

G680 1367

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



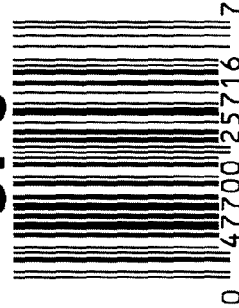
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801367

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

66801367

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RR
430	ASSEMBLE TO STOCK		3-6-09	RR
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RR
475	DRILL AND TAP SIGHT HOLES	MAR 10 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/13/09	(H)
490	MAGNAFLUX BOLT		3/13/09	mk
500	ROLLMARK CALIBER		3/13/09	RR
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	R. W.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

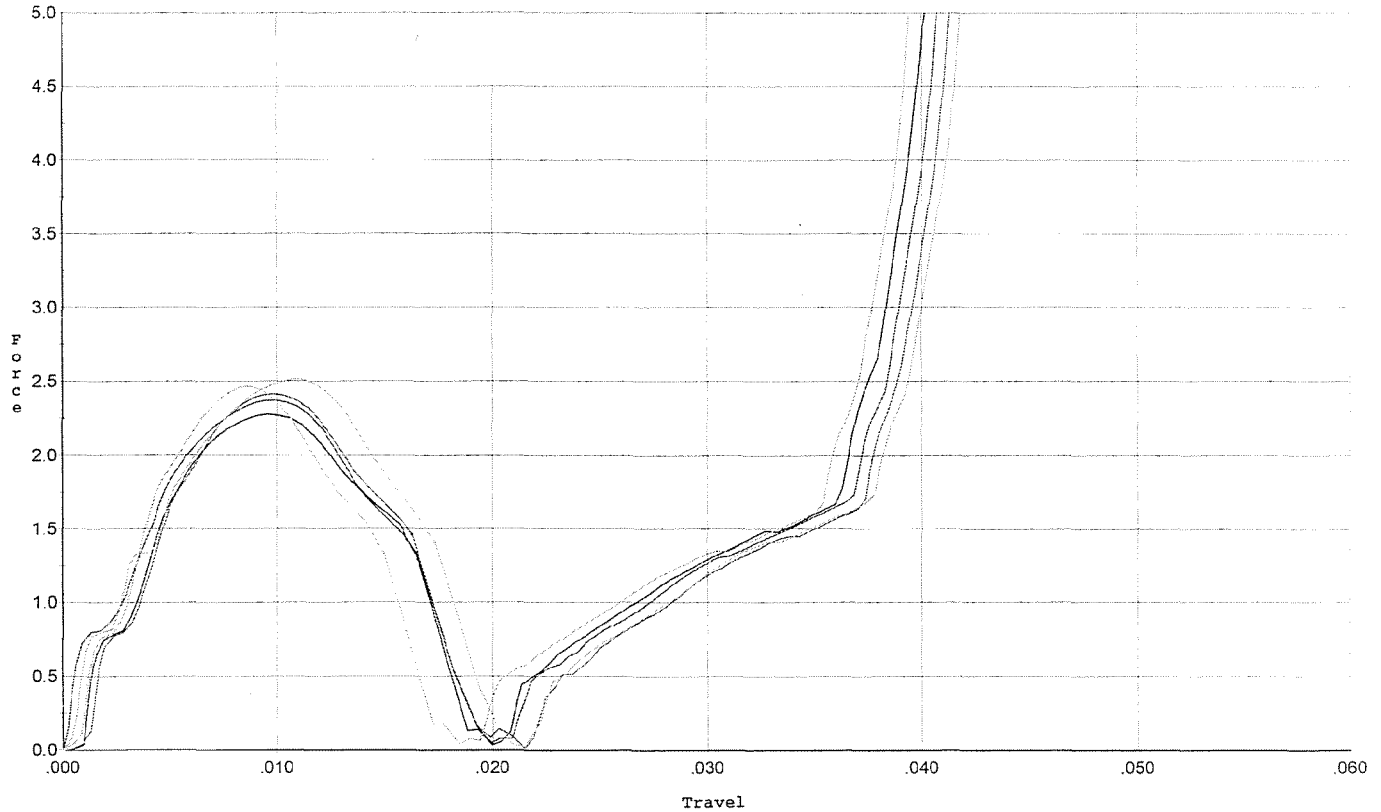
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-28-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	3-28-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-28-09	L.N.
	J) ASSEMBLE STOCK		3-28-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		3-28-09	L.N.
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	3-26-09	W.W.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-28-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.31</u> <u>2.31</u> <u>2.29</u> <u>2.32</u>	3-26-09	TL
	C) FUNCTION		3-28-09	L.N.
690	PACK		3-28-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



