

G677 8904

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



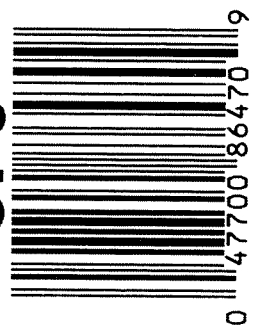
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6778904

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 677 8904

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	JPD
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	JPD
460	CHECK HEADSPACE		8-20-08	JPD
470	DIS-ASSEMBLE ACTION		8-20-08	JPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8/21/08	BSH
475	DRILL AND TAP SIGHT HOLES	AUG 22 2008	8-21-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BSH	8-22-08	BSH
490	MAGNAFLUX BOLT		8/22/08	MR
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC		8/22/08	DG
542	APPLY COATINGS (BARREL ACTION)		8-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9-25-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-25-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-25-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-20-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

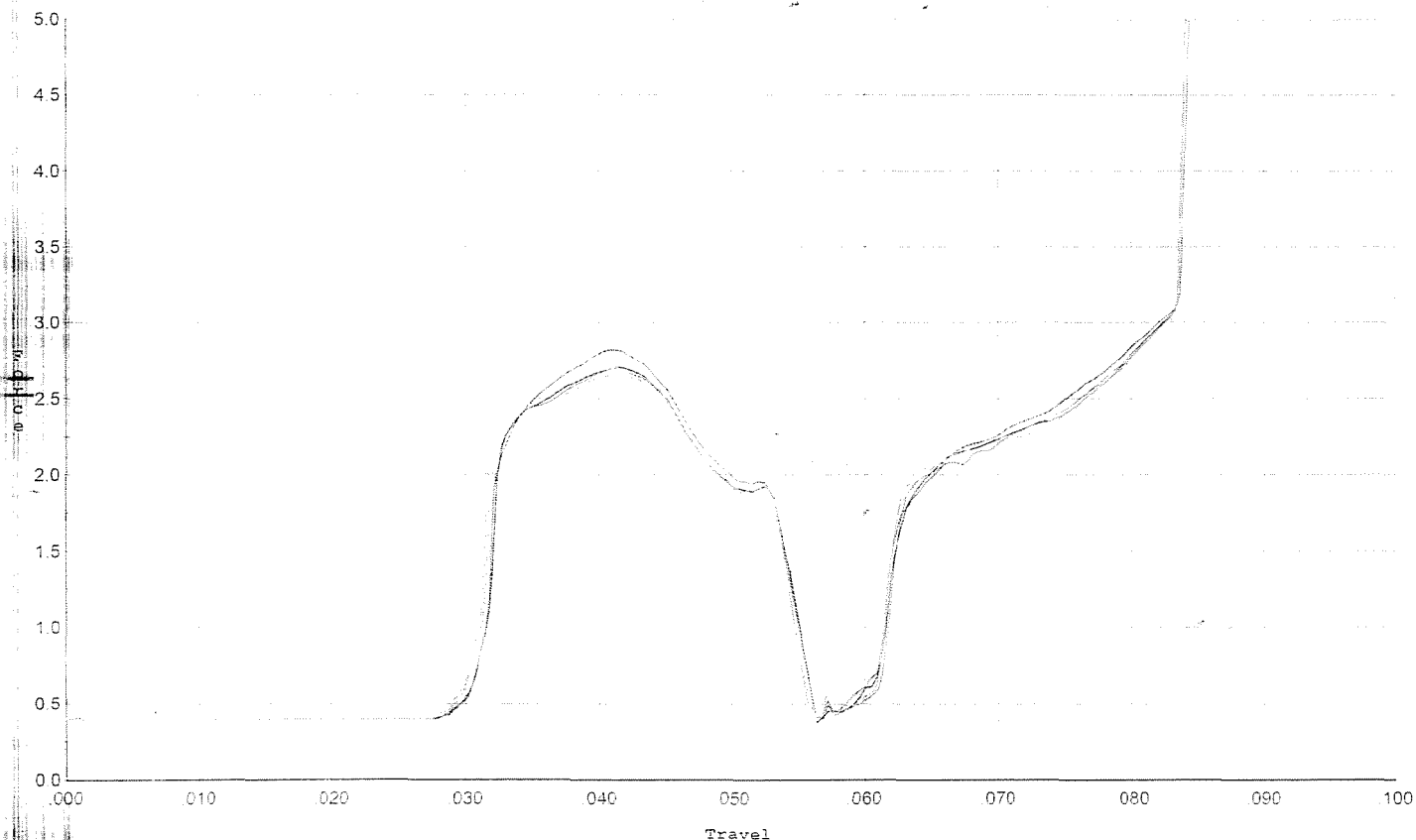
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	2-16-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-16-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	2-16-09	LJ
	J) ASSEMBLE STOCK		1-20-09	RJ
	K) ASSEMBLE SWIVEL STUDS		2-16-09	LJ
	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	2-12-09	K
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-12-09	NW
670	FINAL INSPECTION A) HEADSPACE		2-16-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.65</u> <u>2.65</u> <u>2.65</u> <u>2.57</u>	2-13-09	NW
	C) FUNCTION		2-16-09	LJ
690	PACK		2/18/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/19/2009

