

2680 7696

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



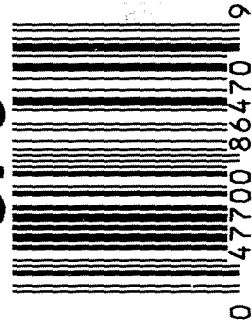
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807696

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 7696

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	OPERATOR 	1/23/09	
490	MAGNAFLUX BOLT		1/23/09	MR
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1-24-09	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		1-29-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

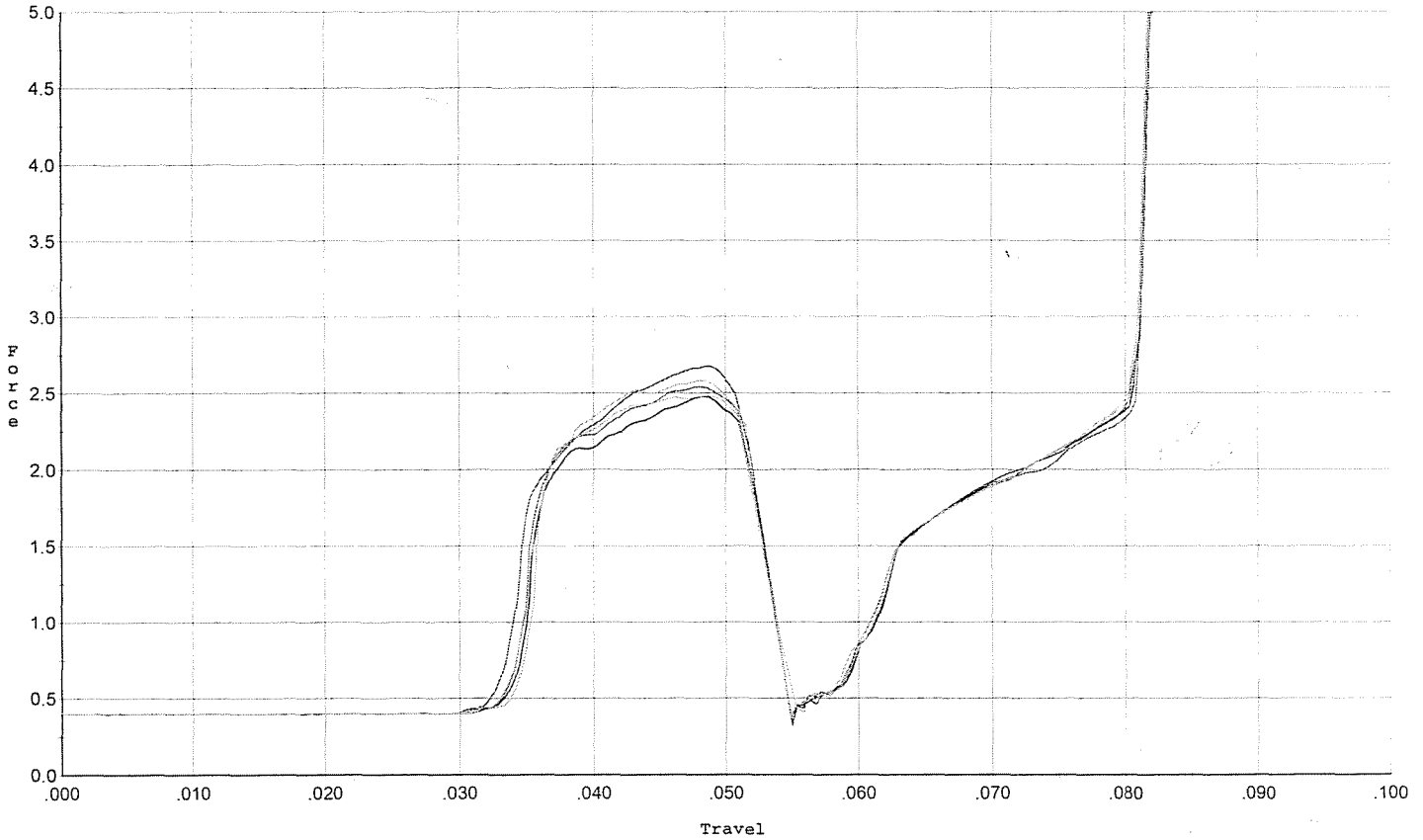
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4°</u>	<u>4°</u>	<u>4°</u>	2-10-09	LJ		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5°</u>	<u>5°</u>	<u>5°</u>	2-10-09	LJ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.024</u>	<u>.024</u>	2-10-09	LJ		
	J) ASSEMBLE STOCK					1-29-09	LJ		
	K) ASSEMBLE SWIVEL STUDS					2-10-09	LJ		
	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		PASS	FAIL		2-2-09	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					2-2-09	W N		
670	FINAL INSPECTION A) HEADSPACE					2-10-09	LJ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u>	<u>2.55</u>	<u>2.28</u>	<u>2.46</u>	<u>2.46</u>	2-4-09	W N
	C) FUNCTION							2-10-09	LJ
690	PACK							2/12/09	Fry