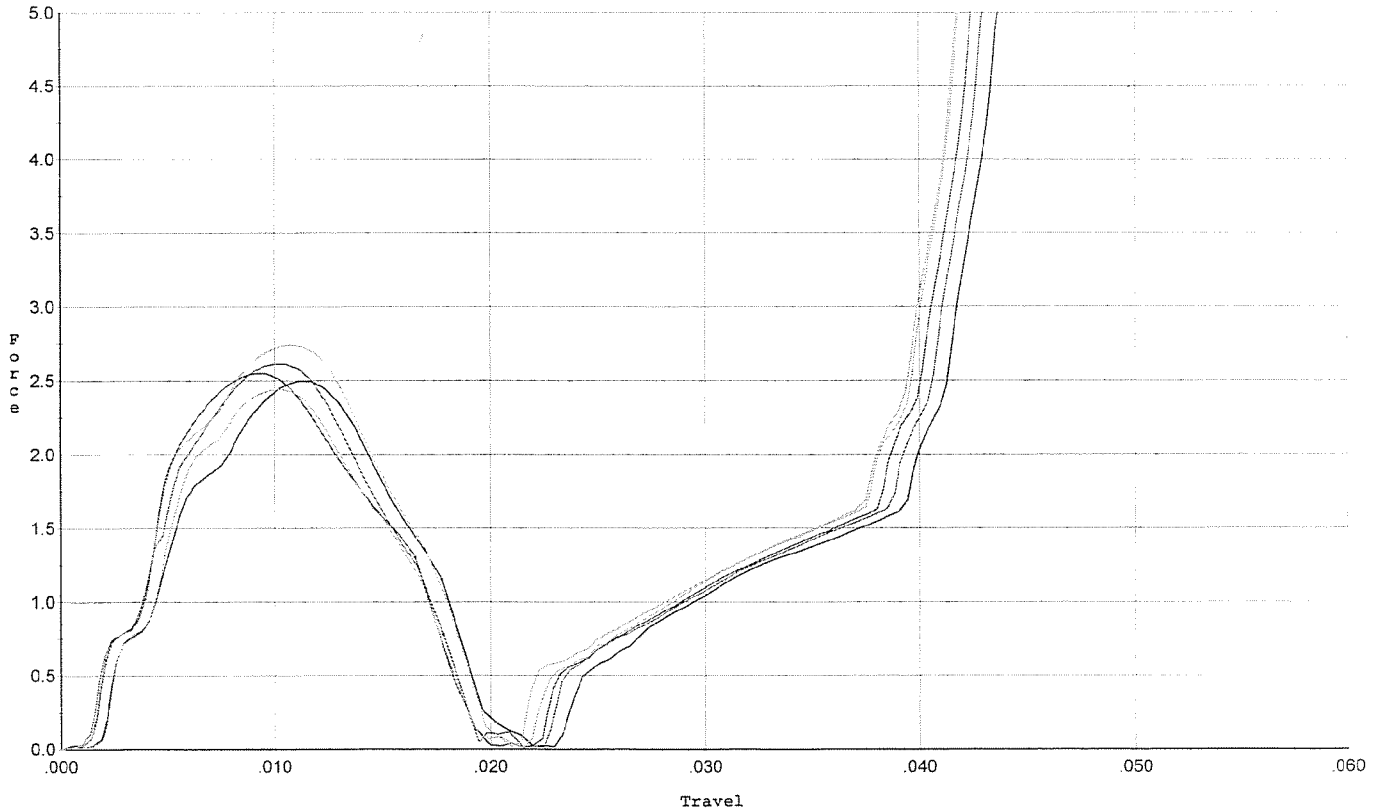
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.371	0.016	0.00	0.030	0.027		Set Trigger
2	2.277	0.017	0.00	0.030	0.025		Set Trigger
3	2.415	0.016	0.00	0.031	0.025		Set Trigger
4	2.512	0.017	0.00	0.030	0.029		Set Trigger
5	2.465	0.015	0.00	0.030	0.024		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



