

G6794588

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



BM FORM

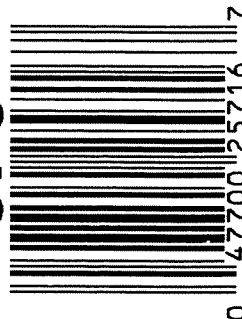
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794588

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794588

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE		10-28-08	SP
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/24/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11-3-	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-7-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

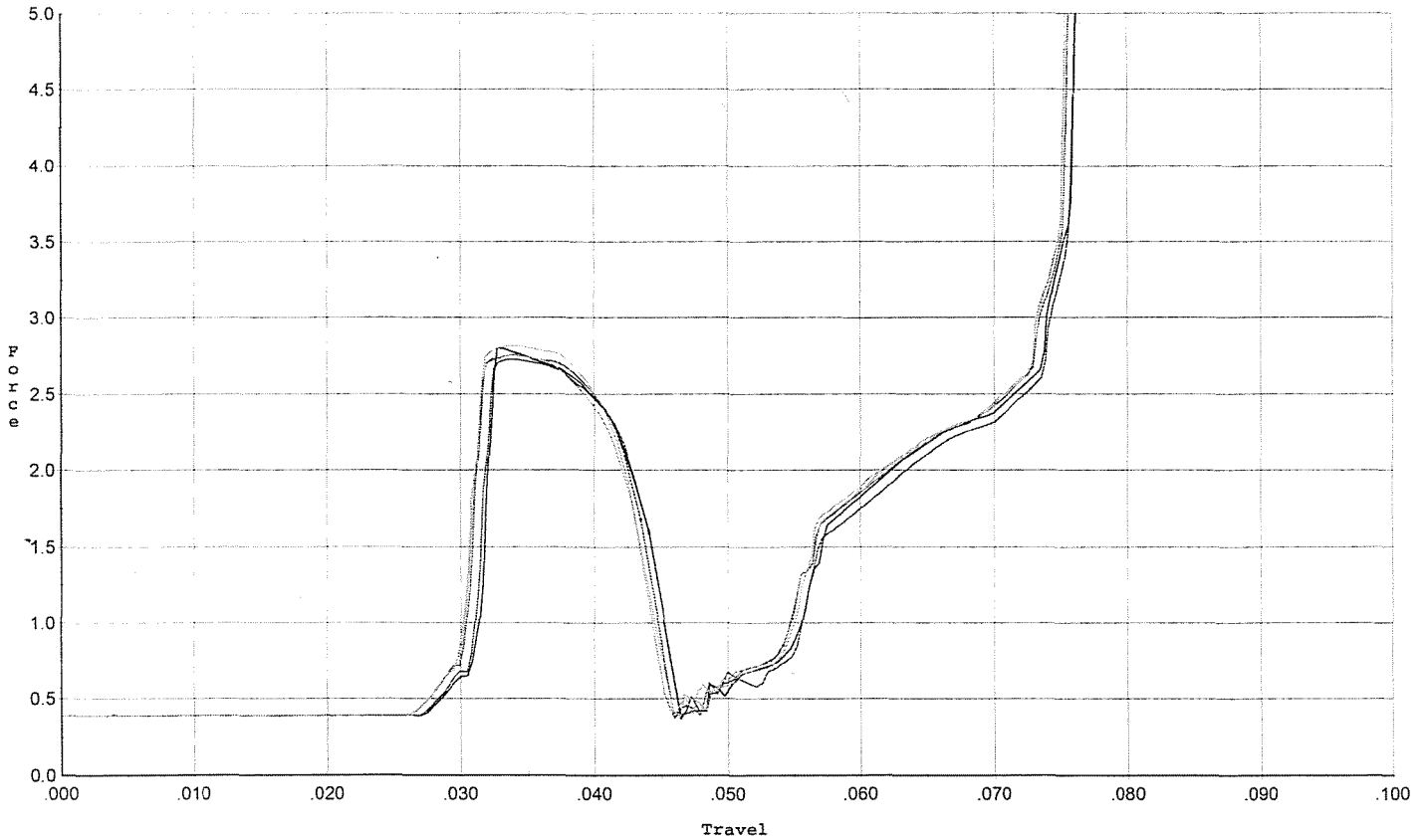
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>5.0</u> <u>4.0</u>	11-13-08	RJD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-13-08	RJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	RJD
	J) ASSEMBLE STOCK		11-7-08	LJD
	K) ASSEMBLE SWIVEL STUDS		11-13-08	RJD
	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	11-10-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-10-08	RJD
670	FINAL INSPECTION A) HEADSPACE		11-13-08	RJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.41</u> <u>2.50</u> <u>2.50</u> <u>2.48</u>	11-10-08	TC
	C) FUNCTION		11-13-08	RJD
690	PACK		11/17/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



