

G680 7725

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

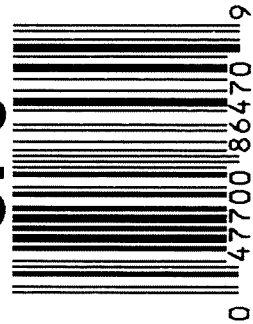
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6807725

UPC



GUN SERIAL # G 6807725

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-12-09	SP
430	ASSEMBLE TO STOCK		2-12-09	SP
440	PROOF		2-12-09	SP
460	CHECK HEADSPACE		2-12-09	SP
470	DIS-ASSEMBLE ACTION		2-12-09	SP
472	SERIALIZE BOLT HANDLE		2-12-09	RT
475	DRILL AND TAP SIGHT HOLES		2-13-09	SP
480	MAGNAFLUX BBL ACTION		2-18-09	SP
490	MAGNAFLUX BOLT		2-18-09	MR
500	ROLLMARK CALIBER		2-19-09	RT
520	GOFF BLAST BBL / REC		19-Feb-09	SP
542	APPLY COATINGS (BARREL ACTION)		3/4	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-4-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-4-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-4-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-9-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

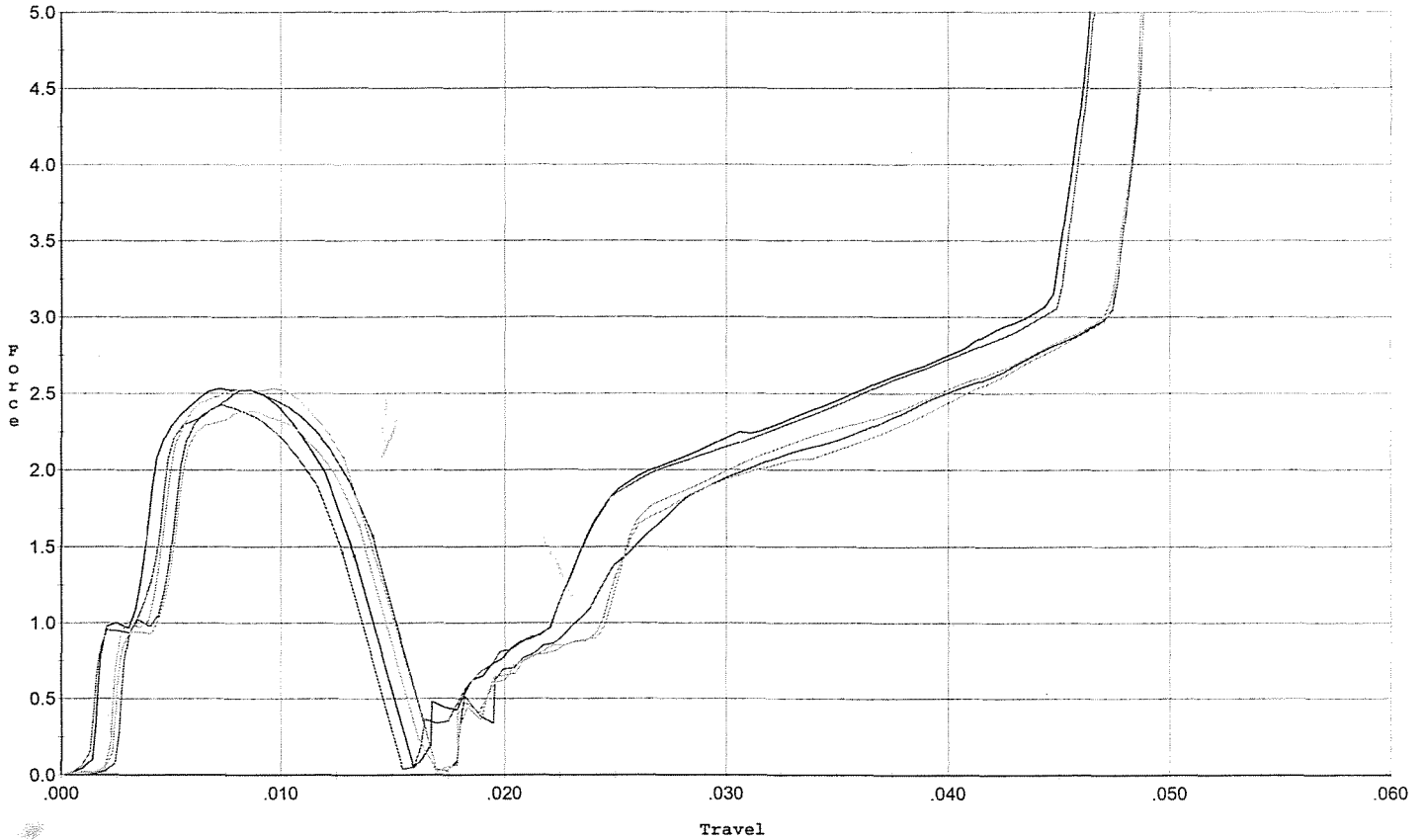
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4</u> <u>6</u> <u>55</u>	3-13-09	NW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-13-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-13-09	NW
	J) ASSEMBLE STOCK			3-9-09	NW
	K) ASSEMBLE SWIVEL STUDS			3-17-09	NW
	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	3-10-09	TL
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			3-10-09	NW
670	FINAL INSPECTION A) HEADSPACE			3-13-09	NW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.74</u> <u>2.72</u> <u>2.67</u> <u>2.48</u>	3-12-09	NW
	C) FUNCTION			3-13-09	NW
690	PACK			3/23/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



