

G680 1398

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



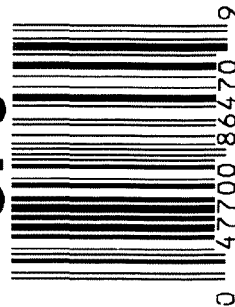
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801398

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 1398

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SPD
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SPD
460	CHECK HEADSPACE		10-21-08	SPD
470	DIS-ASSEMBLE ACTION		10-21-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-22-08	ESN
475	DRILL AND TAP SIGHT HOLES	2000	10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10-21-08	SP
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/25/08	DS
542	APPLY COATINGS (BARREL ACTION)		10-28	✓
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		1-9-09	ESN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

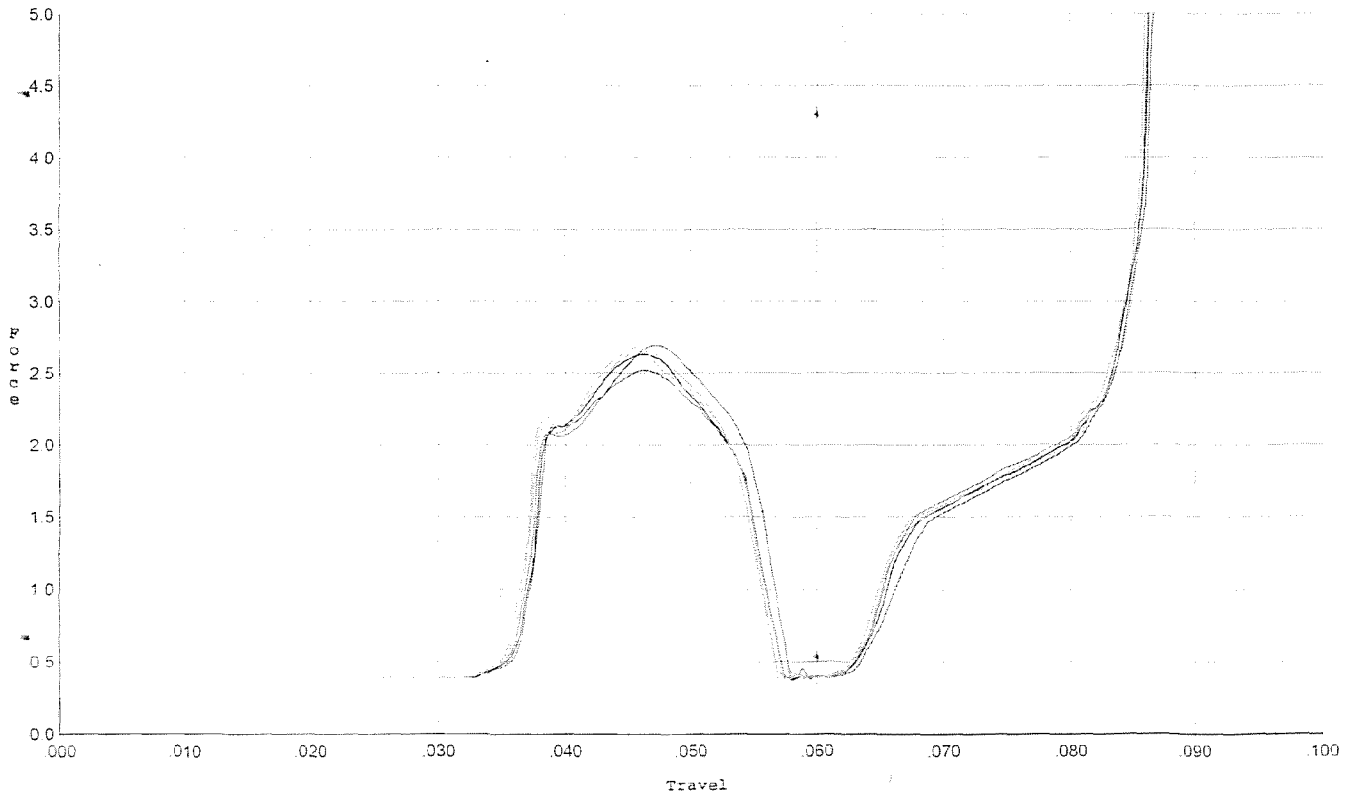
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-13-09	LDH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	1-13-09	LDH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	1-13-09	LDH
	J) ASSEMBLE STOCK		1-9-09	RPW
	K) ASSEMBLE SWIVEL STUDS		1-13-09	LDH
	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	1-12-09	LDH
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-12-09	RP
670	FINAL INSPECTION A) HEADSPACE		1-13-09	LDH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.4</u> <u>2.54</u> <u>2.35</u> <u>2.45</u> <u>2.45</u>	1-13-09	LDH
	C) FUNCTION		1-13-09	LDH
690	PACK		1/14/08	FMJ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



