

6680 7766

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

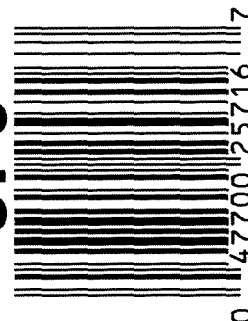
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase

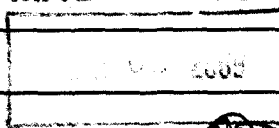


owner registration sticker

**ORDER NO. 25716****BARREL LENGTH 24"****CAPACITY 6****G6807766****UPC**

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6 8 0 7 7 6 6

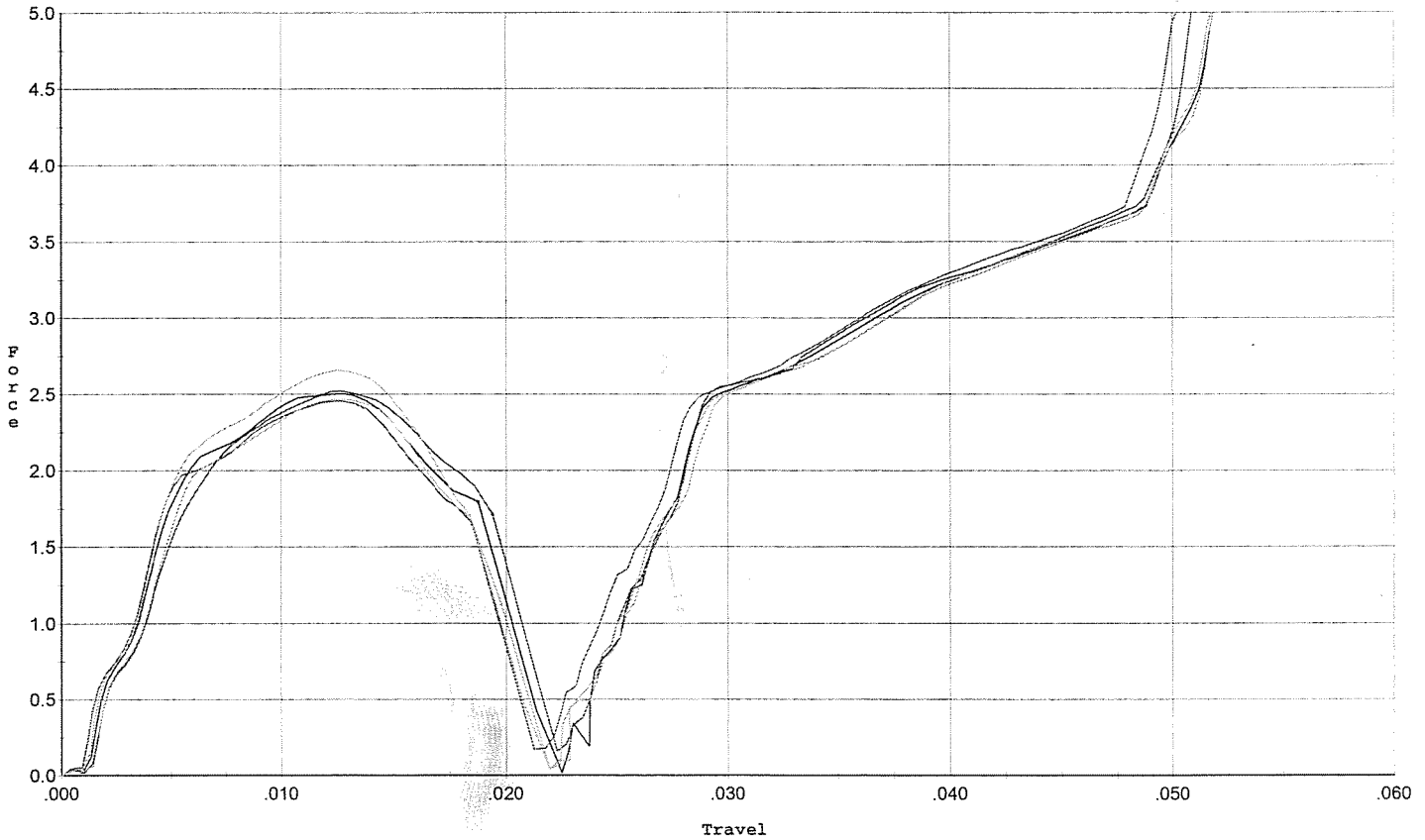
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX  OPERATOR 	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION		3/5/09	RP
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/6/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		4/6/07	wom
540	APPLY COATINGS (BARREL ACTION)		3/11	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-18-09	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>2.6</u> <u>2.6</u> <u>2.8</u>	3/23/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.8</u> <u>5.0</u> <u>5.0</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-18-09	292
	K) ASSEMBLE SWIVEL STUDS		3/23/09	RP
	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	3-18-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.67</u> <u>2.60</u> <u>2.69</u> <u>2.78</u>	3-23-09	TL
	C) FUNCTION		3/23/09	RP
690	PACK		3/25/09	Fm

