

G686 3622

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

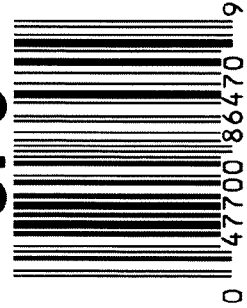
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863622

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 686 3622

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-27-09	SPD
430	ASSEMBLE TO STOCK		5-27-09	SP
440	PROOF		5-27-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	5-27-09	SPD
470	DIS-ASSEMBLE ACTION	MAY 20 2009	5-27-09	SPD
472	SERIALIZE BOLT HANDLE		5-28-09	KTC
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/30/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/1/09	RT
510	DRILL AND TAP SIGHT HOLES		5-28-09	SP
520	GOFF BLAST BBL / REC		6-1-09	DWD
540	APPLY COATINGS (BARREL ACTION)		6/1/11	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-15-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-15-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-15-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-18-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

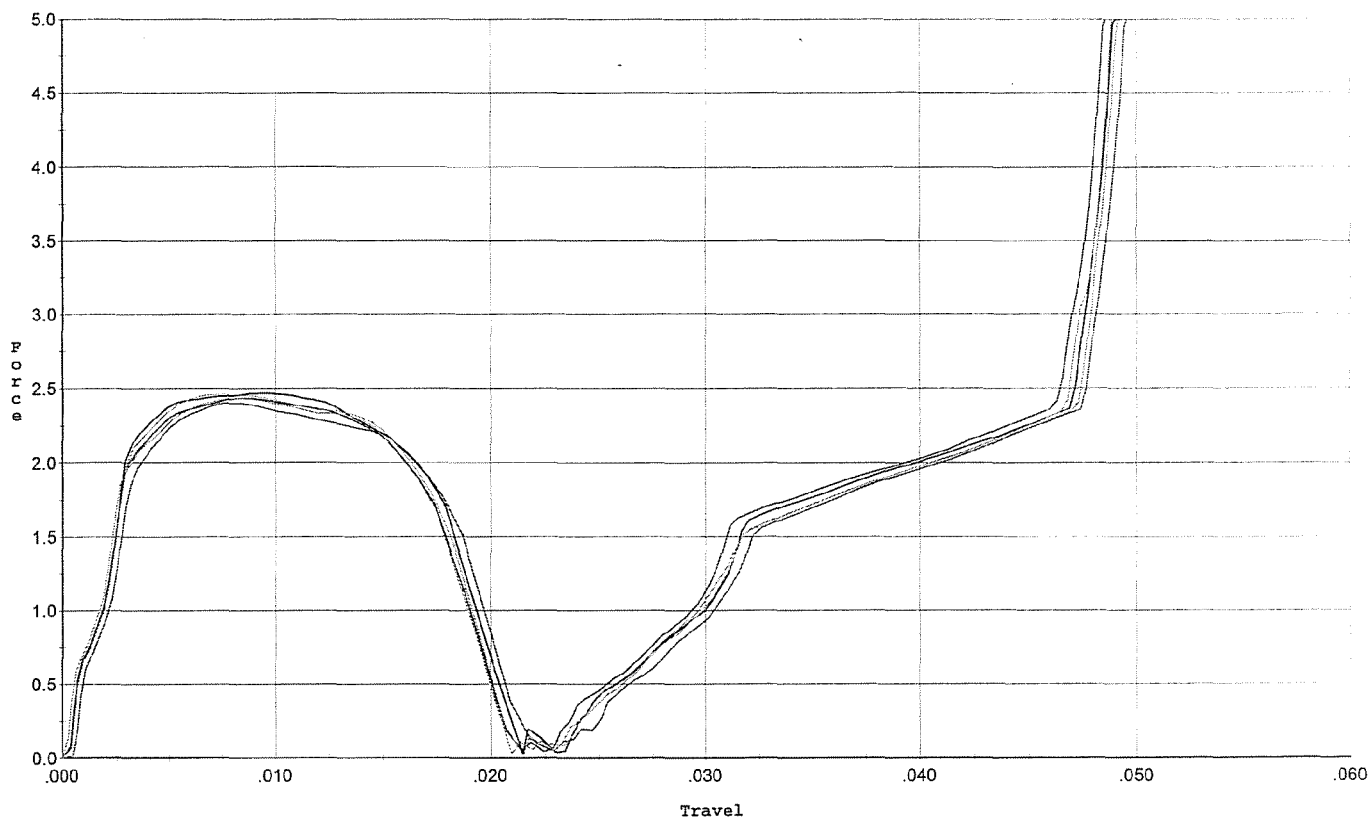
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	7-24-09	RN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	7-24-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	7-24-09	RN
	J) ASSEMBLE STOCK		6-18-09	L.H.D.
	K) ASSEMBLE SWIVEL STUDS		7-24-09	RN
	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	7/23	R/B
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/23	TAR
670	FINAL INSPECTION A) HEADSPACE		7-24-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>262</u> <u>245</u> <u>252</u> <u>253</u> <u>263</u>	7-24-09	RN
	C) FUNCTION		7-24-09	RN
690	PACK		7/31/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