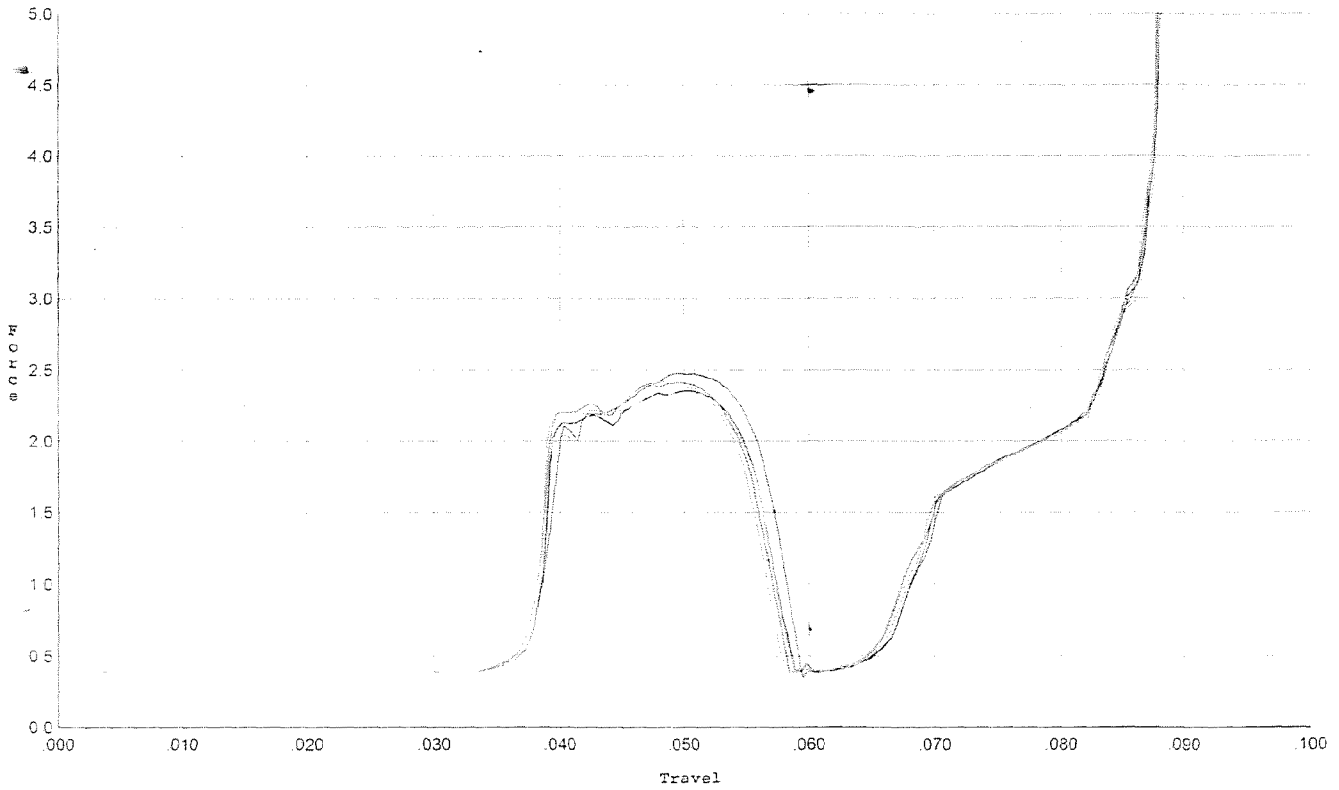
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.694	0.056	0.036	0.037	0.057		Set Trigger
2	2.634	0.054	0.036	0.037	0.054		Set Trigger
3	2.520	0.054	0.036	0.037	0.054		Set Trigger
4	2.660	0.054	0.036	0.037	0.055		Set Trigger
5	2.688	0.055	0.036	0.037	0.057		Set Trigger

