

6852290

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



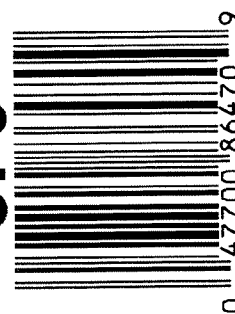
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6852290

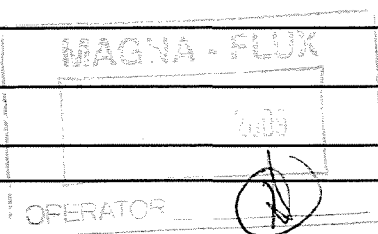
UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6852290

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-16-09	SP
430	ASSEMBLE TO STOCK		6-16-09	SP
440	PROOF		6-16-09	SP
460	CHECK HEADSPACE		6-16-09	SP
470	DIS-ASSEMBLE ACTION		6-16-09	SP
472	SERIALIZE BOLT HANDLE		6-17-09	RT
480	MAGNAFLUX BBL ACTION		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		6-18-09	ms
	APPLY COATINGS		7-25	C
540	(BARREL ACTION)			
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-13-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

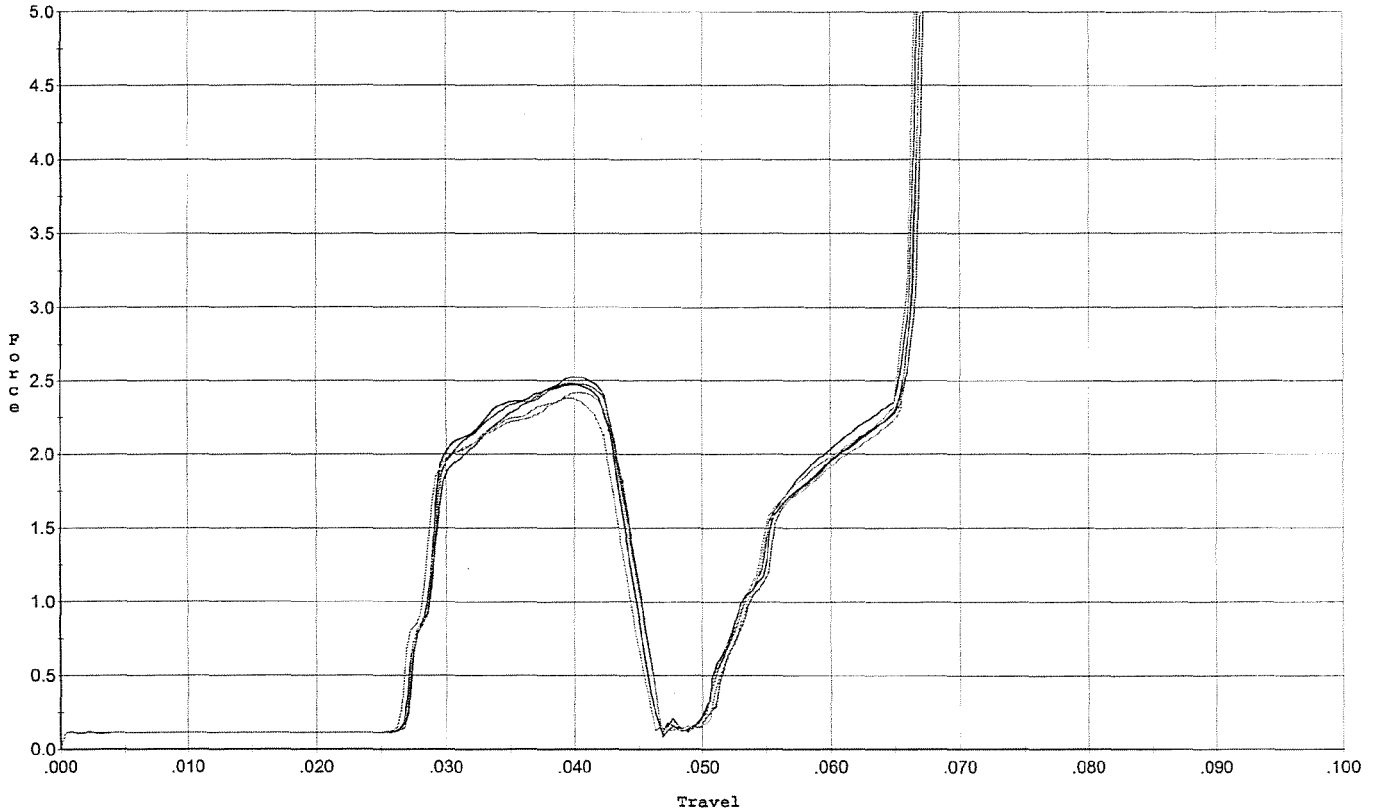
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	9/1/09	RB
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	9/1/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	9/1/09	RB
	J) ASSEMBLE STOCK		8-25-09	RJR
	K) ASSEMBLE SWIVEL STUDS		9/1/09	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	8-27-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-27-09	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		9/1/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u> <u>2.52</u> <u>2.51</u> <u>2.57</u> <u>2.51</u>	9/1/09	RB
	C) FUNCTION		9/1/09	RB
690	PACK		9/1/09	Fm

