

6848434

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

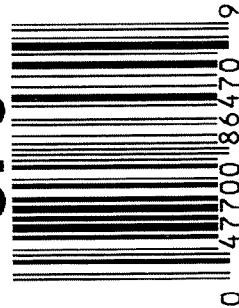


BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6848434

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6848434

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6/16/09	SPD
430	ASSEMBLE TO STOCK		6-16-09	SP
440	PROOF		6/16/09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	6/16/09	SPD
470	DIS-ASSEMBLE ACTION		6/16/09	SPD
472	SERIALIZE BOLT HANDLE		6/16/09	SPD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(R)</u>	6/20/09	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/23/09	RT
510	DRILL AND TAP SIGHT HOLES		6-17-09	SP
520	GOFF BLAST BBL / REC		6-23-09	SP
540	APPLY COATINGS (BARREL ACTION)		2-25	-
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-13-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

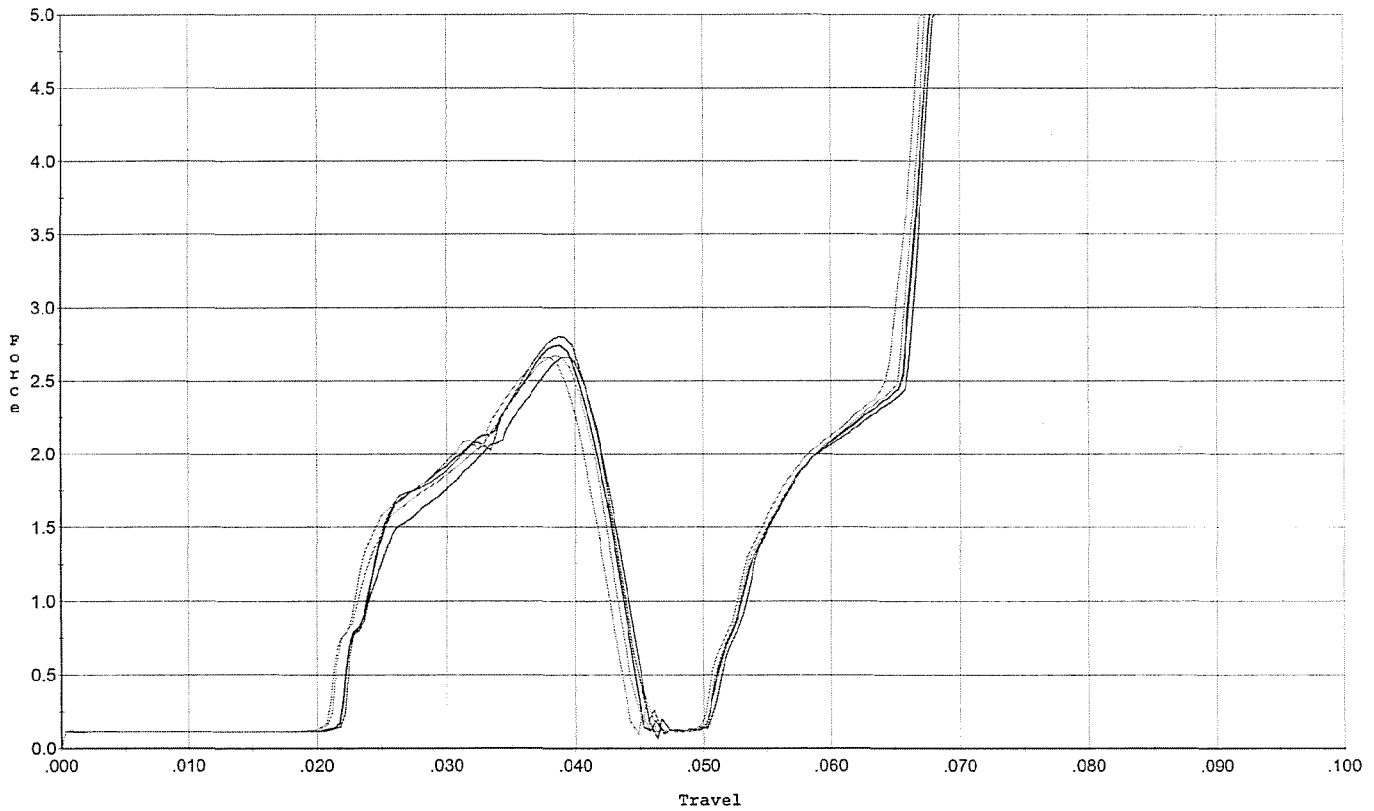
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	8/29/09	RB
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>8°</u> <u>8°</u> <u>8°</u>	8/29/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	8/29/09	RB
	J) ASSEMBLE STOCK		8-25-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		8/29/09	RB
	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	8-27-09	RP
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-27-09	J.P.D.
670	FINAL INSPECTION A) HEADSPACE		8/29/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.66</u> <u>2.71</u> <u>2.64</u> <u>2.68</u>	8/28/09	RB
	C) FUNCTION		8/29/09	RB
690	PACK		8/31/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



