

G6863653

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



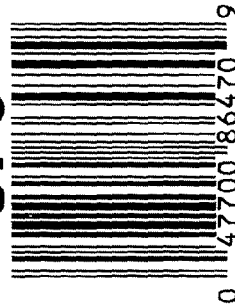
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863653

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6863653

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	MAGNA FLUX	6-10-09	SP
470	DIS-ASSEMBLE ACTION		6-10-09	SP
472	SERIALIZE BOLT HANDLE		6-11-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	6-13-09	
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	RTW
540	APPLY COATINGS (BARREL ACTION)		6/24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-11-09	R.N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

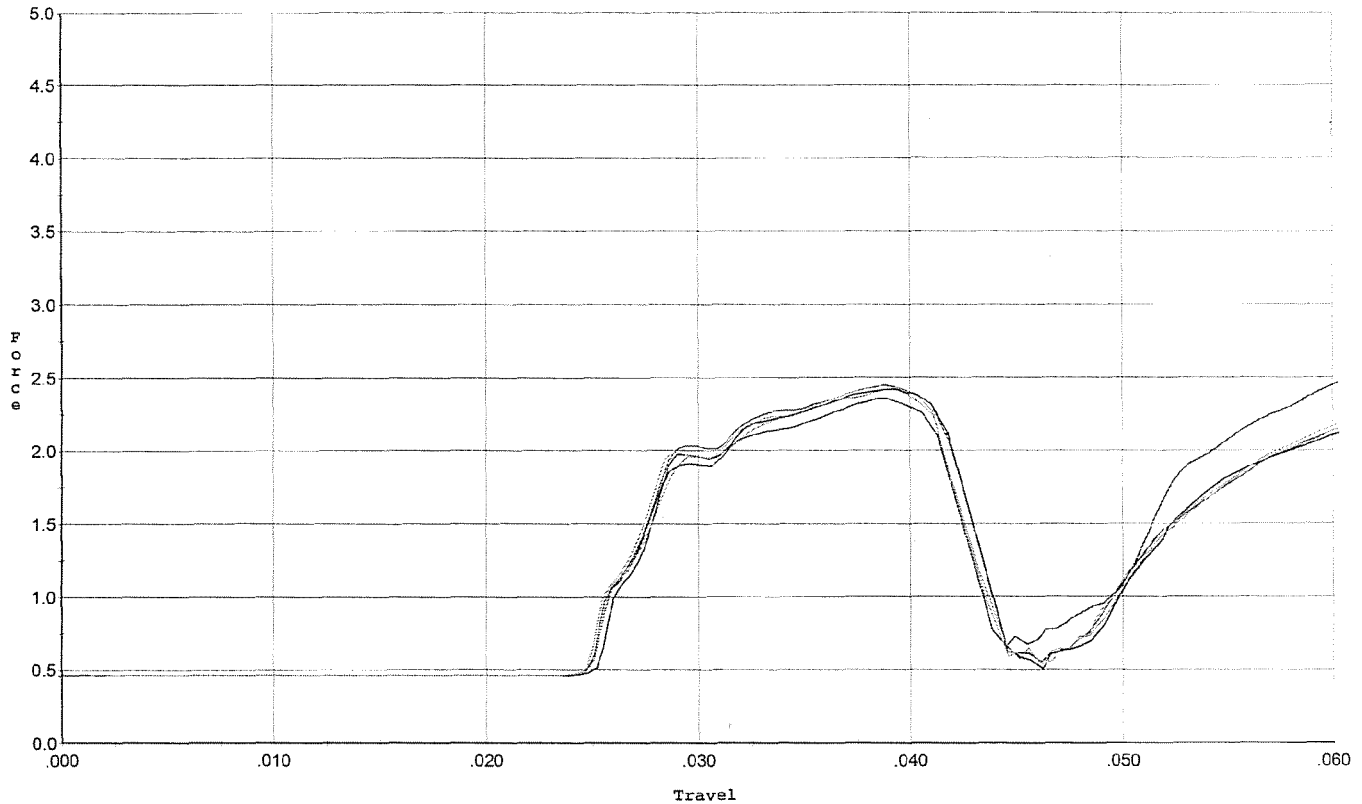
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	8/24/09	RB
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4°</u> <u>5°</u> <u>4°</u>	8/20/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>023</u> <u>024</u> <u>024</u>	8/20/09	RB
	J) ASSEMBLE STOCK		8-11-09	LN
	K) ASSEMBLE SWIVEL STUDS		8/20/09	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	8-18-09	LN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-18-09	LN
670	FINAL INSPECTION A) HEADSPACE		8/20/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>240</u> <u>259</u> <u>238</u> <u>249</u> <u>240</u>	8-20-09	LN
	C) FUNCTION		8/20/09	RB
690	PACK		8/21/09	FN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



