

G6801368

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



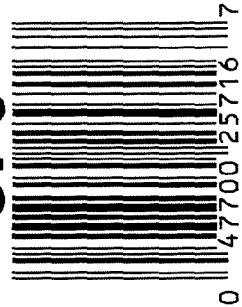
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801368

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801368

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RTL
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION	(D)	3-27-09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

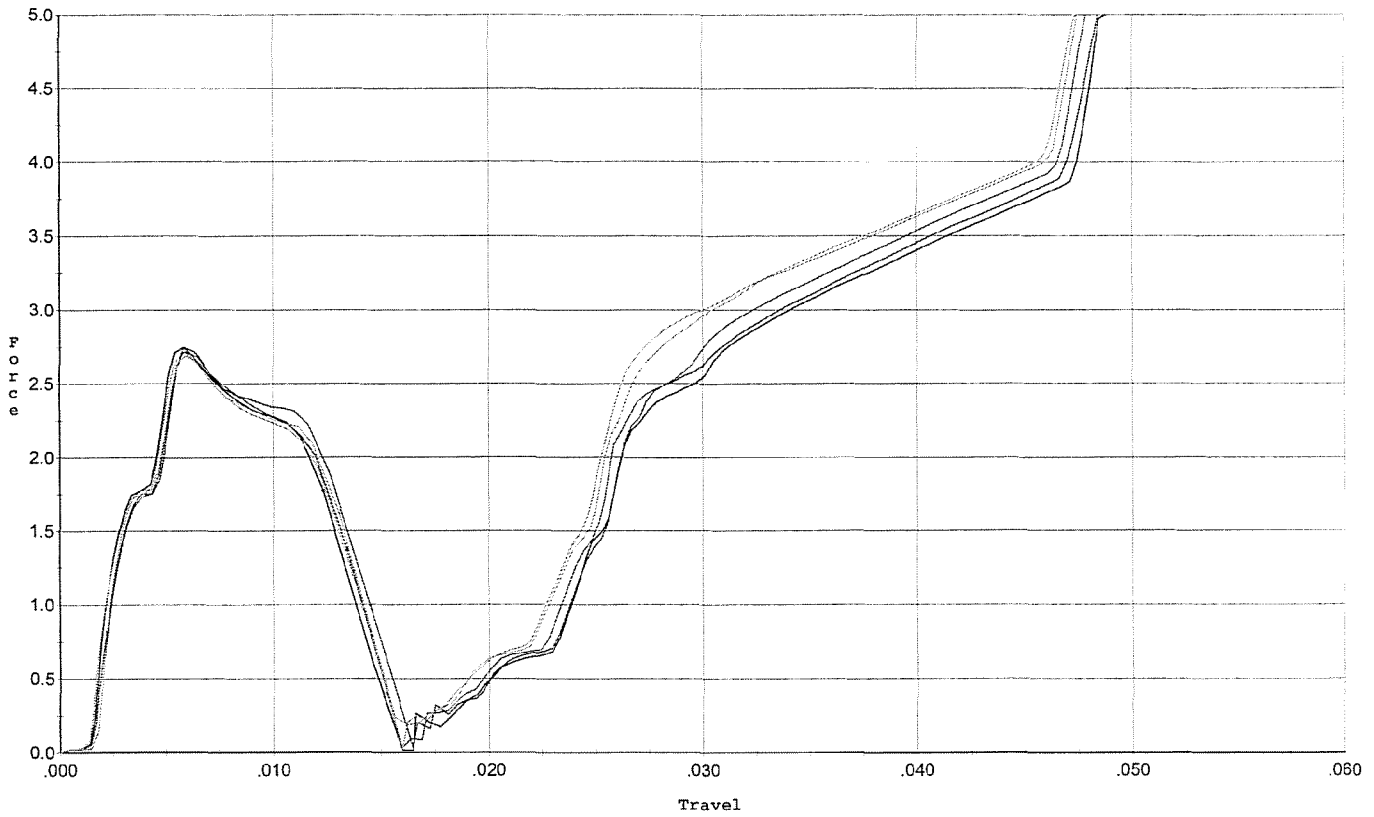
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-29-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-29-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	4-29-09	WV
	J) ASSEMBLE STOCK		4-23-09	L.D.
	K) ASSEMBLE SWIVEL STUDS		4-29-09	WV
	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	4-24-09	RP
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		4-29-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.83</u> <u>2.83</u> <u>2.79</u> <u>2.79</u>	4-28-09	WV
	C) FUNCTION		4-29-09	WV
690	PACK		5/2/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



