

G680 1403

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



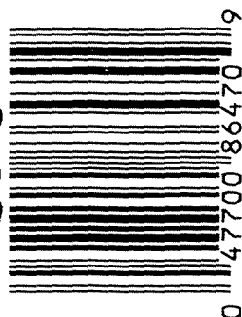
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6801403

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801403

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	MAGNAFLUX	10-22-08	SPN
475	DRILL AND TAP SIGHT HOLES	24	10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (RA)	10/24/08	(RA)
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/30/08	DG
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		1-8-09	W
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

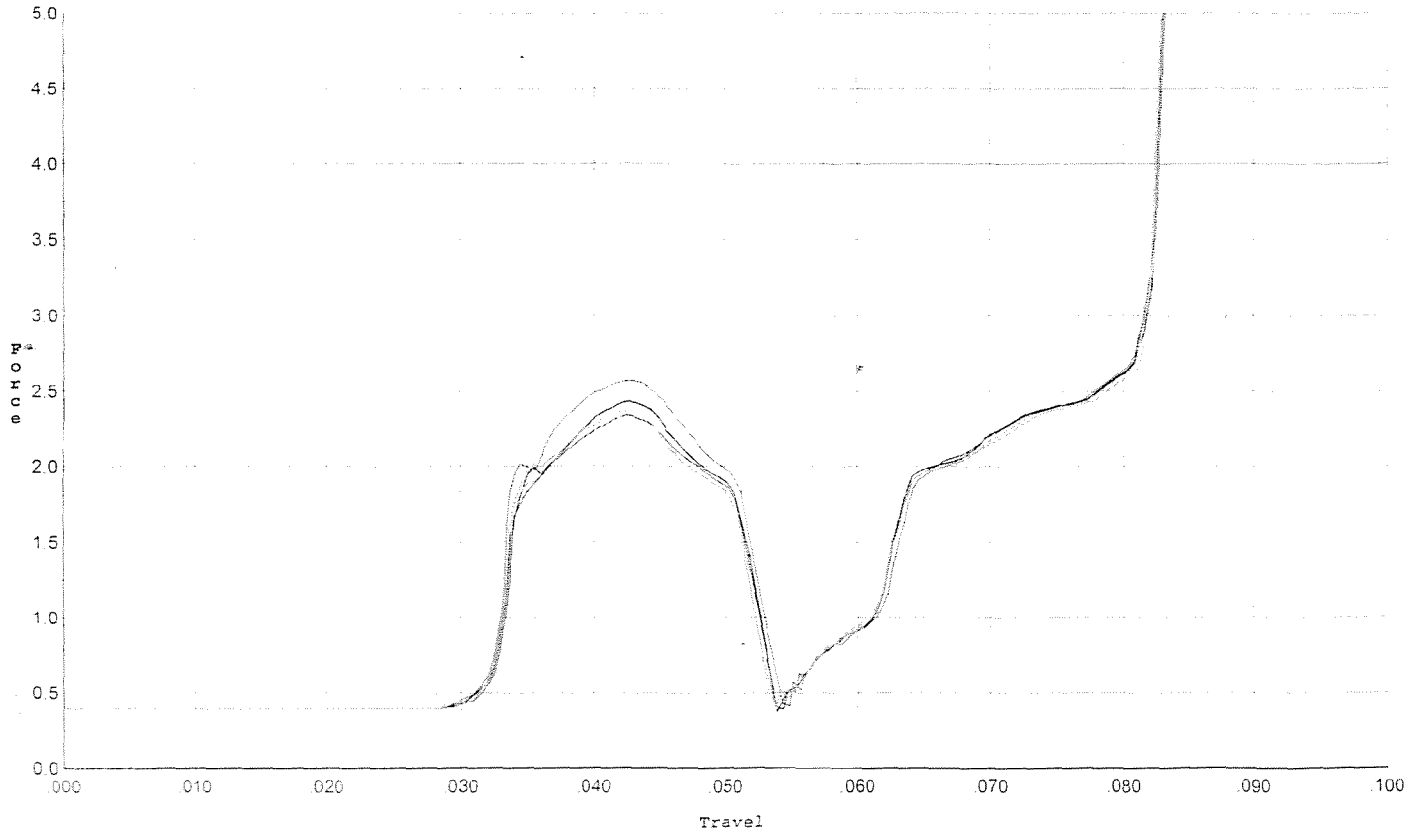
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-13-09	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	1-13-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	1-13-09	R.N.
	J) ASSEMBLE STOCK		1-8-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		1-13-09	R.N.
	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	1-8-09	R.N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-8-09	RP
670	FINAL INSPECTION A) HEADSPACE		1-13-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.56</u> <u>2.56</u> <u>2.53</u> <u>2.52</u>	1-12-09	TC
	C) FUNCTION		1-13-09	R.N.
690	PACK		1/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



