

6684-5845

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

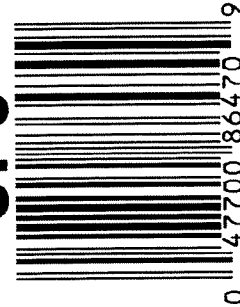
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6845845

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G684 5845

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-20-09	SPD
430	ASSEMBLE TO STOCK		4-20-09	RP
440	PROOF		4-20-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	4-20-09	SPD
470	DIS-ASSEMBLE ACTION		4-20-09	SPD
472	SERIALIZE BOLT HANDLE		4-21-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR (ID)	4/24/09	(ID)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/27/09	RT
510	DRILL AND TAP SIGHT HOLES		4-21-09	SP
520	GOFF BLAST BBL / REC		4/28	noy
540	APPLY COATINGS (BARREL ACTION)		4-30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-1-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-1-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-1-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-4-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

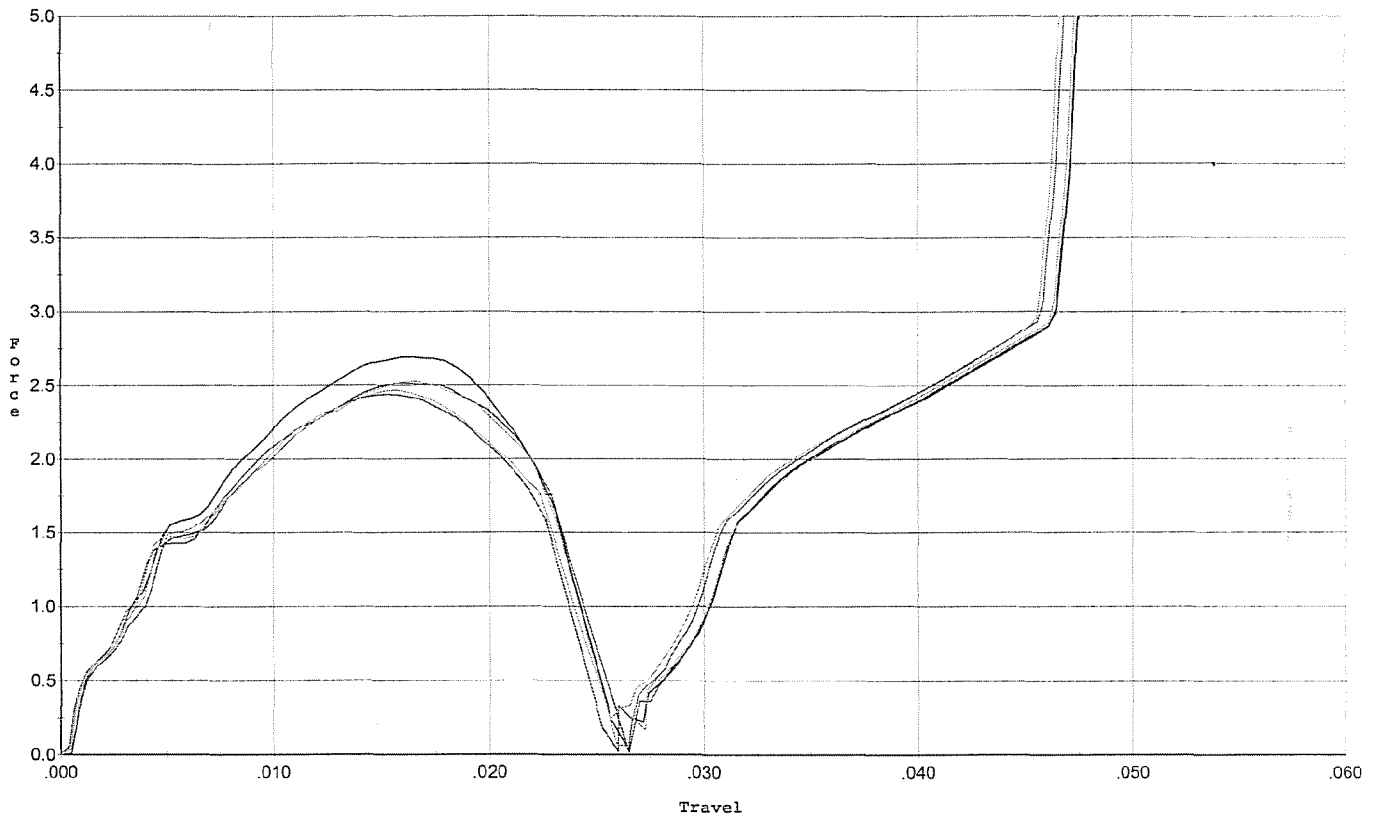
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	5-13-09	L.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	5-13-09	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	5-13-09	L.P.D.
	J) ASSEMBLE STOCK		5-14-09	J. N.
	K) ASSEMBLE SWIVEL STUDS		5-13-09	L.P.D.
	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	5-7-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	5-7-09	TCR
660	INSPECT FOR LIVE AMMO		5-7-09	TCR
670	FINAL INSPECTION A) HEADSPACE		5-13-09	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.67</u> <u>2.69</u> <u>2.75</u> <u>2.64</u>	5-7-09	RP
	C) FUNCTION		5-13-09	L.P.D.
690	PACK		7/23/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/1/2009