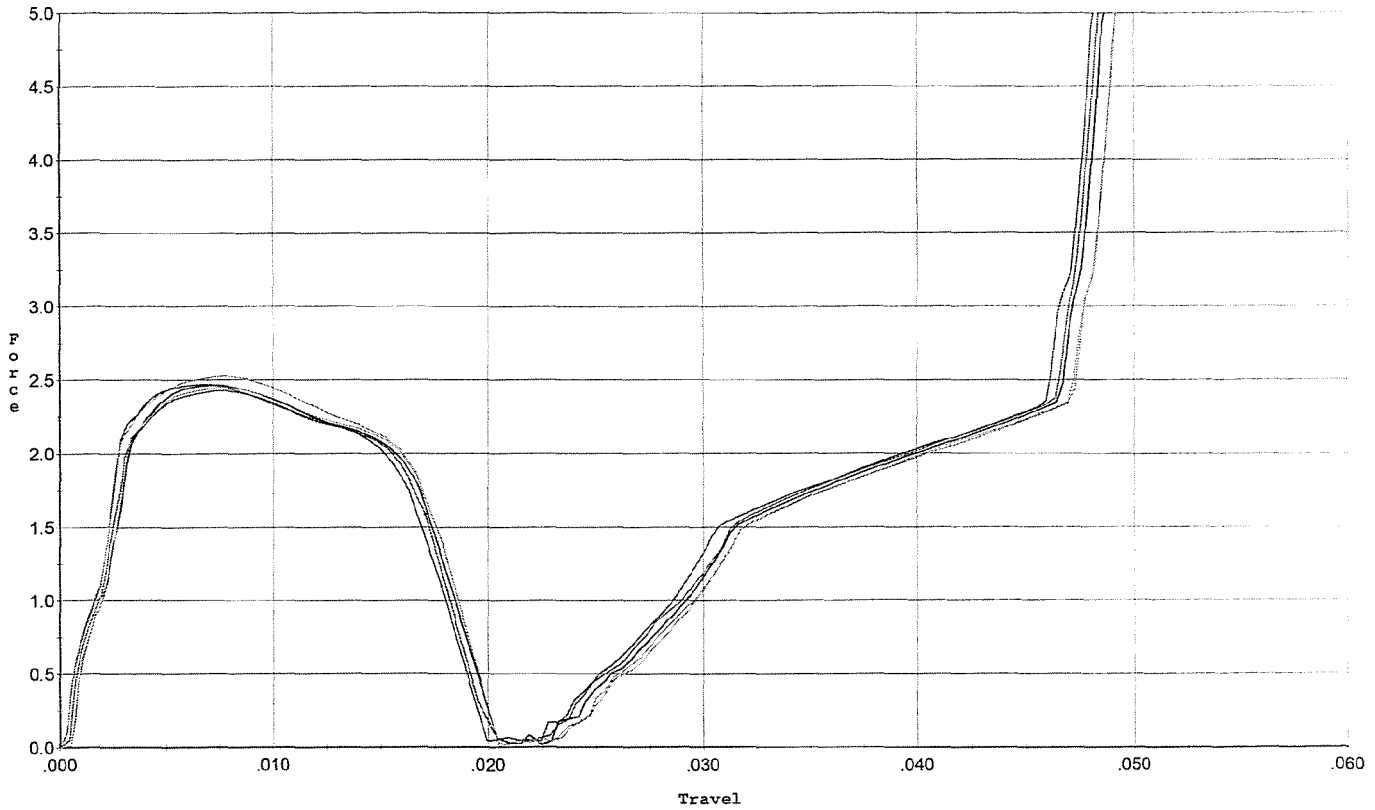
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.019	0.00	0.035	0.035		Set Trigger
2	2.467	0.018	0.00	0.036	0.035		Set Trigger
3	2.402	0.019	0.00	0.036	0.034		Set Trigger
4	2.459	0.018	0.00	0.036	0.035		Set Trigger
5	2.436	0.019	0.00	0.035	0.036		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



