

G680 7722

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

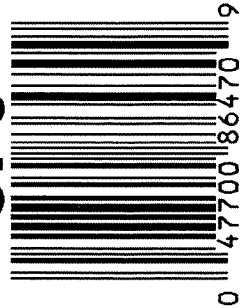
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6807722

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 7722

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-26-09	SPD.
430	ASSEMBLE TO STOCK		2-26-09	RP
440	PROOF		2-26-09	SPD.
460	CHECK HEADSPACE		2-26-09	SPD.
470	DIS-ASSEMBLE ACTION		2-26-09	SPD.
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	2-27-09	RT
475	DRILL AND TAP SIGHT HOLES		2-27-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/2/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/2/09	RT
520	GOFF BLAST BBL / REC		3/3/09	DC
542	APPLY COATINGS (BARREL ACTION)		3/6	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

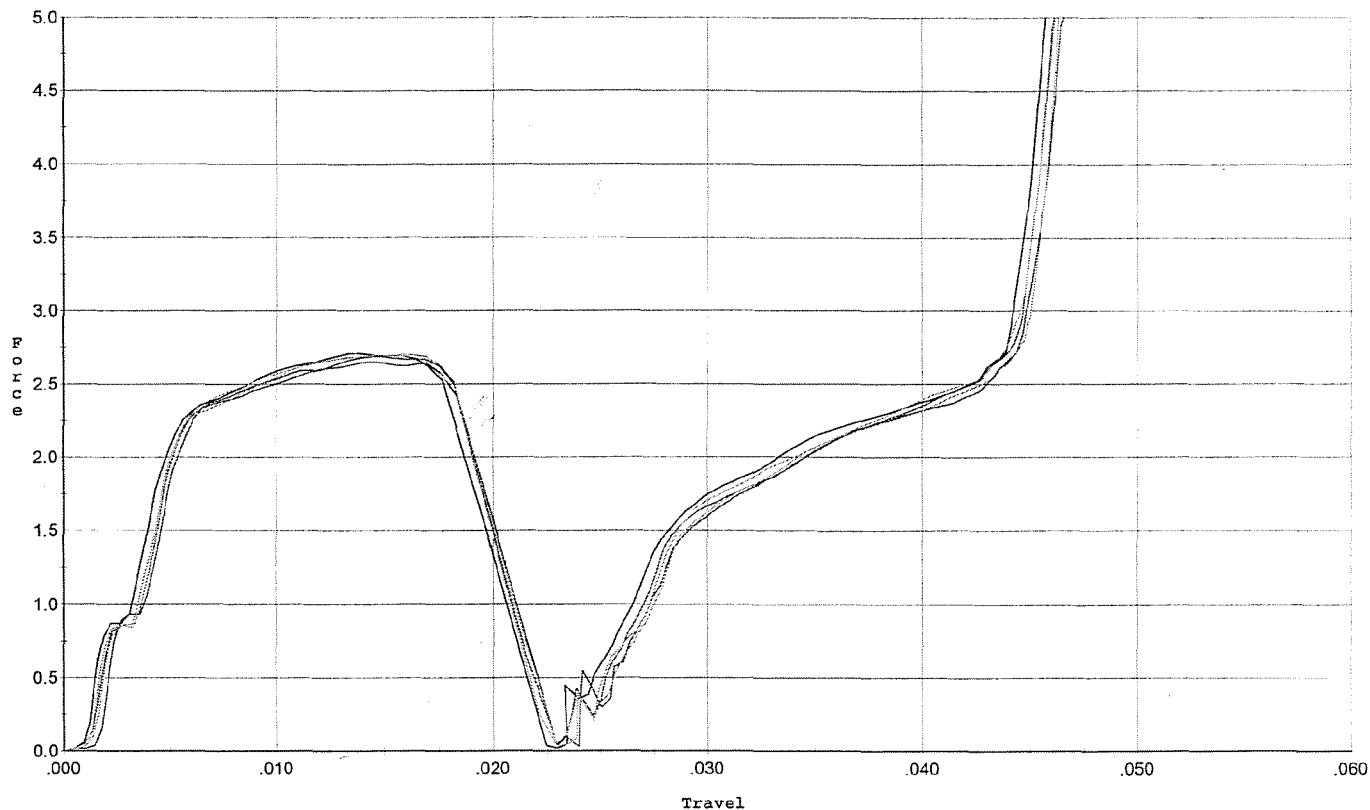
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-24-09	WN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-24-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	3-24-09	WN
	J) ASSEMBLE STOCK		3-11-09	WJ
	K) ASSEMBLE SWIVEL STUDS		3-24-09	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	3-16-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	WN
670	FINAL INSPECTION A) HEADSPACE		3-24-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.51</u> <u>2.53</u> <u>2.60</u> <u>2.64</u>	3-18-09	TC
	C) FUNCTION		3-24-09	WN
690	PACK		5-27-09	WN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