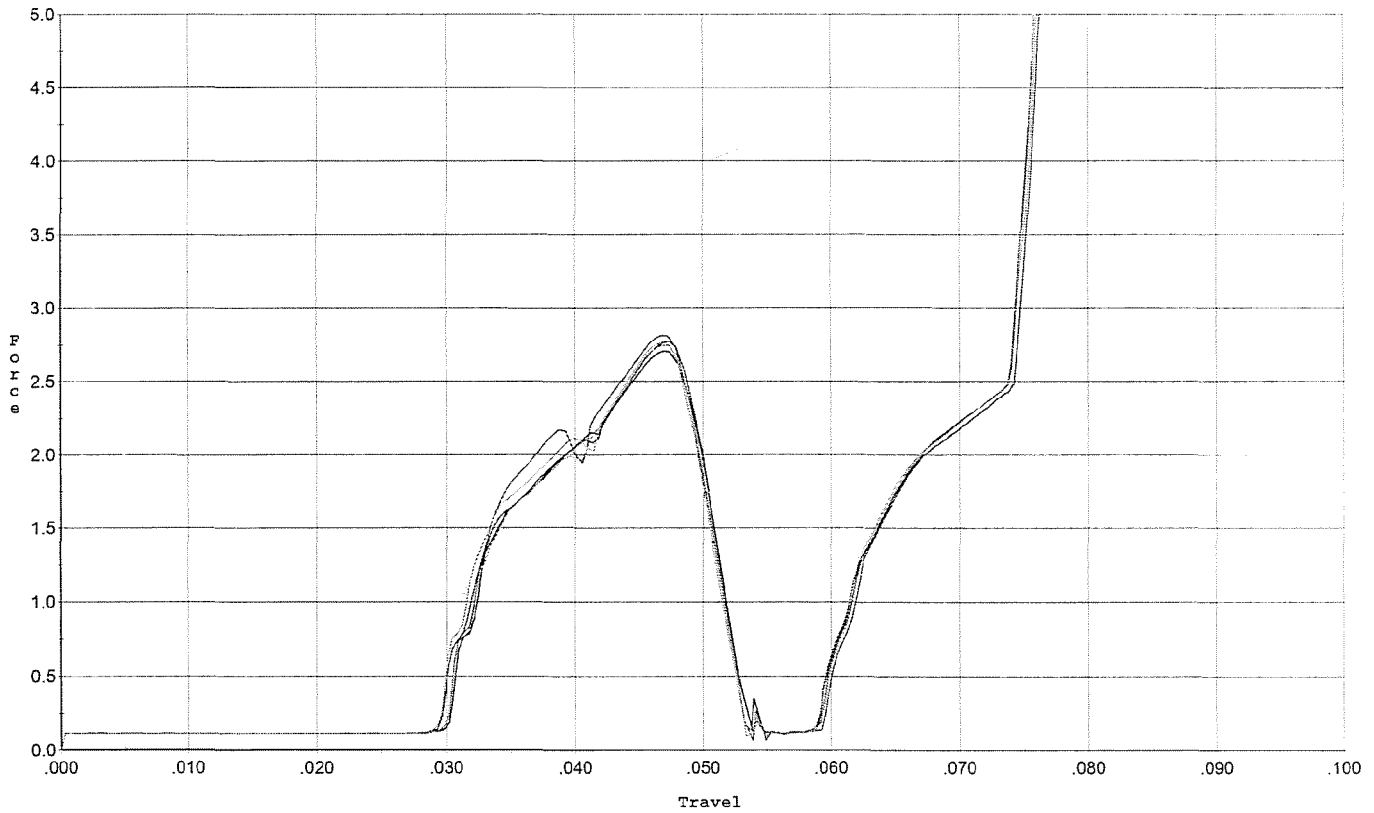
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.663	0.043	0.022	0.030	0.042		Set Trigger
2	2.745	0.043	0.022	0.030	0.043		Set Trigger
3	2.807	0.042	0.022	0.030	0.043		Set Trigger
4	2.677	0.041	0.021	0.030	0.042		Set Trigger
5	2.664	0.042	0.021	0.030	0.042		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