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



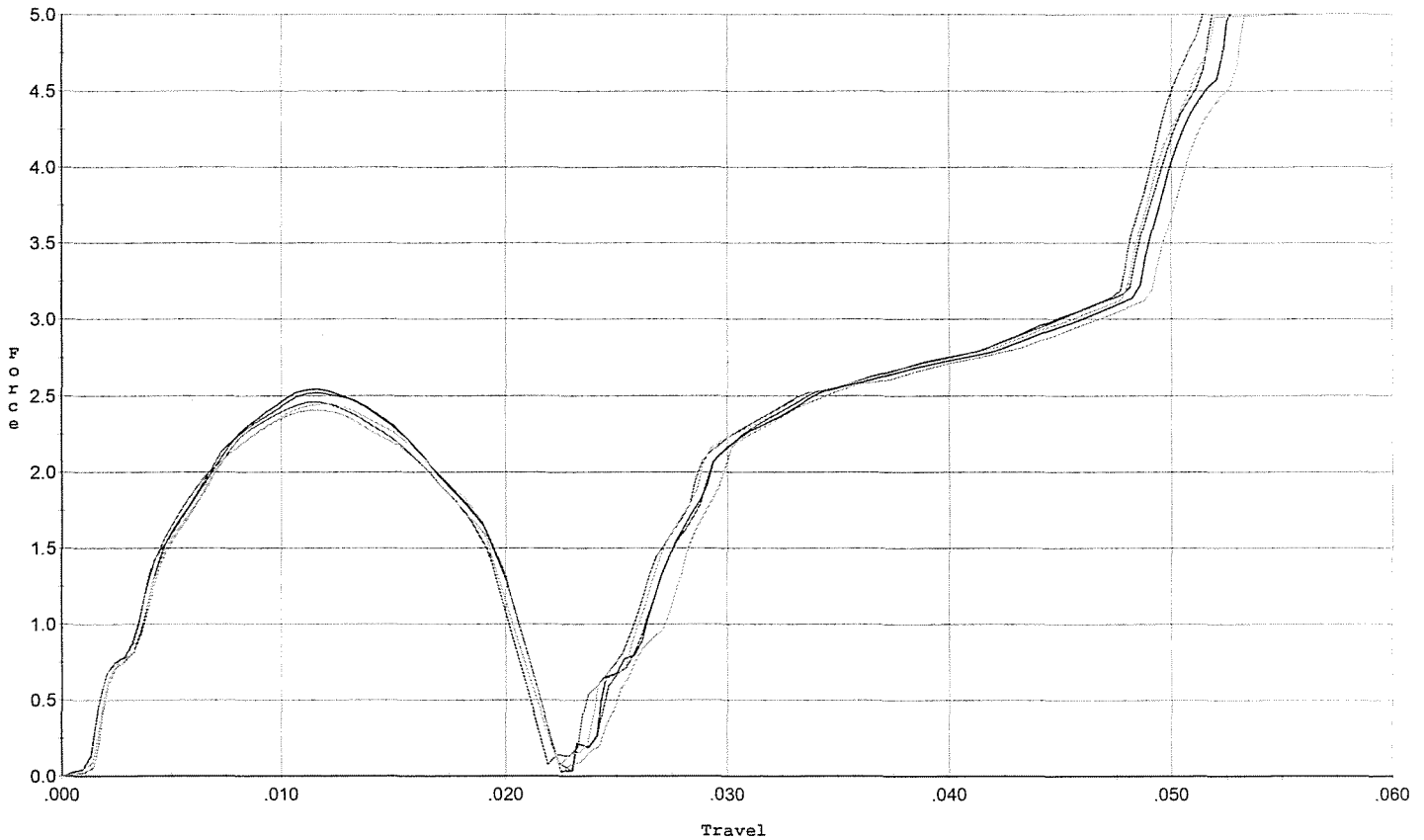
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.019	0.00	0.035	0.033		Set Trigger
2	2.503	0.019	0.00	0.036	0.033		Set Trigger
3	2.452	0.018	0.00	0.035	0.032		Set Trigger
4	2.465	0.020	0.00	0.036	0.033		Set Trigger
5	2.655	0.018	0.00	0.036	0.033		Set Trigger

