

G686 3559

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



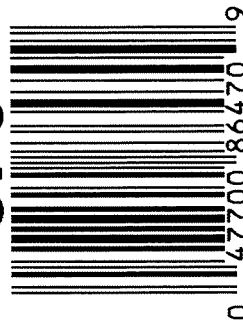
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6863559

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863559

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SPD
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX TYPE 2009 OPERATOR 11	5-21-09	RP
470	DIS-ASSEMBLE ACTION		5-21-09	RP
472	SERIALIZE BOLT HANDLE		5-21-09	SPN
480	MAGNAFLUX BBL ACTION		5/24/09	(11)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RT
510	DRILL AND TAP SIGHT HOLES		5-22-09	SP
520	GOFF BLAST BBL / REC		5/29/09	SP
540	APPLY COATINGS (BARREL ACTION)		6/1	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		6-1-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-1-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-1-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-2-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

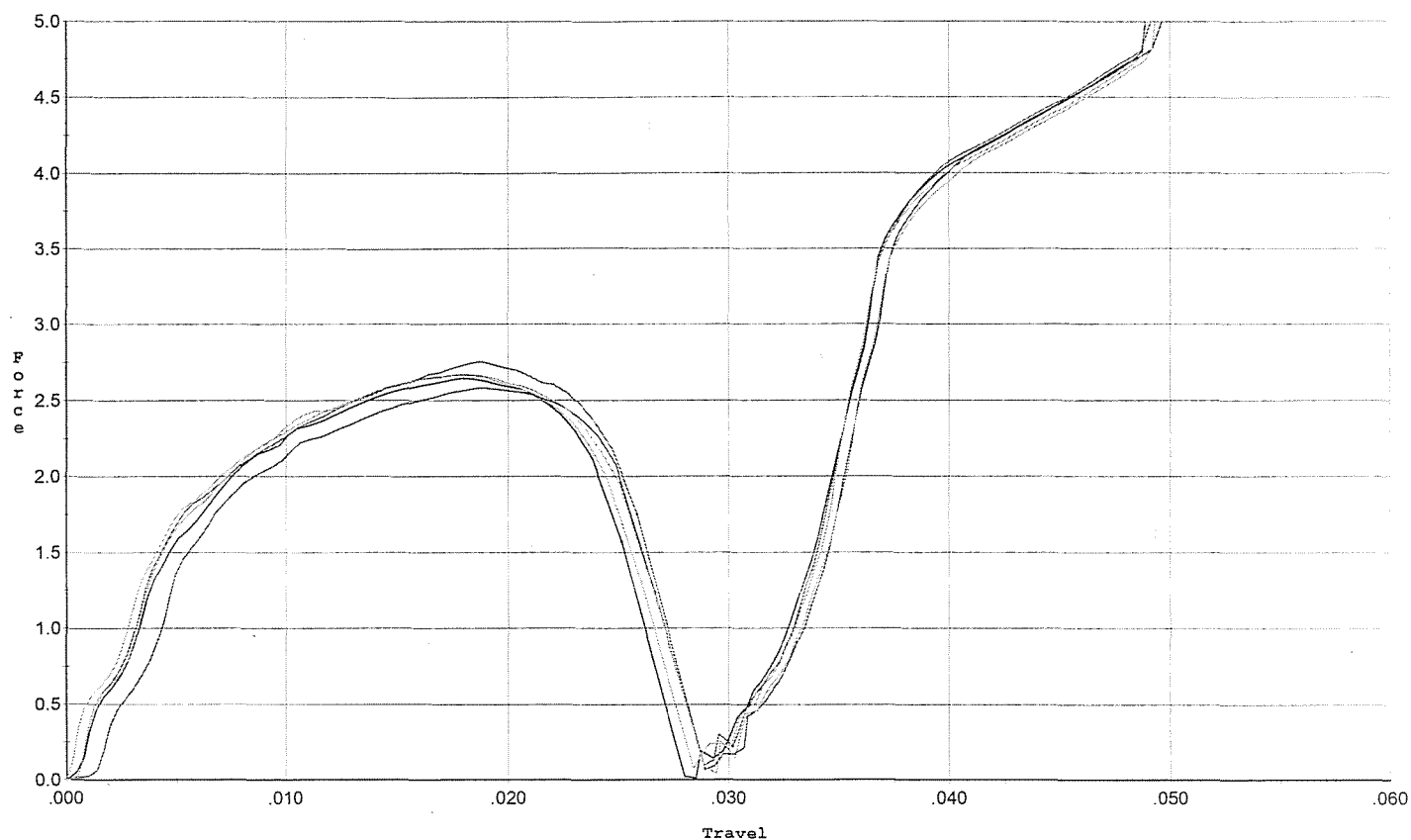
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-18-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	6-18-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	6-18-09	L.N.
	J) ASSEMBLE STOCK		6-2-09	SPD.
	K) ASSEMBLE SWIVEL STUDS		6-18-09	L.N.
	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	6/16/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TOR
670	FINAL INSPECTION A) HEADSPACE		6-18-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>287</u> <u>281</u> <u>284</u> <u>285</u> <u>286</u>	6-18-09	L.N.
	C) FUNCTION		6-18-09	L.N.
690	PACK		7/24/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