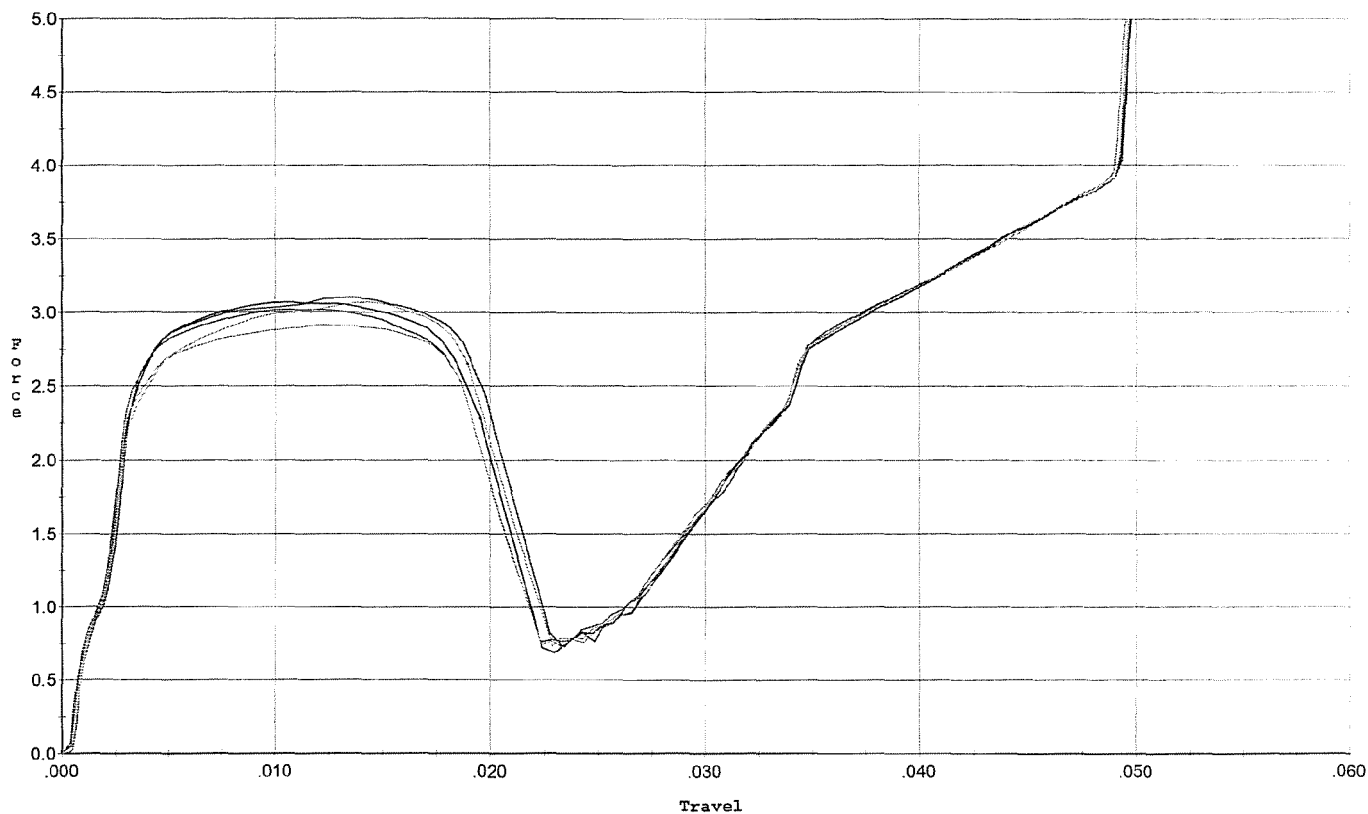
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.470	0.018	0.00	0.036	0.034		Set Trigger
2	2.464	0.019	0.00	0.036	0.034		Set Trigger
3	2.429	0.017	0.00	0.036	0.032		Set Trigger
4	2.450	0.018	0.00	0.036	0.033		Set Trigger
5	2.528	0.018	0.00	0.036	0.035		Set Trigger