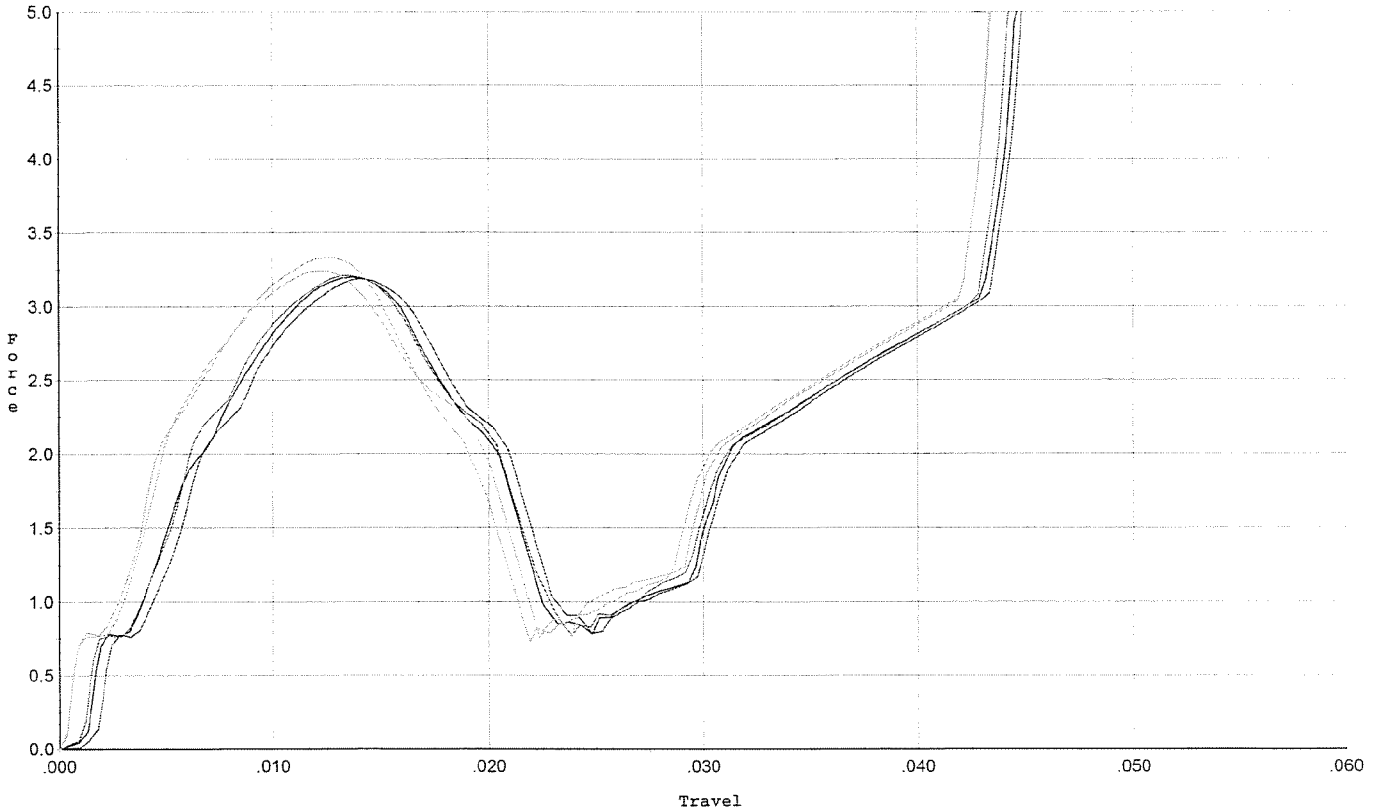
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.017	0.00	0.032	0.026		Set Trigger
2	2.498	0.018	0.00	0.032	0.026		Set Trigger
3	2.612	0.018	0.00	0.032	0.028		Set Trigger
4	2.740	0.018	0.00	0.030	0.030		Set Trigger
5	2.442	0.017	0.00	0.031	0.024		Set Trigger

