

G6810403

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

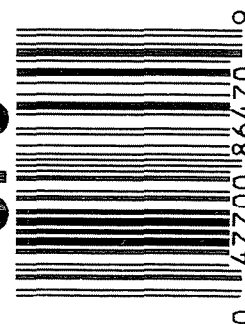
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810403

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6810403

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-9-09	SPD
430	ASSEMBLE TO STOCK		2-9-09	SP
440	PROOF		2-9-09	SPD
460	CHECK HEADSPACE		2-9-09	SPD
470	DIS-ASSEMBLE ACTION		2-9-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	2-9-09	RR
475	DRILL AND TAP SIGHT HOLES		2-10-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	2/13/09	
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/13/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DE
542	APPLY COATINGS (BARREL ACTION)		2/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-18-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-18-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-18-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-18-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

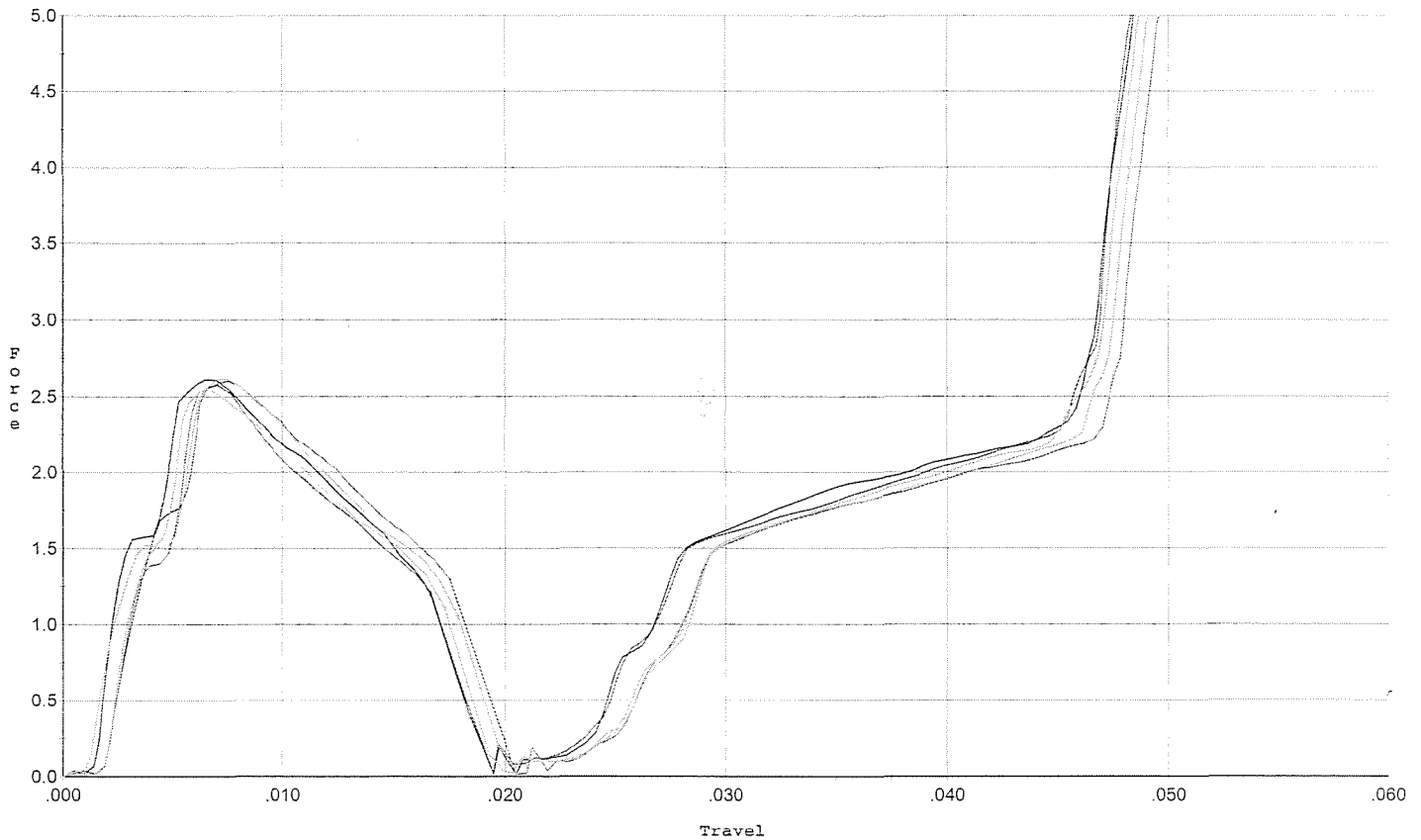
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>7</u> <u>7</u>	3-2-09	WU
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-2-09	WU
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	3-2-09	WU
	J) ASSEMBLE STOCK		2-18-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-2-09	WU
	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	2-20-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-20-09	WU
670	FINAL INSPECTION A) HEADSPACE		3-2-09	WU
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>251</u> <u>245</u> <u>251</u> <u>250</u> <u>260</u>	2-23-09	WU
	C) FUNCTION		3-2-09	WU
690	PACK		3/5/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