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



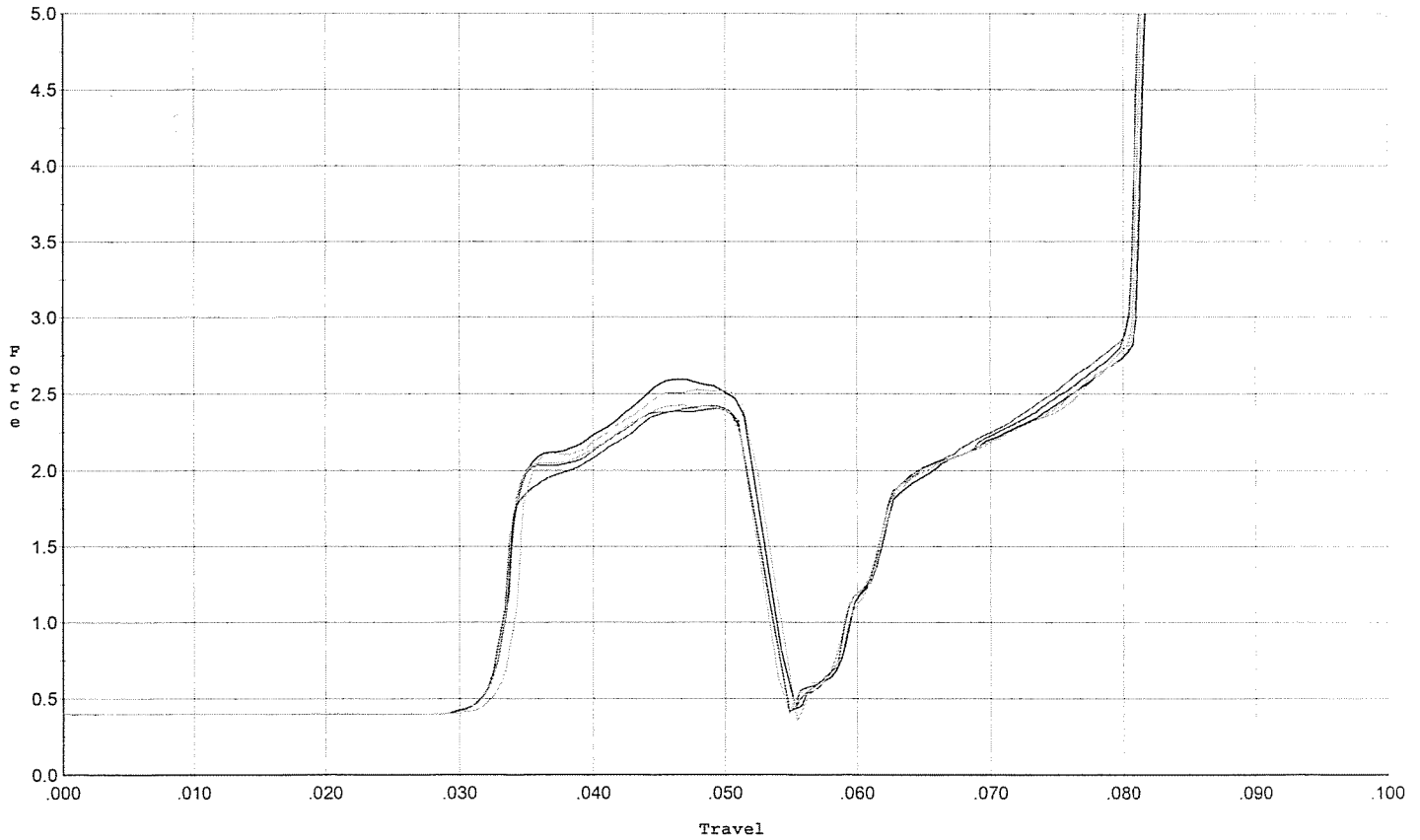
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel.	Energy To Actuate	Lock Time	Action Type
1	2.673	0.052	0.033	0.035	0.056		Set Trigger
2	2.476	0.053	0.034	0.035	0.053		Set Trigger
3	2.539	0.052	0.034	0.035	0.054		Set Trigger
4	2.482	0.053	0.033	0.035	0.054		Set Trigger
5	2.583	0.052	0.034	0.035	0.054		Set Trigger