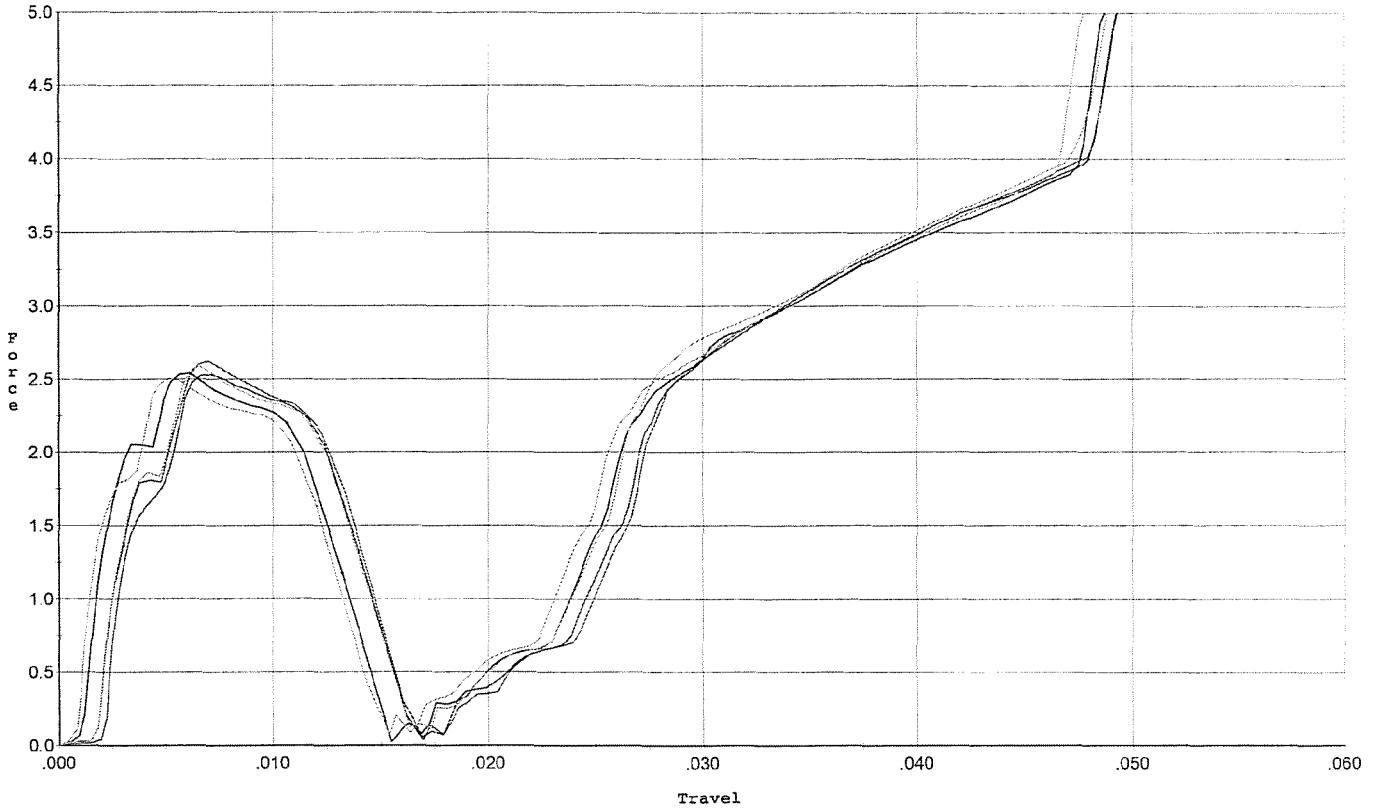
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.747	0.014	0.00	0.038	0.024		Set Trigger
2	2.748	0.012	0.00	0.038	0.021		Set Trigger
3	2.720	0.013	0.002	0.037	0.022		Set Trigger
4	2.685	0.013	0.00	0.037	0.022		Set Trigger
5	2.710	0.014	0.00	0.037	0.023		Set Trigger

