

G6858447

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



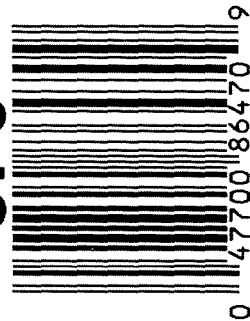
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6858447

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6858447

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-16-09	SP
430	ASSEMBLE TO STOCK		6-16-09	SP
440	PROOF		6-16-09	SP
460	CHECK HEADSPACE		6-16-09	SP
470	DIS-ASSEMBLE ACTION		6-16-09	SP
472	SERIALIZE BOLT HANDLE		6-17-09	RT
480	MAGNAFLUX BBL ACTION		6-20-09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-23-09	RT
510	DRILL AND TAP SIGHT HOLES		6-17-09	SP
520	GOFF BLAST BBL / REC		6-23-09	ms
540	APPLY COATINGS (BARREL ACTION)		7-25	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-13-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-19-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

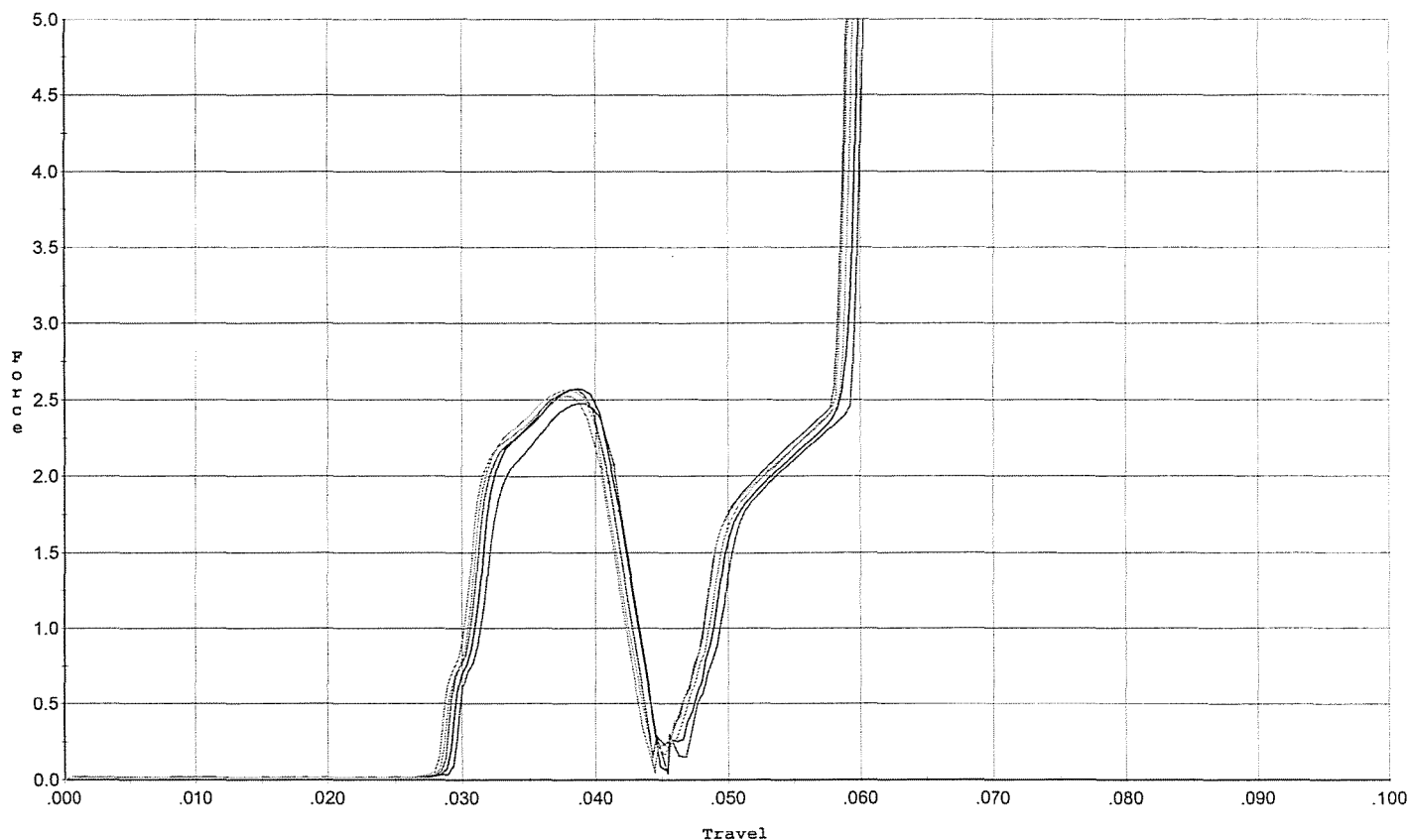
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	8/26/09	RB
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>8°</u> <u>8°</u> <u>8°</u>	8/26/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	8/26/09	RB
	J) ASSEMBLE STOCK		8-19-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		8/26/09	RB
	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	8/25/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/25/09	TAR
670	FINAL INSPECTION A) HEADSPACE		8/26/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.58</u> <u>2.67</u> <u>2.70</u> <u>2.69</u>	8/26/09	RB
	C) FUNCTION		8/26/09	RB
690	PACK		8/26/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



