

G685 8457

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



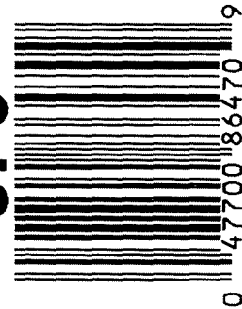
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6858457

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6858457

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		5-21-09	S.P.H.
430	ASSEMBLE TO STOCK		5-21-09	SP
440	PROOF		5-21-09	S.P.H.
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	R.P.D.
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(D)</u>	5/29/09	(D)
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	SP
540	APPLY COATINGS (BARREL ACTION)		6/1	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-1-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-1-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-1-09	SP
	D) OIL FIRING PIN ASSEMBLY		6-2-09	S.P.H.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

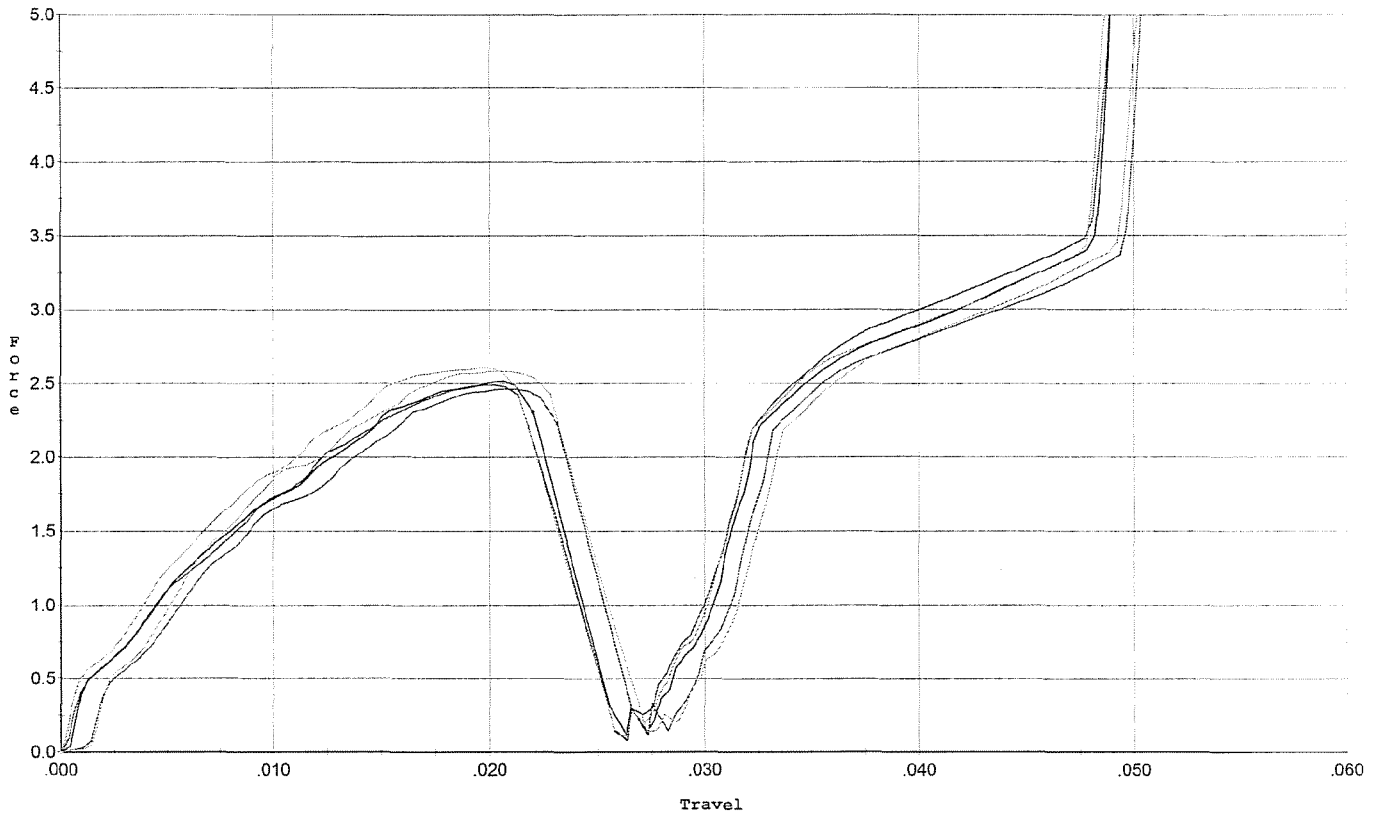
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	6-18-09	LJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	6-18-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	6-18-09	LJ
	J) ASSEMBLE STOCK		6-2-09	L.P.L.
	K) ASSEMBLE SWIVEL STUDS		6-18-09	LJ
	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	6/16/09	RB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6/16/09	TAR
670	FINAL INSPECTION A) HEADSPACE		6-18-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.84</u> <u>2.81</u> <u>2.87</u> <u>2.81</u>	6-18-09	LJ
	C) FUNCTION		6-18-09	LJ
690	PACK		7/24/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



