

G-680 7721

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



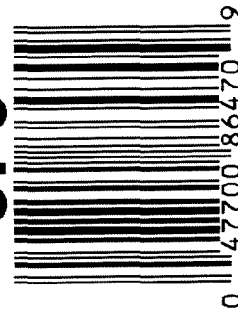
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6807721

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807721

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-12-09	SPD
430	ASSEMBLE TO STOCK		2-12-09	SP
440	PROOF		2-12-09	SPD
460	CHECK HEADSPACE		2-12-09	SPD
470	DIS-ASSEMBLE ACTION		2-12-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	2-13-09	RTZ
475	DRILL AND TAP SIGHT HOLES		2-13-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	2-18-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		2/19/09	RT
520	GOFF BLAST BBL / REC		19 Feb 09	SPD
542	APPLY COATINGS (BARREL ACTION)		3/2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-4-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

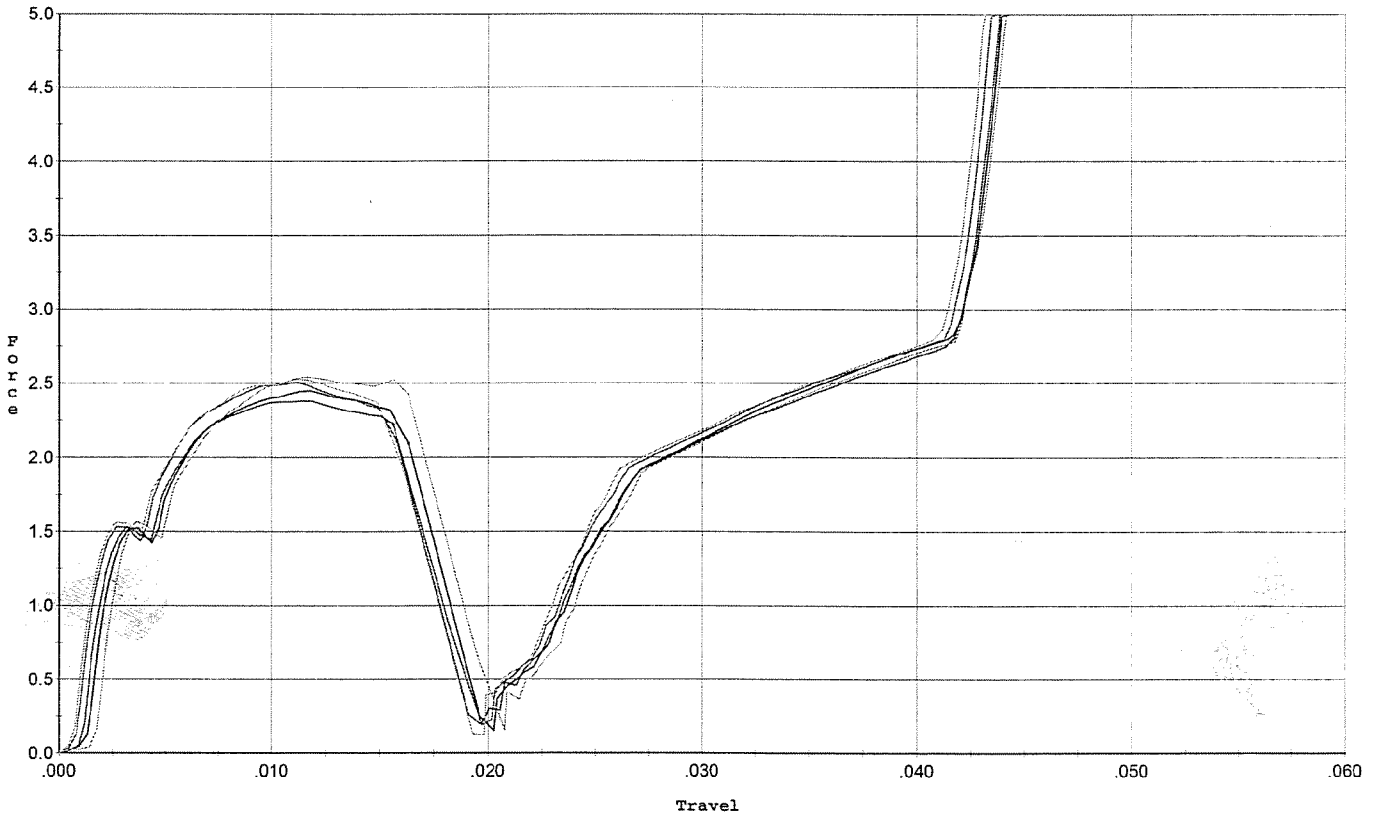
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>6.5</u>	3-12-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-12-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-12-09	WN
	J) ASSEMBLE STOCK		3-4-09	FT
	K) ASSEMBLE SWIVEL STUDS		3-12-09	WN
	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	3-5-09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-5-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-12-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.53</u> <u>2.39</u> <u>2.72</u> <u>2.42</u>	3-6-09	WN
	C) FUNCTION		3-12-09	WN
690	PACK		5-28-09	WN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



