

66801374

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



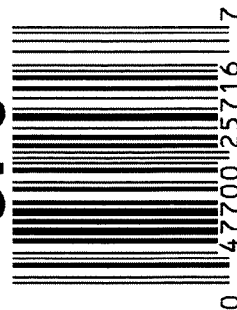
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801374

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6801374

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE		3-6-09	RT
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION	(H)	3-9-09	(H)
490	MAGNAFLUX BOLT		3-9-09	MR
500	ROLLMARK CALIBER		3-9-09	RT
520	GOFF BLAST BBL / REC		3-11	RT
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

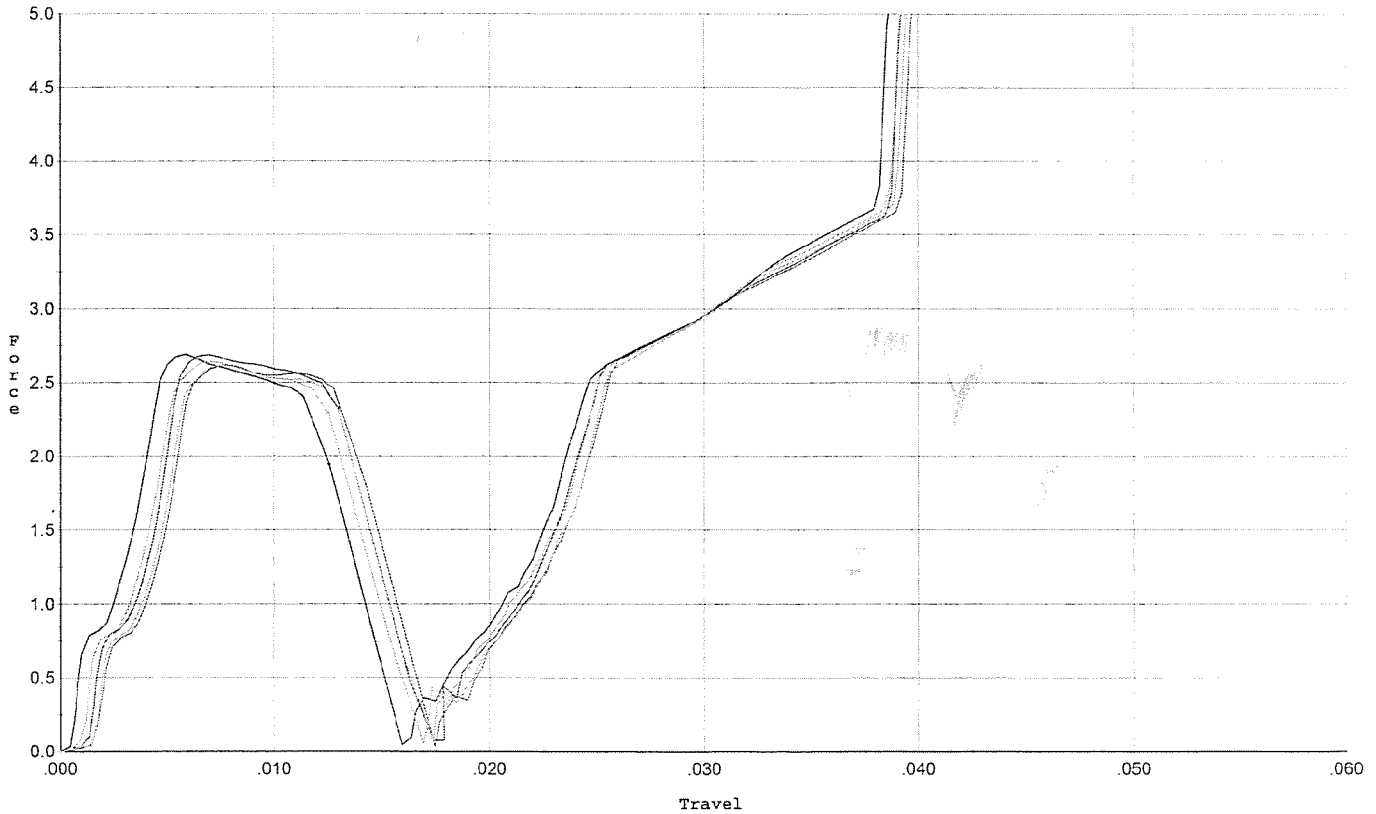
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-25-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-25-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-25-09	WW
	J) ASSEMBLE STOCK		3-23-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WW
	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	3-24-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WW
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.37</u> <u>2.43</u> <u>2.47</u> <u>2.36</u>	3-24-09	TL
	C) FUNCTION		3-25-09	WW
690	PACK		3/27/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