Avg 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



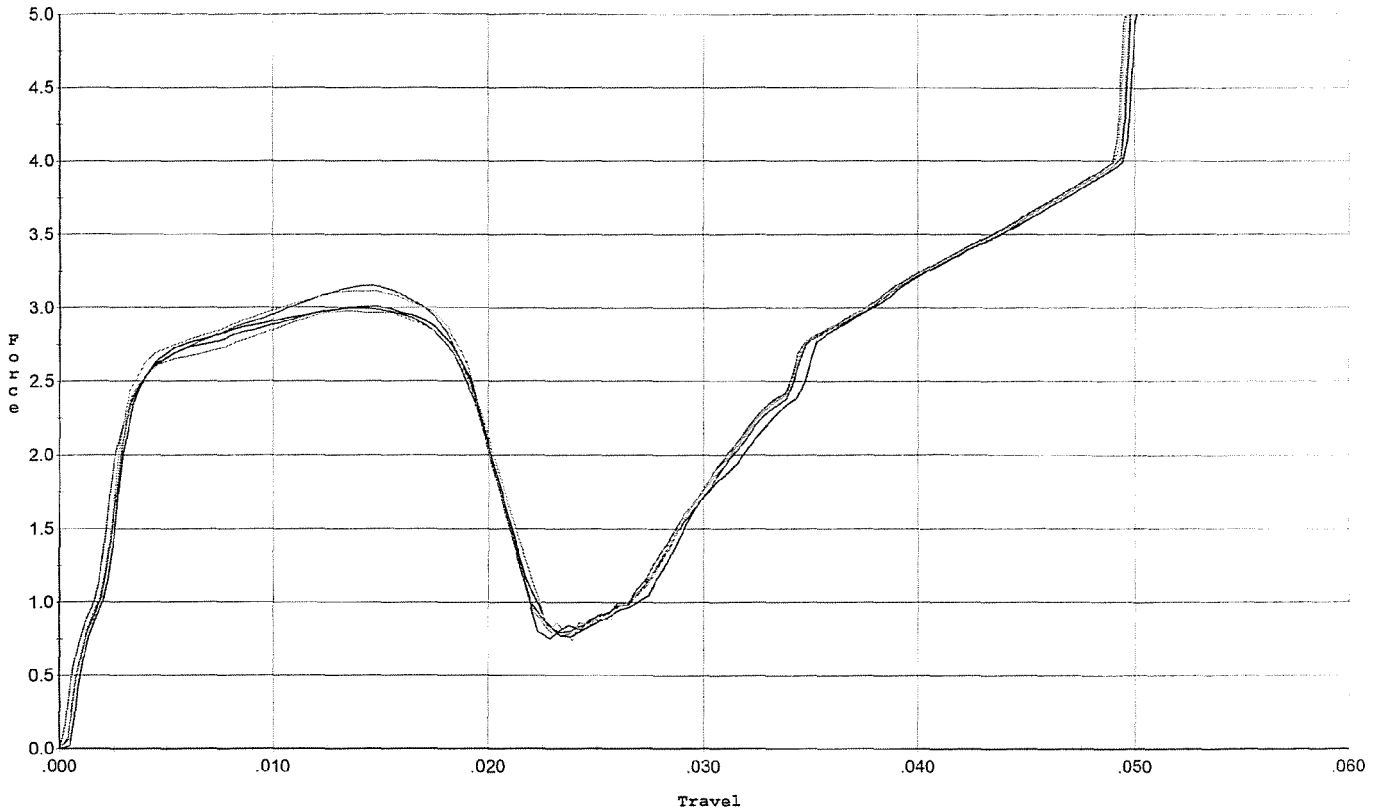
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.099	0.020	0.00	0.033	0.048		Set Trigger
2	3.067	0.020	0.00	0.033	0.047		Set Trigger
3	3.016	0.019	0.00	0.034	0.045		Set Trigger
4	3.070	0.019	0.00	0.033	0.045		Set Trigger
5	2.913	0.019	0.00	0.034	0.043		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



