

G680 7671

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



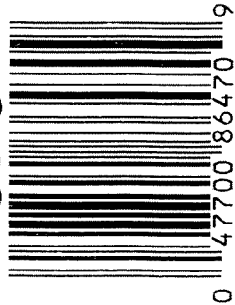
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807671

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807671

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-21-09	SPD
430	ASSEMBLE TO STOCK		1-21-09	SP
440	PROOF		1-21-09	SPD
460	CHECK HEADSPACE		1-21-09	SPD
470	DIS-ASSEMBLE ACTION		1-21-09	SPD
472	SERIALIZE BOLT HANDLE		1-22-09	SPD
475	DRILL AND TAP SIGHT HOLES		1-22-09	SP
480	MAGNAFLUX BBL ACTION	(S)	1/23/09	(S)
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		26 Jan 09	SPD
542	APPLY COATINGS (BARREL ACTION)		1-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION		1/27/09	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1/27/09	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1/27/09	RP
	D) OIL FIRING PIN ASSEMBLY		1-30-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

FC04 REV 5/2006

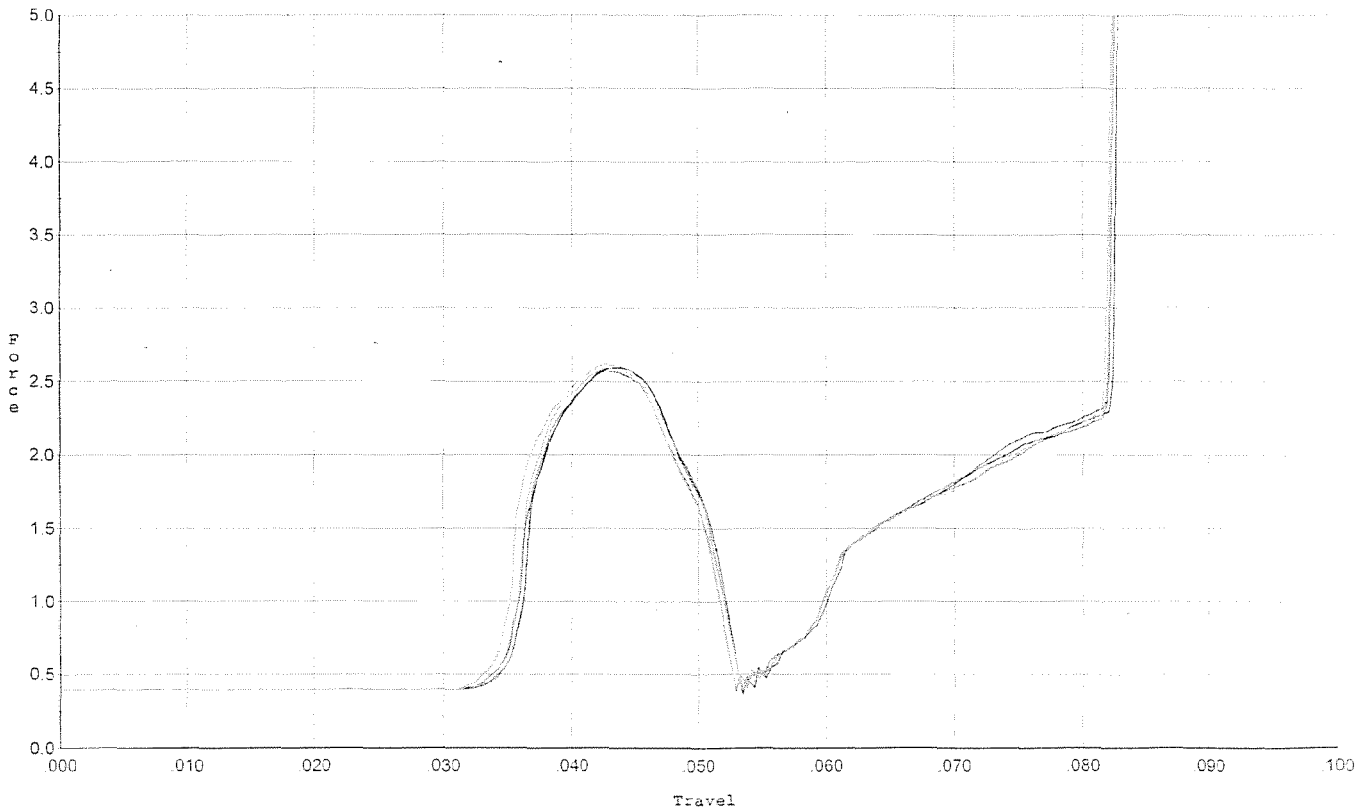
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2-16-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-16-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	2-16-09	L.N.
	J) ASSEMBLE STOCK		1-30-09	W.N.
	K) ASSEMBLE SWIVEL STUDS		2-16-09	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	2-12-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-12-09	W.N.
670	FINAL INSPECTION A) HEADSPACE		2-16-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.76</u> <u>2.76</u> <u>2.74</u> <u>2.76</u>	2-13-09	W.N.
	C) FUNCTION		2-16-09	L.N.
690	PACK		2/25/09	F.N.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