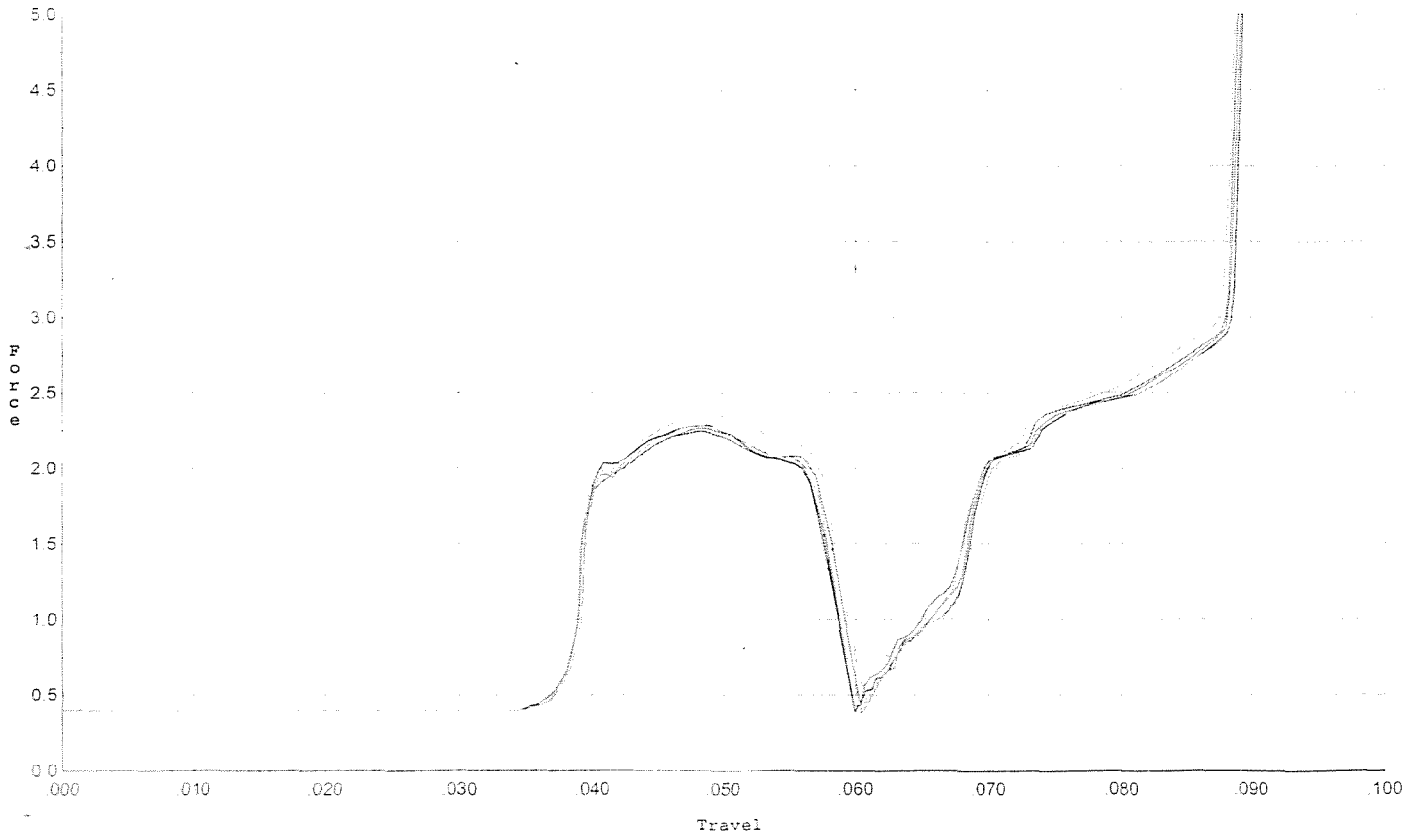
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.339	0.052	0.032	0.036	0.052		Set Trigger
2	2.432	0.052	0.032	0.036	0.052		Set Trigger
3	2.569	0.051	0.032	0.036	0.055		Set Trigger
4	2.327	0.051	0.032	0.036	0.051		Set Trigger
5	2.363	0.051	0.033	0.036	0.050		Set Trigger

