

G-6845850

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD

proof of purchase



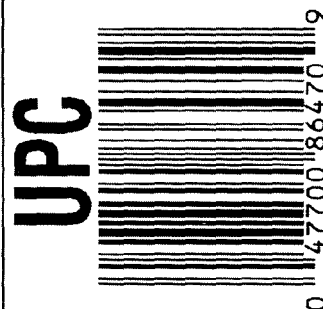
owner registration sticker



BM FORM

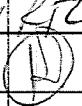
ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6845850



M-24
INSPECTION CHECKLIST-NEW GUNS

5850
GUN SERIAL # G684 ~~5860~~

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-20-09	RP
430	ASSEMBLE TO STOCK		4-20-09	RP
440	PROOF		4-20-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	4-20-09	RP
470	DIS-ASSEMBLE ACTION		4-20-09	RP
472	SERIALIZE BOLT HANDLE		4-21-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	4/21/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4/27/09	RT
510	DRILL AND TAP SIGHT HOLES		4-21-09	SP
520	GOFF BLAST BBL / REC		4/28	RP
540	APPLY COATINGS (BARREL ACTION)		5/7	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-7-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-7-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-7-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-7-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

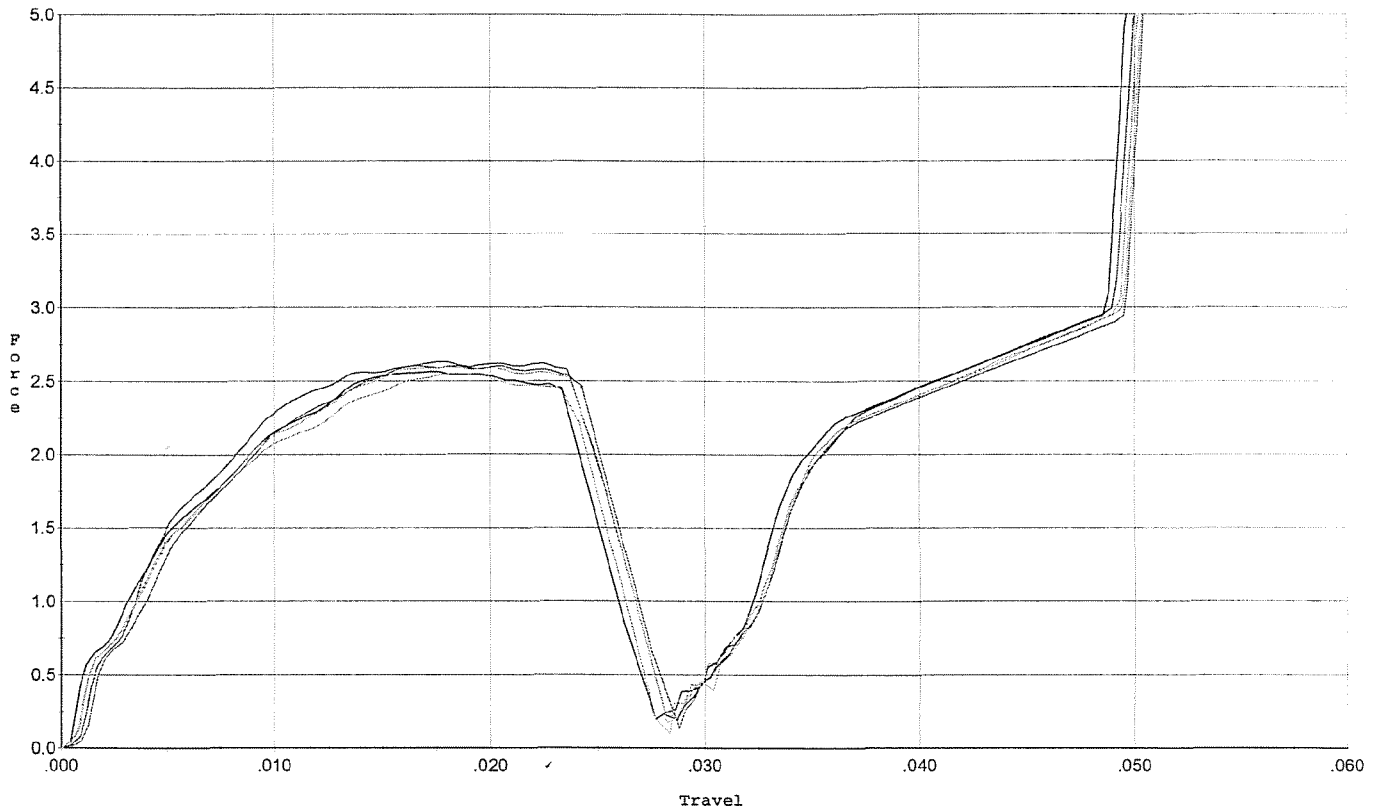
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	5-14-09	SPD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	5-14-09	SPD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	5-14-09	SPD
	J) ASSEMBLE STOCK		5-7-09	SPD
	K) ASSEMBLE SWIVEL STUDS		5-14-09	SPD
	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	5/11/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-11-09	WV
670	FINAL INSPECTION A) HEADSPACE		5-14-09	SPD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.51</u> <u>2.57</u> <u>2.50</u> <u>2.50</u>	5-13-09	WV
	C) FUNCTION		5-14-09	SPD
690	PACK		7/12/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