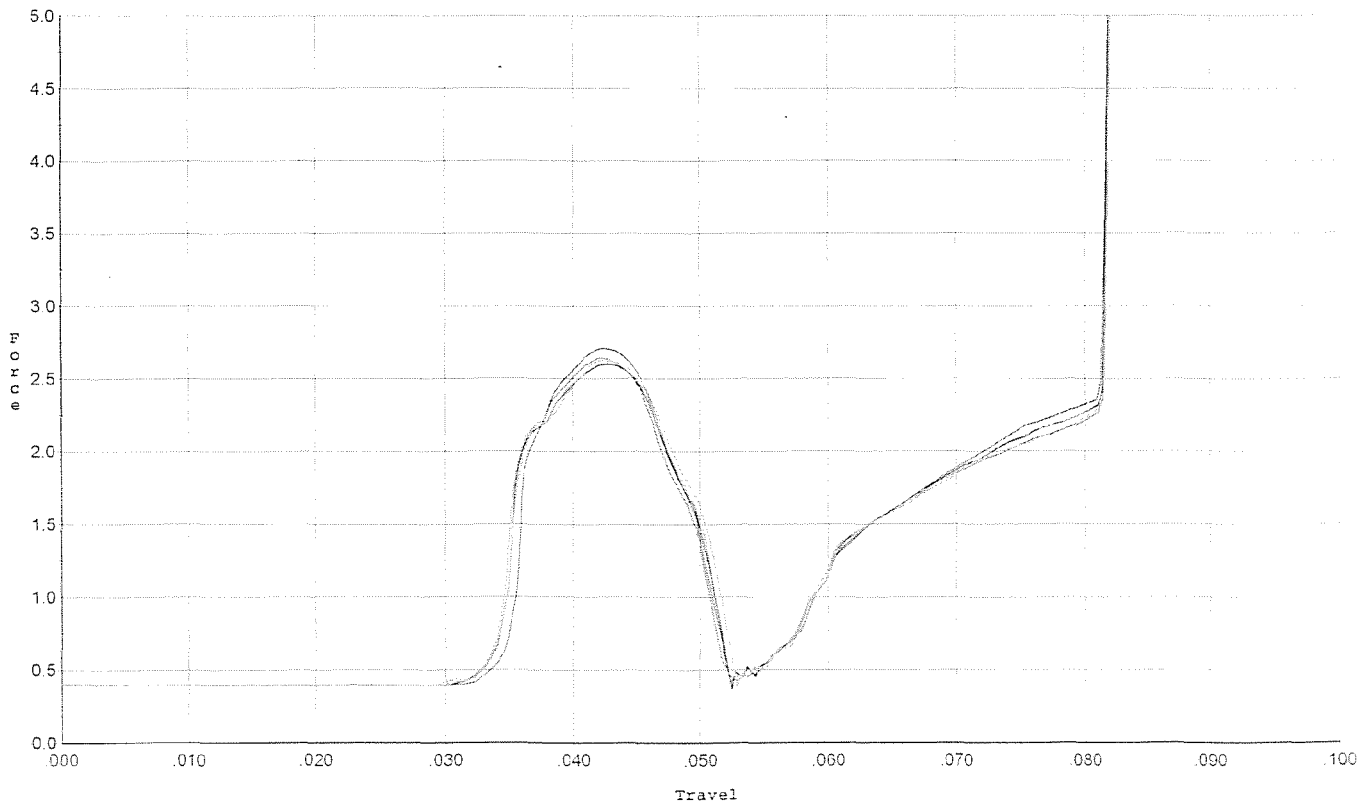
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.592	0.050	0.035	0.037	0.047		Set Trigger
2	2.594	0.051	0.035	0.037	0.049		Set Trigger
3	2.564	0.051	0.035	0.037	0.047		Set Trigger
4	2.590	0.051	0.035	0.036	0.048		Set Trigger
5	2.612	0.052	0.034	0.036	0.051		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



