

6680 1381

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

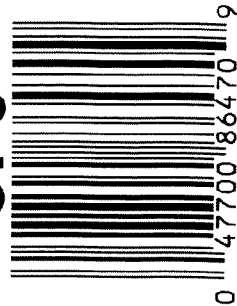
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801381

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 1381

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE		10-22-08	RSN
475	DRILL AND TAP SIGHT HOLES	24	10-22-08	SP
480	MAGNAFLUX BBL ACTION	(#)	10/24/08	(HB)
490	MAGNAFLUX BOLT		10-24-08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10-25-08	TL
542	APPLY COATINGS (BARREL ACTION)		10-25-08	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-30-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-13-09	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

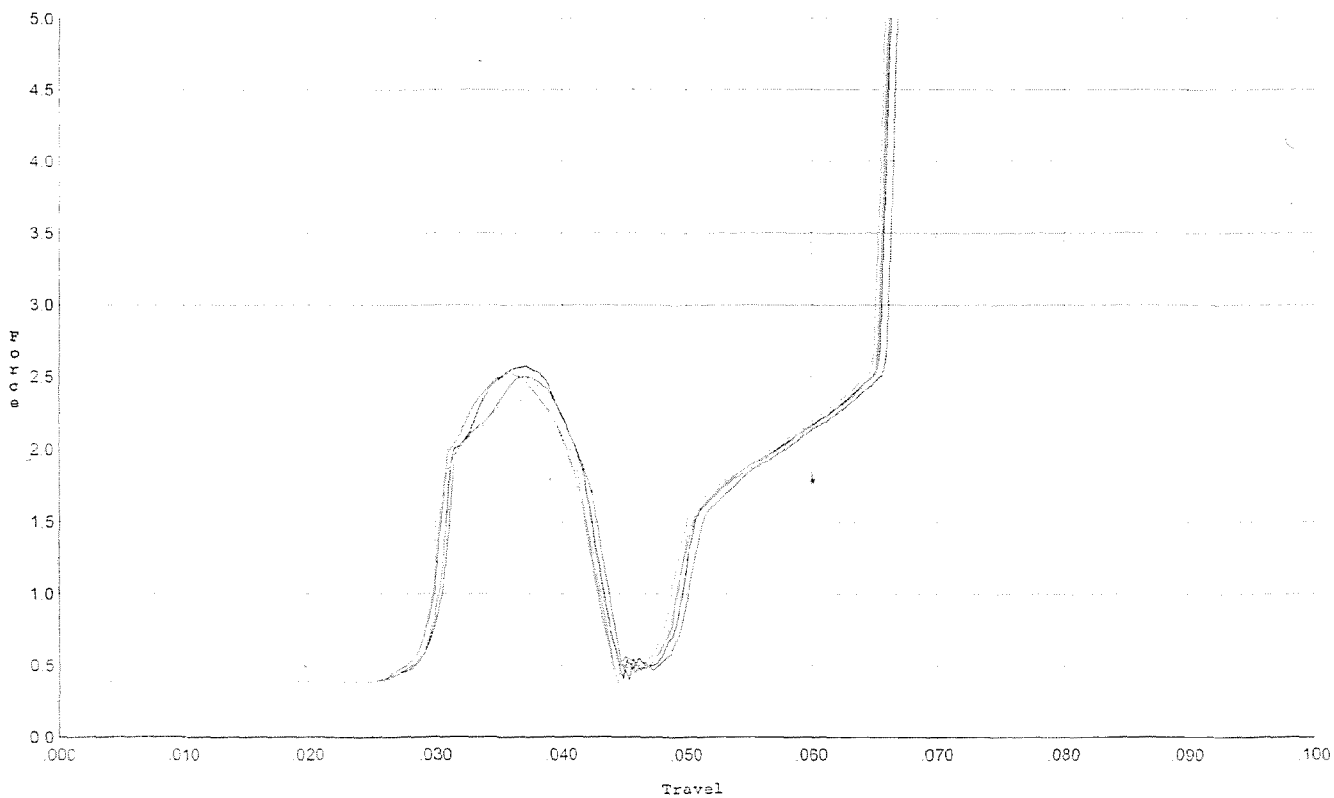
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-20-09	RJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	1-20-09	RJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-20-09	RJN
	J) ASSEMBLE STOCK		1-13-09	RBN
	K) ASSEMBLE SWIVEL STUDS		1-20-09	RJN
	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	1-19-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-19-09	M/A
670	FINAL INSPECTION A) HEADSPACE		1-20-09	RJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>247</u> <u>267</u> <u>249</u> <u>260</u> <u>262</u>	1-20-09	RJN
	C) FUNCTION		1-20-09	RJN
690	PACK		1-20-09	RBN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