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



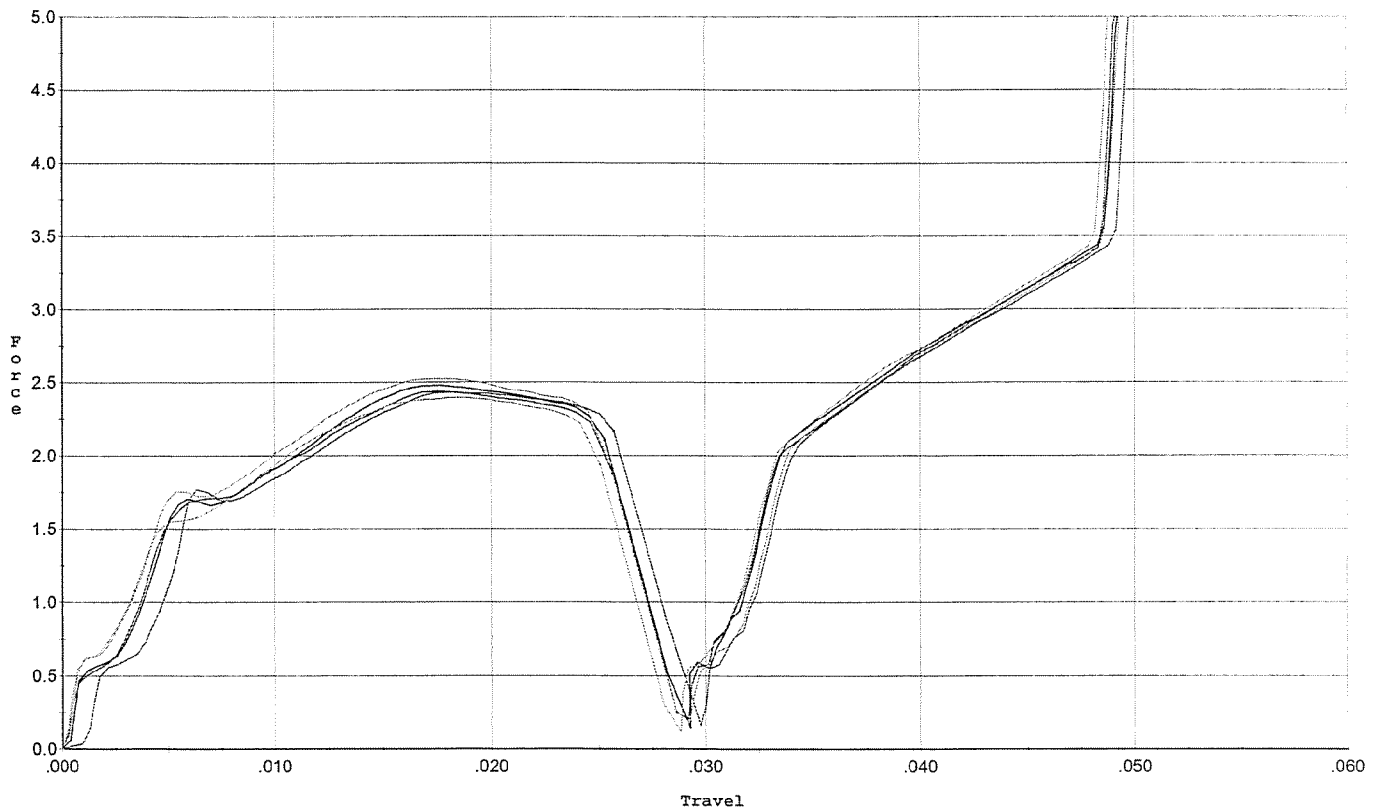
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.517	0.023	0.00	0.030	0.040		Set Trigger
2	2.693	0.023	0.00	0.030	0.042		Set Trigger
3	2.439	0.023	0.007	0.030	0.039		Set Trigger
4	2.468	0.022	0.00	0.030	0.038		Set Trigger
5	2.528	0.023	0.00	0.030	0.041		Set Trigger

