

G6801465

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



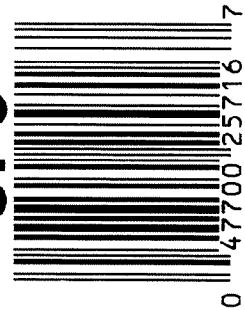
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801465

UPC



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801465

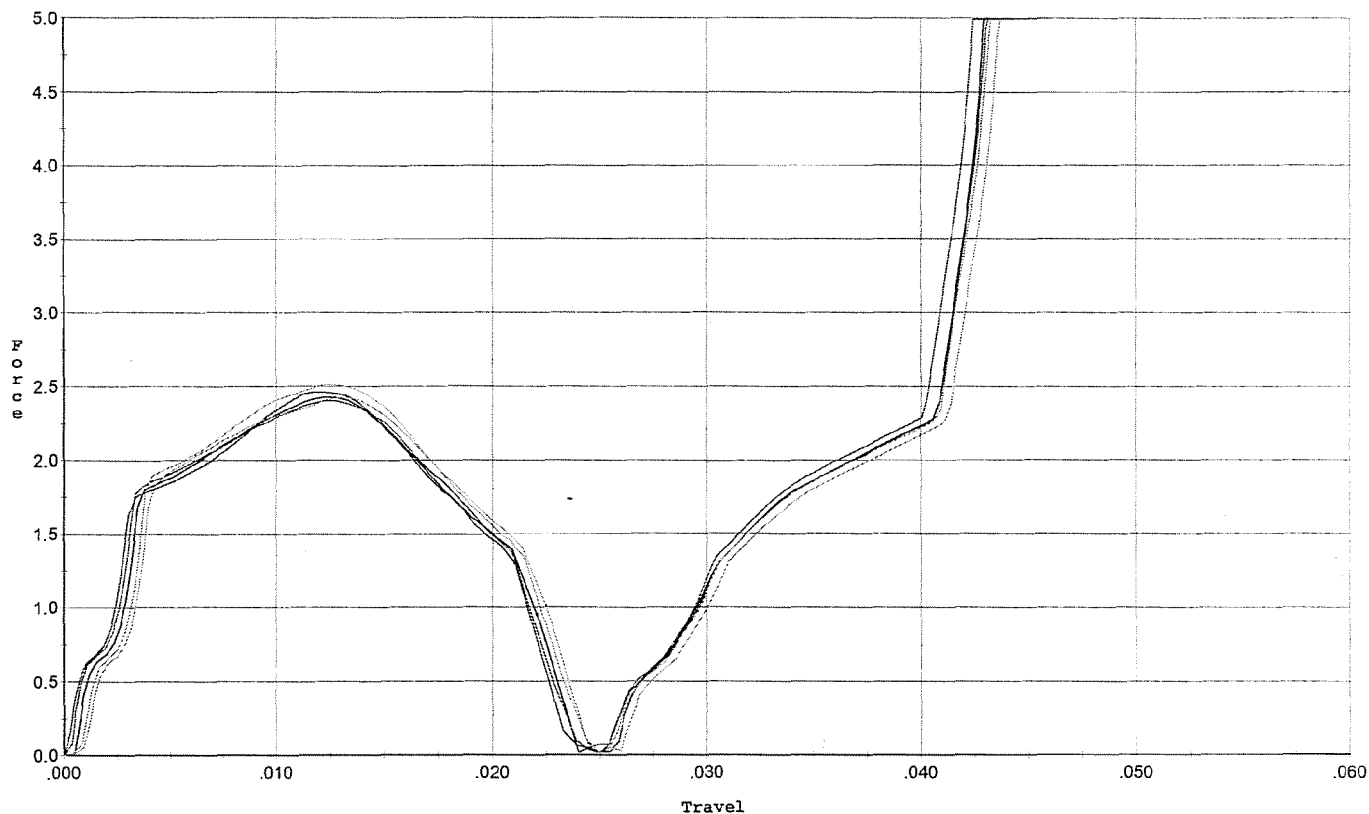
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RL
480	MAGNAFLUX BBL ACTION	EJECTOR	3/9/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		5-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP # OPERATION NAME		READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	3-31-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-31-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-31-09	NW
	J) ASSEMBLE STOCK		3-27-09	RPD
	K) ASSEMBLE SWIVEL STUDS		4-1-09	NW
	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	3-30-09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.55</u> <u>2.79</u> <u>2.58</u> <u>2.56</u>	3-31-09	NW
	C) FUNCTION		3-31-09	NW
690	PACK		5/24/09	FM