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



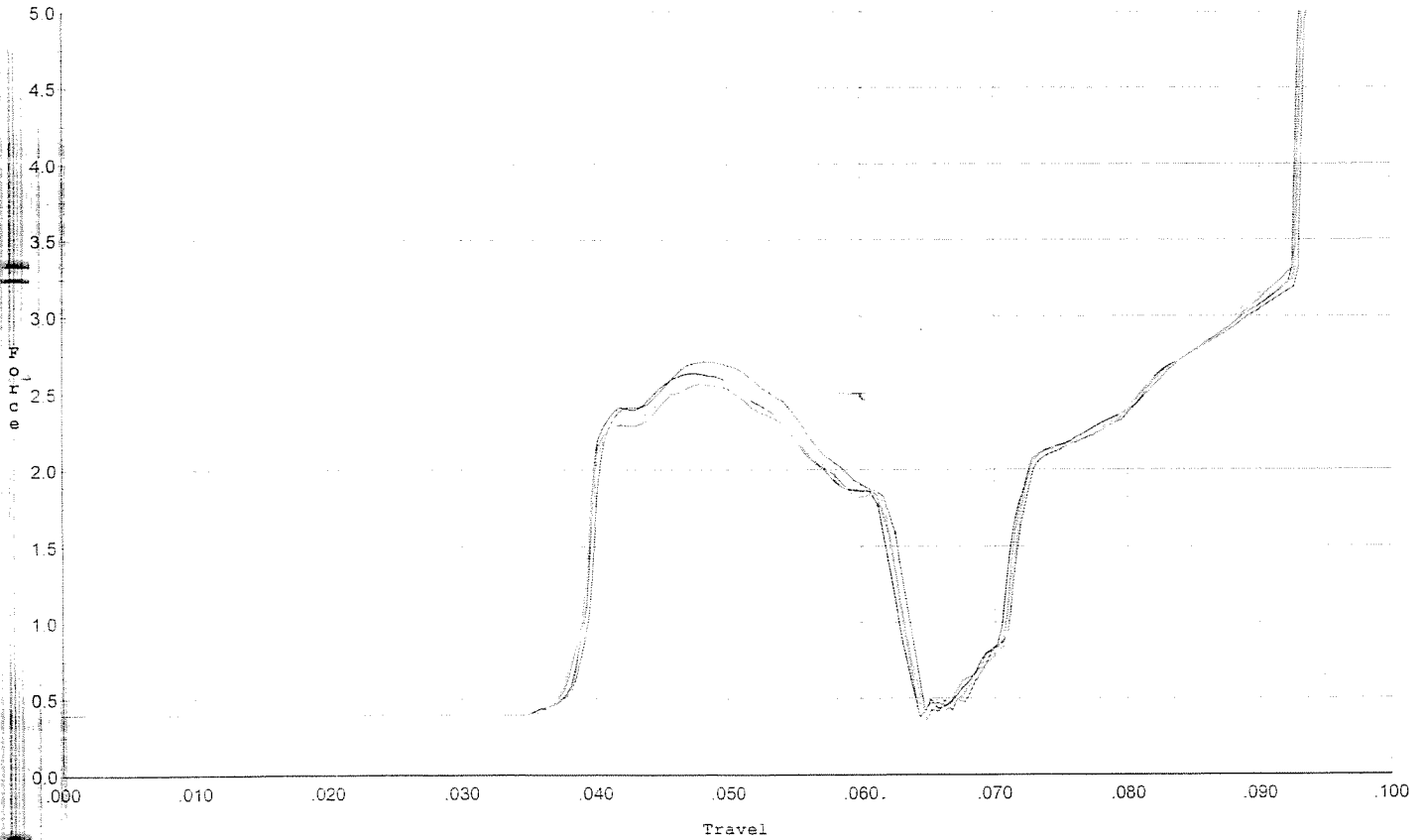
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.819	0.053	0.031	0.034	0.065		Set Trigger
2	2.707	0.054	0.031	0.034	0.065		Set Trigger
3	2.697	0.055	0.031	0.034	0.065		Set Trigger
4	2.701	0.053	0.029	0.034	0.064		Set Trigger
5	2.651	0.053	0.030	0.034	0.064		Set Trigger

