

G 6863675

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



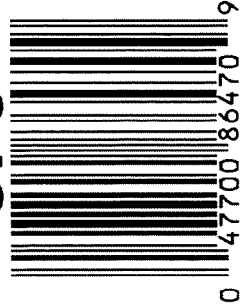
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863675

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863675

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	RP
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	6-10-09	RP
470	DIS-ASSEMBLE ACTION		6-10-09	RP
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	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		8-25-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

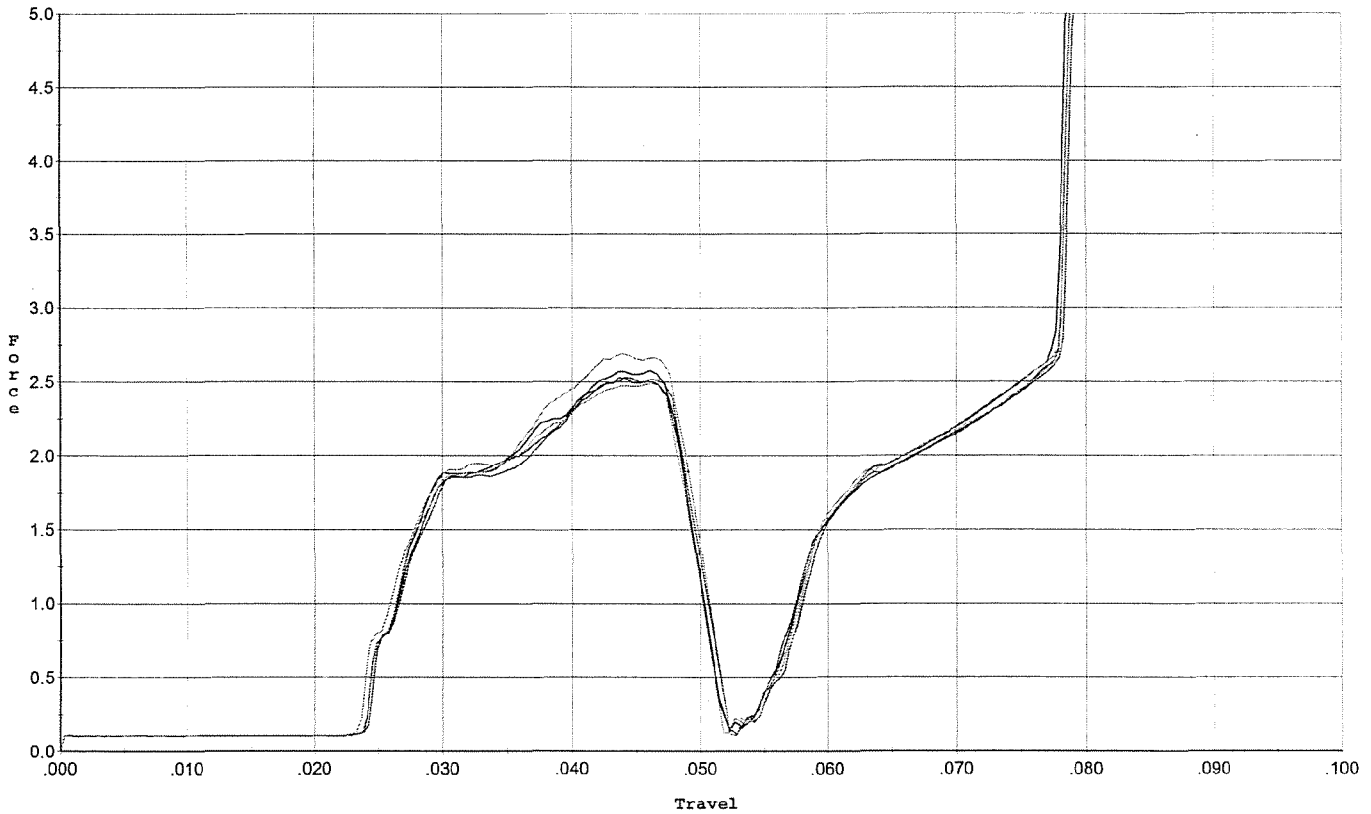
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	8/27/09	RB
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	8/22/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8/27/09	RB
	J) ASSEMBLE STOCK		8-25-09	AN
	K) ASSEMBLE SWIVEL STUDS		8/22/09	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	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-26-09	L.R.D.
670	FINAL INSPECTION A) HEADSPACE		8/27/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>242</u> <u>241</u> <u>235</u> <u>264</u> <u>2.33</u>	8/27/09	RB
	C) FUNCTION		8/17/09	LB
690	PACK		8-27-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