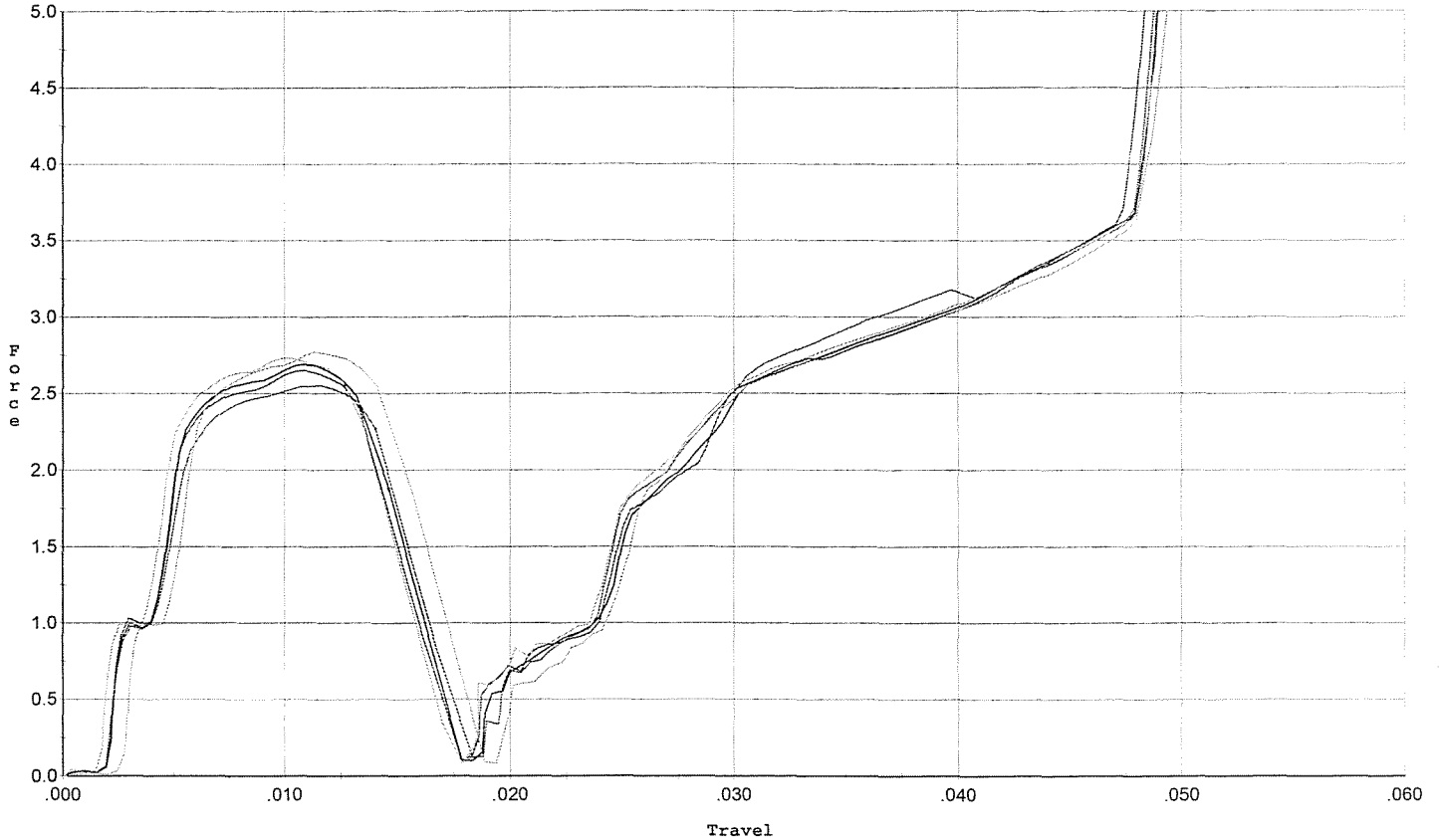
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.014	0.00	0.038	0.022		Set Trigger
2	2.531	0.013	0.00	0.037	0.022		Set Trigger
3	2.425	0.013	0.003	0.038	0.020		Set Trigger
4	2.388	0.014	0.004	0.039	0.020		Set Trigger
5	2.532	0.015	0.00	0.038	0.023		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