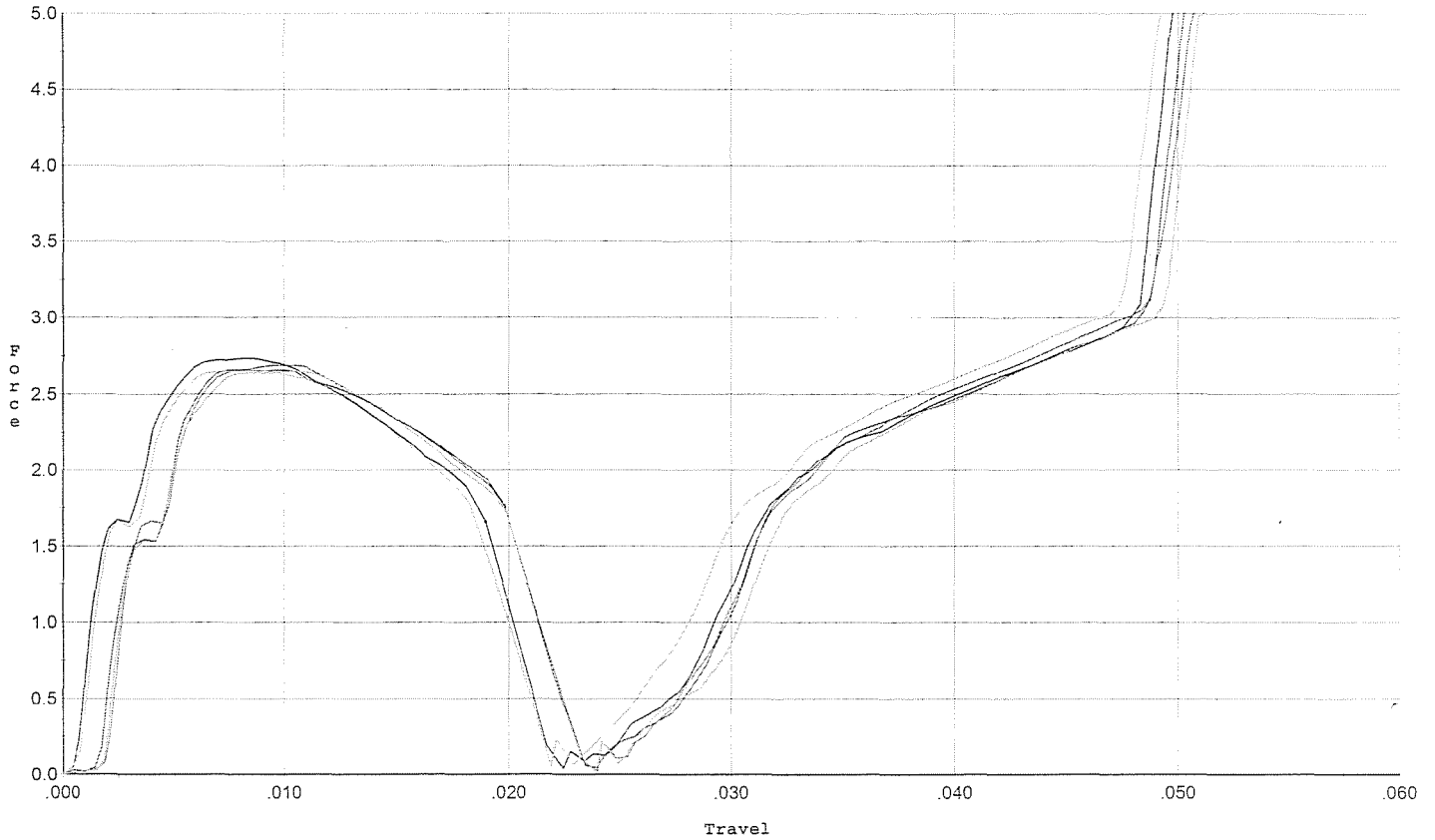
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.576	0.017	0.00	0.037	0.025		Set Trigger
2	2.612	0.017	0.00	0.037	0.027		Set Trigger
3	2.603	0.018	0.002	0.037	0.028		Set Trigger
4	2.558	0.017	0.00	0.037	0.027		Set Trigger
5	2.618	0.018	0.002	0.037	0.028		Set Trigger