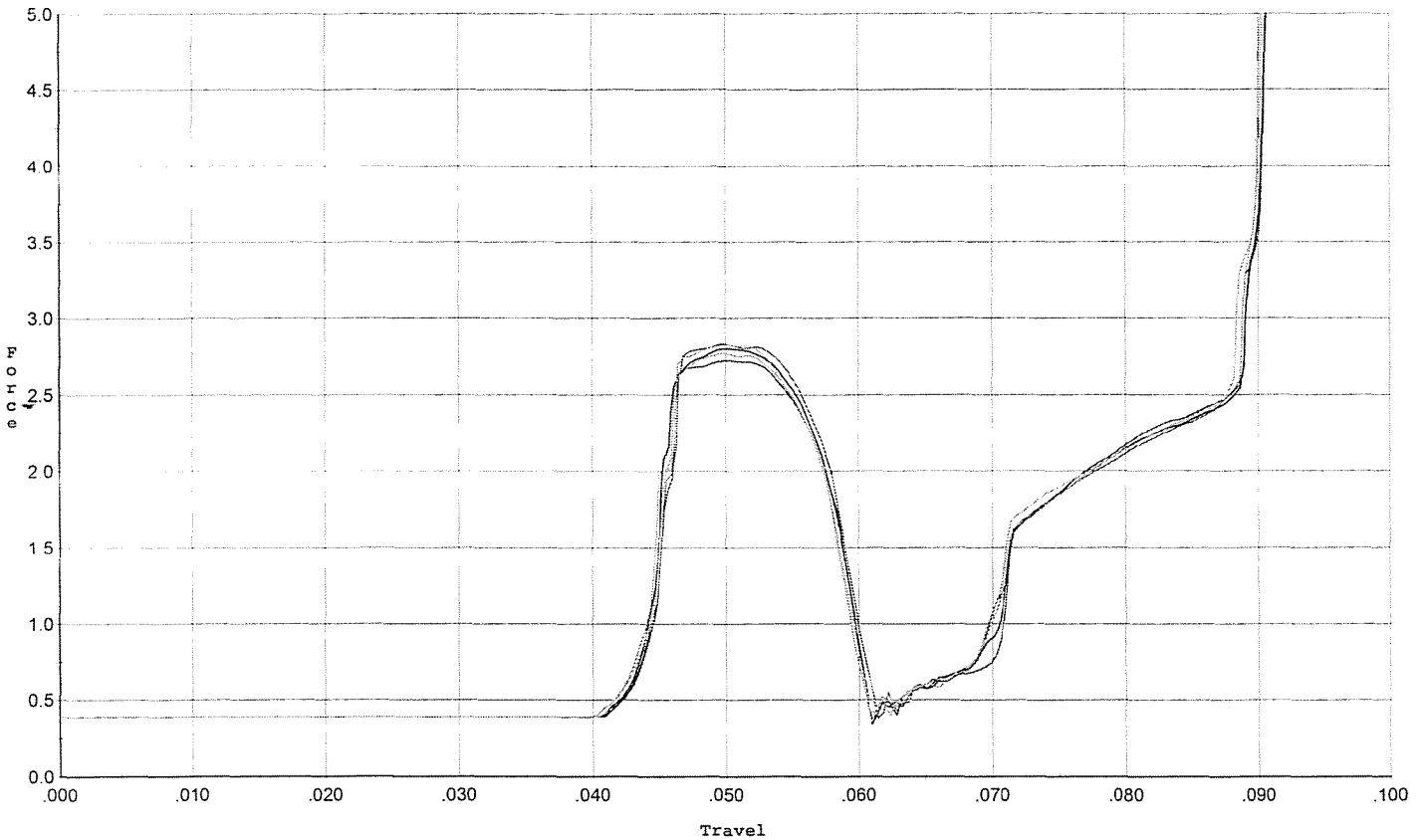
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.728	0.044	0.029	0.035	0.044		Set Trigger
2	2.801	0.044	0.030	0.035	0.044		Set Trigger
3	2.757	0.043	0.029	0.035	0.045		Set Trigger
4	2.817	0.043	0.029	0.035	0.044		Set Trigger
5	2.752	0.043	0.030	0.035	0.044		Set Trigger