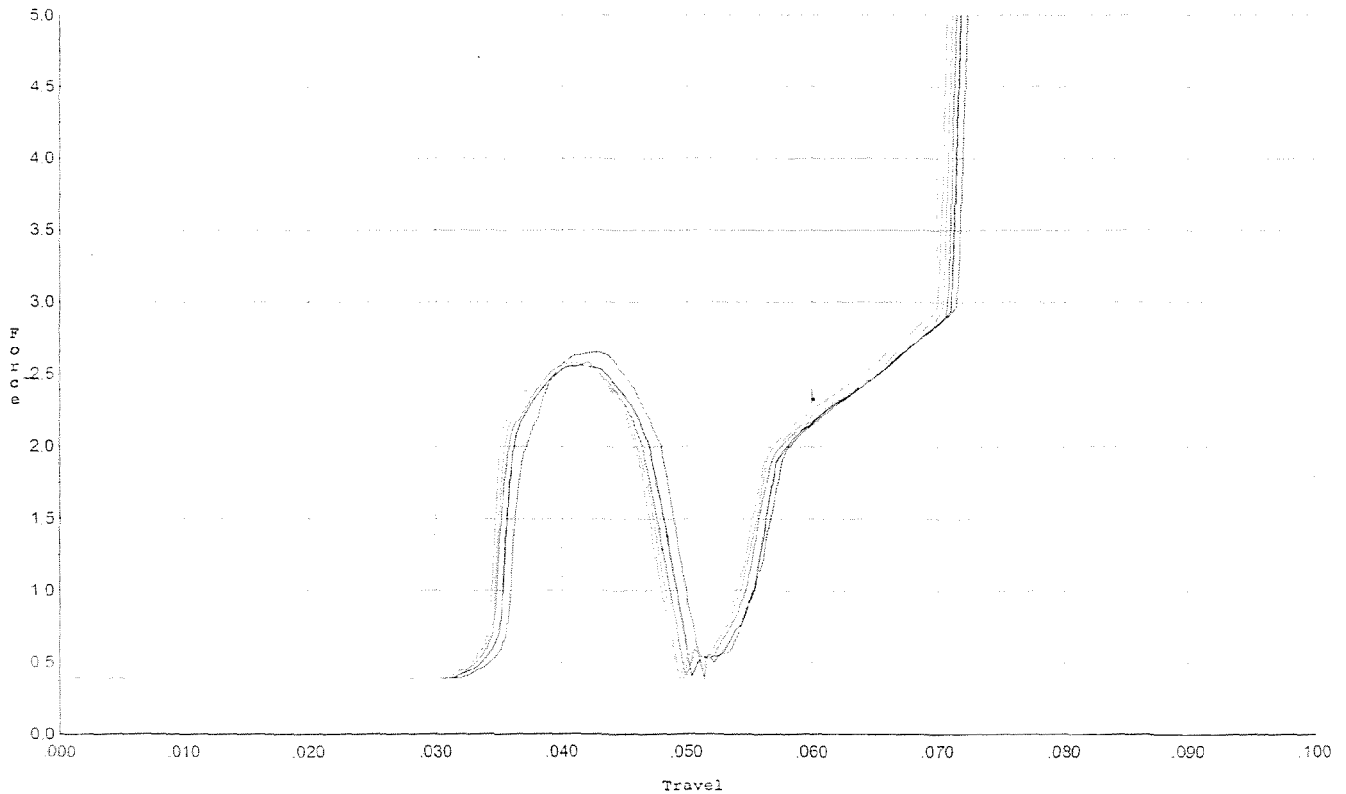
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.502	0.042	0.029	0.030	0.039		Set Trigger
2	2.575	0.042	0.029	0.030	0.039		Set Trigger
3	2.525	0.041	0.029	0.030	0.038		Set Trigger
4	2.338	0.043	0.029	0.030	0.037		Set Trigger
5	2.539	0.041	0.029	0.030	0.038		Set Trigger