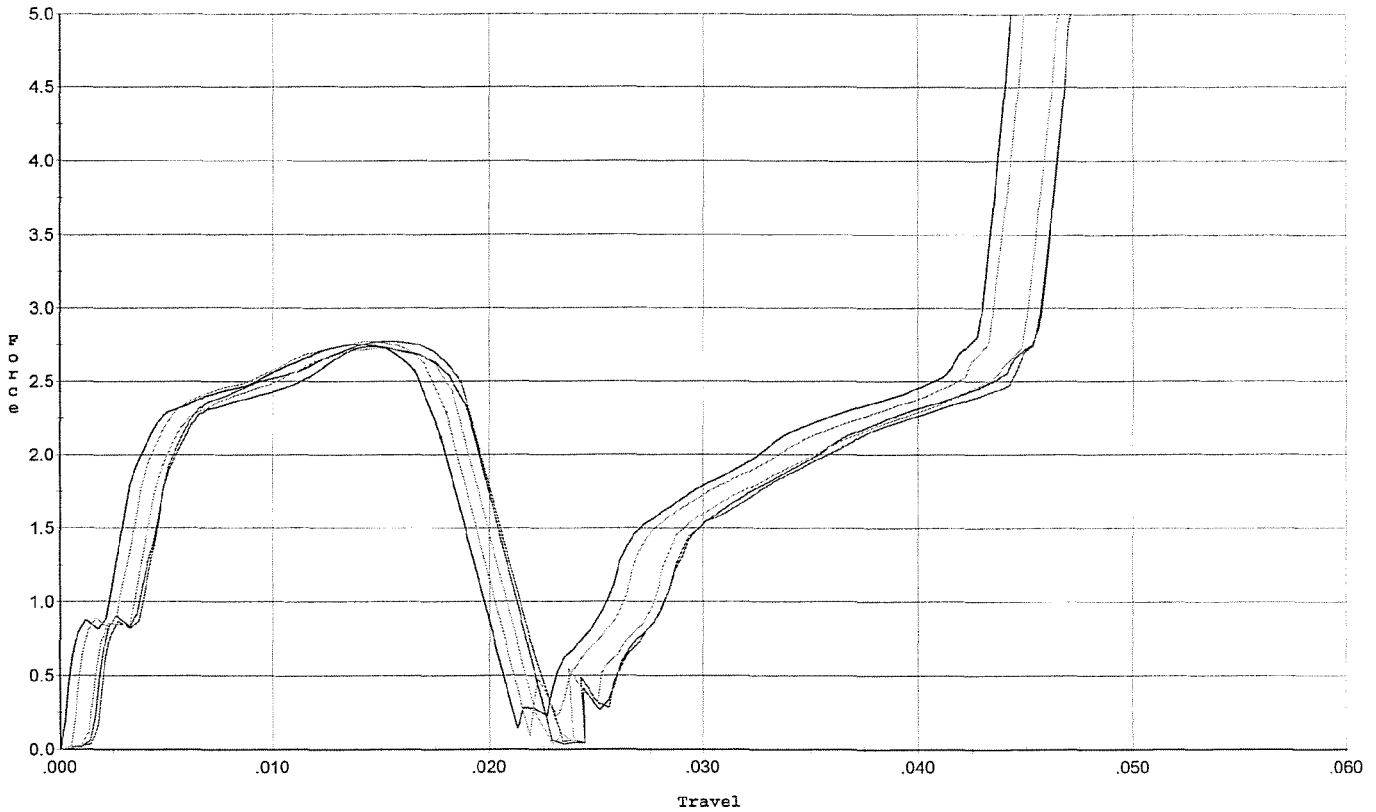
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.021	0.00	0.031	0.039		Set Trigger
2	2.710	0.020	0.00	0.031	0.039		Set Trigger
3	2.653	0.018	0.00	0.031	0.035		Set Trigger
4	2.715	0.018	0.00	0.031	0.036		Set Trigger
5	2.704	0.018	0.00	0.031	0.035		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