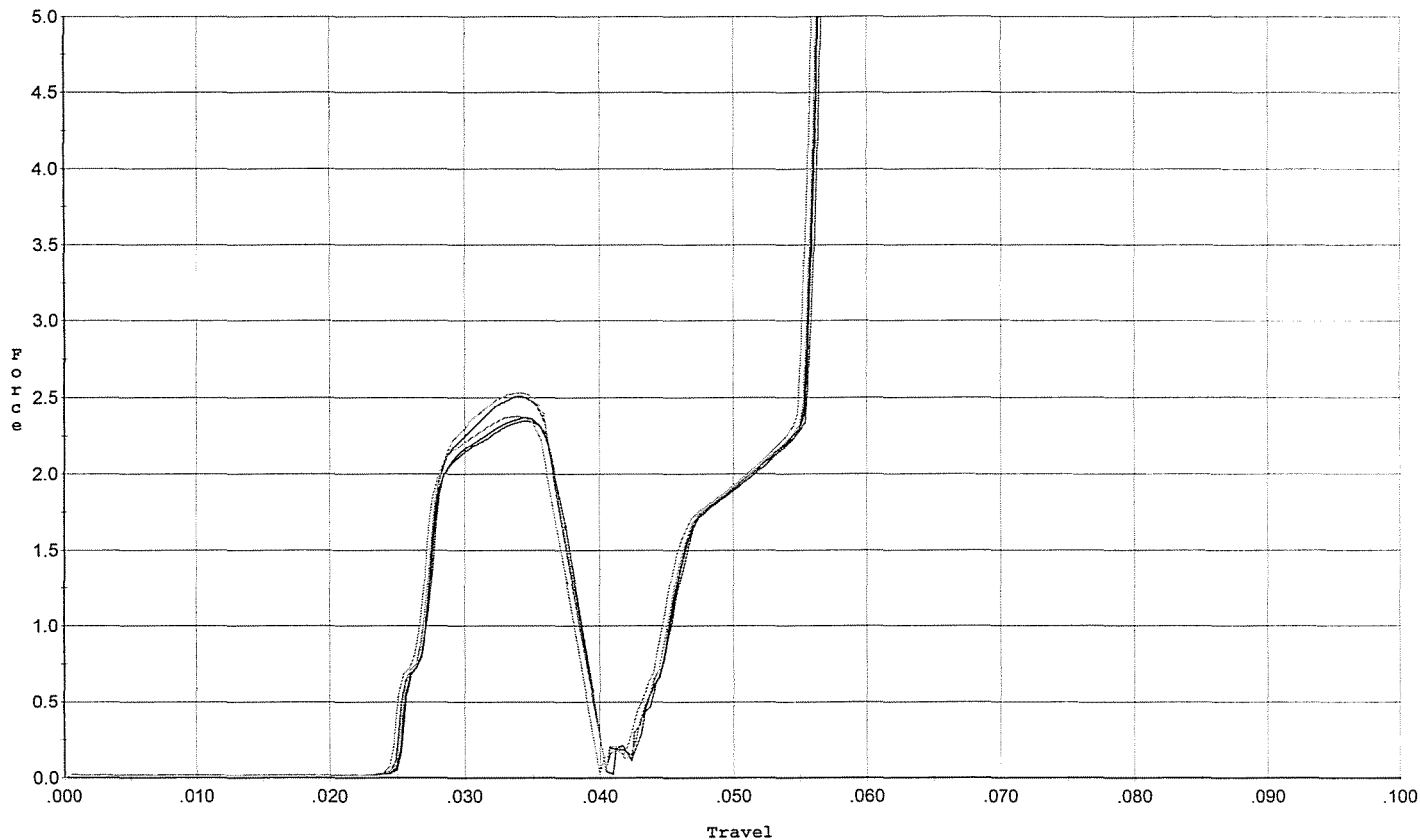
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.041	0.029	0.025	0.025		Set Trigger
2	2.573	0.042	0.029	0.025	0.027		Set Trigger
3	2.566	0.041	0.029	0.024	0.027		Set Trigger
4	2.564	0.040	0.029	0.025	0.026		Set Trigger
5	2.523	0.040	0.028	0.025	0.026		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