A-2-77

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



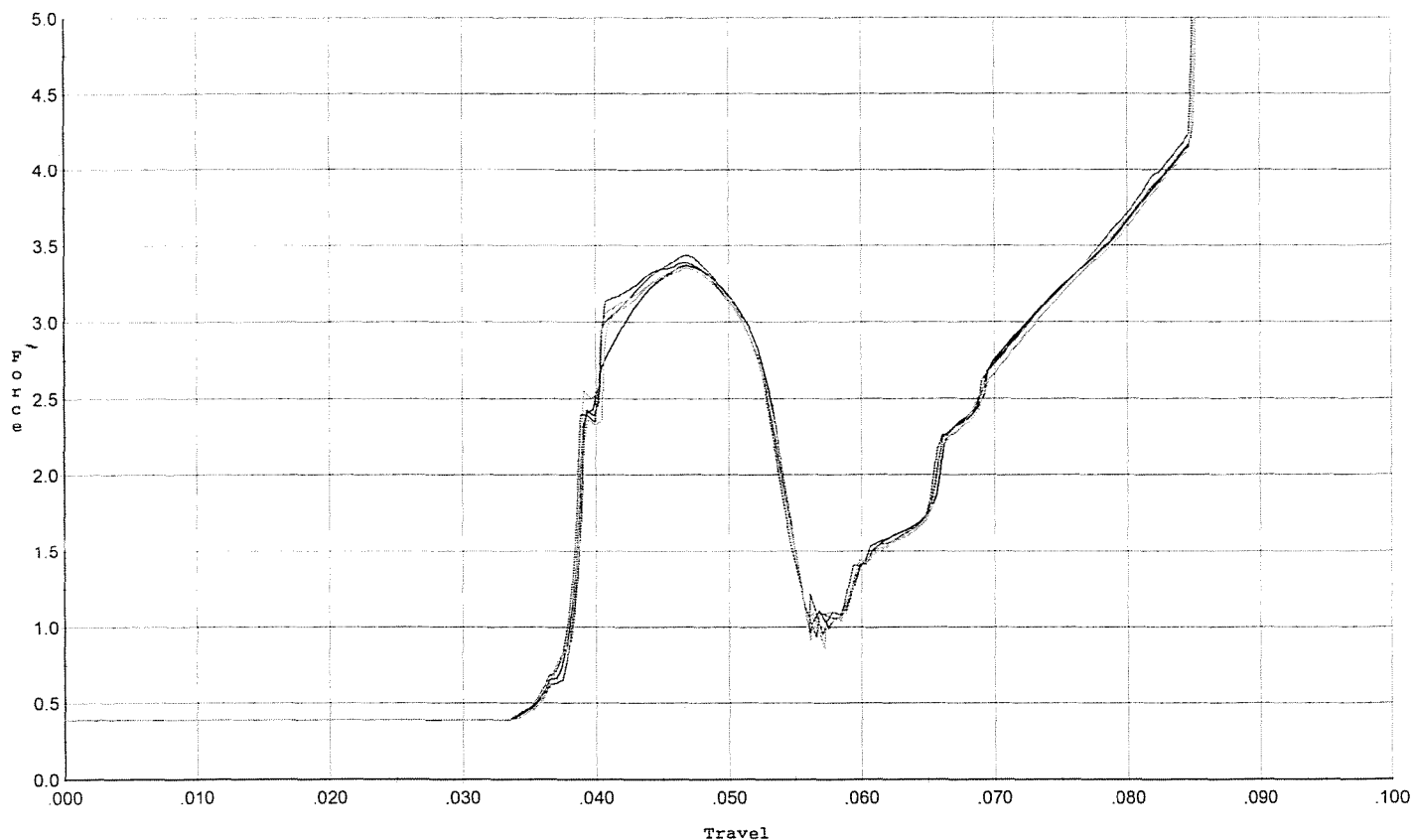
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.726	0.058	0.043	0.039	0.052		Set Trigger
2	2.802	0.058	0.043	0.039	0.053		Set Trigger
3	2.832	0.058	0.043	0.039	0.053		Set Trigger
4	2.772	0.057	0.042	0.039	0.052		Set Trigger
5	2.826	0.058	0.043	0.039	0.052		Set Trigger