A-2.72

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



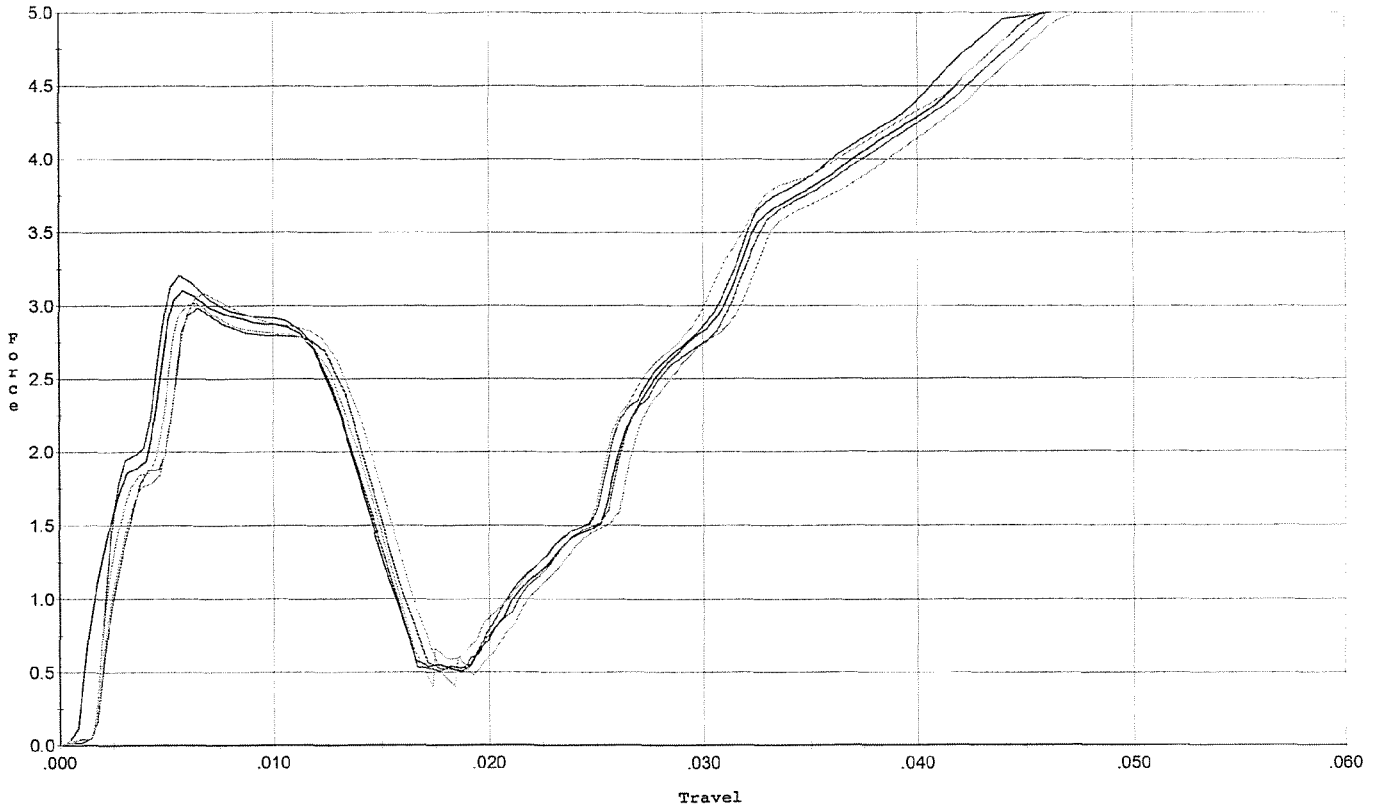
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.014	0.002	0.038	0.022		Set Trigger
2	2.540	0.013	0.00	0.039	0.023		Set Trigger
3	2.626	0.013	0.002	0.038	0.022		Set Trigger
4	2.591	0.014	0.00	0.038	0.023		Set Trigger
5	2.509	0.012	0.00	0.038	0.021		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



