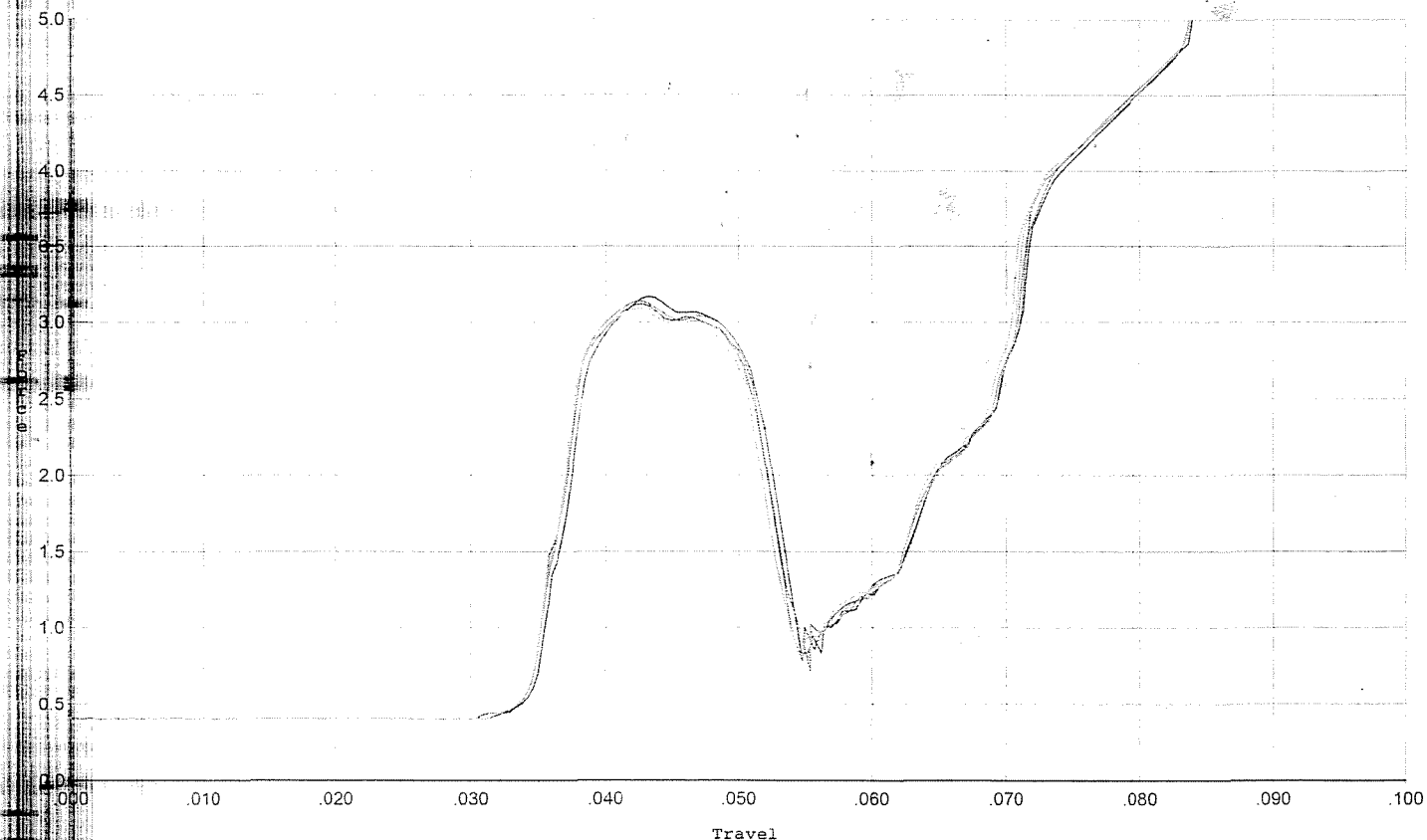
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.040	0.049	0.033	0.036	0.058		Set Trigger
2	3.023	0.050	0.033	0.036	0.058		Set Trigger
3	3.041	0.051	0.034	0.036	0.060		Set Trigger
4	3.058	0.050	0.034	0.036	0.060		Set Trigger
5	3.143	0.050	0.033	0.036	0.059		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