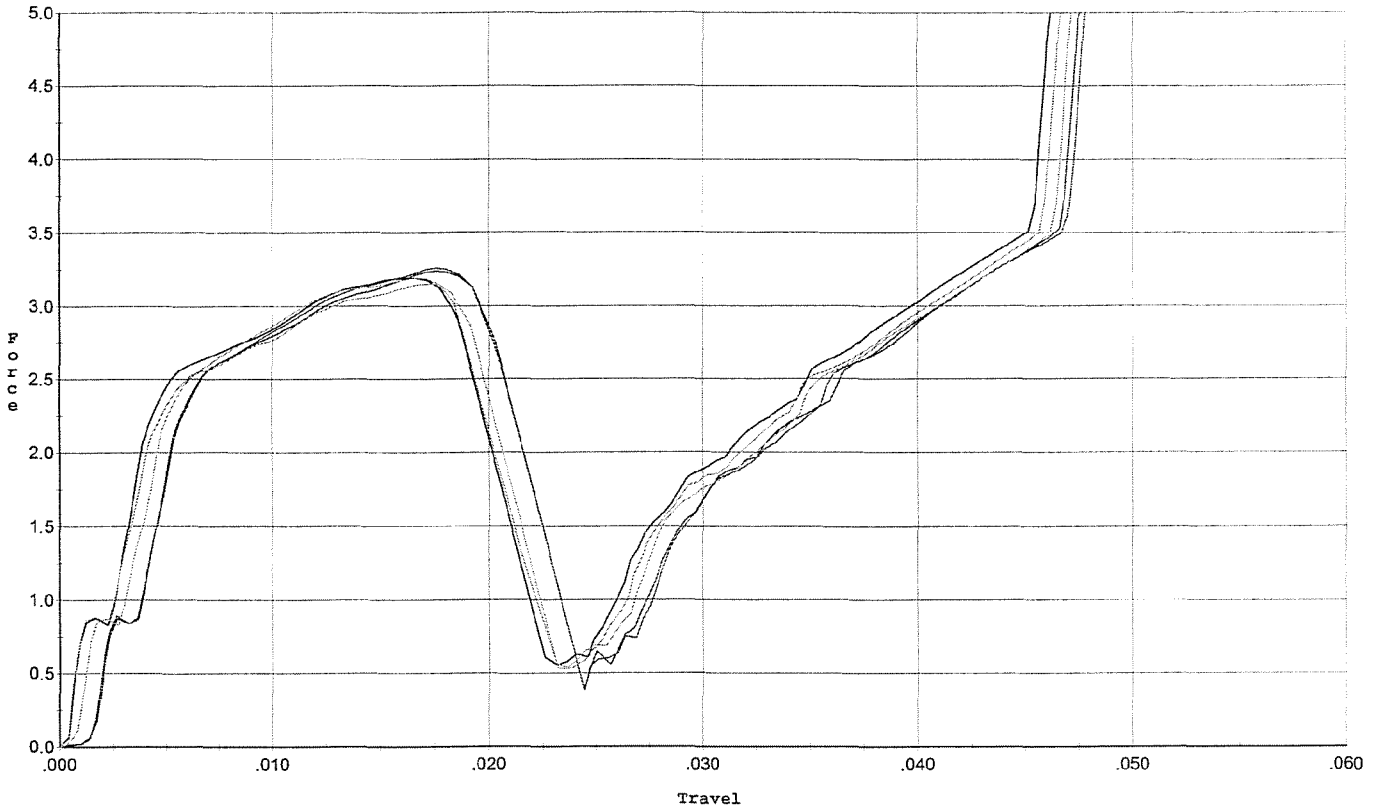
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.735	0.019	0.00	0.032	0.036		Set Trigger
2	2.753	0.018	0.00	0.030	0.036		Set Trigger
3	2.774	0.019	0.00	0.032	0.036		Set Trigger
4	2.725	0.018	0.003	0.032	0.036		Set Trigger
5	2.771	0.018	0.00	0.030	0.037		Set Trigger