A-2.55

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



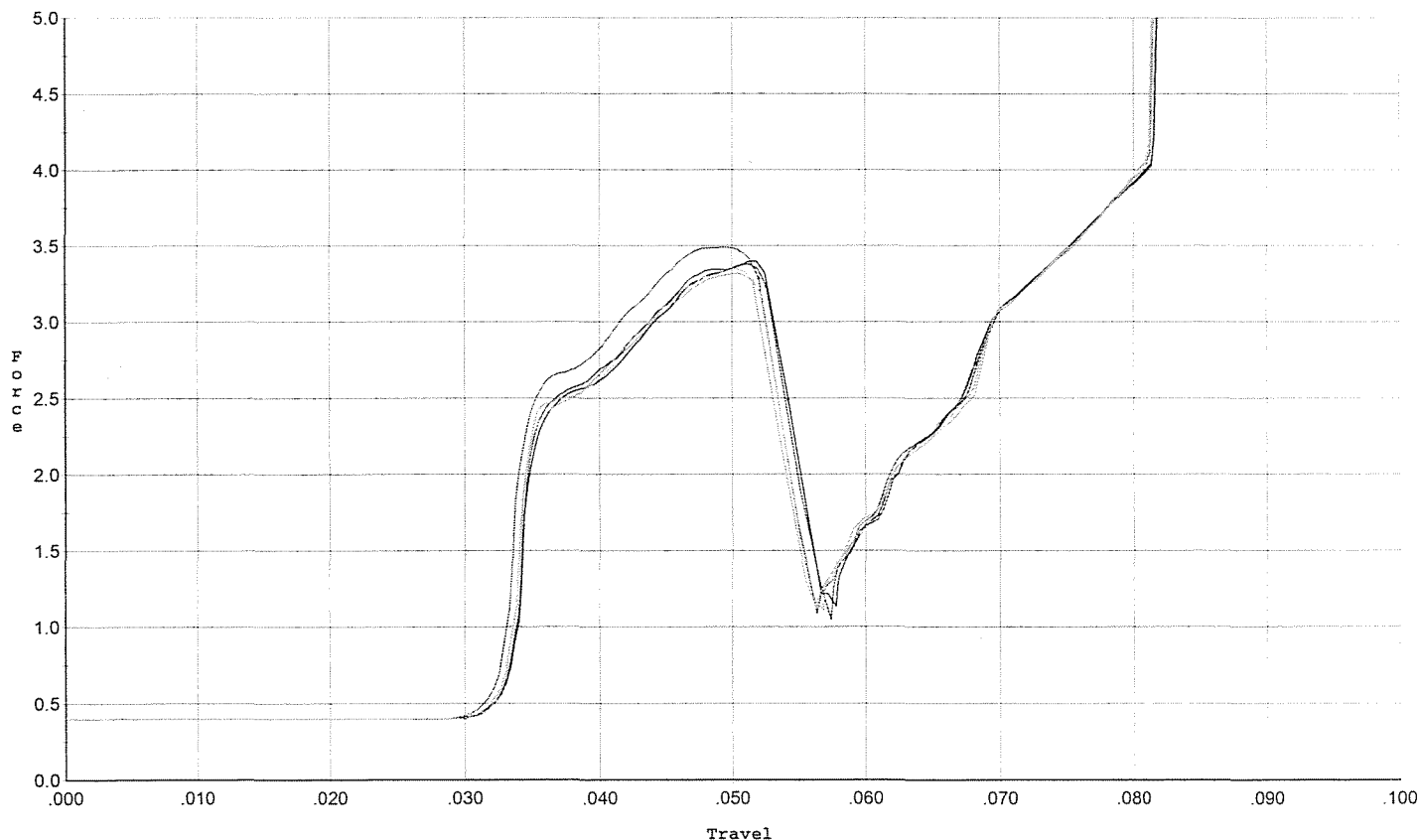
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.404	0.051	0.032	0.034	0.053		Set Trigger
2	2.593	0.051	0.032	0.034	0.056		Set Trigger
3	2.422	0.051	0.032	0.034	0.053		Set Trigger
4	2.524	0.053	0.033	0.034	0.056		Set Trigger
5	2.429	0.051	0.033	0.034	0.054		Set Trigger