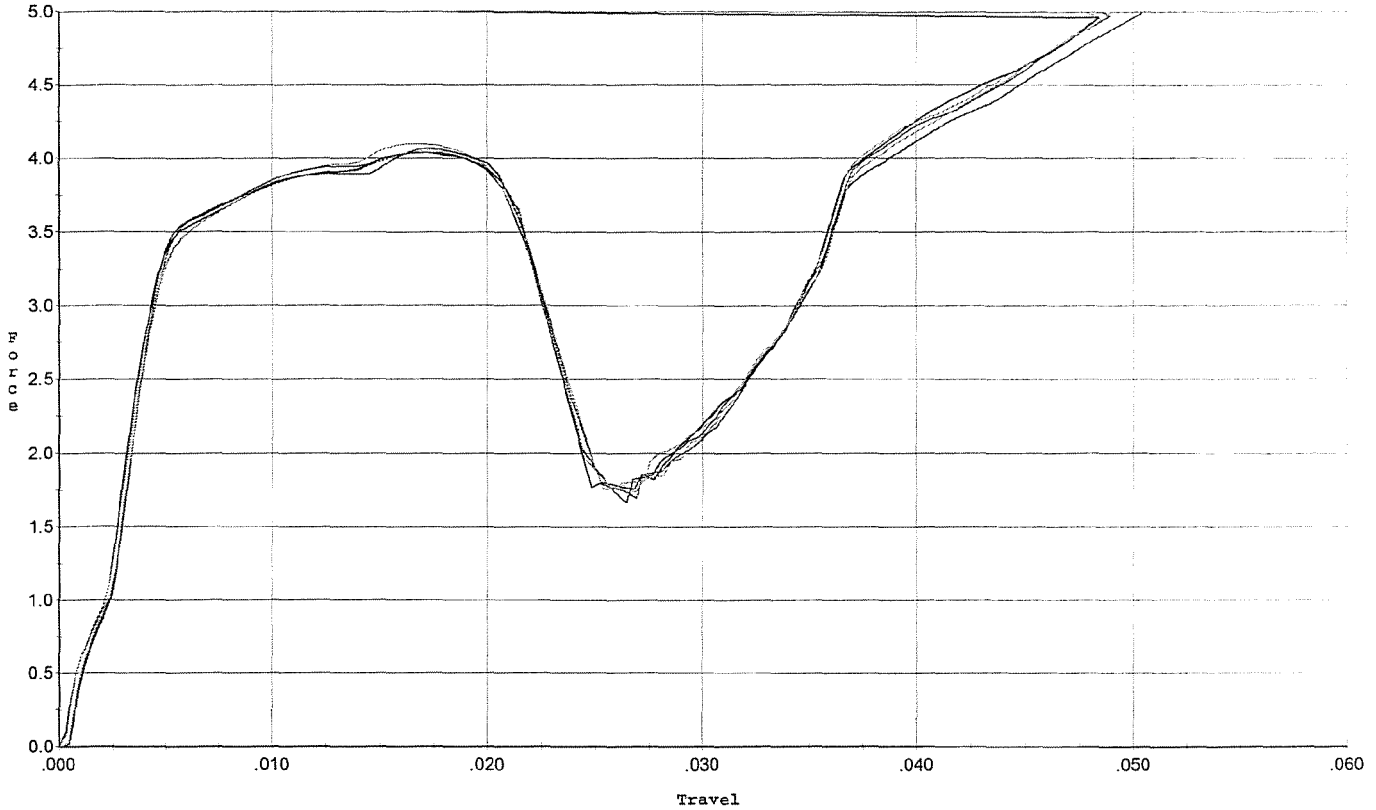
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.996	0.019	0.00	0.033	0.045		Set Trigger
2	3.009	0.019	0.00	0.034	0.045		Set Trigger
3	3.153	0.019	0.00	0.033	0.046		Set Trigger
4	3.115	0.019	0.00	0.033	0.046		Set Trigger
5	2.977	0.019	0.00	0.033	0.045		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



