

G 685 2284

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

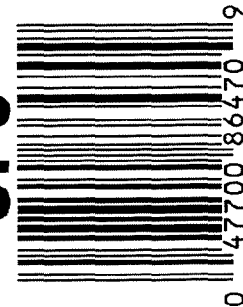
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6852284

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 685 2284

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-16-09	SPD
430	ASSEMBLE TO STOCK		6-16-09	SP
440	PROOF		6-16-09	SPD
460	CHECK HEADSPACE	MAGNA-FLUX	6-16-09	SPD
470	DIS-ASSEMBLE ACTION		6-16-09	SPD
472	SERIALIZE BOLT HANDLE		6-17-09	RIC
480	MAGNAFLUX BBL ACTION	OPERATOR	6/20/09	D
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/23/09	RT
510	DRILL AND TAP SIGHT HOLES		6-17-09	SP
520	GOFF BLAST BBL / REC		6-23	ms
540	APPLY COATINGS (BARREL ACTION)		7-25	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-15-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-15-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-15-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-24-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

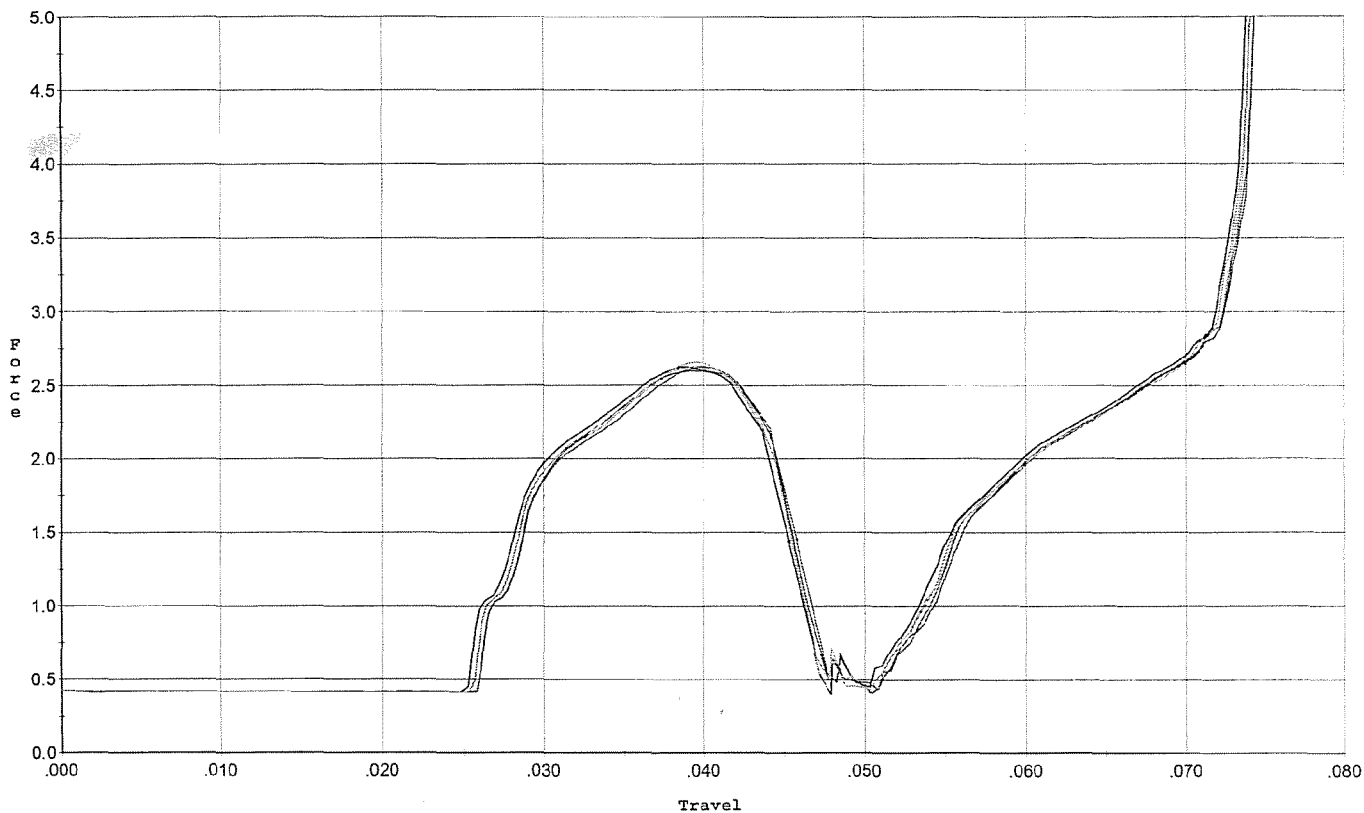
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	8/27/09	RB
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	8/27/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8/27/09	RB
	J) ASSEMBLE STOCK		8-24-09	J.P.D.
	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 <u>PASS</u> FAIL	8-26-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-26-09	J.P.D.
670	FINAL INSPECTION A) HEADSPACE		8/27/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.71</u> <u>2.68</u> <u>2.64</u> <u>2.70</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



