

G 6848446

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

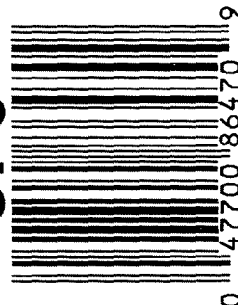
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6848446

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6848446

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		6-17-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR	6/20/09	SP
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	SP
540	APPLY COATINGS (BARREL ACTION)		7/25	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-15-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-15-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-15-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-18-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

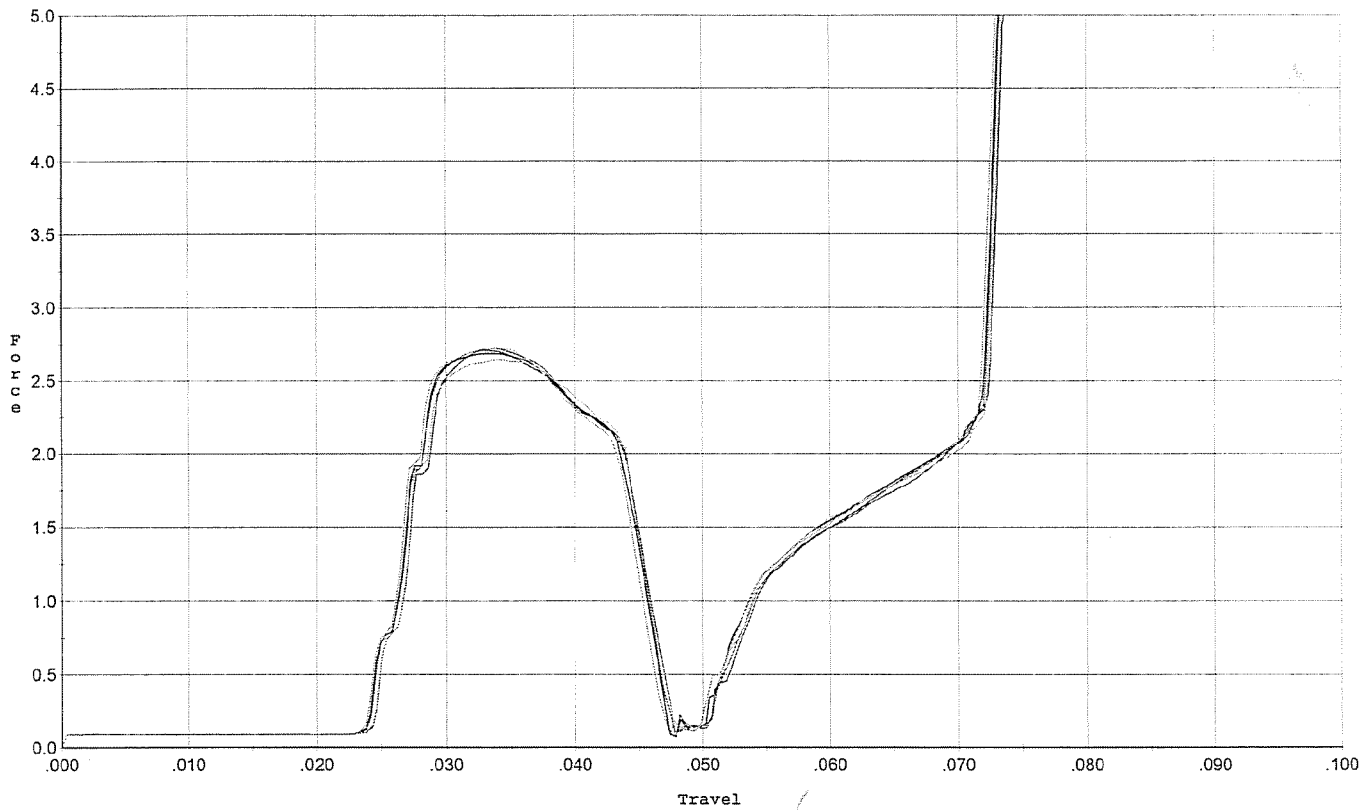
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	8-21-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	8-21-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-21-09	LN
	J) ASSEMBLE STOCK		8-21-09	RJZ
	K) ASSEMBLE SWIVEL STUDS		8-21-09	LN
	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	8-20-09	SP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-20-09	
660	INSPECT FOR LIVE AMMO		8-20-09	SP
670	FINAL INSPECTION A) HEADSPACE		8-21-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>257</u> <u>267</u> <u>264</u> <u>265</u> <u>272</u>	8/21/09	RR
	C) FUNCTION		8-21-09	LN
690	PACK		8/21/09	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



