

G680 1411

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



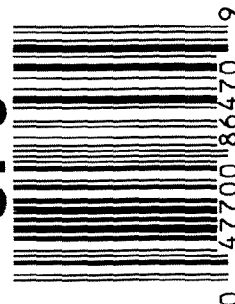
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6801411

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801411

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	MAGNA FLUX	10-21-08	SPD.
472	SERIALIZE BOLT HANDLE		10-22-08	Rsn
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/24/08	SP
490	MAGNAFLUX BOLT		10/24/08	mR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/24/08	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			
	D) OIL FIRING PIN ASSEMBLY		1-9-09	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

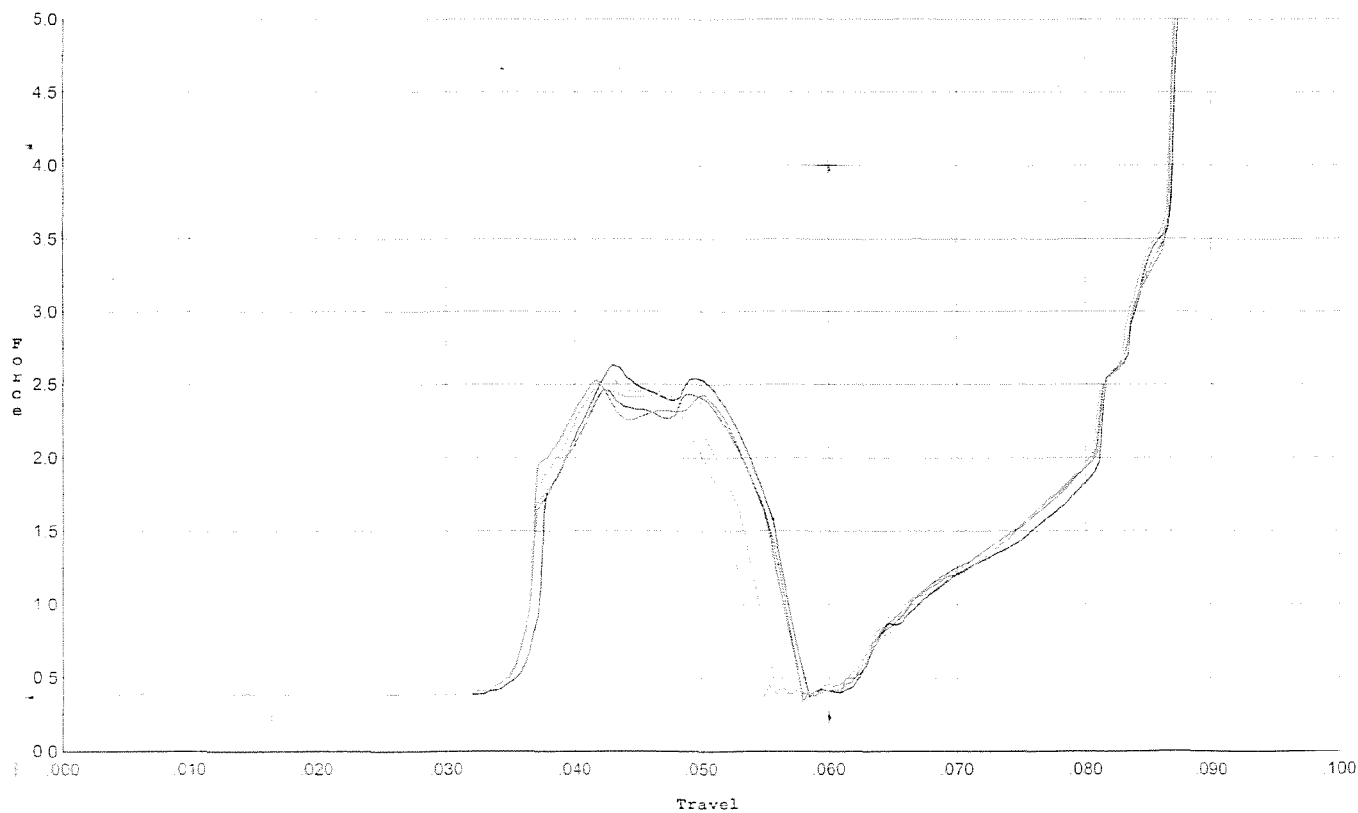
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	1-16-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	1-16-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-16-09	L.N.
	J) ASSEMBLE STOCK		1-9-09	Law
	K) ASSEMBLE SWIVEL STUDS		1-16-09	L.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	1-15-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-15-09	L.N.
670	FINAL INSPECTION A) HEADSPACE		1-16-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.64</u> <u>2.69</u> <u>2.69</u> <u>2.66</u>	1-16-09	TC
	C) FUNCTION		1-16-09	L.N.
690	PACK		1/20/09	Fry