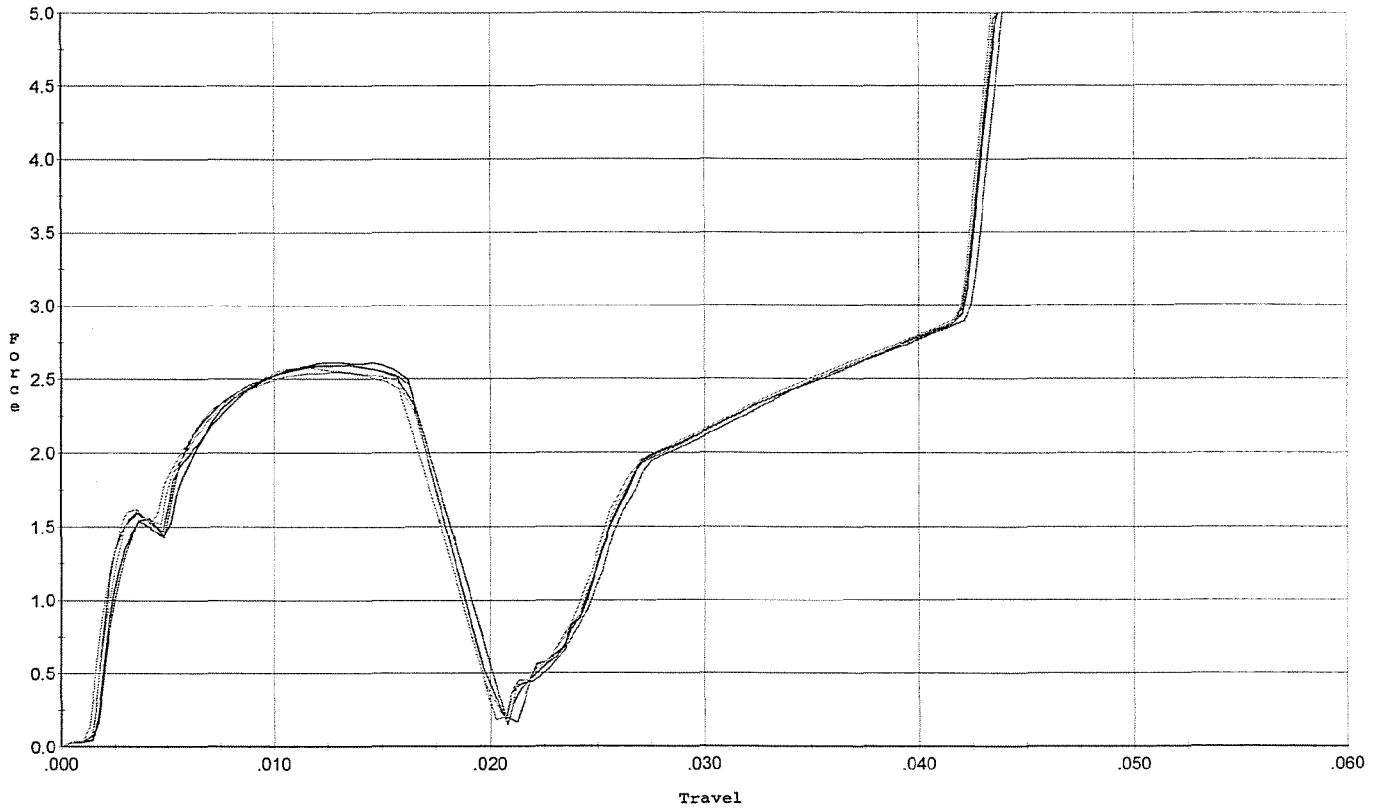
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.380	0.016	0.00	0.032	0.027		Set Trigger
2	2.447	0.016	0.00	0.031	0.029		Set Trigger
3	2.507	0.016	0.004	0.031	0.029		Set Trigger
4	2.526	0.016	0.004	0.031	0.030		Set Trigger
5	2.542	0.016	0.005	0.031	0.029		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