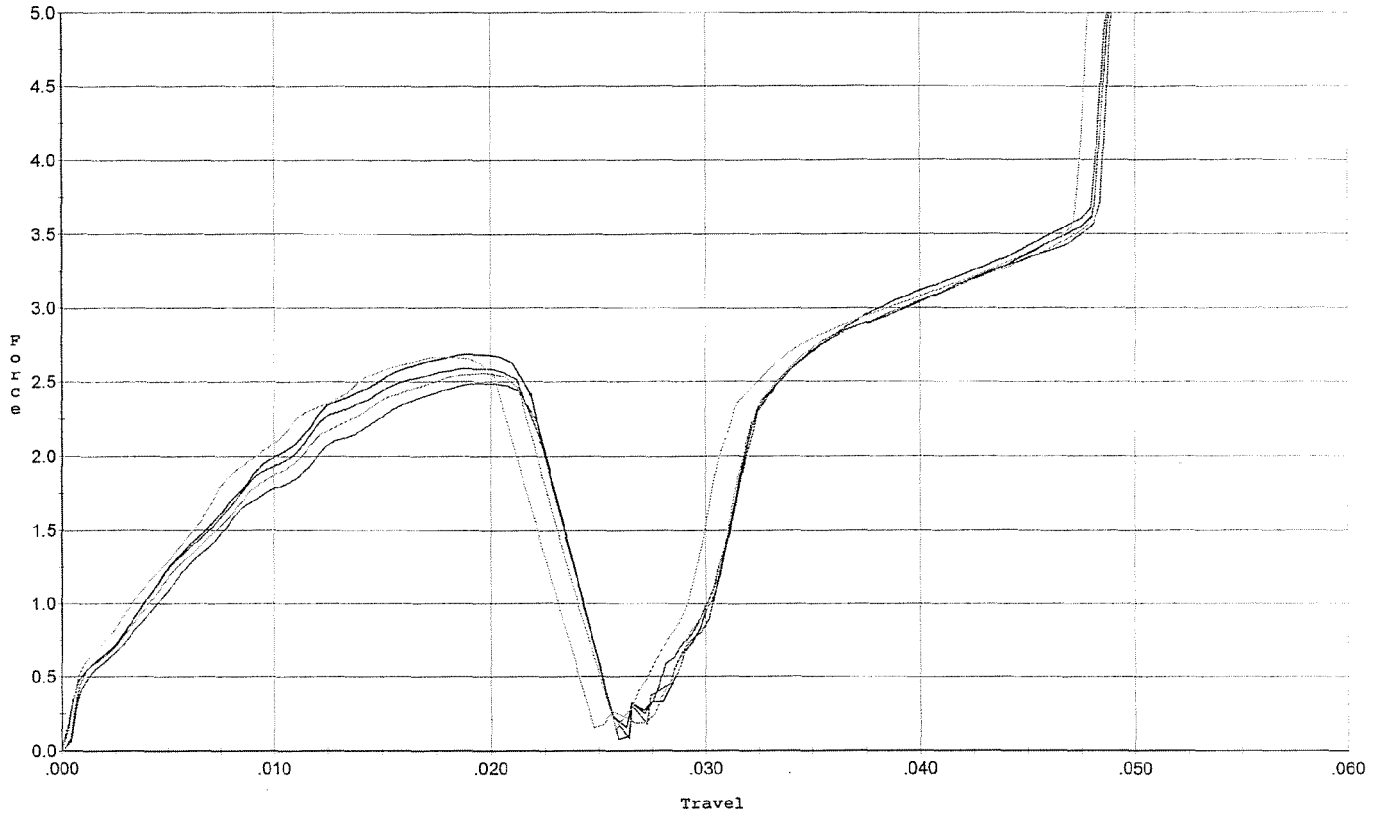
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.023	0.00	0.031	0.038		Set Trigger
2	2.518	0.022	0.00	0.031	0.036		Set Trigger
3	2.463	0.023	0.00	0.032	0.036		Set Trigger
4	2.582	0.023	0.00	0.032	0.038		Set Trigger
5	2.607	0.021	0.00	0.031	0.037		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 5/4/2009