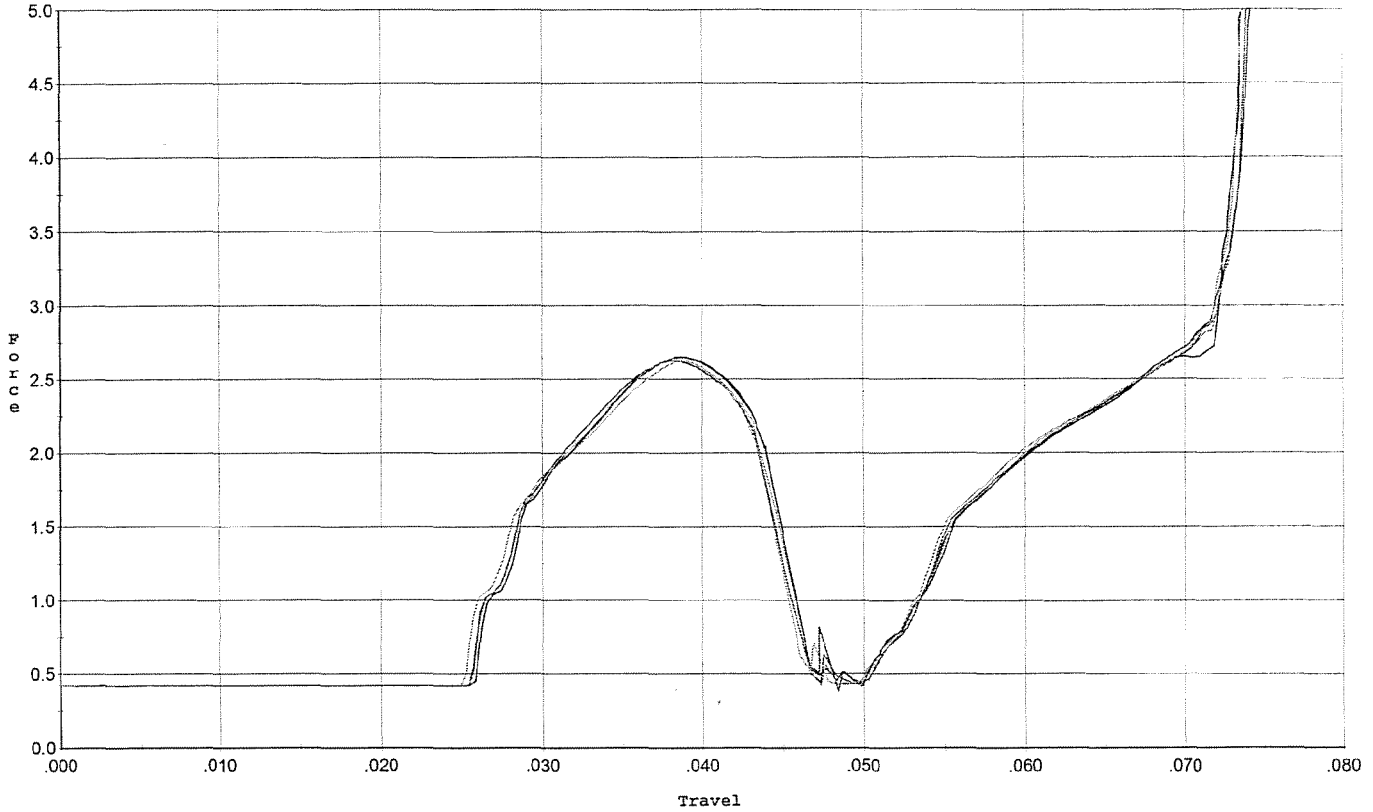
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.044	0.026	0.033	0.050		Set Trigger
2	2.627	0.045	0.026	0.033	0.052		Set Trigger
3	2.623	0.046	0.026	0.033	0.052		Set Trigger
4	2.661	0.044	0.026	0.033	0.051		Set Trigger
5	2.634	0.044	0.026	0.033	0.051		Set Trigger