A-2.75

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



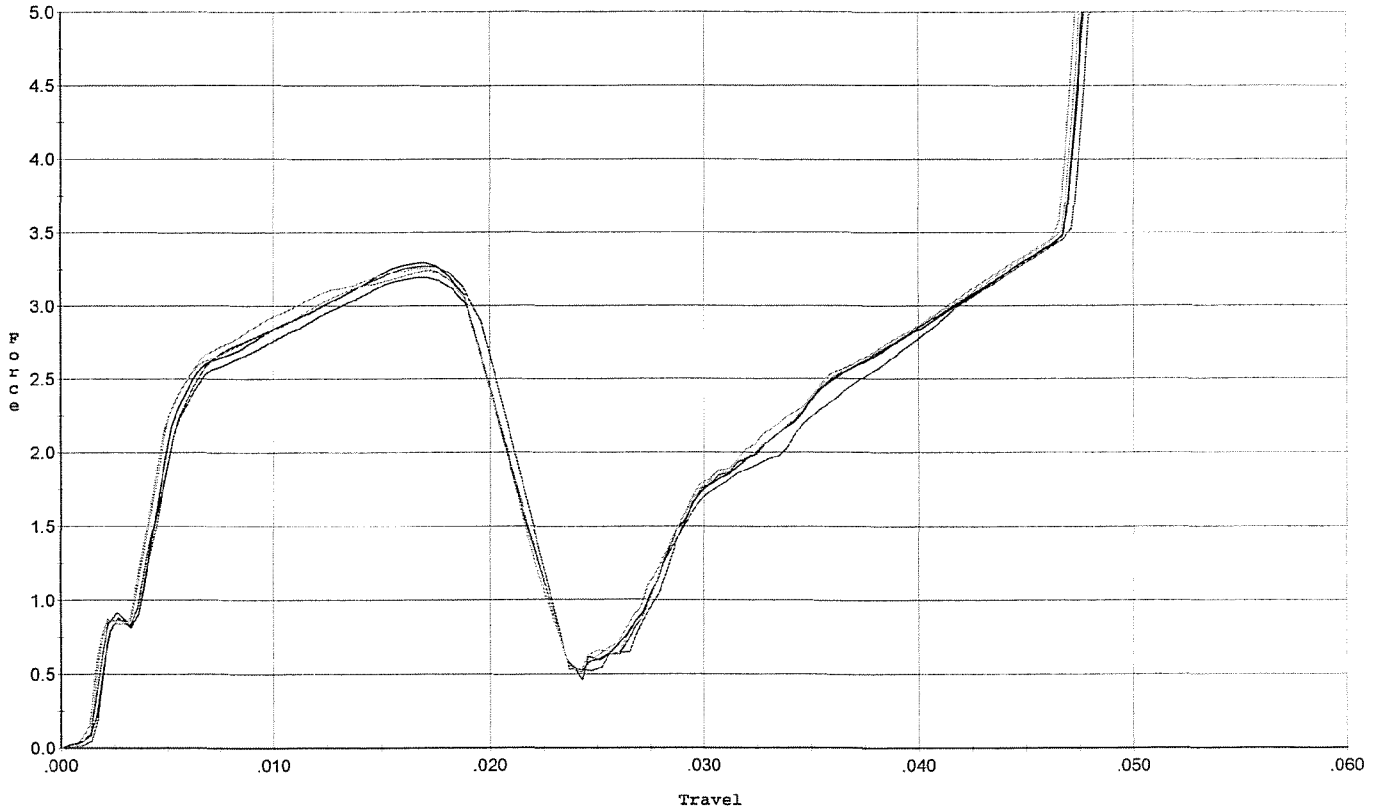
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.241	0.020	0.00	0.030	0.045		Set Trigger
2	3.191	0.019	0.00	0.030	0.043		Set Trigger
3	3.261	0.021	0.00	0.030	0.045		Set Trigger
4	3.153	0.019	0.00	0.031	0.043		Set Trigger
5	3.192	0.018	0.00	0.031	0.042		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