A 2-51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



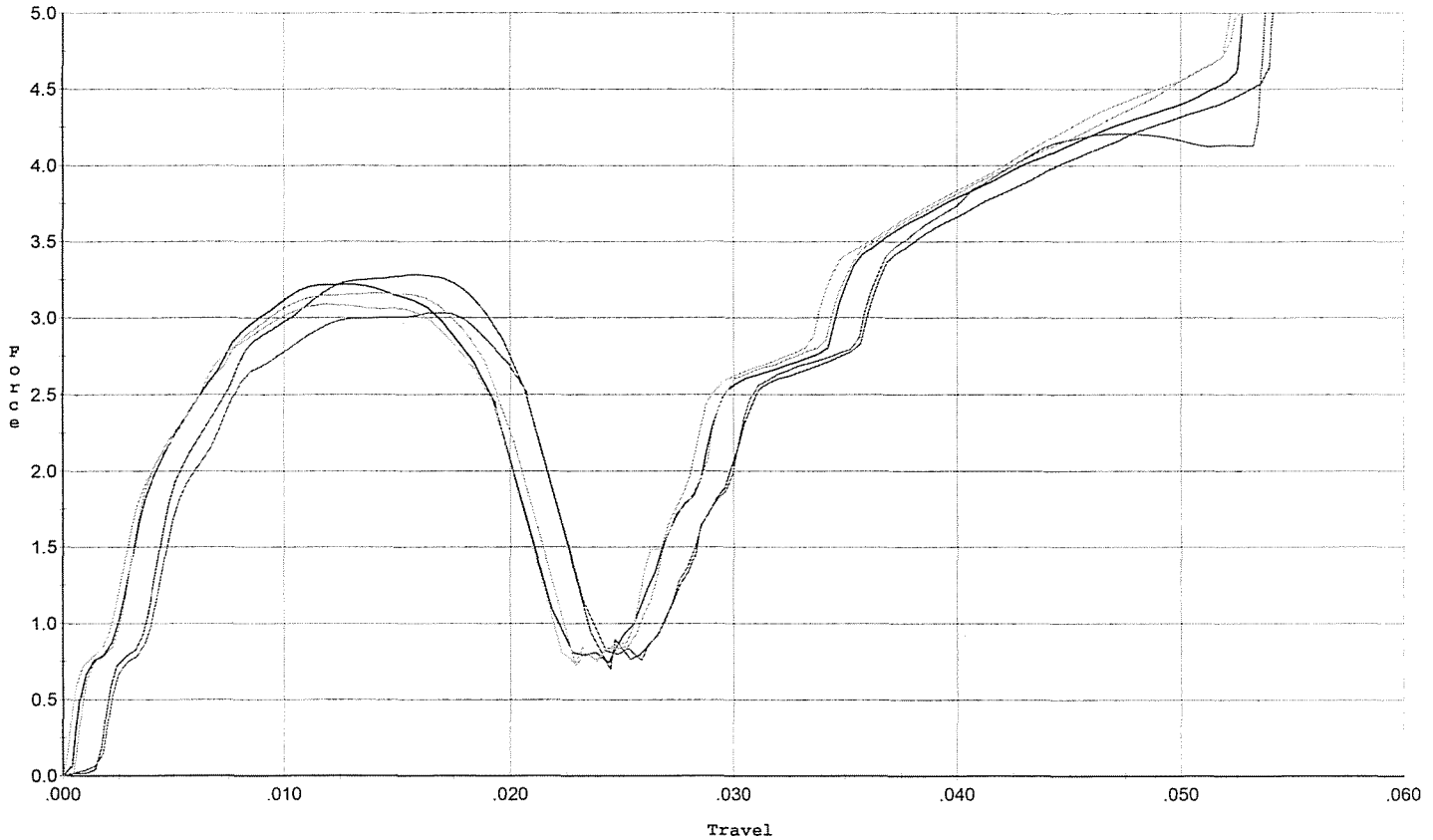
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.521	0.020	0.00	0.036	0.034		Set Trigger
2	2.543	0.020	0.00	0.037	0.034		Set Trigger
3	2.460	0.019	0.00	0.036	0.032		Set Trigger
4	2.447	0.020	0.00	0.036	0.033		Set Trigger
5	2.406	0.019	0.00	0.038	0.031		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