A-2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



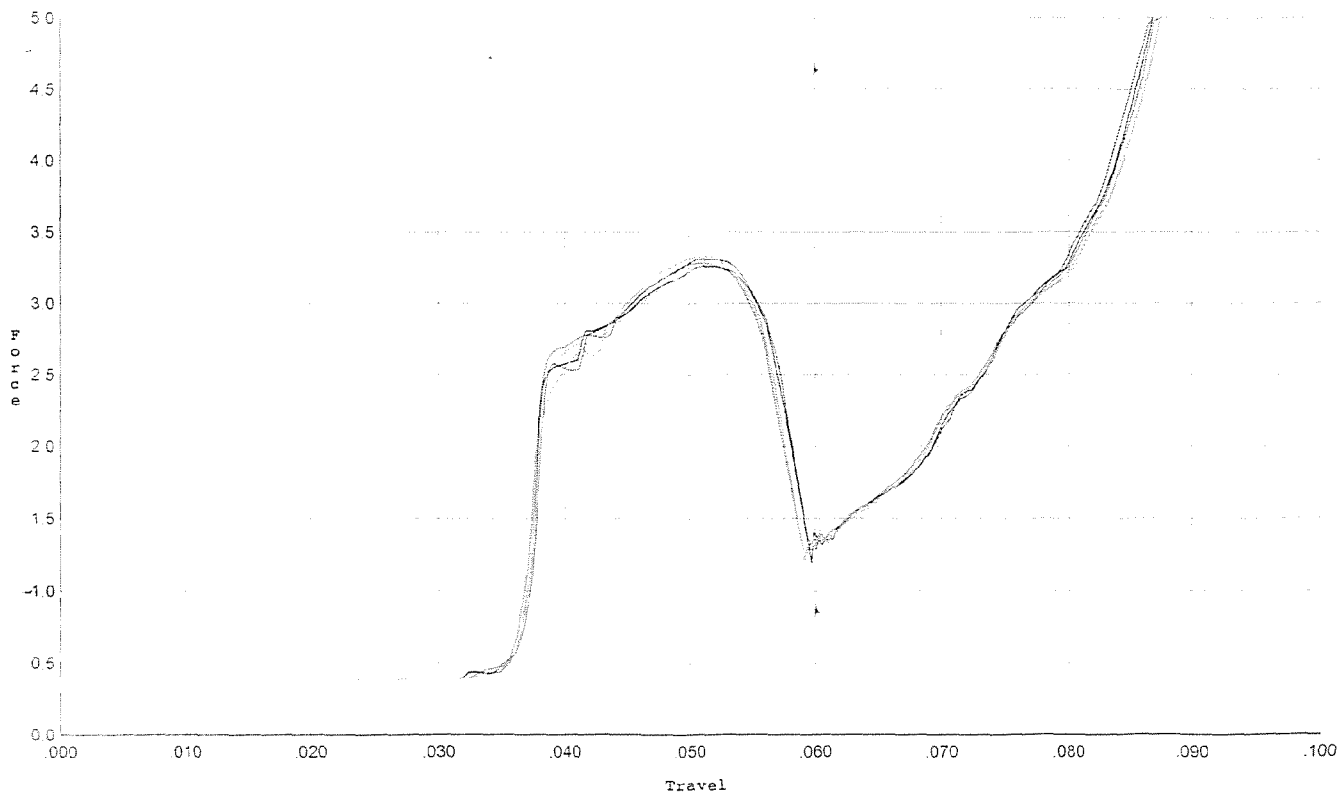
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.475	0.057	0.038	0.037	0.057		Set Trigger
2	2.353	0.056	0.038	0.038	0.054		Set Trigger
3	2.413	0.057	0.037	0.038	0.055		Set Trigger
4	2.343	0.056	0.038	0.038	0.054		Set Trigger
5	2.420	0.056	0.037	0.038	0.054		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