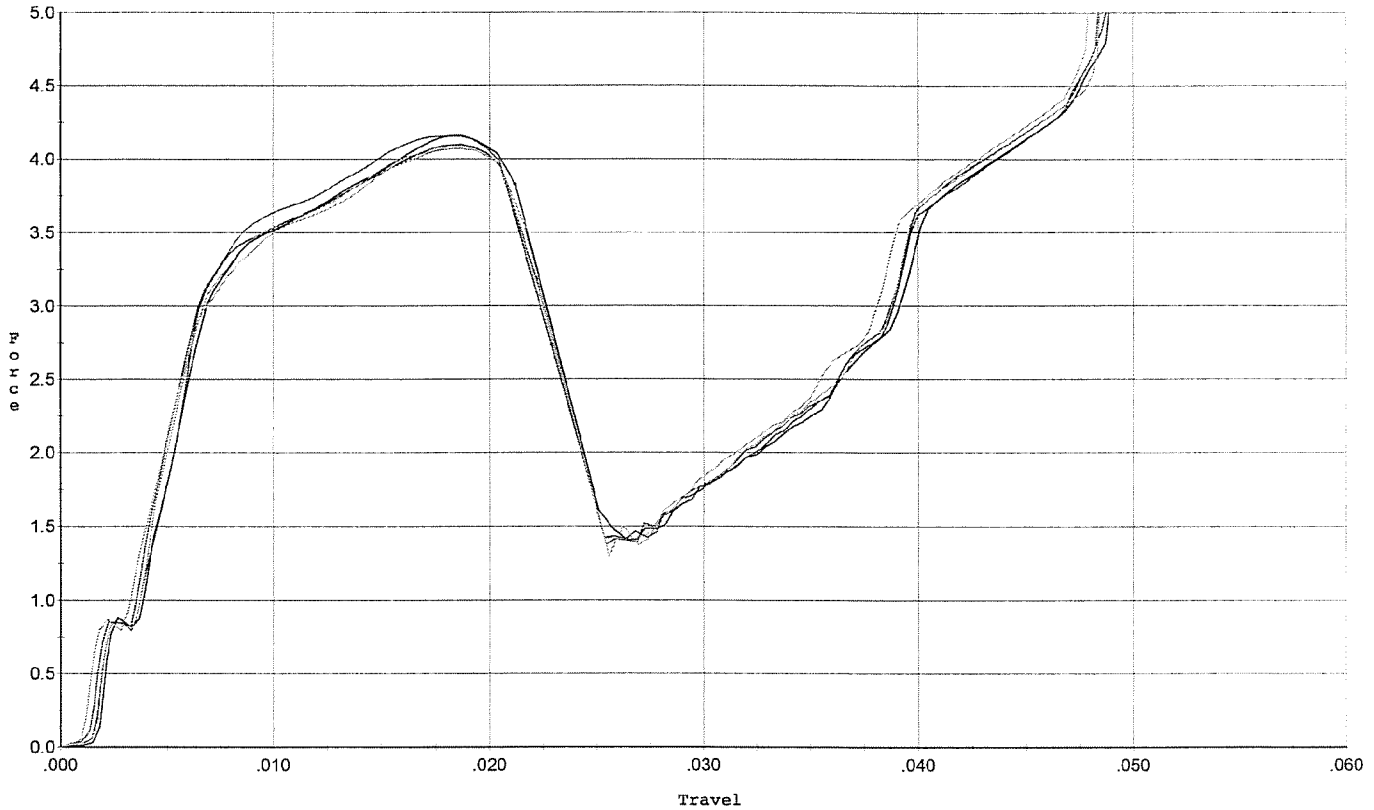
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.193	0.019	0.00	0.031	0.041		Set Trigger
2	3.296	0.019	0.00	0.031	0.042		Set Trigger
3	3.272	0.020	0.00	0.031	0.043		Set Trigger
4	3.258	0.019	0.003	0.031	0.043		Set Trigger
5	3.244	0.019	0.00	0.031	0.042		Set Trigger