A.2.71

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 20 cycles+/- .50 lb



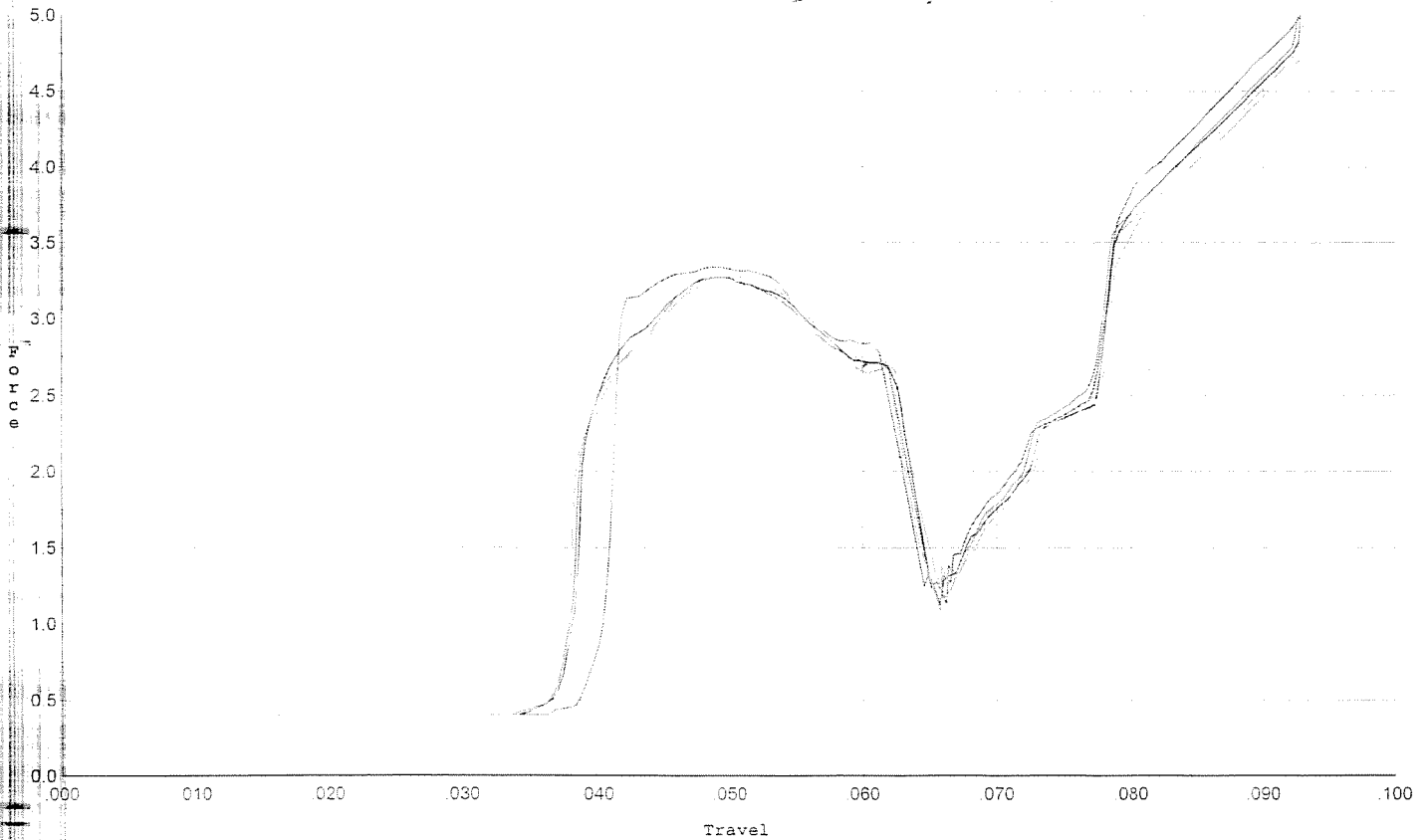
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.708	0.063	0.039	0.038	0.070		Set Trigger
2	2.631	0.061	0.038	0.038	0.067		Set Trigger
3	2.563	0.062	0.038	0.038	0.067		Set Trigger
4	2.592	0.062	0.038	0.038	0.067		Set Trigger
5	2.601	0.062	0.038	0.038	0.067		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