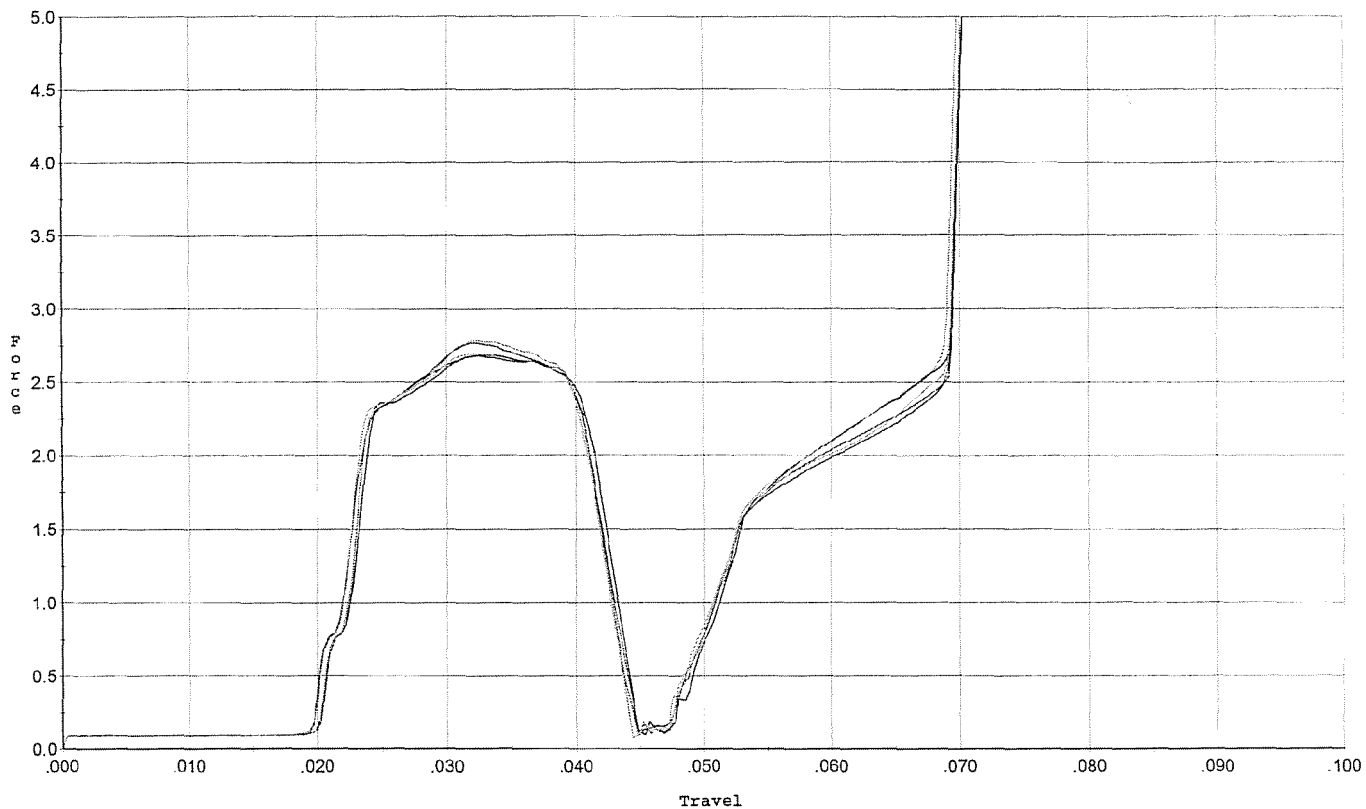
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.707	0.044	0.025	0.032	0.045		Set Trigger
2	2.688	0.045	0.024	0.032	0.047		Set Trigger
3	2.722	0.044	0.024	0.032	0.046		Set Trigger
4	2.643	0.044	0.025	0.032	0.045		Set Trigger
5	2.723	0.044	0.024	0.032	0.046		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: ~~2.5~~ lbs after 50 cycles +/- .50 lb



