

G685 8446

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



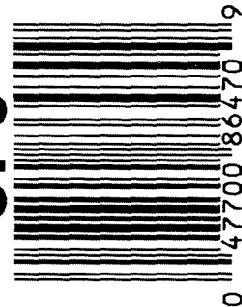
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6858446

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6858446

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	SP
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	5-21-09	RP
470	DIS-ASSEMBLE ACTION	MAY 20 2009	5-21-09	RP
472	SERIALIZE BOLT HANDLE		5-22-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	5/26/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5/29/09	RP
510	DRILL AND TAP SIGHT HOLES		5-22-09	SP
520	GOFF BLAST BBL / REC		5/29/09	gm
540	APPLY COATINGS (BARREL ACTION)		6/1	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6/2/09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6/2/09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6/2/09	SP
	D) OIL FIRING PIN ASSEMBLY		6-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

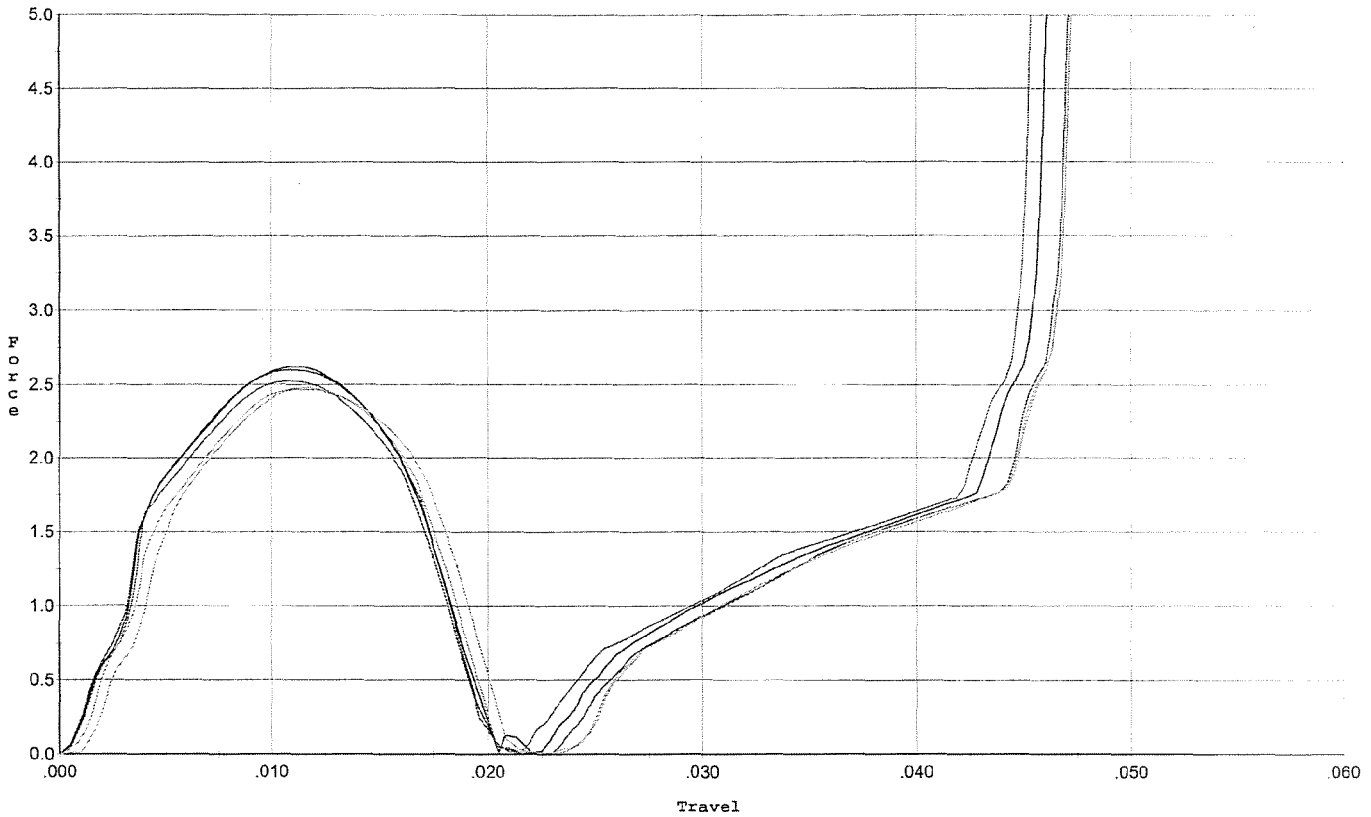
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-16-09	LJN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-16-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	6-16-09	LJN
	J) ASSEMBLE STOCK		6-8-09	LJN
	K) ASSEMBLE SWIVEL STUDS		6-16-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	6/12/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/12/09	TCR
670	FINAL INSPECTION A) HEADSPACE		6-16-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>230</u> <u>247</u> <u>227</u> <u>222</u> <u>243</u>	6-15-09	LTZ
	C) FUNCTION		6-16-09	LJN
690	PACK		7/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