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



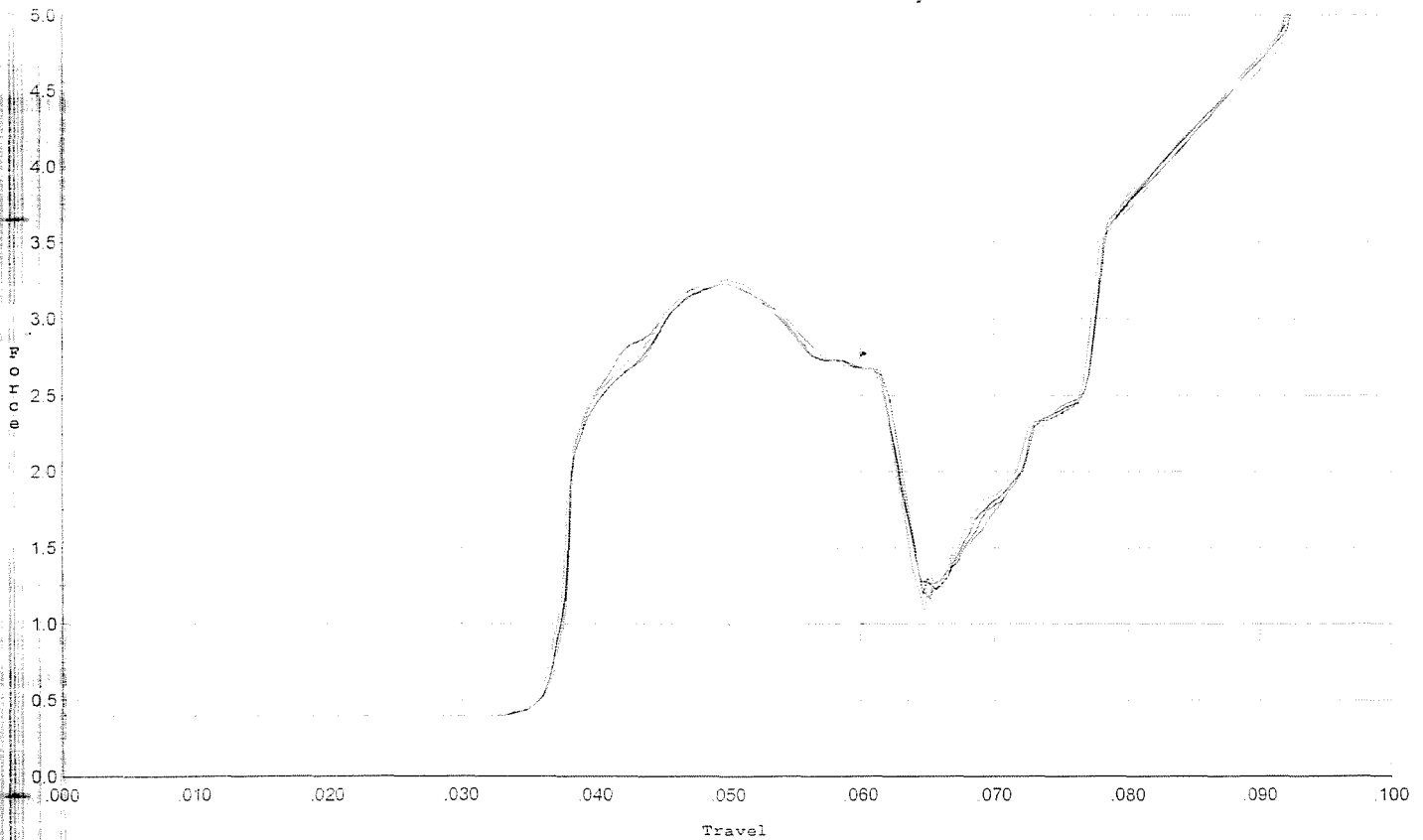
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.340	0.063	0.039	0.036	0.084		Set Trigger
2	3.272	0.063	0.037	0.035	0.087		Set Trigger
3	3.271	0.063	0.037	0.035	0.088		Set Trigger
4	3.253	0.062	0.037	0.036	0.086		Set Trigger
5	3.287	0.062	0.037	0.036	0.086		Set Trigger