A-3-25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



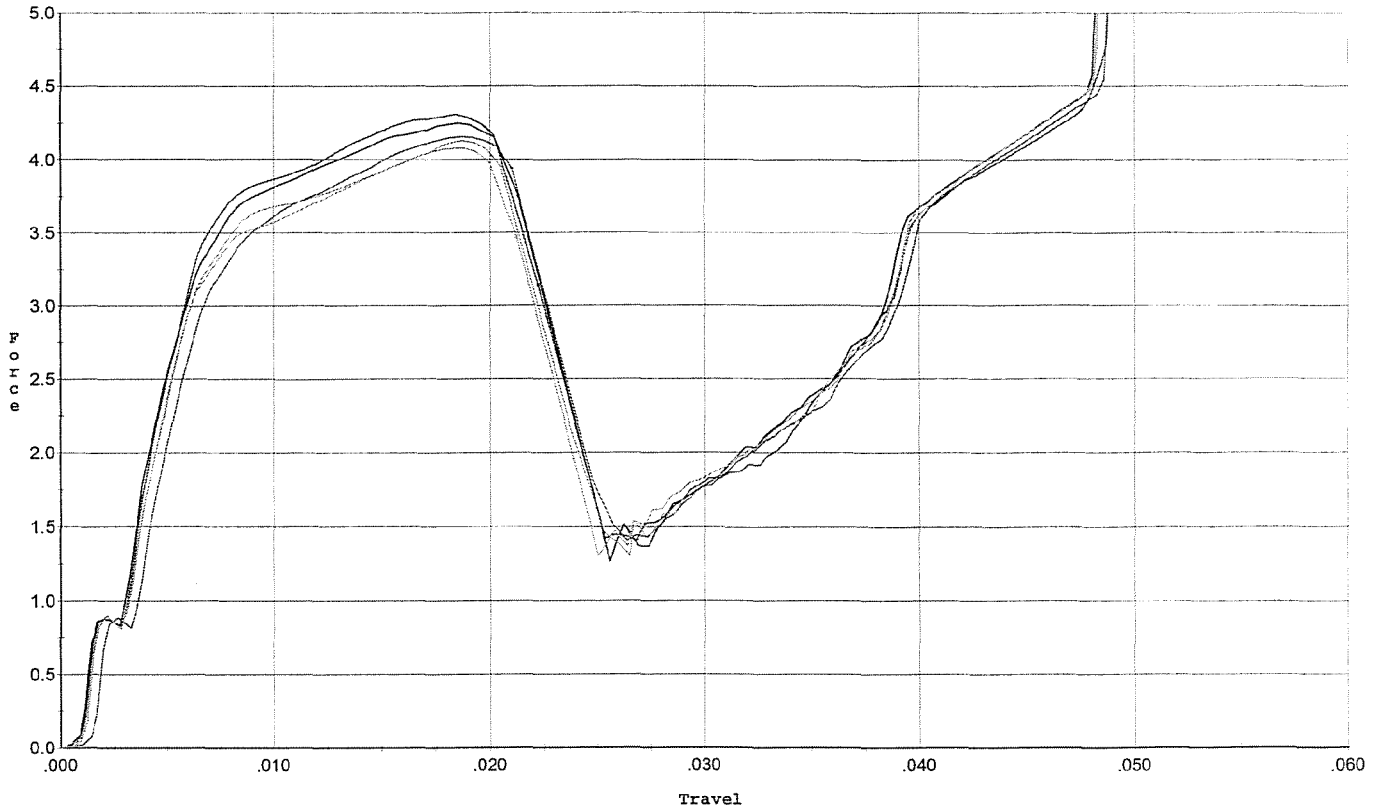
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.096	0.023	0.00	0.029	0.062		Set Trigger
2	4.160	0.021	0.00	0.029	0.058		Set Trigger
3	4.156	0.022	0.003	0.029	0.062		Set Trigger
4	4.102	0.022	0.00	0.028	0.062		Set Trigger
5	4.070	0.022	0.00	0.028	0.059		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



