

G6801440

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

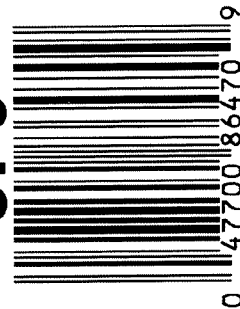
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6801440

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G680 1440

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-15-09	RT
430	ASSEMBLE TO STOCK		5-19-09	WV
440	PROOF		5-19-09	WV
460	CHECK HEADSPACE		5-19-09	WV
470	DIS-ASSEMBLE ACTION		5-19-09	RT
472	SERIALIZE BOLT HANDLE		5-19-09	RT
480	MAGNAFLUX BBL ACTION	MAGNA - FLUX MAY 29 2009 OPERATOR W	5/21/09	(W)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/22/09	RT
510	DRILL AND TAP SIGHT HOLES		5-19-09	SP
520	GOFF BLAST BBL / REC		5-19-09	WV
540	APPLY COATINGS (BARREL ACTION)		6/2	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-2-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-2-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-2-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-3-09	WV
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

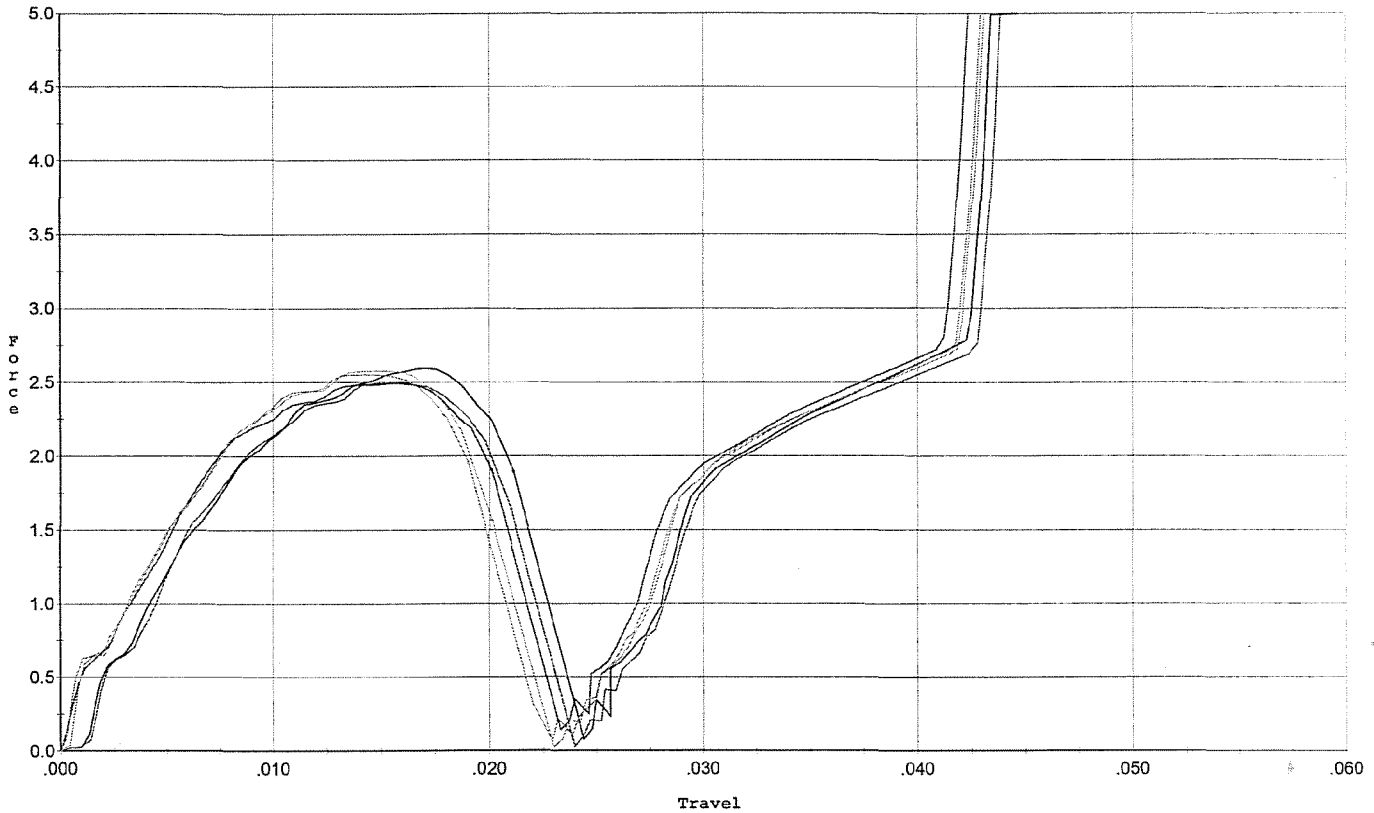
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	6-22-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	6-22-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	6-22-09	LN
	J) ASSEMBLE STOCK		6-3-09	LN
	K) ASSEMBLE SWIVEL STUDS		6-22-09	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	6/16/09	LR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TQR
670	FINAL INSPECTION A) HEADSPACE		6-22-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.57</u> <u>2.41</u> <u>2.64</u> <u>2.65</u>	6-18-09	LN
	C) FUNCTION		6-22-09	LN
690	PACK		7/17/09	Em