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



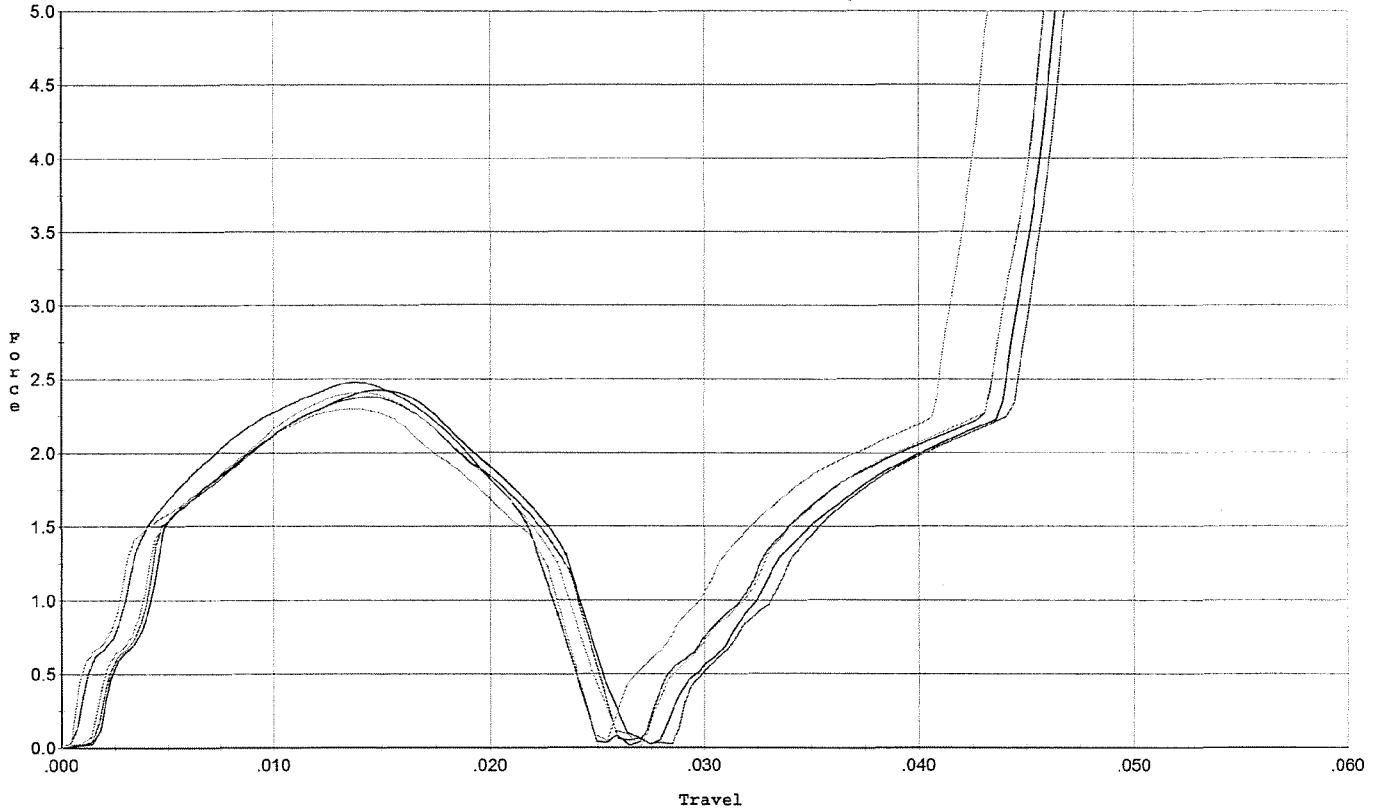
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.021	0.00	0.029	0.037		Set Trigger
2	2.428	0.022	0.00	0.028	0.038		Set Trigger
3	2.404	0.021	0.00	0.028	0.037		Set Trigger
4	2.512	0.021	0.00	0.029	0.038		Set Trigger
5	2.427	0.022	0.00	0.028	0.038		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



