

G6861372

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



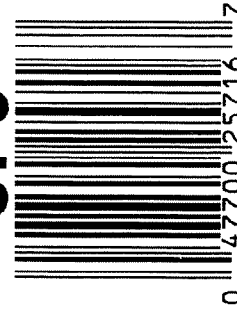
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801372

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6801372

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE	MAGNA-FLUX	3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-9-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-9-09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TR
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

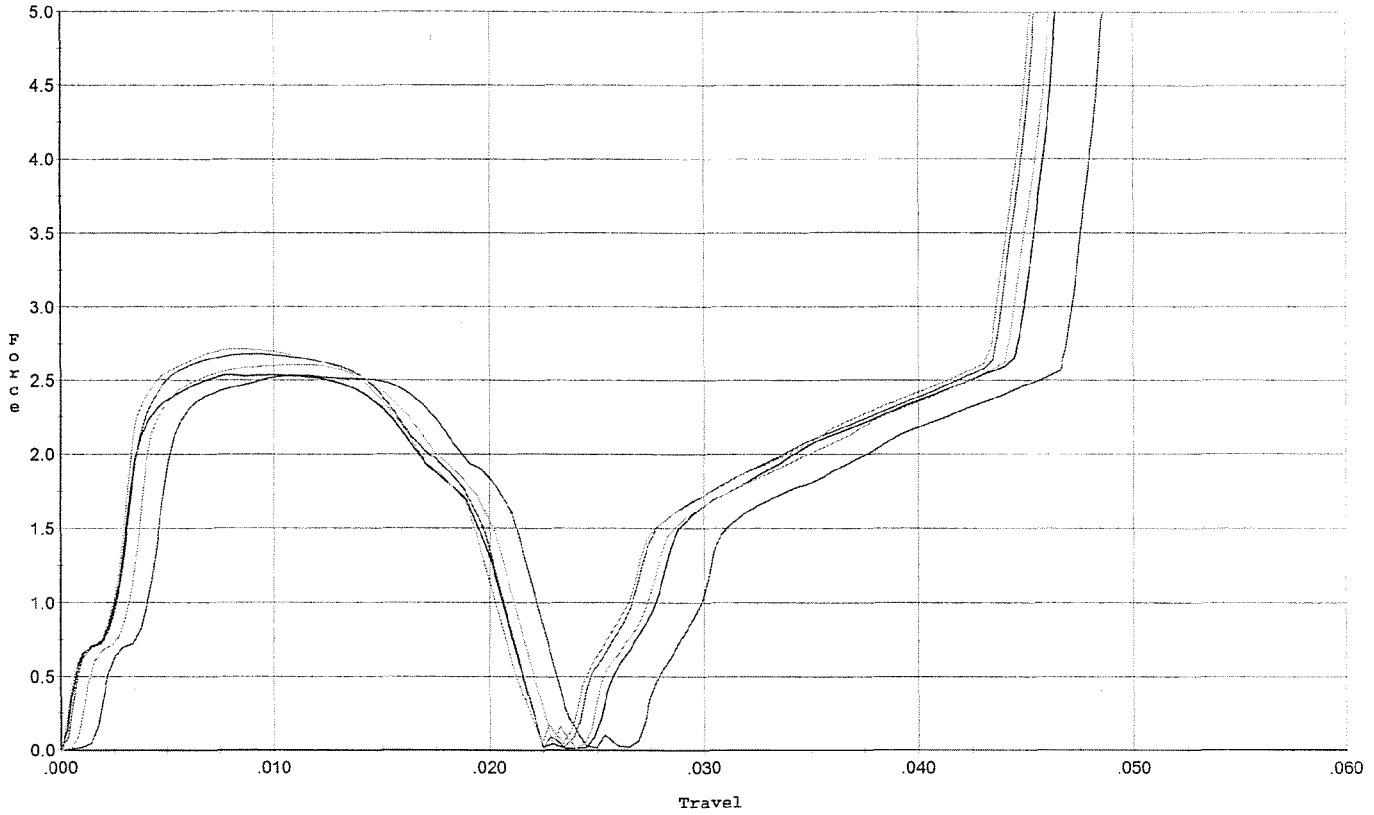
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>4</u> <u>4</u>	3-31-09	W W
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3.5</u>	3-31-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	3-31-09	W W
	J) ASSEMBLE STOCK		3-27-09	LLD
	K) ASSEMBLE SWIVEL STUDS		3-31-09	W W
	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	3-30-09	LLD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	R P
670	FINAL INSPECTION A) HEADSPACE		3-31-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.63</u> <u>2.59</u> <u>2.53</u> <u>2.49</u>	3-31-09	W W
	C) FUNCTION		3-31-09	W W
690	PACK		5-29-01	W W