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



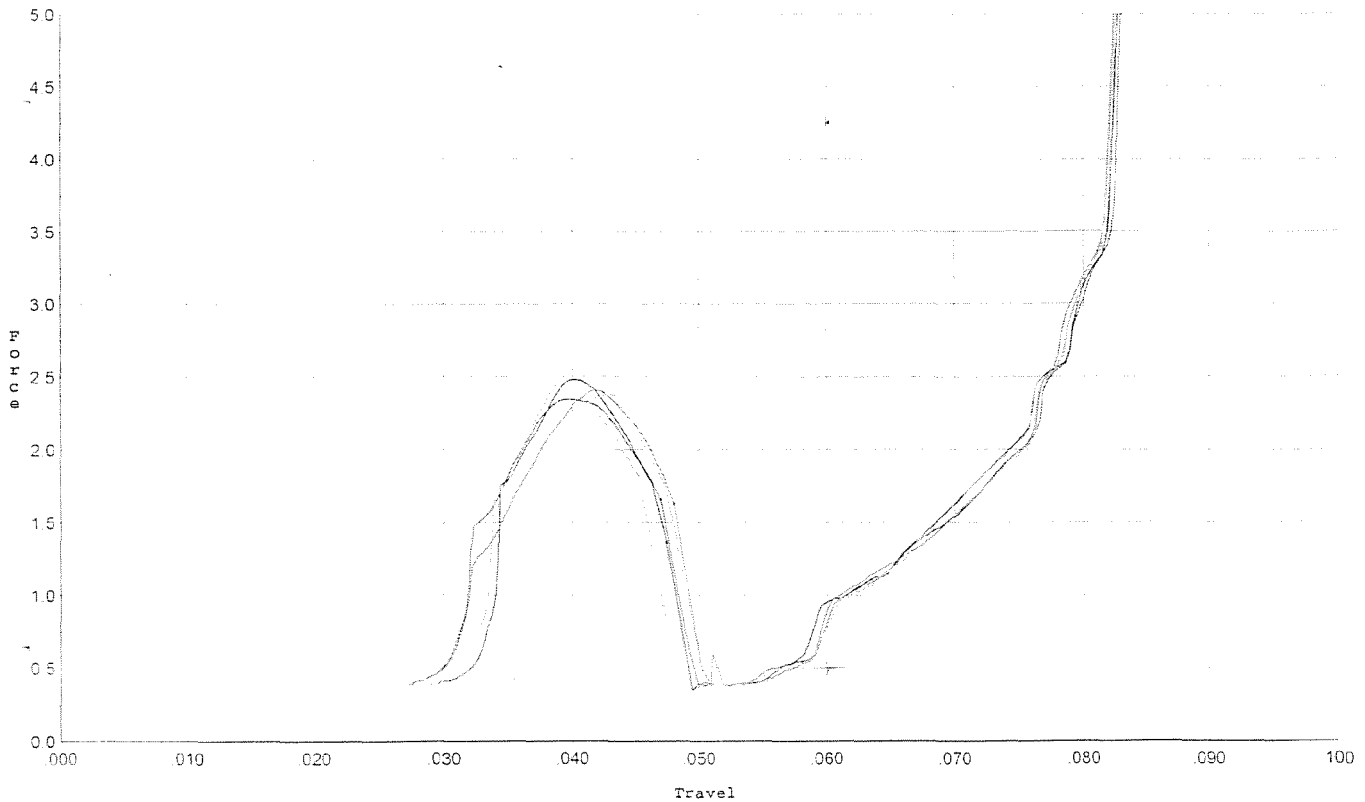
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.457	0.055	0.036	0.037	0.055		Set Trigger
2	2.635	0.056	0.036	0.037	0.057		Set Trigger
3	2.530	0.056	0.036	0.037	0.057		Set Trigger
4	2.546	0.052	0.036	0.039	0.049		Set Trigger
5	2.465	0.054	0.036	0.038	0.052		Set Trigger

