

66863633

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

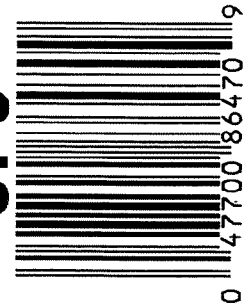
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863633

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 686 3633

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SP
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SP
460	CHECK HEADSPACE		6-10-09	RP
470	DIS-ASSEMBLE ACTION		6-10-09	RP
472	SERIALIZE BOLT HANDLE		6-10-09	RT
480	MAGNAFLUX BBL ACTION		6-13-09	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-16-09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6-16-09	RT
540	APPLY COATINGS (BARREL ACTION)		7/2	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-8-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-8-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-8-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-25-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

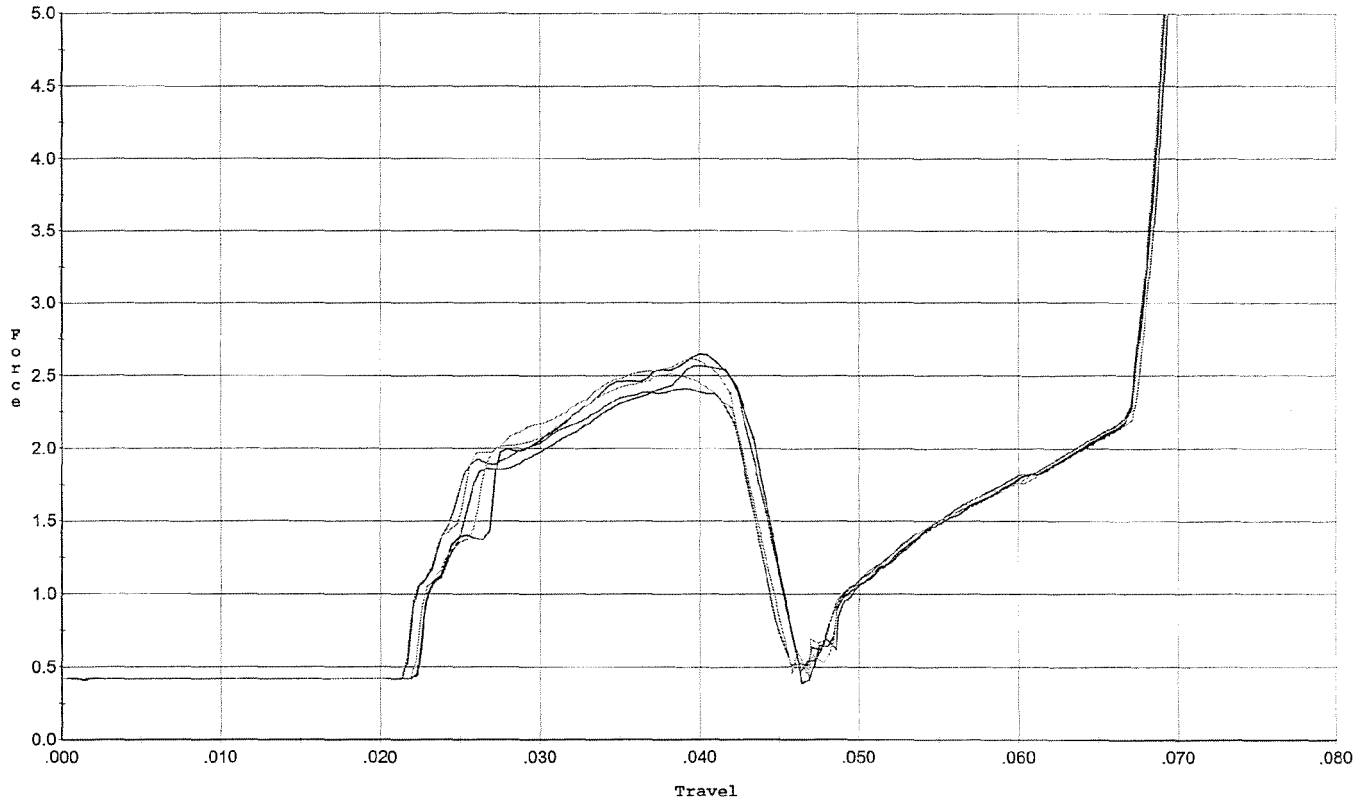
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>29</u> <u>29</u> <u>29</u>	8/28/09	RB
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>69</u> <u>69</u> <u>69</u>	8/28/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>023</u> <u>023</u> <u>023</u>	8/28/09	RB
	J) ASSEMBLE STOCK		8-25-09	X.N.
	K) ASSEMBLE SWIVEL STUDS		8/28/09	RB
	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	8-26-09	RPD
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-26-09	RP
670	FINAL INSPECTION A) HEADSPACE		8/28/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.54</u> <u>2.53</u> <u>2.46</u> <u>2.41</u>	8/27/09	RB
	C) FUNCTION		8/27/09	RB
690	PACK		8-28-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