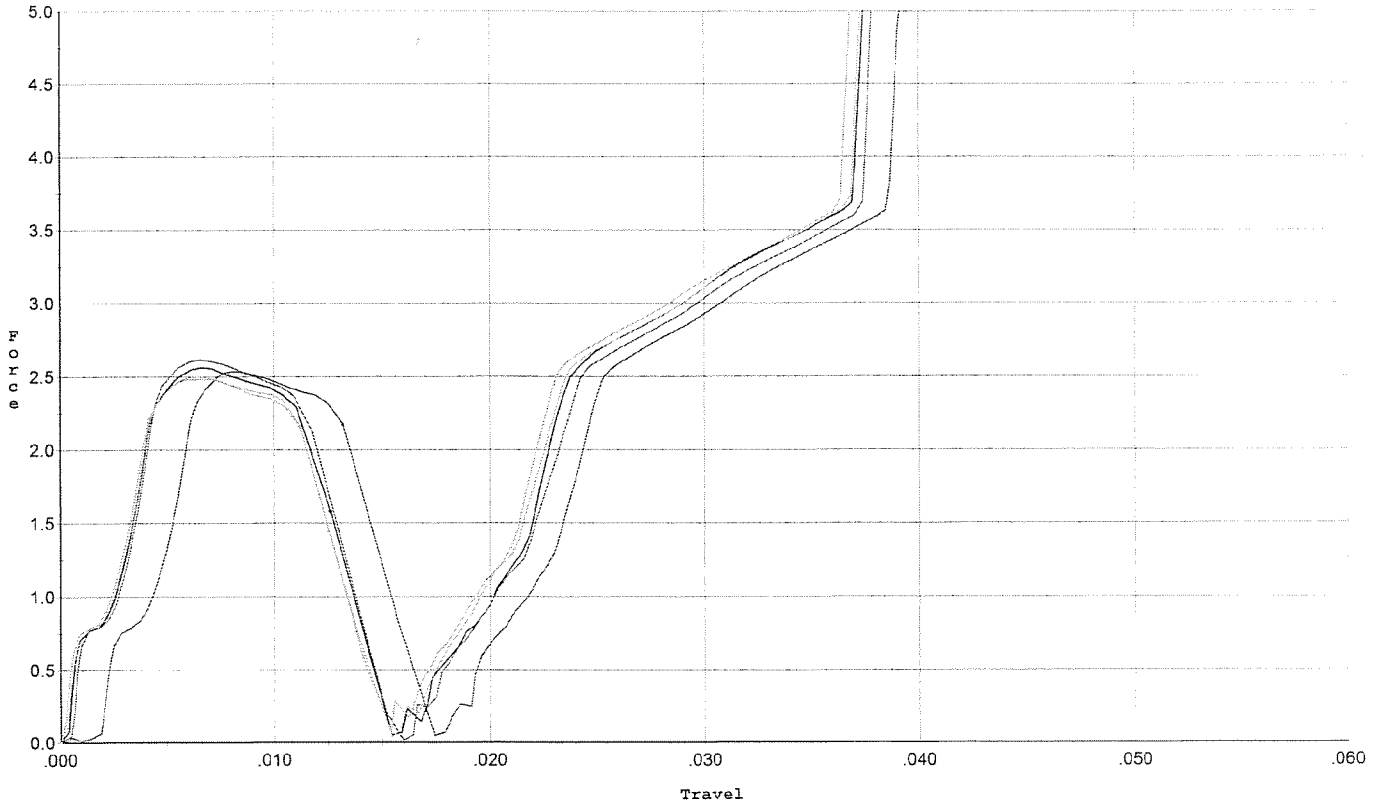
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.013	0.00	0.028	0.023		Set Trigger
2	2.691	0.013	0.00	0.029	0.023		Set Trigger
3	2.618	0.014	0.00	0.028	0.024		Set Trigger
4	2.615	0.013	0.00	0.028	0.022		Set Trigger
5	2.644	0.013	0.00	0.029	0.022		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