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



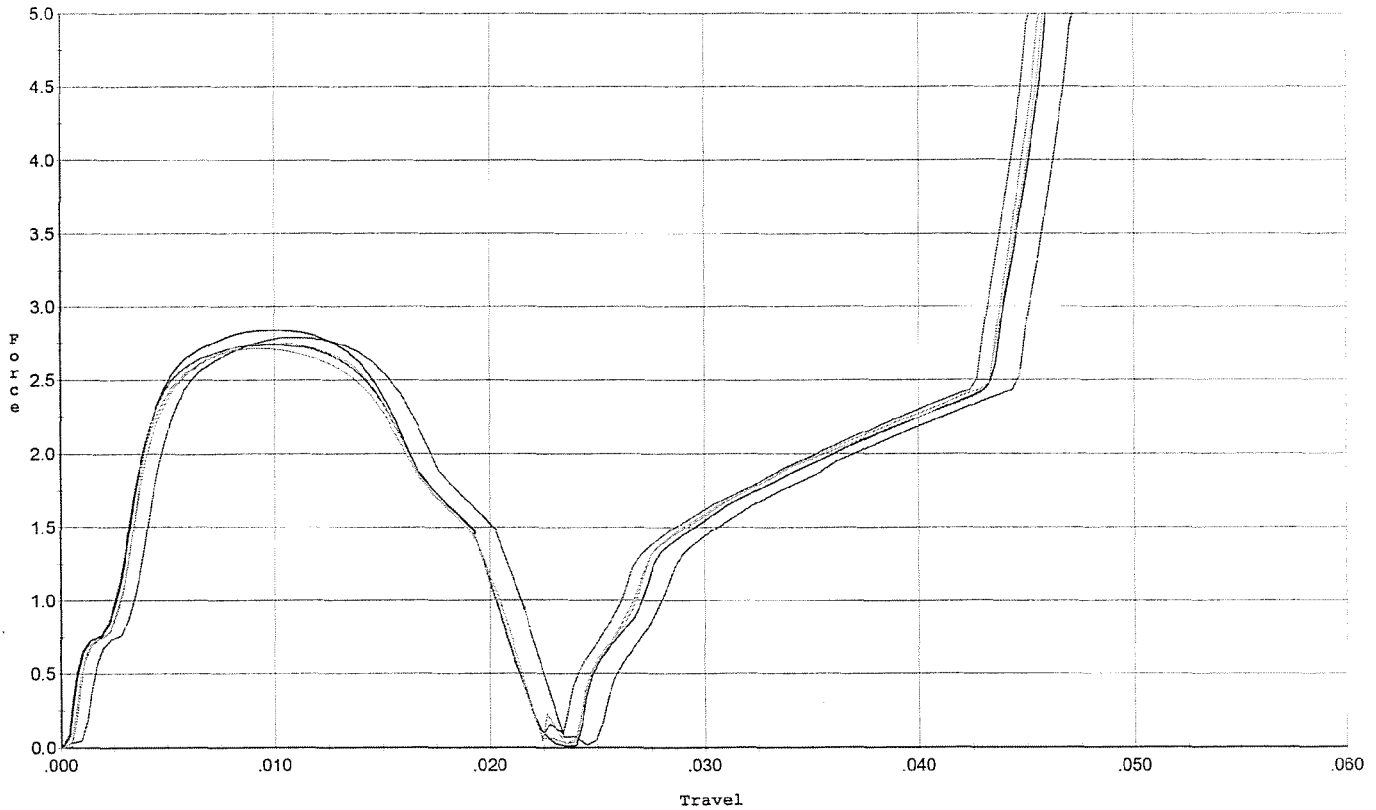
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.021	0.00	0.032	0.038		Set Trigger
2	2.535	0.020	0.00	0.031	0.038		Set Trigger
3	2.680	0.020	0.00	0.030	0.039		Set Trigger
4	2.607	0.020	0.00	0.031	0.039		Set Trigger
5	2.714	0.019	0.00	0.031	0.038		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