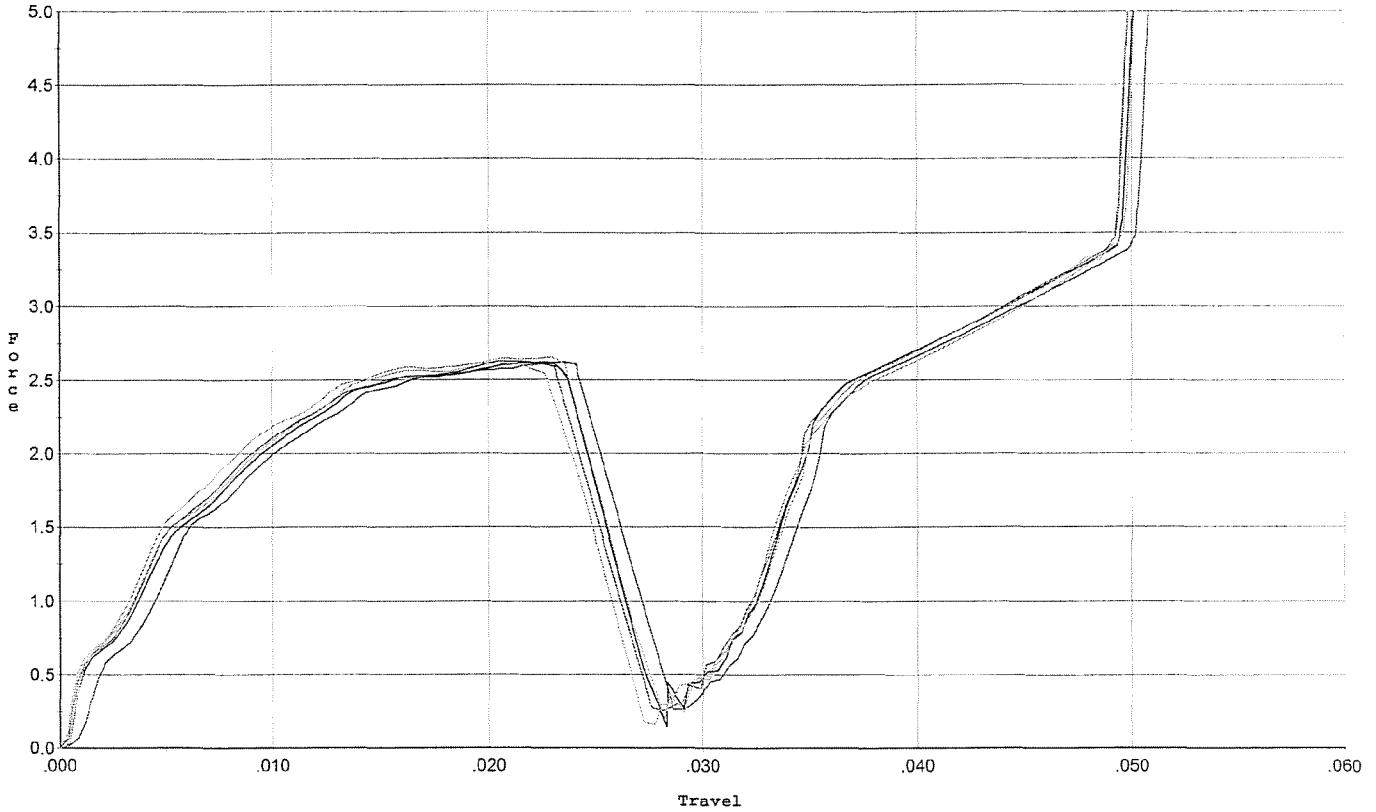
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.025	0.00	0.031	0.049		Set Trigger
2	2.564	0.023	0.00	0.031	0.044		Set Trigger
3	2.605	0.024	0.00	0.031	0.046		Set Trigger
4	2.596	0.025	0.00	0.031	0.047		Set Trigger
5	2.553	0.024	0.00	0.031	0.045		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



