

G 680 1422

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

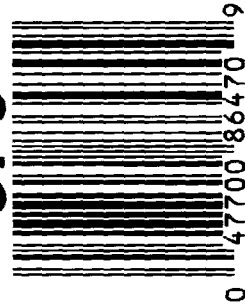
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6801422

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C680 1422

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-15-09	RT
430	ASSEMBLE TO STOCK		5-19-09	W W
440	PROOF		5-19-09	W W
460	CHECK HEADSPACE	MAGNA - FLUX	5-19-09	W W
470	DIS-ASSEMBLE ACTION		5-19-09	RT
472	SERIALIZE BOLT HANDLE		5-19-09	RT
480	MAGNAFLUX BBL ACTION	2009 OPERATOR 	5/24/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-19-09	SP
520	GOFF BLAST BBL / REC		5/29/09	SP
540	APPLY COATINGS (BARREL ACTION)		6/2	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-2-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-2-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-2-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-3-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

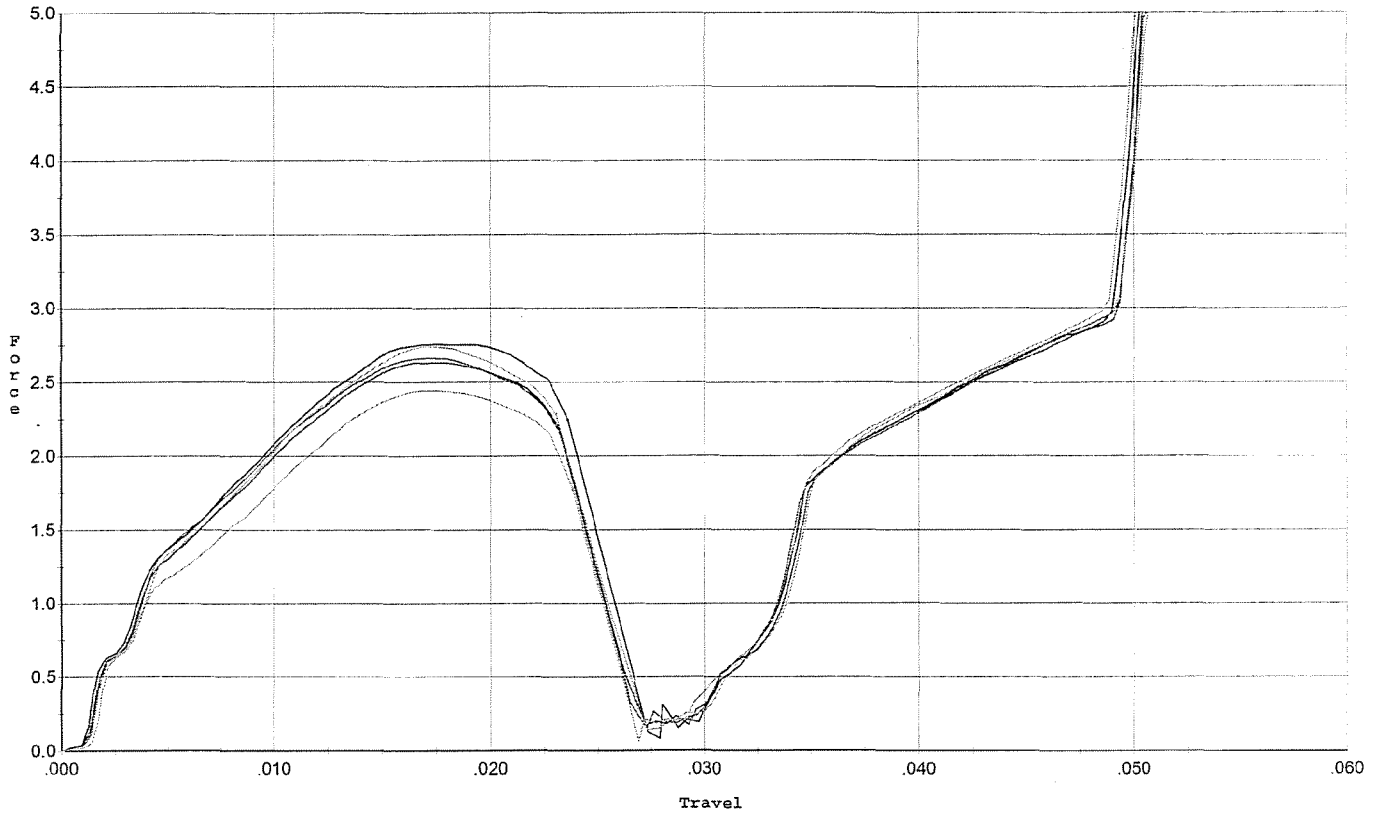
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.5</u>	6-22-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	6-22-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	6-22-09	LN
	J) ASSEMBLE STOCK		6-3-09	LN
	K) ASSEMBLE SWIVEL STUDS		6-22-09	LN
	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	6/16/09	RR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-22-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.66</u> <u>2.63</u> <u>2.54</u> <u>2.66</u>	6-19-09	LN
	C) FUNCTION		6-22-09	LN
690	PACK		7/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