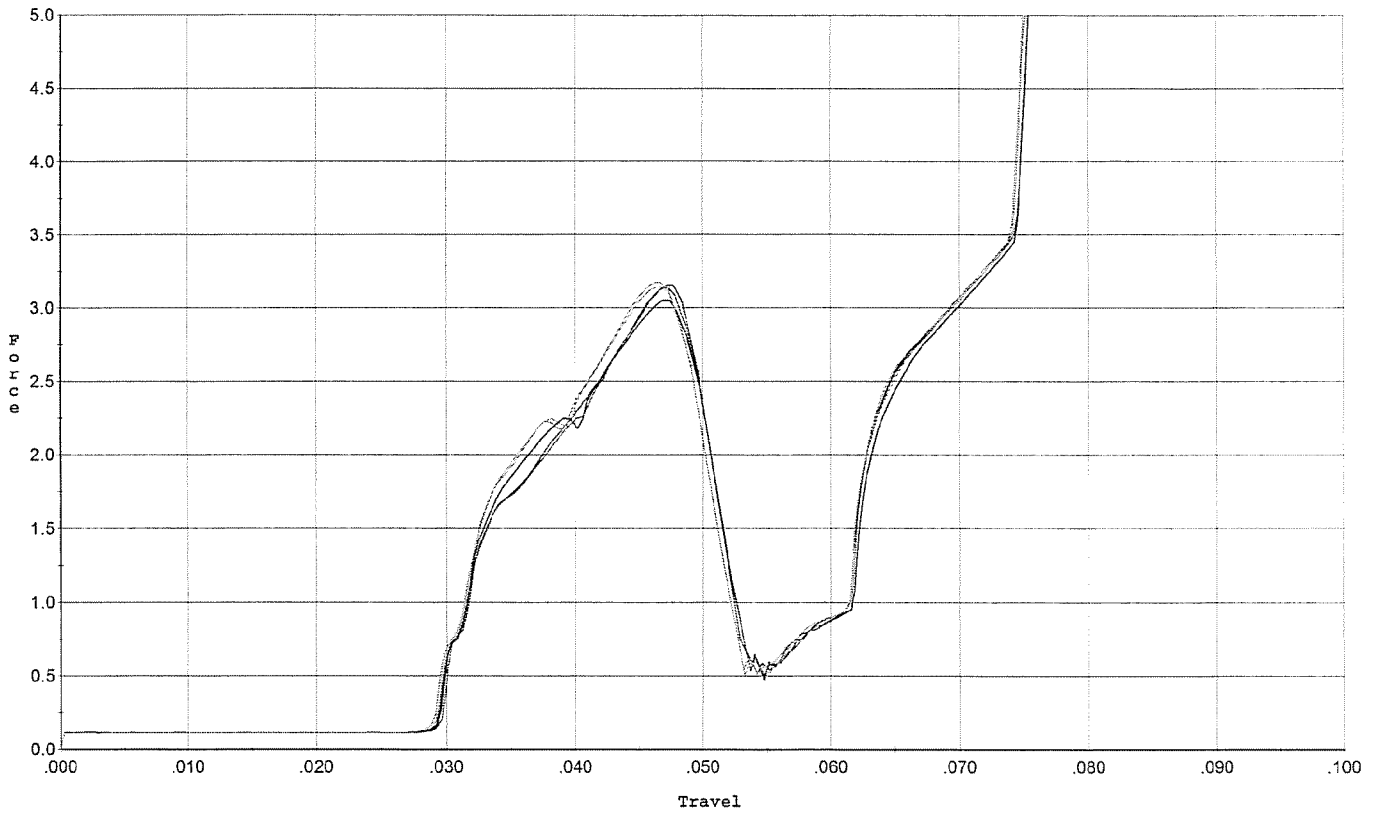
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.774	0.050	0.030	0.032	0.044		Set Trigger
2	2.707	0.050	0.030	0.032	0.043		Set Trigger
3	2.812	0.051	0.030	0.032	0.045		Set Trigger
4	2.771	0.049	0.030	0.032	0.043		Set Trigger
5	2.745	0.050	0.030	0.032	0.043		Set Trigger