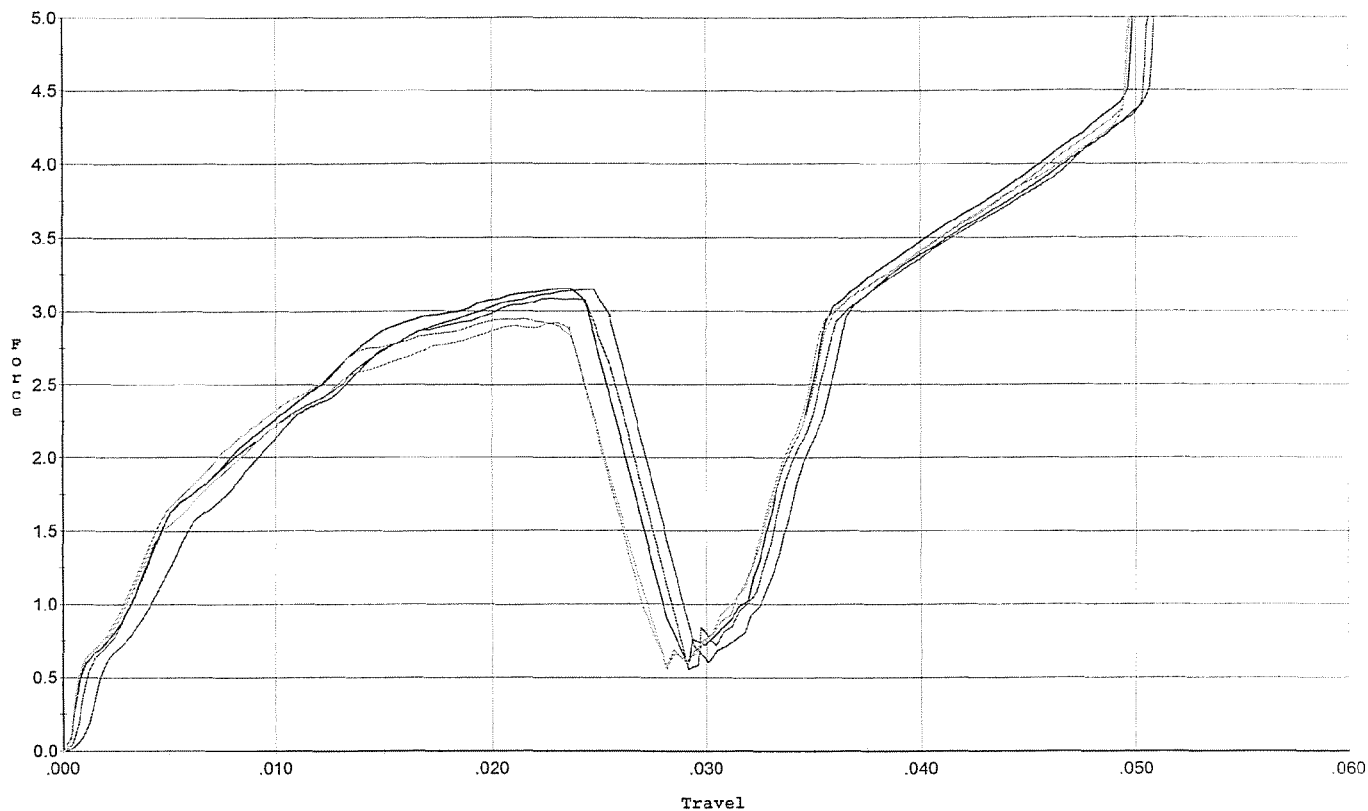
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.628	0.024	0.00	0.032	0.044		Set Trigger
2	2.618	0.024	0.00	0.031	0.044		Set Trigger
3	2.608	0.023	0.00	0.031	0.043		Set Trigger
4	2.657	0.024	0.00	0.031	0.045		Set Trigger
5	2.615	0.024	0.00	0.031	0.046		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