A. 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



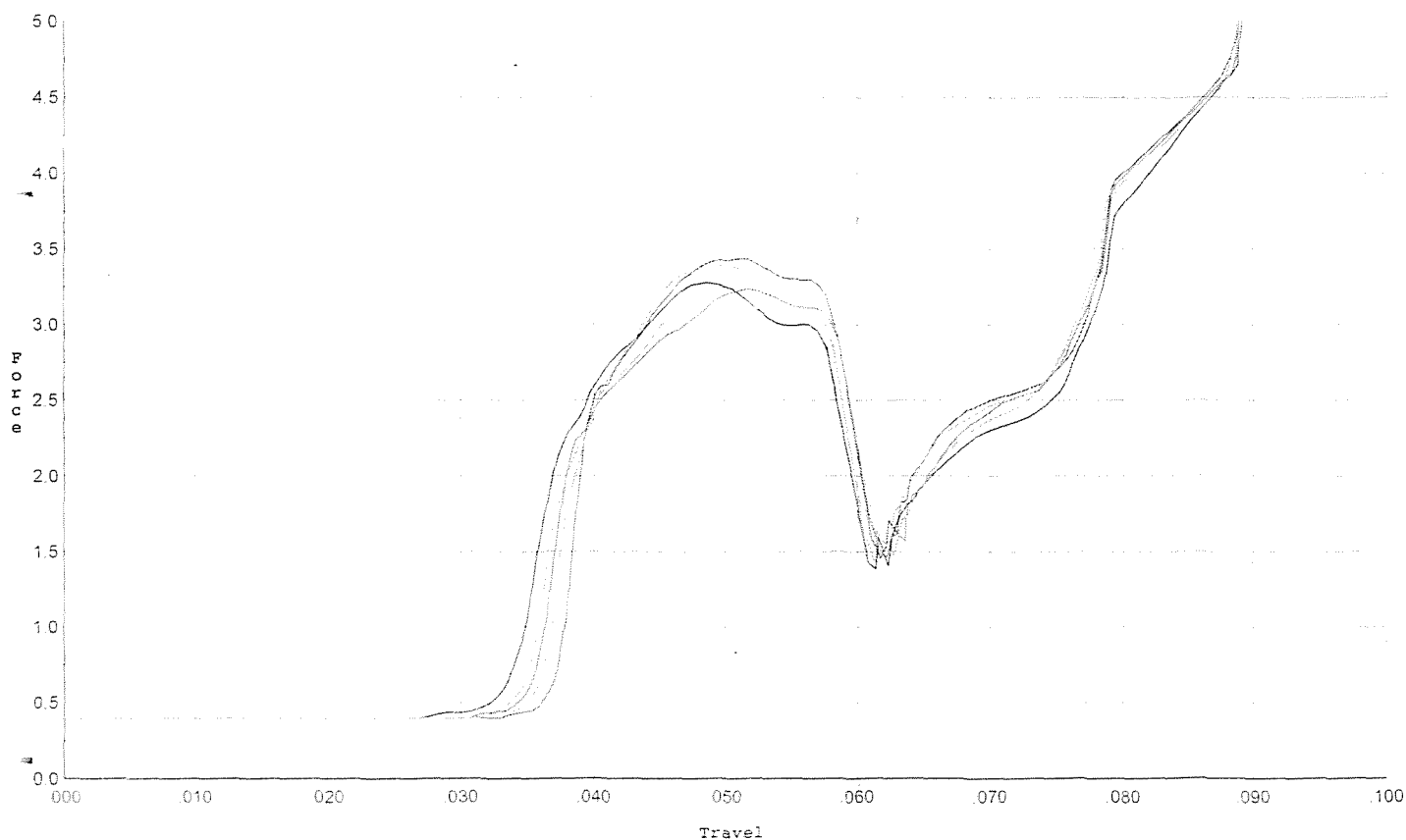
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.243	0.058	0.038	0.038	0.055		Set Trigger
2	2.282	0.058	0.038	0.038	0.055		Set Trigger
3	2.265	0.058	0.038	0.038	0.056		Set Trigger
4	2.283	0.057	0.038	0.038	0.054		Set Trigger
5	2.367	0.058	0.038	0.037	0.057		Set Trigger