A-3.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

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



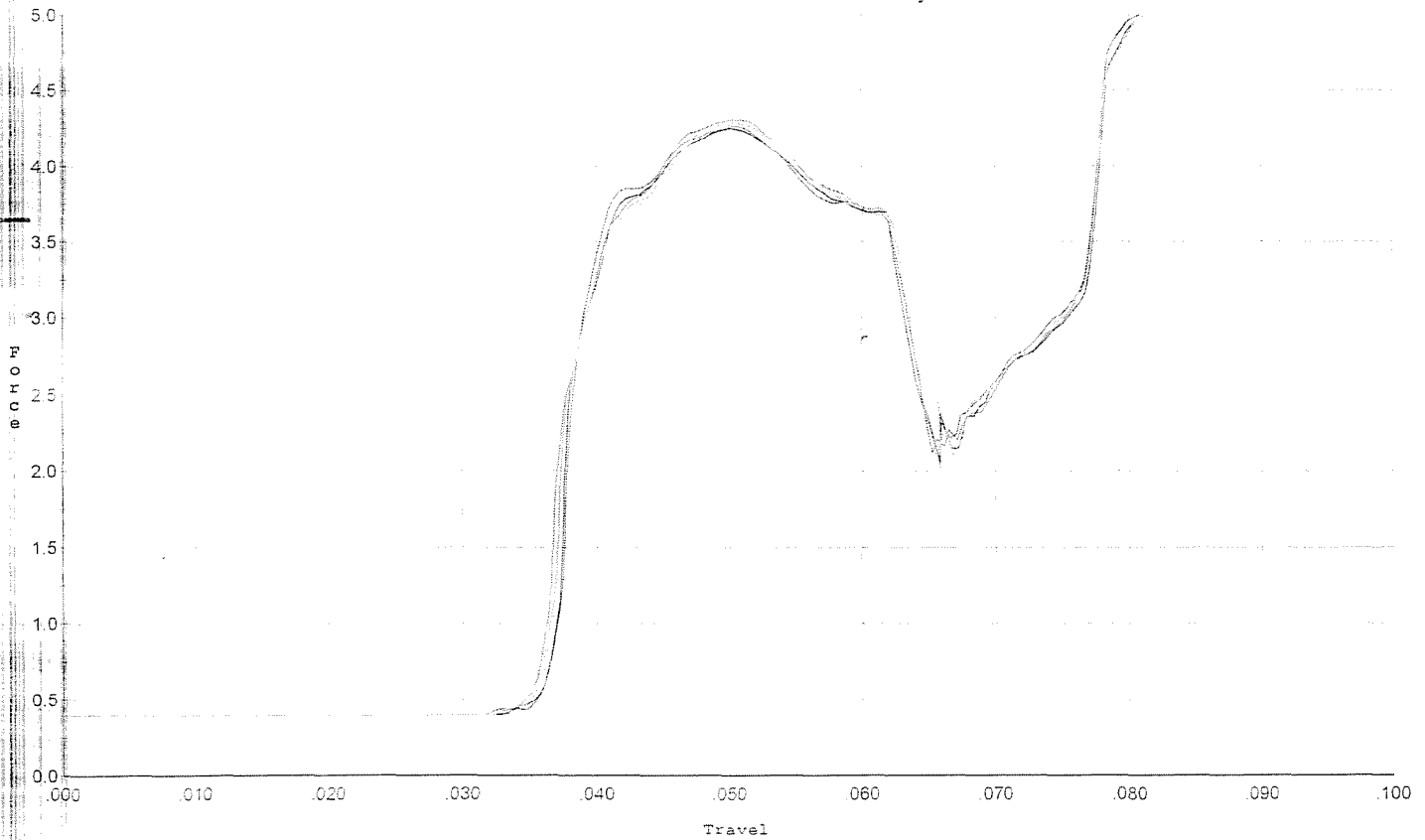
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.261	0.063	0.037	0.035	0.087		Set Trigger
2	3.228	0.062	0.037	0.036	0.084		Set Trigger
3	3.228	0.062	0.037	0.035	0.085		Set Trigger
4	3.236	0.062	0.036	0.035	0.084		Set Trigger
5	3.244	0.062	0.036	0.036	0.084		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 1/19/2009