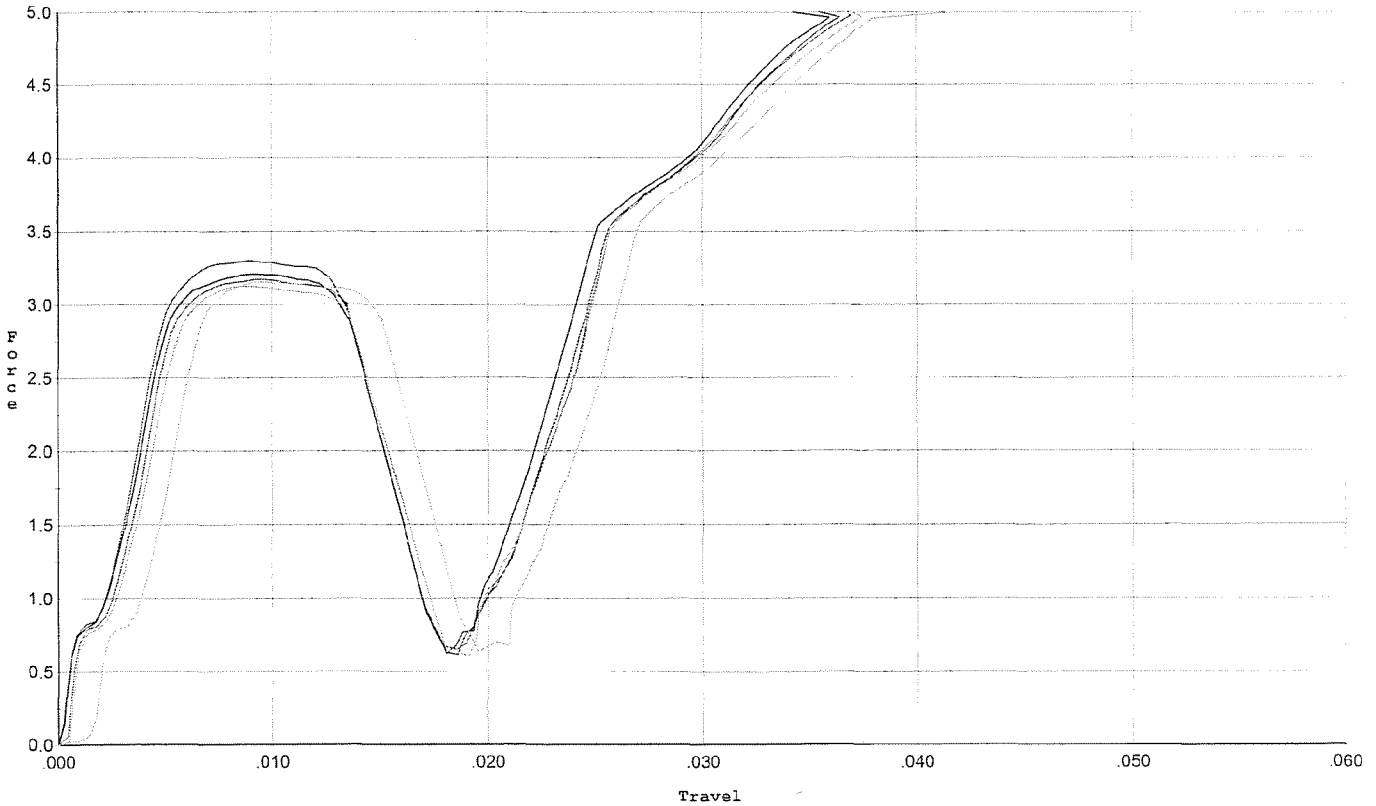
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.013	0.00	0.028	0.021		Set Trigger
2	2.561	0.013	0.00	0.028	0.022		Set Trigger
3	2.616	0.012	0.00	0.028	0.021		Set Trigger
4	2.485	0.011	0.00	0.028	0.019		Set Trigger
5	2.498	0.011	0.00	0.028	0.020		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