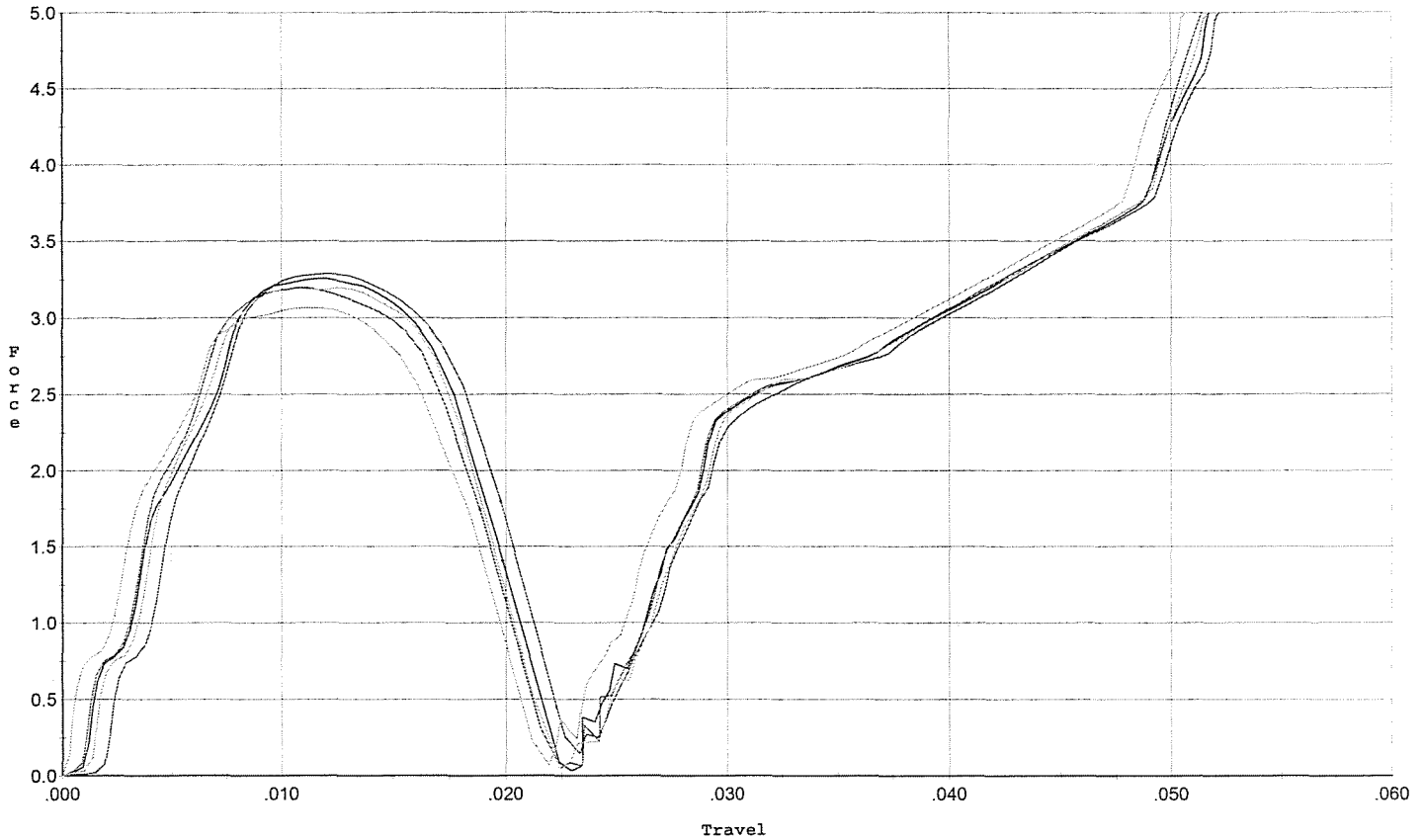
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.281	0.021	0.00	0.035	0.046		Set Trigger
2	3.219	0.019	0.00	0.035	0.045		Set Trigger
3	3.031	0.021	0.00	0.035	0.043		Set Trigger
4	3.089	0.019	0.00	0.034	0.044		Set Trigger
5	3.162	0.020	0.00	0.034	0.046		Set Trigger