A-2.79

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



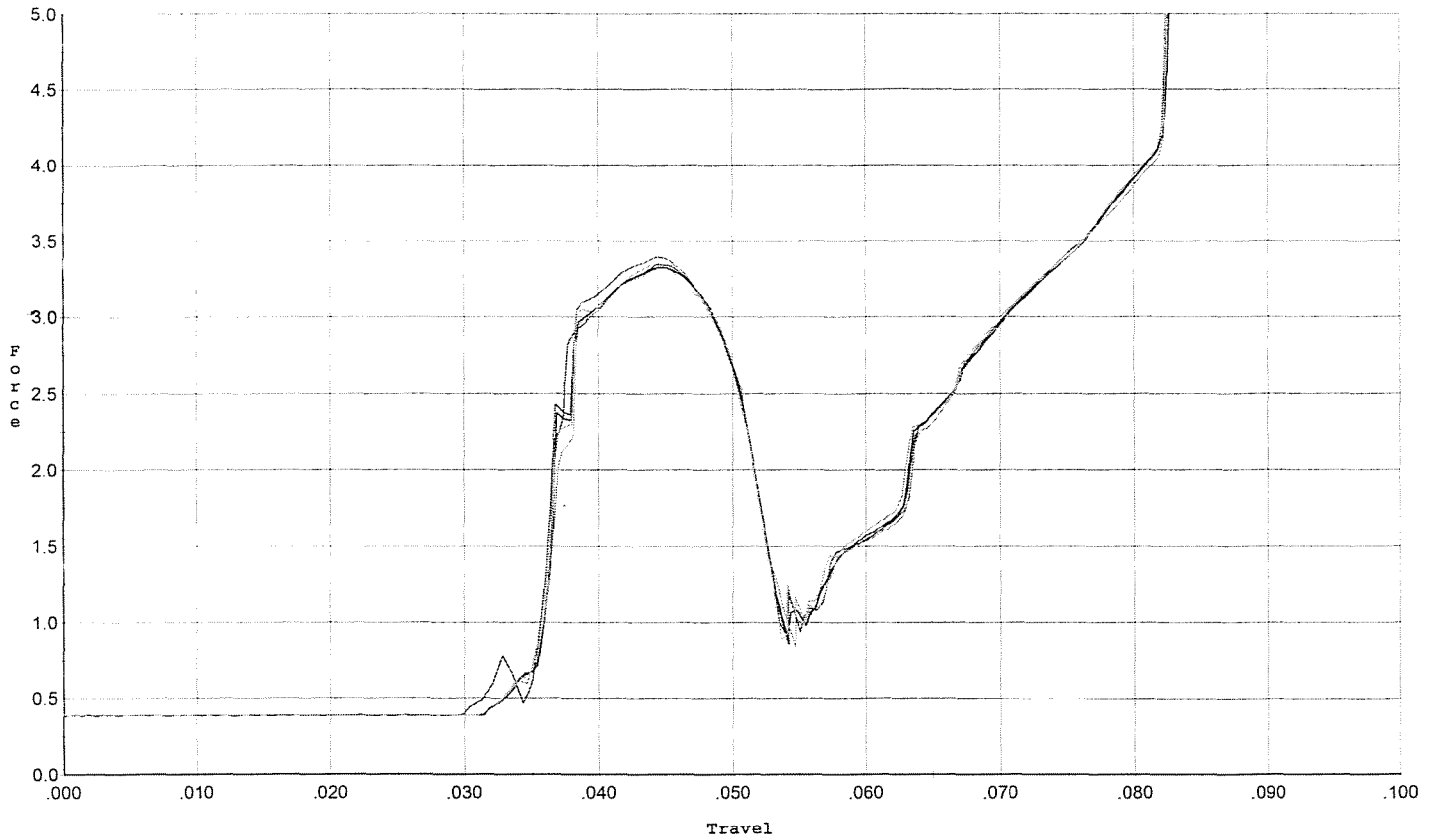
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.389	0.054	0.037	0.037	0.062		Set Trigger
2	3.373	0.053	0.036	0.037	0.062		Set Trigger
3	3.438	0.052	0.036	0.037	0.061		Set Trigger
4	3.354	0.053	0.036	0.037	0.061		Set Trigger
5	3.362	0.052	0.036	0.037	0.060		Set Trigger