A.2.419

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



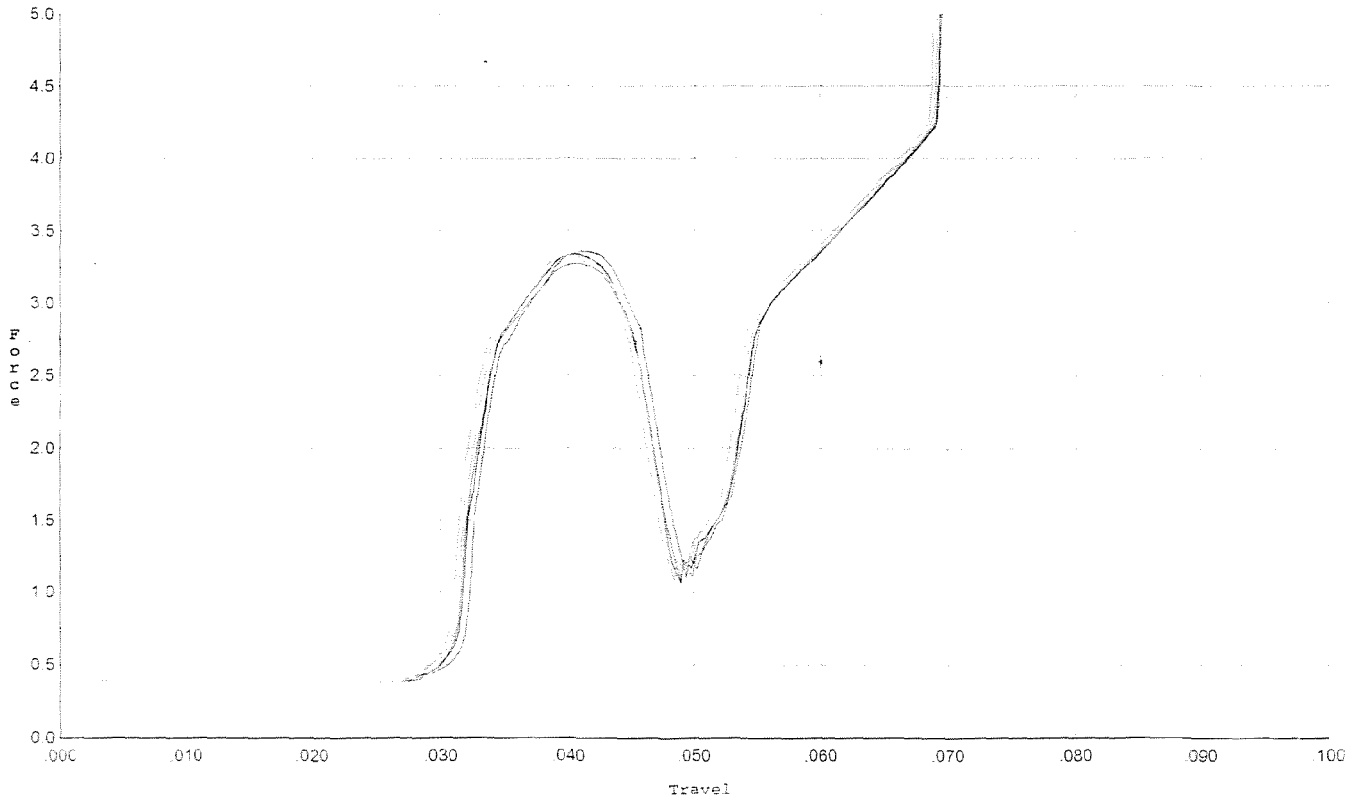
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.648	0.048	0.035	0.030	0.044		Set Trigger
2	2.562	0.048	0.035	0.030	0.044		Set Trigger
3	2.585	0.048	0.034	0.030	0.044		Set Trigger
4	2.577	0.047	0.034	0.031	0.043		Set Trigger
5	2.593	0.046	0.034	0.031	0.042		Set Trigger

