

6680 7776

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



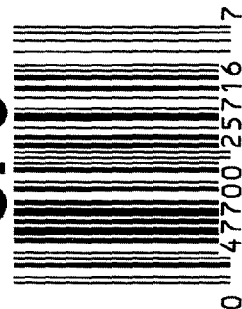
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807776

UPC



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807776

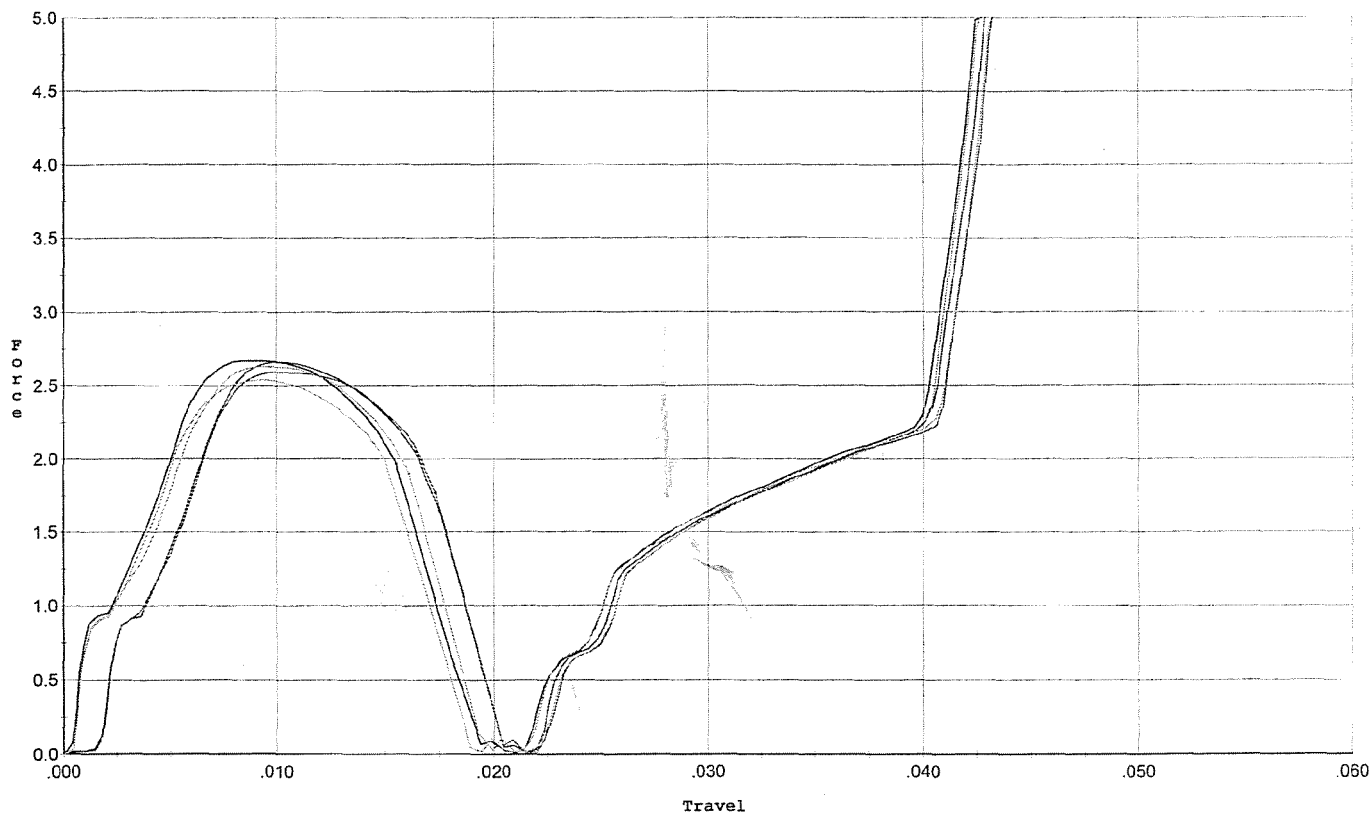
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	(A)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		5/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-11-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-11-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-17-09	LD
	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>4</u> <u>4</u> <u>4</u>	3-20-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3</u>	3-20-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-20-09	WV
	J) ASSEMBLE STOCK		3-17-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	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	3-19-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-19-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.22</u> <u>2.25</u> <u>2.23</u> <u>2.20</u>	3-20-09	TL
	C) FUNCTION		3-20-09	WV
690	PACK		3-20-09	TL