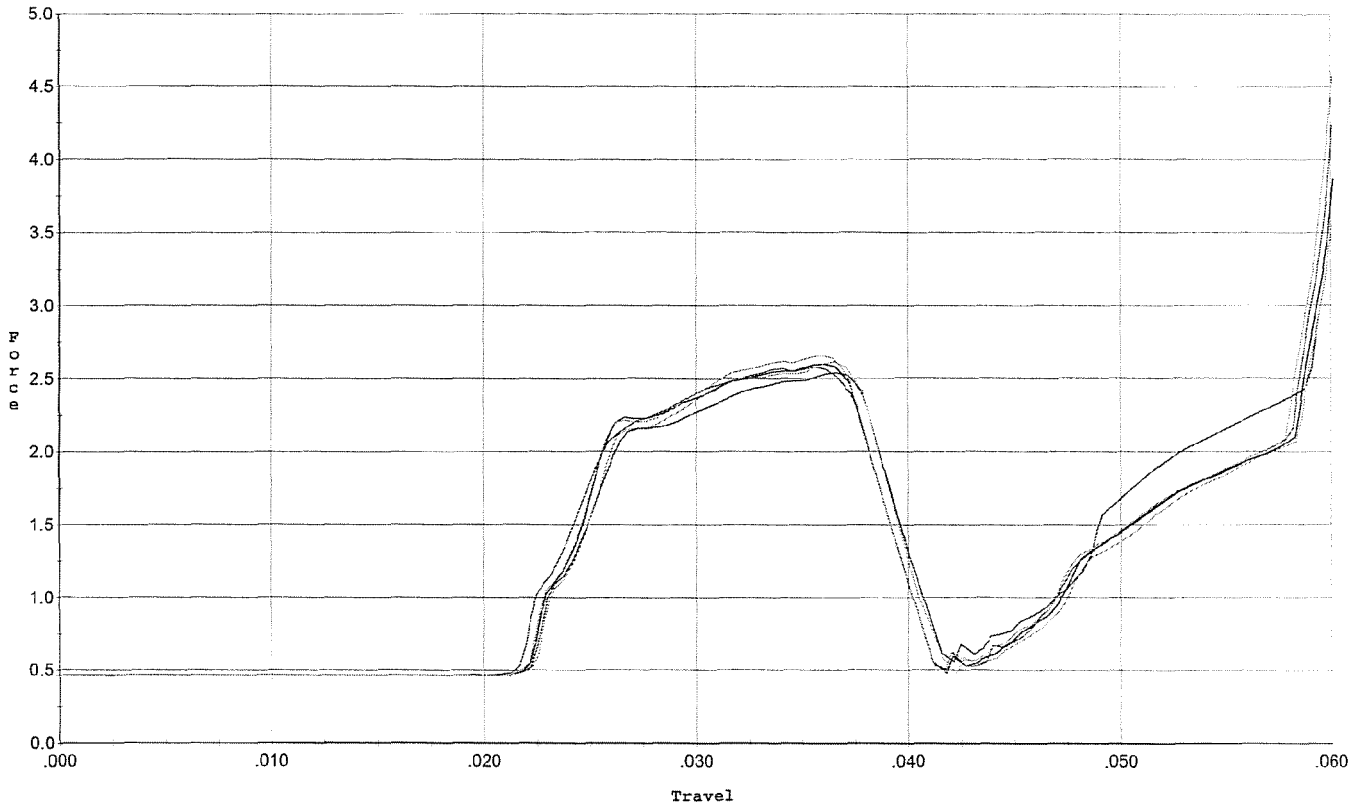
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.358	0.041	0.025	0.028	0.044		Set Trigger
2	2.420	0.042	0.026	0.027	0.046		Set Trigger
3	2.451	0.042	0.025	0.027	0.046		Set Trigger
4	2.447	0.041	0.025	0.027	0.045		Set Trigger
5	2.415	0.041	0.025	0.027	0.044		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