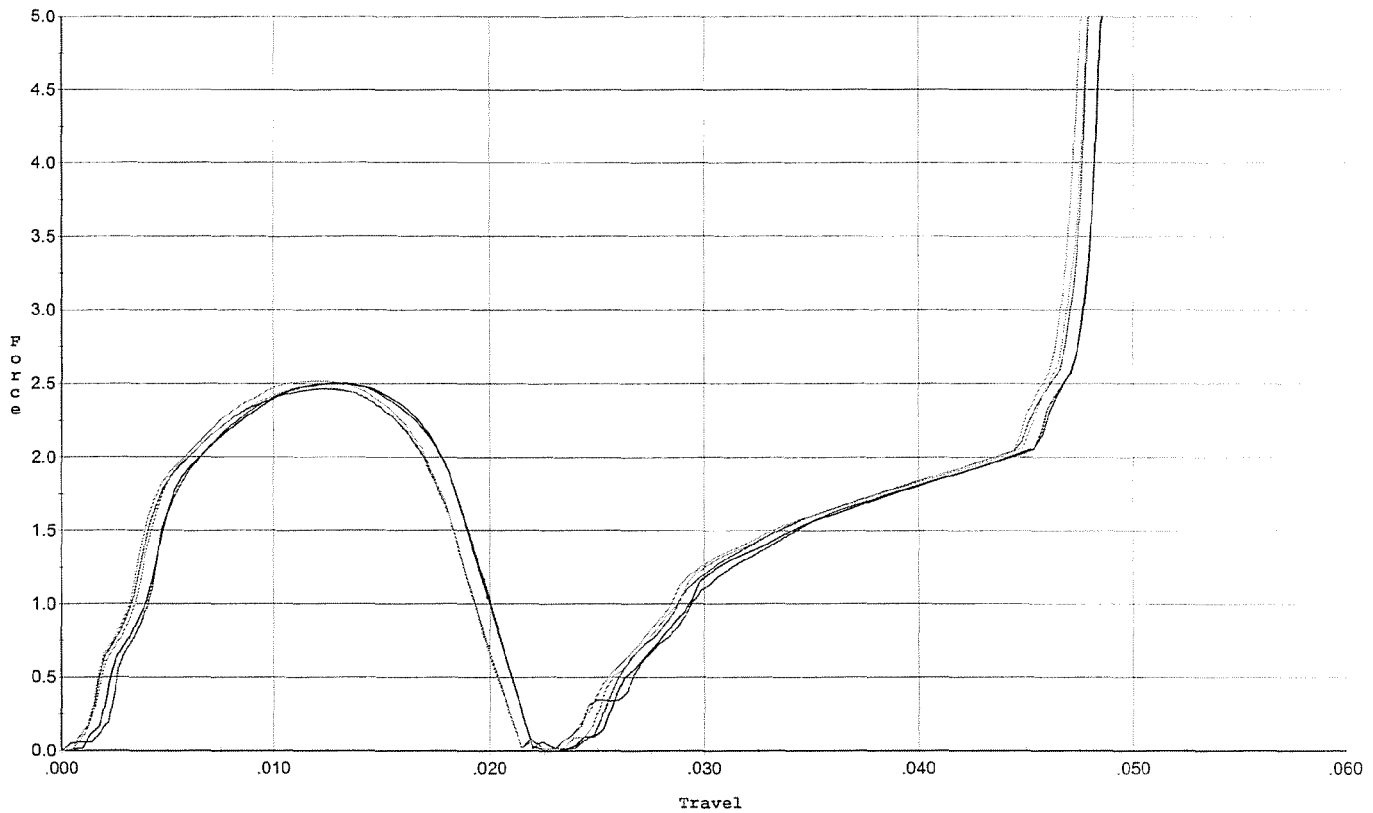
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.597	0.017	0.00	0.035	0.030		Set Trigger
2	2.621	0.017	0.00	0.034	0.030		Set Trigger
3	2.526	0.017	0.00	0.033	0.030		Set Trigger
4	2.482	0.018	0.00	0.035	0.030		Set Trigger
5	2.468	0.019	0.00	0.035	0.030		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