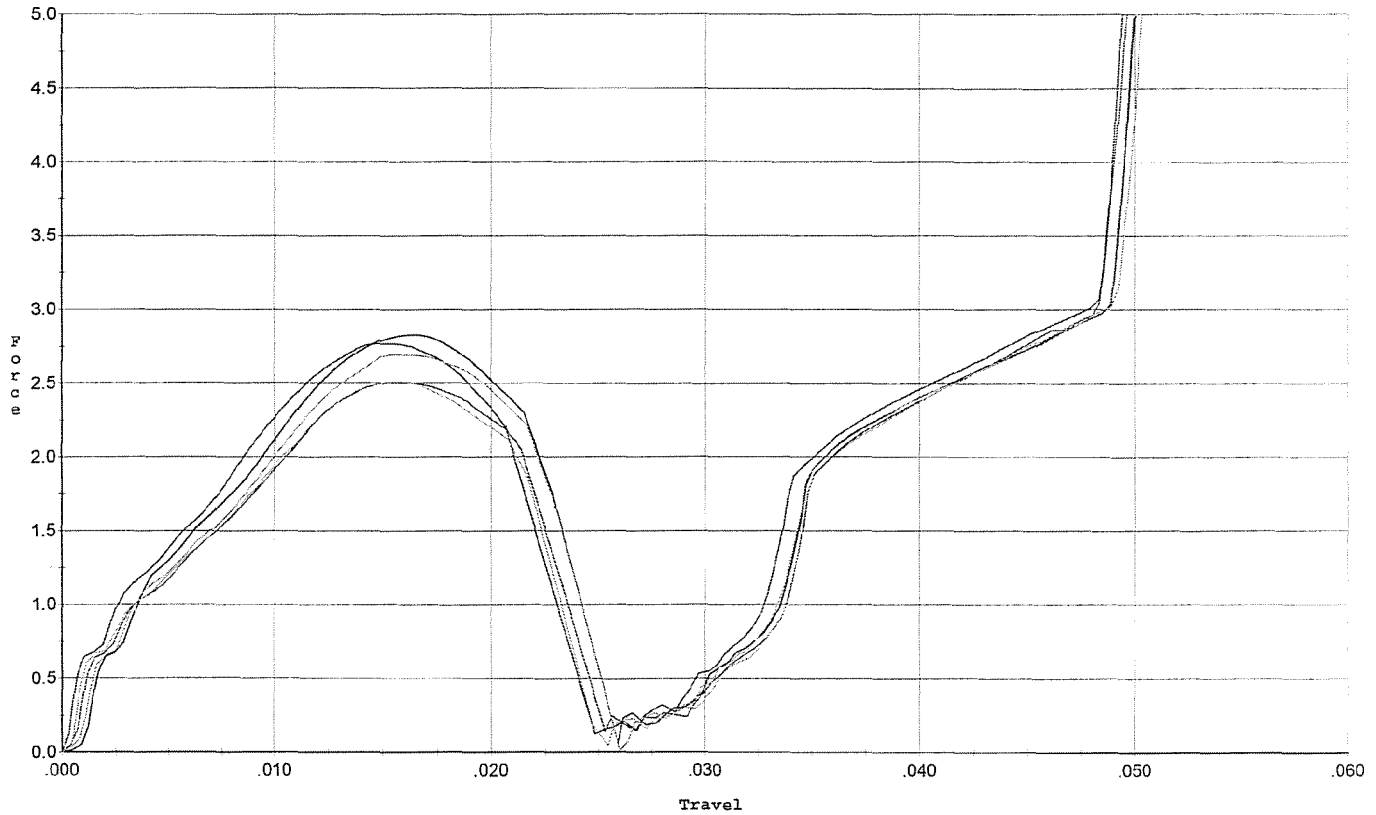
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.023	0.00	0.033	0.042		Set Trigger
2	2.754	0.024	0.00	0.032	0.045		Set Trigger
3	2.661	0.023	0.00	0.033	0.042		Set Trigger
4	2.740	0.023	0.00	0.033	0.042		Set Trigger
5	2.445	0.024	0.00	0.032	0.039		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

