

G686 3657

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

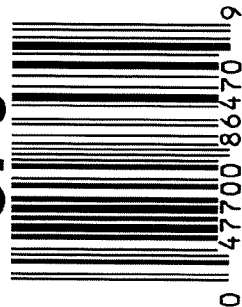
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

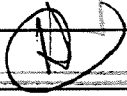
G6863657

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6863657

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SP
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5-21-09	SP
470	DIS-ASSEMBLE ACTION	MAY 20 2009	5-21-09	SP
472	SERIALIZE BOLT HANDLE		5-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/29/09	(N)
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)		6/9	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-9-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-9-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-9-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-11-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

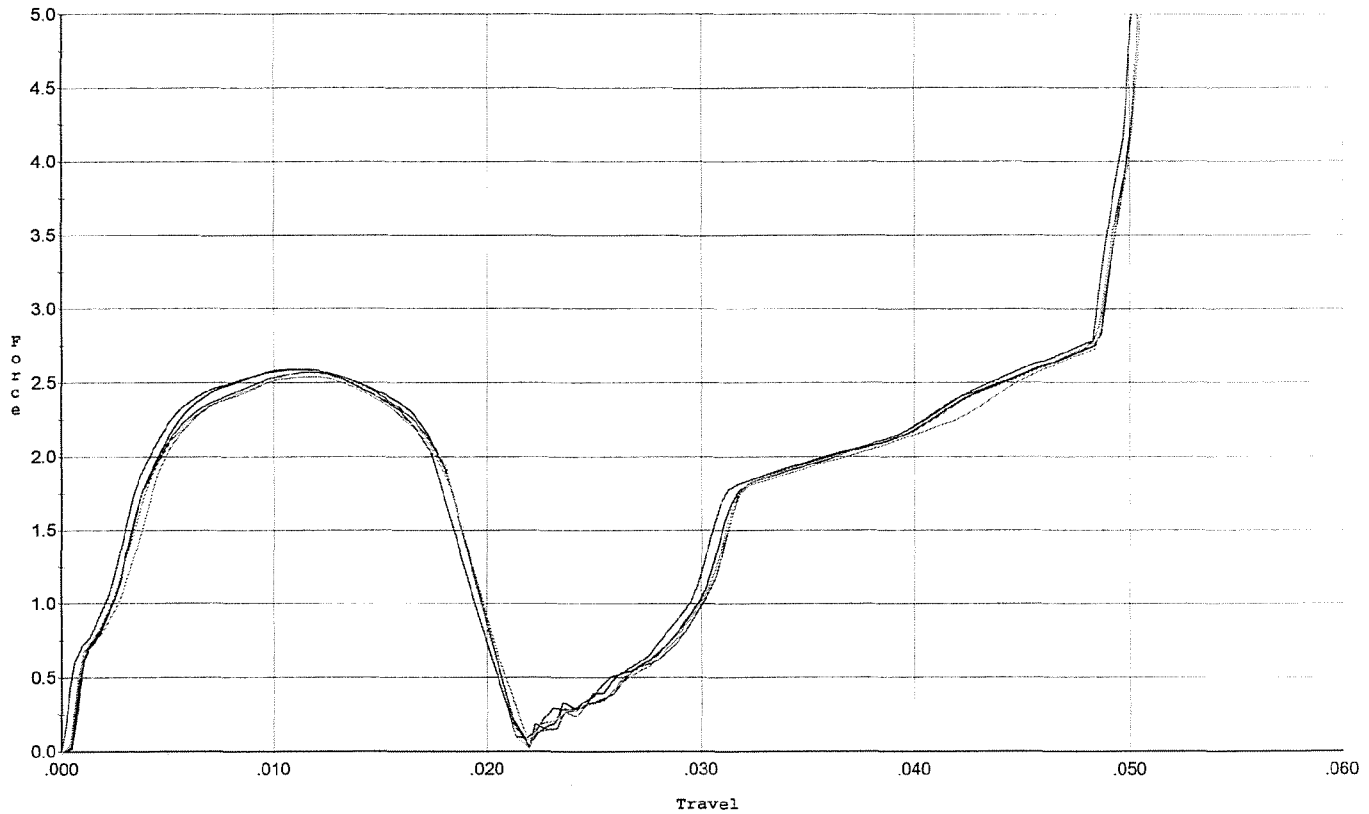
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-18-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-18-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.032</u> <u>.032</u> <u>.032</u>	6-18-09	L.N.
	J) ASSEMBLE STOCK		6-11-09	L.N.
	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	TAR
670	FINAL INSPECTION A) HEADSPACE		6-18-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.53</u> <u>2.45</u> <u>2.75</u> <u>2.67</u>	6-18-09	L.N.
	C) FUNCTION		6-18-09	L.N.
690	PACK		7/24/09	Em