A-252

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/1/2009

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



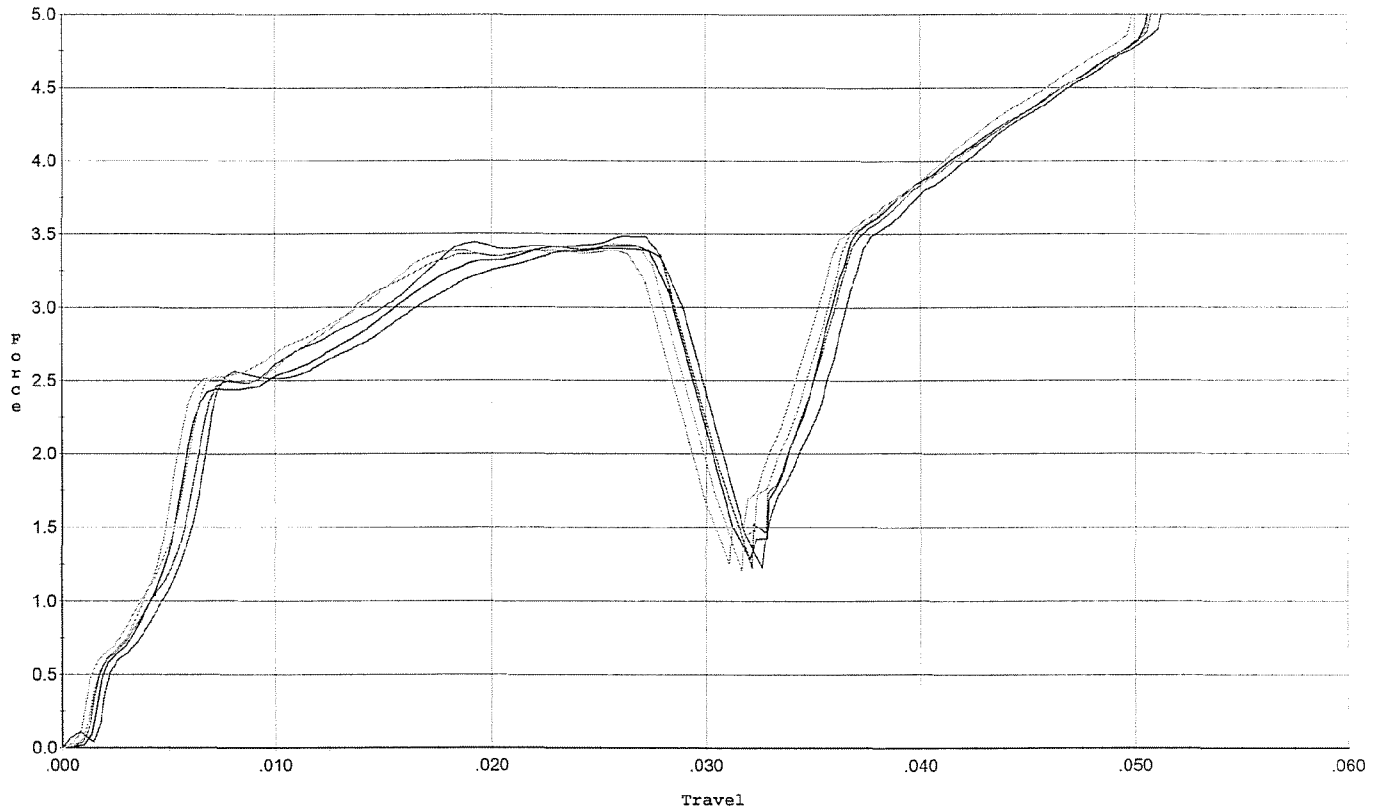
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.439	0.026	0.00	0.030	0.046		Set Trigger
2	2.477	0.025	0.00	0.030	0.046		Set Trigger
3	2.431	0.026	0.00	0.030	0.045		Set Trigger
4	2.397	0.025	0.00	0.030	0.045		Set Trigger
5	2.524	0.026	0.00	0.030	0.048		Set Trigger