A-2.62

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



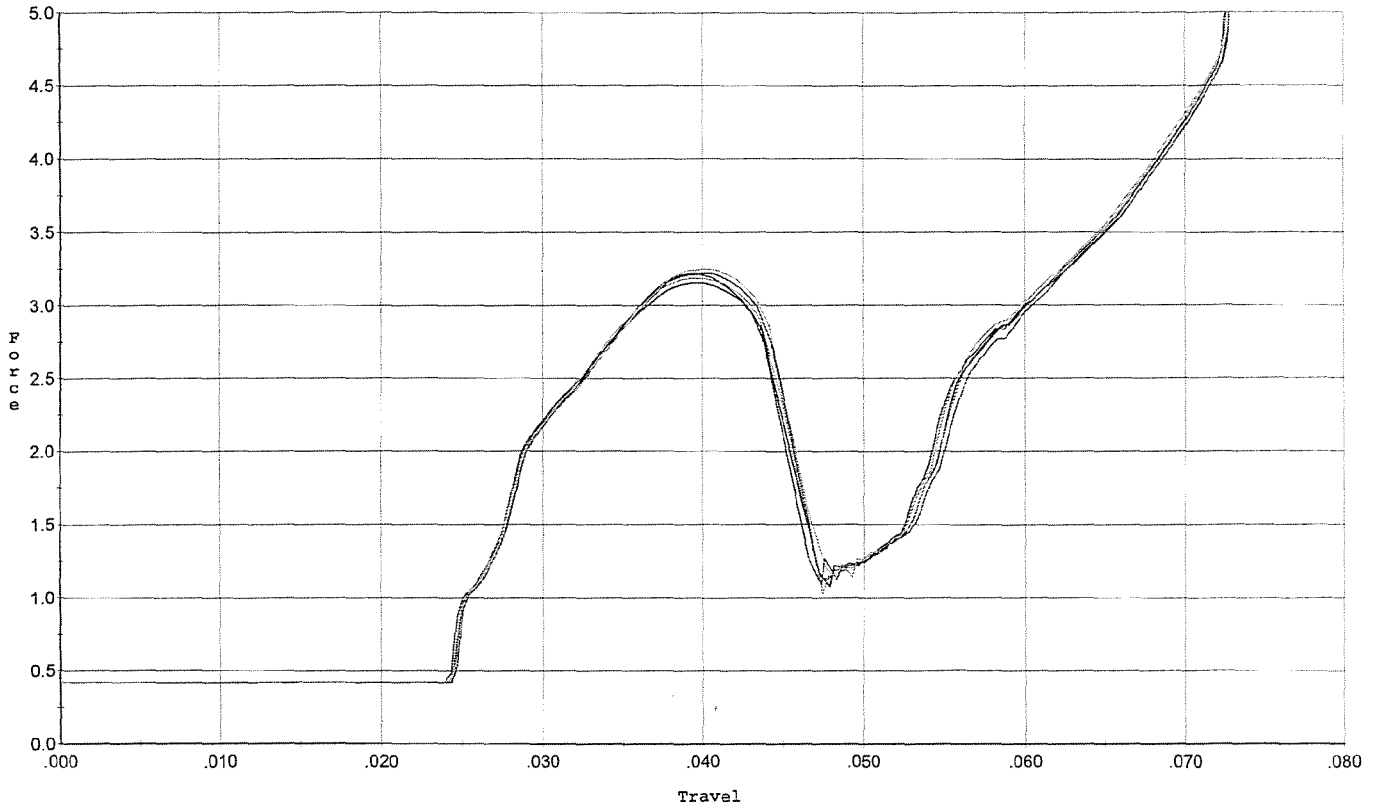
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.650	0.044	0.026	0.034	0.049		Set Trigger
2	2.653	0.044	0.026	0.033	0.049		Set Trigger
3	2.626	0.043	0.026	0.034	0.048		Set Trigger
4	2.641	0.043	0.025	0.034	0.049		Set Trigger
5	2.621	0.045	0.026	0.033	0.049		Set Trigger