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



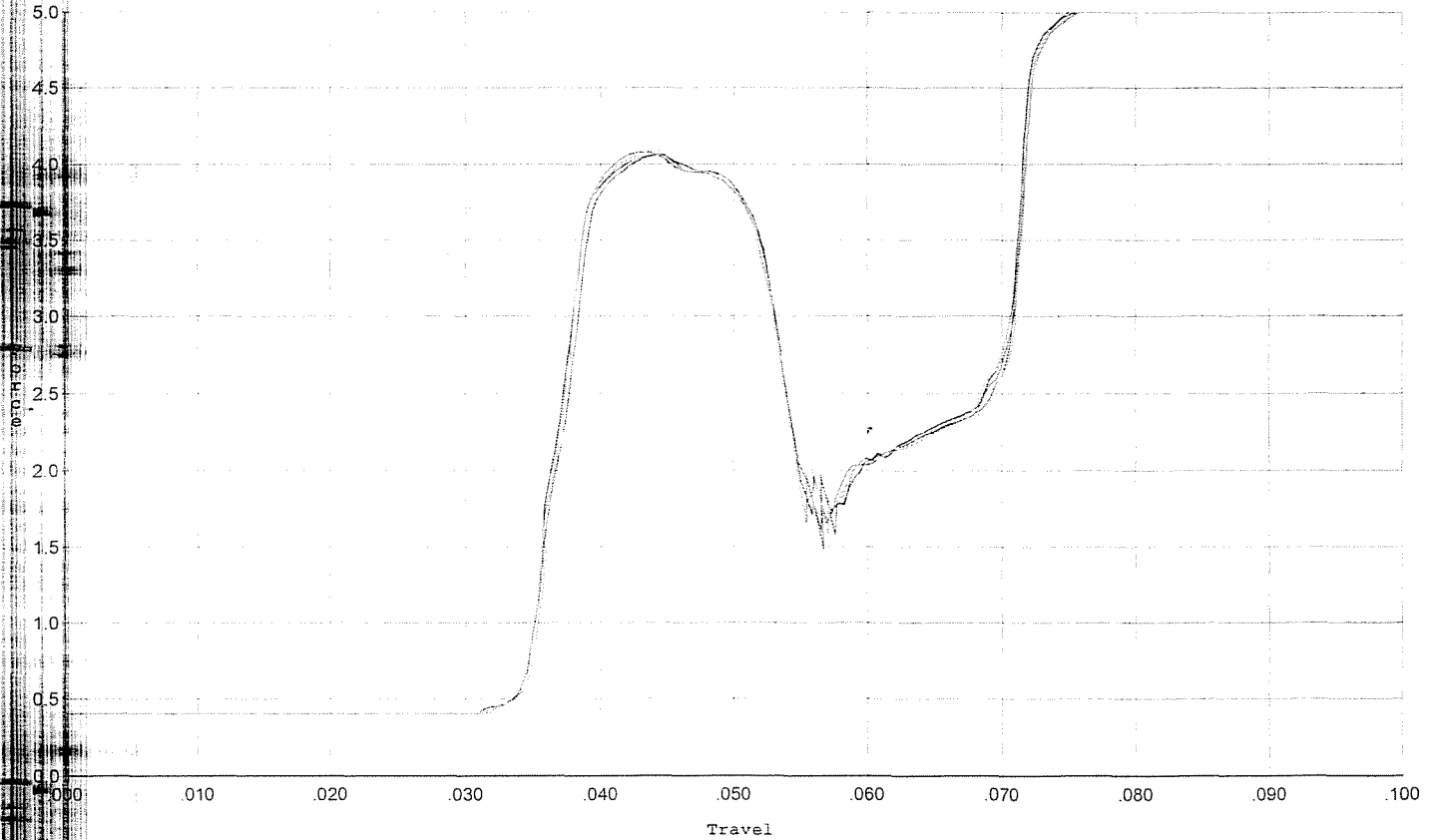
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.122	0.051	0.034	0.036	0.060		Set Trigger
2	3.172	0.052	0.035	0.036	0.061		Set Trigger
3	3.139	0.051	0.034	0.036	0.060		Set Trigger
4	3.093	0.050	0.034	0.037	0.058		Set Trigger
5	3.087	0.051	0.034	0.036	0.058		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