A-2-76

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



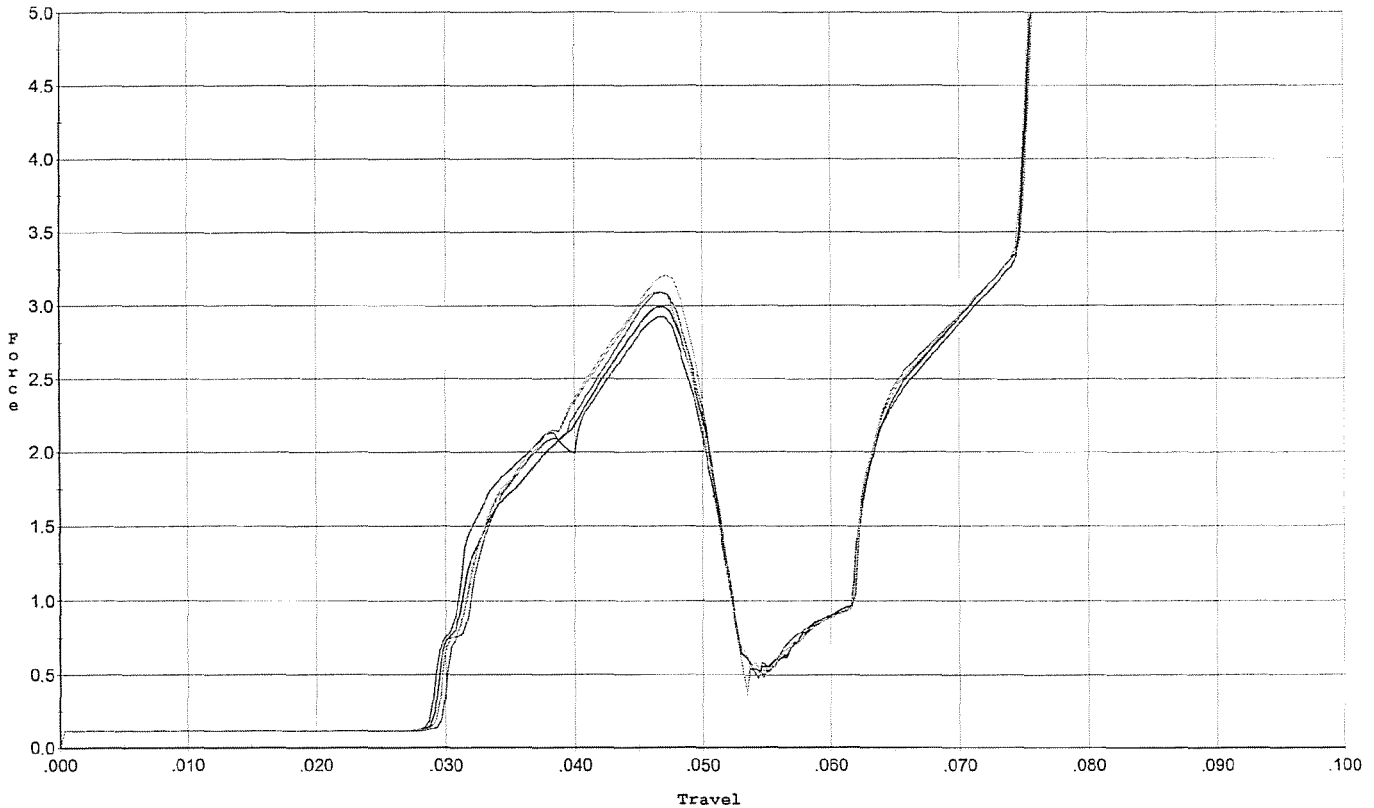
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.153	0.050	0.030	0.030	0.049		Set Trigger
2	3.053	0.050	0.030	0.031	0.049		Set Trigger
3	3.134	0.050	0.030	0.031	0.048		Set Trigger
4	3.142	0.049	0.029	0.031	0.049		Set Trigger
5	3.174	0.049	0.029	0.031	0.049		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