17-2.63

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



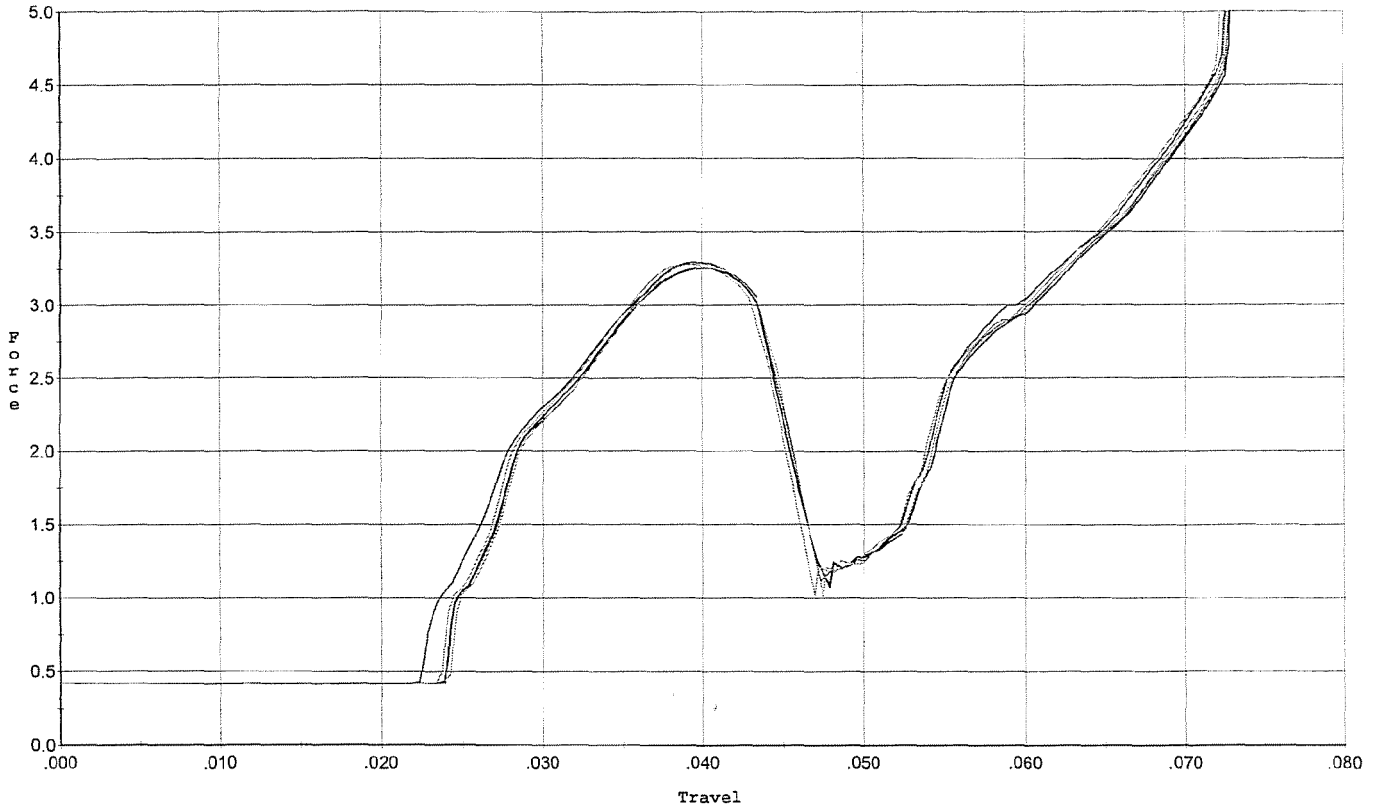
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.219	0.044	0.024	0.031	0.059		Set Trigger
2	3.155	0.044	0.025	0.031	0.059		Set Trigger
3	3.218	0.044	0.025	0.031	0.060		Set Trigger
4	3.246	0.044	0.025	0.031	0.060		Set Trigger
5	3.185	0.045	0.025	0.031	0.061		Set Trigger