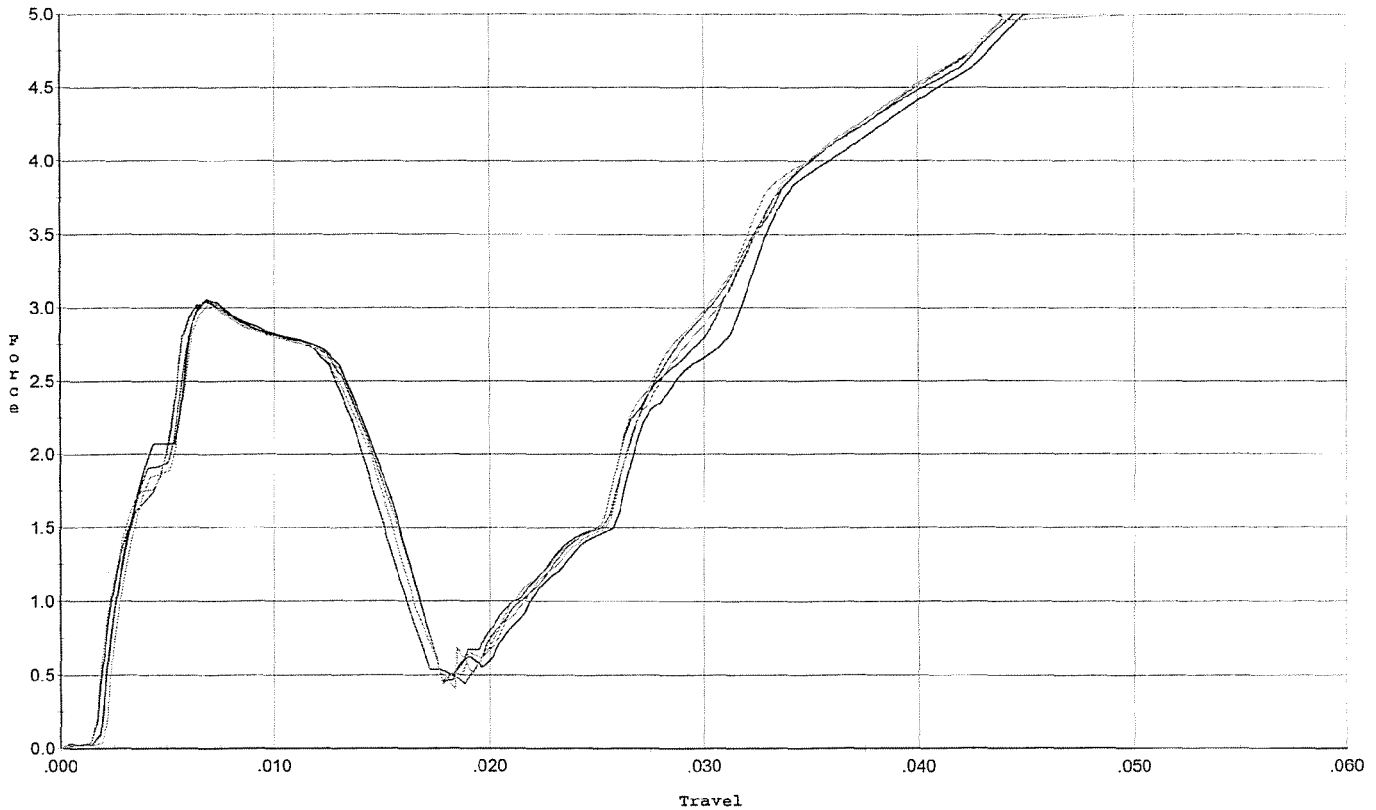
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.206	0.015	0.00	0.036	0.030		Set Trigger
2	3.101	0.013	0.00	0.036	0.027		Set Trigger
3	2.982	0.013	0.00	0.037	0.026		Set Trigger
4	3.018	0.014	0.00	0.036	0.028		Set Trigger
5	3.083	0.014	0.00	0.037	0.028		Set Trigger