A-252

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



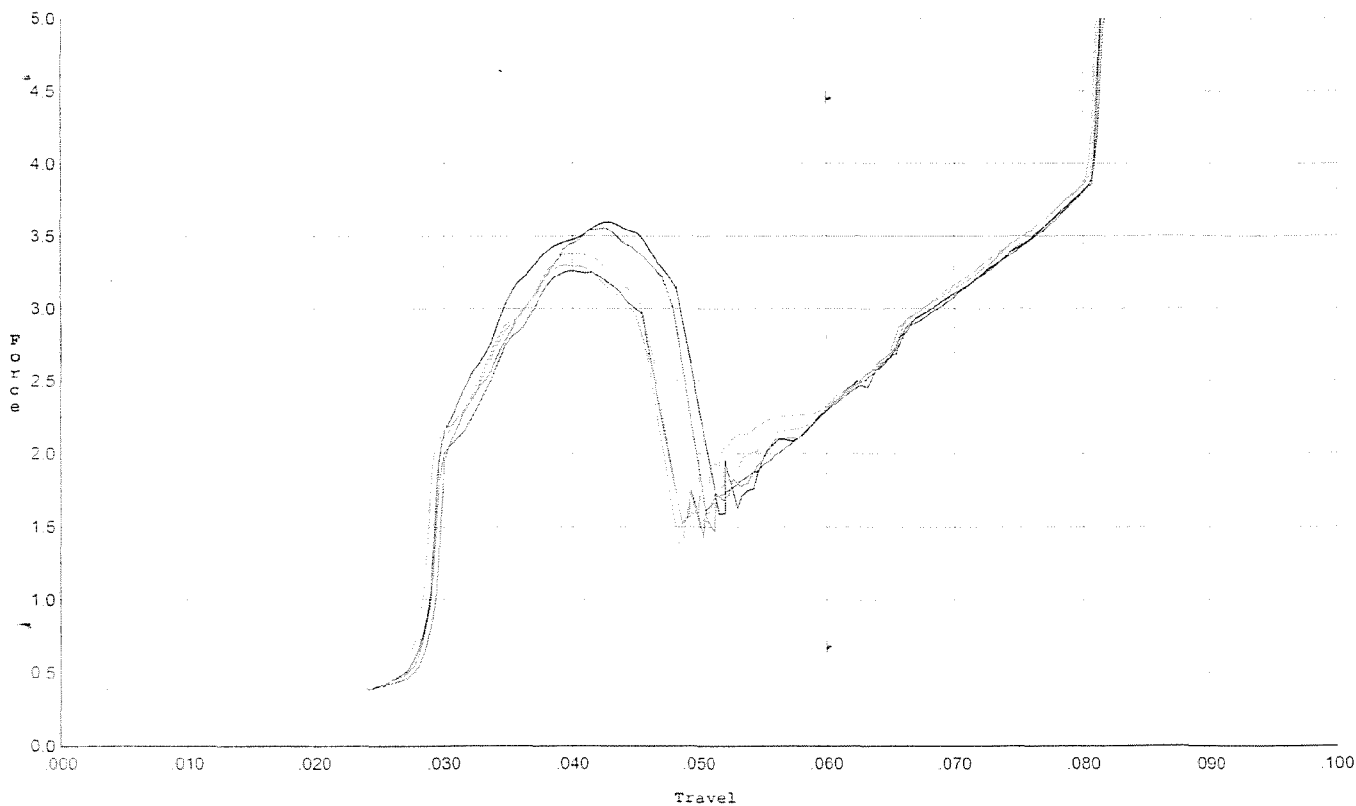
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.341	0.047	0.031	0.039	0.044		Set Trigger
2	2.478	0.047	0.033	0.039	0.042		Set Trigger
3	2.412	0.048	0.031	0.039	0.045		Set Trigger
4	2.380	0.049	0.038	0.039	0.037		Set Trigger
5	2.504	0.045	0.032	0.041	0.039		Set Trigger