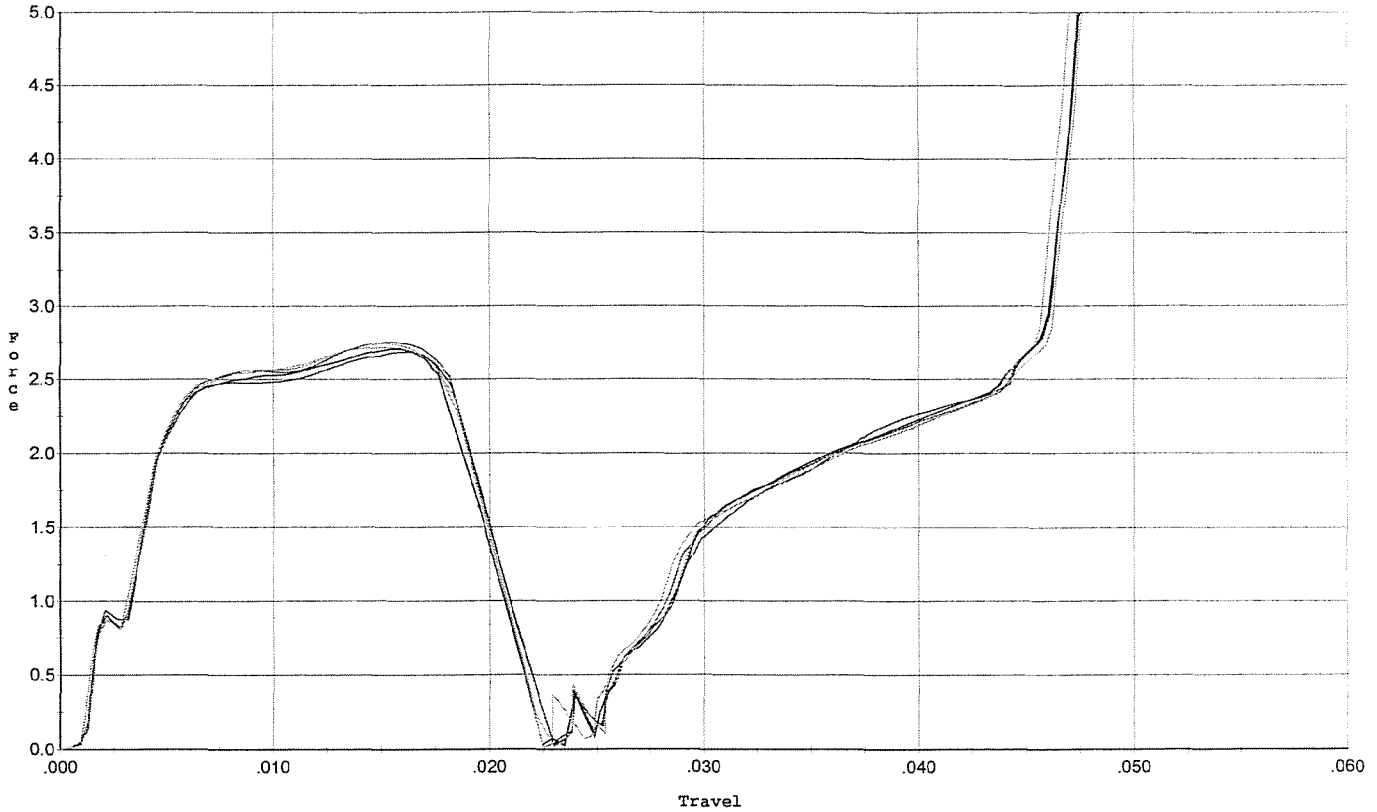
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.308	0.022	0.00	0.029	0.066		Set Trigger
2	4.249	0.021	0.00	0.028	0.063		Set Trigger
3	4.156	0.021	0.00	0.029	0.059		Set Trigger
4	4.079	0.021	0.00	0.029	0.060		Set Trigger
5	4.129	0.020	0.00	0.029	0.058		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