A-2-45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 5/1/2009

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



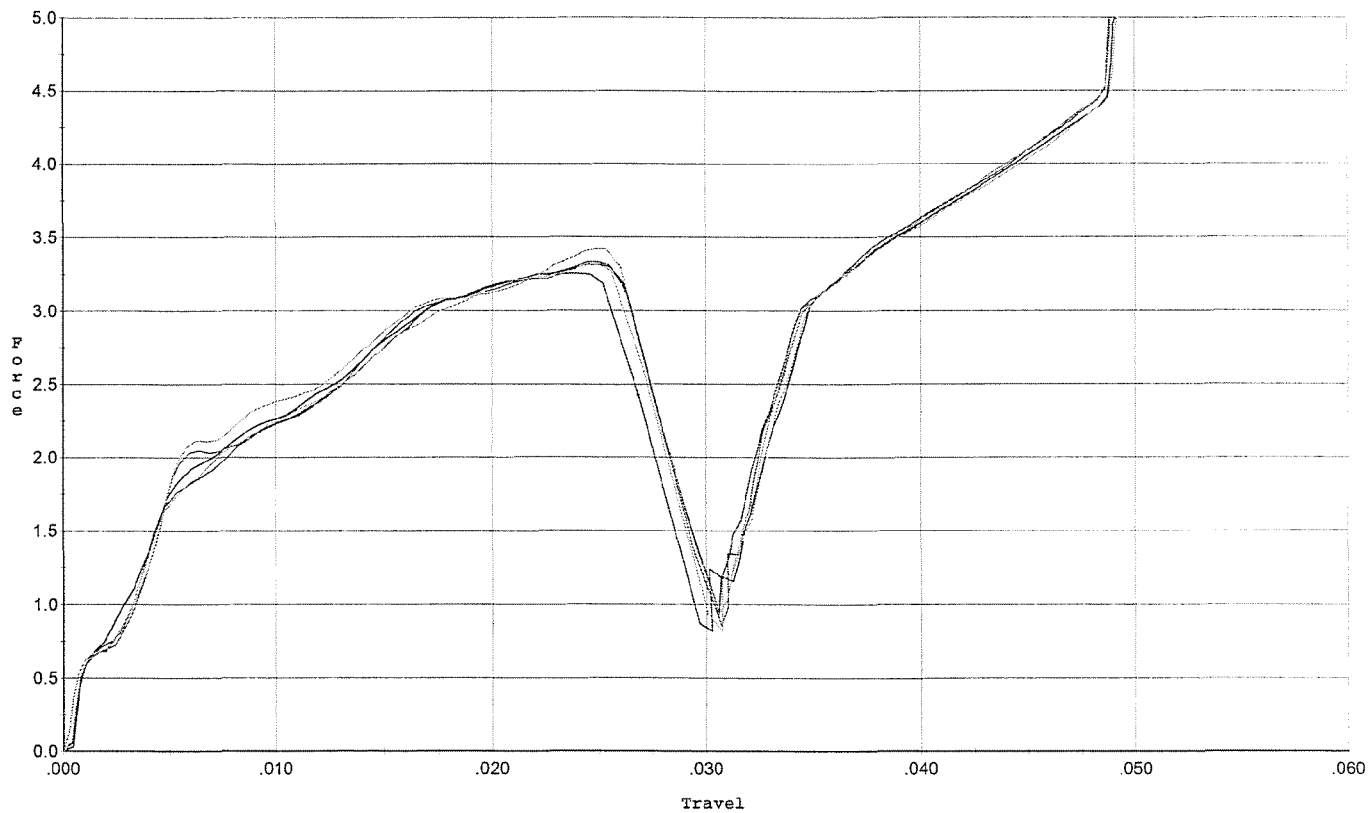
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.404	0.029	0.00	0.022	0.068		Set Trigger
2	3.423	0.028	0.00	0.022	0.068		Set Trigger
3	3.487	0.028	0.00	0.022	0.068		Set Trigger
4	3.436	0.027	0.00	0.023	0.068		Set Trigger
5	3.391	0.027	0.00	0.022	0.067		Set Trigger