A-2.42

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 lbs



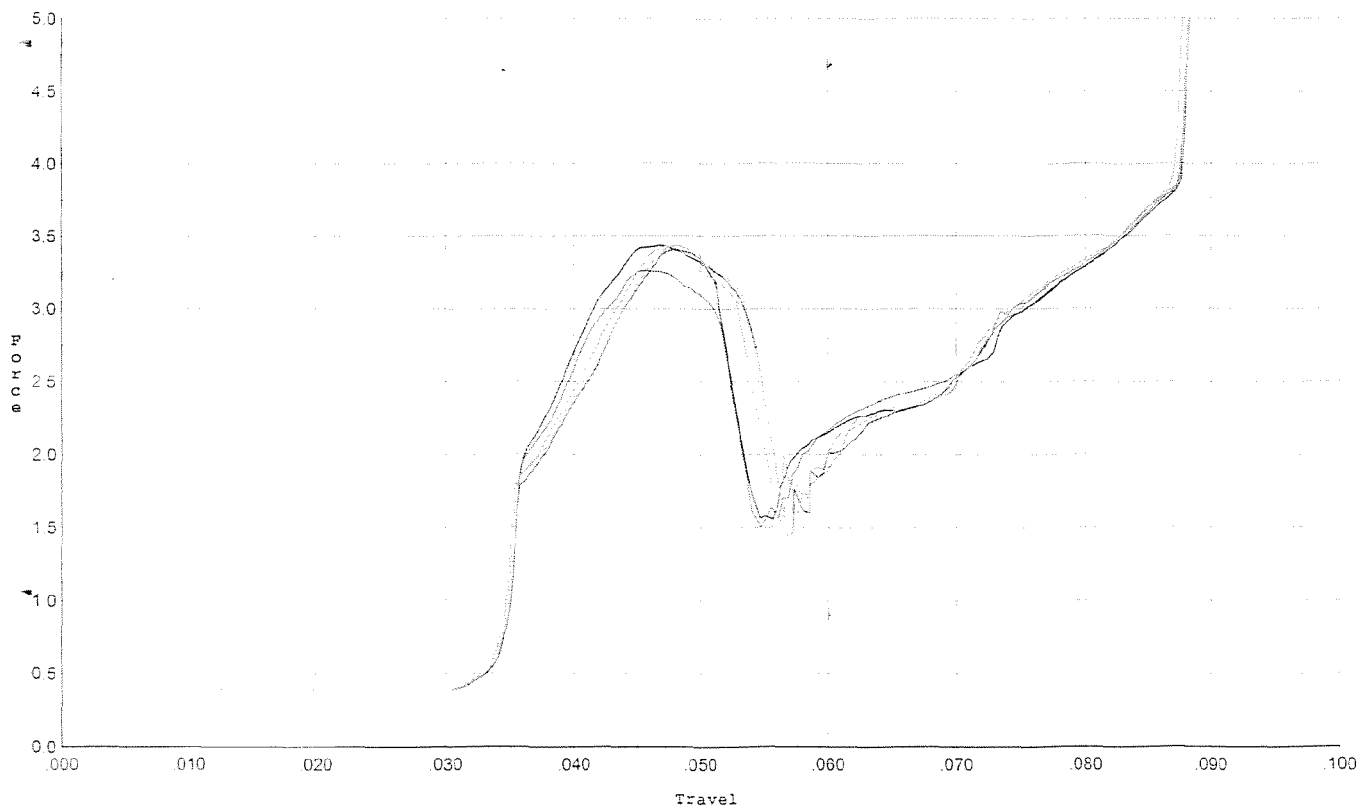
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.045	0.028	0.037	0.059		Set Trigger
2	3.593	0.048	0.028	0.034	0.073		Set Trigger
3	3.555	0.048	0.028	0.035	0.069		Set Trigger
4	3.377	0.047	0.028	0.036	0.064		Set Trigger
5	3.296	0.046	0.028	0.036	0.062		Set Trigger