A.3.07

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



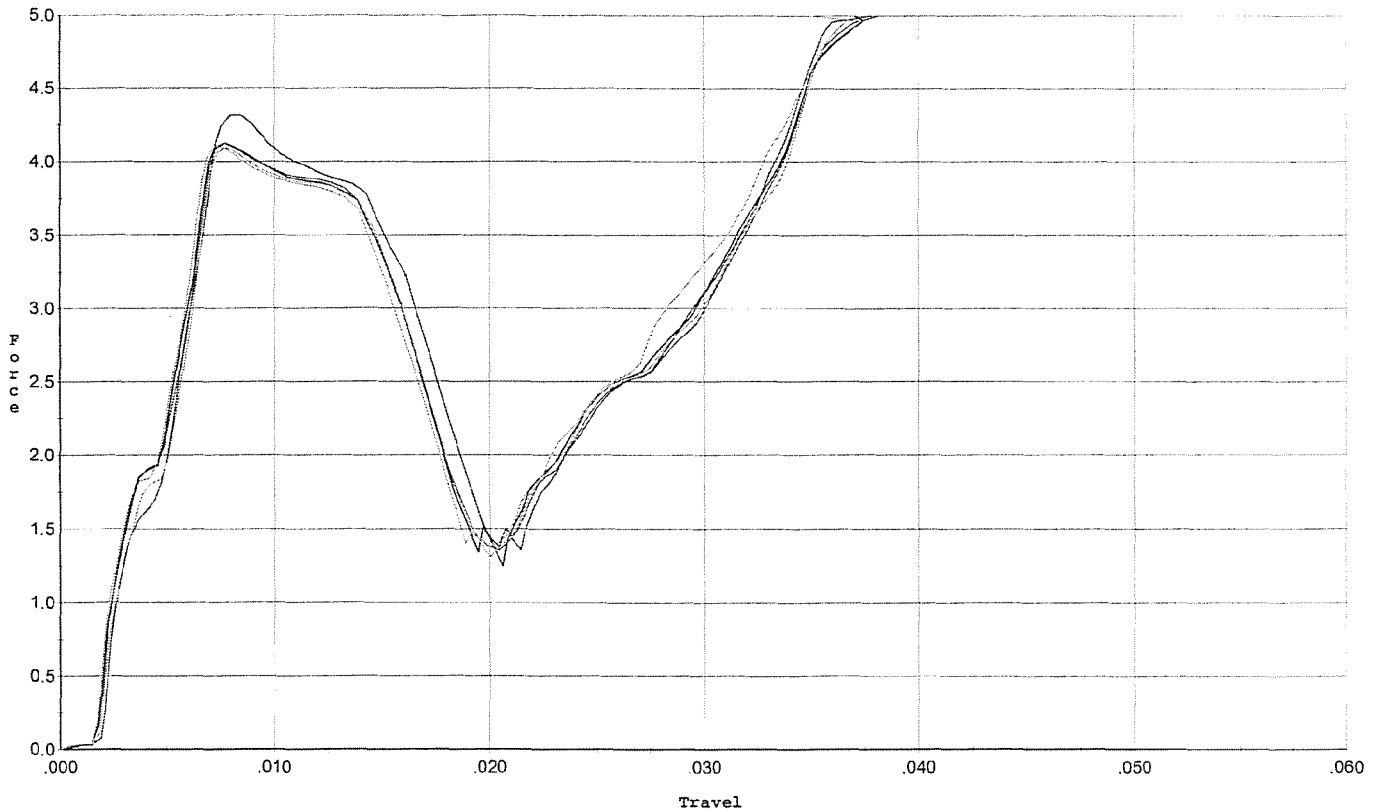
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.014	0.00	0.036	0.026		Set Trigger
2	3.060	0.015	0.002	0.036	0.030		Set Trigger
3	3.050	0.016	0.002	0.035	0.030		Set Trigger
4	3.015	0.016	0.00	0.035	0.029		Set Trigger
5	3.036	0.014	0.00	0.036	0.028		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



