

Q6794490

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

proof of purchase



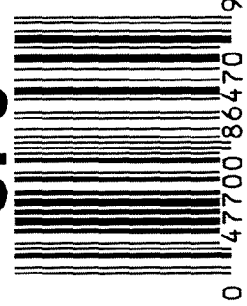
owner registration sticker



ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6794490

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794490

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		1-20-09	SP
430	ASSEMBLE TO STOCK		1-20-09	SP
440	PROOF		1-20-09	SP
460	CHECK HEADSPACE		1-20-09	SP
470	DIS-ASSEMBLE ACTION		1-20-09	SP
472	SERIALIZE BOLT HANDLE		1-21-09	RT
475	DRILL AND TAP SIGHT HOLES		1-21-09	SP
480	MAGNAFLUX BBL ACTION	(A)	1/23/09	(A)
490	MAGNAFLUX BOLT		1/23/09	mrl
500	ROLLMARK CALIBER		1/24/09	RT
520	GOFF BLAST BBL / REC		1/24/09	DR
542	APPLY COATINGS (BARREL ACTION)		1-29	~
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-3-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-3-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-3-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-3-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

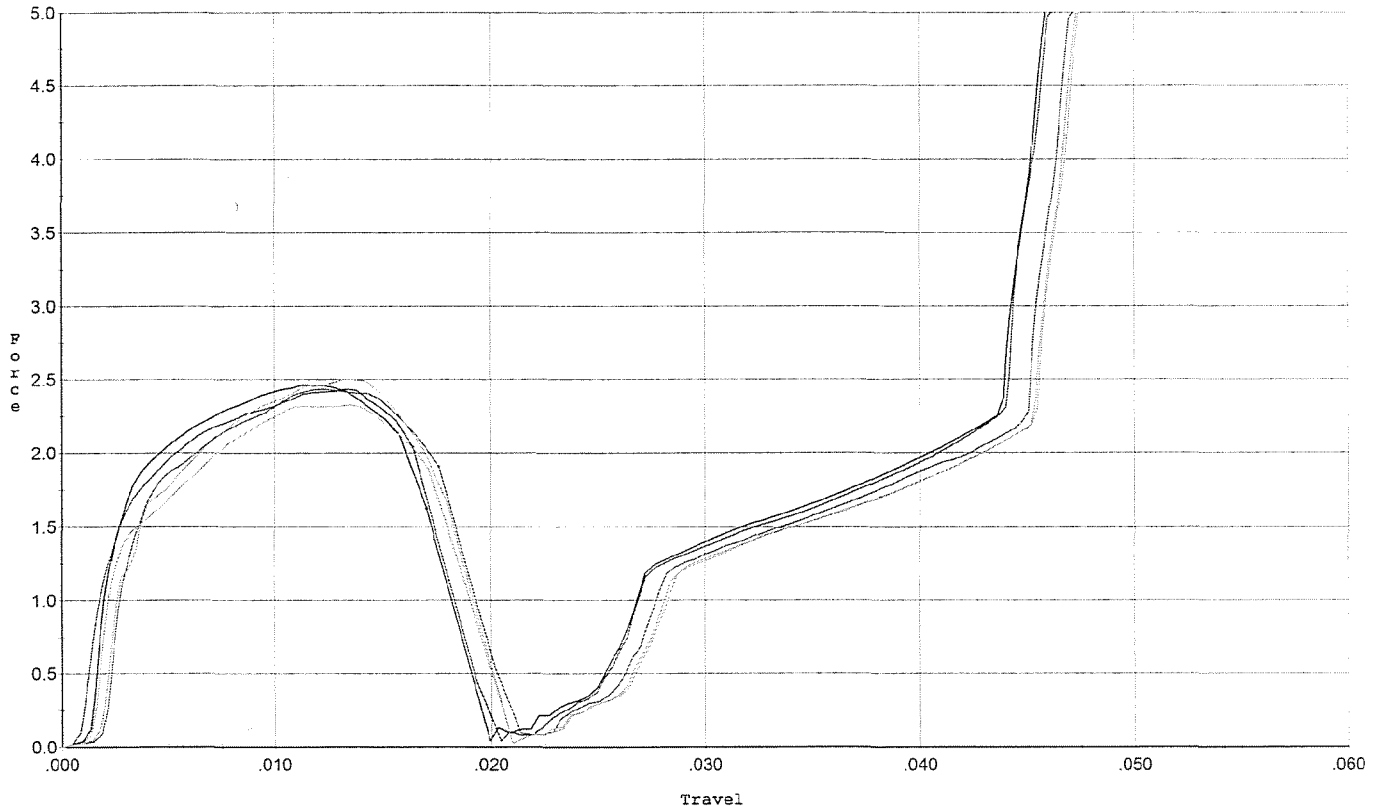
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	2-10-09	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>30</u>	2-10-09	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.020</u> <u>.034</u>	2-10-09	RJ
	J) ASSEMBLE STOCK		2-3-09	RPD
	K) ASSEMBLE SWIVEL STUDS		2-10-09	RJ
	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	2-5-09	TE
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-5-09	TV TV
670	FINAL INSPECTION A) HEADSPACE		2-10-09	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.18</u> <u>2.20</u> <u>2.27</u> <u>2.27</u> <u>2.27</u>	2-6-09	VR
	C) FUNCTION		2-10-09	RJ
690	PACK		2/12/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/3/2009