A-259

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



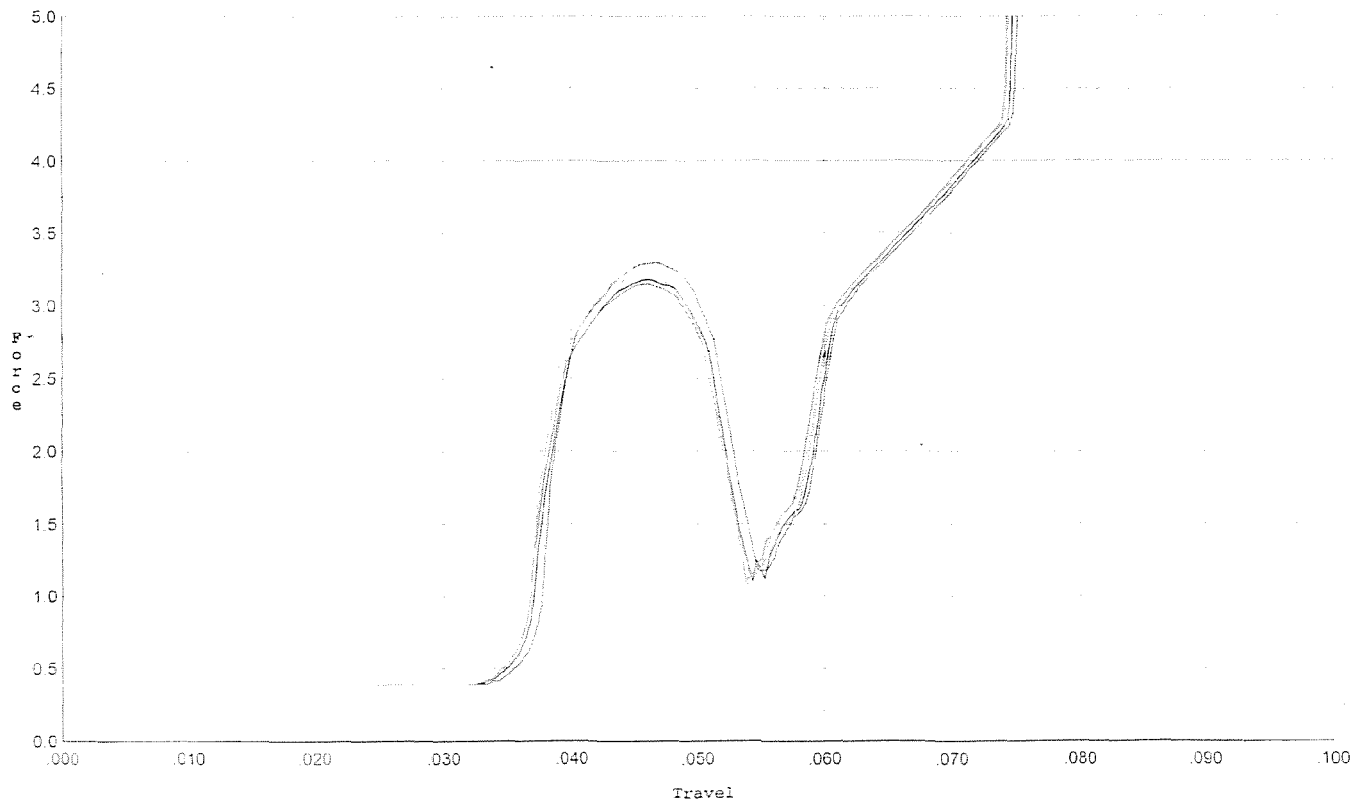
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.356	0.046	0.032	0.029	0.054		Set Trigger
2	3.340	0.045	0.031	0.029	0.054		Set Trigger
3	3.274	0.045	0.031	0.029	0.054		Set Trigger
4	3.351	0.046	0.031	0.029	0.055		Set Trigger
5	3.326	0.045	0.030	0.029	0.054		Set Trigger

