

G685-2303

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



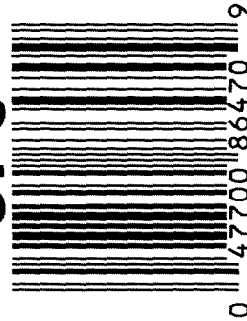
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6852303

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 685 2303

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-5-09	RP
430	ASSEMBLE TO STOCK		5-5-09	SP
440	PROOF		5-5-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX MAY 02 2009 OPERATOR JD	5-5-09	RP
470	DIS-ASSEMBLE ACTION		5-5-09	RP
472	SERIALIZE BOLT HANDLE		5-5-09	RP
480	MAGNAFLUX BBL ACTION		5/8/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/12/09	RT
510	DRILL AND TAP SIGHT HOLES		5-6-06	SP
520	GOFF BLAST BBL / REC		5/12/09	REM
540	APPLY COATINGS (BARREL ACTION)		5/22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-26-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-26-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	5-26-09	SP
	D) OIL FIRING PIN ASSEMBLY		5-29-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

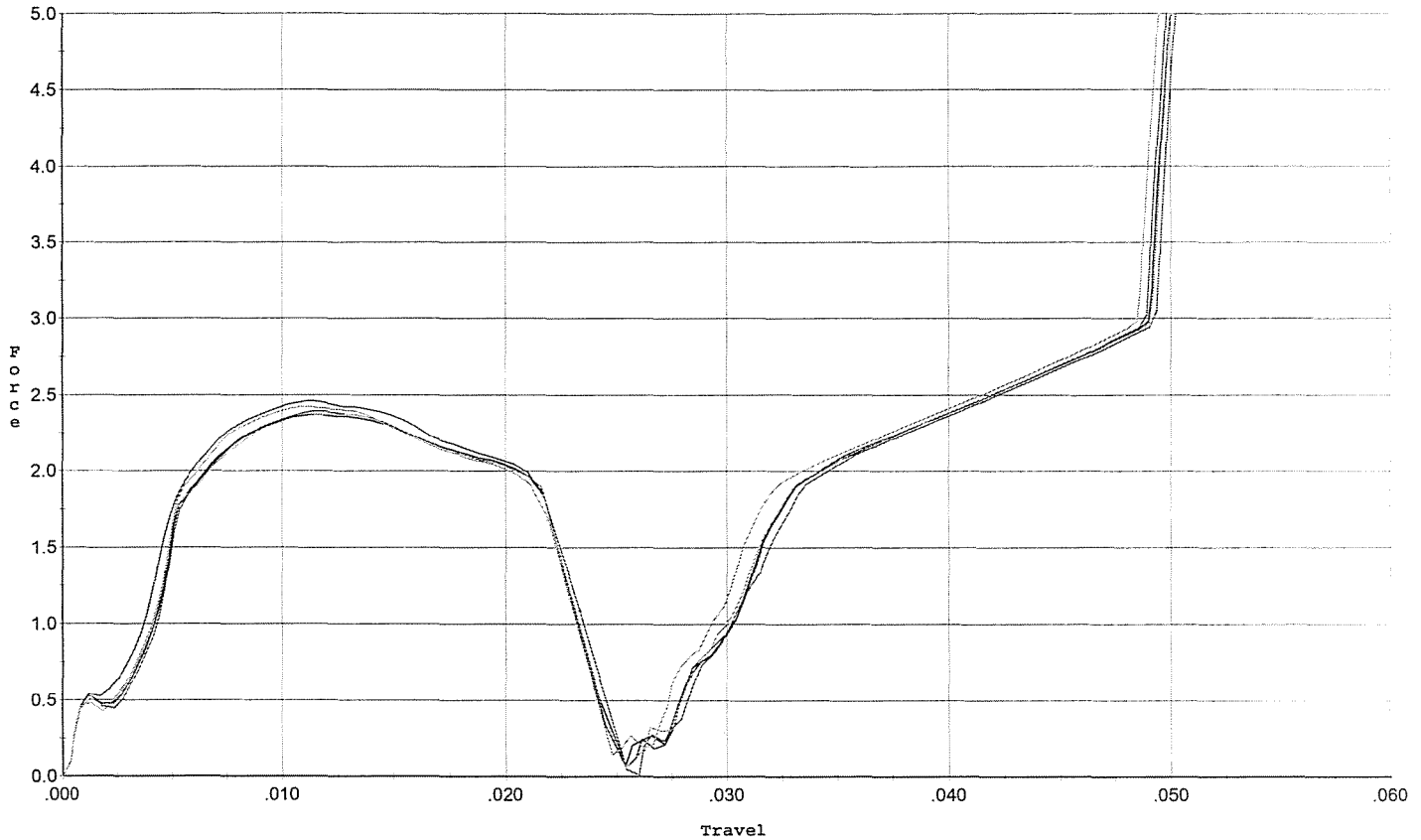
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4⁰</u> <u>4⁰</u> <u>4⁰</u>	6-24-09	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5⁰</u> <u>5⁰</u> <u>4⁰</u>	6-24-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	6-24-09	LJN
	J) ASSEMBLE STOCK		5-29-09	LJN
	K) ASSEMBLE SWIVEL STUDS		6-24-09	LJN
	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	PASS FAIL PASS FAIL	6-9-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-9-09	LJN
670	FINAL INSPECTION A) HEADSPACE		6-24-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>286</u> <u>283</u> <u>280</u> <u>282</u> <u>287</u>	6-23-09	LJN
	C) FUNCTION		6-24-09	LJN
690	PACK		7/22/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