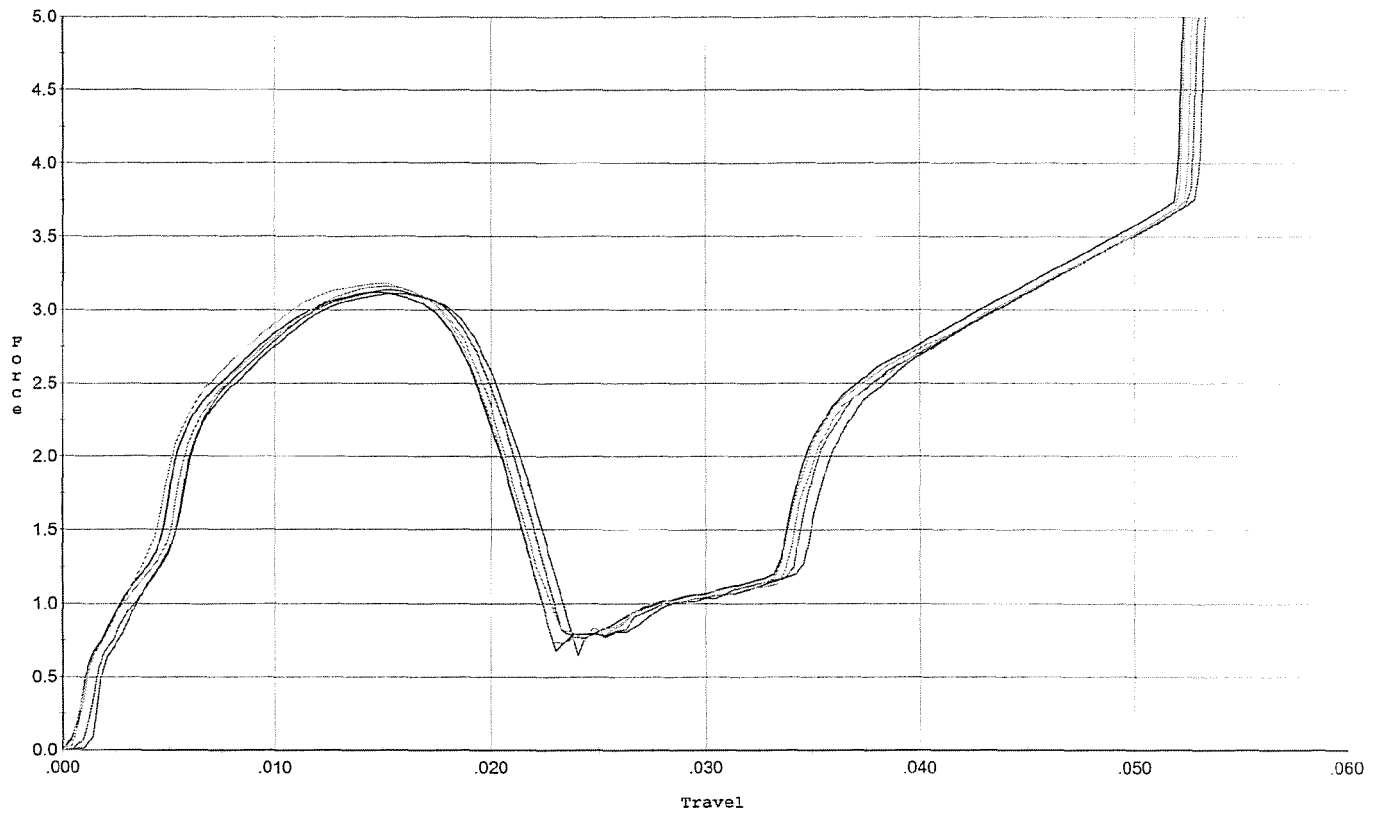
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.497	0.020	0.002	0.035	0.033		Set Trigger
2	2.504	0.020	0.00	0.035	0.034		Set Trigger
3	2.462	0.018	0.00	0.035	0.031		Set Trigger
4	2.518	0.018	0.00	0.035	0.032		Set Trigger
5	2.477	0.018	0.00	0.035	0.031		Set Trigger