A-3.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



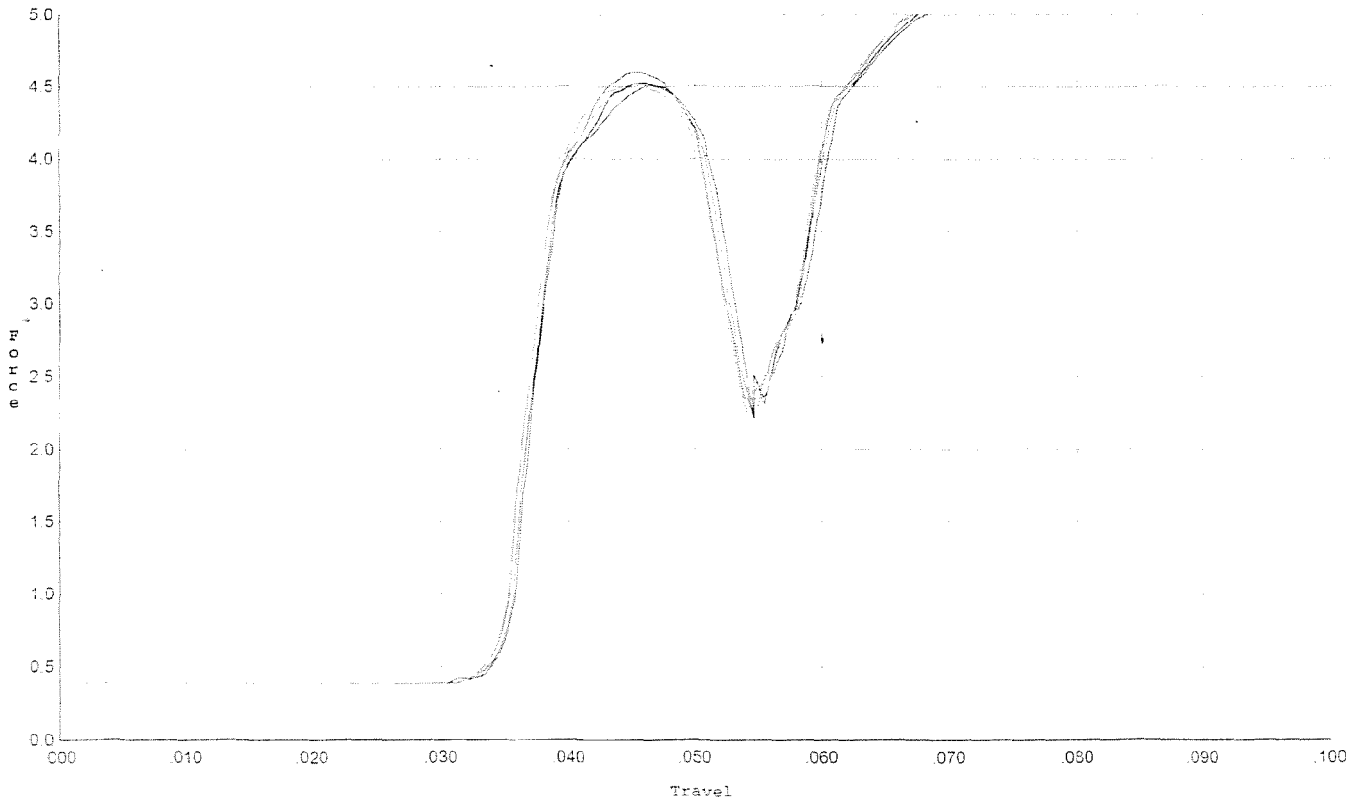
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.292	0.051	0.037	0.029	0.057		Set Trigger
2	3.179	0.051	0.036	0.029	0.055		Set Trigger
3	3.147	0.052	0.036	0.028	0.056		Set Trigger
4	3.269	0.052	0.036	0.029	0.058		Set Trigger
5	3.212	0.052	0.036	0.029	0.057		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/17/2008