A-2.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



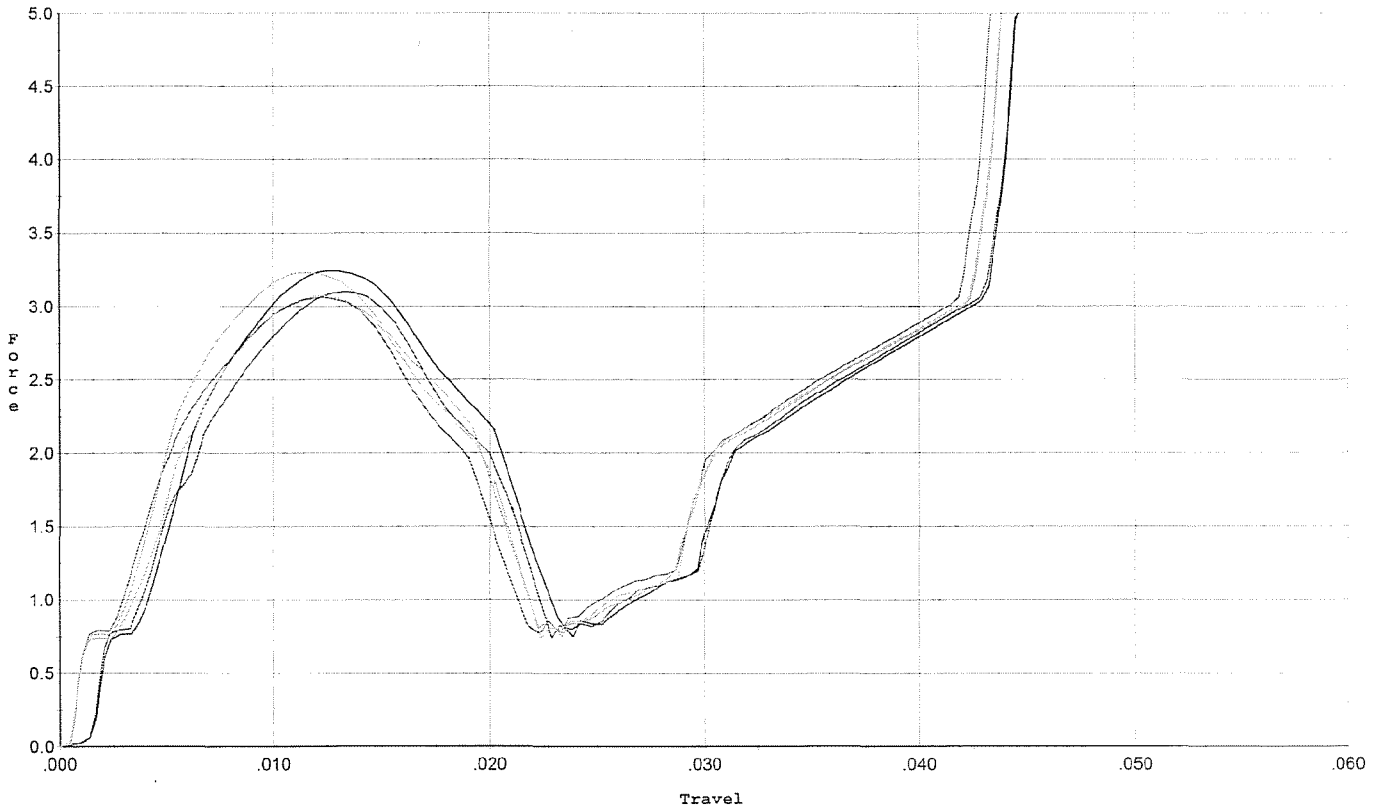
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.188	0.021	0.00	0.029	0.041		Set Trigger
2	3.197	0.020	0.00	0.029	0.041		Set Trigger
3	3.208	0.020	0.00	0.029	0.041		Set Trigger
4	3.242	0.020	0.00	0.029	0.043		Set Trigger
5	3.330	0.020	0.00	0.029	0.043		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



