

G6868460

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

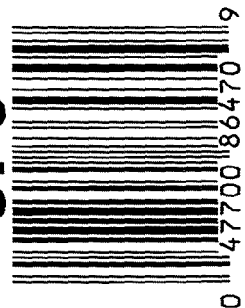
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6868460

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6868460

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-28-09	SP
430	ASSEMBLE TO STOCK		7-28-09	SP
440	PROOF		7-28-09	SP
460	CHECK HEADSPACE	MAGNA-FLUX	7-28-09	SP
470	DIS-ASSEMBLE ACTION		7-28-09	SP
472	SERIALIZE BOLT HANDLE		7-29-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	7/31/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-31-09	AWO
510	DRILL AND TAP SIGHT HOLES		7-29-09	SP
520	GOFF BLAST BBL / REC		7/31/09	SP
540	APPLY COATINGS (BARREL ACTION)		8/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		8-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-24-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

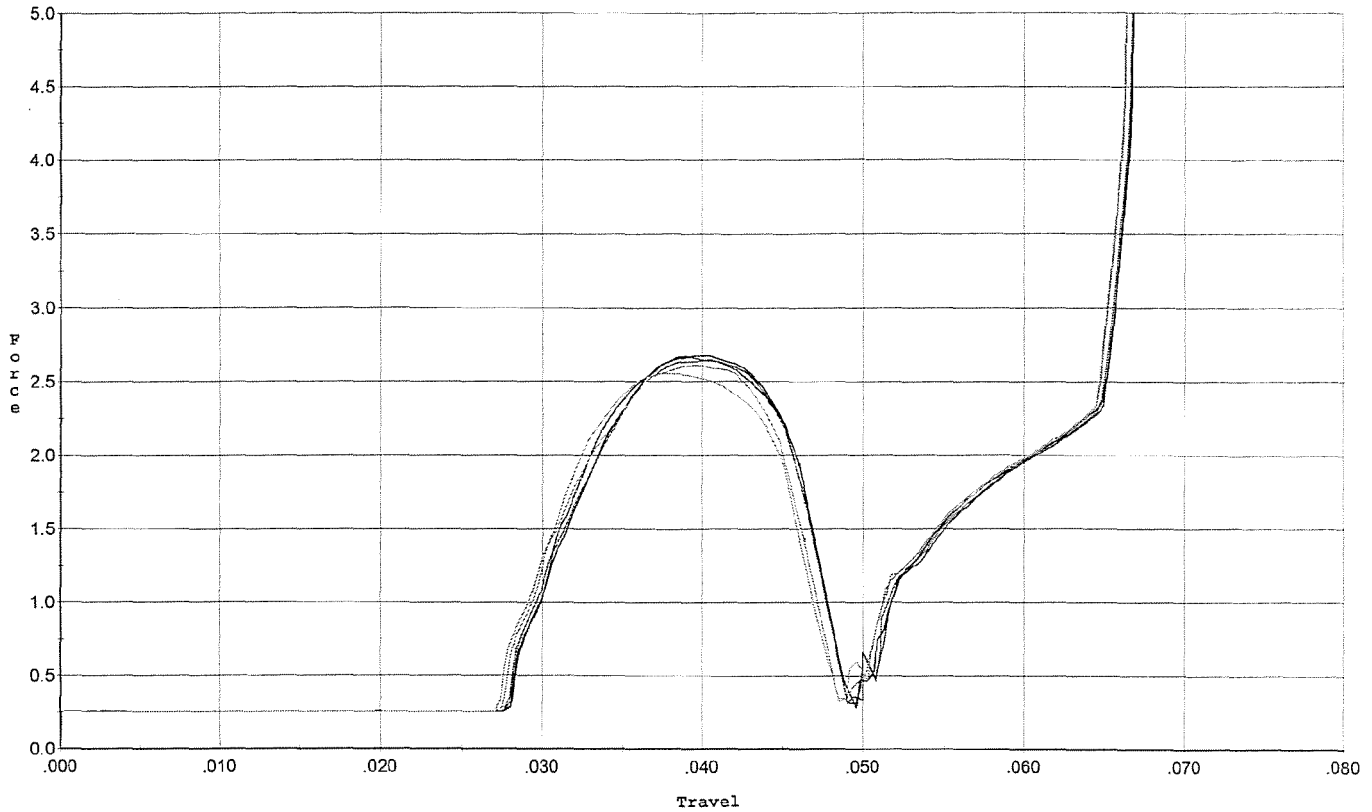
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>3°</u> <u>3°</u> <u>3°</u>	8/27/09	RB
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	8/27/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	8/27/09	RB
	J) ASSEMBLE STOCK			8-24-09	
	K) ASSEMBLE SWIVEL STUDS			8/27/09	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	8/26/09	RB
			<u>PASS</u> FAIL		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			8/26/09	TAR
670	FINAL INSPECTION A) HEADSPACE			8/27/09	RB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u> <u>2.79</u> <u>2.73</u> <u>2.82</u> <u>2.55</u>	8/26/09	RB
	C) FUNCTION			8/27/09	RB
690	PACK			8-27-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