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



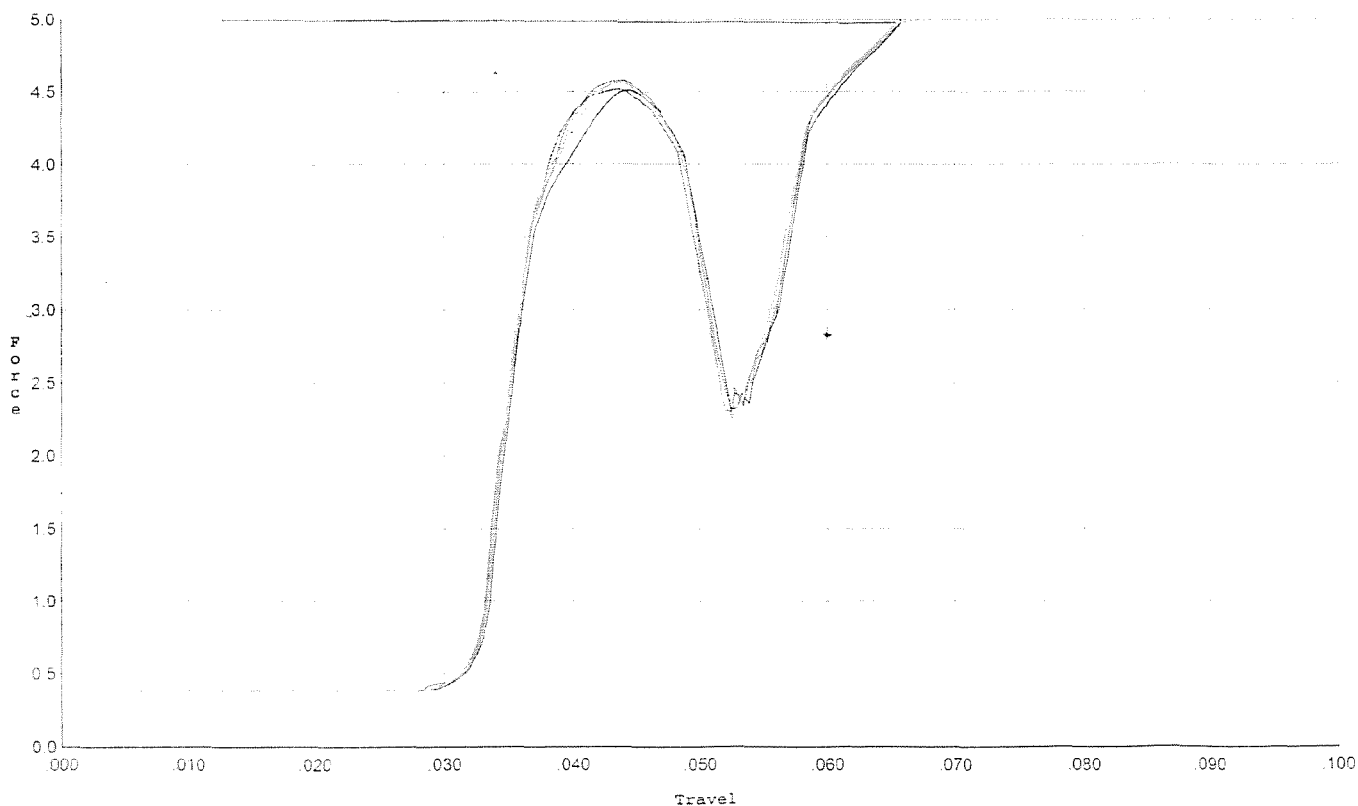
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.511	0.052	0.035	0.026	0.080		Set Trigger
2	4.527	0.051	0.035	0.026	0.078		Set Trigger
3	4.600	0.050	0.034	0.026	0.078		Set Trigger
4	4.505	0.051	0.035	0.026	0.078		
5	4.518	0.050	0.034	0.026	0.077		