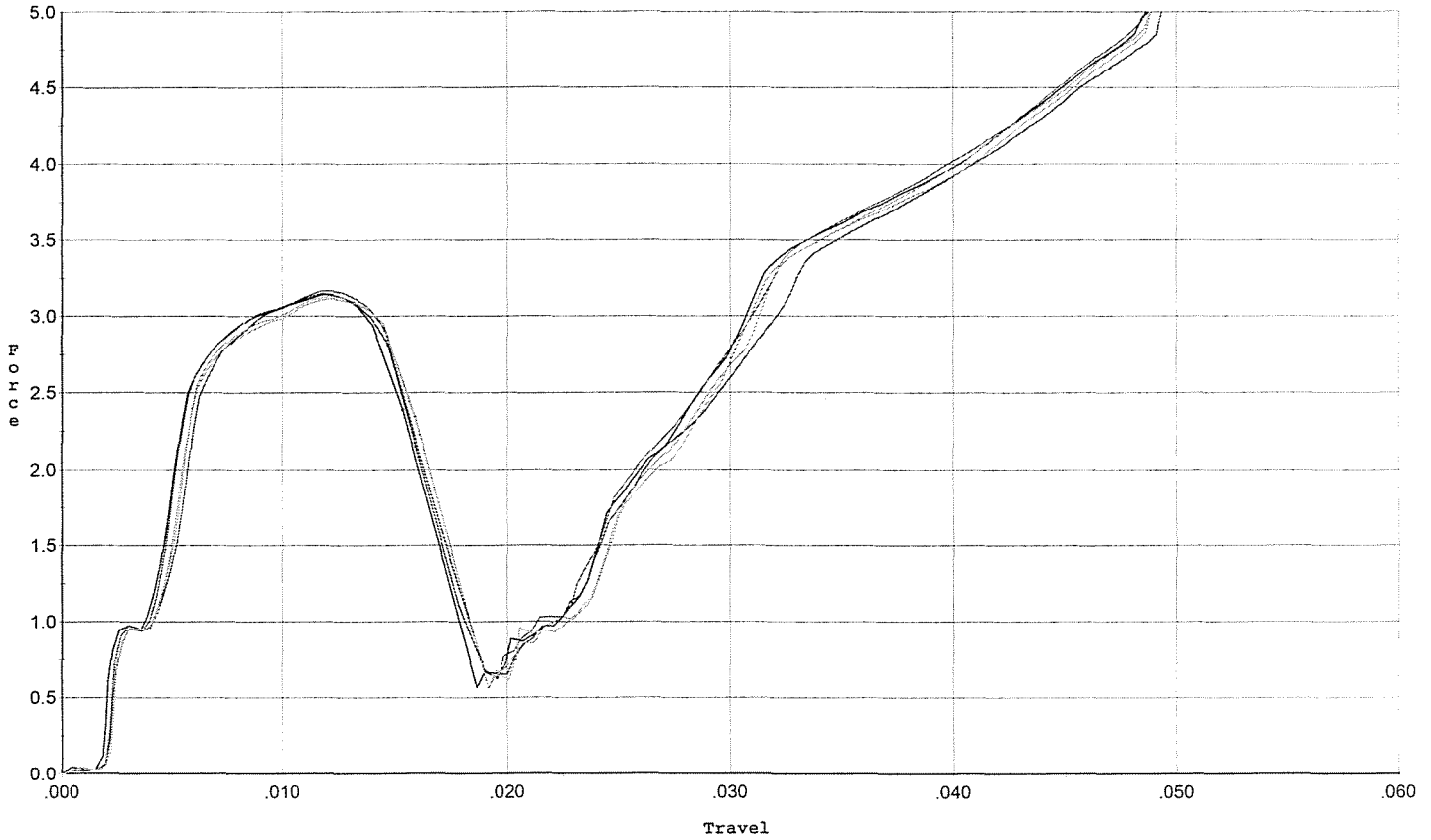
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.649	0.013	0.00	0.037	0.023		Set Trigger
2	2.689	0.015	0.00	0.037	0.025		Set Trigger
3	2.551	0.014	0.002	0.036	0.023		Set Trigger
4	2.730	0.014	0.004	0.037	0.024		Set Trigger
5	2.774	0.016	0.003	0.036	0.027		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