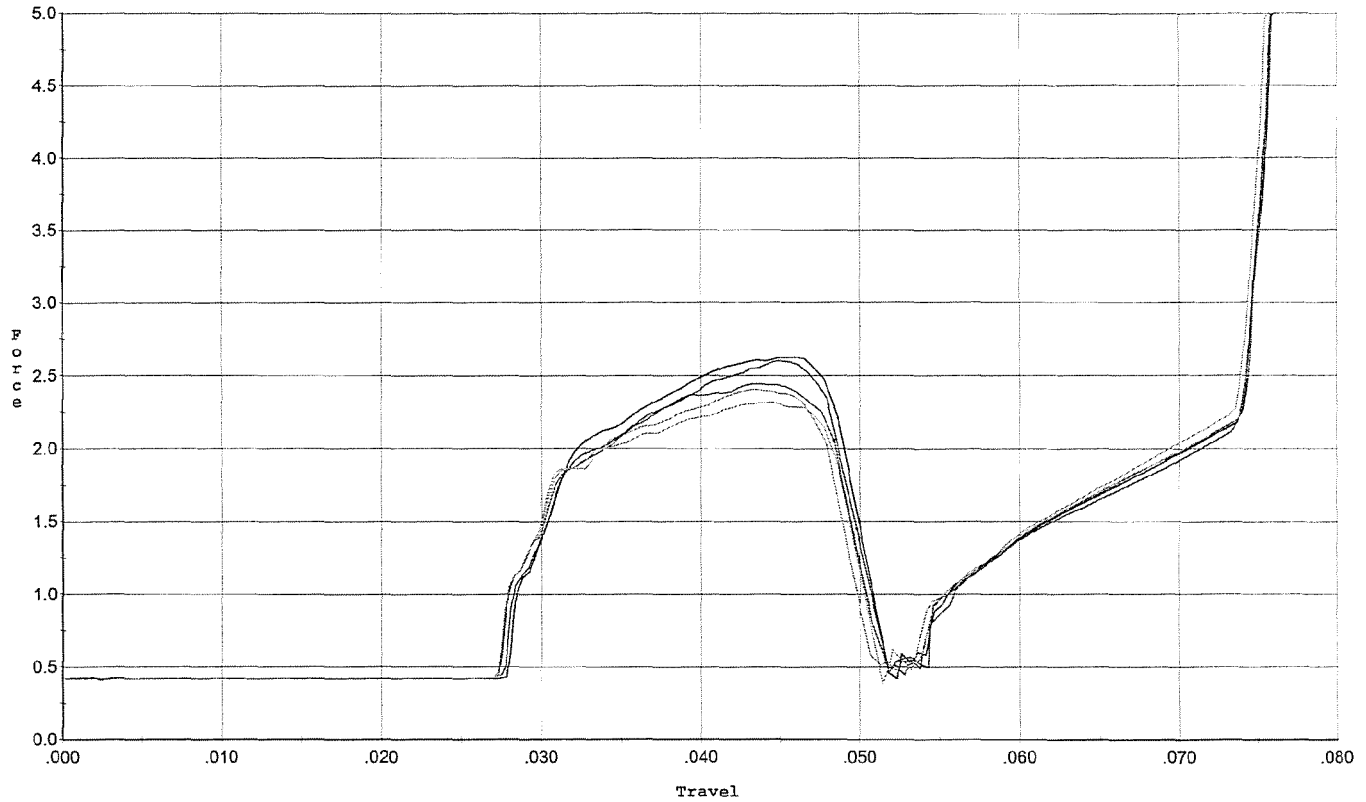
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.044	0.023	0.030	0.053		Set Trigger
2	2.649	0.043	0.023	0.029	0.053		Set Trigger
3	2.412	0.042	0.022	0.030	0.051		Set Trigger
4	2.513	0.042	0.022	0.030	0.051		Set Trigger
5	2.615	0.042	0.022	0.030	0.053		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