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



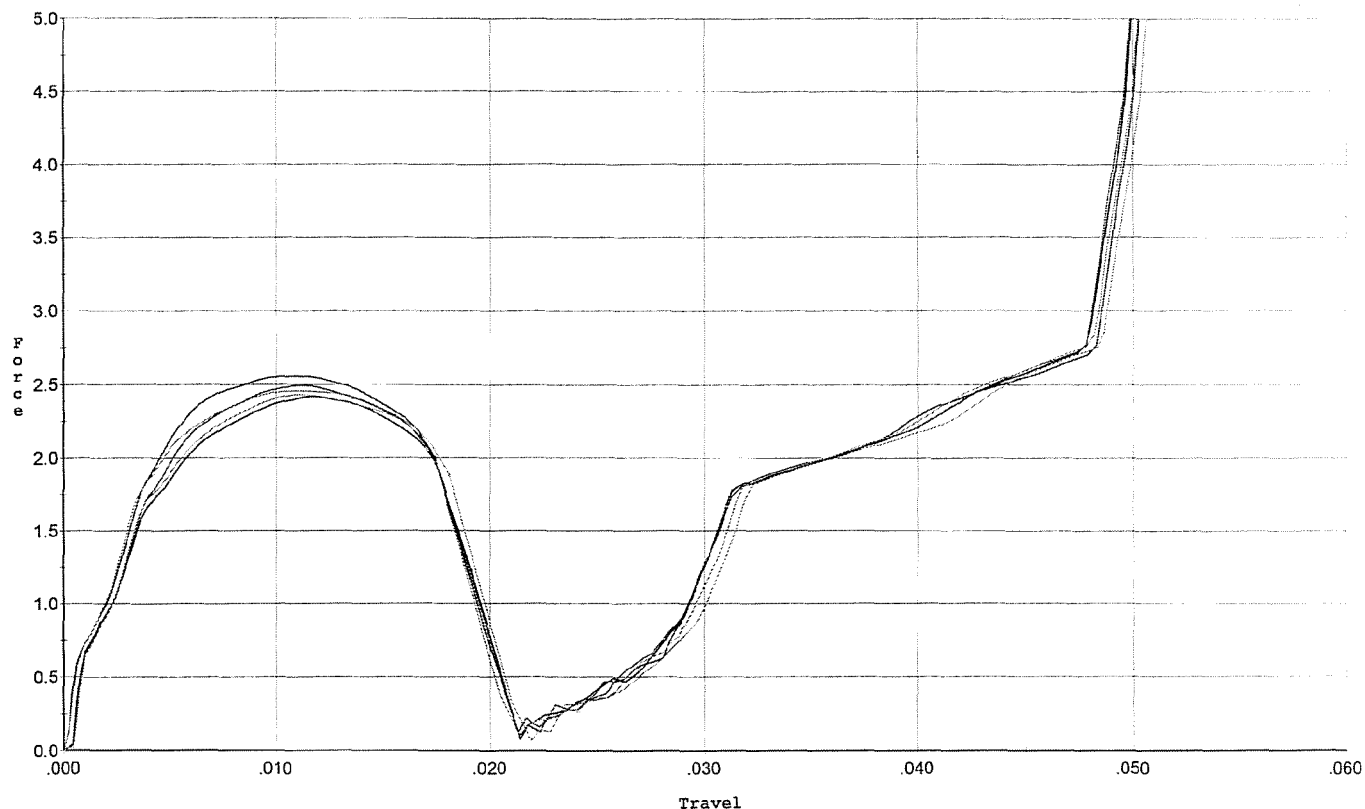
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.589	0.017	0.00	0.036	0.034		Set Trigger
2	2.588	0.018	0.00	0.036	0.035		Set Trigger
3	2.572	0.018	0.00	0.036	0.035		Set Trigger
4	2.580	0.018	0.00	0.036	0.035		Set Trigger
5	2.540	0.018	0.00	0.036	0.034		Set Trigger