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



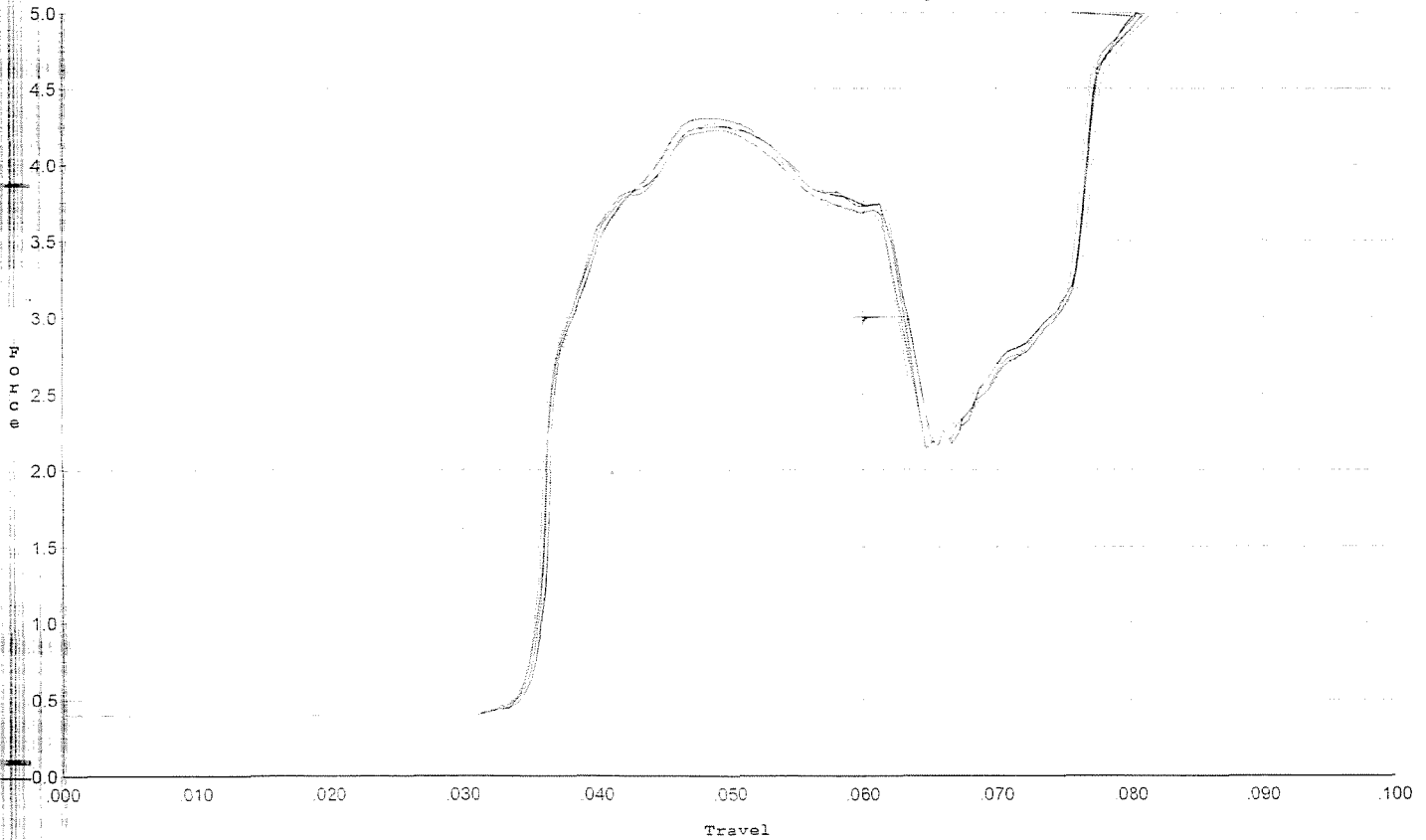
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.263	0.062	0.036	0.032	0.111		Set Trigger
2	4.249	0.063	0.036	0.032	0.112		Set Trigger
3	4.306	0.063	0.036	0.032	0.115		Set Trigger
4	4.292	0.063	0.036	0.032	0.113		Set Trigger
5	4.265	0.063	0.036	0.032	0.113		Set Trigger