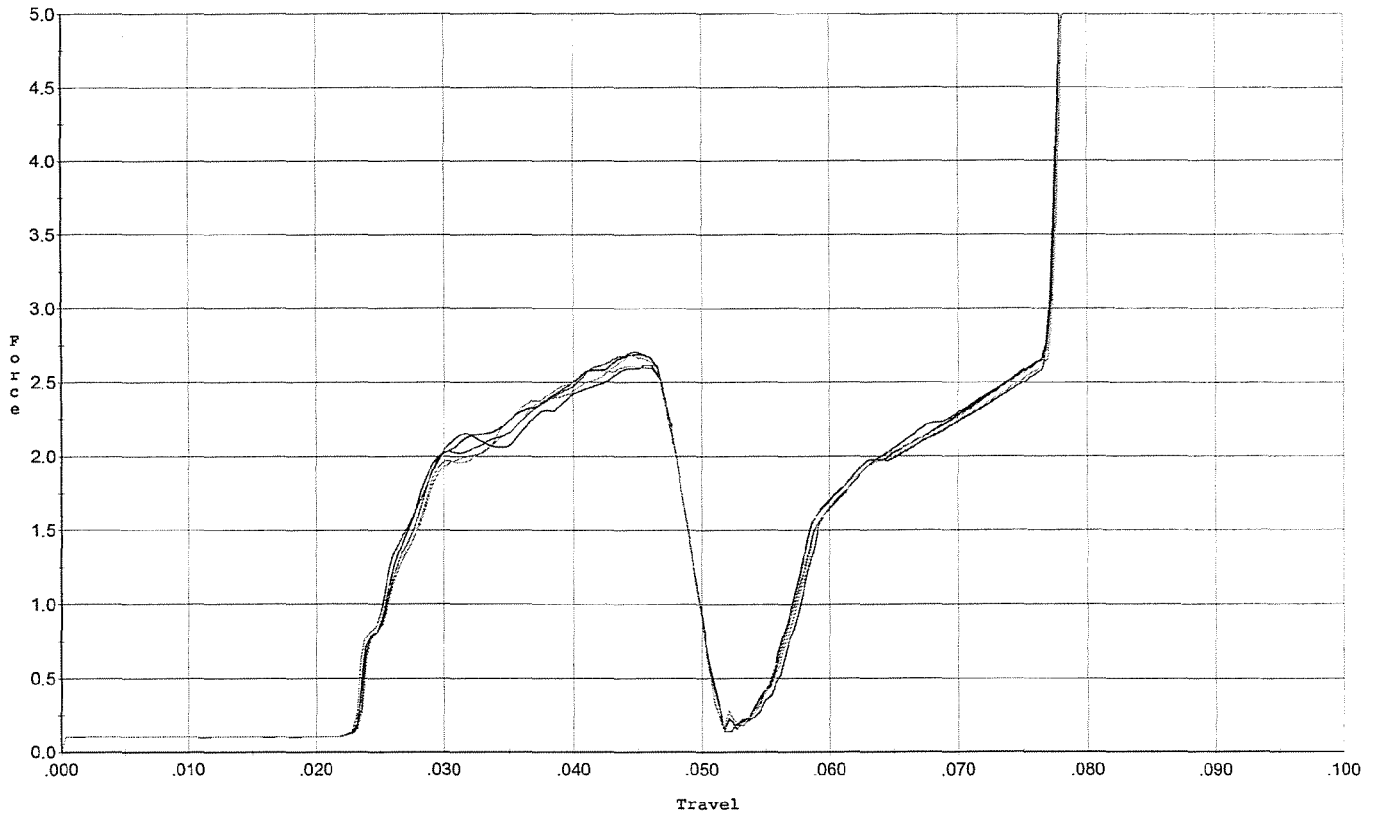
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.529	0.048	0.024	0.034	0.050		Set Trigger
2	2.577	0.048	0.024	0.034	0.051		Set Trigger
3	2.532	0.050	0.024	0.034	0.052		Set Trigger
4	2.491	0.049	0.024	0.034	0.051		Set Trigger
5	2.690	0.049	0.024	0.034	0.054		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