A-3.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/1/2009

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



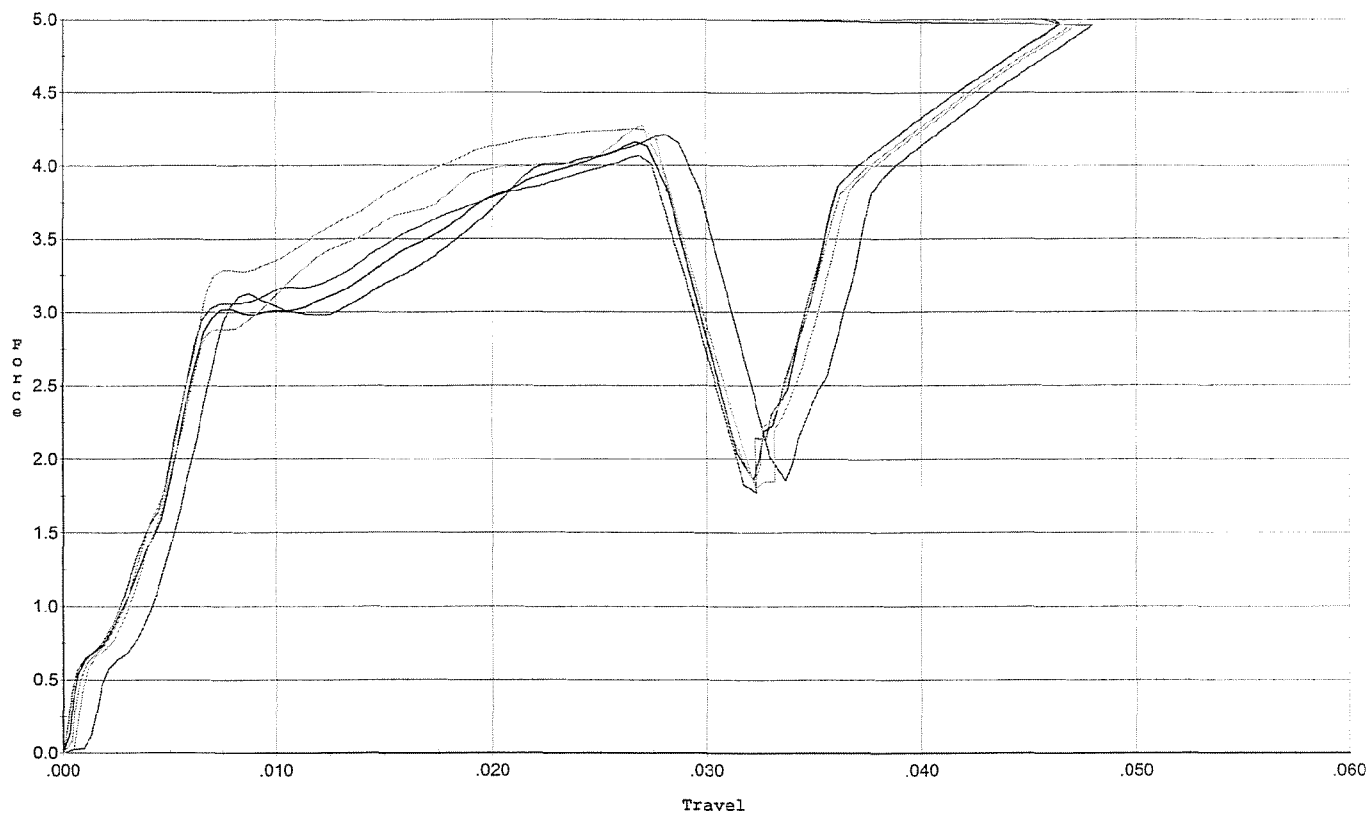
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.253	0.027	0.00	0.023	0.060		Set Trigger
2	3.320	0.026	0.00	0.023	0.060		Set Trigger
3	3.339	0.026	0.00	0.023	0.060		Set Trigger
4	3.316	0.027	0.00	0.023	0.061		Set Trigger
5	3.420	0.026	0.00	0.023	0.060		Set Trigger