A.3-20

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



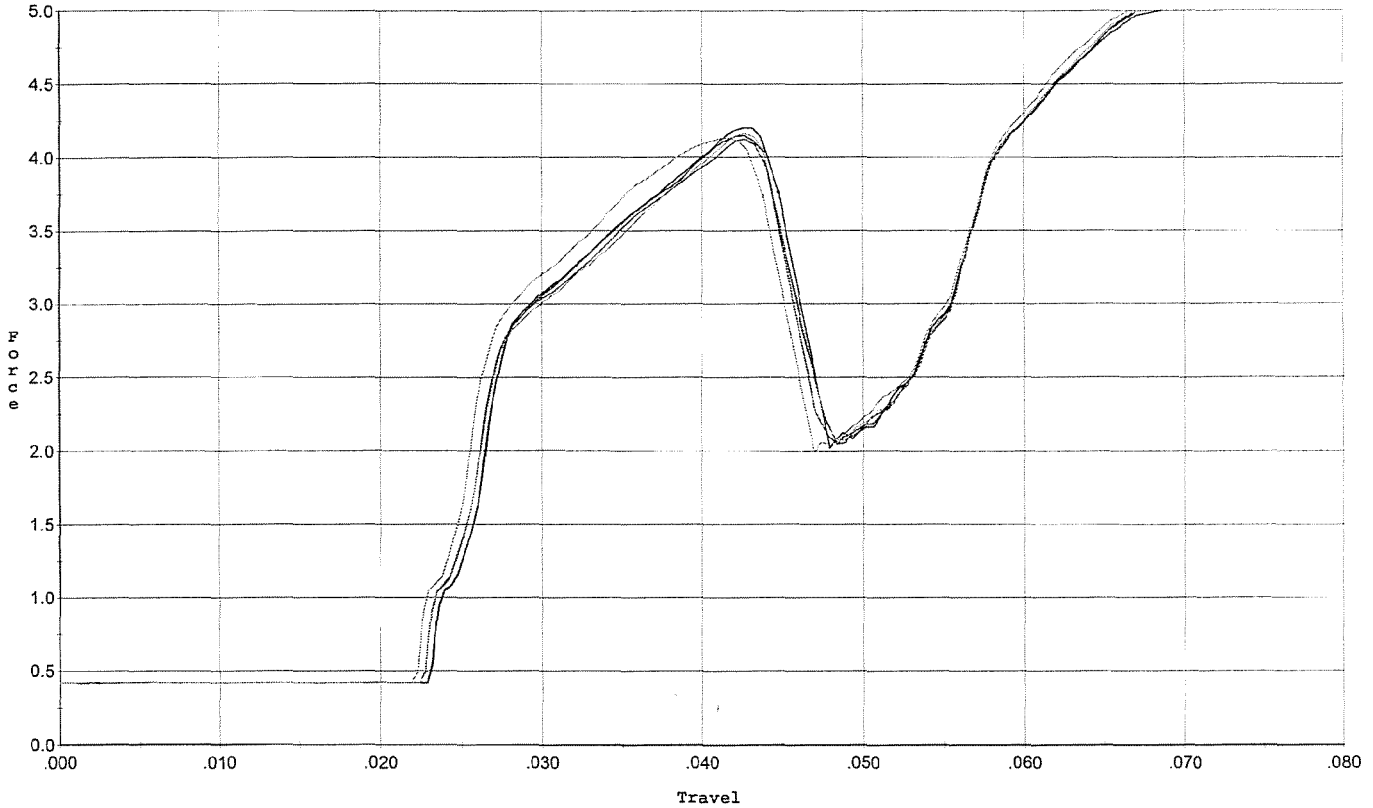
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.254	0.043	0.023	0.031	0.062		Set Trigger
2	3.253	0.043	0.024	0.031	0.060		Set Trigger
3	3.293	0.045	0.024	0.031	0.063		Set Trigger
4	3.280	0.045	0.024	0.031	0.062		Set Trigger
5	3.277	0.044	0.024	0.030	0.061		Set Trigger