A-2-47

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



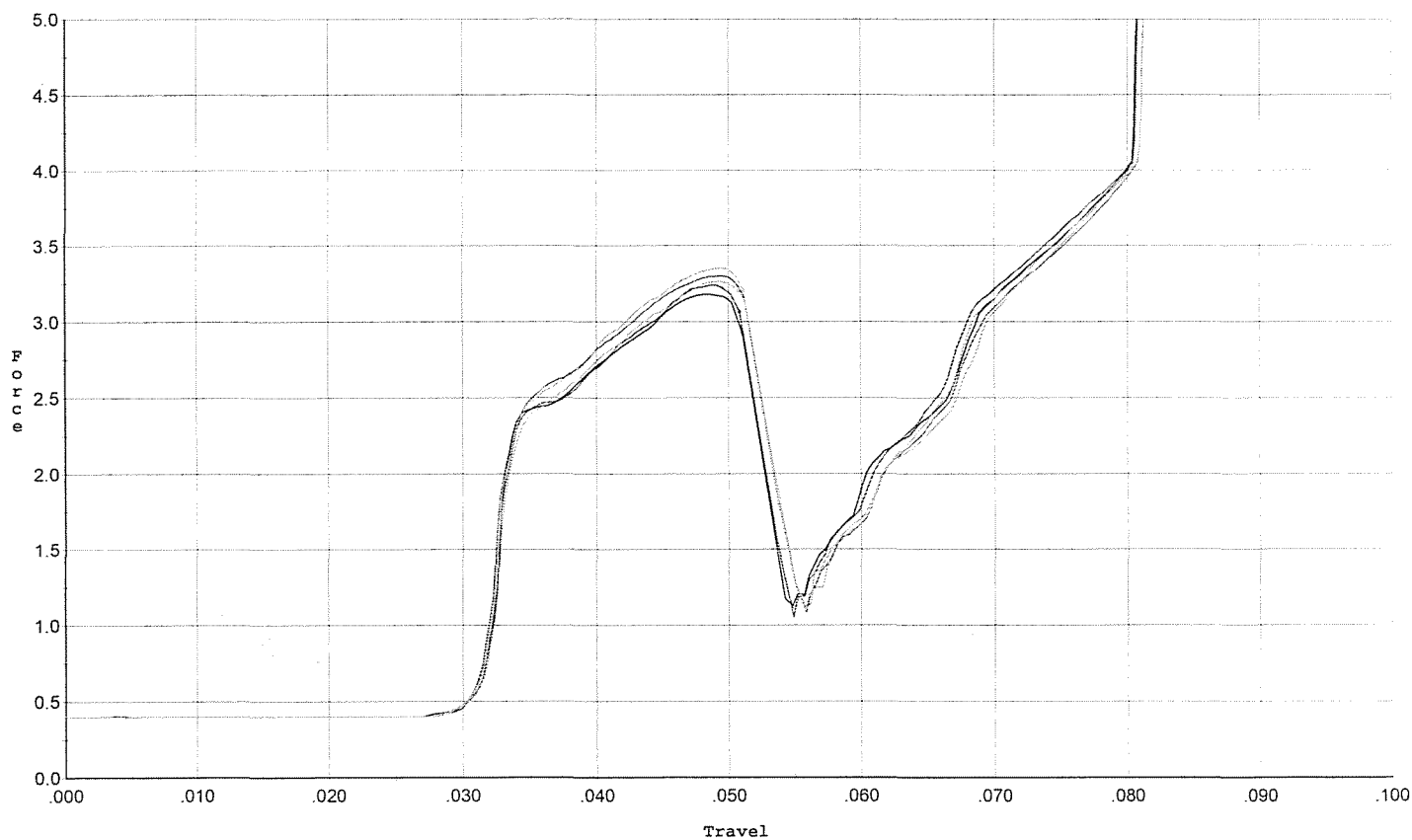
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.374	0.053	0.033	0.033	0.070		Set Trigger
2	3.398	0.054	0.033	0.033	0.073		Set Trigger
3	3.488	0.052	0.032	0.033	0.072		Set Trigger
4	3.320	0.052	0.033	0.033	0.069		Set Trigger
5	3.352	0.052	0.033	0.033	0.067		Set Trigger