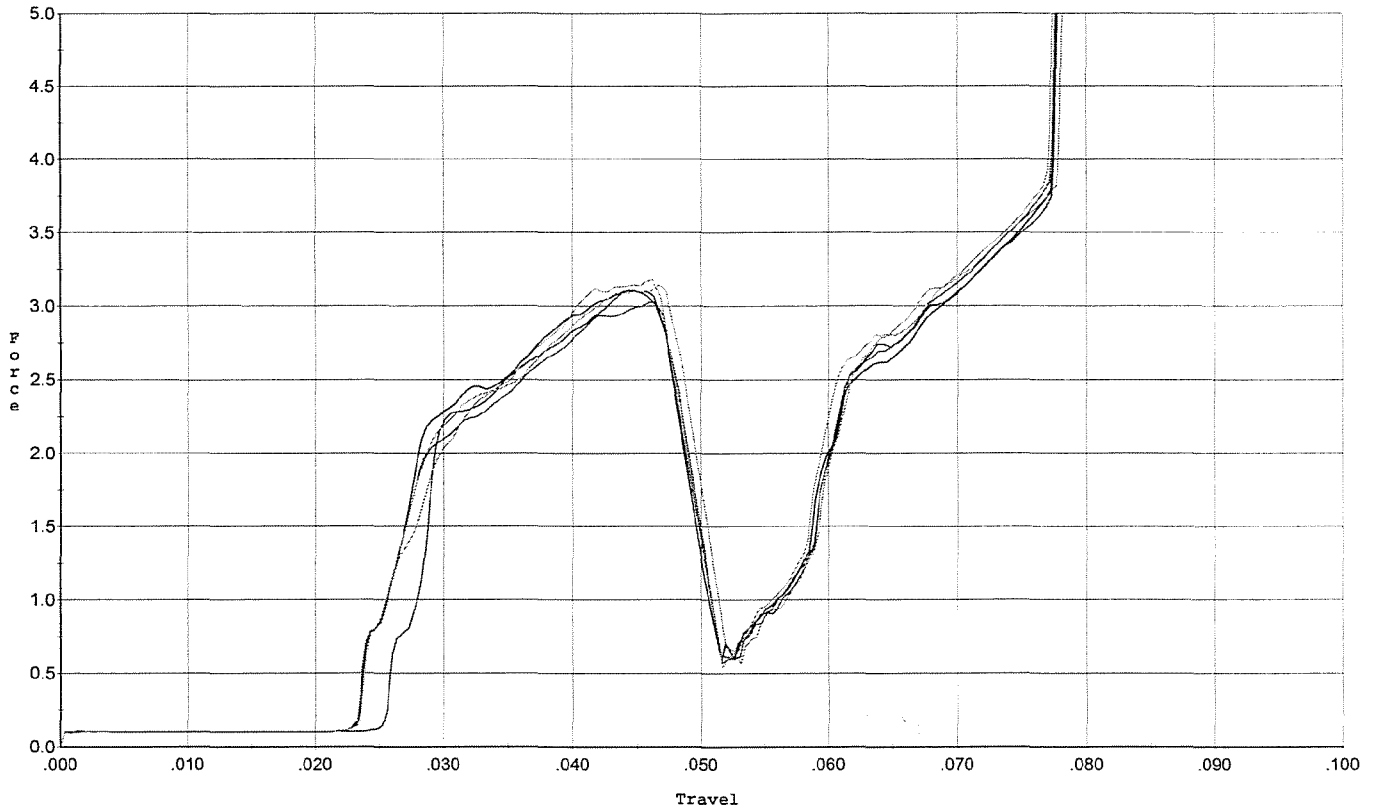
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.048	0.023	0.033	0.053		Set Trigger
2	2.690	0.048	0.023	0.033	0.054		Set Trigger
3	2.704	0.048	0.024	0.033	0.053		Set Trigger
4	2.689	0.048	0.024	0.034	0.053		Set Trigger
5	2.609	0.048	0.023	0.034	0.053		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