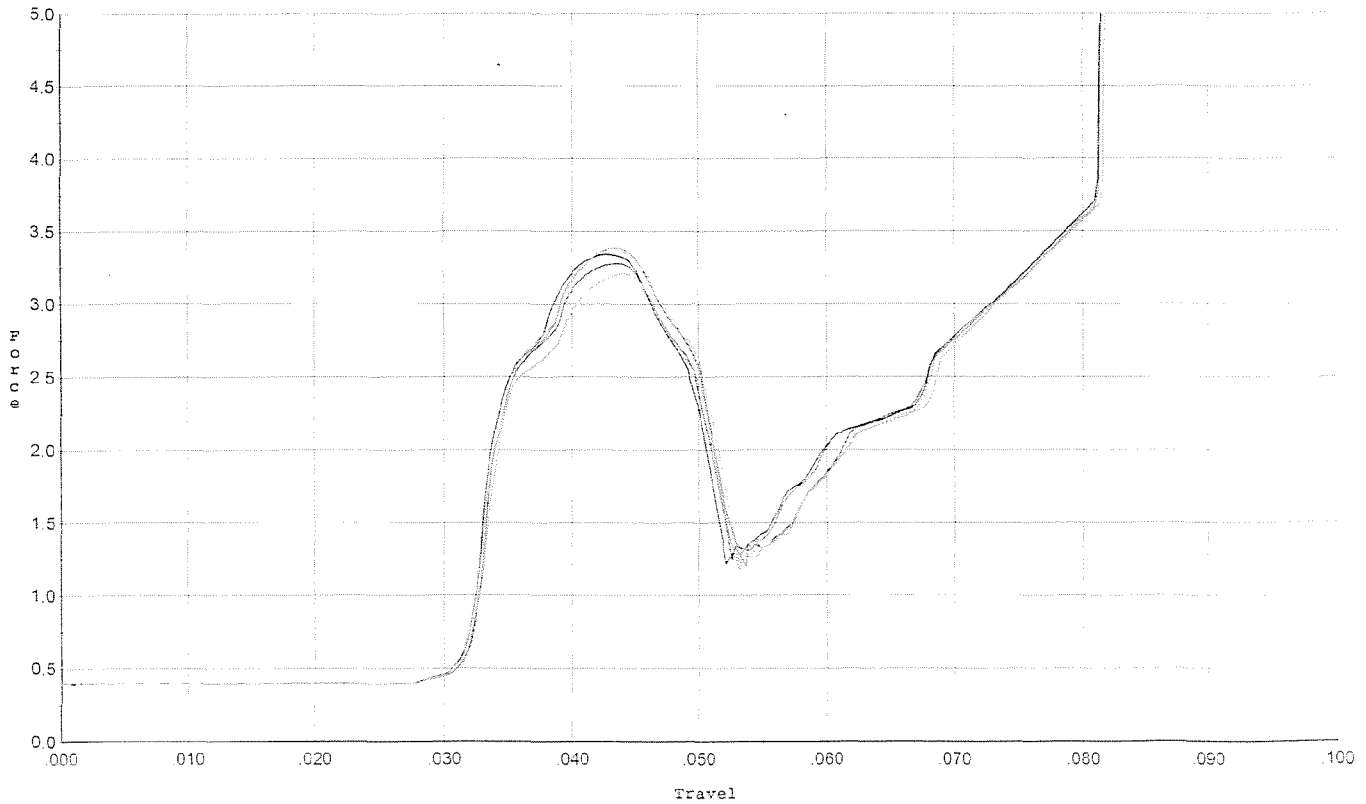
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.708	0.050	0.035	0.036	0.047		Set Trigger
2	2.598	0.051	0.034	0.036	0.049		Set Trigger
3	2.639	0.050	0.034	0.036	0.048		Set Trigger
4	2.629	0.050	0.033	0.036	0.049		Set Trigger
5	2.622	0.051	0.034	0.036	0.050		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