Model: M/24
Serial No: Form #F005
Trigger: 2..5 lbs after 50 cycles+/- .50 lb



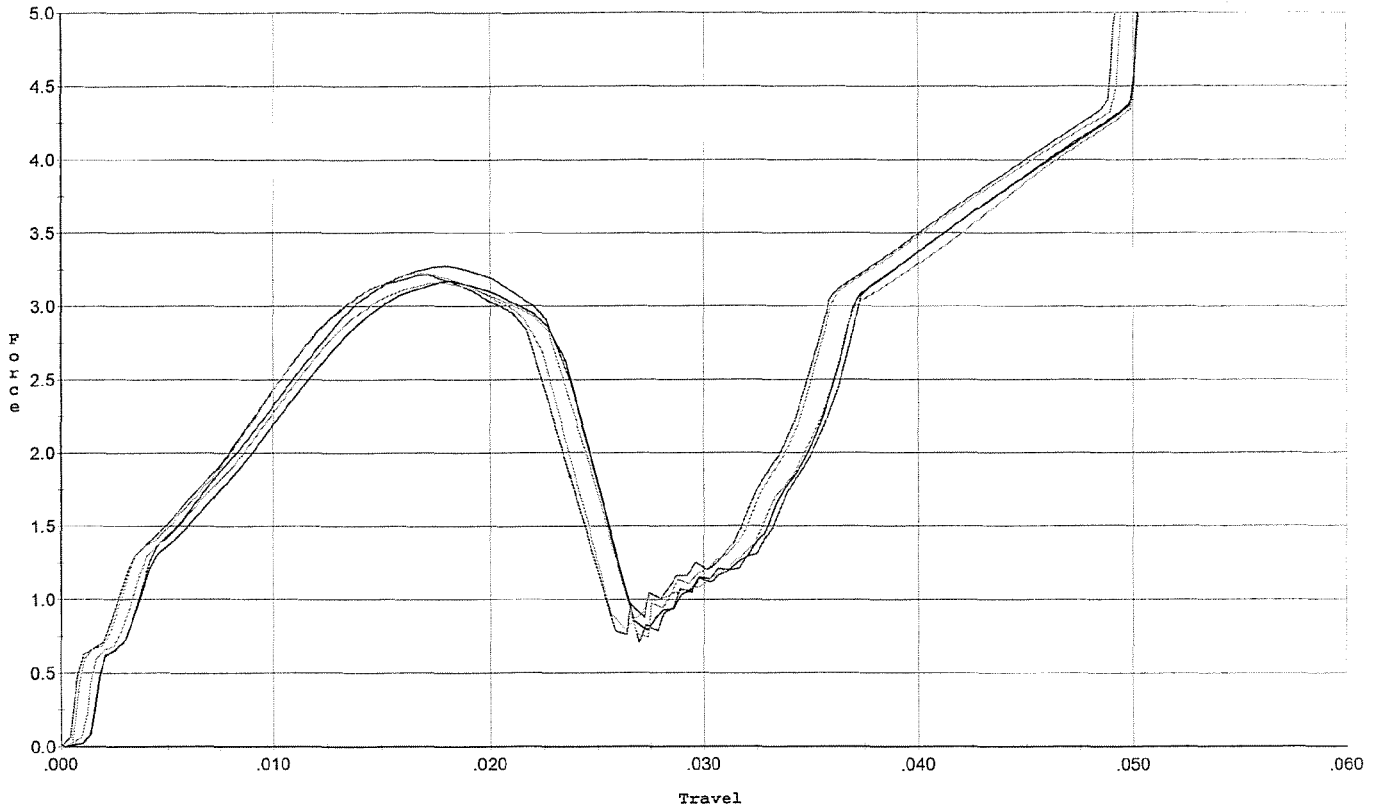
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.769	0.021	0.00	0.033	0.039		Set Trigger
2	2.828	0.023	0.00	0.033	0.042		Set Trigger
3	2.507	0.023	0.00	0.033	0.039		Set Trigger
4	2.513	0.022	0.00	0.034	0.037		Set Trigger
5	2.694	0.023	0.00	0.033	0.041		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