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



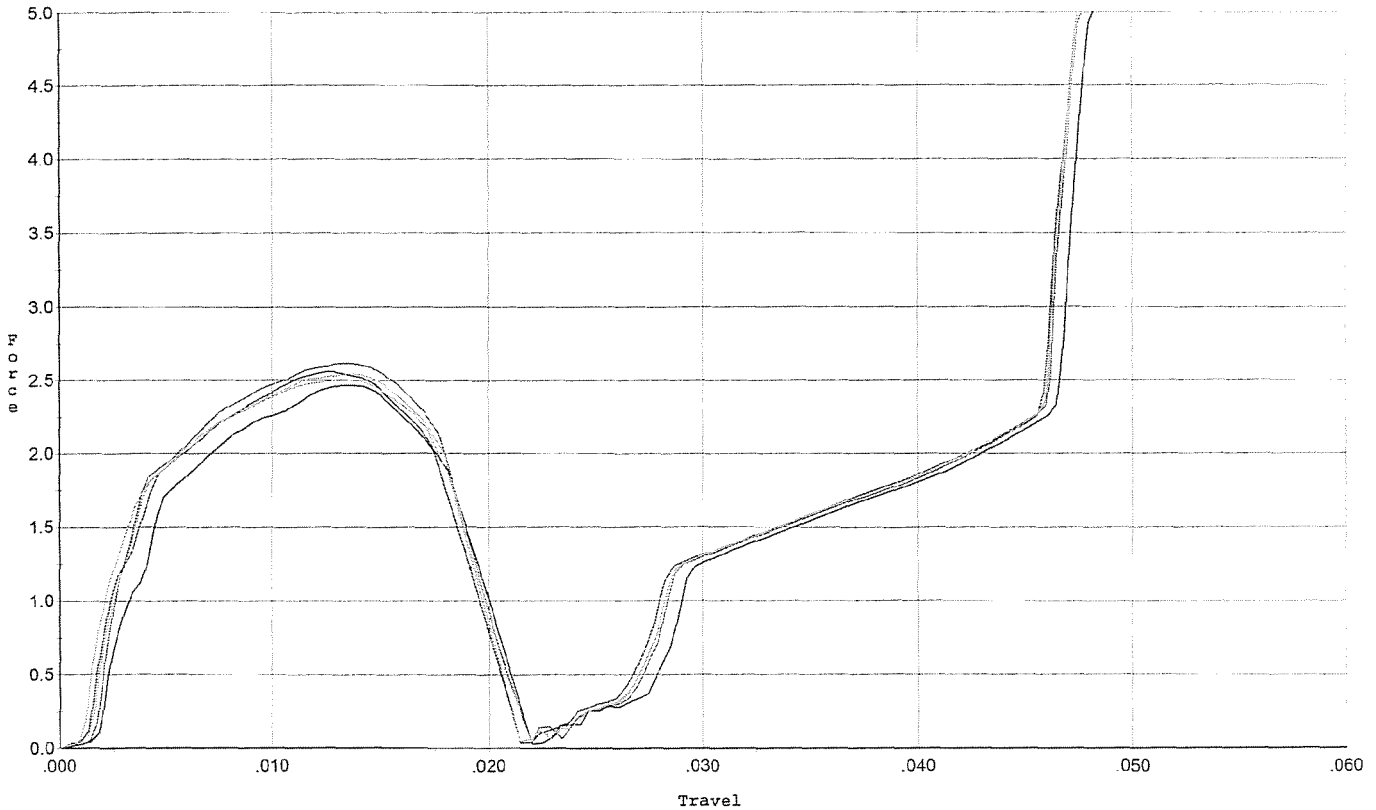
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.434	0.016	0.00	0.034	0.030		Set Trigger
2	2.461	0.017	0.00	0.034	0.031		Set Trigger
3	2.433	0.018	0.00	0.034	0.030		Set Trigger
4	2.327	0.019	0.00	0.035	0.031		Set Trigger
5	2.501	0.018	0.00	0.035	0.031		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