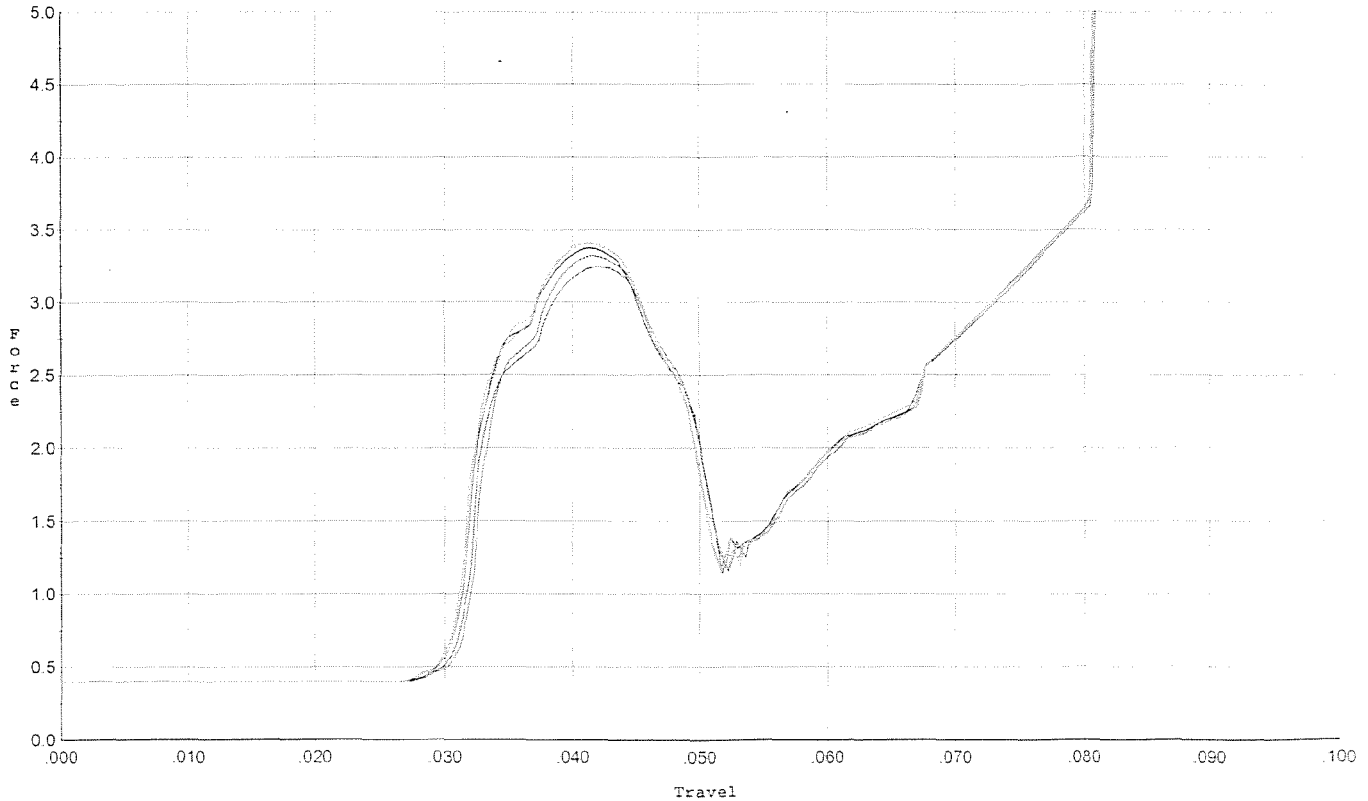
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.051	0.032	0.034	0.064		Set Trigger
2	3.341	0.050	0.032	0.034	0.063		Set Trigger
3	3.381	0.050	0.032	0.034	0.064		Set Trigger
4	3.378	0.051	0.032	0.034	0.066		Set Trigger
5	3.206	0.050	0.032	0.034	0.062		Set Trigger