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



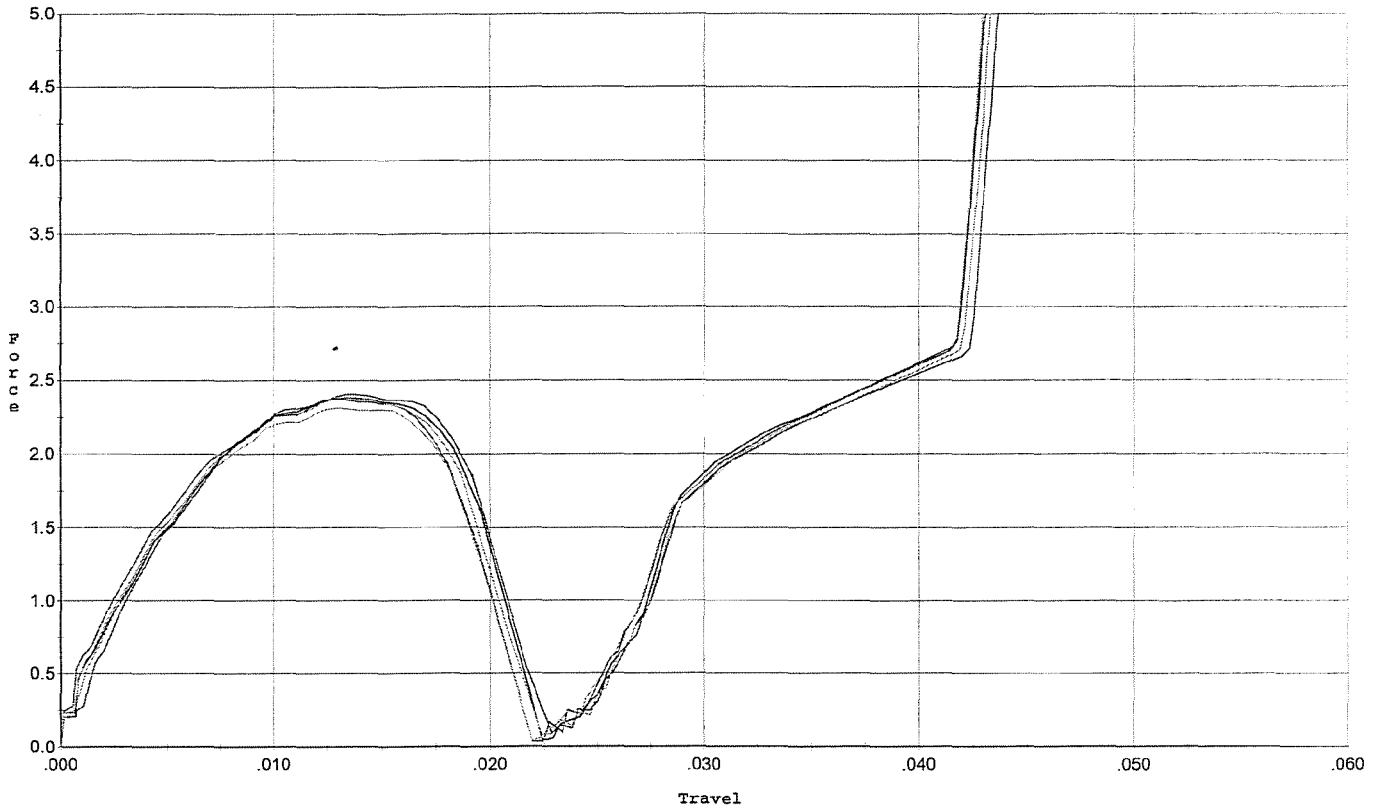
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.496	0.020	0.00	0.027	0.036		Set Trigger
2	2.594	0.021	0.00	0.028	0.036		Set Trigger
3	2.492	0.021	0.00	0.028	0.035		Set Trigger
4	2.577	0.020	0.00	0.028	0.036		Set Trigger
5	2.551	0.019	0.00	0.028	0.034		Set Trigger