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



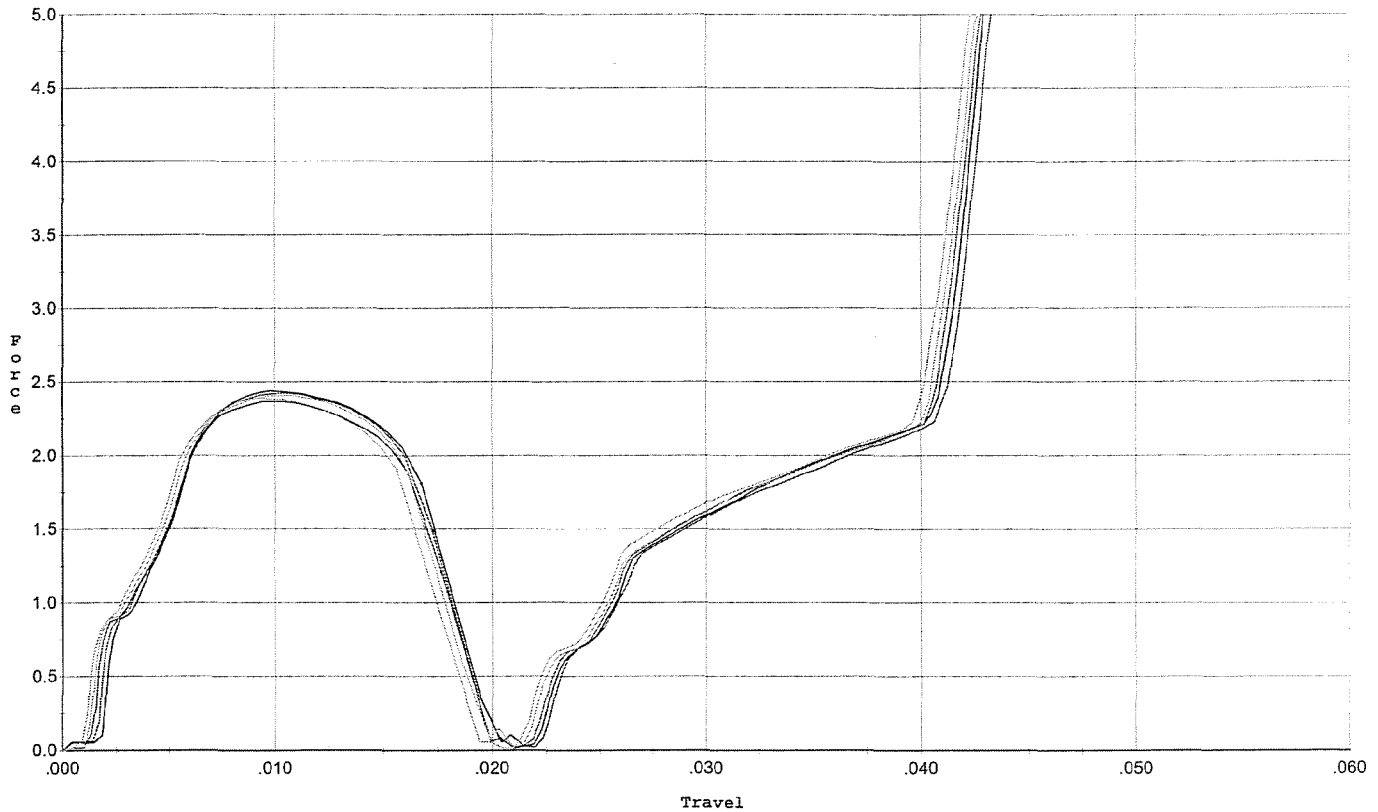
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.658	0.018	0.00	0.031	0.030		Set Trigger
2	2.668	0.016	0.00	0.031	0.029		Set Trigger
3	2.589	0.017	0.00	0.031	0.030		Set Trigger
4	2.537	0.017	0.00	0.032	0.030		Set Trigger
5	2.627	0.016	0.00	0.031	0.030		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