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



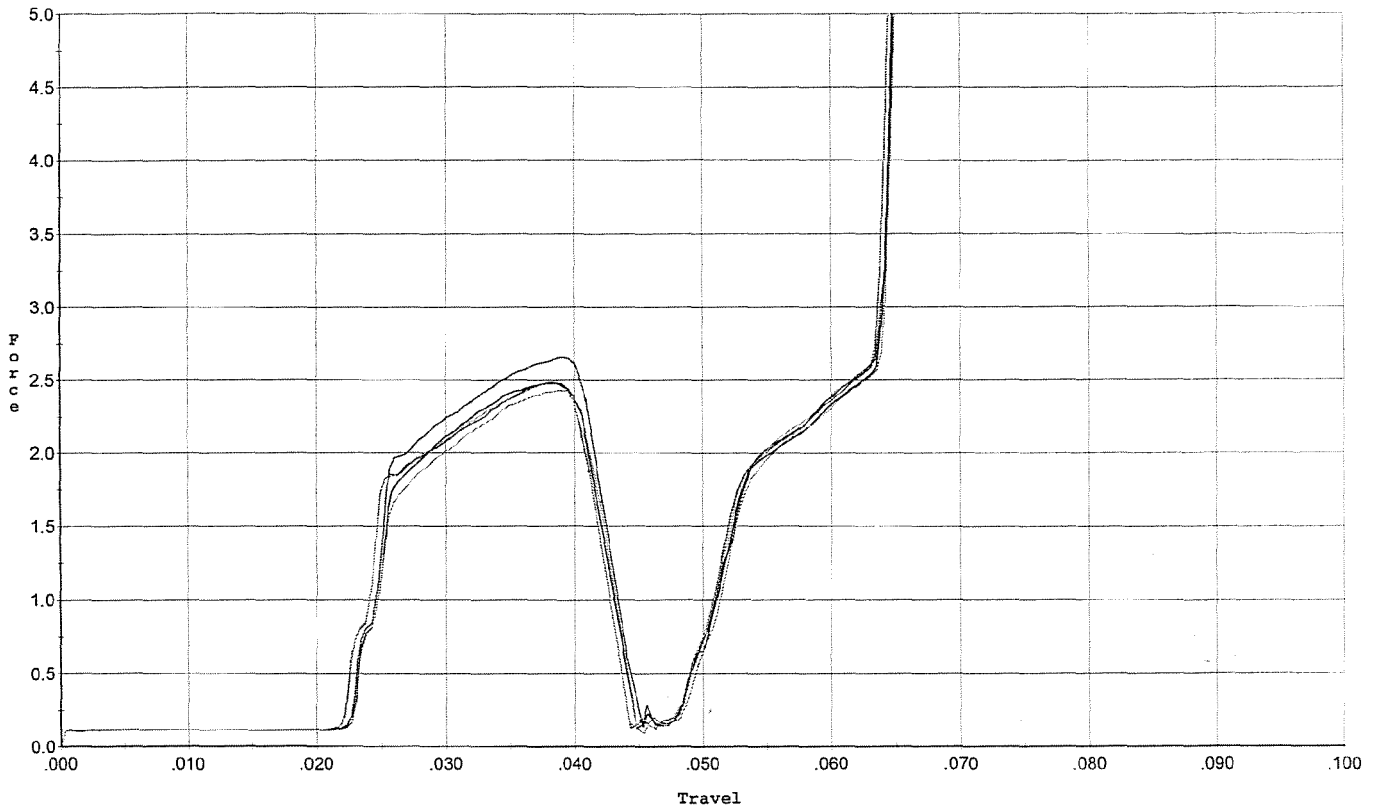
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.044	0.027	0.029	0.038		Set Trigger
2	2.476	0.043	0.027	0.029	0.037		Set Trigger
3	2.484	0.044	0.027	0.029	0.038		Set Trigger
4	2.418	0.045	0.027	0.029	0.038		Set Trigger
5	2.382	0.042	0.027	0.029	0.036		Set Trigger