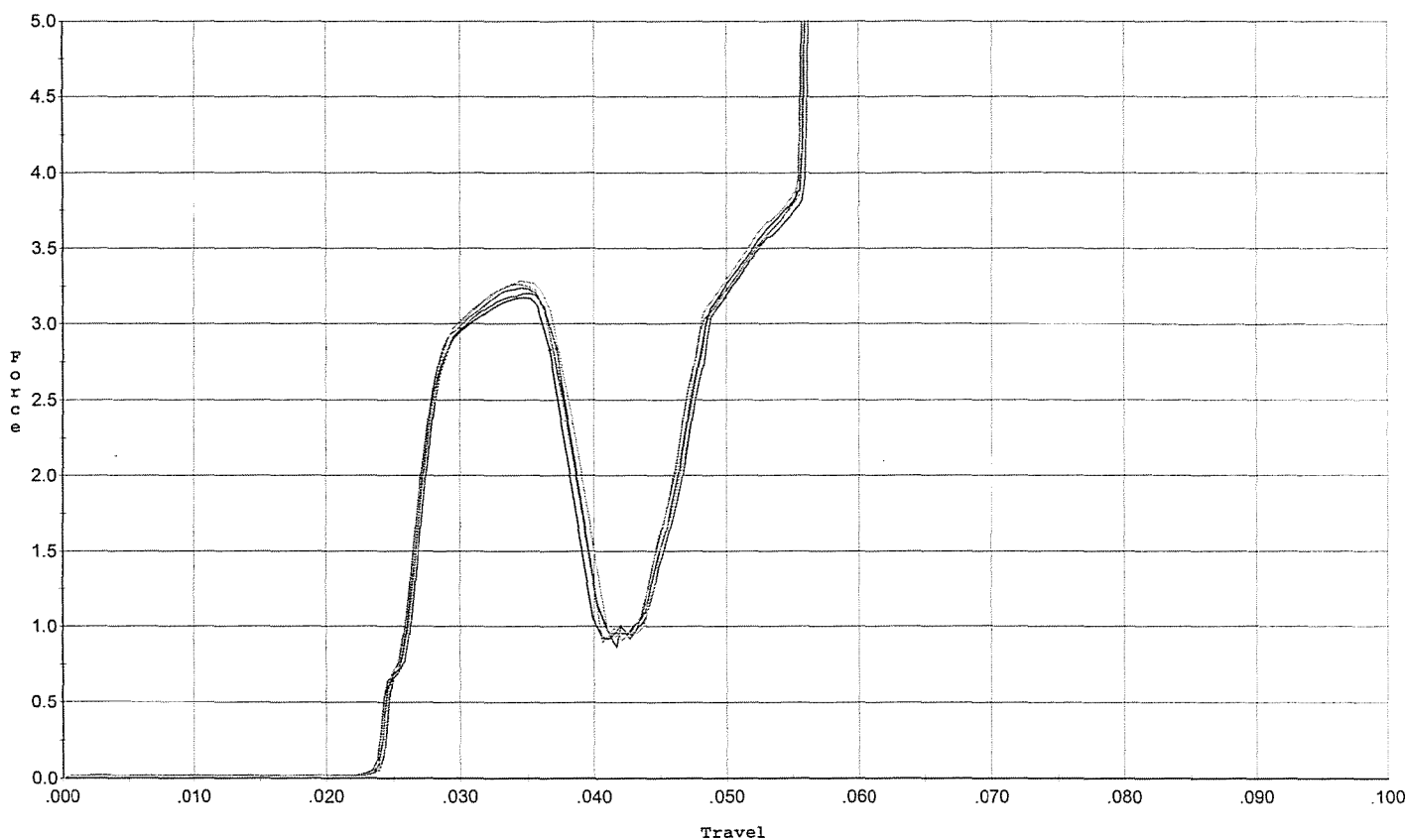
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.350	0.037	0.025	0.025	0.024		Set Trigger
2	2.373	0.036	0.025	0.026	0.023		Set Trigger
3	2.509	0.038	0.025	0.025	0.026		Set Trigger
4	2.532	0.036	0.025	0.026	0.025		Set Trigger
5	2.380	0.038	0.025	0.025	0.025		Set Trigger