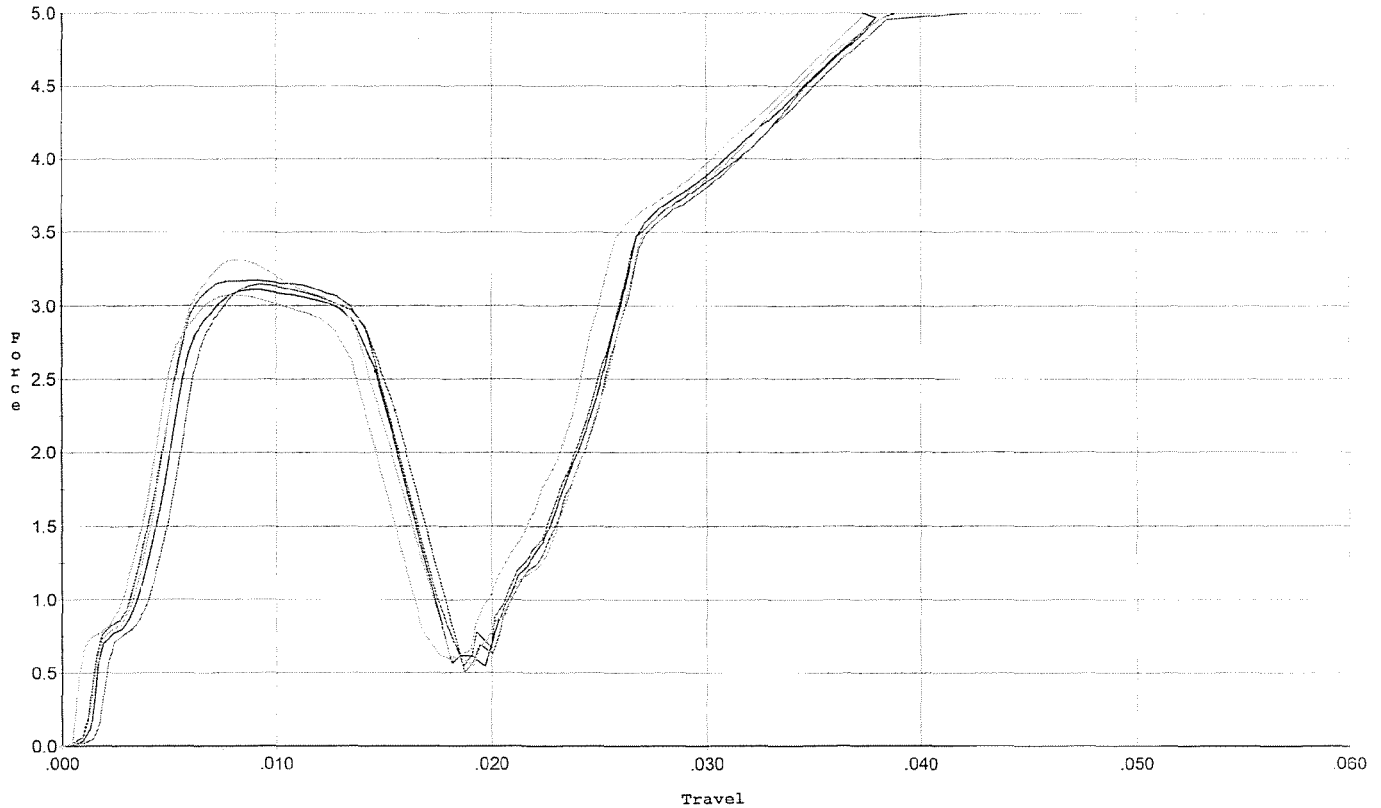
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.300	0.013	0.00	0.025	0.031		Set Trigger
2	3.209	0.014	0.00	0.025	0.031		Set Trigger
3	3.172	0.013	0.00	0.025	0.030		Set Trigger
4	3.153	0.015	0.00	0.026	0.031		Set Trigger
5	3.124	0.016	0.00	0.025	0.034		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