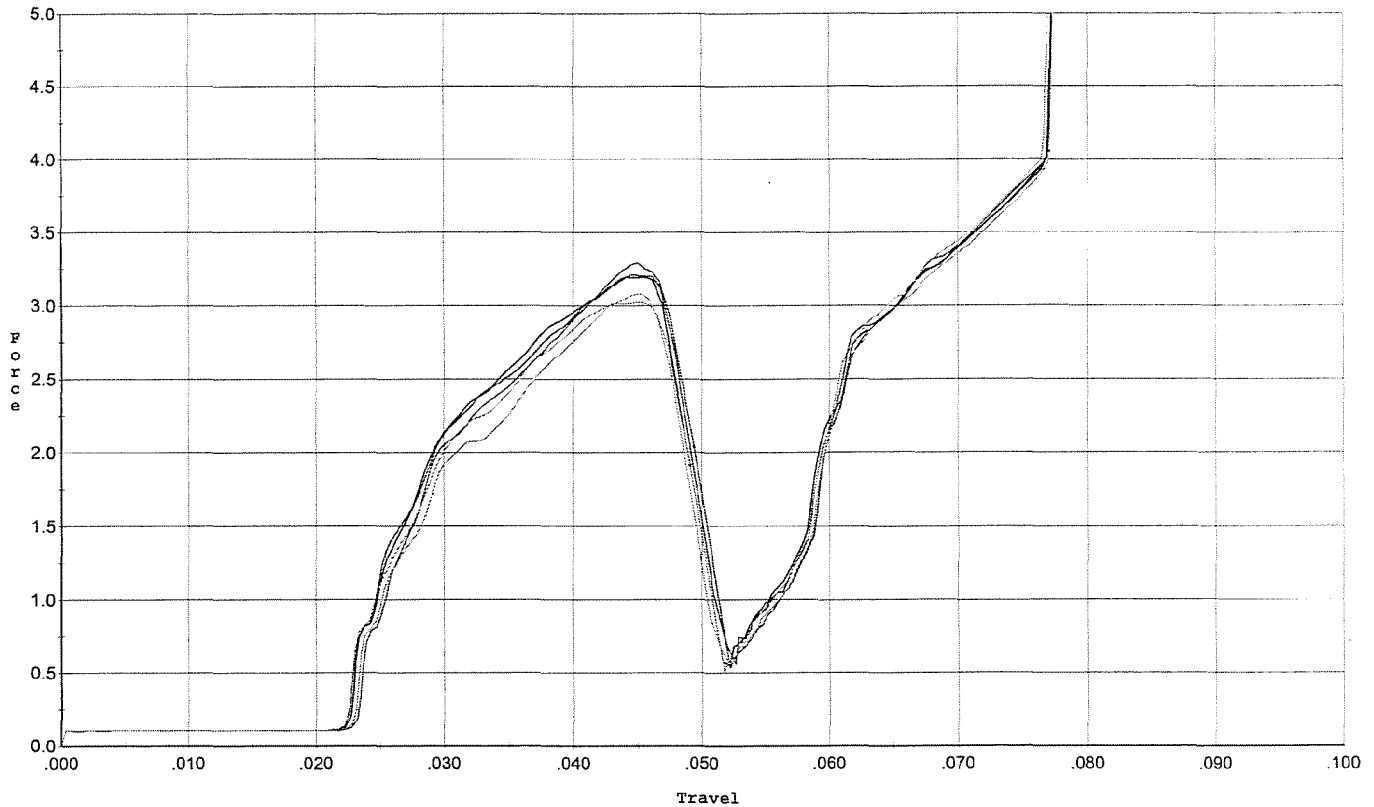
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.106	0.049	0.026	0.032	0.059		Set Trigger
2	3.107	0.047	0.024	0.032	0.061		Set Trigger
3	3.028	0.048	0.024	0.032	0.060		Set Trigger
4	3.182	0.049	0.023	0.031	0.063		Set Trigger
5	3.147	0.049	0.024	0.032	0.062		Set Trigger