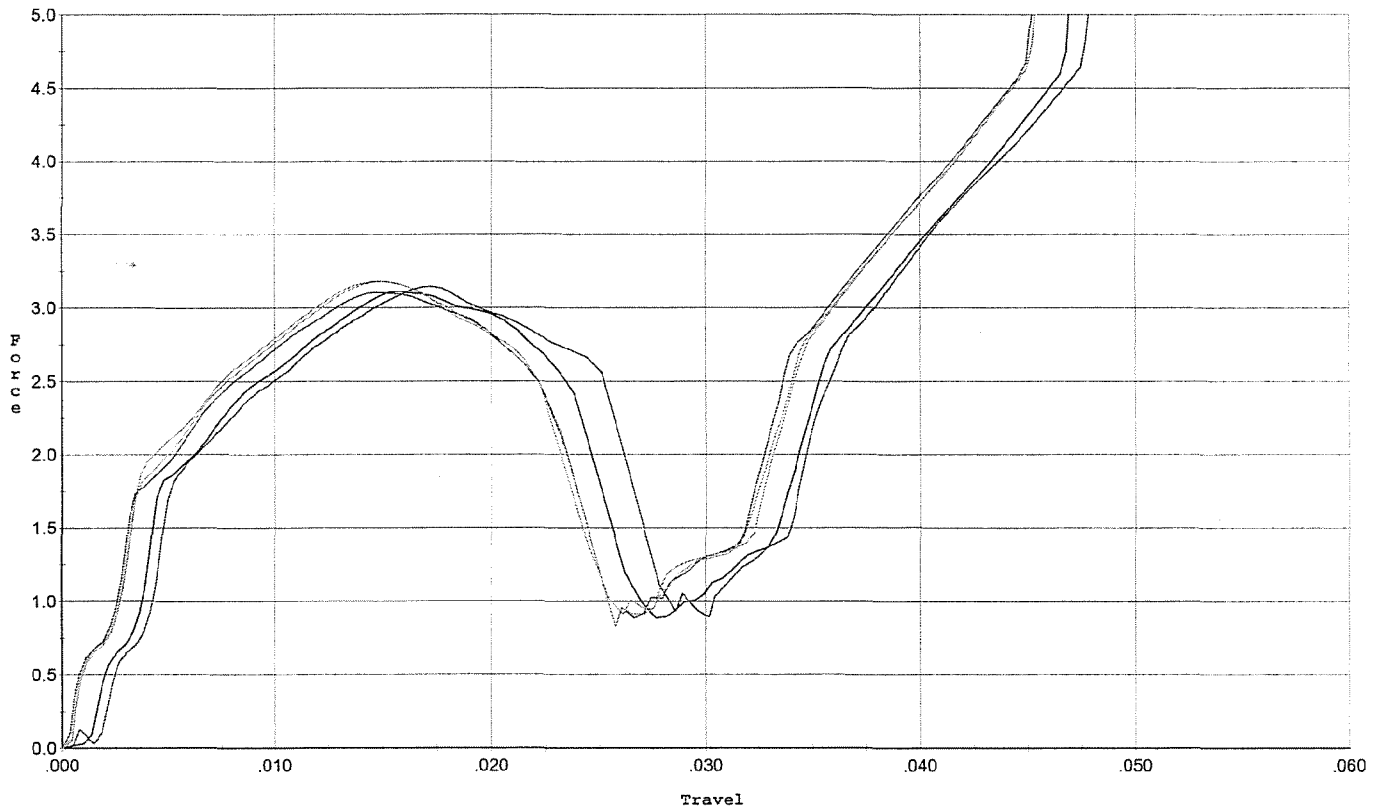
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.023	0.00	0.030	0.040		Set Trigger
2	2.425	0.024	0.00	0.030	0.039		Set Trigger
3	2.379	0.024	0.00	0.030	0.038		Set Trigger
4	2.410	0.023	0.00	0.030	0.038		Set Trigger
5	2.299	0.023	0.00	0.028	0.037		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