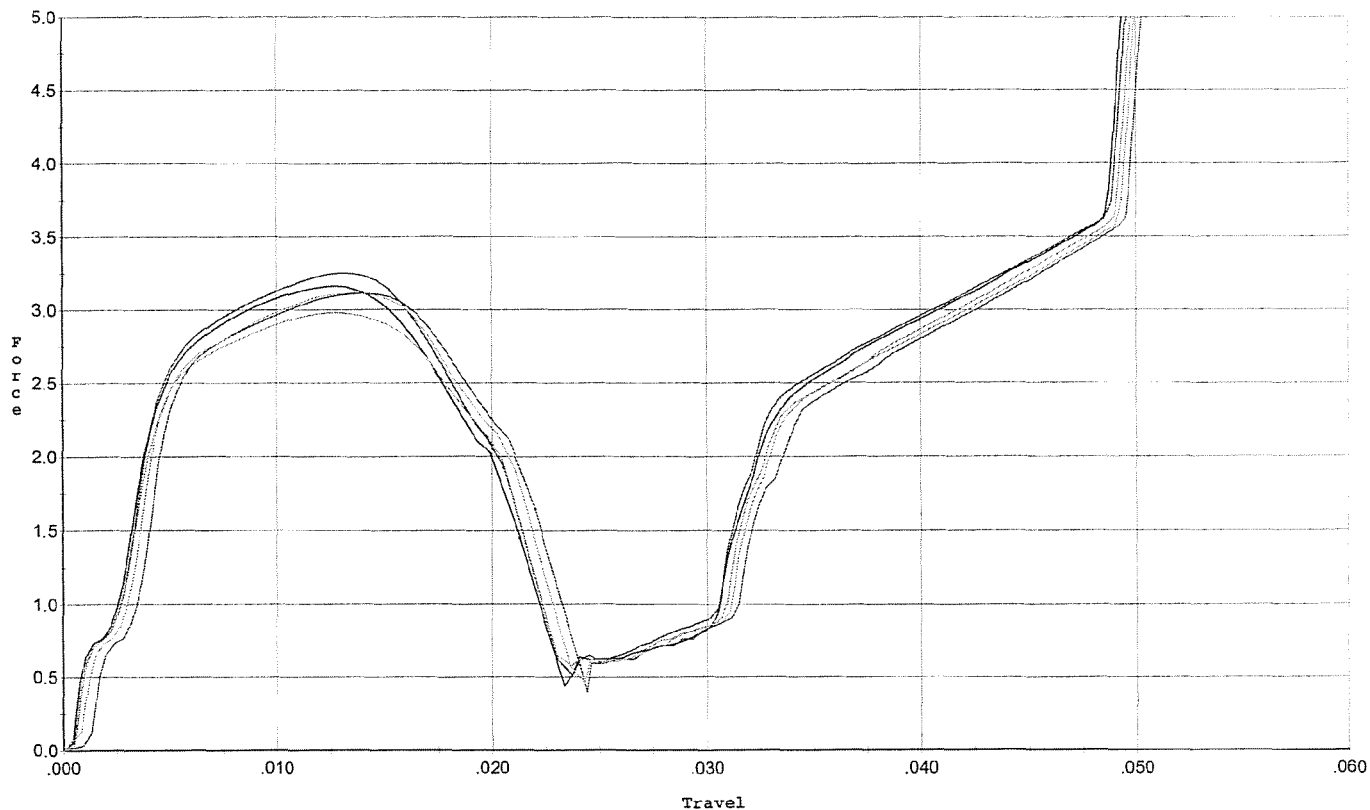
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.788	0.022	0.00	0.032	0.041		Set Trigger
2	2.839	0.019	0.00	0.032	0.039		Set Trigger
3	2.740	0.019	0.00	0.031	0.038		Set Trigger
4	2.747	0.021	0.00	0.031	0.039		Set Trigger
5	2.713	0.019	0.00	0.031	0.037		Set Trigger