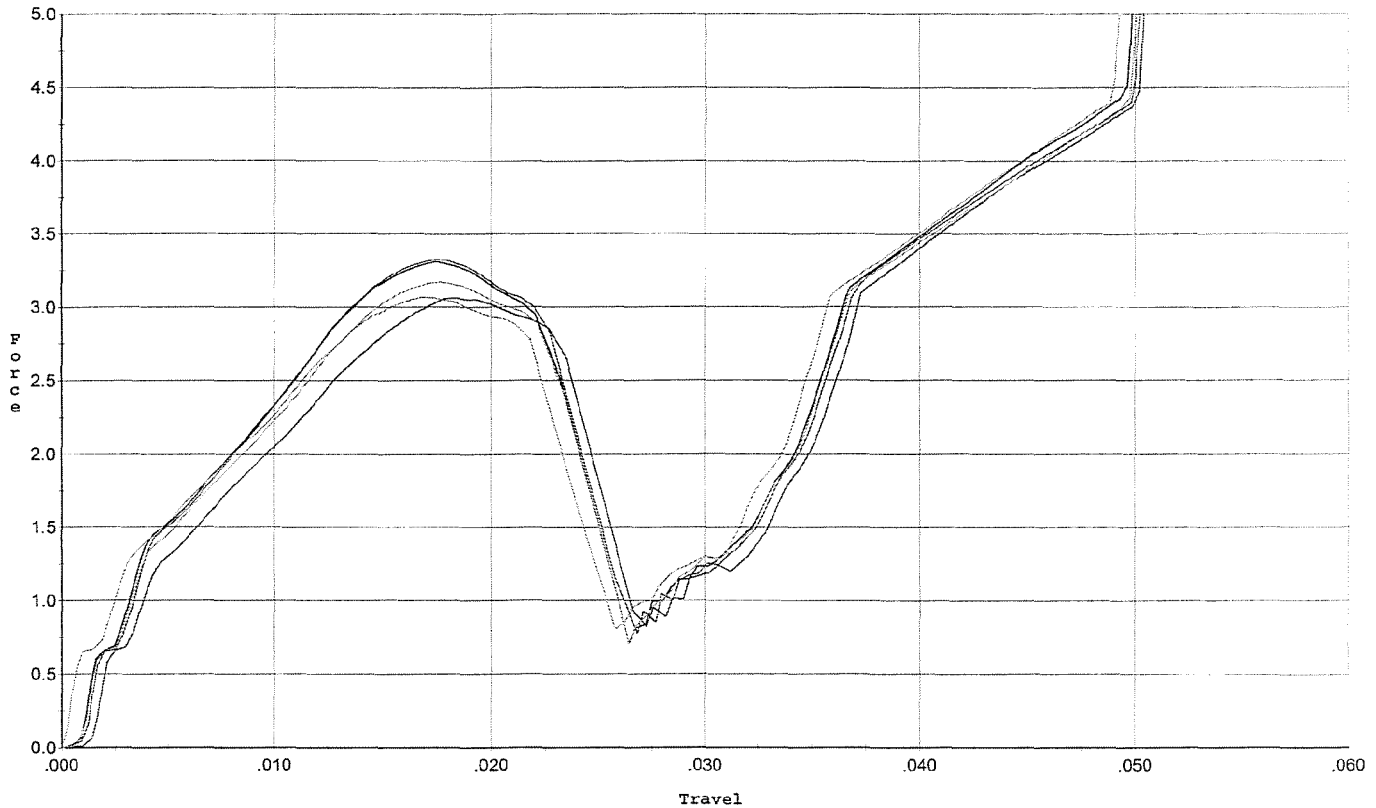
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.273	0.024	0.00	0.031	0.051		Set Trigger
2	3.171	0.023	0.00	0.031	0.049		Set Trigger
3	3.213	0.024	0.00	0.031	0.051		Set Trigger
4	3.222	0.022	0.00	0.031	0.049		Set Trigger
5	3.163	0.025	0.00	0.031	0.051		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