A.3-27

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



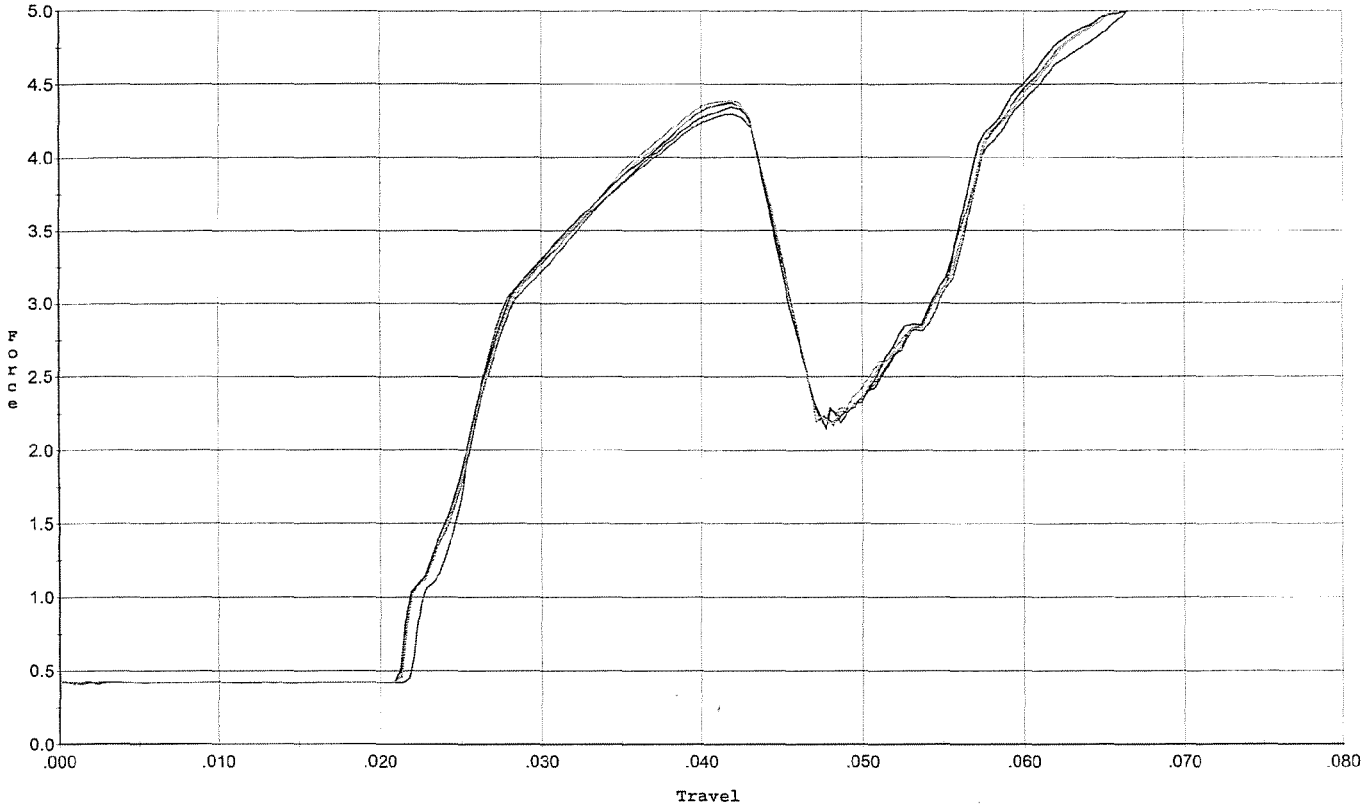
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.044	0.023	0.027	0.077		Set Trigger
2	4.201	0.045	0.023	0.027	0.080		Set Trigger
3	4.126	0.044	0.023	0.027	0.078		Set Trigger
4	4.164	0.044	0.023	0.027	0.077		Set Trigger
5	4.134	0.044	0.022	0.027	0.080		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: 4.0 lbs after 20 cycles+/- 1.0 lb