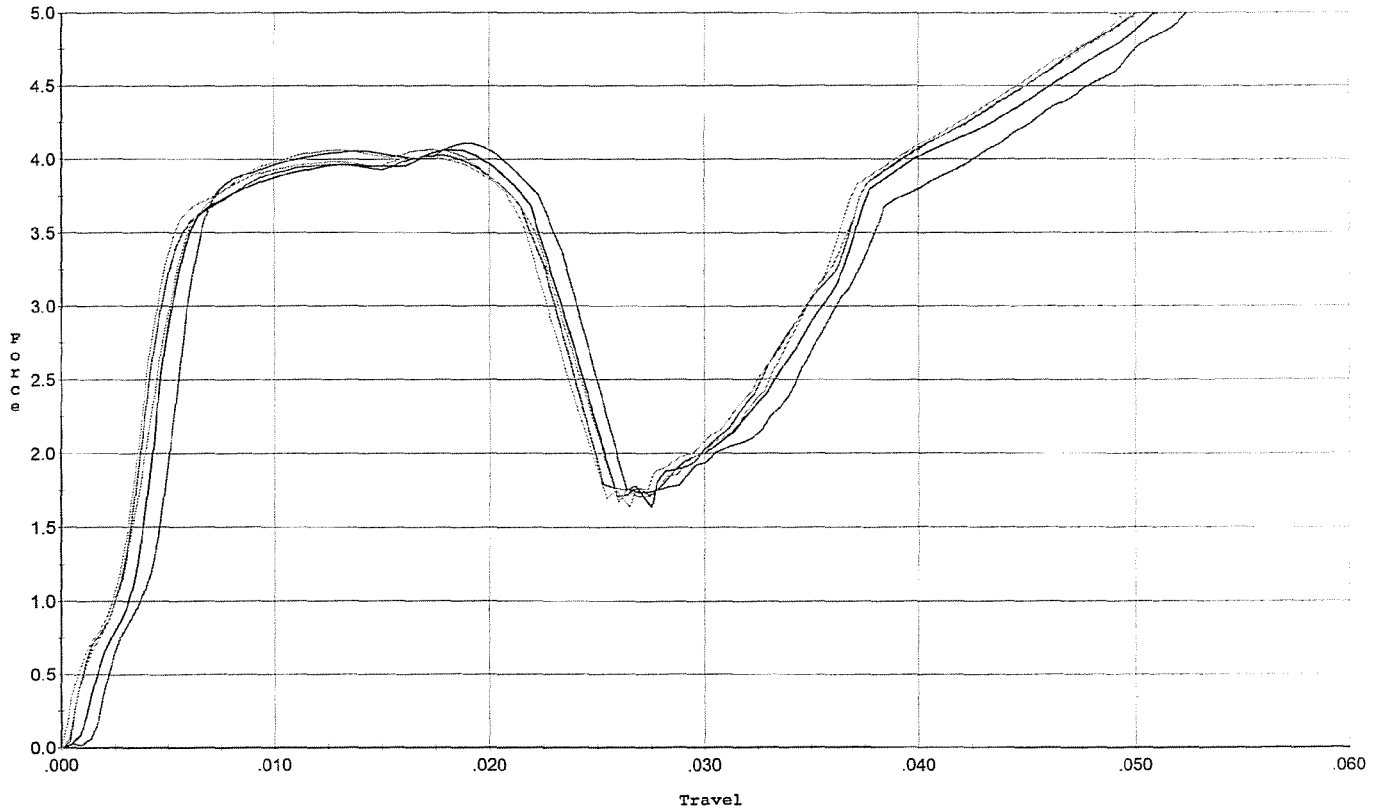
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.068	0.022	0.00	0.030	0.065		Set Trigger
2	4.037	0.022	0.00	0.030	0.066		Set Trigger
3	4.036	0.021	0.00	0.030	0.065		Set Trigger
4	4.101	0.022	0.00	0.030	0.066		Set Trigger
5	4.055	0.021	0.00	0.030	0.065		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