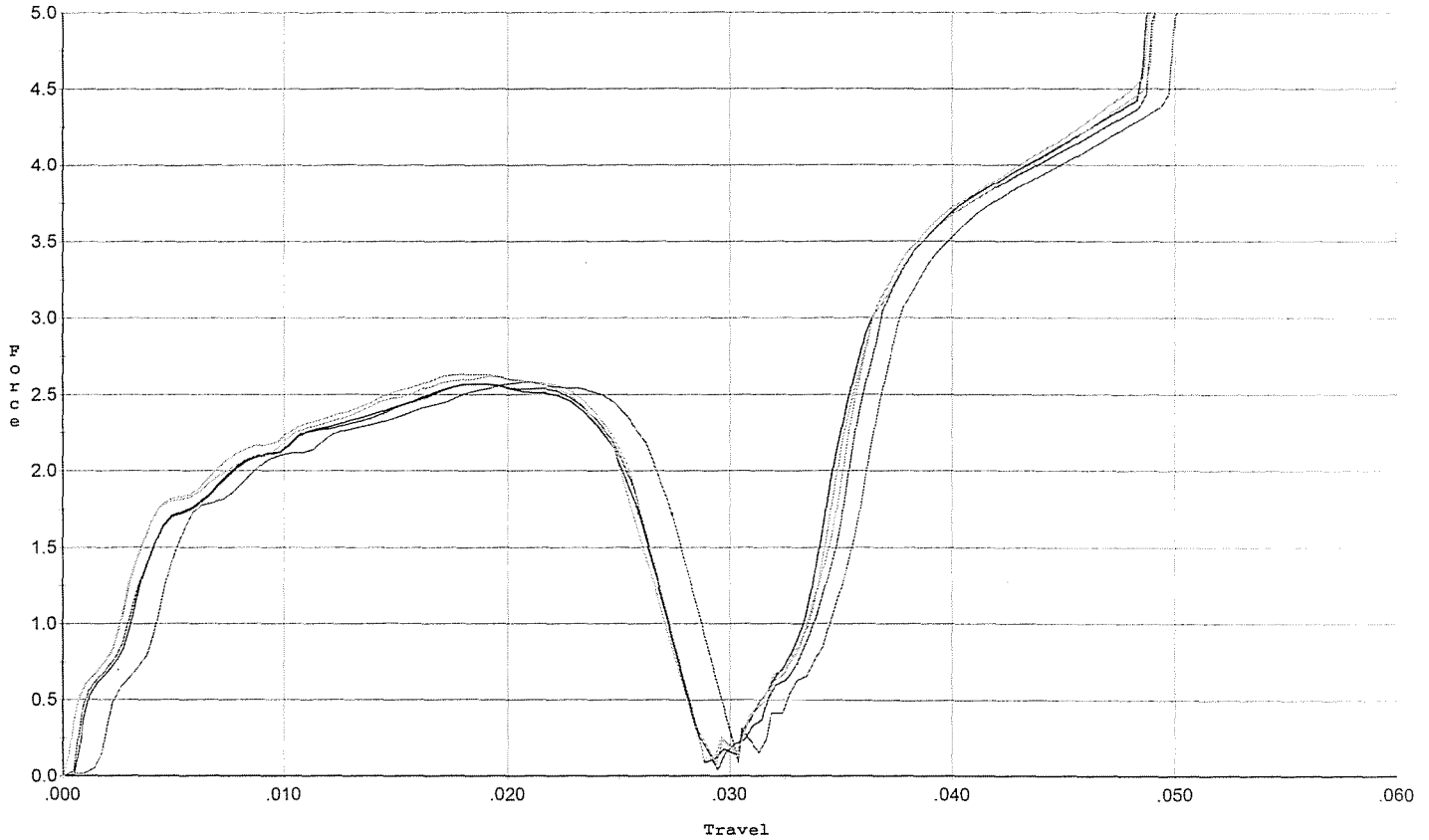
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.580	0.027	0.00	0.031	0.049		Set Trigger
2	2.645	0.025	0.00	0.031	0.048		Set Trigger
3	2.753	0.026	0.00	0.030	0.051		Set Trigger
4	2.664	0.026	0.00	0.030	0.051		Set Trigger
5	2.672	0.027	0.00	0.030	0.052		Set Trigger