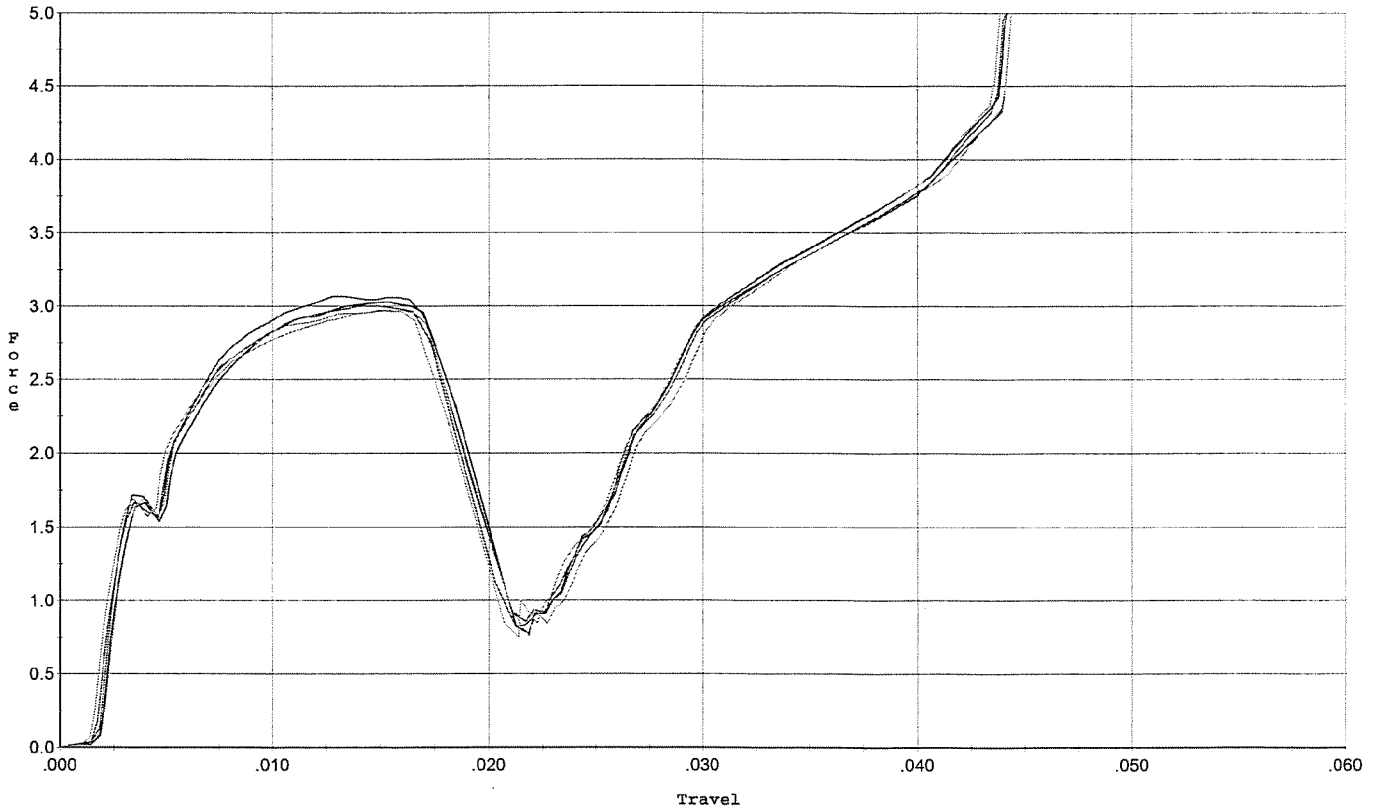
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.016	0.005	0.030	0.030		Set Trigger
2	2.611	0.018	0.00	0.030	0.033		Set Trigger
3	2.592	0.018	0.005	0.030	0.033		Set Trigger
4	2.576	0.017	0.00	0.030	0.031		Set Trigger
5	2.545	0.018	0.00	0.030	0.033		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