A.4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

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



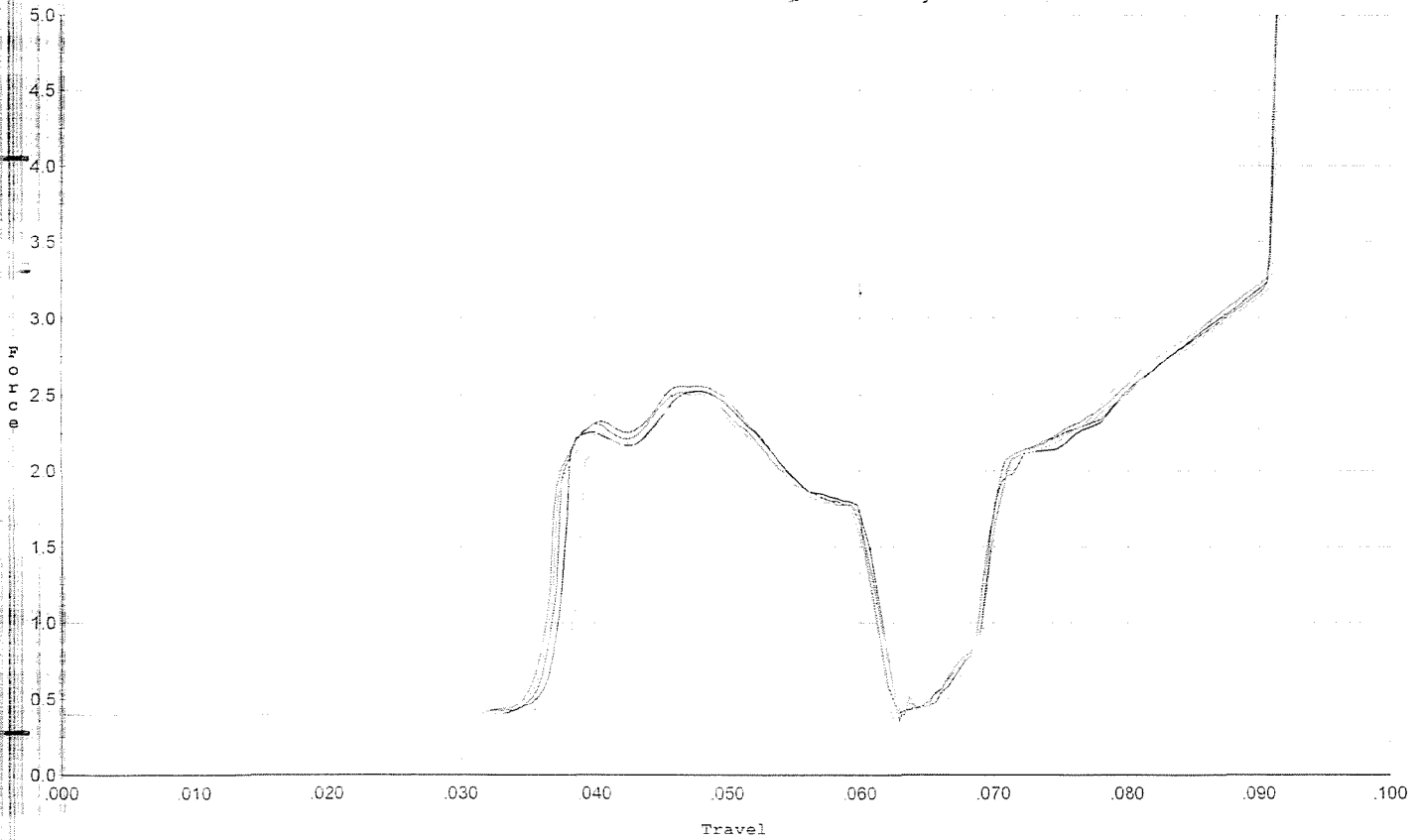
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.304	0.062	0.035	0.032	0.116		Set Trigger
2	4.255	0.063	0.035	0.032	0.117		Set Trigger
3	4.228	0.061	0.035	0.033	0.112		Set Trigger
4	4.248	0.062	0.035	0.033	0.114		Set Trigger
5	4.285	0.062	0.035	0.033	0.114		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