A.3.38

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



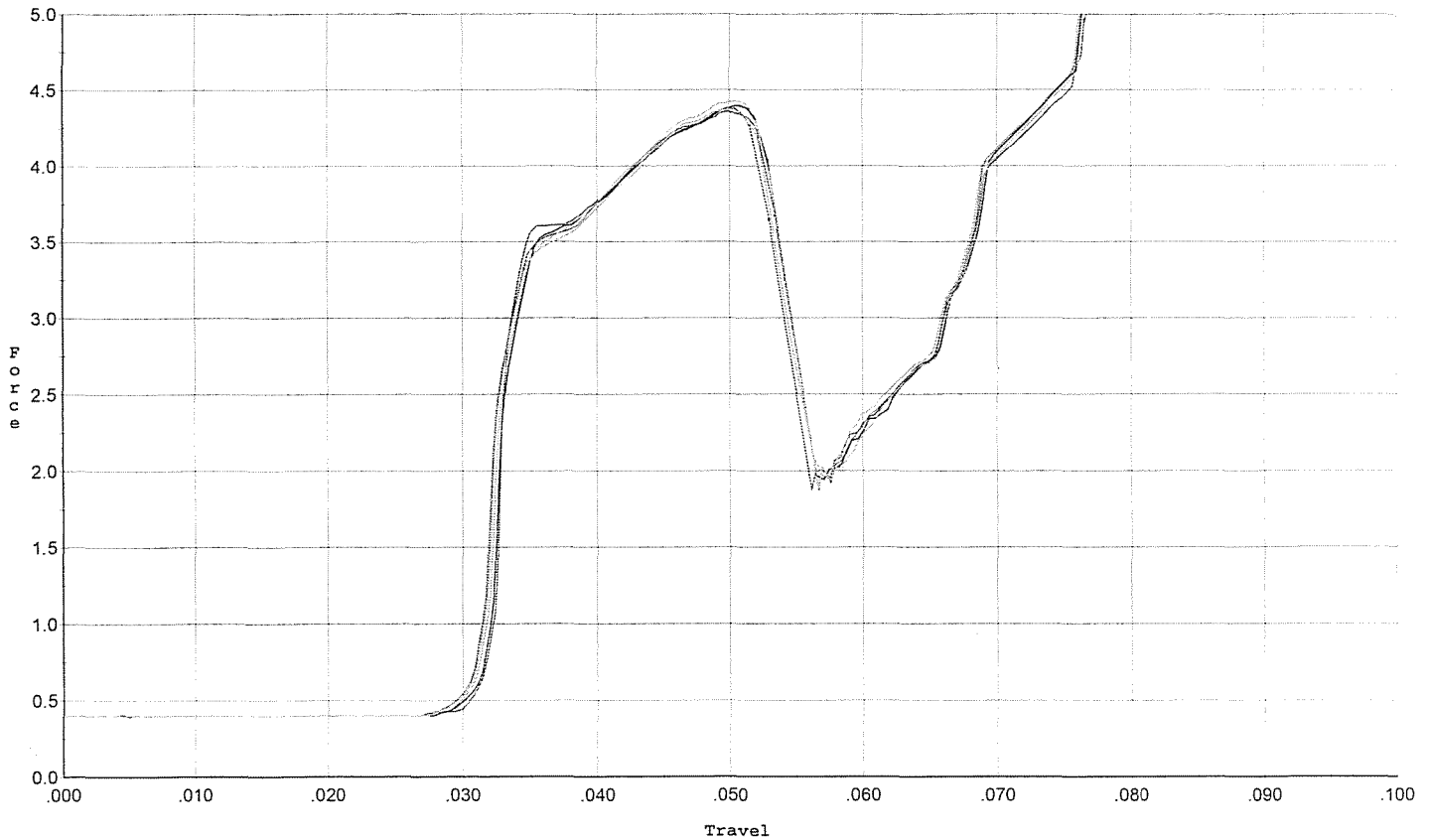
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.240	0.051	0.031	0.033	0.067		Set Trigger
2	3.180	0.051	0.031	0.033	0.067		Set Trigger
3	3.301	0.051	0.031	0.033	0.069		Set Trigger
4	3.261	0.051	0.031	0.033	0.068		Set Trigger
5	3.352	0.051	0.031	0.032	0.070		Set Trigger