A 2.66

Trigger Profile [lbs,inch]

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

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



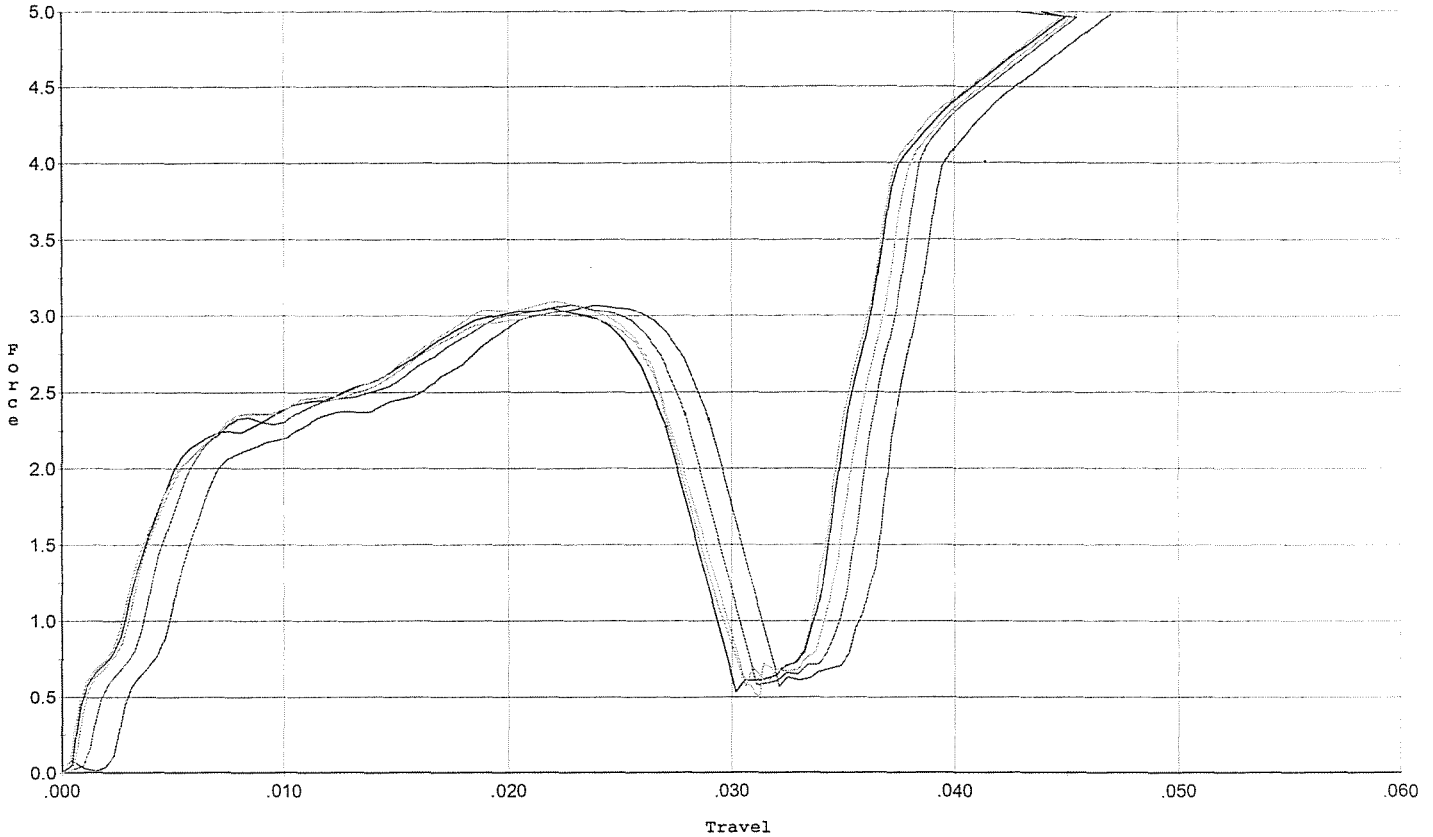
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.571	0.026	0.00	0.030	0.049		Set Trigger
2	2.569	0.026	0.00	0.030	0.050		Set Trigger
3	2.580	0.027	0.00	0.027	0.051		Set Trigger
4	2.618	0.027	0.00	0.030	0.053		Set Trigger
5	2.632	0.025	0.00	0.030	0.051		Set Trigger