A-3-15-

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



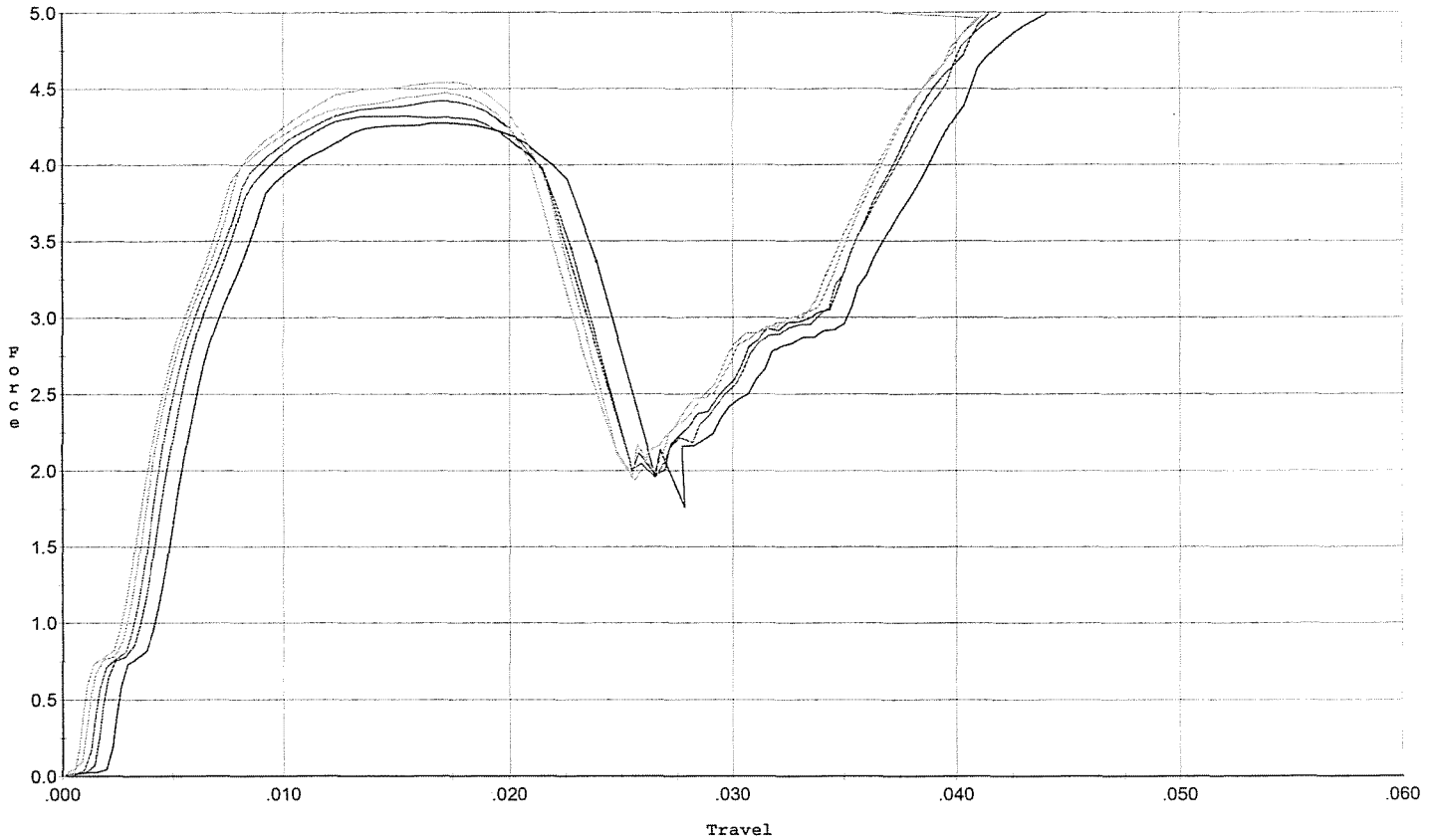
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.288	0.020	0.00	0.035	0.042		Set Trigger
2	3.253	0.020	0.00	0.036	0.043		Set Trigger
3	3.197	0.019	0.00	0.036	0.041		Set Trigger
4	3.195	0.018	0.00	0.036	0.039		Set Trigger
5	3.065	0.018	0.00	0.035	0.040		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