A. 2-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



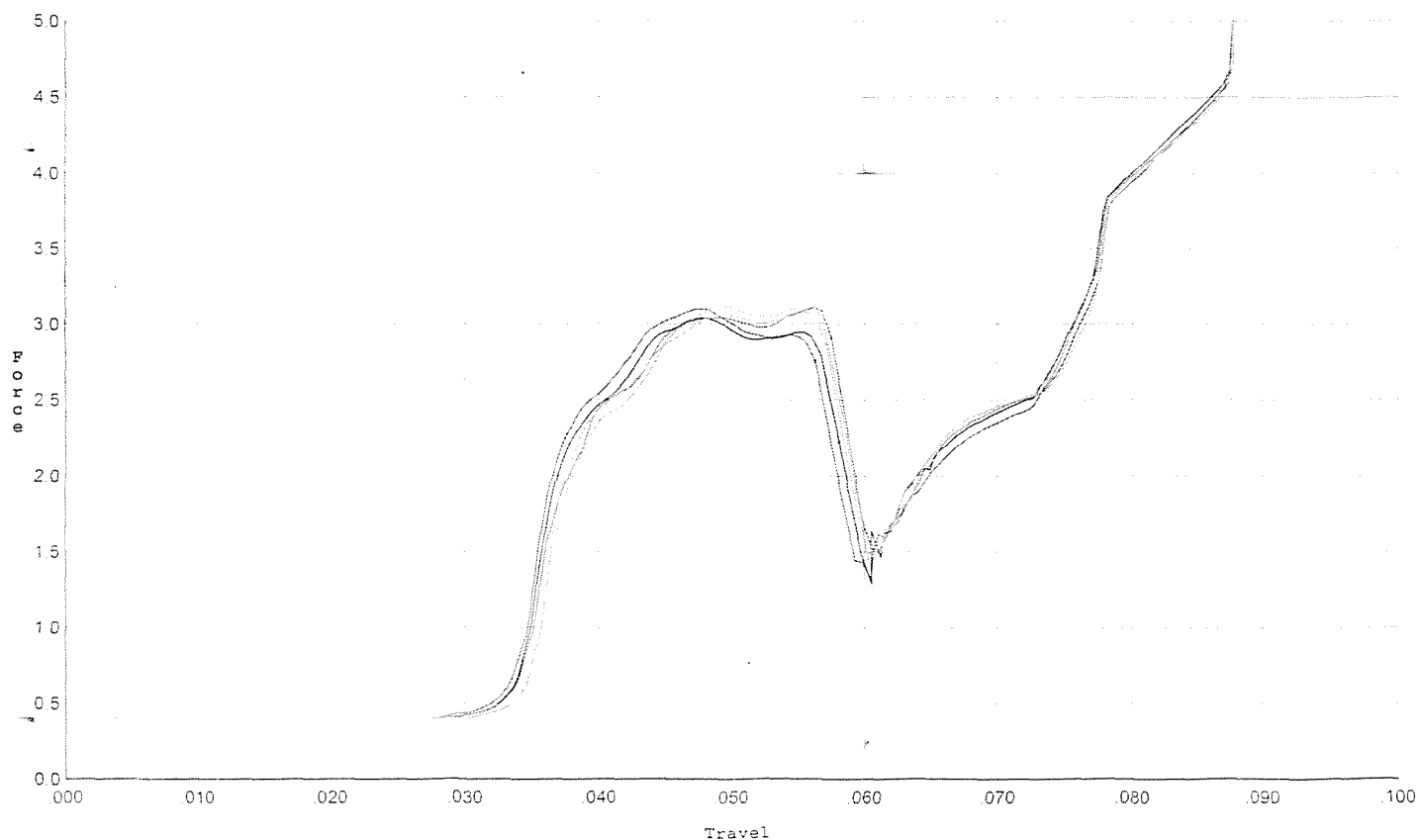
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.438	0.059	0.037	0.035	0.080		Set Trigger
2	3.277	0.058	0.034	0.035	0.080		Set Trigger
3	3.234	0.059	0.035	0.035	0.079		Set Trigger
4	3.158	0.059	0.035	0.035	0.080		Set Trigger
5	3.395	0.058	0.036	0.035	0.079		Set Trigger