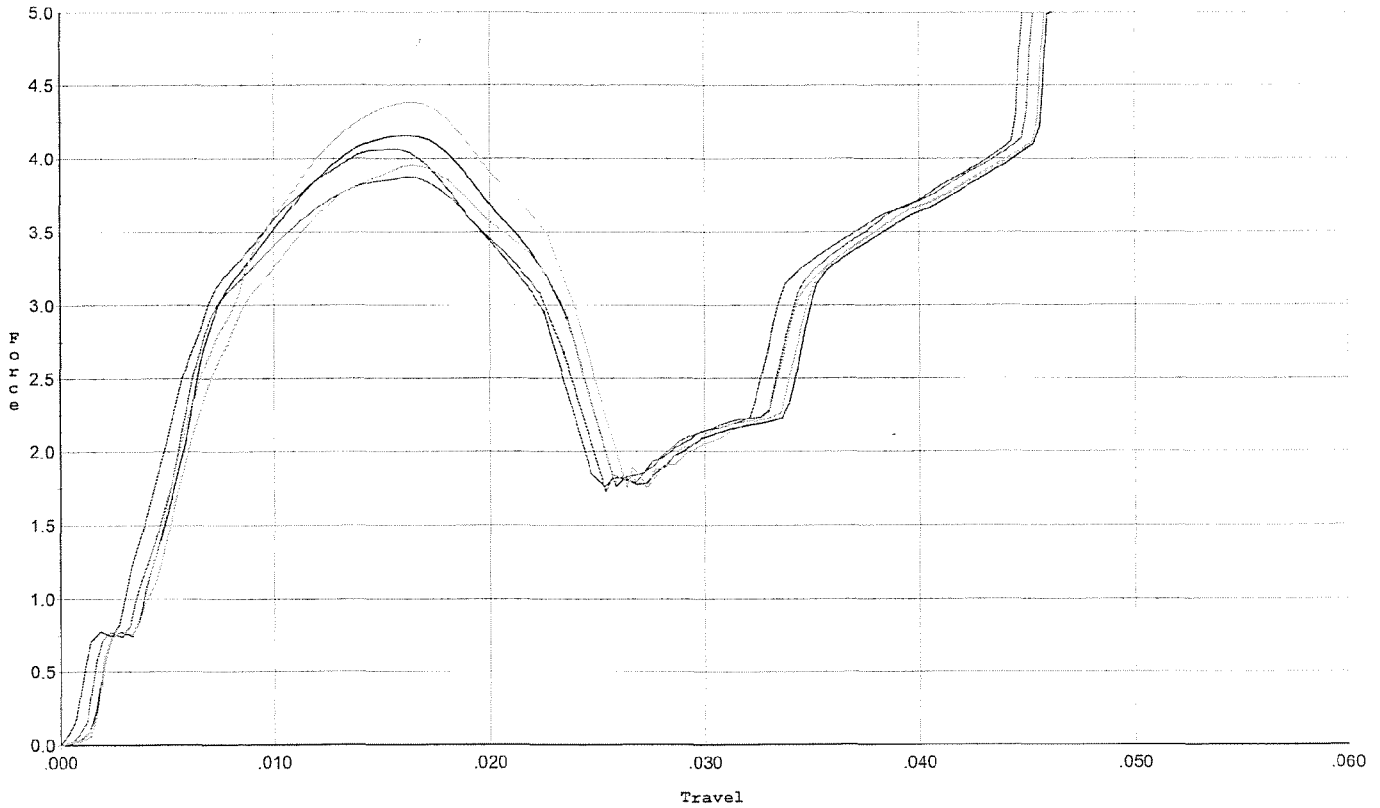
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.100	0.021	0.00	0.029	0.041		Set Trigger
2	3.243	0.020	0.00	0.029	0.042		Set Trigger
3	3.063	0.019	0.00	0.029	0.039		Set Trigger
4	3.074	0.020	0.00	0.029	0.041		Set Trigger
5	3.234	0.021	0.00	0.029	0.045		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