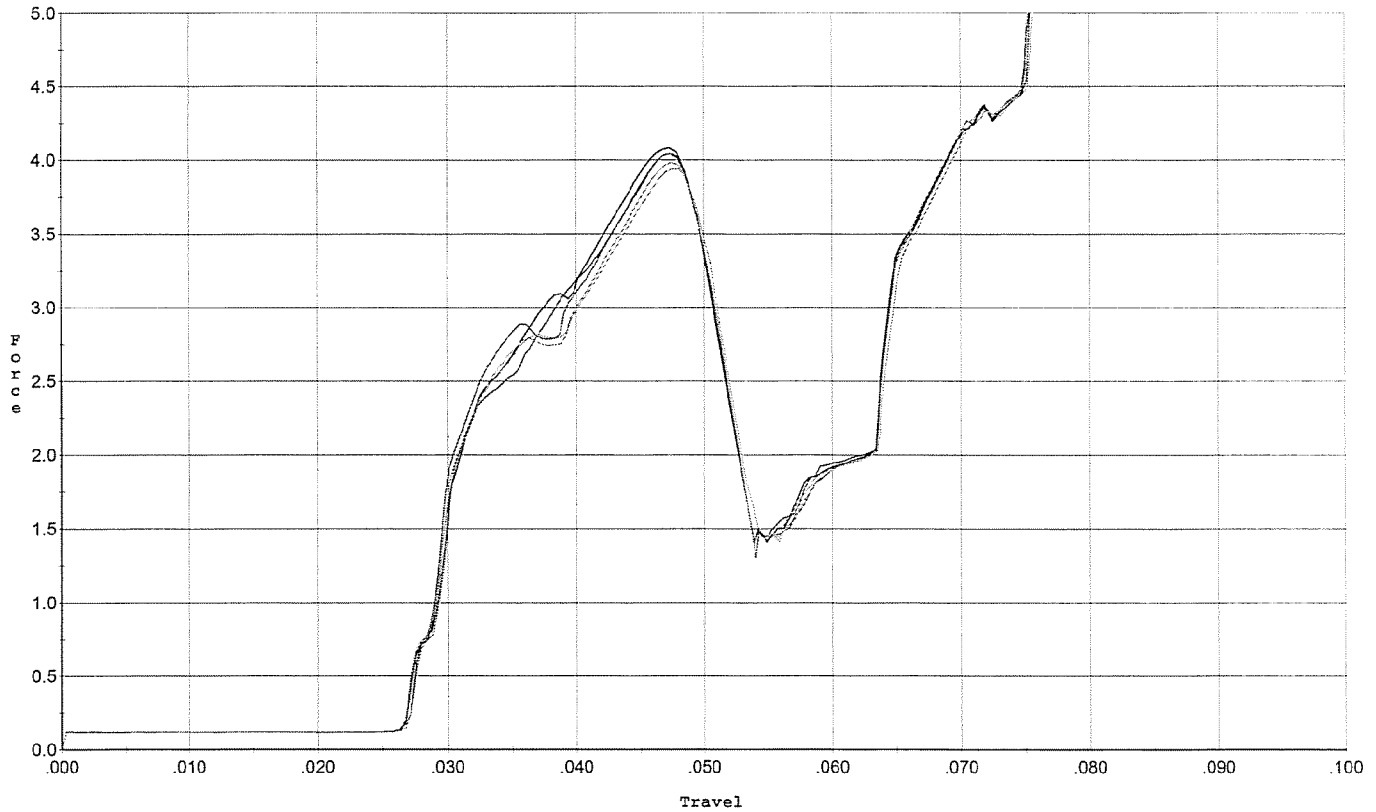
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.923	0.051	0.029	0.031	0.049		Set Trigger
2	2.993	0.050	0.029	0.031	0.048		Set Trigger
3	3.093	0.050	0.030	0.031	0.048		Set Trigger
4	3.207	0.050	0.030	0.031	0.050		Set Trigger
5	3.095	0.051	0.029	0.031	0.050		Set Trigger