A-2-42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



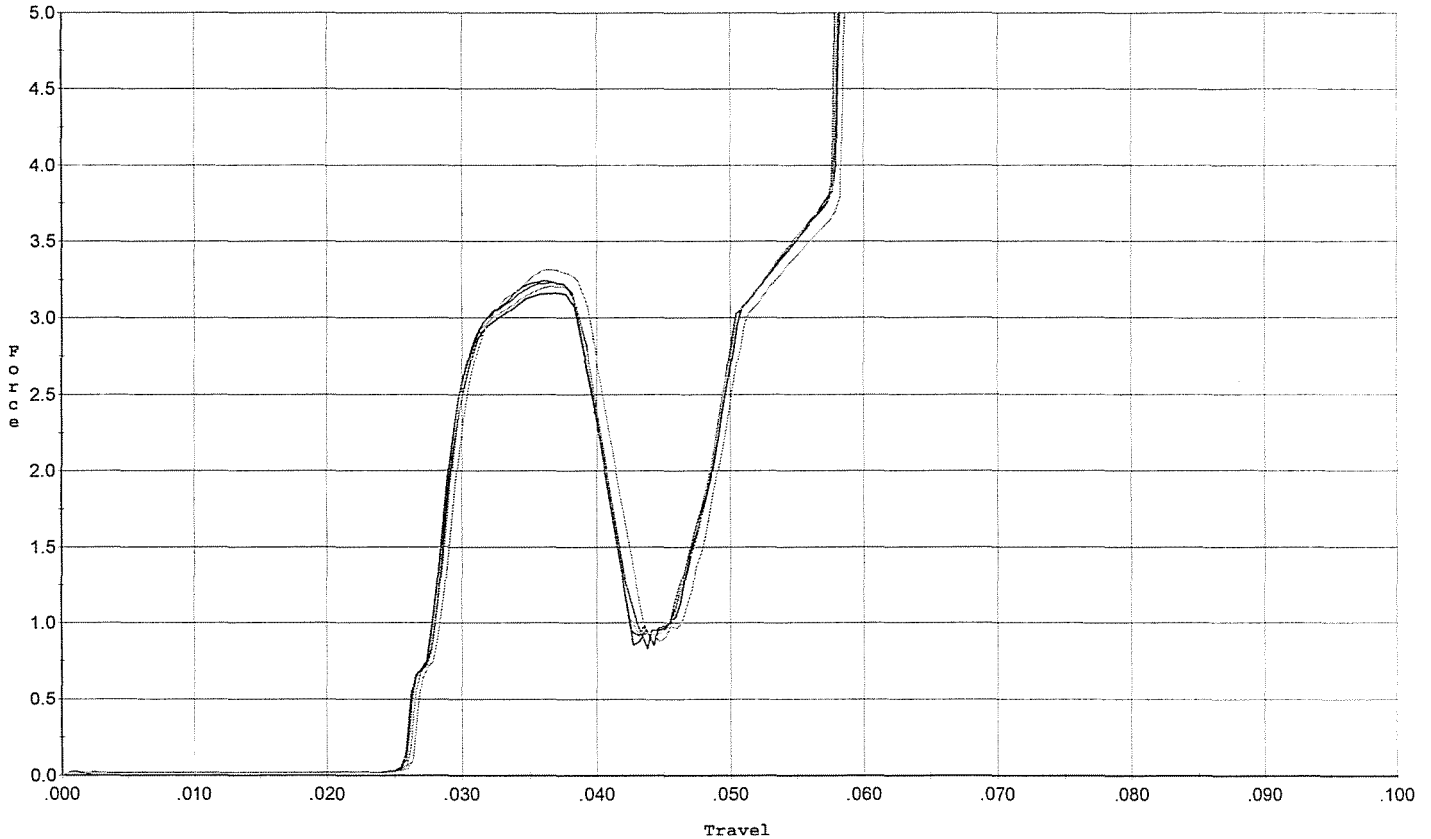
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.205	0.037	0.024	0.024	0.035		Set Trigger
2	3.175	0.037	0.024	0.024	0.034		Set Trigger
3	3.240	0.038	0.024	0.024	0.037		Set Trigger
4	3.285	0.038	0.024	0.023	0.038		Set Trigger
5	3.261	0.038	0.024	0.024	0.037		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