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



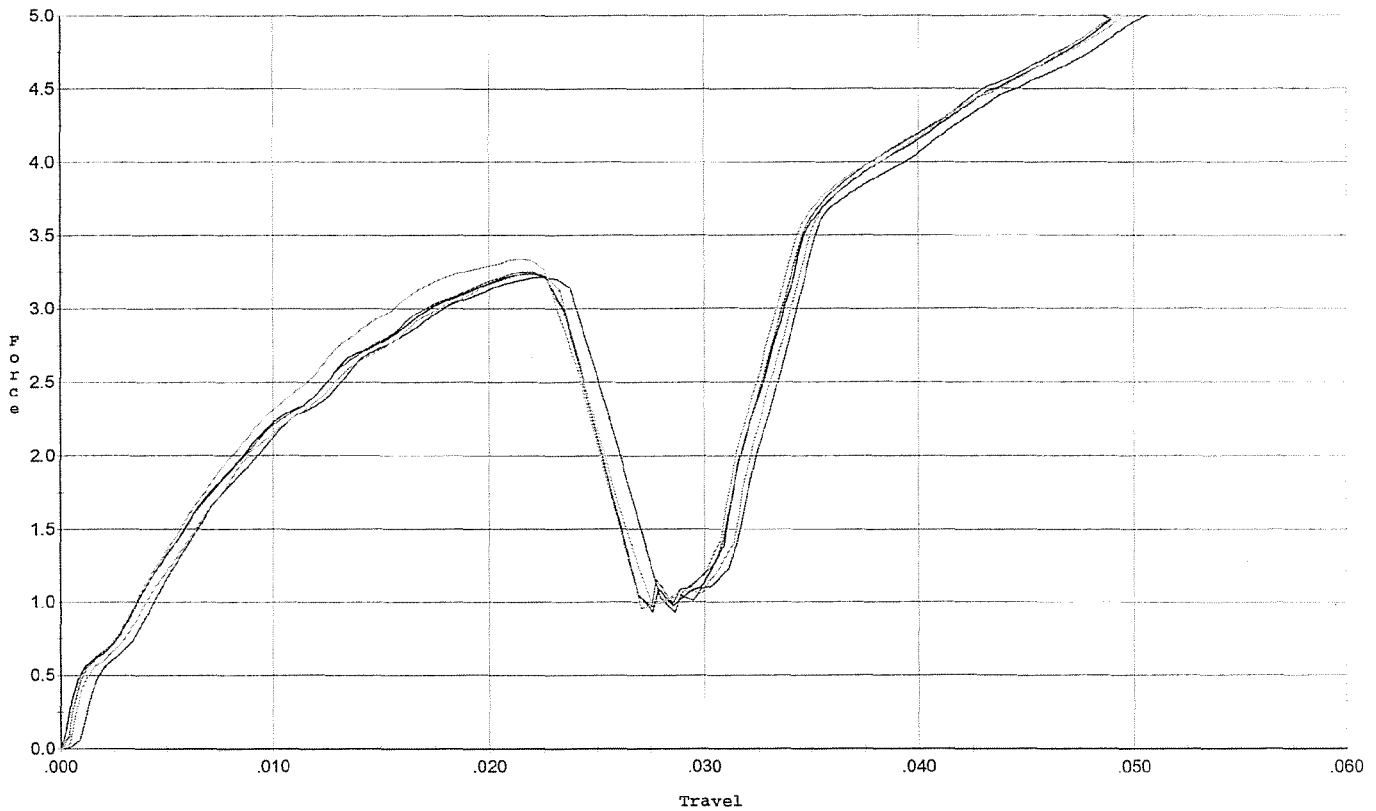
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.588	0.022	0.00	0.031	0.039		Set Trigger
2	2.685	0.022	0.00	0.031	0.039		Set Trigger
3	2.487	0.022	0.00	0.031	0.037		Set Trigger
4	2.668	0.020	0.00	0.031	0.037		Set Trigger
5	2.561	0.021	0.00	0.031	0.036		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