A-4-53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



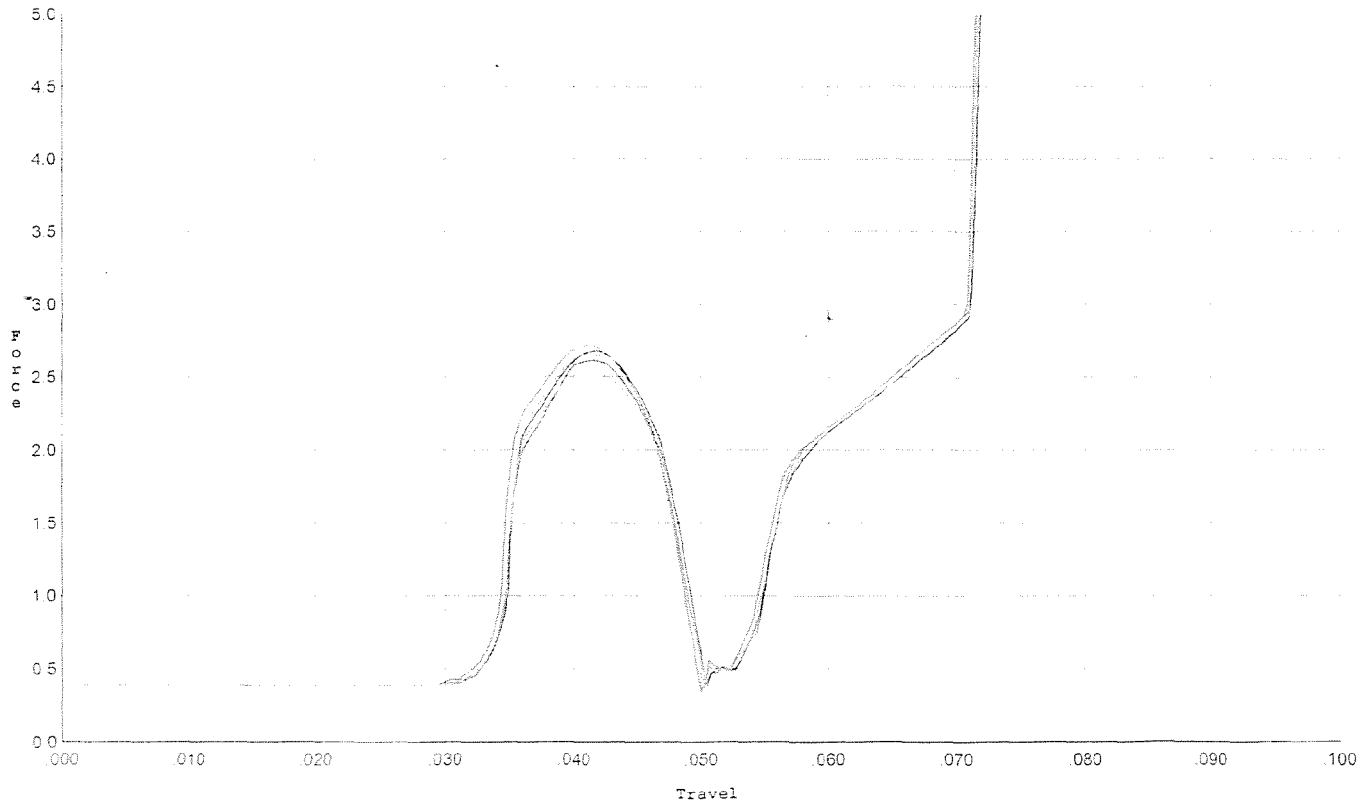
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.517	0.050	0.032	0.026	0.079		Set Trigger
2	4.509	0.051	0.032	0.026	0.079		Set Trigger
3	4.577	0.049	0.032	0.026	0.078		Set Trigger
4	4.564	0.049	0.032	0.026	0.078		Set Trigger
5	4.561	0.049	0.032	0.026	0.078		Set Trigger