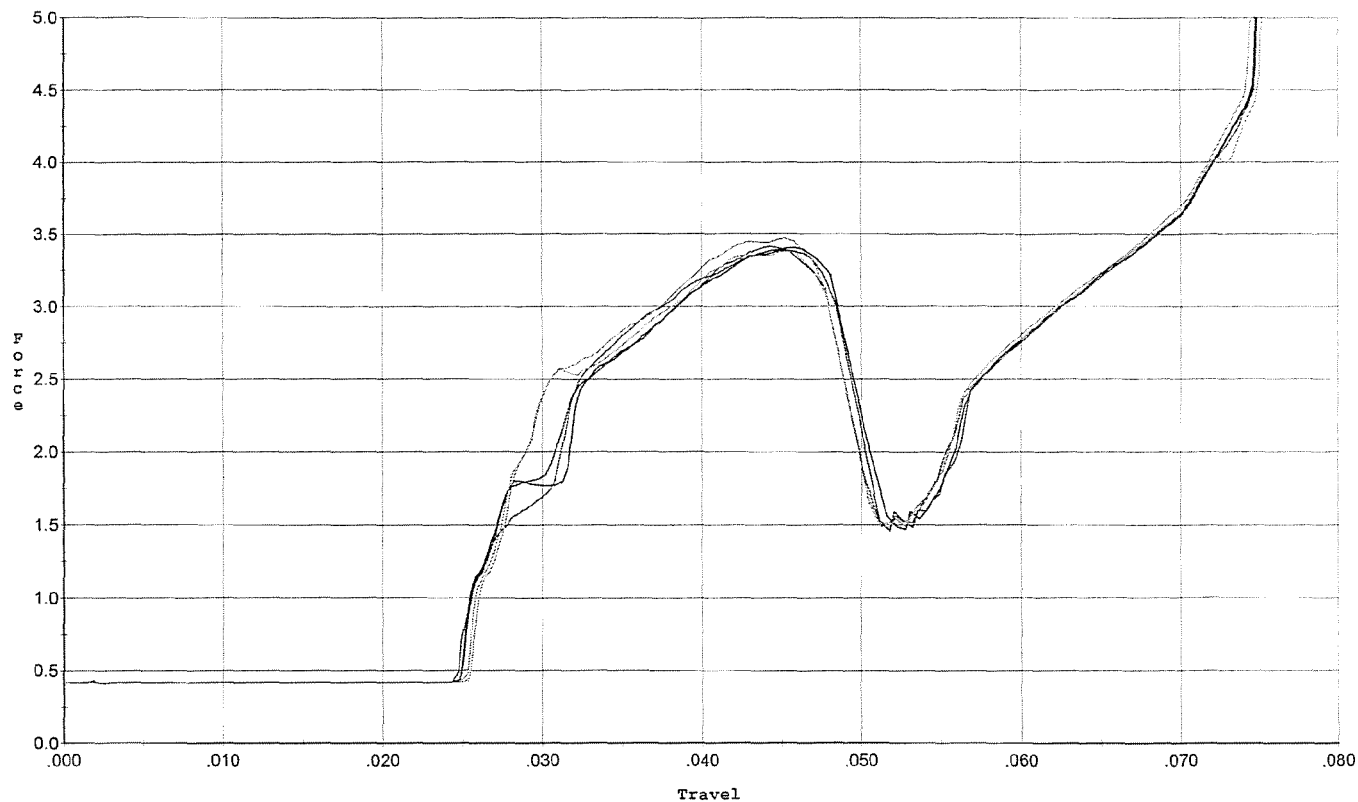
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.050	0.028	0.031	0.058		Set Trigger
2	2.628	0.049	0.028	0.031	0.058		Set Trigger
3	2.445	0.048	0.028	0.031	0.055		Set Trigger
4	2.320	0.049	0.028	0.031	0.054		Set Trigger
5	2.407	0.048	0.028	0.032	0.054		Set Trigger