A. 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



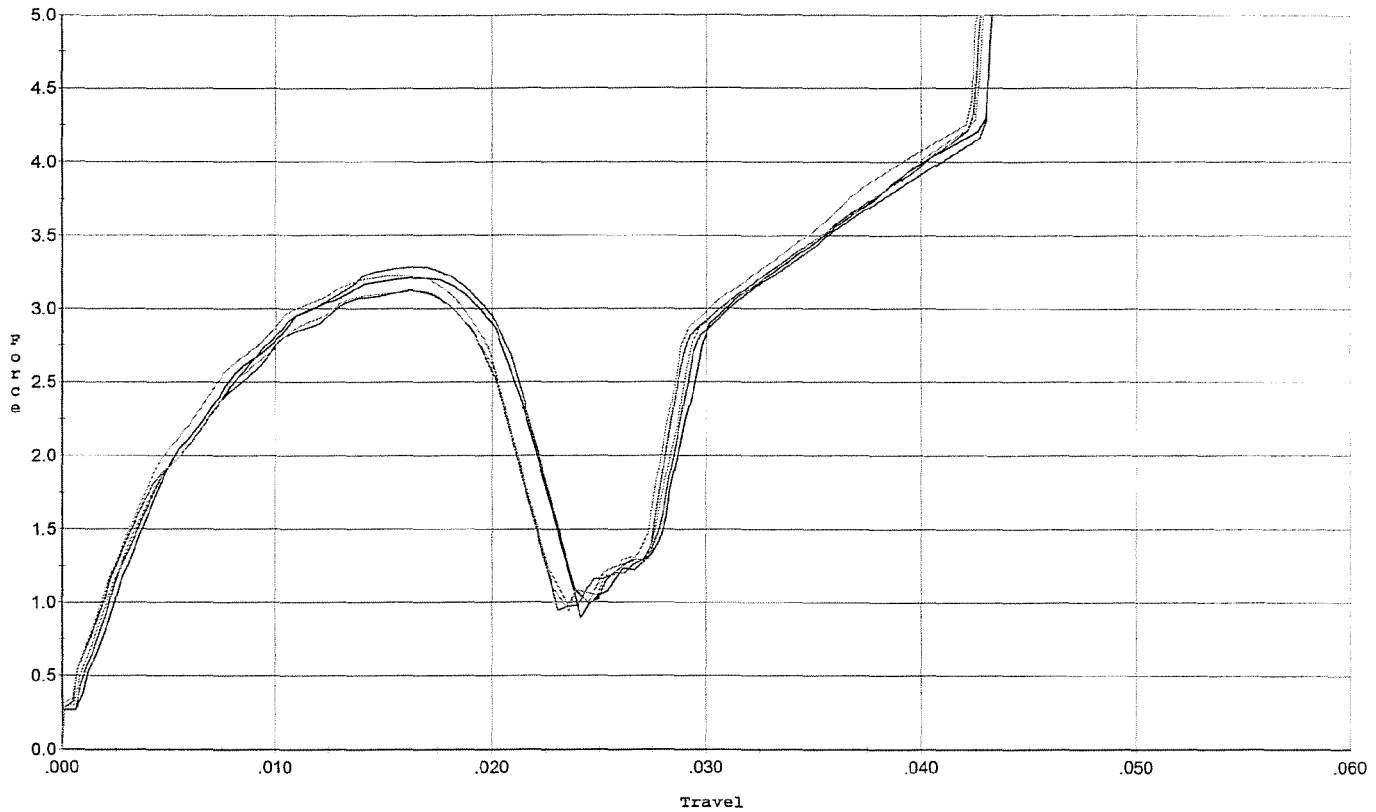
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.404	0.019	0.00	0.029	0.033		Set Trigger
2	2.383	0.020	0.00	0.029	0.034		Set Trigger
3	2.375	0.019	0.00	0.029	0.034		Set Trigger
4	2.312	0.020	0.00	0.029	0.033		Set Trigger
5	2.386	0.019	0.00	0.029	0.032		Set Trigger