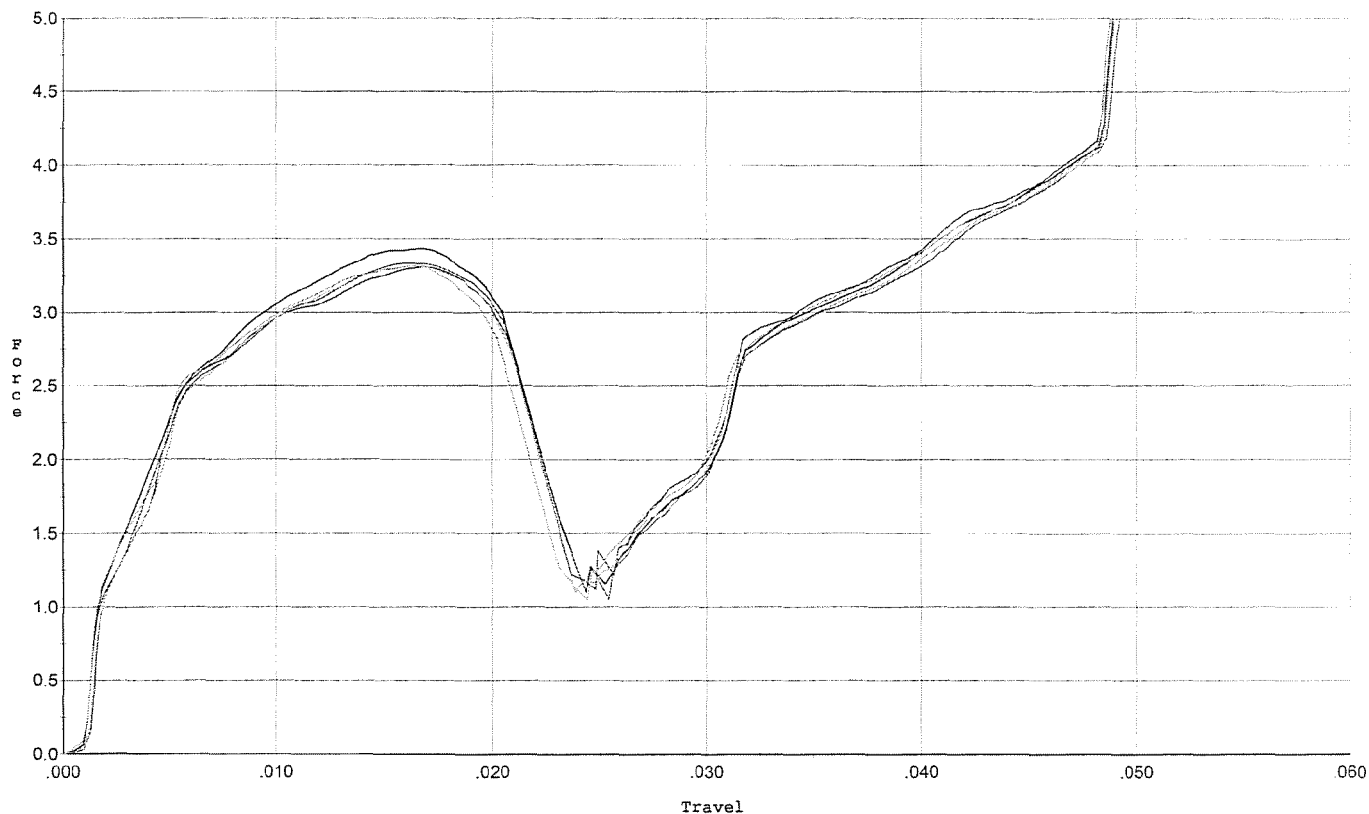
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.560	0.019	0.00	0.034	0.034		Set Trigger
2	2.467	0.020	0.00	0.034	0.033		Set Trigger
3	2.618	0.018	0.00	0.034	0.033		Set Trigger
4	2.545	0.018	0.00	0.034	0.033		Set Trigger
5	2.511	0.018	0.00	0.034	0.033		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