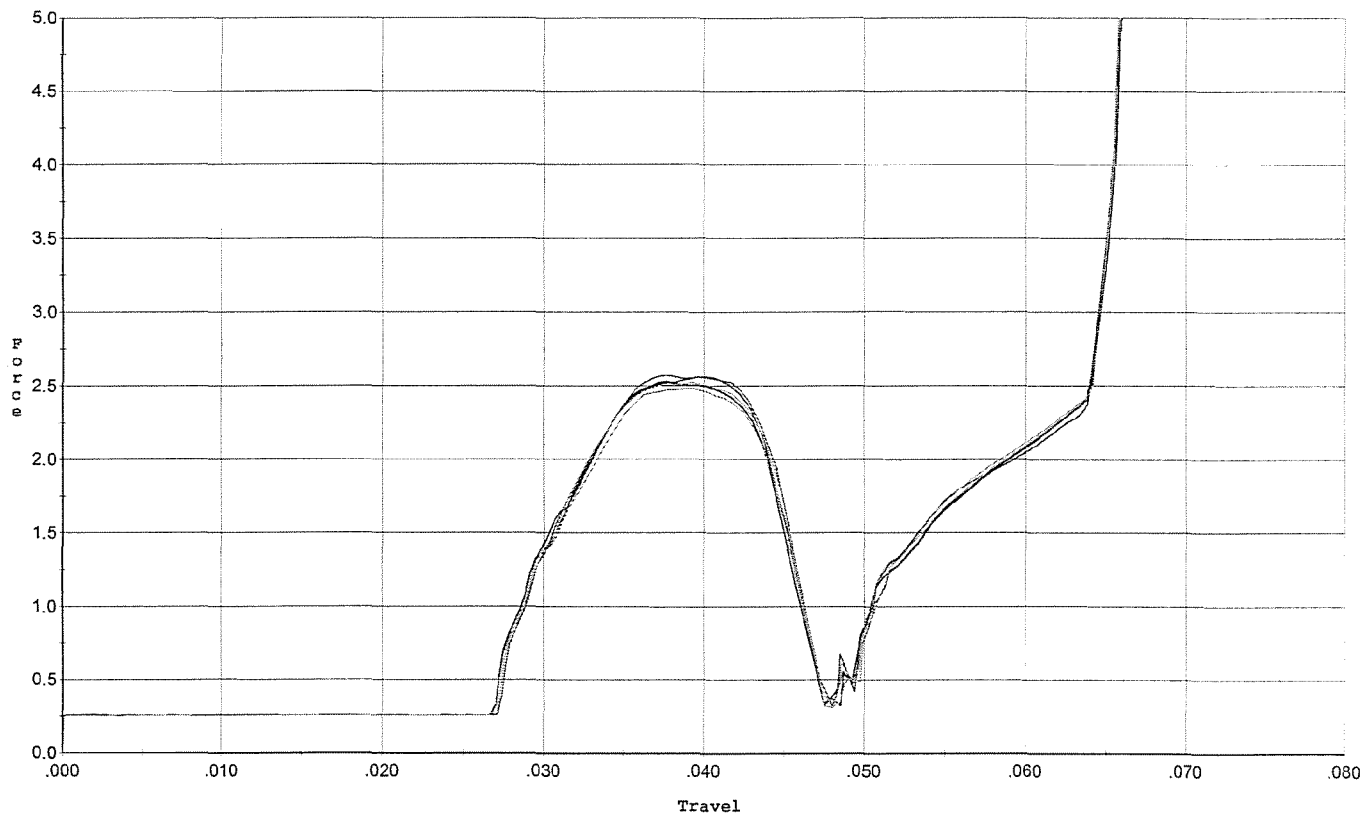
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.675	0.046	0.028	0.027	0.046		Set Trigger
2	2.677	0.046	0.028	0.027	0.046		Set Trigger
3	2.650	0.046	0.028	0.027	0.046		Set Trigger
4	2.557	0.045	0.028	0.028	0.044		Set Trigger
5	2.612	0.046	0.027	0.027	0.046		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