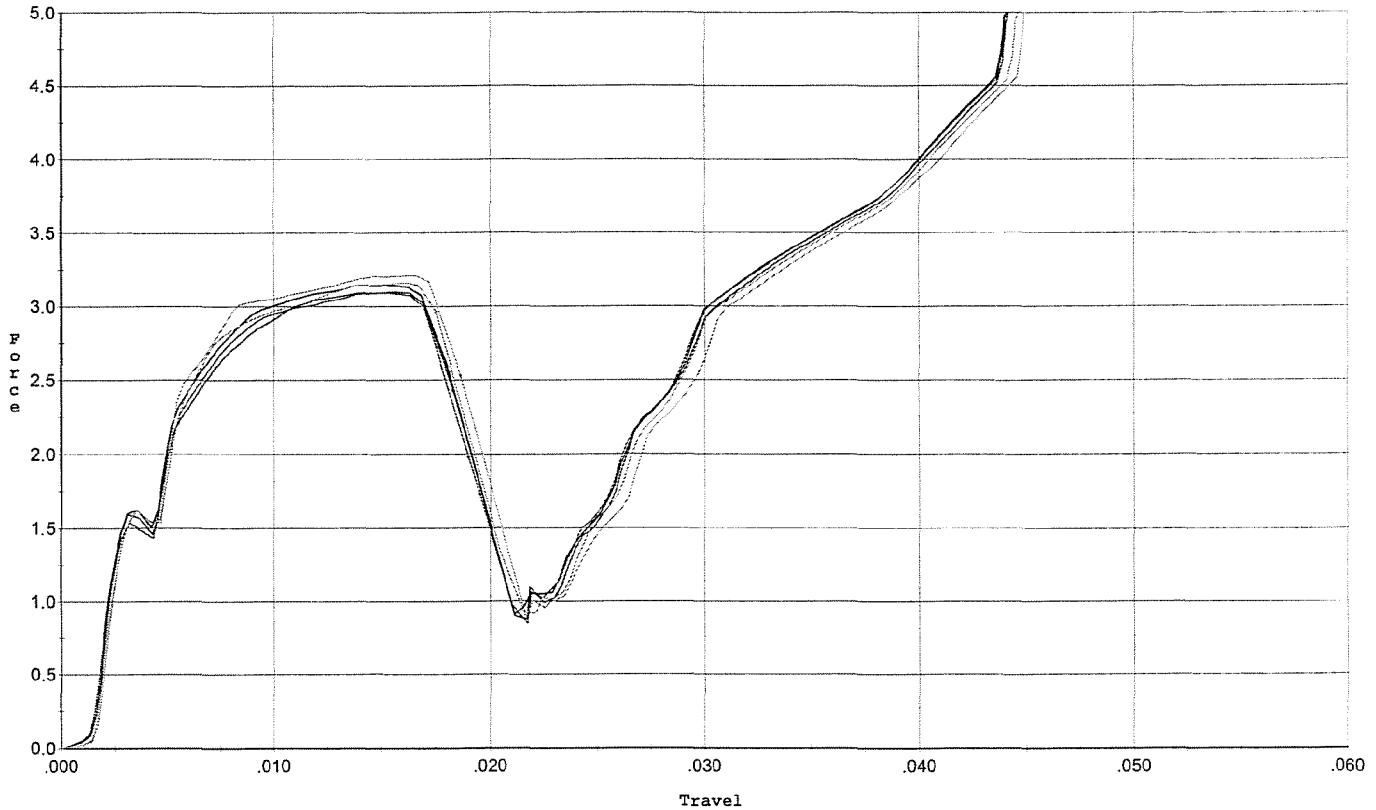
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.017	0.005	0.029	0.036		Set Trigger
2	3.028	0.018	0.002	0.028	0.038		Set Trigger
3	3.002	0.017	0.005	0.029	0.036		Set Trigger
4	2.974	0.018	0.00	0.029	0.038		Set Trigger
5	2.974	0.017	0.002	0.029	0.035		Set Trigger