A.3.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



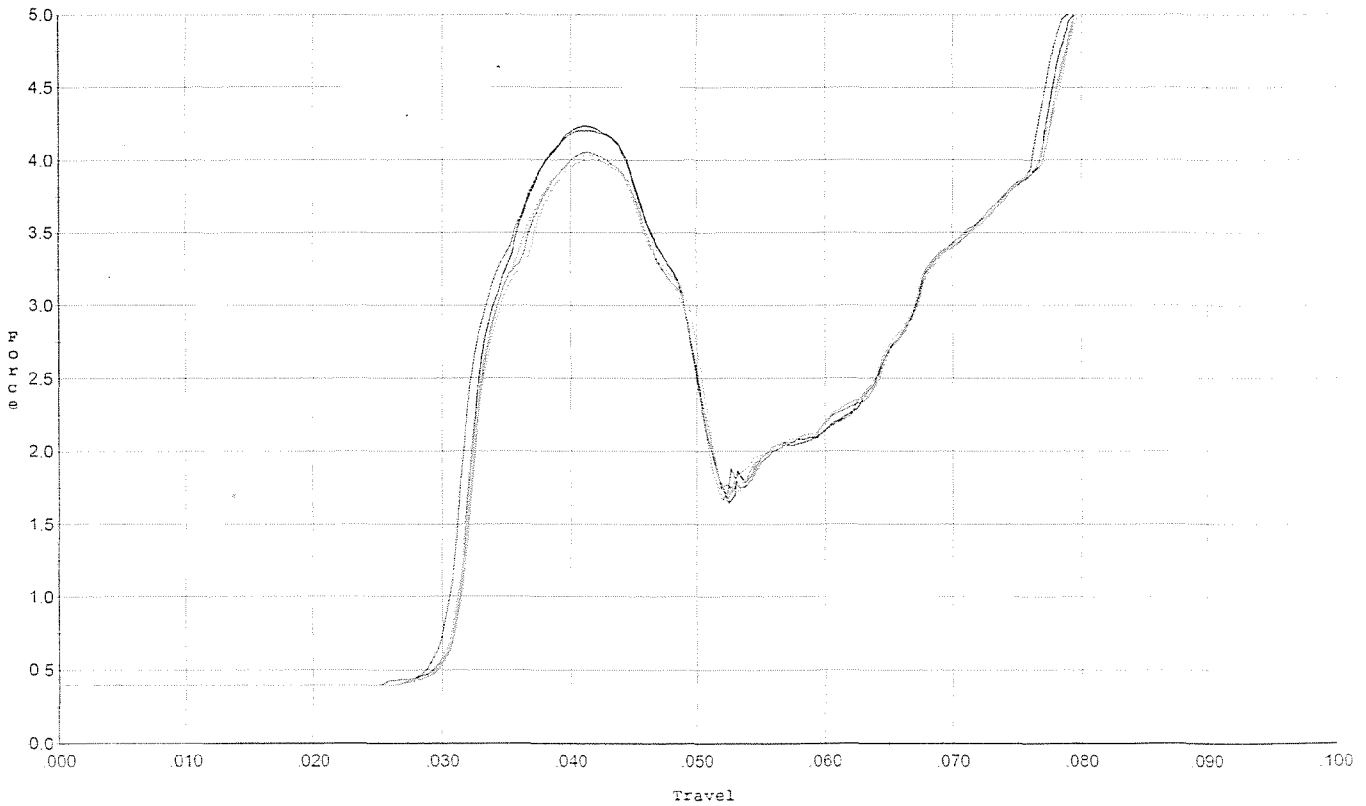
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.242	0.050	0.031	0.034	0.062		Set Trigger
2	3.373	0.049	0.030	0.034	0.063		Set Trigger
3	3.317	0.050	0.031	0.034	0.063		Set Trigger
4	3.405	0.049	0.030	0.034	0.064		Set Trigger
5	3.409	0.049	0.030	0.034	0.064		Set Trigger