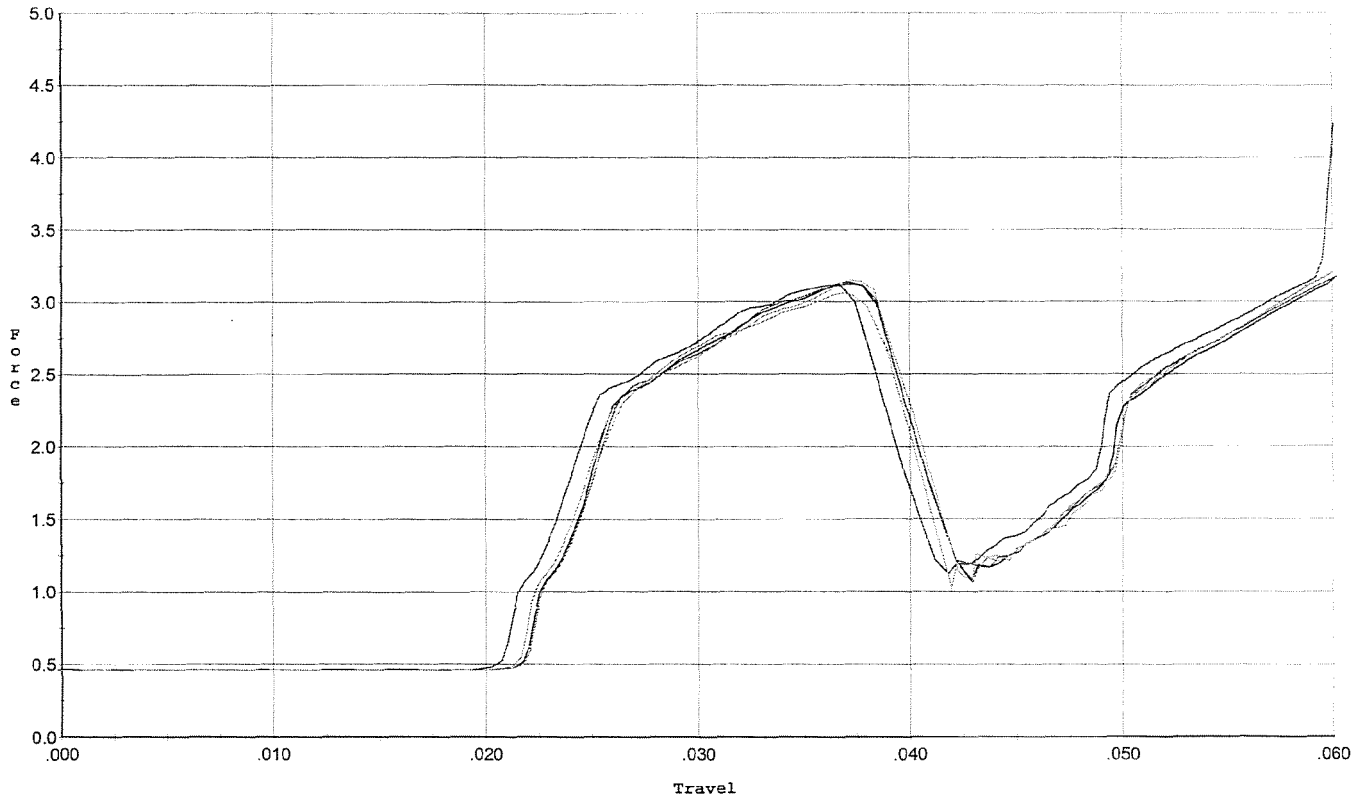
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.038	0.022	0.026	0.044		Set Trigger
2	2.598	0.037	0.022	0.026	0.044		Set Trigger
3	2.580	0.037	0.022	0.026	0.044		Set Trigger
4	2.614	0.038	0.023	0.026	0.044		Set Trigger
5	2.658	0.037	0.022	0.026	0.044		Set Trigger