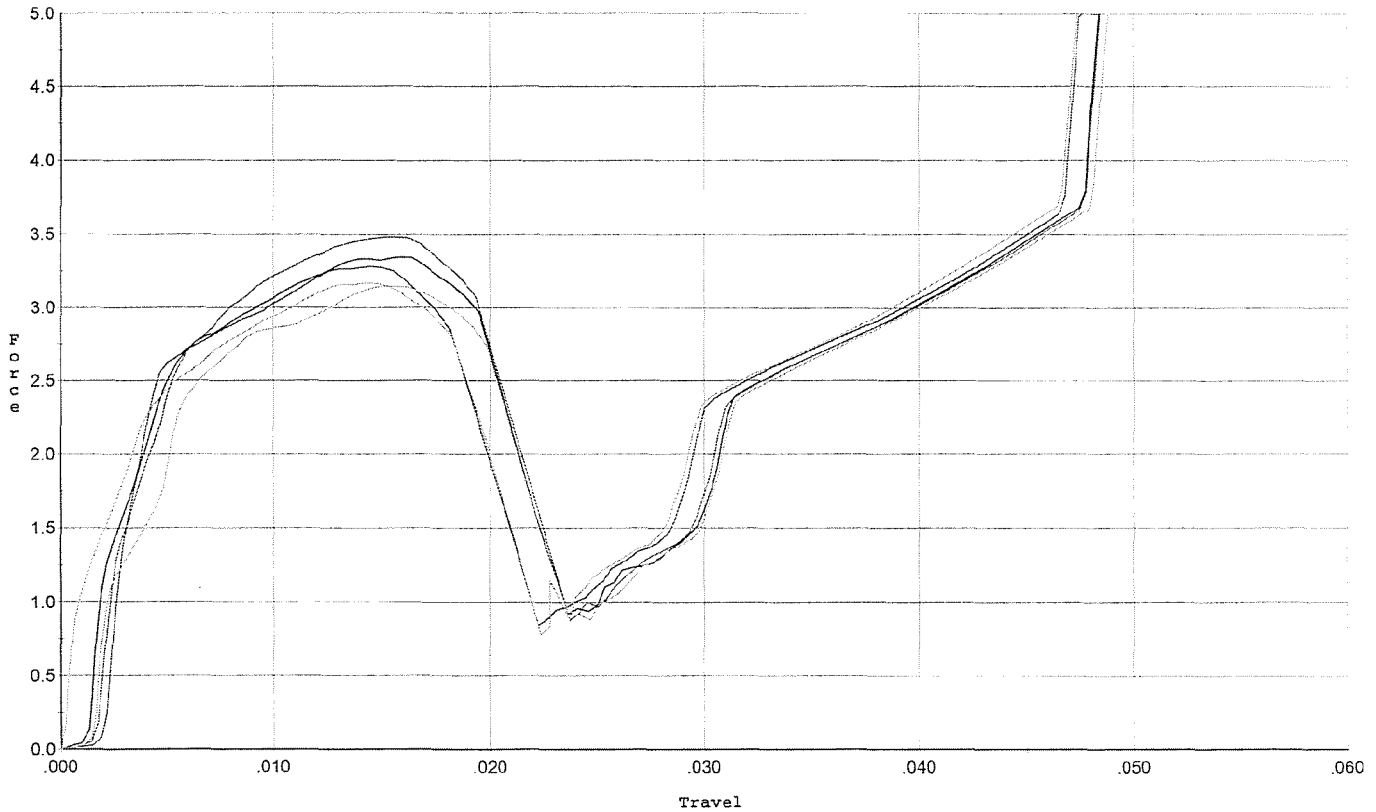
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.312	0.021	0.00	0.031	0.049		Set Trigger
2	3.434	0.020	0.00	0.031	0.050		Set Trigger
3	3.335	0.021	0.00	0.031	0.049		Set Trigger
4	3.324	0.021	0.00	0.031	0.049		Set Trigger
5	3.315	0.020	0.00	0.031	0.048		Set Trigger