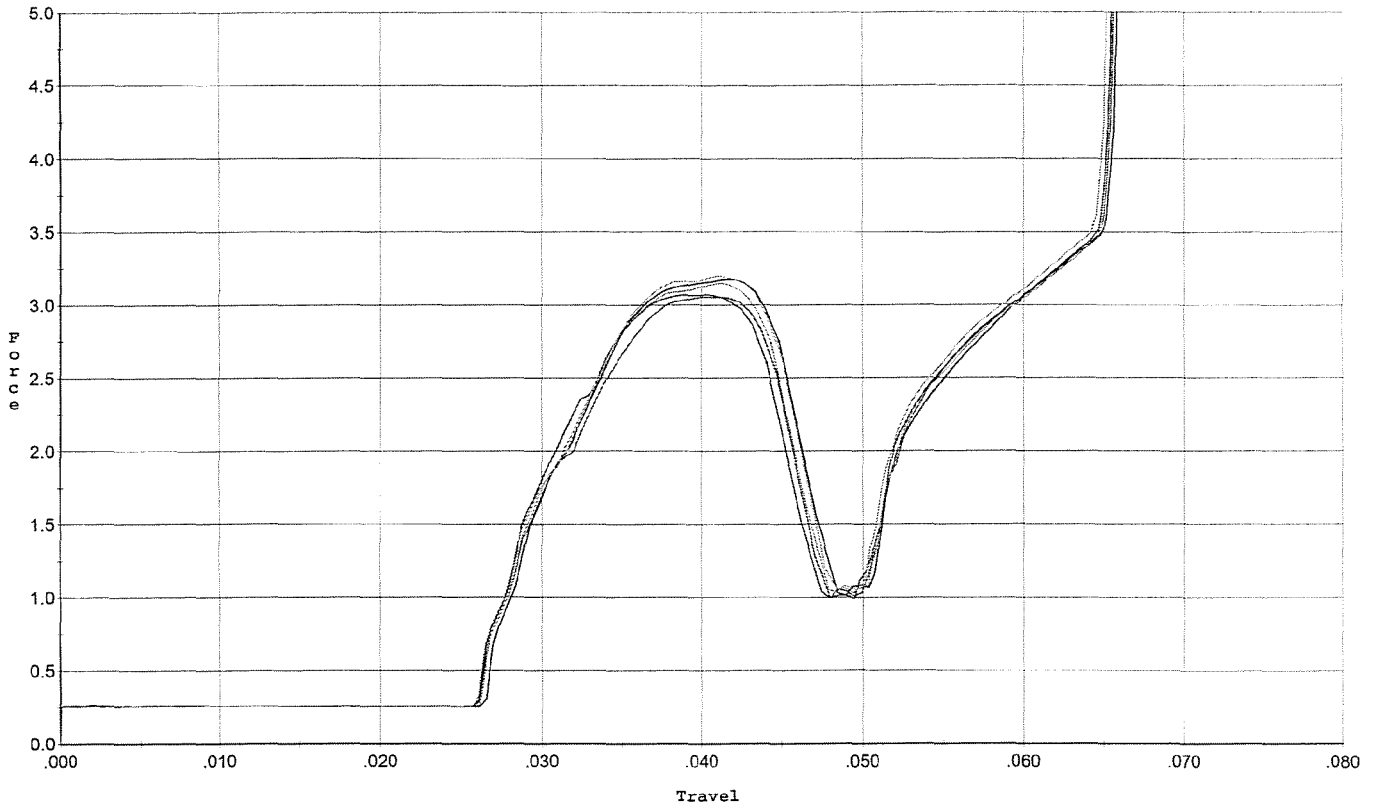
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.045	0.027	0.027	0.044		Set Trigger
2	2.529	0.044	0.027	0.027	0.042		Set Trigger
3	2.574	0.045	0.027	0.027	0.043		Set Trigger
4	2.521	0.045	0.027	0.027	0.043		Set Trigger
5	2.484	0.045	0.027	0.027	0.042		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