A-259

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



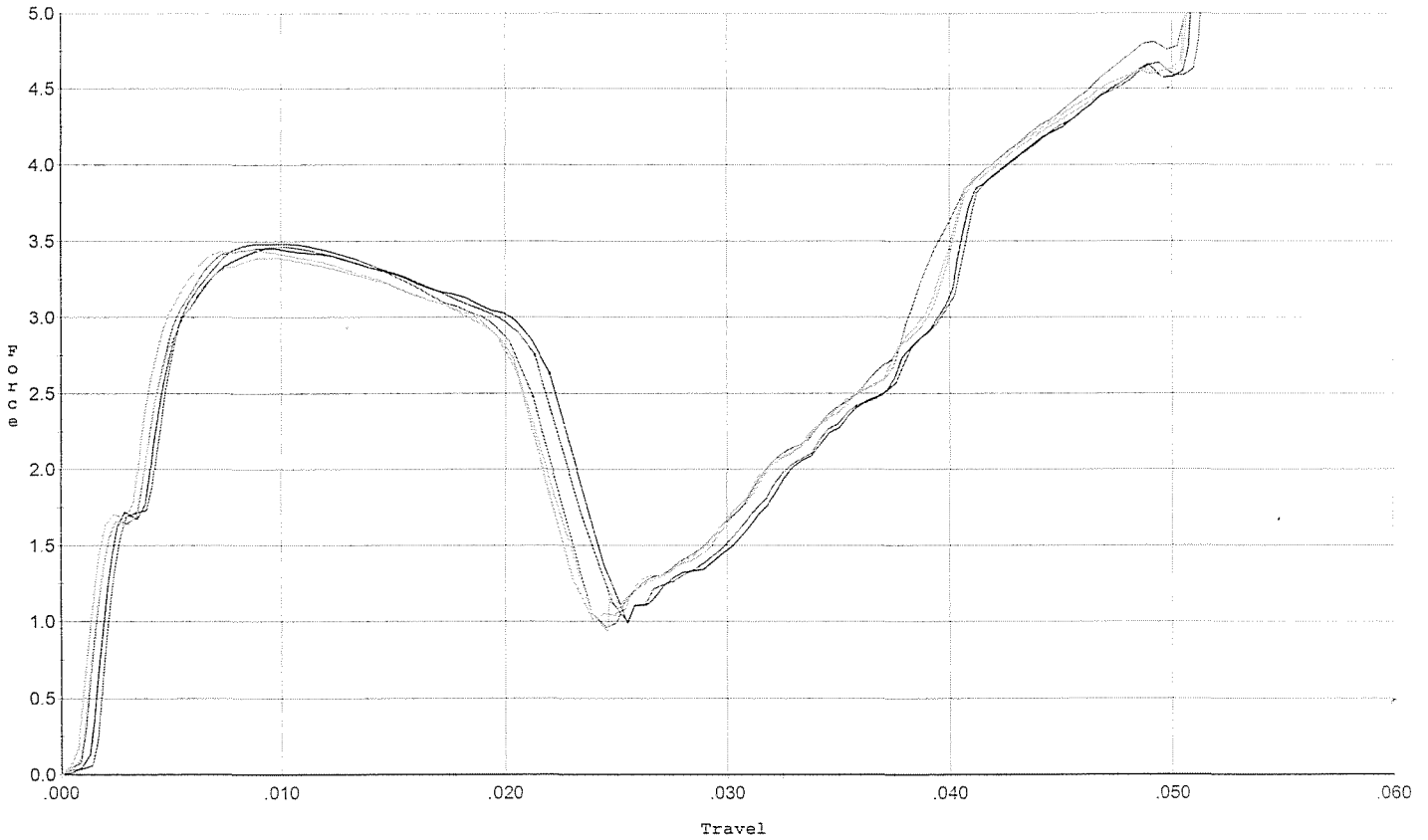
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.660	0.020	0.00	0.034	0.038		Set Trigger
2	2.736	0.019	0.00	0.035	0.039		Set Trigger
3	2.688	0.020	0.00	0.035	0.037		Set Trigger
4	2.656	0.020	0.00	0.034	0.039		Set Trigger
5	2.650	0.020	0.00	0.035	0.037		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