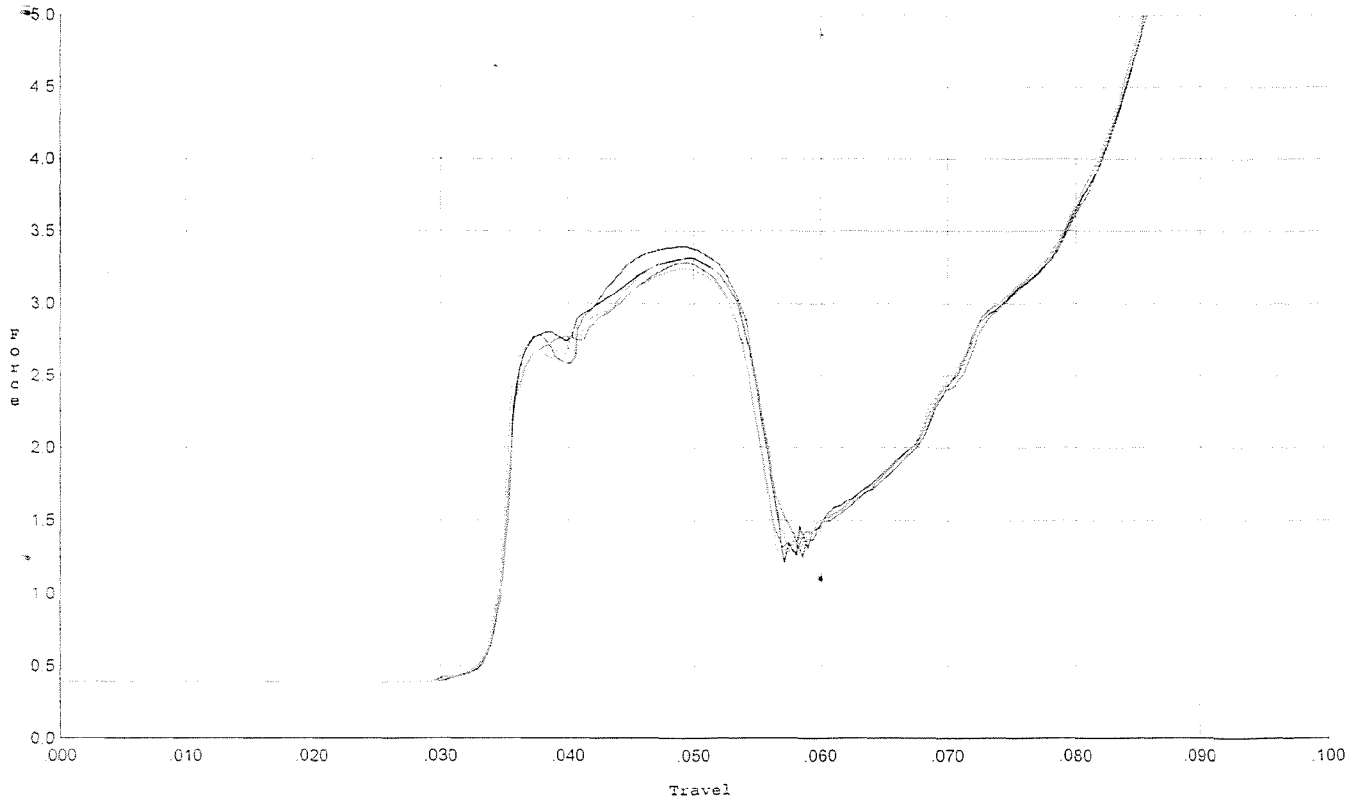
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.309	0.057	0.036	0.036	0.074		Set Trigger
2	3.261	0.058	0.036	0.036	0.074		Set Trigger
3	3.283	0.057	0.036	0.036	0.074		Set Trigger
4	3.274	0.057	0.036	0.036	0.072		Set Trigger
5	3.331	0.057	0.036	0.036	0.073		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