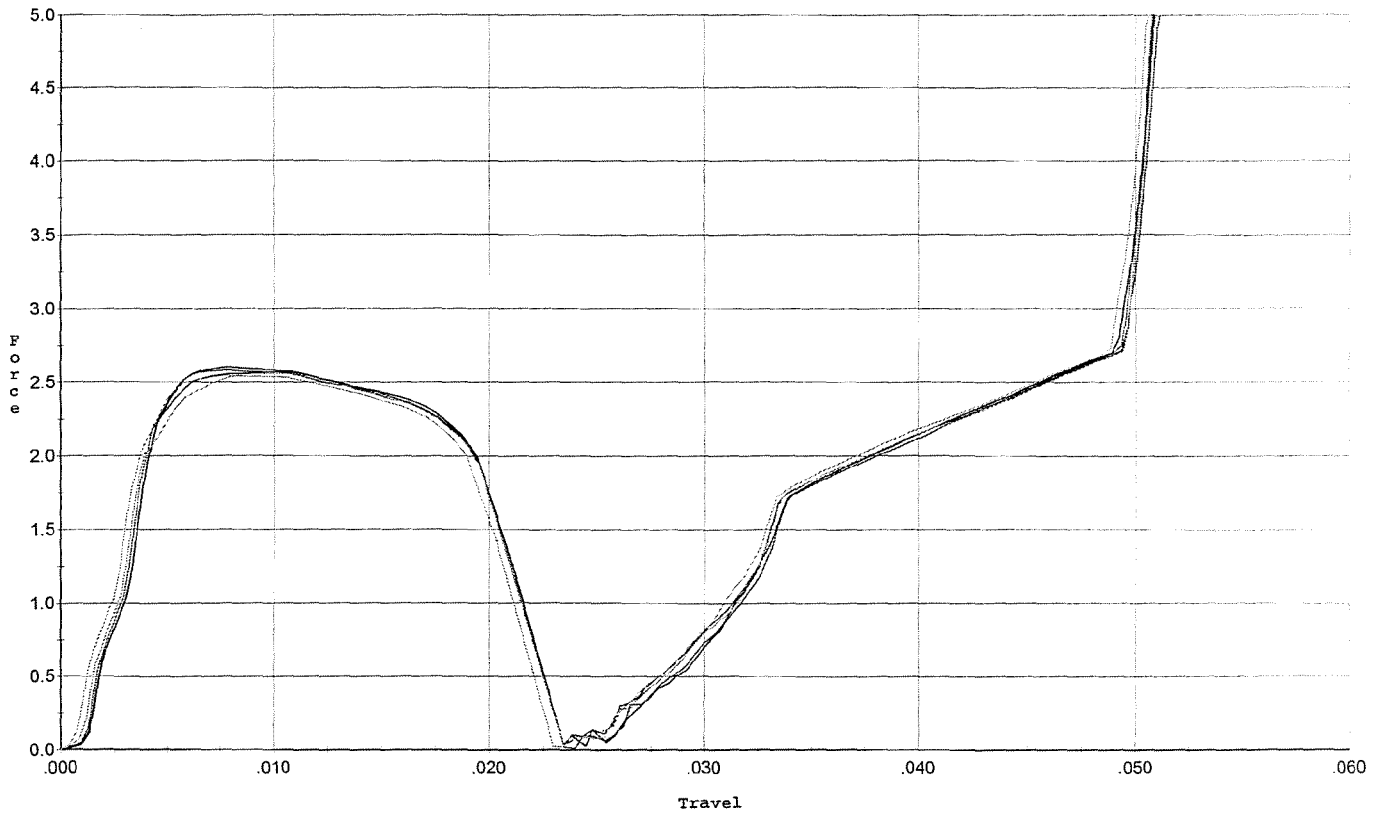
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.023	0.00	0.030	0.068		Set Trigger
2	4.064	0.024	0.00	0.030	0.070		Set Trigger
3	4.026	0.023	0.00	0.030	0.068		Set Trigger
4	4.009	0.022	0.00	0.030	0.066		Set Trigger
5	4.064	0.022	0.00	0.030	0.067		Set Trigger