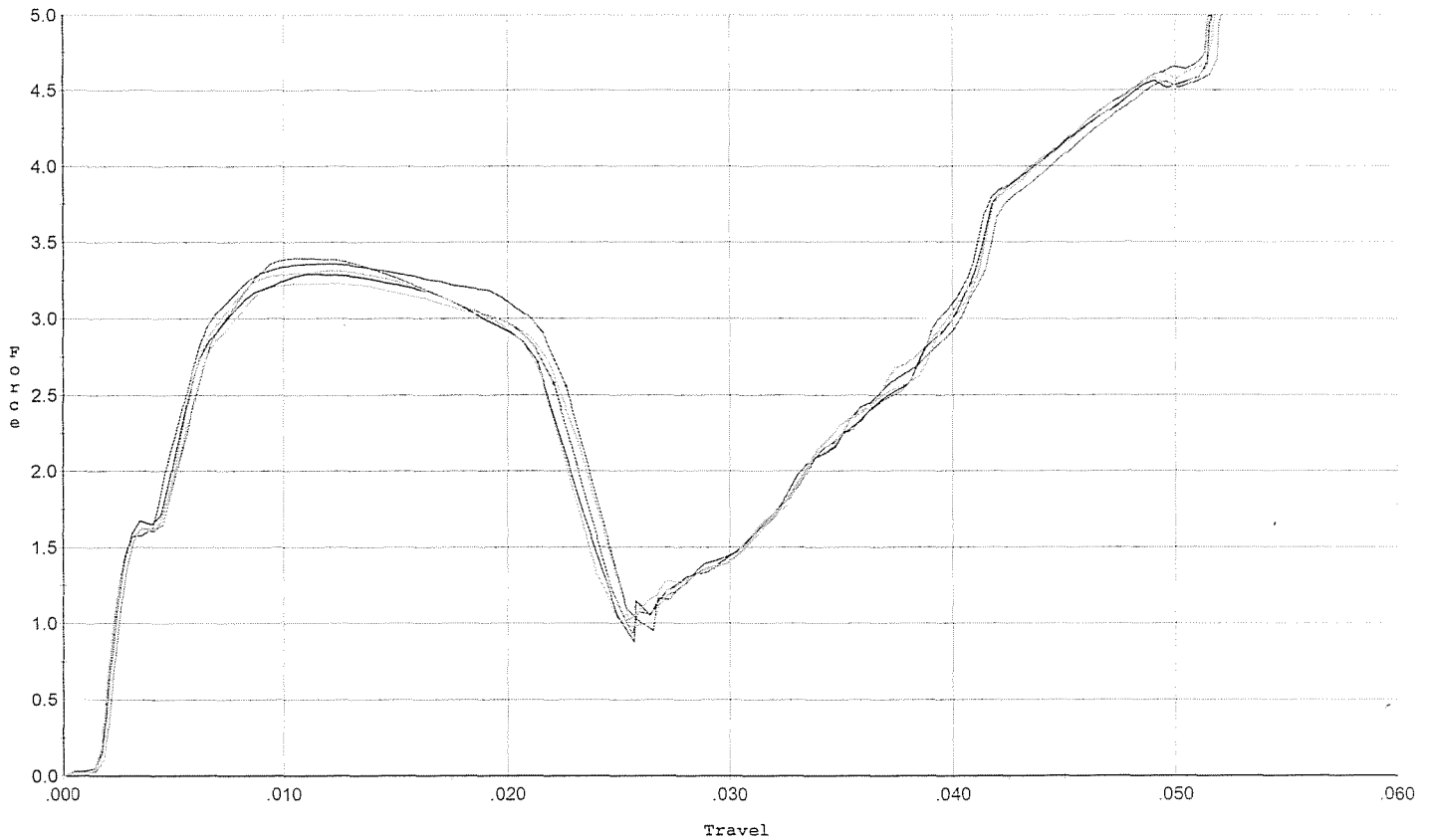
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.482	0.021	0.00	0.033	0.054		Set Trigger
2	3.453	0.022	0.00	0.032	0.057		Set Trigger
3	3.464	0.021	0.00	0.032	0.055		Set Trigger
4	3.393	0.020	0.00	0.033	0.052		Set Trigger
5	3.443	0.020	0.00	0.033	0.053		Set Trigger