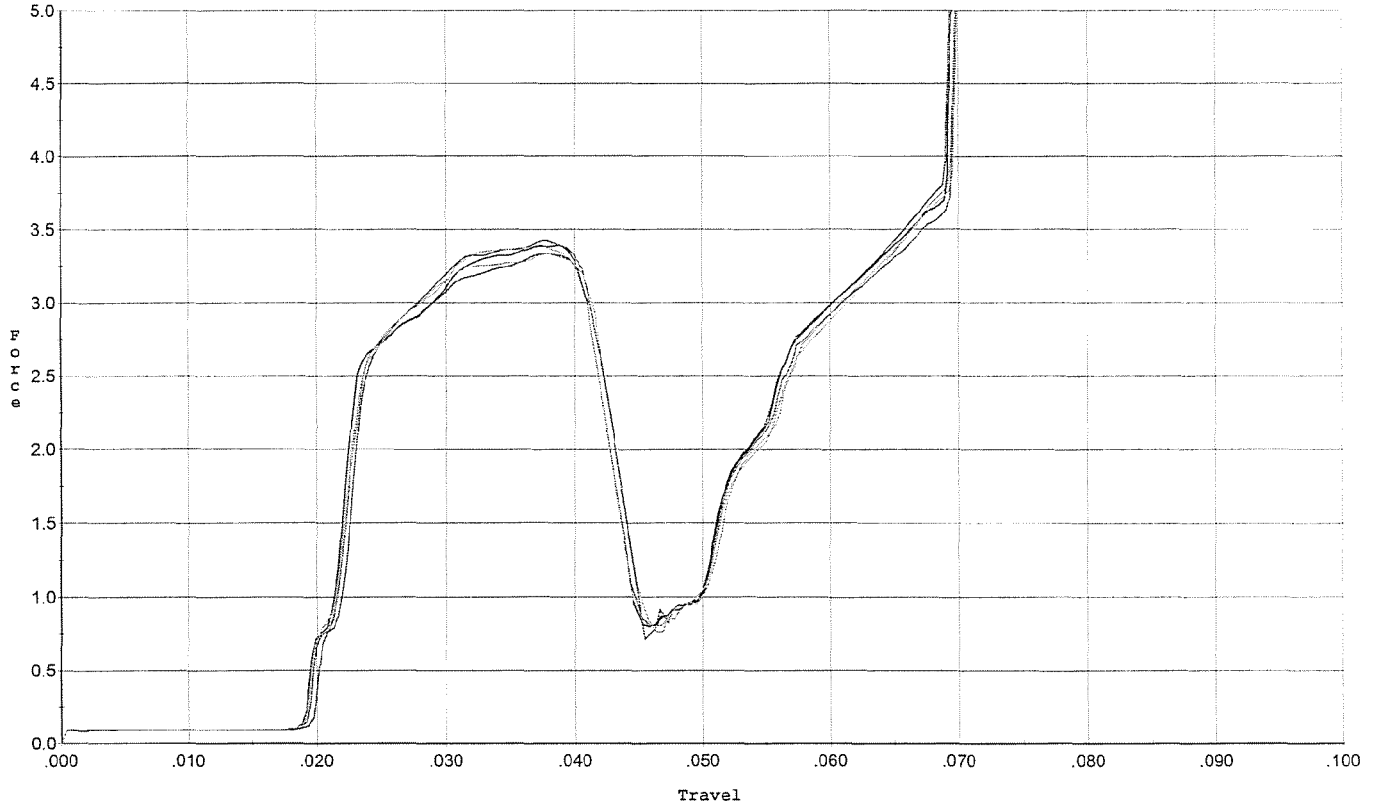
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.680	0.041	0.020	0.032	0.049		Set Trigger
2	2.682	0.041	0.020	0.031	0.050		Set Trigger
3	2.766	0.041	0.020	0.032	0.049		Set Trigger
4	2.693	0.041	0.020	0.031	0.050		Set Trigger
5	2.783	0.041	0.020	0.032	0.050		Set Trigger