A-3-411

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 lbs



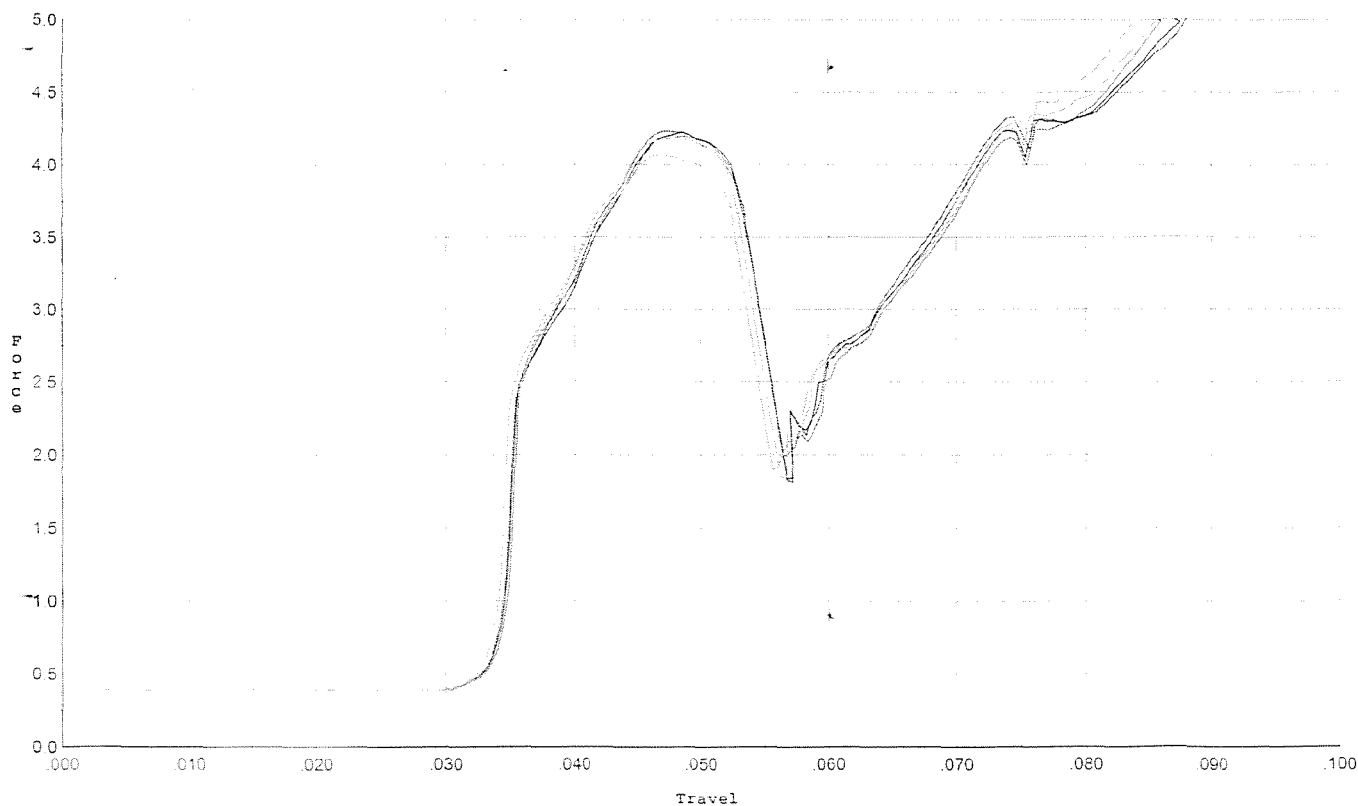
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.404	0.054	0.034	0.037	0.069		Set Trigger
2	3.434	0.051	0.034	0.039	0.064		Set Trigger
3	3.259	0.052	0.034	0.039	0.062		Set Trigger
4	3.429	0.053	0.034	0.037	0.067		Set Trigger
5	3.434	0.054	0.034	0.036	0.070		Set Trigger