A-3-33

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/1/2009

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



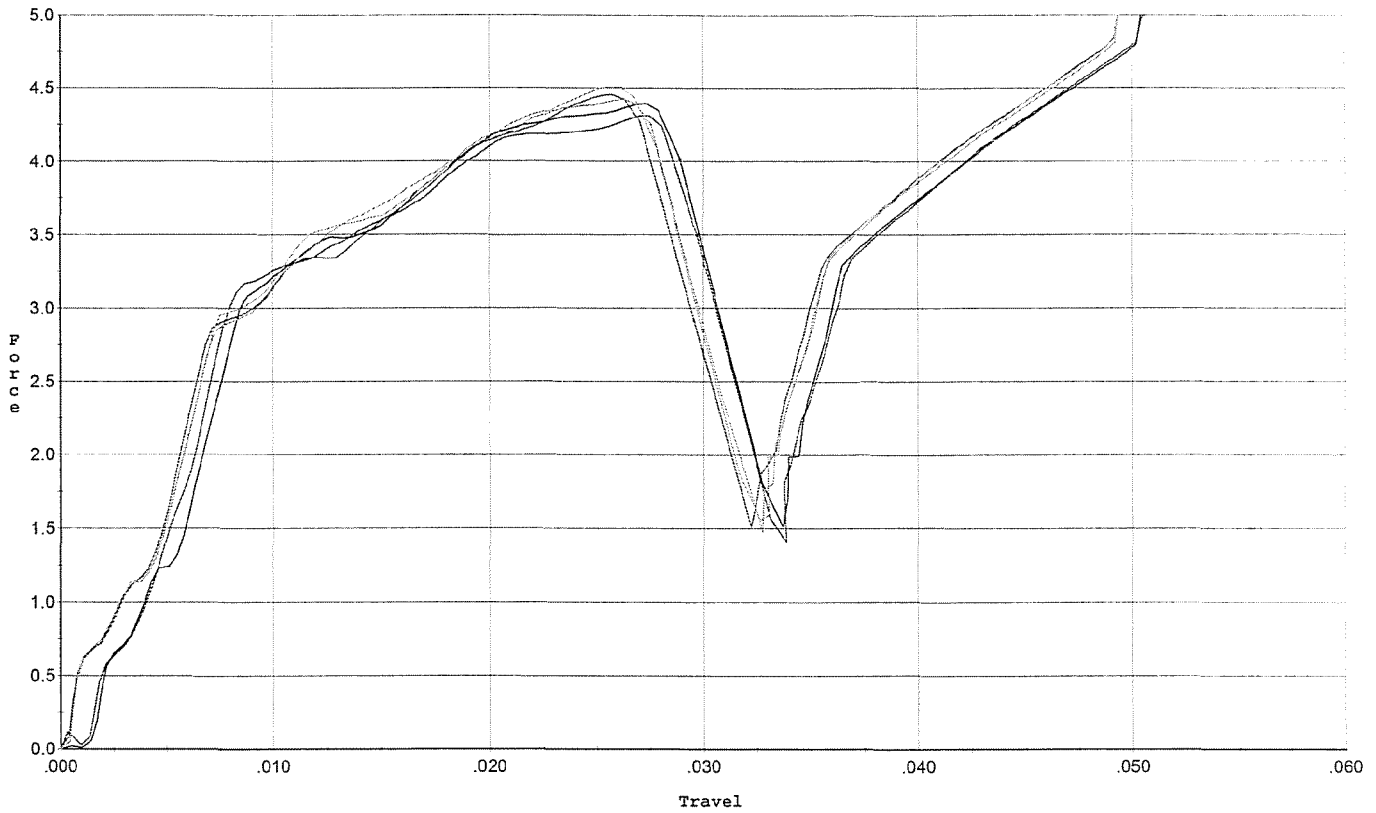
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.210	0.030	0.00	0.020	0.083		Set Trigger
2	4.160	0.028	0.00	0.019	0.080		Set Trigger
3	4.066	0.029	0.00	0.019	0.085		Set Trigger
4	4.274	0.028	0.00	0.019	0.081		Set Trigger
5	4.252	0.028	0.00	0.019	0.086		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/1/2009