A. 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



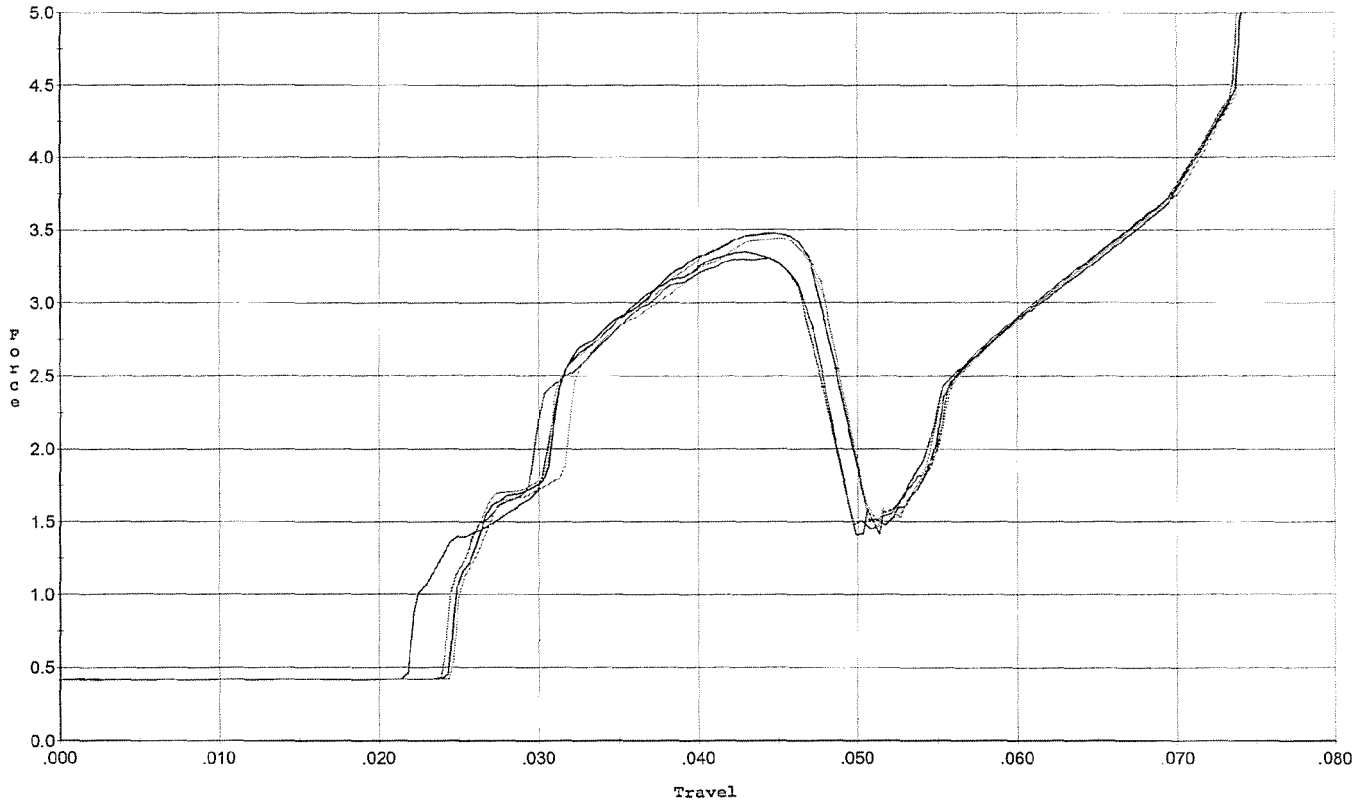
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.384	0.048	0.025	0.029	0.073		Set Trigger
2	3.404	0.048	0.025	0.029	0.072		Set Trigger
3	3.414	0.048	0.025	0.030	0.071		Set Trigger
4	3.380	0.048	0.025	0.029	0.073		Set Trigger
5	3.470	0.048	0.026	0.029	0.073		Set Trigger