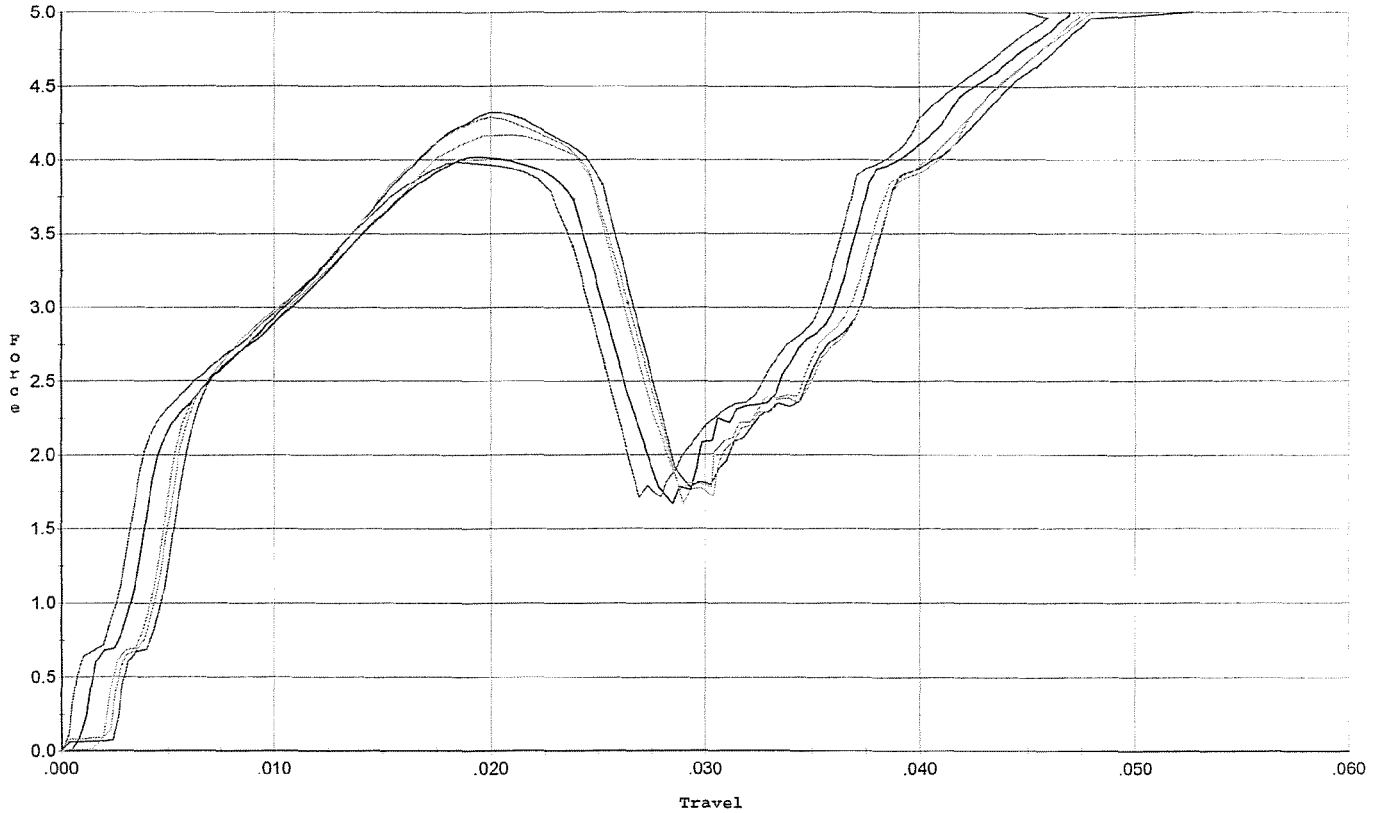
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.062	0.023	0.00	0.031	0.047		Set Trigger
2	3.310	0.023	0.00	0.031	0.050		Set Trigger
3	3.325	0.023	0.00	0.031	0.049		Set Trigger
4	3.171	0.023	0.00	0.031	0.049		Set Trigger
5	3.069	0.022	0.00	0.031	0.046		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