Aug 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



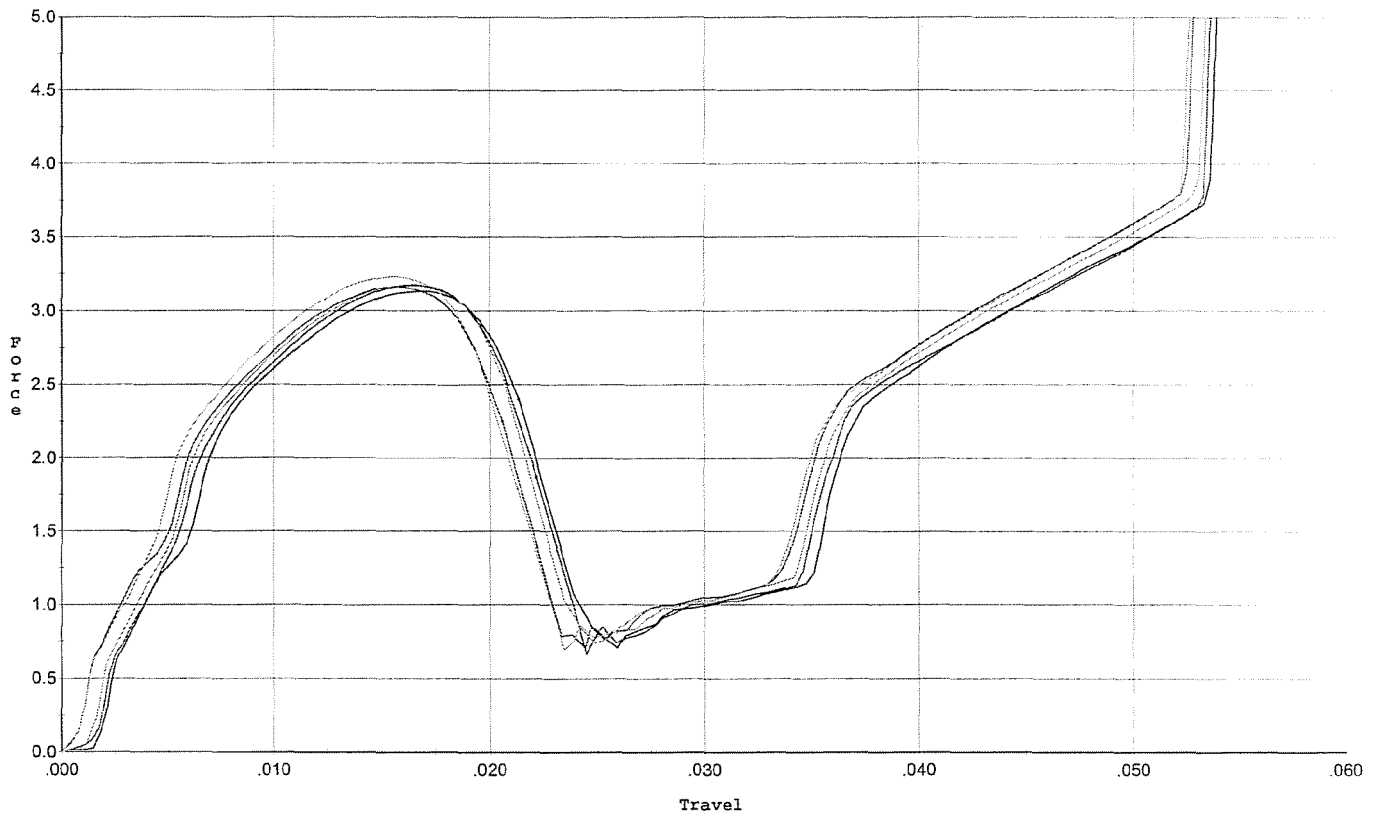
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.110	0.022	0.00	0.036	0.046		Set Trigger
2	3.120	0.020	0.00	0.035	0.044		Set Trigger
3	3.134	0.021	0.00	0.035	0.044		Set Trigger
4	3.180	0.020	0.00	0.035	0.045		Set Trigger
5	3.163	0.020	0.00	0.036	0.043		Set Trigger