A.339

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



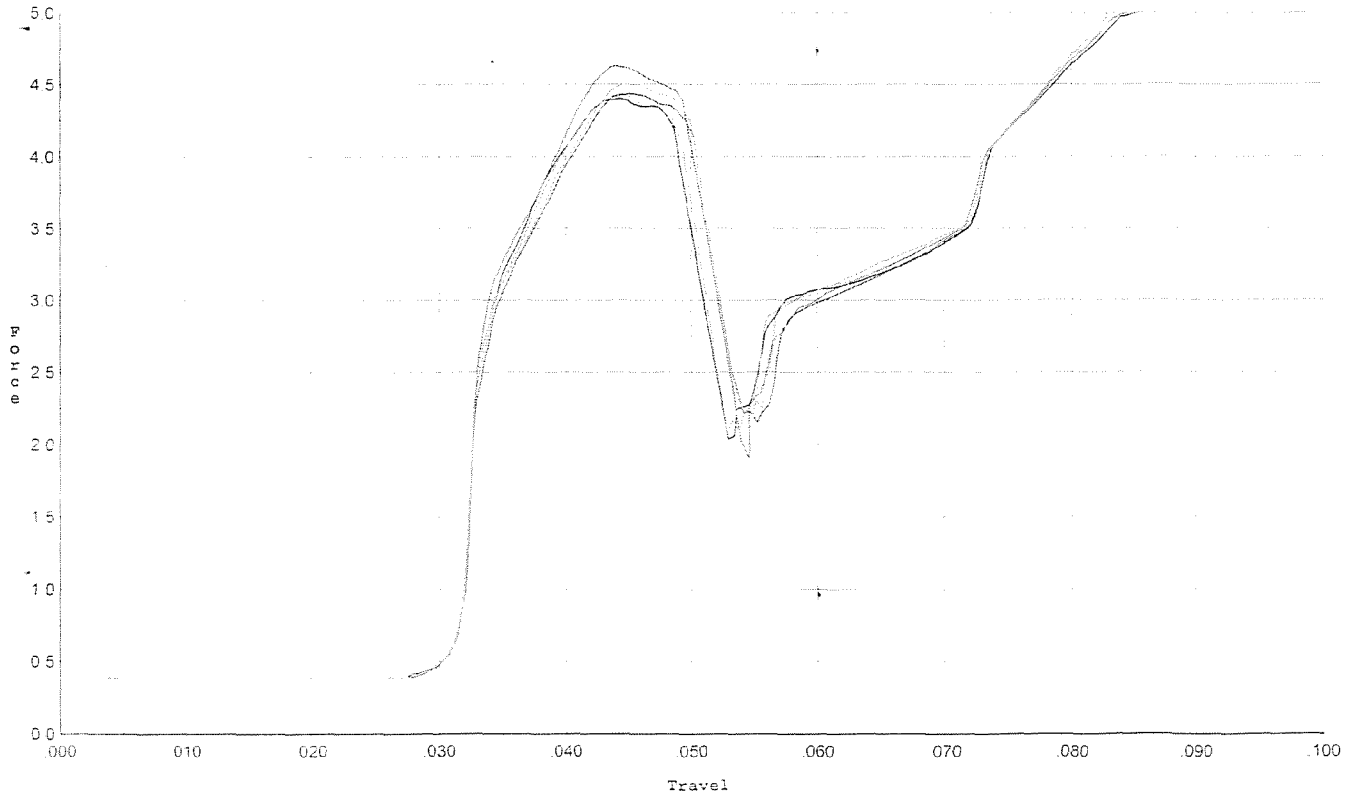
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.232	0.054	0.034	0.036	0.084		Set Trigger
2	4.222	0.053	0.034	0.035	0.084		Set Trigger
3	4.196	0.053	0.034	0.035	0.084		Set Trigger
4	4.188	0.053	0.033	0.035	0.084		Set Trigger
5	4.072	0.052	0.034	0.036	0.079		Set Trigger