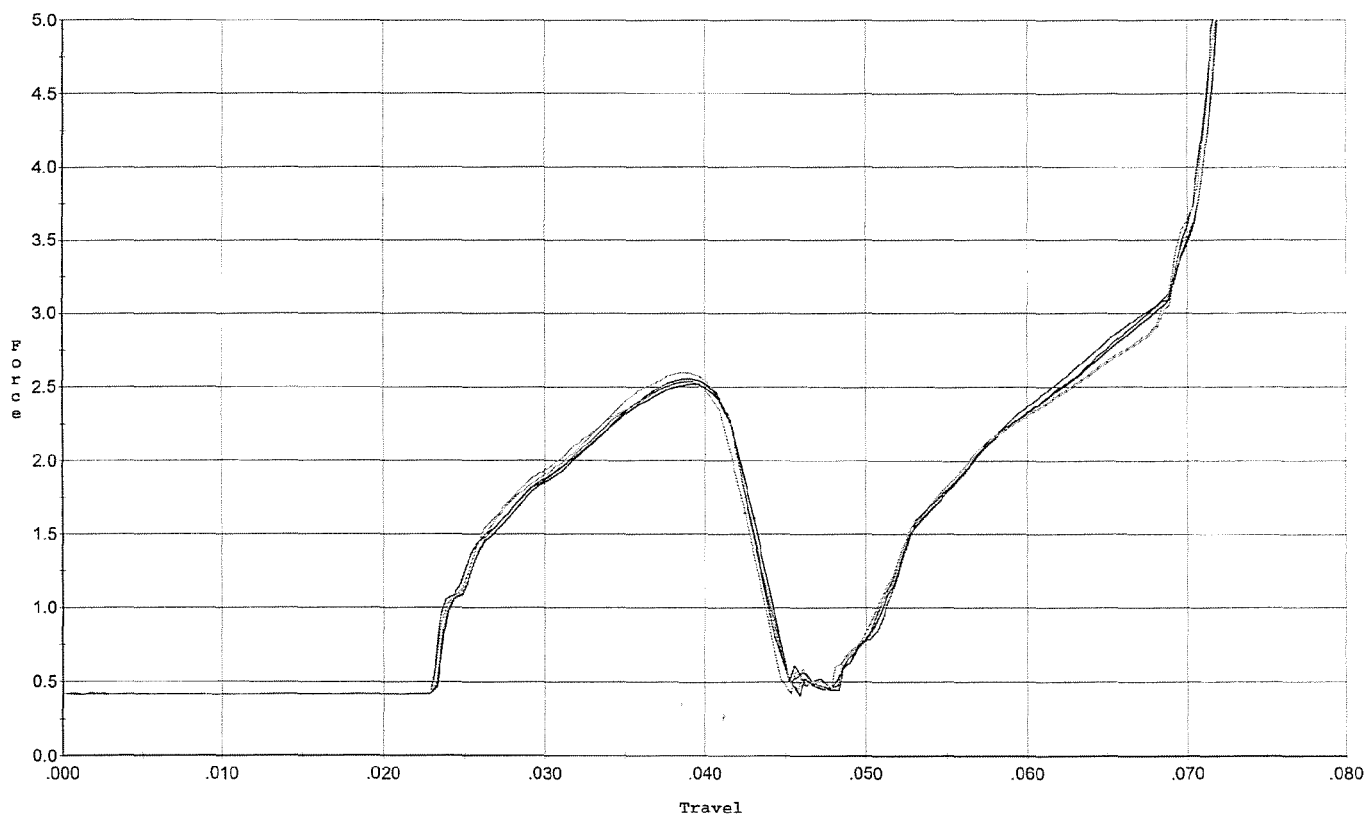
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.346	0.045	0.022	0.027	0.085		Set Trigger
2	4.376	0.043	0.021	0.027	0.082		Set Trigger
3	4.296	0.045	0.021	0.027	0.084		Set Trigger
4	4.364	0.045	0.022	0.027	0.085		Set Trigger
5	4.388	0.045	0.021	0.027	0.086		Set Trigger