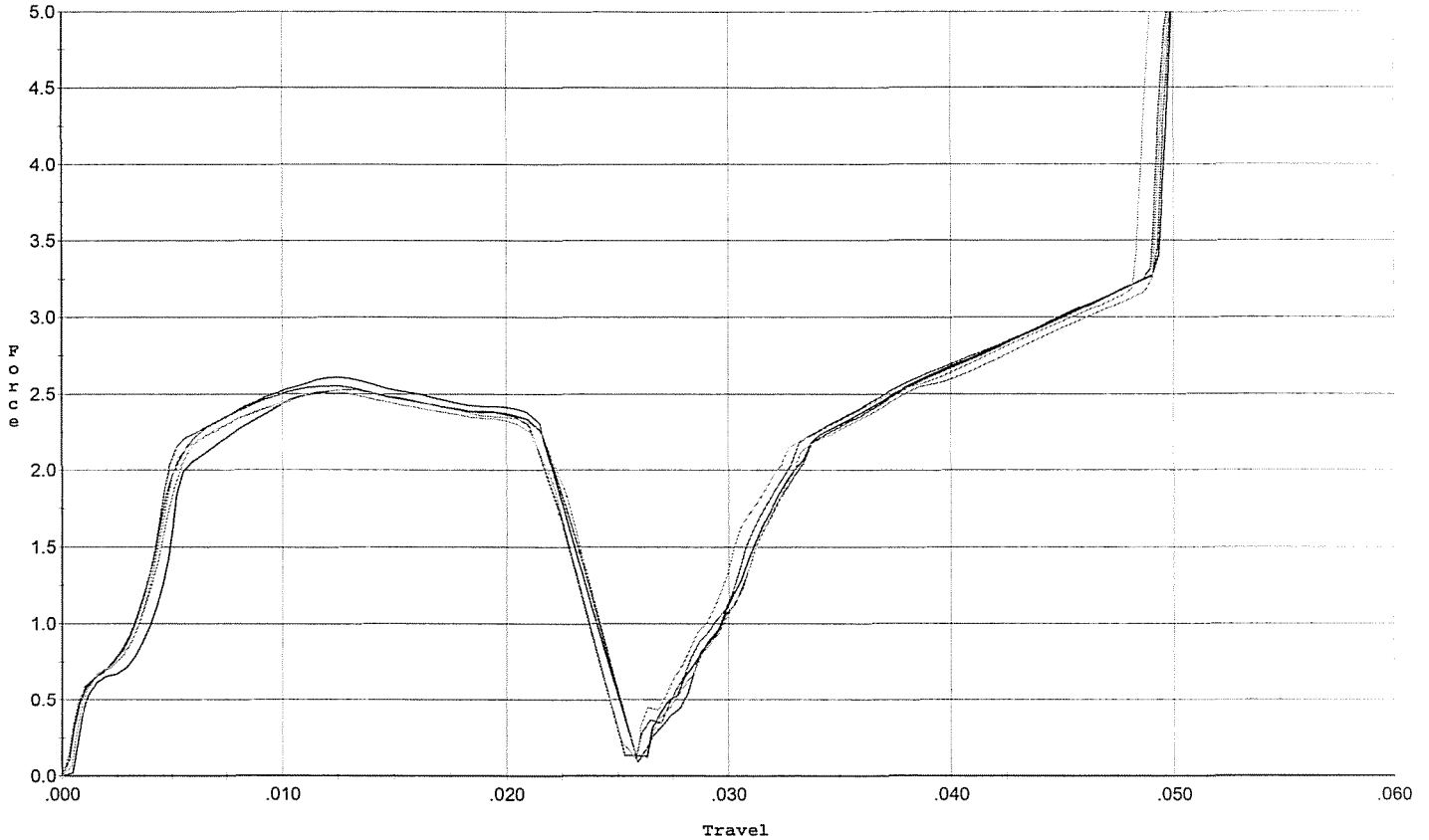
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.463	0.022	0.00	0.032	0.039		Set Trigger
2	2.372	0.022	0.003	0.032	0.038		Set Trigger
3	2.393	0.023	0.003	0.032	0.040		Set Trigger
4	2.372	0.022	0.00	0.032	0.038		Set Trigger
5	2.423	0.022	0.00	0.032	0.038		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