A. 4.18

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



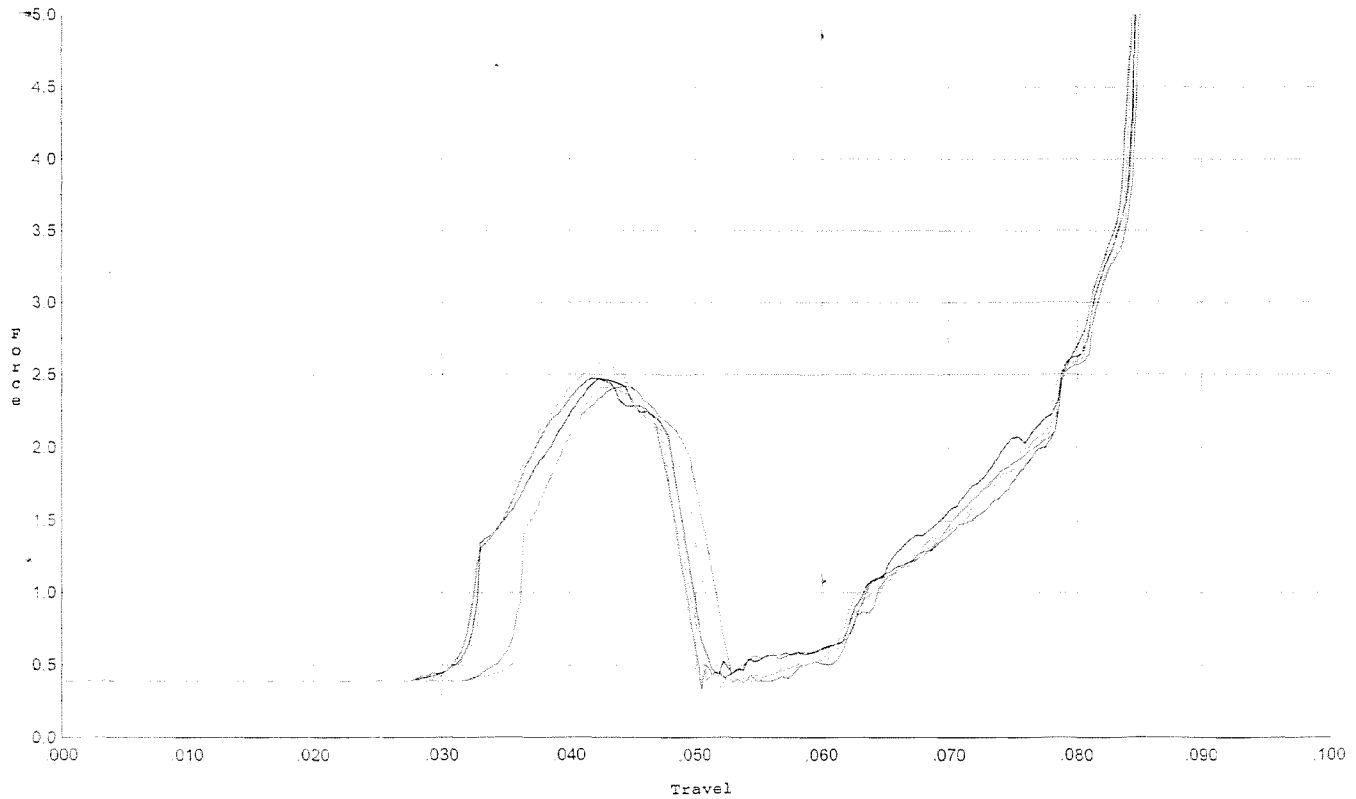
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.436	0.050	0.031	0.035	0.085		Set Trigger
2	4.403	0.049	0.031	0.036	0.080		Set Trigger
3	4.630	0.051	0.031	0.034	0.089		Set Trigger
4	4.499	0.050	0.031	0.034	0.086		Set Trigger
5	4.423	0.049	0.031	0.035	0.082		Set Trigger

M 447

Trigger Profile [lbs,inch]