Avg 2.57

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



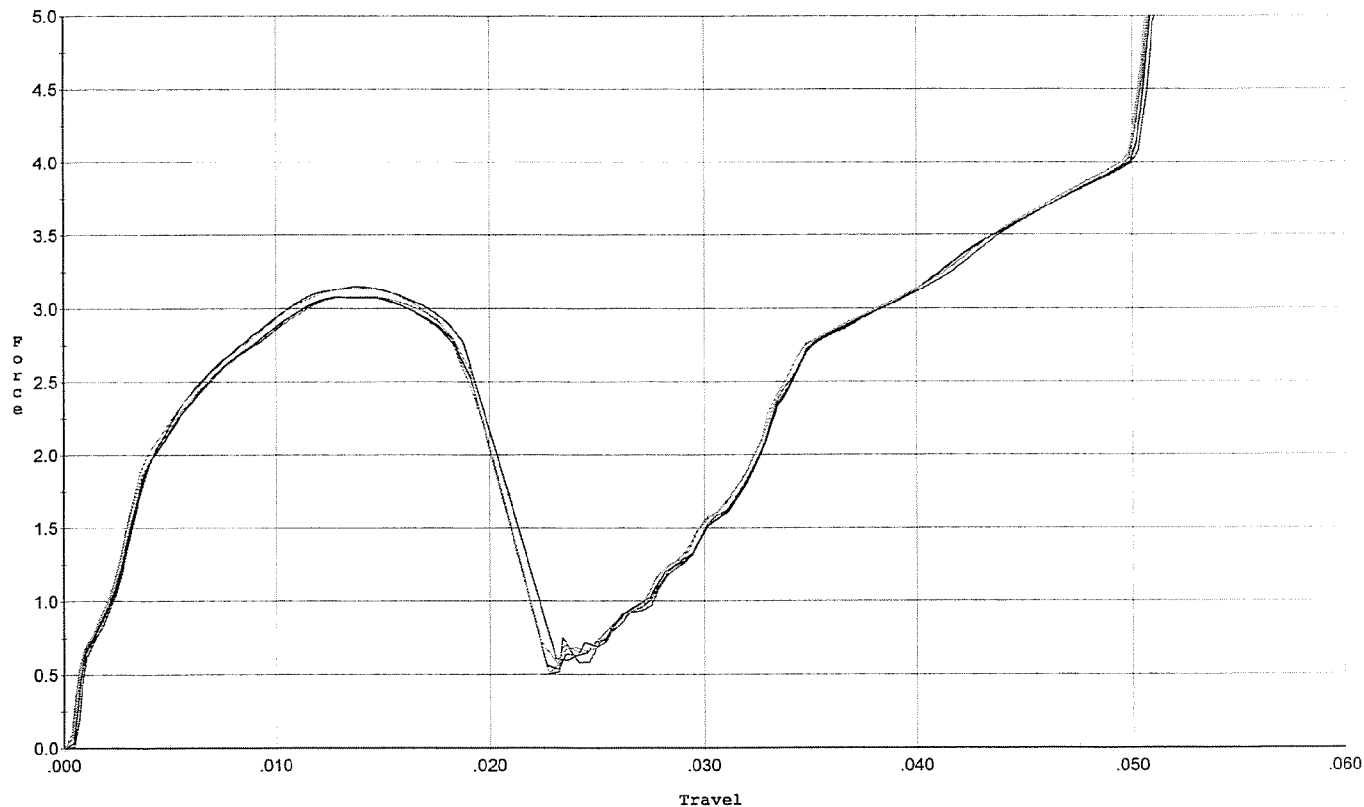
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.558	0.017	0.00	0.036	0.034		Set Trigger
2	2.419	0.019	0.00	0.035	0.034		Set Trigger
3	2.493	0.017	0.00	0.036	0.032		Set Trigger
4	2.429	0.018	0.00	0.036	0.033		Set Trigger
5	2.457	0.018	0.00	0.036	0.033		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