A-2.76

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



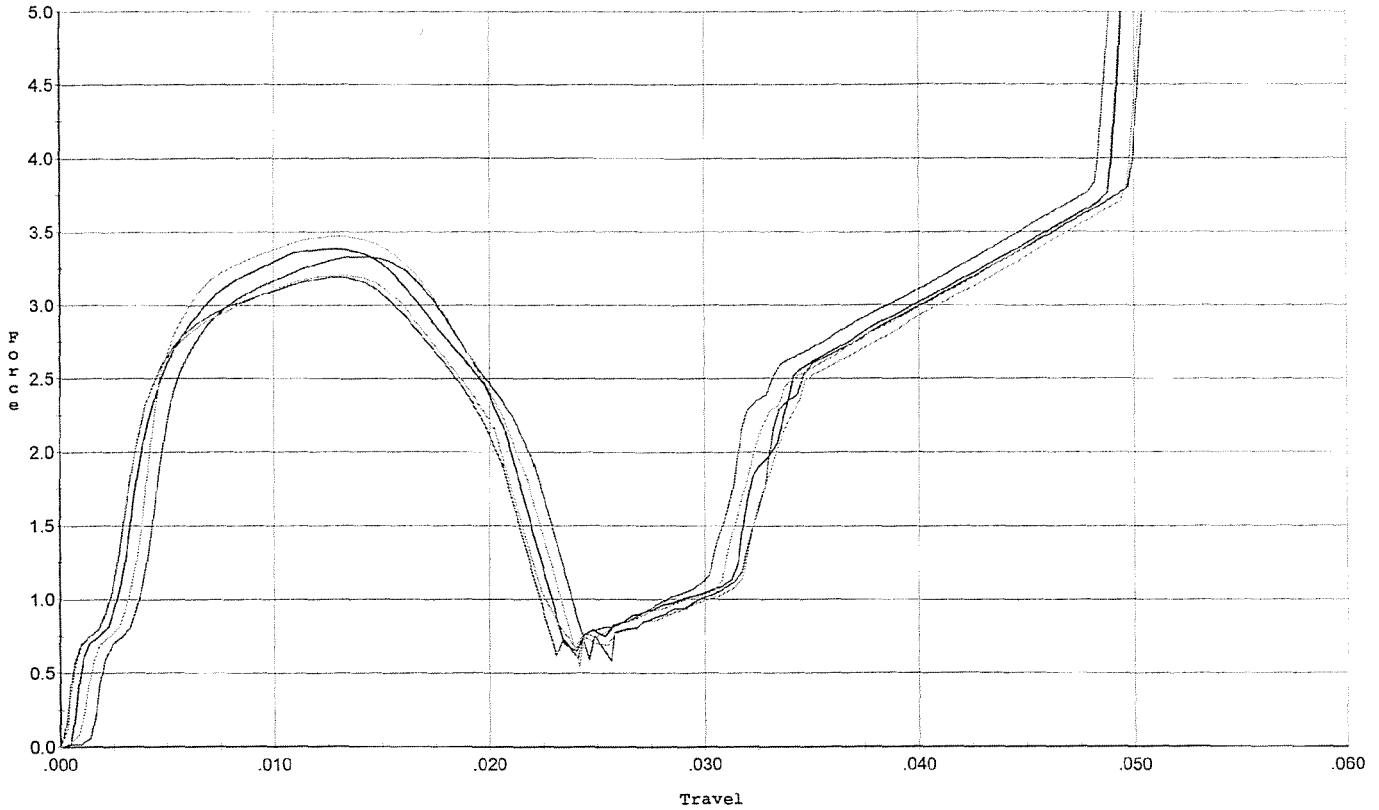
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.251	0.021	0.00	0.033	0.047		Set Trigger
2	3.162	0.021	0.00	0.032	0.048		Set Trigger
3	3.112	0.022	0.00	0.033	0.048		Set Trigger
4	3.117	0.021	0.00	0.033	0.047		Set Trigger
5	2.980	0.020	0.00	0.033	0.045		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