A-2.59

Trigger Profile [lbs,inch]

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

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



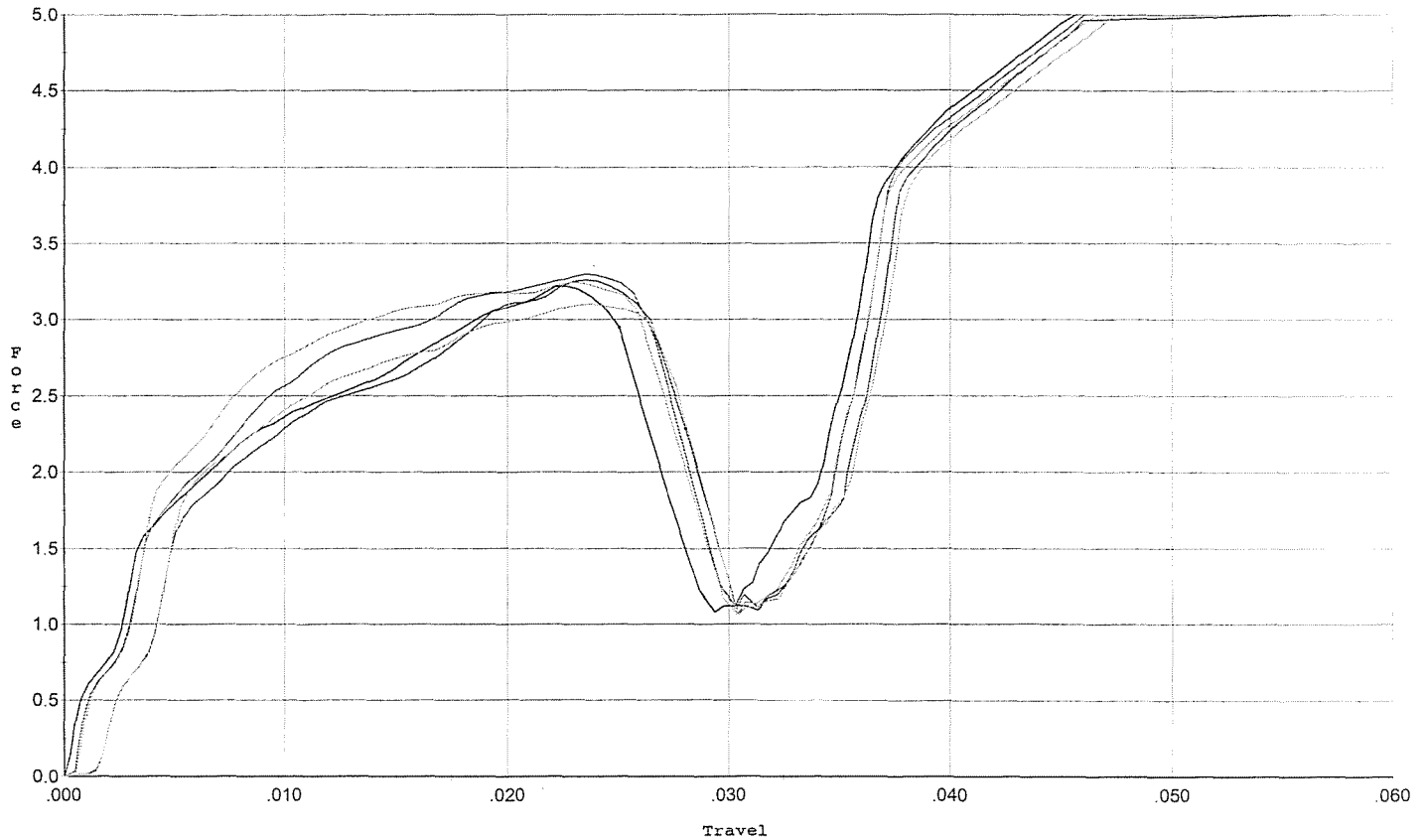
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.029	0.002	0.024	0.060		Set Trigger
2	3.050	0.027	0.00	0.024	0.060		Set Trigger
3	3.072	0.028	0.00	0.024	0.061		Set Trigger
4	3.093	0.028	0.00	0.024	0.063		Set Trigger
5	3.020	0.027	0.00	0.024	0.059		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