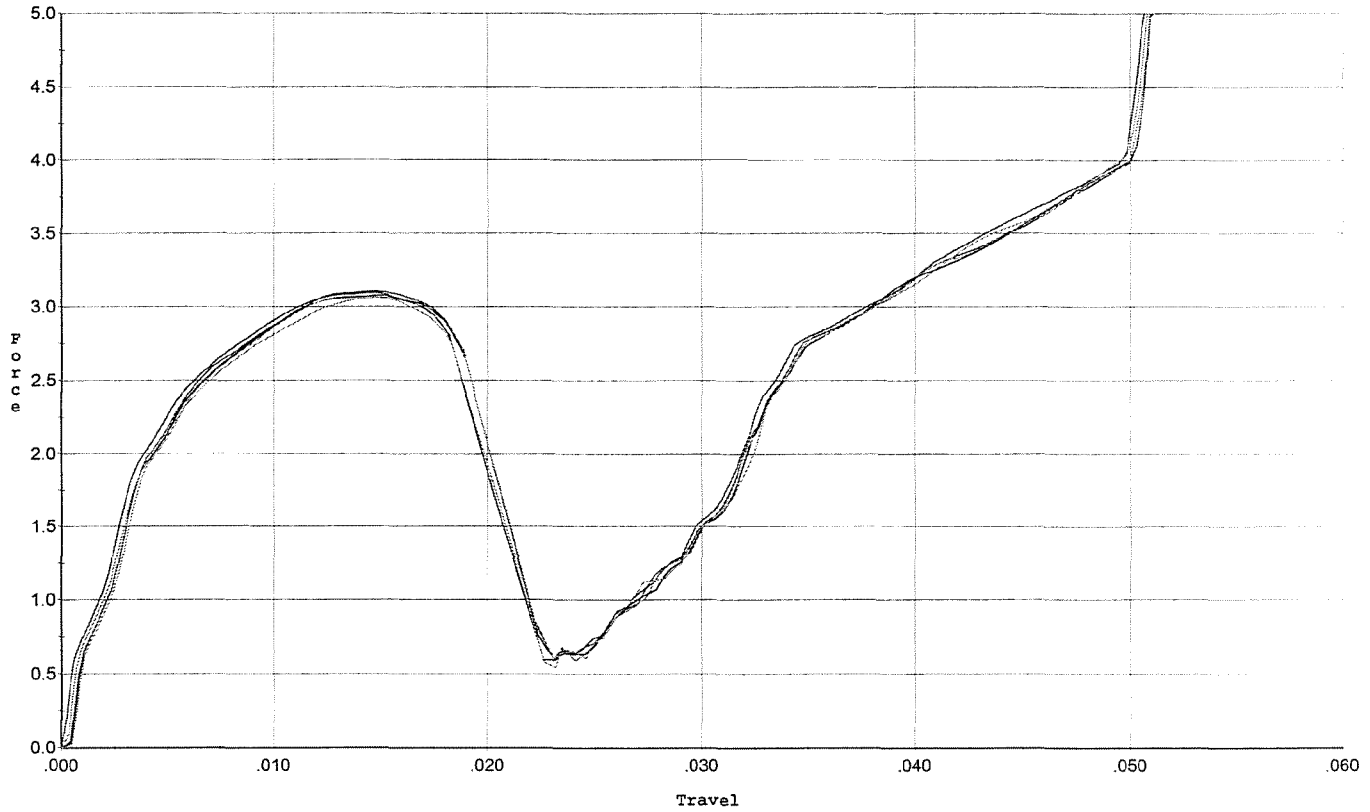
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.021	0.00	0.034	0.047		Set Trigger
2	3.080	0.019	0.00	0.034	0.043		Set Trigger
3	3.074	0.019	0.00	0.034	0.043		Set Trigger
4	3.139	0.019	0.00	0.034	0.044		Set Trigger
5	3.082	0.019	0.00	0.034	0.043		Set Trigger