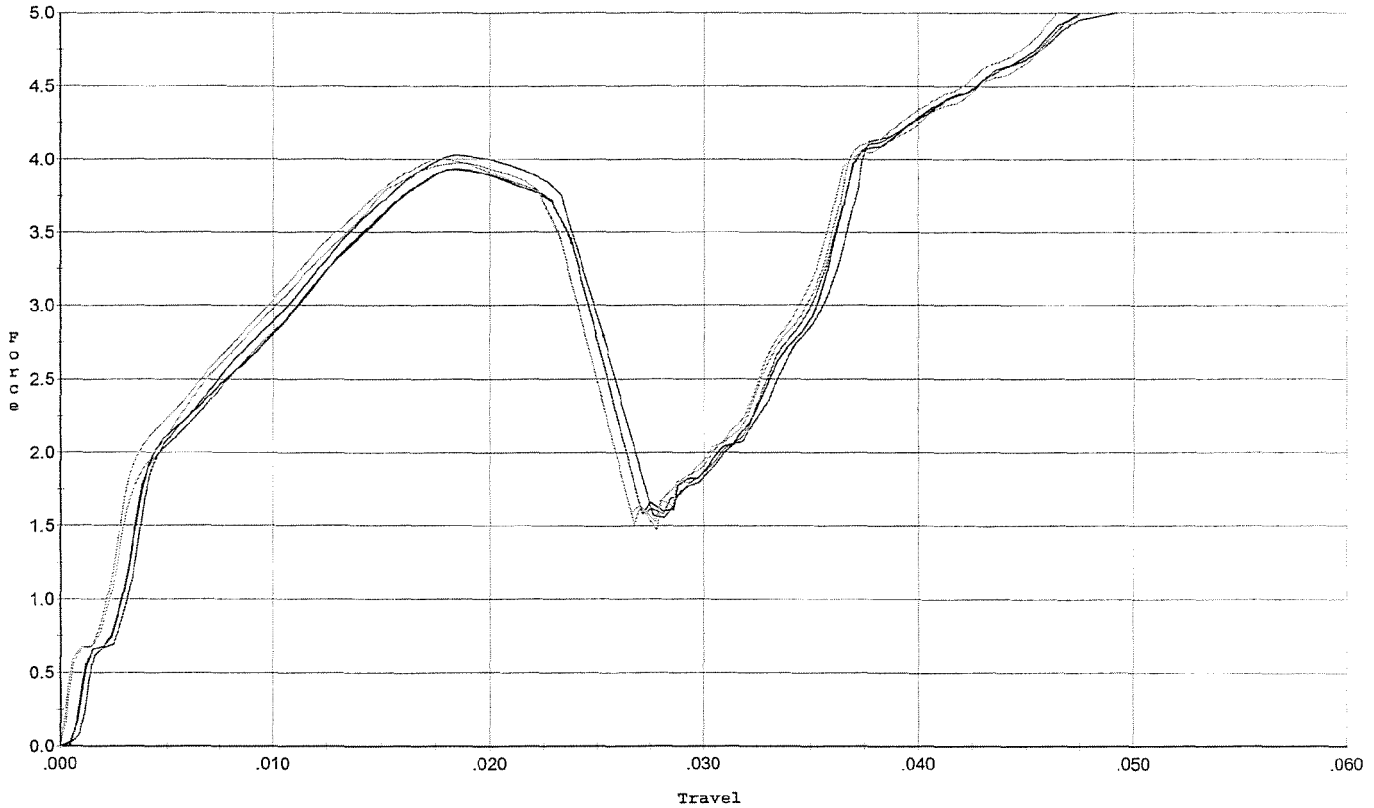
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.323	0.025	0.003	0.025	0.069		Set Trigger
2	4.019	0.024	0.00	0.028	0.064		Set Trigger
3	3.982	0.024	0.00	0.028	0.065		Set Trigger
4	4.169	0.025	0.002	0.025	0.067		Set Trigger
5	4.289	0.026	0.002	0.025	0.073		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