A 306

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



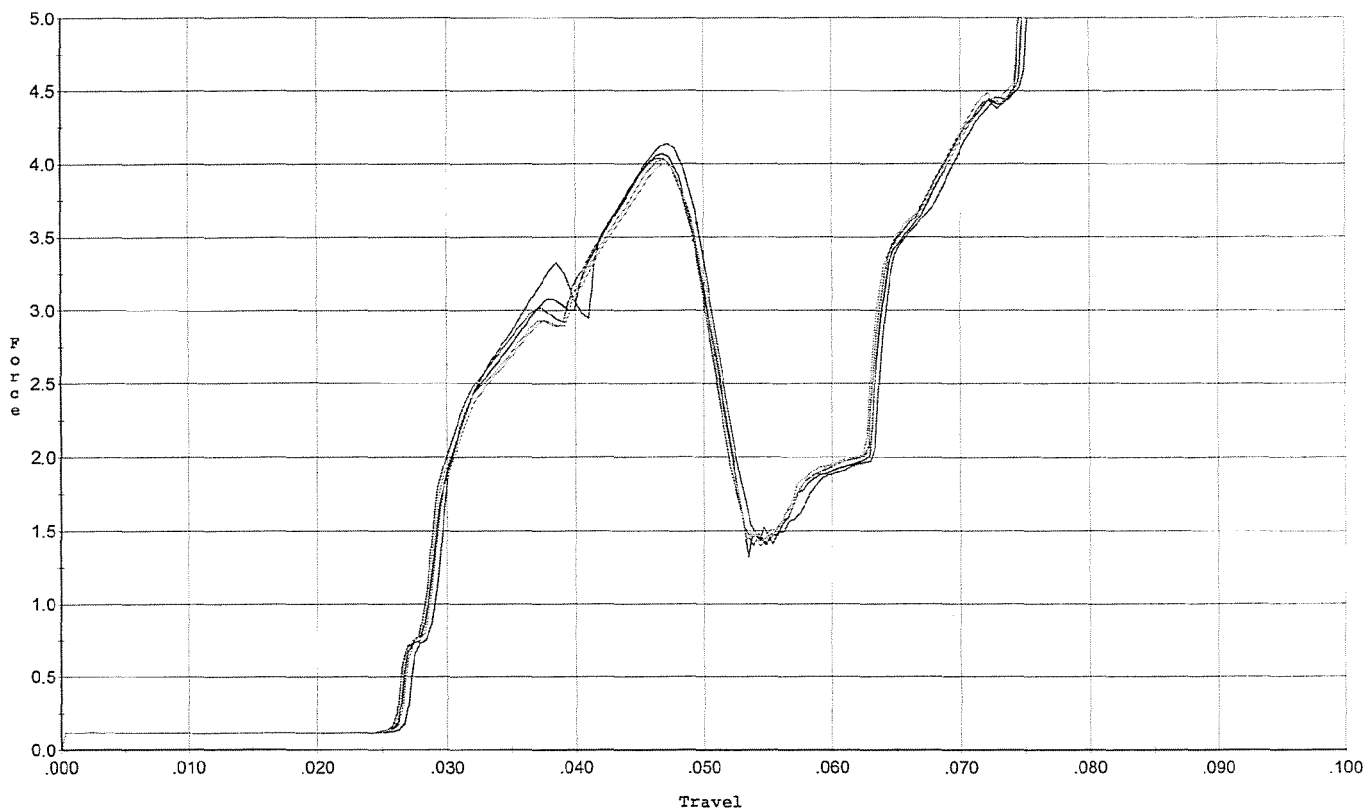
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.046	0.051	0.027	0.029	0.072		Set Trigger
2	4.083	0.050	0.027	0.029	0.071		Set Trigger
3	4.042	0.051	0.027	0.028	0.074		Set Trigger
4	3.940	0.050	0.027	0.029	0.070		Set Trigger
5	3.982	0.051	0.027	0.028	0.072		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