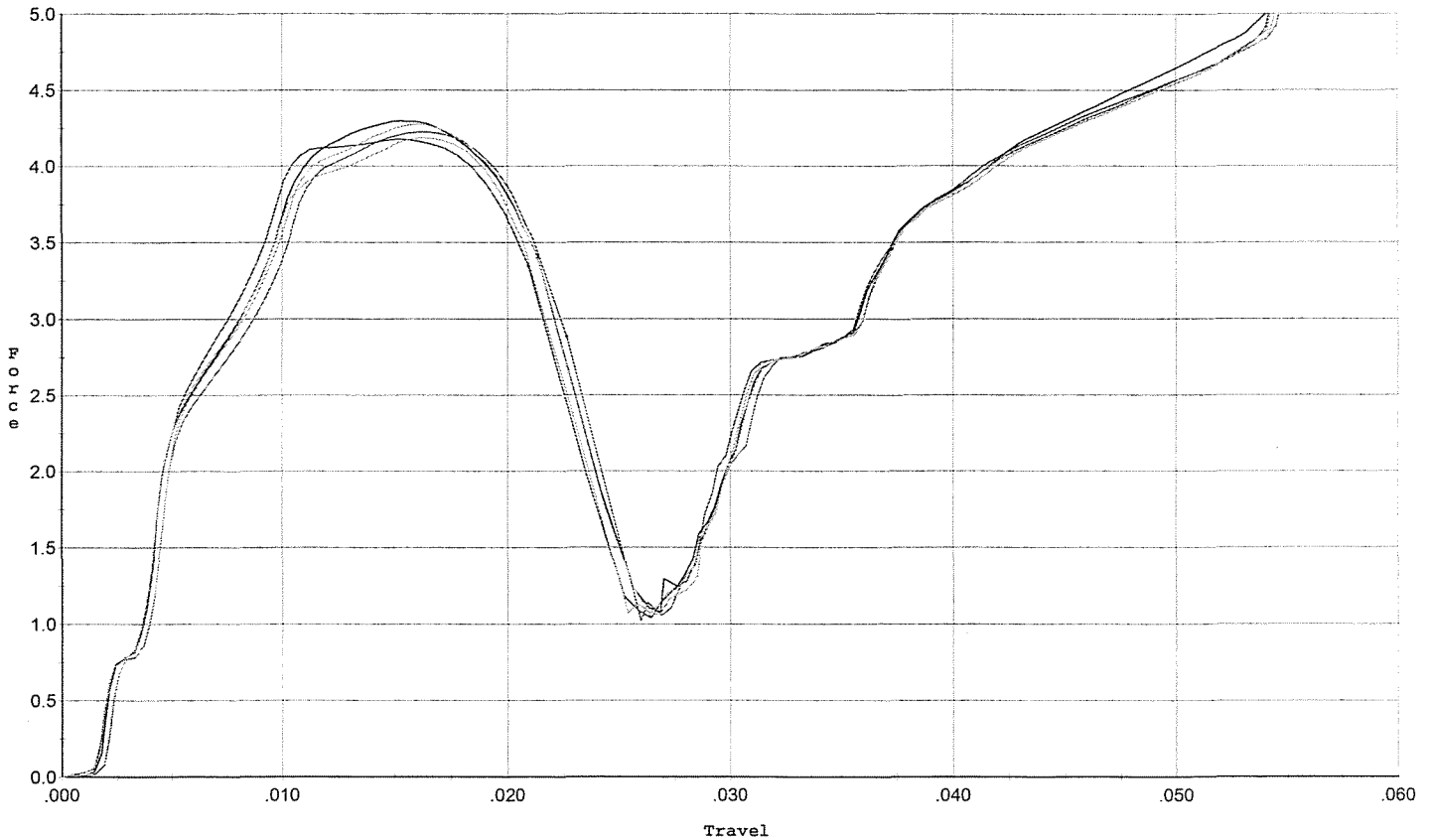
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.323	0.023	0.00	0.031	0.068		Set Trigger
2	4.275	0.024	0.00	0.031	0.070		Set Trigger
3	4.419	0.023	0.00	0.031	0.072		Set Trigger
4	4.472	0.021	0.00	0.031	0.066		Set Trigger
5	4.543	0.022	0.00	0.031	0.068		Set Trigger