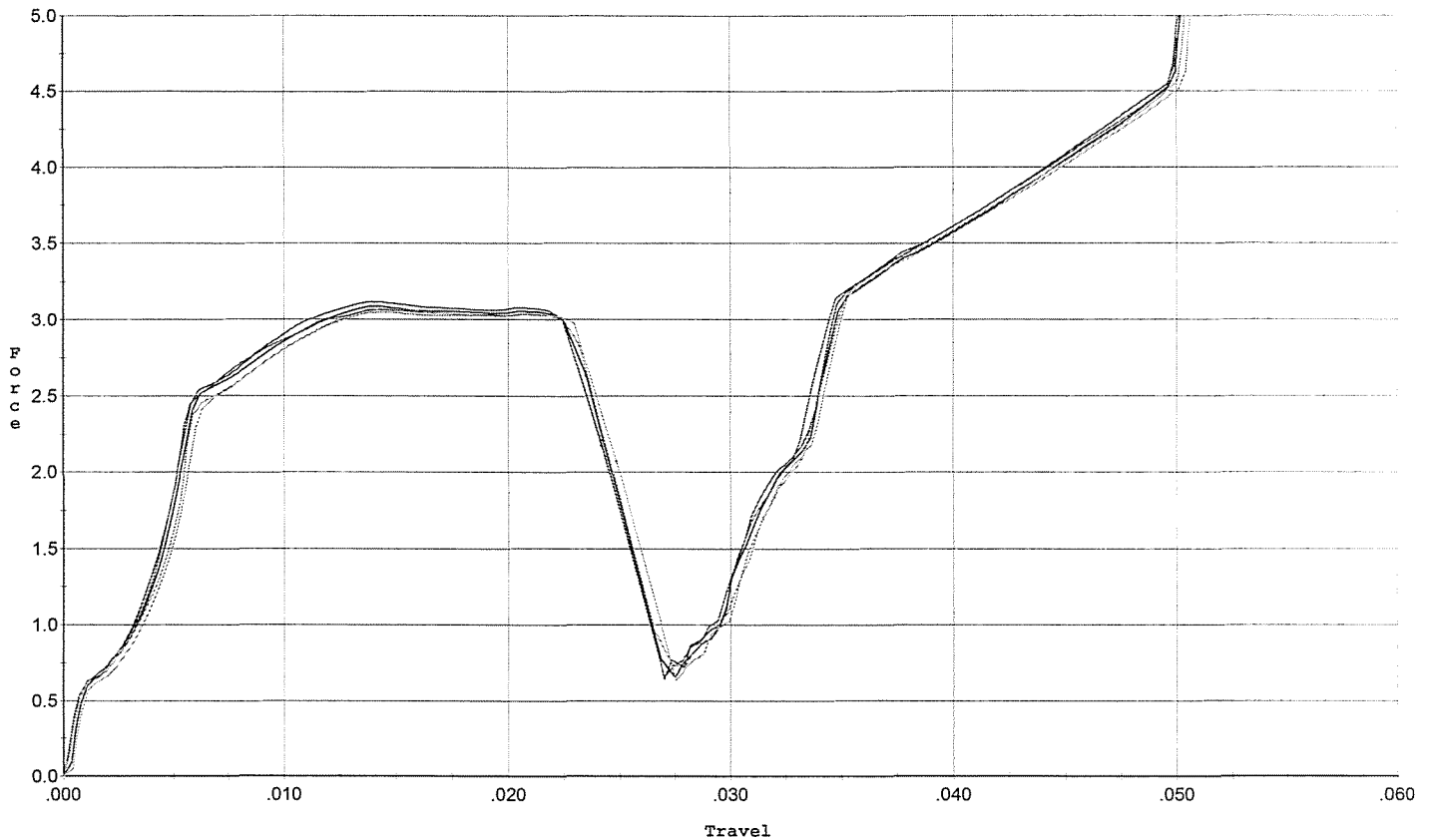
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.023	0.00	0.032	0.046		Set Trigger
2	2.527	0.022	0.00	0.032	0.041		Set Trigger
3	2.550	0.022	0.00	0.032	0.044		Set Trigger
4	2.510	0.022	0.00	0.031	0.042		Set Trigger
5	2.530	0.023	0.00	0.032	0.044		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