A-2-45

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



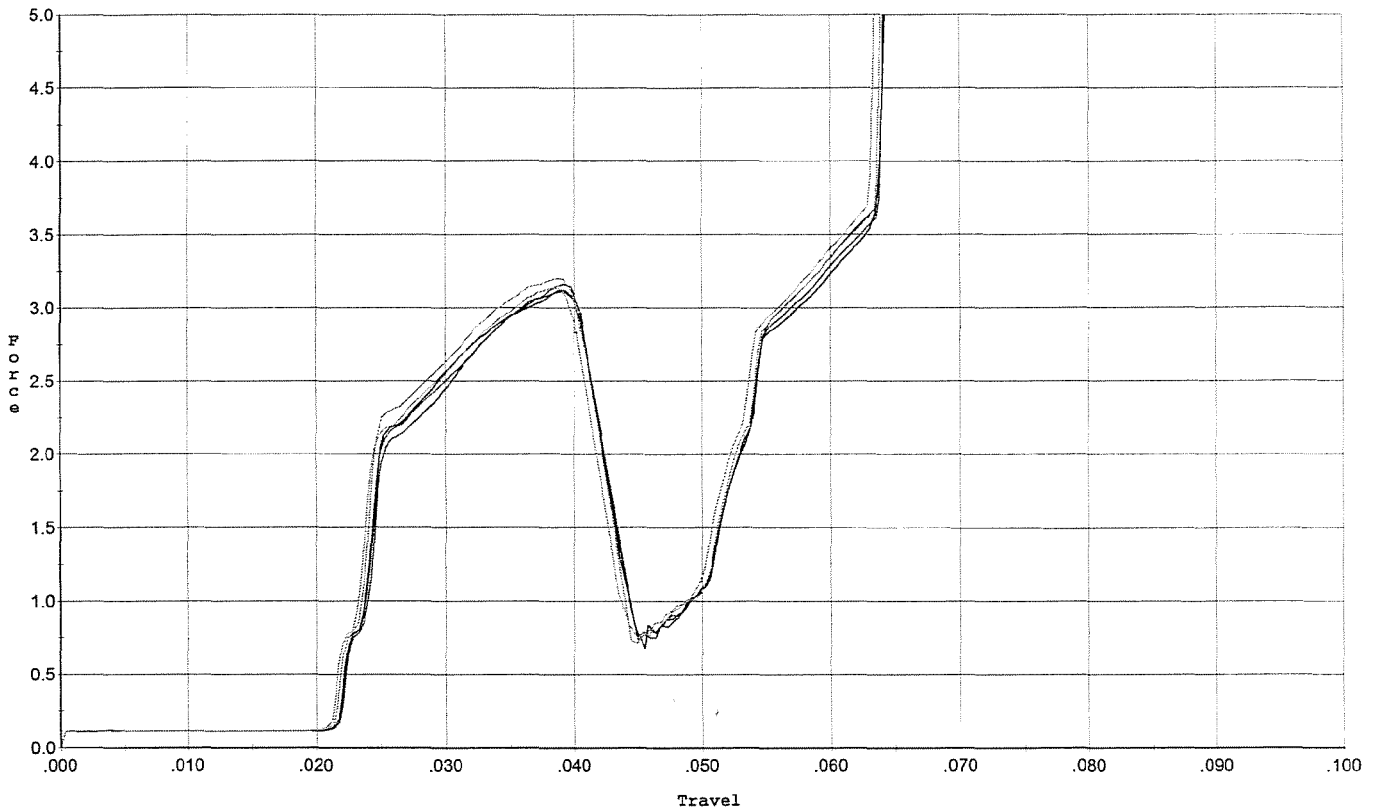
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.041	0.023	0.027	0.043		Set Trigger
2	2.476	0.043	0.023	0.027	0.042		Set Trigger
3	2.482	0.041	0.022	0.027	0.041		Set Trigger
4	2.491	0.041	0.022	0.027	0.041		Set Trigger
5	2.426	0.042	0.023	0.027	0.040		Set Trigger