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



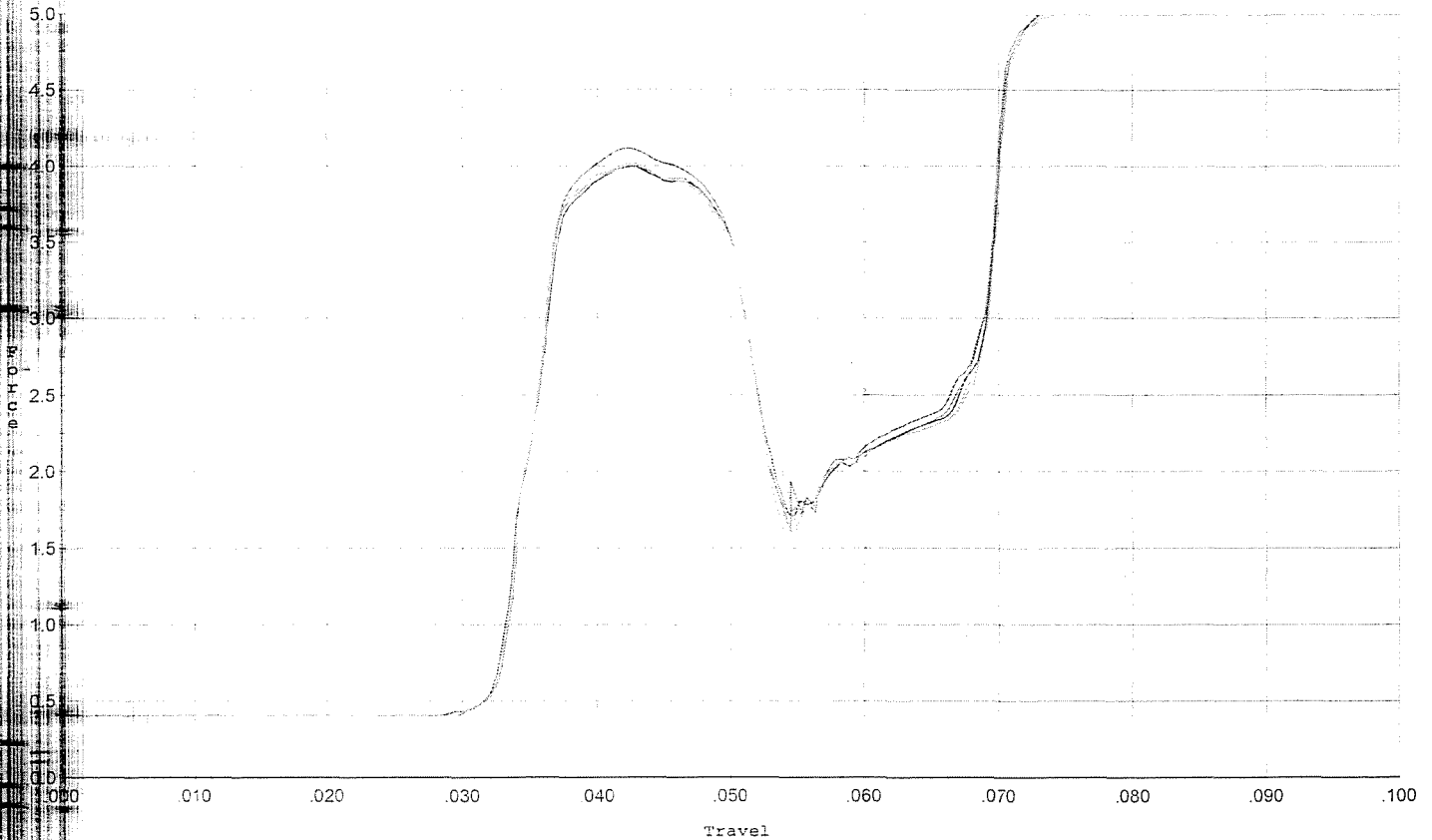
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.065	0.052	0.034	0.035	0.077		Set Trigger
2	4.063	0.052	0.034	0.035	0.078		Set Trigger
3	4.075	0.053	0.034	0.035	0.079		Set Trigger
4	4.064	0.053	0.034	0.035	0.078		Set Trigger
5	4.090	0.053	0.035	0.035	0.078		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