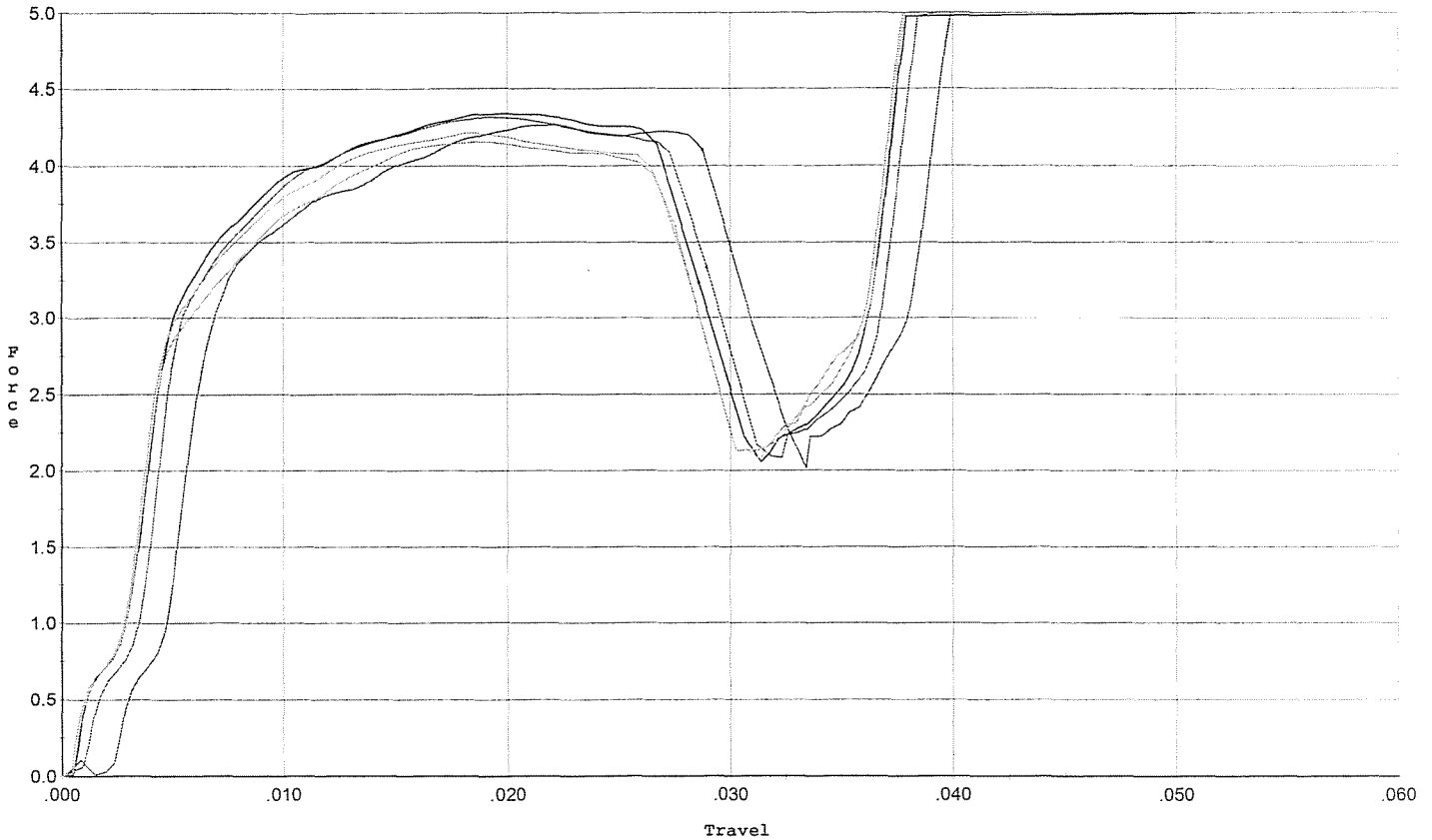
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.262	0.028	0.00	0.023	0.061		Set Trigger
2	3.223	0.025	0.00	0.024	0.056		Set Trigger
3	3.299	0.027	0.00	0.023	0.063		Set Trigger
4	3.104	0.028	0.00	0.024	0.060		Set Trigger
5	3.248	0.028	0.00	0.023	0.067		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