A-2.72

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



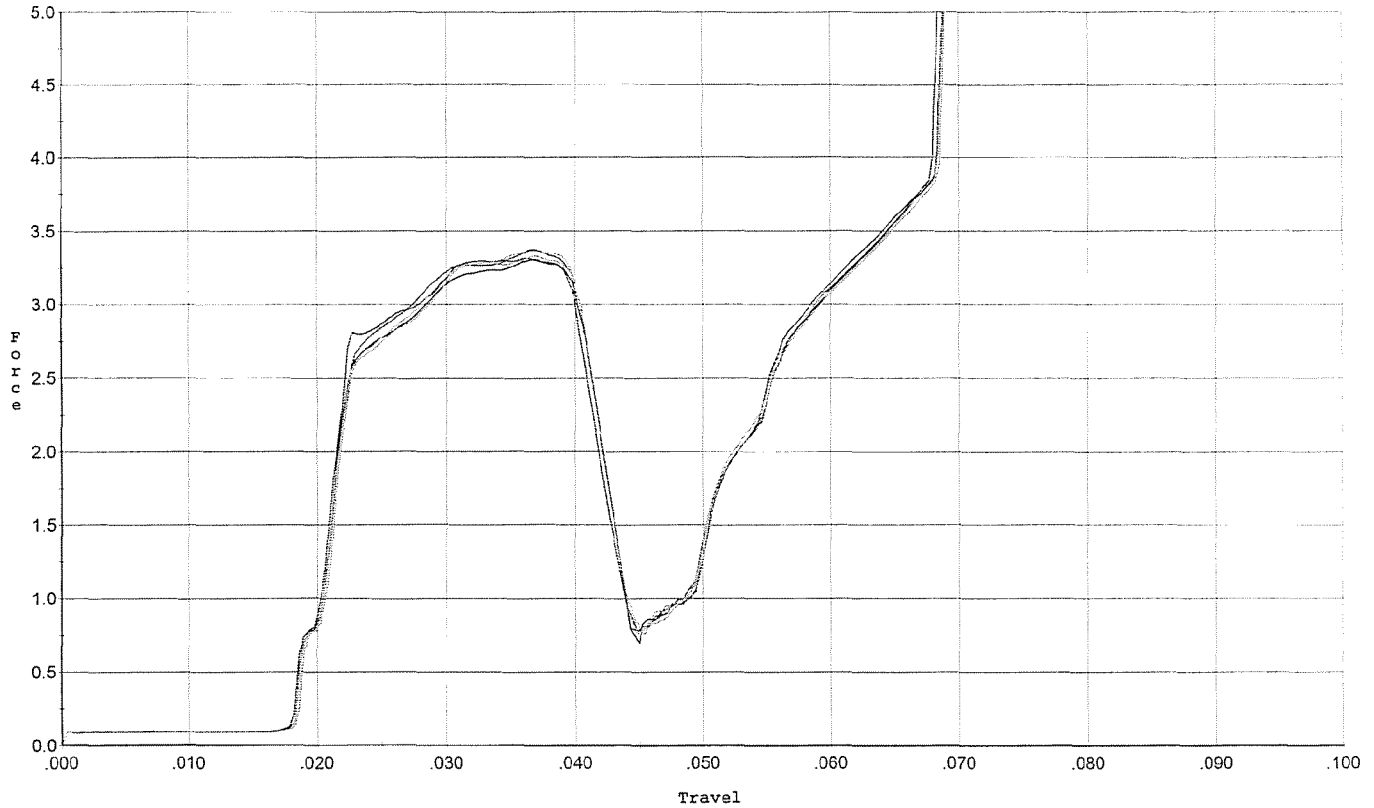
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.338	0.041	0.020	0.029	0.061		Set Trigger
2	3.393	0.041	0.019	0.029	0.063		Set Trigger
3	3.424	0.042	0.020	0.029	0.065		Set Trigger
4	3.399	0.041	0.019	0.029	0.063		Set Trigger
5	3.336	0.042	0.019	0.029	0.064		Set Trigger