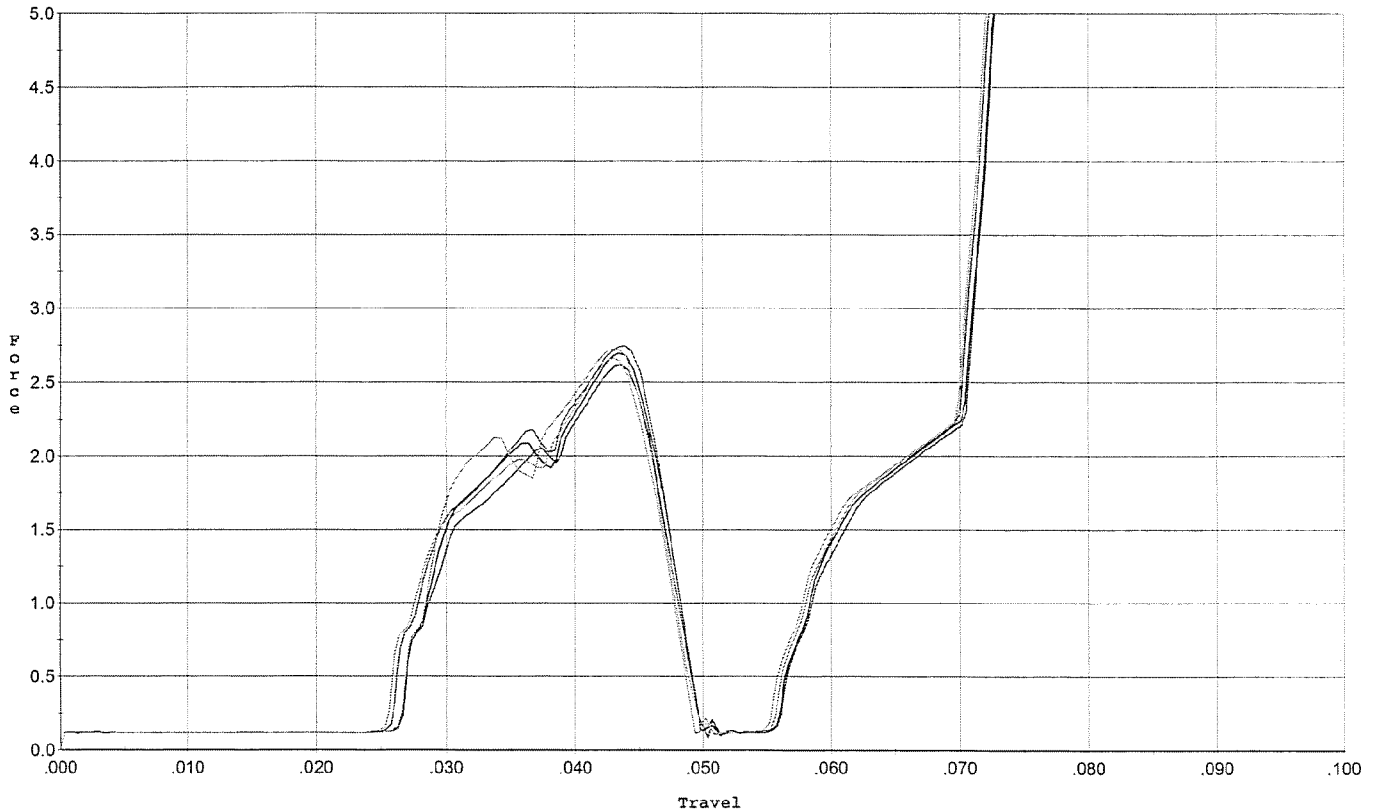
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.141	0.050	0.027	0.029	0.072		Set Trigger
2	4.072	0.051	0.026	0.028	0.074		Set Trigger
3	4.040	0.049	0.026	0.028	0.071		Set Trigger
4	4.001	0.050	0.027	0.029	0.071		Set Trigger
5	4.027	0.049	0.026	0.028	0.070		Set Trigger