Aug 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



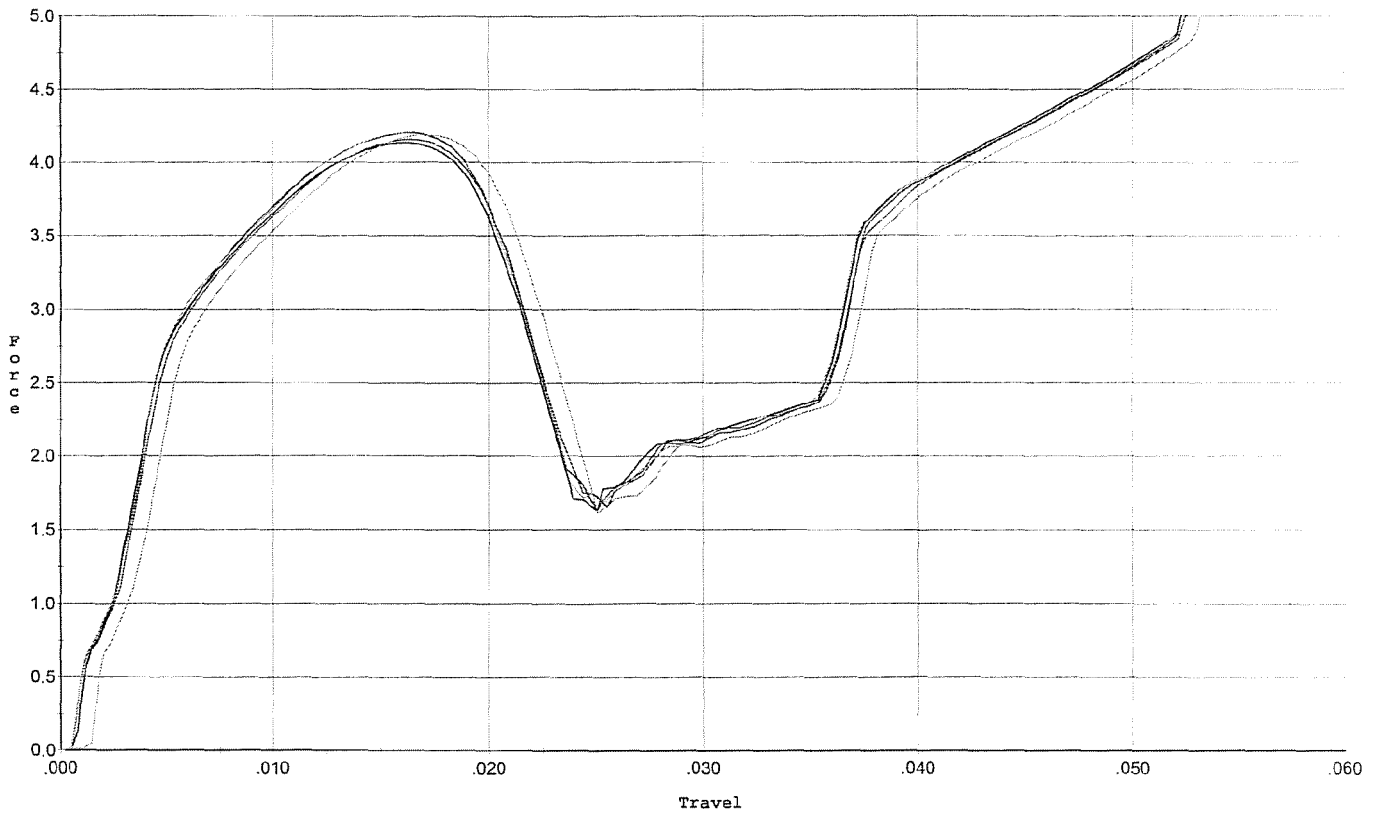
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.171	0.022	0.00	0.036	0.046		Set Trigger
2	3.132	0.021	0.00	0.036	0.044		Set Trigger
3	3.164	0.021	0.00	0.035	0.044		Set Trigger
4	3.231	0.021	0.00	0.035	0.047		Set Trigger
5	3.176	0.021	0.00	0.036	0.044		Set Trigger