A-3.11

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



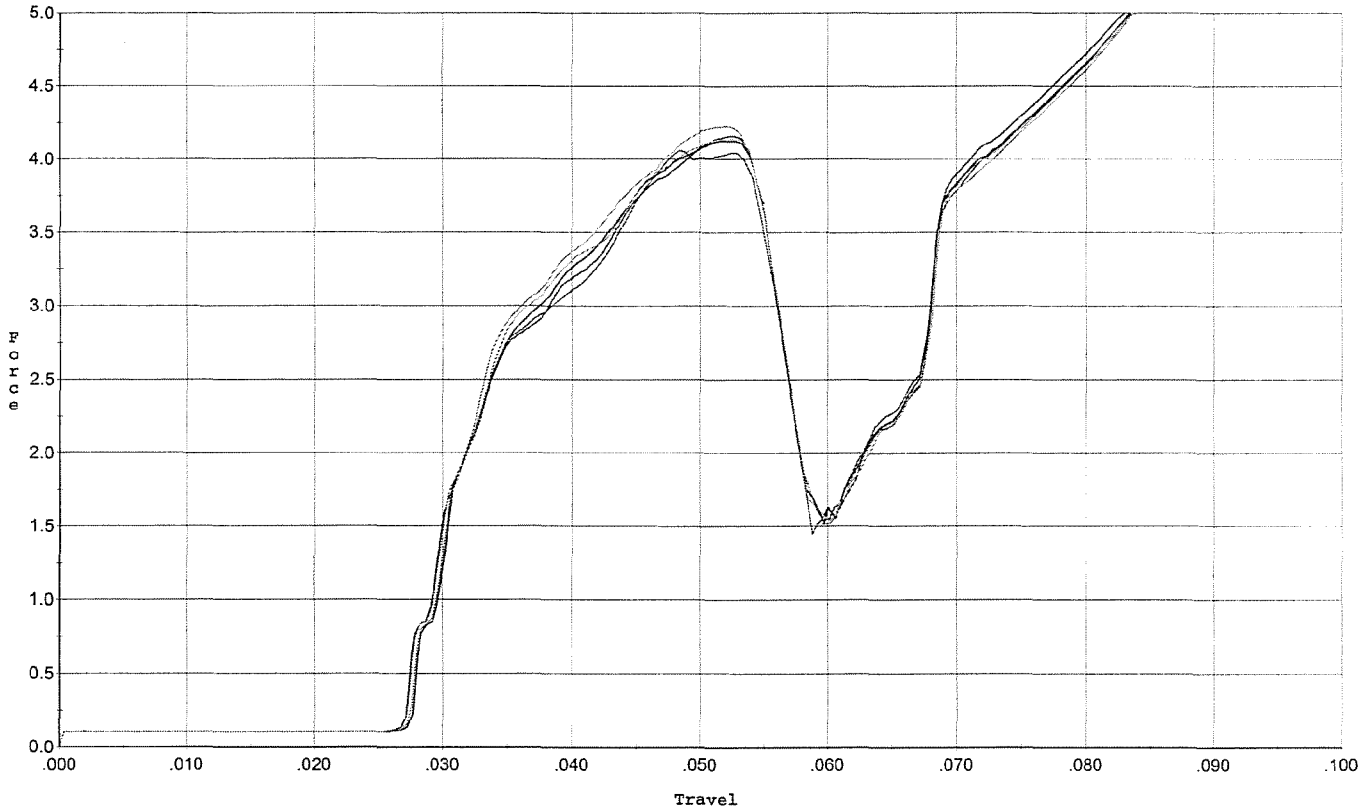
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.213	0.048	0.023	0.032	0.063		Set Trigger
2	3.194	0.049	0.023	0.032	0.064		Set Trigger
3	3.291	0.049	0.023	0.031	0.064		Set Trigger
4	3.082	0.048	0.023	0.032	0.060		Set Trigger
5	3.023	0.049	0.023	0.032	0.059		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