A 3.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



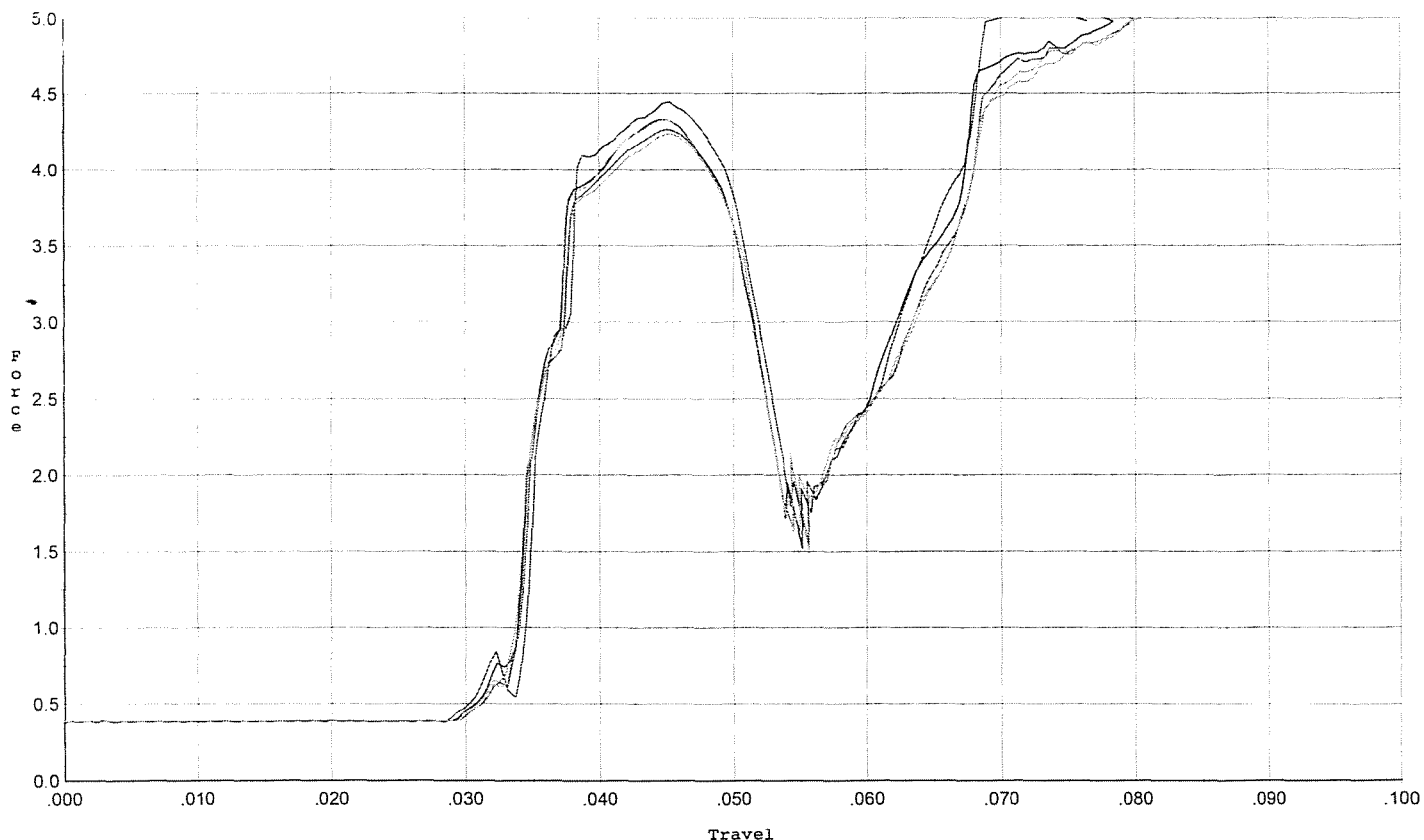
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.348	0.051	0.032	0.036	0.060		Set Trigger
2	3.328	0.051	0.034	0.036	0.059		Set Trigger
3	3.395	0.051	0.034	0.036	0.060		Set Trigger
4	3.323	0.051	0.035	0.036	0.060		Set Trigger
5	3.361	0.051	0.035	0.036	0.059		Set Trigger