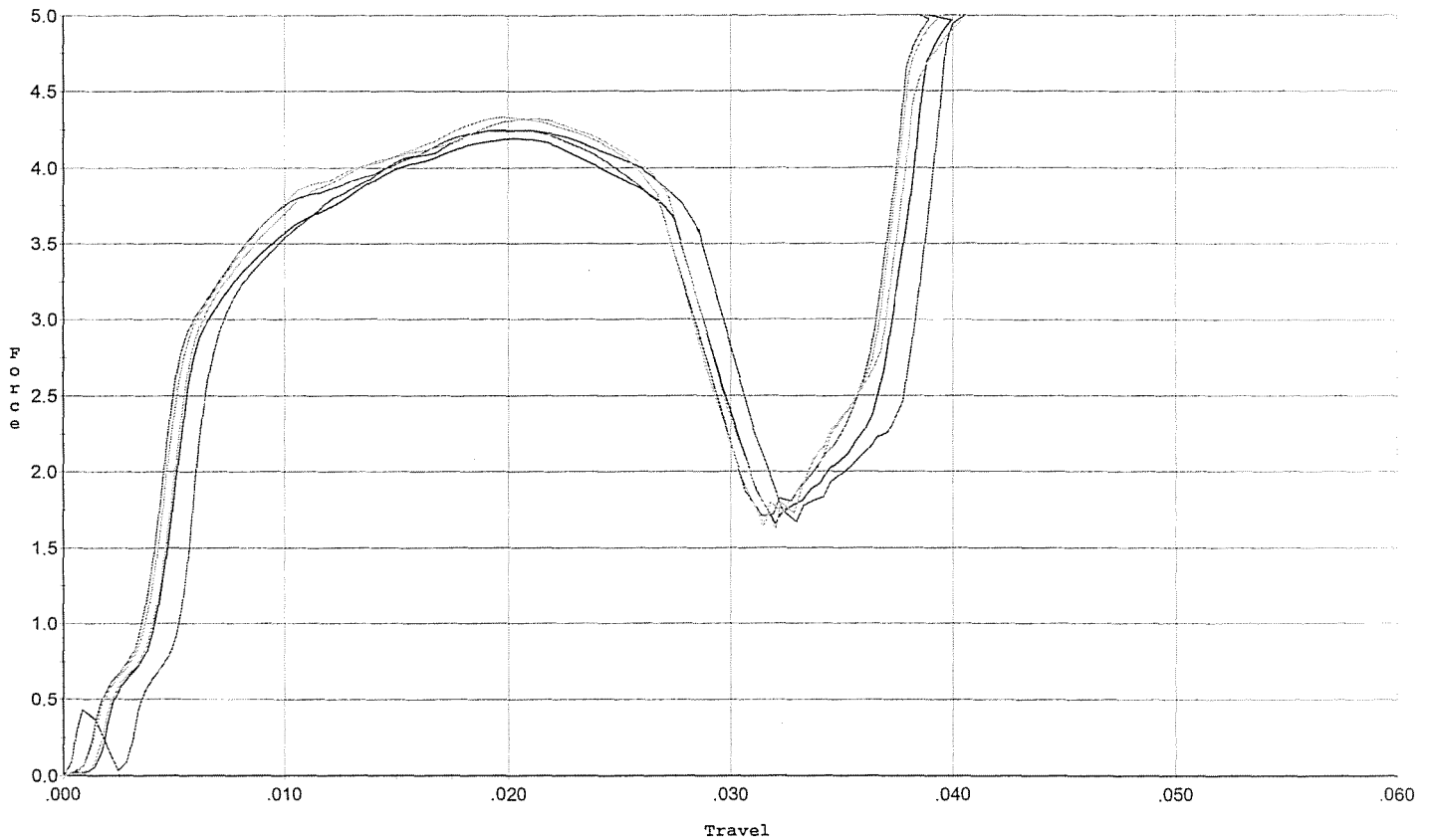
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.265	0.029	0.00	0.016	0.088		Set Trigger
2	4.341	0.029	0.00	0.015	0.094		Set Trigger
3	4.317	0.029	0.00	0.015	0.093		Set Trigger
4	4.213	0.028	0.00	0.015	0.089		Set Trigger
5	4.156	0.028	0.00	0.015	0.086		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