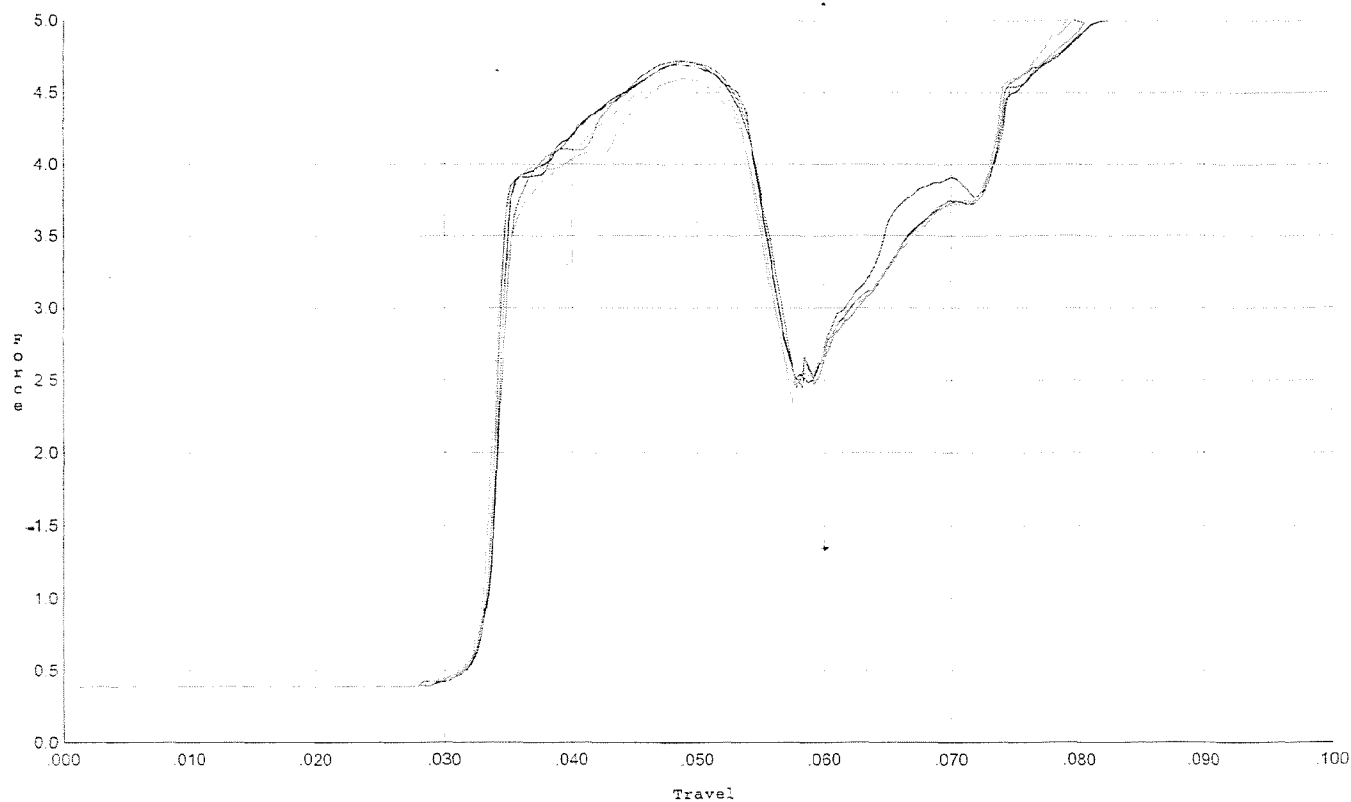
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.394	0.054	0.034	0.035	0.073		Set Trigger
2	3.314	0.054	0.034	0.035	0.073		Set Trigger
3	3.283	0.054	0.034	0.035	0.070		Set Trigger
4	3.309	0.054	0.034	0.035	0.072		Set Trigger
5	3.240	0.054	0.034	0.035	0.071		Set Trigger