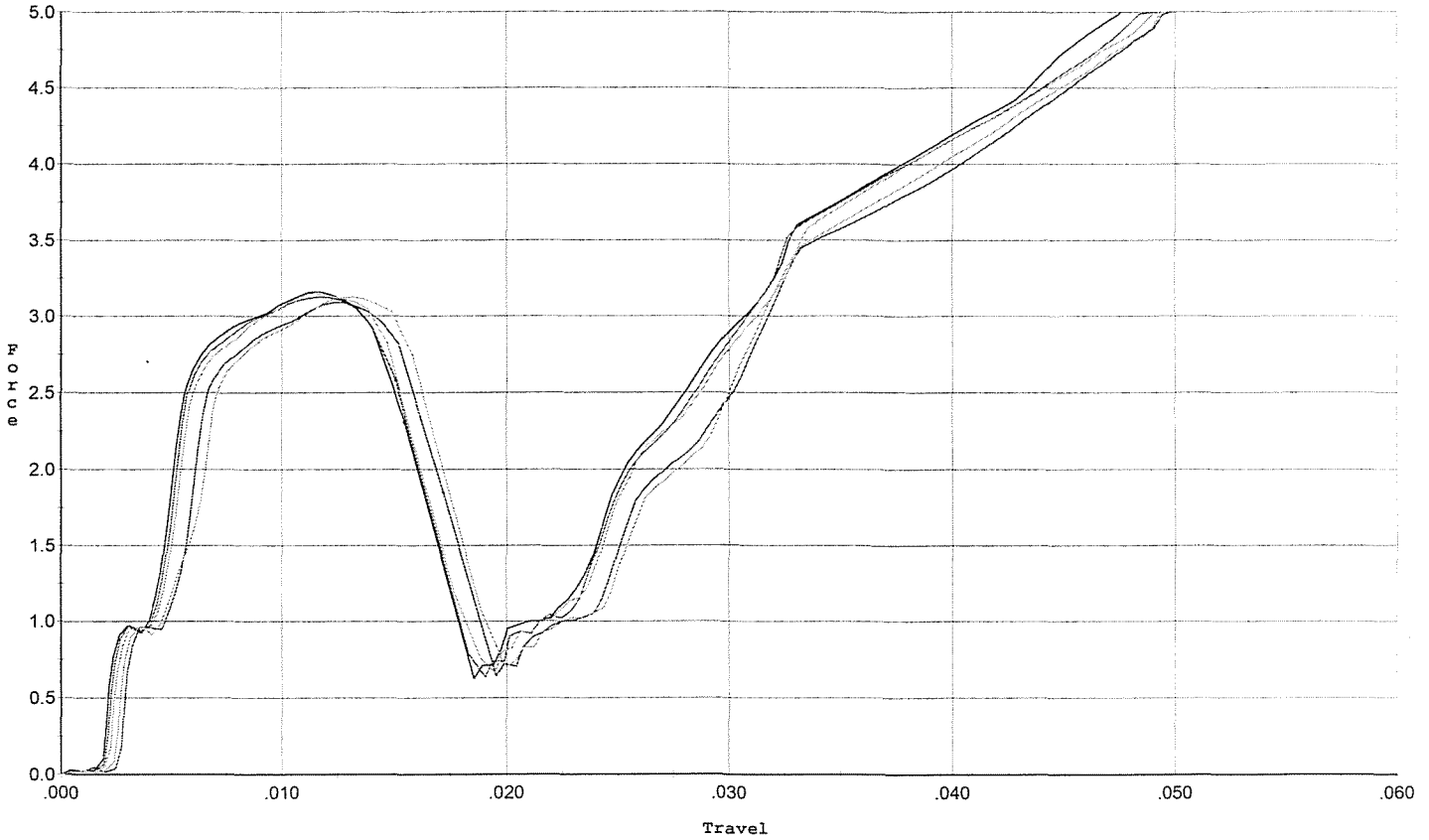
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.015	0.002	0.035	0.029		Set Trigger
2	3.139	0.015	0.002	0.034	0.031		Set Trigger
3	3.168	0.015	0.00	0.034	0.029		Set Trigger
4	3.114	0.016	0.00	0.034	0.031		Set Trigger
5	3.133	0.016	0.00	0.034	0.032		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