A-3-26

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



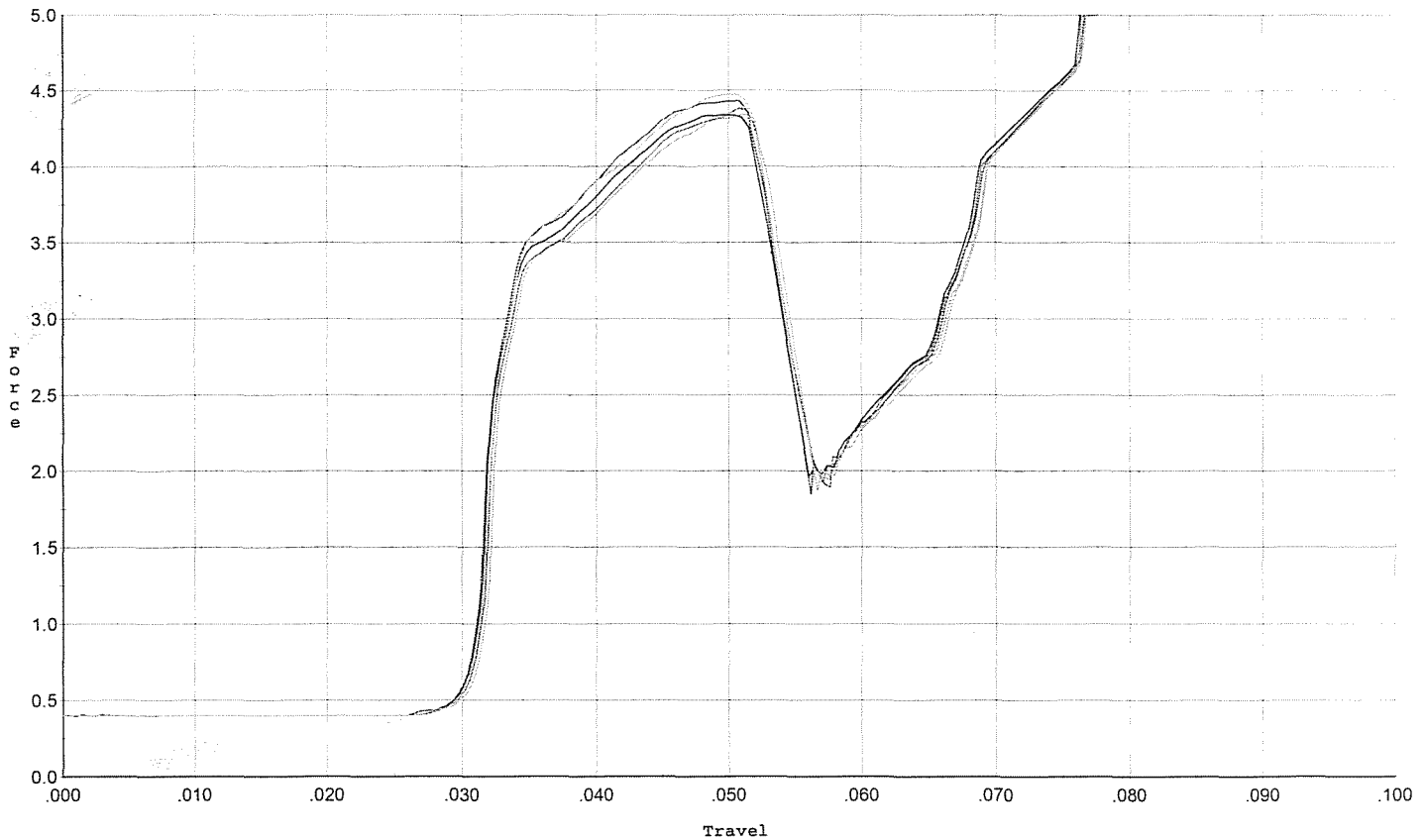
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.358	0.053	0.031	0.027	0.096		Set Trigger
2	4.397	0.053	0.031	0.027	0.095		Set Trigger
3	4.382	0.053	0.031	0.027	0.095		Set Trigger
4	4.426	0.053	0.031	0.027	0.096		Set Trigger
5	4.365	0.052	0.031	0.027	0.093		Set Trigger