~~A 2.72~~ cms
A 2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



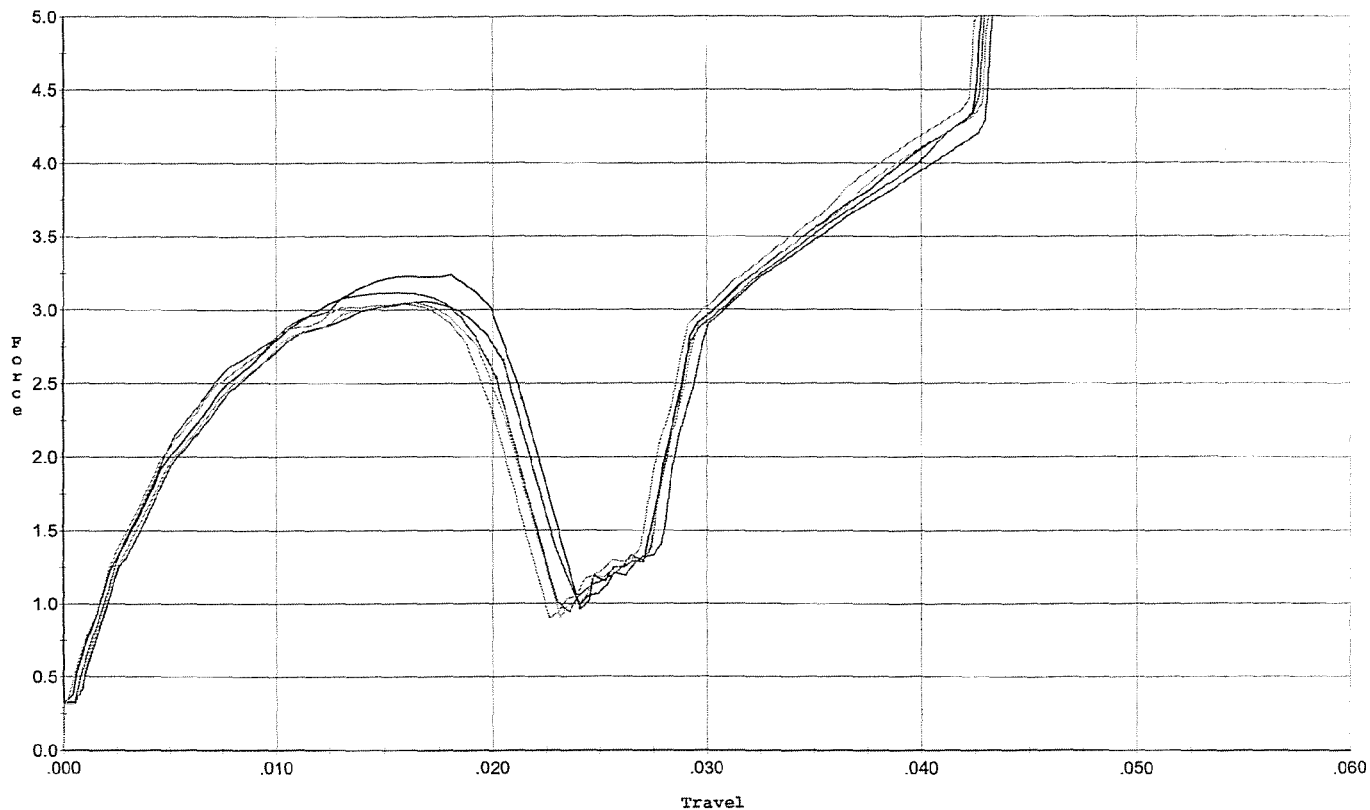
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.285	0.021	0.00	0.026	0.048		Set Trigger
2	3.210	0.021	0.00	0.026	0.049		Set Trigger
3	3.128	0.020	0.00	0.027	0.045		Set Trigger
4	3.125	0.020	0.00	0.027	0.044		Set Trigger
5	3.223	0.020	0.00	0.027	0.046		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