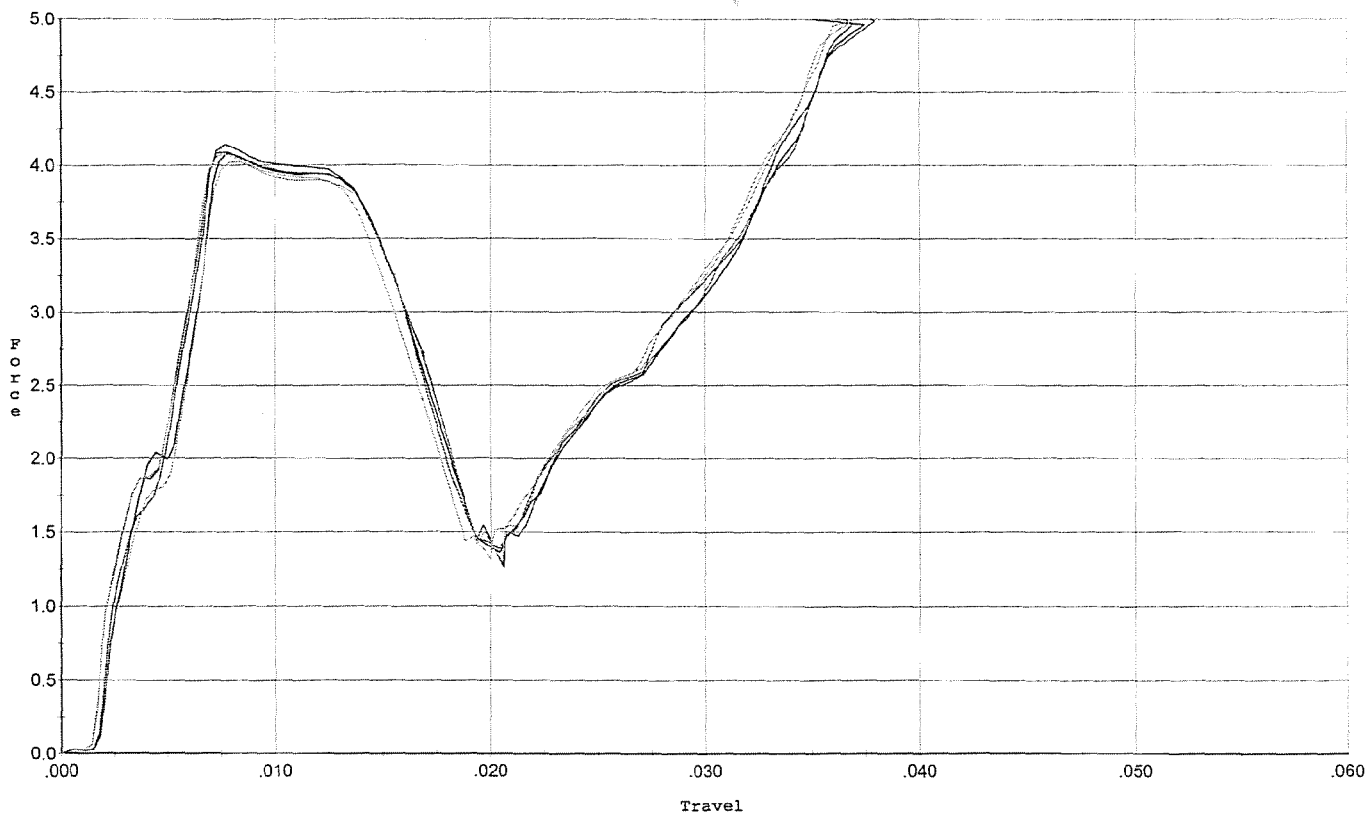
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.315	0.016	0.00	0.031	0.042		Set Trigger
2	4.126	0.016	0.00	0.032	0.041		Set Trigger
3	4.123	0.016	0.00	0.032	0.041		Set Trigger
4	4.103	0.017	0.00	0.032	0.043		Set Trigger
5	4.096	0.016	0.002	0.032	0.040		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 2/11/2009