A . 4.38

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



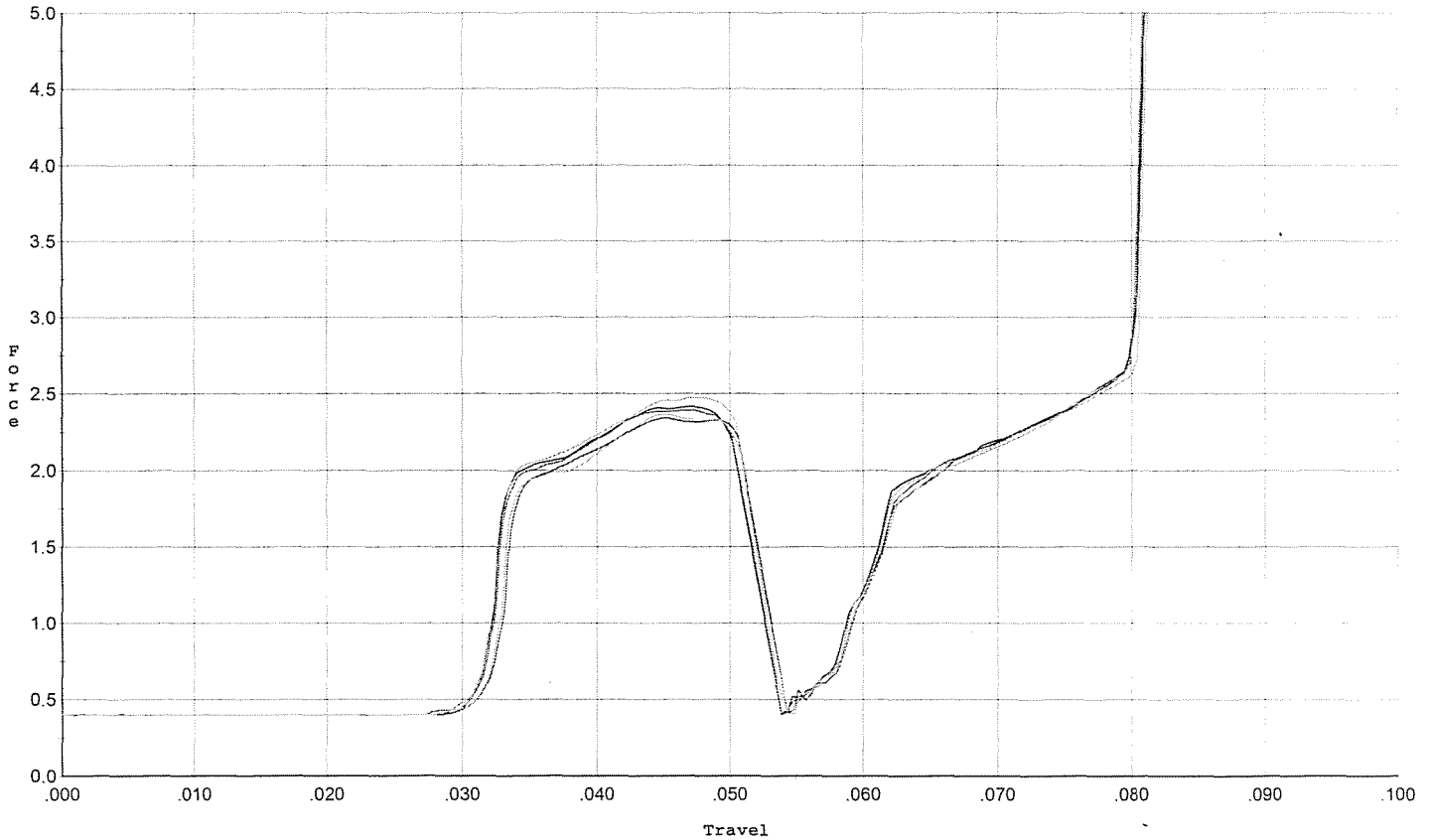
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.431	0.053	0.030	0.028	0.097		Set Trigger
2	4.338	0.053	0.030	0.027	0.097		Set Trigger
3	4.384	0.052	0.031	0.027	0.093		Set Trigger
4	4.476	0.052	0.031	0.028	0.096		Set Trigger
5	4.342	0.053	0.031	0.027	0.095		Set Trigger