A-250

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



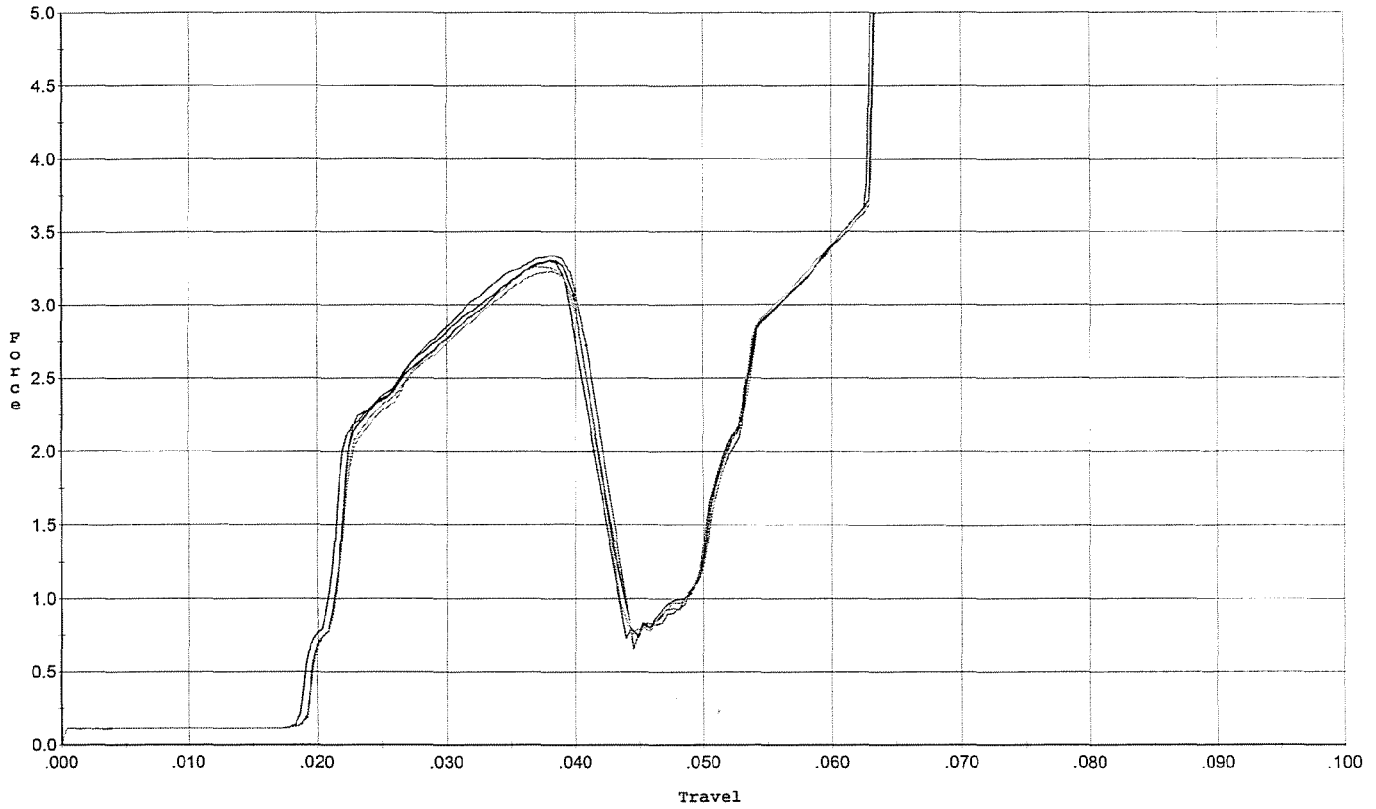
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.041	0.022	0.026	0.049		Set Trigger
2	3.120	0.041	0.022	0.026	0.050		Set Trigger
3	3.108	0.041	0.022	0.026	0.049		Set Trigger
4	3.134	0.040	0.021	0.025	0.050		Set Trigger
5	3.201	0.041	0.022	0.025	0.052		Set Trigger