A-3.30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 1/7/2009

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



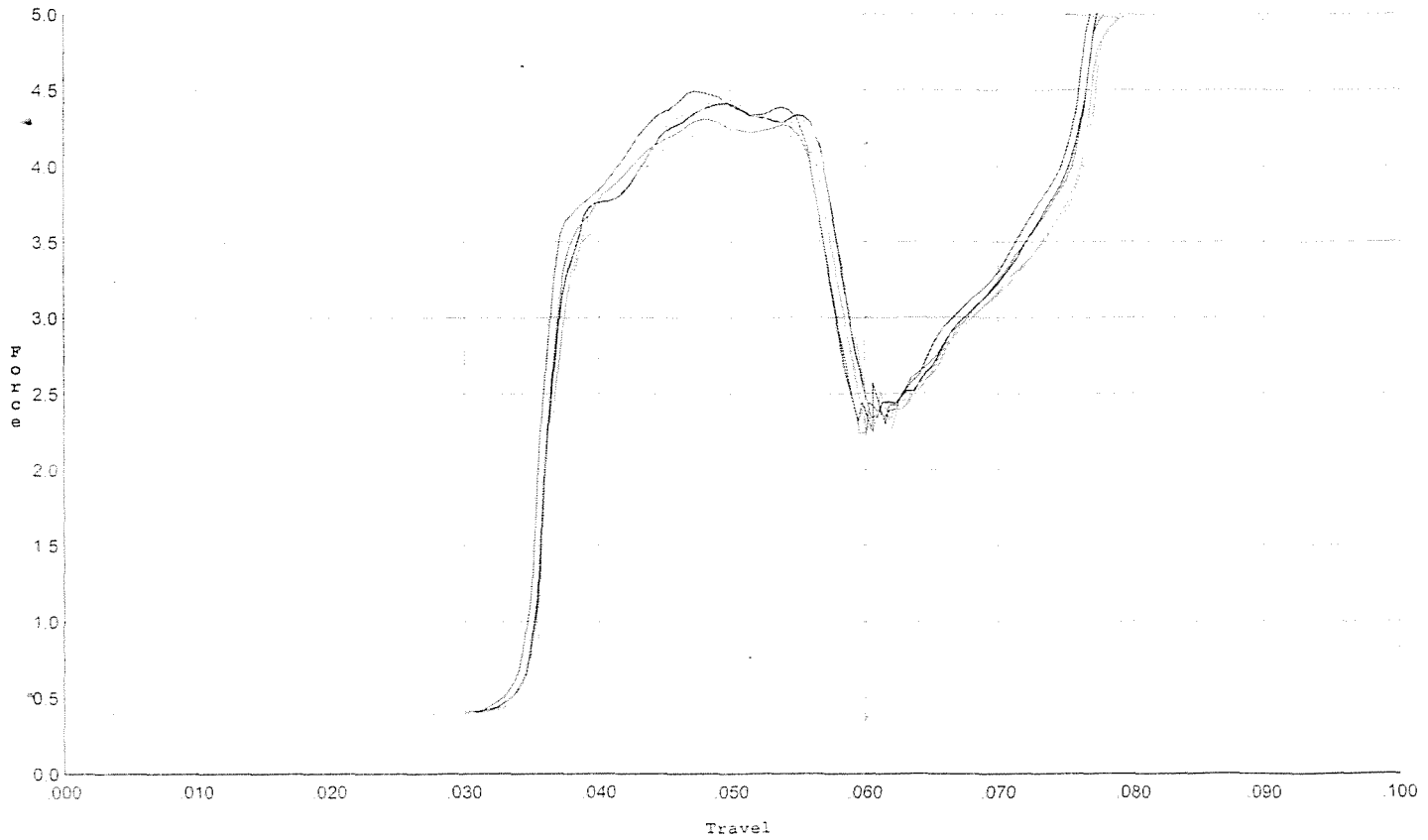
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.099	0.056	0.033	0.035	0.075		Set Trigger
2	3.040	0.058	0.034	0.035	0.077		Set Trigger
3	3.107	0.058	0.034	0.034	0.077		Set Trigger
4	3.074	0.057	0.035	0.035	0.074		Set Trigger
5	3.118	0.058	0.035	0.035	0.076		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