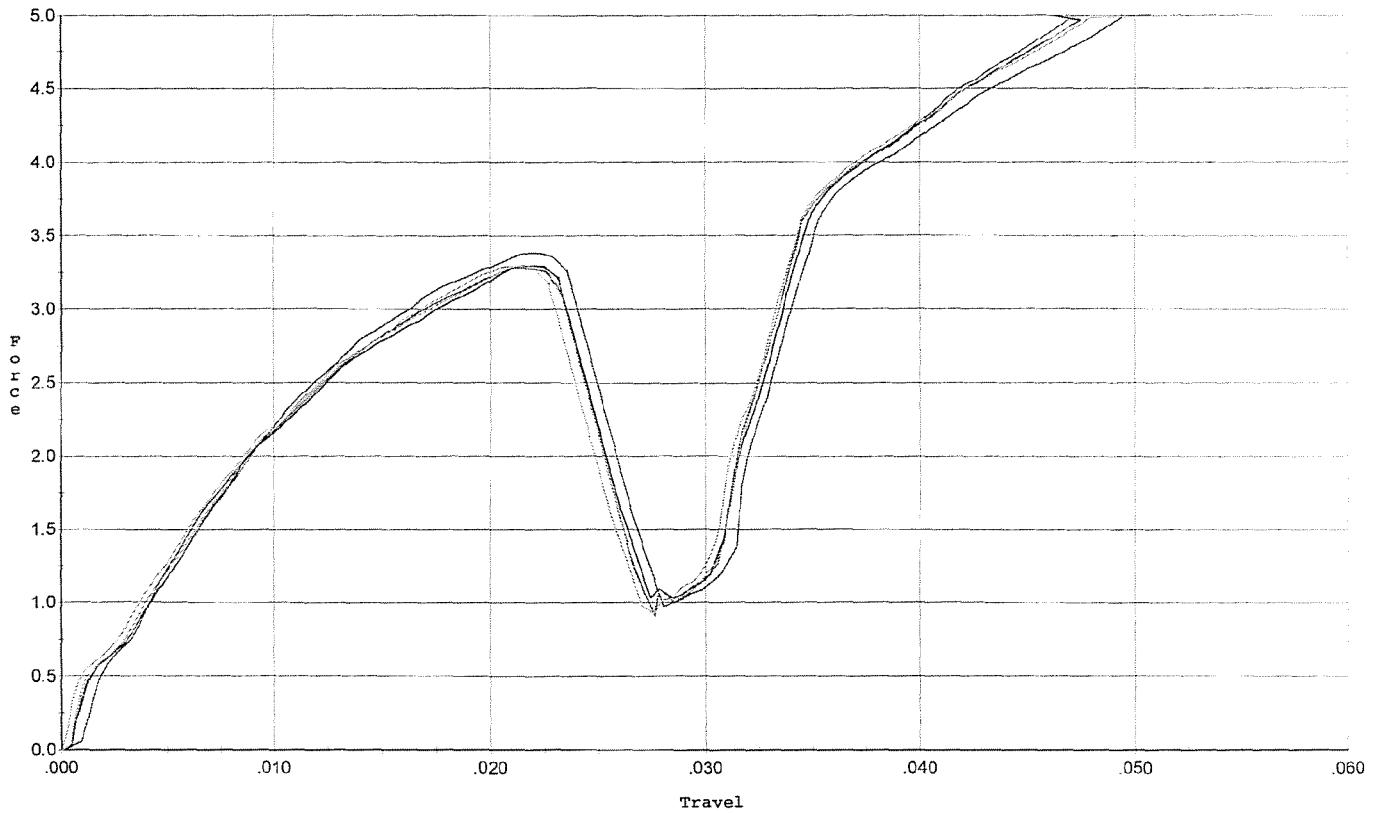
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.026	0.00	0.029	0.052		Set Trigger
2	3.234	0.023	0.00	0.030	0.049		Set Trigger
3	3.249	0.023	0.00	0.029	0.049		Set Trigger
4	3.242	0.023	0.00	0.030	0.048		Set Trigger
5	3.337	0.024	0.00	0.029	0.052		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