Avg 3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



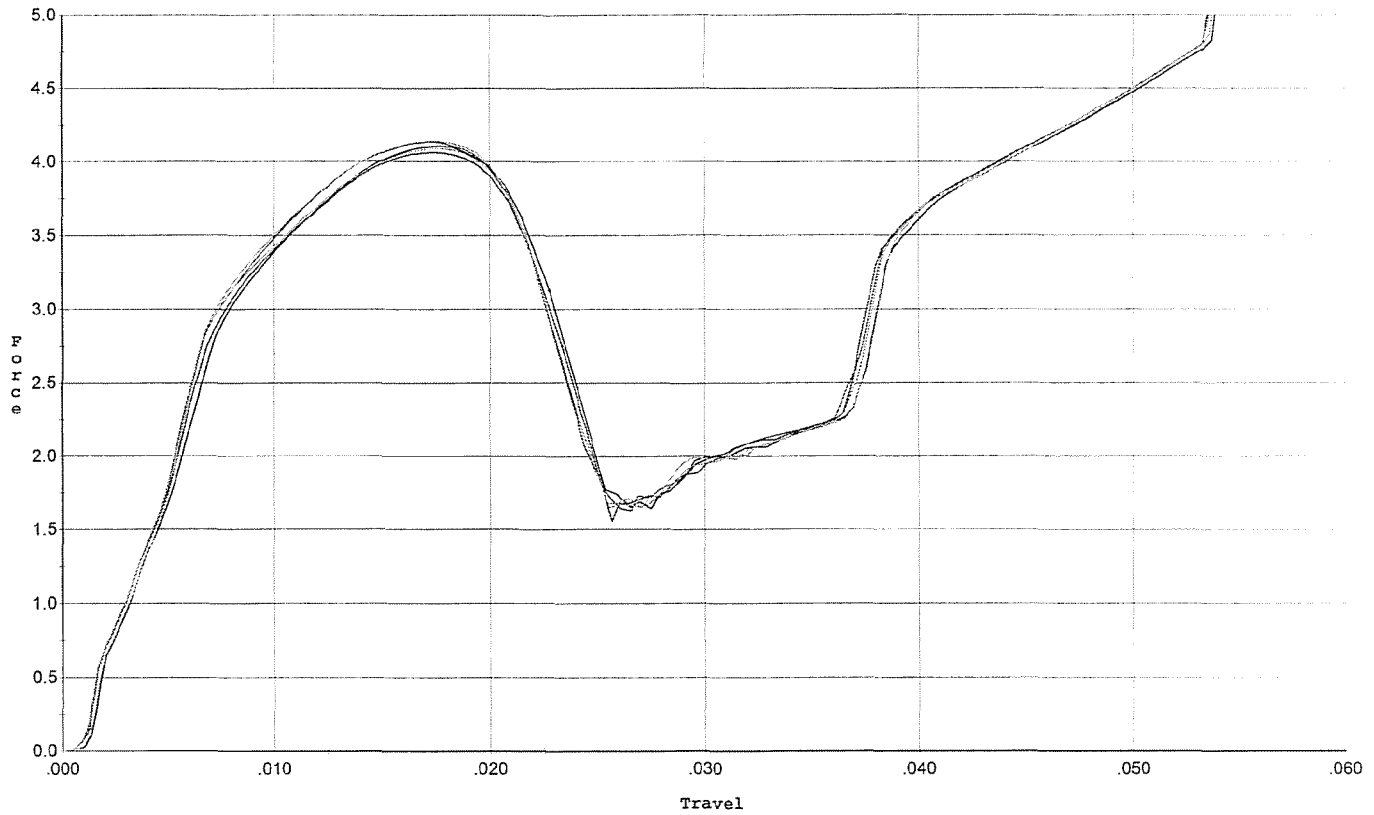
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.202	0.021	0.00	0.033	0.061		Set Trigger
2	4.136	0.021	0.00	0.033	0.061		Set Trigger
3	4.157	0.021	0.00	0.033	0.060		Set Trigger
4	4.203	0.021	0.00	0.033	0.061		Set Trigger
5	4.188	0.022	0.00	0.033	0.063		Set Trigger