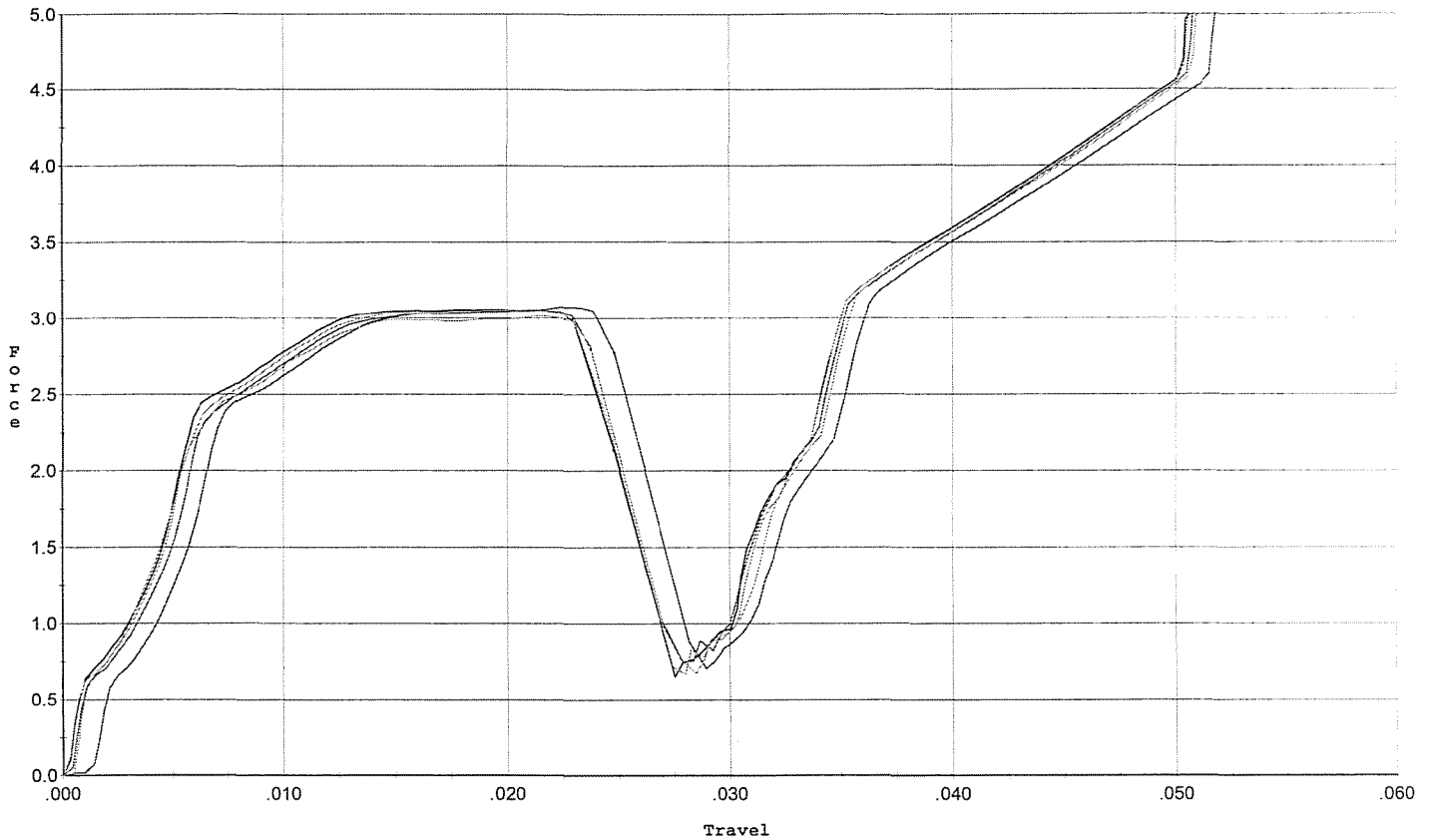
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.024	0.00	0.030	0.057		Set Trigger
2	3.089	0.023	0.00	0.030	0.054		Set Trigger
3	3.066	0.024	0.00	0.030	0.056		Set Trigger
4	3.071	0.025	0.00	0.030	0.057		Set Trigger
5	3.052	0.023	0.00	0.030	0.053		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