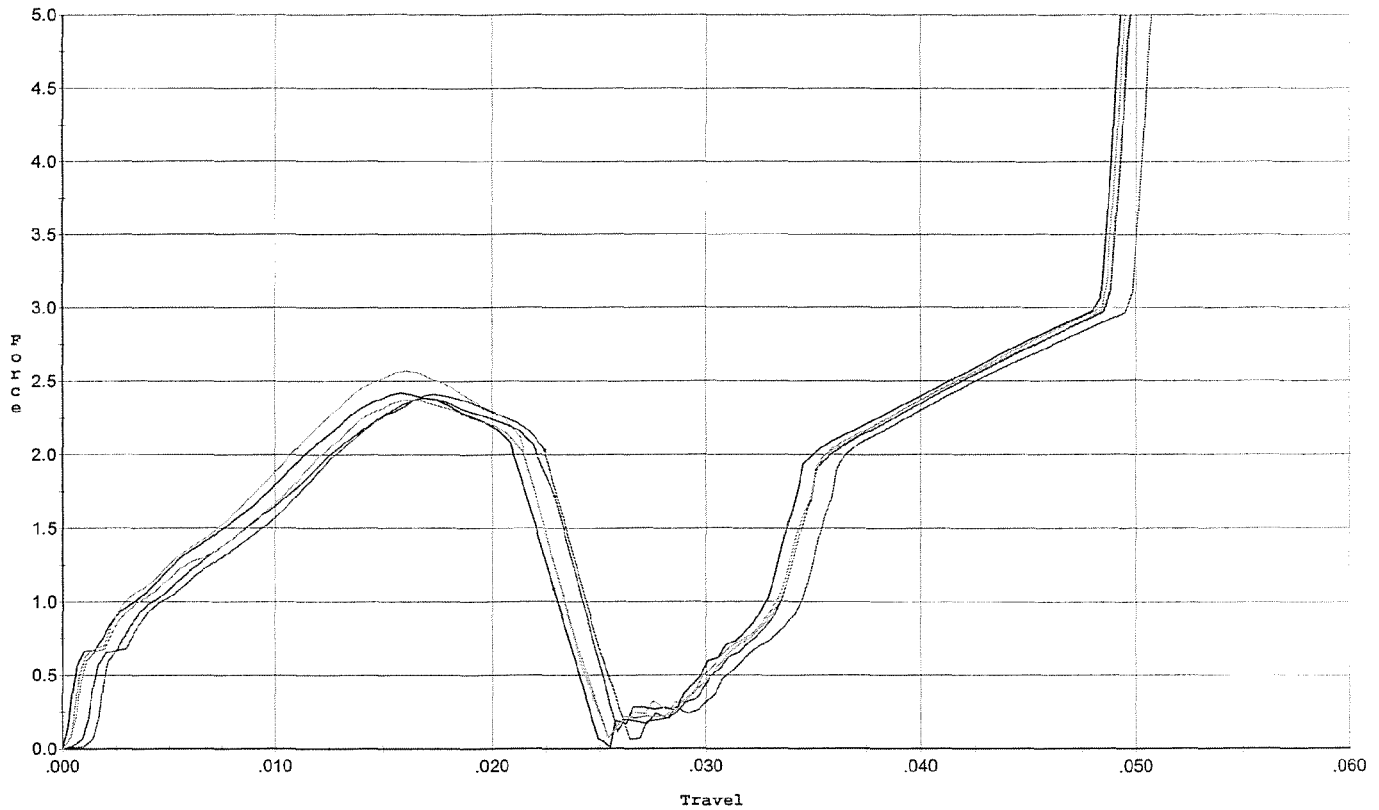
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.029	0.025	0.00	0.029	0.068		Set Trigger
2	3.931	0.024	0.00	0.029	0.063		Set Trigger
3	3.926	0.024	0.00	0.028	0.063		Set Trigger
4	3.970	0.023	0.00	0.029	0.063		Set Trigger
5	3.999	0.023	0.00	0.028	0.064		Set Trigger