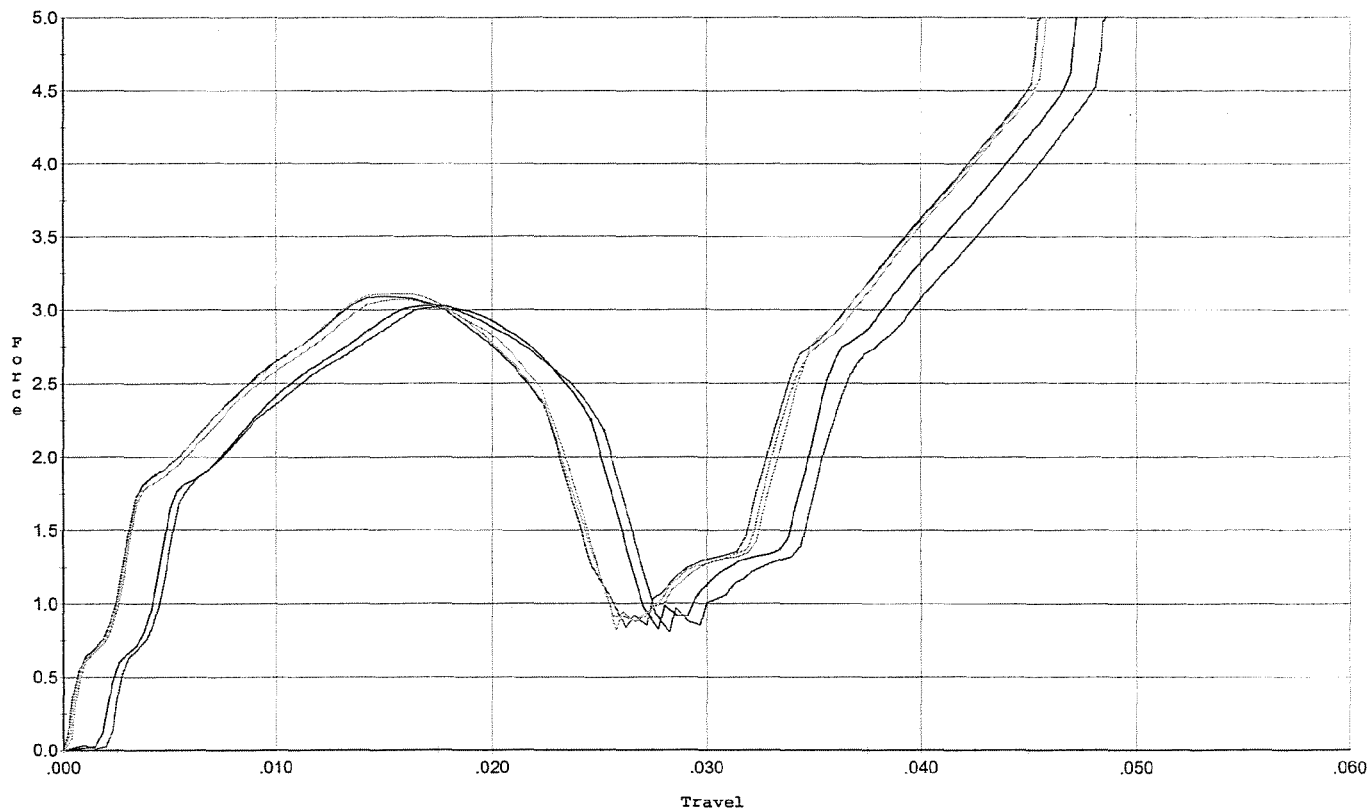
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.147	0.025	0.00	0.024	0.054		Set Trigger
2	3.111	0.024	0.00	0.028	0.052		Set Trigger
3	3.104	0.023	0.00	0.027	0.052		Set Trigger
4	3.180	0.023	0.00	0.028	0.053		Set Trigger
5	3.182	0.022	0.00	0.028	0.051		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