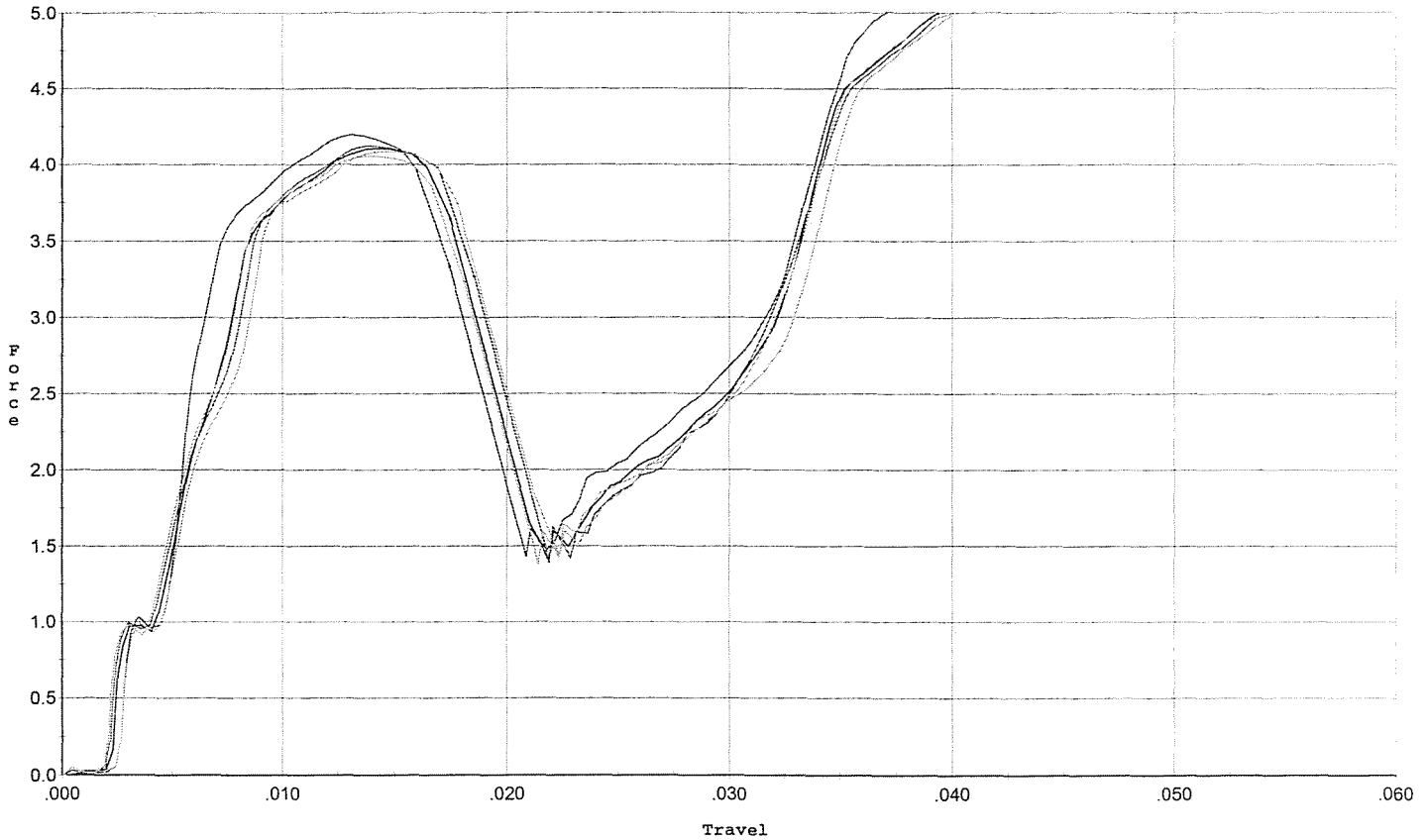
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.088	0.017	0.005	0.034	0.032		Set Trigger
2	3.160	0.015	0.00	0.034	0.031		Set Trigger
3	3.127	0.015	0.00	0.034	0.030		Set Trigger
4	3.151	0.015	0.002	0.034	0.029		Set Trigger
5	3.127	0.016	0.00	0.034	0.030		Set Trigger