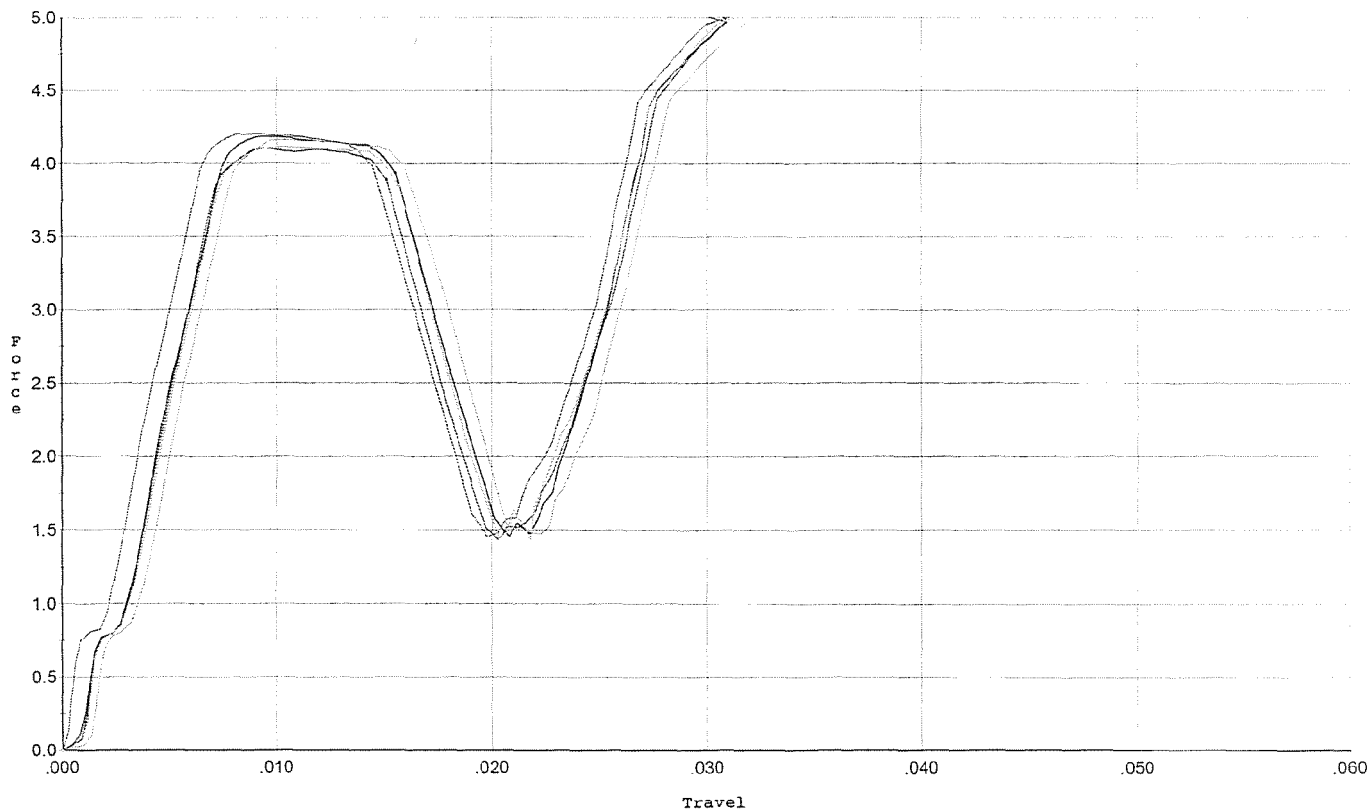
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.171	0.014	0.00	0.026	0.030		Set Trigger
2	3.108	0.015	0.00	0.026	0.030		Set Trigger
3	3.147	0.016	0.00	0.026	0.031		Set Trigger
4	3.312	0.014	0.00	0.027	0.029		Set Trigger
5	3.077	0.014	0.00	0.026	0.028		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