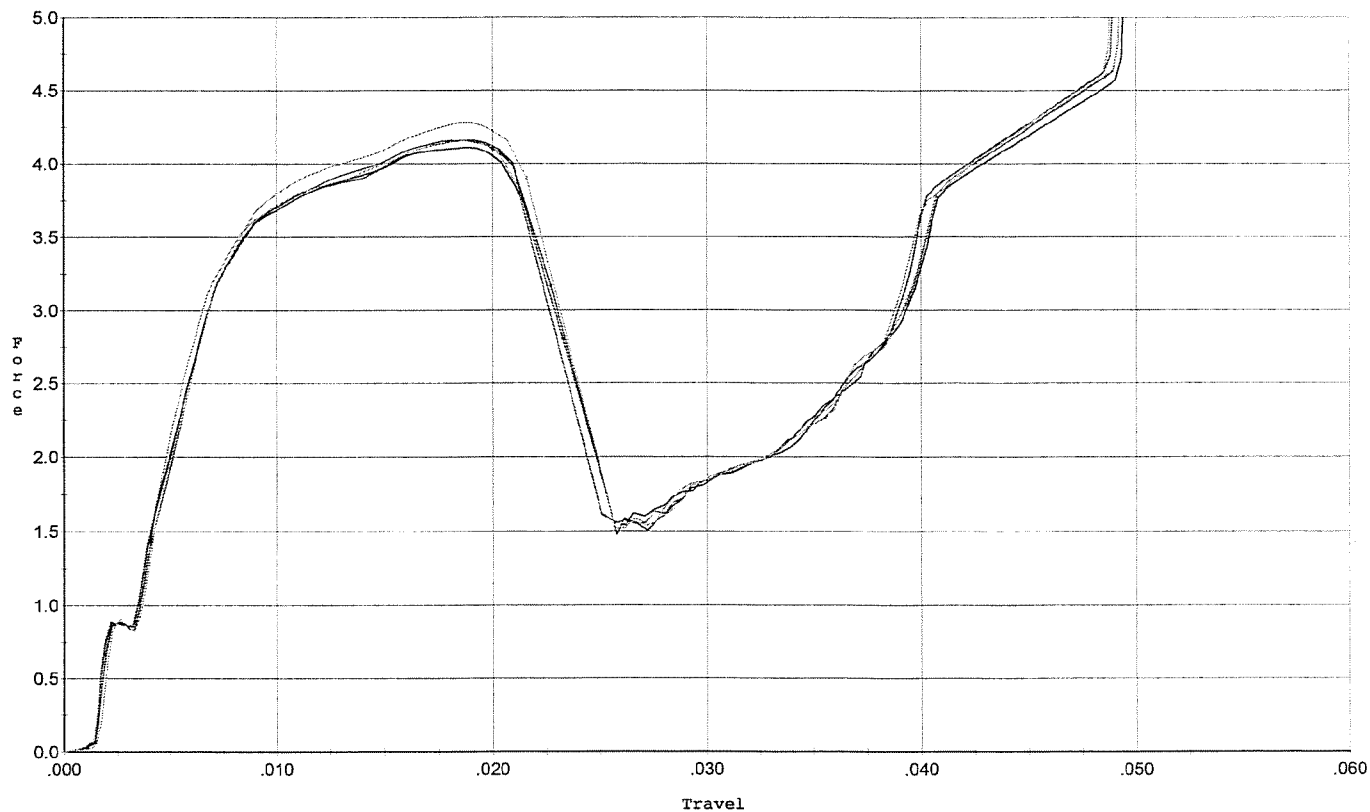
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.684	0.018	0.003	0.033	0.036		Set Trigger
2	2.707	0.020	0.00	0.032	0.038		Set Trigger
3	2.754	0.018	0.00	0.032	0.036		Set Trigger
4	2.718	0.018	0.00	0.033	0.037		Set Trigger
5	2.745	0.019	0.00	0.032	0.037		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.159	0.023	0.00	0.028	0.064		Set Trigger
2	4.107	0.021	0.003	0.029	0.060		Set Trigger
3	4.161	0.023	0.00	0.029	0.066		Set Trigger
4	4.282	0.022	0.00	0.029	0.062		Set Trigger
5	4.158	0.021	0.003	0.029	0.060		Set Trigger

A-4.17