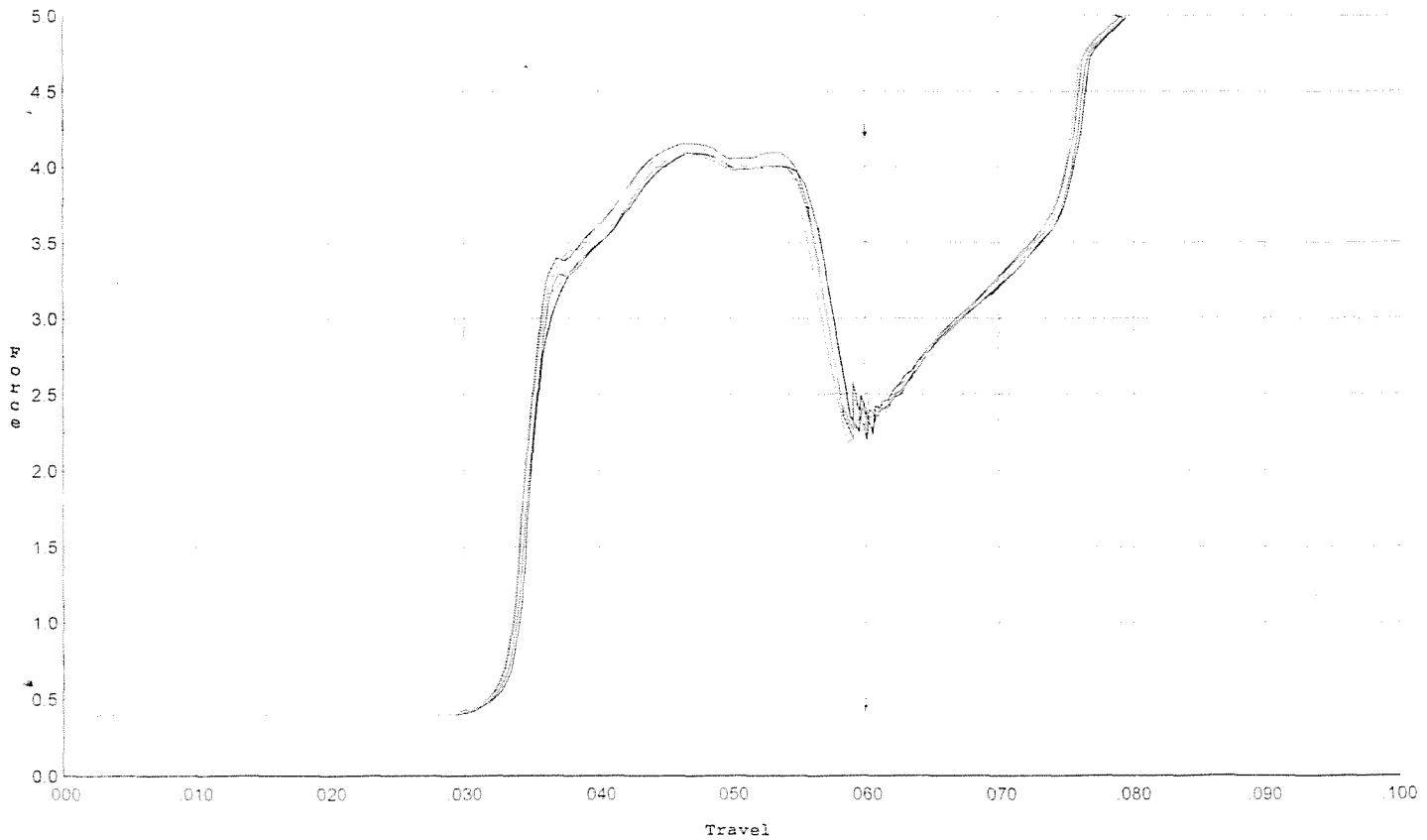
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.490	0.056	0.034	0.033	0.101		Set Trigger
2	4.412	0.057	0.034	0.032	0.102		Set Trigger
3	4.308	0.056	0.034	0.033	0.098		Set Trigger
4	4.436	0.059	0.035	0.032	0.105		Set Trigger
5	4.267	0.056	0.035	0.033	0.098		Set Trigger

A - 4.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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