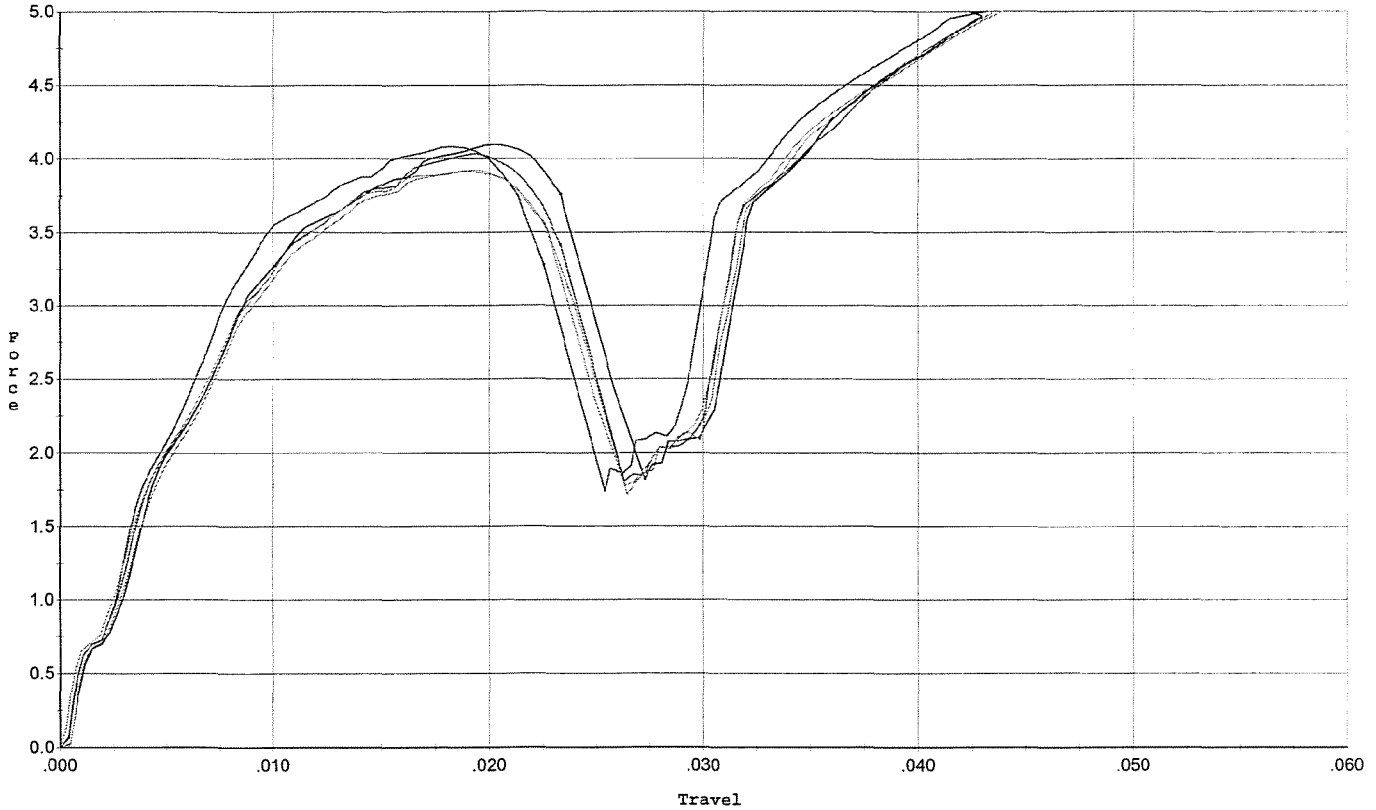
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.056	0.020	0.00	0.027	0.045		Set Trigger
2	3.238	0.021	0.00	0.026	0.050		Set Trigger
3	3.117	0.020	0.00	0.026	0.046		Set Trigger
4	3.045	0.021	0.00	0.027	0.045		Set Trigger
5	3.038	0.020	0.00	0.027	0.045		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