A-3-41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



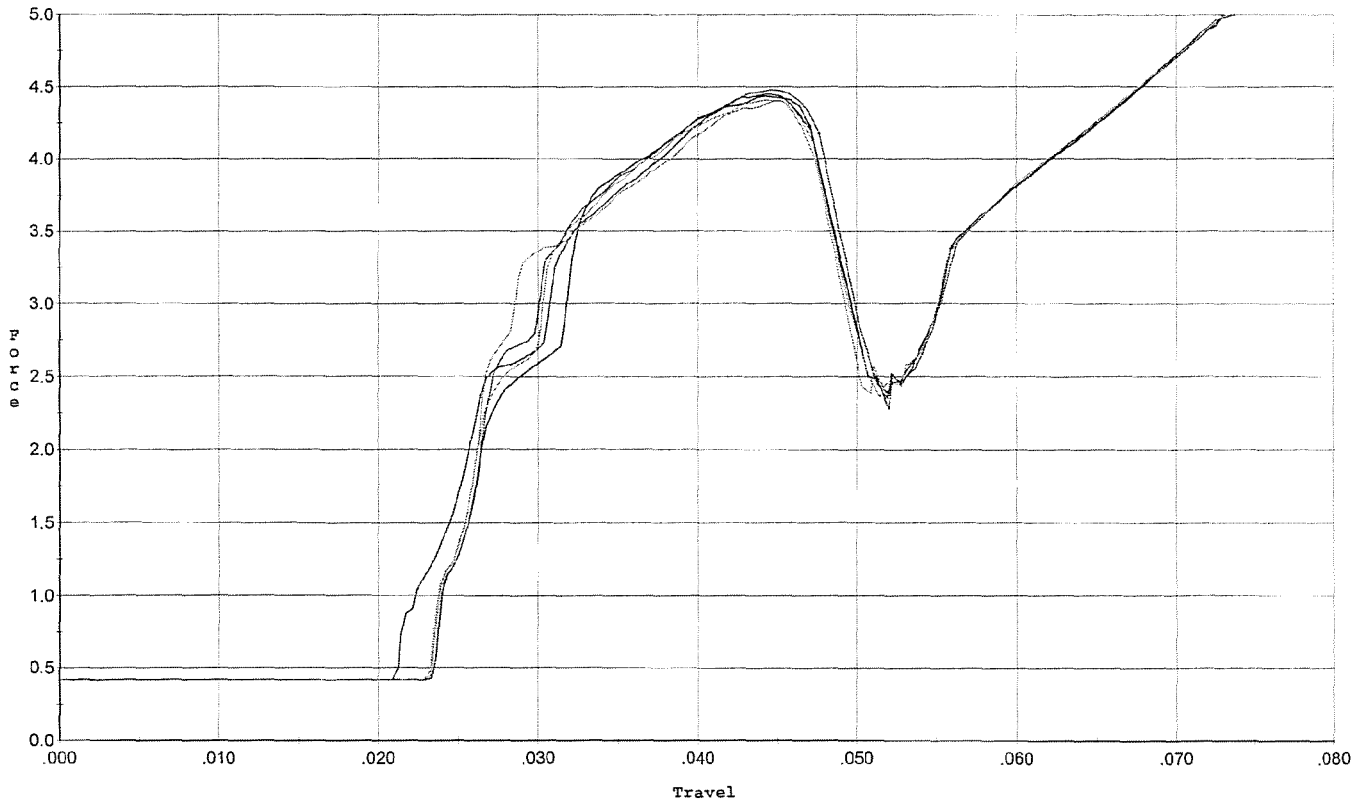
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.348	0.047	0.022	0.029	0.072		Set Trigger
2	3.476	0.049	0.025	0.029	0.075		Set Trigger
3	3.304	0.048	0.024	0.029	0.071		Set Trigger
4	3.442	0.048	0.025	0.029	0.072		Set Trigger
5	3.472	0.048	0.024	0.028	0.074		Set Trigger