A-330

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



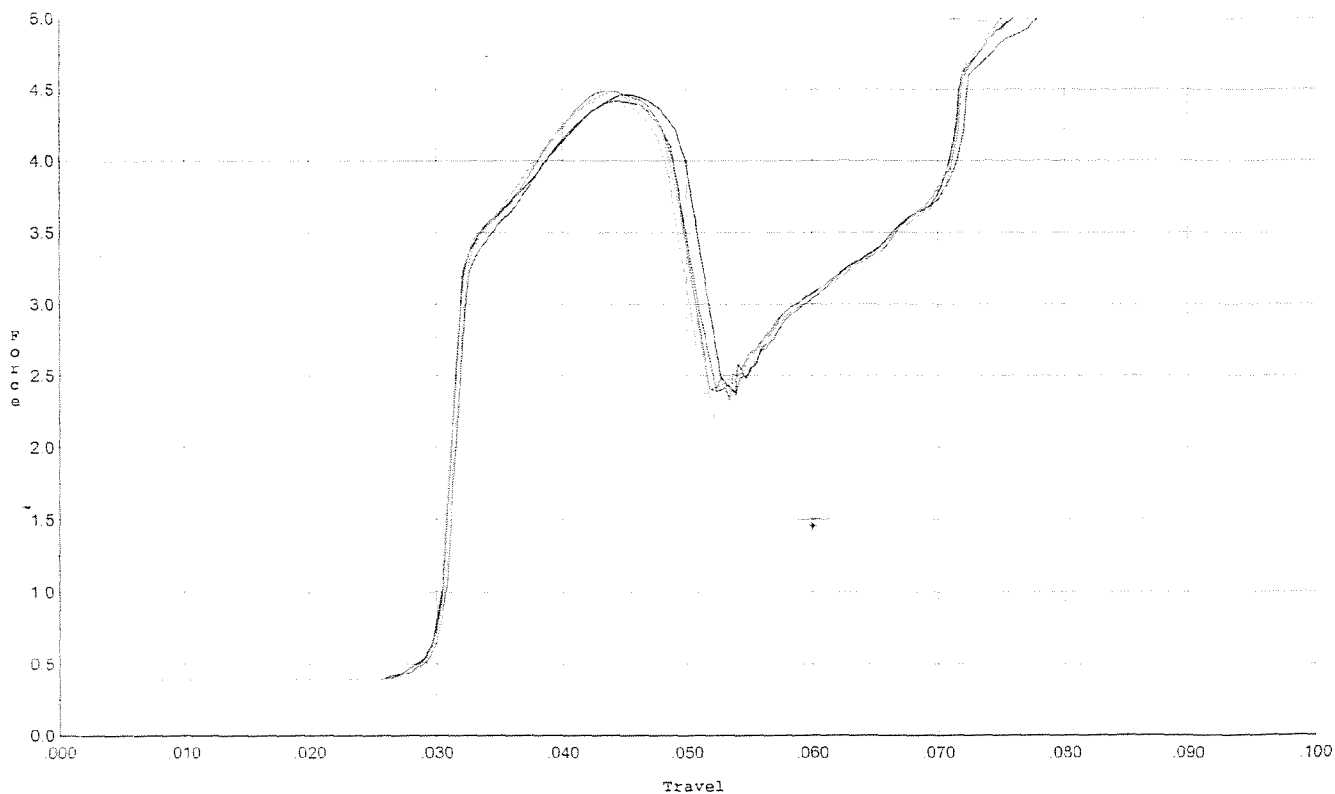
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.724	0.054	0.032	0.033	0.104		Set Trigger
2	4.691	0.054	0.033	0.033	0.103		Set Trigger
3	4.716	0.056	0.033	0.033	0.106		Set Trigger
4	4.691	0.054	0.032	0.033	0.101		Set Trigger
5	4.601	0.055	0.032	0.033	0.102		Set Trigger