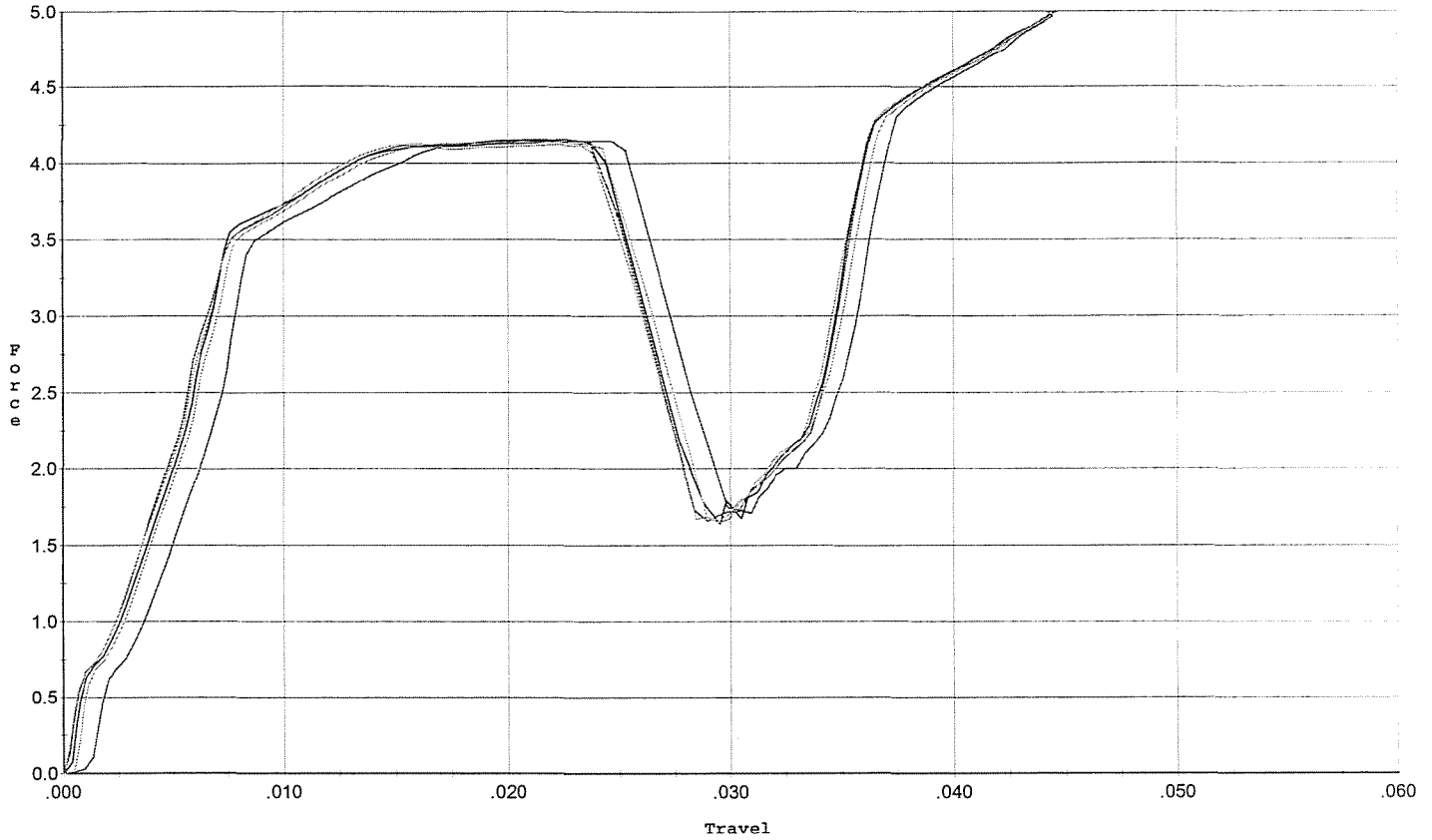
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.074	0.025	0.00	0.031	0.055		Set Trigger
2	3.057	0.025	0.00	0.030	0.057		Set Trigger
3	3.051	0.024	0.00	0.031	0.054		Set Trigger
4	3.056	0.024	0.00	0.031	0.056		Set Trigger
5	3.015	0.024	0.00	0.031	0.054		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