A. 4.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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



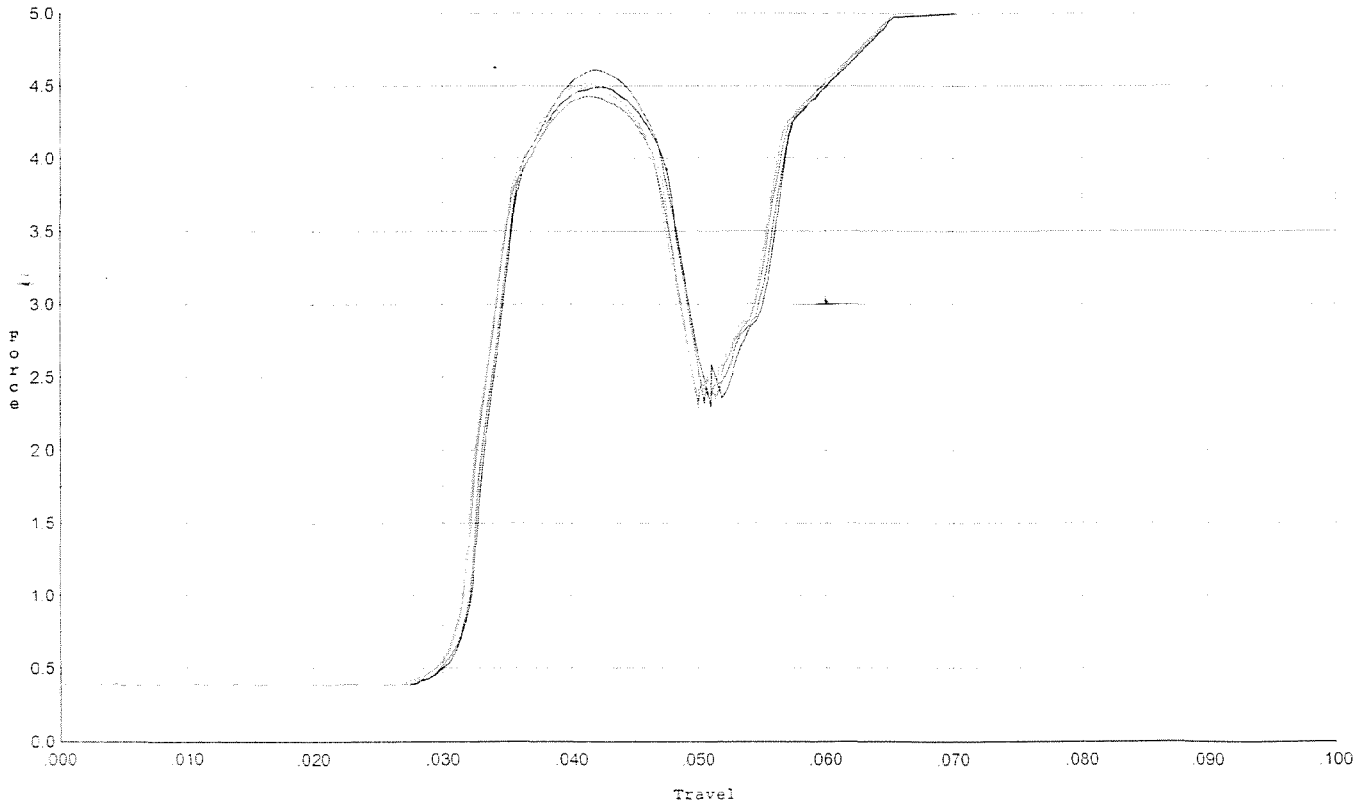
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.047	0.033	0.031	0.043		Set Trigger
2	2.680	0.048	0.034	0.030	0.045		Set Trigger
3	2.718	0.047	0.033	0.031	0.045		Set Trigger
4	2.673	0.047	0.034	0.031	0.044		Set Trigger
5	2.524	0.047	0.034	0.031	0.043		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/17/2008

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	4.609	0.048	0.031	0.026	0.078		Set Trigger
2	4.493	0.048	0.031	0.026	0.076		Set Trigger
3	4.430	0.048	0.031	0.026	0.076		Set Trigger
4	4.520	0.047	0.031	0.026	0.076		Set Trigger
5	4.489	0.046	0.030	0.027	0.074		Set Trigger

A.4.50