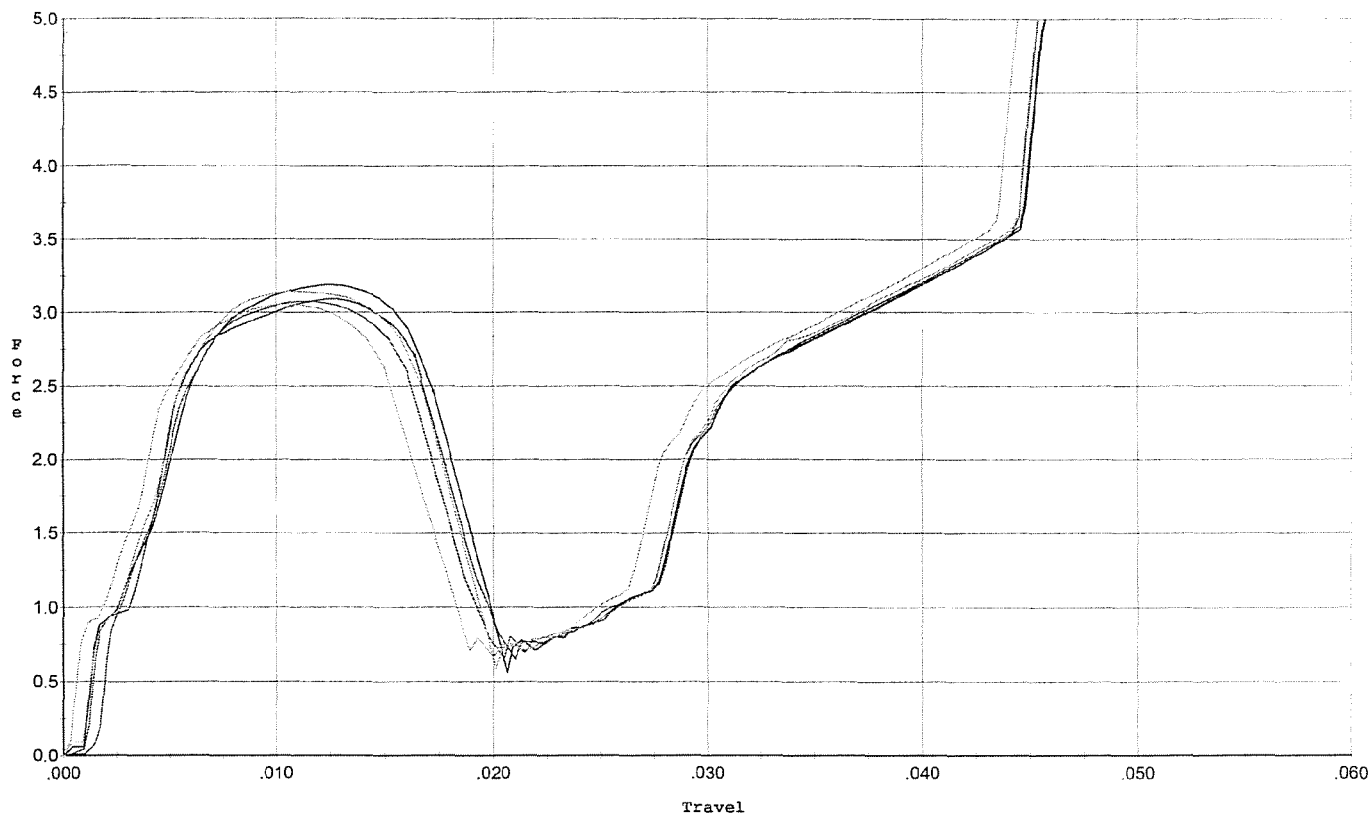
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.366	0.018	0.00	0.031	0.029		Set Trigger
2	2.439	0.017	0.002	0.031	0.028		Set Trigger
3	2.423	0.017	0.002	0.030	0.029		Set Trigger
4	2.409	0.016	0.00	0.031	0.027		Set Trigger
5	2.388	0.016	0.00	0.031	0.026		Set Trigger