A.3-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



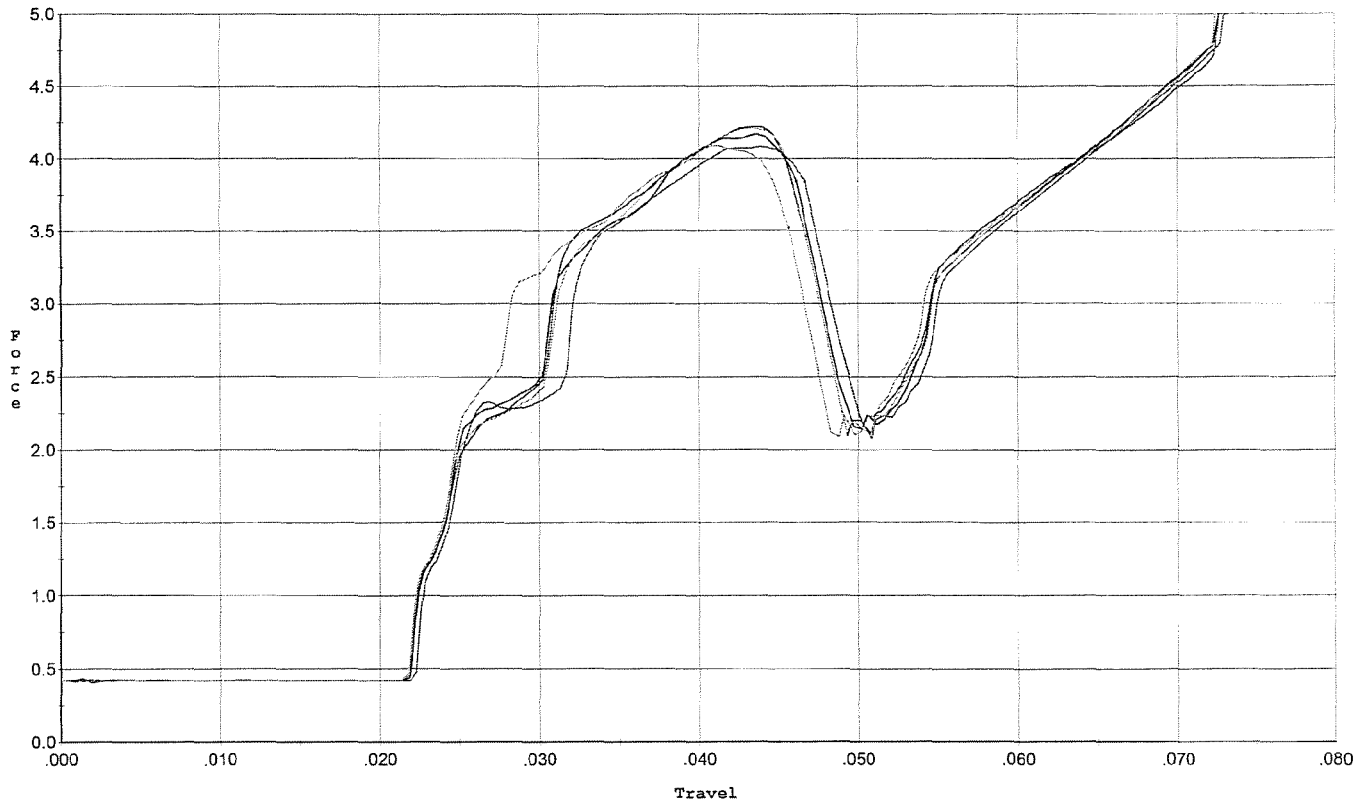
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.450	0.049	0.021	0.026	0.099		Set Trigger
2	4.438	0.047	0.024	0.027	0.092		Set Trigger
3	4.478	0.048	0.024	0.026	0.096		Set Trigger
4	4.409	0.047	0.023	0.027	0.094		Set Trigger
5	4.403	0.047	0.023	0.026	0.094		Set Trigger