A-3.35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



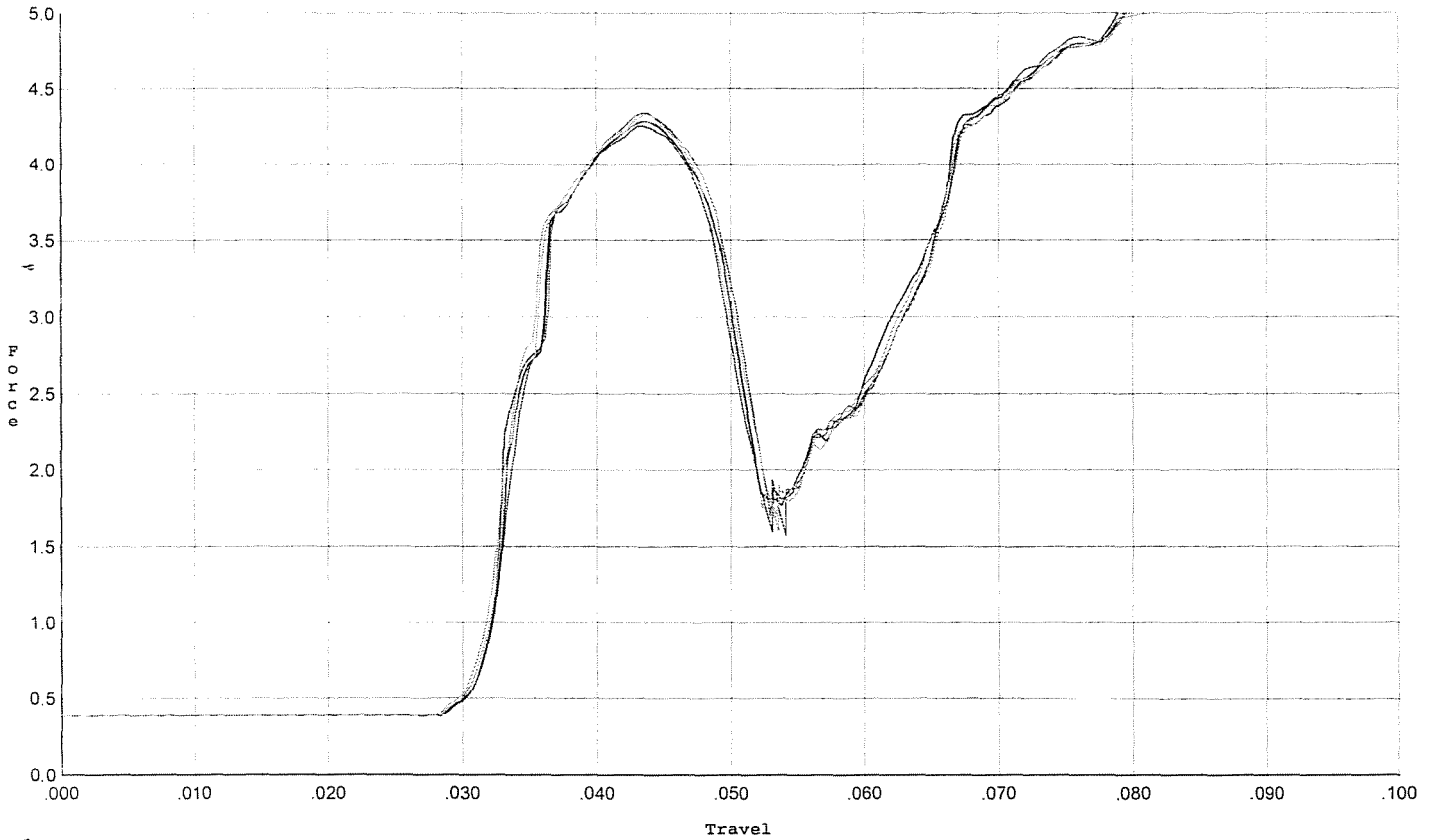
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.446	0.052	0.031	0.034	0.082		Set Trigger
2	4.329	0.051	0.032	0.034	0.080		Set Trigger
3	4.264	0.051	0.032	0.034	0.077		Set Trigger
4	4.236	0.051	0.032	0.034	0.077		Set Trigger
5	4.331	0.052	0.032	0.034	0.080		Set Trigger