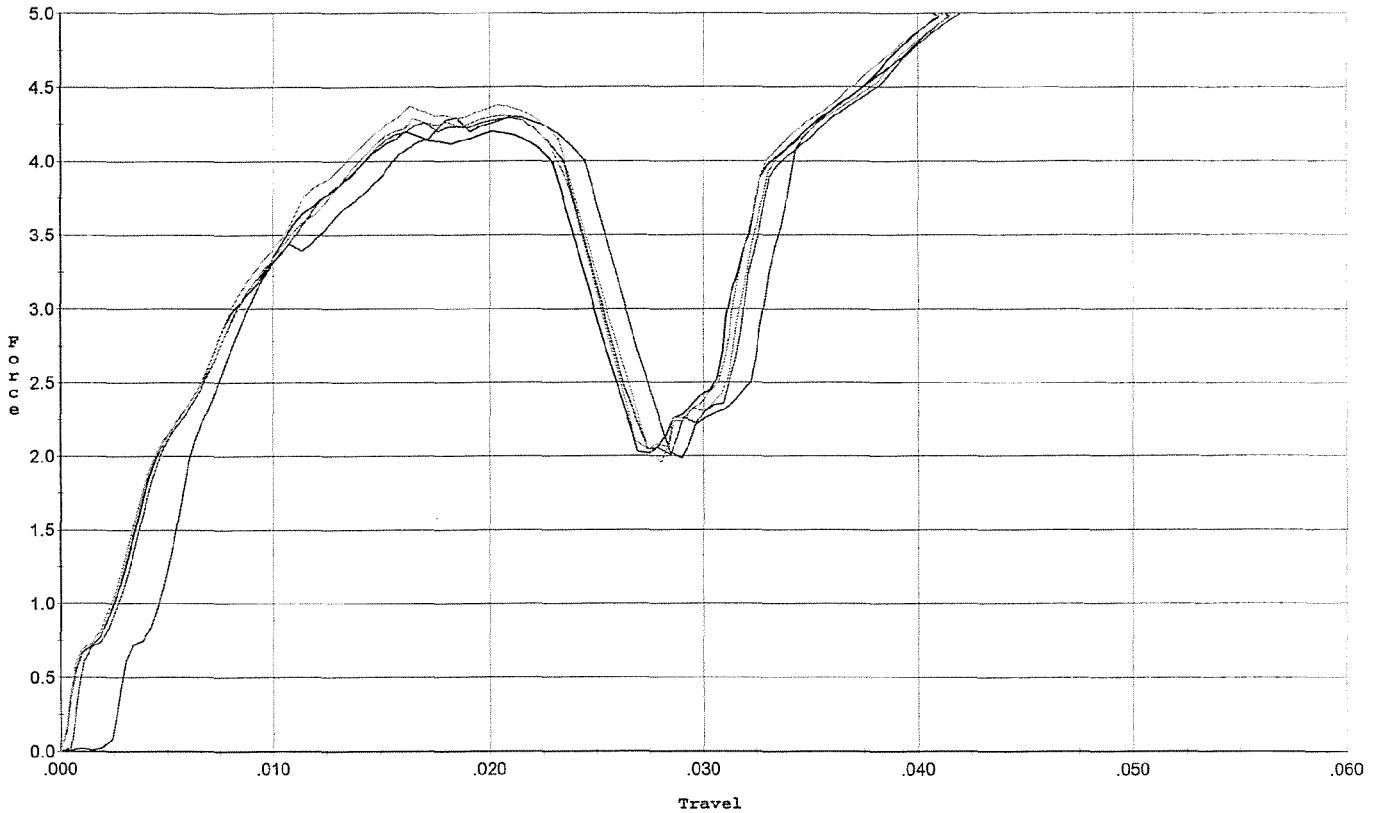
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.082	0.023	0.00	0.020	0.063		Set Trigger
2	4.099	0.023	0.00	0.020	0.065		Set Trigger
3	4.035	0.023	0.00	0.020	0.064		Set Trigger
4	3.926	0.023	0.00	0.021	0.062		Set Trigger
5	3.914	0.024	0.00	0.021	0.064		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