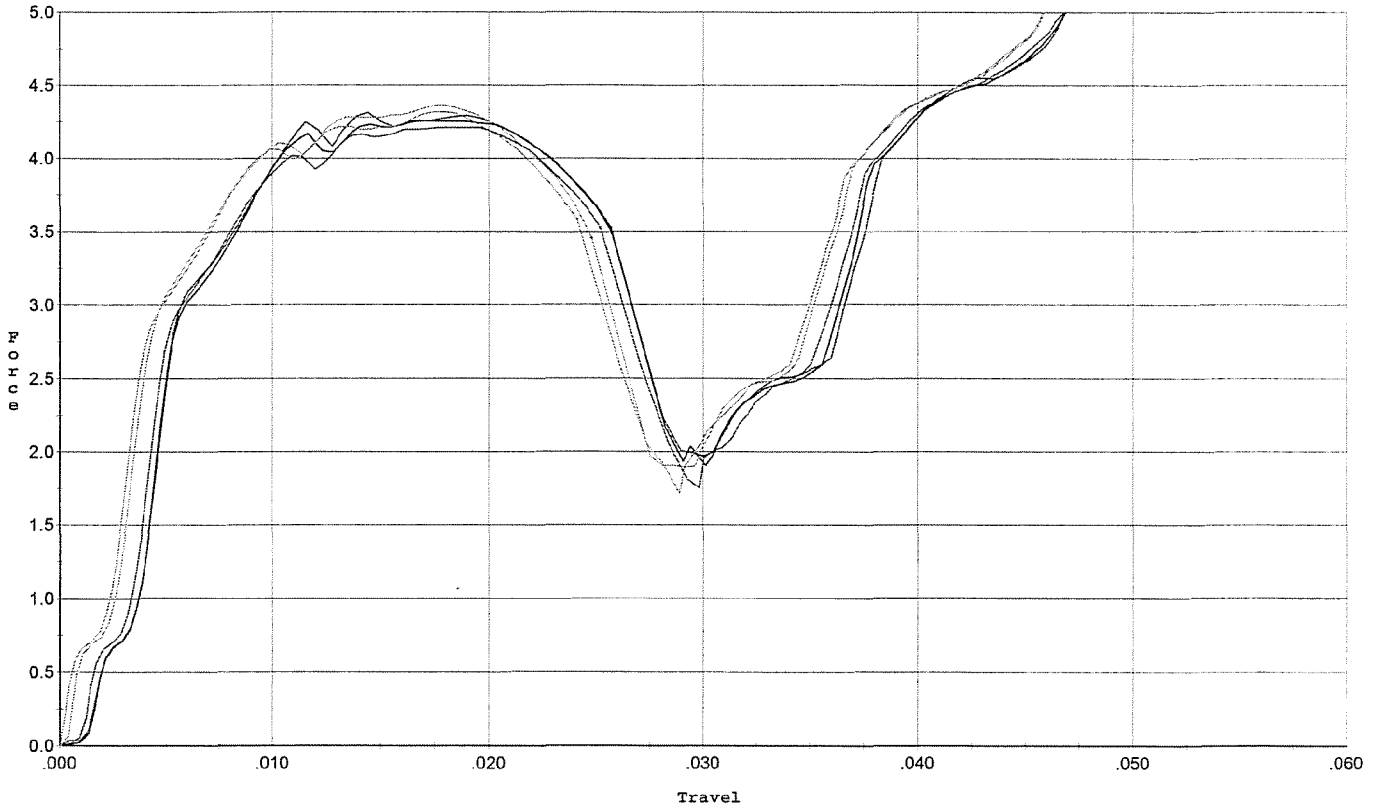
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.016	0.025	0.00	0.029	0.051		Set Trigger
2	3.025	0.025	0.00	0.028	0.051		Set Trigger
3	3.091	0.022	0.00	0.028	0.050		Set Trigger
4	3.109	0.022	0.00	0.028	0.050		Set Trigger
5	3.071	0.024	0.00	0.028	0.052		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