A-3-44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



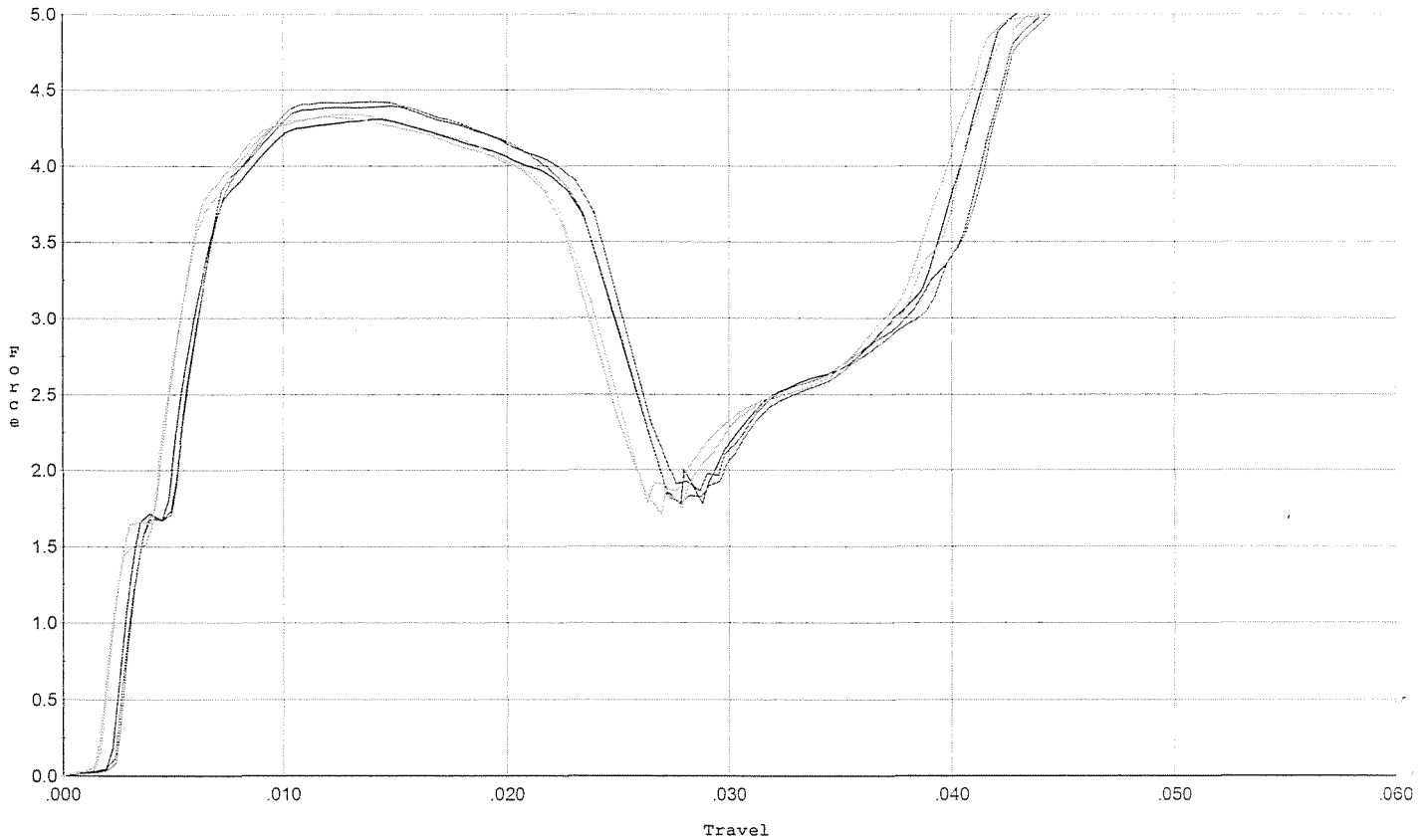
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.359	0.023	0.00	0.032	0.056		Set Trigger
2	3.291	0.021	0.00	0.033	0.051		Set Trigger
3	3.394	0.022	0.002	0.033	0.053		Set Trigger
4	3.229	0.023	0.00	0.032	0.055		Set Trigger
5	3.313	0.021	0.00	0.033	0.052		Set Trigger