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



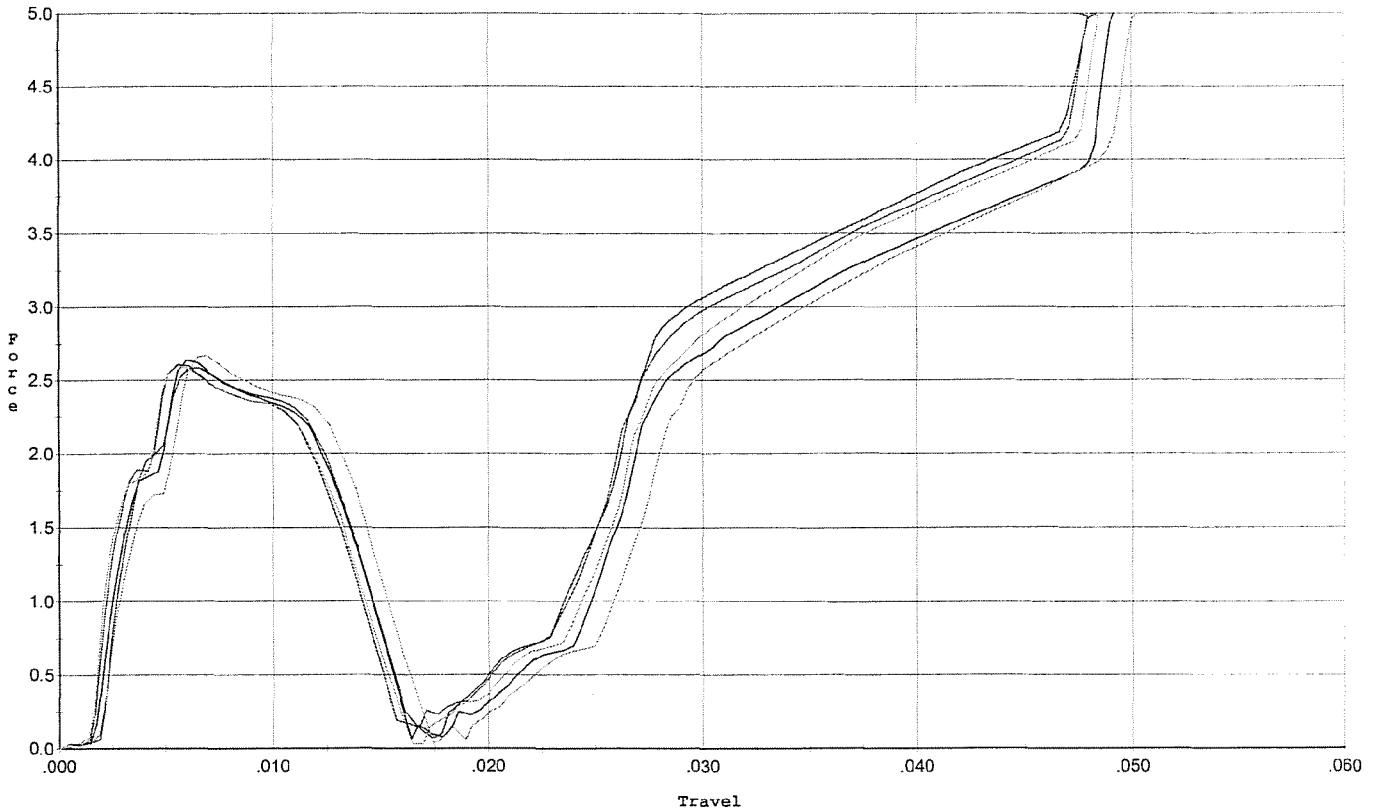
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.142	0.017	0.00	0.031	0.043		Set Trigger
2	4.085	0.016	0.002	0.032	0.040		Set Trigger
3	4.092	0.016	0.00	0.032	0.041		Set Trigger
4	4.074	0.017	0.00	0.031	0.043		Set Trigger
5	4.020	0.017	0.00	0.030	0.042		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