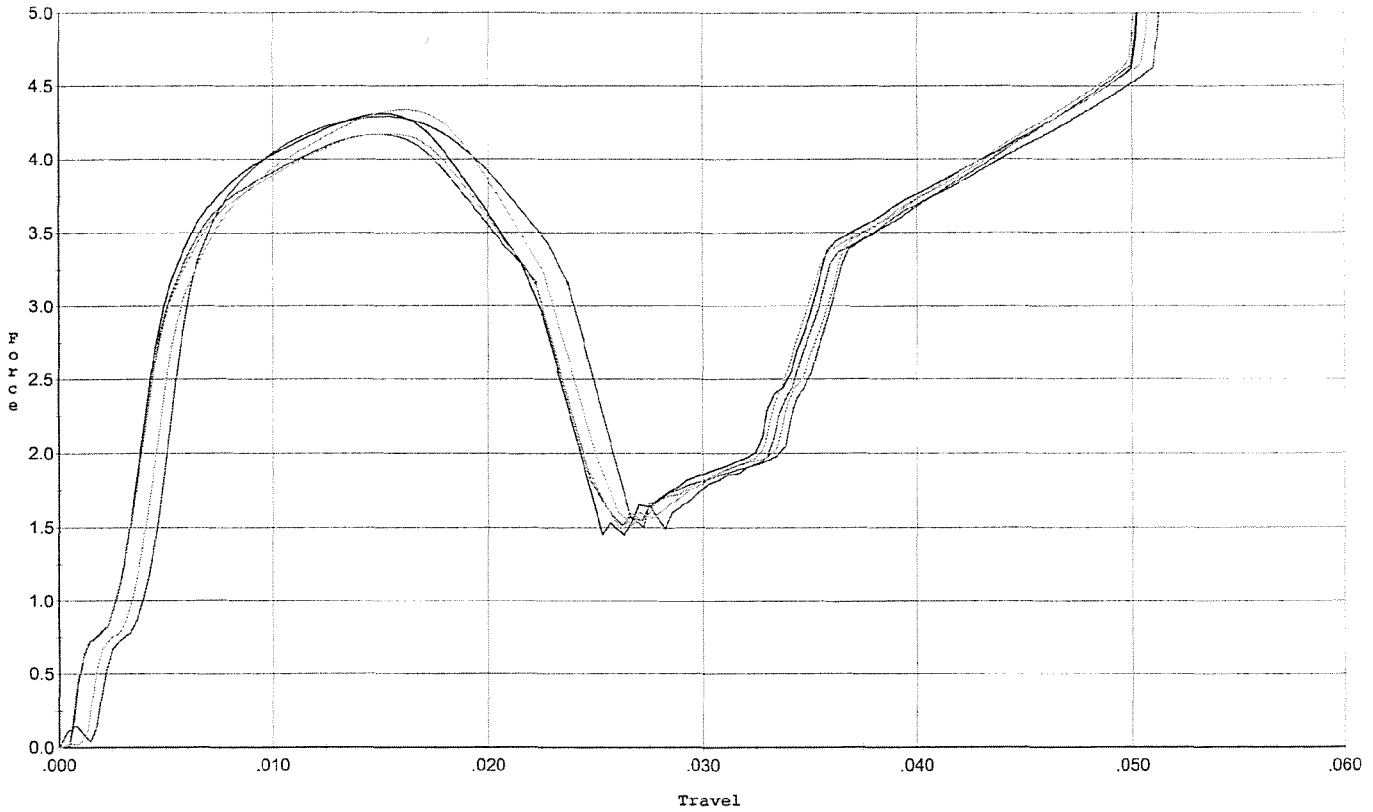
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.022	0.00	0.033	0.050		Set Trigger
2	3.388	0.021	0.00	0.033	0.050		Set Trigger
3	3.192	0.021	0.00	0.032	0.048		Set Trigger
4	3.473	0.022	0.00	0.033	0.053		Set Trigger
5	3.207	0.020	0.00	0.032	0.048		Set Trigger