A-3-37

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



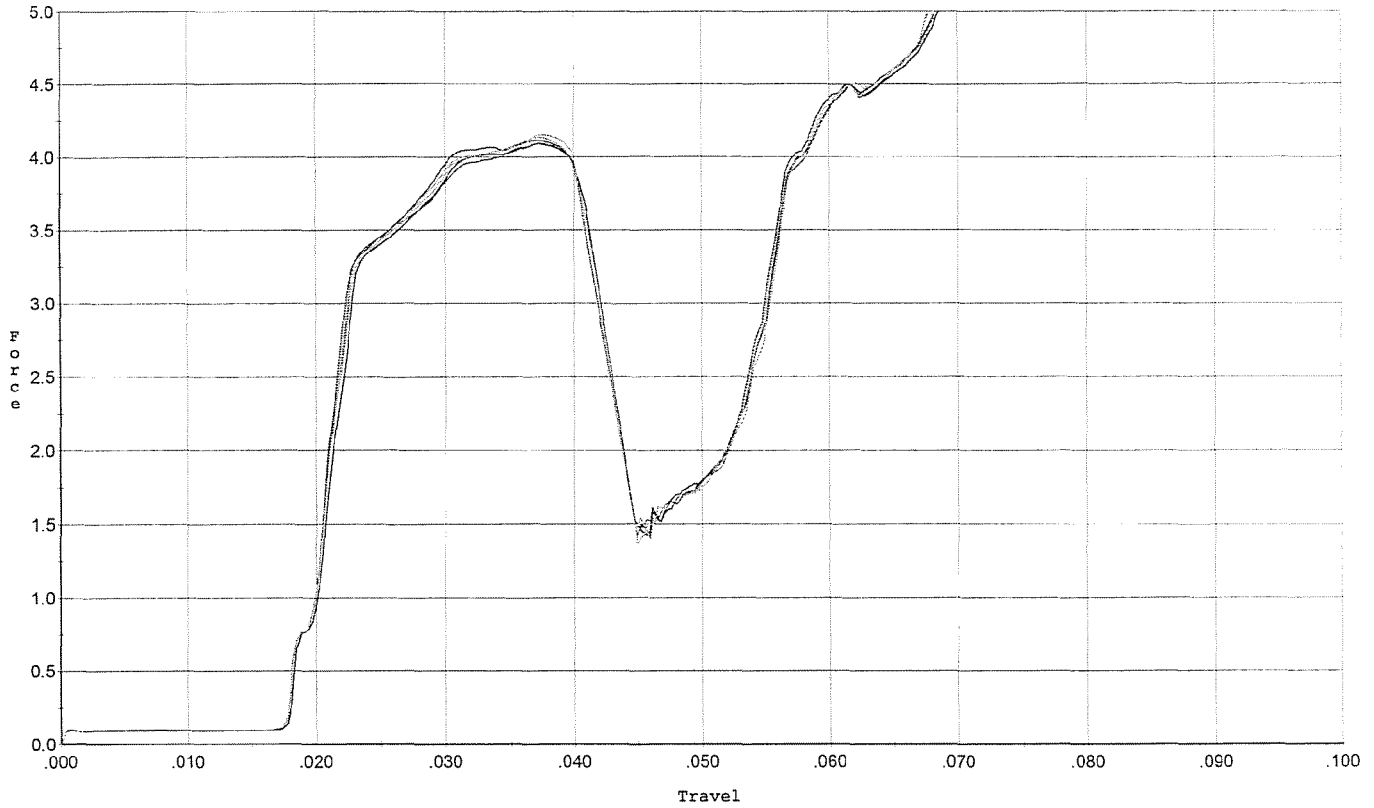
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.315	0.040	0.018	0.029	0.062		Set Trigger
2	3.307	0.041	0.018	0.029	0.063		Set Trigger
3	3.370	0.040	0.018	0.029	0.064		Set Trigger
4	3.334	0.040	0.018	0.029	0.063		Set Trigger
5	3.363	0.040	0.019	0.029	0.063		Set Trigger