A-3.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



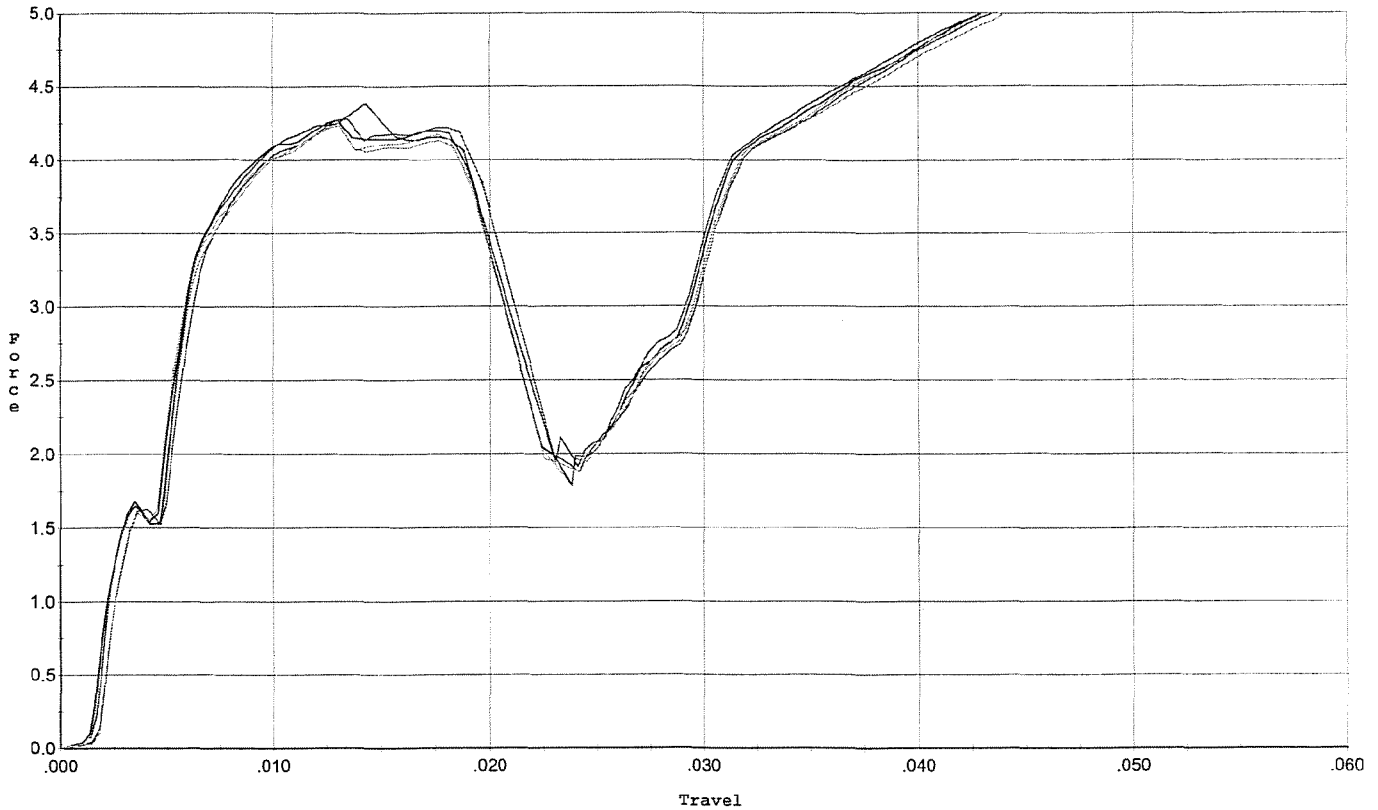
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.018	0.005	0.028	0.040		Set Trigger
2	3.147	0.018	0.00	0.028	0.040		Set Trigger
3	3.092	0.019	0.005	0.028	0.041		Set Trigger
4	3.209	0.019	0.00	0.029	0.042		Set Trigger
5	3.159	0.017	0.005	0.029	0.038		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