A-2.59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



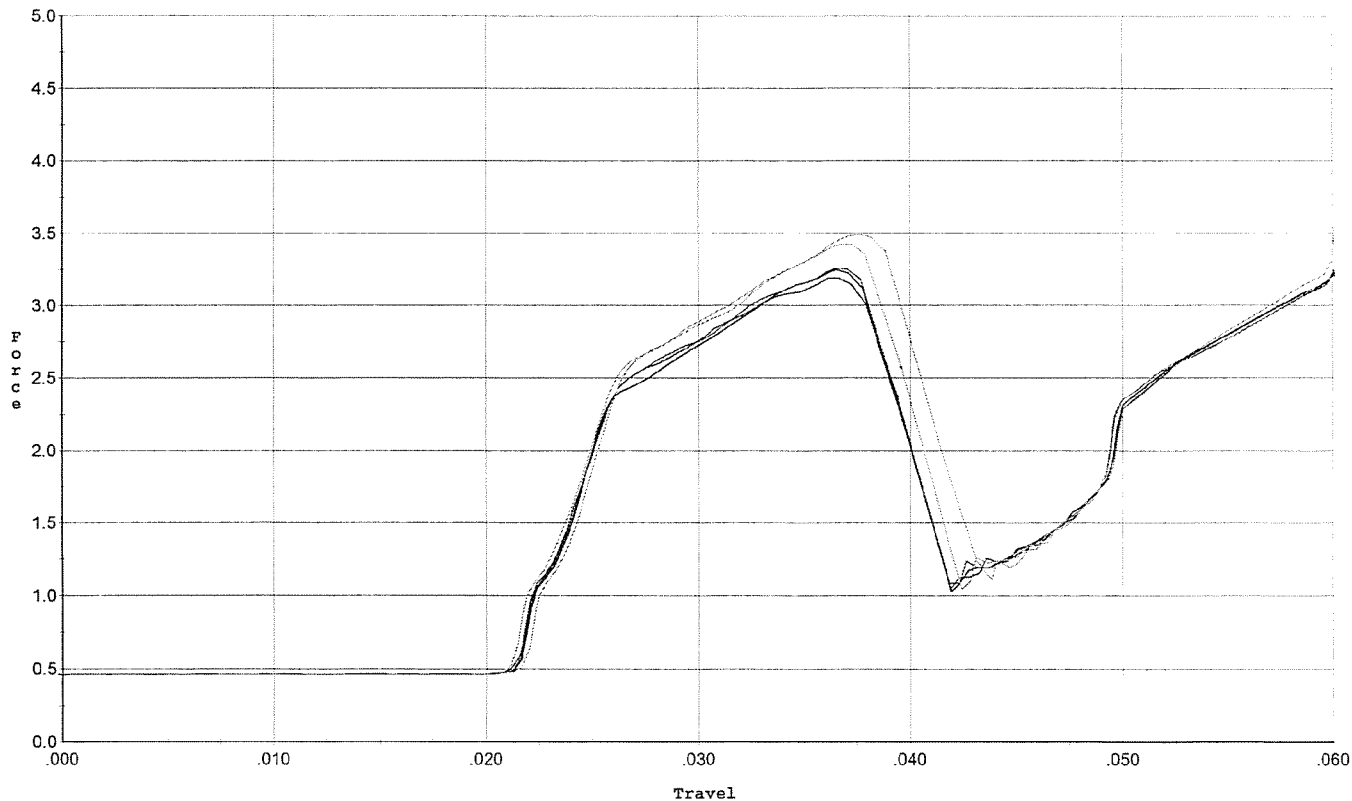
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.115	0.037	0.021	0.025	0.052		Set Trigger
2	3.128	0.038	0.022	0.025	0.052		Set Trigger
3	3.118	0.038	0.022	0.025	0.052		Set Trigger
4	3.147	0.040	0.022	0.025	0.054		Set Trigger
5	3.062	0.039	0.022	0.025	0.053		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 8/10/2009