A. 4.35

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



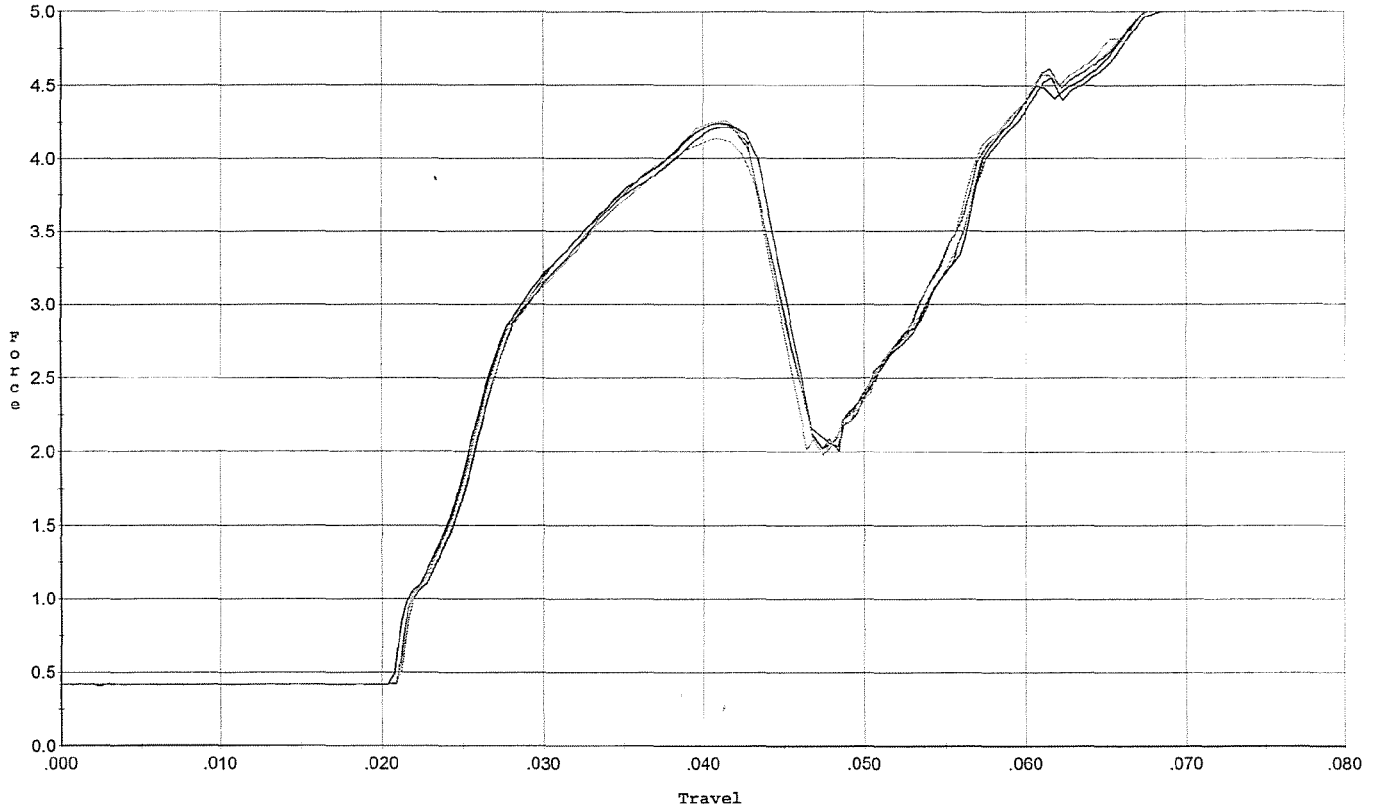
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.042	0.023	0.033	0.047		Set Trigger
2	2.522	0.043	0.024	0.033	0.048		Set Trigger
3	2.536	0.042	0.023	0.033	0.047		Set Trigger
4	2.597	0.041	0.023	0.034	0.047		Set Trigger
5	2.547	0.042	0.023	0.033	0.048		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: 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	4.212	0.043	0.021	0.027	0.080		Set Trigger
2	4.242	0.043	0.021	0.028	0.079		Set Trigger
3	4.241	0.043	0.021	0.028	0.078		Set Trigger
4	4.254	0.043	0.021	0.027	0.078		Set Trigger
5	4.137	0.043	0.021	0.028	0.078		Set Trigger

A-4-21