Avg 3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



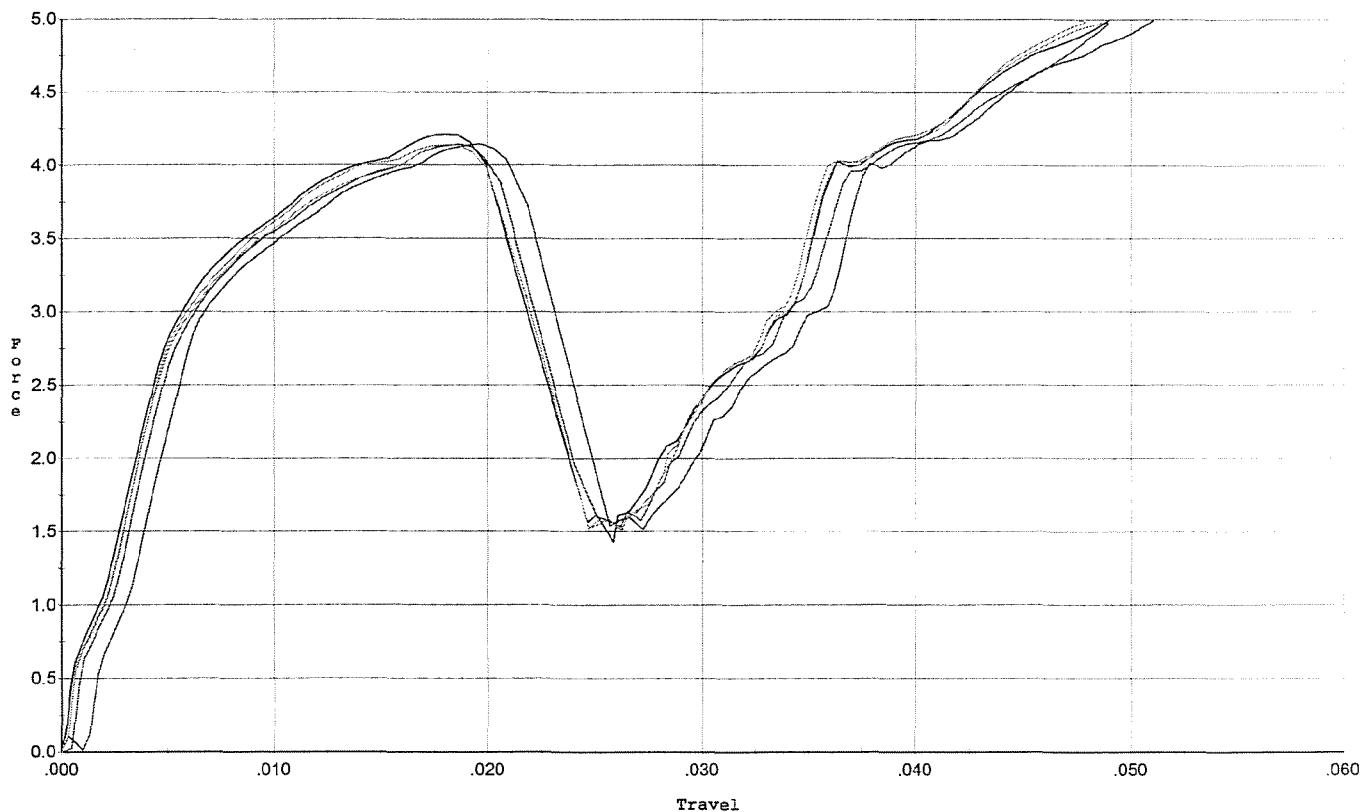
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.018	0.00	0.034	0.042		Set Trigger
2	3.076	0.019	0.00	0.034	0.043		Set Trigger
3	3.107	0.019	0.00	0.034	0.043		Set Trigger
4	3.068	0.019	0.00	0.034	0.042		Set Trigger
5	3.063	0.020	0.00	0.034	0.045		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