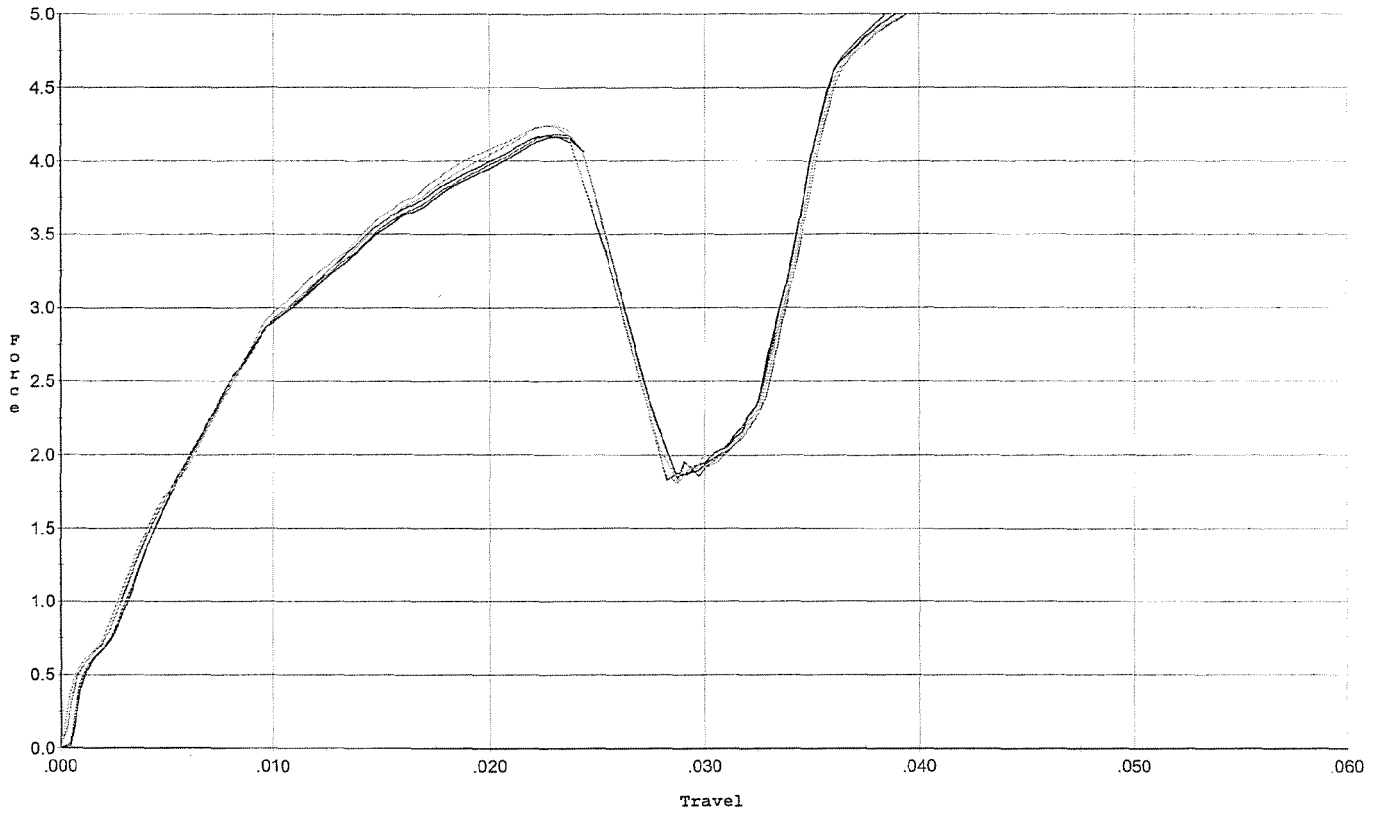
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.382	0.024	0.00	0.030	0.050		Set Trigger
2	3.295	0.023	0.00	0.029	0.048		Set Trigger
3	3.282	0.023	0.00	0.029	0.048		Set Trigger
4	3.291	0.023	0.00	0.030	0.048		Set Trigger
5	3.295	0.023	0.00	0.029	0.049		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