A-4.65

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



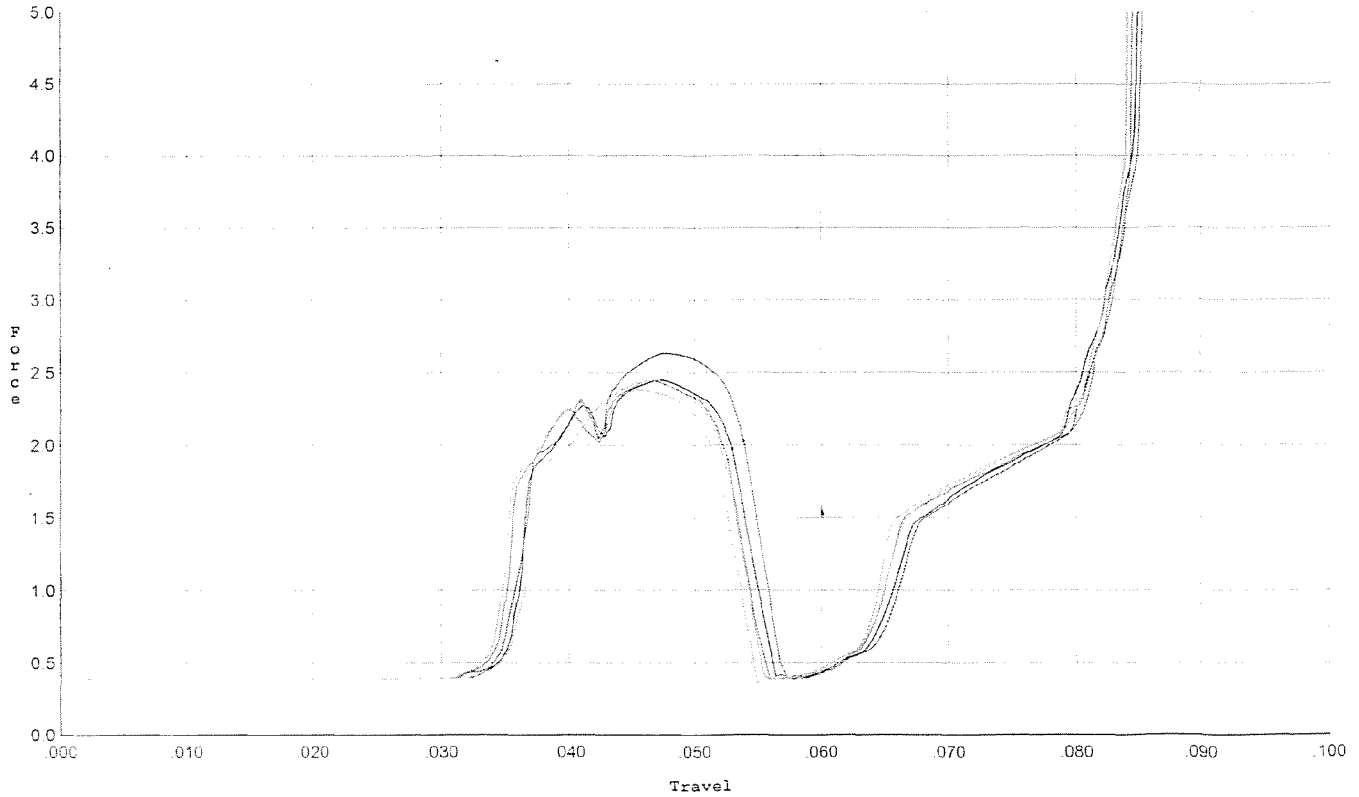
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.416	0.049	0.030	0.033	0.085		Set Trigger
2	4.462	0.050	0.030	0.032	0.091		Set Trigger
3	4.488	0.049	0.030	0.032	0.087		Set Trigger
4	4.422	0.049	0.030	0.033	0.084		Set Trigger
5	4.473	0.049	0.030	0.032	0.088		Set Trigger