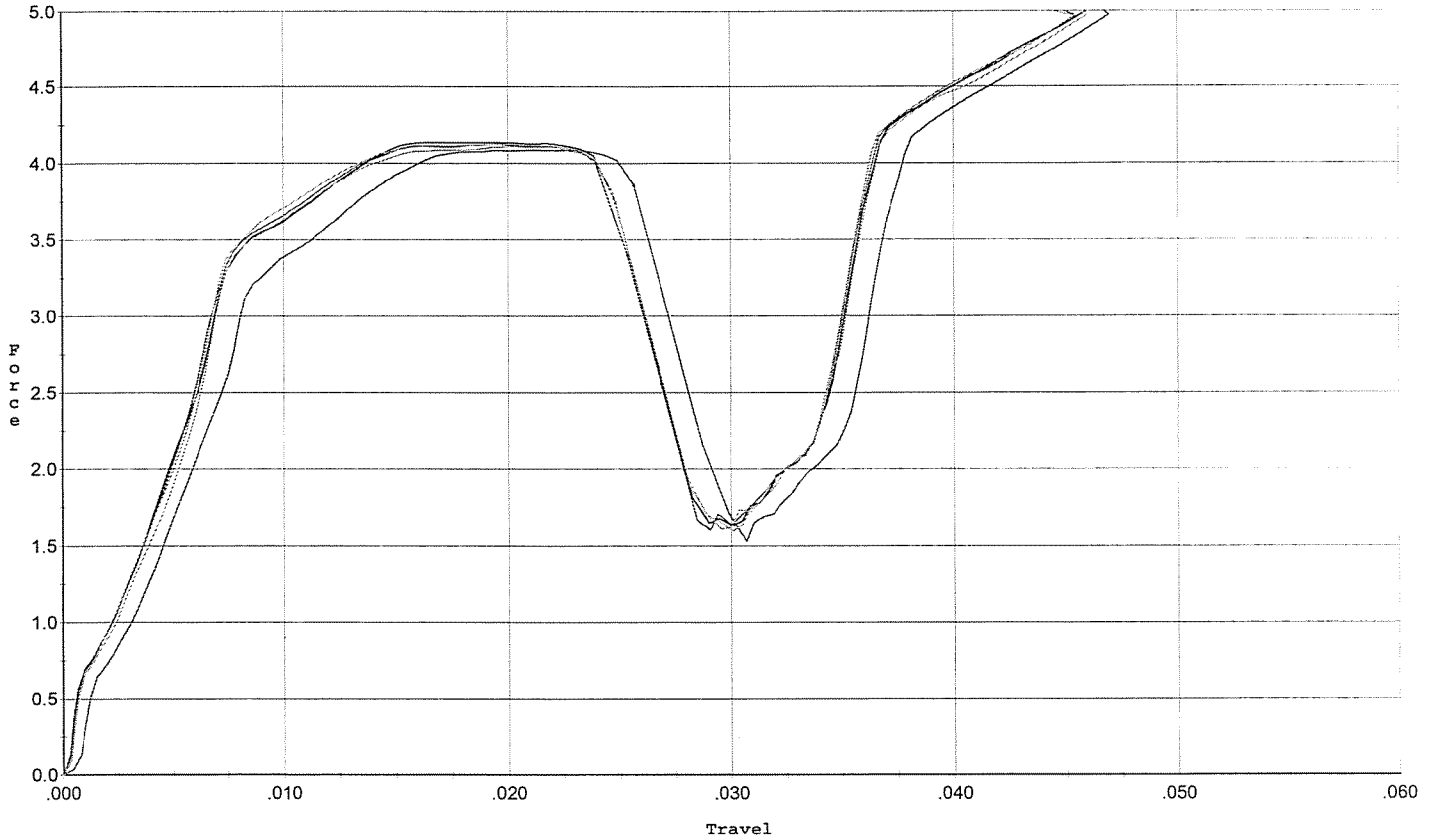
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.161	0.025	0.00	0.024	0.074		Set Trigger
2	4.157	0.024	0.00	0.024	0.074		Set Trigger
3	4.145	0.025	0.00	0.025	0.076		Set Trigger
4	4.123	0.026	0.00	0.024	0.079		Set Trigger
5	4.144	0.026	0.00	0.026	0.078		Set Trigger