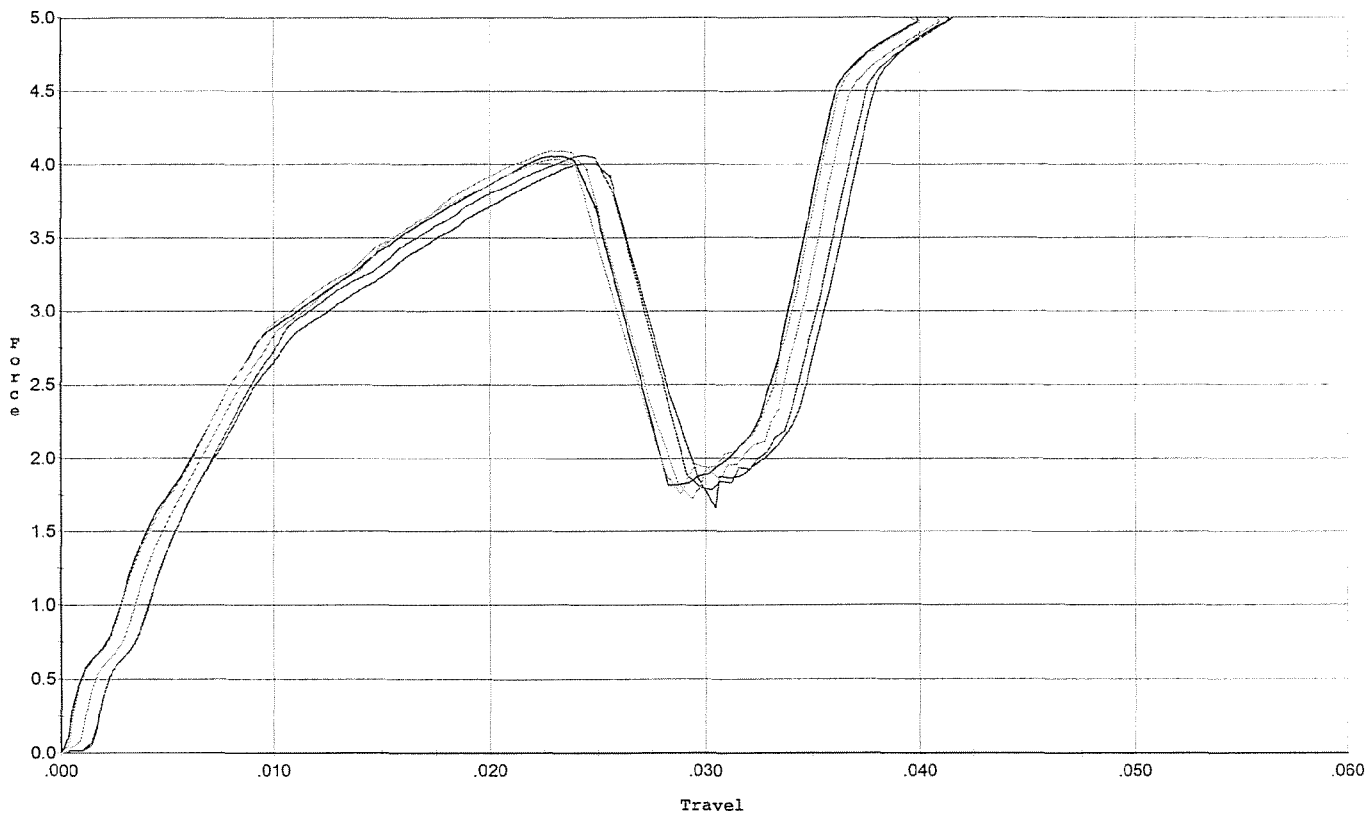
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.174	0.025	0.00	0.022	0.069		Set Trigger
2	4.168	0.024	0.00	0.023	0.065		Set Trigger
3	4.181	0.024	0.00	0.023	0.066		Set Trigger
4	4.243	0.024	0.00	0.023	0.066		Set Trigger
5	4.239	0.026	0.00	0.023	0.070		Set Trigger