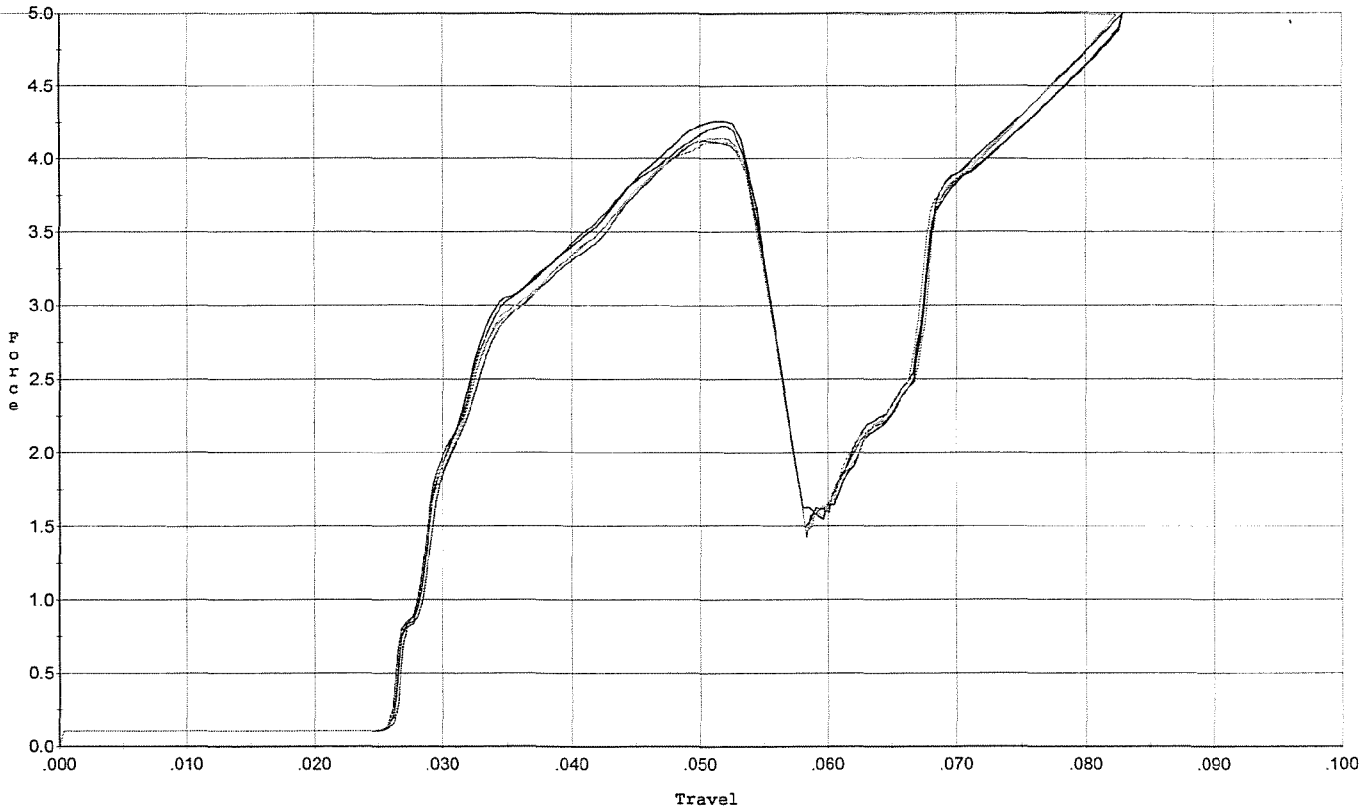
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.157	0.055	0.027	0.030	0.090		Set Trigger
2	4.124	0.055	0.028	0.030	0.090		Set Trigger
3	4.059	0.056	0.028	0.030	0.089		Set Trigger
4	4.136	0.055	0.028	0.031	0.090		Set Trigger
5	4.226	0.055	0.027	0.030	0.092		Set Trigger