A-2.40

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



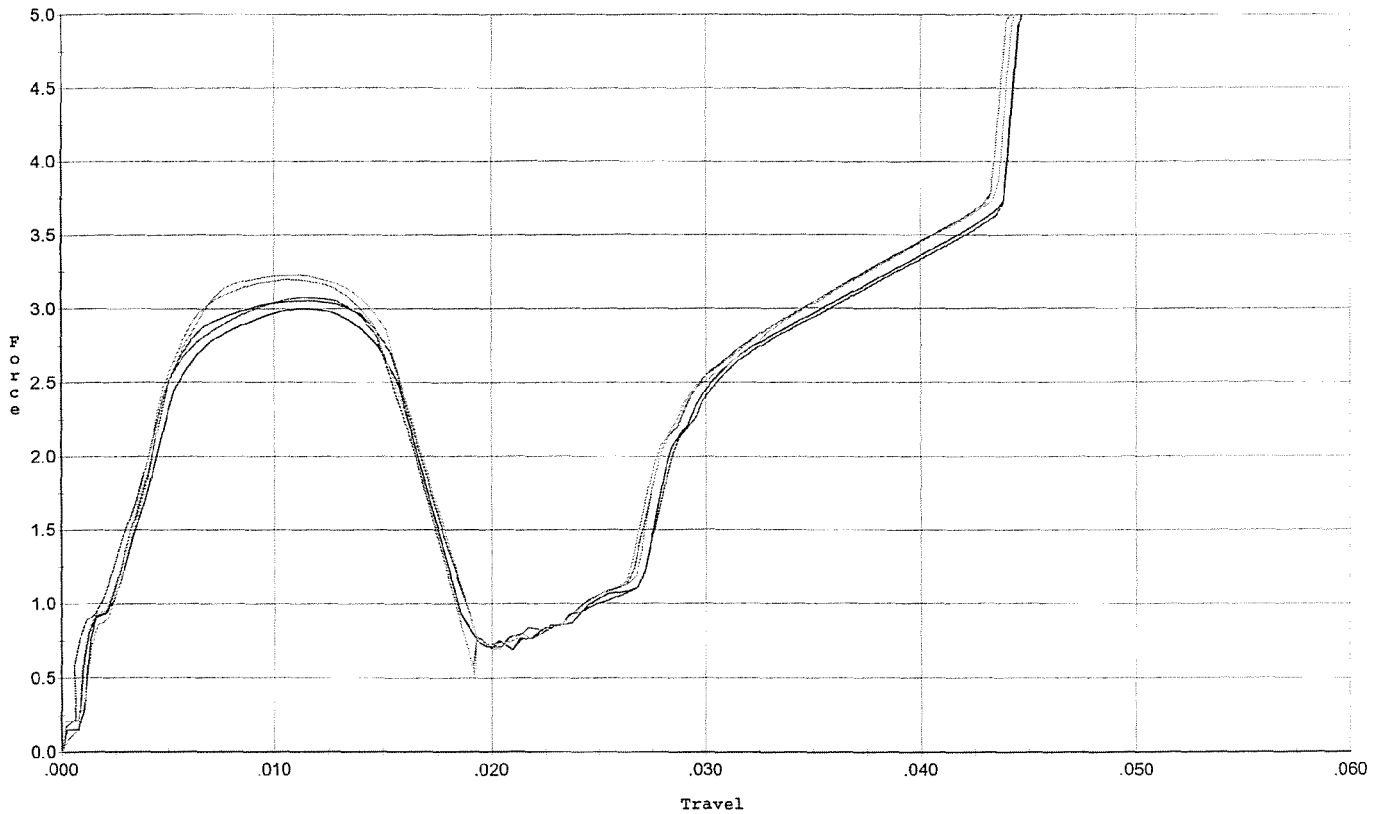
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.091	0.016	0.00	0.031	0.035		Set Trigger
2	3.188	0.017	0.00	0.031	0.038		Set Trigger
3	3.075	0.016	0.00	0.032	0.034		Set Trigger
4	3.055	0.015	0.00	0.031	0.033		Set Trigger
5	3.145	0.017	0.00	0.031	0.037		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