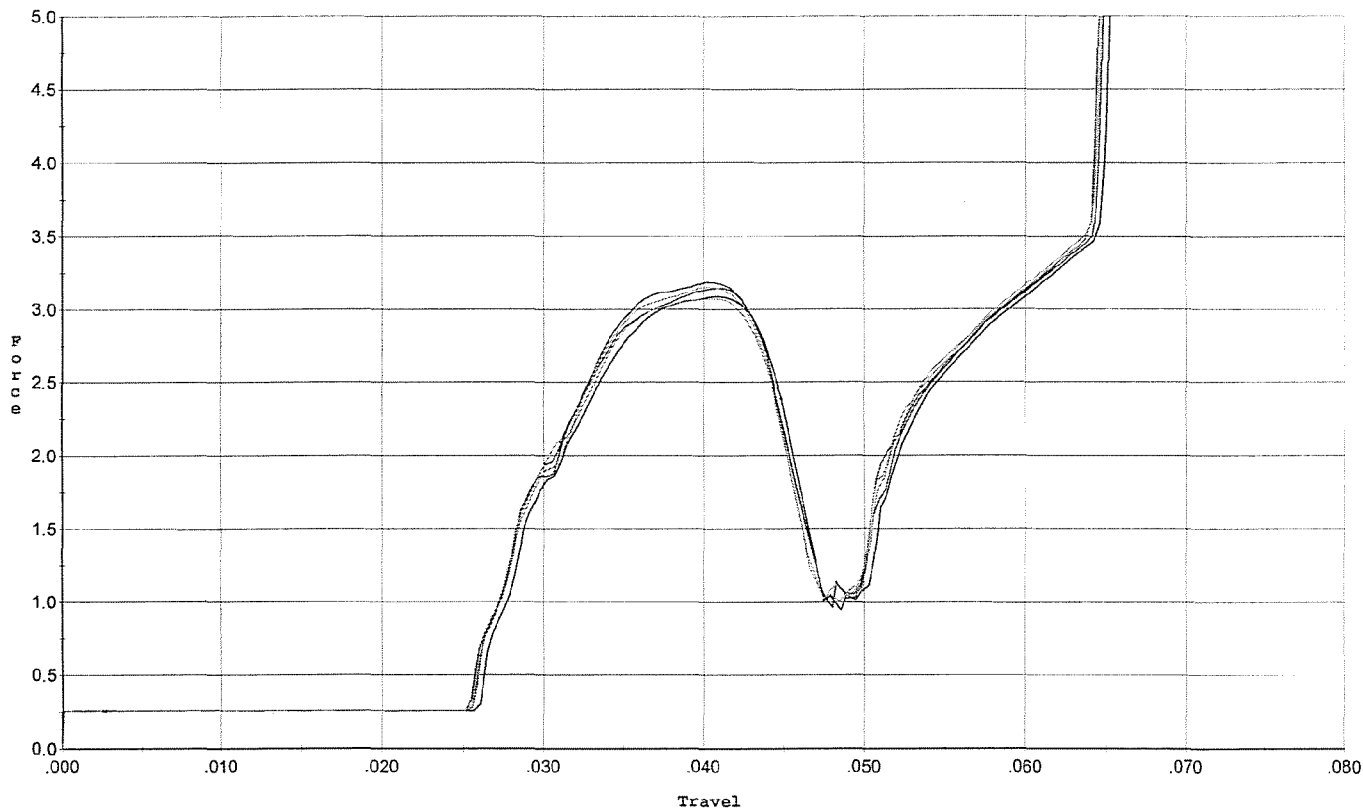
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.044	0.026	0.026	0.051		Set Trigger
2	3.177	0.045	0.027	0.026	0.053		Set Trigger
3	3.058	0.045	0.026	0.026	0.051		Set Trigger
4	3.199	0.045	0.026	0.026	0.054		Set Trigger
5	3.152	0.044	0.026	0.026	0.053		Set Trigger