A-4-14

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



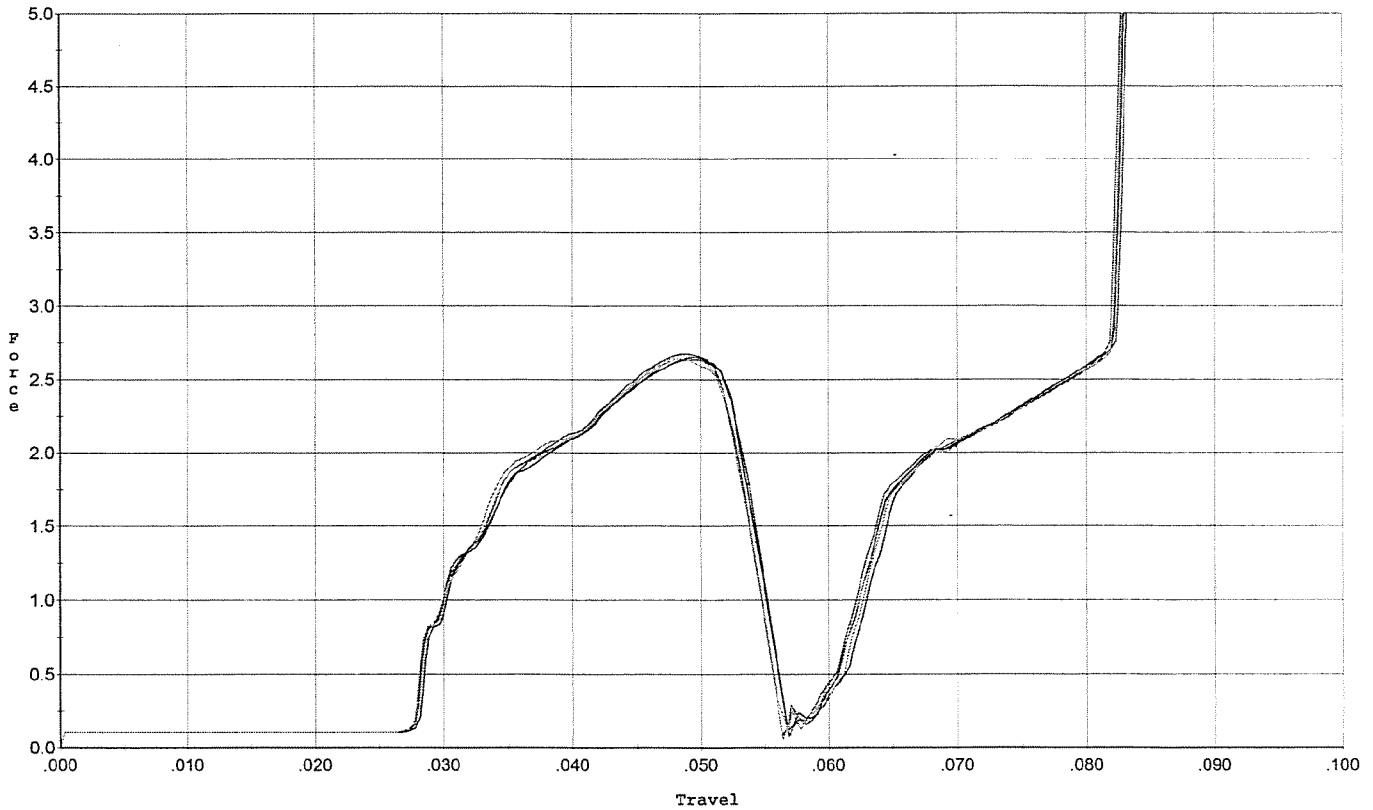
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.224	0.055	0.026	0.030	0.094		Set Trigger
2	4.255	0.054	0.026	0.030	0.094		Set Trigger
3	4.123	0.055	0.027	0.030	0.092		Set Trigger
4	4.142	0.055	0.026	0.030	0.093		Set Trigger
5	4.109	0.055	0.026	0.030	0.093		Set Trigger

A-4-17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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