A 4-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



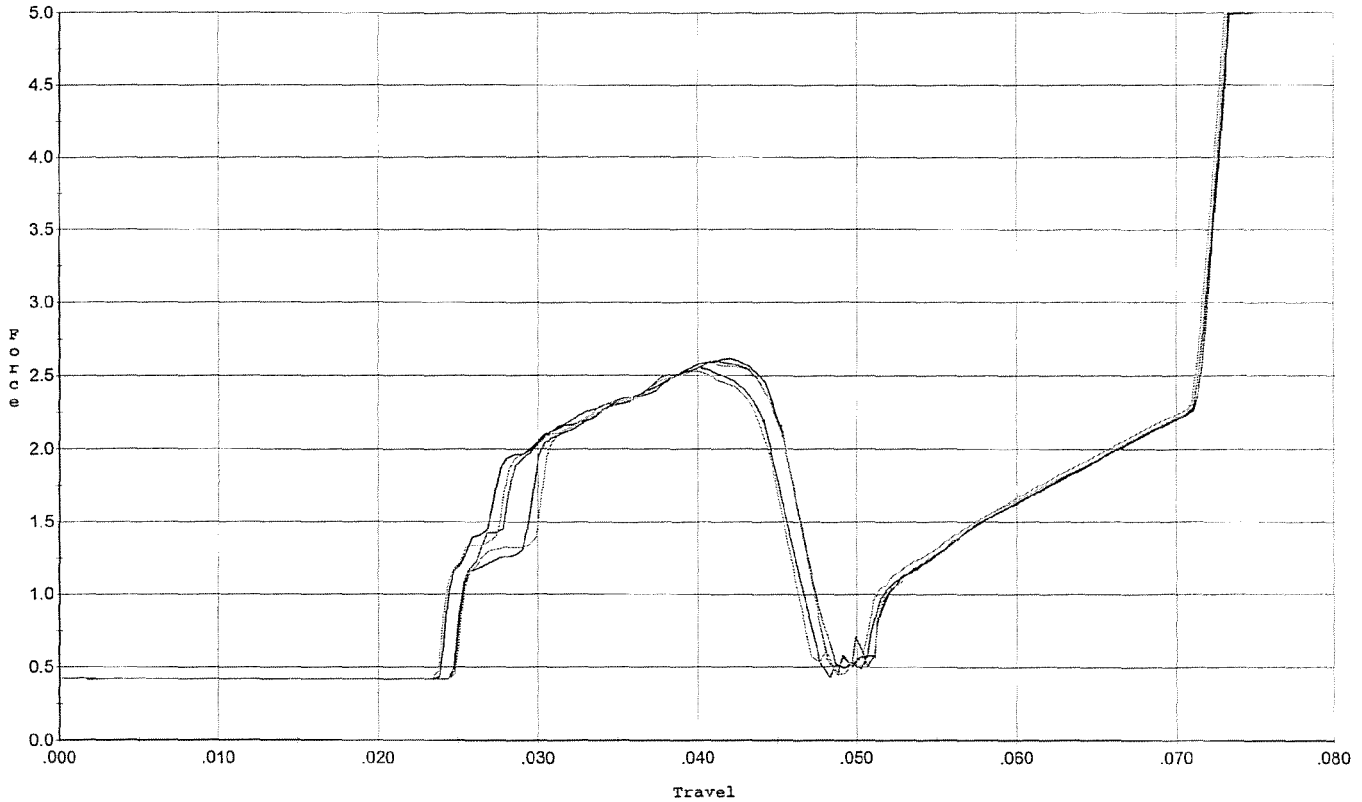
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.220	0.047	0.022	0.027	0.088		Set Trigger
2	4.169	0.046	0.022	0.027	0.087		Set Trigger
3	4.081	0.047	0.022	0.027	0.086		Set Trigger
4	4.208	0.047	0.022	0.027	0.087		Set Trigger
5	4.088	0.046	0.022	0.028	0.086		Set Trigger