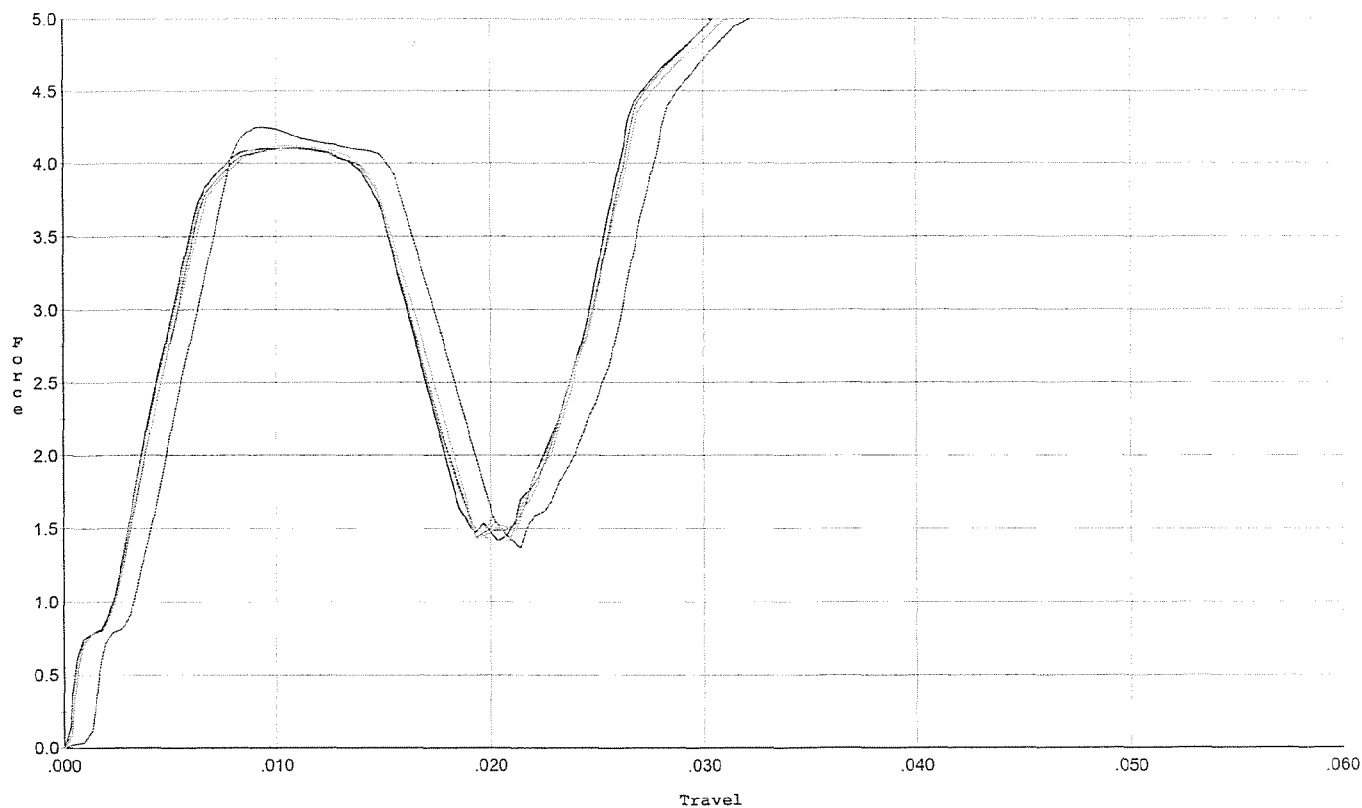
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.015	0.00	0.024	0.040		Set Trigger
2	4.184	0.016	0.00	0.024	0.042		Set Trigger
3	4.203	0.017	0.00	0.024	0.047		Set Trigger
4	4.112	0.016	0.00	0.024	0.042		Set Trigger
5	4.161	0.018	0.00	0.024	0.047		Set Trigger