AVG 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



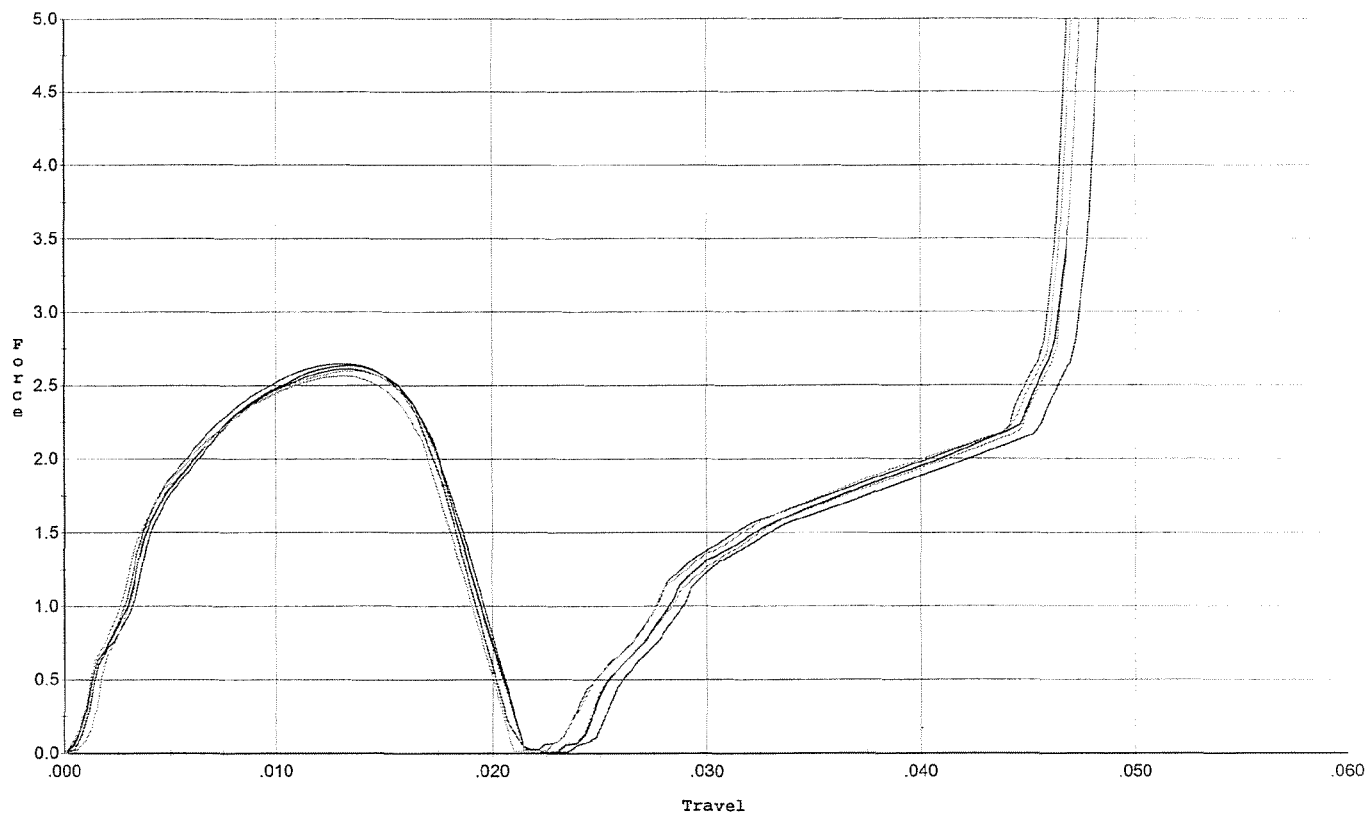
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.023	0.00	0.032	0.063		Set Trigger
2	4.107	0.023	0.00	0.033	0.062		Set Trigger
3	4.134	0.022	0.00	0.033	0.060		Set Trigger
4	4.138	0.022	0.00	0.033	0.060		Set Trigger
5	4.092	0.022	0.00	0.033	0.059		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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