A-4-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



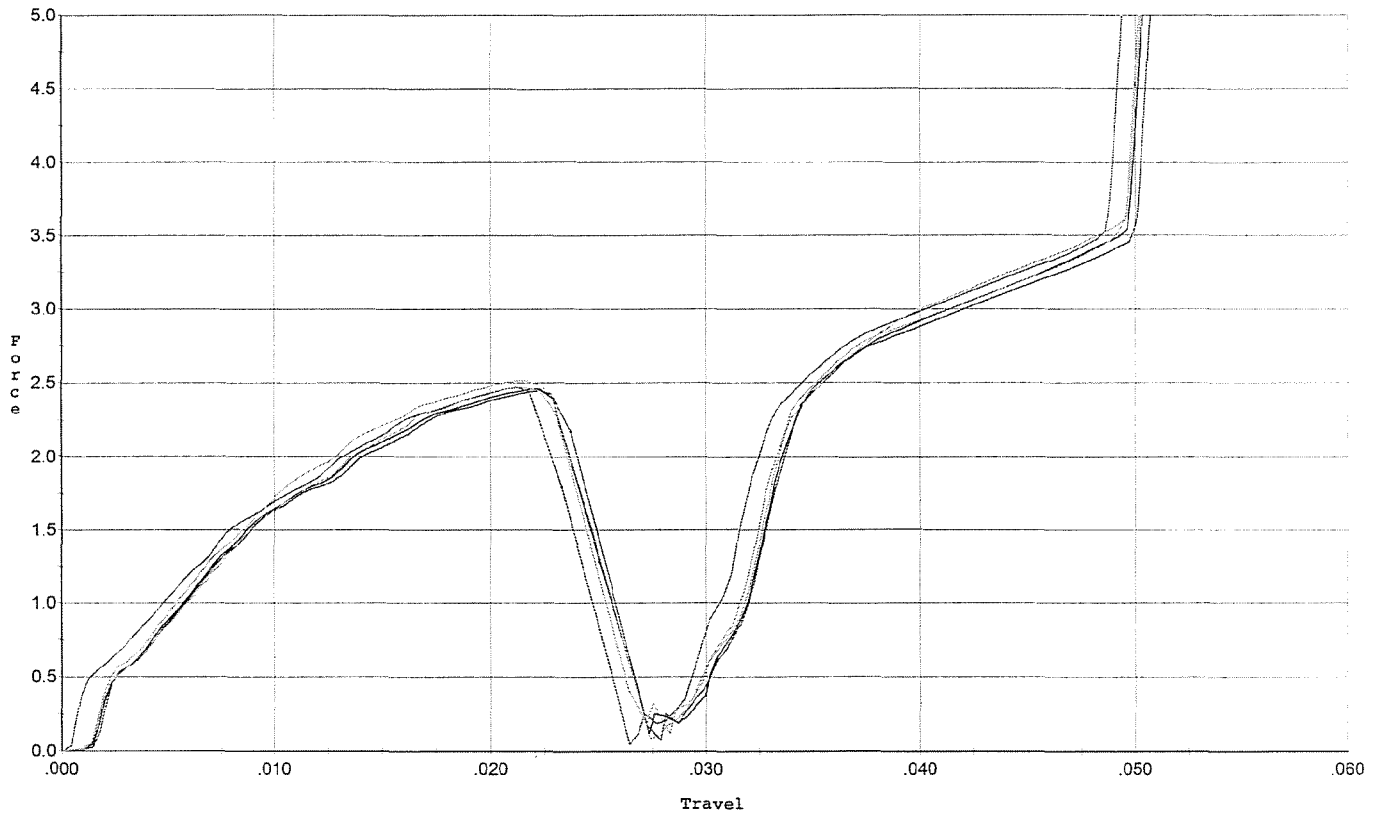
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.004	0.026	0.00	0.024	0.065		Set Trigger
2	4.056	0.025	0.00	0.023	0.066		Set Trigger
3	4.063	0.026	0.00	0.023	0.066		Set Trigger
4	4.042	0.024	0.00	0.024	0.063		Set Trigger
5	4.092	0.024	0.00	0.024	0.064		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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