A.4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

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



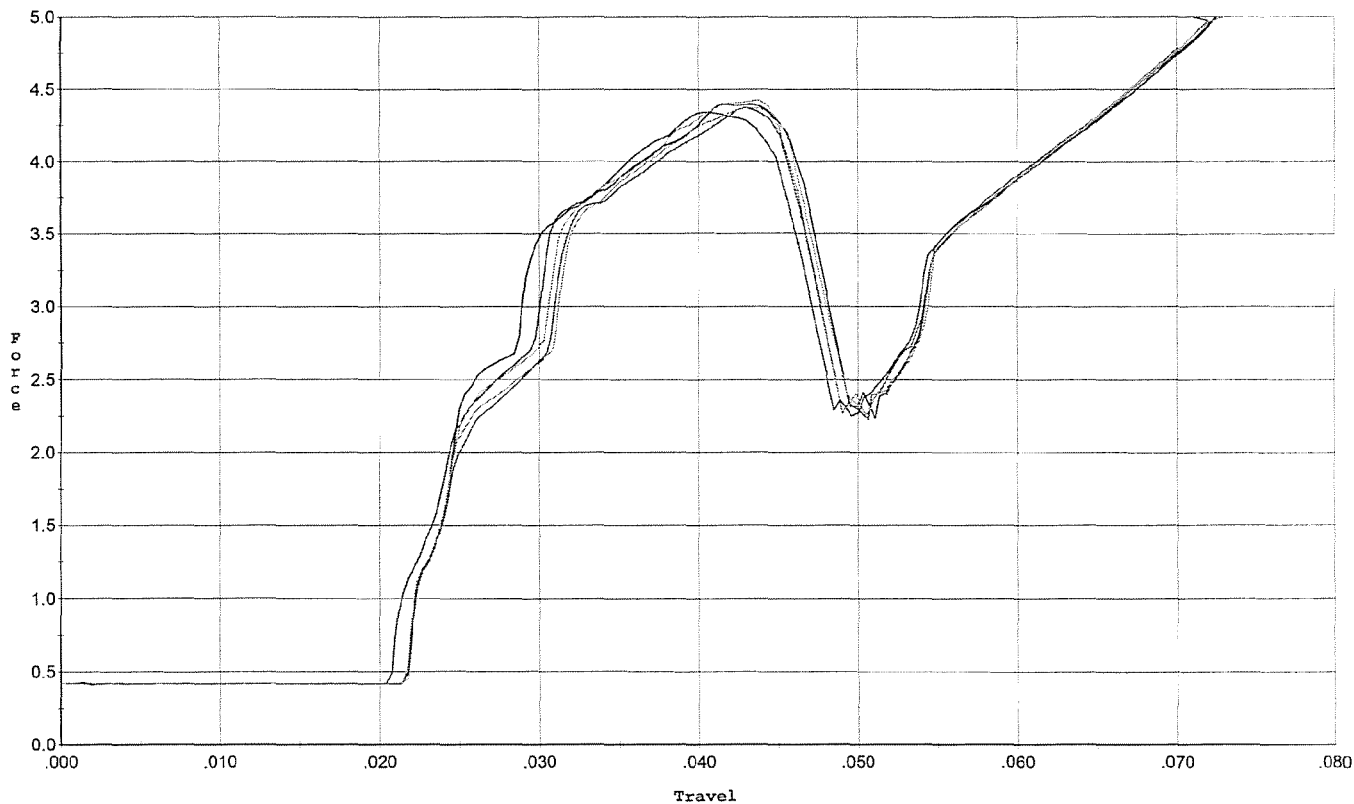
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.551	0.044	0.025	0.033	0.050		Set Trigger
2	2.618	0.045	0.024	0.032	0.056		Set Trigger
3	2.605	0.045	0.025	0.032	0.055		Set Trigger
4	2.580	0.045	0.025	0.031	0.053		Set Trigger
5	2.529	0.045	0.024	0.032	0.053		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/24/2009

Model: M/24
Serial No: Form #F005
Trigger: set ti 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	4.342	0.046	0.021	0.027	0.092		Set Trigger
2	4.398	0.047	0.022	0.026	0.095		Set Trigger
3	4.372	0.047	0.022	0.027	0.090		Set Trigger
4	4.425	0.046	0.022	0.027	0.091		Set Trigger
5	4.371	0.046	0.022	0.027	0.090		Set Trigger

A-4.38