A3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



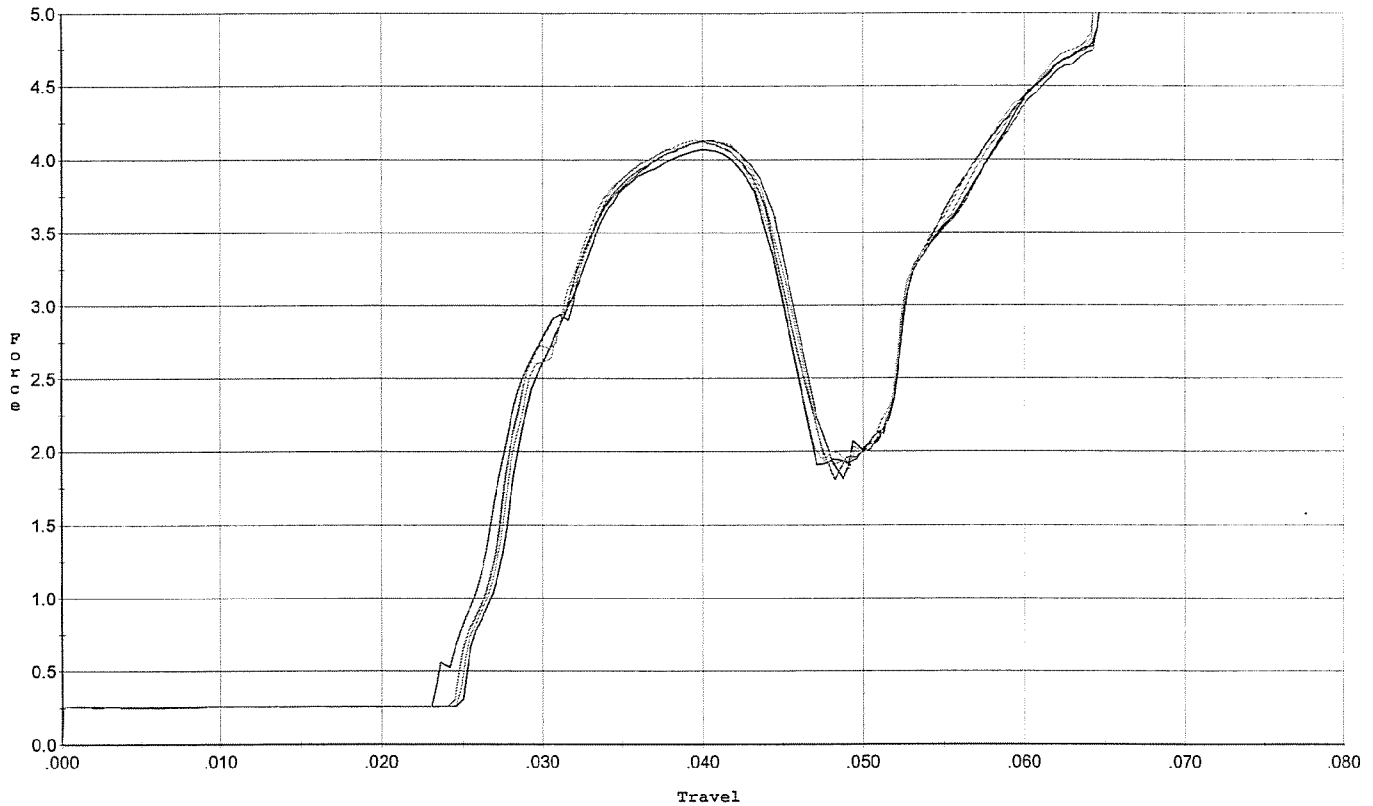
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.188	0.044	0.025	0.026	0.053		Set Trigger
2	3.090	0.045	0.026	0.026	0.052		Set Trigger
3	3.146	0.044	0.026	0.026	0.052		Set Trigger
4	3.153	0.044	0.026	0.026	0.053		Set Trigger
5	3.070	0.044	0.026	0.026	0.052		Set Trigger