A-3-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



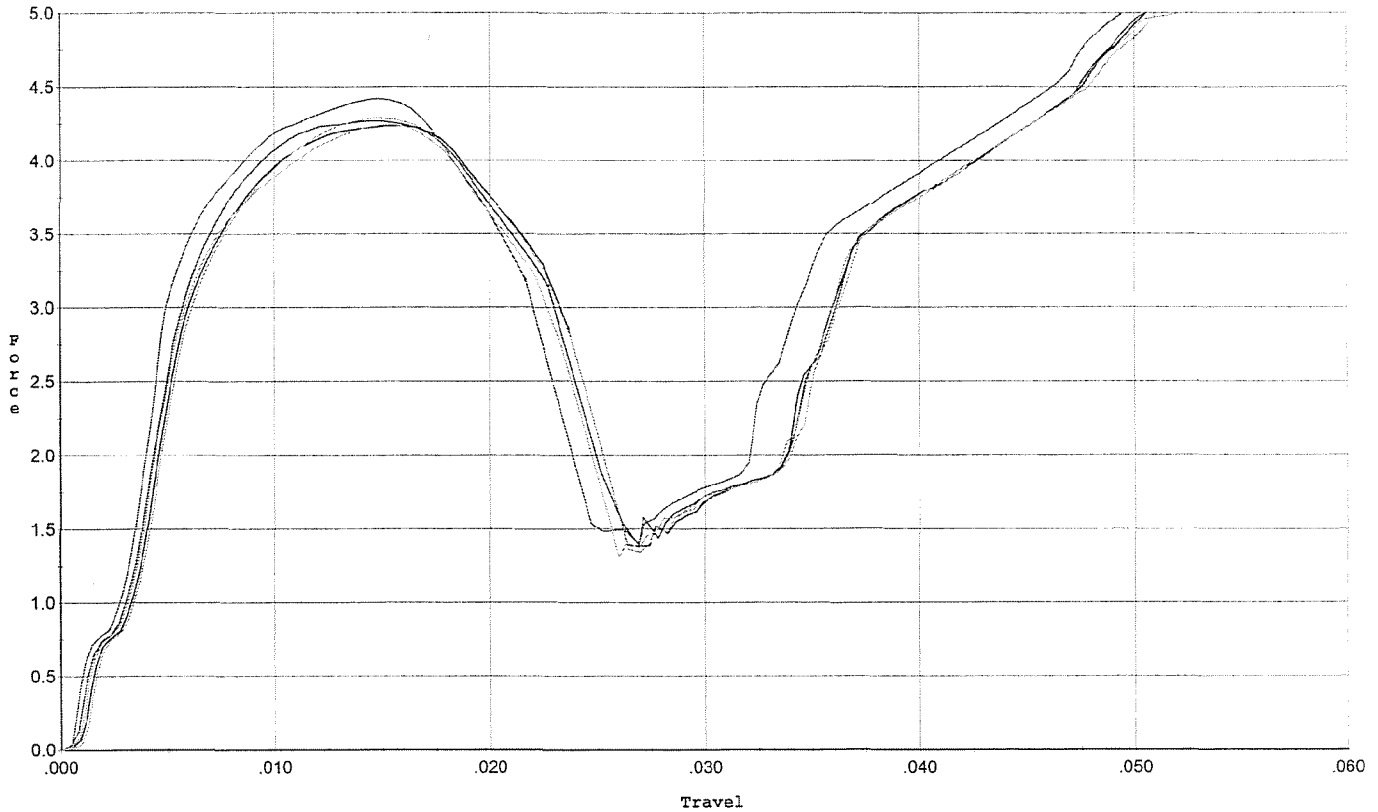
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.024	0.00	0.030	0.070		Set Trigger
2	4.310	0.023	0.00	0.030	0.068		Set Trigger
3	4.173	0.022	0.00	0.030	0.066		Set Trigger
4	4.336	0.023	0.00	0.030	0.067		Set Trigger
5	4.175	0.022	0.00	0.030	0.066		Set Trigger