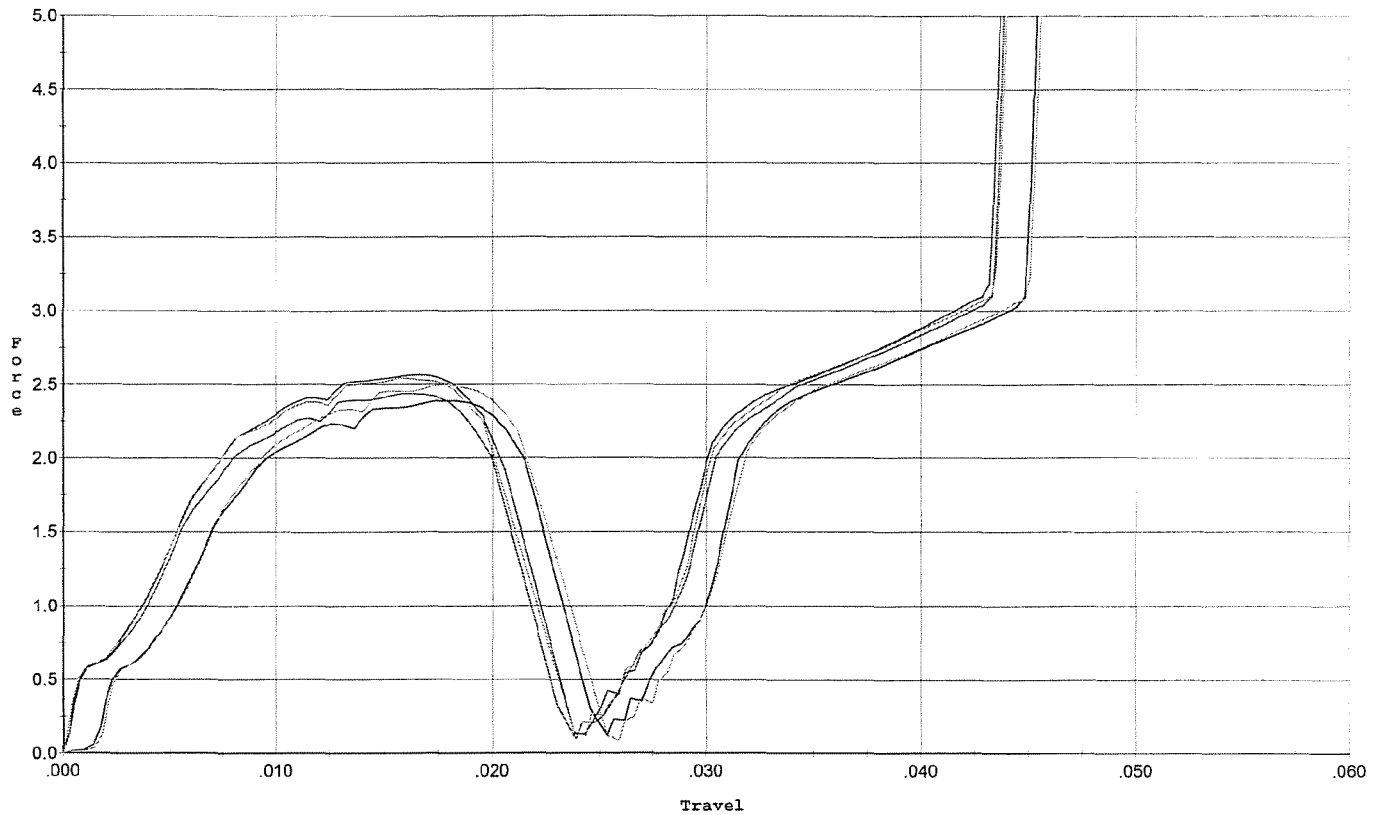
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.302	0.024	0.00	0.019	0.068		Set Trigger
2	4.202	0.023	0.00	0.019	0.067		Set Trigger
3	4.292	0.023	0.00	0.019	0.068		Set Trigger
4	4.379	0.023	0.00	0.018	0.069		Set Trigger
5	4.307	0.024	0.00	0.019	0.070		Set Trigger