A-3-33

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



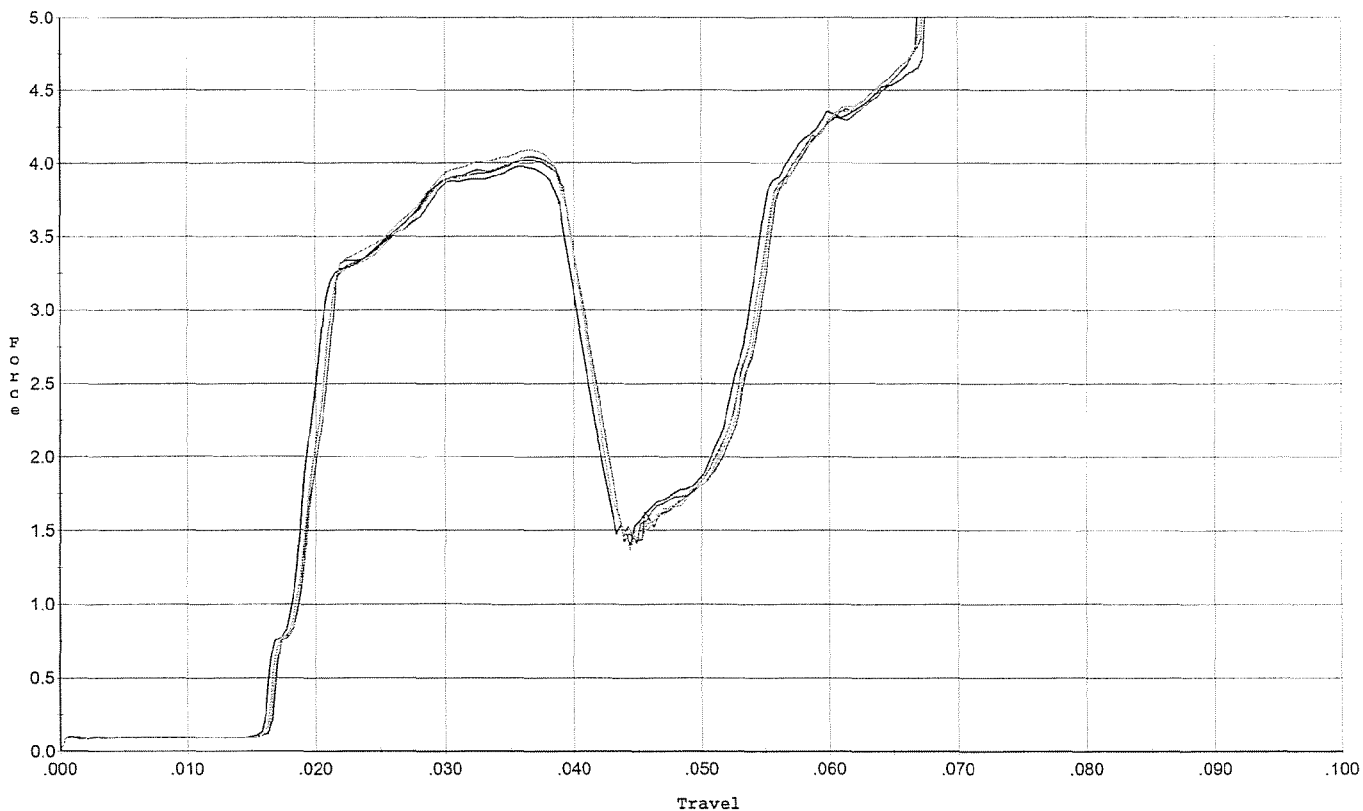
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.042	0.018	0.026	0.082		Set Trigger
2	4.093	0.041	0.018	0.027	0.078		Set Trigger
3	4.092	0.042	0.018	0.026	0.081		Set Trigger
4	4.153	0.041	0.018	0.026	0.080		Set Trigger
5	4.136	0.040	0.018	0.027	0.077		Set Trigger