A-3-34

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/3/2009

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



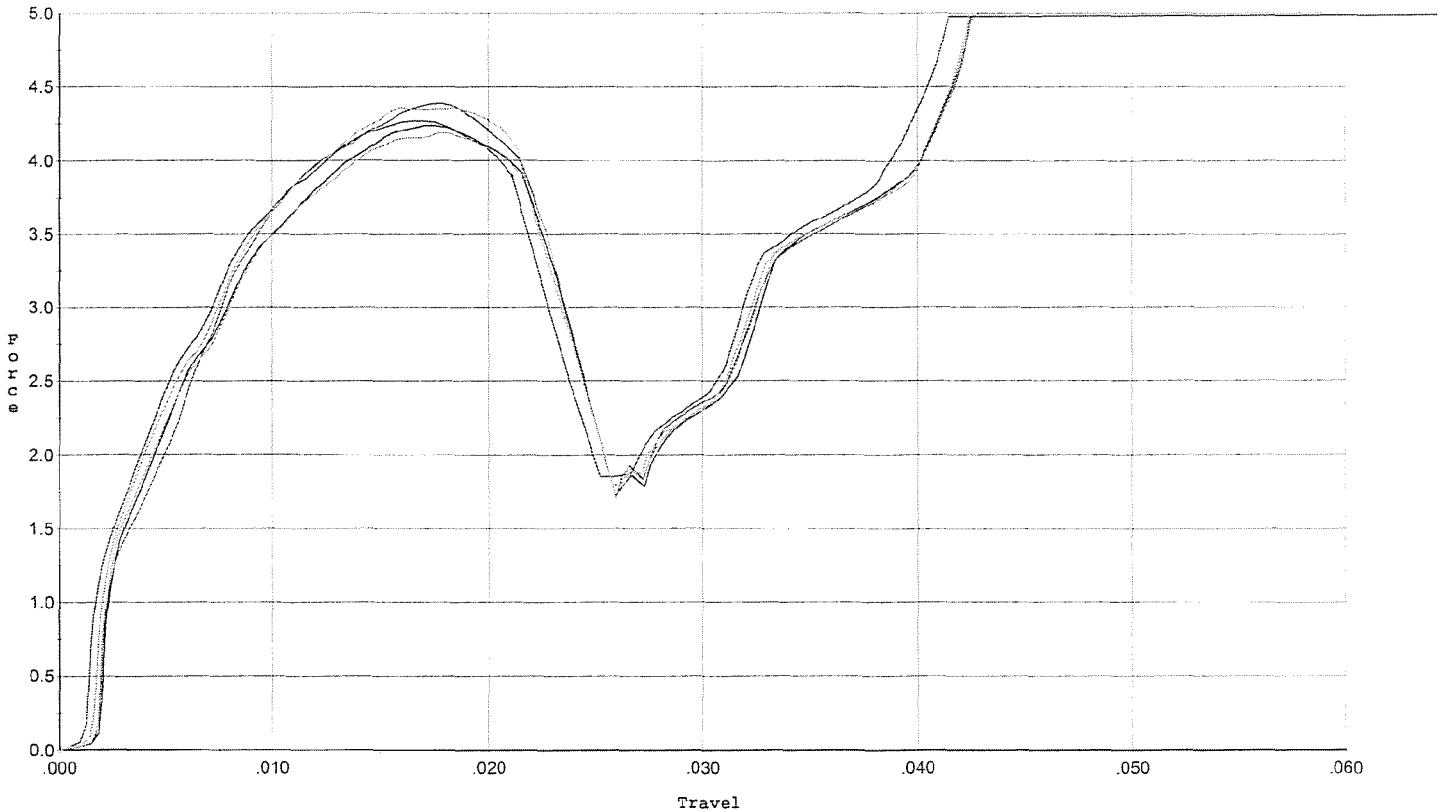
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.280	0.018	0.00	0.031	0.042		Set Trigger
2	3.347	0.019	0.00	0.031	0.047		Set Trigger
3	3.480	0.021	0.00	0.031	0.053		Set Trigger
4	3.145	0.020	0.00	0.031	0.044		Set Trigger
5	3.166	0.020	0.00	0.031	0.047		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