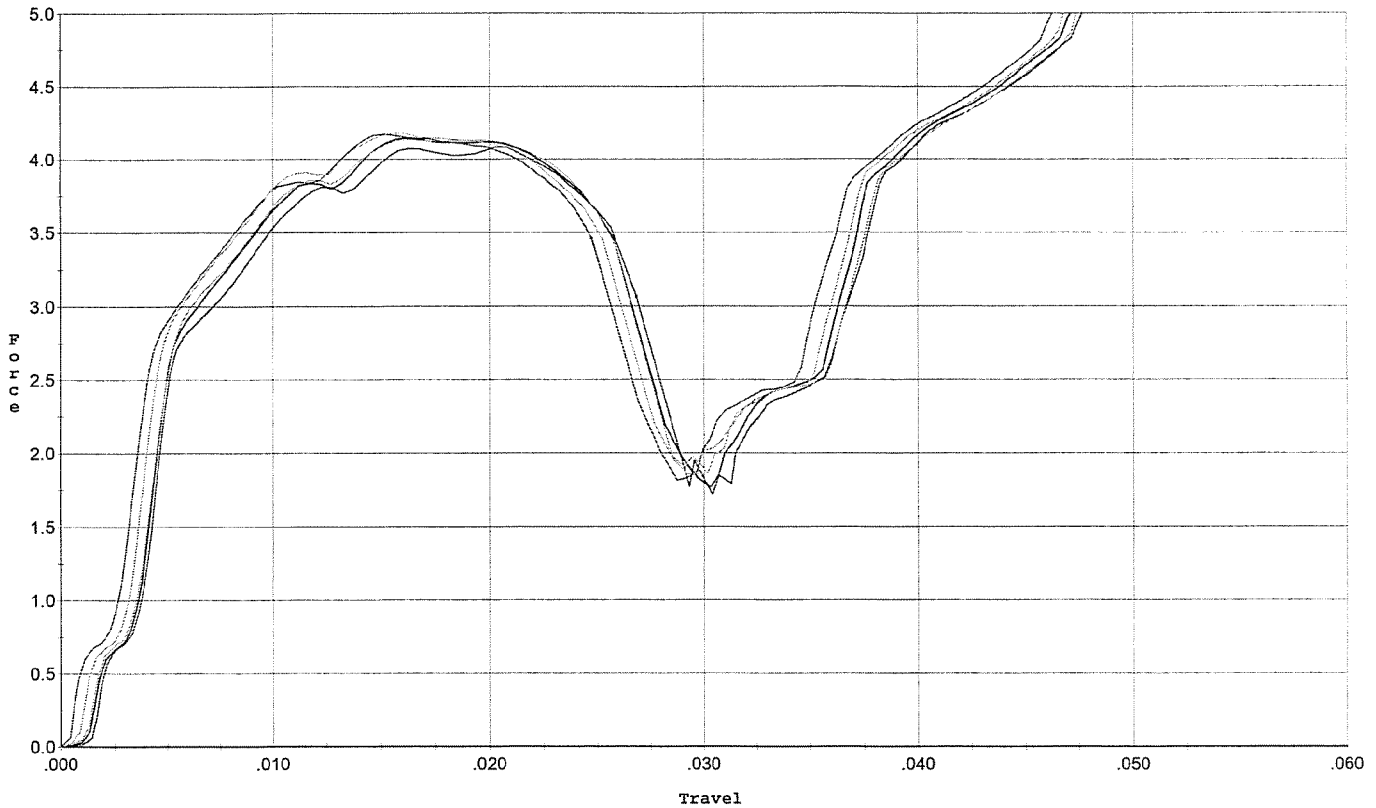
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.313	0.026	0.00	0.019	0.079		Set Trigger
2	4.258	0.026	0.00	0.020	0.079		Set Trigger
3	4.211	0.025	0.00	0.020	0.077		Set Trigger
4	4.365	0.025	0.00	0.019	0.079		Set Trigger
5	4.317	0.024	0.00	0.020	0.077		Set Trigger