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



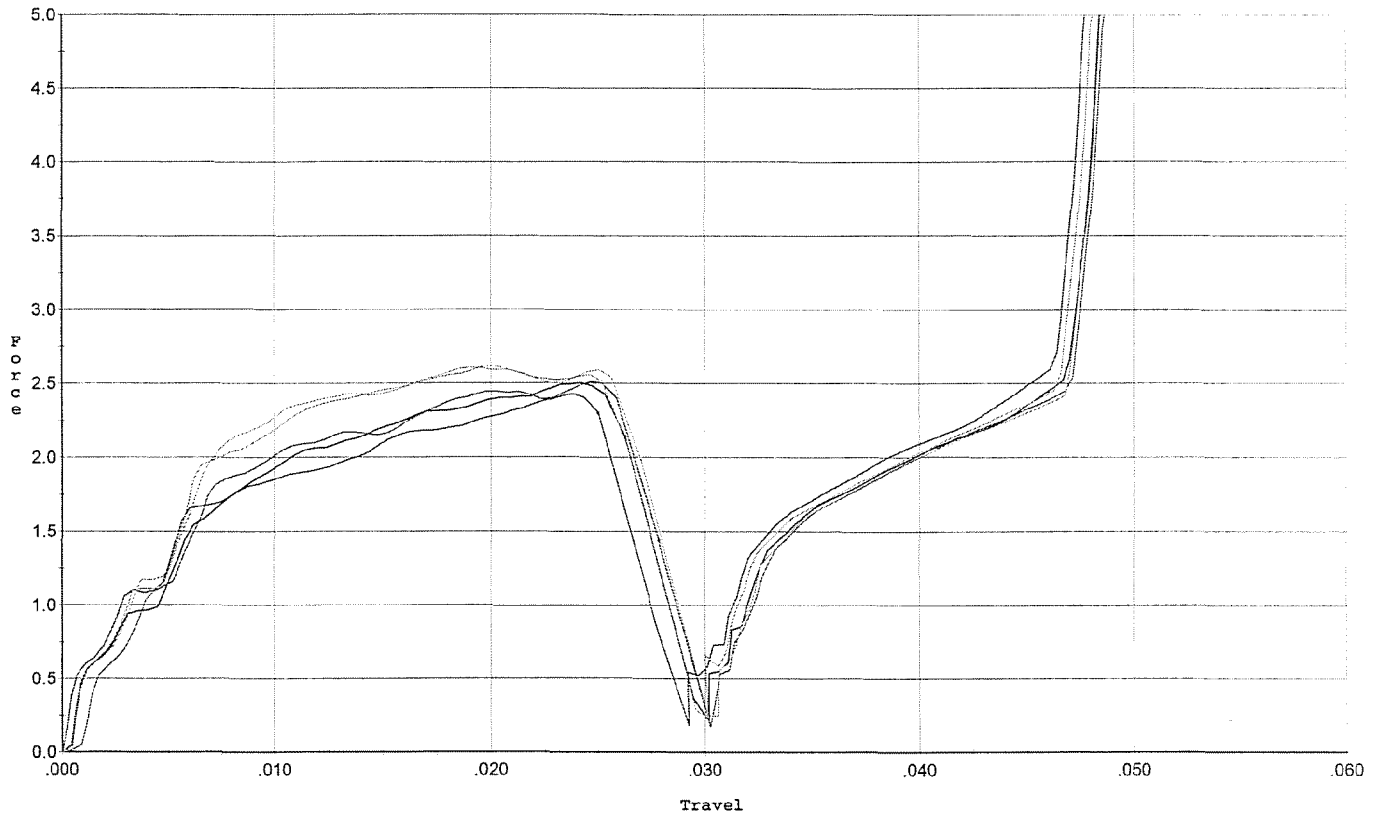
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.310	0.030	0.00	0.019	0.087		Set Trigger
2	4.394	0.029	0.00	0.019	0.085		Set Trigger
3	4.457	0.030	0.00	0.019	0.087		Set Trigger
4	4.511	0.028	0.00	0.019	0.083		Set Trigger
5	4.423	0.028	0.00	0.019	0.082		Set Trigger