A.3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



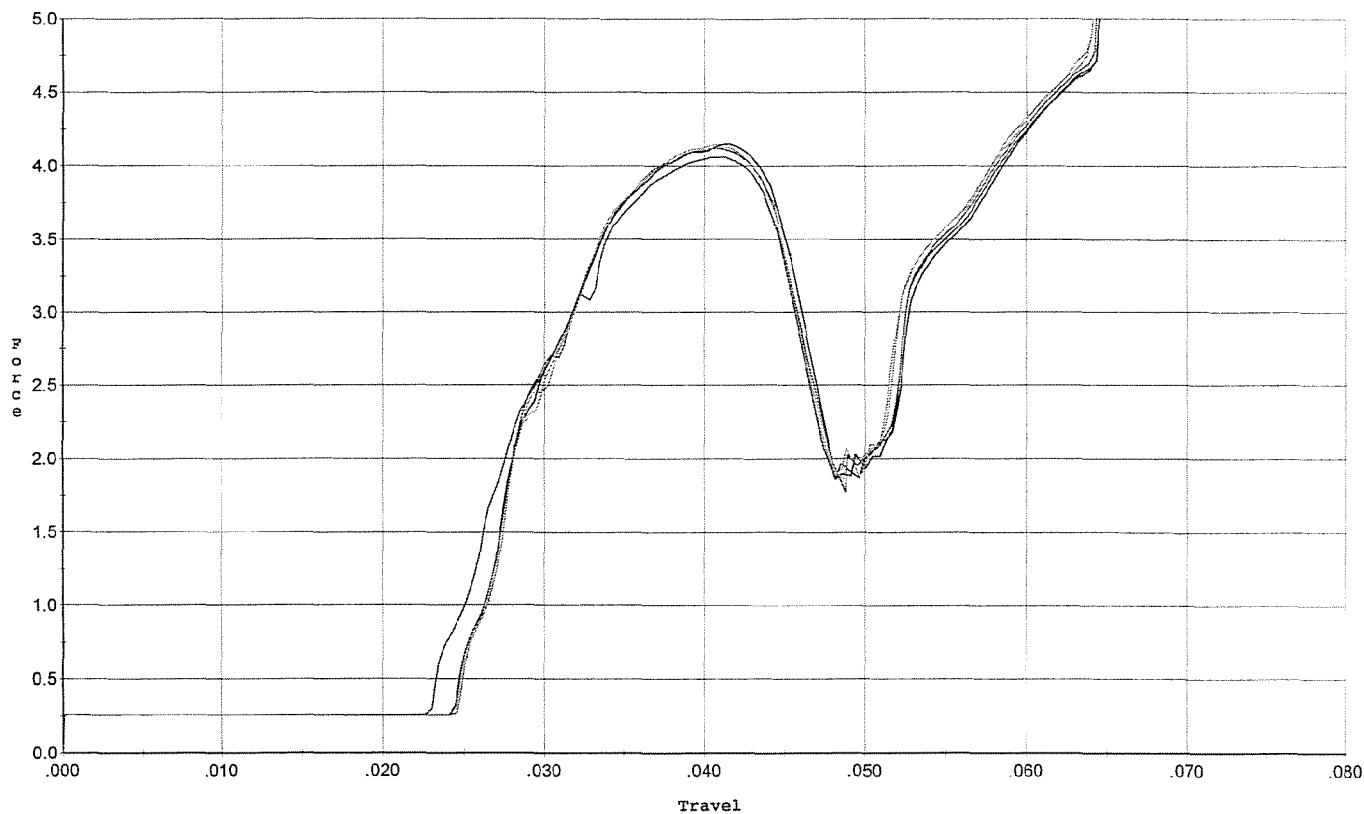
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.130	0.045	0.023	0.024	0.073		Set Trigger
2	4.064	0.044	0.025	0.025	0.069		Set Trigger
3	4.118	0.044	0.025	0.024	0.070		Set Trigger
4	4.135	0.044	0.025	0.024	0.070		Set Trigger
5	4.124	0.045	0.025	0.024	0.072		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