Avg 4.05

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/20/09

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



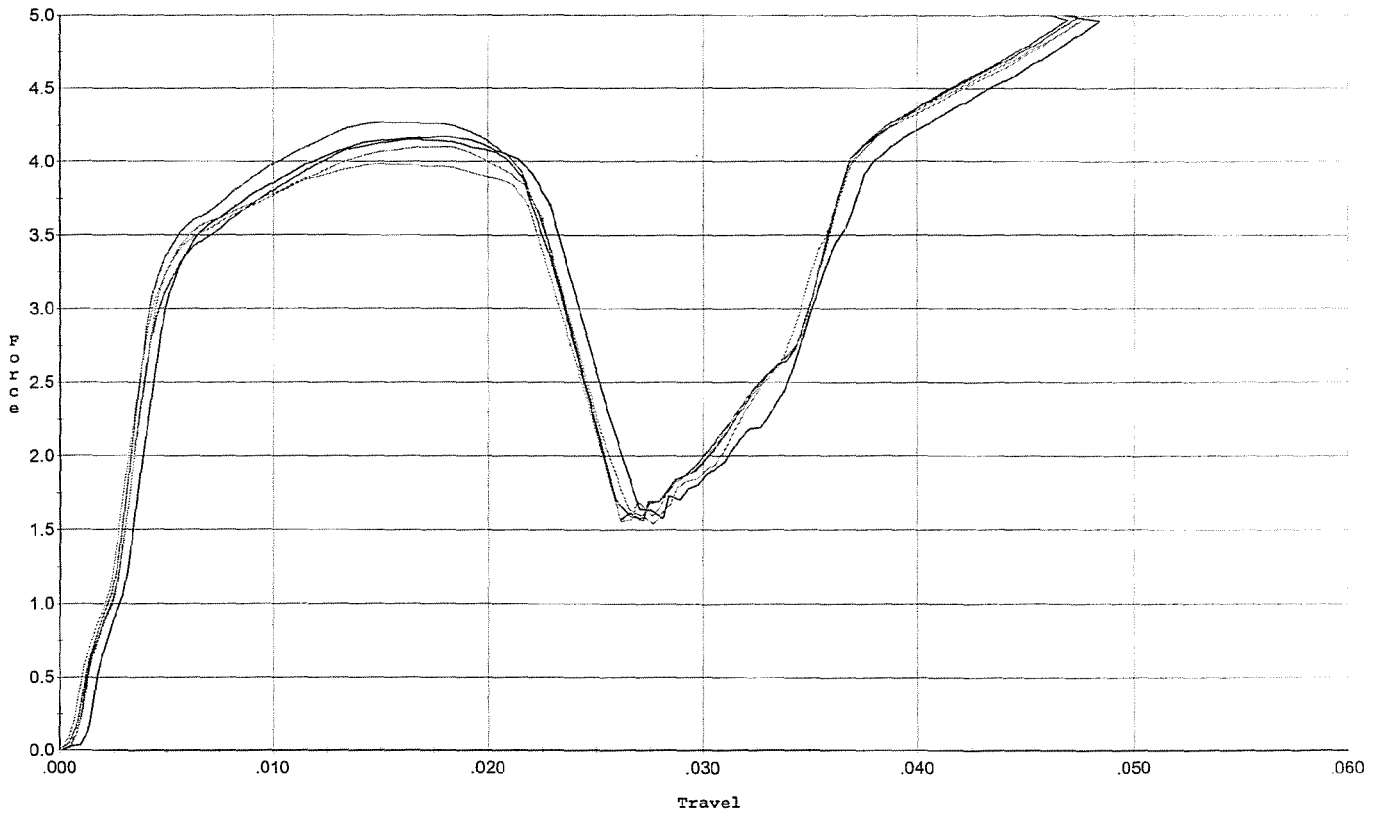
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.021	0.00	0.035	0.041		Set Trigger
2	2.602	0.021	0.00	0.035	0.041		Set Trigger
3	2.580	0.021	0.00	0.035	0.041		Set Trigger
4	2.545	0.020	0.00	0.035	0.040		Set Trigger
5	2.555	0.021	0.00	0.035	0.041		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 5/20/09

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.148	0.023	0.00	0.030	0.070		Set Trigger
2	4.168	0.023	0.00	0.031	0.070		Set Trigger
3	4.266	0.023	0.00	0.030	0.072		Set Trigger
4	3.982	0.024	0.00	0.030	0.072		Set Trigger
5	4.099	0.023	0.00	0.031	0.069		Set Trigger

Avg 4.13