A - 4.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



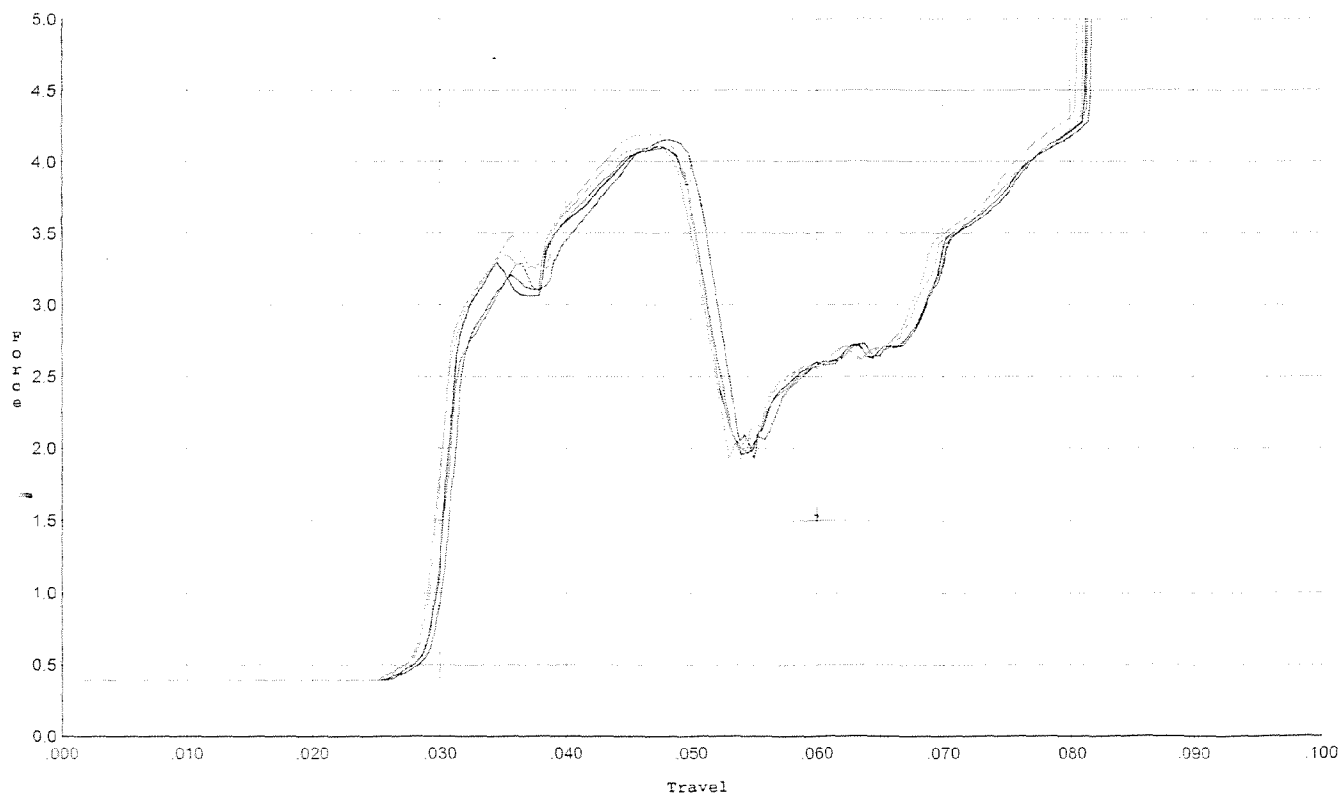
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.633	0.054	0.035	0.036	0.057		Set Trigger
2	2.451	0.053	0.035	0.036	0.052		Set Trigger
3	2.448	0.053	0.034	0.036	0.053		Set Trigger
4	2.448	0.053	0.036	0.037	0.050		Set Trigger
5	2.380	0.053	0.034	0.036	0.052		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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	4.155	0.051	0.029	0.032	0.085		Set Trigger
2	4.104	0.050	0.029	0.031	0.083		Set Trigger
3	4.094	0.050	0.029	0.032	0.082		Set Trigger
4	4.193	0.050	0.028	0.031	0.086		Set Trigger
5	4.113	0.050	0.028	0.031	0.087		Set Trigger

A. 4.13