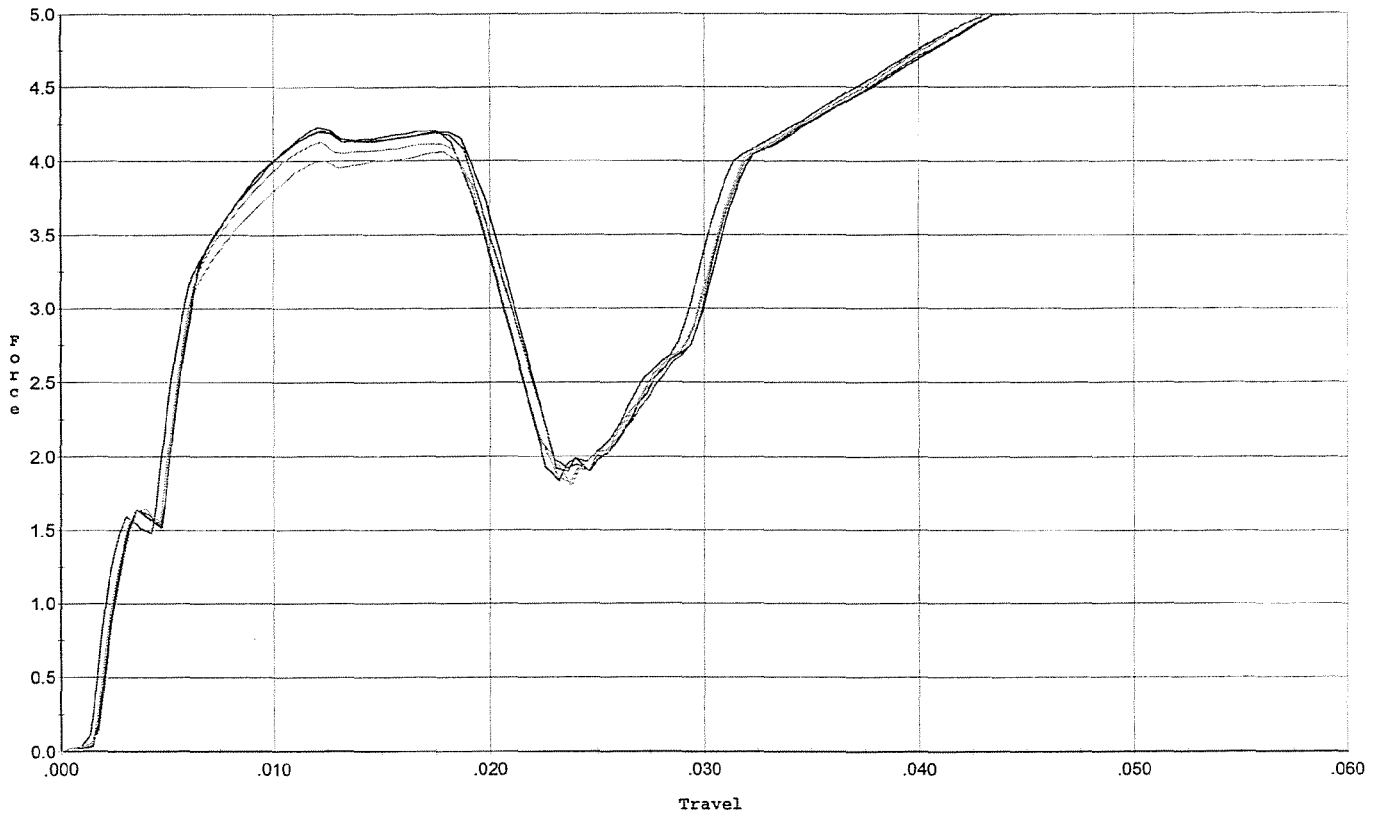
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.385	0.019	0.00	0.026	0.055		Set Trigger
2	4.270	0.019	0.00	0.026	0.055		Set Trigger
3	4.277	0.020	0.00	0.026	0.057		Set Trigger
4	4.234	0.019	0.00	0.026	0.056		Set Trigger
5	4.247	0.019	0.002	0.027	0.054		Set Trigger