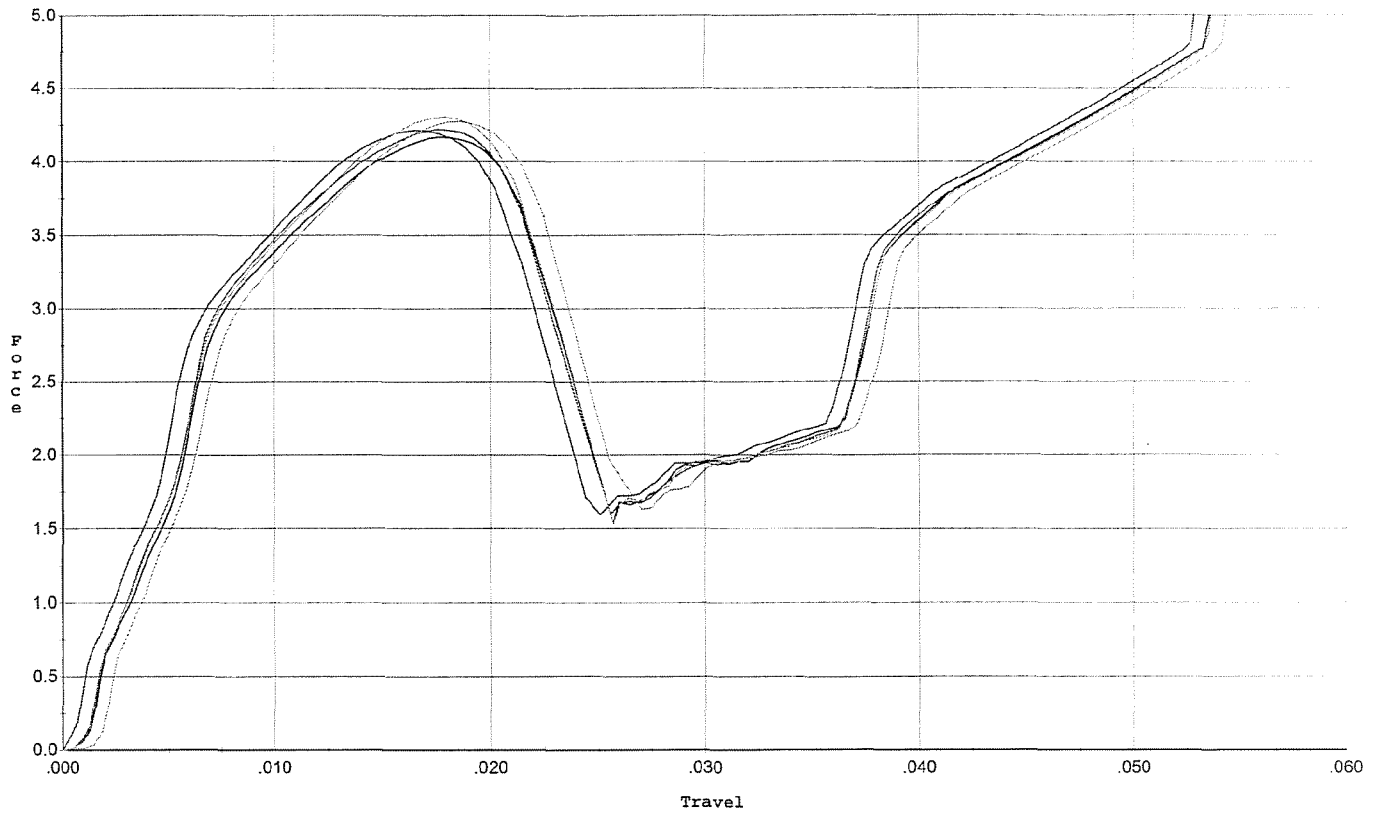
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.019	0.00	0.035	0.034		Set Trigger
2	2.635	0.017	0.00	0.034	0.032		Set Trigger
3	2.646	0.018	0.00	0.034	0.033		Set Trigger
4	2.561	0.019	0.00	0.034	0.034		Set Trigger
5	2.600	0.017	0.00	0.034	0.032		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 6/1/09

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	4.213	0.022	0.00	0.033	0.061		Set Trigger
2	4.166	0.023	0.00	0.032	0.063		Set Trigger
3	4.219	0.021	0.00	0.033	0.059		Set Trigger
4	4.305	0.023	0.00	0.033	0.064		Set Trigger
5	4.272	0.022	0.00	0.033	0.061		Set Trigger

Aug 4.23