A-3.13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



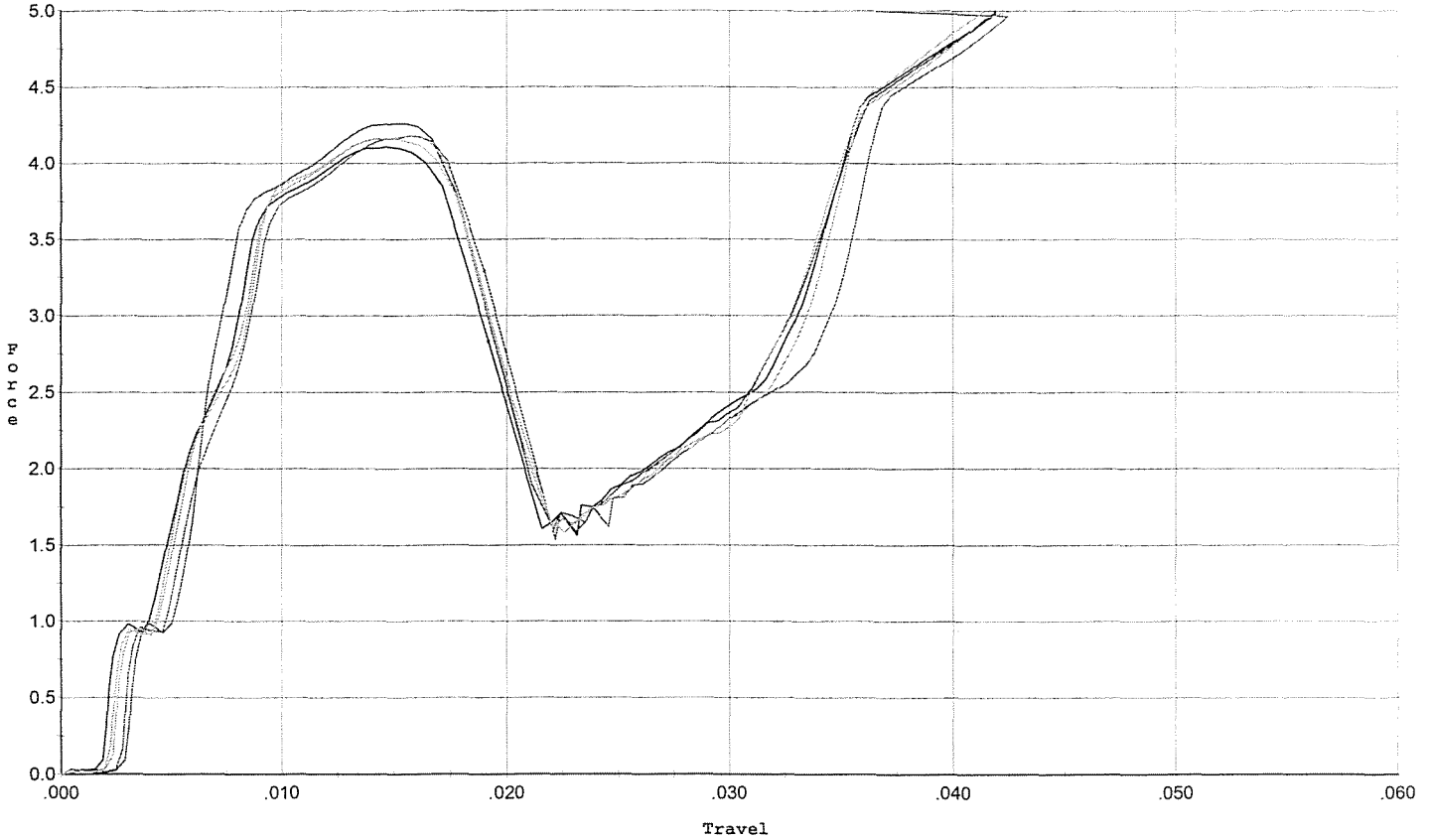
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.198	0.017	0.003	0.032	0.045		Set Trigger
2	4.106	0.017	0.004	0.032	0.044		Set Trigger
3	4.123	0.019	0.00	0.032	0.047		Set Trigger
4	4.058	0.018	0.002	0.032	0.045		Set Trigger
5	4.085	0.018	0.003	0.033	0.044		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