A-4.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



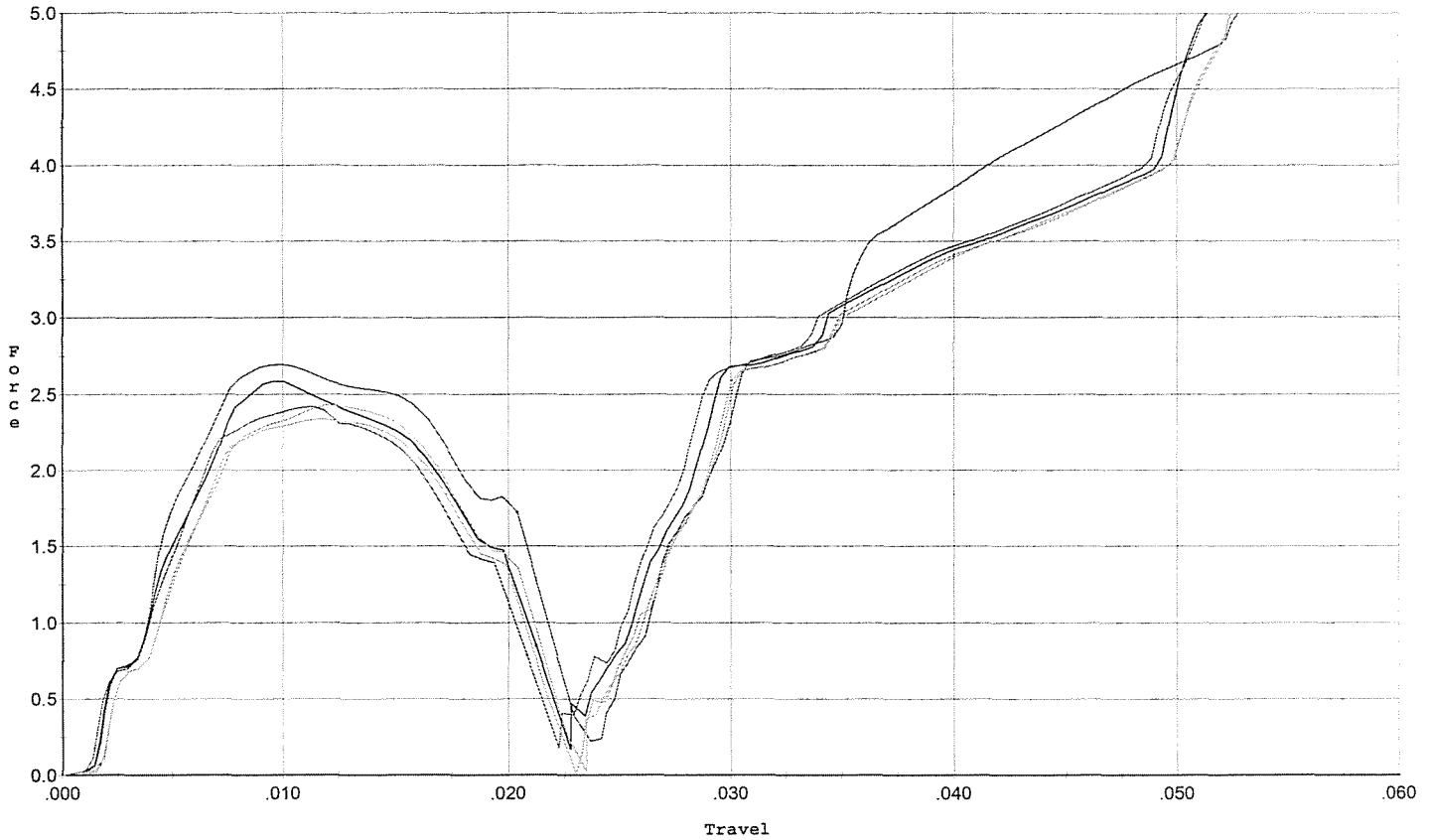
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.178	0.021	0.00	0.034	0.058		Set Trigger
2	4.297	0.021	0.00	0.033	0.060		Set Trigger
3	4.224	0.023	0.00	0.033	0.061		Set Trigger
4	4.277	0.021	0.00	0.033	0.059		Set Trigger
5	4.188	0.023	0.00	0.033	0.062		Set Trigger