A-3-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



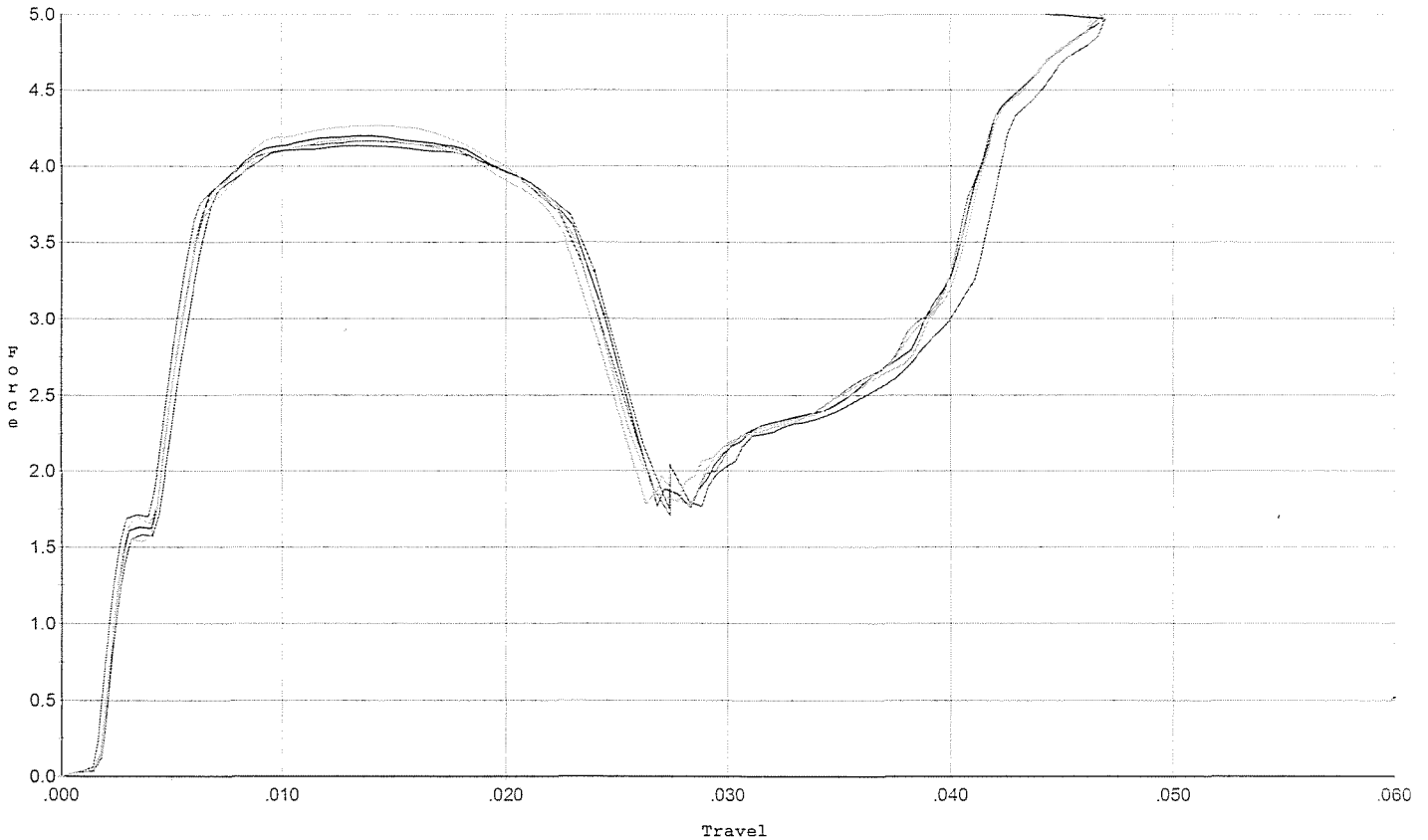
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.395	0.024	0.00	0.029	0.074		Set Trigger
2	4.307	0.023	0.00	0.029	0.072		Set Trigger
3	4.422	0.025	0.003	0.029	0.078		Set Trigger
4	4.322	0.024	0.00	0.029	0.074		Set Trigger
5	4.340	0.023	0.00	0.028	0.070		Set Trigger