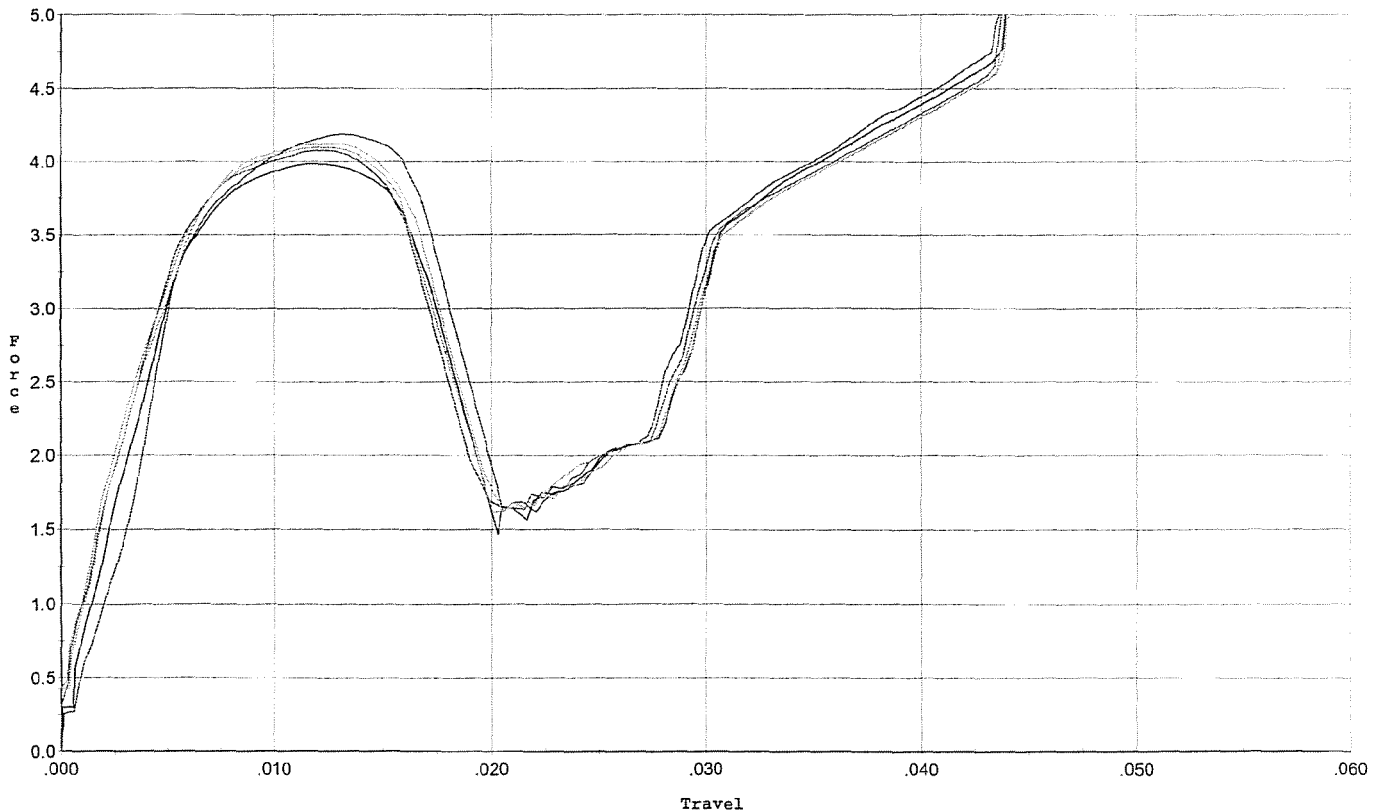
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.053	0.015	0.00	0.031	0.034		Set Trigger
2	3.001	0.016	0.00	0.031	0.033		Set Trigger
3	3.076	0.016	0.00	0.031	0.036		Set Trigger
4	3.229	0.015	0.00	0.031	0.034		Set Trigger
5	3.201	0.016	0.00	0.031	0.036		Set Trigger