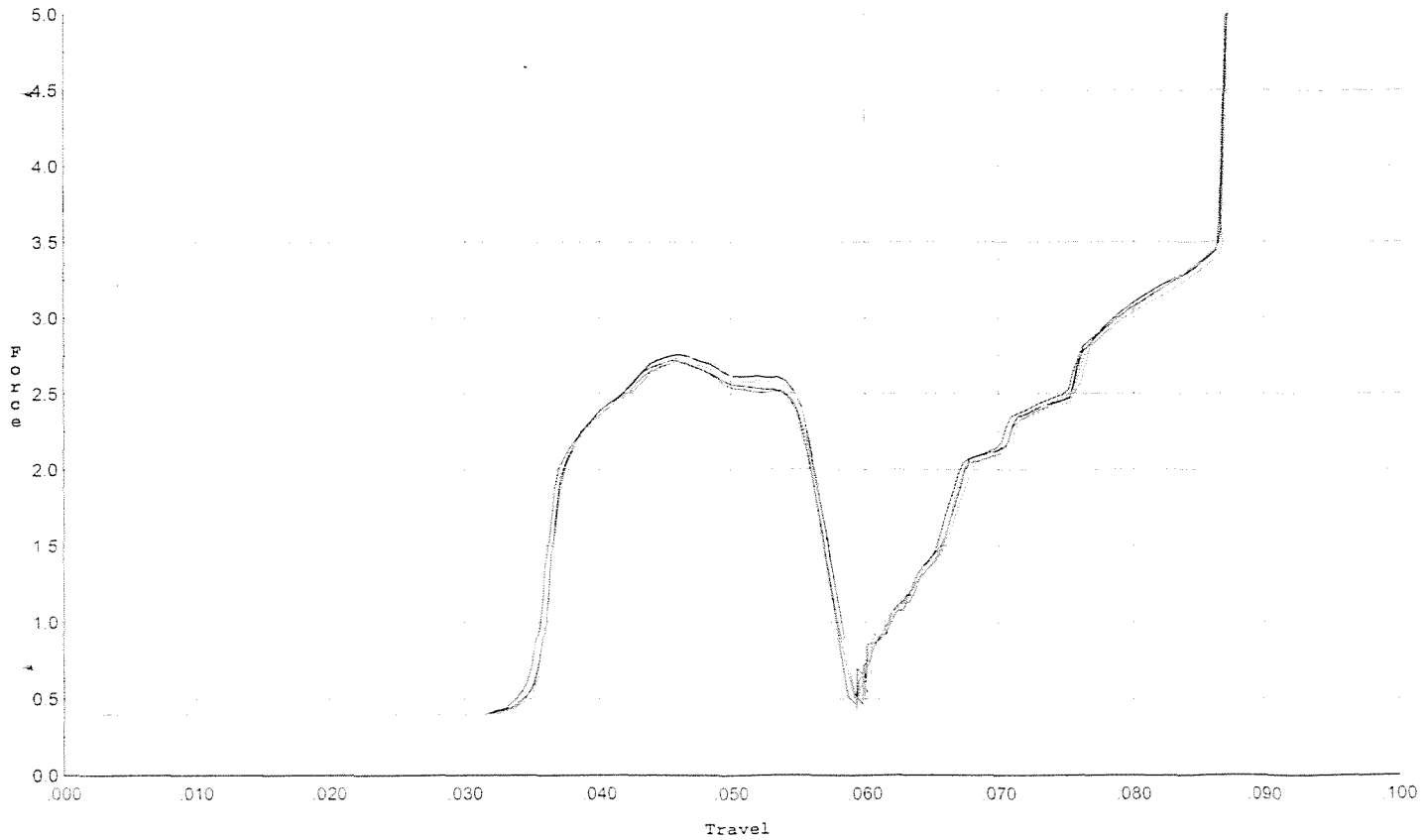
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.156	0.056	0.033	0.033	0.098		Set Trigger
2	4.091	0.057	0.033	0.033	0.097		Set Trigger
3	4.097	0.056	0.033	0.033	0.096		Set Trigger
4	4.088	0.056	0.033	0.033	0.097		Set Trigger
5	4.136	0.055	0.033	0.033	0.096		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 1/7/2009