A-405

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



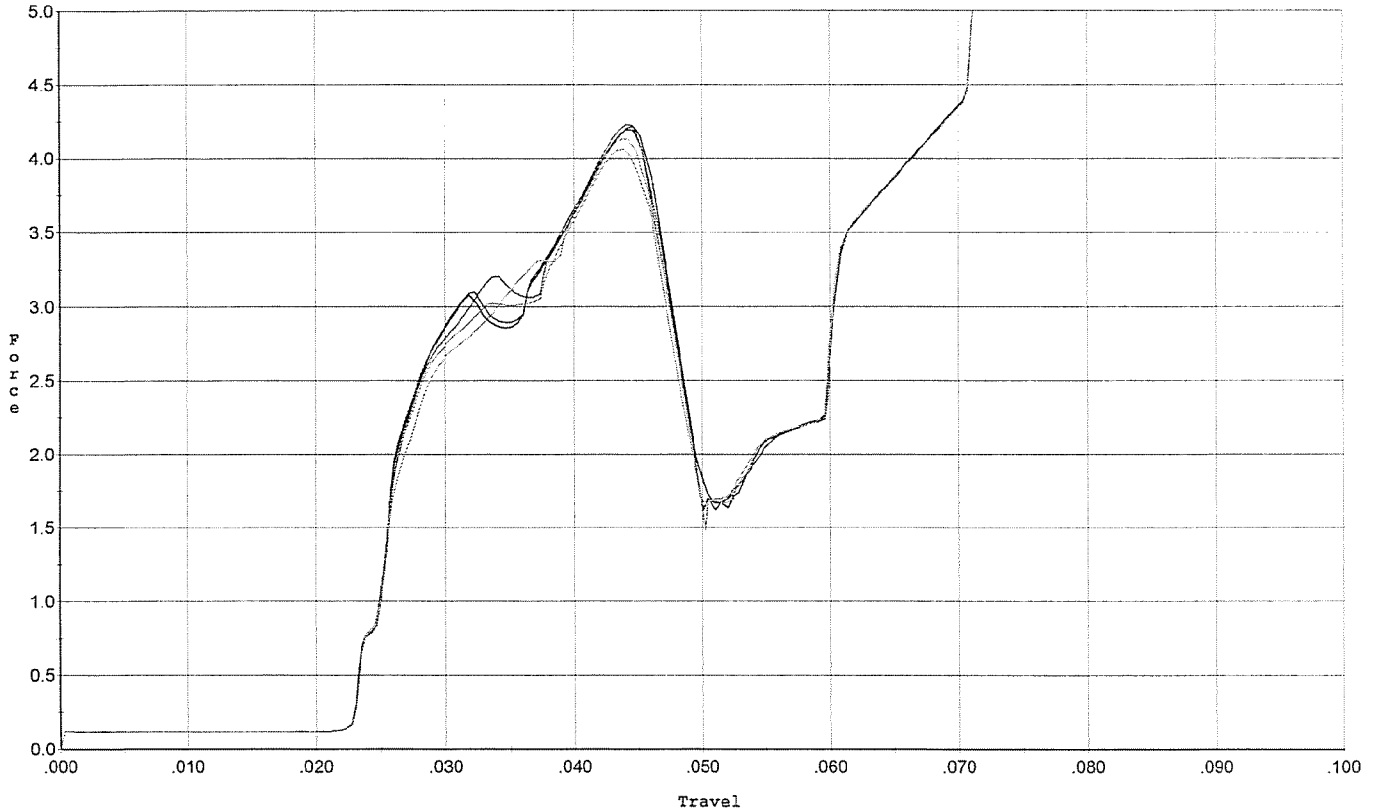
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.046	0.027	0.031	0.040		Set Trigger
2	2.696	0.047	0.027	0.031	0.043		Set Trigger
3	2.746	0.047	0.026	0.031	0.044		Set Trigger
4	2.664	0.046	0.026	0.031	0.043		Set Trigger
5	2.725	0.046	0.027	0.030	0.043		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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	4.196	0.047	0.023	0.026	0.075		Set Trigger
2	4.219	0.046	0.023	0.026	0.074		Set Trigger
3	4.232	0.047	0.023	0.026	0.076		Set Trigger
4	4.132	0.047	0.023	0.026	0.074		Set Trigger
5	4.060	0.046	0.023	0.026	0.071		Set Trigger

A-4-16