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



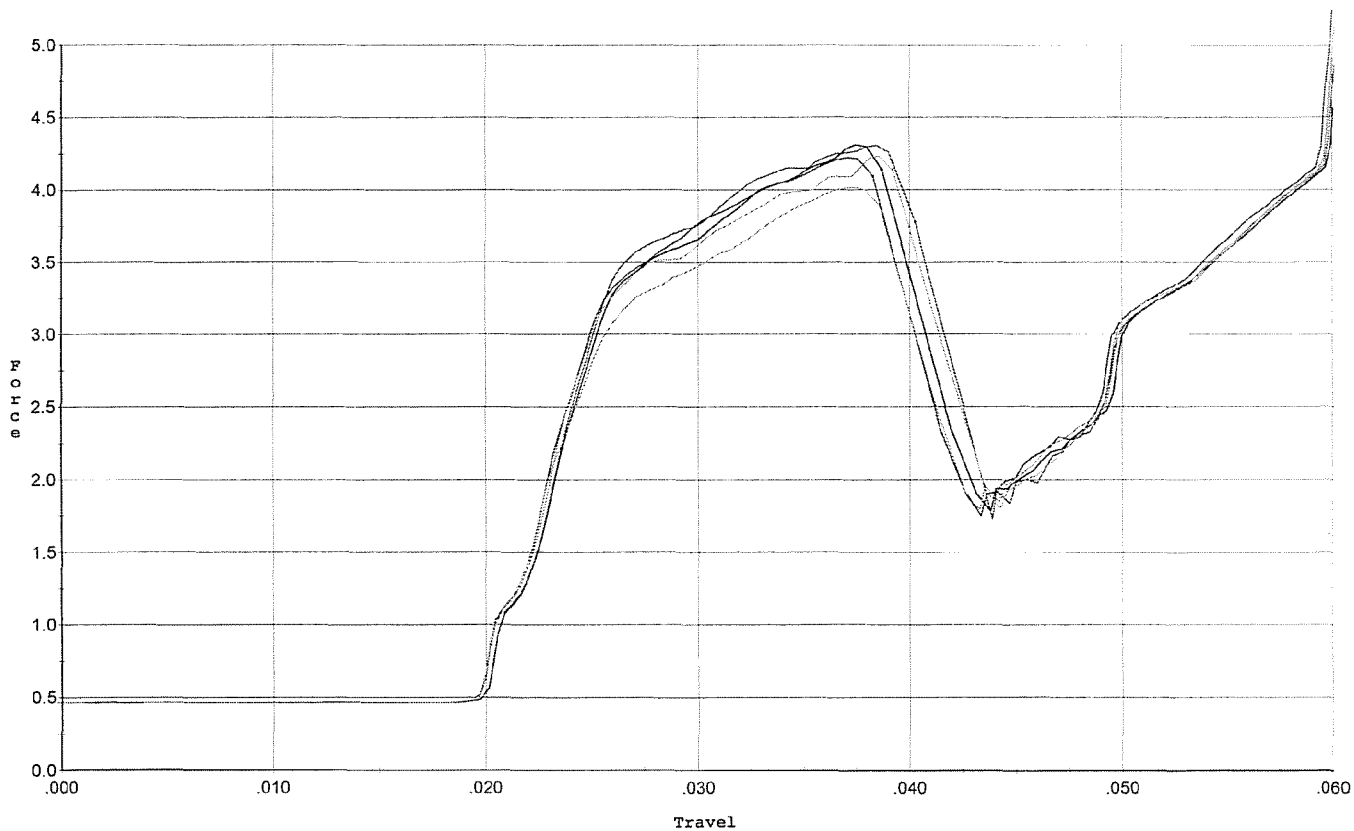
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.191	0.040	0.022	0.025	0.055		Set Trigger
2	3.247	0.039	0.022	0.025	0.055		Set Trigger
3	3.258	0.039	0.022	0.025	0.055		Set Trigger
4	3.423	0.040	0.021	0.025	0.058		Set Trigger
5	3.491	0.039	0.022	0.025	0.058		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