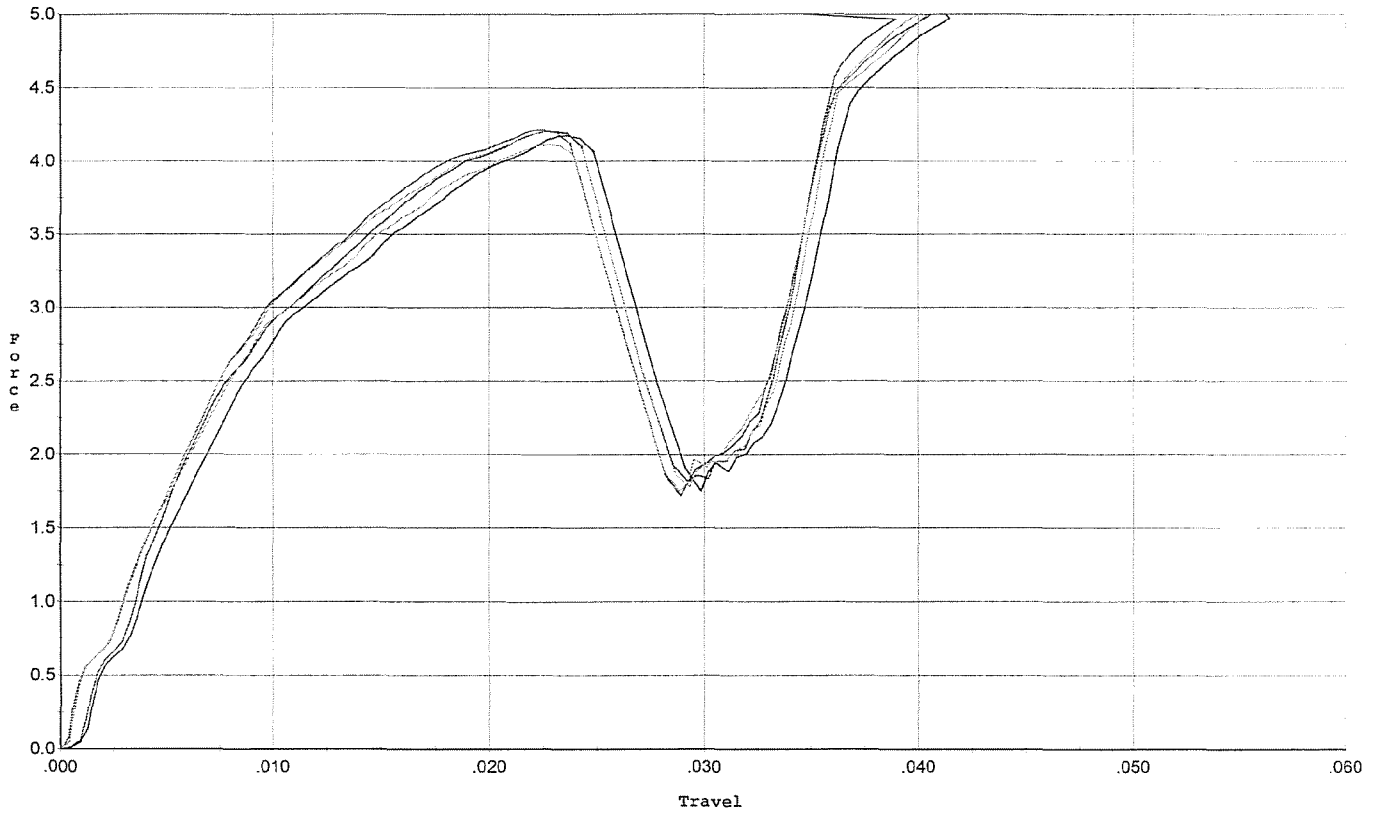
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.024	0.00	0.032	0.037		Set Trigger
2	2.455	0.025	0.00	0.032	0.039		Set Trigger
3	2.468	0.023	0.00	0.031	0.037		Set Trigger
4	2.472	0.023	0.00	0.032	0.036		Set Trigger
5	2.515	0.025	0.00	0.032	0.040		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 5/4/2009

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	4.203	0.024	0.00	0.023	0.066		Set Trigger
2	4.175	0.025	0.00	0.023	0.065		Set Trigger
3	4.213	0.024	0.00	0.024	0.065		Set Trigger
4	4.209	0.024	0.00	0.023	0.067		Set Trigger
5	4.113	0.024	0.00	0.023	0.064		Set Trigger

A-4-18