A-4-23

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



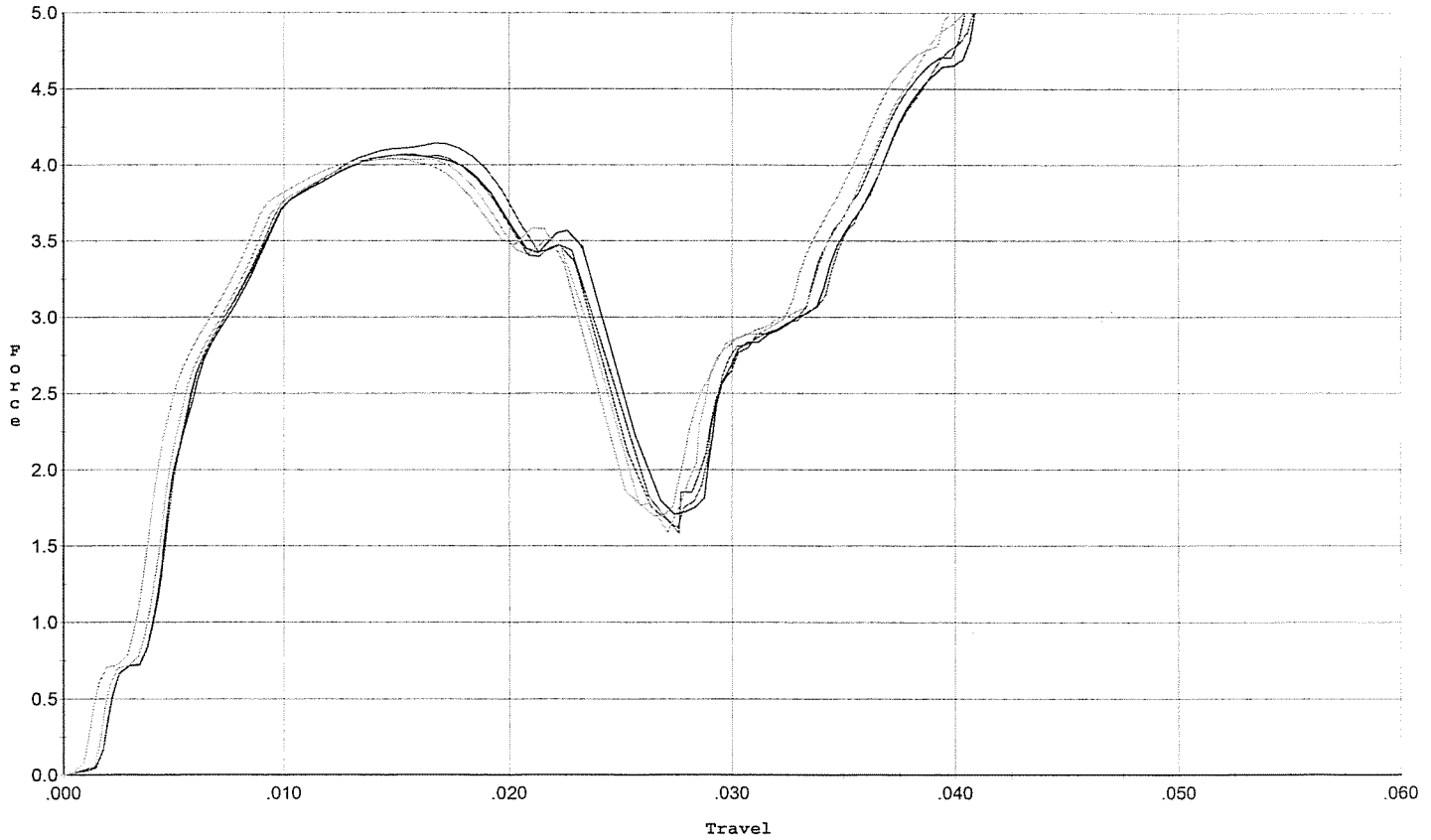
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.020	0.00	0.035	0.037		Set Trigger
2	2.585	0.021	0.00	0.035	0.035		Set Trigger
3	2.420	0.021	0.00	0.035	0.033		Set Trigger
4	2.336	0.020	0.00	0.036	0.031		Set Trigger
5	2.430	0.020	0.00	0.035	0.033		Set Trigger

A-2-49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

Model: M/24
Serial No: Form #F005
Trigger: reset 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	4.142	0.024	0.00	0.028	0.068		Set Trigger
2	4.068	0.023	0.00	0.028	0.064		Set Trigger
3	4.063	0.023	0.00	0.028	0.063		Set Trigger
4	4.039	0.024	0.00	0.027	0.065		Set Trigger
5	4.042	0.022	0.00	0.027	0.063		Set Trigger

A-4.07