A-3.14

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



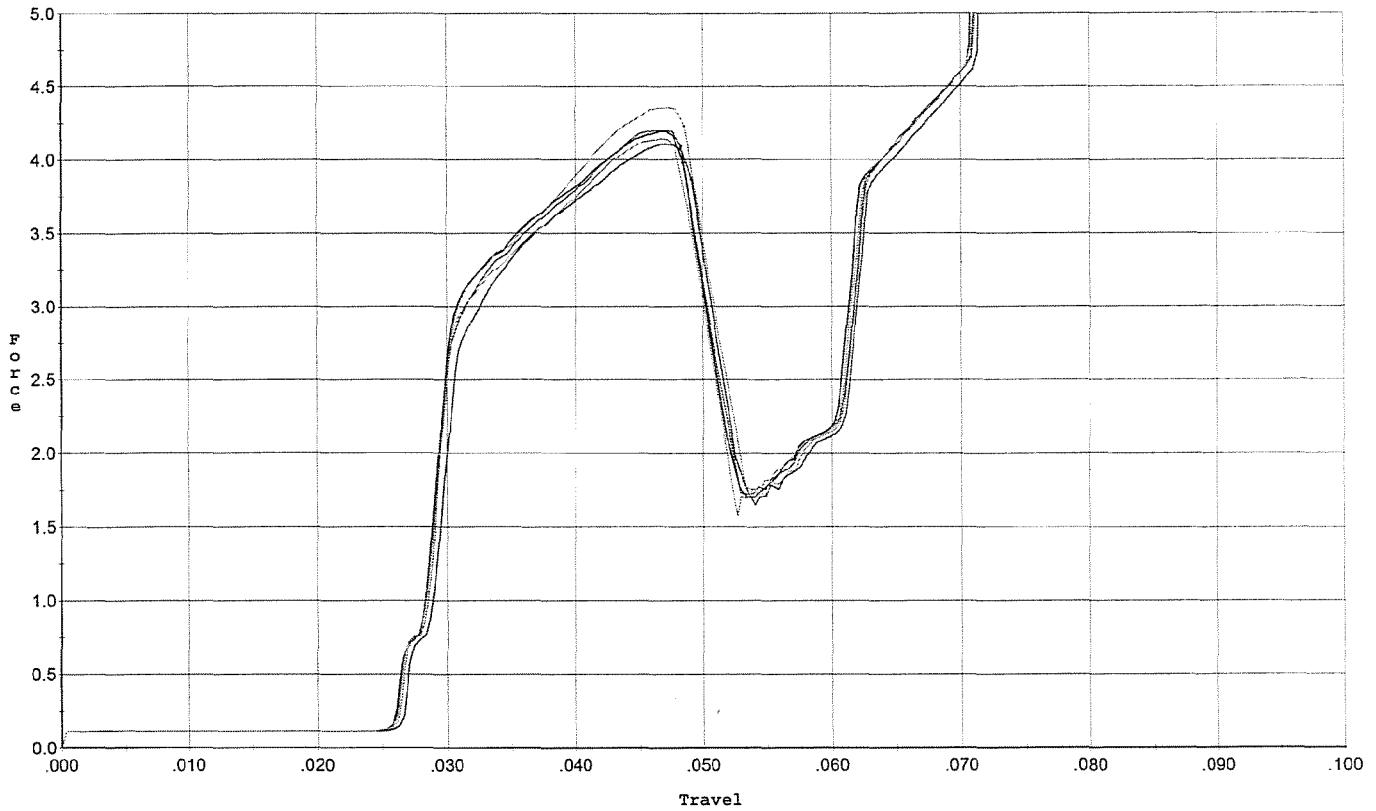
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.302	0.041	0.019	0.025	0.059		Set Trigger
2	3.304	0.040	0.019	0.025	0.056		Set Trigger
3	3.334	0.041	0.019	0.024	0.059		Set Trigger
4	3.261	0.040	0.019	0.025	0.056		Set Trigger
5	3.228	0.040	0.019	0.025	0.055		Set Trigger