A-4-11

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



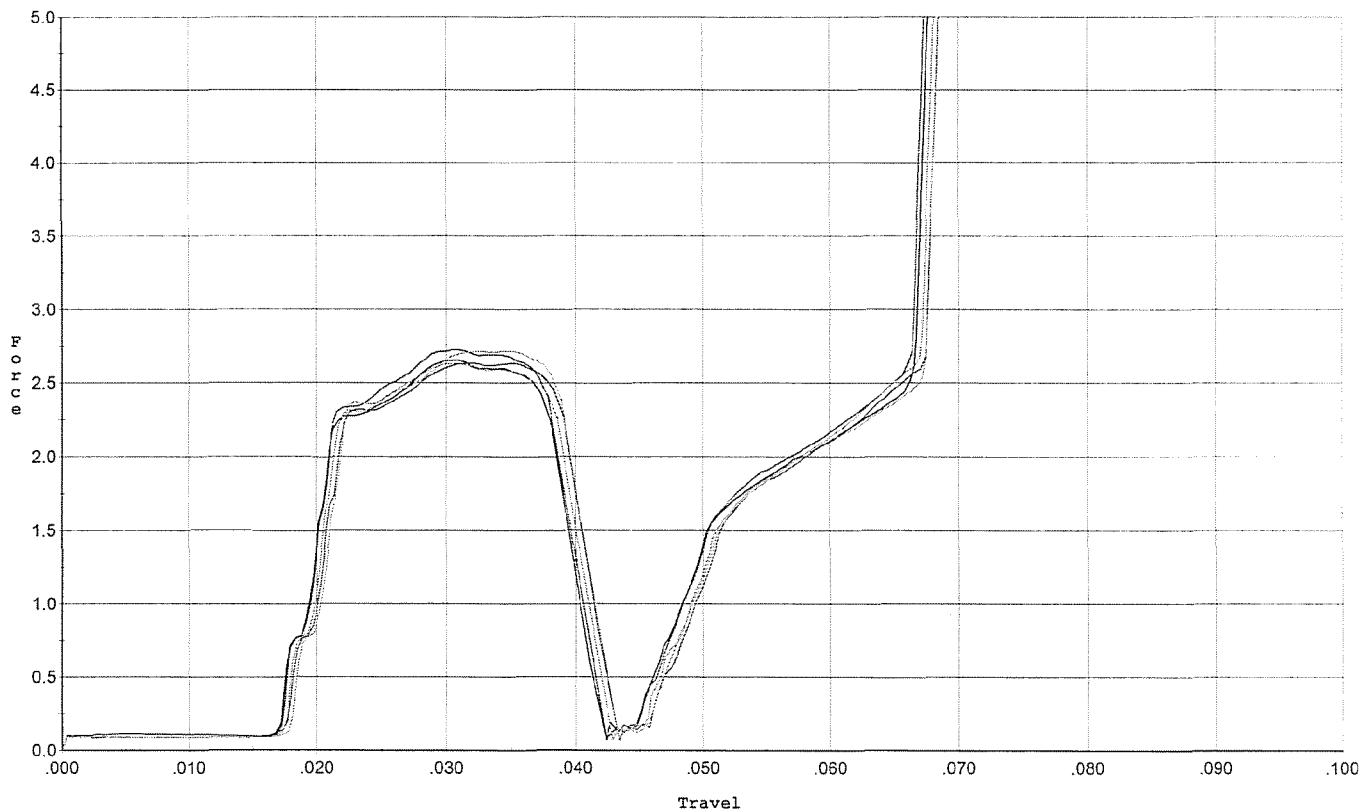
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.019	0.039	0.017	0.027	0.076		Set Trigger
2	3.977	0.039	0.016	0.027	0.076		Set Trigger
3	4.045	0.039	0.017	0.027	0.076		Set Trigger
4	4.042	0.039	0.016	0.027	0.077		Set Trigger
5	4.088	0.039	0.017	0.027	0.077		Set Trigger