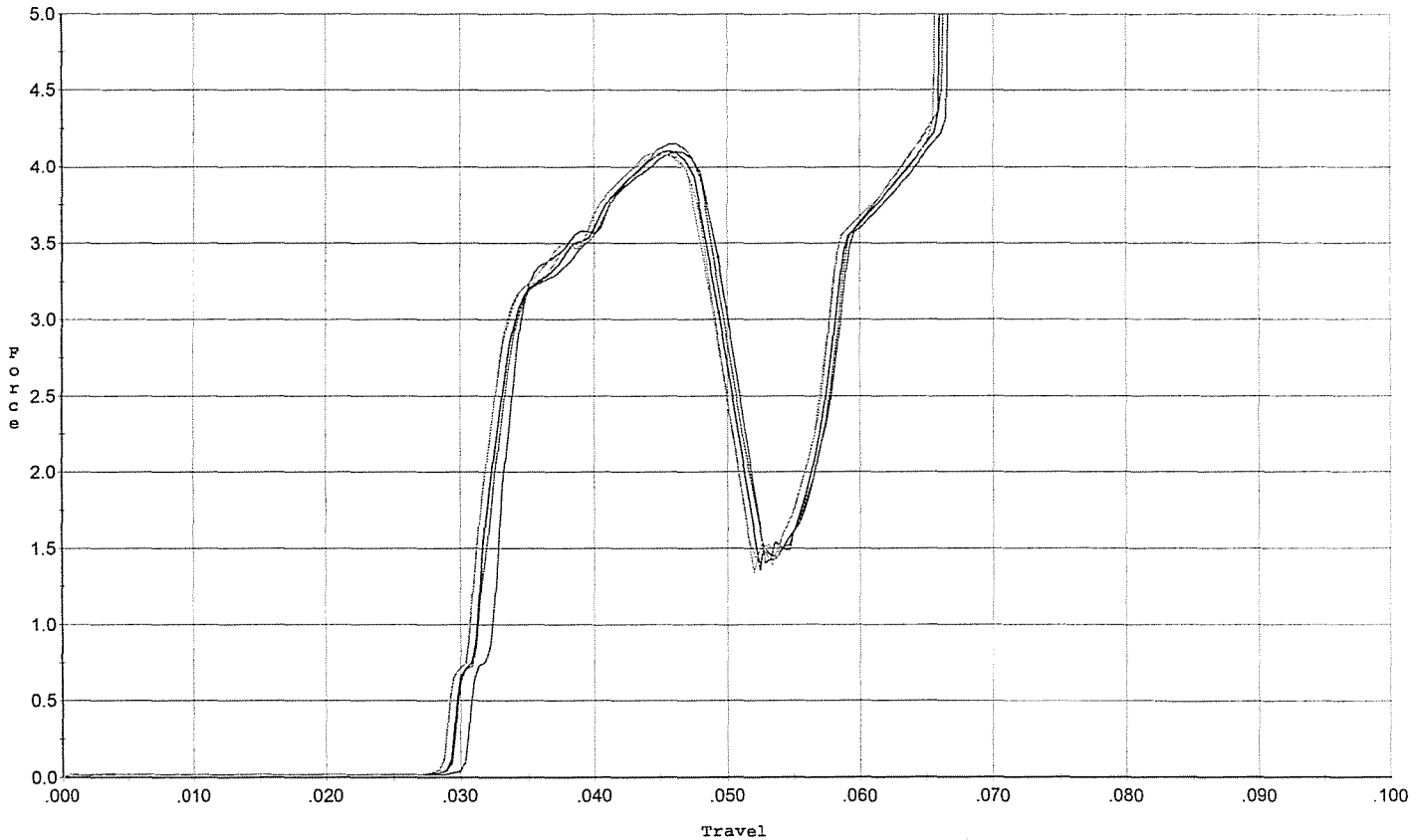
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.245	0.039	0.026	0.024	0.037		Set Trigger
2	3.165	0.040	0.026	0.024	0.036		Set Trigger
3	3.231	0.040	0.026	0.024	0.037		Set Trigger
4	3.206	0.039	0.026	0.024	0.036		Set Trigger
5	3.316	0.039	0.026	0.024	0.037		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