Aug 4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



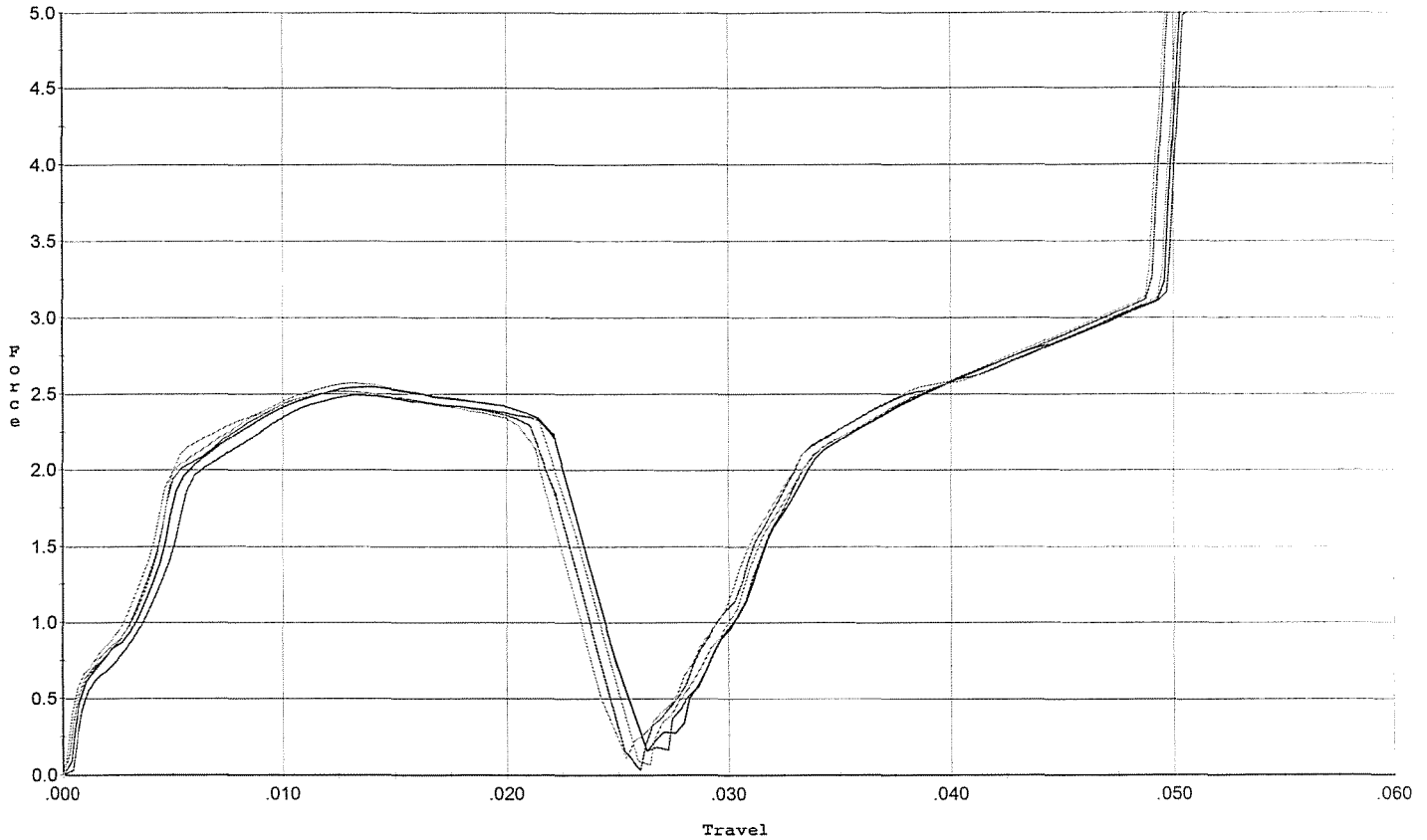
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.087	0.026	0.00	0.025	0.074		Set Trigger
2	4.137	0.025	0.00	0.028	0.075		Set Trigger
3	4.125	0.025	0.00	0.028	0.076		Set Trigger
4	4.112	0.025	0.00	0.028	0.074		Set Trigger
5	4.128	0.025	0.00	0.028	0.075		Set Trigger

Aug 4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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