A. 4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



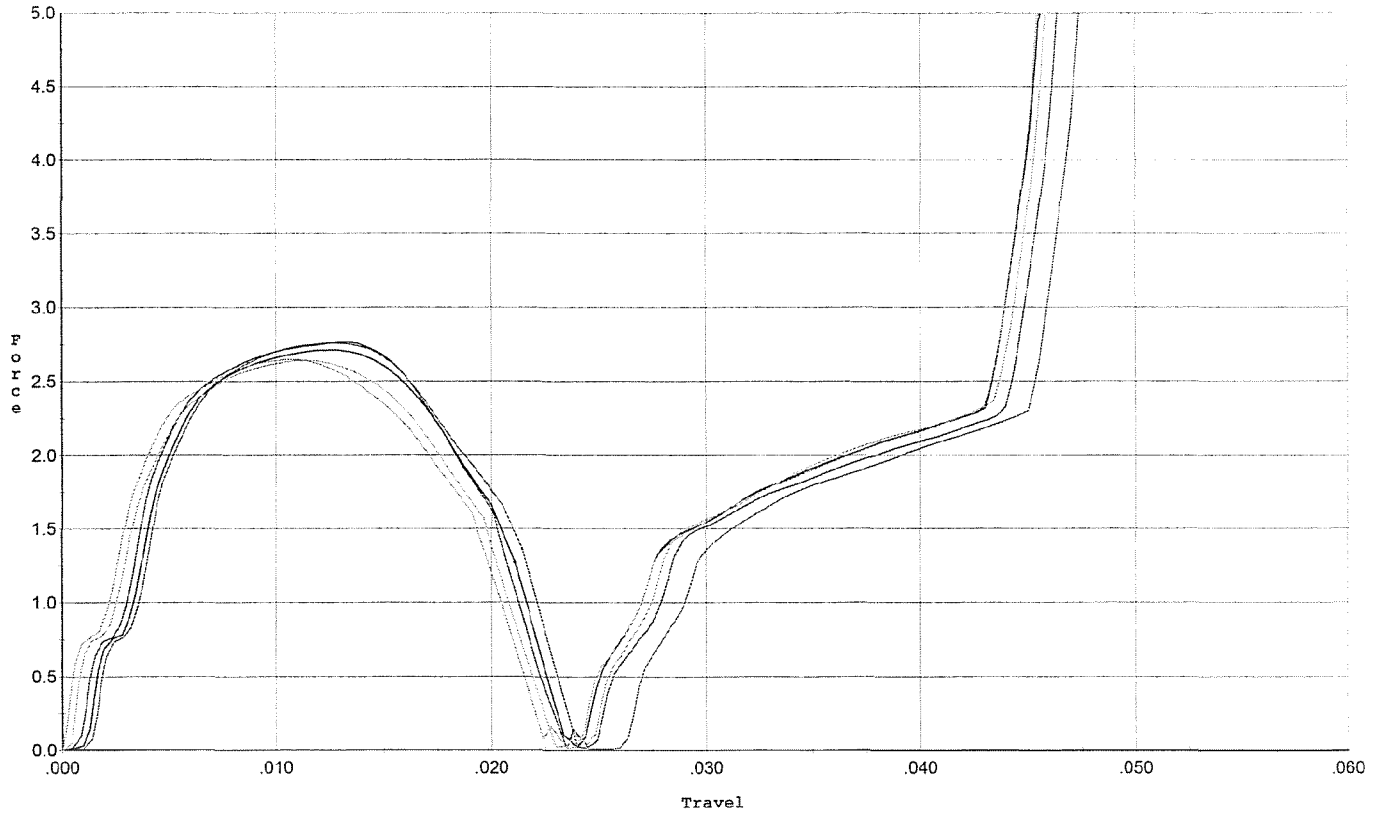
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.268	0.023	0.00	0.031	0.068		Set Trigger
2	4.234	0.024	0.00	0.030	0.069		Set Trigger
3	4.420	0.022	0.00	0.031	0.066		Set Trigger
4	4.242	0.023	0.00	0.031	0.068		Set Trigger
5	4.287	0.024	0.00	0.031	0.069		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