A 3.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



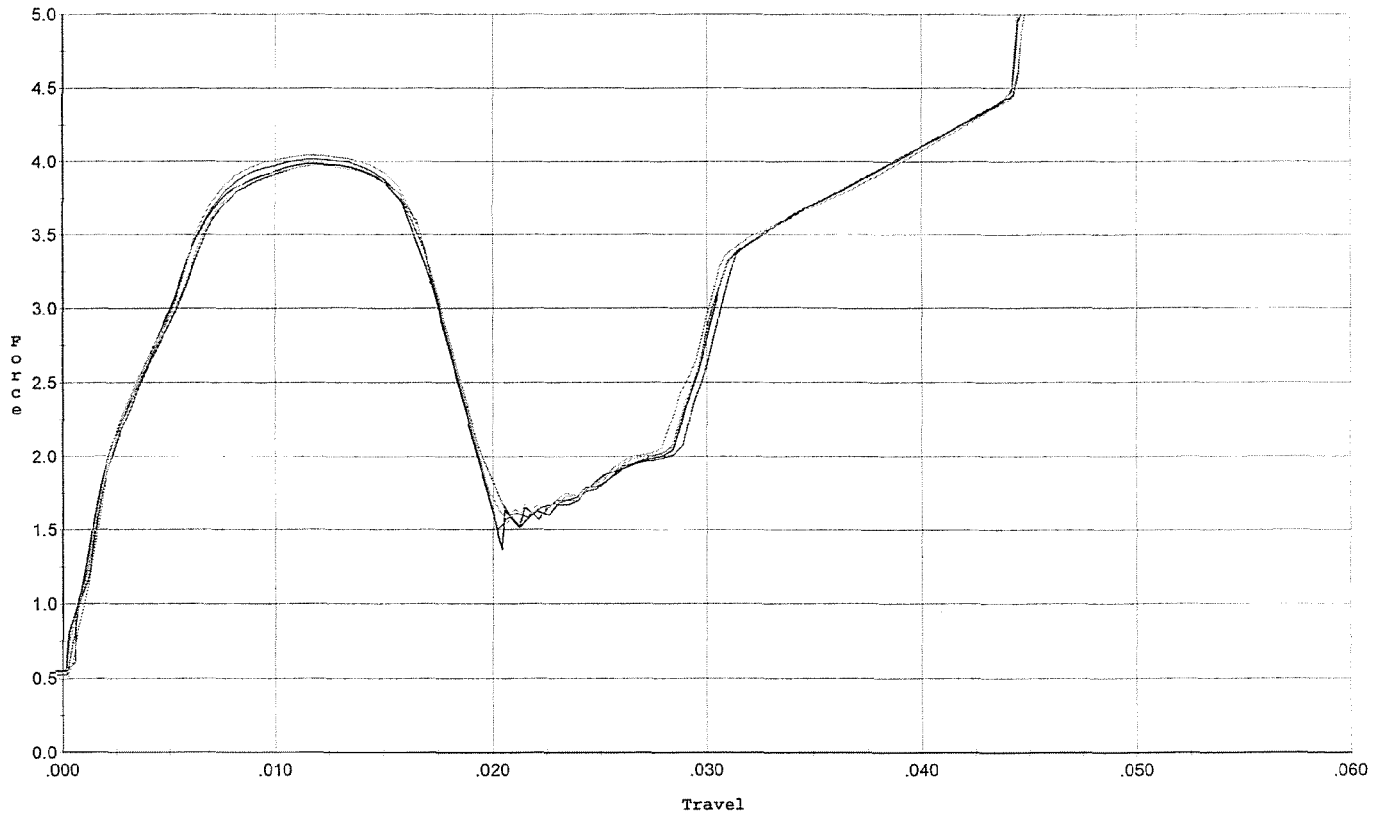
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.017	0.00	0.028	0.048		Set Trigger
2	3.984	0.017	0.00	0.028	0.049		Set Trigger
3	4.080	0.016	0.00	0.028	0.047		Set Trigger
4	4.122	0.016	0.00	0.028	0.049		Set Trigger
5	4.097	0.018	0.00	0.028	0.053		Set Trigger