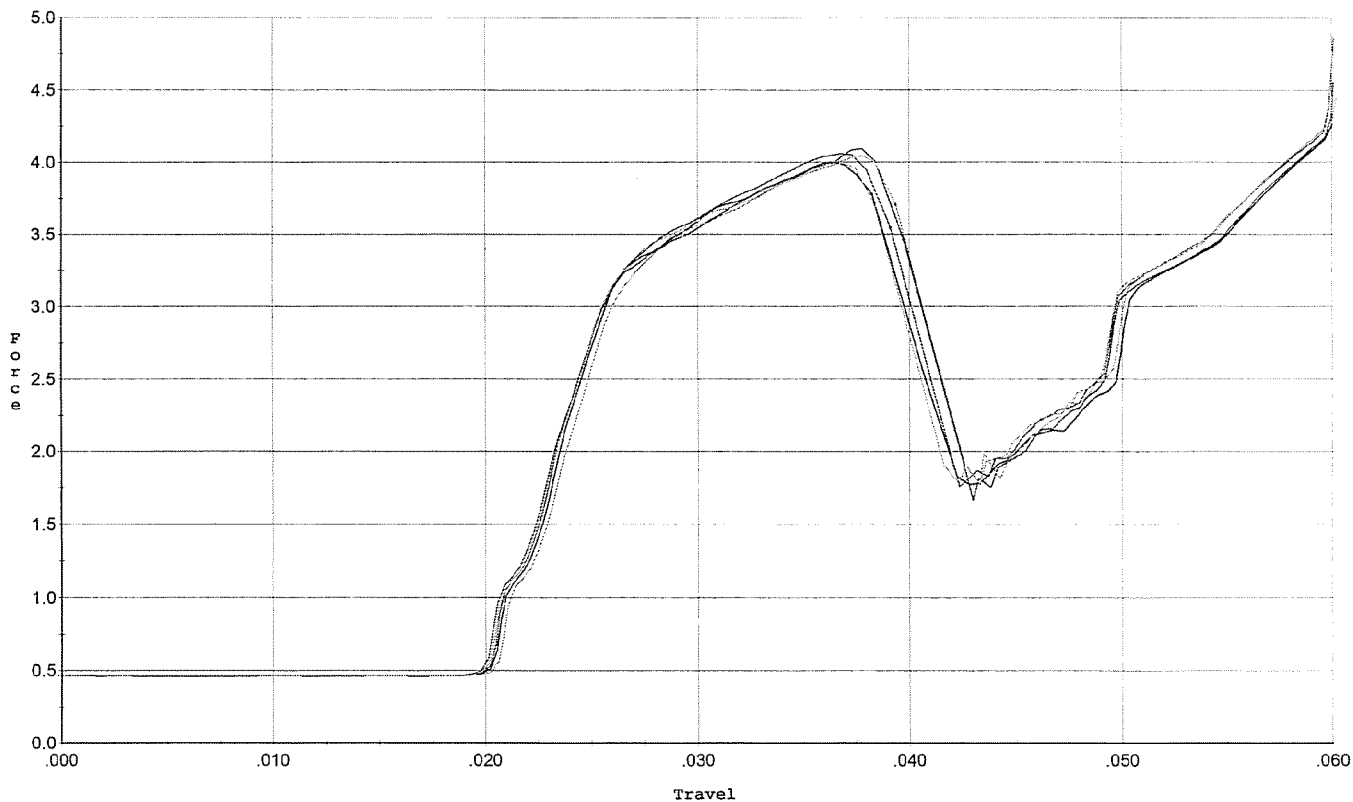
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.038	0.020	0.023	0.071		Set Trigger
2	4.309	0.039	0.020	0.023	0.072		Set Trigger
3	4.306	0.040	0.020	0.022	0.078		Set Trigger
4	4.233	0.039	0.020	0.022	0.074		Set Trigger
5	4.019	0.039	0.020	0.023	0.069		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