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

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



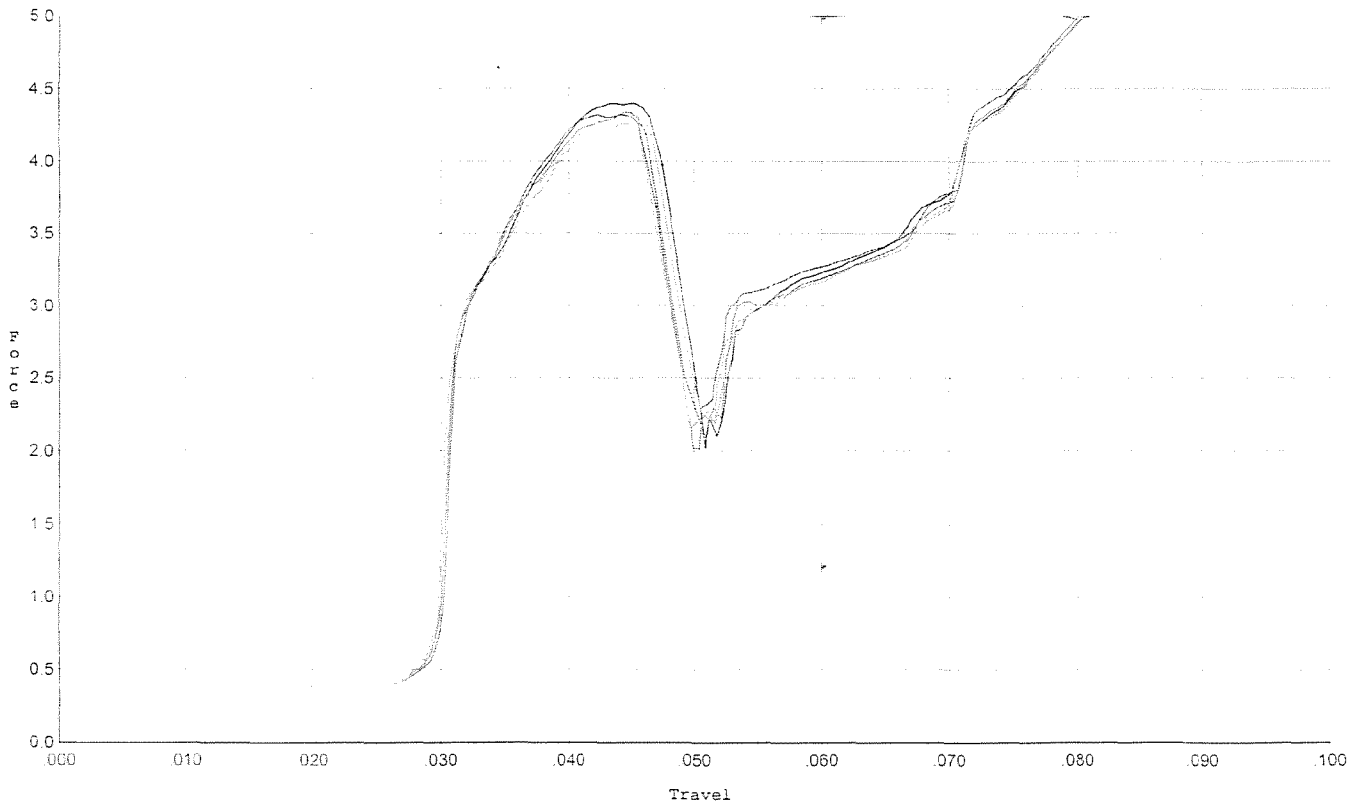
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.470	0.048	0.031	0.040	0.045		Set Trigger
2	2.468	0.048	0.032	0.040	0.045		Set Trigger
3	2.416	0.051	0.035	0.039	0.045		Set Trigger
4	2.411	0.050	0.036	0.039	0.042		Set Trigger
5	2.585	0.047	0.032	0.040	0.045		Set Trigger

A2.47

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 b for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.318	0.047	0.030	0.036	0.077		Set Trigger
2	4.398	0.047	0.029	0.035	0.081		Set Trigger
3	4.339	0.046	0.029	0.036	0.076		Set Trigger
4	4.261	0.048	0.029	0.035	0.078		Set Trigger
5	4.310	0.047	0.029	0.035	0.077		Set Trigger

A 4.32