A.4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



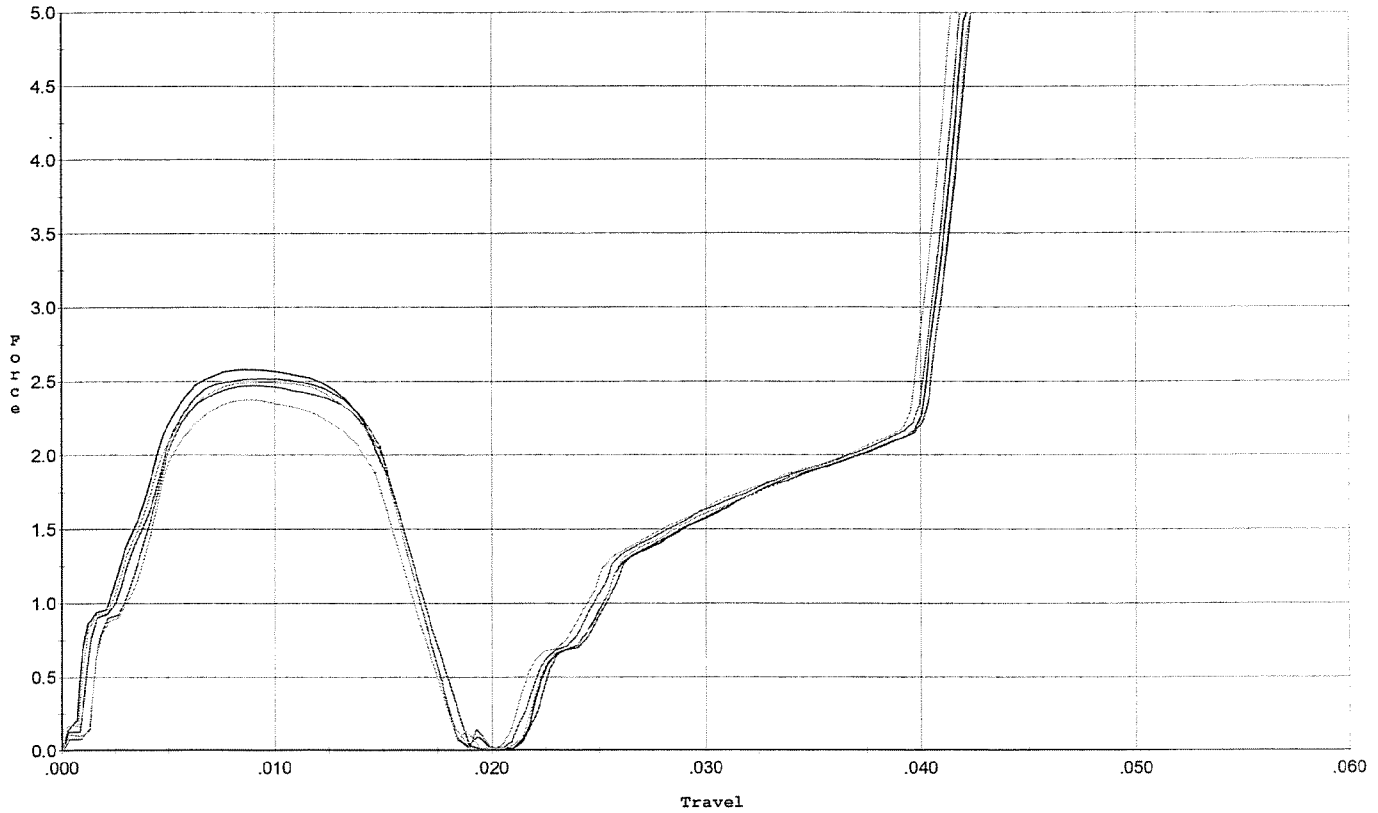
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.977	0.017	0.00	0.029	0.048		Set Trigger
2	3.984	0.017	0.00	0.029	0.050		Set Trigger
3	4.015	0.017	0.00	0.029	0.049		Set Trigger
4	3.976	0.017	0.00	0.029	0.048		Set Trigger
5	4.042	0.017	0.00	0.029	0.049		Set Trigger