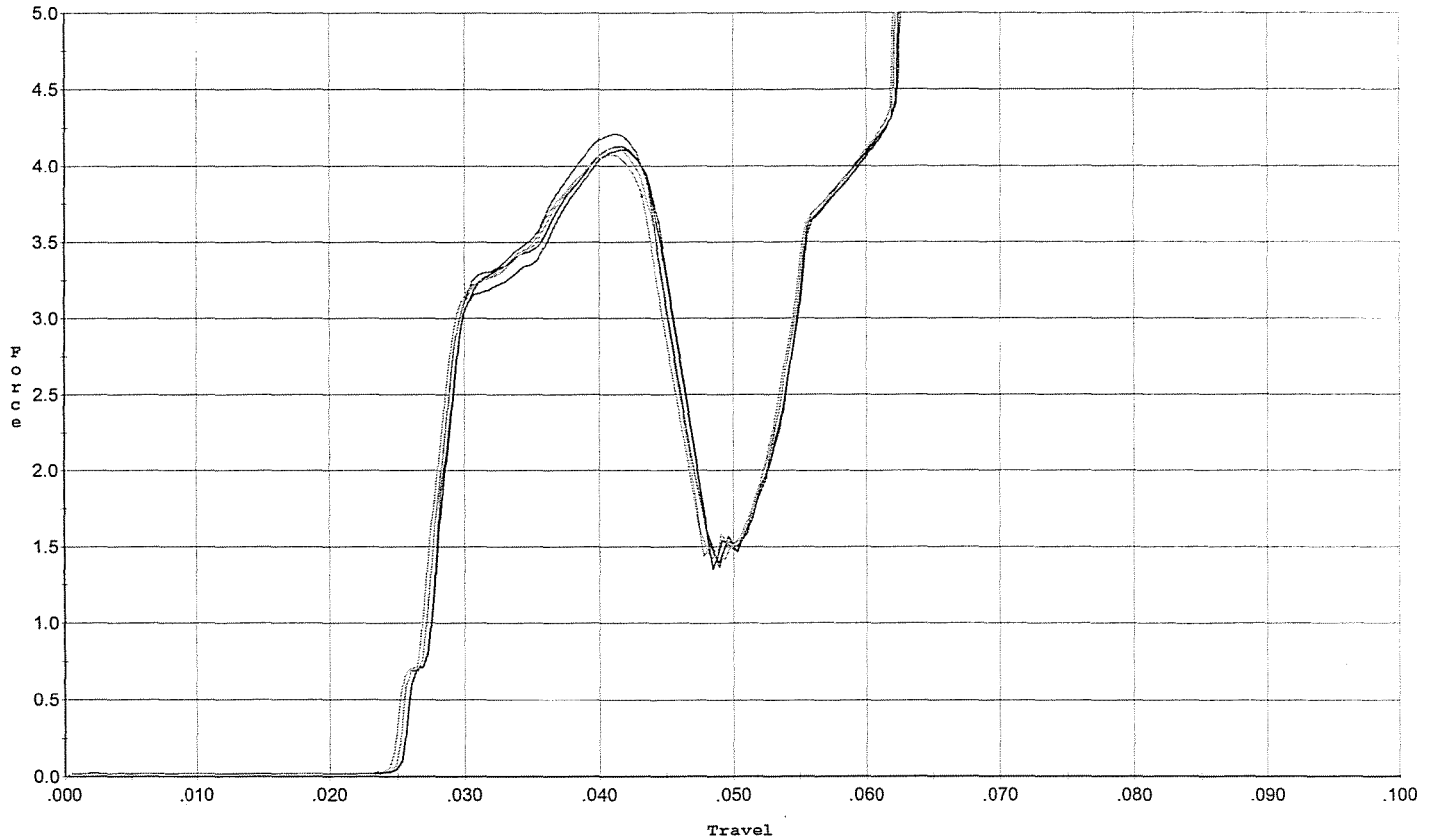
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.049	0.030	0.021	0.064		Set Trigger
2	4.104	0.049	0.029	0.021	0.066		Set Trigger
3	4.152	0.048	0.030	0.022	0.064		Set Trigger
4	4.080	0.049	0.029	0.022	0.065		Set Trigger
5	4.096	0.048	0.029	0.021	0.065		Set Trigger