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



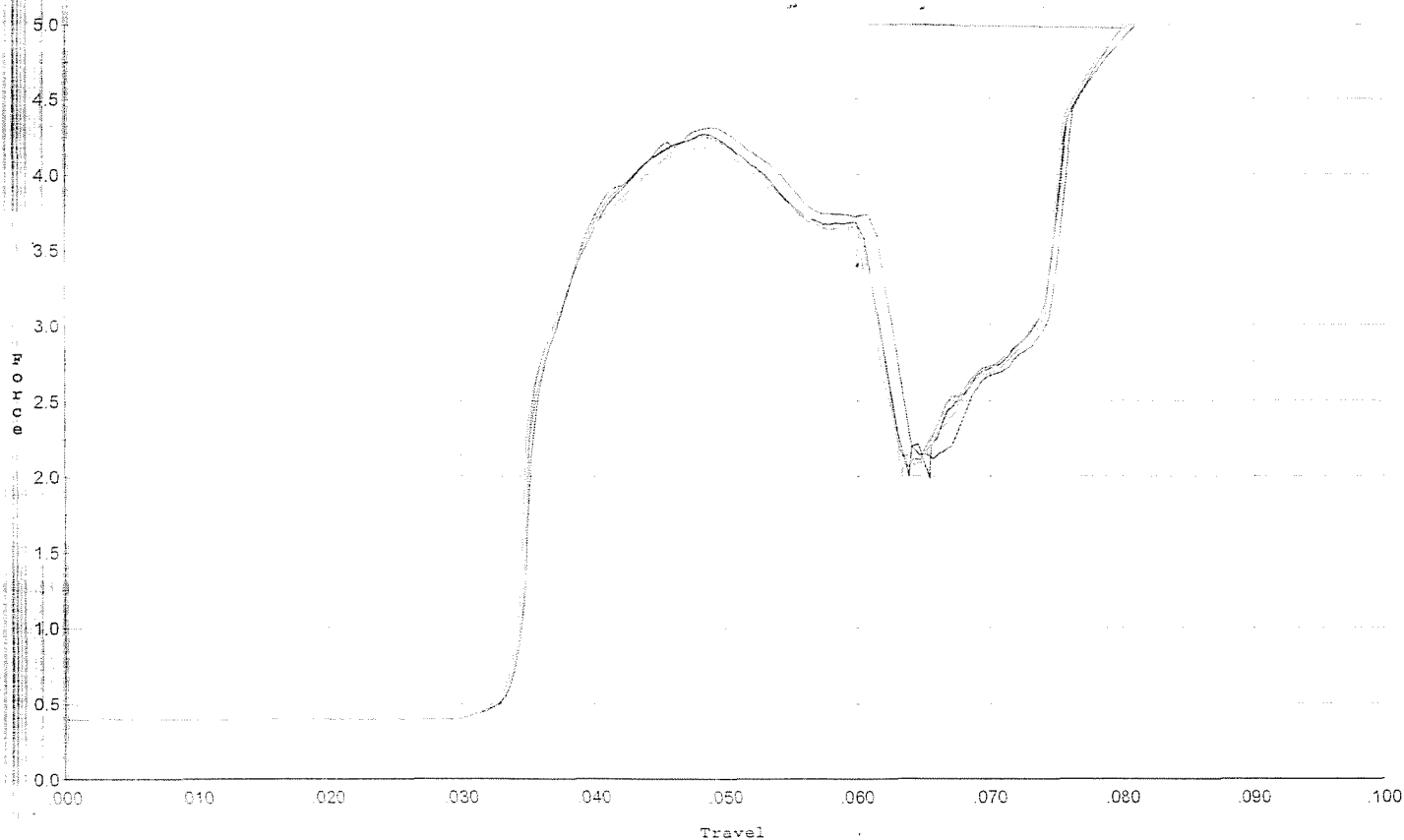
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.557	0.061	0.036	0.037	0.067		Set Trigger
2	2.524	0.061	0.037	0.037	0.065		Set Trigger
3	2.520	0.060	0.035	0.037	0.066		Set Trigger
4	2.508	0.060	0.038	0.038	0.062		Set Trigger
5	2.453	0.061	0.036	0.037	0.066		Set Trigger

A-2-S1

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 1/19/2009

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	4.309	0.062	0.034	0.032	0.117		Set Trigger
2	4.265	0.061	0.034	0.033	0.112		Set Trigger
3	4.247	0.061	0.034	0.033	0.113		Set Trigger
4	4.177	0.061	0.034	0.033	0.111		Set Trigger
5	4.175	0.060	0.033	0.033	0.110		Set Trigger

A-4.23