A 4.29

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



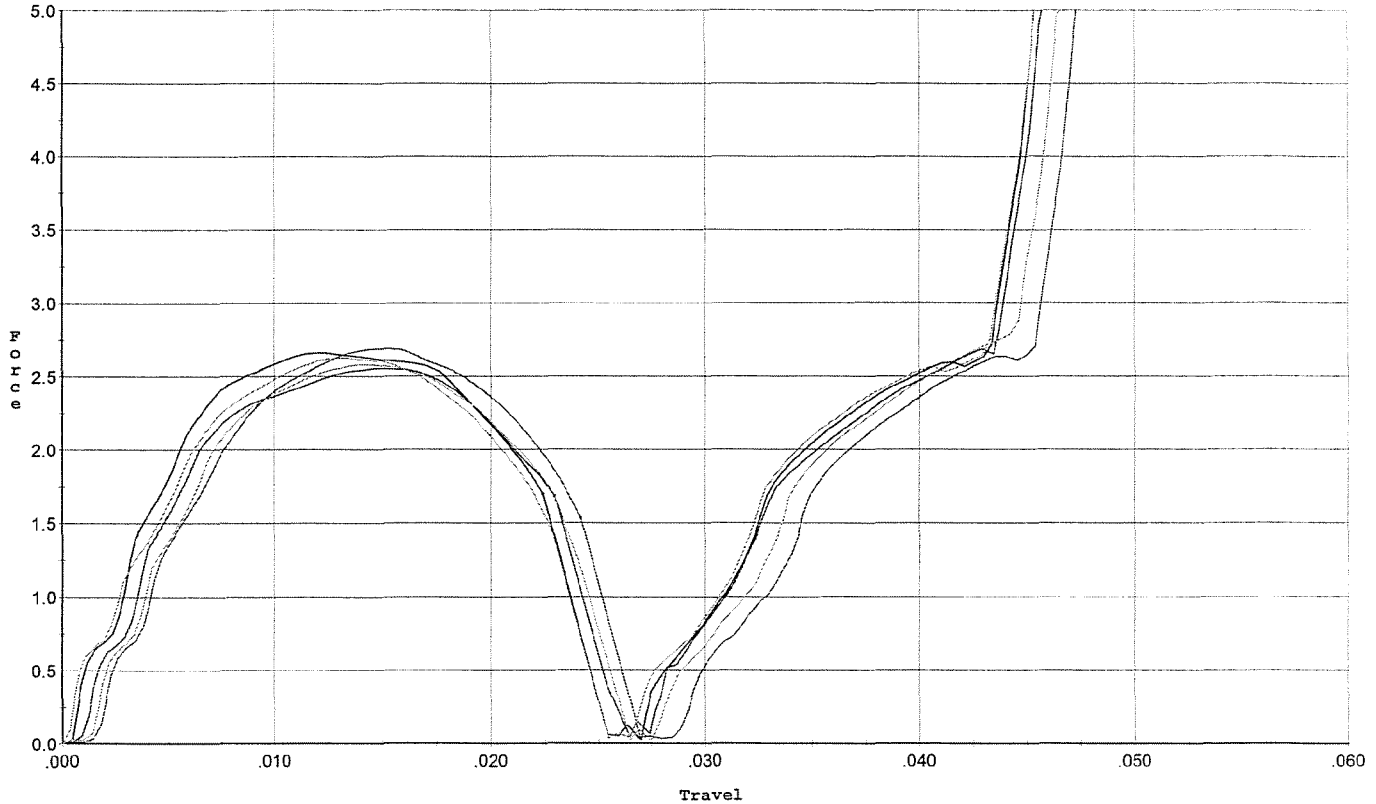
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.082	0.027	0.00	0.020	0.078		Set Trigger
2	4.146	0.026	0.00	0.020	0.076		Set Trigger
3	4.174	0.025	0.00	0.020	0.076		Set Trigger
4	4.182	0.025	0.00	0.020	0.077		Set Trigger
5	4.138	0.026	0.00	0.020	0.077		Set Trigger