A 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



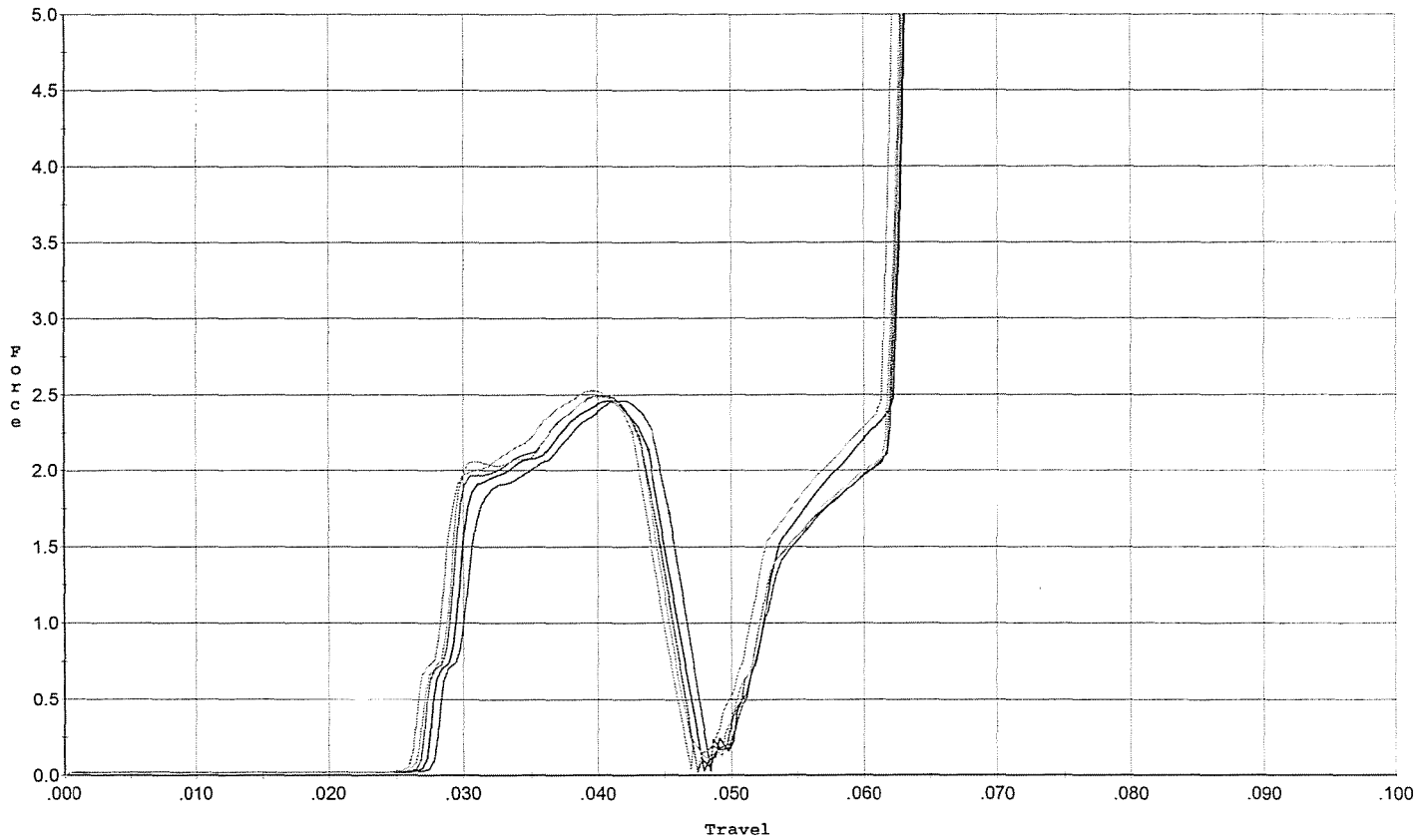
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.044	0.026	0.022	0.063		Set Trigger
2	4.127	0.045	0.025	0.022	0.064		Set Trigger
3	4.211	0.044	0.025	0.022	0.063		Set Trigger
4	4.120	0.044	0.025	0.022	0.063		Set Trigger
5	4.074	0.043	0.025	0.022	0.061		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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