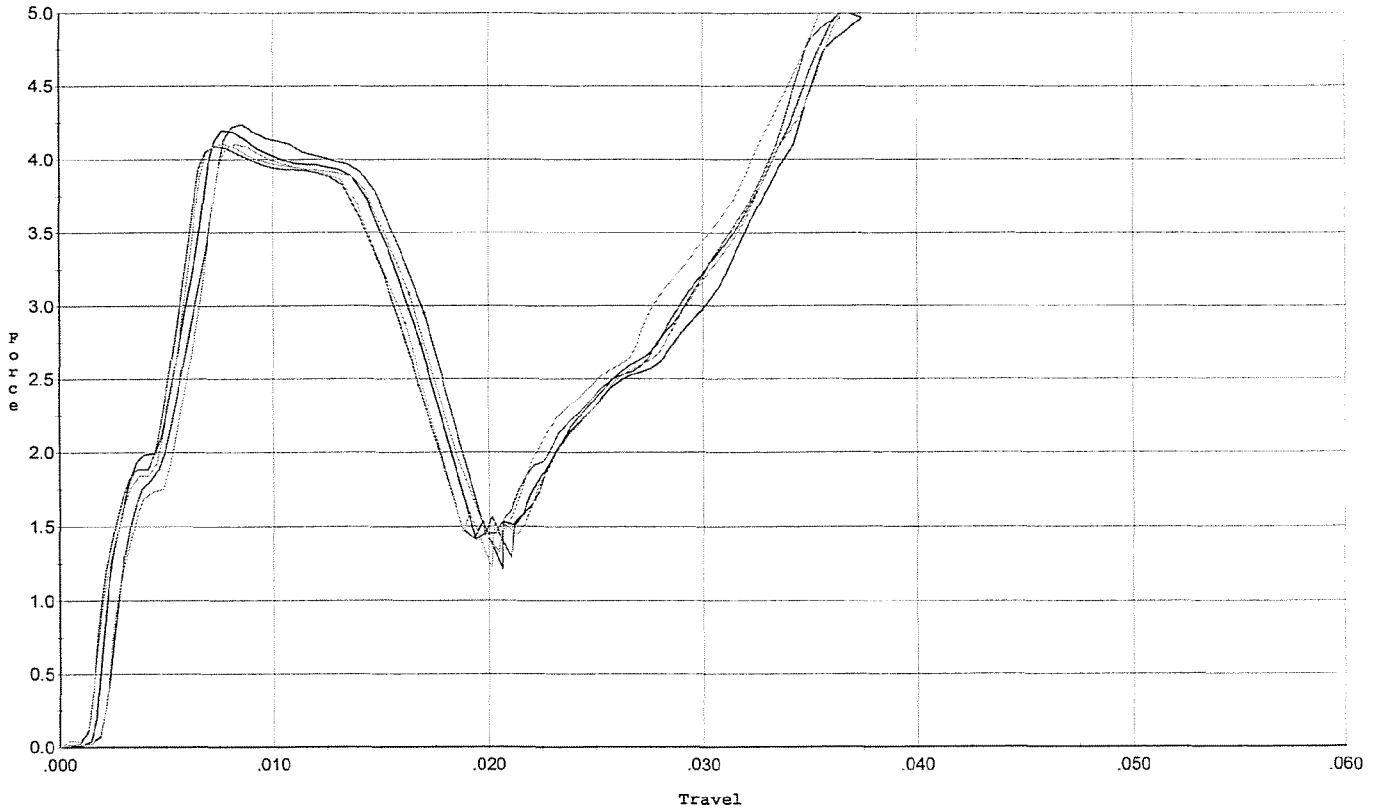
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.583	0.014	0.00	0.037	0.023		Set Trigger
2	2.639	0.014	0.00	0.038	0.023		Set Trigger
3	2.607	0.013	0.00	0.038	0.023		Set Trigger
4	2.601	0.013	0.00	0.038	0.022		Set Trigger
5	2.670	0.014	0.00	0.039	0.023		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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	4.238	0.017	0.00	0.030	0.044		Set Trigger
2	4.198	0.017	0.00	0.031	0.044		Set Trigger
3	4.091	0.017	0.00	0.030	0.044		Set Trigger
4	4.104	0.016	0.00	0.029	0.042		Set Trigger
5	4.107	0.016	0.002	0.031	0.041		Set Trigger

A. 4.14