A-3-28

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



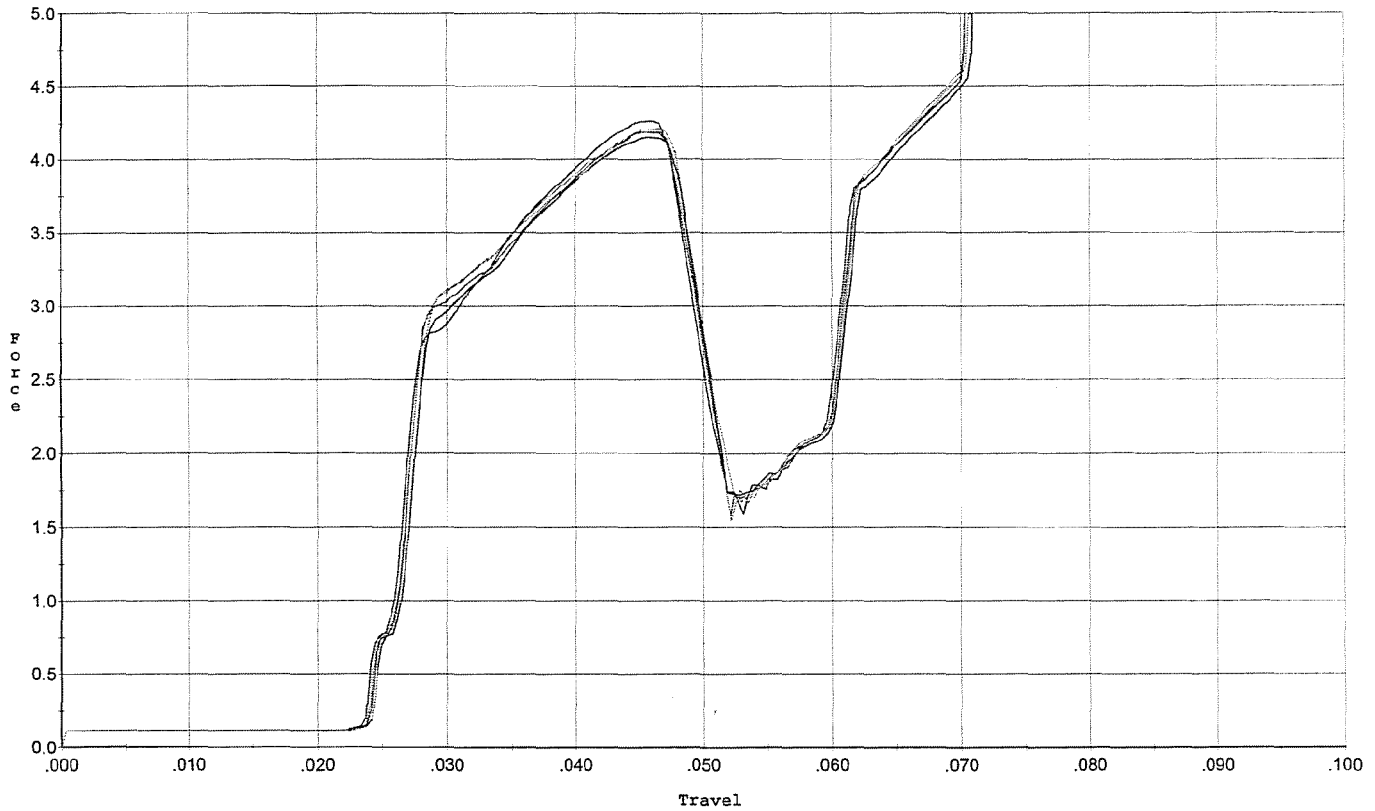
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.105	0.049	0.027	0.026	0.078		Set Trigger
2	4.193	0.048	0.026	0.026	0.079		Set Trigger
3	4.201	0.048	0.026	0.026	0.078		Set Trigger
4	4.143	0.049	0.026	0.026	0.079		Set Trigger
5	4.354	0.049	0.026	0.026	0.081		Set Trigger