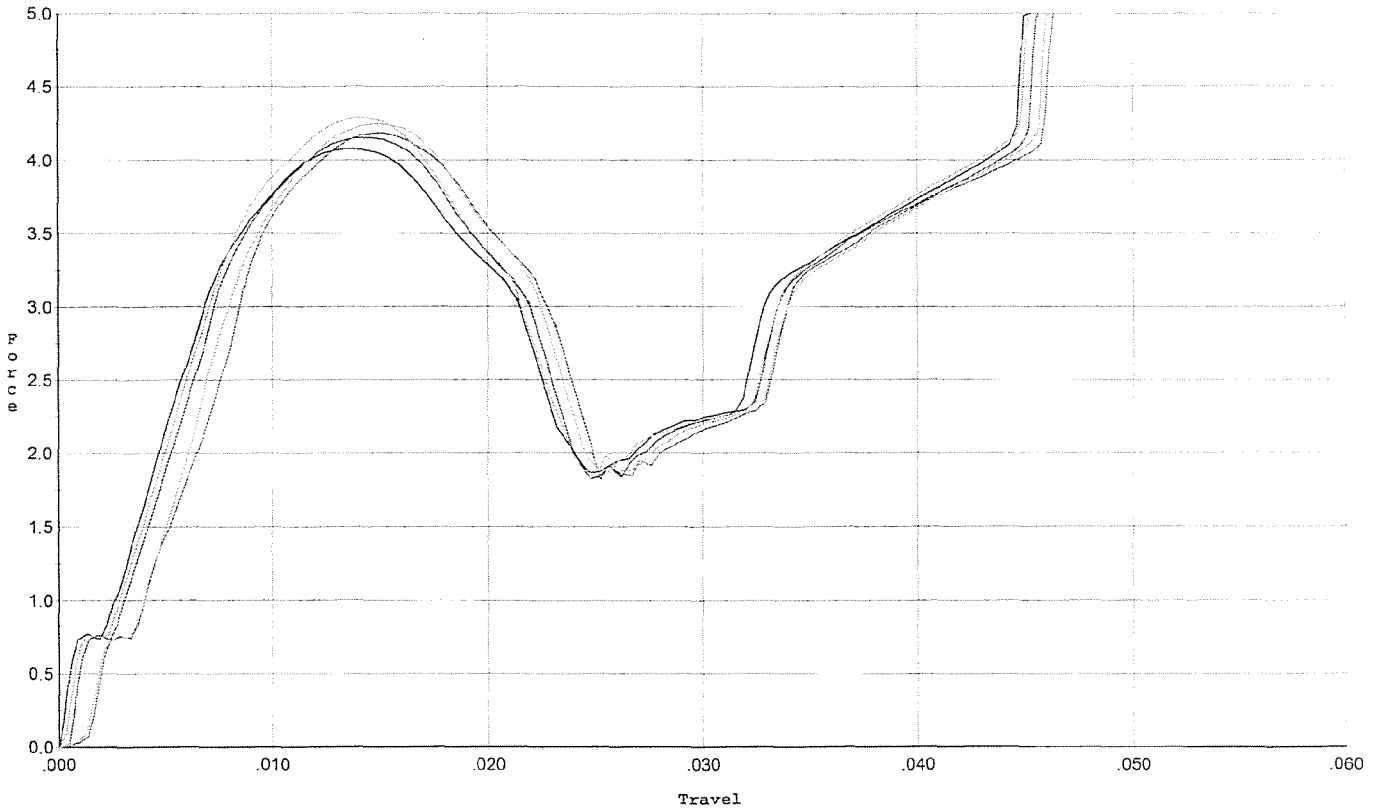
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.065	0.023	0.00	0.025	0.062		Set Trigger
2	4.158	0.024	0.00	0.023	0.064		Set Trigger
3	3.876	0.023	0.00	0.023	0.061		Set Trigger
4	4.383	0.024	0.00	0.021	0.067		Set Trigger
5	3.954	0.023	0.00	0.023	0.060		Set Trigger