A-4.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/1/2009

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



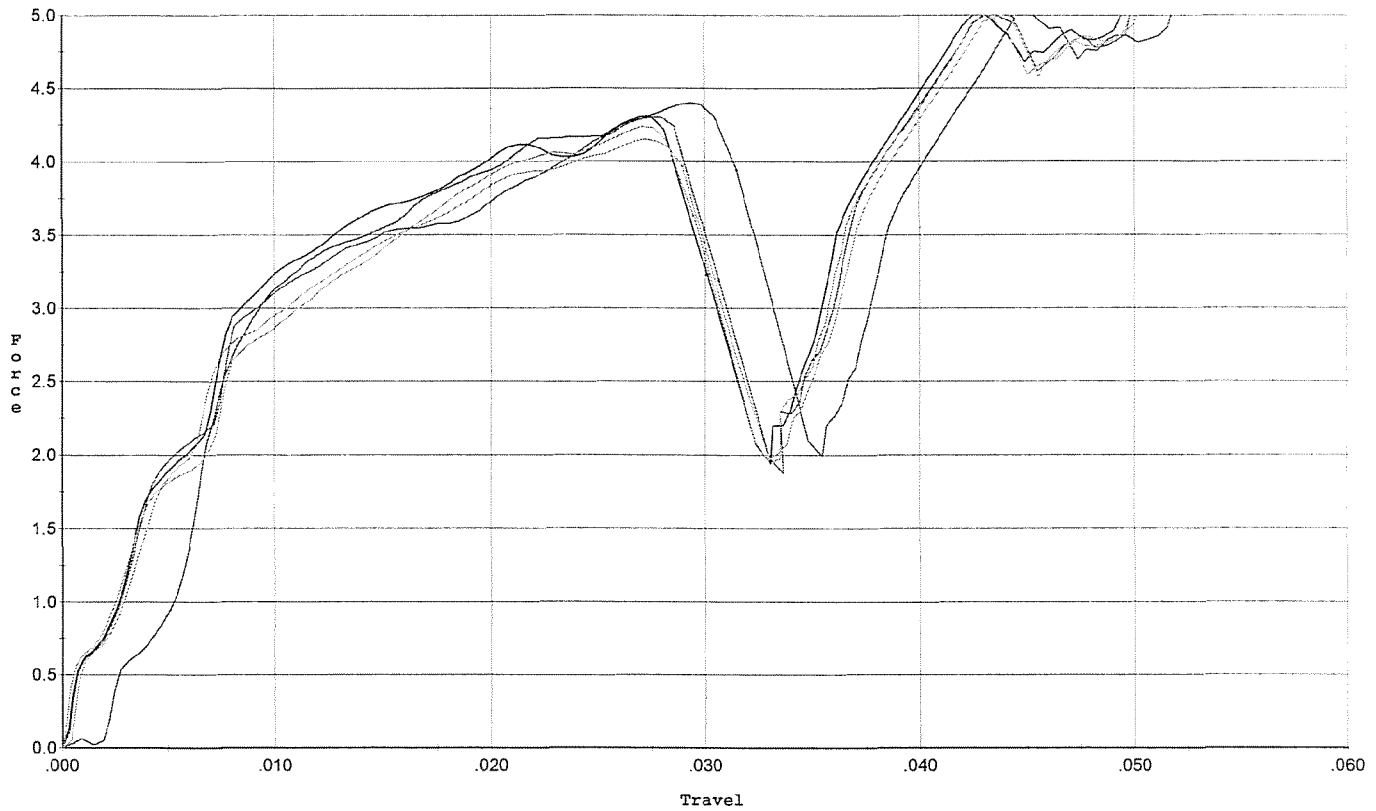
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.025	0.00	0.028	0.044		Set Trigger
2	2.504	0.026	0.00	0.025	0.047		Set Trigger
3	2.511	0.028	0.00	0.025	0.050		Set Trigger
4	2.607	0.027	0.00	0.024	0.053		Set Trigger
5	2.619	0.026	0.005	0.025	0.051		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/1/2009

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	4.401	0.032	0.00	0.018	0.092		Set Trigger
2	4.311	0.030	0.00	0.018	0.090		Set Trigger
3	4.304	0.031	0.00	0.019	0.089		Set Trigger
4	4.153	0.029	0.00	0.019	0.083		Set Trigger
5	4.237	0.029	0.00	0.019	0.085		Set Trigger

A-4.28