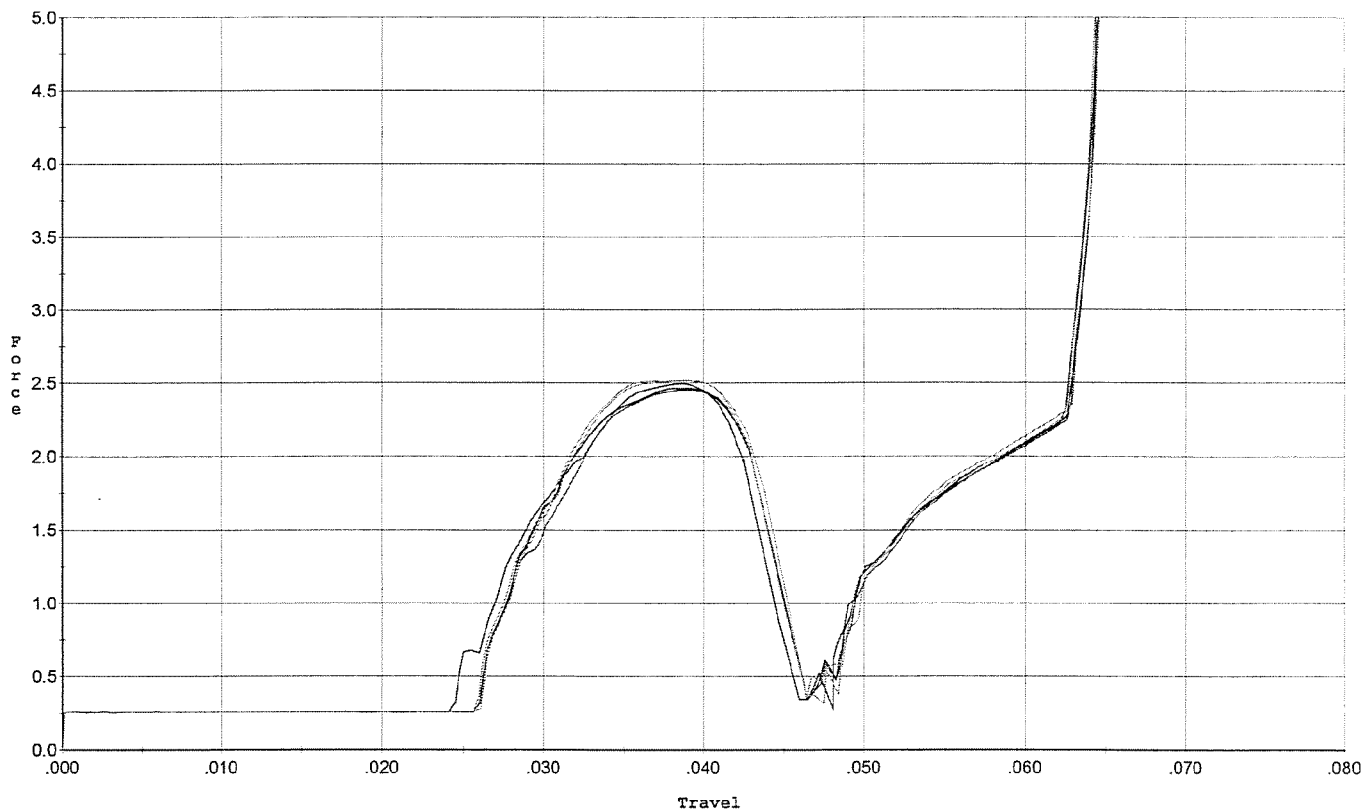
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.058	0.045	0.023	0.023	0.072		Set Trigger
2	4.146	0.045	0.025	0.023	0.073		Set Trigger
3	4.120	0.044	0.024	0.024	0.071		Set Trigger
4	4.127	0.044	0.025	0.023	0.070		Set Trigger
5	4.145	0.044	0.025	0.023	0.071		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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