A-399

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



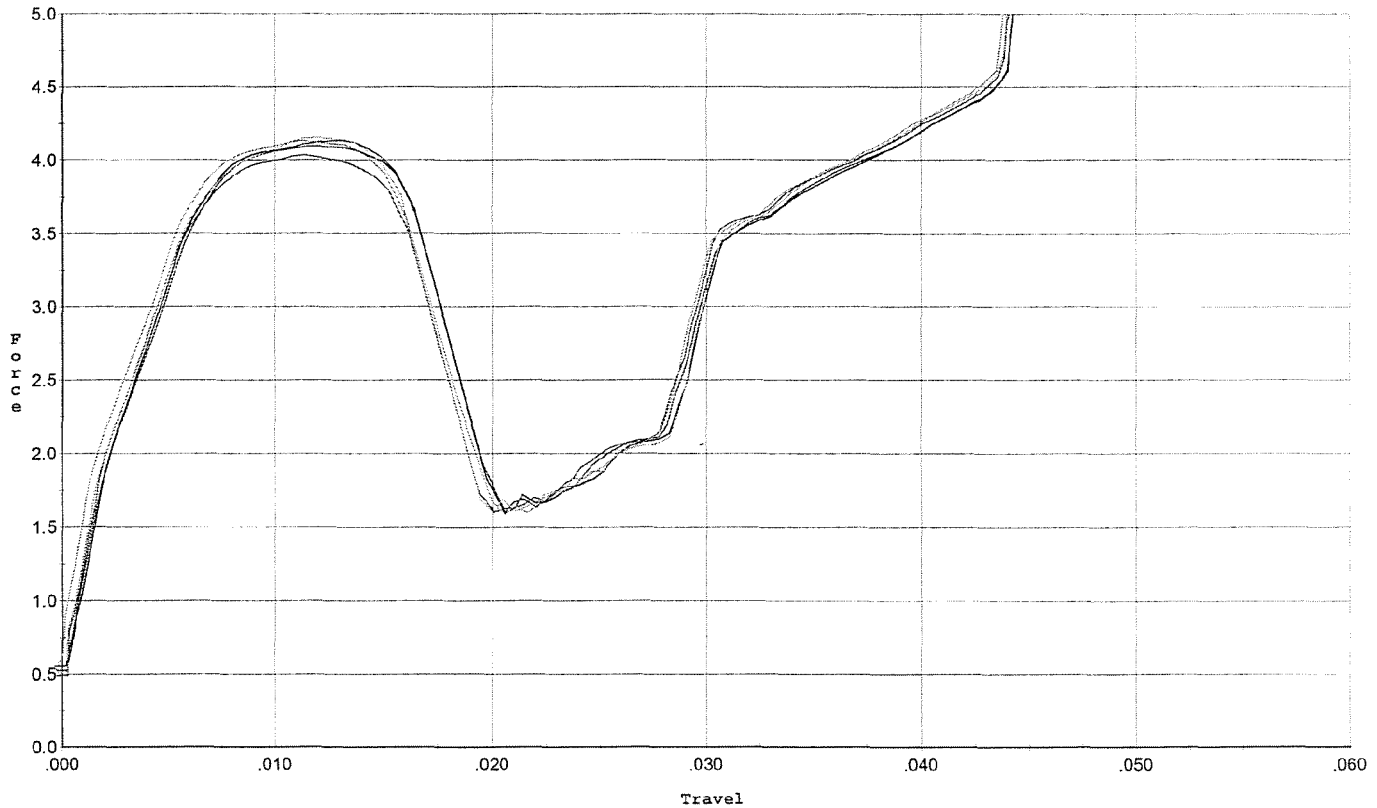
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.015	0.00	0.032	0.027		Set Trigger
2	2.580	0.015	0.00	0.031	0.028		Set Trigger
3	2.471	0.015	0.00	0.031	0.026		Set Trigger
4	2.496	0.015	0.00	0.032	0.028		Set Trigger
5	2.375	0.015	0.00	0.031	0.024		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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	4.131	0.016	0.00	0.028	0.049		Set Trigger
2	4.093	0.016	0.00	0.029	0.049		Set Trigger
3	4.033	0.016	0.00	0.029	0.048		Set Trigger
4	4.150	0.016	0.00	0.029	0.048		Set Trigger
5	4.128	0.016	0.00	0.028	0.049		Set Trigger

A-4.10