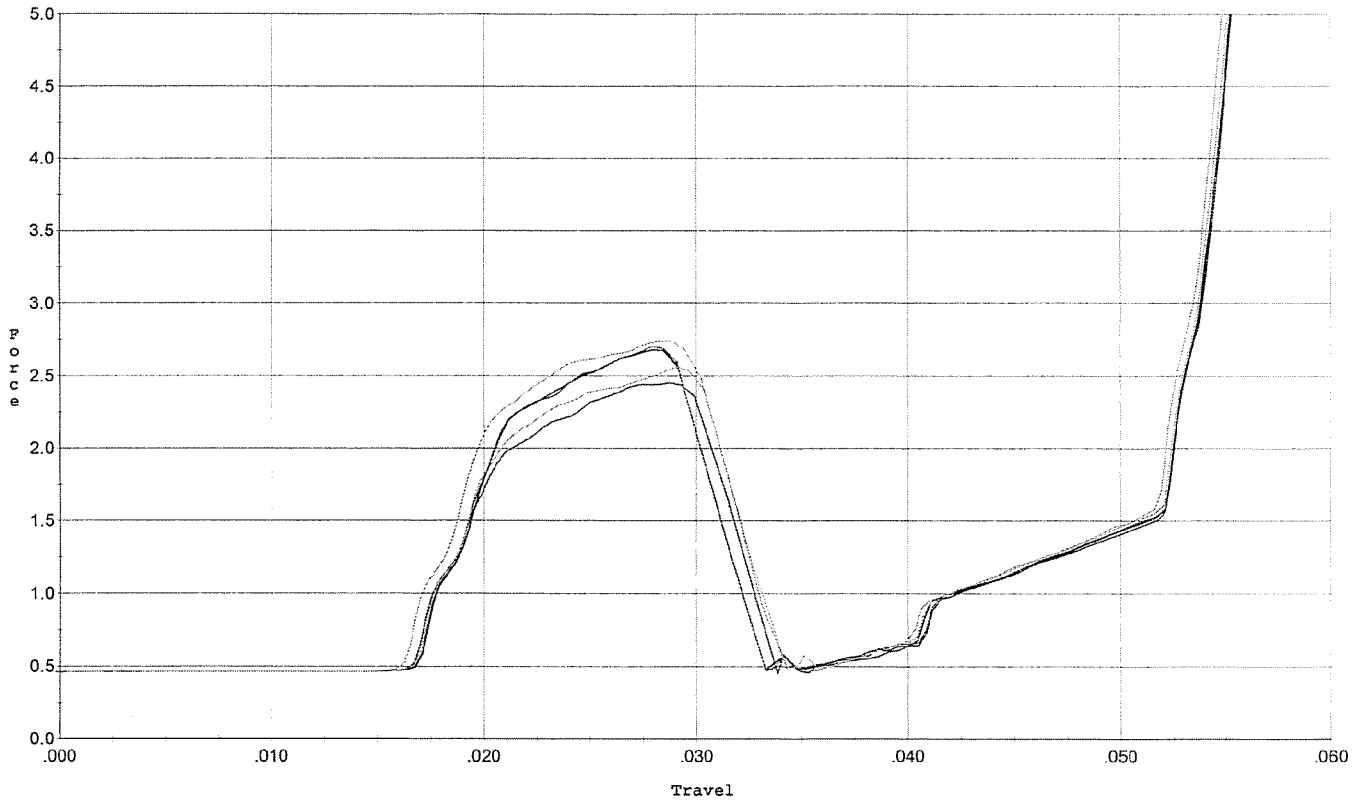
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.040	0.020	0.023	0.072		Set Trigger
2	4.001	0.038	0.021	0.023	0.067		Set Trigger
3	4.059	0.039	0.020	0.023	0.070		Set Trigger
4	3.994	0.038	0.020	0.023	0.068		Set Trigger
5	4.045	0.039	0.021	0.023	0.070		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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