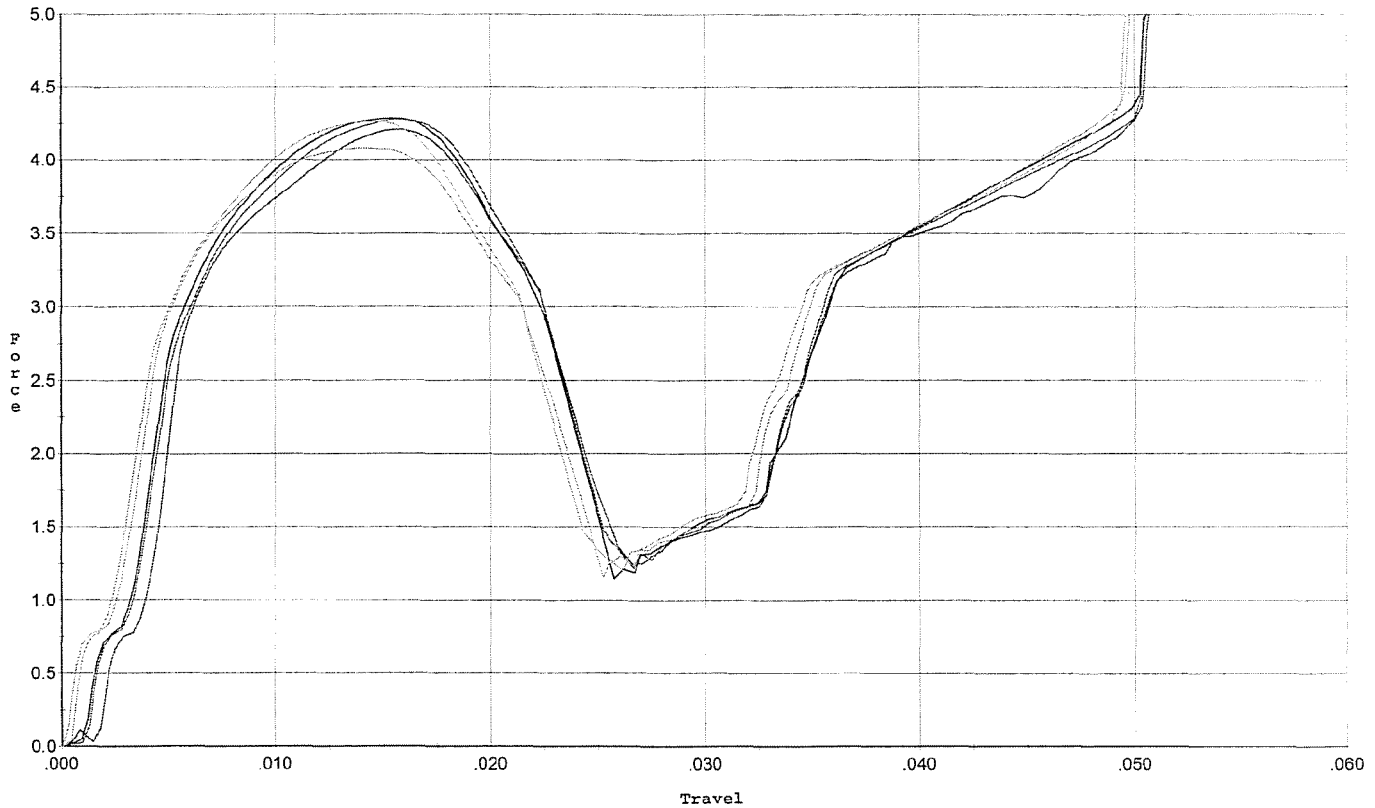
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.766	0.020	0.00	0.031	0.040		Set Trigger
2	2.710	0.021	0.00	0.030	0.040		Set Trigger
3	2.758	0.021	0.00	0.031	0.041		Set Trigger
4	2.644	0.020	0.00	0.031	0.038		Set Trigger
5	2.647	0.021	0.00	0.031	0.040		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for final test



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.022	0.00	0.031	0.062		Set Trigger
2	4.285	0.023	0.00	0.031	0.066		Set Trigger
3	4.278	0.022	0.00	0.031	0.064		Set Trigger
4	4.264	0.021	0.00	0.031	0.064		Set Trigger
5	4.079	0.023	0.00	0.031	0.066		Set Trigger

A-4.22