A-435

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



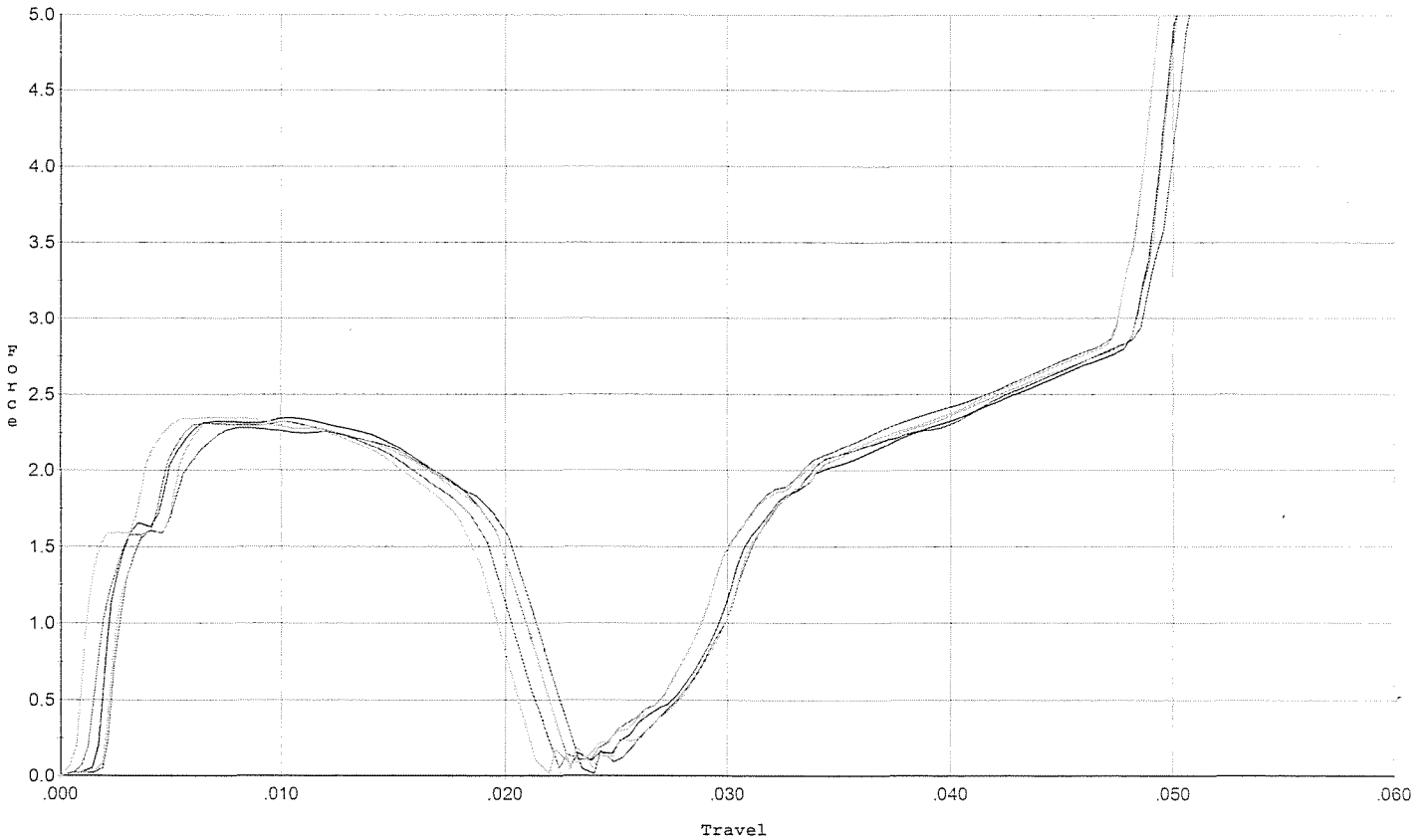
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.134	0.024	0.002	0.029	0.073		Set Trigger
2	4.199	0.024	0.00	0.029	0.075		Set Trigger
3	4.168	0.023	0.00	0.029	0.072		Set Trigger
4	4.267	0.023	0.00	0.029	0.072		Set Trigger
5	4.187	0.024	0.00	0.029	0.073		Set Trigger

A-409

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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