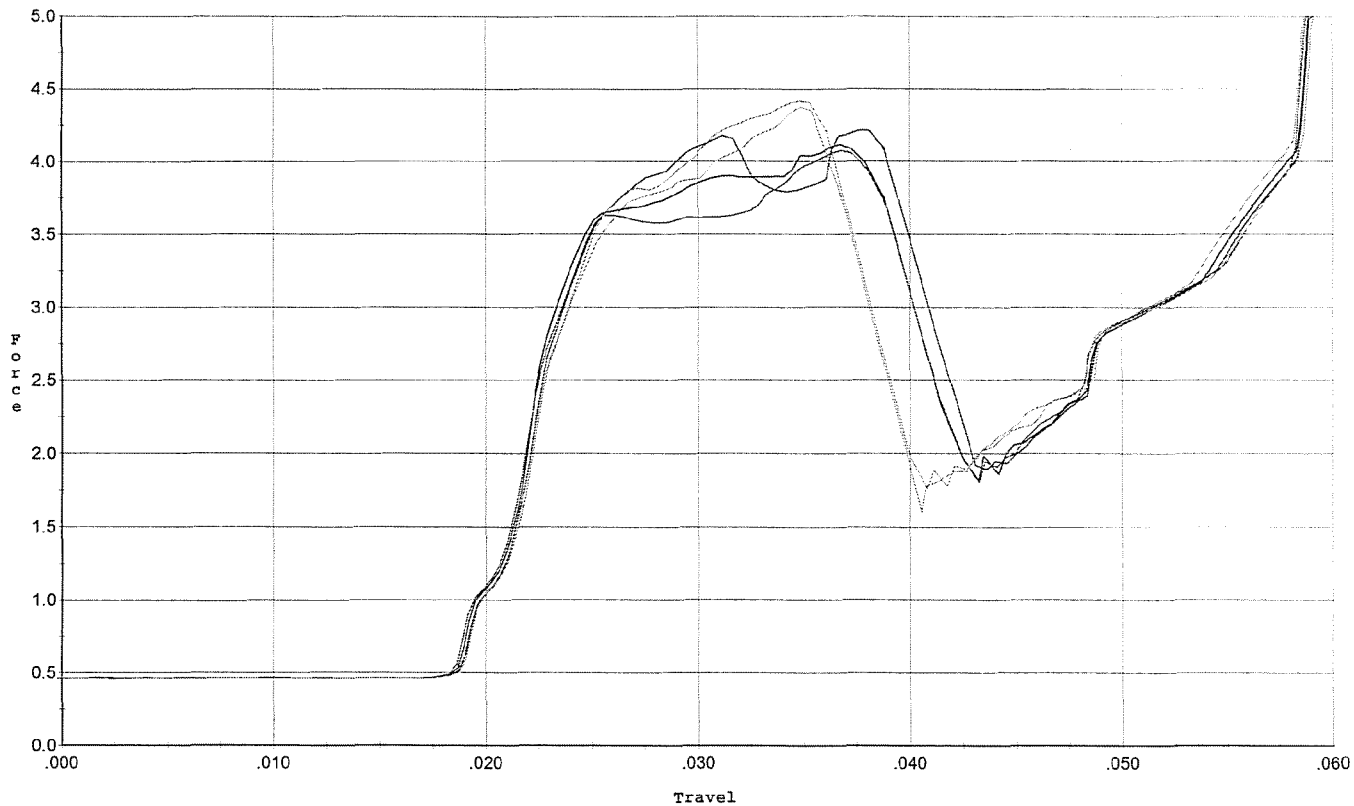
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.032	0.017	0.027	0.037		Set Trigger
2	2.679	0.029	0.017	0.028	0.035		Set Trigger
3	2.701	0.029	0.017	0.028	0.035		Set Trigger
4	2.560	0.030	0.017	0.027	0.036		Set Trigger
5	2.742	0.030	0.017	0.027	0.039		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 8/10/2009

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	4.215	0.039	0.019	0.022	0.077		Set Trigger
2	4.117	0.039	0.019	0.022	0.076		Set Trigger
3	4.074	0.039	0.019	0.022	0.074		Set Trigger
4	4.374	0.037	0.019	0.023	0.068		Set Trigger
5	4.420	0.036	0.019	0.023	0.068		Set Trigger

A-4.24