A 3.97

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



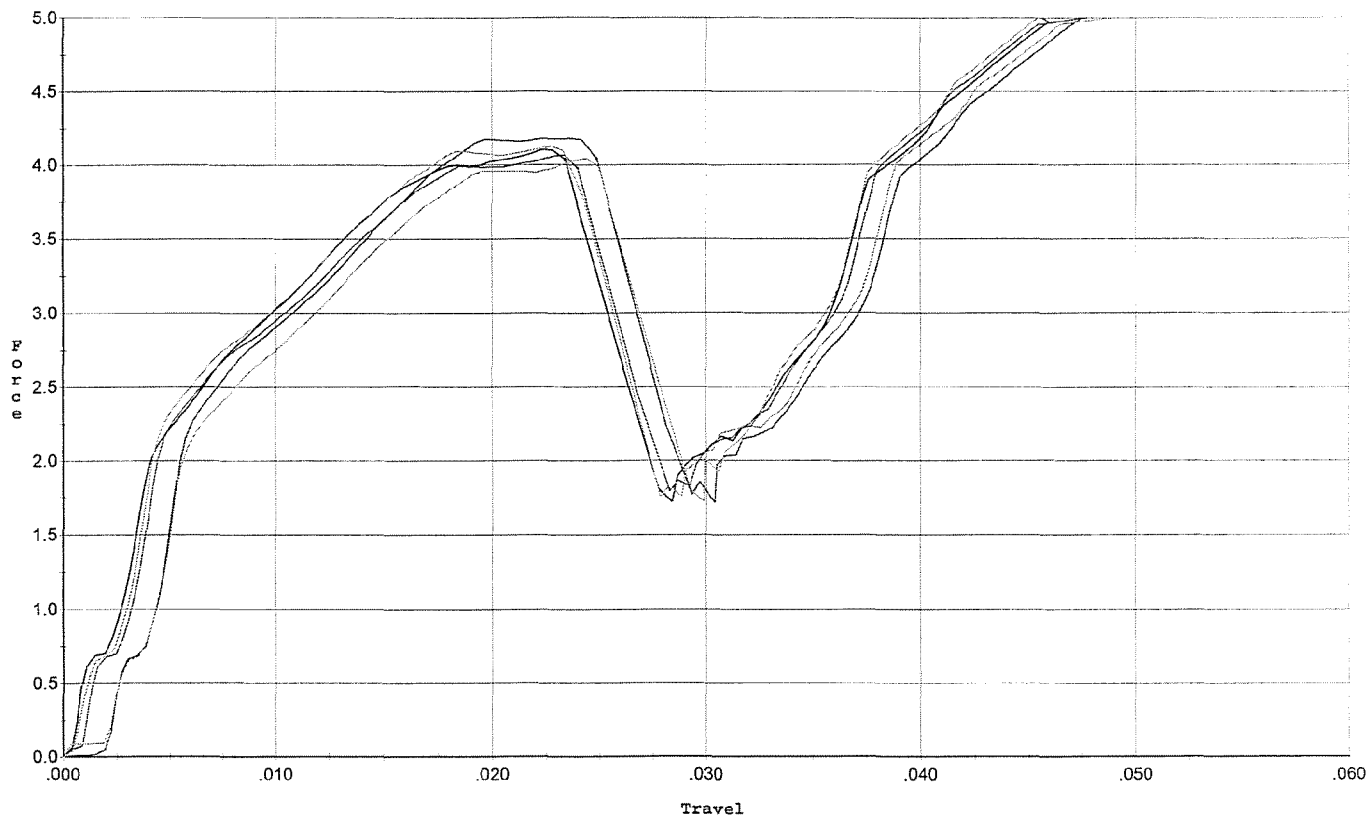
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.383	0.023	0.00	0.033	0.036		Set Trigger
2	2.421	0.023	0.00	0.033	0.037		Set Trigger
3	2.411	0.022	0.00	0.034	0.035		Set Trigger
4	2.570	0.021	0.00	0.033	0.037		Set Trigger
5	2.374	0.021	0.00	0.033	0.034		Set Trigger

A-2-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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	4.180	0.025	0.002	0.024	0.068		Set Trigger
2	4.104	0.023	0.00	0.028	0.065		Set Trigger
3	4.066	0.024	0.00	0.027	0.066		Set Trigger
4	4.130	0.024	0.00	0.024	0.069		Set Trigger
5	4.043	0.025	0.002	0.024	0.065		Set Trigger

A-4410