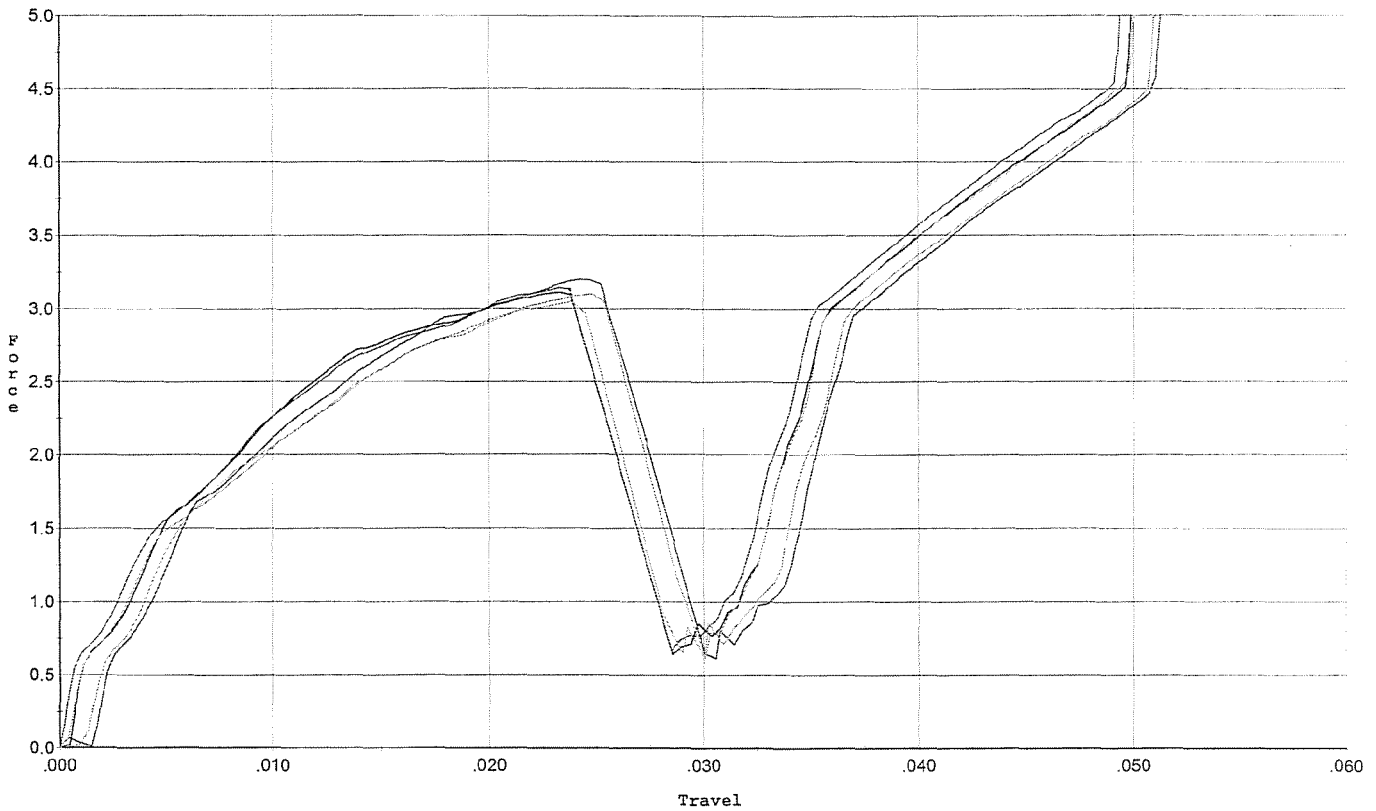
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.025	0.00	0.029	0.053		Set Trigger
2	3.155	0.024	0.00	0.029	0.053		Set Trigger
3	3.088	0.026	0.00	0.030	0.054		Set Trigger
4	2.920	0.024	0.00	0.030	0.048		Set Trigger
5	2.945	0.024	0.00	0.030	0.050		Set Trigger