A-4.03

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



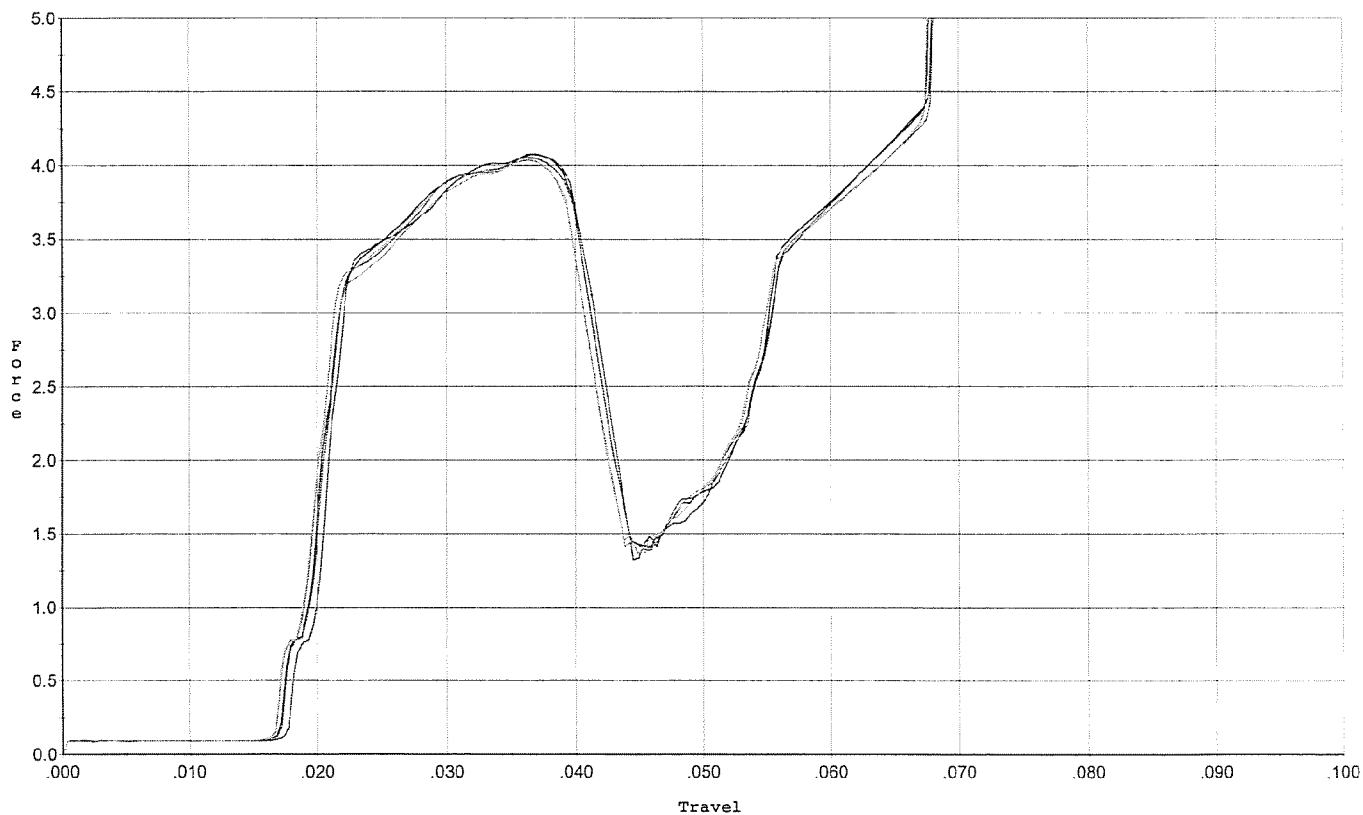
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.726	0.040	0.017	0.031	0.052		Set Trigger
2	2.653	0.038	0.017	0.032	0.048		Set Trigger
3	2.634	0.039	0.018	0.031	0.049		Set Trigger
4	2.716	0.039	0.018	0.031	0.049		Set Trigger
5	2.630	0.039	0.018	0.032	0.048		Set Trigger

A-2-67

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 ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.080	0.041	0.018	0.026	0.079		Set Trigger
2	4.077	0.040	0.017	0.027	0.077		Set Trigger
3	4.056	0.040	0.017	0.027	0.076		Set Trigger
4	4.042	0.039	0.017	0.027	0.076		Set Trigger
5	4.036	0.039	0.017	0.027	0.075		Set Trigger

A. 4.05