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



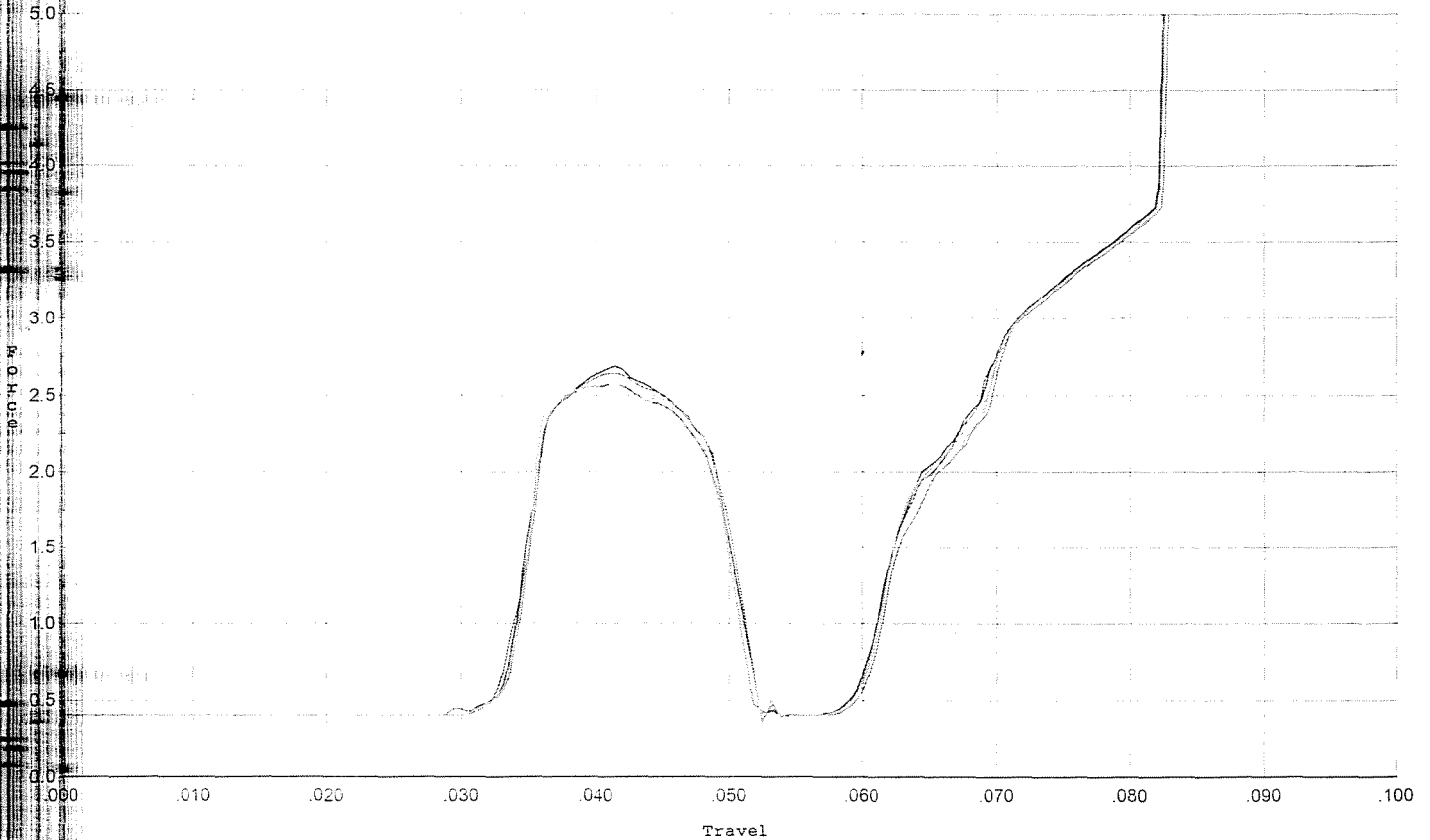
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.117	0.050	0.032	0.034	0.077		Set Trigger
2	3.998	0.050	0.033	0.034	0.075		Set Trigger
3	3.999	0.050	0.033	0.034	0.076		Set Trigger
4	4.009	0.050	0.033	0.034	0.076		Set Trigger
5	4.020	0.050	0.033	0.034	0.076		Set Trigger