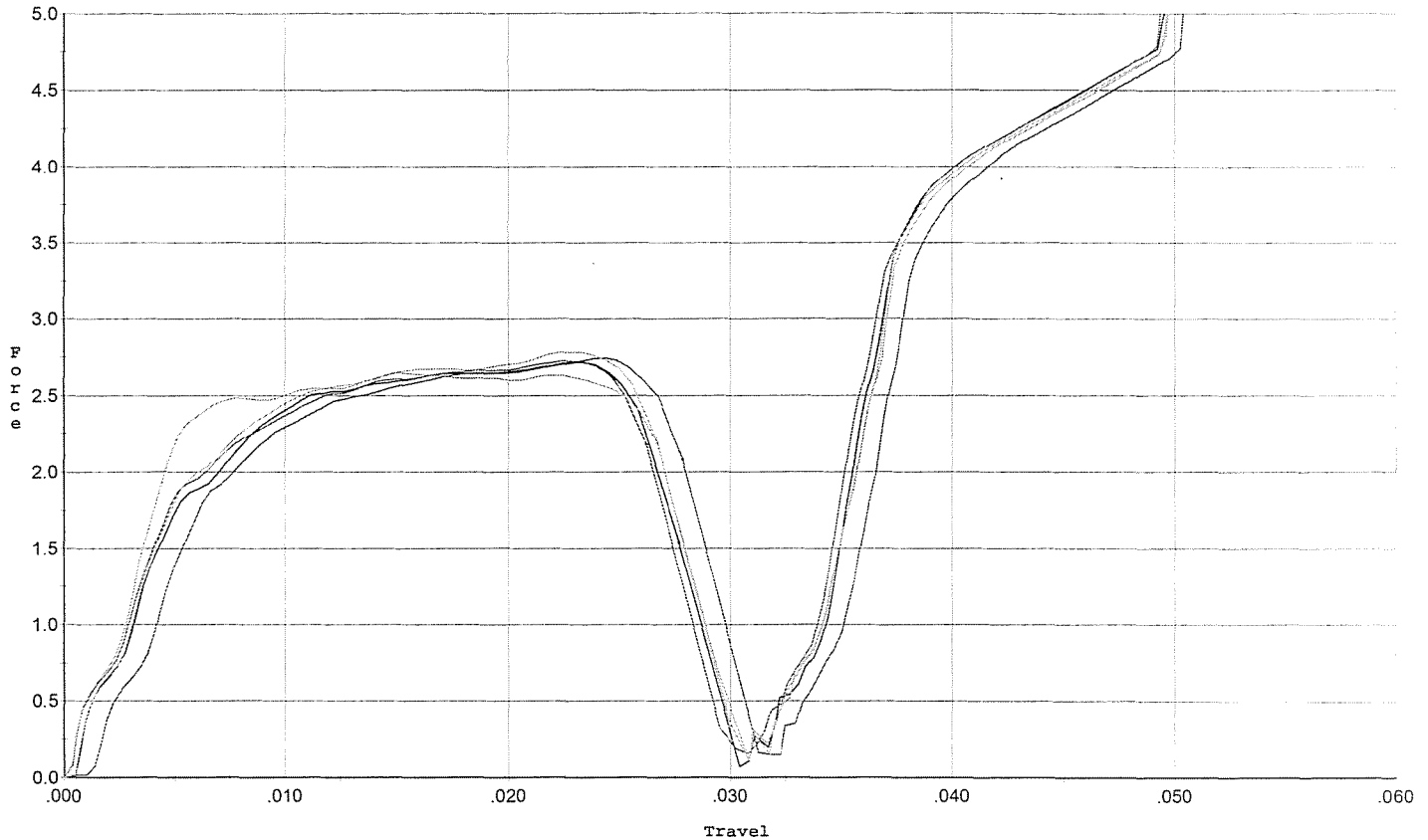
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.246	0.029	0.003	0.018	0.085		Set Trigger
2	4.193	0.027	0.00	0.019	0.082		Set Trigger
3	4.248	0.029	0.00	0.018	0.088		Set Trigger
4	4.331	0.027	0.00	0.018	0.083		Set Trigger
5	4.320	0.027	0.00	0.019	0.084		Set Trigger