A-3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



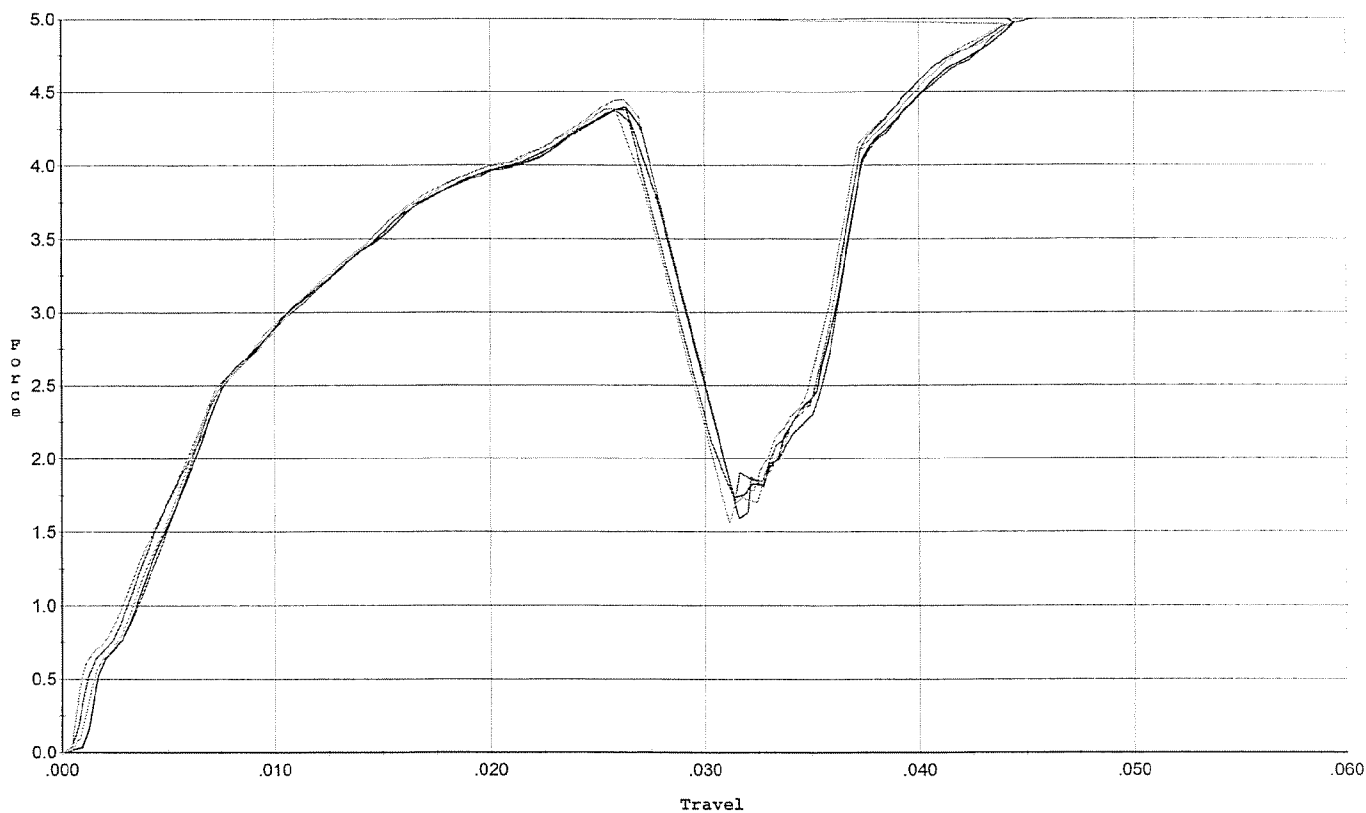
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.199	0.027	0.002	0.027	0.057		Set Trigger
2	3.111	0.024	0.00	0.030	0.050		Set Trigger
3	3.142	0.024	0.00	0.029	0.051		Set Trigger
4	3.048	0.024	0.00	0.029	0.050		Set Trigger
5	3.097	0.025	0.00	0.029	0.052		Set Trigger