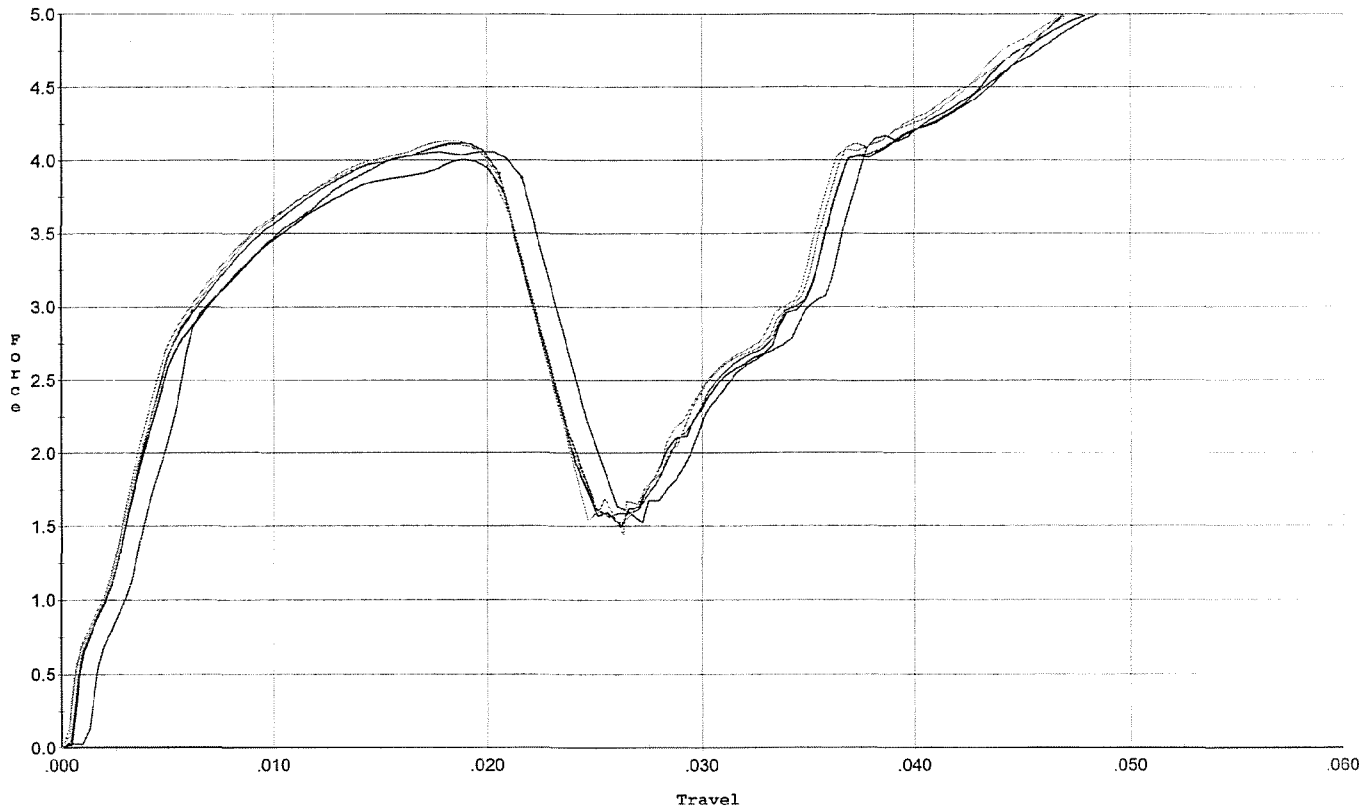
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.144	0.022	0.00	0.031	0.061		Set Trigger
2	4.214	0.020	0.00	0.031	0.059		Set Trigger
3	4.144	0.021	0.00	0.031	0.059		Set Trigger
4	4.142	0.022	0.00	0.031	0.063		Set Trigger
5	4.139	0.022	0.00	0.031	0.064		Set Trigger