A. 4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



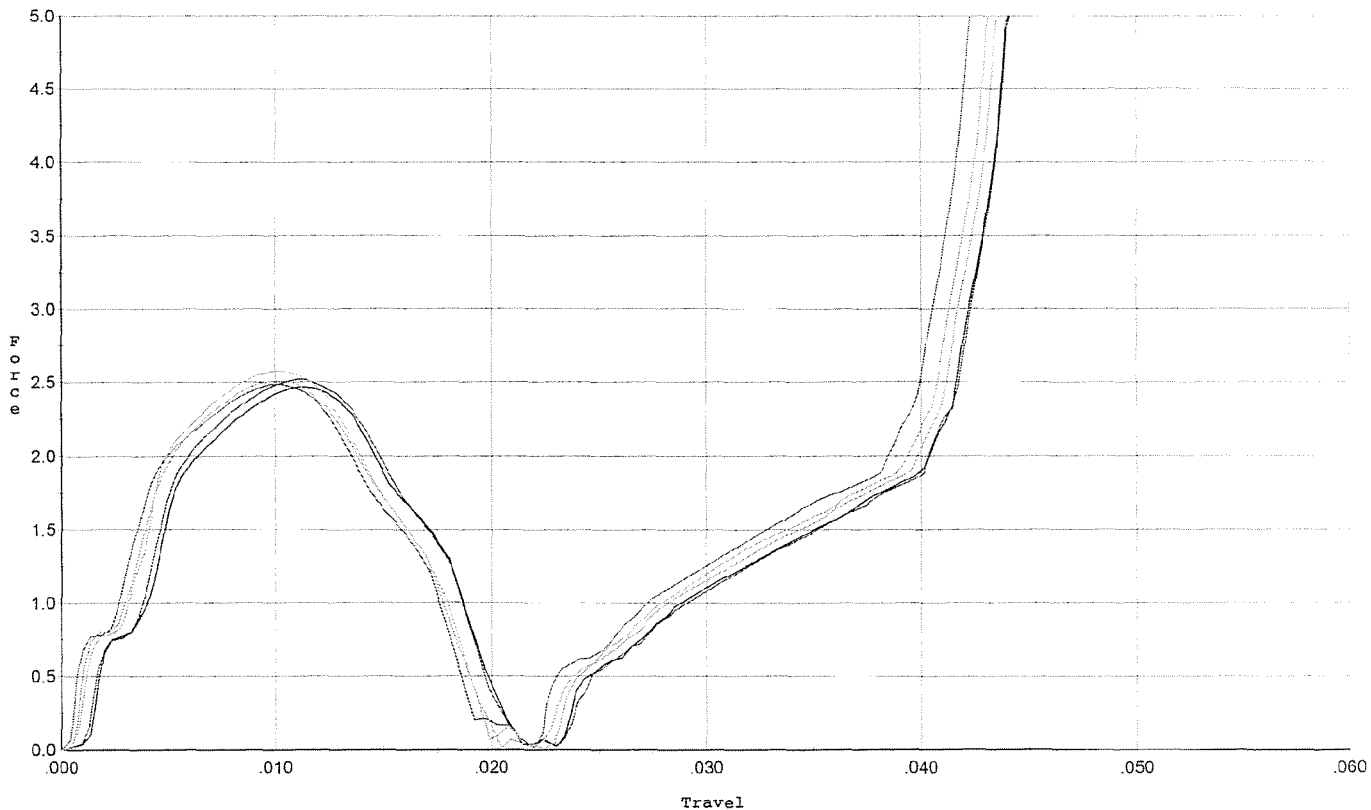
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.153	0.022	0.00	0.026	0.060		Set Trigger
2	4.075	0.021	0.00	0.026	0.059		Set Trigger
3	4.185	0.023	0.00	0.026	0.061		Set Trigger
4	4.247	0.022	0.00	0.026	0.060		Set Trigger
5	4.291	0.021	0.00	0.026	0.059		Set Trigger