A-3-34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



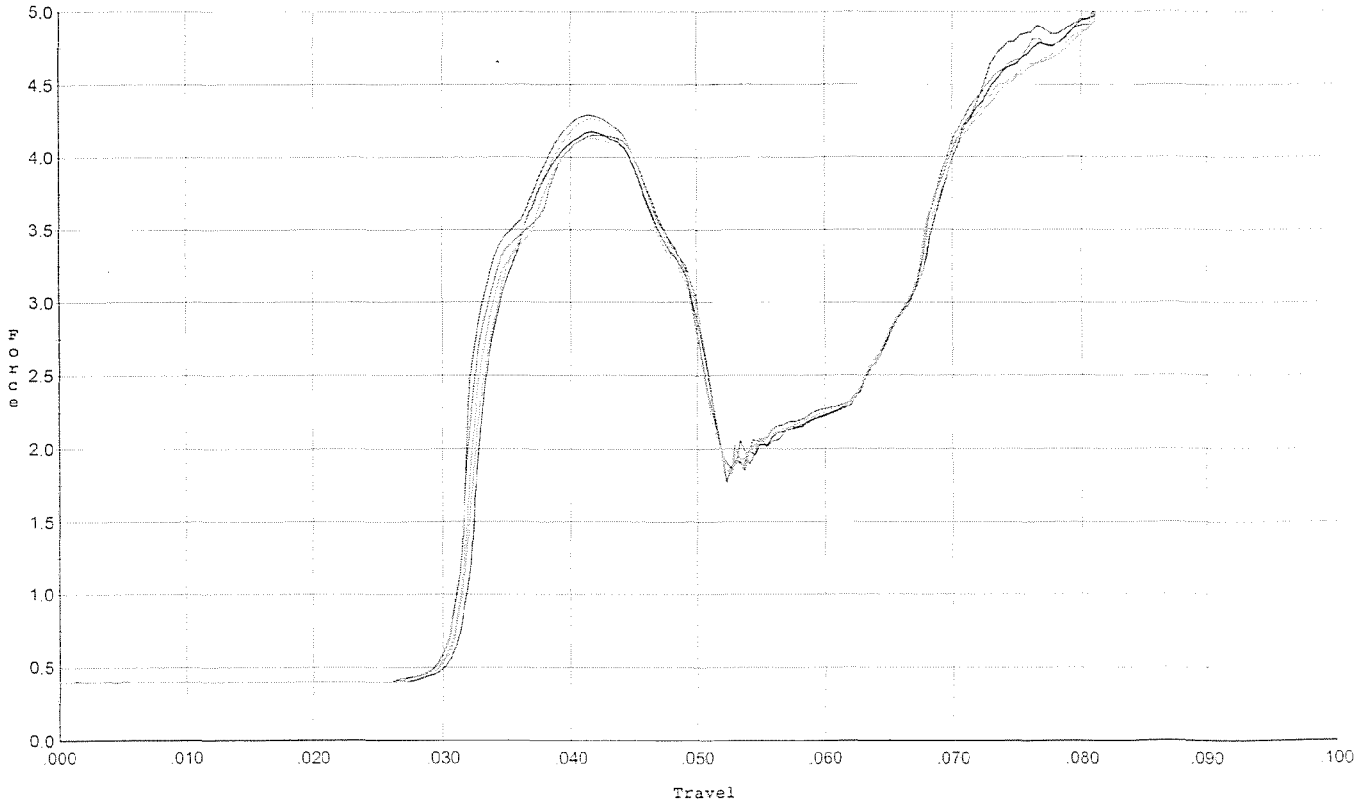
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.205	0.049	0.029	0.032	0.078		Set Trigger
2	4.235	0.049	0.030	0.033	0.076		Set Trigger
3	4.055	0.049	0.030	0.033	0.073		Set Trigger
4	4.001	0.049	0.030	0.033	0.074		Set Trigger
5	4.045	0.049	0.030	0.033	0.074		Set Trigger