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



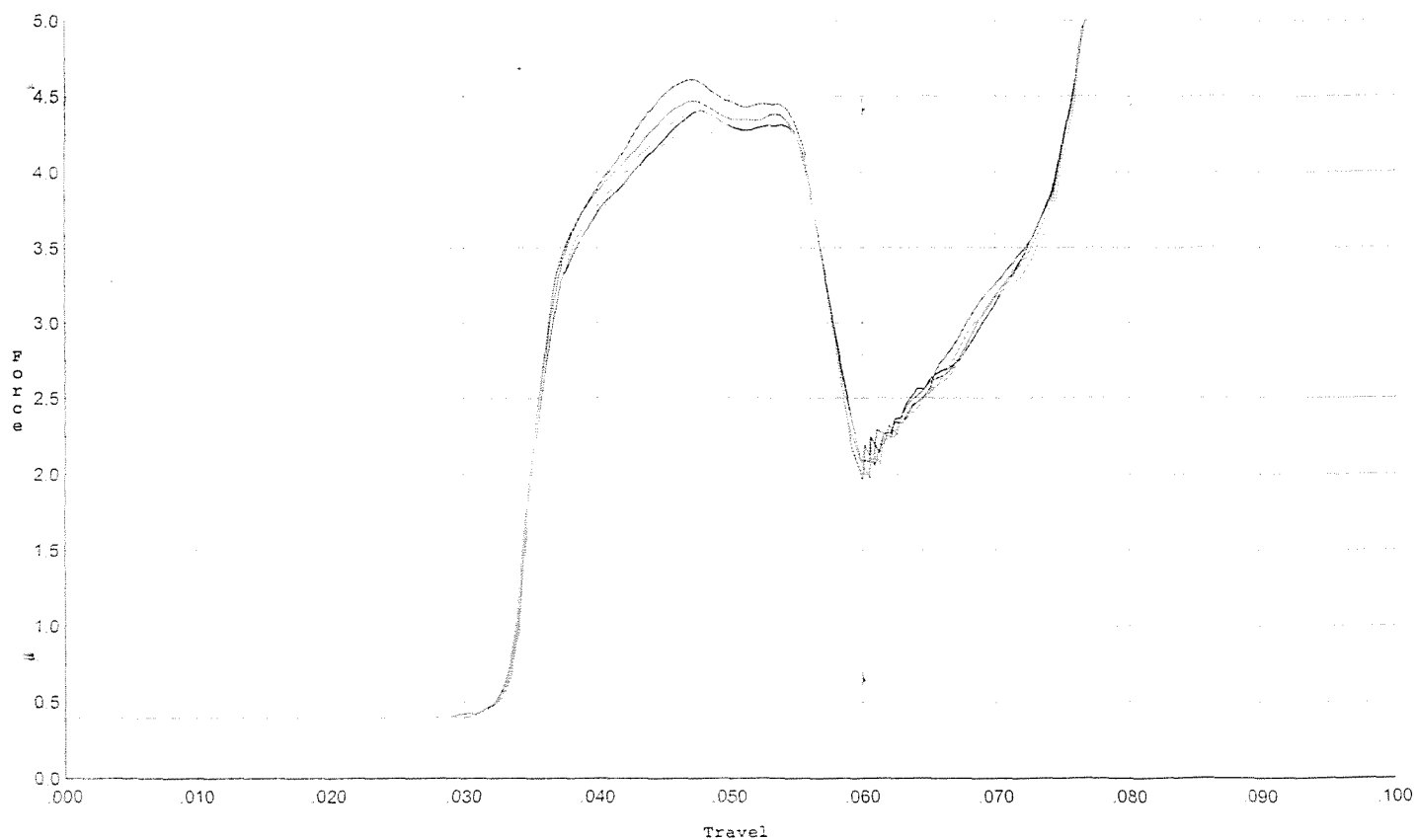
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.716	0.056	0.035	0.036	0.064		Set Trigger
2	2.755	0.057	0.035	0.036	0.066		Set Trigger
3	2.708	0.056	0.035	0.036	0.063		Set Trigger
4	2.708	0.056	0.036	0.036	0.063		Set Trigger
5	2.739	0.057	0.036	0.036	0.065		Set Trigger

A.2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 1/7/2009

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	4.609	0.056	0.033	0.033	0.104		Set Trigger
2	4.405	0.056	0.034	0.033	0.100		Set Trigger
3	4.471	0.056	0.033	0.033	0.102		Set Trigger
4	4.401	0.056	0.034	0.033	0.100		Set Trigger
5	4.282	0.056	0.033	0.033	0.100		Set Trigger

A-4.43