A. 4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



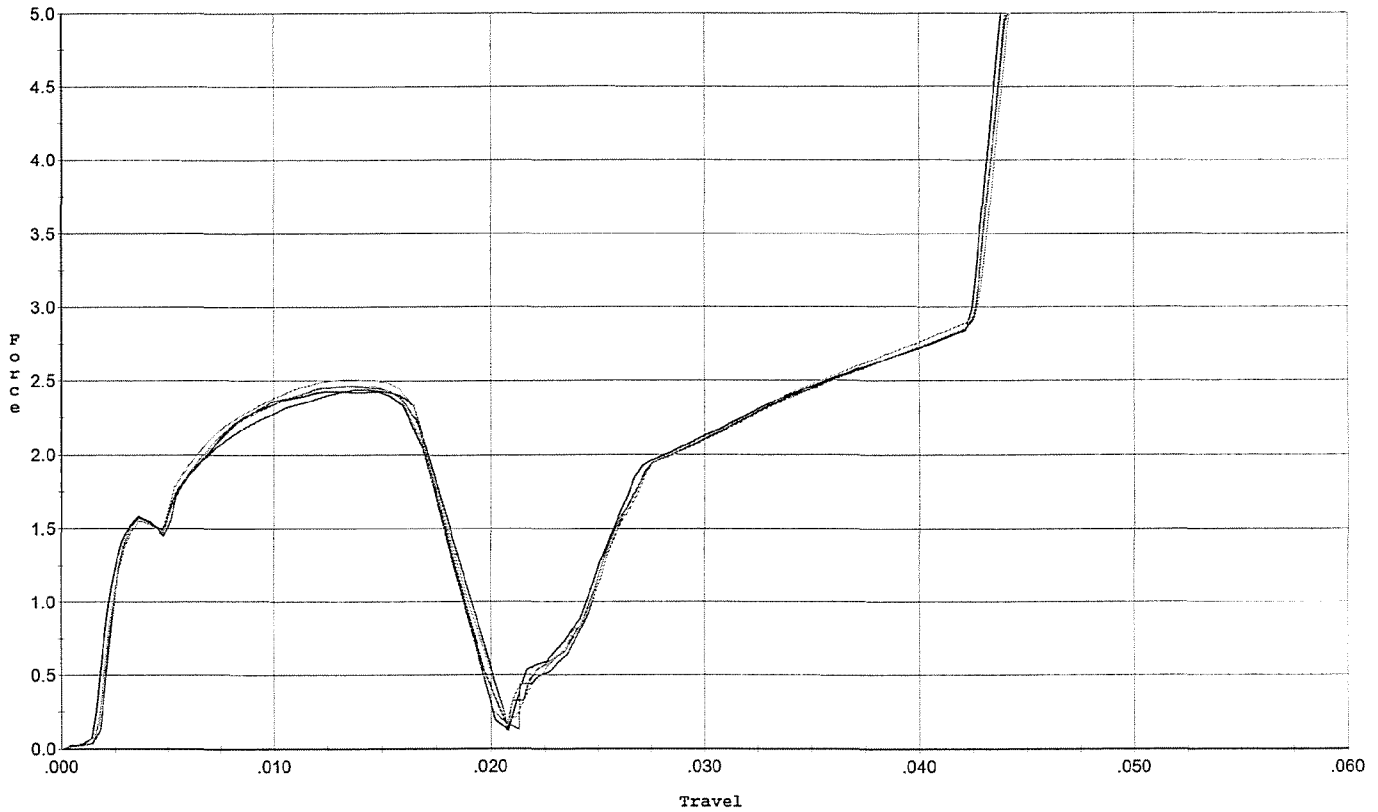
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.230	0.019	0.004	0.026	0.056		Set Trigger
2	4.196	0.020	0.005	0.027	0.057		Set Trigger
3	4.207	0.021	0.005	0.027	0.059		Set Trigger
4	4.131	0.019	0.005	0.027	0.054		Set Trigger
5	4.064	0.019	0.00	0.027	0.053		Set Trigger

A-4-16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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