A4.39

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



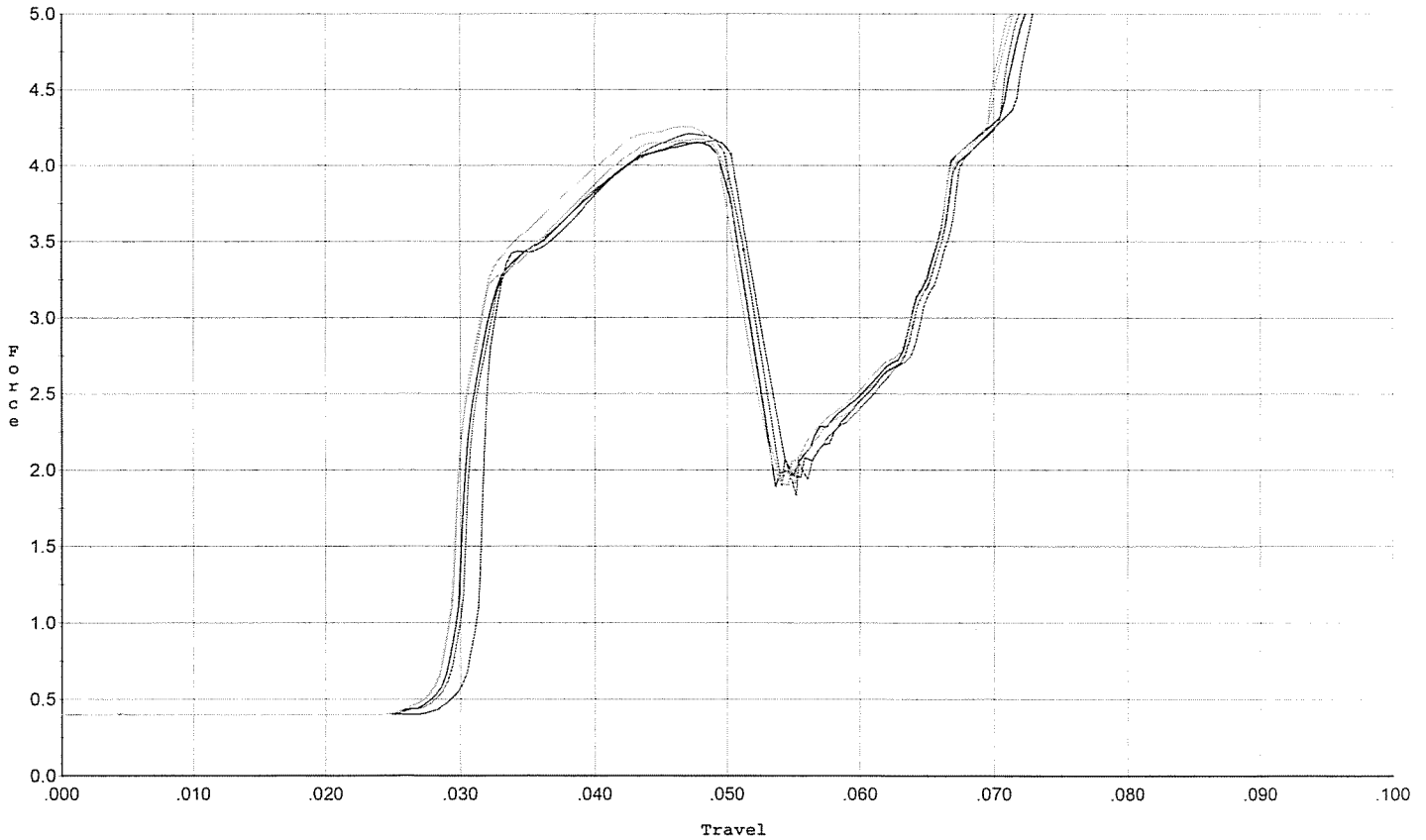
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.342	0.051	0.032	0.034	0.053		Set Trigger
2	2.415	0.050	0.031	0.034	0.054		Set Trigger
3	2.392	0.052	0.031	0.034	0.055		Set Trigger
4	2.368	0.051	0.032	0.034	0.053		Set Trigger
5	2.474	0.052	0.031	0.034	0.057		Set Trigger

A-2-39

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	4.164	0.050	0.030	0.026	0.087		Set Trigger
2	4.152	0.050	0.029	0.026	0.089		Set Trigger
3	4.210	0.051	0.029	0.026	0.091		Set Trigger
4	4.256	0.049	0.028	0.027	0.090		Set Trigger
5	4.175	0.050	0.028	0.026	0.090		Set Trigger

A - 4.19