A 4.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



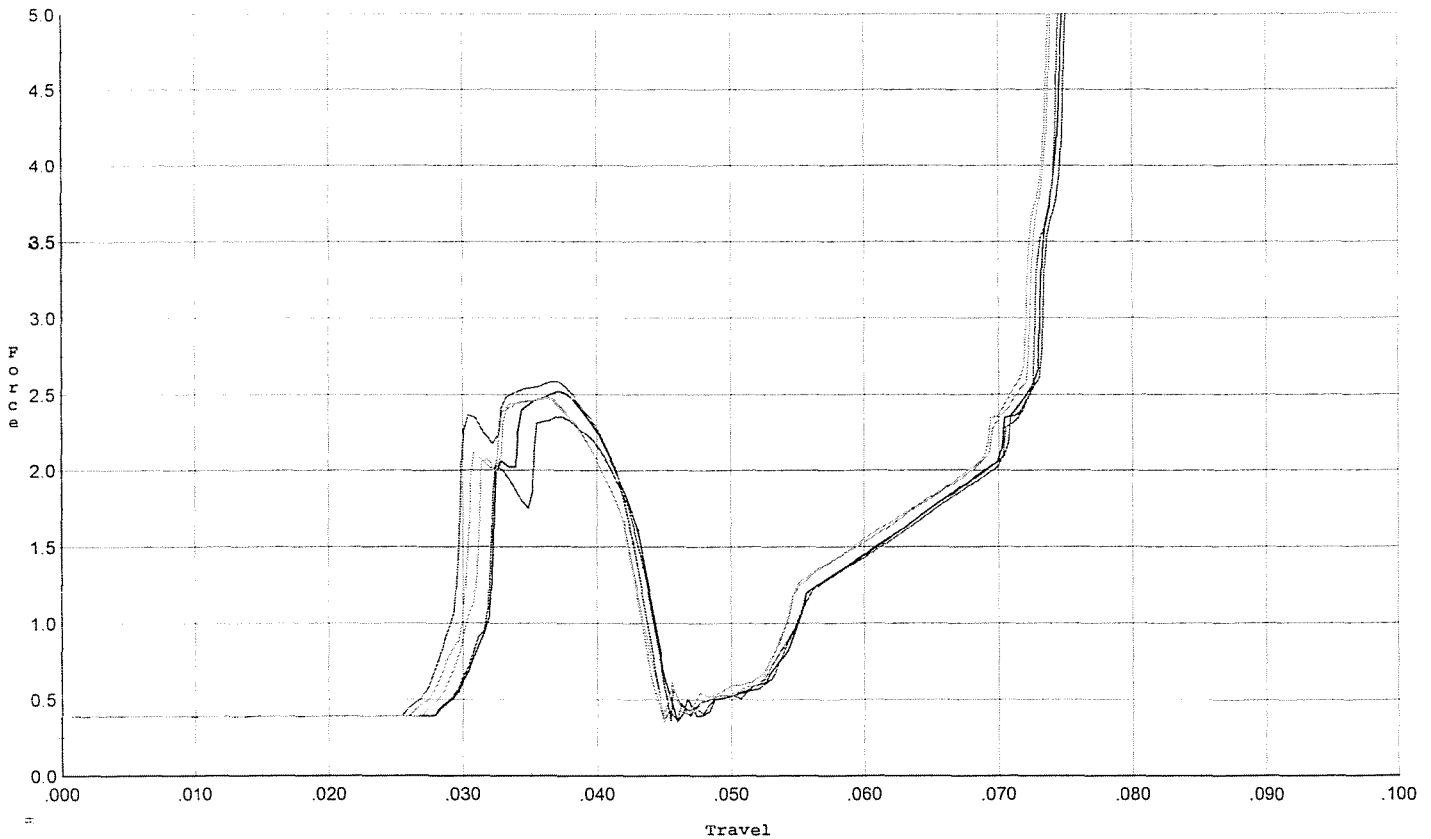
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.255	0.049	0.031	0.033	0.075		Set Trigger
2	4.284	0.049	0.031	0.033	0.076		Set Trigger
3	4.338	0.050	0.031	0.033	0.079		Set Trigger
4	4.323	0.049	0.031	0.033	0.077		Set Trigger
5	4.286	0.050	0.031	0.033	0.079		Set Trigger