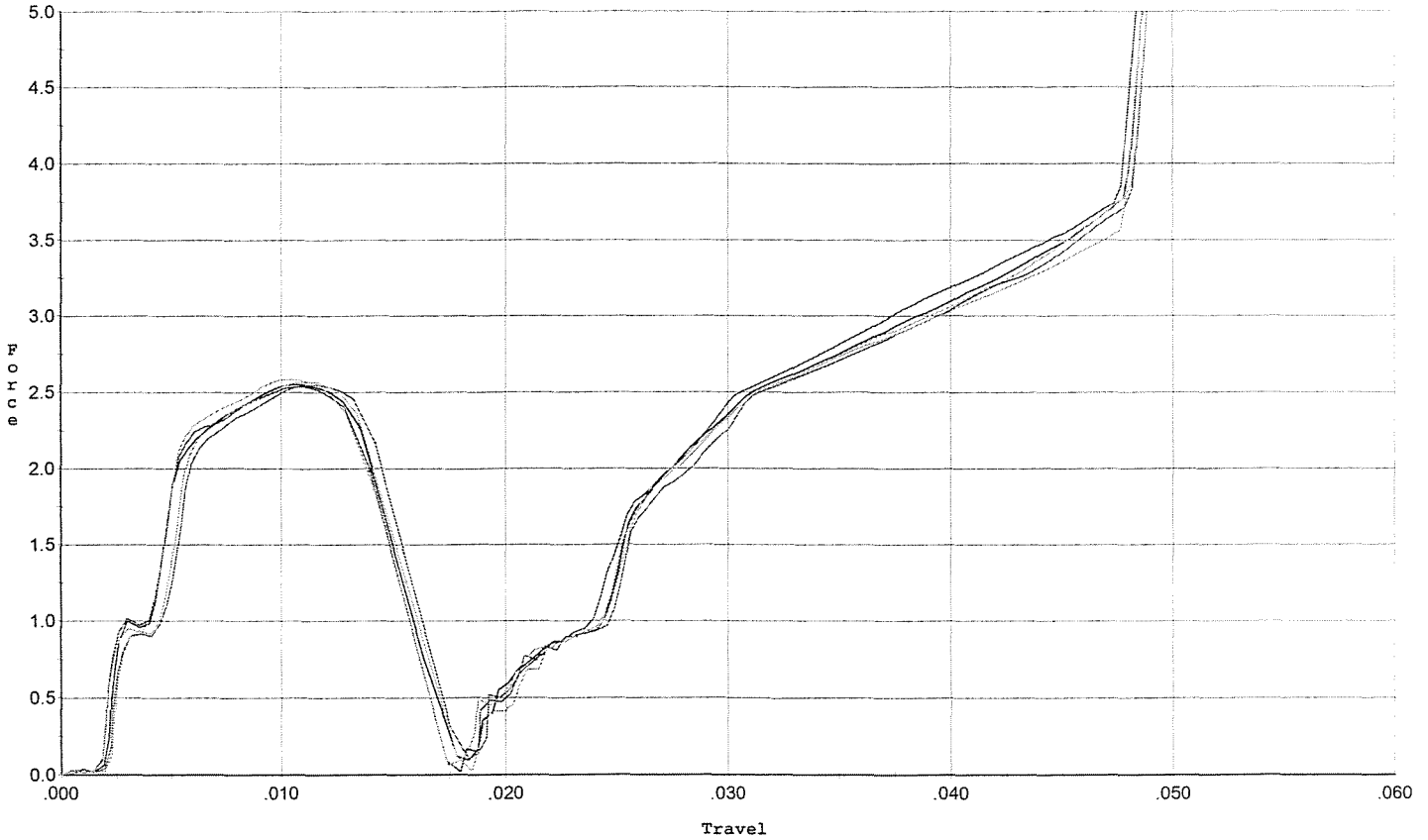
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.259	0.018	0.003	0.033	0.045		Set Trigger
2	4.109	0.019	0.002	0.032	0.048		Set Trigger
3	4.180	0.019	0.003	0.033	0.047		Set Trigger
4	4.158	0.018	0.002	0.032	0.045		Set Trigger
5	4.178	0.017	0.002	0.032	0.044		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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