A-4.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



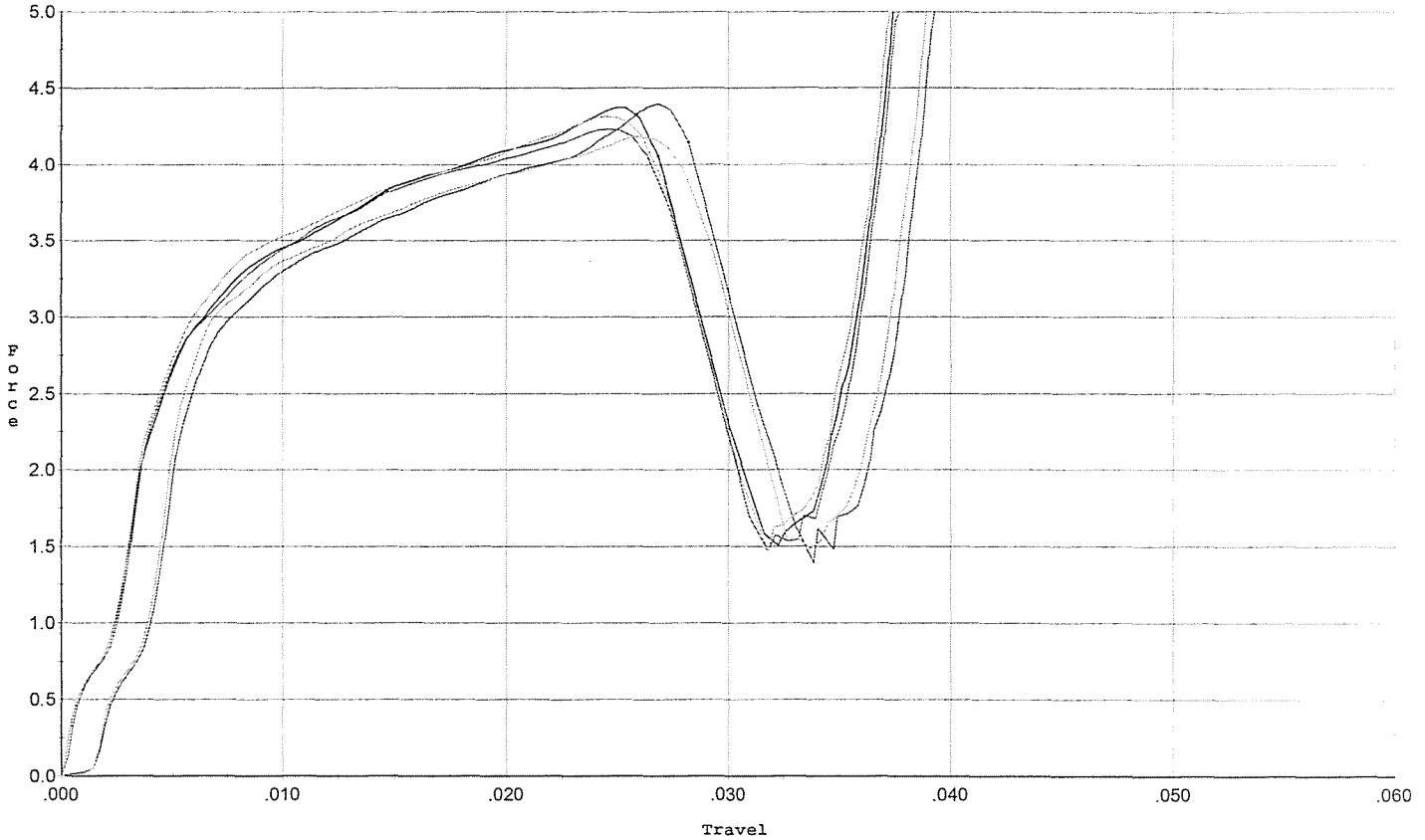
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.745	0.028	0.00	0.025	0.056		Set Trigger
2	2.716	0.028	0.00	0.026	0.057		Set Trigger
3	2.723	0.026	0.00	0.026	0.055		Set Trigger
4	2.783	0.027	0.00	0.026	0.056		Set Trigger
5	2.647	0.027	0.00	0.026	0.057		Set Trigger

A-2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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	4.398	0.028	0.00	0.015	0.083		Set Trigger
2	4.372	0.027	0.00	0.014	0.084		Set Trigger
3	4.229	0.027	0.00	0.015	0.084		Set Trigger
4	4.181	0.029	0.00	0.014	0.086		Set Trigger
5	4.312	0.027	0.00	0.013	0.085		Set Trigger

A-4.29