A 4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



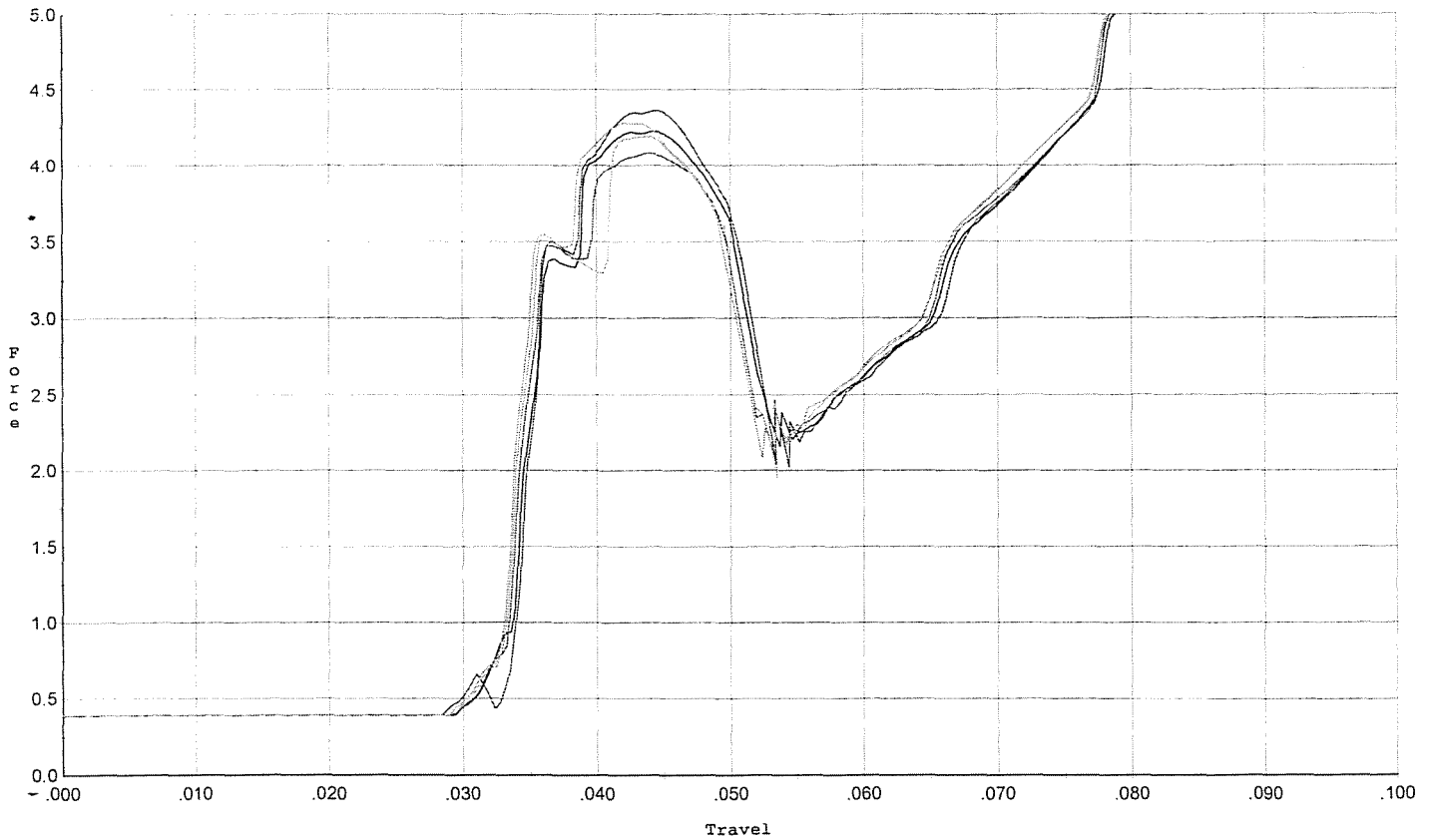
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.355	0.043	0.030	0.036	0.037		Set Trigger
2	2.518	0.043	0.030	0.035	0.038		Set Trigger
3	2.582	0.043	0.028	0.035	0.043		Set Trigger
4	2.475	0.042	0.029	0.035	0.038		Set Trigger
5	2.486	0.042	0.028	0.035	0.039		Set Trigger

A.2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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	4.360	0.051	0.031	0.034	0.079		Set Trigger
2	4.222	0.050	0.032	0.034	0.076		Set Trigger
3	4.081	0.050	0.032	0.034	0.074		Set Trigger
4	4.187	0.050	0.031	0.034	0.075		Set Trigger
5	4.279	0.050	0.031	0.034	0.079		Set Trigger

A 4.22