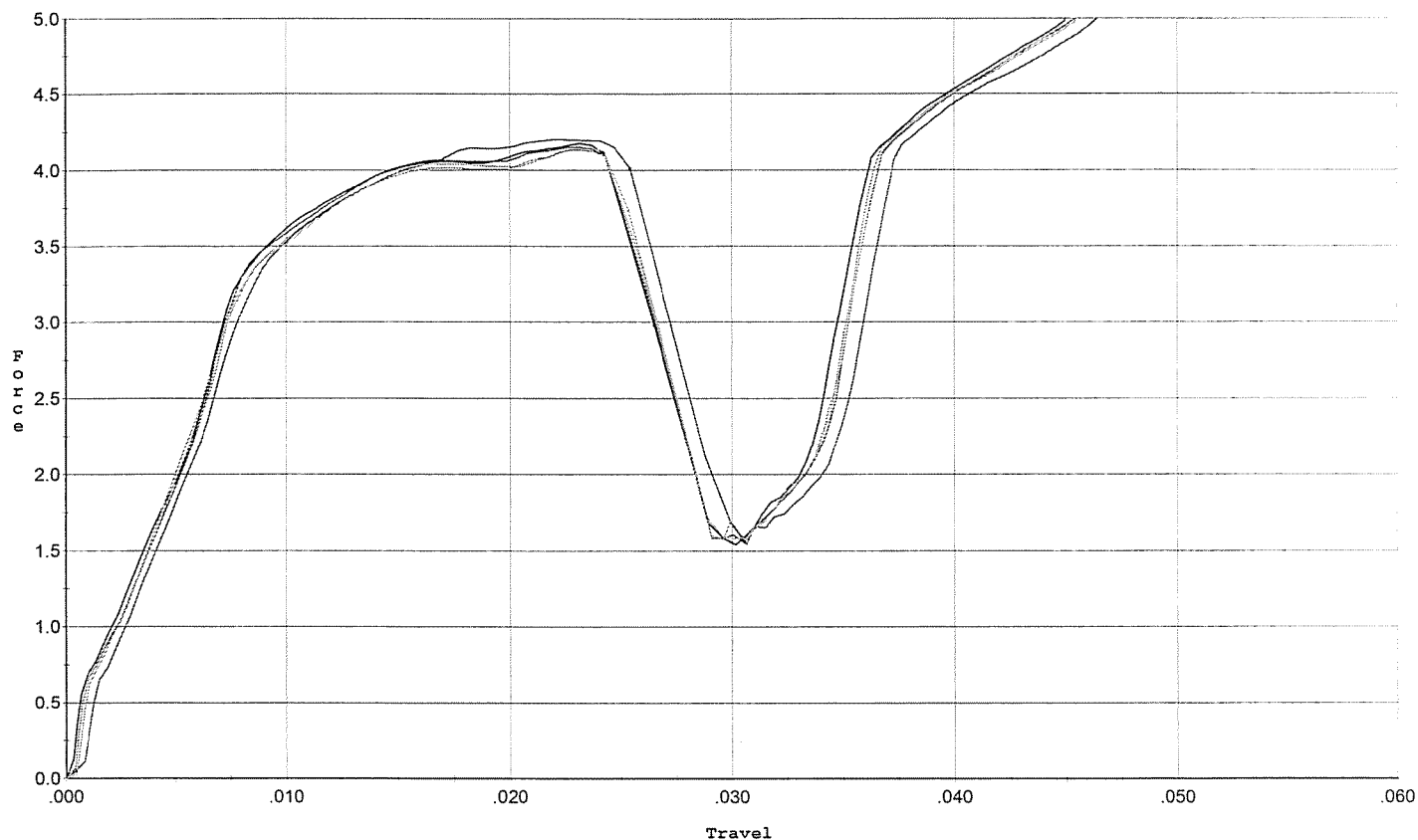
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.494	0.022	0.00	0.032	0.042		Set Trigger
2	2.547	0.022	0.00	0.032	0.043		Set Trigger
3	2.519	0.022	0.00	0.032	0.043		Set Trigger
4	2.518	0.021	0.00	0.032	0.041		Set Trigger
5	2.572	0.023	0.00	0.032	0.045		Set Trigger

Aug 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 5/15/09

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	4.201	0.025	0.00	0.024	0.076		Set Trigger
2	4.174	0.026	0.00	0.024	0.079		Set Trigger
3	4.151	0.026	0.00	0.024	0.078		Set Trigger
4	4.143	0.025	0.00	0.024	0.075		Set Trigger
5	4.131	0.026	0.00	0.024	0.076		Set Trigger

Aug 4.16