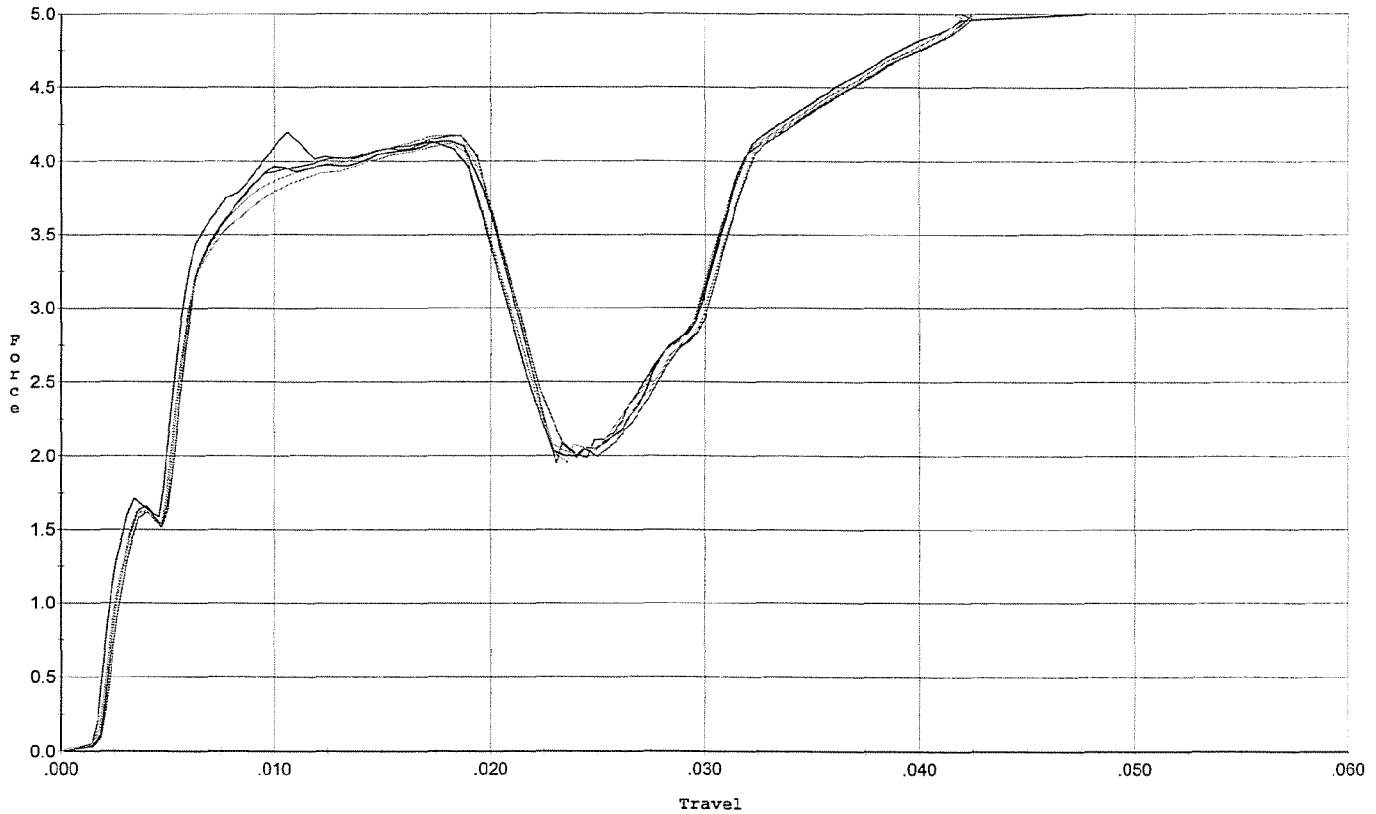
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.018	0.005	0.030	0.032		Set Trigger
2	2.423	0.017	0.00	0.031	0.030		Set Trigger
3	2.461	0.017	0.00	0.031	0.029		Set Trigger
4	2.507	0.016	0.00	0.031	0.029		Set Trigger
5	2.463	0.017	0.00	0.031	0.029		Set Trigger

A.2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/20/2009

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	4.197	0.019	0.005	0.026	0.055		Set Trigger
2	4.131	0.020	0.00	0.027	0.056		Set Trigger
3	4.172	0.019	0.00	0.027	0.055		Set Trigger
4	4.180	0.020	0.00	0.027	0.055		Set Trigger
5	4.120	0.019	0.005	0.026	0.052		Set Trigger

A-4.16