A-4-19

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



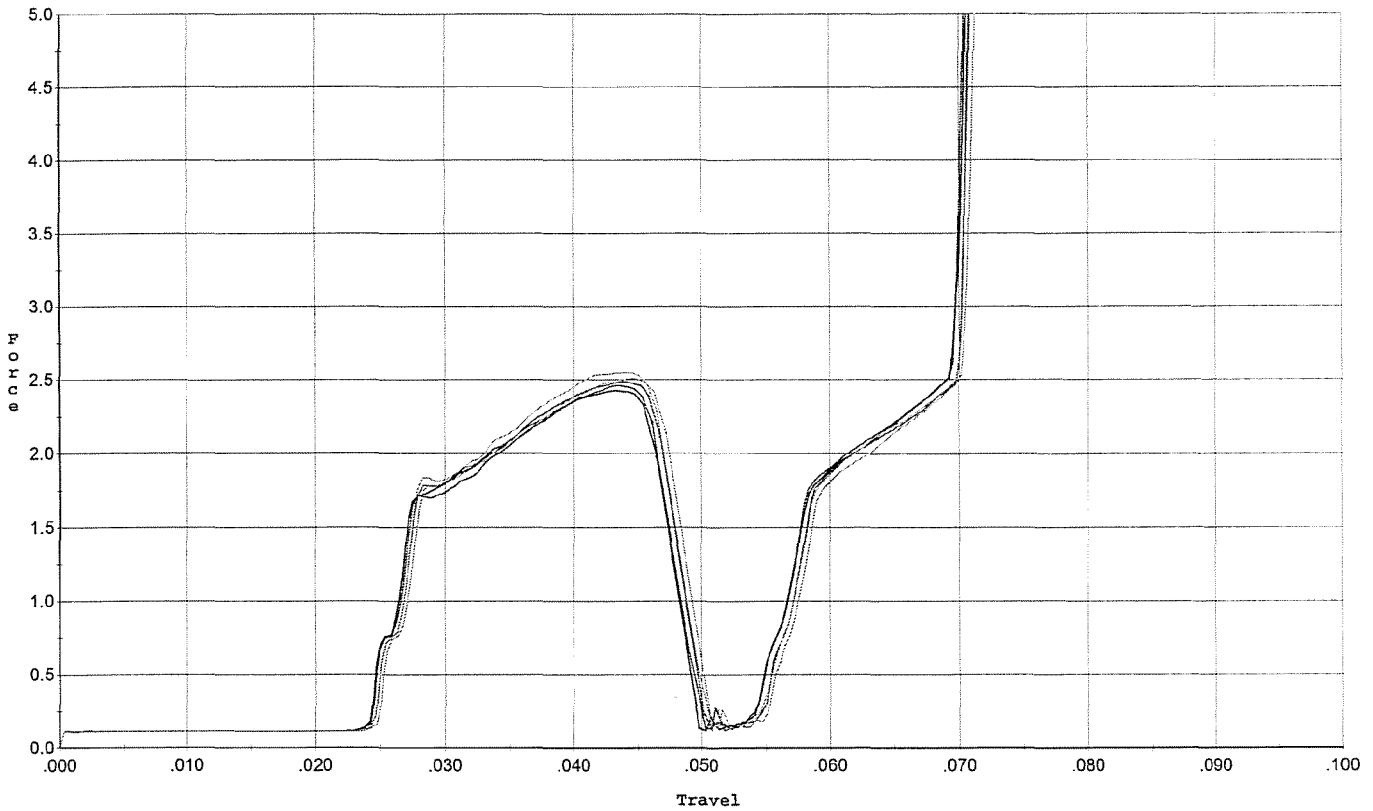
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.262	0.047	0.024	0.025	0.082		Set Trigger
2	4.152	0.048	0.024	0.025	0.082		Set Trigger
3	4.191	0.049	0.024	0.025	0.085		Set Trigger
4	4.210	0.048	0.024	0.025	0.083		Set Trigger
5	4.193	0.049	0.024	0.025	0.084		Set Trigger