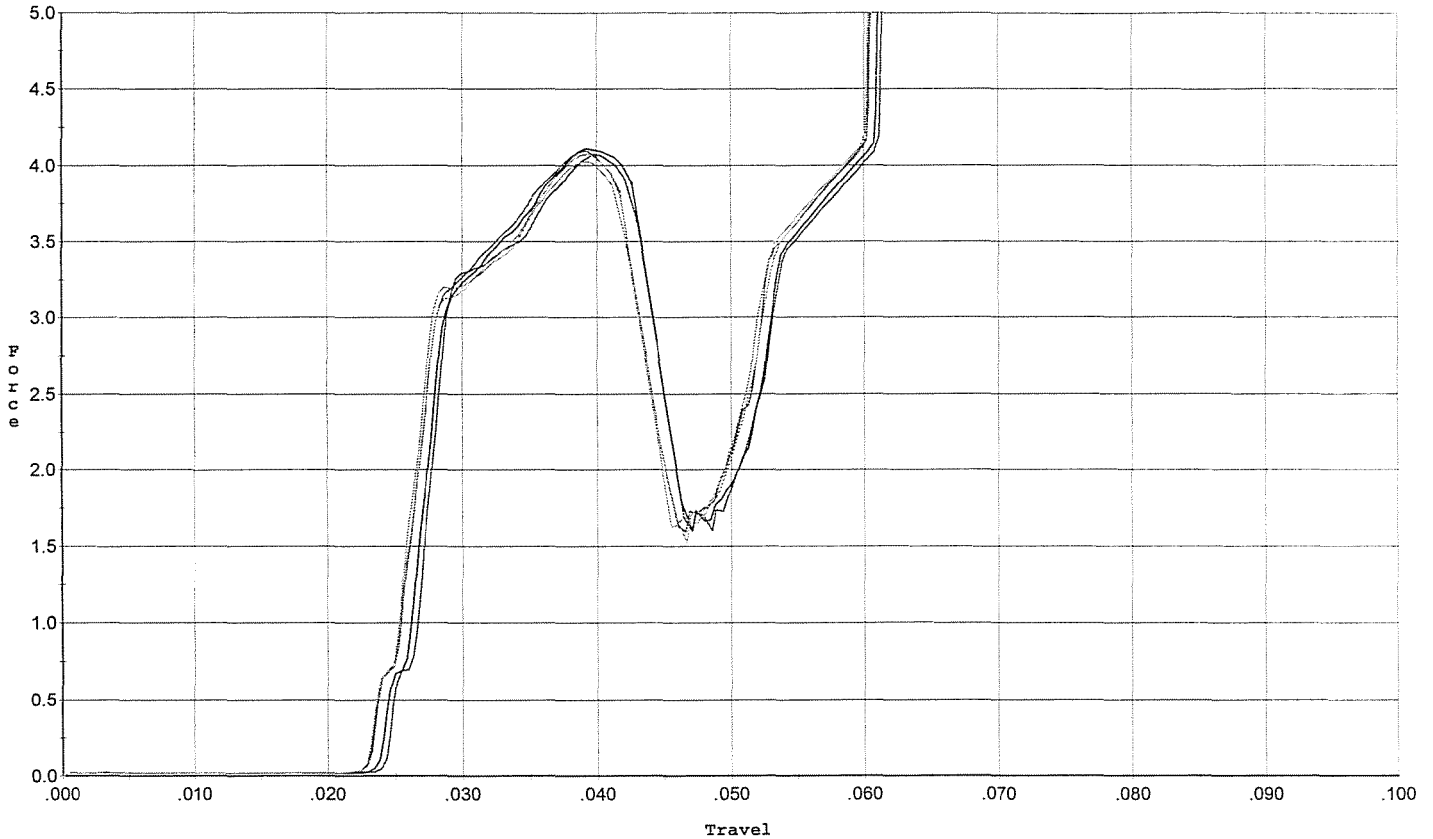
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.045	0.028	0.024	0.035		Set Trigger
2	2.458	0.044	0.027	0.026	0.034		Set Trigger
3	2.496	0.045	0.027	0.025	0.036		Set Trigger
4	2.494	0.043	0.027	0.026	0.035		Set Trigger
5	2.528	0.043	0.026	0.026	0.035		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/13/2009

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	4.073	0.043	0.024	0.022	0.061		Set Trigger
2	4.111	0.043	0.024	0.022	0.062		Set Trigger
3	4.096	0.042	0.023	0.022	0.061		Set Trigger
4	4.073	0.042	0.023	0.022	0.060		Set Trigger
5	4.025	0.042	0.023	0.022	0.061		Set Trigger

A-4.07