Avg 4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



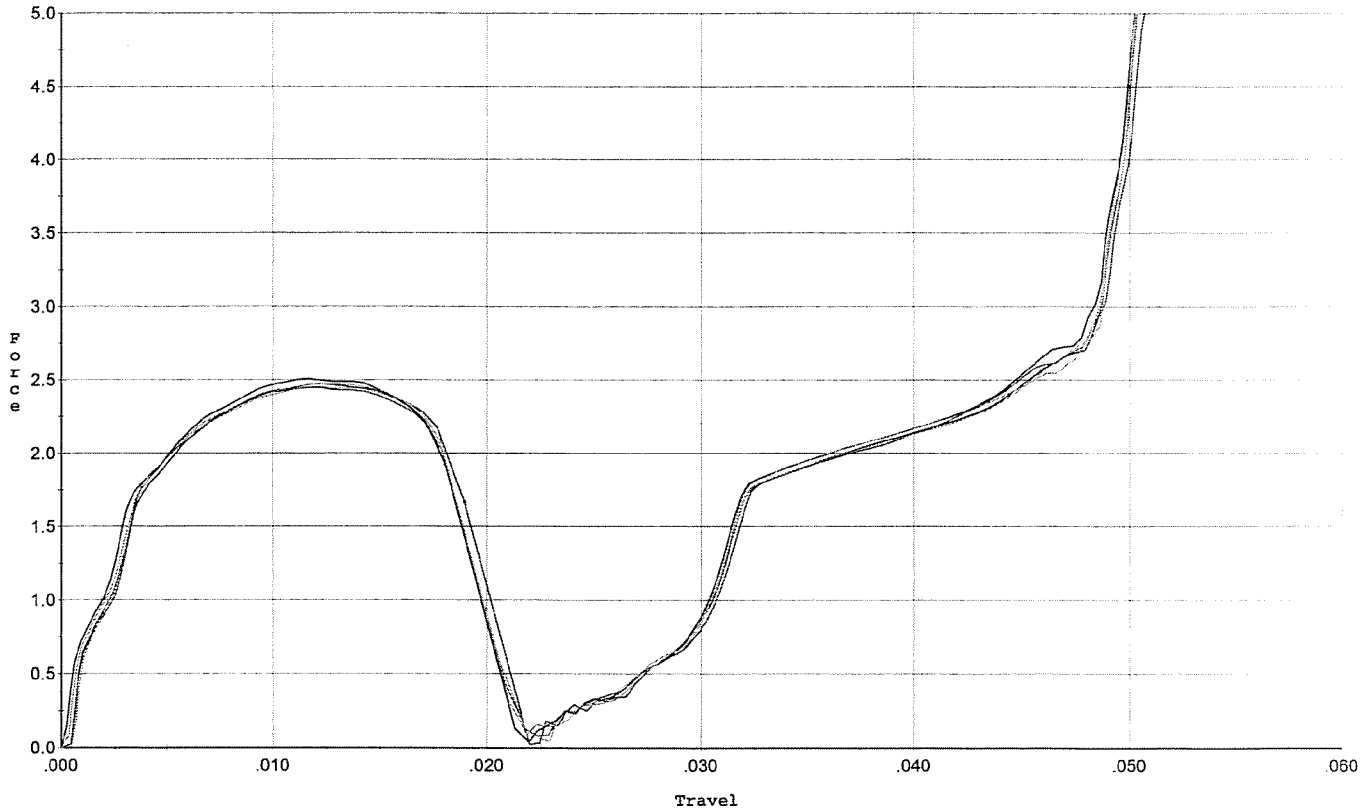
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.058	0.022	0.00	0.031	0.061		Set Trigger
2	4.004	0.021	0.00	0.031	0.058		Set Trigger
3	4.117	0.021	0.00	0.031	0.059		Set Trigger
4	4.131	0.021	0.00	0.031	0.061		Set Trigger
5	4.105	0.021	0.00	0.031	0.060		Set Trigger

Avg 4.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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