Avg 4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

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



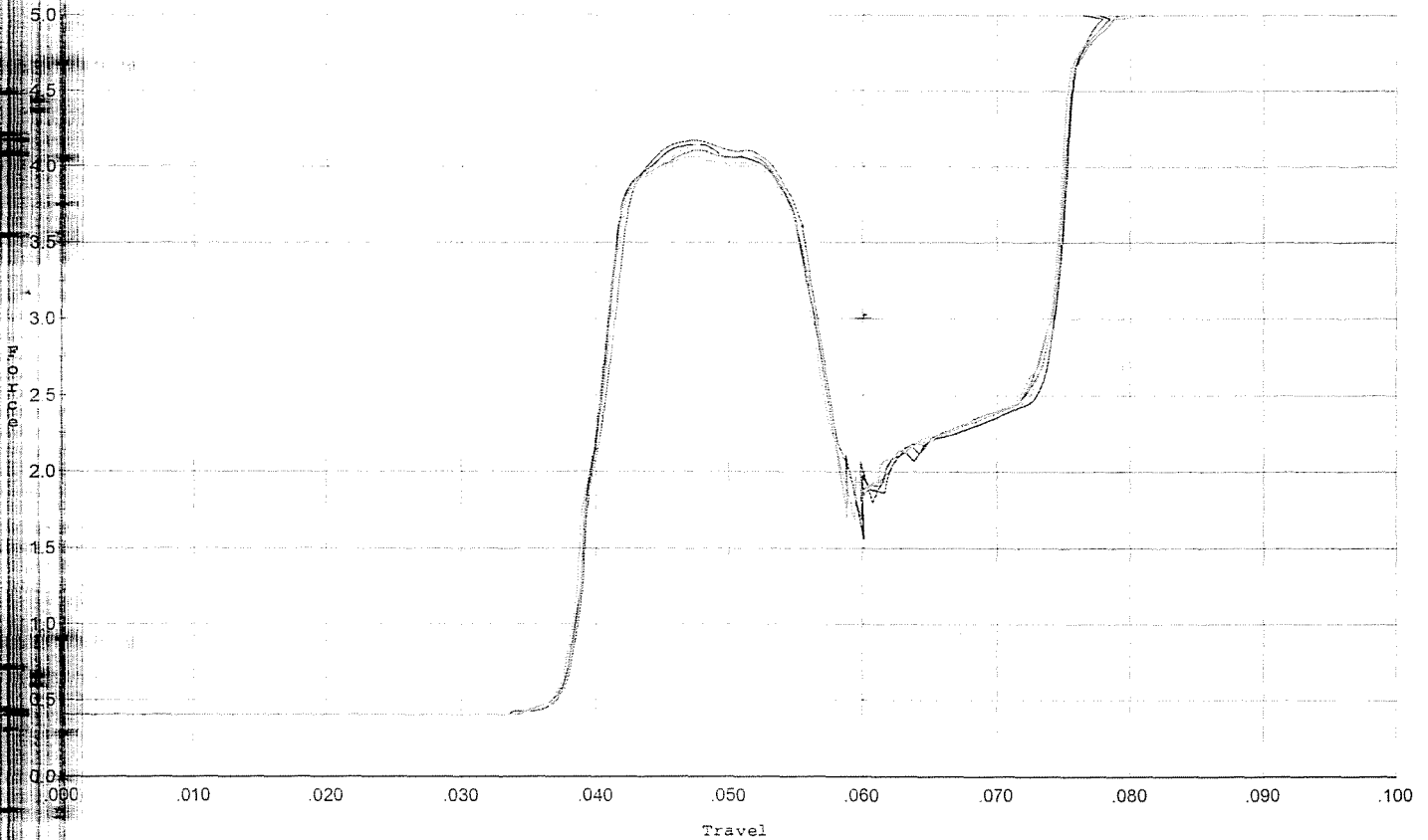
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.571	0.049	0.033	0.036	0.050		Set Trigger
2	2.688	0.049	0.033	0.036	0.050		Set Trigger.
3	2.642	0.050	0.033	0.036	0.051		Set Trigger
4	2.555	0.049	0.033	0.037	0.050		Set Trigger
5	2.572	0.049	0.034	0.037	0.050		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 1/20/09

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.174	0.056	0.038	0.036	0.081		Set Trigger
2	4.145	0.056	0.038	0.035	0.083		Set Trigger
3	4.107	0.056	0.038	0.036	0.082		Set Trigger
4	4.146	0.056	0.038	0.035	0.082		Set Trigger
5	4.069	0.055	0.037	0.036	0.080		Set Trigger

Avg 4.12

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