A-4-20

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



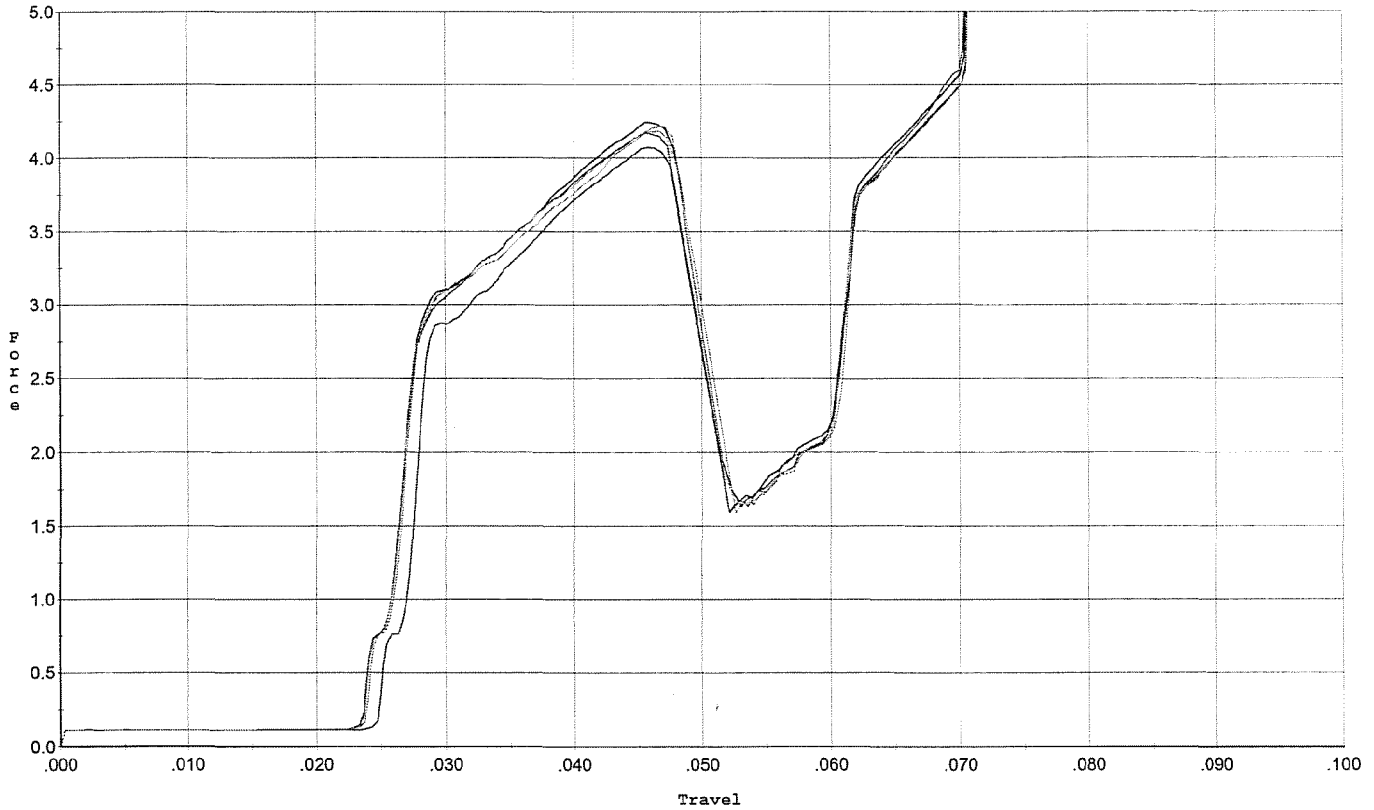
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.046	0.025	0.028	0.046		Set Trigger
2	2.428	0.046	0.024	0.028	0.047		Set Trigger
3	2.485	0.047	0.025	0.028	0.048		Set Trigger
4	2.547	0.047	0.025	0.028	0.048		Set Trigger
5	2.509	0.047	0.025	0.028	0.048		Set Trigger

A-2-48

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	4.073	0.050	0.025	0.025	0.081		Set Trigger
2	4.243	0.048	0.024	0.025	0.084		Set Trigger
3	4.170	0.049	0.024	0.025	0.086		Set Trigger
4	4.183	0.048	0.024	0.025	0.084		Set Trigger
5	4.214	0.050	0.024	0.025	0.087		Set Trigger

A-4-17