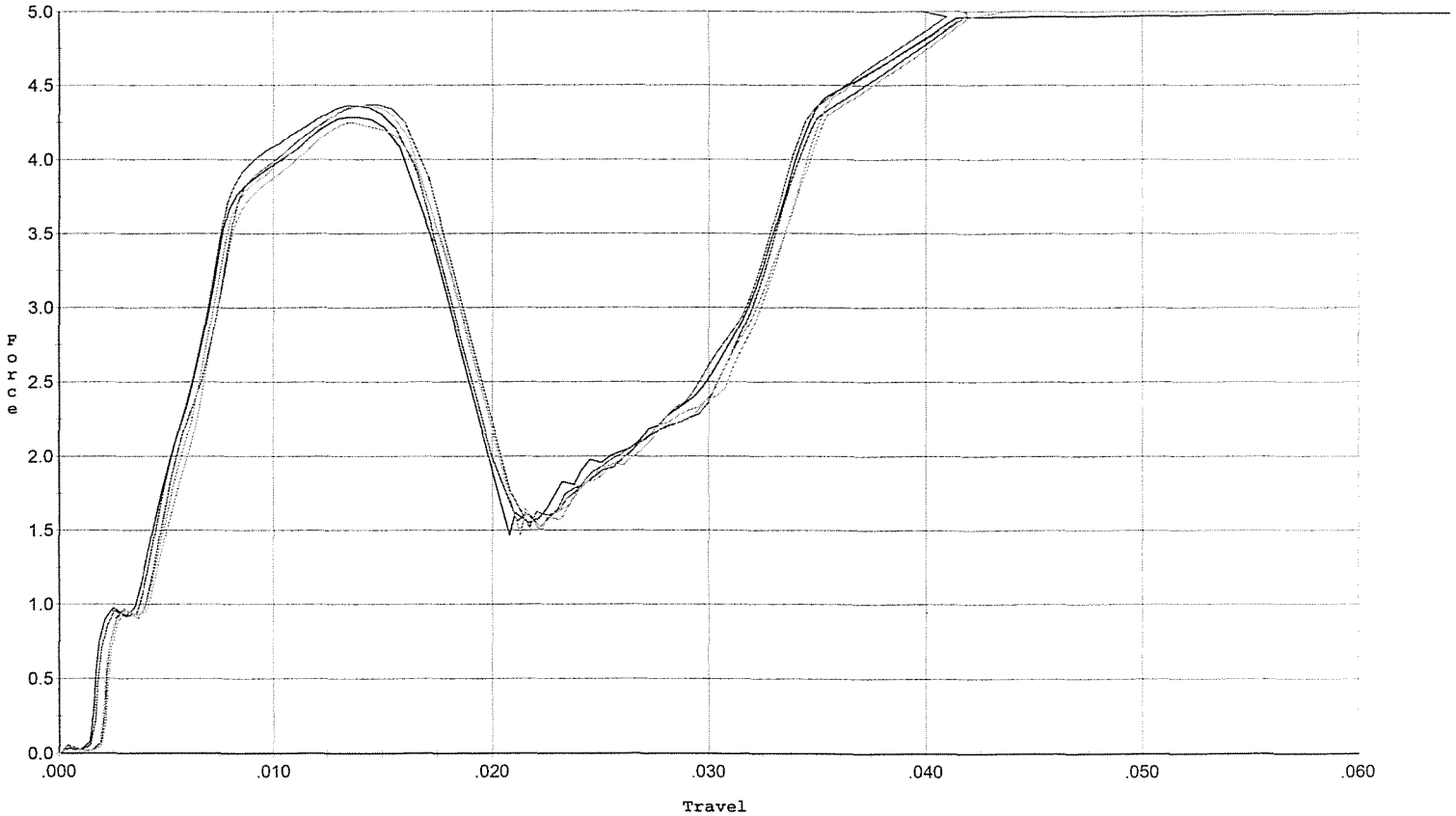
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.535	0.014	0.00	0.037	0.023		Set Trigger
2	2.551	0.014	0.00	0.037	0.022		Set Trigger
3	2.547	0.014	0.002	0.037	0.023		Set Trigger
4	2.568	0.016	0.002	0.037	0.025		Set Trigger
5	2.585	0.014	0.00	0.037	0.023		Set Trigger

A 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/4/2009

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	4.362	0.017	0.00	0.032	0.044		Set Trigger
2	4.284	0.017	0.00	0.032	0.046		Set Trigger
3	4.369	0.017	0.002	0.032	0.045		Set Trigger
4	4.359	0.018	0.002	0.032	0.047		Set Trigger
5	4.250	0.018	0.002	0.032	0.046		Set Trigger

A-4.32