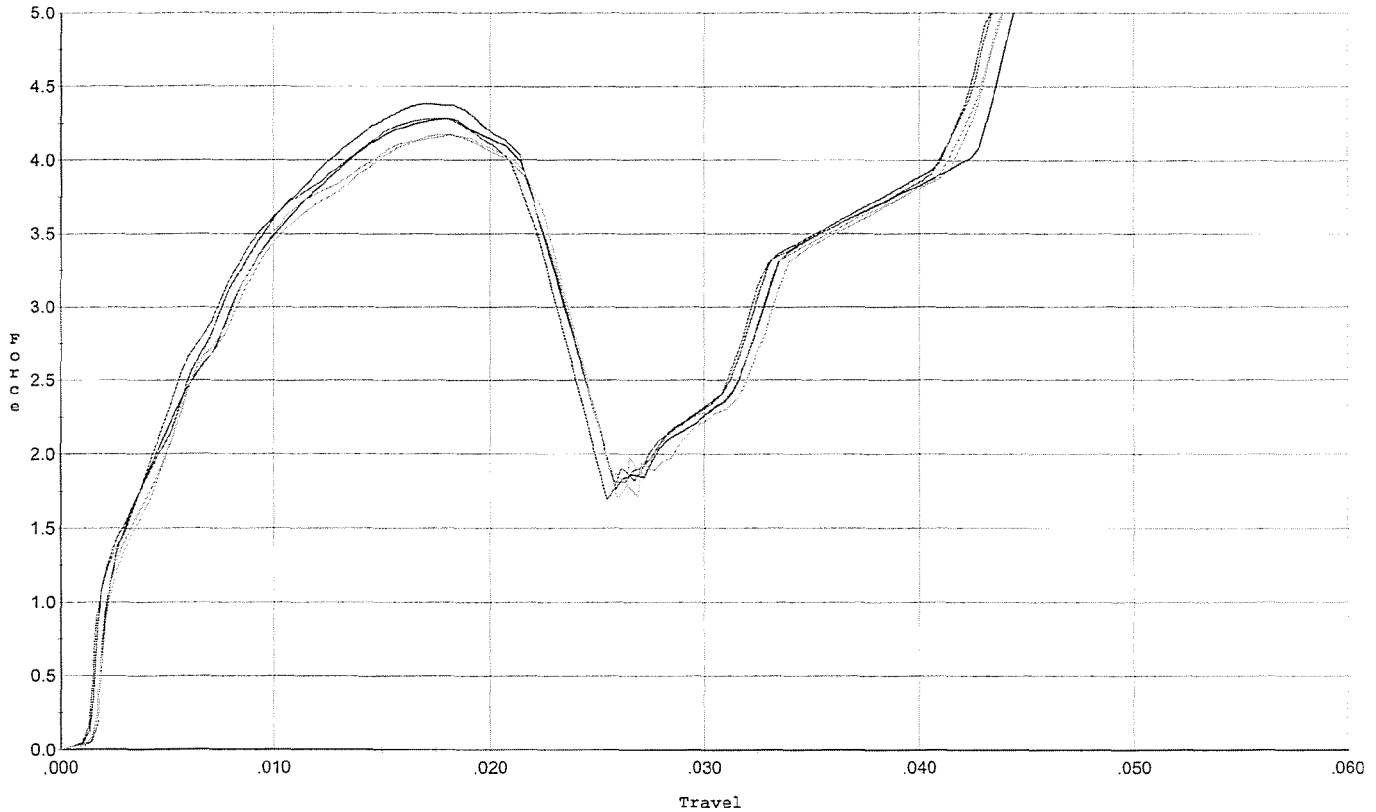
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.267	0.021	0.00	0.019	0.062		Set Trigger
2	4.237	0.023	0.00	0.019	0.066		Set Trigger
3	4.386	0.023	0.00	0.019	0.066		Set Trigger
4	4.356	0.023	0.00	0.018	0.067		Set Trigger
5	4.185	0.024	0.00	0.019	0.067		Set Trigger