A-3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



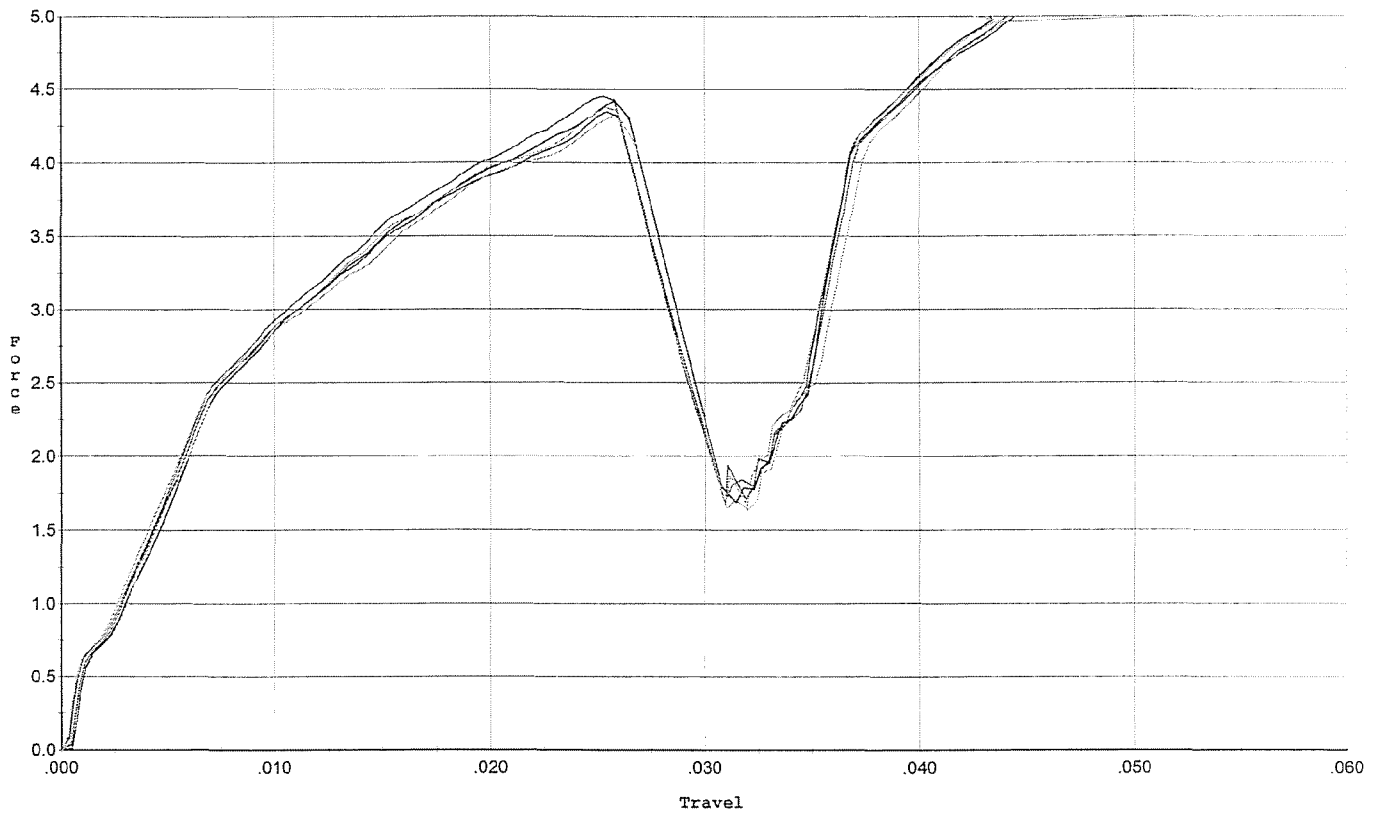
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.379	0.028	0.00	0.020	0.078		Set Trigger
2	4.397	0.027	0.00	0.021	0.076		Set Trigger
3	4.372	0.026	0.00	0.021	0.075		Set Trigger
4	4.450	0.027	0.00	0.021	0.077		Set Trigger
5	4.386	0.027	0.00	0.021	0.077		Set Trigger