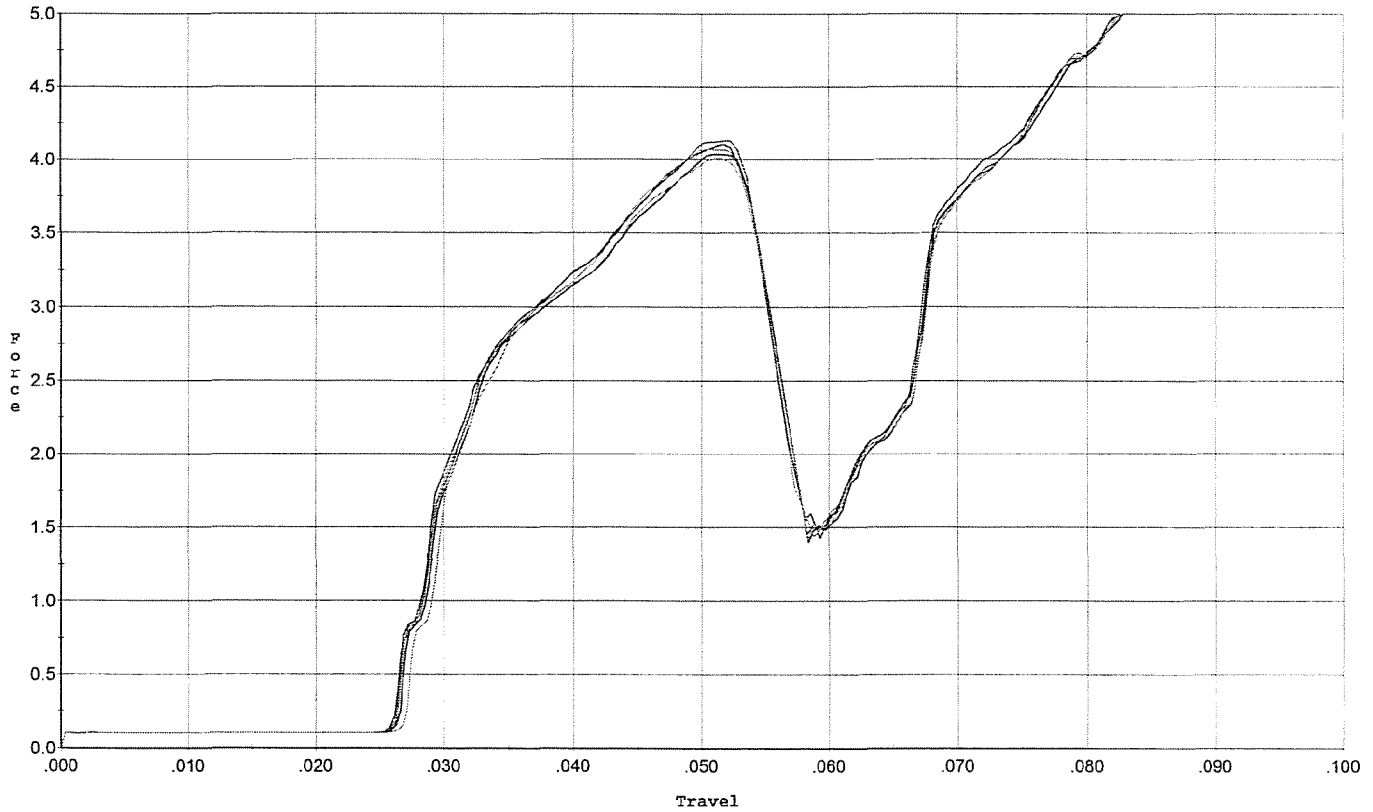
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.637	0.054	0.028	0.034	0.055		Set Trigger
2	2.653	0.054	0.028	0.034	0.055		Set Trigger
3	2.679	0.053	0.028	0.034	0.054		Set Trigger
4	2.645	0.053	0.028	0.034	0.054		Set Trigger
5	2.676	0.053	0.028	0.034	0.054		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/17/2009

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	4.102	0.054	0.026	0.030	0.088		Set Trigger
2	4.037	0.056	0.027	0.030	0.090		Set Trigger
3	4.131	0.054	0.026	0.030	0.088		Set Trigger
4	4.007	0.056	0.027	0.030	0.089		Set Trigger
5	4.069	0.054	0.026	0.030	0.088		Set Trigger

A 4.06