A.419

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



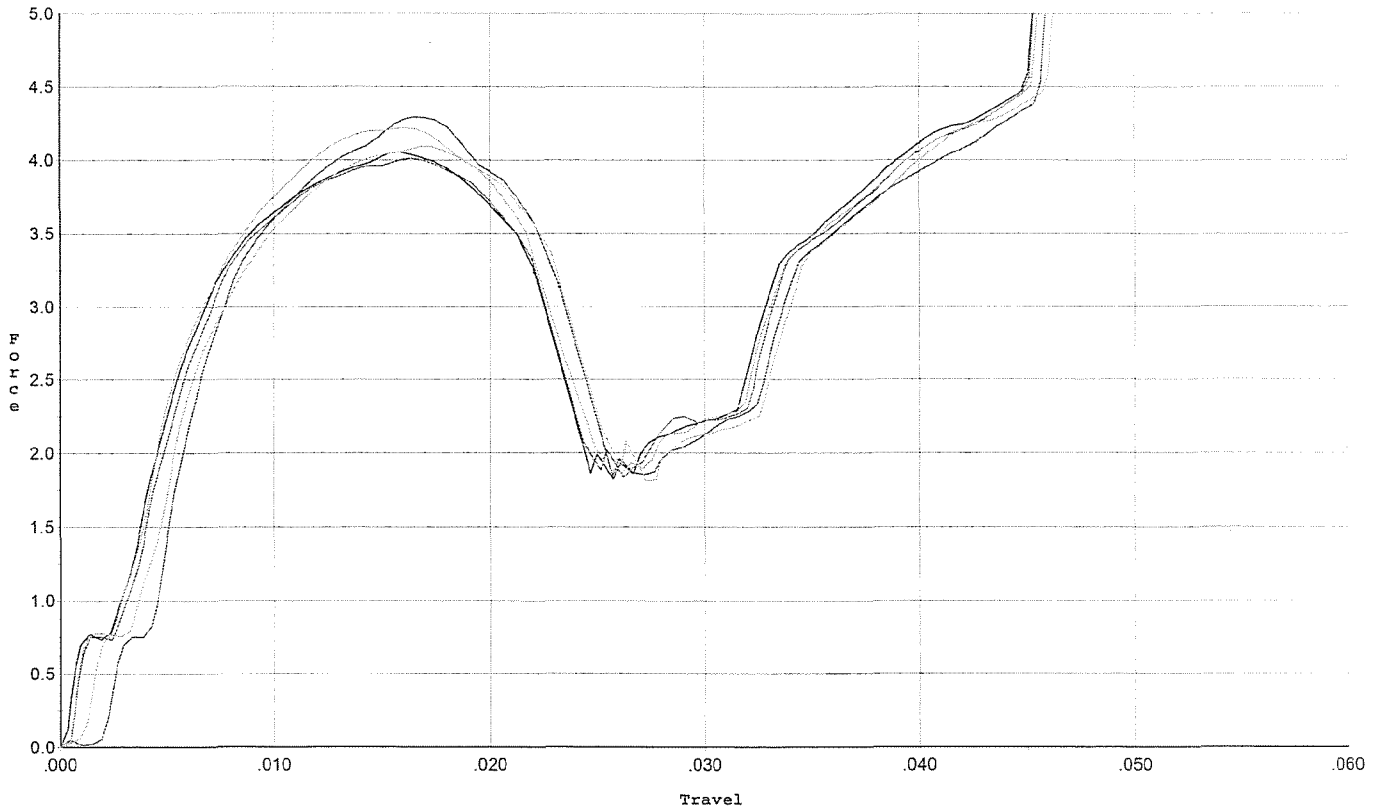
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.018	0.00	0.032	0.030		Set Trigger
2	2.467	0.018	0.00	0.032	0.029		Set Trigger
3	2.485	0.017	0.00	0.031	0.029		Set Trigger
4	2.577	0.017	0.00	0.032	0.029		Set Trigger
5	2.509	0.018	0.00	0.032	0.030		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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	4.294	0.023	0.002	0.022	0.064		Set Trigger
2	4.054	0.022	0.00	0.025	0.062		Set Trigger
3	4.012	0.022	0.003	0.025	0.061		Set Trigger
4	4.093	0.023	0.00	0.023	0.063		Set Trigger
5	4.221	0.022	0.003	0.026	0.063		Set Trigger

A-4.13