A-4.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



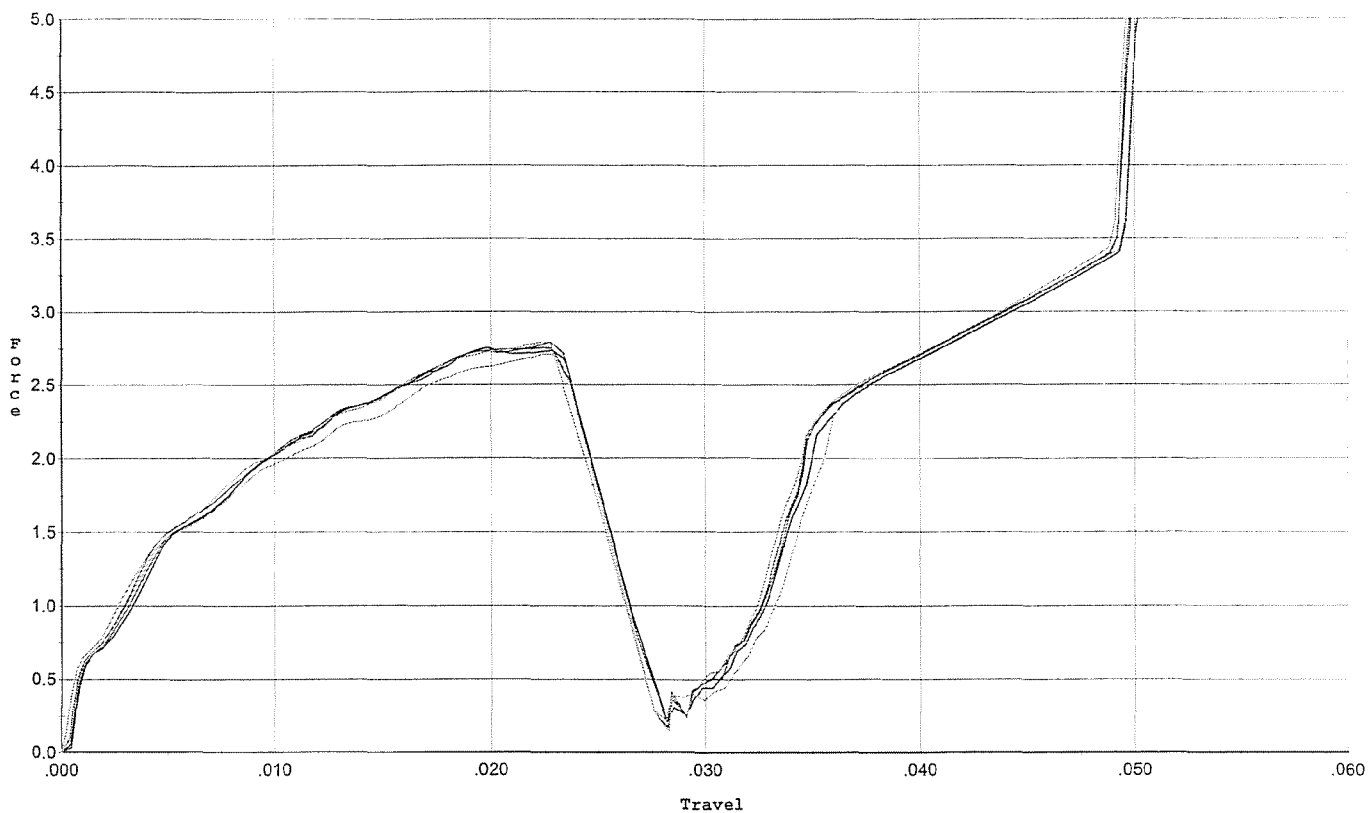
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.345	0.026	0.00	0.021	0.072		Set Trigger
2	4.420	0.026	0.00	0.021	0.074		Set Trigger
3	4.453	0.026	0.00	0.021	0.074		Set Trigger
4	4.328	0.027	0.00	0.021	0.074		Set Trigger
5	4.374	0.026	0.00	0.021	0.073		Set Trigger

A-4.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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