A-4-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



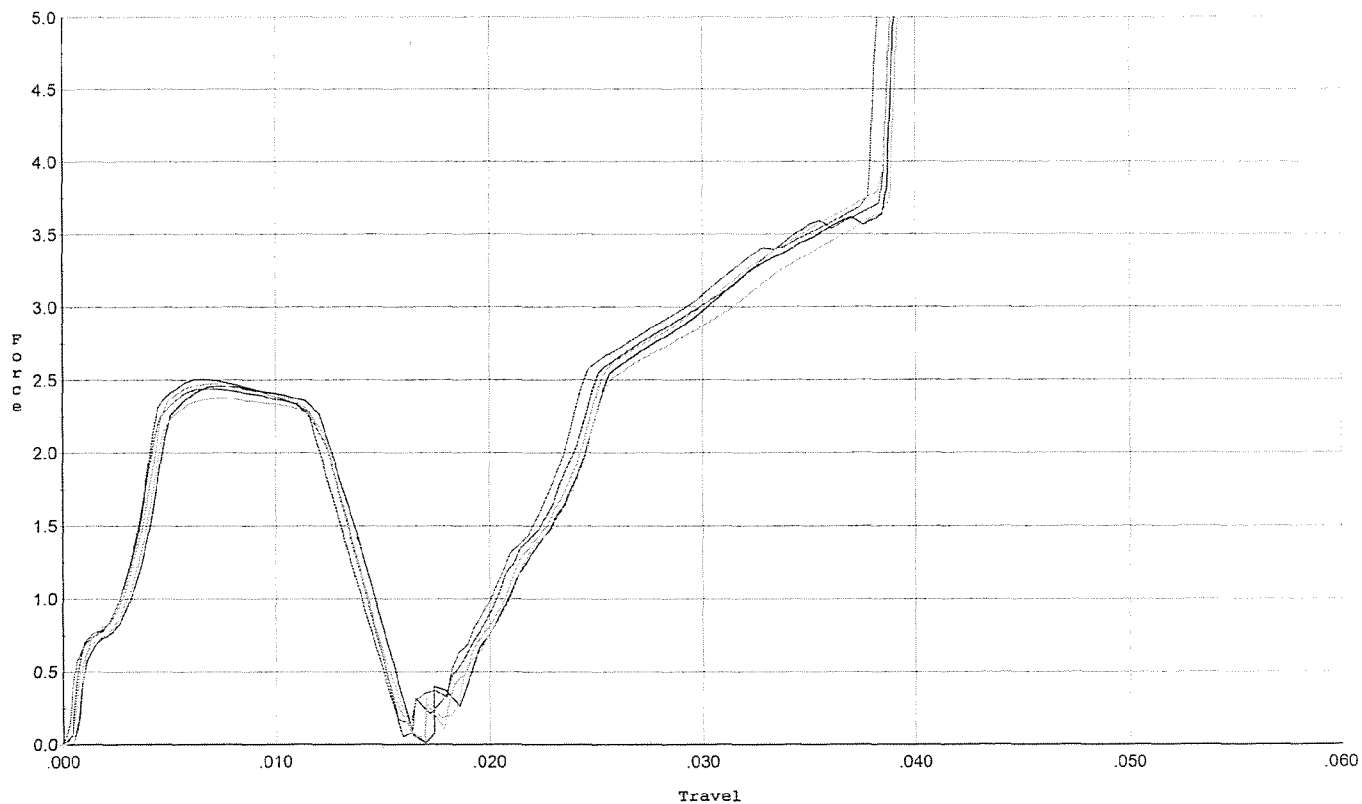
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.018	0.00	0.025	0.047		Set Trigger
2	4.104	0.015	0.00	0.024	0.041		Set Trigger
3	4.109	0.015	0.00	0.024	0.040		Set Trigger
4	4.125	0.015	0.00	0.024	0.041		Set Trigger
5	4.091	0.016	0.00	0.024	0.045		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