17.4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



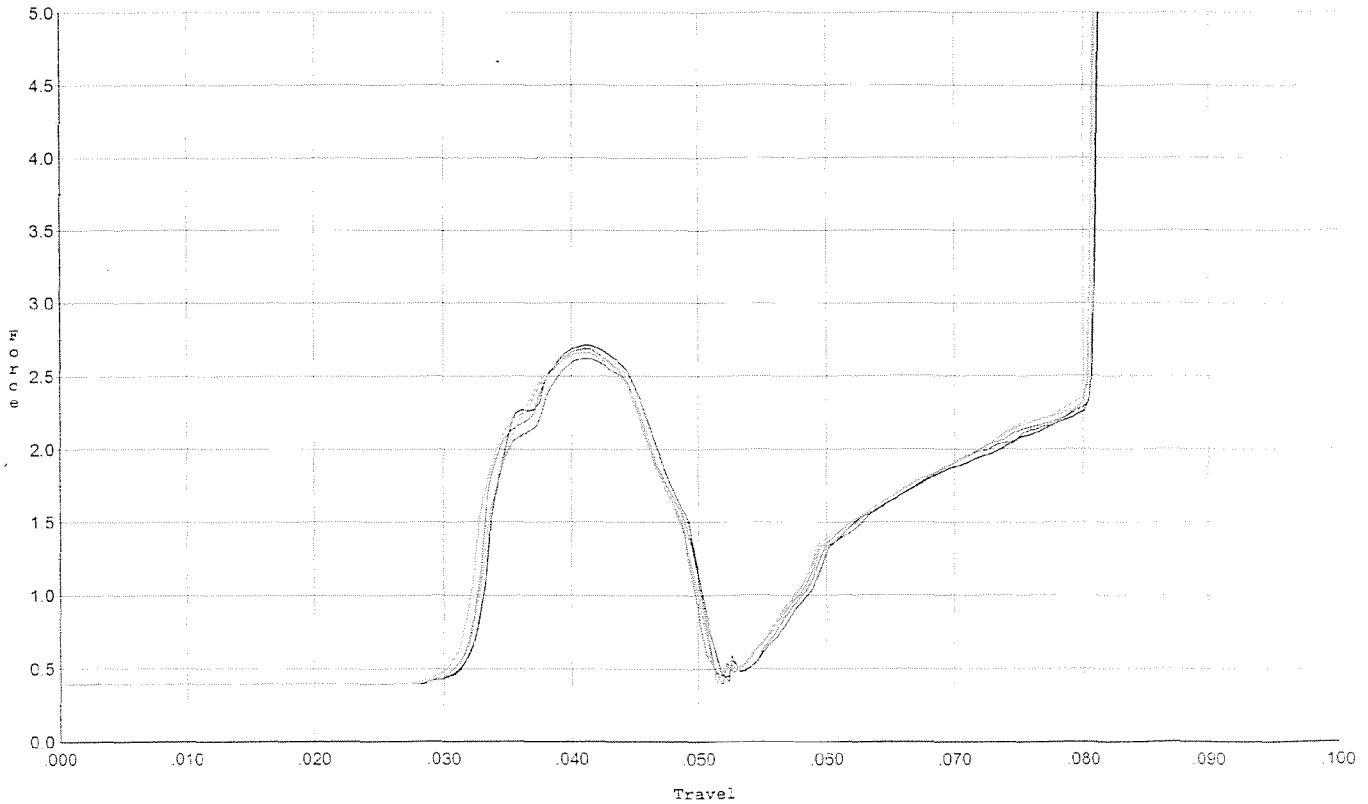
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.049	0.030	0.032	0.080		Set Trigger
2	4.174	0.050	0.031	0.033	0.078		Set Trigger
3	4.151	0.050	0.030	0.032	0.080		Set Trigger
4	4.134	0.049	0.031	0.033	0.076		Set Trigger
5	4.264	0.050	0.031	0.033	0.079		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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