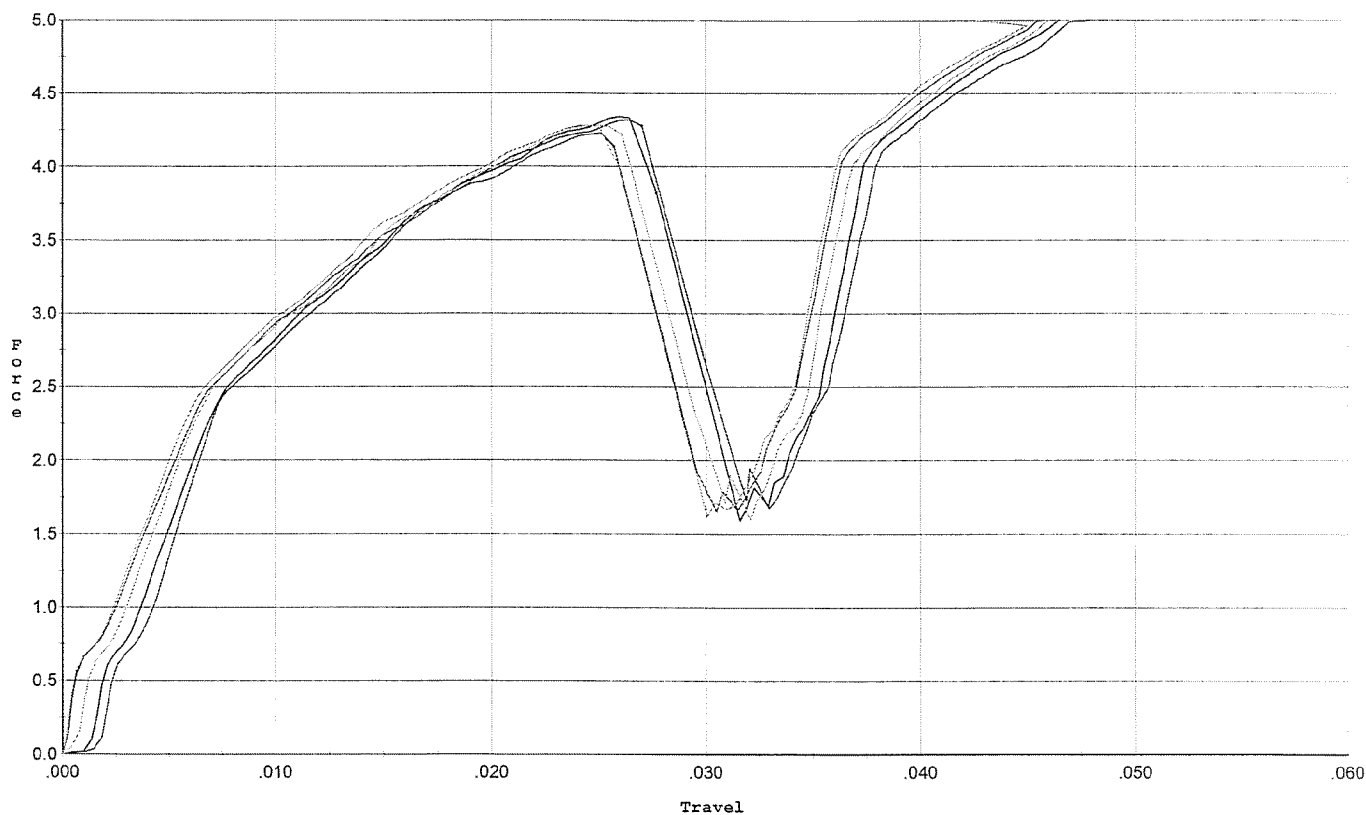
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.793	0.023	0.00	0.031	0.045		Set Trigger
2	2.753	0.023	0.00	0.031	0.045		Set Trigger
3	2.755	0.024	0.00	0.031	0.046		Set Trigger
4	2.709	0.024	0.00	0.032	0.044		Set Trigger
5	2.789	0.025	0.00	0.031	0.048		Set Trigger

A-2-76

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/6/2009

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	4.319	0.027	0.00	0.021	0.074		Set Trigger
2	4.342	0.028	0.00	0.021	0.077		Set Trigger
3	4.230	0.026	0.00	0.021	0.072		Set Trigger
4	4.282	0.026	0.00	0.021	0.074		Set Trigger
5	4.287	0.026	0.00	0.021	0.074		Set Trigger

A-4.29