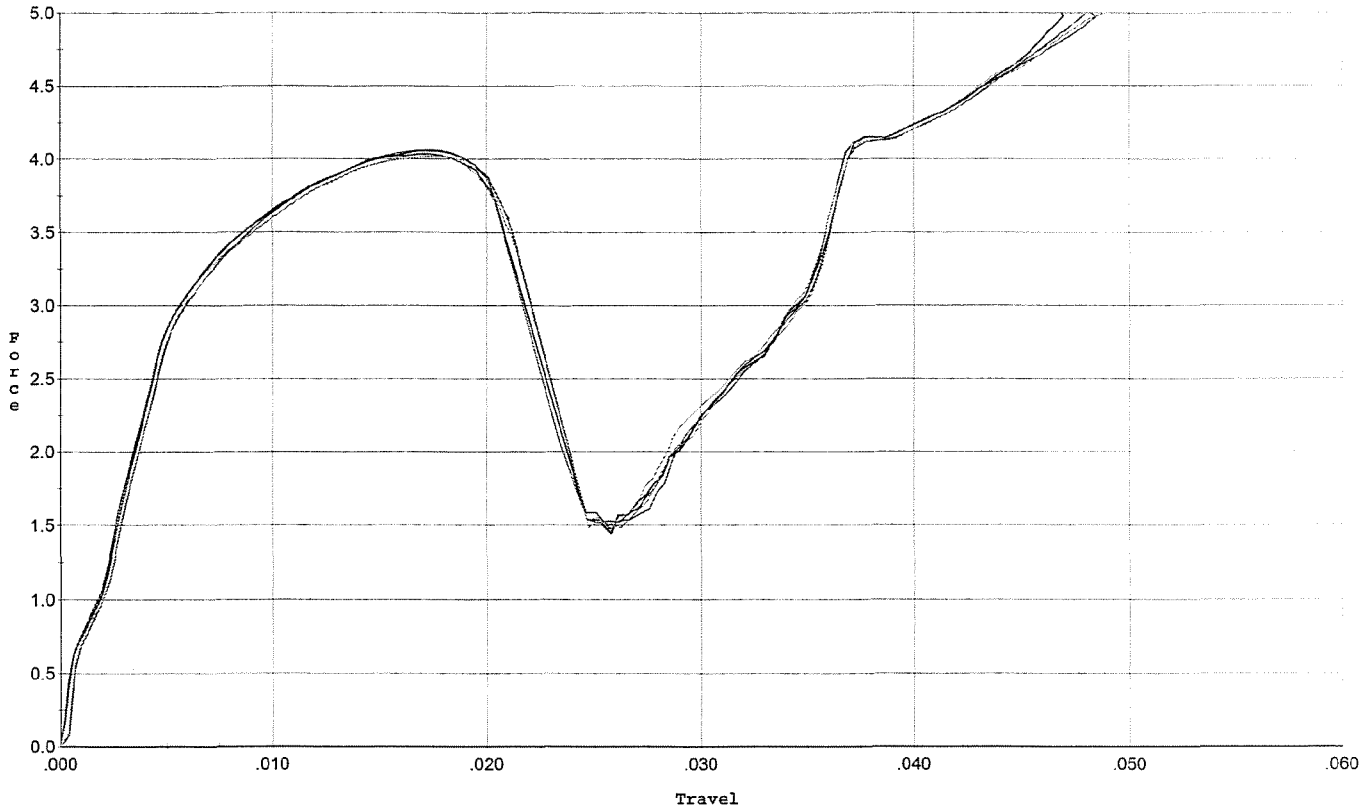
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.019	0.00	0.036	0.035		Set Trigger
2	2.508	0.018	0.00	0.036	0.035		Set Trigger
3	2.449	0.018	0.00	0.036	0.033		Set Trigger
4	2.454	0.018	0.00	0.036	0.033		Set Trigger
5	2.471	0.018	0.00	0.036	0.034		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/28/09

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	4.038	0.020	0.00	0.031	0.059		Set Trigger
2	4.057	0.020	0.00	0.031	0.059		Set Trigger
3	4.064	0.021	0.00	0.031	0.061		Set Trigger
4	4.021	0.021	0.00	0.031	0.062		Set Trigger
5	4.028	0.020	0.00	0.031	0.059		Set Trigger

Avg 4.04