A-4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



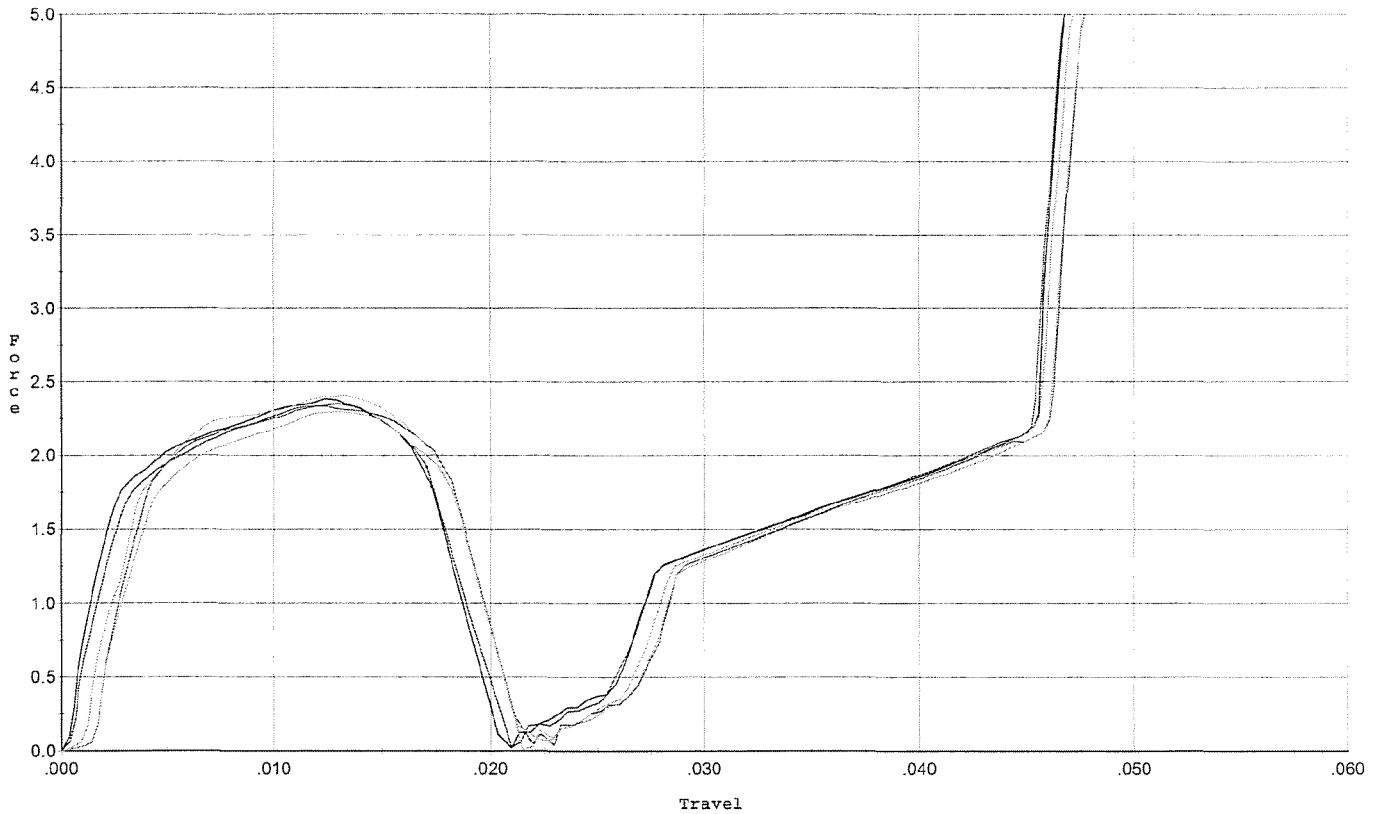
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.380	0.023	0.00	0.020	0.069		Set Trigger
2	4.280	0.023	0.00	0.021	0.067		Set Trigger
3	4.282	0.022	0.00	0.021	0.065		Set Trigger
4	4.169	0.022	0.00	0.021	0.063		Set Trigger
5	4.174	0.023	0.00	0.020	0.065		Set Trigger

A-24.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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