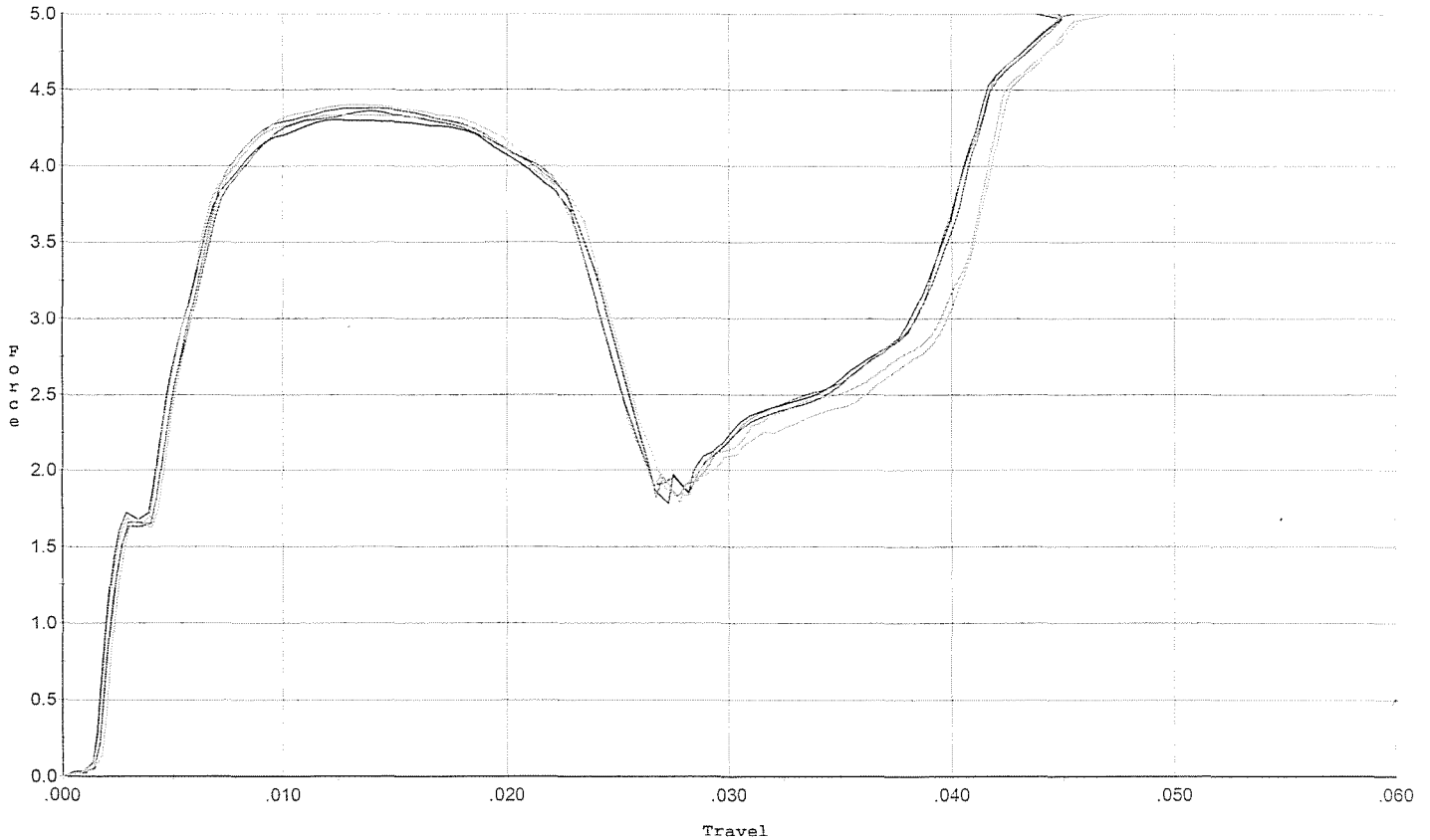
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.283	0.022	0.002	0.034	0.036		Set Trigger
2	2.348	0.021	0.00	0.034	0.037		Set Trigger
3	2.322	0.019	0.00	0.034	0.034		Set Trigger
4	2.353	0.019	0.00	0.035	0.035		Set Trigger
5	2.318	0.021	0.00	0.034	0.036		Set Trigger

A-2-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/16/2009

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	0.024	0.00	0.029	0.075		Set Trigger
2	4.304	0.023	0.00	0.029	0.072		Set Trigger
3	4.380	0.024	0.004	0.029	0.076		Set Trigger
4	4.400	0.023	0.00	0.029	0.074		Set Trigger
5	4.336	0.023	0.00	0.030	0.073		Set Trigger

A-4-35