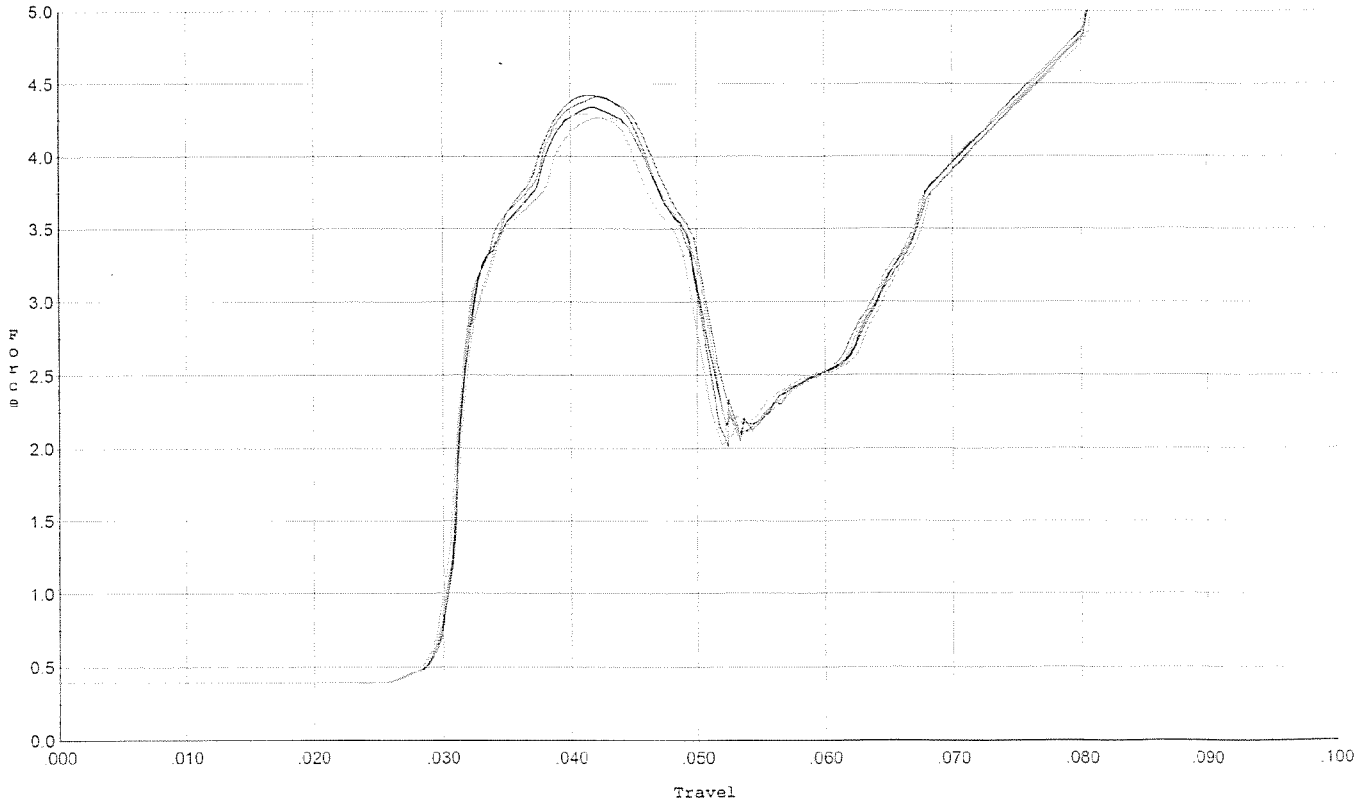
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.620	0.049	0.032	0.036	0.049		Set Trigger
2	2.713	0.049	0.032	0.036	0.050		Set Trigger
3	2.684	0.049	0.032	0.036	0.049		Set Trigger
4	2.658	0.050	0.032	0.036	0.050		Set Trigger
5	2.664	0.049	0.031	0.036	0.050		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/23/2009

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	4.420	0.049	0.029	0.032	0.085		Set Trigger
2	4.336	0.049	0.029	0.032	0.083		Set Trigger
3	4.412	0.050	0.029	0.031	0.087		Set Trigger
4	4.294	0.049	0.029	0.032	0.082		Set Trigger
5	4.269	0.050	0.029	0.032	0.084		Set Trigger

A. 4.34