A-4-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



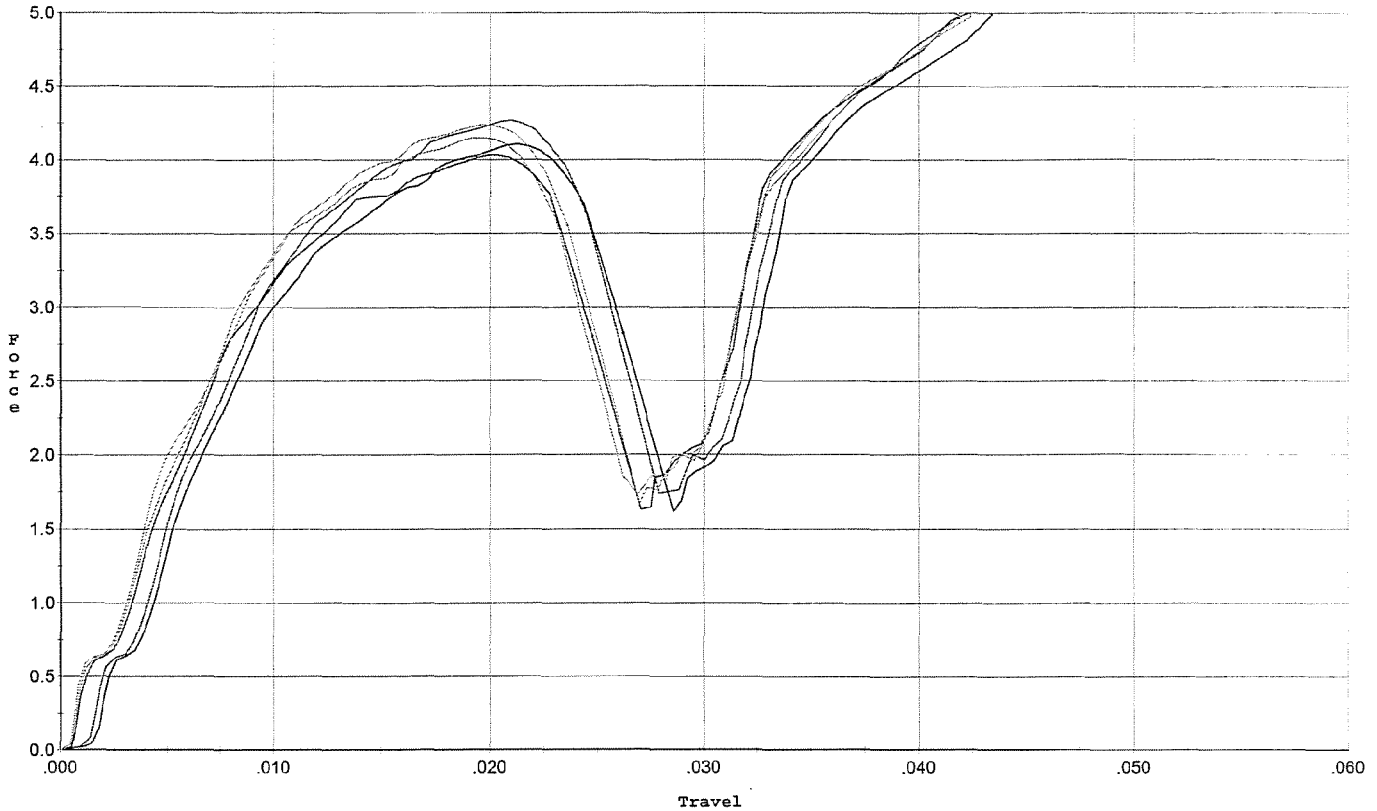
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.568	0.021	0.00	0.028	0.037		Set Trigger
2	2.389	0.021	0.00	0.029	0.035		Set Trigger
3	2.437	0.020	0.00	0.029	0.035		Set Trigger
4	2.493	0.023	0.00	0.029	0.038		Set Trigger
5	2.541	0.020	0.00	0.029	0.035		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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	4.029	0.025	0.00	0.019	0.067		Set Trigger
2	4.108	0.026	0.00	0.019	0.069		Set Trigger
3	4.268	0.024	0.00	0.019	0.067		Set Trigger
4	4.237	0.024	0.00	0.019	0.067		Set Trigger
5	4.148	0.023	0.00	0.020	0.064		Set Trigger

A-4.15