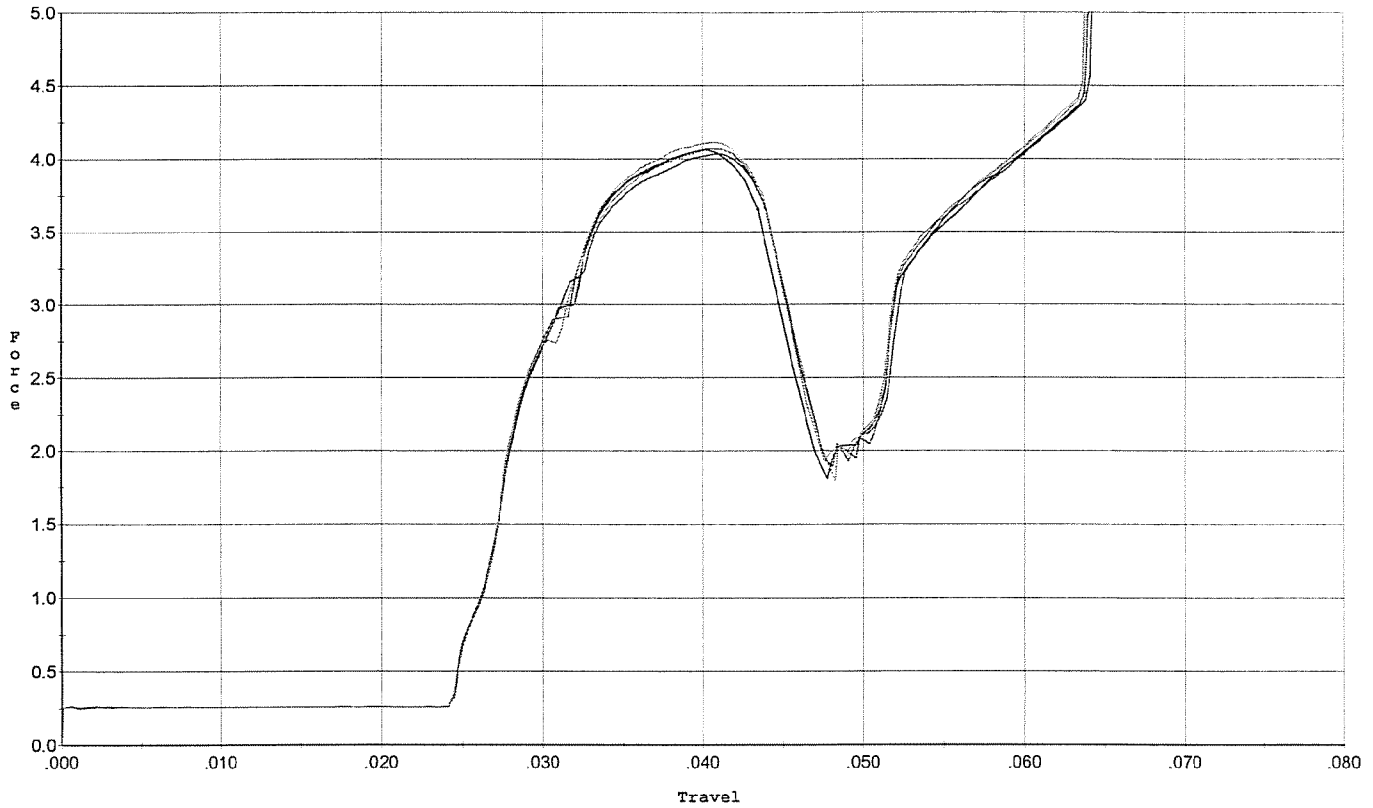
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.496	0.042	0.025	0.027	0.041		Set Trigger
2	2.464	0.043	0.026	0.027	0.041		Set Trigger
3	2.450	0.043	0.026	0.027	0.040		Set Trigger
4	2.515	0.044	0.026	0.027	0.043		Set Trigger
5	2.513	0.043	0.026	0.027	0.042		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/21/2009

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	4.036	0.044	0.024	0.024	0.069		Set Trigger
2	4.061	0.043	0.024	0.024	0.067		Set Trigger
3	4.072	0.044	0.024	0.024	0.070		Set Trigger
4	4.066	0.044	0.024	0.024	0.069		Set Trigger
5	4.115	0.044	0.025	0.024	0.070		Set Trigger

A-4.07