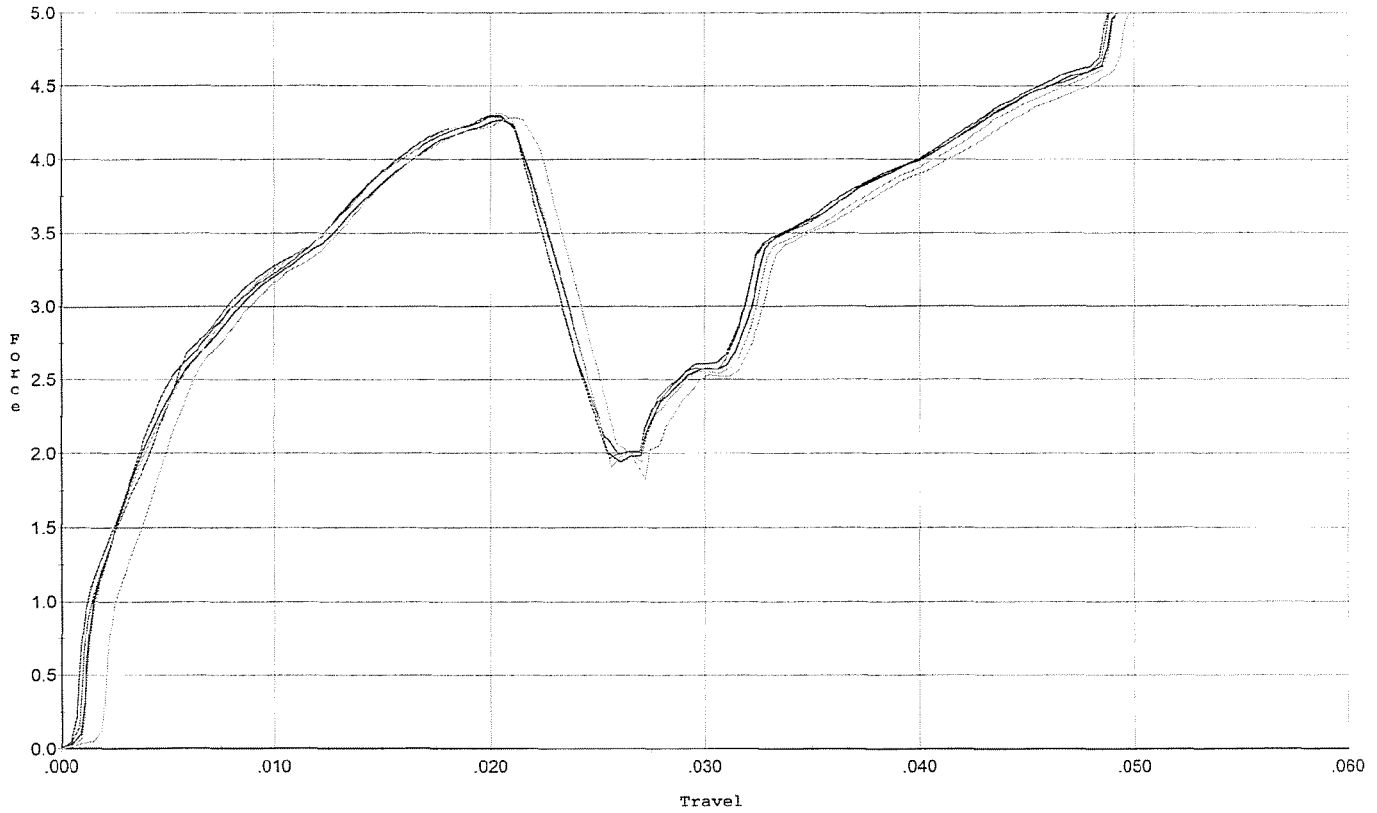
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.352	0.017	0.00	0.035	0.031		Set Trigger
2	2.385	0.017	0.00	0.035	0.032		Set Trigger
3	2.334	0.018	0.00	0.035	0.032		Set Trigger
4	2.405	0.018	0.00	0.034	0.033		Set Trigger
5	2.295	0.018	0.00	0.035	0.031		Set Trigger

A-2-35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/3/2009

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	4.297	0.021	0.00	0.028	0.061		Set Trigger
2	4.269	0.023	0.00	0.028	0.065		Set Trigger
3	4.290	0.021	0.00	0.028	0.060		Set Trigger
4	4.318	0.022	0.00	0.028	0.064		Set Trigger
5	4.285	0.022	0.00	0.028	0.062		Set Trigger

A- 4.29