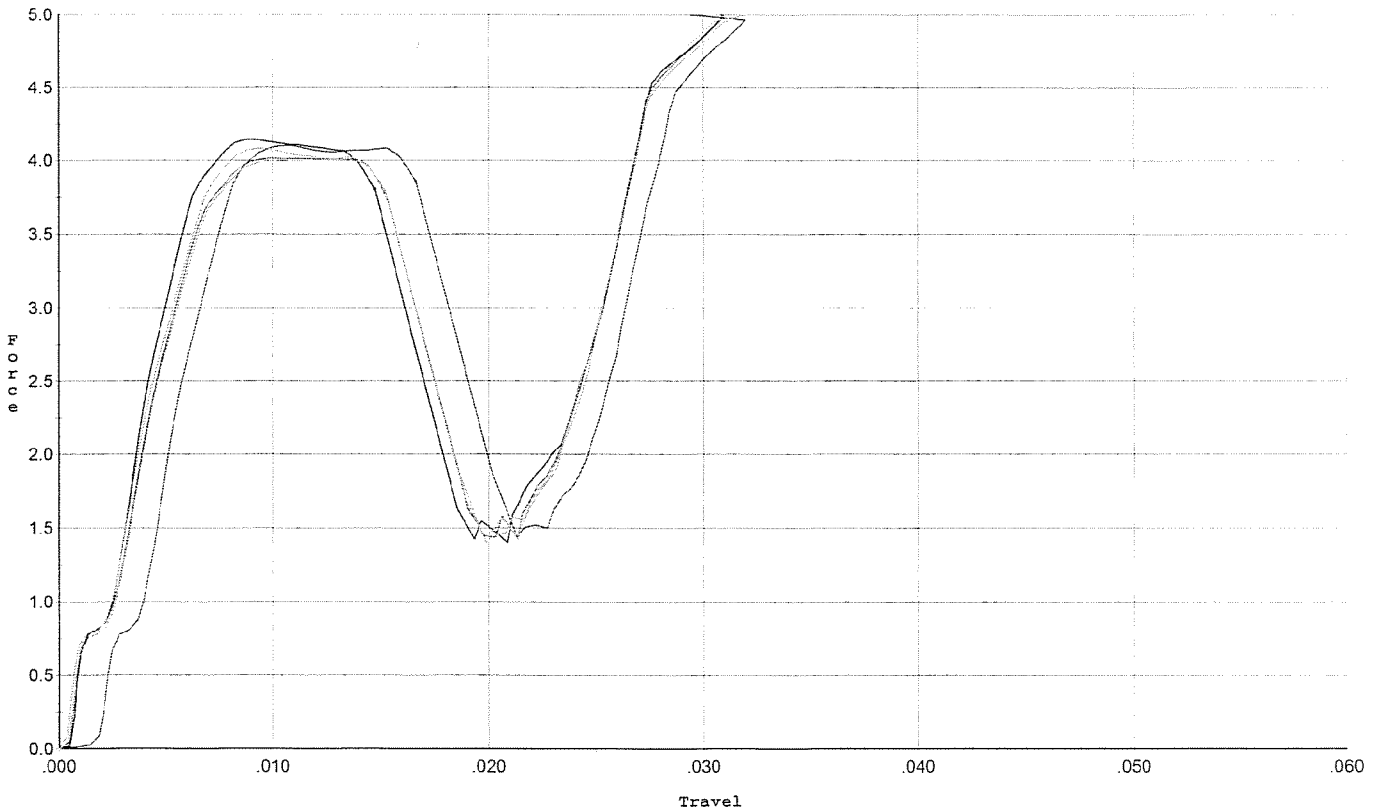
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.504	0.012	0.00	0.029	0.020		Set Trigger
2	2.457	0.014	0.00	0.028	0.023		Set Trigger
3	2.435	0.012	0.00	0.028	0.022		Set Trigger
4	2.380	0.012	0.00	0.029	0.020		Set Trigger
5	2.476	0.012	0.00	0.029	0.021		Set Trigger

A.2. 45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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	4.101	0.017	0.00	0.025	0.044		Set Trigger
2	4.142	0.015	0.00	0.025	0.041		Set Trigger
3	4.015	0.015	0.00	0.025	0.042		Set Trigger
4	4.081	0.015	0.00	0.025	0.042		Set Trigger
5	4.001	0.015	0.00	0.024	0.041		Set Trigger

A-4.06