A. 4.14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



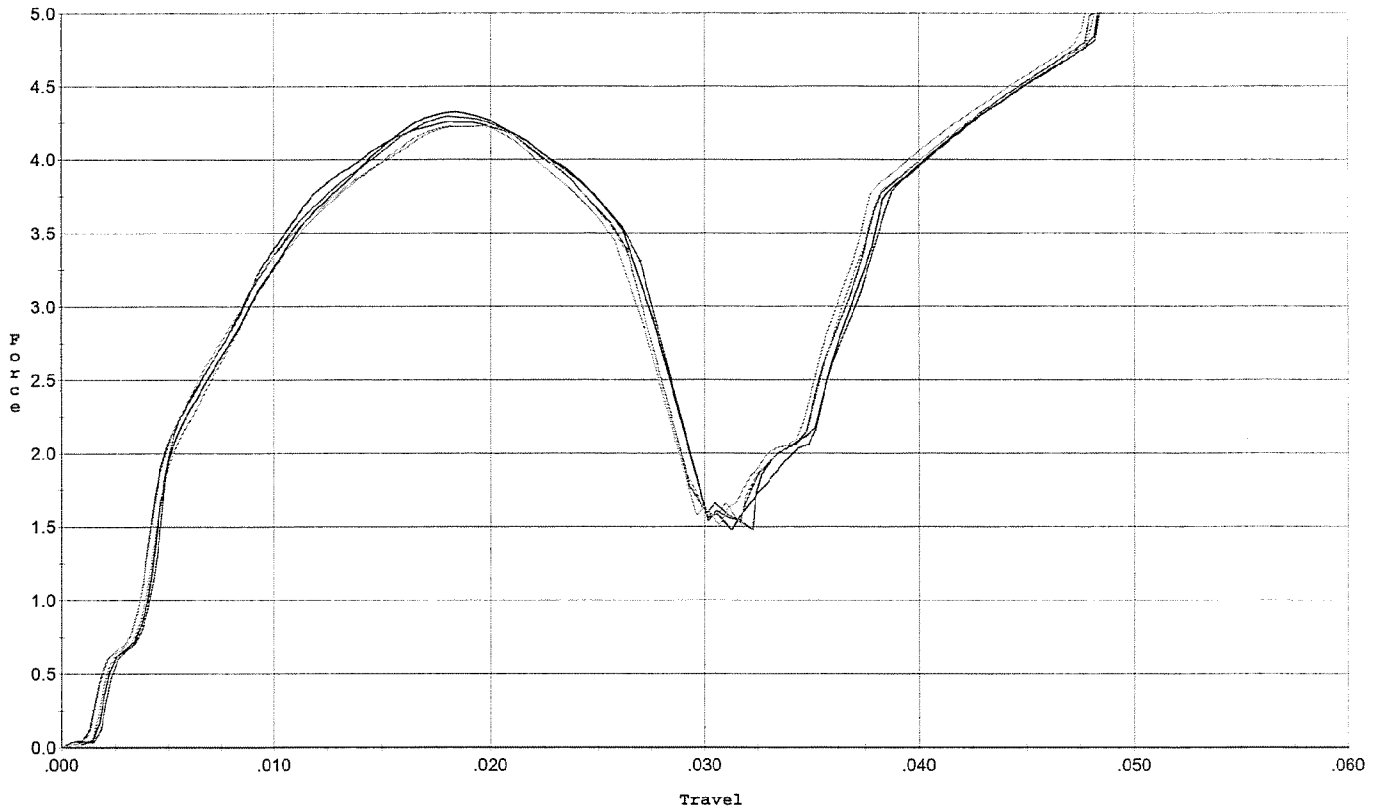
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.023	0.00	0.029	0.042		Set Trigger
2	2.661	0.022	0.00	0.029	0.044		Set Trigger
3	2.689	0.024	0.00	0.030	0.044		Set Trigger
4	2.581	0.024	0.00	0.030	0.043		Set Trigger
5	2.627	0.023	0.00	0.029	0.043		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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	4.256	0.027	0.00	0.020	0.078		Set Trigger
2	4.325	0.028	0.00	0.020	0.079		Set Trigger
3	4.294	0.026	0.00	0.020	0.077		Set Trigger
4	4.226	0.027	0.00	0.020	0.078		Set Trigger
5	4.230	0.026	0.00	0.020	0.075		Set Trigger

A 4.26